

**CATION EXCHANGER MIXED MATRIX
MEMBRANE (MMM) FOR LEAD (II) REMOVAL
FROM WASTEWATER**

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CATION EXCHANGER MIXED MATRIX MEMBRANE (MMM) FOR LEAD (II)
REMOVAL FROM WASTEWATER

NURUL FARHANA BINTI MOHAMED BASRI

Thesis submitted in fulfillment of the requirements
for the award of the degree of
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MAC 2012

SUPERVISOR'S DECLARATION

I hereby declare that I have checked this thesis and in my opinion, this thesis is adequate in terms of scope and quality for the award of the degree of Bachelor of Chemical Engineering

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STUDENT'S DECLARATION

I hereby declare that the work in this thesis is my own except for quotations and summaries which have been duly acknowledged. This thesis has not been accepted for any degree and is not concurrently submitted for award of other degree.

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DEDICATION

In The name of Allah, most gracious, Most Merciful

Love special dedicate to...

Special inspiring and special encouraging of my lovely parent: Mohamed Basri Bin Husain
and Ramlah Binti Zakaria;

My siblings, my friends, my fellow course mates and all faculty members.

Those who has influenced my life on the right course

Thank you so much

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ABSTRACT

Many toxic heavy metals have been discharged into the environment as industrial wastes everyday. In all over the world, industry is forced by the regulation body to diminish down the heavy metal content to the acceptable level in their wastewaters effluents. In the current research, cation exchanger mixed matrix membrane (MMM) was developed for the lead (Pb) removal from wastewater. A list of commercial cation resin was screened for highest Pb removal. These resins include Dowex M-31, Dowex MAC-3, Amberlite IR-120, Lewatit SP 112, Amberlite IRC-86, Lewatit TP-214, Amberlite IRN-150 and Dowex Marathon MSC. Dowex M-31 cation resin was incorporated into ethylene vinyl alcohol based polymer at different resin loading range from 10 – 30 weight % to prepare cation MMM. In a batch experiment, several parameters were optimized including Pb (II) concentration between 100 to 2000 mg/L, pH between 1 to 8, contact time between 3 to 12 hours and the amount of adsorbent from 0.1 to 1 g. Adsorption isotherm for the cation MMM and ground resin were follow to Langmuir isotherm. The increase in resin loading will increase the binding capacity of cation MMM up to a limitation of 50 wt% resin loading. The concept of MMM was successfully expanded to the application of heavy metal removal.

ABSTRAK

Setiap hari banyak toksik logam berat telah dilepaskan ke alam sekitar sebagai bahan buangan industri. Di seluruh dunia, badan pengawal seliaan menghadkan pengeluaran kandungan logam berat ke tahap yang diterima dalam sisa buangan mereka. Di dalam penyelidikan ini, *mixed matrix membrane* (MMM) penukar cas positif telah di bangukan untuk menyingkirkan plumbum (Pb) dari sisa air kumbahan. Beberapa jenis resin penukar cas positif komersial telah di uji untuk penyingkiran plumbum tertinggi seperti Dowex M-31, Dowex MAC-3, Amberlite IR-120, Lewatit SP 112, Amberlite IRC-86, Lewatit TP-214, Amberlite IRN-150 dan Dowex Marathon MSC. Dowex M-31 telah dicampurkan ke dalam polimer etilena vinilalkohol (EVAL) berdasarkan muatan resin yang berbeza-beza dari peratusan 10-30% berat cecair polimer untuk menyediakan MMM) penukar cas positif. Beberapa parameter telah dilakukan ujikaji seperti kepekatan Pb (II) antara 100 hingga 2000 ppm, masa penjerapan di antara 3-12 jam dan jumlah bahan penjerap antara 0.1-1 g. Ukuran penyerapan MMM penukar cas positif dan resin mengikut hubungan Langmuir. Peningkatan jumlah resin di dalam membran meningkatkan keupayaan muatan resin untuk penyikiran sehingga muatan maksimum 50% resin. Konsep MMM telah berjaya di luaskan dalam aplikasi penyingkiran logam berat.

TABLE OF CONTENT

CHAPTER	TITLE	PAGE
	SUPERVISOR’S DECLARATION	ii
	STUDENT’S DECLARATION	iii
	DEDICATION	iv
	ACKNOWLEDGEMENT	v
	ABSTRACT	vi
	ABSTRAK	vii
	TABLE OF CONTENTS	viii-x
	LIST OF TABLES	xi
	LIST OF FIGURES	xii-xiii
	LIST OF EQUATIONS	xiv
	LIST OF ABBREVIATIONS	xv
1	INTRODUCTION	1
	1.1 Background	1-2
	1.2 Problem Statement	3
	1.3 Objective	3
	1.4 Scopes of Study	4

2	LITERATURE REVIEW	5
2.1	Ion Exchanger	5
2.2	Resin Types	6-7
2.3	Comparison Technologies for Heavy Metal Removal	7-9
2.4	Membrane Process Use for Heavy Metal Removal	10
3	METHODOLOGY	11
3.1	Materials	11
3.2	Resin Screening	12
3.3	Preparation of Mixed Matrix Membrane	13-14
3.4	Batch Adsorption Experiment	15
3.5	Determination of Adsorption Isotherm	15-16
3.6	Regeneration of Membrane	16
3.7	Preparation of Standard Curve	16
4	RESULT AND DISCUSSION	17
4.1	Screening of Cation Resin	17-18
4.2	Absorption Isotherm	18-19
4.3	Effect of Cation Loading in MMM	20-21
4.4	Regeneration of Membrane	21-22

5	CONCLUSION	23
	5.1 Conclusion	23
	5.2 Recommendations	24
	REFERENCES	25-27
	APPENDICES	28-45

LIST OF TABLES

Table No.	Title	Page
2.1	Selectivity of Ion Exchange Resins	7
2.2	Comparison of technologies to heavy metal removal from wastewater	8
3.1	List of Commercial resin	12
3.2	Properties of resin Dowex M-31	13
4.1	Cation resin properties and price	18
4.2	Binding capacity of ground resin, mixed matrix membrane (MMM) 30% loading and ethyl vinyl alcohol (EVAL) membrane	19
4.3	Binding properties of mixed matrix membrane with different cation loading	20

LIST OF FIGURES

Figure No.	Title	Page
3.1	Preparation of Mixed Matrix Membrane	14
4.1	Capacity of ground cation resin for binding 35 ml of 1000 ppm lead (II)	17
4.2	Binding capacity versus equilibrium concentration for different format of Dowex M-31 based adsorbent	19
4.3	Binding capacity of mixed matrix membrane with different cation loading	21
4.4	Graph Recovery of Ground Resin and MMM	22
A.1	ResinScreening Analysis Part I	28
A.2	Resin Screening Analysis Part II	29
A.3	ResinScreening Analysis Part III	30
A.4	ResinScreening Analysis Part IV	31
A.5	ResinScreening Analysis Part V	32
A.6	ResinScreening Analysis Part VI	33
A.7	ResinScreening Analysis Part VII	34
A.8	ResinScreening Analysis Part VIII	35
A.9	Absorption Isotherm Analysis Part I	36
A.10	Absorption Isotherm Analysis Part II	37
A.11	Absorption Isotherm Analysis Part III	38
A.12	Absorption Isotherm Analysis Part IV	39

A.13	Absorption Isotherm Analysis Part V	40
A.14	Absorption Isotherm Analysis Part VI	41
A.15	Absorption Isotherm Analysis Part VII	42
A.16	Resin Loading Analysis Part I	43
A.17	Resin Loading Analysis Part II	44
A.18	Recovery Analysis	45

LIST OF EQUATIONS

Equation No.	Title	Page
3.1	Resin Loading	13
3.2	Absorption Lead Amount	15
3.3	Langmuir Adsorption Isotherm	15
3.4	Recovery	16

LIST OF ABBREVIATIONS

AAS	-	Atomic Absorption Spectroscopy
DMSO	-	Dimethyl sulfoxide
EVAL	-	Ethylene vinyl alcohol
MMM	-	Mixed Matrix Membrane

CHAPTER 1

INTRODUCTION

1.1 Background

Heavy metals are ordinary in industrial applications such as in the manufacture of pesticides, battery, alloys, electroplated metal parts, textiles dyes, and steel (Abo Farha et al., 2008). Many toxic heavy metals have been discharge into the environment as industrial wastes. Industry has been forced by the regulation authority to reduce the contents of heavy metal in their industrial wastewaters to the acceptance level. Excessive content of heavy metal in water or wastewater might give an adverse effect to the environment as well as human life such as kidney failure, nervous system damage and bone damage, and other serious illness (Sgarlata et al., 2008). Heavy metal toxicity can also result in break or reduced mental and central nervous function, lower energy levels, and damage to blood composition, lungs, kidneys, liver and other vital organs. However, in small quantities, certain heavy metals are nutritionally important for a healthy life. These metals are commonly found naturally in foodstuffs.

Several methods has been developed for removal heavy metals from wastewaters such as precipitation, coagulation, complexing, solvent extraction, ion-exchange, electrochemical reduction and membrane processes such as reverse osmosis, nanofiltration and electrodialysis (Smara et al., 2005). Most of these processes however required continuous input of chemicals, high cost and even incomplete metal removal (Ismael et al., 2011).

Adsorption is a very efficient process for a variety of applications, and now it is considered an economical and effective method for metal ions removal from

wastewaters. In general, adsorption is the process of collecting soluble substances that are in a solution, on a suitable interface. The interface can be between the liquid and a gas, a solid, or another liquid. Studies on the treatment of effluent bearing heavy metal have revealed adsorption to be a highly effective technique for the removal of heavy metal from waste stream and activated carbon has been widely used as an adsorbent. Despite its extensive use in the water and wastewater treatment industries, activated carbon remains an expensive material. In recent years, the need for safe and economical methods for the elimination of heavy metals from contaminated waters has necessitated research interest towards the production of low cost alternatives to commercially available activated carbon.

The potential absorption method by using of mixed matrix membrane is affordable and economical for effluents containing metal ions. Mixed matrix membrane requires absorption agents to enhance its performance, thus increasing treatment cost. Therefore, the need of alternative low-cost adsorbents has prompted the search for new and cheap sorption processes for wastewater treatment, as these materials could reduce significantly the wastewater-treatment cost.

Cation exchange resin is gained a significant interest among scientist mainly due to their unique properties on ion exchange capability. Large deposits of cation exchange resin in many countries provide local industries some promising benefits, such as cost efficiency, since they are able to treat wastewater contaminated with heavy metal at low cost. This cation exchange can be an adsorbent for mixed matrix membrane performance to remove heavy metal and also for repeated used by regenerate the cation exchange resin.

1.2 Problem Statement

Even though their large static adsorption capacity, conventional methods involved in heavy metal chromatographic separations are generally not able to operate at high linear velocities of the mobile phase. The pressure drop over the column is high even for low flow rates, and increases during the process time due to bed consolidation and plugging. The pressure drop in conventional chromatographic columns with particles diameter of 2 μm is usually high, up to 25MPa (Borneman et al., 2006).

In the recent years, membrane chromatography has gained considerable interest in adsorption-based process. In membrane chromatography, a short and wide chromatographic column is used in which the adsorptive membrane is stacked or packed in the module. In separation, the diffusion of the molecule into the adsorbent determines the adsorption limits of macromolecules from a liquid phase by adsorption into the porous media. Unlike to packed bed chromatography that depend on diffusional transport of solute molecule, membranes chromatography strongly controlled by convective transport of solute molecules. This results a shorter process times and could minimize the denaturation of the products. An ideal membrane support for application in chromatographic separation processes should be microporous to provide free interactions of molecules with the support. The membrane should be chemically and physically stable to resist to the conditions of adsorption, regeneration and should possess functional groups which provide interactions like ion exchange and affinity between the support and the solute molecules.

1.3 Objective

The main objective for this research is to produce cation exchanger mixed matrix membranes that are capable for lead removal from wastewater.

1.4 Scope of Study

The main scopes of this research are:

- (i) To screen the potential cation resin that can give high binding capacity to lead (II) removal from eight commercial cation resins.
- (ii) To produce an ethylene vinyl alcohol (EVAL) based MMM with different cation resin loading range from 10% - 30%.
- (iii) To determine adsorption isotherm for various type of absorbent including ground resin and MMM.
- (iv) To study different type of regeneration solution such as HCl, H₂SO₄, NaCl for the regeneration of MMM after the binding process.

