

User Manual

GRScientific

Aquamax KF *“Portable”*



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Aquamax KF Portable v.13.08

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INTRODUCTION

Key personnel at G.R. Scientific are recognised experts in coulometric Karl Fischer titration technology and electrochemistry. They have designed and manufactured coulometric titrators since the early 1980's and are widely regarded as some of the leading specialists in this technique.

Designed primarily for the oil and power industries, the Aquamax KF *Portable* is the only model on the market with a carry handle attached directly to the unit. It also features a protective stainless steel cage, built-in printer and single button operation for water standards analysis, using either distilled water or water pellets. Specially designed Low Drift Cell twin port glassware avoids the need for Teflon sleeves or grease on the electrodes to seal titration cell from moisture invasion. Also available is a carry case for transportation in the field and an OPS Workstation which includes everything the user needs, such as syringes, standards, reagents, etc. all in one footprint for ultimate efficiency.

Aquamax KF Formula reagents have been specially formulated for use with Aquamax KF titrators. Formula A anode reagent is suitable for most routine applications and is especially useful for water content determination of oil samples, e.g. transformer oils, crude oils, etc. This anode reagent is supplied in "single shot" bottles of 100ml – No measuring of volumes required – No mixing of other solvents required. Cathode reagent Formula C is supplied in "single shot" 5ml vials which have "safety snappers" pre-fitted thereby reducing risk to the operator.

Where appropriate G.R. Scientific products include traceable calibration certificates and are backed up by a three year parts and labour warranty. These titrators are used by many leading companies in the oil, petrochemical, gas, pharmaceutical, biotechnology, automotive and power generation industries.

For a list of users, typical applications or details of our network of international distributors, please visit our website, www.grscientific.com, or contact G.R. Scientific Ltd. on:-

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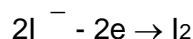
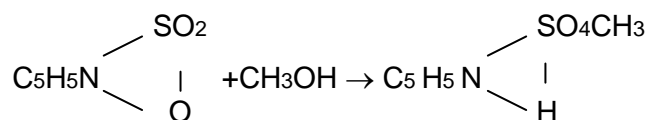
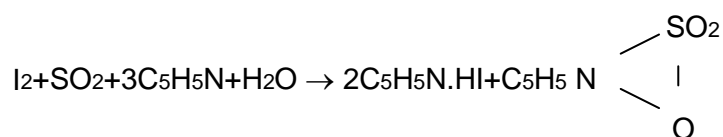
To obtain the full benefits that this instrument can offer it is recommended that you read this user manual before assembling the unit.

Cou-Lo and Aquamax KF are registered trade marks of G.R. Scientific Ltd. "ACE" control system is patented technique owned by G.R. Scientific Ltd.

(All Aquamax KF power supplies are double insulated units that do not need an earth (ground) connection. These units are sealed and conform to CSA(LR84459), UL listings and CE requirements. Aquamax KF titrators only require a low voltage 15V input to the electronic / control circuitry. The moulded plastic casing of the instrument also provides additional insulation.)

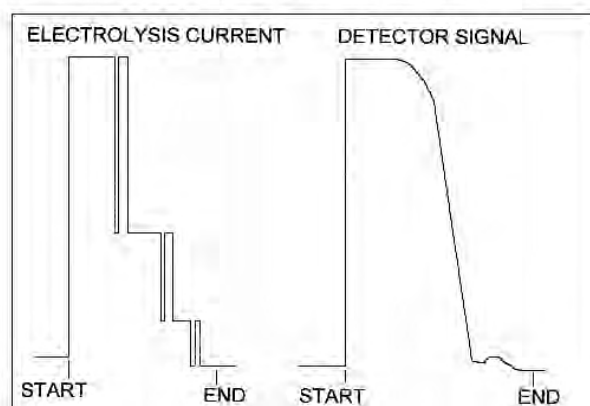
PRINCIPLE OF MEASUREMENT

Karl Fischer titration is simply a means to measure water content of samples. Modern instruments, such as the Aquamax KF, use the coulometric principle, whereby the water present in the sample is coulometrically titrated to a predefined end point at which there is a minute excess of free iodine present. Stoichiometrically, 1 mole of water will react with 1 mole of iodine, so that 1 milligram of water is equivalent to 10.71 coulombs of electricity. Combining the coulometric technique with Karl Fischer titration, Aquamax KF titrators determine the water content of the sample by measuring the amount of electrolysis current necessary to produce the required iodine. This is an absolute technique which does not require calibration of the reagents. For further information, visit www.grscientific.com, and download the PDF article titled "Recent Advances".



Using the latest pulse current technology and our patented "ACE" control system, (Patent No.GB2370641), the Aquamax KF automatically selects the appropriate titration speed dependent upon the amount of water present in the sample. The titration speed is reduced as the end point is approached, and when the titration is completed the instrument prints out and displays the results. For a more detailed explanation of the technique, and a comparison with volumetric Karl Fischer titration, please visit our website, www.grscientific.com

SCHEMATIC OF TYPICAL TITRATION



Technical Specifications *Aquamax KF Portable*

Titration Method:	Coulometric Karl Fischer titration
Electrolysis Control:	Patented "ACE" control system GB2370641
Titration vessel:	Low Drift Cell design, no grease or PTFE sleeves required
End Point Detection:	AC polarisation
End point indication:	Visual display/print out/acoustic beep
Measuring range:	Possible: 1µg – 200 mg water. Typical: 1µg - 10mg water
Moisture range:	1ppm - 100% water
Max. sensitivity:	0.1µg
Max. titration speed:	2.24 mg per minute
Max. current:	400 ma
Drift compensation:	Automatically controlled
Precision:	10-100µg ± 3µg, 100µg-1mg ±3µg, above 1mg ±0.3%
Start delay time:	0-30 minutes, user selectable
End delay time:	0-30 minutes, user selectable
Calculation modes: (user programmable)	Weight/weight, (W/w) Weight/dilution ratio, (W/K) Volume/density, (V/SG) Volume/volume, (V/v)
Display format:	µg, mg/kg, ppm, %
Print format:	µg, mg/kg, ppm, %
Statistics:	max, mean, min values up to 99 runs
Method storage:	10 user programmable methods stored plus multi method via pc link
Sample ID number:	User programmable
Stirrer speed:	Microprocessor controlled
Languages:	Multi languages – user selectable
Calendar/clock:	Analysis time & date print out
Battery low indicator:	Display & print out indication
Data outputs:	USB and RS232 ports
Removable Data storage:	Flash drive (memory stick)
Data Entry:	15 key touchpad
Display:	40 character alphanumeric backlit LCD
Printer:	42 character high speed thermal printer
Protection cage:	Stainless steel
Carry handle:	Built in
Power supply:	90-264V AC, 47-63 Hz. 12V DC car adapter/internal battery
Dimensions:	250 x 245 x 300 mm (incl. cage)
Weight:	4 kg

UNPACKING & PARTS LIST

Inside the shipping carton you will find a plastic case which contains the glassware and accessories pack and the user manual. The Aquamax KF titrator is located underneath the glassware case (or inside the optional carry case if ordered). The mains power pack and in-car adapter are inside the carry case lid compartment. Remove all of these items and check that they have arrived undamaged. The built-in battery may lose some charge if stored for prolonged period. We advise connecting the Aquamax KF *Portable* to mains power supply for 12 hours before first switching the power on.



After unpacking your Aquamax KF *Portable* check that the glassware/accessories pack contains:-

<u>Item</u>	<u>Description</u>	<u>Low Drift Cell</u>
1 pce	Titration Vessel twin port	503053
1 pce	Detector electrode LDC	503054
1 pce	Generator electrode LDC	503055
1 pce	Desiccant tube & cap	503058
1 pack	Injection septa (10)	503059
1 pce	1ml Gas Tight syringe	503063
1 pce	Luer needle Pair (17 & 19 gauge)	503067
1 bottle	Molecular sieve	503070
1 pce	Stirrer bar	503071
1 pce	Funnel	503072
1 pce	Thermal paper roll	503073

ACCESSORIES

1 pce	Mains power pack	401607
1 pce	In Car Adapter	401421

AQUAMAX KF TITRATION CELL
STEP BY STEP ASSEMBLY INSTRUCTIONS
 (SHOWN WITHOUT PROTECTIVE CAGE OR CARRY HANDLE)



Position titration vessel on Aquamax KF titrator



The glass joints do not require PTFE sleeves or grease. The special screw fittings seal the vessel from ingress of moisture from the atmosphere and are easily released, even after several weeks.



