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Optimization of ZLD in Distillery Industry by Reverse Osmosis Process for Prediction of Multi Responses by Taguchi Orthogonal Array

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ABSTRACT
In this study, the effects of Operating Pressure, Potential Hydrogen, Oxidation Reduction Potential and Anti Scaling Agent on multi responses like Permeate, COD, Total Solids, Conductivity and Hardness in the Reverse Osmosis Process were experimentally investigated on RO 8100 ST8 PT44 400Wl machine. The settings of RO parameters were determined by using Taguchi's experimental design method. Orthogonal arrays of Taguchi, the signal-to-noise (S/N) ratio, the analysis of variance (ANOVA) are employed to find the optimal levels and to analyze the effect of the RO parameters. Results show that potential of hydrogen, operating pressure, oxidation reduction potential and anti scaling agent are the four Parameters that influence the Permit more effectively and COD, Total Solids, Conductivity and Hardness respectively. Finally, the ranges for best RO conditions are proposed for ZLD process.

KEYWORDS: *ANOVA, reverse osmosis parameters, design of experiment, multi response, orthogonal array, Taguchi method.*

I. INTRODUCTION

One of the most important environmental problems faced by the world is the pollution that is mostly generated by industries. India is the most sugar producing country in world in recent time and integrated with distilleries and distillery waste have hazardous effects. Molasses based distilleries are classified as a 'Red' category Industry by the Central Pollution Control Board. With the amount of highly polluting, spent wash being generated at 10 to 15 times the volume of spirit produced, it is an area of major environmental concern. A recent report suggests that there are 325 molasses based distilleries in the country producing 3063 million litres/year (M.Ltr/year) of alcohol and generating 45945 M.Ltr/year of spent wash as waste annually. A Spent wash goes through different phases like pretreatment in digester then lagooning for settling of solids and then major process of reverse osmosis separating clean water from effluent and make the spent wash concentrate for agriculture Biocomposting and clean water again used in industry. In this paper the RO processes parameters are complete study and how to improve the clean water call permeate with quality in that again used in industry and study. The RO Parameters are pressure ph, ORP and anti scaling which more affect the process of RO by Taguchi Array set of representation in done so that effective utilization in resources to get the maximum quality output.

II. LITERATURE REVIEW

Lingyung Hung et.al [1] this paper states that objective of this study is to remove salt from high salinity wastewater and recycle a purified stream using an RO process. It was found that high operating pressure and temperature were beneficial for wastewater treatment using the RO process. R Gunther et al [2] states that the paper some aspect of engineering plant designs and economics of high pressure reverse osmosis system will be discussed. S. Velikova ET. Al. [3] The effects of operating pressure and feed concentration on the solute transport parameter (D,,/KS) and mass transfer coefficient (k) with respect to aqueous sodium chloride solutions for different cellulose acetate membranes have been studied. Payel Sarkar ET. Al. [4] Small scale brackish water desalination units are used in remote areas and their sustenance depend on the twin factors of consistency of product water quality and availability of raw water resources. Jongs up Hong eP. Al. [5] Pressurized oxy-fuel combustion power cycles have been investigated as alternatives. In this paper, as the extended work of our previous study, we perform a pressure sensitivity analysis to determine the optimal combustor operating pressure for the pressurized oxy-fuel combustion powercycle. R.Rauntenbach ET. Al. [6] this Paper discussed a simpler and more-energy efficient process the combination of RO, operating at 16, 120 and 200 bar, with nano filtration ad crystallizer/filtration. Jolanta Bohdziewicz ET. Al. [7] this paper review an attempt at removal of nitrate ions from tap water by means of the compound reverse osmosis process and nono filtration. In the first stage water was filtered from Nano filtration membranes which resultant in the absence of bivalent ions in the obtained permeates. Vidyadhar V. Gedam ET. Al. [8] this paper examines the influence of different operating parameters such as pressure, temperature, pH on the performance of polyamide reverse osmosis membrane. Thus, proper control of these factors is essential for successful operation and maintenance. B. A. WINFIELD et. Al. [9] states that Investigations have been made into techniques of removing sewage fouling from cellulose acetate membranes using a pilot scale reverse osmosis unit. It has been found that reductions in the pH of solutions surrounding the membrane when not pressurized are effective in loosening the fouling: Hoang ET. Al. [10] states that conversely, calcium rejection improves in the presence of even small quantities of alginate foulant at all pH values. The concentration of foulant, the feed pH and the presence of calcium are all shown to impact upon this performance.

Pham Thanh Hai et. Al.[11]This project aims to investigate the effect of pH in order to improve the efficiency of the RO desalination process. Based on the primary knowledge, decreasing the pH of the solution to a certain extent can create several improvements to both the plant and the product. Bogdan C. Donose et. Al.[12]In this study, three types of commercially available RO membranes were statically exposed to hypochlorite solutions and analyzed by Fourier transform infrared spectroscopy (FTIR), Scanning Electron Microscopy (SEM) and Atomic Force Microscopy(AFM) in conjunction with performance tests.) Hiroaki Ozaki et. Al.[13] states that the investigation was conducted for synthetic wastewater and wastewater from the heavy metal industry. L. Y. Dudley ET. Al. [14] this paper highlights how the selection of appropriate proprietary chemicals and their use in conjunction with good pre-treatment design can ensure cost-effective and efficient operation. Yuelian Peng ET. Al. [15] In this work, effects of four anti-scaling and five cleaning agents on calcium sulfate scaling in direct contact membrane.