CHAPTER 2

LITERATURE REVIEW

2.1 Ion Exchanger

Ion exchange is a reversible chemical reaction where an ions, atom or molecule that has lost or gained an electron and thus attained an electrical charge from solution is exchanged for a similarly charged ion attached to a stationary solid particle. This attraction may take place by direct contact with free metal anions, but that mechanism may be also absorbed in the sorption of metal, as a result of the interaction of metal cations with ligands in the solution. Actually, the formation of complexes, with ligands and/or OH^- influences the speciation of metals ions and thus the sorption efficiency and taking mechanism (Eric Guibal, 2004). These solid ion exchange particles are either naturally happen inorganic zeolites or synthetically generates organic resins. The synthetic organic resins are the major types used today because their characteristics can be fitted to specific applications.

Based on all the chromatographic methods, the most common used techniques in downstream processing are ion exchange. It is occupied for recovery and purification of proteins, polypeptides, nucleic acids, polynucleotides and other biomolecules. Ion exchange is advantageous in terms of wide applicability, high declaration and large adsorption capacity in large-scale protein purification processes. Another advantage of this technique is that the regeneration takes place under mild conditions (Saiful et.al., 2006).

2.2 Resin Types

There are variety of commercial ion exchange resins are available and have been applied in protein capturing, purifying and polishing steps (Saiful et al., 2006). Resins currently available exhibit a range of selectivity's and thus have wide application. Ion exchange resins are classified as cation exchanger, which has positively charged mobile ion available for exchange, and anions exchanger, whose exchangeable ion are negatively charged.

Resin can be classified as strong or weak acid cation exchanger or strong or weak base anion exchanger. Some example, cation exchange resin particles, Amberlite IR-12 styrene-divinyl benzene type of resin has an ion-exchange capacity of 4.4 meq/g dry resin (Kiyono et al., 2003). Mono-Plus SP112, a strong acidic, macroporous, cation-exchange resin with an average diameter of 10 micron. (Zhang et al., 2005). The chelating ion exchanger with iminodiacetate functional groups, Lewatit TP-207 is suggested by the Bayer company for selective removal of metal ions, mostly Pb (II) ions (Dabrowski et al., 2004). Selectivity is a guideline to the new types of ion exchangers with specific affinity to definite metal ions or groups of metals. Higher selectivity can gives a great exchangeability as well as reversibility of the sorption-elution process towards Pb (II). Frequently, cation-exchange is jointed with precipitation for Pb (II) removal from wastes (Lee and Hong, 1995). It should be emphasized that in most cases ion exchange enables replacing the undesirable ion by another one which is neutral within environment.

Table 2.1: Selectivity of Ion Exchange Resins

Strong acid cation exchanger	Strong base anion exchanger
Barium	Iodide
Lead	Nitrate
Calcium	Bisulfite
Nickel	Chloride
Cadmium	Cyanide
Copper	Bicarbonate
Zinc	Hydroxide
Magnesium	Fluoride
Potassium	Sulfate
Ammonia Sodium	
Hydrogen	

2.3 Comparison Technologies for Heavy Metal Removal

Many of studies have been made to avoid increases of heavy metal ions to human body and damages to environment. Several methods have been used to remove heavy metal ions, for examples, chemical precipitation, ion-exchange, adsorption, membrane filtration, and electro-chemical treatment technology. Adsorption using ion exchange is an effective and economic method for heavy metal removal from wastewater.

Activated carbon is the common used adsorbent although it is quite expensive. Many researchers have tried to find easily available adsorbents and low-cost in terms of economics to remove heavy metal ions, for examples, agricultural wastes, plant wastes, zeolites, and clays. Biosorption of heavy metals from aqueous solutions is a rather new process that has been established as a very talented process in the removal of heavy metal contaminants. The benefits of biosorption are its elevated efficient in reducing the heavy metal ions and the reasonably priced of biosorbents. Although biosorbents are characteristic in wide sources, the researchers are still in the theoretical and

experimental phase (Kyong-Soo Hong et al., 2010). Table 2.2 shown summarize of technologies to remove heavy metal from wastewater.

Table 2.2: Comparison of technologies to heavy metal removal from wastewater

Method	Advantages	Disadvantages
Chemical precipitation	<ul style="list-style-type: none"> • Simple • Inexpensive 	<ul style="list-style-type: none"> • Large amount of sludge produced • Disposal problem
Chemical coagulant	<ul style="list-style-type: none"> • Sludge settling • Dewatering 	<ul style="list-style-type: none"> • High cost • Large consumption of chemicals
Ion-exchange	<ul style="list-style-type: none"> • High regeneration of materials • Metal selective 	<ul style="list-style-type: none"> • High cost • Less number of metal ions removed
Electrochemical methods	<ul style="list-style-type: none"> • Metal selective • No consumption of chemicals • Pure metals can be achieved 	<ul style="list-style-type: none"> • High capital cost • High running cost • Initial solution pH and current density
Adsorption Using activated carbon	<ul style="list-style-type: none"> • Most of metals can be removed • High efficiency (99%) 	<ul style="list-style-type: none"> • Cost of activated carbon • No regeneration • Performance depends upon absorbent • Low efficiency
Adsorption Using natural zeolite	<ul style="list-style-type: none"> • Most metals can be removed • Relatively less costly materials 	<ul style="list-style-type: none"> • Low efficiency
Membrane process and ultrafiltration	<ul style="list-style-type: none"> • Less solid waste produced • Less chemical consumption • High efficiency (>95% for single metal) 	<ul style="list-style-type: none"> • High initial and running cost • Low flow rates • Removal (%) decreases with the presence of other metals

Source: Farouq et al (2010)

Solvent extraction, or liquid ion exchange removes the metal by contacting the solution with an organic reagent that will react with the metal ion and result in its exchange to a dissolved form in the solvent. For optimum operation, this method needs high initial metal concentrations and the environmental standards for acceptable metal levels in discharged water cannot be met with this method alone. It is more to operate it

with other treatment systems such as membranes. Solvent extraction of metals is commonly working for selective recovery (Mack et al., 2004).

Conventional ion exchange resins have been used with solvent extraction in the recovery of metals. The simple phase separation and high concentration efficiency of ion exchange pretence the disadvantages of solvent extraction, mainly the difficulty in phase separation. However, these ion exchangers are insufficient selective to remove certain metals from large volumes of additional metals and thus metal-selective resins are being constructed. Disadvantages of these methods are relatively expensive, requiring complicated equipment with high operation costs, such as the regeneration and / or disposal of the regeneration liquid and the spent resin, and large energy requirements. Resin usage causes a large environmental burden in terms of disposal (Lee et al., 1998).

Chemical precipitation is still the simplest and cheapest means of removing metals from solution. The increase in pH caused by the precipitant results in the immobilization of the metal ions in insoluble forms, either as a metal hydroxide or a metal sulphide (Eccles, 1999). Sodium hydroxide introduces the least amount of inert material to the sludge, but this becomes expensive in the long-term, as large volumes of effluent and metal-laden sludge are produced and must be treated daily (Van Hille et al., 1999).

Membrane processes involving the removal of heavy metals from solution are mainly limited to those that require a membrane as a pretreatment filtration device linked to a second removal mechanism. An example of this is a combination of membrane technology and solvent extraction suggested by Kentish and Stevens (2001) in which metal is removed from industrial wastewater. In this example, the membrane is placed between the waste stream and the solvent stream and mass transfer of the selected chemical species occurs across the membrane into the solvent (Mack et al., 2004).

2.4 Membrane Process Use for Heavy Metal Removal

Membrane separation have been earlier used in order to retain metallic cations and the filtration was performed using chelating reagents as additives in the feed by increasing the size of the solute to be retained. In ultrafiltration, the more often used chelating polymer are poly-acrylic acid and polyethylenimine and their derivatives but natural chelating ligand as alginate and chitosan were also used. The filtration assisted by complex formation is extended to nanofiltration. In such type of filtration, the chelating ligand had to be regenerated in the final step of the process, before recycling, in order to minimise waste amounts. Consequently, to overcome this step, the recent studies involve membranes bearing the chelating groups (Anne Bougen et al., 2001).

Reverse osmosis membranes used have an opaque barrier layer in the polymer matrix where most separation occurs. Mostly, the membrane is designed for water to pass through this dense layer while preventing the passage of solutes (such as salt ions). This process needs a high pressure to be applied on the high concentration side of the membrane (Bakalár et al., 2009).

CHAPTER 3

METHODOLOGY

3.1 Materials

EVAL (a random copolymer of ethylene and vinyl alcohol) with an average ethylene content of 44 mol% was purchased from Aldrich and was used as membrane material without further modification. Dimethylsulfoxide (DMSO, Merck) was employed as solvent and 1-octanol (Fluka) as non solvent additive in the casting solution. Water was used as non-solvent in the coagulation bath. Commercial cation resin which are Dowex M-31, Dowex Marathon MSC, Dowex Mac-3 (Sigma-Aldrich), Amberlite IR 120, Amberlite IRN 150, Amberlite IRC 86, Lewatit MonoPlus TP 214 and Lewatit MonoPlus SP 112 (Fluka) were used as a potential adsorbent particle in screening experiment. Resins were freeze-dried to remove moisture and then were grinded and fractionated down to a fraction with an average size of 45 μm . Hydrochloric acid (HCl), sulfuric acid (H_2SO_4) was purchased by Fisher Chemical and sodium chloride (NaCl, Merck) are used for the regeneration of MMM adsorbers. Lead (II) solution was prepared by dissolving lead (II) nitrate (PbNO_3) powder in water.

Buffer solutions were freshly prepared in ultra pure water. Ultra purewater was prepared using a Millipore purification unit Milli-Q plus. The buffers used for washing were phosphate buffer at pH 7.

3.2 Resin Screening

The list of resin used in screening experiment is showed in Table 3.1. The resin was freeze dried and then grinded using ultra centrifugal grinder to obtain a particle fraction small than 0.45 μ m.

Approximately 0.05g dried ground resin was used in the screening experiment with triplicate run. The resin was equilibrate with phosphate buffer solution (pH 7) for about 3 hours in centrifuge test tube. The buffer was removed by centrifugation at 12000 rpm about 20 minutes to settle down the resin. Lead (II) nitrate solution (1000 ppm) was added to the tube and bind on rotator for about 12 hours. The remaining lead concentration was checked by atomic absorption spectrometer (AAS). The binding capacity for each resin is expressed by the amount of lead bound per gran of resin used.

Table 3.1 List of Commercial resin

Commercial resin	Functional Group	Matrix
LewatitMonoPlus TP214	Thiourea	Styrene divinylbenzene, macroporous
LewatitMonoPlus SP112	Sulfonic acid	Crosslinked polystyrene
Amberlite IRN 150	Sulfonic acid	Styrene divinylbenzene copolymer
Amberlite IR 120	Sulfonic acid	Styrene divinylbenzene copolymer
Amberlite IRC 86	Carboxylic acid	Gel polyacrylic copolymer
Dowex Mac-3	Carboxylic acid	Polyacrylic, macroporous
Dowex M-31	Sulfonic acid	Styrene divinylbenzene, macroporous
Dowex Marathon MSC	Sulfonic acid	Styrene divinylbenzene, macroporous

3.3 Preparation of Mixed Matrix Membrane.

Dowex M-31, properties shown in Table 3.2, was selected from the resin screening experiment as absorbent in MMM. The composition of base membrane polymer solution is 15 wt% EVAL and 15% 1-octanol in DMSO. The cation resin loading in the EVAL solution was calculated using Equation 3.1.

$$\text{Resin loading (\%)} = \frac{W_{\text{resin}}}{W_{\text{resin}} + W_{\text{polymer}}} \times 100 \quad (\text{Equation 3.1})$$

Where W_{resin} is the mass of resin (g), W_{polymer} the mass of polymer contain 15% EVAL (g)

Table 3.2: Properties of resin Dowex M-31 (DOWEX Resins Design Guidelines)

Recommended Operating Conditions for DOWEX Strong Acid Cation Resins	
Maximum operating temperature:	120-150°C (250°F) gel Type I 50°C (300°F) macroporous type
pH range	0-14
Swelling Na → H	5-8%
Bed depth, min.	800 mm (2.6 ft)
Flow Rates:	
Service / Fast Rinse	5-60 m/h (2-24 gpm/ft ²)
Service / condensate polishing	75-150 m/h (30-60 gpm/ft ²)
Backwash	10-25 m/h (4-10 gpm/ft ²)
Co-current regeneration / displacement rinse	1-10 m/h (0.4-4 gpm/ft ²)
Counter-current regeneration / displacement rinse	5-20 m/h (2-8 gpm/ft ²)
Total rinse requirement	2-6 Bed Volumes
Regenerant:	1-8% H ₂ SO ₄ 4-8% HCl 8-12% NaCl

The preparation step involved in casting MMM is showed in Figure 3.1. The EVAL polymer solution and cation resin mixtures were stirred over night at 50 °C and 200 rpm to form a homogenous slurry solution for membrane casting. The bubble in the casting solution was removed by ultrasonic bath at 50°C until all the bubbles was completely disappeared. The casting solution was spread on glass plate by using a casting block, which has 0.45µm gap between the block and the glass plate. The gel formed on glass plate was immersed into a water coagulation bath at room temperature to form a solidified membrane. The membranes were washed with tap water at room temperature to remove residual solvent and then dried using freeze-dryer.