Position electrodes on titration vessel. It is not necessary to overtighten these screw joints.



Connect leads to generator and detector electrodes then connect the leads to the titrator. Generator electrode lead connects to socket marked "GENERATOR" – detector electrode lead connects to socket marked "DETECTOR"



Place stirrer bar inside titration vessel



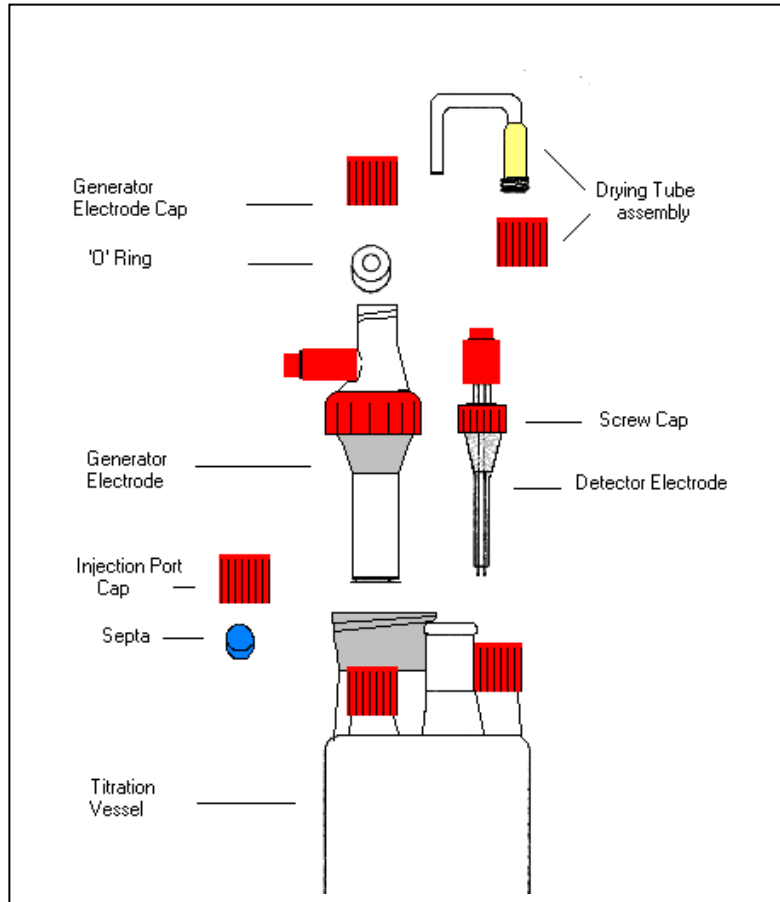
Fit injection septa into plastic screw cap connectors and locate onto injection ports of titration vessel.

Fill drying tube with molecular sieve and locate on top of generator electrode



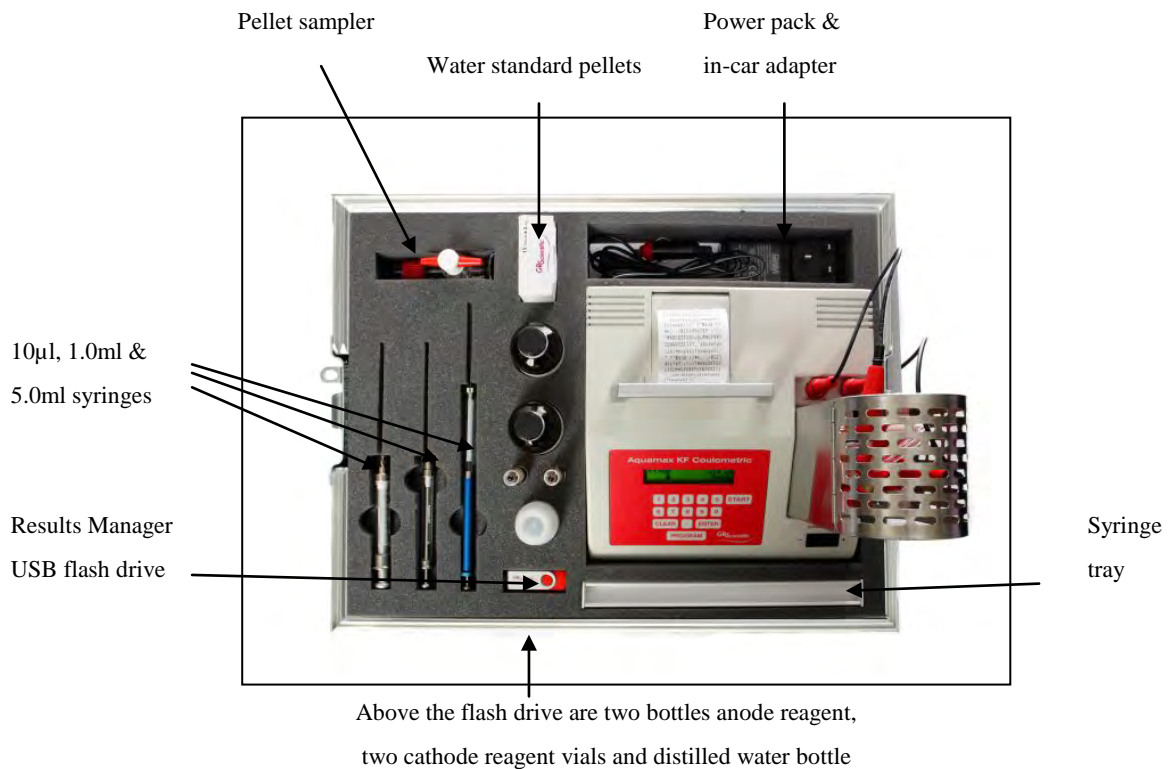
The assembled titration cell is now ready to be charged with reagents prior to use. Please be sure to assemble correctly every time the cell is cleaned or re-filled. It is recommended that the titrator is **NOT** switched on until after the titration vessel has been charged with reagents. This will avoid damage being caused to the electrodes by the stirrer bar. Avoid twisting the electrode leads otherwise they may become damaged.

AQUAMAX KF TITRATION CELL



OPS WORKSTATION

The Aquamax KF *Portable* can also be supplied complete with an OPS Workstation. A sturdy outer case secures and enables transportation of the titrator complete with spare anode reagent bottles, cathode reagent vials, distilled water and 10 microlitre syringe of water standard test, pellet sampler and water standard pellets, 1.0ml & 5.0ml gas tight syringes and luer needles, power pack, in-car adapter and Results Manager USB flash drive for storage of all results whilst in the field.



FILLING & CHANGING REAGENTS

The Aquamax KF *Portable* has been designed to operate with all major coulometric Karl Fischer reagents, however optimum performance can be obtained by using Aquamax KF Formula reagents which have been specifically formulated for use with these instruments. For most routine applications 100ml of Formula “A” (anode reagent) and 5ml of Formula “C” (cathode reagent) are used. When analysing Transformer oils, Crude oils and other petroleum products Formula “A” is especially suited as it contains other solvents to improve sample miscibility and solubility.

(When analysing samples of Ketones, amines or others which may interfere with the reaction it is advisable to use specialised reagents which can be obtained from various suppliers).



