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Process Intensification of Anaerobically digested Palm Oil Mill Effluent (AAD-POME) Treatment Using Combined Chitosan Coagulation, Hydrogen Peroxide (H₂O₂) and Fenton’s Oxidation

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Highlights

- An eco-friendly green processing method for Anaerobically digested POME treatment has been investigated.
- Combined chitosan coagulation with AOPs was utilised.
- Higher COD (82.82±1.71%) removal for chitosan/H$_2$O$_2$ compared to chitosan-Fenton oxidation was observed.
- Chitosan-Fenton oxidation was found to be favourable for higher TSS removal but not for COD removal.
- Comparison of performance with other technologies has been reported with economic analysis.

Research significance

Industrial wastewater treatment exploiting advanced oxidation processes (AOPs) involves generation of hydroxyl radicals (OH$^-$) to degrade the organic components and is a well-documented approach. In the present study, natural biomaterial Chitosan as a coagulant combined with various AOP’s have been investigated for the anaerobically digested palm oil mill effluent (AAD-POME) treatment. Research investigations to-date on the post-treatment of POME is very limited and the lacking of lab-scale study could be the major reason for the failing industrial plant trials. Hence the current study explores the possibility and reports in detail on an alternative eco-friendly green processing technique for POME treatment. The objectives of present investigation focuses on the post-treatment of AAD-POME primarily by coagulation using (a) chitosan (b) chitosan with FeSO$_4$ (c) chitosan with H$_2$O$_2$ and (d) chitosan with Fenton oxidation. The results conclude that chitosan with H$_2$O$_2$ proved to be the most promising alternative for POME treatment compared to chitosan with Fenton oxidation.
Abstract

The present study investigates the removal efficiency of chemical oxygen demand (COD) and total suspended solids (TSS) of anaerobically digested palm oil mill effluent (AAD-POME) in batch studies through the following 4 strategies: coagulation by chitosan, addition of ferrous sulphate (FeSO₄), chitosan with hydrogen peroxide (H₂O₂) and chitosan with Fenton oxidation. The parameters tested were: chitosan dosage (500-12500 mg/L), FeSO₄ dosage (500-12500 mg/L), mixing time (15-60 min), sedimentation time (1-4 h), initial pH (2-9) and H₂O₂ (500–7500 mg/L). Coagulation only by using chitosan (2500 mg/L) achieved the maximum COD and TSS removal of 70.22±0.23% and 85.59±0.13% respectively. An increase in the TSS removal (98.7±0.06 %) but with a reduction in the COD removal (62.61±2.41%) was observed when FeSO₄ (2500 mg/L) was added along with chitosan (2500 mg/L). Alternatively, an improvement in the COD (82.82±1.71%) and TSS (89.92±0.48 %) removal efficiencies was observed when chitosan was coupled with H₂O₂ (500 mg/L). Finally chitosan (2500mg/L) integrated with Fenton oxidation (FeSO₄ of 2500 mg/L and H₂O₂ of 500 mg/L) resulted in 100% TSS and 73.08±4.11% COD removals. Overall chitosan with H₂O₂ proved to be the most promising alternative for POME treatment compared to chitosan with Fenton oxidation.

Keywords: Palm oil mill effluent, POME, Treatment, Chitosan, Hydrogen peroxide, Coagulation, Chemical oxygen demand, Total suspended solids.
1 Introduction

The palm oil industry is one of the fastest growing agro based industries in Malaysia (Wu et al. 2009). The major downside of this industry is the large volume of wastewater, commonly termed as palm oil mill effluent (POME), generated from the palm oil milling process (Faisal and Unno 2001; Chungsiriporn et al. 2006; Al-Shorgani et al. 2012). Palm oil mill effluent contains 95-96% water, 0.6-0.7% oil, 2-5% solids and possesses a very high chemical oxygen demand (COD) (45000-75000 mg/L) and biochemical oxygen demand (11000-45000 mg/L) (Bhatia et al. 2007).

Anaerobic digestion of POME followed by aerobic post-treatment by ponding system is commonly practiced in palm oil mills mainly because of the low equipment cost and simple operational control to achieve the discharge limit standards (Chaiprapat and Laklam 2011; Zinatizadeh et al. 2007). Table 1 shows the Environmental Quality Act (EQA) 1974 for POME discharge (Zinatizadeh et al. 2007).

Table 1 POME discharge standards set by Department of Environment (Malaysia) under the Environmental Quality Act 1974

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Discharge Limits</th>
</tr>
</thead>
<tbody>
<tr>
<td>Biochemical Oxygen Demand</td>
<td>100</td>
</tr>
<tr>
<td>Chemical Oxygen Demand</td>
<td>Not legislated</td>
</tr>
<tr>
<td>Total Suspended Solids</td>
<td>400</td>
</tr>
<tr>
<td>Total Nitrogen</td>
<td>200</td>
</tr>
<tr>
<td>Oil &amp; Grease</td>
<td>50</td>
</tr>
<tr>
<td>pH</td>
<td>5 - 9</td>
</tr>
</tbody>
</table>