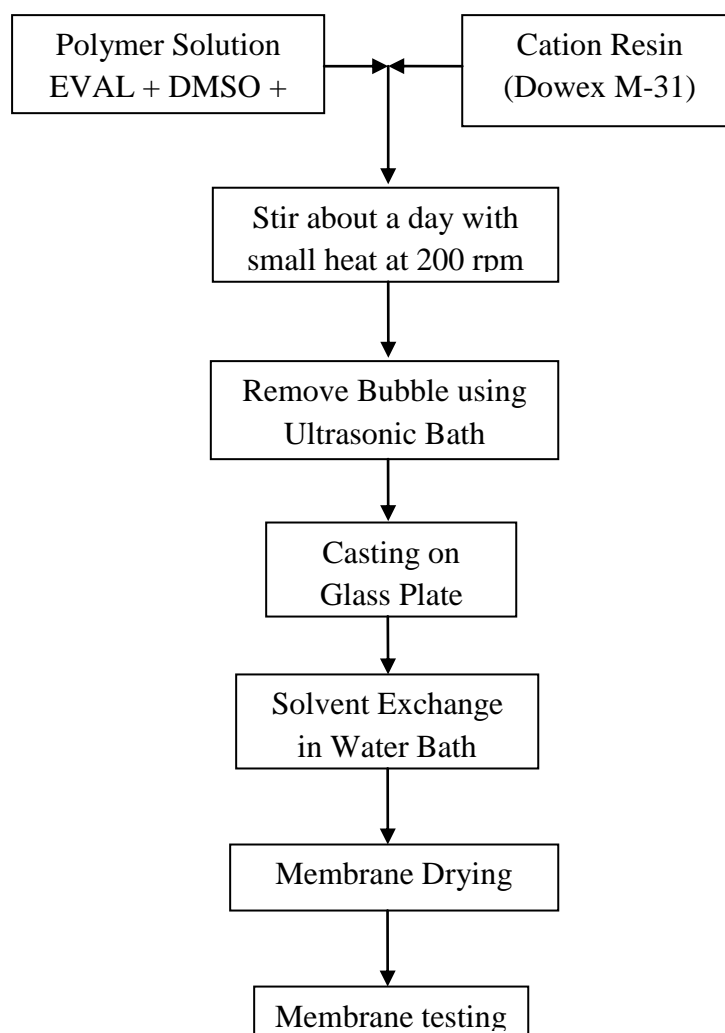


Figure 3.1: Preparation of mixed matrix membrane

3.4 Batch Adsorption Experiment

The adsorption capacities of cation exchange membrane was determined by batch experiments. Lead concentrations of 100-2000 ppm are employed in the adsorption experiments. A known weight of membrane is immersed overnight in ultra-pure water to ensure a steady inner structure during the experiments and afterwards transferred in the lead solution. The lead solutions are prepared using phosphate buffer solutions with pH 7. The samples containing a known concentration of lead are incubated with an exact amount of membranes in a 15 ml or 50 ml centrifuge tube under continuous rotating at 25 °C. The lead adsorbs on the membrane adsorbers thereby reducing the lead concentration in the bulk solution until equilibrium is reached. The equilibrium lead concentration was determined by atomic absorption spectrometer analysis after 24 h. The adsorbed lead amount, q_{eq} (mg lead/g membrane), at equilibrium is calculated by Equation 3.2:

$$q_{eq} = \frac{(C_0 - C_{eq})V}{W_{membrane}} \quad (\text{Equation 3.2})$$

where C_0 is the initial lead concentration (ppm), C_{eq} the lead concentration at equilibrium (ppm), V the volume of the solution (ml) and $W_{membrane}$ is the weight of the dry membrane (g).

3.5 Determination of Adsorption Isotherm

The adsorption isotherm was determined similar with batch experiment by binding the membrane with 8 different initial lead concentrations from 100ppm to 1500ppm. The final concentration and the binding capacity of the membrane were calculated. The data was fitted with Langmuir adsorption isotherm as shown in Equation 3.3:

$$\frac{1}{q} = \frac{1}{q_m} + \frac{K_d}{q_m} \times \frac{1}{c} \quad (\text{Equation 3.3})$$

Since the parameters q (the heavy metal concentration into the adsorber membrane) and c (the heavy metal concentration in the bulk solution) at equilibrium are experimental data, a plot of $1/q$ versus $1/c$ allows to determine the dissociation constant K_d and the maximum adsorption capacity q_m using a linear curve fitting.

3.6 Regeneration of Membrane

Three regeneration solutions were tested for recovery of bound lead from the membrane. These solutions are hydrochloric acid (HCl), sulfuric acid (H₂SO₄) and sodium chloride (NaCl) which have a concentration of 8% each. The ground resin and membrane was incubated with 500ppm lead overnight. The equilibrium concentration was checked by AAS and the amount of lead bound was calculated. The adsorbent was then incubated with regeneration solution for 30 minutes and the lead released into the solution was checked by AAS. The lead recovery was calculated Equation 3.4:

$$\text{recovery} = \frac{\text{mass of Pb (II) released in regeneration solution}}{\text{mass of Pb (II) bound onto the adsorbent}} \quad (\text{Equation 3.4})$$

3.7 Preparation of Standard Curve

Polarized Zeeman Atomic Absorption Spectrophotometer (Model Z-5000 Series) was used to measure the concentration of lead in solution. AAS standard curve for lead (II) was prepared by serial dilution of Pb NO₃ solution into a range of 0 ppm, 3.75 ppm, 7.5 ppm, 15 ppm, 30 ppm and 60 ppm. This solution was added a small volume of nitric acid to make the solution acidic to preserve the solution.

CHAPTER 4

RESULT AND DISCUSSION

4.1 Screening of Cation Resin

Eight cation resins were screened as potential absorbent in MMM. Figure 4.1 showed the binding of these resin to lead (II). Apart from binding capacity, other factor such as pricing also critical in selecting the resin to be used in MMM. Four resin was shortlist based on highest binding capacity which are Lewatit MonoPlus TP 214, Lewatit MonoPlus Sp 112, Dowex M-31 and Amberlite IR 120 as shown in Table 4.1. Based on price, Dowex M-31 was selected for further study in making cation exchange mixed matrix membrane for lead (II) removal.

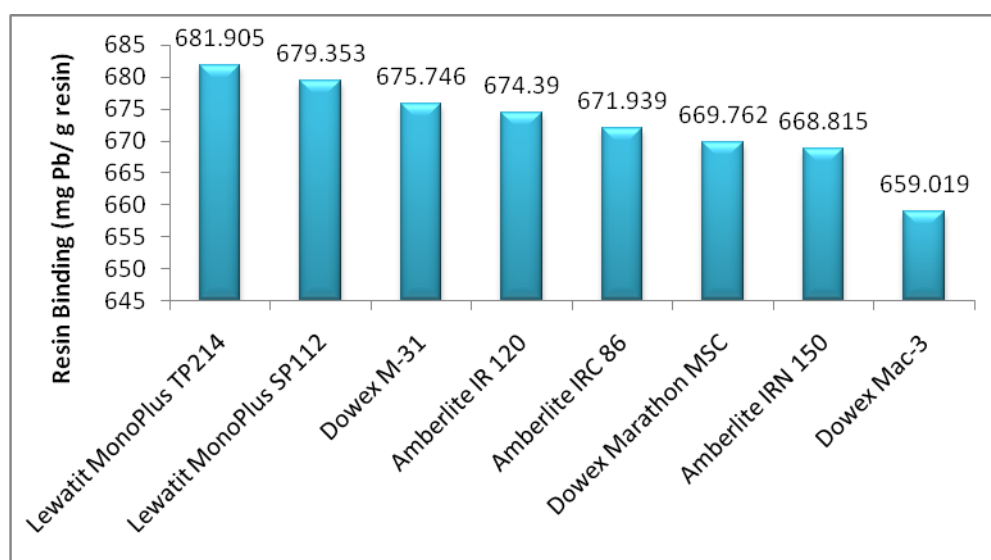


Figure 4.1: Capacity of ground cation resin for binding 35 ml of 1000 ppm lead (II) solution for 24 hour.

Table 4.1: Cation resin properties and price

Resin	Average mg Pb bound/g resin	Type	Ionic form	Functional group	Matrix	Particle density (g/ml)	pH range	Regenerant	price /kg (USD/MYR)
Lewatit monoplus TP 214	681.905	strong acid cation	NA	thioarea	crosslinked polystyrene	1.1	0-10	NA	2609.9/kg
Lewatit Monoplus SP 112	679.353	strong acid cation	Na+	sulfonic acid	crosslinked polystyrene	1.24	0-14	HCl , H ₂ SO ₄ NaCl	541.96/kg
Dowex M-31	675.746	strong acid cation	H+	sulfonic acid	styrene divinylbenzene, macroporous	0.76	0-14	1-8% H ₂ SO ₄ 4-8% HCl 8-12% NaCl	203.49/kg
Amberlite IR 120	674.39	strong acid cation	H+	sulfonic acid	styrene divinylbenzene copolymer	>1 (vs air)	0-14	5-8% HCl 0.7-6% H ₂ SO ₄	295.98/kg

4.2 Adsorption Isotherm

Pb (II) was strongly adsorbed to Dowex M-31 cation resin for all forms of the resins. More than 98% of the Pb (II) was removed from the test solution with an initial concentration ranging from 100 to 1500 ppm in a 24-h incubation time as shown in Table 4.2.

The adsorption isotherm of the ground resin and MMM were found to be Langmuir type isotherm as shown in Figure 4.2. Typical lead (II) binding capacity was in the range of 1 000-30 000 mg Pb bound/ g resin. The ground resin has the highest binding capacity because it is mainly a pure cation resin. The MMM 30% showed a capability to adsorb lead (II) due to the presence of Dowex M-31 resin. EVAL itself has a relatively low binding capacity toward lead in the solution.

