



This is the accepted version of this paper. The version of record is available at  
<https://doi.org/10.1016/j.jwpe.2021.102346>

1 **Preliminary Study on Low-Density Polystyrene Microplastics**  
2 **Bead Removal from Drinking Water by Coagulation-**  
3 **Flocculation and Sedimentation**

4 **Chaoran Li<sup>1</sup>, Rosa Busquets<sup>1,2</sup>, Rodrigo B. Moruzzi<sup>3</sup>, Luiza C. Campos<sup>1\*</sup>**

5 <sup>1</sup> University College London, Gower St, London WC1E 6BT

6 <sup>2</sup> Kingston University, Penrhyn Road, Kingston Upon Thames, Surrey, KT1 2EE

7 <sup>3</sup> Universidade Estadual Paulista (UNESP), Dept. Geografia e Planejamento Ambiental – Rio Claro (SP),  
8 Brazil

9  
10 \* Corresponding author: *l.campos@ucl.ac.uk*

11 **Key words:** Microplastics, Drinking water, Coagulation-flocculation, Floc breakage

12

13

14

15

16

17

18

19

20

## Abstract

21

22 Microplastics (MPs), sized ~150  $\mu\text{m}$ , have been found in tap water at levels of ~ 5  
23 particles/L, suggesting that water treatment plants are not effectively removing MPs.  
24 Therefore, there is an urgent need to evaluate their fate in drinking water treatment  
25 processes. Coagulation-flocculation and sedimentation are applied in water treatment to  
26 primarily decrease turbidity, and MPs contribute to water turbidity. This study focuses on  
27 the removal of polystyrene (PS) beads of 100  $\mu\text{m}$  with density 1.04-1.06  $\text{g}/\text{cm}^3$ . The low-  
28 density PS beads offer a removal challenge because they have similar density to the media.  
29 The effects of initial water pH and stirring speed on MPs removal by coagulation-  
30 flocculation and sedimentation were studied. The most effective conditions found for  
31 removing the PS beads from water, that led to removal rates up to  $98.9 \pm 0.94\%$ , were 3.4  
32 mg Al/L of coagulant, pH 5, flocculation time of 7 min and sedimentation time of 30 min.  
33 For the first time, floc breakage and regrowth following the addition of Al, has shown to  
34 favour the removal of the PS beads. Based on this research, coagulation-flocculation can  
35 play a very important role in removing MPs during drinking water treatment.

36 **Keywords:** aluminium sulphate, polystyrene; microbead; water treatment; floc breakage

37

38

39

## 40 **1. Introduction**

41 Microplastics (MPs) have attracted great attention globally. At present, the  
42 investigation of microplastic pollution mainly focuses on the marine environment (Michida  
43 et al. 2019; Jones et al. 2019; Li et al. 2020; Kumar et al. 2021). As a relatively new type  
44 of pollutant, extensive attention has been paid to its occurrence, distribution, abundance,  
45 separation and identification methods, adsorption and desorption mechanisms, and  
46 ecotoxicological effects in current research, and MPs have been gradually detected in  
47 freshwater (Zhang et al. 2021; Zhao et al. 2021; Frank et al. 2021; Li et al. 2020;  
48 Christensen et al. 2020). Freshwater is abstracted and treated for producing drinking water.  
49 In this process, coagulation-flocculation-sedimentation is the main step for removing  
50 particulate matter in drinking water treatment plants (DWTP). However, the removal of  
51 MPs in this key step to produce drinking water has received little attention. In the UK,  
52 coagulation-flocculation stages are usually combined with pre-ozonation, sand filtration  
53 and granular activated carbon contactors. Also, sedimentation is a worldwide technique for  
54 water treatment and an important step to prevent the subsequent overload of filters.

55 The percentage of samples from DWTP containing MPs ranges from 24 % to 100 %  
56 and the MPs content from below the limit of detection to 1247 MPs/L across studies  
57 (Danopoulos et al. 2020). When finding MPs in the treated water, for accurate  
58 quantification, it is important to work with large sampling volumes specially when the  
59 concentration of MPs is low (Zihajahomi et al. 2017).

60 The variety of MPs in sources of drinking water is diverse. Among them, PS is one of  
61 the most abundant types of MPs in freshwater globally (13 %) (Li et al. 2020). It is used in  
62 rigid packaging and construction material (British Plastics Federation 2021a), among other  
63 uses. In the UK, the Water Industry Research (UKWIR) found that the most common MPs  
64 in DWTP are PS and Acrylonitrile Butadiene Styrene (ABS) (Ball et al. 2019). Specifically,  
65 in raw water where the content was ~ 113 MPs/L, after treatment, the water still contained  
66 2-27 MPs/L (Ball et al. 2019). This shows that the current drinking water treatment  
67 processes need to improve.

68 In the production of drinking water from a river with initial concentration of  $6614 \pm$   
69  $1132$  MPs/L, the removal efficiency of conventional treatment processes (including  
70 coagulation/flocculation, sedimentation and sand filtration) was about 58.9-70.5 % (Wang  
71 et al. 2020). There, MPs > 10 $\mu$ m were removed with 50.7-60.6 % efficiencies which was  
72 greater than for the rest of MPs (Wang et al. 2020). Polyacrylamide (PAM) was the  
73 coagulant used and it led to large amount of PAM in the sludge of the sedimentation tanks  
74 (Wang et al. 2020). Currently, there are no legal restrictions on the MPs content in drinking  
75 water, and there is no treatment technology that directly targets the removal of MPs.

76 Skaf et al. (2020) found high removal efficiency (99 %) of kaolin flocs using  
77 aluminium at pH 6.5 by coagulation-flocculation and sedimentation. Because zeta potential  
78 of polyethylene beads was similar to that of kaolin in water adjusted to pH 4-7, these  
79 authors assumed that MP beads could be removed under their study conditions. However,

80 because there are a large variety of MP types, sizes and densities (around 1 g/cm<sup>3</sup>), and  
81 Kaolin density is about 2.65 g/cm<sup>3</sup>, their results cannot be generalized.

82 When a variety of coagulants (iron, aluminium and polyamine-based) was used to  
83 study coagulation-flocculation as a tertiary wastewater treatment process to treat secondary  
84 sewage containing microplastics (~ 10 µm) (Rajala et al. 2020), the optimal microplastic  
85 removal (i.e. 93 %) was achieved with polyaluminum chloride as coagulant. Both Shahi et  
86 al. (2020) and Lapointe et al. (2020) indicated that different plastic types, sizes, densities,  
87 solution environments and coagulants have an impact on the flocculation effect, and  
88 highlighted that further research is needed.

89 Among the studies on treatment of MPs through coagulation-flocculation, some  
90 focused on MPs of different polymers such as polyethylene, polypropylene, polyvinyl  
91 chloride, or a mixed solution of MPs (Wang et al. 2020; Skaf et al. 2020). However, the  
92 study focusing on the treatment of low-density PS MPs as a pollutant by coagulation-  
93 flocculation and sedimentation has not been reported and has special interest. PS is rigid  
94 and brittle (British Plastics Federation 2021b) which are properties that favour its  
95 degradation. PS' photo resistance outdoors is competitive; however, it can change  
96 depending on its additives (e.g. metal complexes, benzophenone or Ethylene Propylene  
97 Diene Monomer (EPDM)) (Zweifel et al. 2012). Photooxidation is a predominant  
98 weathering process that will favour the formation of plastic debris (Wypych 2018). These  
99 fragments can diffuse to freshwater used for the production of drinking water.

100 The density of PS (1.04-1.06 g/cm<sup>3</sup>) (Cincinelli et al. 2020) is close to that of natural  
101 water and, hence, they may result in PS particles in suspension or floating in water.  
102 Therefore, they pose a greater potential risk than plastics that settle during drinking water  
103 treatment. In addition, it is recognised that flocs can be broken after flocculation in water  
104 treatment plants due to potential high shear zones, leading to low removal efficiency of the  
105 flocs. However, it is known that restoring the previous low shear conditions, flocs can grow  
106 back to the previous size (Yukselen and Gregory 2004). Considering the low density of the  
107 PS particles, we were interested on what the effect of breakage and regrowth of flocs on  
108 their removal as well. The aim of this paper was to preliminary investigate the potential  
109 impacts of coagulation-flocculation and sedimentation on low-density 100 µm PS  
110 microbeads, which were spiked in natural and tap waters.

