UNIVERSITI PUTRA MALAYSIA

SOLVENT CRYSTALLIZATION OF PALM-BASED DIHYDROXYSTEARIC ACID

SUMAIYA ZAINAL ABIDIN @ MURAD.

FK 2006 68
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By
SUMAIYA ZAINAL ABIDIN @ MURAD

Thesis Submitted to the School of Graduate Studies, Universiti Putra Malaysia,
in Partial Fulfilment of the Requirement for the Degree of Master of Science

July 2006
This thesis is dedicated to
My beloved parents, Zainal Abidin and Sadiah
My siblings, Irfan, Anis, Zuhair and Atifa
My gradma, Saunah Awang
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Palm based 9,10-threo dihydroxy stearic acid (DHSA) was produced from epoxidation of oleic acid with performic acid, followed by hydrolysis of the epoxide. It is widely used as ingredient in cosmetic industries. However, it is a requirement for low purity crude DHSA to undergo a purification stage in order to fulfil the stringent quality requirement in this field. Solvent crystallization has been employed with detailed examination to produce good quality crystallized product.

The objective of this research work is to carry out a preliminary and detailed study on the solvent crystallization of palm based DHSA. Preliminary study was done using two different solvents, ethanol and hexane, at several concentrations and cooling conditions. The chemical and physical product properties of the crystallized product are evaluated using gas chromatography (GC), crystal size distribution (CSD) and scanning electron microscopy (SEM). The preliminary studies suggested that crystallization of DHSA using ethanol has been successfully achieved and natural cooling mode gives better performance compared to rapid cooling mode, almost in
all aspects. However, crystallization of DHSA using hexane as solvent was unable to shape DHSA into crystal. It produced bulk solid DHSA with low purity percentage (79%).

Based on preliminary studies, an investigation on controlled cooling crystallization using a fabricated crystallizer has been conducted. This study focuses on various operating conditions, namely temperature (24°C, 26°C, 28°C), time (1 – 12 hours), seeding process (2.5, 5, 10 grams) and cooling modes (natural and controlled crystallization). Effect of these parameters on crystal size distribution (CSD), purity and yield of crystallized product has been examined. Quality and quantity of crystals produced via the controlled cooling crystallizer are greatly influenced by the operating temperature. Higher working temperature produced crystals with higher purity and larger average crystal size. However, the yield is lower. Controlled crystallization process results in a better crystal properties compared to natural cooling crystallization, generally in almost all aspects. Furthermore, the addition of DHSA seed into the solution could reduce the purity of product and at the same time, as it could retard the crystal growth.
Asid 9,10-threo dihydroxystearik (DHSA) dihasilkan daripada proses epoksidaian antara asid oleic dan asid performik, dituruti dengan hidrolisis ke atas hasilan tersebut. DHSA digunakan secara meluas di dalam industri sebagai bahan asas dalam produk kosmetik. Oleh itu, DHSA mentah yang mempunyai kadar ketulenannya yang rendah perlu melalui proses purifikasi bagi memenuhi keperluan kualiti yang ketat bagi setiap penghasilan produk dalam cabang ini. Penghabluran menggunakan bahan larut telah digunakan dan kajian terperinci telah dijalankan untuk menghasilkan produk yang berkualiti tinggi.

Objektif thesis ini adalah untuk menjalankan kajian asas dan terperinci ke atas penghabluran DHSA yang berasaskan kelapa sawit, dengan menggunakan bahan larut. Kajian asas mencangkupi dua jenis bahan larut, etanol dan heksana pada beberapa kepekatan dan persekitaran penghabluran yang berbeza. Keputusan kajian dianalisis menggunakan beberapa kaedah, diantaranya adalah gas kromatografi (GC), penyebaran saiz kristal (CSD) dan mikroskop pengimbas elektron (SEM). Kajian
asas ini memperlihatkan kejayaan menghablurkan DHSA menggunakan etanol sebagai bahan larut. Penghabluran semulajadi pula menghasilkan keputusan yang lebih baik, secara amnya dalam semua aspek. Walau bagaimanapun, penghabluran DHSA menggunakan heksana sebagai bahan larut tidak berjaya membentuk hablur DHSA, sebaliknya menghasilkan DHSA pada peratus ketulenan yang rendah (79%).

