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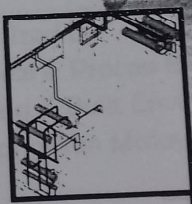
15th
**REGIONAL SYMPOSIUM
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**INNOVATIONS FOR
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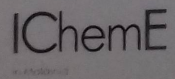


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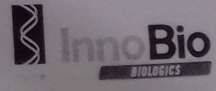
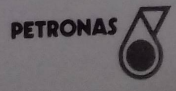
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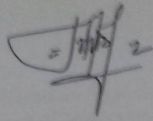


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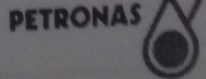
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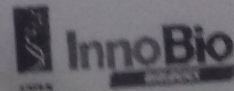
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INNOVATIONS FOR SUSTAINABLE FUTURE

VOLUME II

Proceedings of the 15th Regional Symposium On
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PREFACE

RSCE-SOMChE 2008 is the formal proceedings of the 15th Regional Symposium of Chemical Engineering 2008 and the 22nd Symposium of Malaysian Chemical Engineers 2008 jointly held at the Impiana Hotel & Spa in Kuala Lumpur, Malaysia on the 2-3 December 2008. The combined symposia is a continuation of the two highly successful symposia; the former is an important annual forum for academicians, researchers, and practitioners in the South East and Pacific Asian region and the latter is an equally important forum for their Malaysian counterparts, to exchange knowledge and information in the broad area of chemical engineering science and technology. The RSCE-SOMChE 2008 has a pivotal role in improving chemical engineering research and linkages in the ASEAN region as well as in Malaysia.

The theme *Innovation for Sustainable Future* reflects the urgent need for chemical engineers to practice their art in a sustainable way to ensure future generations will still enjoy a high quality of life. In general, RSCE-SOMChE 2008 highlights the roles of chemical engineering in meeting the challenges and exploring opportunities in sustainable engineering.

As the chief editor of the proceedings, I am delighted that the response of papers has been overwhelming from so many countries. Exactly 402 abstracts were received and accepted but only 300 papers were finally received and accepted for inclusion in both volumes of the proceedings. I am happy to report that authors from 12 countries, 61 universities and 3 companies are participating in this conference. The countries are Malaysia, Australia, Finland, India, Indonesia, Iran, Japan, Singapore, New Zealand, Philippines, Poland & Thailand.

While RSCE-SOMChE 2008 set the pace for regional collaboration and sustainable development in the field of chemical engineering, the symposium also emphasizes innovative chemical engineering in meeting the goals of sustainable engineering. As the Third World develops at a very fast rate, there is concern that indiscriminate use of unsustainable technology there may destroy the environment at an even faster rate leading to environmental and ecological disasters some of which are already emerging.

The first volume of the proceedings contains the plenary papers and papers in the field of biomolecular and bioprocess engineering, complex fluid engineering, clean production and safe practice and food and product technology. The second volume contains papers in advanced materials and nanotechnology, process system engineering, renewable energy and reaction engineering.

The massive editorial effort has been lightened by untiring efforts of fellow editors. Finally I would like to acknowledge with thanks the efforts of Keynote lecturers and all authors in meeting manuscript deadlines and adhering to the format. I would like to apologize to authors if any errors inevitably have crept into their work during the editorial process.

Prof. Ir. Dr. Wan Ramli Wan Daud, Chief Editor, November 19, 2008

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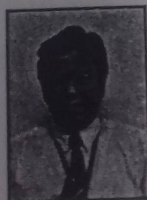
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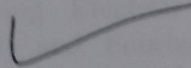
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SYNTHESIS AND CHARACTERIZATION THE COMPOSITE ORGANIC-INORGANIC MEMBRANE USING SOL-GEL PROCESS FOR PROTON EXCHANGE MEMBRANE FUEL CELL (PEMFC)

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Keywords: Heteropolyacid (PWA), Nafion, Nanocomposite, Sol-gel