## 111 **2. Materials and Methods**

### 112 **2.1 Materials**

113 All chemical reagents used were analytical grade and obtained from Sigma-Aldrich  
114 (UK), including Al<sub>2</sub>(SO<sub>4</sub>)<sub>3</sub>·18H<sub>2</sub>O, Na<sub>2</sub>CO<sub>3</sub>, NaCl, 37 % HCl, NaOH and kaolin. PS beads  
115 (100 µm, 1.04-1.06 g/cm<sup>3</sup>) were purchased from Dongguan Xingwang Plastics Co., Ltd.  
116 Water used in this research was tap water (pH 7.7±0.1; turbidity: 0.2±0.1 NTU; absorbance  
117 at 254 nm (UV-254) was 0.177±0.001 for the breakage and regrowth process and Regent's  
118 Park pond water (pH 8.4±0.1; turbidity: 0.8±0.3 NTU; UV-254, 0.64±0.59) for other tests.  
119 All MPs stock solutions were prepared at 5 g/L and were stored in the dark at 4 °C.

## 120 2.2 Coagulation-flocculation and sedimentation tests

121 A PB-900 programmable Jar tester (Phips & Bird, USA) was used with a total of six  
122 beakers (1 L) with one flat-bladed mixer with diameter ( $d$ ) = 0.0504 m. PS beads (100  $\mu\text{m}$ )  
123 stock solutions (Dongguan Xingwang Plastics Co., Ltd., China) were added to Regent's  
124 Park pond water at 10 mg/L. For imaging and MPs counting purposes only, MPs were dyed  
125 with red acrylic paint prior to the coagulation-flocculation experiment; the optimization of  
126 the treatment steps was carried out with undyed beads.

127 The coagulant used was  $\text{Al}_2(\text{SO}_4)_3 \cdot 18\text{H}_2\text{O}$  at 3.4 mg Al/ L based on previous work (Yu  
128 et al. 2010). During coagulation, the solution pH was adjusted with 0.1 M  $\text{NaHCO}_3$ , and  
129 the pH of the untreated water (before adding the coagulant) was adjusted to 1, 3, 5, 7, 12  
130 and 13 by adding 0.1 M HCl or 0.1M NaOH (Fisher Scientific).

131 To investigate the effect of flocculation mixing speed and sedimentation time,  
132 coagulation speed was maintained at 300 rpm ( $G = 345 \text{ s}^{-1}$ ) for 1 min, and then the mixing  
133 intensity was decrease to seven individual test speeds (50, 100, 150, 200, 250 rpm;  $G = 23$ ,  
134 66, 122, 188, 263  $\text{s}^{-1}$ ) for 7 min of flocculation (Zhou et al. 2021). The mixing intensities  
135 were converted into velocity gradient using Equation (1) (Rushton et al. 1950) and  
136 Equation (2) (Camp 1954):

$$137 \quad P = N_p \rho N^3 d^5 \quad (1)$$

$$138 \quad G = \sqrt{\frac{P}{\mu V}} \quad (2)$$



139       Where P is the power requirement (W), N is the rotational speed of the impeller (rpm),  
140  $N_p$  is the power number (dimensionless), d is the impeller diameter (m), V is the tank  
141 volume ( $m^3$ ), and  $\rho$  and  $\mu$  are the density and absolute viscosity of the water (kg/m.s) at  
142 temperature 'T'. The following parameters were used:  $N_p = 7$  (Cornwell and Bishop 1983);  
143  $V = 8 \times 10^{-4} m^3$ ; water temperature 25 °C;  $\rho = 1 \times 10^3 kg/m^3$ ;  $\mu = 0.0091 kg/m.s$ ;  $d = 0.0504$   
144 m. Finally, the sedimentation step spanned for 30 min (Ma et al. 2019a). All experiments  
145 were carried out in triplicate. The effect of the duration of the different flocculation speed  
146 was investigated from 100 s to 800 s (Ma et al. 2019a) with increments of 100 s. In all tests,  
147 coagulation speed was set at 300 rpm ( $G = 345 s^{-1}$ ) for 1 min. Sedimentation time was  
148 screened and the optimum time, based on maximum number of MPs separated from  
149 solution and counted, was selected.

### 150 **2.3 Floc breakage and re-growth experiment**

151       In a dynamic test, the PDA 3000, Photometric Dispersion Analyzer (Rank Brothers  
152 Ltd., Cambridge) (Figure S1 in Supplementary Information) was sampled every two  
153 seconds. Kaolin (50 mg/L) and PS MPs (10 mg/L) were prepared in 800 mL of tap water  
154 (central London). Coagulant (3.4 mg Al/L) was added to the raw water as specified in  
155 Section 2.2. The pH of the suspension was adjusted to 5 with 0.1M HCl and stirred at 300  
156 rpm ( $G = 345 s^{-1}$ ) for 1 min. Then, the stirring speed was reduced to 50 rpm ( $G = 23 s^{-1}$ )  
157 for 10 min. Next, it was increased to 300 rpm ( $G = 345 s^{-1}$ ) for 1 min to break the flocs and  
158 then back to 50 rpm ( $G = 23 s^{-1}$ ) for 10 min for flocs re-growth. In the case of the addition

159 of coagulant for a second time, the additional dosage of alum (0.8 mg/L) was added into  
160 the stirred suspension during the floc breakage phase (Yu et al. 2010). All experiments were  
161 carried out in triplicate.

## 162 **2.4 Quantification of MPs**

163 For the quantification of MPs, an optical microscope (model Euromex Oxion Material  
164 Science, Netherlands) and Countess<sup>TM</sup> cell counting chamber slides (C10228, Thermo  
165 Fisher Scientific, UK) were used for the visual inspection of MPs with microscopy. A glass  
166 graduated pipette (5 mL) was used to draw the diluent (0.85 % NaCl aqueous solution) into  
167 a test tube. An aliquot (1 mL) of water sample with suspended MPs was taken (using  
168 polypropylene micropipette tips) and it was added to a glass test tube. The suspension was  
169 shaken to resuspend the MPs adhered inside the test tube. Then, the test tube was manually  
170 shaken several times. An aliquot (1 mL) of the tube was placed in between the flat counting  
171 chamber and the cover glass, allowing the suspension to flow naturally into the counting  
172 chamber for up to 2 min. The concentration of MPs in the suspension was determined by  
173 visually counting the MPs with the optical microscope and the volume of sample was taken  
174 into account. The MPs percentage removal was obtained from the difference between the  
175 concentration of MPs before and after the treatment and was normalised by the starting  
176 concentration of MPs.

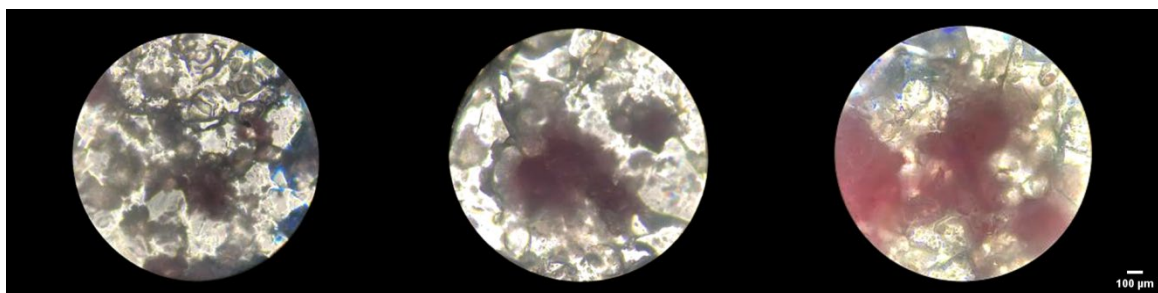
177

### 178 **3. Results and Discussion**

179 In this work, PS beads of 100  $\mu\text{m}$  were selected because this size belongs to a relatively  
180 abundant size fraction (9.7 %) in the final clarifier effluent (Wolff et al. 2021). This size  
181 range has shown to be toxic in fish (Ding et al. 2020) and PS particles (0.2  $\mu\text{m}$ ), although  
182 smaller than the ones studied here, were observed to cross the membrane in red blood cells  
183 with microscopy (Rothen-Rutishauser et al. 2006).

184 This study used spiked MPs at 10 mg/L which is greater contamination than in the  
185 freshwater. The study concentration stems from the need to carry out accurate mass  
186 measurements and compare initial and final concentrations after the effect of coagulation,  
187 flocculation and sedimentation, while using an analytical balance for the preparation of  
188 solutions with MPs and working with 1 L jars. Given that, unlike molecules and ions,  
189 microplastics only become suspended in water (and not dissolved in water), preparing a  
190 concentrated solution for further dilution would entail uncertainty on the concentration of  
191 MPs in the working solutions. Therefore, to maintain low uncertainty in the MP levels, the  
192 authors opted by spiking MPs at levels greater than those in freshwater. The disadvantage  
193 of this is that there may be agglomeration of PS MPs in solution, which will be minimised  
194 by the stirring in the jars. The agglomeration and location of the beads during the  
195 clarification process, including in the floc are illustrated in Figure S2. The MPs in Figure  
196 S2 were dyed to illustrate their distribution in the study treatment. Figure 1 shows flocs  
197 sampled directly from the sludge after sedimentation without changing properties of the

198 flocs.



