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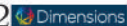
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Effect of Catalysts H₂SO₄ 8% and Baggase Ratio on Yield of Furfural with Hydrolysis Method Using Microwaves

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ABSTRAK

Ampas tebu mengandung pentosan sebesar 12,7%. Kandungan pentosan yang cukup tinggi dalam ampas tebu dapat digunakan sebagai bahan baku pembuatan furfural melalui proses hidrolisis. Penelitian ini bertujuan untuk menentukan pengaruh rasio ampas tebu dan katalis H₂SO₄ terhadap yield furfural yang didapat dari proses hidrolisis menggunakan *microwave*. Ampas tebu ditambahkan dengan H₂SO₄ 8% sebagai katalisator dengan variasi rasio ampas tebu dan katalisator H₂SO₄ yaitu 1:20, 1:30, 1:40, 1:50, dan 1:60 pada temperatur *microwave* 100°C dan waktu reaksi 75 menit. Sampel dianalisa secara kualitatif dengan uji warna menggunakan anilin-asetat sebagai pereaksi. Setelah anilin-asetat ditambahkan ke sampel, warna sampel berubah dari kuning cerah menjadi merah sebagai tanda sampel mengandung furfural. Furfural yang dihasilkan dianalisa untuk mengetahui *yield* dari furfural dengan menggunakan *Gas Chromatography* (GC). Hasil penelitian menunjukkan *yield* furfural terbaik pada rasio ampas tebu dan katalisator H₂SO₄ 1:30 yakni sebesar 0,28%.

Kata Kunci : ampas tebu, asam sulfat, furfural, hidrolisis, microwave.

ABSTRACT

The sugar cane bagasse contains 12.7% pentosan. The relatively high pentosan content in the sugar cane bagasse can be used as the raw material of furfural production by utilizing the hydrolysis process. This research aims to determine the effects of ratio variations of bagasse and H₂SO₄ catalyst on the yield of furfural obtained from the hydrolysis process using a microwave. The sugar cane bagasse was added with H₂SO₄ 8% as catalyst with a variations ratio of sugar cane bagasse and H₂SO₄ catalyst that is 1:20, 1:30, 1:40, 1:50, and 1:60 in a microwave with the reaction temperature of 100°C and reaction time of 75 minutes. The sample was analyzed qualitatively with a color test by using aniline-acetic as the reactant. After the aniline-acetic was added to the sample, the color of the sample changed from bright yellow to red as a sign that the sample contains furfural. The obtained furfural was analyzed to find out the yield of furfural by using Gas Chromatography (GC). The research product showed that the best yield of furfural on the ratio of bagasse and H₂SO₄ catalyst of 1:30 is 0.28%.

Keywords: sugar cane bagasse, sulfuric acid, furfural, hydrolysis, microwave.

1. INTRODUCTION

Sugarcane bagasse is often found in Sungai Pinang Dalam Village, Samarinda, through surveys from sugar cane traders or sellers. According to the ice cane traders, the dry bagasse produced per day is 2.51 kg. In a week, sugar cane sellers can yield 17.6 kg of

bagasse. So, there is at least 528 kg of bagasse that can be produced in a month by eight ice cane sellers in the village. This amount is quite significant considering that in just a week, more than 60 kg of bagasse has been produced per person. This is also accompanied by the general public's lack of

a hydrolysis time of 30 minutes to 150 minutes. In this study, the best yield of furfurals were obtained at a temperature of 100°C and 120 minutes, which were 5.07% and 5.67%, respectively. The hydrolysis process carried out by using a catalyst concentration of 12% H₂SO₄ [2]. While in Atima's research [10], the hydrolysis process was carried out at different ratios of bagasse and H₂SO₄ catalyst, namely, 1:20, 1:30, 1:40, 1:50, and 1:60. In this study, the best yield of furfural was 10.67%, at a ratio of 1:40 with a hydrolysis temperature of 100°C, a hydrolysis time of 120 minutes, and a concentration of H₂SO₄ 8%.