a: All parameters are in mg/L except pH

However the disadvantages of this biological treatment include long hydraulic retention time (HRT) (75-120 days), huge investment in the land for ponds and digesters and problems associated with the methane gas collection which have been identified to be the most important reasons for the greenhouse effect on the environment (Ahmad et al. 2009; Igwe and Onyegbado 2007). Even after aerobic ponding, many mills are not able to achieve the discharge limits due to poor operational design of the existing aerobic ponding system. Moreover, the chemical components from the finally treated effluent after anaerobic treatment become difficult to treat further biologically (Bhatia et al. 2007).
Research studies dealing with the post-treatment of anaerobically digested POME (AAD-POME) are limited with the most dealing with biological approaches for the treatment. Vijayaraghavan et al. 2007 used an activated sludge reactor for the post-treatment of AAD-POME. However the treated effluents failed to meet the discharge limits, in addition to their high operational cost. A sequential batch reactor (SBR) was proposed to treat AAD-POME by Chan et al. 2010, where a maximum COD (95–96%), BOD (97–98%) and TSS (98–99%) removal were obtained and met the standard discharge limits. Even though the earlier treatment methods delivered promising results, their operational costs were neither cheap nor an easy route to commercialise industrially. The disadvantages of the current biological methods necessitate looking for alternative and efficient technologies to treat POME.

Coagulation is a process by which agglomeration and hence destabilization of colloidal particles occur due to chemical aids (coagulants) and the resulting agglomerates could be removed by flocculation, sedimentation and filtration (Chan et al. 2010; Aboulhassan et al. 2006; Abood et al. 2013). In flocculation, the destabilised colloidal particles further conglomerate into larger agglomerates, referred as flocs, which are easily settled down (Jiang and Graham 1998; Bolto and Greory 2007). Chitosan is a poly N-acetyl-glucosamine, a non-toxic biopolymer and a cationic polyelectrolyte and environmentally safe (Roussy et al. 2004). It is produced by the acetylation of chitin and has a wide range of applications in pulp and paper, food, agriculture as well as in the industrial effluent treatments (Roussy et al. 2004; Chi and Cheng 2006; Meyssami and Kasaeian 2005). For a majority of the applications, the following characteristics of chitosan are considered i.e. molecular weight, pH, degree of deacetylation and basicity (Meyssami and Kasaeian 2005; Bratskaya et al. 2006). Since chitosan is positively charged and hydrophilic in nature, the electrostatic interactions between chitosan and other negatively charged compounds could be easily achieved resulting into charge neutralisation. This is a very unique feature of this biopolymer (Roussy et al. 2005). In addition, its use eases the sludge handling abilities. Application of chitosan has been reported for the following wastewater treatments i.e. brewery wastewater (Cheng et al. 2005), river silt (Divakaran and Pillai 2001) and raw POME (Ahmad et al. 2006). However, its use for post-treatment of AAD-POME has yet to be explored.

Ferrous sulphate (FeSO₄) is a commercially available and a cheaper inorganic coagulant when compared with synthetic polyelectrolytes and hence widely used for the municipal and industrial wastewater treatment to control odour, to thicken sludge and as a dewatering agent (Tang and Chen 1996). Since it is positively charged in nature, it can attract the negatively charged counter ions present in the colloidal suspensions to form small
flocs. Coupling FeSO₄ with chitosan has never been investigated to treat POME and the reasons to employ both of them in the present study are due to: (1) chitosan acts both as a destabiliser and as a bridge (2) FeSO₄ acts as a coagulant aid and improves the destabilisation efficiency.

Industrial wastewater treatment exploiting advanced oxidation processes (AOPs) involves generation of hydroxyl radicals (OH) to degrade the organic components and is a well-documented approach (Oller et al. 2011; Klavarioti et al. 2009; Pera-Titus et al. 2004; Sekaran et al. 2013). Hydrogen peroxide (H₂O₂) is a well-known and a promising oxidant (Raffellini et al. 2011) and owing to its performance and ease of operation, many studies utilise this oxidant (Chu et al. 2012; Kestioğlu et al. 2005; Szpyrkowicz et al. 2001; Cailean et al. 2014). However, it has been previously reported that when H₂O₂ was used alone it was not effective for certain complex organic components due to kinetic limitations at reasonable peroxide concentrations (Kestioğlu et al. 2005; Chen et al. 2014). Taking into account of its oxidant capability, H₂O₂ has been considered along with chitosan as a hybrid system so that process intensification and hence an improvement in the efficiency could be achieved. The main idea behind this hybrid approach is to apply AOP for POME and optimising the concentration of H₂O₂ required to form the intermediate by-products thereby improving the performance of subsequent coagulation using chitosan. Such a coupled operation of chitosan with H₂O₂ for the post-treatment of AAD-POME has yet to be attempted. H₂O₂ with an iron salt known as Fenton’s reagent generates hydroxyl radicals is another promising oxidation process for industrial wastewater treatment (Szpyrkowicz et al. 2001). Pre-treatment of organic compounds using Fenton’s oxidation has been reported earlier (Szpyrkowicz et al. 2001; Tang and Chen 1996; Rizzo et al. 2008). Fenton oxidation is a simple AOP technique utilized to generate hydroxyl radical (HO•) (Gernjak et al. 2006). HO• is generated through the reaction between ferrous (Fe²⁺) and hydrogen peroxide (H₂O₂) at acidic condition is shown in equation (1).