199

200 Fig. 1 Flocs including PS microplastics (dyed in pink) that have undergone a  
201 coagulation-flocculation and sedimentation treatment observed with the microscope (400X)  
202 (Water used: Regent's Park pond water (pH  $8.4 \pm 0.1$ ; turbidity:  $0.8 \pm 0.3$  NTU; absorbance  
203 at 254 nm, UV-254,  $0.64 \pm 0.59$ ), Coagulation-flocculation condition: 3.4 mg Al/L from  
204  $\text{Al}_2(\text{SO}_4)_3 \cdot 18\text{H}_2\text{O}$ , PS MP 10 mg/L, initial pH 5. The coagulation time was 60 s with 300  
205 rpm ( $G = 345 \text{ s}^{-1}$ ), flocculation time was 400 s with 50 rpm ( $G = 23 \text{ s}^{-1}$ ), and sedimentation  
206 time was 30 min).

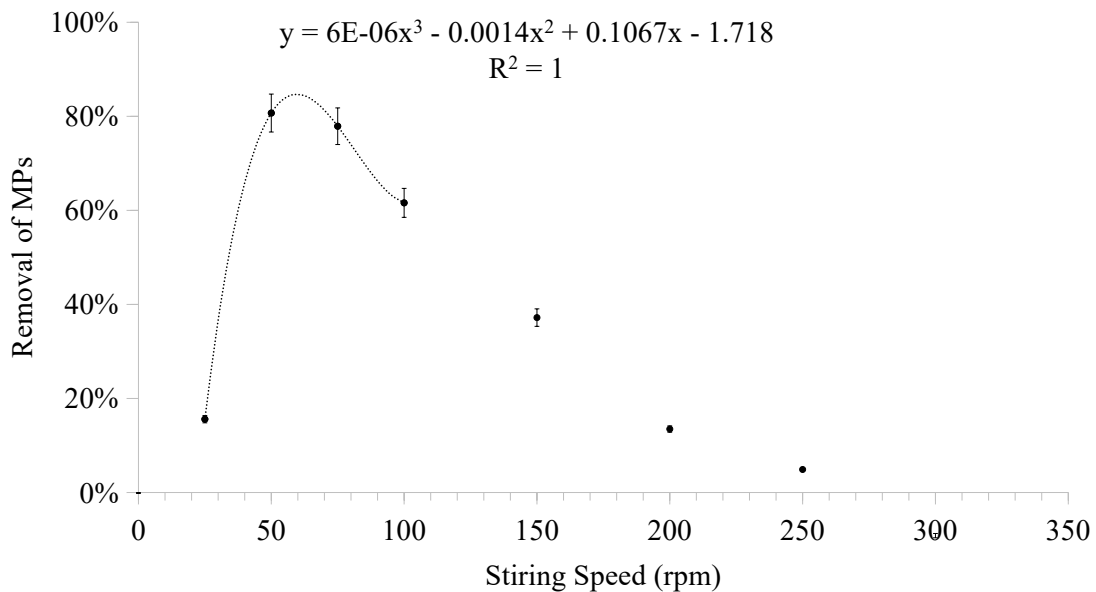
207

### 208 3.1 Effect of flocculation stirring intensity on MPs' removal

209 Stirring speed has a crucial influence on flocculation. Faster the stirring speeds will  
210 cause greater breakage of the flocs and may lead to a reduction of the effect of the treatment.  
211 Previous studies selected stirring speed of 100 rpm ( $G = 66 \text{ s}^{-1}$ ) when using Al as coagulant  
212 (Zheng et al. 2011; Ma et al. 2019b). The range of stirring speeds investigated in this  
213 research were  $\leq 250$  rpm ( $G = 263 \text{ s}^{-1}$ ) (see reaction condition in Section 2.2) and while this

214 favours the dispersion of the PS beads and the reproducibility of the system, it can affect  
215 the size of the flocs. Figure 2 shows the efficiency of the removal of MPs with the mixing  
216 conditions. The MPs removal initially increased to up to 95 % and then decreased rapidly  
217 from stirring intensity above 67 rpm ( $G = 36 \text{ s}^{-1}$ ). This may be explained by the fact that  
218 increasing mixing intensity, decreased the size of the flocs, making the removal less  
219 effective (Moruzzi et al. 2019). Therefore, in practice, for PS MPs removal, controlling the  
220 stirring speed at 50 rpm ( $G = 23 \text{ s}^{-1}$ ) in the flocculation process led to working conditions  
221 close to the optimum ones with reproducible stirring. Figure 2 includes a regression  
222 polynomial adjusted to the critical range of stirring speeds. This facilitates calculating the  
223 removal of MPs within that range. Figures 3-5 also include regression curves adjusted to  
224 the experimental conditions around the optimal removal of MPs.

225



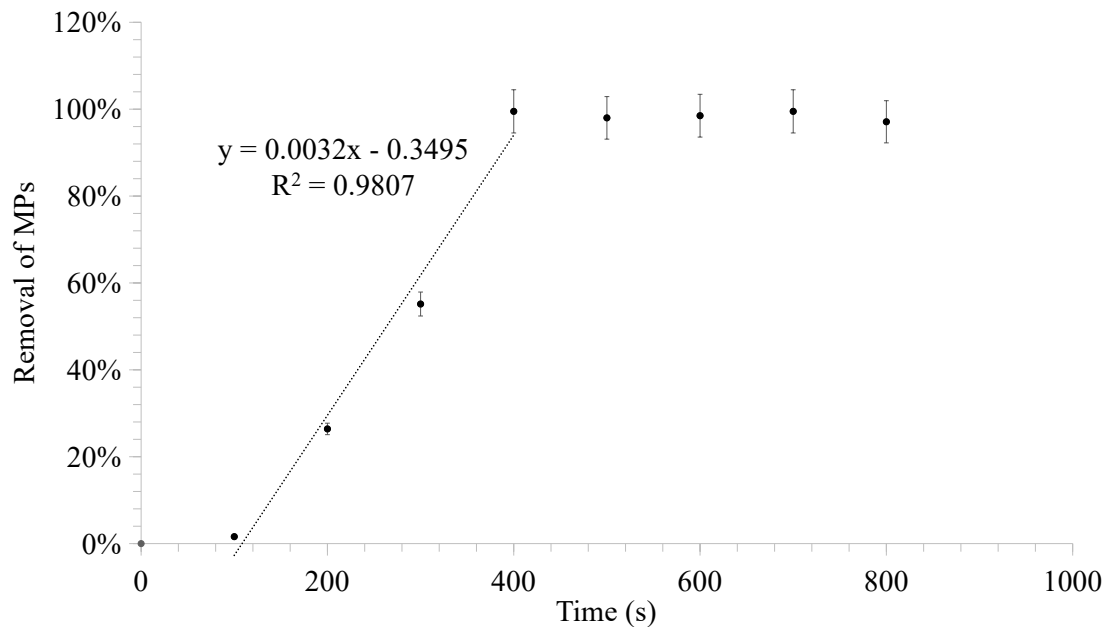
226

227 Fig. 2 Effect of flocculation stirring speed on the removal of 100  $\mu\text{m}$  PS spiked in Regents  
228 Park pond water. The conditions used were: 3.4 mg Al/L from  $\text{Al}_2(\text{SO}_4)_3 \cdot 18\text{H}_2\text{O}$ , PS MPs  
229 10mg/L, initial pH 5. The coagulation time was 60 s, flocculation time was 400 s, and  
230 sedimentation time was 30 min.

### 231 **3.2 Effect of flocculation time on MPs' removal**

232 The length of the flocculation time often determines the removal of suspended  
233 particles (Wu et al. 2012). Studies using Al salts as coagulant usually require about 15 min  
234 of flocculation time (Ahmad et al. 2006; Zhu et al. 2011; Wu et al. 2012). Shorter  
235 flocculation times than the optimum often lead to insufficient removal of particulates, while  
236 prolonged flocculation stages are unnecessary. From Figure 3, it can be observed that for  
237 stirring speed of 50 rpm ( $G = 23 \text{ s}^{-1}$ ) when increasing the flocculation time to 400 s, or even  
238 longer, the removal of the flocs by sedimentation increased till  $98.52 \pm 1.04 \%$  for the case  
239 of 100  $\mu\text{m}$  PS beads. This behaviour can be explained by the flocculation kinetics as both  
240 stirrer speed and time dictates floc size and structure, and a dynamic equilibrium is  
241 expected (Oliveira et al. 2015; Moruzzi et al. 2013; Moruzzi et al. 2017), leading to the  
242 almost complete removal of MPs.