Berdasarkan daripada kajian asas, penyelidikan terperinci telah dijalankan dengan mengaplikasi kaedah penghabluran melalui penyejukan terkawal dimana sebuah penghablur telah direka khas bagi memenuhi keperluan tujuan ini. Kajian ini memberi tumpuan kepada beberapa pembolehubah, iaitu suhu (24°C, 26°C, 28°C), masa (1 - 12 jam), proses pembenihan (2.5, 5, 10 gram) dan persekitaran penghabluran (peghabluran semulajadi dan penghabluran terkawal) yang berbeza. Pembolehubah ini dikaji berdasarkan kesannya terhadap CSD, ketulenan dan perolehan produk yang telah terhablur. Suhu memberikan pengaruh yang besar ke atas kualiti dan kuantiti hablur yang dihasilkan. Pada suhu yang tinggi, proses ini menghasilkan hablur yang berketulenan tinggi degan purata saiz partikel yang lebih besar tetapi rendah dari segi perolehan. Secara kasarnya, penghabluran pada suhu terkawal menghasilkan produk yang lebih baik berbanding penghasilan produk melalui penghabluran pada suhu natural. Selain daripada itu, penambahan benih DHSA pada larutan pula menyebabkan penurunan dari segi ketulenan produk. Pada masa yang sama juga, ia boleh membantut pertumbuhan hablur.
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In the Name of Allah The Most Gracious and Most Merciful

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I certify that an Examination Committee has met on 26 July 2006 to conduct the final examination of Sumaiya bt Zainal Abidin @ Murad on her Master of Science thesis entitled “Solvent Crystallization of Palm-Based Dihydroxystearic Acid” in accordance with Universiti Pertanian Malaysia (Higher Degree) Act 1980 and Universiti Pertanian Malaysia (Higher Degree) Regulations 1981. The Committee recommends that the candidate be awarded the relevant degree. Members of the Examination Committee are as follows:

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viii
This thesis submitted to the Senate of Universiti Putra Malaysia and has been accepted as fulfilment of the requirement for the degree of Master of Science. The members of the Supervisory Committee are as follows:

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Date: **14 SEP 2006**
DECLARATION

I hereby declare that the thesis is based on my original work except for quotations and citation which have been duly acknowledged. I also declare that it has not been previously or concurrently submitted for any other degree at UPM or other institutions.

SUMAIYA BT ZAINAL ABIDIN @ MURAD

Date: 25 August 2006
# TABLE OF CONTENTS

<table>
<thead>
<tr>
<th>Section</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>DEDICATION</td>
<td>ii</td>
</tr>
<tr>
<td>ABSTRACT</td>
<td>iii</td>
</tr>
<tr>
<td>ABSTRAK</td>
<td>v</td>
</tr>
<tr>
<td>ACKNOWLEDGEMENTS</td>
<td>vi</td>
</tr>
<tr>
<td>APPROVAL</td>
<td>viii</td>
</tr>
<tr>
<td>DECLARATION</td>
<td>x</td>
</tr>
<tr>
<td>LIST OF TABLES</td>
<td>xiv</td>
</tr>
<tr>
<td>LIST OF FIGURES</td>
<td>xv</td>
</tr>
<tr>
<td>LIST OF ABBREVIATIONS</td>
<td>xix</td>
</tr>
</tbody>
</table>

## CHAPTER

### 1 INTRODUCTION

1.1 Hydroxy Fatty Acid
1.2 Dihydroxystearic Acid (DHSA)
1.3 Crystallization of Palm Oil and Fatty Acids
1.4 Fractionation Process
1.4.1 Dry Fractionation
1.4.2 Detergent Fractionation
1.4.3 Solvent Fractionation
1.5 Problem Statements
1.6 Scope of Work
1.7 Objectives

### 2 LITERATURE REVIEW

2.1 General Review of Fats and Oil: Chemistry & Technology
2.2 Palm and Palm Kernel Oil
2.3 Oleochemical
2.4 Palm and Palm Kernel Oil as the Raw Material for Oleochemical
2.5 Fatty Acids in Palm and Palm Kernel Oil
2.6 Crystallization of Fats and Oils
2.6.1 Polymorphism
2.6.2 Phase Behaviour
2.6.3 Supersaturation
2.6.4 Nucleation
2.6.5 Crystal Growth
2.6.6 Crystal Size and Shape
2.6.7 Seeding Effect on Crystallization Process
2.7 Kinetic of Crystallization
2.7.1 Crystal Size Distribution (CSD)
2.7.2 Laser Diffraction as a Measurement Techniques
2.8 Filtration Method
2.9 Morphology Studies
# METHODOLOGY