C.Saleh Al-Zahrani et. Al.[16] states that the purpose of this paper is to review the results of using different types of anti-sealant chemicals at the Al-Jubail Desalination Plant. This paper will compare the results experienced using the above chemicals. This paper will also discuss the necessity of anti-sealant selection for every operating mode in MSF evaporators. A Mubarak. ET. Al. [17] meanwhile, In this paper, a) the reaction mechanism leading to CaCO 3 crystallization is presented, b) the rates of the individual steps at this operational temperature are reported; and c) the inhibiting effects of antiscalants on all of the rates involved are quantified and discussed. S.A. Al-Saleh ET. Al. [18] states that in the past three decades a great deal of research activity has focus& on the development and testing of anti-scale agents. Three basic methods are commonly applied in inhibition of scale formation. The first method involves the prevention of scale deposition through pH adjustment by acid addition. The second method controls scale precipitation through the addition of special chemicals either alone or coupled with sponge ball cleaning. The third method is a combination of additive and acid addition. R.J. Xie et. Al.[19] states that changes in reduction and oxidation potential (ORP) were studied with variations in chlorine doses (0–5 mg L–1 NaOCl) and salinities. As expected, the ORP values were greater at higher than at lower chlorine doses for any given water.

III. TAGUCHI BASED DESIGN OF EXPERIMENTS

Among the available methods, Taguchi design is one of the most powerful DOE methods for analyzing of experiments. It is widely recognized in many fields particularly in the development of new products and processes in quality control. The salient features of the method are as follows: a. a simple, efficient and systematic method to optimize product/process to improve the performance or reduce the cost. b. Help arrive at the best parameters for the optimal conditions with the least number of analytical investigations. c. It is a scientifically disciplined mechanism for evaluating and implementing improvements in products, processes, materials, equipment's and facilities. d. Can include the noise factor and make the design robust. e. Therefore, the Taguchi method has great potential in the area of low cost experimentation. Thus it becomes an attractive and widely accepted tool to engineers and scientists. [20] Sharda R. Nayse ET. Al. The machining processes generate a wide variety of surface textures. Surface texture consists of the repetitive and random deviations from the ideal smooth surface. These deviations are Roughness: small, finely spaced surface irregularities (micro irregularities) Waviness: surface irregularities of greater spacing (macro irregularities) lay: predominant direction of surface texture [21] Ani Idris et. Al. states that cellulose acetate hollow fiber membranes for reverse osmosis (RO) were spun using a forced convection technique. In this study, a systematic experimental design based on Taguchi's method (which is a fractional factorial method) has been employed for discussing the relationship between the rejection rate coefficient, permeation rate and the dry–wet spinning conditions for making cellulose acetate hollow fibers for RO. The factors considered in the experimental design included the

polymer contents (PCs), the ratio of the solvent (acetone) to swelling agents (form amide) in the dope solution, the dope extrusion rate (DER), the type of bore fluid (BF), the residence time (RT) and the nitrogen gas flushing rate (GR). The results indicate that the BF and the DER are the two most important factors in determining the performance of the RO membranes. [22] Soumaya Yacout ET. Al. Quality control, quality assurance and total quality management are all concerned with managing and controlling variations. The less variation a system has the better quality it provides. Using the Taylor Expansion Series, Dr. Taguchi (1986) developed a mathematical model in which loss is a quadratic function of the deviation of the quality of interest from its target value.
Taguchi defines three quality characteristics in terms of signal to noise (S/N) ratio which can be formulated for different categories which are as follows:

a. Larger is best characteristics
Data sequence for maximizing the permeate, which is higher-the-better performance characteristics, is preprocessed as per equation 3. S/N = -10 log ((1/n) (Σ (1/y2))……..…3, Where, y is value of response variables and n is the number of observations in the experiments.

b. Nominal and small are best characteristics
Data sequence for Chemical oxygen demand, Total Solids, Conductivity and hardness, which are lower-the-better performance characteristics, are preprocessed as per equations. S/N = -10 log (ŷ/s2y)………………….1, S/N = -10 log ((l/n) (Σy2))…………..……2

2.1 Taguchi method- based design of experiments involved following steps,
a. Definition of the problem
b. Identification of noise factors
c. Selection of response variables
d. Selection of control parameters and their levels
e. Identification of control factor interactions
f. Selection of the orthogonal array
g. Conducting the matrix experiments (experimental procedure and set-ups)
h. Analysis of the data and prediction of optimum level

a. Definition of the problem
A brief statement of the problem under investigation is "To optimize the Reverse Osmosis Process parameters to minimize COD, Total solids, Conductivity and hardness and maximize the Recovery."

b. Identification of noise factors
The environment in which experiments are performed is the main external source of temperature of performance of Reverse Osmosis process. Some examples of the environmental noise factors are temperature, Feed Salinity, Cleaning Procedure and human error in operating the process.

c. Selection of response variables
In any process, the response variables need to be chosen so that they provide useful information about the performance of the process under study. Various parameters used while designing the experiments. By considering all parameters given below and by taking literature review as technical base Permeate, COD, TS, COND and Hardness are chosen as response variables.

D. Selection of control parameters and their levels:
The process parameters affecting the functioning of Machine Related Parameters: Operating Pressure and Process Related parameters are - Potential of Hydrogen by HCL adding, ORP by SMBS adding and Anti scaling agent by ROHIB adding.