243



244

245 Fig. 3 Effect of flocculation time on 100 µm PS beads' removal from spiked Regents Park  
 246 pond water. The conditions used were: 3.4 mg Al/L from Al<sub>2</sub>(SO<sub>4</sub>)<sub>3</sub>·18H<sub>2</sub>O, PS 10 mg/L in  
 247 water, initial pH 5, flocculation speed 50 rpm ( $G = 23 \text{ s}^{-1}$ ), coagulation time 60 s,  
 248 sedimentation time 30 min.

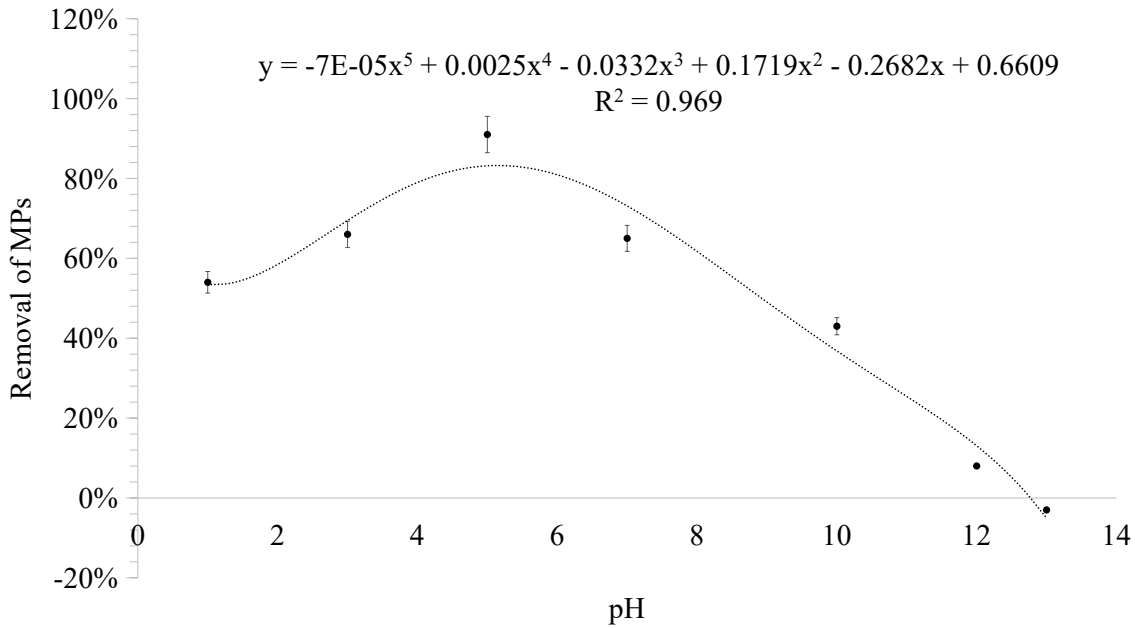
### 249 3.3 Effect of initial water pH on the removal of 100 µm PS beads

250 Ionic strength has a crucial role in clarification (Yukselen et al. 2004) and the water  
 251 pH generally has a great effect on the floc characteristics (Liu et al. 2013; Lee et al. 2012;  
 252 Zhang et al. 2017; Zhao et al. 2014). Hence, to further investigate removal mechanisms of  
 253 PS beads (as purchased and without the acrylic painting), the corresponding removal  
 254 efficiencies were investigated at initial pH levels (before adding the coagulant) of 1, 3, 5,  
 255 7, 10, 12, 13, with the coagulation-flocculation conditions shown in Section 2.2. Among  
 256 these pHs, the most relevant pH range of drinking and wastewater treatment (before adding

257 the coagulant) is pH 5-7. After adding the coagulant, the pH of the suspensions was 3.27,  
258 3.91, 4.88, 6.15, 8.41, 11.03, 11.75, respectively.

259 At acidic (pH 1 – 5), the MPs removal was ~ 54 % to 91 % (Figure 4) for flocculation  
260 speed 50 rpm ( $G = 23 \text{ s}^{-1}$ ), coagulation time 60 s, flocculation time 400 s and sedimentation  
261 time 30 min. By adjusting the pH to > 6.8, the  $\text{Al}_2(\text{SO}_4)_3$  flocculant hardly worked (the  
262 suspension remained turbid) and the MPs removal was low (~ 70 %). From Figure 4,  
263 adjusting pH to ~ 5 has favoured the removal of hydrophobic MPs because under these  
264 conditions aluminium sulphate has a large surface potential (Liu et al. 2013). Under these  
265 conditions, the removal of MPs achieved was 91 %. This may be explained by the fact the  
266 pH and the coagulant dosage determine which hydrolysis species is formed during  
267 coagulation. For example, in the case of aluminium coagulants, it is recognized that the  
268 optimal removal of particles from water is achieved under optimum pH conditions close to  
269 the point of minimum aluminium solubility i.e.  $5.8 > \text{pH} > 6.5$  where the sweep coagulation  
270 mechanisms occur (Gregory and Duan 2001).





271

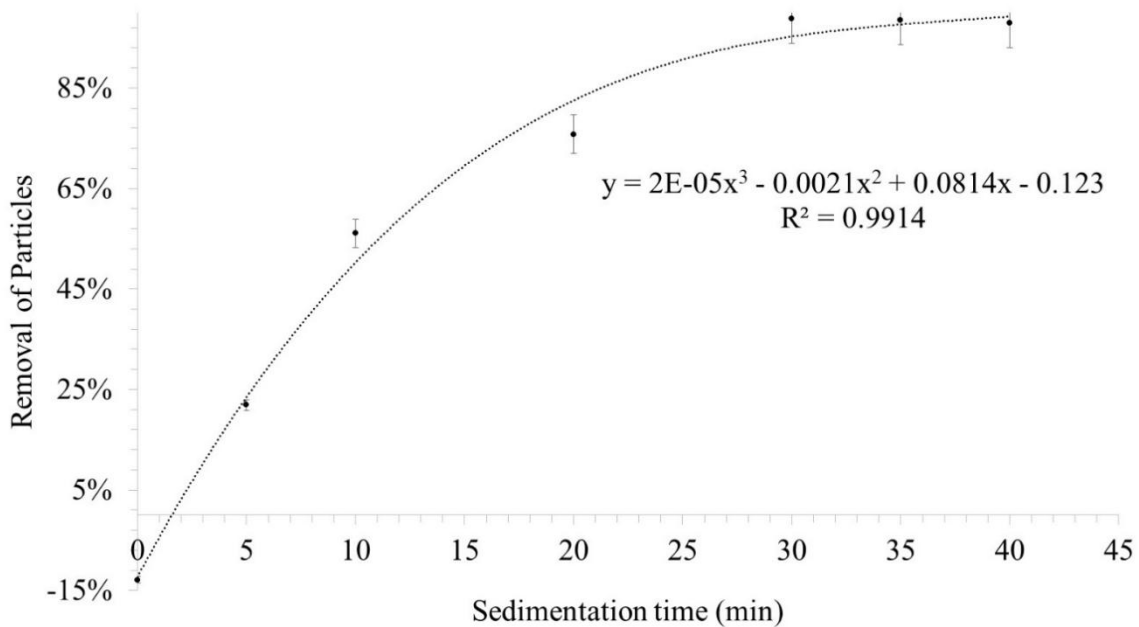
272 Fig. 4 Effect of coagulation pH on 100 µm PS beads' removal in spiked Regents Park pond  
 273 water. The conditions used were: 3.4 mg/L as Al from Al<sub>2</sub>(SO<sub>4</sub>)<sub>3</sub>·18H<sub>2</sub>O, PS MPs 10 mg/L,  
 274 flocculation speed 50 rpm ( $G = 23 \text{ s}^{-1}$ ), coagulation time 60 s, flocculation time 400 s and  
 275 sedimentation time 30 min.

276 **3.4 Effect of sedimentation time on removal of PS MPs**

277 After flocculation, sufficient sedimentation time will allow the suspended flocs to  
 278 completely settle. This will minimise errors in the measurement of MPs because if there  
 279 were smaller flocs floating in water, these could have been left in suspension and not  
 280 sampled for MP counting with microscopy. Past studies trying to clarify kaolin (with  
 281 density 2.6 g/cm<sup>3</sup> and particle size: 0.4 – 0.75 µm) in drinking water treatment found that  
 282 Al<sub>2</sub>(SO<sub>4</sub>)<sub>3</sub> coagulation with sedimentation time of 30 min was effective to remove the flocs  
 283 (Domopoulou et al. 2015), which is similar to the results found here for MPs with density

284 lower than kaolin.