\[
H_2O_2 + Fe^{2+} \rightarrow Fe^{3+} + HO^+ + OH^- \tag{1}
\]

Numerous studies on the applications of Fenton oxidation process with different pollutants and wastewaters have been reported (Szpyrkowicz et al. 2001; Tang and Chen 1996; Rizzo et al. 2008). In addition, Fenton oxidation is also capable of removing pollutants via coagulation (Kuo, 1992; Lin and Lo, 1997; Kang and Hwang, 2000). A study was conducted by Aris et al. 2008 to determine the feasibility of Fenton oxidation process in treating biologically treated palm oil mill effluent. It was reported that the highest removals of COD (75.2%) and color (92.4%) for were achieved by Fenton oxidation. Also, it was reported that Fenton oxidation...
is capable of removing COD and color from the POME and thus a viable treatment option. However the effectiveness of chitosan coupled with Fenton oxidation has never been explored for POME. Thus, the objectives of present investigation focus on the post-treatment of AAD-POME primarily by coagulation using (a) chitosan (b) chitosan with FeSO₄ (c) chitosan with H₂O₂ and (d) chitosan with Fenton oxidation. Besides, the investigation also looked into evaluating and optimising the suitable process conditions such as dosage, mixing time, sedimentation time and pH for the effective treatment of AAD-POME.

2 Experimental

2.1 Materials

Anaerobically digested POME (AAD-POME) was collected from Ulu Kanchong Oil Palm Mill, Rantau, Malaysia. The collected POME samples were at a temperature of 27.5±2.5 °C and the characteristics of samples differed based upon the processing of palm oil, climate and operating conditions during the sampling period. The COD and TSS of the samples were 15290±855 mg/L and 14950±2400 mg/L respectively. Chitosan, a white fine powder with a molecular weight of 350 kDa with 95% deactylation was obtained from Chitin-Chitosan Research Centre of Universiti Kebangsaan Malaysia. FeSO₄ was purchased from R&M chemicals, (NJ, USA). Distilled water was used for diluting 37 % fuming H₂O₂ (Merck, Germany) and sodium hydroxide pellets (R&M chemicals, NJ, USA) to prepare 5M solution for pH adjustment.

2.2 Methods

The experiments were carried out in a conventional jar-tester (Loviband water testing, model ET720, Germany) which accommodates six glass reactors at a time and all the reactors were simultaneously mixed at the same speed using the stainless steel paddles. Each reactor was filled with 200 ml of POME and the coagulant was added into POME and mixed rapidly for various periods (15-60 min) with different doses of chitosan and ferrous sulphate (500-12500 mg/L). The effect of sedimentation time (1-4 h) and the effect of pH (2-9) were also investigated. The role of hydrogen peroxide (500–7500 mg/L) in the treatment was also considered. At the end of the treatment, the samples were taken from the clarified supernatant layer to determine the COD, TSS and Zeta potential (ζ).

2.3 Analysis

The COD test was carried out using COD vials (HR 20-1500 mg/L) following the American Public Health Association (APHA) standard method 8000 using a spectrophotometer (HACH model DRB 2000). TSS was
measured by following the APHA standard method 8006 using a spectrophotometer (HACH model DR 2800) by filling 10 ml of sample in a specially designed glass bottle. Zeta potential was calculated using Zetasizer (Malvern 2000, UK) and pH was tested using a pH meter (Martini Instruments, NC, USA).

3 Results and discussion

3.1 Effect of dosage

Fig. 1 shows the effect of chitosan dosage (500-12500 mg/L) on the COD (%) and TSS (%) removal of POME. At an initial dose of 500 mg/L, 67.34 ± 3.76 % (Fig. 1 (a)) and 85.68 ± 0.81 % (Fig. 1 (b)) of COD and TSS removals were observed. A further increase in the dose to 2500 mg/L improved the COD removal to 70.22 ± 0.23 %, whereas the removal of TSS remained the same (85.59 ± 0.13 %). A decrease in the COD (66.57 ± 7.13%) was observed when the dosage was finally increased to 12500 mg/L which may be probably due to overdosing of chitosan. Similar observations were noticed by Zhu et al. 2011 during the coagulation process by employing polymeric aluminium ferric sulphate (PAFS). It has been observed that when the dosage was increased more than the optimum, restabilisation of colloidal particles of POME occurs, decreasing the COD and TSS removal efficiencies. From the results it is evident that optimising the chitosan dose is important for the increased removal of COD and TSS.

The obtained results could be explained by three different mechanisms i.e. charge neutralisation, patch flocculation and micro-bridging. Charge neutralisation of the colloidal particles is normally achieved by the addition of coagulant aids of opposite charges (Zhu et al. 2011; Assaad et al. 2007). The organic molecules in POME are normally negatively charged and the coagulant aids are positively charged in nature. Thus, when these coagulant aids are introduced to the effluent, attraction of oppositely charged ions occurs owing to Van der Waals forces resulting in neutralisation of charges and hence the formation of larger agglomerates (Wu et al. 2008; Crini and Badot 2008; Gérente et al. 2007). The bridging of colloidal particles is achieved by the addition of polyelectrolytes and is very similar to the charge neutralisation by the coagulant aids. The colloidal particles are attracted to the long polymer chains of these polyelectrolytes forming a bridge resulting in the agglomeration and coagulation (Varma et al. 2004; No and Mayers 2000). POME contains various types of colloidal particulates including organic components and is negatively charged. Chitosan is a linear polyelectrolyte and has a positive charge at acidic conditions and thus attracts the negatively charged colloidal particles of POME and destabilizes them resulting in agglomeration (Ravi Kumar 2000). Besides, amine functional groups of chitosan help to adsorb components of POME into larger agglomerates thereby achieving the maximum COD removal at
lower dosages of chitosan (Ravi Kumar 2000). The obtained results using chitosan could be compared with the previous results for olive oil wastewater where it was observed that increasing the chitosan dosage achieved the maximum TSS removal (Rizzo et al. 2008). Based on this study, the optimised chitosan dosage of 2500 mg/L was used for further investigation to treat POME using FeSO₄.