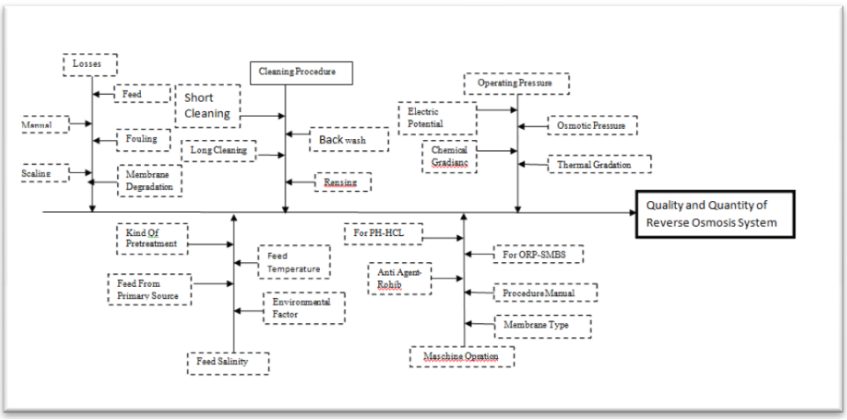


Figure 2.1 Fishbone diagram of cause of effect

1.1. Selection of Operating Pressure (OP)

It is known from the fundamental of R.O process on operations pressure plays a vital role for maximizing the permeate and quality of the permeate in literature[1-10] of R.O Process note that by increasing OP the quantity of output increases with quality. Further by more increase in pressure lead to damaging the system and quality of output. Which then lead to deterioration the membrane such as quality and integrity of the system. So with destiny specification from manufacturer the range of OP is determined the effect is analyzed on output.

1.2. Selection of Potential of Hydrogen (PH)

Available literature [11-12-13] on RO process include that the influence of PH on output of RO on membrane efficiency. Then proper control of ph is essential for successful operation and maintenance. The changing physicochemical property of effluent produce an explanation of the modes, action of the PH effect feed PH presence of calcium impact upon the performance of RO Process. Performance test shown a reduction of de-ionized water and blackish water permeability

1.3. Selection of Oxidation Reduction Potential (ORP)

It is known that ORP of the feed greatly affect permeate as move the negative the ORP the better the result we get in permeate. Some quality parameter gets affected by the ORP changing. The surface of membrane get less gel formation (Concentration Polarization) paper suggests that. ORP plays a vital role in it came to smooth operation and efficiency of RO process.

1.4. Selection of Quantity of Anti Scaling Agent (ASA)

It is found that scaling and fouling is a major loss to the RO process by which the permeate is affected and is the qualities of permeate also. On view of Literature [14-18] facedown of anti-scalant is given according with the feed and avoids the machine failure. Consulting the literature review and available anti scalant is to be managed. Considering the literature review and the available machine settings following process parameters were selected for the present work:

a) Operating Pressure (OP), b)Potential OF Hydrogen (PH), c)Oxidation Reduction Potential (ORP) ,d)Anti Scaling agent (ASA)

d. **Selection of orthogonal array**-

Selection of particular orthogonal array from the standard O.A depends on the number of factors, levels of each factor and the total degrees of freedom.

- Number of control factors = 4
- Number of levels for control factors = 3
- Degree of freedom of each factor= number of level-1=3-1=2
- Degree of freedom of interaction of A*B= (2*2)=4
- Degree of freedom of interaction of A*C= (2*2)=4
- Degree of freedom of interaction A*D= (2*2)=4
- Total Degree of freedom of control factors = 4*2=8
- Total Degree of freedom of interaction = 4+4+4=12
- Total degree of freedom-8+12=20
- Minimum number of experiments to be conducted =20+1=21

Based on these values and the required minimum number of experiments to be conducted is 21, the nearest O.A. fulfilling this condition is L27.Therefore, Number of trials =27. The Experimental design has been shown with coded and actual values of input parameters are shown in Table 1

Table1. Methodology Used For Termination of Reverse Osmosis Process

Work piece Material	Parameters	TSS	COND	TDS	TH $CACO_3$	CH $CACO_3$	MH $CACO_3$	M-alkalinity as $caco_3$
	Values	3000max	33600max	24000max	800max	450-500max	300max	2000max
	Parameters	**P-alkalinity** as $caco_3$	**Chlorides as Cl**	**Sulphates as SO4**	**Iron as Fe**	**Oil &Grease**	**Free chlorine**	**Phosphates**
	Values	Nil	3000-5000max	1000 – 1500max	0.5max	Nil	Nil	600 - 700max
	Parameters	**Sodium as Na**	**Potassium as K**	**Nitrogen**	**Fluoride**	**Total Silica as SiO2***	**COD**	**BOD**
	Values	4000max	8000 - 10000max	1000 – 1100max	0.5max	30max.	27000 - 29000max	4500 – 5500max
Response Variables	**In-process**	Quantity- Permeate		Quality- COD, Total Solids, Conductivity, Hardness				
Control Variables	**Process related**	Potential of Hydrogen (PH)		Oxidation Reduction Potential (ORP)			Anti Scaling Agent (ASA)	
	Machine Related	Operating Pressure						
Design of Experiments		**Taguchi Method**		L27(45) Orthogonal array				
Tools & Equipments		**Machine**		**RO 8100 PHARM ST8 PT44400W**				
Membrane Type		Spiral		Plate and Frame				
Reverse Osmosis Process Component		Filter Pump, Sand Filters, Dosing Systems, Cartridge Filters, High pressure Pump, ST Modules, Inline Booster Pump, PT Modules, Servo Motor Control Valve, Diverter Valves, Cleaning System, Control Panel, Measuring Equipments Instruments, Intermediate Tank, Intermediate pump, Degasser, Permeate transfer pump, Permeate tank						
Assessment of response variables		COND Meter, (COD, Total Solids and Hardness) according to Procedure Manual of test						
Method of effect analysis		MINTAB-15 software ANOVA			Quantitative analysis of Reverse Osmosis Machine			
Criteria for analysis		Smaller the better			COD, Total Solids, Conductivity, Hardness			
Larger the better		Permeate						