In the research by Andaka [2] and Atima [10], the hydrolysis of sugarcane bagasse into furfural is still conventional. In Andaka's study [2], to get the best yield of furfural, a relatively high reaction temperature and concentration of H₂SO₄ catalyst is needed, while in Atima's research [10], to get the best yield of furfural, a relatively high ratio of bagasse and H₂SO₄ catalyst volume is required. The hydrolysis of bagasse into furfural was carried out using microwaves to make the process more efficient. Research by Rahim and Nadhir [8] has succeeded in increasing the yield of hydrolysis of oil palm empty fruit bunches into furfural with the help of a microwave compared to the conventional process carried out by Parasta [11]. Therefore, it is necessary to research the effect of the ratio of bagasse to the H₂SO₄ catalyst. In the process of bagasse hydrolysis into furfural assisted by microwaves, the utilization of higher ratio can cause a decrease in the obtained furfural yield because the number of polar H₂O compounds will cause higher interactions of dipole-dipole between polar molecules when irradiated with microwaves. As a result of the molecule's rotation, which will produce higher energy, the furfural formed can decompose into other compounds, such as furoic acid [12].

This research was intended to increase the use-value of bagasse and obtain maximum yield of furfural. In particular, to study the

effect of the ratio of bagasse and H₂SO₄ catalyst on the yield of obtained furfural by using microwave assistance.

2. RESEARCH METHODS

2.1. Materials and Instruments

The raw material used in this research is sugar cane bagasse. The chemicals used were H₂SO₄ 8% solution, aquadest, aniline-acetate solution, standard furfural solution, and chloroform.

The microwave used is the Electrolux brand, EMM2007X model with a maximum power specification of 800 W, voltage 220 V, magnetron frequency 2450 MHz (2.45 GHz), dimensions of length 45 cm, width 30 cm, and height 25 cm. The microwave device has a temperature sensor (thermocouple type K), a temperature controller, and a temperature indicator (TIC/temperature indicator controller). Sample was analyzed by GC. The schematic equipment can be seen in Figure 1.

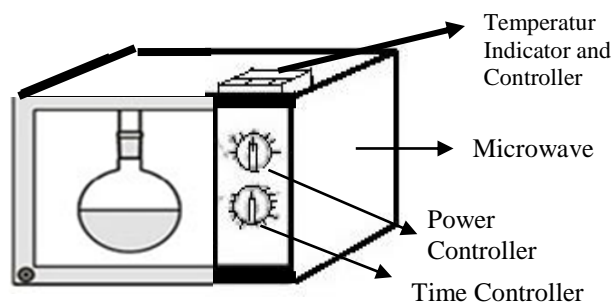


Figure 1. Microwave equipment for the hydrolysis process.

2.2. Research Methods

The research was conducted through the following stages :

a. Preparation

Wet bagasse is dried in the sun, then mashed using a blender until it becomes powder. The bagasse powder was then sieved through a -20+70 mesh sieve. After that, the bagasse powder was dried again using an oven at a temperature of 105°C until a constant weight was reached.

b. Hydrolysis Process

5 g of dry bagasse was put into a 1000 mL two neck flask and mixed with 100 mL H₂SO₄ 8% v/v (E Merck). The two-neck flask containing a mixture of bagasse and sulfuric acid was put in a microwave to be heated. The hydrolysis process in the microwave was carried out at a temperature of 100°C, heated by microwave with a power of 400 W for 75 minutes. The procedure was repeated for various ratios of bagasse and H₂SO₄ catalyst 1:30, 1:40, 1:50, and 1:60.

c. Furfural Separation

After the hydrolysis process, the material was cooled at room temperature (30°C), then the liquid (hydrolyzate) was separated from the bagasse solids using Whatman filter paper.

d. Analysis

In the research, two stages of analysis were carried out, namely :

1. Qualitative Analysis

1 mL of obtained hydrolyzate then poured as much as into a test tube. Next, three drops of the aniline-acetate solution were added into the test tube and the color change was observed. If the hydrolyzate solution changes color from bright

yellow to red, then the solution is detected to contain furfural.