Although reagents can be poured into the titration vessel whilst it is located on the titrator, we recommend that the vessel and electrodes are removed from the instrument whilst this procedure is performed to avoid reagent spillage onto the instrument casing. *(Any spillage onto the instrument casing should be wiped off immediately to avoid damage or staining).*



Remove the drying tube and injection septa. Using the funnel supplied, charge the titration vessel up to the lower line with Formula “A” reagent. For your convenience these reagents are supplied in “single shot” bottles which contain 100ml so it is not necessary to measure any volumes – simply pour in the complete bottle

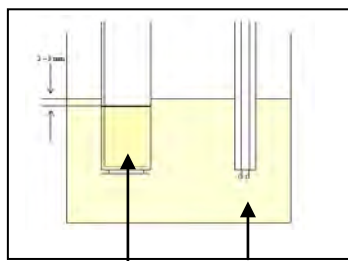


Also using the funnel, charge the inner chamber of the generator electrode with Formula “C” reagent which are supplied in “single shot” 5 ml vials which have “safety snappers” pre-fitted thereby reducing risk to the operator. *(It is not necessary to clean the funnel between reagents.)*



Reconnect the drying tube and injection septa so that the titration vessel is sealed from ingress of atmospheric moisture.

Locate the complete titration vessel onto the titrator and connect the electrode leads onto the appropriate sockets



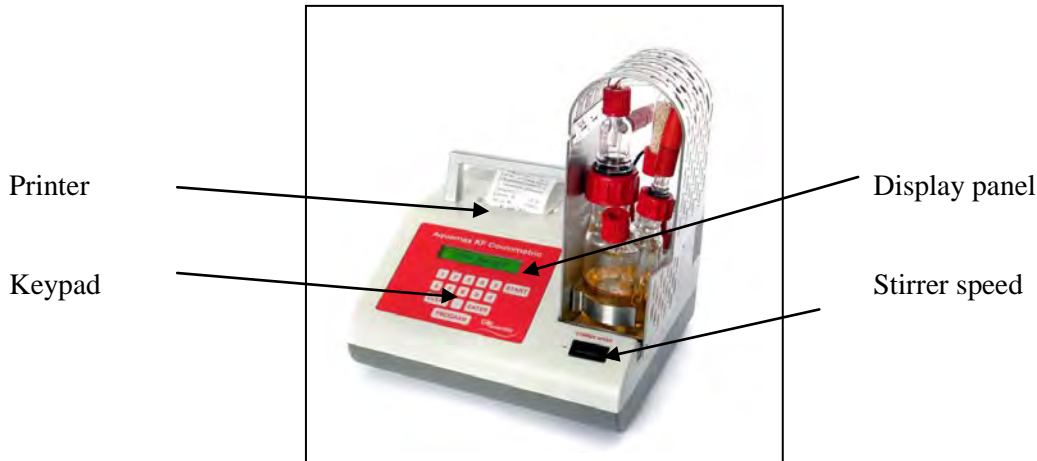
Cathode Reagent Anode Reagent

The colours of anode and cathode reagent are only an illustration to show that there are two different liquids. These are not necessarily the exact colours of the reagents being used.

The Aquamax KF *Portable* titrator is now ready to be switched on.

DESCRIPTION

Front Panel



Rear Panel



Power Jack:-	Nominal 18v DC 45w. Supply Input
Fuse:-	3,15amp T type Time delay
RS232:-	Standard 4 wire RS232 Input / Output Port.
USB-B:-	Direct cable to PC / Results Manager Port.
USB-A:-	Removable Flash Memory Store Port.

RS232 Port. –


For updating titrator software, connecting to other equipment for remote controlling (software specific protocols to be provided).


USB-B Port. –

For connecting directly to PC to export data to Results Manager and enable results to be saved on files for future reference. (See Results Manager User Manual section)

USB-A Port. –

For exporting results data to a Removable Flash Drive (memory stick), when running sample tests in the field or remote locations, and subsequent transfer to PC at a later date for loading onto Results Manager files.

To use the memory store, insert Flash Drive into USB port A, titrator will see it and a symbol  will appear on the display.

The symbol will appear blacked out while the drive is being written to and then as  when idle.

The drive should only be removed when in the idle mode.

To read data saved on drive insert it into PC USB port. Start Results Manager, load selected file and then save in the format you require, see Results Manager user manual for full instructions.

There is a separate power ON/OFF switch on the rear panel. Whilst connected to mains power supply, a trickle charge is continuously applied to the battery. It is therefore recommended that the instrument is used from mains power supply whenever possible so that the battery is kept fully charged. Maximum battery operating time is 8 hours continuous use. This may be reduced if repeated high water contents are being determined or if the printer is being continually used.

SETTING THE DATE AND TIME

1. Switch on the Aquamax KF *Portable* and wait for it to display the following:

Aquamax KF Portable
Press START

2. Hold down the **START** key until the Aquamax KF *Portable* displays:-

START

Set Date / Time:
DD/MM/YYYY HH:MM:SS

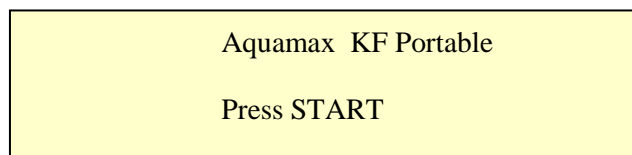
3. Use the  decimal point key to move the cursor across the screen.

4. Use the numerical keys to set / alter the required number

5. When completed press the **ENTER** key to save the changes and exit.

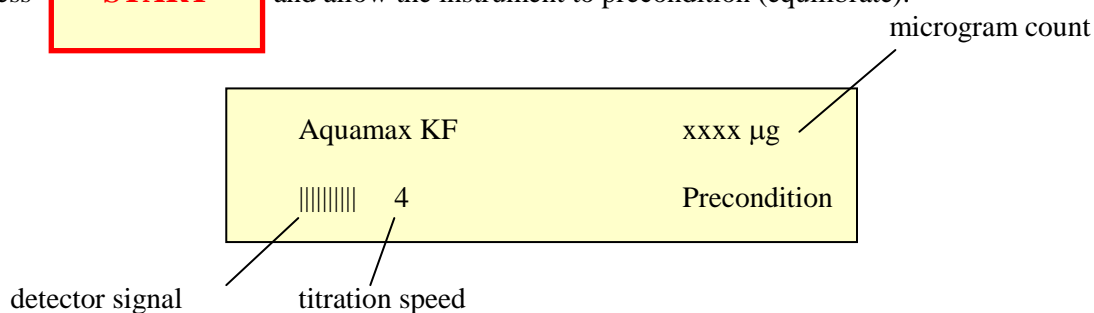
CONNECTION & START UP PROCEDURE

1. Assemble glassware (see Assembly Instructions)
2. Charge vessel and generator electrode with reagents (see Filling & Changing Reagents)
3. Locate assembled titration vessel onto the Aquamax KF *Portable*
4. Connect electrode leads
5. Connect mains lead / power cord
6. Switch ON (using switch on rear panel) and wait for display to show:-

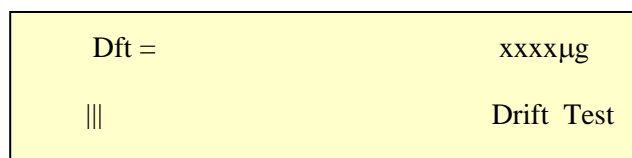


(If required adjust the stirrer speed using the black toggle switch on the front of the instrument.)

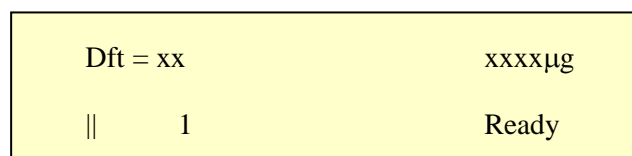
7. Press **START** and allow the instrument to precondition (equilibrate).



At the end of the precondition period the display will show:-



After the initial drift has been calculated, in micrograms of water per minute, the Aquamax KF is ready for operation.



The background drift value will usually slowly decrease with time as the titration vessel becomes drier and more stable. Although it is possible for the titrator to be used at high drift values, it is advisable to wait until the drift value is below 20 $\mu\text{g}/\text{minute}$, and stable, before commencing, especially for low water content samples in the ppm ranges. The lower, and more stable the drift – the more accurate the result.

PROGRAM FUNCTIONS

When the Aquamax KF *Portable* displays Ready you can enter titration parameters, recall or edit existing methods, enter new method files, etc., by using the **PROGRAM, ENTER, CLEAR** and **•** keys.

Key Functions:-

PROGRAM

press PROGRAM key to scroll through menus listed.

ENTER

allows parameter values for the displayed menu to be entered into memory.