Table 2: Design of Experiments - Taguchi Array (L27)

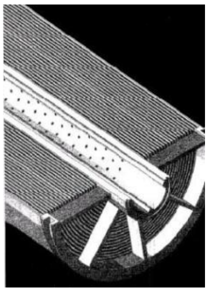
RUN	OP	PH	ORP	ASA
1	35	5.9	-30	0.5
2	35	5.9	-180	1
3	35	5.9	-330	1.5
4	35	6.4	-30	1
5	35	6.4	-180	1.5
6	35	6.4	-330	0.5
7	35	6.9	-30	1.5
8	35	6.9	-180	0.5
9	35	6.9	-330	1
10	40	5.9	-30	0.5
11	40	5.9	-180	1
12	40	5.9	-330	1.5
13	40	6.4	-30	1
14	40	6.4	-180	1.5
15	40	6.4	-330	0.5
16	40	6.9	-30	1.5
17	40	6.9	-180	0.5
18	40	6.9	-330	1
19	45	5.9	-30	0.5
20	45	5.9	-180	1
21	45	5.9	-330	1.5
22	45	6.4	-30	1
23	45	6.4	-180	1.5
24	45	6.4	-330	0.5
25	45	6.9	-30	1.5
26	45	6.9	-180	0.5
27	45	6.9	-330	1

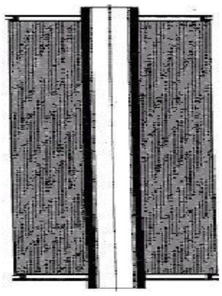
III. SELECTION OF WORK AND TOOL MATERIAL

I. St Tube Module (ST 161 -162)
i. Specification of STModule:
ii. Description:

Spacer Tube Module
The spacer tube module has been developed to gain hybrid advantages from an open channel and spiral module design. The result is a membrane element with a channel design that is narrow and open.

SR.N	DESCRIPTION	UNIT	VALUE
1.	Part No: RO Pressure Vessel	-	100601310115
2.	Length of PressureVessel	MM	1105
3.	No. ofElement	Nos.	04 (Stage – I) 04 (Stage –2)





IV. CONSTRUCTION DETAILS OF PT MODULE

The Plastic Flow Schematic of PT Module is shown in the diagram. This diagram gives the important components of the PT Module a fully modular design comprising the following components:
Membrane Cushion Plastic Carrier Discs with internal 'O' RingGasket

Fig 4.1 Cushion Plastic Carrier Discs

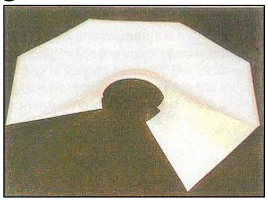
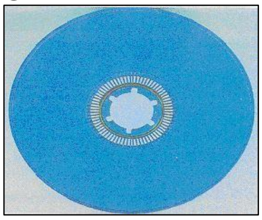


Fig 4.2 Internal 'O'Gasket



Parameters	TSS	COND	TDS	TH $CACO_3$	CH $CACO_3$	MH $CACO_3$	M-alkalinity as $caco_3$
Values	3000max	33600max	24000max	800max	450-500max	300max	2000max
Parameters	**P-alkalinity as $caco_3$**	**Chlorides as Cl**	**Sulphates as SO4**	**Iron as Fe**	**Oil &Grease**	**Free chlorine**	**Phosphates**
Values	Nil	3000-5000max	1000 – 1500max	0.5max	Nil	Nil	600 - 700max
Parameters	**Sodium as Na**	**Potassium as K**	**Nitrogen**	**Fluoride**	**Total Silica as SiO2***	**COD**	**BOD**
Values	4000max	8000 - 10000max	1000 – 1100max	0.5max	30max.	27000 - 29000max	4500 – 5500max

Table3. Chemical composition of Spent washes

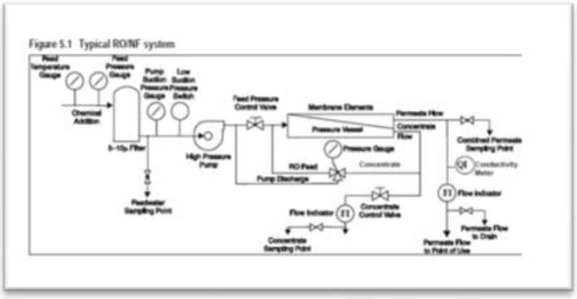
a. Test specimen
The work material used for the present study of SSK industry spent wash of characteristics of table no 3.

b. *Cutting Tool*
The recently developed tool materials like ST Module and PT Module With Perfect Combination have improved the productivity with good output machine material. Table 3 and 4 gives the specification of different membrane type.