ABSTRACT

Nafion-silicon oxide (SiO₂)-phosphotungstic acid (PWA) composite membrane has been synthesized for medium temperature Proton Exchange Membrane Fuel Cell (PEMFC) application using sol-gel method. X-ray diffraction (XRD) was used to determine saturated absorption of PWA in the silica matrix. A transparent film was achieved at annealing temperature of 140°C over 10 hours duration. The film than was characterized by Scanning Electron Microscope (SEM), Transmission Electron Microscope (TEM) and Fourier Transform Infrared Spectroscopy (FTIR). The SEM and TEM results indicated homogenous structure of the Nafion-SiO₂-PWA composite membrane with SiO₂ and PWA particles size less than 10 nm. X-Ray Diffraction (XRD) result showed that the maximum loading of PWA in the SiO₂ matrix is in the ratio of PWA/SiO₂ equal to 0.45 (wt./wt.). The vibration absorption peak of Si-O-Si bond at 800 cm⁻¹ and W-O-W at 755 cm⁻¹ were observed thus indicated the inorganic compound was embedded in the Nafion matrix and did not leach out after washing treatment using acid and base solutions.

INTRODUCTION

Perfluorosulfonic acid (PFSA) membrane (e.g. Nafion) is not suitable for low relative humidity PEMFC application because the conductivity of PFSA membrane was dramatically reduced at low relative humidity (RH). Therefore, a need exists to develop membrane for PEMs application that are functional at low operating RHs.

Nafion based organic/inorganic composite membrane with heteropolyacid (phosphotungstic acid, PWA) additive using tetraethoxyorthosilicate (TEOS) as immobilizer to the PWA have been investigated as alternative material for low humidity PEMFC operation.

The aim of this experiment is to prepare the Nafion-SiO₂-PWA composite membrane using solution phase sol-gel method with incorporation of silica and PWA in the Nafion cluster to produce Nafion-SiO₂-PWA nanocomposite membrane. XRD was utilized to determine the maximum PWA loading in the silica matrix. The parameters that have been studied are: (i) annealing time and (ii) ratio of SiO₂/Nafion to the physic-chemical properties of the composite membrane.

MATERIALS AND METHOD

Materials

Nafion solution of 5 wt% (EW 1100 Dupont), TEOS (Si(OC₂H₅)₄) 98%, PWA (H₃PW₁₂O₄₀) 96%, Dimethylformamide (DMF), Sulfuric acid (H₂SO₄) 98%, Hydrogen Peroxide (H₂O₂) 30% were all purchased from Aldrich. Deionized water was used as solvent in all the experiments.

Method

Membrane Preparation.

Appropriately 5% wt Nafion solution was evaporated at room temperature to obtain solid Nafion. Solid Nafion was dissolved in DMF solvent to obtain 5% wt Nafion solution in DMF. PWA was also dissolved in deionized water and then mixed with TEOS at weight ratio of PWA:SiO₂ = 4:10. Subsequently, it was stirred in an ultrasonic bath for 30 min, and added to the Nafion-DMF solution and further stirred in an ultrasonic bath for 6 hours. The mixture was allowed to stand at room condition to release trapped air bubbles for another 24 hours without mixing. This solution was casted in a Petri dish and heated at 80°C for 2 hours to remove the solvent. In order to enhance the mechanical properties of the composite matrix, heating was continuously applied at 140°C at different periods of 2, 4, 6 and 10 hours until transparent membrane was obtained. Then, the recast composite membrane was made to detach from the Petri dish by boiling it in the de-ionized water. Finally, the membrane was cleaned by heating at 80°C in the solution of 3 wt. % H₂O₂, de-ionized water, 0.5M H₂SO₄ and again in de-ionized water until the pH of the washing water becomes almost neutral. These composite membranes are designated NS10W, NS15W and NS20W, whose specifications in ratio of Nafion/TEOS/PWA are 100:10:1.1538; 100:15:1.7303 and 100:20:2.3072 (wt./wt./wt.), respectively.

RESULTS AND DISCUSSION

Saturated Loading of PWA Particle in the SiO₂ Matrix

The XRD pattern of pure silica, pure PWA and the mixture of Silica-PWA are as show in Fig 1. The amount of heteropolyacid (PWA) loaded on silica was limited

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by the uptake characteristics of silica. Fig 1(a-b) show consecutively the XRD pattern of PWA crystalline and silica amorphous phase. While Fig 1(c-e) show the XRD pattern of the PWA entrapped on silica with the ratio of PWA/SiO₂ is 0.45, 0.6 and 0.15 (wt/wt.), respectively. The selected of PWA loaded amount correspond to uniform distribution of the PWA on the silica pore shows overlapping between the typical crystalline structure of PWA and the amorphous structure of silica at ratio of PWA/SiO₂ is (0.15) and (0.45) (wt./wt.).