285 In the specific conditions of this study (removal of 100  $\mu\text{m}$  PS beads (3.4 mg Al/L, PS  
286 MPs 10 mg/L, pH 5, stirring speed 50 rpm ( $G = 23 \text{ s}^{-1}$ ), coagulation time 60 s, flocculation  
287 time 400 s) sedimentation time was gradually increased until 40 min. The percentage of  
288 MPs removal reached 98 % at 30 min under these conditions (see Figure 5). After that,  
289 increasing sedimentation time did not lead to improvements in the removal of the study  
290 beads.



291

292 Fig. 5 Effect of sedimentation time on removal of 100  $\mu\text{m}$  PS beads. The conditions used  
293 were:  $\text{Al}_2(\text{SO}_4)_3 \cdot 18\text{H}_2\text{O}$  3.4 mg/L as Al, PS MPs 10 mg/L, pH 5, flocculation speed 50 rpm  
294 ( $G = 23 \text{ s}^{-1}$ ), coagulation time 60 s, flocculation time 400 s.

295 **3.5 Effect of floc-breakage and regrowth on MPs' removal**

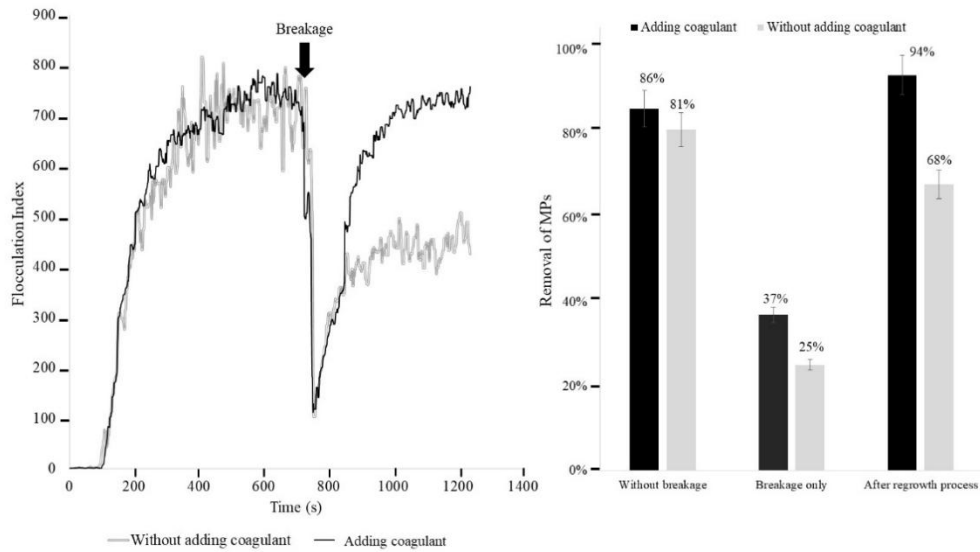
296 In this study, when flocs broke after increasing the stirring speed, additional dosage of  
297 coagulant (0.8 mg Al/L) led to the re-growth of flocs. These second flocs were larger than  
298 those before breakage (Figure 6). It is likely that, under the experiment conditions,  
299 additional MPs (which are hydrophobic and with non-formal negative charge) coated the  
300 surface of the broken flocs (positively charged) and as a result stronger and more  
301 interactions might have formed between the fragmented flocs. This interpretation agrees  
302 with a study that proposed that adsorption sites inside flocs can become exposed by the  
303 breakage and there is also a decrease of the zeta potential on the surface of the flocs (Yu et  
304 al. 2010).

305 The phenomenon of floc-breakage and regrowth with addition of coagulant improved  
306 the capacity for removing kaolin (Yu et al., 2010). In addition, floc removal after  
307 breakage/regrowth is dependent on the dosage of the additional coagulant. However, MPs  
308 beads have very different physical and chemical properties than kaolin clay in terms of  
309 density, surface area and surface chemistry. Therefore, the removal effect of reformed flocs  
310 and direct flocculation on PS MPs in the presence of kaolin needs to be investigated. To  
311 study floc breakage in detail, the average transmitted light intensity (Direct Current Value)  
312 and fluctuating root mean square (rms) components of the transmitted light intensity were  
313 monitored. This was done with the PDA instrument. The ratio (rms/DC), called as the  
314 Flocculation Index (FI) provides a measure of particle aggregation (Yu et al. 2010). The FI  
315 value is related to the size and concentration of the suspended particles and it significantly

316 increases as aggregation occurs and decreases when aggregates break (Figure 6). From  
317 Figure 6, the FI value when adding coagulant increased even more than the original FI  
318 value after regrowth, therefore, this indicates that more particles were included in the flocs.

319       The removal of the PS 100  $\mu\text{m}$  beads after floc breakage and regrowth reached 94 %  
320 at 1000 s, and this is about 16 % larger than traditional flocculation process (81 %) (Figure  
321 6). Flocculation contact time throughout the floc breakage-regrowth process (i.e. 20 min)  
322 is therefore important in relation to the collisions between flocs including the PS beads but  
323 it also suggests that in case of floc breakage in a water treatment plant, flocs containing  
324 MPs may potentially be re-grown before greater removal of MPs by sedimentation. This  
325 potential advantageous step should be further investigated, particularly considering the  
326 different densities, types and sizes of MPs, water qualities and coagulant dosages as these  
327 may affect the results. These will be investigated in future experiments supported with zeta  
328 potential measurements.

329



330

331

Fig. 6 Effect of floc-breakage on FI with and without additional coagulant

332

333

334

335

336

337

338

339

340

The current conditions for alum flocculation in drinking water treatment plants are 40 rpm flocculation for 10 min, sedimentation for 20 min, and pH ~ 6 before coagulation (Ma et al. 2019a; Combatt et al. 2020; Cardoso Valverde et al. 2018). According to the results of this study, if the stirring rate is increased to the equivalent gradient of velocity ( $G = 23 \text{ s}^{-1}$ ), the settling velocity is modified to the equivalent time of 30 min at Jartest, and the pH before coagulation is adjusted to ~ 5, the effect of flocculation on low-density PS microplastics will be their increased removal to 99 %. Adjusting the flocculation process however will impact other suspended solids and pollutants and needs further study.

341

342

A limitation of the present study is that it used commercially available pristine PS beads and research is starting to show that irregularly shape beads may have markedly

343 different toxicity and may interact with flocs slightly differently than commercial bead.  
344 Hence it is recommended to harvest MPs in the environment or water treatment when  
345 possible (Yokota and Marissa 2020). However, we opted for using commercially available  
346 MPs in order to have sufficient availability of similar type of beads for the experiments  
347 planned in this work.

#### 348 **4. Conclusions**

349 It is urgent to understand how to remove MPs in drinking and wastewater treatment  
350 given that these are an opportunity to reduce MPs' spread and protect the environment and  
351 humans. This study investigates the removal of low-density MPs during the flocculation  
352 process, which plays an important role in decreasing the turbidity of water and hence may  
353 be the key to remove MPs particles. This is a preliminary study that has screened the effect  
354 of the duration and stirring speeds in coagulation-flocculation and sedimentation when  
355 using a common coagulant for 100  $\mu\text{m}$  low-density PS beads as a model. These MPs have  
356 been selected due to their toxicity and composition and size commonly found in effluents  
357 from clarifiers. The study on a single type of MPs has allowed to achieve greater detail in  
358 the removal conditions. The optimized coagulation-flocculation conditions found were 3.4  
359 mg Al/L, pH 5, flocculation time 7 min, precipitation time 30 min. Under these conditions,  
360 and when natural water was used, percentage removals were  $98.9 \pm 0.94$  %.

361 The breakage and regrowth process of flocs have shown to enhance the removal of  
362 100  $\mu\text{m}$  low-density PS beads by flocculation, when additional dosage is applied. Although

363 this study used PS (1.04-1.06 g/cm<sup>3</sup>) as model, these findings can potentially be applicable  
364 for other hydrophobic MPs and MPs of similar density (e.g. PP (0.9 g/cm<sup>3</sup>); PS (1.06 g/cm<sup>3</sup>),  
365 Polyethylene (PE, 0.92 g/cm<sup>3</sup>) and nylon (1.14 g/cm<sup>3</sup>)). Further research on different sizes  
366 of the MPs is needed as well.

