

# Study on Dispersion of TiO<sub>2</sub> Nanopowder in Aqueous Solution via Near Supercritical Fluids

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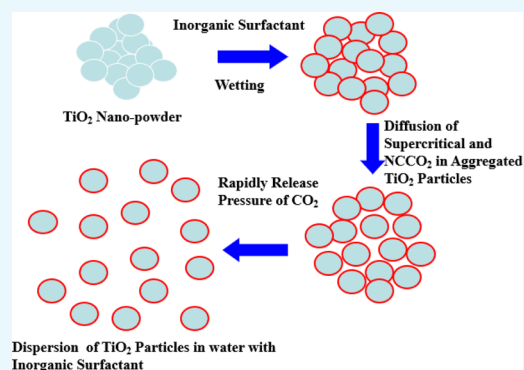
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**ABSTRACT:** In this study, we investigated the effects of near supercritical carbon dioxide (SCCO<sub>2</sub>) parameters, including pressure, temperature, and saturation time on titanium dioxide (TiO<sub>2</sub>) nanopowder dispersion in water-containing sodium hexametaphosphate (SHMP). The stability and morphology of TiO<sub>2</sub> particles dispersed in an aqueous solution were examined using a zeta potential instrument, dynamic light scattering, and transmission electron microscopy. As shown in the results, of particular interest, it was found that near SCCO<sub>2</sub>'s pressure and saturation time had the strongest impact on TiO<sub>2</sub> dispersion in water-containing SHMP. This finding indicated that TiO<sub>2</sub>'s secondary average particle size was significantly reduced with an increase in near SCCO<sub>2</sub>'s pressure and saturation time. Additionally, in the presence of SHMP, the zeta potential of the as-prepared dispersion solution reached  $-53.7$  mV because of production of the larger negative static charge repulsion force (resulting from SHMP dissociation) on the TiO<sub>2</sub> particle surface. The secondary average size was  $127 \pm 68$  nm, indicating good stability of TiO<sub>2</sub> dispersed in water containing an inorganic dispersant.



## 1. INTRODUCTION

Titanium dioxide (TiO<sub>2</sub>) has been widely used for photocatalytic coating,<sup>1,2</sup> cosmetic,<sup>3</sup> antibacterial,<sup>4</sup> self-cleaning,<sup>5</sup> and biological<sup>6</sup> purposes. Furthermore, TiO<sub>2</sub>'s smaller particle size has a specific surface area effect,<sup>7</sup> resulting in outstanding light absorption, catalytic, and magnetic qualities. However, the small particle size is easily agglomerated because of van der Waals forces,<sup>8</sup> decreasing the stability of the TiO<sub>2</sub> dispersion solution and making it difficult to detect the advantages of the small particle size.<sup>9</sup> Therefore, the process to reduce the secondary average particle size and enhance the stability of TiO<sub>2</sub> dispersion solution is a very important topic in application sectors.

Generally, the dispersion processes involve three steps: wetting, mechanical dispersion, and stability. In order to understand TiO<sub>2</sub> dispersion in solution, it is essential to understand the formation and properties of the solid–liquid interface. Dispersion may be defined as a two-phase system, in which one is the dispersion of the small particle phase and the other is the continued fluid phase. Following particle wetting, a mechanical process, such as ultrasonic dispersion,<sup>10</sup> is usually required to complete their separation. Typically, a mechanical method, such as a continuous stirring recirculating media mill,<sup>11</sup> is applied to disperse the wetted particles into a separating unit. Ultrasonic waves have also been proven as useful tools for dispersing nanoparticles and eliminating agglomeration in aqueous suspensions.<sup>12</sup> Ultrasonic irradiation generates shock waves by causing cavitation collapse, leading to interparticle collisions. The agglomerated particles thus become eroded and

split by the collisions. Many studies have applied ultrasonic wave to disperse TiO<sub>2</sub> particles in various solutions for application in different fields.<sup>13–18</sup>