<table>
<thead>
<tr>
<th>Section</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.1 Introduction</td>
<td>3.1</td>
</tr>
<tr>
<td>3.2 Raw Materials</td>
<td>3.1</td>
</tr>
<tr>
<td>3.3 Equipment Design</td>
<td>3.2</td>
</tr>
<tr>
<td>3.4 Equipment Operation</td>
<td>3.5</td>
</tr>
<tr>
<td>3.5 Summary of Experimental Techniques for Controlled Crystallization</td>
<td>3.7</td>
</tr>
<tr>
<td>3.5.1 Preliminary Studies on the Crystallization of Palm Based DHSA</td>
<td>3.7</td>
</tr>
<tr>
<td>3.5.2 Detailed Studies on Controlled Cooling Crystallization of Palm Based DHSA</td>
<td>3.9</td>
</tr>
<tr>
<td>3.6 Analytical Method</td>
<td>3.11</td>
</tr>
<tr>
<td>3.6.1 Gas Chromatography (GC)</td>
<td>3.11</td>
</tr>
<tr>
<td>3.6.2 Scanning Electron Microscopy (SEM)</td>
<td>3.12</td>
</tr>
<tr>
<td>3.6.3 Crystallization Size Distribution (CSD)</td>
<td>3.12</td>
</tr>
<tr>
<td>3.6.4 Fourier Transform Infra Red (FT-IR)</td>
<td>3.14</td>
</tr>
<tr>
<td>3.6.5 X-ray Diffraction (XRD)</td>
<td>3.14</td>
</tr>
</tbody>
</table>

# PRELIMINARY STUDIES ON THE SOLVENT CRYSTALLIZATION OF PALM BASED DIHYDROXYSTEARIC ACID (DHSA)

<table>
<thead>
<tr>
<th>Section</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>4.1 Introduction</td>
<td>4.1</td>
</tr>
<tr>
<td>4.2 Effect of Cooling Modes on Solvent Crystallization of Palm Based Dihydroxystearic Acid Using Ethanol/Ethanol-Water Mixtures</td>
<td>4.2</td>
</tr>
<tr>
<td>4.2.1 Crystal Morphology</td>
<td>4.2</td>
</tr>
<tr>
<td>4.2.2 Size Distribution Analysis</td>
<td>4.7</td>
</tr>
<tr>
<td>4.2.3 Yield and Purity Analysis</td>
<td>4.13</td>
</tr>
<tr>
<td>4.2.4 X-ray Diffraction (XRD)</td>
<td>4.17</td>
</tr>
<tr>
<td>4.2.5 Fourier Transform-Infra Red (FT-IR)</td>
<td>4.18</td>
</tr>
<tr>
<td>4.3 Crystallization of Palm Based Dihydroxystearic Acid using Hexane as Solvent</td>
<td>4.21</td>
</tr>
<tr>
<td>4.3.1 Crystal Morphology</td>
<td>4.21</td>
</tr>
<tr>
<td>4.3.2 Mass and Purity Analysis</td>
<td>4.23</td>
</tr>
<tr>
<td>4.4 Summary</td>
<td>4.24</td>
</tr>
</tbody>
</table>

# EFFECT OF CONTROLLED AND NATURAL COOLING CRYSTALLIZATION ON YIELD, PURITY AND CRYSTAL SIZE DISTRIBUTION OF DHSA

<table>
<thead>
<tr>
<th>Section</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>5.1 Introduction</td>
<td>5.1</td>
</tr>
<tr>
<td>5.2 Effect of crystallization temperature on yield, purity and average crystals size using controlled cooling crystallizer</td>
<td>5.2</td>
</tr>
<tr>
<td>5.3 Comparison on yield, purity and crystal size distribution between controlled cooling crystallization and natural cooling crystallization</td>
<td>5.7</td>
</tr>
<tr>
<td>5.4 Summary</td>
<td>5.14</td>
</tr>
</tbody>
</table>
6 EFFECT OF SEEDED CRYSTALLIZATION ON YIELD, PURITY AND CRYSTAL SIZE DISTRIBUTION OF DHSA