367 Given that, the re-flocculation process has not been maturely applied in the water  
368 treatment industry as a MPs target technology. This paper points to considerations for the  
369 improvement of drinking water flocculation treatment process in the future. Future work  
370 should address how coagulation-flocculation-sedimentation conditions change over wider  
371 variety of MPs; and how these optimal conditions for MPs will be affected in the presence  
372 of organic pollutants and other suspended particles. It is necessary to investigate wider  
373 types of raw water and give further insights of removal mechanisms by monitoring the  
374 change of zeta potential of flocs under different conditions. Finally, this work confirms that  
375 coagulation-flocculation and sedimentation are important steps for the removal of MPs.

376

## 377 **5. Acknowledgement**

378 We sincerely thank Prof John Gregory, Emeritus Professor of Water Chemistry in  
379 Determent of Civil, Environmental and Geomatic Engineering in University College  
380 London for his initial constructive comments on various parts of this article and his  
381 suggestions on floc breakage experiment.

382

383 **Declaration of Competing Interest**

384 The authors report no conflict of interest.

385

386 **CRedit authorship contribution statement**

387 **Chaoran Li:** Methodology, Investigation, Visualization, Writing - Original Draft,

388 Resources; **Rosa Busquets:** Conceptualization, Supervision, Writing - Review & Editing;

389 **Rodrigo B. Moruzzi:** Writing - Review & Editing; **Luiza C. Campos:** Conceptualization,

390 Supervision, Writing - Review & Editing

391

392 **References**

393 Ahmad, A. L., S. Sumathi, and B. H. Hameed (2006). Coagulation of residue oil and

394 suspended solid in palm oil mill effluent by chitosan, alum and PAC. Chemical

395 Engineering Journal 118.1-2: 99-105. <https://doi.org/10.1016/j.cej.2006.02.001>

396 Ball, H (2019). Sink to River-River to Tap: A Review of Potential Risks from Nanoparticles

397 and Microplastics: Period Covered 2018/2019. UK Water Industry Research Limited.

398 British Plastics Federation (2021). Polystyrene (General Purpose) GPPS".

399 [www.bpf.co.uk/Plastipedia/Polymers/GPPS.aspx](http://www.bpf.co.uk/Plastipedia/Polymers/GPPS.aspx).



400 British Plastics Federation (2021). Polystyrene Station Platforms Slash Construction Time  
401 And Minimise Customer Inconvenience For Network Rail,  
402 [www.bpf.co.uk/article/polystyrene-station-platforms-slash-construction-time-and-](http://www.bpf.co.uk/article/polystyrene-station-platforms-slash-construction-time-and-minimi-801.aspx)  
403 [minimi-801.aspx](http://www.bpf.co.uk/article/polystyrene-station-platforms-slash-construction-time-and-minimi-801.aspx).

404 Cardoso Valverde, Karina, Priscila Ferri Coldebella, Marcela Fernandes Silva, Letícia  
405 Nishi, Milene Carvalho Bongiovani, Rosângela Bergamasco. (2018). Moringa  
406 oleifera Lam. and Its Potential Association with Aluminium Sulphate in the Process  
407 of Coagulation/Flocculation and Sedimentation of Surface Water. International  
408 Journal of Chemical Engineering. <https://doi.org/10.1155/2018/4342938>

409 Christensen, Nicholas D., Catherine E. Wisinger, Leslie A. Maynard, Natasha Chauhan,  
410 John T. Schubert, Jonathan A. Czuba, Justin R. Barone. (2020). Transport and  
411 characterization of microplastics in inland waterways. Journal of Water Process  
412 Engineering 38 : 101640. <https://doi.org/10.1016/j.jwpe.2020.101640>

413 Cincinelli, Alessandra, Costanza Scopetani, David Chelazzi, Tania Martellini, Maria  
414 Pogojeva, Jaroslav Slobodnik. (2020). Microplastics in the Black Sea sediments.  
415 Science of The Total Environment 760: 143898.  
416 <https://doi.org/10.1016/j.scitotenv.2020.143898>

417 Combatt, M. P. M., W.C.S. Amorim, E.M. da S. Brito, A.F. Cupertino, R.C.S. Mendonça,  
418 H.A. Pereira. (2020). Design of parallel plate electrocoagulation reactors supplied by

419 photovoltaic system applied to water treatment. *Computers and Electronics in*  
420 *Agriculture* 177: 105676. <https://doi.org/10.1016/j.compag.2020.105676>

421 Cornwell DA., Bishop MM (1983). Determining velocity gradients in laboratory and full-  
422 scale systems. *Journal American Water Works Association*, 75(9): pp. 470-475.

423 Danopoulos, Evangelos, Maureen Twiddy, and Jeanette M. Rotchell (2020). Microplastic  
424 contamination of drinking water: A systematic review. *PloS one* 15.7: e0236838.  
425 <https://doi.org/10.1371/journal.pone.0236838>

426 Ding, Jiannan, Yejing Huang, Shujiao Liu, Shanshan Zhang, Hua Zou, Zhenyu Wang,  
427 Wenbin Zhu, Jinju Geng. (2020). Toxicological effects of nano-and micro-polystyrene  
428 plastics on red tilapia: Are larger plastic particles more harmless?. *Journal of*  
429 *hazardous materials* 396: 122693. <https://doi.org/10.1016/j.jhazmat.2020.122693>

430 Domopoulou, A. E., Gudulas, K. H., Papastergiadis, E. S., & Karayannis, V. G. (2015).  
431 Coagulation/flocculation/sedimentation applied to marble processing wastewater  
432 treatment. *Modern Applied Science*, 9(6), 137. <https://doi.org/10.5539/mas.v9n6p137>

433 Frank, Yulia A., et al. (2021). Preliminary Screening for Microplastic Concentrations in the  
434 Surface Water of the Ob and Tom Rivers in Siberia, Russia. *Sustainability* 13.1 : 80.  
435 <https://doi.org/10.3390/su13010080>

436 Jones, Ellie Sophie (2019). Plastic Debris in Deep-Sea Canyon, Estuarine, and Shoreline  
437 Sediments. Diss. University of Oregon.

438 Kumar, Rakesh, Prabhakar Sharma, and Somnath Bandyopadhyay. (2021). "Evidence of  
439 microplastics in wetlands: Extraction and quantification in Freshwater and coastal  
440 ecosystems." *Journal of Water Process Engineering* 40 : 101966.  
441 <https://doi.org/10.1016/j.jwpe.2021.101966>

442 Lapointe, Mathieu, et al. (2020). Understanding and Improving Microplastic Removal  
443 during Water Treatment: Impact of Coagulation and Flocculation. *Environmental  
444 Science & Technology* 54.14: 8719-8727. <https://doi.org/10.1021/acs.est.0c00712>

445 Lee, K. E., Morad, N., Teng, T. T., & Poh, B. T. (2012). Development, characterization and  
446 the application of hybrid materials in coagulation/flocculation of wastewater: A  
447 review. *Chemical Engineering Journal*, 203, 370-386.  
448 <https://doi.org/10.1016/j.cej.2012.06.109>

449 Li, Chaoran, Rosa Busquets, and Luiza C. Campos (2020). Assessment of microplastics in  
450 freshwater systems: A review. *Science of the Total Environment* 707: 135578.  
451 <https://doi.org/10.1016/j.scitotenv.2019.135578>

452 Liu, Jiexia, Yi Zhu, Yujun Tao, Yuanming Zhang, Aifen Li, Tao Li, Ming Sang, Chengwu  
453 Zhang. (2013). Freshwater microalgae harvested via flocculation induced by pH  
454 decrease. *Biotechnology for biofuels* 6.1: 1-11. [https://doi.org/10.1186/1754-6834-6-  
455 98](https://doi.org/10.1186/1754-6834-6-98)

456 Ma, Baiwen, Wenjing Xue, Chengzhi Hu, Huijuan Liu, Jiuhui Qu, Liangliang Li. (2019a).

457 Characteristics of microplastic removal via coagulation and ultrafiltration during  
458 drinking water treatment. *Chemical Engineering Journal* 359: 159-167.  
459 <https://doi.org/10.1016/j.cej.2018.11.155>

460 Ma, Jie, Runnan Wang, Xiyue Wang, Hao Zhang, Bo Zhu, Lili Lian, Dawei Lou. (2019b).  
461 Drinking water treatment by stepwise flocculation using polysilicate aluminium  
462 magnesium and cationic polyacrylamide. *Journal of Environmental Chemical*  
463 *Engineering* 7.3: 103049. <https://doi.org/10.1016/j.jece.2019.103049>

464 Michida, Yutaka, Chavanich, Suchana, Chiba, Sanae, Cordova, Muhammad Reza, Cozsar  
465 Cabanas, Andrés, Glagani, Francois, Hagmann, Pascal, Hinata, Hirofumi, Isobe,  
466 Atsuhiko, Kershaw, Peter, Kozlovskii, Nikolai, Li, Daoji, Lusher, Amy L., Marti,  
467 Elisa, Mason, Sherri A., Mu, Jingli, Saito, Hiroaki, Shim, Won Joon, Syakti, Agung  
468 Dhamar, Takada, Hideshige, Thompson, Richard, Tokai, Tadashi, Uchida, Keiichi,  
469 Vasilenko, Katerina (2019). Guidelines for Harmonizing Ocean Surface Microplastic  
470 Monitoring Methods. Version 1.1[J].