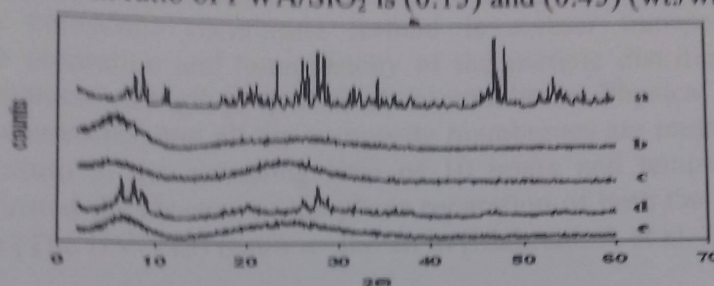


Figure 1.

XRD Pattern of (a) Pure PWA, (b) Pure SiO₂, (c) Ratio of PWA/SiO₂ (0.45), (d) Ratio PWA/SiO₂ (0.6) and (e) Ratio PWA/SiO₂ (0.15).

Fig 1(c) and Fig 1(e). revealed an overlapping between the typical crystalline structure of PWA and the amorphous structure of silica. The results indicated that at the ratio of PWA/SiO₂ (0.15) until 0.45 all of the PWA particles have inserted in the silica pores and the peak assign to the PWA particle has disappeared. If the ratio of PWA/SiO₂ increase to 0.6, a different spectral pattern is obtained that the sharp spectral peak attributed to the presence of PWA crystalline in the SiO₂-PWA mixture appear. It means that a part of PWA particle is not insert in the silica pores cause the silica pore has been full filled by PWA particles and saturated loading has been reached. Therefore it can be conclude that the saturated PWA loading on the silica pore is best at the ratio of 0.45 (wt./wt.) as show by Fig 1 (c). This ratio will be used for the designed of the composition of NS10W, NS15W and NS20W composite membrane prepared using sol-gel method.

Clarity analysis to optimize annealing time and temperature

The time required to produce transparent membrane is 10 hours at annealing temperature 140°C for all the composite membranes. After the post treatment of

washing and drying, the membrane was analyzed using UV-VIS spectrophotometer, to determine qualitatively the amount of inorganic phase distribution in the organic polymer matrix. The transparency of the composite membrane is a measure of inorganic phase distribution in the range of nanoscale dimension in the organic polymer matrix [Khana, P.K. et al. 2005]. If phase dissociation has taken place, the composite membrane formed is neither transparent nor translucent. Phase separation and homogeneity of the particle distribution also influence the mechanical strength properties of the membrane. Physical visibility of Nafion 112 (commercial) and all the composite membranes are transparent in the UV-VIS spectrum at the annealing time of 10 hours and temperature of 140°C, which indicated the absence of the phase separation of both the inorganic and organic phase (The UV-VIS) result is shown in [Mahreni, A et al. 2008].

The result also showed that there are chemical interactions taking place between the organic and inorganic compounds through the hydrogen bonding between the sulfonate group of Nafion polymer and the hydroxyl (OH) group of the silanol Si(OH) produced via the hydrolysis of TEOS molecules. On the other hand, the electrostatic interactions between the ions of $H_3PW_{12}O_{40}$ and SiOH took place in the composite membrane material. Therefore, the composite membrane has strong bonding between organic-inorganic compounds, which could have been responsible for the transparency and homogeneous distribution of the inorganic phase in the organic matrix.

SEM and TEM analysis

The morphology of the composite Nafion-SiO₂ recasted membrane are shown in Fig 2. It can be seen that the solid SiO₂ and PWA are uniformly distributed within the membrane and do not form any agglomerate structures. The thickness of composite membrane is measured to be $70 \pm 5 \mu m$.

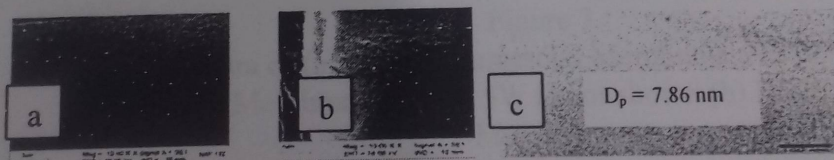


Figure 2.