V. EXPERIMENTATION

The experiment was performed on **RO 8100 ST8 PT44400W** machine. The experimental set figure 6.2 consist of list of attachment and steps of different quality sensors, sense the parameter like temperature, ph, ORP, Conductivity of the feed. Some of them can be control through the different attachment given to the system such as HCL feed pump with HCL tank provide the level of ph control. Sodium Meta Bisulfate (SMBS) tank with pump that it can control ORP level of the feed antiscalant tank and pump control the scaling and fouling as per the need of the feed given. The temperature is noise factor can't be control its total depend on the environmental factor but for experimentation a small lagoon is made so that the define degree can be achieved. The four parameter and noise factor have different setting and adjustment such as Ph-HCL adding, ORP- SMBS adding, Anti Scalant- ROHIB adding and Operating Pressure- By HP pump adjustment by control this four factor over year and with whether support the experimentation are conducted. The sensors are well calibrated with six month duration. After the different setting given by taguchi array experimentation are conducted and water sample as permeate is taken to ORIPAL Lab pvt. Ltd. For COD, Conductivity, Total Solids and Hardness by a procedure manual with calibrated equipment and the result are taken out. The results are feed to MINITAB software to get the interaction and result.

Figure 5.1 RO Process **Fig 5.2** Control Panel **Figure5.3** Meter



VI. EXPERIMENTAL DATA ANALYSIS

Minitab 14 software was used as it provides an effortless method to create, edit and update graphs. Also it provides a dynamic link between a graph and its worksheet that helps in updating the graph automatically whenever the data is changed. Its appearance and easy to use enhancements further add to its advantages. Data analysis has been carried out by the procedural hierarchy as shown below.

1. Computation of (Signal-to-Noise Ratio) S/N ratio of experimental data. For calculating S/N ratio of Permeate, Total Solids, Conductivity and hardness, formula of S/N ratio has been selected from equation 1,2 &3 according to the objective of optimization.
2. ANOVA is carried out to find out the contribution of each parameter on the reverse osmosis process.
3. The predicted optimal setting has been evaluated from Mean Response.
4. Finally optimal setting has been verified by confirmatory test.

VII.TAGUCHI ANALYSIS (SIGNAL TO NOISE RATIO)

The Mean S/N Ratio is used to find out Optimal Level for Each Parameter and Rank of the parameter. The Rank of the parameter shows that which parameter is most effective. The mean S/N ratio for each factor at levels 1, 2, 3and 4 can be calculated by averaging the S/N ratios for the experiments. Fig. 6.1, Fig. 6.3, fig. 6.5 shows the S/N response graph for Permeate, COD, Total Solids, Conductivity and Hardness and respectively.

Table 7.1 Response Table for Signal to Noise Ratios (Permeate) Higher is better

Level	OP	PH	ORP	ASA
1	40.69	40.23	43.99	41.98
2	43.10	46.62	46.62	43.18
3	44.88	41.82	42.11	43.51
Delta	4.19	6.39	1.88	1.53
Rank	2	1	3	4

Table 7.2 Response Table for Signal to Noise Ratios (COD) Larger is better

Level	OP	PH	ORP	ASA
1	-40.24	-39.03	-36.86	-38.80
2	-38.80	-38.14	-38.57	-37.43
3	-36.37	-37.96	-39.71	-38.90
Delta	3.87	1.07	2.85	1.47
Rank	1	4	2	3

Table 7.3 Response Table for Signal to Noise Ratios (Total Solids) Smaller is better

Level	OP	PH	ORP	ASA
1	-55.03	-54.75	-54.68	-54.09
2	-54.25	-54.32	-54.36	-54.30
3	-53.51	-53.72	-53.74	-54.40
Delta	1.52	1.04	0.94	0.30
Rank	1	2	3	4

Table 7.4 Response Table for Signal to Noise Ratios (Conductivity) Smaller is better

Level	OP	PH	ORP	ASA
1	-56.02	-55.64	-55.06	-53.43
2	-54.19	-54.46	-53.97	-54.19
3	51.79	-51.90	-52.97	-54.38
Delta	4.23	3.74	2.08	0.95
Rank	1	2	3	4

Table 7.5 Response Table for Signal to Noise Ratios (Hardness) Smaller is better

Level	OP	PH	ORP	ASA
1	-26.27	-25.64	-25.08	-25.77
2	-25.57	-25.57	-25.50	-25.21
3	-24.84	-25.47	-39.71	-38.90
Delta	3.87	1.07	2.85	1.47
Rank	1	4	2	3

VIII. ANALYSIS OF VARIANCE (ANOVA)

The main aim of ANOVA is to investigate the design parameters and to indicate which parameters are significantly affecting the output performance characteristics. In the analysis, the sum of squares and variance are calculated. F-test value at 95 % confidence level is used to decide the significant factors affecting the process and percentage contribution is calculated.