CLEAR

this key has two functions:

- (1) If you have finished entering data, press CLEAR and the Aquamax KF *Plus* will return to the Ready condition.
- (2) If you have started to enter an incorrect value, press CLEAR and the Aquamax KF *Plus* will display the previously stored value, you can now select the correct value and press ENTER.

•

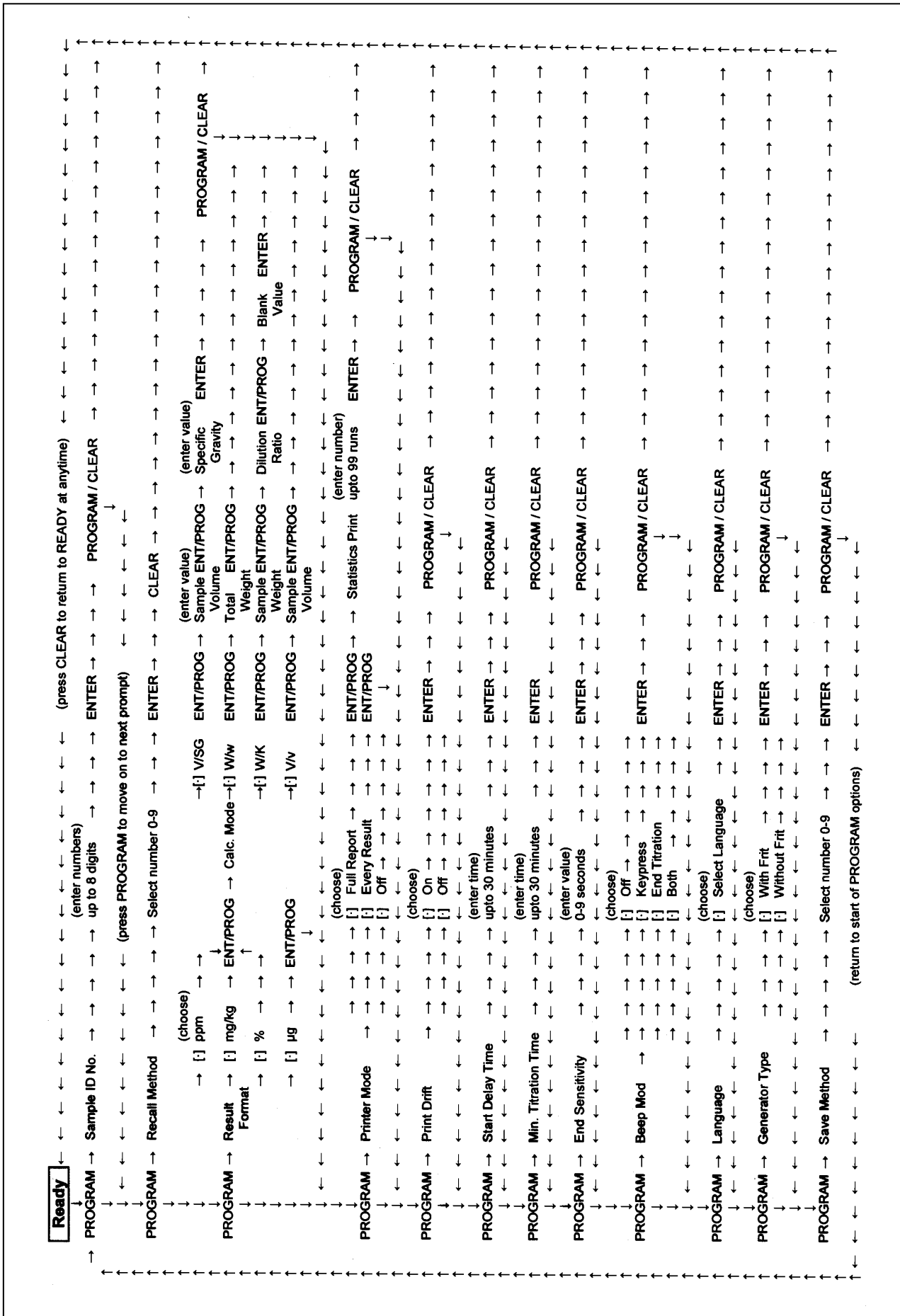
decimal point key allows scroll through of individual parameters in each menu. When the required parameter is displayed, press ENTER to store it.

MENU LIST

Sample ID Number	- upto 8 digits
Result Format	- µg, ppm, mg/kg or % water
Calculation Mode	- V/SG, W/W, W/K or V/v
Printer Mode	- off, every result or full report
Statistics Print	- upto 99 runs, will print min., max., mean, SD & CV
Print Drift	- on or off
Start Delay Time	- upto 30 minutes
Min. Titration Time	- upto 30 minutes
End Sensitivity	- 0 – 9 seconds
Beep Mode	- off, keypress, end titration or both
Language	- select language
Generator Electrode	- with frit, without frit
Save Method	- store upto 10 methods

See PROGRAMMING A METHOD for an explanation of each Menu List parameter

PROGRAMMING FLOW CHART



PROGRAMMING A METHOD

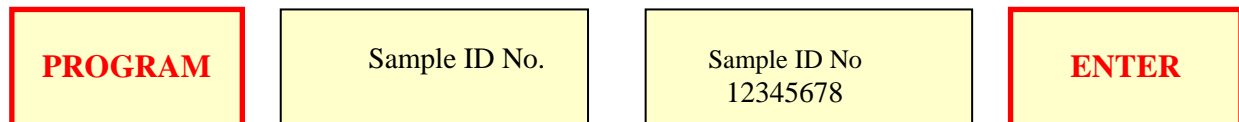
After the initial drift has been calculated, in micrograms (μg) of water per minute, the Aquamax KF *Portable* is ready for operation. It is now possible to step through the PROGRAM parameters and enter the required calculation data.

Dft = xx	xxxx μg
1	Ready

The Flow Chart on the previous page may prove helpful. Press the PROGRAM key until the required option is displayed then simply follow the Flow Chart to enter the specific data values. Pressing PROGRAM will move you on to the next prompt, pressing CLEAR will return to Ready condition. It is not necessary to step through all of the programme functions for every method, for example, if you only require to change the Beep Mode from Off to Both – simple press PROGRAM until display shows Beep Mode, press the decimal point key \bullet until display shows Both, then press ENTER and CLEAR to return to Ready.

SAMPLE ID NUMBER

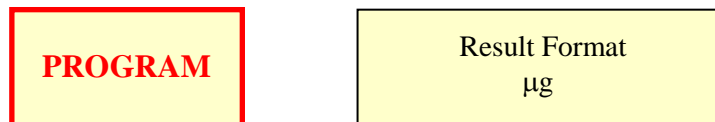
Press PROGRAM → Display will show → Key upto 8 numbers → Press ENTER



If you do not want to enter any further parameters simply press CLEAR to go back to the Ready condition. Press PROGRAM if you want to continue entering other parameters

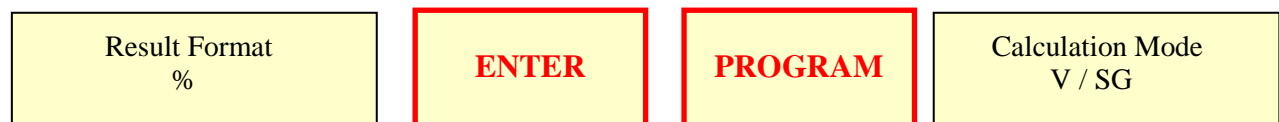
RESULT FORMAT

Press PROGRAM → Display will show



Results can be selected in μg , ppm, mg/kg or % water.

If you want to select the format already stored in memory (and shown on display), press PROGRAM and the instrument will go to the next prompt. If you want to change format to give results in ppm, mg/kg or % you can scroll through these options by pressing decimal point key \bullet until the required format is displayed, then press ENTER to store this in memory and PROGRAM to move onto the next prompt. If you have selected a result format in ppm, mg/kg or % the instrument will prompt you for the necessary calculation mode and data values.



