



amine experts

**Subject: Amine Analytical Service Program
Analysis Report**

Amine Experts has developed outstanding capabilities for the laboratory analysis and evaluation of amine samples. This analysis and evaluation can provide valuable information to evaluate and troubleshoot the performance of the amine system. When these analyses are carried out on a regular basis, a very valuable operating history is established, which significantly speeds up troubleshooting.

Amine Experts' analysis report includes:

- Mass Balance Closure
- Several built in cross checks on the results
- Trend analysis
- Comments on the significance of the results
- Target values for most of the parameters

Analysis Options Include

Basic

Amine concentration, viscosity, heat stable amine salts, H₂S loading, ash content, suspended matter, pH, metal scan (Fe, Mn, Cr, Ni, K, Na), water content, visual appearance, mass balance, evaluation report and targets.

Basic Plus

All analyses in the Basic analysis, plus CO₂ loading, ion chromatographic (IC) analysis of all organic and inorganic acids, density and GC analysis of the solvent to identify degradation products.

Others

Hydrocarbon content and distribution, foam test, bicine, sulfolane.

An Amine Experts Analysis Request form is attached with sample shipping instructions.

Amine Experts Inc.

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www.AmineExperts.com

Amine Analysis Request Form:

Company name & address: _____

Company Representative: _____

Phone: _____

Fax: _____

Amine System Name: _____

Location: _____

Amine System Volume: _____ m³

Amine Type: _____

Analysis Required

Basic

Basic Plus

Other (specify) _____

Sample Preparation

Sample quality:

- well regenerated lean amine, which is almost free of H₂S.
- *Rich amine samples must not be shipped for analysis.*

Sample packing:

- amine samples should be shipped in sealed glass bottles.
- sample size - 0.5 litre
- sample bottle should be filled almost to the top, leaving just enough volume for liquid expansion.
- bottle must be properly protected in an appropriate shipping container with MSDS (Material Safety Data Sheet) attached.
- bottle must be labelled, indicating the time, day and location (unit) that the sample was taken.

Sample Shipment:

- amine samples for laboratory analysis should be sent by DHL or TNT courier (use of a courier can save as much as two weeks in transportation time).
- Please advise Amine Experts by e-mail of any shipment and include the courier waybill number.

Amine Experts

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