Table 8.1 Analysis Of Variance For (Permeate) Higher is better

Source	DF	SS Adj	SS Adj	MS	F	% contribution
OP	2	**79.72387**	**79.7238743**	**39.861937**	195.2102	24%
PH	2	199.4341	199.43419	99.717094	488.3305	62%
ORP	2	17.45676	17.4567687	8.7283843	42.74429	054%
ASA	2	11.81435	11.814356	5.9071779	28.92839	036%
OP+PH	4	9.386	9.386	2.3464	11.49	22%
OP+ORP	4	0.735	0.735	0.1837	0.90	25%
OP+ASA	4	0.627	0.627	0.1568	0.77	15%
Residual Error	6	1.225	1.225	0.2042		
Total	26	319.68				

Table 8.2 Analysis of Variance for COD

Source	DF	SS Adj	SS Adj	MS	F	% contribution
OP	2	**67.6208**	**67.62083**	**33.81041**	500.154	54%
PH	2	5.949807	5.949807	2.974903	44.00745	47%
ORP	2	36.97252	36.97252	18.48626	273.4654	096%
ASA	2	12.13072	12.13072	6.06536	89.72426	19%
OP+PH	4	0.244	0.244	0.0610	0.90	10 %
OP+ORP	4	1.267	1.267	0.3169	4.69	037%
OP+ASA	4	0.475	0.475	0.1187	1.76	062%
Residual Error	6	0.405	0.405	0.0676		
Total	26	125.0654				

Table 8.3 Analysis of Variance for Total Solids

Source	DF	SS Adj	SS Adj	MS	F	% Contribution
OP	2	**10.38635**	**10.38635**	**5.1931797**	337.6579	06%
PH	2	4.903225	4.903225	2.4516125	159.4026	24%
ORP	2	4.156560	4.156560	2.0782802	135.1287	20%
ASA	2	0.463101	0.463101	0.2315507	15.05531	02%
OP+PH	4	0.1639	0.1639	0.04096	2.66	008%
OP+ORP	4	0.0366	0.0366	0.00916	0.60	006%
OP+ASA	4	0.0466	0.0466	0.01166	0.77	003%
Residual Error	6	0.0923	0.0923	0.01538		
Total	26	20.1274				

Table 8.4 Analysis of Variance for Conductivity

Source	DF	SS Adj	SS Adj	MS	F	% contribution
OP	2	81.292206	81.292206	40.6461033	516.46891	46%
PH	2	66.255273	66.255273	33.1276369	420.93566	37%
ORP	2	19.860891	19.860891	9.93044568	126.18101	11%
ASA	2	4.9520830	4.9520830	2.47604154	31.461773	02%
OP+PH	4	2.746	2.746	0.6865	8.72	02%
OP+ORP	4	0.426	0.426	0.1064	1.35	01%
OP+ASA	4	0.277	0.277	0.0692	0.88	03%
Residual Error	6	0.472	0.472	0.0787		
Total	26	175.2017				

Table 8.5 Analysis of Variance for Hardness

Source	DF	SS Adj	SS Adj	MS	F	% Contribution
OP	2	**9.094267**	**9.094267**	**4.547133**	21.33302	52%
PH	2	0.141035	0.141035	0.070517	0.330834	081%
ORP	2	4.751426	4.751426	2.375713	11.14573	29%
ASA	2	1.705979	1.705979	0.85299	4.001828	098%
OP+PH	4	0.0378	0.0378	0.00945	0.04	021%
OP+ORP	4	0.1495	0.1495	0.03737	0.18	080 %
OP+ASA	4	0.2187	0.2187	0.05468	0.26	12%
Residual Error	6	1.2789	1.2789	0.21315		
Total	26	17.37757				

IX. RESULTS AND DISCUSSION

For Permeate the objective is to maximize it, therefore for calculating the S/N ratio larger the better S/N ratio is used and S/N ratio is calculated for each experiment and mean of S/N ratio is also calculated for each parameter. The mean of S/N ratio is calculated to find the rank of parameter and rank of parameter shows that which parameter is most effective to the reverse osmosis process. From the mean S/N ratio at each level, maximum S/N ratio is selected which indicates the optimal level for that parameter. For potential of hydrogen (PH) the maximum S/N ratio is 62% at B2 .This indicates the optimal level for PH. Similarly for OP, ORP and anti agent the minimum S/N ratio is at A3, C1, and D3. Therefore, optimal parameter for maximum permeate is at level (A3B2C1D3) shown in fig. 7.1 i.e. Operating Pressure = 24%, potential of hydrogen = 62%, Oxidation reduction potential; = 054%, Anti Agent = 036%.

For COD the objective is to minimize it, therefore for calculating the S/N ratio smaller the better S/N ratio is used and S/N ratio is calculated for each experiment and mean of S/N ratio is also calculated for each parameter. The mean of S/N ratio is calculated to find the rank of parameter and rank of parameter shows that which parameter is most effective to the reverse osmosis process. From the mean S/N ratio at each level select the maximum S/N ratio and this S/N ratio indicate the optimal level for the parameter. Therefore for OP the maximum S/N ratio is 54% at A3 .This indicates the optimal level for OP. Similarly for ph, Oxidation reduction potential (ORP) and anti agent the maximum S/N ratio is at B2, C1, and D3. Therefore, optimal parameter for maximum COD is at level (A3 B2 C1 D3) shown in the fig. 7.3.i.e at Operating Pressure (OP) = 54%, potential of Hydrogen (PH) =47%, Oxidation Reduction Potential (ORP) =0 96%, Anti Agent (ASA) = 19%.

For Total Solids the objective is to minimize it, smaller the better S/N ratio is used and S/N ratio is calculated for each experiment and mean of S/N ratio is also calculated for each parameter. The mean of S/N ratio is calculated to find the rank of parameter and rank of parameter shows that which parameter is most effective to the reverse osmosis (RO) process. From the mean S/N ratio at each level, maximum S/N ratio is selected which indicates the optimal level for that parameter. For PH the maximum S/N ratio is 24% at A3. This indicates the optimal level for potential of Hydrogen. Similarly for Operating Pressure (OP), potential of Hydrogen (PH), Oxidation Reduction Potential (ORP) and anti agent the maximum S/N ratio is at B3, C3, and D1. Therefore, optimal parameter for minimum is at level (A3 B3 C3 D1) shown in the fig. 7.5.i.e at Operating Pressure = 06%, Potential of Hydrogen (PH) = 24%, Oxidation Reduction Potential (ORP) = 20% and Anti Agent = 012%.