The display shows the calculated water content according to the programmed Result Format and Calculation Mode program settings, ie. whatever has been chosen to be shown/printed at the end of the titration. The only exception to this is in the W/w mode when the Tare Weight has not yet been entered. In this case the display will show the μg count. The PROGRAM key can be used to enter the Tare Weight at any time during the titration, once this has been done the display will start to show the calculated result in ppm, mg/kg or % water.

CALCULATION MODE

The Aquamax KF *Portable* has four standard calculation modes in memory. Each of these allow the instrument to divide the microgram count by the gram weight of sample introduced so that the calculated result can be printed out in either ppm or percentage of water.

Press the decimal point key **•** to scroll through the options available.

Select the calculation mode required and press ENTER.

The display will prompt you with the appropriate parameters.

Enter the numerical value for each parameter and press ENTER.

The four standard calculations are:-

1. Weight difference W/w

(This is the most accurate calculation and is suitable for almost all types of samples, powders, liquids, gases, etc.)

$$\text{Result (ppm or \%)} = \frac{\text{microgram count}}{W - w}$$

Where W = total weight of sampler + sample (gm)
w = tare weight of empty sampler (gm)

After entering the total weight (W) the instrument will return to the Ready condition. The Tare weight (w) can be entered at any time during the titration by pressing PROGRAM, or at the end of titration. For ease of operation it is possible to enter the Total weight (W) as 0.0000gm, then place the full sampler on the balance and tare to zero. Thereafter it is only necessary to enter the weight difference (tare weight w) for each titration. This procedure reduces potential data entry errors.

2. Weight/Dilution ratio W/K

(Use this method if you need to dissolve a sample in another solvent. Suitable for samples which will not dissolve in the anode reagent or which might interfere with the KF reaction)

$$\text{Result (ppm or \%)} = \frac{\text{microgram count} - \text{bl}}{W} \times K$$

where:

W = weight of sample dissolved (gm)

K = $\frac{\text{total volume of diluent + sample}}{\text{volume injected into Cou-Lo Aquamax}}$

bl = micrograms of water for same injected volume of diluent (μg)

e.g.

Accurately weigh approximately 2 gm of sample into a 20ml stoppered graduated flask. Make upto the volume line with suitable solvent / diluent. Using appropriate syringe inject 100 μl of diluted sample into the titration cell. Calculation parameters for this example would be:-

W = 2 gm
K = $\frac{20\text{ml}}{100\mu\text{l}} = 200$
bl = microgram count of 100 μl injected volume diluent

3. Volume / Specific Gravity V/SG

(The most widely used technique for liquid samples. However, care must be taken to ensure removal of all air bubbles from the syringe)

$$\text{Result (ppm or \%)} = \frac{\text{microgram count}}{V \times SG}$$

where V = volume of sample (ml)
SG = specific gravity

4. Volume V/v

$$\text{Result \% volume} = \frac{\text{microgram count}}{V \times 1.0}$$

where V = volume of sample (ml)

This is essentially the same as V / SG mode, except that the sample S.G. is fixed at 1.0

PRINTER MODES

Selecting this program allows the printer to be turned ON or OFF. It also enables you to print out the titration parameters being used at that time. Simply scroll through the options using the decimal point key

- until the required mode is displayed, then press ENTER.

Options available:

Off - no result print out
Every result - will print result after every titration, first result also prints all calculation input data.
Full Report - will print results after every titration and then print out statistical data after a selected number of titrations.

STATISTICS PRINT

The Aquamax KF *Portable* can be programmed to print out the statistical data from a series of results when using "Full Report" print mode. If no number has been selected, the Aquamax will automatically clear after 99 runs. If 3 or more runs have been selected the Aquamax will print out the minimum, maximum, mean, SD & CV values.

PRINT DRIFT

The Aquamax KF *Portable* can be programmed to print out the drift value for each titration. This is a useful indicator of titration cell stability. If drift is above 25 µg / minute print will show ****XX****. This is a warning that a high drift value was present at start of the titration.

DELAY TIMES

The Aquamax KF *Portable* has been programmed to accept two different types of delay times, one at the start of titration and one at the end as a minimum titration time.

START DELAY TIME

The Aquamax KF *Portables* has a preset delay of five seconds which allows samples to be dispersed into the reagents before the titration starts. Some samples, particularly powders and viscous samples, may need additional time to fully dissolve. By selecting the start delay program, you can increase this time by upto 30 minutes.

Display shows:

Start Delay Time 00 mins 00 secs

Select required time delay and press ENTER.

Whilst a delay time is in operation, the display will show “add sample” and the clock counter will show the time remaining before the start of titration. A start delay can be overridden by simply pressing START

MINIMUM TITRATION TIME

For some applications, such as certain gas samples or when using the Aquamax KF *Portable* combined with an oil evaporator or solids evaporator system it can prove useful to delay the end point of the titration. By selecting this parameter you can increase the minimum titration time by upto 30 minutes.

Display shows:

Min. Titration Time 00 mins 15 secs
--

Select required minimum time and press ENTER.

END SENSITIVITY

The sensitivity of detector signal as the end point is approached can be set from 0 – 9 seconds. The default value is 3 seconds and there are very few occasions when this may need to be altered. Decreasing this value can prove useful if samples cause interference, e.g. some Lube Oil samples.

BEEP MODE

Four options are available for the audible alarm (beeper) and they can be scrolled through using the decimal point key **.** until the required one is displayed. Then press ENTER.

The options are:

- Off - beeper inactive
- Keypress - beep once every time a key is pressed
- End titration - beep three times at the end of a titration
- Both - beep after every keypress and three times at the end of a titration

LANGUAGE

The Aquamax KF *Portable* can be programmed to show all display prompts and print outs in various languages. Use the decimal point key **.** to select language then press ENTER.

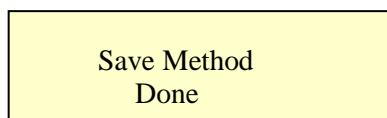
GENERATOR ELECTRODE

The Aquamax KF *Portable* can be operated using generator electrodes with or without frit (diaphragm). Use the decimal point key **.** to select either with or without frit then press ENTER. The titration electrolysis current settings are automatically adjusted for each style of generator and appropriate reagents.

SAVE METHOD

If you want to save a method for future use, this can be done by pressing a numerical key, 0 - 9, and ENTER. All titration parameters, printer mode, beeper mode, etc. are stored automatically.

Display then shows:



Save Method
Done

Then press CLEAR and the instrument will revert back to the Ready condition.

RECALL METHOD

If any methods have been saved to memory then the first prompt (before Sample ID number) will be "Recall Method"

When this prompt is displayed, simply press the number of the method file you wish to recall and press ENTER. There are 10 method files available numbered from 0 to 9. The titration parameters etc will all be automatically recalled. Press PROGRAM to view the recalled method parameters or press CLEAR and the instrument will go back to the Ready condition.

If you do not want to recall a method, press PROGRAM to view the next prompt.

WATER STANDARD TEST

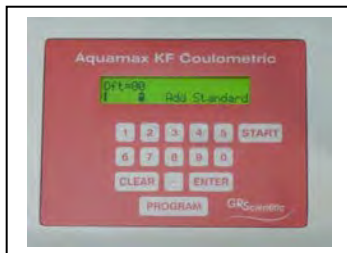
The display prompt, when first switched on, reads “Water Standard Test”. By simply pressing just one button, the titrator is ready for the operator to inject 10 µl of distilled water as required by the ASTM methods for these analyses. After running the 10,000 µg check the titrator reverts back to ordinary user mode. The Water Standard Test can also be used to check lower microgram count levels using water standard pellets and pellet sampler.

In Water Standard Test mode the Aquamax KF *Portable* will display only microgram counts and print out the final result in micrograms. This is an absolute result to check that the titrator is performing correctly and within required parameters.

For 10,000 µg counts use the 10µl syringe with distilled water, for lower counts use the pellet sampler and Water Standard Pellets as shown below:-



When titrator is in “Ready” mode, press Program key and display will show “Water Standard Test”. Press Enter to activate and display will return to “Ready” mode.



Either using the 10 microlitre syringe with distilled water, or using the water standard pellets and pellet sampler, press Start and display will prompt “Add standard”. Inject the 10 microlitres of water or turn the 3 way cock to allow pellet to drop into titration vessel. Remove syringe from titration vessel or close the 3 way cock of pellet sampler immediately after sample introduction.