The effect of dosage of FeSO₄ was studied in the range of 500-12500 mg/L. Maximum COD removal of 62.61 ± 2.41 % (Fig. 2 (a)) and TSS removal of 98.7 ± 0.06 % (Fig. 2 (b)) were achieved for 2500 mg/L of FeSO₄. Further it was observed that with the addition of FeSO₄ to chitosan, TSS removal increased from 85.59 ± 0.13 % (2500 mg/L of chitosan) to 98.7 ± 0.06 % (2500 mg/L of chitosan with 2500 mg/L of FeSO₄) whereas the COD removal was decreased from 70.22% (2500 mg/L of chitosan alone) to 62.61 ± 2.41 % (2500 mg/L of chitosan with 2500 mg/L of FeSO₄). Similar observations were earlier reported by Ginos et al. 2006 while using FeSO₄ coupled with poly-electrolytes where a maximum TSS removal of 95-98% with the lower COD removal of 22-28% was noticed for olive mill wastewater treatment. This observation clearly indicates that addition of FeSO₄ is favourable for TSS removal but not for COD removal. The obtained results could be further supported by analysing the zeta potential. Fig. 3 shows the zeta potential measurements using different doses of chitosan and chitosan with FeSO₄.

Zeta potential (ζ) is defined as the electrical potential difference between the colloidal particles and the solution and it is an indirect way of measuring the charge of colloidal particles. Isoelectric point is defined as the condition where the colloidal particles have enough counter ions so that they can be electrically neutral and zeta potential is zero. The highest degree of agglomeration is achieved at this isoelectric point (Ariffin et al. 2012). It was observed that increasing the chitosan dosage increased the ζ value nearing the isoelectric point (mV=0). Similar observations were earlier reported by Ariffin et al. for the paper and pulp mill wastewaters using a hybrid flocculant system of PolyDADMAC and polyacrylamide (Ariffin et al. 2012). The observed ζ values were -0.9 mV for 2500 mg/L of chitosan and 0.07 mV for 2500 mg/L of chitosan with 2500 mg/L of FeSO₄ which were very close to the isoelectric point. Thus, a consistency in the results was observed in this range of dosage with COD and TSS removal. Hence at the end of this study, 2500 mg/L of chitosan and 2500 mg/L of FeSO₄ were selected for further investigation.

3.2 Effect of mixing time

The effect of mixing time (15-60 min) was studied for the optimised chitosan and chitosan with FeSO₄ dosages at a mixing speed of 100 rpm and the observed results have been shown in Fig. 4. In the case of chitosan after
an initial mixing time of 15 min, the COD and TSS removal efficiencies were 82.11 ± 0.23 % (Fig. 4 (a)) and
89.61 ± 0.43 % (Fig. 4 (b)) respectively. But after 15 min of mixing time, no significant improvement in the
COD and TSS removal was observed. Thus 15 min of mixing time was found to be the optimum condition for
chitosan. The zeta potential values were also observed within the range of -0.805 to 1.37 mV (Fig. 5) which are
close to near zero or isoelectric point proving the role of chitosan as a coagulant that causes charge
neutralisation.

For coagulation processes, two kinds of mixing were followed i.e. rapid mixing (up to 700 rpm for 5 min) and
slow mixing (150 rpm for 30 min). Rapid mixing focused on the coagulant dispersion for the destabilisation of
colloidal system whereas the slow mixing concentrated on the propagation of growth of floc by limiting the
breakdown of aggregates. When the mixing speed was very rapid and mixing time was longer, the COD and
TSS removal efficiencies were decreased, even though it was assumed that the longer mixing time and higher
mixing speed would indirectly increase the collision frequency of the flocs. The disruption of flocs to smaller
particles occurs with the higher shear rate, thereby inhibiting the flocs to settle down and decreasing the COD,
TSS removal efficiencies. On the other hand when the mixing time was very short, the flocs would not have
been formed due to the inadequate contact of the coagulants with the components of the effluent.

For chitosan with FeSO₄, the maximum COD and TSS removal efficiencies were 69.06 ± 0.27 % (Fig. 4 (a))
and 98.01 ± 1.26 % (Fig. 4 (b)) respectively after 15 min of mixing. However at the end of 60 min, the COD
and TSS removal efficiencies were 65.59 ± 0.36 % and 97.60 ± 0.77% respectively. The zeta potential (Fig. 5)
was 0.0414 mV for chitosan with FeSO₄ after 15 min of mixing time which clearly proves that the surface
charge was very close to zero or to the isoelectric point improving the coagulation performance of POME
treatment. Thus, 15 min was considered as the optimised mixing time for chitosan and chitosan with ferrous
sulphate.