For Conductivity the objective is to minimize it, smaller the better S/N ratio is used and S/N ratio is calculated for each experiment and mean of S/N ratio is also calculated for each parameter. The mean of S/N ratio is calculated to find the rank of parameter and rank of parameter shows that which parameter is most effective to the reverse osmosis (RO) process. From the mean S/N ratio at each level, maximum S/N ratio is selected which indicates the optimal level for that parameter. For OP the maximum S/N ratio is 46% at A3. This indicates the optimal level for Operating Pressure (OP). Similarly for Operating Pressure (OP), potential of Hydrogen (PH), Oxidation Reduction Potential (ORP) and anti agent the maximum S/N ratio is at B3, C3, and D1. Therefore, optimal parameter for minimum is at level (A3 B3 C3 D1) shown in the fig. 7.5.i.e at Operating Pressure = 46%, Potential of Hydrogen (PH) = 37%, Oxidation Reduction Potential (ORP) = 11% and Anti Agent = 02%.

For Hardness the objective is to minimize it, smaller the better S/N ratio is used and S/N ratio is calculated for each experiment and mean of S/N ratio is also calculated for each parameter. The mean of S/N ratio is calculated to find the rank of parameter and rank of parameter shows that which parameter is most effective to the reverse osmosis (RO) process. From the mean S/N ratio at each level, maximum S/N ratio is selected which indicates the optimal level for that parameter. For OP the maximum S/N ratio is 52% at A3. This indicates the optimal level for Operating Pressure (OP). Similarly for Operating Pressure (OP), potential of Hydrogen (PH), Oxidation Reduction Potential (ORP) and anti agent the maximum S/N ratio is at B3, C1, and D2. Therefore, optimal parameter for minimum is at level (A3 B3 C1 D2) shown in the fig. 7.5.i.e at Operating Pressure = 52%, Potential of Hydrogen (PH) =081%, Oxidation Reduction Potential (ORP) = 29% and Anti Agent = 098%.