After completing Water Standard Test press Program and display will prompt “Water Standard Cancel”. If you want to repeat standard sample analysis simply press Start and introduce next sample. Otherwise press Enter to cancel water standard test parameters and revert back to pre programmed methods.



Tear open the foil pouch containing water standard pellet. Carefully pour this into the funnel of pellet sampler device avoid contact with skin to reduce contamination of sample with moisture from your fingers.



Press Start and turn the 3 way cock so that pellet drops into titration vessel. After sample introduction close 3 way cock to avoid ingress of atmospheric moisture.

EXAMPLE COULOMETRIC METHODS

The Aquamax KF series of Coulometric Karl Fischer titrators can be used for the following standard methods, either by direct sample introduction or in conjunction with accessories such as water evaporators:-

ASTM	D 1533	Insulating liquids
	D 3401	Halogenated organic solvents
	D 4928	Crude oils
	D 5460	Rubber compounding materials
	D 6304	Petroleum products, lubricating oils and additives
	D 6869	Plastics
	E 1064	Organic liquids
API MPMS	Ch. 10.9	Crude oil
EI / IP	386	Crude petroleum
	438	Petroleum products
BS	6829:1.5	Surface active agents
ISO	TC 158/SC	Natural gas and gas substitutes
	10101-1	Natural gas
	10101-3	Natural gas
	10337	Crude petroleum
	12937	Petroleum products
IEC	60814	Insulating liquids

EXAMPLE APPLICATIONS

LIQUID SAMPLES

Liquid samples are usually introduced into the titration vessel by using a syringe. The greater the amount of water introduced into the titration cell will cause the titration to take longer and also consume the reagents more quickly. It is recommended that the smallest representative amount of sample be used to ensure fastest titration speed and maximum sample throughput before reagents have to be replenished. Supplied as standard with every Aquamax KF titrator is a 1ml syringe and luer needle. These are suitable for injection of oil samples and water standards. Other volume syringes are commercially available from various suppliers. Please ensure that the needle is long enough to reach into the anode reagent.

This guide may be of assistance when selecting injection volume of samples:-

Expected water content.....		Suggested sample size
1	- 10 ppm.....	1 or 2 ml
10	- 100 ppm.....	1 or 2 ml
100	- 500 ppm.....	0.5 or 1 ml
500	- 1000 ppm.....	0.5 or 1 ml
0.001	- 0.01 %	1 or 2 ml
0.01	- 0.1 %	1 or 2 ml
0.1	- 0.5 %	0.5 or 1 ml
0.5	- 1.0 %	0.5 or 1 ml
1.0	- 5.0 %	0.2 ml
above	5.0 %	0.1 ml or less

Please note that these volumes are only a guide. You may wish to experiment with sample size to determine the optimum balance between repeatability, reagent depletion and speed of analysis.

CRUDE OILS

(IP 386 & 438, ASTM D1533, D4928, D6304, API MPMS Chapter 10.9, ISO 10337 & 12937)

Most coulometric reagents contain Methanol as the main solvent and as such it is possible that waxy deposits from crude oils can “drop out” and contaminate the electrodes, requiring more frequent and thorough cleaning of the glassware. This problem can be reduced by using Aquamax KF “Formula A” anode reagent which has been specially formulated for this application. The most common interference in crude oil samples is usually caused by mercaptans or sulphides. Samples containing alkyl groups will react stoichiometrically so that:

100 ppm Mercaptans would show as approximately 30 ppm water

100 ppm Sulphides would show as approximately 50 ppm water

In normal practice oils containing less than 500 ppm mercaptans or sulphides are regarded as having no appreciable effect. Repeatability problems are usually caused by sampling inaccuracies or improper homogenisation of the sample.

TRANSFORMER/INSULATING OILS

(ASTM D 1533, BS EN 60814, IEC 60814)

Due to the viscosity of these samples, and the fact that typical water content levels are in the range 5 – 40 ppm, it is usually necessary to inject sample volumes of 1 ml. This means that upto 50 samples would fill the titration cell. Provided that the other criteria governing reagent life, (total water titrated and reagent age), have not been reached, then it is possible to switch off the titrator and allow the oil to separate from the reagent. The oil can then be siphoned off and the instrument switched on again. After this operation it may take upto 30 minutes before the instrument settles down to a stable baseline. If it takes longer than 30 minutes then it is advisable to clean the cell and recharge with fresh reagents. For optimum performance use Aquamax KF “Formula A” reagent.

TURBINE / LUBRICATING OILS

For most Lube Oil applications a sample size of 1ml is sufficient. However, if it is suspected that the water content is above 1 %, then a sample size of 0.2 to 0.5 ml is suggested.

Some lubricating oils contain additives which can coat the detector electrode or block the glass frit of the generator electrode. For these applications we suggest using the Aquamax KF *Portable* in conjunction with an oil evaporator such as the model 51000.

GAS SAMPLES

Gas samples can be introduced by fitting a needle onto the gas sampling bomb and selecting Calculation mode W/w. Alternatively, gas samples can be bubbled through the titration vessel and the passed volume measured. For this method we suggest using the gas analysis kit (503074).

1. Fit the gas inlet and outlet adapters in place of the injection septa.
2. Remove the drying tube and seal the top of electrode using the injection port septa and screw cap.
3. Connect outlet adapter to wet gas flow meter.
4. Flush the sample lines and allow instrument to stabilise.
5. Press START and allow gas sample to flow through the cell at an approximate flow rate of 0.5 litres/minute.
6. Turn off gas flow and allow titration to reach end point.

Calculation

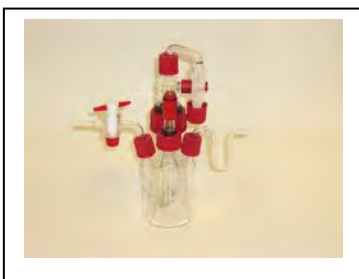
$$W = \frac{G \times (273 + t) \times 22.4}{V \times 273 \times 18}$$

W = moisture content

G = microgram count

V = gas volume, litres

t = water temperature of wet gas flow meter (°C)



Gas sample adapter



Fitted to vessel

HOW TO RUN A TEST

Please read the section PROGRAMMING A METHOD then use the PROGRAMMING FLOW CHART before running any samples,

Example: Transformer oil sample by V/SG

Program the Aquamax KF *Portable* with parameters for the analysis. For Transformer Oil samples, these parameters are usually:-

Result Format	= mg/kg or ppm
Calculation Mode	= V/SG
Sample Volume	= 1.0 ml
Sample SG	= 0.875

Other parameters such as Sample ID number, Printer Mode etc are optional.

ANALYSIS METHOD

1. Confirm that Aquamax KF *Portable* is in “Ready” mode
2. Flush 1.0ml syringe several times (minimum 6 times) with sample
3. Fit luer needle and flush through with sample
4. Draw sample into syringe beyond the 1.0ml marking
5. Invert syringe so that any air bubbles can be ejected through the needle and adjust syringe plunger to the 1.0 ml mark
6. Wipe off excess sample from outside of needle using a clean, dry tissue or paper towel
7. Pierce needle through injection septa of titration vessel (1 – 2 cm)
8. Press START
9. Push needle into anode reagent and inject sample
10. Withdraw needle from titration vessel
11. Read result, in mg/kg (ppm) water, on display and printout
12. Repeat steps 2 – 11 if duplicate result required

Example: Crude Oil by W/w

Program the Aquamax KF *Portable* with parameters for the analysis.

ANALYSIS METHOD (1)

1. Confirm that Aquamax KF *Portable* is in “Ready” mode
2. Flush 1.0ml syringe several times (minimum 6 times) with sample
3. Fit luer needle and flush through with sample
4. Draw sample into syringe beyond the 1.0ml marking
5. Invert syringe so that any air bubbles can be ejected through the needle and adjust syringe plunger to the 1.0 ml mark
6. Wipe off excess sample from outside of needle using a clean, dry tissue or paper towel
7. Weigh syringe
8. Press PROGRAM until Calculation Mode displayed then select W/w
9. Enter the syringe weight when prompted by display, then press ENTER / CLEAR
10. Pierce needle through injection septa of titration vessel (1 – 2 cm)
11. Press START
12. Push needle into anode reagent and inject sample
13. Withdraw needle from titration vessel
14. Reweigh the syringe.
15. The net weight of syringe can be entered either during the titration by pressing PROGRAM or waiting until the end of titration when display will prompt TARE Weight. Enter the weight then press CLEAR.