3.3 Effect of sedimentation time

Using the optimised conditions of dosage and mixing time from the previous studies, optimisation of
sedimentation time was investigated both for chitosan and chitosan with FeSO₄ without aeration and the
obtained results have been presented in Fig. 6 and Fig. 7. For chitosan, after 1 h of sedimentation time, the COD
and TSS removal efficiencies were 85.70 ± 3.09% (Fig. 6 (a)) and 90.06 ± 4.36% (Fig. 6 (b)) respectively with
a surface charge of 0.0015 mV (Fig. 7). Since no aeration was employed, the chances of oxidation of FeSO₄ to
Fe₂(SO₄)₃ is not possible and hence the possibility of its precipitaton is negligible.
Whereas, after 4 h of sedimentation, the COD and TSS removal efficiencies were 87.18±4.06 % and 91.84 ± 2.61% respectively, along with a surface charge of 0.093 mV. Thus with an increase in sedimentation time no significant change in the COD and TSS removal efficiencies was observed. Chitosan shows a faster agglomeration of organic compounds forming larger flocs and hence a higher settling velocity (Divakaran and Pillai 2001). In the case of chitosan with FeSO₄, after 1 h of sedimentation time, COD and TSS removal efficiencies were found to be 67.06 ± 3.37% (Fig. 6 (a)) and 98.32±0.24% (Fig. 6 (b)) respectively with a surface charge of 0.0545 mV. But at the end of 4 h of sedimentation time, COD and TSS removal efficiencies were 66.38 ± 5.64 % and 91.84 ± 2.61% respectively with a surface charge of -0.883mV.

Chitosan shows predominant effects as compared to chitosan with FeSO₄ for the COD removal. But maximum TSS removal was achieved when chitosan was coupled with FeSO₄ as compared to using chitosan alone. This effect is mainly because of iron salts which act as destabilisers for the POME colloidal suspension, whereas chitosan acts as a neutraliser and bridger that promotes faster agglomeration of organic particulates and resulted in faster settling of the formed flocs thereby reducing the TSS of POME. Based on this investigation, 1 h was considered to be the optimised sedimentation time to achieve the maximum removal of COD and TSS.

3.4 Effect of pH

In the case of coagulation-flocculation process, pH acts as a crucial parameter since the performance of coagulant aids is always observed to be in a specific range of pH. Hence the effect of initial pH of POME was studied using the optimised dosage of coagulant, mixing time and sedimentation time in reducing the COD and TSS.

Fig. 8 shows the effect of initial pH on the COD and TSS removal efficiencies. From the results, a very similar trend in the COD reduction could be observed for chitosan and chitosan with FeSO₄. As the pH increased from 2 to 7 there was a substantial increase in the COD removal for chitosan and chitosan with FeSO₄. For chitosan, the COD removal increased from 69.39 ± 1.38 % at pH 2 to 82.66 ± 0.18 % at pH 7 (Fig. 8 (a)). Similarly for chitosan with FeSO₄, the COD removal increased from 38.65 ± 0.83 % to 67.49 ± 1.20 % (Fig. 8 (a)). There was also a decrease in the COD removal at pH 9. This could be due to the hydrolysis of coagulant at a higher alkaline environment resulting in the inhibition of bridging flocculation or particle aggregation (Divakaran and Pillai 2001). The highest TSS removal for chitosan was observed at pH 2; also with an increase in pH there was a substantial reduction in the TSS removal from 95.37 ± 1.01% at pH 2 to 91.43% at pH 9 (Fig. 8 (b)). Fig. 9 shows the zeta potential measurements at various pH.
The highest degree of agglomeration is achieved at the isoelectric point. The surface charges increase when the pH increased from 2 to 5 for both the coagulants whereas there was a decrease in the surface charge at neutral pH 7. The surface charge of POME gets decreased due to the charge neutralisation mechanism at neutral pH indirectly improving the coagulation efficiency and hence the COD and TSS removals. At an alkaline pH, an increase in the surface charge decreases the coagulation efficiency. This trend was very similar to the observations as reported by Zhu et al. 2011. At the end of this study, pH 7 was chosen to be the optimum pH which is also the pH after the aerobic digestion of POME and which resulted in the COD and TSS removals.

3.5 Effect of hydrogen peroxide

The effect of hydrogen peroxide (500–7500 mg/L) on the COD and TSS removals was investigated and the results have been shown in Fig. 10, whereas Fig. 11 shows the surface charge measurements.

