



## Product Data Sheet

### **DuPont™ AmberLite™ HPR4700 OH Ion Exchange Resin**

Uniform Particle Size, Gel, Strong Base Anion Exchange Resin for Condensate Polishing for the Power Industry and Industrial Demineralization Applications

#### **Description**

DuPont™ AmberLite™ HPR4700 OH Ion Exchange Resin is specifically designed for use in condensate polishing beds at fossil-fired electric generating stations and industrial demineralization applications when a balance of operating performance, simple operation, long resin life, and cost-effective operation is required. A faster startup can be achieved with a strong base anion exchange resin delivered in the OH<sup>-</sup> form by providing higher water quality combined with lower TOC throw from startup, compared to the Cl<sup>-</sup> form.

This resin provides good bead integrity and rapid exchange kinetics due to its small average particle size, making it ideally suited to the high flowrate demands commonly encountered in power plant condensate polishing systems. The bead size uniformity and a distinguishable light color is tailored to complement the larger, denser, cationic, gel AmberLite™ HPR1300 H Ion Exchange Resin, offering exceptional separation in mixed beds. The color distinction between this pair of resins allows easy visual confirmation of separation following backwash.

For post-RO mixed bed polishing with a strict silica specification and/or the need to maximize silica removal capacity, AmberLite™ HPR4700 OH is an ideal choice.

AmberLite™ HPR4700 OH can also be used in single-bed demineralization applications when organic loading is not a limiting factor.

#### **Resin Pairings**

Recommended pairing in condensate polishing:

- AmberLite™ HPR1300 H Ion Exchange Resin (gel)

Recommended pairing in industrial demineralization applications:

- AmberLite™ HPR1300 H Ion Exchange Resin (gel)

Additional pairing in industrial demineralization applications:

- AmberLite™ HPR1200 H Ion Exchange Resin (gel)

#### **Applications**

- Demineralization
  - Ideally when treating water with:
    - High percentage of silica
  - When the treatment goal is:
    - Removal of strong and weak acids
    - Lowest silica leakage
  - Single bed industrial demineralization requiring high water purity
- Condensate polishing
- Mixed bed polishing

## System Designs

Compatible with all system technologies:

- Co-current
- Counter-current / Hold-down
- Packed beds
- Mixed beds

## Historical Reference

DuPont™ AmberLite™ HPR4700 OH Ion Exchange Resin has previously been sold as DOWEX MARATHON™ 550A OH Ion Exchange Resin.

## Typical Properties

### Physical Properties

Copolymer	Styrene-divinylbenzene
Matrix	Gel
Type	Strong base anion, Type I
Functional Group	Trimethylammonium
Physical Form	White to amber, translucent, spherical beads

### Chemical Properties

Ionic Form as Shipped	OH <sup>-</sup>
Total Exchange Capacity	≥ 1.1 eq/L (OH <sup>-</sup> form)
Water Retention Capacity	55.0 – 65.0% (OH <sup>-</sup> form)
Ionic Conversion	
OH <sup>-</sup>	≥ 93%
Cl <sup>-</sup>	≤ 0.5%

### Particle Size §

Particle Diameter	590 ± 50 µm
Uniformity Coefficient	≤ 1.10
< 300 µm	≤ 0.5%
> 850 µm	≤ 1.0%

### Stability

Whole Uncracked Beads	≥ 95%
Swelling	Cl <sup>-</sup> → OH <sup>-</sup> : 25%

### Density

Particle Density	1.08 g/mL
Shipping Weight	660 g/L

§ For additional particle size information, please refer to the [Particle Size Distribution Cross Reference Chart](#) (Form No. 45-D00954-en).

## Suggested Operating Conditions

### Temperature Range

OH <sup>-</sup> form ‡	5 – 60°C (41 – 140°F)
Cl <sup>-</sup> form	5 – 100°C (41 – 212°F)

### pH Range

Service Cycle	1 – 14
Stable	0 – 14

‡ Operating at elevated temperatures, for example above 60 – 70°C (140 – 158°F), may impact resin life. Contact our technical representative for details.