Supercritical fluids (SCFs) are involved in numerous industrial processes and have a potentially wide field of new applications.<sup>19</sup> The SCF has both liquid- and gas-like properties, so that it concurrently exhibits good diffusion and wettability. Additionally, SCFs have lower surface tensions, resulting in faster permeations than those seen with a liquid.<sup>20</sup> As a result, a SCF dispersion process was developed in order to separate the aggregated particles. The supercritical carbon dioxide (SCCO<sub>2</sub>) dispersing method was first studied by Kamiwano et al.<sup>20</sup> for dispersing carbon black particles in water without dispersants. The results showed that the samples of 2 wt % carbon black were uniformly dispersed throughout the solutions after standing for 100 h and had a secondary average particle size of  $<5$   $\mu\text{m}$ . Cheng et al.<sup>21</sup> used SCCO<sub>2</sub> to disperse aminoanthraquinone red, green 36, and blue 15:6 organic pigments in propylene glycol monomethyl ether acetate (PGMEA) in which the organic pigment concentration was 0.001 wt % in order to obtain secondary average particle sizes of 178.5, 93.5, and 188.7, respectively, in the dispersion solution. Wu et al.<sup>22</sup> used SCCO<sub>2</sub>

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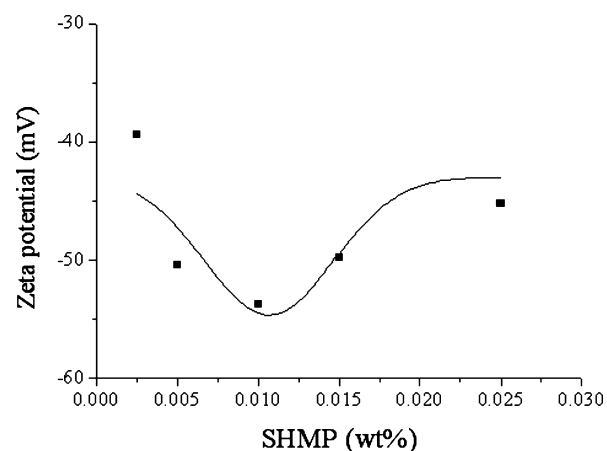
to disperse 1 wt % violet 23 organic pigment in PGMEA. They found that under the favorable conditions of 328.2 K and 20 MPa, the secondary average particle size of pigment dispersion containing dispersants in PGMEA was as small as 175 nm. Cheng and Wu<sup>23</sup> studied a cyclohexanone and PGMEA mixture as a binary solvent for assisting SCCO<sub>2</sub> dispersion and stabilizing organic nanoparticles in the presence of a polyester/polyamine copolymer as a capping agent. As shown in the results, a secondary average particle sizes of 59 and 64 nm were obtained for diketopyrrolopyrrole (red 254) and copper phthalocyanine (green 36) organic pigments, respectively.

After dispersing the wetted particles into a separated unit, sufficient stability should be maintained for a long time for application purposes. Many studies have focused on the TiO<sub>2</sub> particle dispersion stability in water. Mou et al.<sup>24</sup> studied the TiO<sub>2</sub> dispersion solution's solubility by adding ethanol, tetrahydrofuran, polyvinylpyrrolidone (PVP), and sodium hexametaphosphate (SHMP) as dispersants. The results showed that SHMP and tetrahydrofuran as dispersants were the most stable ones. Almusallam et al.<sup>25</sup> explored the stability of TiO<sub>2</sub> particles suspended in various aqueous solutions with and without salicylic acid as an organic contaminant. They found that stable TiO<sub>2</sub> dispersion solution could be obtained under basic solution conditions. However, when changing the pH values of the solution from basic to acidic, it was observed that TiO<sub>2</sub> particles aggregated at pH values below the isoelectric point.<sup>26</sup> It was also shown that TiO<sub>2</sub> aggregation was accelerated by an increase in the concentration of particles in solution. Mahlalela et al.<sup>27</sup> examined the stability of the dispersion solution by using different conducting liquids (deionized water, NaCl, CaCl<sub>2</sub>, and MgCl<sub>2</sub>) in the various solutions with different pH values. Agglomeration and zeta potentials were influenced by ionic strength, electrolyte type, and the presence of dyestuff. Tsai et al.<sup>28</sup> investigated SHMP and polyacrylic acid (PAA) dispersant effects on TiO<sub>2</sub> dispersion stability. The results illustrated that the SHMP was more stable than PAA for facilitating TiO<sub>2</sub> dispersion in water. In addition, ammonium polyacrylate (PAA-NH<sub>4</sub>) has been investigated and compared with respect to the dispersion stabilities of TiO<sub>2</sub> powders with different particle sizes and surface chemistries in aqueous suspensions containing a common water-based dispersant.<sup>29</sup>

According to the studies described in the literature, the present study examined the use of near SCCO<sub>2</sub> dispersing TiO<sub>2</sub> nanopowder in water-containing SHMP as a dispersant, which could be called as a green process because the used materials are nontoxic chemicals. The effects of near SCCO<sub>2</sub> conditions, including pressure, temperature, and saturated time, on the stability and morphology of TiO<sub>2</sub> particles dispersed in aqueous solution was examined by zeta potential instruments, a pH meter, dynamic light scattering (DLS), transmission electron microscopy (TEM), and ultraviolet–visible absorption spectroscopy (UV–vis) associated with high-speed centrifugation and natural sedimentation in this study.