471 Moruzzi R.B., Silva P.G., Sharifi S., Campos L.C, Gregory J. (2019). Strength assessment  
472 of Al-Humic and Al-Kaolin aggregates by intrusive and non-intrusive methods.  
473 *Separation and Purification Technology*, Volume 217, pp. 265-273,  
474 <https://doi.org/10.1016/j.seppur.2019.02.033>.

475 Moruzzi R.B., Oliveira A.L., Conceição F.T., Gregory J., Campos L.C. (2017). Fractal

476 dimension of large aggregates under different flocculation conditions. Science of The  
477 Total Environment, Volume 609, pp.807-814,  
478 <https://doi.org/10.1016/j.scitotenv.2017.07.194>.

479 Moruzzi RB, de Oliveira SC. (2013). Mathematical modeling and analysis of the  
480 flocculation process in chambers in series. Bioprocess and biosystems engineering,  
481 36(3):357-63.

482 Oliveira A.L. de, Moreno P., Silva P.A.G. da, Julio M.D., Moruzzi R.B. (2015). Effects  
483 of the fractal structure and size distribution of flocs on the removal of particulate  
484 matter. Desalination and Water Treatment., 57(36):1-12, doi:  
485 <https://doi.org/10.1080/19443994.2015.1081833>

486 Gregory J, Duan J (2001). Hydrolysing metal salts as coagulants. Pure Appl. Chem., 73(12):  
487 2017–2026.

488 Rajala, Katriina, Outi Grönfors, Mehrdad Hesampour, Anna Mikola. (2020). Removal of  
489 microplastics from secondary wastewater treatment plant effluent by  
490 coagulation/flocculation with iron, aluminum and polyamine-based chemicals. Water  
491 research 183 : 116045. <https://doi.org/10.1016/j.watres.2020.116045>

492 Rothen-Rutishauser, Barbara M., Rothen-Rutishauser, Samuel Schürch, Beat Haenni,  
493 Nadine Kapp, Peter Gehr. (2006). Interaction of fine particles and nanoparticles with  
494 red blood cells visualized with advanced microscopic techniques." Environmental

495 science & technology 40.14 : 4353-4359. <https://doi.org/10.1021/es0522635>

496 Shahi, Nirmal Kumar, Minsoo Maeng, Donghyun Kim, Seok Dockko. (2020). Removal  
497 behavior of microplastics using alum coagulant and its enhancement using polyamine-  
498 coated sand. *Process Safety and Environmental Protection* 141 : 9-17.  
499 <https://doi.org/10.1016/j.psep.2020.05.020>

500 Skaf, Dorothy W., Vito L. Punzi, Javaz T. Rolle, Kyle A. Kleinberg. (2020). Removal of  
501 micron-sized microplastic particles from simulated drinking water via alum  
502 coagulation. *Chemical Engineering Journal* 386 : 123807.  
503 <https://doi.org/10.1016/j.cej.2019.123807>

504 Wang, Zhifeng, Tao Lin, and Wei Chen (2020). Occurrence and removal of microplastics  
505 in an advanced drinking water treatment plant (ADWTP). *Science of the Total*  
506 *Environment* 700 : 134520. <https://doi.org/10.1016/j.scitotenv.2019.134520>

507 Wolff, Sebastian, Felix Weber, Jutta Kerpen, Miriam Winklhofer, Markus Engelhart, Luisa  
508 Barkmann. (2021). Elimination of Microplastics by Downstream Sand Filters in  
509 Wastewater Treatment. *Water* 13.1 : 33. <https://doi.org/10.3390/w13010033>

510 Wu, C., Wang, Y., Gao, B., Zhao, Y., & Yue, Q. (2012). Coagulation performance and floc  
511 characteristics of  $Al_2(SO_4)_3$  using sodium alginate as coagulant aid for synthetic  
512 dying wastewater treatment. *Separation and purification technology*, 95, 180-187.  
513 <https://doi.org/10.1016/j.seppur.2012.05.009>

514 Wypych, George. Handbook of material weathering. Elsevier, 2018.  
515 <https://doi.org/10.1016/b978-1-927885-31-4.50012-1>

516 Yokota, Kiyoko, and Marissa Mehrlrose (2020). Lake Phytoplankton Assemblage Altered  
517 by Irregularly Shaped PLA Body Wash Microplastics but Not by PS Calibration Beads.  
518 Water 12.9 : 2650. <https://doi.org/10.3390/w12092650>

519 Yu, Wen-Zheng, John Gregory, and Luiza Campos (2010). Breakage and regrowth of Al-  
520 humic flocs-effect of additional coagulant dosage. Environmental science &  
521 technology 44.16 : 6371-6376. <https://doi.org/10.1021/es1007627>

522 Yukselen, M. A., & Gregory, J. (2004). The reversibility of floc breakage. International  
523 Journal of Mineral Processing, 73(2-4), 251-259. [https://doi.org/10.1016/s0301-](https://doi.org/10.1016/s0301-7516(03)00077-2)  
524 [7516\(03\)00077-2](https://doi.org/10.1016/s0301-7516(03)00077-2)

525 Zhang, L., Xie, Y., Zhong, S., Liu, J., Qin, Y., & Gao, P. (2021). Microplastics in freshwater  
526 and wild fishes from Lijiang River in Guangxi, Southwest China. Science of The Total  
527 Environment, 755, 142428. <https://doi.org/10.1016/j.scitotenv.2020.142428>

528 Zhang, R., Yuan, S., Shi, W., Ma, C., Zhang, Z., Bao, X., & Luo, Y. (2017). The impact of  
529 anionic polyacrylamide (APAM) on ultrafiltration efficiency in flocculation-  
530 ultrafiltration process. Water Science and Technology, 75(8), 1982-1989.  
531 <https://doi.org/10.2166/wst.2017.086>

532 Zhao, Y. X., Gao, B. Y., Zhang, G. Z., Phuntsho, S., & Shon, H. K. (2014). Coagulation by

533 titanium tetrachloride for fulvic acid removal: Factors influencing coagulation  
534 efficiency and floc characteristics. *Desalination*, 335(1), 70-77.  
535 <https://doi.org/10.1016/j.desal.2013.12.016>

536 Zhao, Yufeng, Jingyi Liu, Xu Liu, Qingqing Meng, Shuai Wang, Tao Jiang, Li Bai, Yang  
537 Yang. (2021). Analysis and Evaluation of Pollutant Residues in Freshwater Fish at  
538 Jiamusi Section of Songhua River. *Journal of Physics: Conference Series*. Vol. 1732.  
539 No. 1. IOP Publishing. <https://doi.org/10.1088/1742-6596/1732/1/012092>

540 Zheng, H., Zhu, G., Jiang, S., Tshukudu, T., Xiang, X., Zhang, P., & He, Q. (2011).  
541 Investigations of coagulation–flocculation process by performance optimization,  
542 model prediction and fractal structure of flocs. *Desalination*, 269(1-3), 148-156.  
543 <https://doi.org/10.1016/j.desal.2010.10.054>

544 Zhou, G., Wang, Q., Li, J., Li, Q., Xu, H., Ye, Q., ... & Zhang, J. (2021). Removal of  
545 polystyrene and polyethylene microplastics using PAC and FeCl<sub>3</sub> coagulation:  
546 Performance and mechanism. *Science of the Total Environment*, 752, 141837.