Table 4.2: Binding capacity of ground resin, mixed matrix membrane (MMM) 30% loading and ethyl vinyl alcohol (EVAL) membrane

GROUND RESIN		MMM 30%		EVAL	
Average Final Conc,ppm	mg Pb bound/ g resin	Final Conc, ppm	mg Pb bound/g resin	Average Final Conc,ppm	mg Pb bound/ g resin
161.41	28886.25	141.70	17744.56	156.48	17841.62
156.43	24990.89	128.97	15834.63	155.69	15701.80
108.40	19195.32	111.64	13910.86	153.67	14012.66
74.45	17235.57	84.75	11786.00	146.75	11913.15
3.86	13476.30	61.74	9804.99	125.47	9908.19
0.00	9622.09	31.89	5931.12	94.41	5919.52
0.00	5769.78	18.56	1986.49	10.30	1944.52

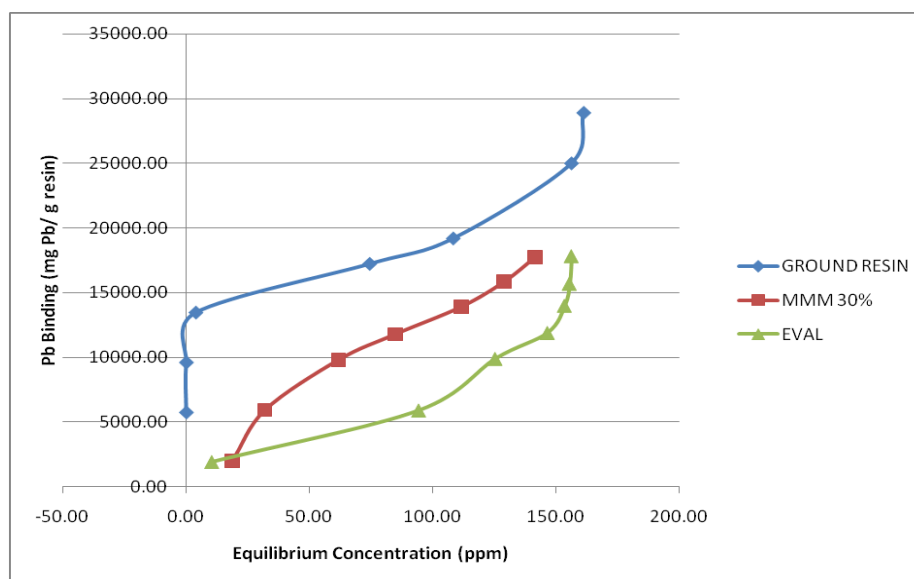


Figure 4.2: Binding capacity versus equilibrium concentration for different format of Dowex M-31 based adsorbent

4.3 Effect of Cation Loading in MMM

Based on results showed in Table 4.5 and Figure 4.3, the binding capacity increase with increasing the resin loading. MMM with 30% resin loading showed the highest binding capacity compare to 20% and 10%. However, further increase of resin loading to 45% was not feasible because the casting solution become too viscous and difficult to form a membrane.

Table 4.5: Binding properties of mixed matrix membrane with different cation loading

MMM 30%		MMM 20%		MMM 10%	
Final Conc, ppm	mg Pb bound/g resin	Final Conc, ppm	mg Pb bound/g resin	Final Conc, ppm	mgPb bound/ g resin
141.70	17744.56	156.73	17566.52	161.31	17809.13
128.97	15834.63	156.29	15795.16	159.13	15952.26
111.64	13910.86	146.17	13956.15	151.78	13789.00
84.75	11786.00	124.93	11820.67	149.18	11743.86
61.74	9804.99	112.30	9770.89	131.91	9920.74
31.89	5931.12	61.88	5957.61	82.56	5939.59
18.56	1986.49	27.41	1956.56	37.33	1988.80

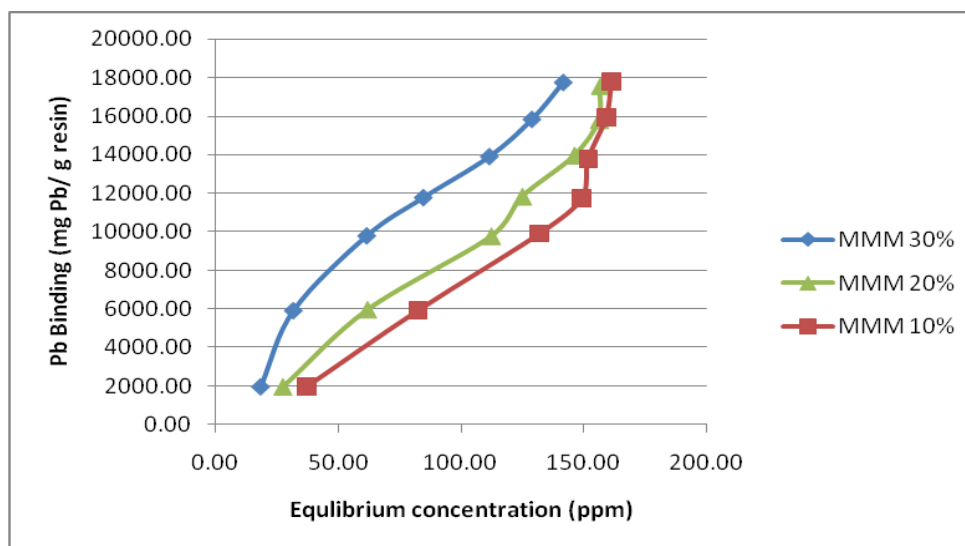


Figure 4.3: Binding capacity of mixed matrix membrane with different cation loading

4.4 Regeneration of Membrane

Three different regeneration solutions were tested for recovery of bound lead which are HCl, H₂SO₄ and NaCl. Each solution prepared at 8% concentration and incubated with the MMM bound with lead for about 30 minutes. All solutions gave a recovery about 98-99% lead (II) as shown in Figure 4.4. Based on environmental factors, NaCl can be more suitable for use as a regeneration agent for lead recovery.



Figure 4.4: Graph Recovery of Ground Resin and MMM

CHAPTER 5

CONCLUSION AND RECOMMENDATIONS

5.1 Conclusion

Mixed matrix membrane (MMM) was successfully applied for wastewater application for removing lead (II). The effects of various parameters like resin selection, resin loading and regeneration of membrane were studied. Among the resins screened Dowex M-31 was selected based on high binding capacity around 675 mg Pb/g resin and low cost of adsorbent. The adsorption isotherm of the ground resin and MMM were found to be Langmuir type isotherm. Typical lead (II) binding capacity was in the range of 1 000-30 000 mg Pb bound/ g resin.

The binding capacity increase with increasing the resin loading. MMM with 30% resin loading showed the highest binding capacity compare to 20% and 10% loading. However, further increase of resin loading to 45% was not feasible because the casting solution become too viscous and difficult to form a membrane. Three different regeneration solutions was tested for recovery of bound lead which are HCl, H₂SO₄ and NaCl. Based on environmental factor and recovery percentage, NaCl can be more suitable for used as regeneration agent for lead recovery. The concept of MMM that been used extensively in preparing membrane for gas separation and protein separation, can be expand to produce cation exchanger membrane for heavy metal removal. The MMM provide a very good platform for application of heavy metal removal.

5.2 Recommendations

There were several recommendations that can be taken for further study in order to improve the efficiency of MMM in heavy metals removal.

- i. Prepared and characterize MMM using another type of polymer such as polysulfone, polyethylene mine, polyvinyl alcohol.
- ii. Produce MMM with different composition of EVAL based membrane casting solution and study the performance for lead removal
- iii. Optimizing the pH in order to get the ideal pH for operation of heavy metals removal.
- iv. Mixed more than one cation resin into membrane to extend the adsorption for other metals.
- v. Ion-exchange resin must be grind to very small pieces to get more surface area and improve adhesion in the membrane matrix.
- vi. Used a proper casting machine to get more efficient membrane structure.

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APPENDIX A

AAS ANALYSIS RESULT

A.1 Resin Screening Analysis

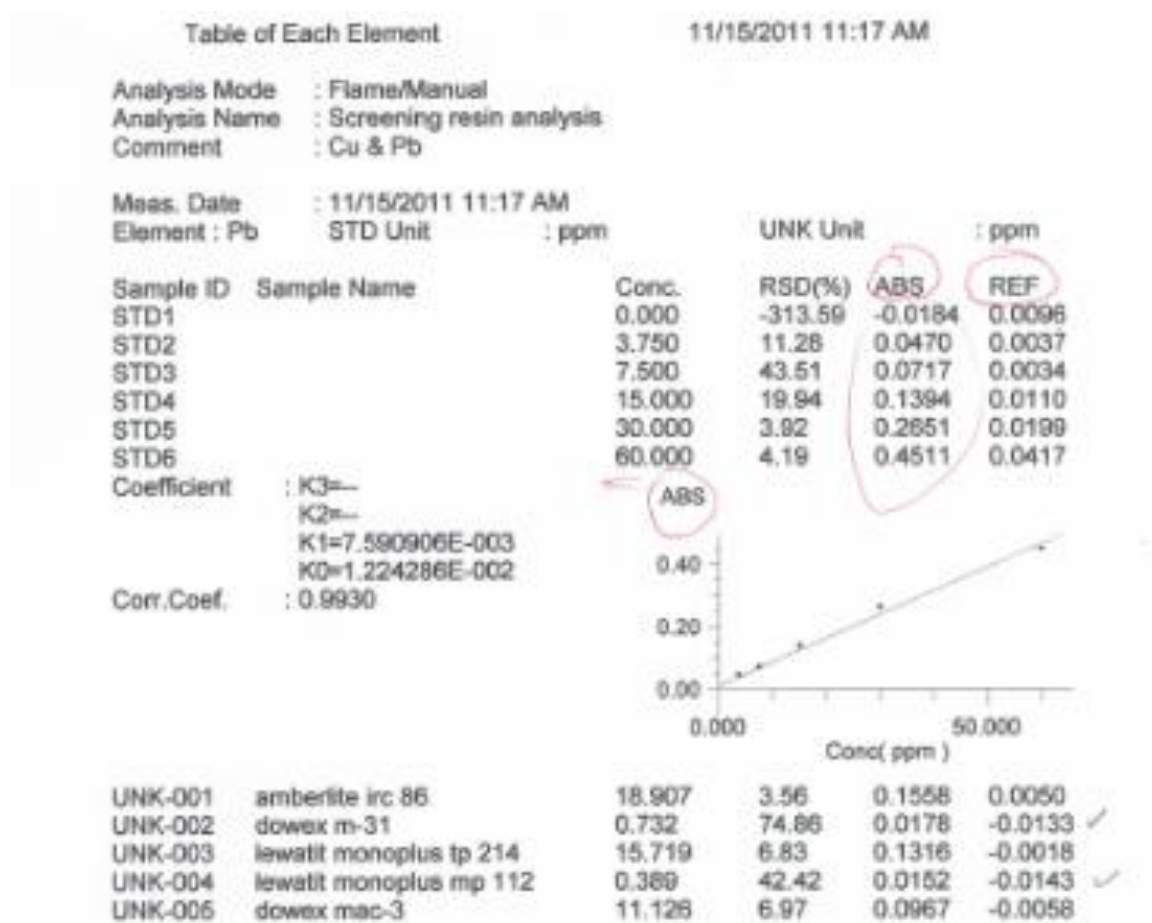


Figure A.1: Resin Screening Analysis Part I

Table of Each Element

11/16/2011 11:13 AM

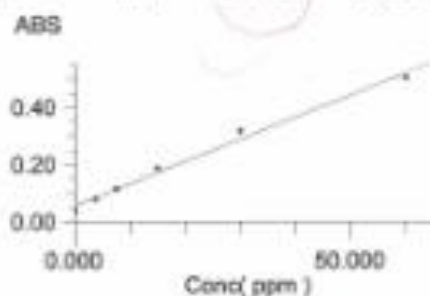
Analysis Mode : Flame/Manual
 Analysis Name : Screening resin analysis
 Comment : Cu & Pb

Meas. Date : 11/16/2011 11:13 AM
 Element : Pb STD Unit : ppm

UNK Unit : ppm

Sample ID	Sample Name	Conc.	RSD(%)	ABS	REF
STD1		0.000	5.13	0.0390	0.0204
STD2		3.750	2.56	0.0781	0.0185
STD3		7.500	3.92	0.1149	0.0180
STD4		15.000	0.32	0.1873	0.0197
STD5		30.000	0.44	0.3169	0.0323
STD6		60.000	2.11	0.5027	0.0590

Coefficient : K3=
 K2=
 K1=7.719102E-003
 K0=5.602572E-002
 Corr.Coef. : 0.9944



UNK-001	dowex marathon msc	-2.301	-10.26	0.0392	0.0046
UNK-002	amberlite ir 120	-2.685	-13.41	0.0362	0.0061
UNK-003	amberlite im 150	-1.394	-72.24	0.0462	0.0008