6.1 Introduction
6.2 Effect of Seed Loading on the Crystal Size Distribution of DHSA
6.3 Comparison between Seeded and Unseeded Crystallization of DHSA
6.4 Summary

7 CONCLUSION AND RECOMMENDATIONS

7.1 Conclusion
7.2 Recommendation on Future Work

REFERENCES/BIBLIOGRAPHY
APPENDICES
BIODATA OF THE AUTHOR
## LIST OF TABLES

<table>
<thead>
<tr>
<th>Table</th>
<th>Description</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.1</td>
<td>Fatty Acid compositions of selected oils/fats</td>
<td>2.4</td>
</tr>
<tr>
<td>2.2</td>
<td>Typical fatty acids found in fats ad oils (Talbot, 1995)</td>
<td>2.5</td>
</tr>
<tr>
<td>2.3</td>
<td>Fatty acid composition of Malaysian palm and palm kernel oil</td>
<td>2.7</td>
</tr>
<tr>
<td>3.1</td>
<td>Properties of Crude DHSA (<em>Source: MPOB</em>)</td>
<td>3.2</td>
</tr>
<tr>
<td>3.2</td>
<td>Properties of Ethanol and Hexane (<em>Source: Euro Chemo-Pharma and Mallinckrodt Chemicals</em>)</td>
<td>3.2</td>
</tr>
<tr>
<td>3.3</td>
<td>Specification summary on the fabricated crystallizer.</td>
<td>3.3</td>
</tr>
<tr>
<td>4.1</td>
<td>X-ray diffraction result on DHSA crystal.</td>
<td>4.18</td>
</tr>
<tr>
<td>5.1</td>
<td>Preliminary results summary on the selection of crystallization temperature.</td>
<td>5.2</td>
</tr>
</tbody>
</table>
### LIST OF FIGURES

<table>
<thead>
<tr>
<th>Figure</th>
<th>Description</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.1</td>
<td>Formation of dihydroxystearic Acid (DHSA) via epoxidation process.</td>
<td>1.2</td>
</tr>
<tr>
<td>2.1</td>
<td>The type of molecular packing in fats (Timms, 1985; Tablot, 1995).</td>
<td>2.10</td>
</tr>
<tr>
<td>2.2</td>
<td>The difference in packing and spacing of TAG: the polymorphic form of a fat is found from its X-ray short spacing (s) whilst the type of chain packing is determined by its X-ray long spacing (l) (Timms, 1985; Tablot, 1995).</td>
<td>2.11</td>
</tr>
<tr>
<td>2.3</td>
<td>Projection showing arrangement of alkyl chains for ( \alpha ), ( \beta' ), and ( \beta ) for cocoa butter (Tablot, 1995).</td>
<td>2.13</td>
</tr>
<tr>
<td>2.4</td>
<td>The schematic phase diagram of a binary mixture of TAG A and B showing a continuous solid solution (Timms, 1991).</td>
<td>2.15</td>
</tr>
<tr>
<td>2.5</td>
<td>Saturation-supersaturation curve (Timms, 1991).</td>
<td>2.17</td>
</tr>
<tr>
<td>2.6</td>
<td>Schematic diagram of laser diffraction instrument</td>
<td>2.26</td>
</tr>
<tr>
<td>2.7</td>
<td>Modes of formation of spherulites. Spherulites formed (a) on a spherical particle of foreign material, (b) on a polycrystalline aggregate of the same species, and (c) by split growth.</td>
<td>2.29</td>
</tr>
<tr>
<td>2.8</td>
<td>Semi-spherical aggregate of the platy barite crystals known as desert rose.</td>
<td>2.30</td>
</tr>
<tr>
<td>3.1</td>
<td>General layout for the crystallizer; (a) plant view, (b) front view, (c) side view and (d) isometric view.</td>
<td>3.4</td>
</tr>
<tr>
<td>3.2</td>
<td>Four different layout of 3.5 inch colour touch screen that has been developed into the controlled cooling crystallizer.</td>
<td>3.6</td>
</tr>
<tr>
<td>4.1</td>
<td>SEM images (1000 times magnification) on crystal products obtained from the crystallization of DHSA at two different conditions using ethanol as solvent: (a) rapid crystallization and (b) slow crystallization at 1000 times magnification.</td>
<td>4.4</td>
</tr>
<tr>
<td>4.2</td>
<td>SEM images of crystal produced from the rapid crystallization of DHSA using ethanol-water mixtures as solvent at (a) 500 times magnification and (b) 1500 magnification.</td>
<td>4.5</td>
</tr>
<tr>
<td>4.3</td>
<td>SEM images of crystal produced from the slow crystallization of</td>
<td></td>
</tr>
</tbody>
</table>
DHSA using ethanol-water mixtures as solvent at (a) 500 times magnification and (b) 1500 magnification.