547 Zhu, Guocheng, Huaili Zheng, Zhi Zhang, Tiroyaone Tshukudu, Peng Zhang, Xinyi Xiang.  
548 (2011). Characterization and coagulation–flocculation behavior of polymeric  
549 aluminum ferric sulfate (PAFS). *Chemical Engineering Journal* 178 : 50-59.  
550 <https://doi.org/10.1016/j.cej.2011.10.008>

551 Zweifel, Hans (2012). *Stabilization of polymeric materials*. Springer Science & Business



552 Media. <https://doi.org/10.1007/978-3-642-80305-5>

553 Ziajahromi, Shima, et al. (2017). Wastewater treatment plants as a pathway for  
554 microplastics: development of a new approach to sample wastewater-based  
555 microplastics. *Water research* 112 : 93-99.  
556 <https://doi.org/10.1016/j.watres.2017.01.042>

557

558

## **Supporting Information**

559

560

561 **Preliminary Study on Low-Density Polystyrene Microplastics**

562 **Bead Removal from Drinking Water by Coagulation-**

563 **Flocculation and Sedimentation**

564 **Chaoran Li<sup>1</sup>, Rosa Busquets<sup>1,2</sup>, Rodrigo B. Moruzzi<sup>3</sup>, Luiza C. Campos<sup>1\*</sup>**

565 <sup>1</sup> University College London, Gower St, London WC1E 6BT

566 <sup>2</sup> Kingston University, Penrhyn Road, Kingston Upon Thames, Surrey, KT1 2EE

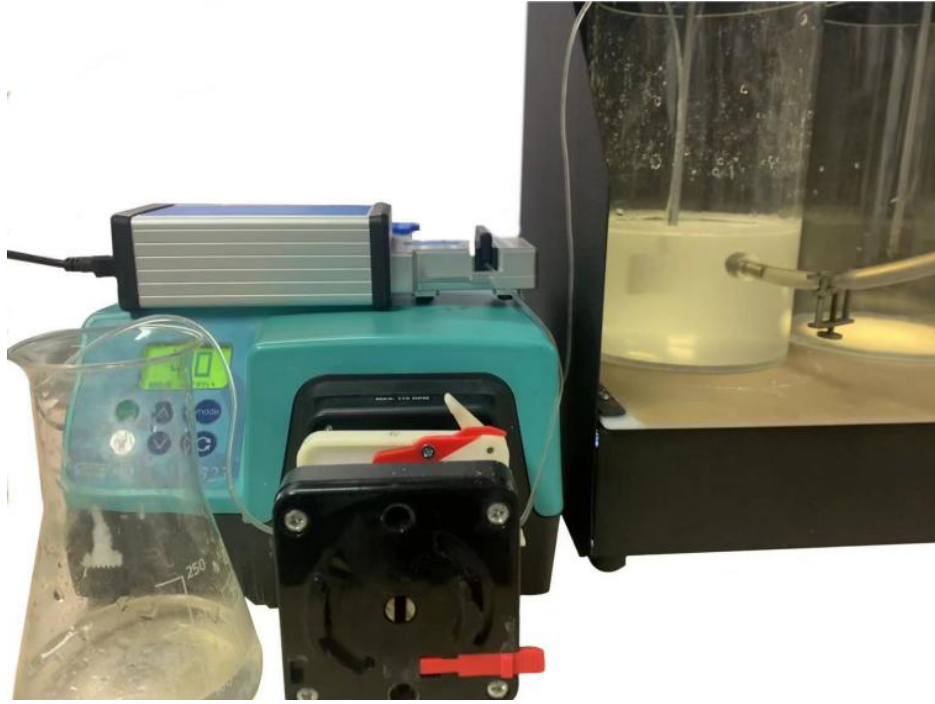
567 <sup>3</sup> Universidade Estadual Paulista (UNESP), Dept. Geografia e Planejamento Ambiental – Rio Claro (SP),

568 Brazil

569

570

571



572

573

574 Fig. S1 - PDA device and jar tester flocculator assembly used in this study.

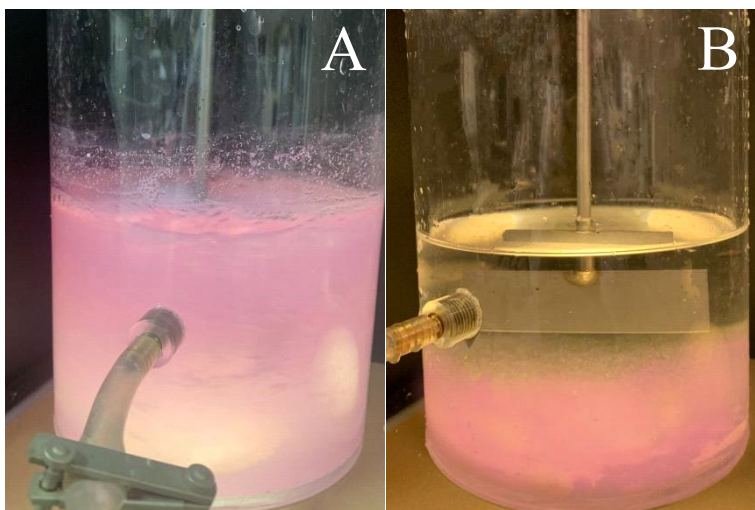
575

576

577

578

579



580

581

582 Fig. S2 – Water solution during the coagulation-flocculation process (A) and after  
583 sedimentation (B). The water used was from the pond in Regent’s Park (pH  $8.4 \pm 0.1$ ;  
584 turbidity:  $0.8 \pm 0.3$  NTU; absorbance at 254 nm, UV-254,  $0.64 \pm 0.59$ ), Coagulation-  
585 Flocculation condition: 3.4 mg Al/L, PS MP 10 mg/L, initial pH 5. The coagulation time  
586 was 60 s with 400 rpm, flocculation time was 400 s with 50 rpm, and sedimentation time  
587 was 30 min.

588

589

590

591

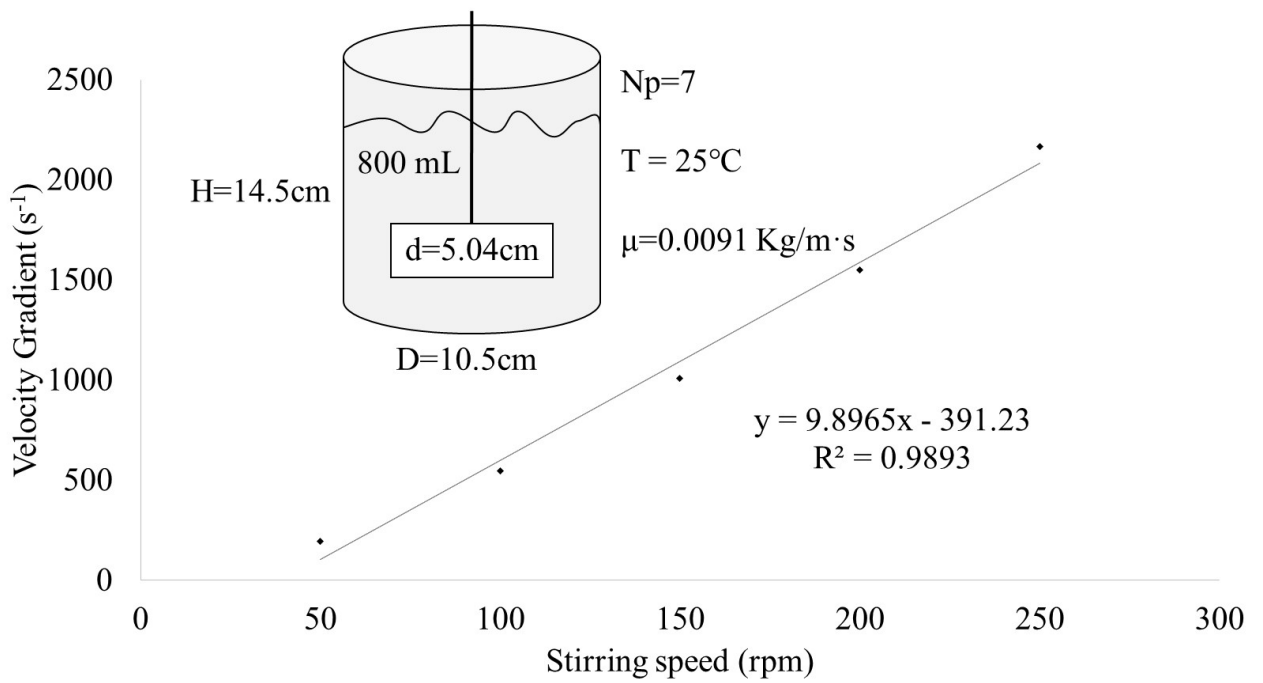
592

593

594

595

596



597

598

599 Fig. S3 - Conversion between stirring speed (in rpm) to velocity gradient (in  $s^{-1}$ ) with the  
600 configuration and conditions used. Note: H = jar depth; D = jar diameter; d = blade diameter;  
601  $N_p$  = power number; T = water temperature;  $\mu$  = water viscosity.

602

603

604

605

606

607

608

609

610

611

612

613