Figure A.2: Resin Screening Analysis Part II

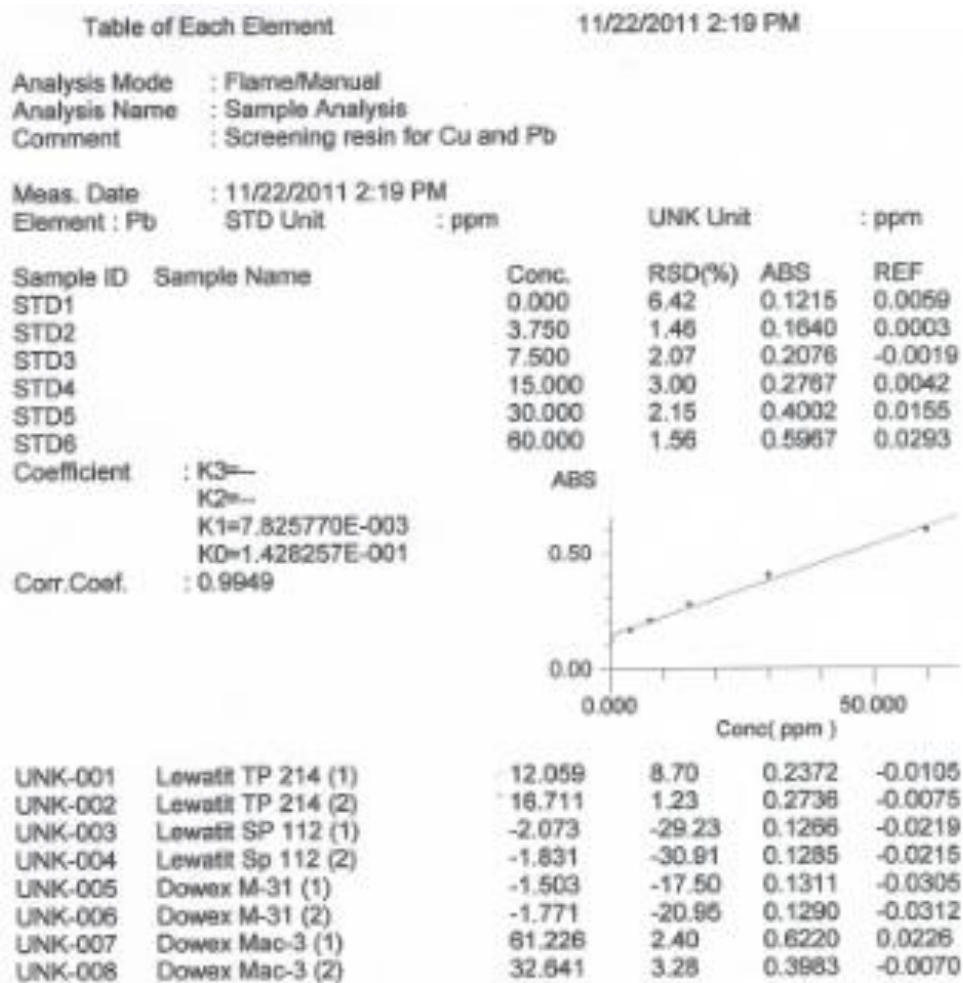


Figure A.3: Resin Screening Analysis Part III

Table of Each Element

11/23/2011 3:39 PM

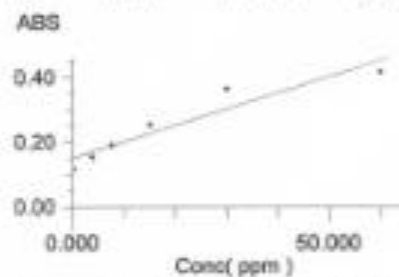
Analysis Mode : Flame/Manual
 Analysis Name : Sample Analysis
 Comment : Screening Resin for Pb

Meas. Date : 11/23/2011 3:39 PM

Element : Pb STD Unit : ppm UNK Unit : ppm

Sample ID	Sample Name	Conc.	RSD(%)	ABS	REF
STD1		0.000	0.61	0.1156	-0.0270
STD2		3.750	2.06	0.1538	-0.0453
STD3		7.500	2.74	0.1898	-0.0526
STD4		15.000	1.50	0.2530	-0.0563
STD5		30.000	0.91	0.3841	-0.0532
STD6		60.000	2.98	0.4167	-0.0316

Coefficient : K3=--
 K2=--
 K1=5.031816E-003
 K0=1.513086E-001
 Corr.Coeff. : 0.9471



UNK-001	Lewatit TP 214 (3)	19.918	2.48	0.2515	-0.0752
UNK-002	Lewatit Sp 112 (3)	-8.209	-1.25	0.1100	-0.0934
UNK-003	Dowex M-31 (3)	-8.728	-5.26	0.1074	-0.0926
UNK-004	Dowex Mac-3 (3)	37.235	9.28	0.3387	-0.0783
UNK-005	Dowex Marathon MSC (1)	-8.170	-8.42	0.1102	-0.1010
UNK-006	Amberlite IRC 86 (1)	62.057	3.85	0.4636	-0.0379
UNK-007	Amberlite IRN 150 (1)	-8.607	-7.58	0.1080	-0.1065
UNK-008	Amberlite IR 120 (1)	-10.011	-8.25	0.1009	-0.1067

Figure A.4: Resin Screening Analysis Part IV

Table of Each Element

11/24/2011 12:54 PM

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 Analysis Name : Sample Analysis
 Comment : Screening Resin and Binding EVAL for Cu & Pb

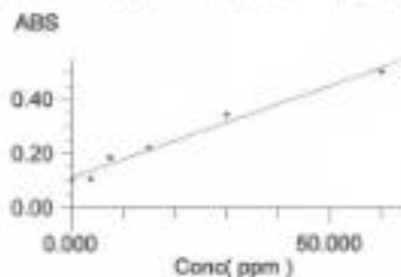
Meas. Date : 11/24/2011 12:54 PM

Element : Pb STD Unit : ppm UNK Unit : ppm

Sample ID	Sample Name	Conc.	RSD(%)	ABS	REF
STD1		0.000	1.30	0.1001	-0.0072
STD2		3.750	8.06	0.1054	-0.0116
STD3		7.500	3.33	0.1834	-0.0122
STD4		15.000	1.51	0.2179	-0.0058
STD5		30.000	2.00	0.3403	-0.0035
STD6		60.000	1.22	0.4988	0.0103

Coefficient : K3=--
 K2=--
 K1=6.748780E-003
 K0=1.102257E-001

Corr. Coef. : 0.9890



UNK-001	Dowex Marathon MSc (2)	3.597	17.63	0.1345	-0.0266
UNK-002	Dowex Marathon MSC (3)	3.360	18.24	0.1329	-0.0270
UNK-003	Amberlite IRC 86 (2)	58.026	7.72	0.5018	0.0139
UNK-004	Amberlite IRC 86 (3)	61.489	0.77	0.5252	0.0125
UNK-005	Amberlite IRN 150 (2)	4.515	22.77	0.1407	-0.0249
UNK-006	Amberlite IRN 150 (3)	-0.122	-282.79	0.1094	-0.0348
UNK-007	Amberlite IR 120 (2)	-1.841	-31.07	0.0978	-0.0386
UNK-008	Amberlite IR 120 (3)	-1.377	-98.91	0.1009	-0.0352
UNK-009	EVAL (1)	38.195	7.96	0.3680	0.0005
UNK-010	EVAL (2)	30.575	10.16	0.3166	0.0032
UNK-011	EVAL (3)	15.451	1.11	0.2145	-0.0043

Figure A.5: Resin Screening Analysis Part V

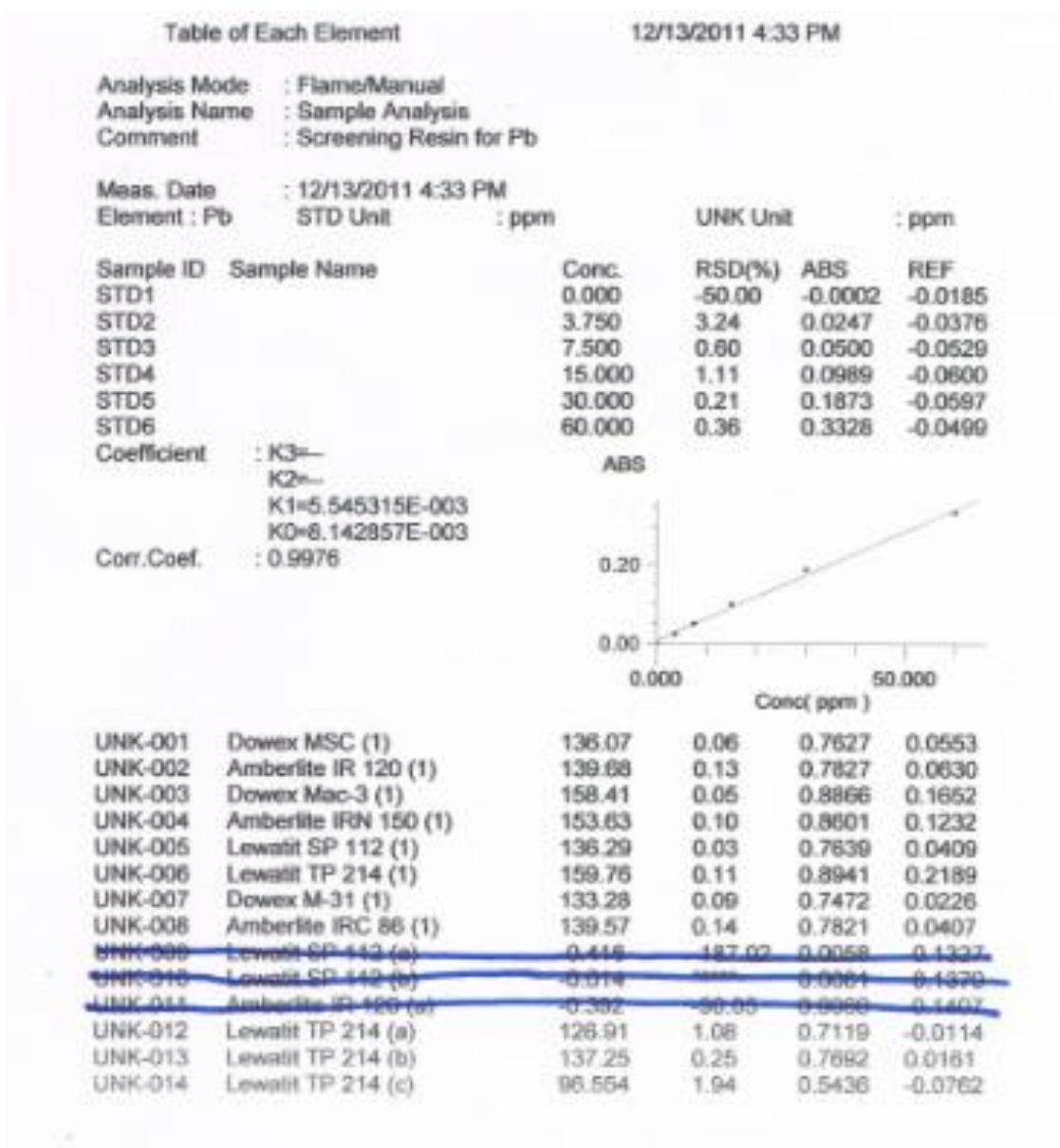


Figure A.6: Resin Screening Analysis Part VI

Table of Each Element

12/14/2011 1:33 PM

Analysis Mode : Flame/Manual
 Analysis Name : Sample Analysis
 Comment : Resin Screening for Pb (SET 2)

Meas. Date : 12/14/2011 1:33 PM

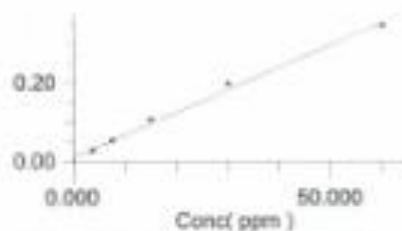
Element : Pb STD Unit : ppm UNK Unit : ppm

Sample ID	Sample Name	Conc.	RSD(%)	ABS	REF
STD1		0.000	-50.00	-0.0002	-0.0163
STD2		3.750	0.38	0.0262	-0.0356
STD3		7.500	0.38	0.0520	-0.0502
STD4		15.000	0.29	0.1035	-0.0580
STD5		30.000	0.26	0.1952	-0.0582
STD6		60.000	0.14	0.3453	-0.0500