ANALYSIS METHOD (2)

1. Confirm that Aquamax KF *Portable* is in “Ready” mode
2. Flush 1.0ml syringe several times (minimum 6 times) with sample
3. Fit luer needle and flush through with sample
4. Draw sample into syringe beyond the 1.0ml marking
5. Invert syringe so that any air bubbles can be ejected through the needle and adjust syringe plunger to the 1.0 ml mark
6. Wipe off excess sample from outside of needle using a clean, dry tissue or paper towel
7. Place syringe on balance and tare to zero
8. Press PROGRAM until Calc. Mode displayed then select W/w
9. Enter the sample weight as 0.0 gram, then press ENTER / CLEAR
10. Pierce needle through injection septa of titration vessel (1 – 2 cm)
11. Press START
12. Push needle into anode reagent and inject sample
13. Withdraw needle from titration vessel
14. Reweigh the syringe.
15. The net weight of syringe can be entered either during the titration by pressing PROGRAM or waiting until the end of titration when display will prompt TARE Weight. Enter the weight then press CLEAR.

LOADING THE PRINTER

(SHOWN WITHOUT PROTECTIVE CAGE OR CARRY HANDLE)

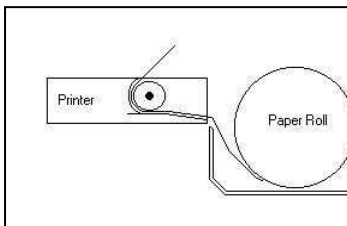
To load the paper into the printer, first open the paper roll holder lid above the print head and remove the old roll and rollers. Now fit rollers to new paper roll (503073), load as shown and insert the paper into the slot at the rear of the print head. As soon as the printer sees the paper it will automatically load it. To avoid damage to the printer mechanism it is advisable to only use the correct part number (503073) thermal paper rolls.



Cut the end of the paper roll at a slight angle as shown. This will make it easier to feed into the printer



The mechanism has optical sensors which detect the paper and will auto feed.



Schematic of paper feed



Fit rollers onto both sides of paper roll



Locate paper roll in to compartment

PRINT-OUTS

The Aquamax KF *Portable* allows you to select different print modes. If you choose to have the printer on, you will receive a hard copy of the result obtained, together with the selected parameters for that particular titration every time a titration is performed. Options available;

- Off - no result print out
- Every result - will print result after every titration, first result also prints all calculation input data.
- Full Report - will print results after every titration and then print out statistical data after a selected number of titrations.

The Aquamax KF *Portable* automatically increments the next run number every time you press the start button. The run counter is reset to zero when power is switched off and back on again. A duplicate set of results can be printed out simply by holding down the start button for 3 seconds. Results memory is cleared after duplicate print out or when power is switched off.

PRINT OUT EXPLANATION

Aquamax KF Portable		
	V xxxx	
Serial No.	71000	
Calibrated	DD/MM/YYYY	
	Run Date	
Run: 1	Run Time	F
Nett Count	0.0 µg	
Drift	00	
Result Format	%	
Calculation Mode	V/SG	
Volume	1.0000 ml	
Density	1.0000	
Res:	0.0000%	
Run: 2	Run Time	
Nett Count	0.0 µg	
Drift	00	
Res:	0.0000%	

EXAMPLE OF V/SG CALCULATION

Titrator model
 Software version
 Titrator serial number
 Date titrator calibrated
 Date sample run

Run number & time of analysis (F = generator electrode with frit)
 Nett microgram count (after drift correction)
 Drift value at start of titration
 Result format selected
 Calculation mode selected
 Sample volume
 Sample density

Calculated result water content

Subsequent runs of the same sample and calculation parameters show run number, run time, nett count, Drift value and calculated result.

Aquamax KF Portable		
	V xxxx	
Serial No.	71000	
Calibrated	DD/MM/YYYY	
	Run Date	
Run: 1	Run Time	N
Nett Count	0.0 µg	
Drift	00	
Result Format	%	
Calculation Mode	W/w	
Total Weight	0.0000 gm	
Tare Weight	0.0000 gm	
Sample Weight	0.0000 gm	
Res:	0.0000%	

EXAMPLE OF W/w CALCULATION

Run number & time of analysis (N = generator electrode without frit)
 Nett microgram count (after drift correction)
 Drift value at start of titration
 Result format selected
 Calculation mode selected
 Weight of syringe plus sample
 Weight of syringe after sample injected
 Weight of sample analysed

Calculated result water content

DRIFT RATE COMPENSATION

At the start of any titration, the drift value in the top left corner of the screen (in micrograms per minute), is stored in memory. This ensures that the displayed result is corrected for any ingress of atmospheric moisture during the titration period.

Whilst in READY condition, the Aquamax KF *Portable* continually compensates for any drift caused by atmospheric moisture ingress or reagent decomposition and displays this information, which is updated every 10 seconds. If the drift value is above 25 µg /minute the display will show High Drift **XX**. This is a warning that the value is high, however the instrument can still be used by simply pressing START to continue. Provided the drift rate is stable then it usually acceptable to continue operation. The Aquamax titration cell design can provide drift values down to less than 5 µg /minute but can also operate at much higher values. The maximum drift value is 60 µg /minute but we recommend operating upto a maximum of 25 whenever possible.

If the drift value is above 60 µg per minute the display will read
“EXCESS DRIFT - SEE INSTRUCTION MANUAL”

Most common causes of excess drift are:

Titration vessel not properly sealed (check septa & fittings).

Reagent almost depleted (clean & recharge the cell).

Sample introduced before pressing START key.

Trace moisture on cell walls.

If excess drift occurs, switch the instrument off, remove titration cell from clamp, gently swirl the anode reagent around the cell walls, replace cell in clamp, switch instrument on and allow to precondition.

OVERTITRATION

If the detector electrode senses too much Iodine in the titration cell, usually caused by instrument being left unoperated for a long period, the display will read :-
“OVERTITRATION - SEE INSTRUCTION MANUAL”

Simply add 3 - 5 microlitres of water, or a small amount of a known wet sample, until the detector signal bars on bottom left of display are activated. Then instrument will automatically carry out its precondition.

REAGENT LIFE

There are three main factors which govern the life of reagents, and therefore, the frequency of cleaning and recharging the titration cell:

1. The physical size of the titration cell allows for 50 – 60 mls of sample to be added. For the analysis of most liquid samples (e.g. solvents) the Aquamax KF *Portable* normally only requires a few microlitres to be injected, therefore the maximum volume of 50 – 60 mls should not become a limiting factor. (Oil samples are an exception and are dealt with elsewhere in this manual).
2. The total amount of water that can be analysed before saturation of the reagents varies slightly from one reagent manufacturer to another. Typically a 100 ml charge of Anode reagent (Formula “A”) will analyse upto 1 gm water, whilst a 5 ml charge of Cathode reagent (Formula “C”) will analyse upto 250 mg water. Considering that the injected sample volume is normally small, and also that the analysis is usually for the determination of low levels of water, these water capacity values are not normally a limiting factor.
3. Similar to all other Karl Fischer reagents, coulometric reagents will deteriorate when exposed to sunlight and with increases in temperature. Placing the instrument in direct sunlight or near to a heat duct can decrease the reagent life. As reagents age, the titration speed will reduce and the drift value will increase.

CLEANING GLASSWARE

IMPORTANT

The platinum mesh and wires of the electrodes are fragile and can be easily bent or broken. Extreme care **MUST** be taken when disassembling, cleaning and reassembling the titration cell. The generator electrode is the most expensive part of the Aquamax KF glassware. **DO NOT USE BRUSH TO CLEAN INSIDE ELECTRODE AS THIS COULD DAMAGE CONNECTIONS.** Coulometric reagents are flammable and toxic, so care should always be taken when handling them and when cleaning the glassware. Whenever possible this should be done in a safe area, e.g. inside a fume cupboard. Reagents should not be recharged while the titration cell is still attached to the titrator. See page 11 on charging procedure.