4.4 Crystal size distribution of three different DHSA:Ethanol ratios (1:1, 1:1.5 and 1:2) for slow crystallization.

4.5 Crystal size distribution of 3 different DHSA:Ethanol ratios (1:1, 1:1.5 and 1:2) for rapid crystallization.

4.6 Crystal size distribution for two different crystallization conditions for DHSA:ethanol ratio of 1:1.

4.7 Crystal size distribution for two different crystallization conditions for DHSA:ethanol ratio of 1:1.5.

4.8 Crystal size distribution for two different crystallization conditions for DHSA:ethanol ratio of 1:2.

4.9 SEM images of crystal produced from the rapid crystallization of DHSA at two different DHSA:ethanol ratio: (a) 1:1.5 and (b) 1:2 at 1000 times magnification.

4.10 Comparison on the percentage of yield between slow and rapid crystallization using ethanol as solvent.

4.11 Comparison on the percentage of yield between slow and rapid crystallization using ethanol-water mixtures as solvent.

4.12 Comparison on percentage of purity between slow and rapid crystallization using ethanol as solvent.

4.13 Comparison on percentage of purity between slow and rapid crystallization using ethanol water mixtures as solvent.

4.14 Gas chromatography results on (a) crude DHSA and (b) purified DHSA.

4.15 Fourier Transform- Infra Red results on (a) crude DHSA and (b) purified DHSA.

4.16 Image of crystal produced from the crystallization of DHSA using hexane as a solvent at (a) 500 and (b) 2000 times magnification.

4.17 DHSA mass and purity analysis on the purified DHSA using hexane as a solvent.

5.1 Comparison on time-temperature profile for three
crystallization temperatures, namely 24°C, 26°C and 28°C.

5.2 Comparison on percentage of yield for three crystallization temperatures, carried out in controlled cooling crystallization.

5.3 Comparison on average crystal size for three crystallization temperatures.

5.4 GC analysis for three different temperatures under controlled cooling crystallization in 12 hours operation time.

5.5 Comparison on time-temperature profile for two different cooling condition, natural cooling condition via room temperature crystallization and controlled cooling crystallization.

5.6 Comparison of two different cooling modes; controlled and natural crystallization on percentage of product yield in 12 hours batch time.

5.7 Comparison of two different cooling modes; controlled and natural crystallization on percentage of product purity in 12 hours batch time.

5.8 Comparison on crystal size distribution between natural cooling crystallization and controlled cooling crystallization at 5th hour batch time.

5.9 Comparison on crystal size distribution between natural cooling crystallization and controlled cooling crystallization at 6th hour batch time.

5.10 Comparison on crystal size distribution between natural cooling crystallization and controlled cooling crystallization at 7th hour batch time.

5.11 Comparison on crystal size distribution between natural cooling crystallization and controlled cooling crystallization at 8th hour batch time.

5.12 Comparison on crystal size distribution between natural cooling crystallization and controlled cooling crystallization at 10th hour batch time.

5.13 Comparison on crystal size distribution between natural cooling crystallization and controlled cooling crystallization at 12th hour batch time.

6.1 Comparison between three seed loading on the 1st hour of controlled crystallization process.
Comparison between three seed loading on the 3rd hour of controlled crystallization process.

Comparison between three seed loading on the 5th hour of controlled crystallization process.

Comparison between three seed loading on the 7th hour of controlled crystallization process.

Comparison on the average crystal size between three seed loading in controlled cooling crystallization.

Comparison between seeded and unseeded crystallization on the 6th hour of controlled crystallization process.

Comparison between seeded and unseeded crystallization on the 8th hour of controlled crystallization process.

Comparison between seeded and unseeded crystallization on the 10th hour of controlled crystallization process.