Coefficient : K3=--
 K2=--
 K1=5.751545E-003
 KD=8.897145E-003

Corr.Coef. : 0.9974

ABS



UNK-001	DOWEX MSC (2)	146.73	0.25	0.8528	0.1130
UNK-002	AMBERLITE IR 120 (2)	139.79	0.24	0.8129	0.0784
UNK-003	DOWEX MAC-3 (2)	150.14	0.09	0.8724	0.1307
UNK-004	AMBERLITE IRN 150 (2)	135.83	0.14	0.7901	0.0560
UNK-005	DOWEX M-31 (2)	150.75	0.06	0.8759	0.1333
UNK-006	LEWATIT SP 112 (2)	143.16	0.20	0.8323	0.0824
UNK-007	LEWATIT TP 214 (2)	153.00	0.10	0.8889	0.2717
UNK-008	AMBERLITE IRC 86 (2)	145.78	0.13	0.8474	0.0924

Figure A.7: Resin Screening Analysis Part VII

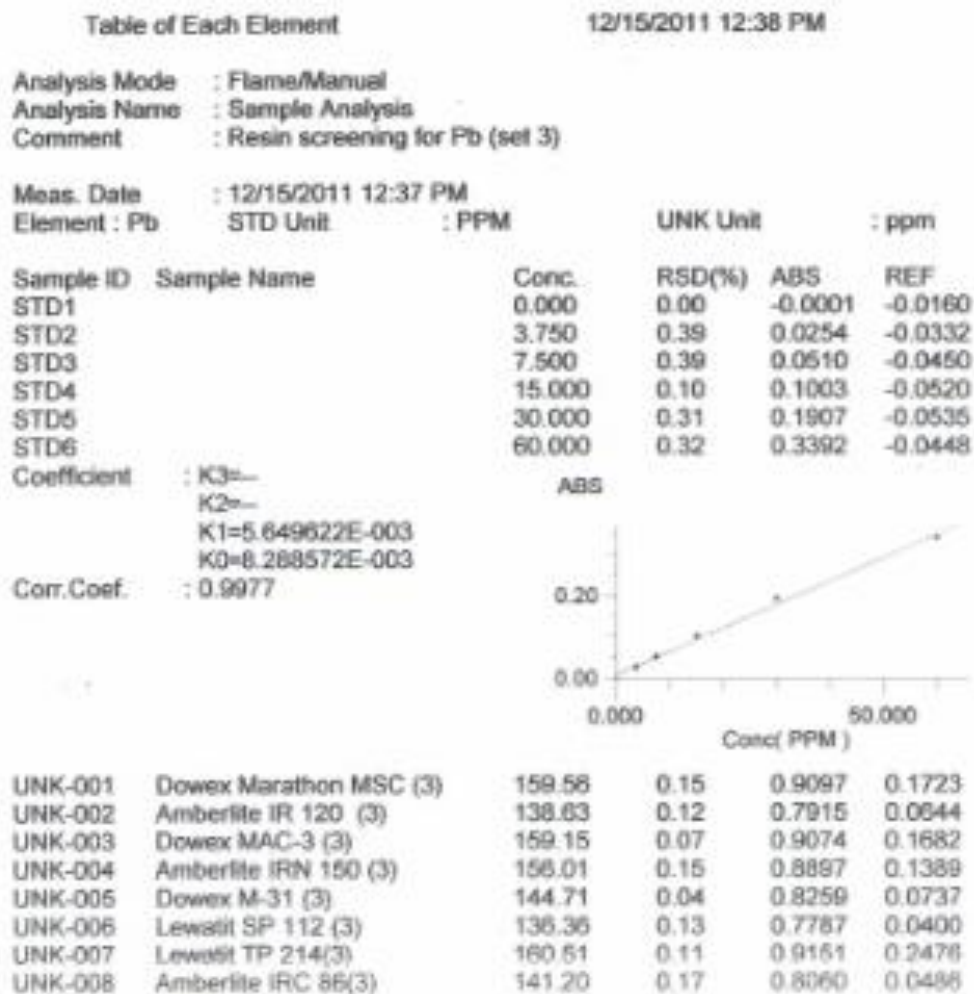


Figure A.8 : Resin Screening Analysis Part VIII

A.2 Absorption Isotherm Analysis

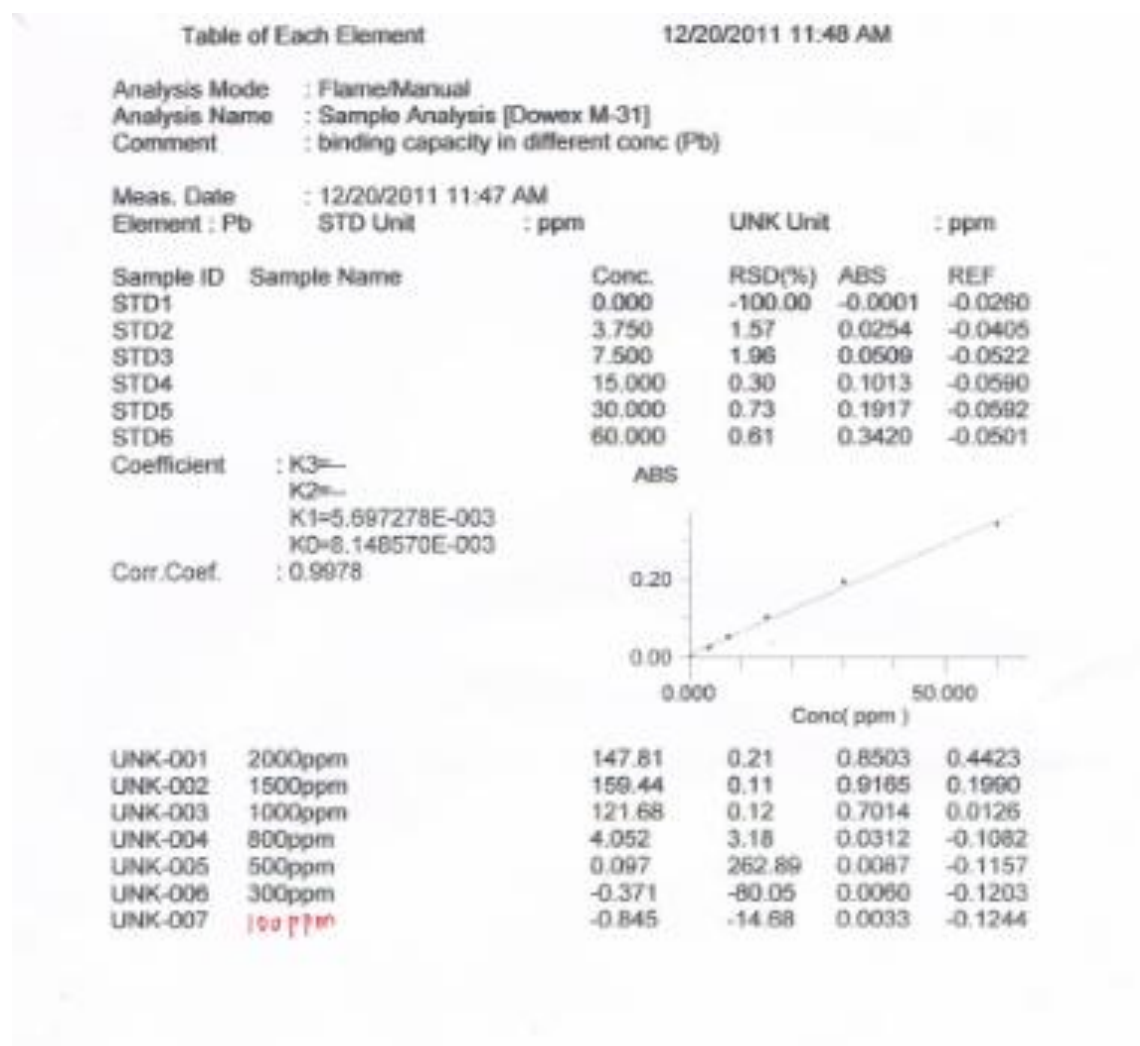


Figure A.9: Absorption Isotherm Analysis Part I

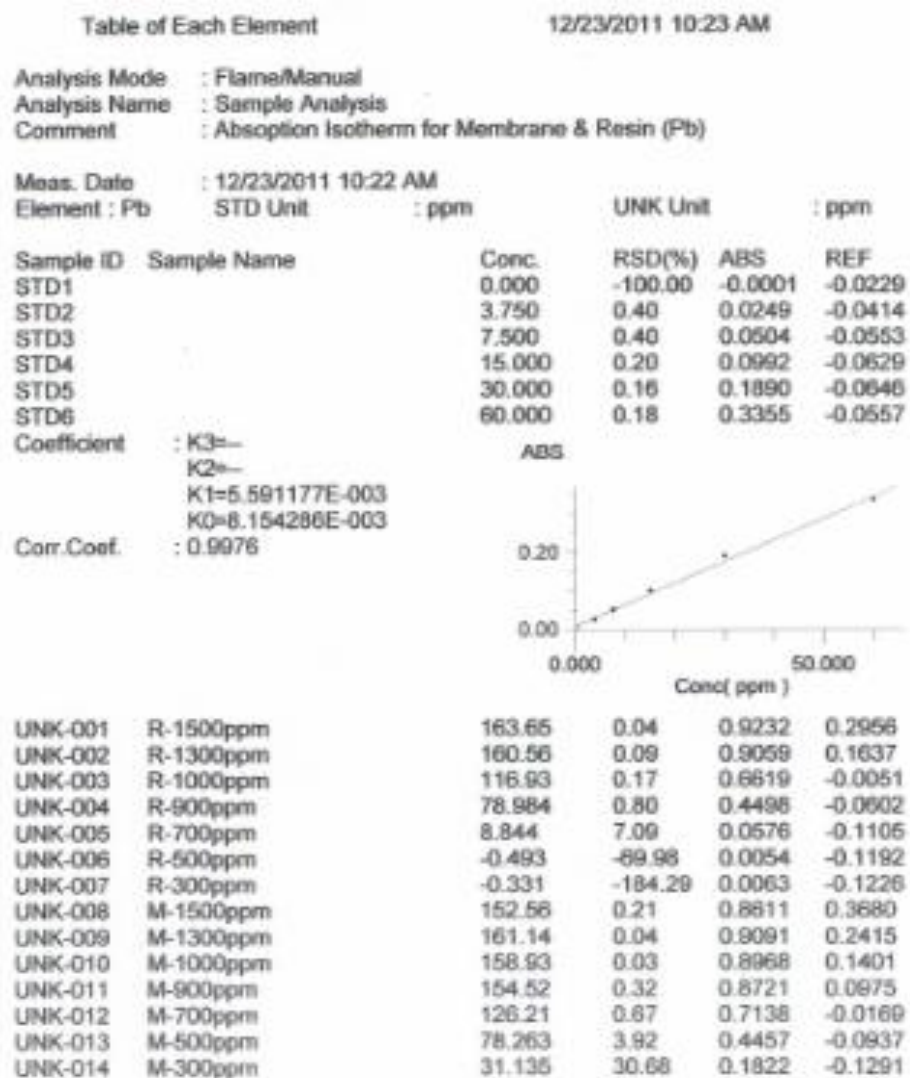


Figure A.10: Absorption Isotherm Analysis Part II

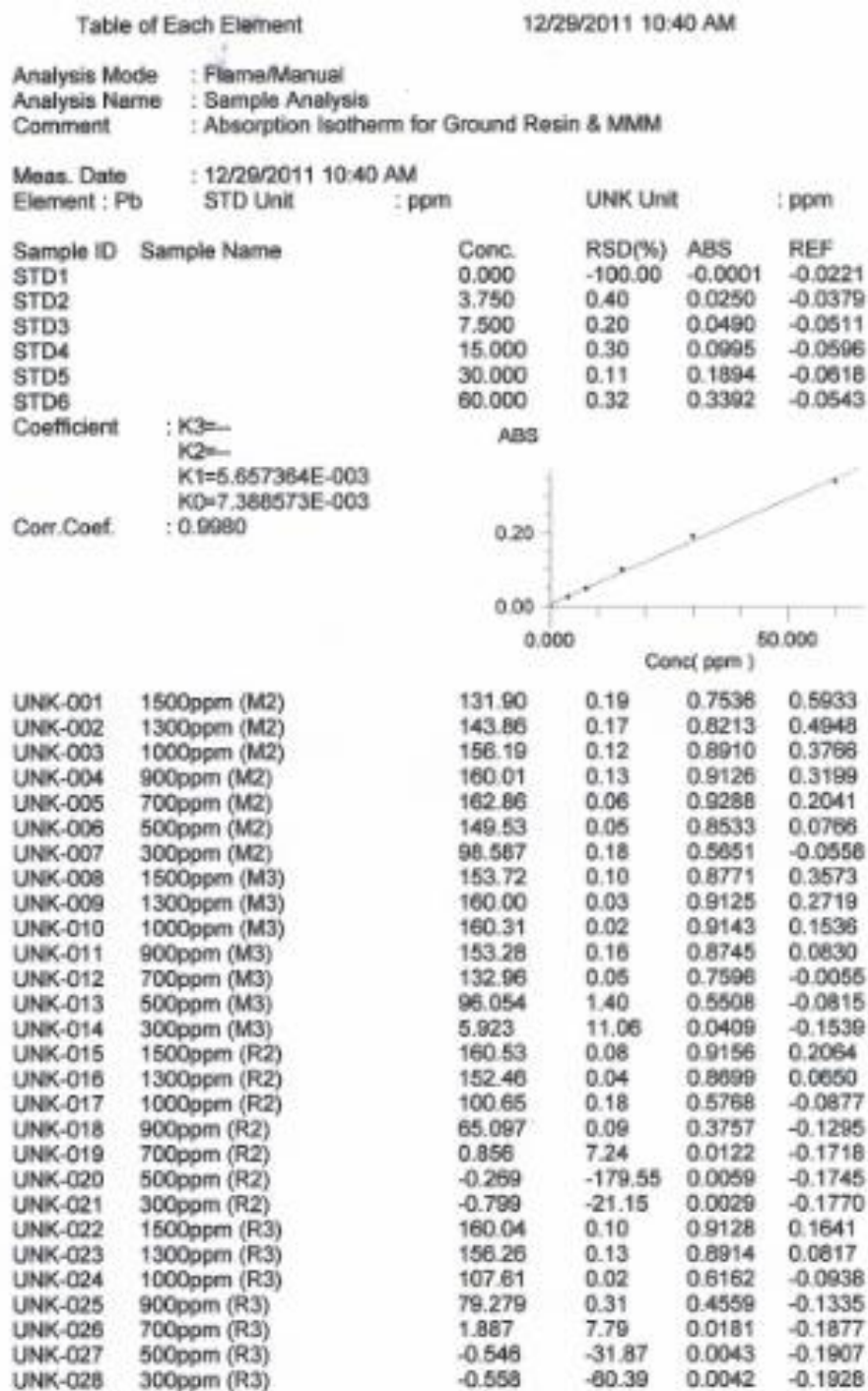


Figure A.11: Absorption Isotherm Analysis Part III

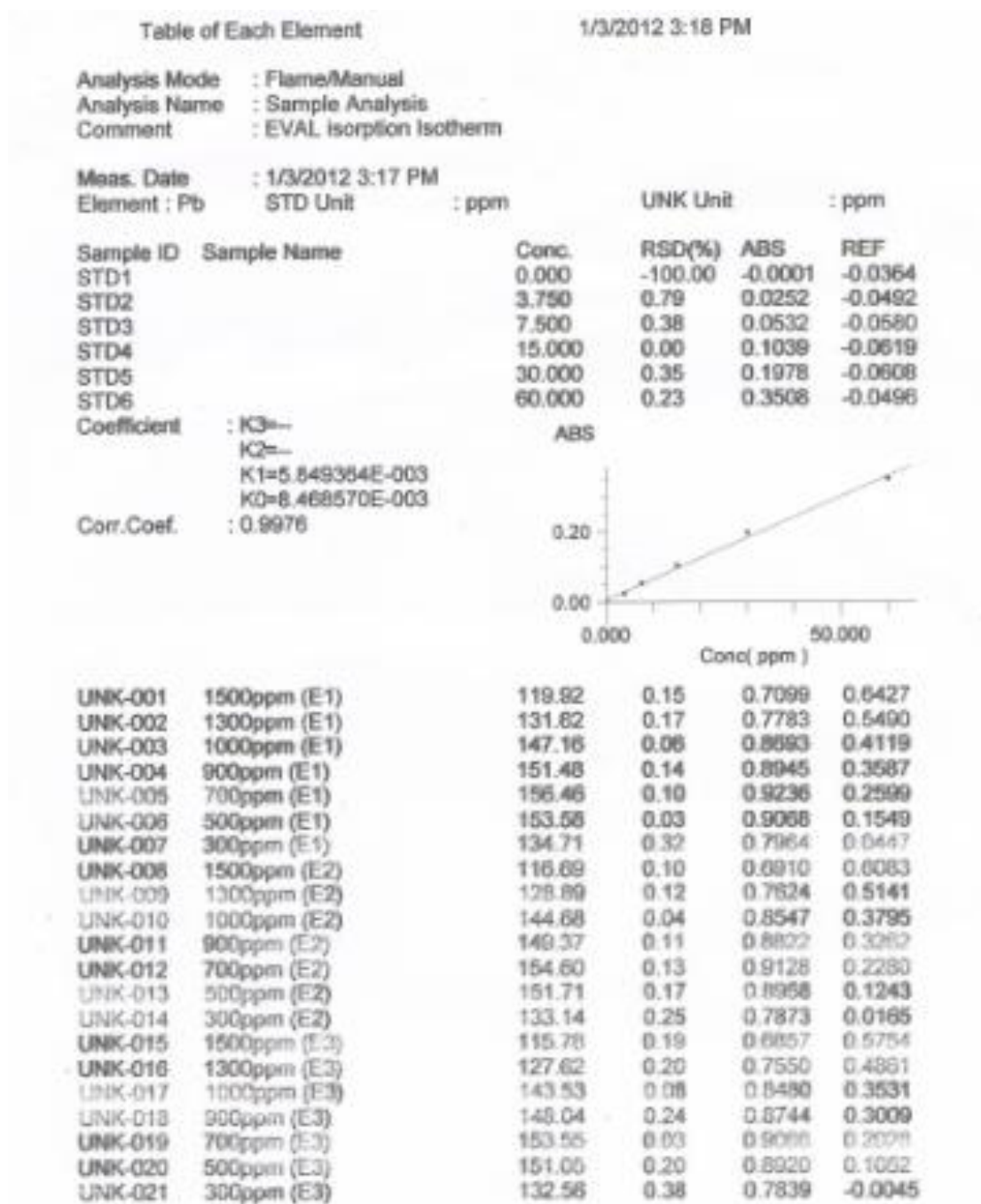


Figure A.12 : Absorption Isotherm Analysis Part IV