2. Quantitative Analysis

The hydrolyzate obtained was then extracted before being analyzed using GC (Gas Chromatography) by adding chloroform (E Merck). The amount of chloroform volume used was (1:5) mL compared to the volume of hydrolyzate. The mixed solution of hydrolyzate and chloroform is then stirred vigorously so that the furfural can dissolve in the chloroform. Incubate for the solution to form into two layers. When two layers of liquid have formed, the next step is to take the lower layer using the help of a separating funnel. The formation of these two layers indicates that the top layer is a residual hydrolyzate containing H₂O and H₂SO₄, while the bottom layer is chloroform containing furfural.

3. RESULTS AND DISCUSSION

The Results obtained from this research shown in Table 1 for qualitative analysis. While, the results of quantitative analysis on the effect of the ratio of bagasse and H₂SO₄ catalyst on yield of furfural are presented in Table 2.

Table 1. Results of qualitative analysis (color test).

No	Sugarcane Bagasse Mass (g)	H ₂ SO ₄ Catalyst Volume (ml)	Before Addition of Aniline Acetate	After Addition of Aniline Acetate
1	5	100	Bright Yellow	Red
2		150	Clear Yellow	Red
3		200	Bright Yellow	Red
4		250	Bright Yellow	Red
5		300	Bright Yellow	Red

Table 2. Results of quantitative analysis.

No	Sugarcane Bagasse Ratio and H ₂ SO ₄ Catalyst	Hydrolyzate Volume (ml)	Chlorofom Volume (ml)	Extract Volume (ml)	Furfural Concentration (% v/v)
1	1 : 20	30	6	35	0.0776
2	1 : 30	78	16	28	0.0725
3	1 : 40	136	27	21	0.0223
4	1 : 50	167	33	12	0.0179
5	1 : 60	215	43	3	0.0125

Table 3. The effect of ratio sugarcane bagasse and h₂so₄ catalyst to yield of furfural.

No	Ratio of Sugarcane Bagasse and H ₂ SO ₄ Catalyst (g/ml)	Yield of Furfural (% w/w)
1	1 : 20	0.07
2	1 : 30	0.28
3	1 : 40	0.15
4	1 : 50	0.16
5	1 : 60	0.14

In Table 1, it can be seen that the average hydrolyzate solution is bright yellow. Then, after the addition of aniline-acetate to the sample, the color changed to red. This change indicates that the sample contains furfural. Following the statement by Mitarlis et al. [13], the addition of aniline-acetate to furfural causes the hydrolyzate solution, which was originally clear yellow to become red. It indicates that the yield tested is furfural. This color change was caused by condensation between furfural and aniline to form dianyl hydroxyglutaric dialdehyde compounds.

Table 3 shows a profile of the relationship between the ratio of bagasse and H₂SO₄ catalyst to yield of furfural obtained from this research. Based on Table 3, the results of quantitative analysis shows that the yield of furfural has decreased from ratio of 1:30 and 1:40. However, the highest yield of furfural from the study was obtained from the variation of 5 g bagasse mass compared to 150 ml H₂SO₄ catalyst volume or a ratio of (1:30) which was 0.28%.

In this study, the catalyst for reaction using H₂SO₄ 8%, it means contain 92% water. The H₂O molecule is a polar molecule with two poles, each with a positive and negative

charge. If one pole or both poles are in a similar electric field originating from the microwave, it can causes a repulsive force so that the water molecules will rotate. This rotational movement causes the increasing of friction between the H₂O and pentosan molecules so that heat energy will arise. This heat acts as a heating agent for the material and the hydrolysis reaction can take place more quickly to produce furfural. It follows the statement from Adhiksana et al. [14] and Rahim et al. [15], microwaves can shorten reaction time and maximize yield gains because radiant heating penetrates directly into the material. For obtained furfural from rice husk using microwave, the processing time need 90 minutes. It is faster than using conventional methods, about 30-60 minutes depends on extraction conditions.

The increase in the catalyst ratio from a ratio of 1:20 to 1:30 indicates that the number of H₂O compounds as polar compounds is sufficient to carry out the hydrolysis reaction. There is an increase in the yield of furfural in this ratio range. At a ratio greater than 1:30, there is a decrease in the yield of furfural produced so that the optimum condition is achieved at a catalyst ratio of

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