For chitosan, it was observed that at the lowest H₂O₂ concentration (500 mg/L), COD and TSS removal efficiencies were 82.82 ± 1.71 % (Fig. 10(a)) and 89.92 ± 0.48 % (Fig. 10(b)) respectively along with a zeta potential of 0.175 mV (Fig. 11). The reason for introducing H₂O₂ was to increase the generation of hydroxyl radicals (OH) thereby improving oxidation and hence the removal of chemical components of POME. H₂O₂ is widely used in the advanced oxidation processes (AOPs) for wastewater treatment. When this AOP is coupled with chemical coagulation, an increase in the removal of chemical components of POME could be expected. It was evident from the observation that the COD removal efficiency was increased from 66.59 ± 7.13 % (for 2500 mg/L chitosan without H₂O₂) to 82.82 ± 1.71 % (for 2500 mg/L chitosan with 500 mg/L H₂O₂); for TSS, the removal efficiency was improved from 85.15 ± 0.47 % (for 2500 mg/L chitosan without H₂O₂) to 89.92 ± 0.48 % (for 2500 mg/L chitosan with 500 mg/L H₂O₂). When the concentration of H₂O₂ was further increased to 5000 mg/L, a maximum removal of 91.80 ± 1.30% in the TSS and 84.95 ± 3.32% in the COD was achieved. Hence an external addition of H₂O₂ improves the removal of chemical components of POME by oxidation due to the abundant availability of OH radicals. This confirms that the radical attack is the main pathway for the POME degradation which significantly increases the performance of chitosan coagulation. Whereas, when the concentration of H₂O₂ was further increased to 7500 mg/L there was a reduction in the removal efficiency of both the COD as well as TSS. This observation could be explained due to the over abundant generation of hydroxyl radicals, which in turn results in the formation of hydrogen peroxide and finally reduces the oxidation as hydrogen peroxide is relatively a weak oxidising agent as compared to OH radicals (Harish Prashanth and
a possibility of oxidation of FeSO₄ by H₂O₂ into Fe₂(SO₄)₃ at pH 7 as well as oxidation of chitosan by H₂O₂ must

Thus an optimum concentration of H₂O₂ (500 mg/L) is found to be suitable for POME treatment. Apart from this, the effect of Fenton oxidation was also investigated using ferrous sulphate. The mechanism involved in the Fenton oxidation has been shown in the following equations (2-10) (Sychev and Isak 1995):

\[
\text{HO}^\cdot + \text{H}_2\text{O}_2 \rightarrow \text{H}_2\text{O} + \text{HO}_2^\cdot \quad (2)
\]
\[
\text{HO}^\cdot + \text{Fe}^{2+} \rightarrow \text{Fe}^{3+} + \text{OH}^- \quad (3)
\]
\[
\text{Fe}^{3+} + \text{H}_2\text{O}_2 \rightarrow \text{Fe}^{3+} + \text{H}^+ + \text{HO}_2^\cdot \quad (4)
\]
\[
\text{HO}^\cdot + \text{HO}_2^\cdot \rightarrow \text{H}_2\text{O} + \text{HO}_2^\cdot \quad (5)
\]
\[
\text{Fe}^{3+} + \text{HO}_2^\cdot \rightarrow \text{Fe}^{2+} + \text{O}_2 + \text{H}^+ \quad (7)
\]

In the presence of organic substrate (XH), the primary product of the oxidation would be the organic radical, X•, which possesses mainly reducing properties and may be consumed through the reactions with H₂O₂ and Fe³⁺:

\[
\text{HO}^\cdot + \text{XH} \rightarrow \text{H}_2\text{O} + \text{X}^- \quad (8)
\]
\[
\text{X}^- + \text{H}_2\text{O}_2 \rightarrow \text{XOH} + \text{HO}_2^\cdot \quad (9)
\]
\[
\text{X}^- + \text{Fe}^{3+} \rightarrow \text{Fe}^{2+} + \text{H}^+ + \text{Product} \quad (10)
\]

It was also observed that chitosan with Fenton oxidation reduced the COD removal from 82.82 ± 1.71 % (for 2500 mg/L chitosan with 500 mg/L H₂O₂) to 73.08 ± 4.11% (for 2500 mg/L chitosan with 2500 mg/L FeSO₄ and 500 mg/L H₂O₂). Thus, chitosan with Fenton oxidation does not show any favourable result for the COD removal and it could be concluded that the chitosan with H₂O₂ proves to be producing better results for POME as compared to chitosan with Fenton oxidation.

3.6 Economic analysis and performance comparison with other technologies

The chitosan coagulation coupled with H₂O₂ as a POME treatment method has been compared to other reported work to evaluate its performances and has been shown in Table 2.
Table 2 Comparison of the current chitosan coagulation coupled with H\textsubscript{2}O\textsubscript{2} treatment process with other reported work for POME treatment

<table>
<thead>
<tr>
<th>Treatment Process</th>
<th>Operational Conditions</th>
<th>Overall COD reduction (%)</th>
<th>Overall TSS reduction (%)</th>
<th>References</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Temperature (°C)</td>
<td>pH</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2.5 g/L chitosan + 0.5 g/L H\textsubscript{2}O\textsubscript{2}</td>
<td>25-30</td>
<td>7</td>
<td>89.92</td>
<td>82.82</td>
</tr>
<tr>
<td>8 g/L alum</td>
<td>26-30</td>
<td>4.5</td>
<td>-</td>
<td>89</td>
</tr>
<tr>
<td>6 g/L alum</td>
<td>30</td>
<td>5</td>
<td>66</td>
<td>89</td>
</tr>
<tr>
<td>6 g/L MOA</td>
<td>30</td>
<td>5</td>
<td>52.2</td>
<td>95</td>
</tr>
<tr>
<td>0.1 g/L Magnafloc LT22 polymer + 0.3 g/L FeCl\textsubscript{3}</td>
<td>25</td>
<td>5</td>
<td>49</td>
<td>92</td>
</tr>
<tr>
<td>4 g/L MOAE + 7 g/L flocculant NALCO 7751</td>
<td>70</td>
<td>5</td>
<td>42</td>
<td>98</td>
</tr>
<tr>
<td>6 g/L polyaluminum chloride</td>
<td>26-30</td>
<td>4.5</td>
<td>-</td>
<td>93</td>
</tr>
</tbody>
</table>

Among the other POME treatment methods reviewed above; it is observed that the chitosan coagulation coupled with H\textsubscript{2}O\textsubscript{2} is appeared to be a suitable alternative for POME treatment. Table 3 shows the operational costs estimation calculation for the POME treatment.