Under normal circumstances the titration cell can be used for a large number of samples before having to replenish the reagents. Once the reagents have been exhausted, or when the titration cell maximum volume has been reached, it should simply be necessary to:-

1. DISASSEMBLE titration cell (disconnect leads from titrator)
2. EMPTY the titration cell and generator electrode
3. RINSE all parts with methanol. Do not use brush on electrodes.
4. DRY all parts
5. REASSEMBLE glassware
6. RECHARGE with fresh reagents

If the cell is heavily contaminated then it may be necessary to clean it more thoroughly. For oil samples, cleaning with chloroform or xylene is suggested, whilst for salt deposits a water wash may be required. Use whichever solvent is most suited for the sample type. The titration vessel can even be cleaned with hot soapy water and a bottle-brush. However, after cleaning with suitable solvent, all glassware parts, **MUST** be rinsed inside and out with methanol. They can then be dried with a warm air blower, such as a domestic hair dryer, placed in a low temperature oven at 40 – 50 ° C, or left in a desiccator.

After being fully dried, reassemble the titration cell and charge with fresh reagents.

THE MORE THOROUGHLY THAT THE TITRATION CELL IS CLEANED AND DRIED, THE FASTER THE INSTRUMENT WILL STABILISE READY FOR OPERATION AFTER RECHARGING REAGENTS.

Under normal conditions, the Aquamax KF *Portable* should be ready for operation within 5 – 10 minutes after reassembly, however it could take up to 20 minutes before to completely stabilise if the drying procedure has not been properly carried out.

TROUBLESHOOTING

OVERTITRATION

Detector senses too much Iodine. Usually caused by old reagents or stirrer switched off. Check stirrer speed. Add 3-5 microlitres of water until detector bars activate, and allow to precondition.

EXCESS DRIFT

Indicates excess moisture ingress or condensation on cell walls. Switch OFF. Remove titration cell from clamp and gently swirl anode reagent around the cell walls. Reconnect, switch ON, and allow to Precondition.

LONG PRECONDITIONING TIME

Normally caused by glassware not being sufficiently dried before assembly. Re-clean glassware and electrodes, dry thoroughly and charge with fresh reagents.

PROGRESSIVELY LOWER RESULTS FOR SAME SAMPLE

Moisture contamination of syringe. Flush syringe and needle with sample several times before beginning new test.

POOR REPEATABILITY FOR SAME SAMPLE

Sample size probably too small or moisture contamination of syringe. Increase sample size and flush syringe and needle several times before beginning new test.

WARNING LETTERS ON PRINT OUT

Warning letters will be printed after time of each analysis to signify the following:-

U – Uncalibrated, E – Calibration expired, B – Battery level low, A – ACE system active

Call G.R. Scientific Ltd or your local dealer for suggestions on sampling technique for your application.

E-mail: info@grscientific.com

TEL: +44 1525 404747 FAX: +44 1525 404848

INSTRUMENT CARE

Although the instrument casing is highly resistive to most solvents care should be taken to ensure that any spillage is wiped off immediately to avoid staining or possible damage to the paint surface.

WARRANTY

Under the conditions of our warranty, all faults which are proved to be due to material, construction or manufacturing defects, which occur within 36 months of the delivery date, will be repaired or replaced, (at our discretion), free of charge at our premises. Freight costs will be chargeable along with any inspection work which was not necessitated by manufacturing or material defects. Breakages of glassware or electrodes are not covered by this guarantee. In the event of instrument failure during the warranty period, written authorisation must be obtained from the manufacturer prior to shipping.

OTHER PRODUCTS IN THE GR SCIENTIFIC RANGE



Aquamax KF *ECO*

This is an economical entry level titrator which has single injection port glassware, full numeric keypad for data entry, results manager software for data storage and retrieval. For use with generator electrodes either with or without frit. This small footprint unit offers excellent value.



Aquamax KF *Plus*

This is the truly versatile model which includes a built-in battery and printer to enable use in areas where the power supply is irregular. Low Drift Cell twin port glassware, results manager software and accessories are supplied as standard. As well as being a stand-alone instrument, the Aquamax KF *Plus* can be combined with our Oil Evaporator or a Solids Evaporator system. Suitable for a wide range of applications the Aquamax KF *Plus* can be used to determine water contents of liquids, gases and solids.



Aquamax KF *Oil Evaporator*

For combined operation with the Aquamax KF *Plus* titrator to determine water content of additives, lube oils, base oils, automatic transmission fluids, hydrocarbon solvents, and other petroleum products.



Aquamax KF *Solids Evaporator*

For combined operation with the Aquamax KF *Plus* titrator to determine water content of solids such as plastics, nylons, paper, powders, etc.

Aquamax KF *Volumetric*



An adaptable titrator capable of titrating with superior accuracy and precision even for samples with low moisture content. Dual syringes enable the operator to dispense titrant and standard automatically eliminating cell opening which may introduce moisture to the system. The Aquamax KF Volumetric comes equipped with a solvent handling system to reduce cell conditioning time and can be connected directly to your laboratory balance via serial interface. Choose from four pre-programmed methods or develop a custom method for almost any application or sample type.

microTAN *Titrator*



An innovative micro system for measuring Total Acid Number which enables the user to save up to 75% of organic solvent per sample analysis compared to standard potentiometers. Supplied with an optimized titration vessel and micro combination electrode that regenerates to optimum efficiency in minutes and offers excellent stability for non-aqueous titrations.

microTAN *OPS Workstation*



Everything you need in one footprint and transportable! The MicroTAN workstation is an organised workspace containing all equipment and chemicals required to run your samples. MicroTAN unit, chemicals and accessories are contained in a sturdy outer case with a firm foam lining in an ergonomic arrangement. Optional accessories include a bottle top dispenser for dedicated dispensing of titration solvent and a mini thermal printer.

TitraMax *Titrator*



Is a simple, versatile yet robust potentiometer for measuring TAN, TBN, mercaptan sulphur and analysis of petroleum products. Pre-programmed methods that conform to ASTM standards and an interchangeable burette system with intelligent volume recognition are key features of the Titramax. In addition each unit is supplied with bespoke UK manufactured electrodes for optimum performance and reproducible results.

E-chem *pH & Conductivity meters*



The E-chem range of pH/conductivity benchtop meters have been developed to provide cost effective, robust and simple to use solutions for your needs. The E512 pH meter offers research grade specifications with a comprehensive range of features and functions, ideal for general laboratory, QC and GLP based applications. Producing rapid and reliable results that are accurate and reproducible, are paramount in all field and laboratory environments. All products within the E-chem series cover a wide range of applications in areas including, food and beverage, water, environmental, power and petrochemical industries

E-chem *electrodes, buffers, standards*



We offer a range of combined pH, glass, epoxy tough and reference electrodes for every application and budget. All of our electrodes are manufactured in the UK so you are guaranteed. Uncompromised quality and fast delivery

For accurate pH and conductivity measurements, we offer certified standards traceable to NIST and are tested using ISO 17025 accredited method. Our conductivity standards have an accuracy of $\pm 1.0\%$ and their shelf life is valid regardless of when the bottle was first opened, provided good laboratory practice is adhered to. Our pH Buffers are manufactured to exacting specifications according to NIST with an extended shelf life. Temperature dependence data is printed on the labels as are lot numbers and expiry dates.

GR Scientific Service

We want you to maximise the return on your equipment through a service program tailored to your requirements from when you purchase our equipment which includes:

- Support and repair
- Maintenance and calibration
- Training and installation
- Quality assurance and certification

Our dedicated service staff are on hand to help in the unlikely event that your equipment develops a fault. Please contact us using the details provided below to discuss the next step.

For further information about any of our products, pricing or details about local representatives, just contact

Telephone: +44 (0) 1525 404747 **Fax: +44 (0) 1525 404848**
Email: info@grscientific.com **Web: www.grscientific.com**