Figure 9.1 Main effect plot for Permeate

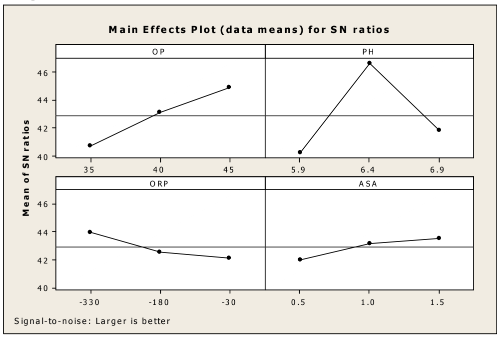


Figure 9.2 Interaction plot Permeate

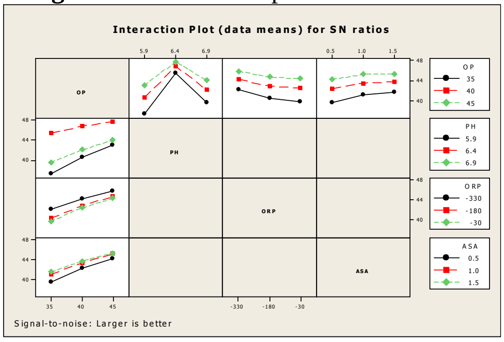


Figure 9.3 Main effect plot for COD

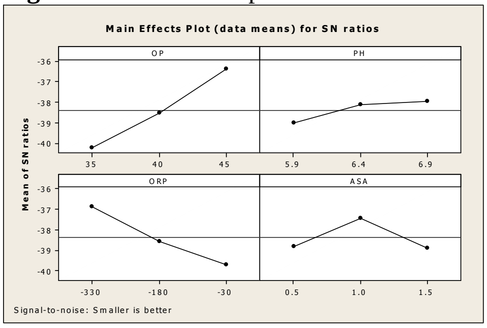


Figure 9.4 Interaction plot for COD

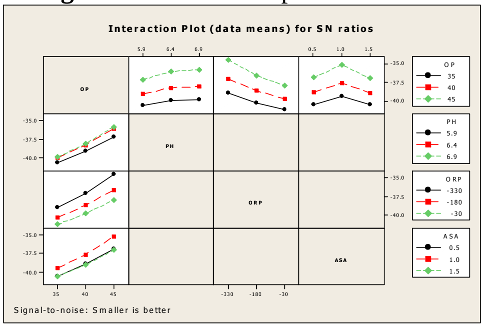


Figure 9.5 Main effect plot for Total Solids

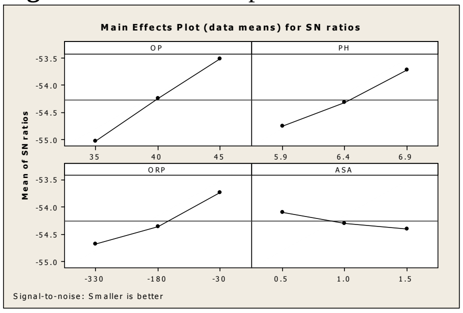


Figure 9.6 Interaction plot Total Solids

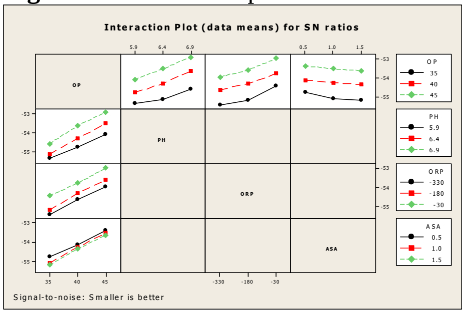


Figure 9.7 Main effect plot for Conductivity

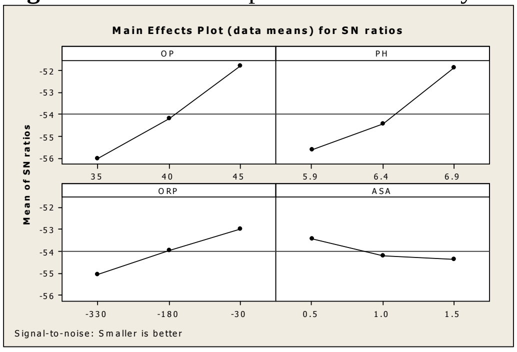


Figure 9.8 Interaction plot for Conductivity

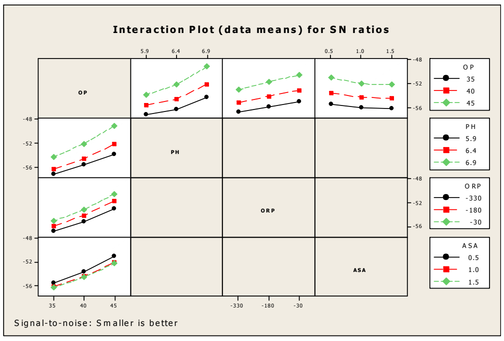


Figure 9.9 Main effect plot for Hardness

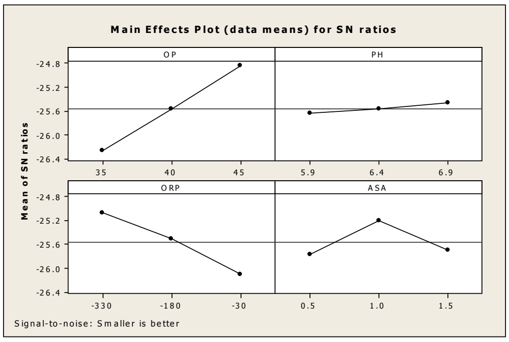
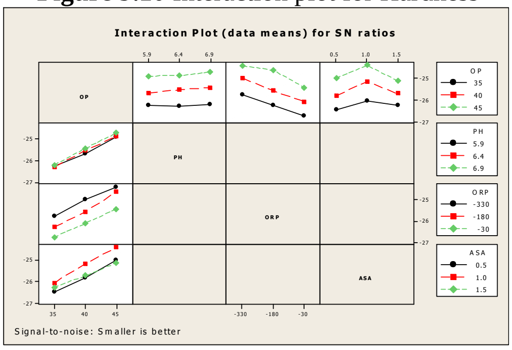


Figure 9.10 Interaction plot for Hardness



X. CONCLUSION

The following are conclusions drawn based on the tests conducted on reverse osmosis process.

I] For Permeate:-

1) From the ANOVA, Table 7.4 and the P value, the nose radius is the most significant factor which contributes to the permeate i.e. 52% contributed by the PH on Permeate
2) The second factor which contributes to permeate is the Operating pressure (OP) having 24%.
3) The third factor which contributes to Permeate is the ORP having 054%.
4) The Fourth factor which contributes to Permeate is the Anti Agent (ASA) having 036%.

II] For Chemical Oxygen Demand:-

1) From the ANOVA, Table 7.5 and the P value, the nose radius is the most significant factor which contributes to the COD i.e. 54% contributed by the OP on COD
2) The second factor which contributes to COD is the Potential of Hydrogen (PH) having 47%.
3) The third factor which contributes to COD is the ORP having 096%.
4) The Fourth factor which contributes to COD is the Anti Agent (ASA) having 019%.

II] For Total Solids:-

1) From the ANOVA, Table 7.5 and the P value, the nose radius is the most significant factor which contributes to the Total Solids (TS) i.e. 24% contributed by the potential of hydrogen on total solids (TS).
2) The second factor which contributes to total solids is the Operating pressure (OP) having 6%.
3) The third factor which contributes to total solids is the ORP having 20%.
4) The Fourth factor which contributes to total solids is the Anti Agent (ASA) having 012%.

II] For Conductivity:-

1) From the ANOVA, Table 7.7 and the P value, the nose radius is the most significant factor which contributes to the Conductivity i.e. 46% contributed by the Operating Pressure (OP) on conductivity.
2) The second factor which contributes to conductivity is the Potential of Hydrogen (PH) having 37%.
3) The third factor which contributes to conductivity is the ORP having 11%.
4) The Fourth factor which contributes to conductivity is the Anti Agent (ASA) having 02%.

II] For Hardness:-

1) From the ANOVA, Table 7.8 and the P value, the Operating Pressure (OP) is the most significant factor which contributes to the hardness i.e. 52% contributed by the Operating Pressure (OP) on hardness.

2) The second factor which contributes to hardness is the Potential of Hydrogen (PH) having 081%.
3) The third factor which contributes to hardness is the ORP having 29%.
4) The Fourth factor which contributes to hardness is the Anti Agent (ASA) having 098%.

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