The optimum dosage for the POME treatment was found to be 2500 mg/L from the previous lab scale optimisation studies. If the price of chitosan used is 162.30 MYR/kg, then for the treatment of 400 tonnes of POME, 1 tonne of chitosan is required. The chemical cost for treating 1m\textsuperscript{3} of POME under optimum conditions is MYR/m\textsuperscript{3} 163575. The treatment needs an electricity usage of 144000 KWh. The total operation cost of anaerobically digested POME treatment using chitosan coagulation was found to be 1.96 MYR/thousand gallon. The operation cost of using chitosan coagulation for the treatment of anaerobically digested POME is still seems to be acceptable for commercial feasibility. It has been reported that the open digesting tank for POME treatment without land application, the capital cost quoted (Gopal et al. 1986) for a palm oil mill processing 30 tons FFB/h is MYR 750,000. Also, the capital cost for a membrane system in POME treatment for a palm oil mill processing 36 tons FFB/h at MYR 3,950,000 (Chong, 2007).
### Table 3 Operational costs estimation

<table>
<thead>
<tr>
<th>Item</th>
<th>Notes</th>
<th>Cost in MYR</th>
</tr>
</thead>
<tbody>
<tr>
<td>Energy</td>
<td>Average unit price of electrical energy MYR</td>
<td>49680</td>
</tr>
<tr>
<td></td>
<td>0.345/kwh</td>
<td></td>
</tr>
<tr>
<td>Labour</td>
<td>Three shift work. Costs MYR 6/hr</td>
<td>345600</td>
</tr>
<tr>
<td>Chemical Costs</td>
<td>Chitosan: MYR 162.3/kg</td>
<td>65704000</td>
</tr>
<tr>
<td></td>
<td>Ferrous sulphate: MYR 0.685/kg</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Hydrogen Peroxide: MYR 1.275/kg</td>
<td></td>
</tr>
<tr>
<td>Land cost</td>
<td>Prices calculated for local market</td>
<td>1235927</td>
</tr>
<tr>
<td>Taxes and Insurance</td>
<td></td>
<td>66522.77</td>
</tr>
<tr>
<td>Maintenance</td>
<td></td>
<td>133045.55</td>
</tr>
<tr>
<td><strong>Total O&amp;M Cost</strong></td>
<td></td>
<td><strong>67534775.33</strong></td>
</tr>
</tbody>
</table>

#### 4 Conclusions

The effectiveness of chitosan, FeSO₄, combined chitosan with H₂O₂ and combined chitosan with Fenton oxidation were evaluated for the AAD-POME. From the results it could be concluded that chitosan has been identified as an effective coagulant for maximum COD removal. Also, FeSO₄ addition to chitosan is favourable for TSS removal but not for COD removal. The TSS removal was improved from 66.59 % (2500 mg/L of chitosan without any H₂O₂) to 82.82 % (2500 mg/L of chitosan with 500 mg/L H₂O₂) whereas the COD removal was improved from 85.15 % (2500 mg/L chitosan without any H₂O₂) to 89.92 % (2500 mg/L chitosan with 500 mg/L H₂O₂). The optimum parameters were: chitosan dose of 2500 mg/L; 500 mg/L of H₂O₂; 15 min of mixing time; 1 h of sedimentation time; and a pH of 7. It could be concluded that chitosan coagulation coupled with H₂O₂ proves to be a better alternative for the post-treatment of anaerobically digested POME due to its improved performance, safe handling and availability.

#### Acknowledgements


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References


Figure Captions

Figure 1 Effect of chitosan dosage on the removal (%) of (a) COD and (b) TSS

Figure 2 Effect of FeSO₄ dosagewithchitosan (2500 mg/L) on the removal (%) of (a) COD and (b) TSS

Figure 3 Zeta potential at different dosages of chitosan and chitosan (2500 mg/L) with FeSO₄

Figure 4 Effect of mixing time by employing chitosan (2500 mg/L) and chitosan (2500 mg/L) with FeSO₄ (2500 mg/L) on the removal (%) of a) COD and (b) TSS

Figure 5 Zeta potential measurements at different mixing time for chitosan (2500 mg/L) and chitosan (2500 mg/L) with FeSO₄ (2500 mg/L)

Figure 6 Effect of sedimentation time using chitosan (2500 mg/L) and chitosan (2500 mg/L) with FeSO₄ (2500 mg/L) on the removal (%) of a) COD and (b) TSS

Figure 7 Zeta potential measurements at different sedimentation time for chitosan (2500 mg/L) and chitosan (2500 mg/L) with FeSO₄ (2500 mg/L)