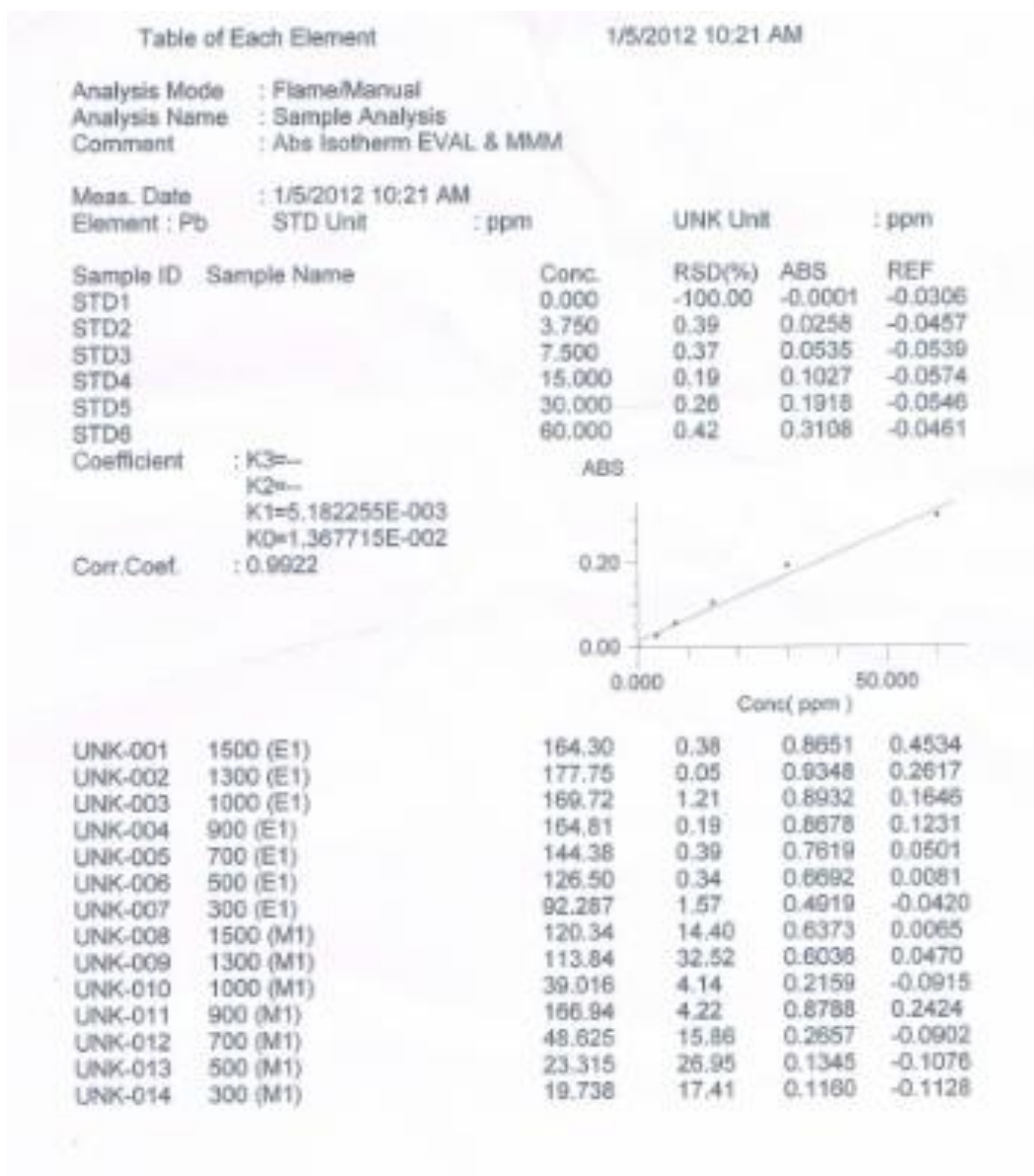


Figure A.13 : Absorption Isotherm Analysis Part V

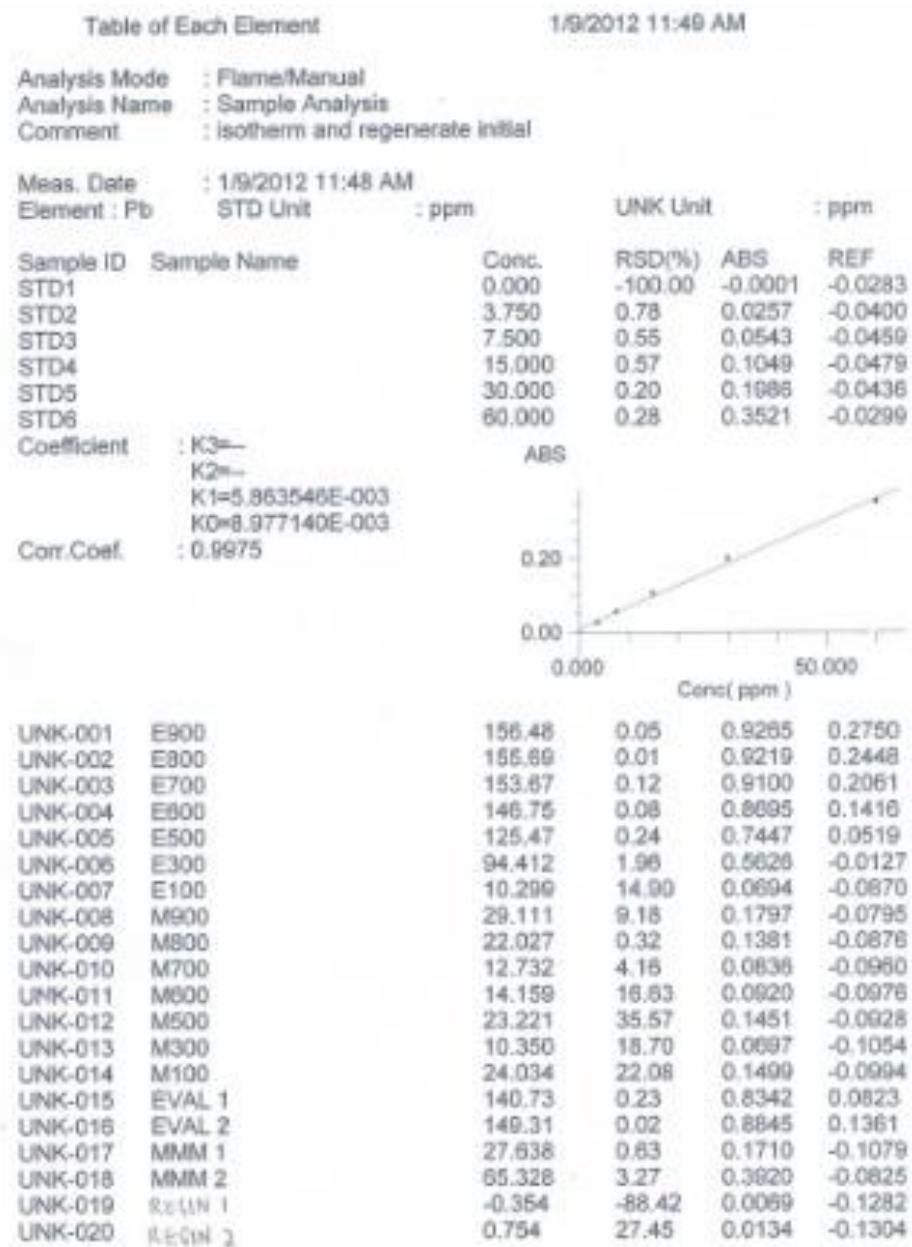


Figure A.14 : Absorption Isotherm Analysis Part VI

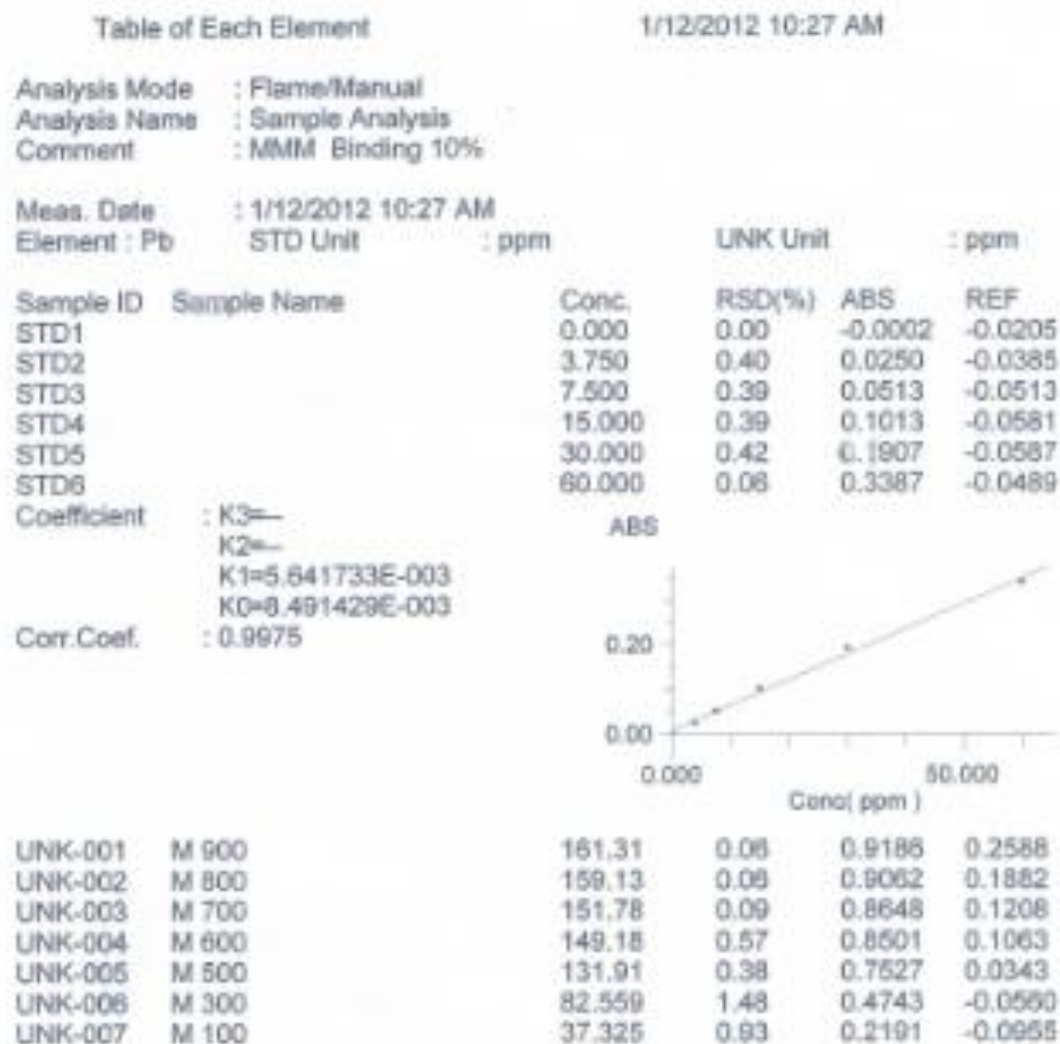


Figure A.15 : Absorption Isotherm Analysis Part VII

A.3 Resin Loading Analysis



Figure A.16 : Resin Loading Analysis Part I

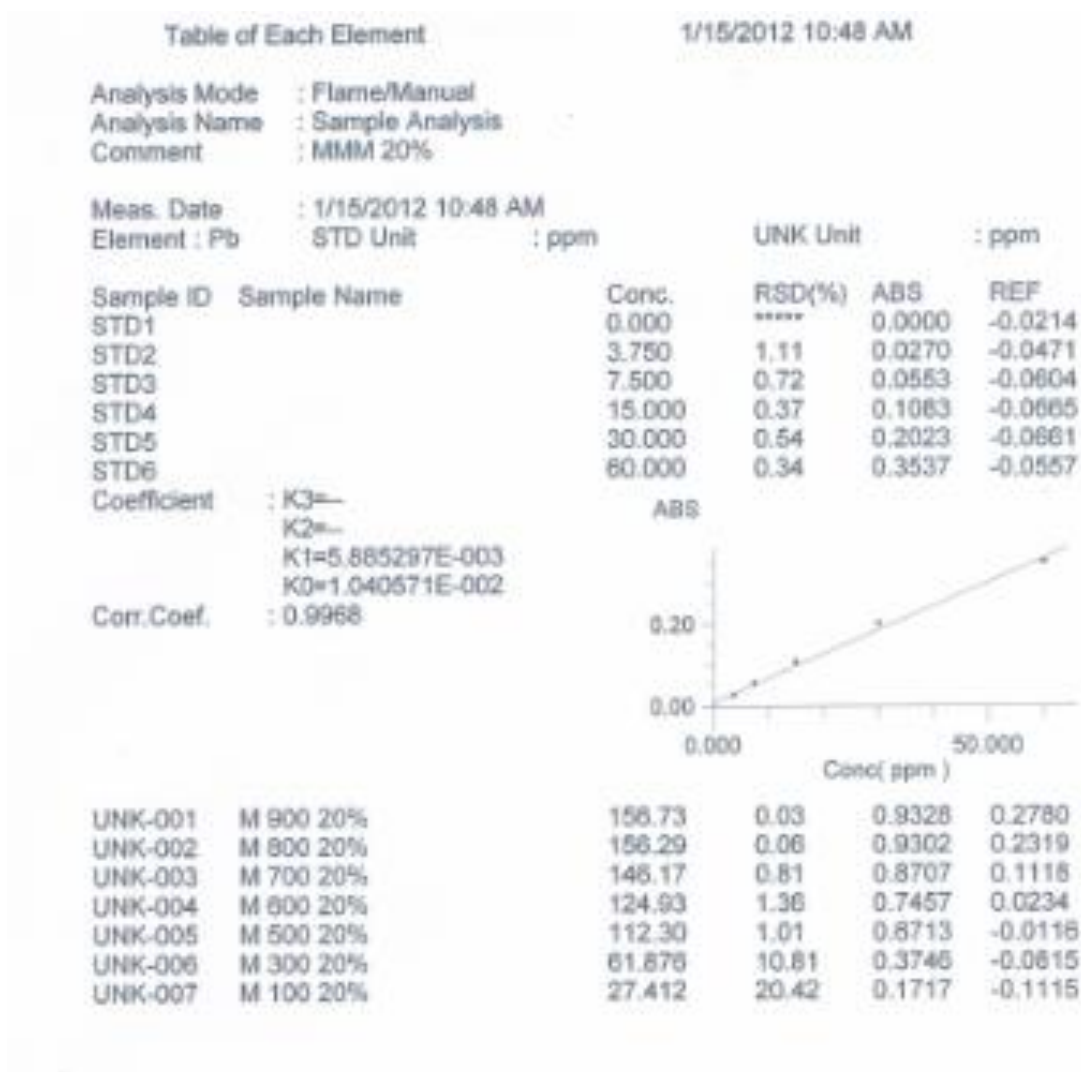


Figure A.17 : Resin Loading Analysis Part II

A.4 Recovery Analysis

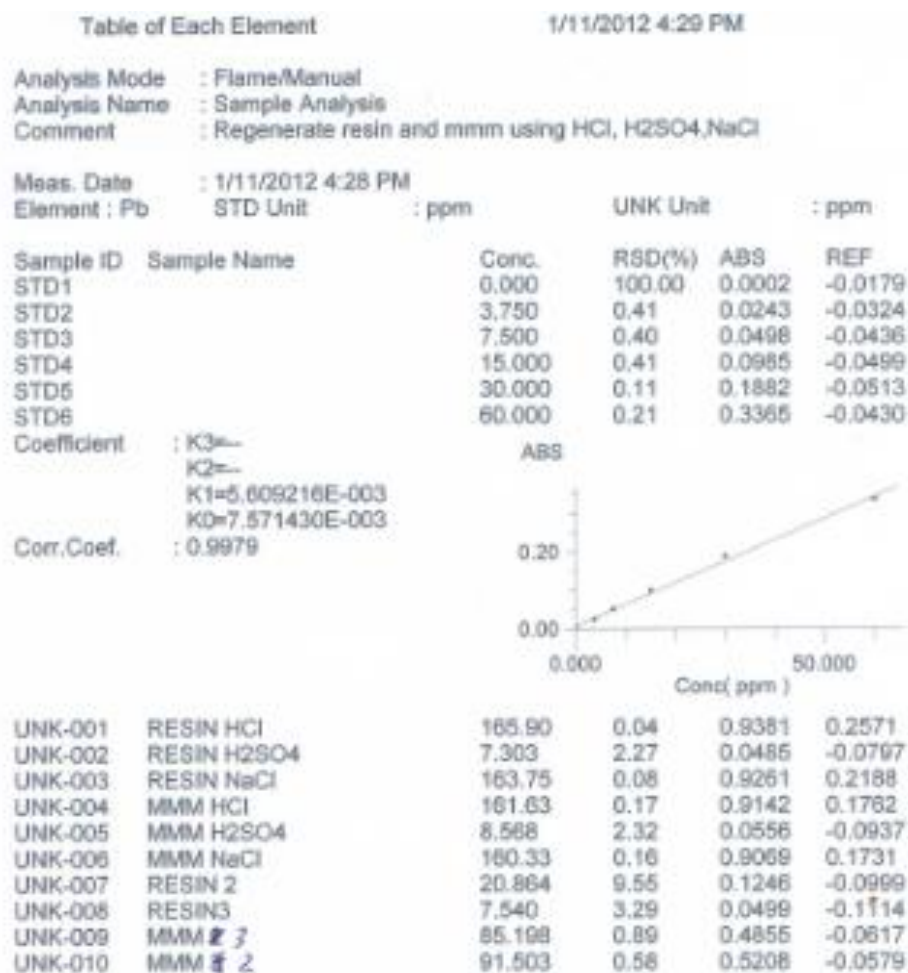


Figure A.18 : Recovery Analysis