Comparison between seeded and unseeded crystallization on the 12th hour of controlled crystallization process.

Comparison on yield and purity between seeded and unseeded crystallization along 12th hours of controlled crystallization process.
LIST OF ABBREVIATIONS

CSD = crystal size distribution
DHSA = dihydroxystearic acid
FT-IR = fourier transform infra red
NBD = neutralized, bleached and deodorized
OHV = OH value
PKO = palm kernel oil
PKOo = palm kernel oil olein
PKOs = palm kernel oil stearin
PO = palm oil
RBD = refined, bleached and deodorized
RI = reflective index
SEM = scanning electron microscopy
TAG = triacylglycerol
XRD = X-ray diffraction
ϕ = general term of frequency (e.g. length, number, surface or volume)
c = concentration (%)
C’ = constant, J m
dav = arithmetic mean of particle diameter
d_i = mean diameter of size band I
D_d = mean diameter of the distribution
d_p = particle diameter
d_s = surface mean particle size
d_v = volume mean particle size
d_vs = volume surface mean particle size
\( E_j = \) light energy falling on any ring \( j \), \( j \)
\( f = \) focal length of lens, m
\( G = \) growth rate (m/s)
\( h = \) thickness of the plate
\( J_0, J_j = \) Bessel functions
\( k = \) wave number of incident light, 1/m
\( L = \) length
\( L_{i,M} = \) measured size of size range \( i \), m
\( L_a = \) initial seed size (mm)
\( L_{sp} = \) final seed size (mm)
\( N = \) number
\( Q_i = \) extinction coefficient of size band \( i \)
\( S = \) surface
\( S_c = \) seed surface area (cm\(^2\))
\( s_{j1}, s_{j2} = \) radii of ring \( j \) in focal plane, m
\( T_{ij} = \) the light energy falling on any ring \( j \) due to a particle of size \( L_i, J \)
\( V = \) volume
\( V_i = \) volume in size band \( i \)
\( W_c = \) theoretical crystallized mass (g)
\( W_i = \) weight percent of particles in size range \( i \) with calibration, %
\( W_s = \) seed mass (g)
\( x_0 = \) smallest particle in the distribution
\( x_{sp} = \) largest particle in the distribution
\( x_g = \) geometric mean size
\( x_m = \) mean size
\begin{align*}
X_{NL} &= \text{length mean diameter by number} \\
X_{NS} &= \text{surface mean diameter by number} \\
X_{NV} &= \text{volume mean diameter by number} \\
X_{SV} &= \text{mean size of surface distribution} \\
X_{VM} &= \text{mean size of weight distribution} \\
\alpha &= \text{volume shape factor (dimensionless)} \\
\beta &= \text{surface shape factor} \\
\lambda &= \text{wavelength of He–Ne laser, m} \\
\rho &= \text{crystal density (g/m}^3) \\
\sigma &= \text{standard deviation of particle distribution} \\
\sigma^2 &= \text{variance of particle distribution} \\
\sigma_g &= \text{geometric standard deviation}
\end{align*}
CHAPTER 1

INTRODUCTION

1.1 Hydroxy Fatty Acid

The industry has shown great interest in hydroxy fatty acid because of their different behavior compared with ordinary fatty acids (Weber et al., 1995). Hydroxyl fatty acids and its derivatives have many applications such as additives in lubricants, in cosmetics and surfactants (Dahlke et al., 1995). Castor oil is the main source of hydroxy fatty acids but because of its unavailability in Malaysia, oleic acid is an alternative for the compound preparation. Palm oil contains around 40% of oleic acid, which can be obtained by splitting the oil/fat. Malaysian Palm Oil Board (MPOB) has successfully synthesized a new fatty acid derivative, which may have a great commercial potential, namely the dihydroxystearic acid (DHSA) (Rolia et al., 1998).

1.2 Dihydroxystearic Acid (DHSA)

Dihydroxystearic acid is a hydroxyl fatty acid. It is produced from the epoxidation of oleic acid with peracetic acid. The resulting epoxide is hydrolyzed in an aqueous solution resulting in 9, 10-dihydroxystearic acid (Rolia et al., 1998). The reaction is presented in Figure 1.1. The presence of hydroxyl and carboxylic group in the structure, provide various reaction sites for the preparation of many useful derivatives.