Figure 8 Effect of pH of chitosan (2500 mg/L) and chitosan (2500 mg/L) with FeSO₄ (2500 mg/L) on the removal (%) of a) COD and (b) TSS

Figure 9 Zeta potential measurements at different pH for chitosan (2500 mg/L) and chitosan (2500 mg/L) with FeSO₄ (2500 mg/L)

Figure 10 Effect of hydrogen peroxide with chitosan (2500 mg/L) and chitosan (2500 mg/L) with FeSO₄ (2500 mg/L) on the removal (%) of a) COD and (b) TSS

Figure 11 Zeta potential measurements at different hydrogen peroxide concentrations for chitosan (2500 mg/L) and chitosan (2500 mg/L) with FeSO₄ (2500 mg/L)
Fig. 1

Panel a: COD removal (%) versus Chitosan dosage (mg/L)

Panel b: TSS removal (%) versus Chitosan dosage (mg/L)
Fig. 2
Fig. 3

- Chitosan
- 2500 mg/L Chitosan + FeSO₄

Dosage (mg/L)

Zeta potential, $\zeta$ (mV)
Fig. 4
Fig. 5

![Graph showing Zeta Potential (mV) vs. Mixing Time (min) for 2500 mg/L Chitosan and 2500 mg/L FeSO₄ solutions. The graph indicates the potential changes over time for each condition.]
Fig. 6

Figure 6: COD and TSS removal efficiency for 2500 mg/L Chitosan and 2500 mg/L Chitosan + 2500 mg/L FeSO₄.
Fig. 7

The diagram shows the Zeta Potential ($\zeta$) in mV as a function of sedimentation time (h) for different concentrations of Chitosan and Chitosan + FeSO$_4$. The data points indicate the trend of Zeta Potential over time for each condition.
Fig. 8

(a) COD removal (%)

(b) TSS removal (%)
Fig. 9

Zeta Potential $\zeta$ (mV)

pH

$\bullet$ 2500 mg/L Chitosan  
$\square$ 2500 mg/L Chitosan + 2500 mg/L FeSO$_4$
**Fig. 10**

- **a**
  - COD removal (%)
  - Concentration of hydrogen peroxide (mg/L)
  - 2500 mg/L Chitosan + Hydrogen Peroxide
  - 2500 mg/L Chitosan + 2500 mg/L FeSO$_4$ + Hydrogen Peroxide

- **b**
  - TSS removal (%)
  - Concentration of hydrogen peroxide (mg/L)
  - 2500 mg/L Chitosan + Hydrogen Peroxide
  - 2500 mg/L Chitosan + 2500 mg/L FeSO$_4$ + Hydrogen Peroxide
Fig. 11

- $2500 \text{ mg/L Chitosan} + \text{Hydrogen Peroxide}$
- $2500 \text{ mg/L Chitosan} + 2500 \text{ mg/L FeSO}_4 + \text{Hydrogen Peroxide}$

Zeta Potential $\zeta$ (mV)

Concentration of hydrogen peroxide (mg/L)
1 List of tables

2 Table 1

3 POME discharge standards set by Department of Environment (DoE), Malaysia under the Environmental Quality Act 1974

<table>
<thead>
<tr>
<th>Parameters*</th>
<th>Discharge limits</th>
</tr>
</thead>
<tbody>
<tr>
<td>Biochemical oxygen demand</td>
<td>100</td>
</tr>
<tr>
<td>Chemical oxygen demand</td>
<td>Not legislated</td>
</tr>
<tr>
<td>Total suspended solids</td>
<td>400</td>
</tr>
<tr>
<td>Total nitrogen</td>
<td>200</td>
</tr>
<tr>
<td>Oil &amp; grease</td>
<td>50</td>
</tr>
<tr>
<td>pH</td>
<td>5 - 9</td>
</tr>
</tbody>
</table>

a: All parameters are in mg/L except pH

5 Table 2

6 Performance comparison between activated carbon (AC) adsorption and ultrasound (US) cavitation on COD (mg/L) and TSS (mg/L) removals from POME

<table>
<thead>
<tr>
<th>Operating conditions</th>
<th>COD (mg/L)</th>
<th>BOD (mg/L)</th>
<th>TSS (mg/L)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Biologically digested POME</td>
<td>4700±550</td>
<td>1355±434</td>
<td>1800±282</td>
</tr>
<tr>
<td>AC adsorption (6 h, 200 g AC/L)</td>
<td>ND*</td>
<td>ND*</td>
<td>ND*</td>
</tr>
<tr>
<td>US cavitation (50% amplitude, 90 min cavitation time)</td>
<td>965±49.49</td>
<td>260±60.10</td>
<td>75±35.35</td>
</tr>
<tr>
<td>US cavitation followed by AC adsorption (50% amplitude &amp; 15 min cavitation time, 50g AC/L &amp; 30 min AC contact time)</td>
<td>ND*</td>
<td>ND*</td>
<td>310±56.56</td>
</tr>
<tr>
<td>US cavitation (50% amplitude, 15 min cavitation time) coupled with AC adsorption (50 g AC/L)</td>
<td>1265±190.91</td>
<td>360±106.06</td>
<td>30±14.14</td>
</tr>
</tbody>
</table>

ND: Not detected