(a) SEM Cross Section Image of Nafion 112 (Commercial)
 (b) NS15W With Magnification 10.000 X, (c) TEM Cross Section Image of NS15W Membrane With Magnification 60.000 X, (NS10W and NS20W are not shown)

FTIR analysis

The interactions between SO₃H and SiOH and PWA were studied by FTIR which were used to monitor the formation of Nafion/SiO₂/PWA nanocomposite film [Ramani, V. et al. 2005]. The FTIR spectra at 4000-400 cm⁻¹ were shown in Fig.

3. The major vibration associated with the Nafion membrane (Fig. 3a) were found in N112, NS10W, NS20W nano-composite membranes. The two C-F stretching vibrations of the PTFE backbone can be observed at 1194 cm^{-1} and 1134 cm^{-1} . The peaks observed at 1054 cm^{-1} and 9670 cm^{-1} were attributed to the stretching vibration moieties of SO_3^- and C-O-C, respectively. IR spectra for bonding structure of C-O-C of Nafion membrane at wave number (967 cm^{-1}) shifts to lower wave number of 967 cm^{-1} for NS15W composite membranes. This phenomenon can be attributed to the strong interactions of SiO_2 component and sulfonate groups in side chain of the Nafion polymer [Ramani V. et al. 2004] [Shao Z.G. et al. 2004]

The observable peak at 980 cm^{-1} represents the vibration moiety of the W=O functional group. Therefore, it is evident from these data that the SiO_2 and PWA are indeed present in the composite membranes even after these membranes had undergone the pretreatment process of washing using 3wt % H_2O_2 and 0.5 M H_2SO_4 solution at the temperature of 80°C for 1 hour. It is apparent that the SiO_2 and PWA are compatible with Nafion membrane and the PWA is able to be immobilized into the SiO_2 media.

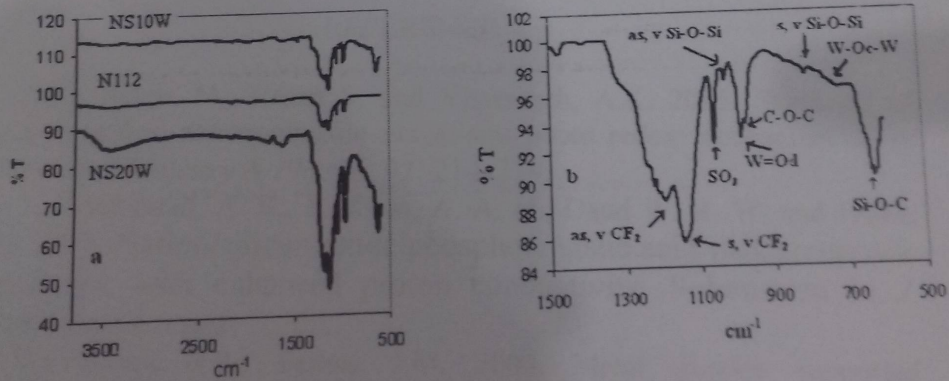


Figure 3
FTIR Spectra of (a) N112 Commercial Membrane, NS10W and NS20W Composite Membrane for NS15W is not shown (b) NS20W Composite Membrane

CONCLUSION

Nafion-SiO₂-PWA composite membrane has been successfully made using sol-gel method at solvent evaporation temperature of 80°C and annealing temperature of 140°C for 10 hours at fixed ratio of PWA/SiO₂ = 0.4 (wt./wt.). All of the composite membrane synthesized at above conditions showed transparent visibility and suggested that the homogeneous distributions of the inorganic particles in the nano dimension of the organic matrix. The SEM and TEM measurements showed homogeneous structure of the composite and the particle size of less than 10 nm is obtained. The observable peak at 980 cm⁻¹ represents the vibration moiety of the W=O functional group. Therefore, it is evident that the SiO₂ and PWA are indeed present in the composite membranes even after these membranes had undergone the pretreatment process. It is apparent that the SiO₂ and PWA are compatible with Nafion membrane and the PWA is able to be immobilized into the SiO₂ media.

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