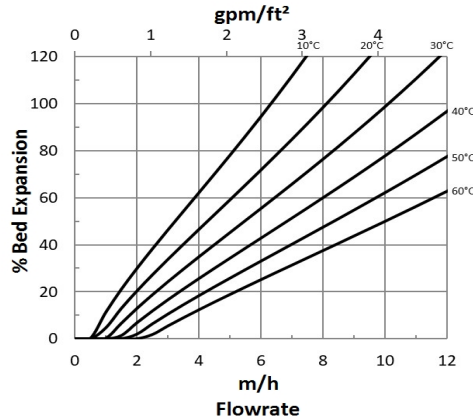
For additional information regarding recommended minimum bed depth, operating conditions, and regeneration conditions for [mixed beds](#) (Form No. 45-D01127-en) or [separate beds](#) (Form No. 45-D01131-en) in water treatment, please refer to our Tech Facts.

## Hydraulic Characteristics

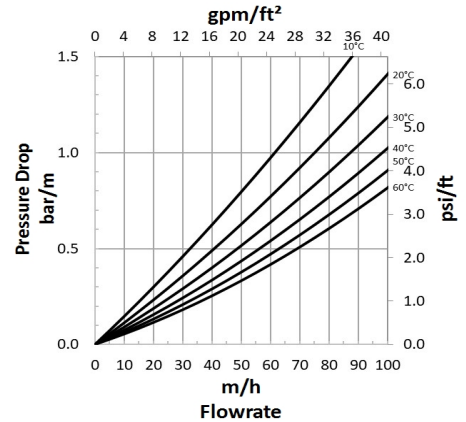
Estimated bed expansion of DuPont™ AmberLite™ HPR4700 OH Ion Exchange Resin as a function of backwash flowrate and temperature is shown in Figure 1.

Estimated pressure drop for AmberLite™ HPR4700 OH as a function of service flowrate and temperature is shown in Figure 2. These pressure drop expectations are valid at the start of the service run with clean water.

**Figure 1: Backwash Expansion**  
Temperature = 10 – 60°C (50 – 140°F)



**Figure 2: Pressure Drop**  
Temperature = 10 – 60°C (50 – 140°F)



## Product Stewardship

DuPont has a fundamental concern for all who make, distribute, and use its products, and for the environment in which we live. This concern is the basis for our product stewardship philosophy by which we assess the safety, health, and environmental information on our products and then take appropriate steps to protect employee and public health and our environment. The success of our product stewardship program rests with each and every individual involved with DuPont products—from the initial concept and research, to manufacture, use, sale, disposal, and recycle of each product.

## Customer Notice

DuPont strongly encourages its customers to review both their manufacturing processes and their applications of DuPont products from the standpoint of human health and environmental quality to ensure that DuPont products are not used in ways for which they are not intended or tested. DuPont personnel are available to answer your questions and to provide reasonable technical support. DuPont product literature, including safety data sheets, should be consulted prior to use of DuPont products. Current safety data sheets are available from DuPont.

Please be aware of the following:

- **WARNING:** Oxidizing agents such as nitric acid attack organic ion exchange resins under certain conditions. This could lead to anything from slight resin degradation to a violent exothermic reaction (explosion). Before using strong oxidizing agents, consult sources knowledgeable in handling such materials.

**Have a question? Contact us at:**

[www.dupont.com/water/contact-us](http://www.dupont.com/water/contact-us)

All information set forth herein is for informational purposes only. This information is general information and may differ from that based on actual conditions. Customer is responsible for determining whether products and the information in this document are appropriate for Customer's use and for ensuring that Customer's workplace and disposal practices are in compliance with applicable laws and other government enactments. The product shown in this literature may not be available for sale and/or available in all geographies where DuPont is represented. The claims made may not have been approved for use in all countries. Please note that physical properties may vary depending on certain conditions and while operating conditions stated in this document are intended to lengthen product lifespan and/or improve product performance, it will ultimately depend on actual circumstances and is in no event a guarantee of achieving any specific results. DuPont assumes no obligation or liability for the information in this document. References to "DuPont" or the "Company" mean the DuPont legal entity selling the products to Customer unless otherwise expressly noted. NO WARRANTIES ARE GIVEN; ALL IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE ARE EXPRESSLY EXCLUDED. No freedom from infringement of any patent or trademark owned by DuPont or others is to be inferred.

© 2023 DuPont. DuPont™, the DuPont Oval Logo, and all trademarks and service marks denoted with ™, SM or ® are owned by affiliates of DuPont de Nemours Inc., unless otherwise noted.

DOWEX MARATHON™ is a trademark of The Dow Chemical Company.