## 2. RESULTS AND DISCUSSION

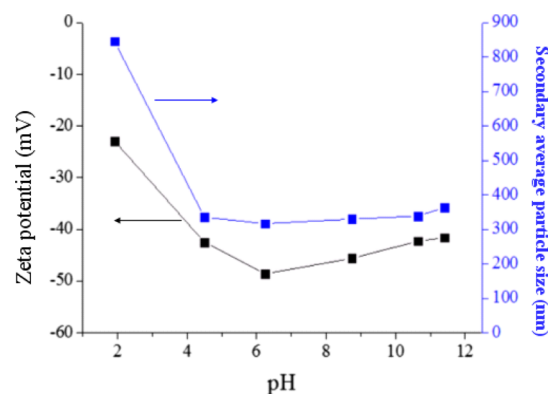
**2.1. Ratio of the Dispersant to TiO<sub>2</sub> and Effect of the pH Value on TiO<sub>2</sub> Dispersion Solution.** Figure 1 shows that the zeta potential of dispersed TiO<sub>2</sub> in water varied with different dispersant concentrations under specified conditions of near SCCO<sub>2</sub>. As observed in the figure, when the ratio of the dispersant is two times that of TiO<sub>2</sub> in weight percentage, the most stable dispersion solution exists because SHMP in water has been dissociated into negatively charged phosphate ions and



**Figure 1.** Zeta potential varying with concentration of the SHMP dispersant in 0.005 wt % TiO<sub>2</sub> solution after being dispersed via SCCO<sub>2</sub> under conditions of 35 °C, 1200 psi, and a saturation time of 30 min, in which the residual CO<sub>2</sub> in the TiO<sub>2</sub> dispersion solution was removed with a ultrasonic bath for 10 min after depressurizing.

adsorbed on the surface of TiO<sub>2</sub> particles to form a perfect electrical double layer. A small amount of inorganic dispersants cannot form an effective electrical double layer on the surface of TiO<sub>2</sub> particles, indicating that the electrostatic repulsion force is small, which results in unstable TiO<sub>2</sub> dispersion in the solution; however, an excess amount of inorganic dispersants would compress the electrical double layer on the surface of TiO<sub>2</sub> particles leading to a low negative zeta potential. Therefore, the weight ratio of the dispersant to TiO<sub>2</sub> was determined as 2/1 in this study.

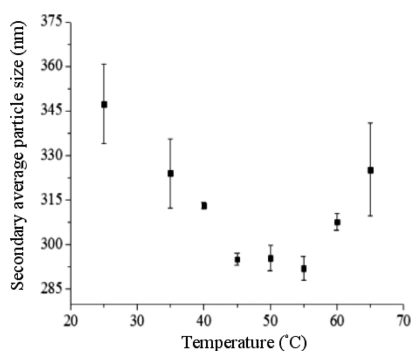
In addition, the effect of pH values on zeta potential and the secondary average particle size estimated by DLS, for the dispersion of 0.05 wt % TiO<sub>2</sub> in solution with 0.1 wt % SHMP through near SCCO<sub>2</sub> under conditions of 35 °C, 1200 psi, and a saturation time of 30 min, is shown in Figure 2. As seen in the figure, it was found that the maximum negative zeta potential reached  $-53.7$  mV at a pH of 6.25, corresponding to a minimum secondary average particle size of about 200 nm. This is because the acidic conditions cause TiOH<sub>2</sub><sup>+</sup> formation on the TiO<sub>2</sub> particles' surfaces; in the meantime, adsorption of phosphate ions occurs, resulting in a decrease in the negative charge on



**Figure 2.** Zeta potential (black) and the secondary average particle size (blue) estimated by DLS of dispersed 0.005 wt % TiO<sub>2</sub> in water varying with the pH value of dispersion solution containing 0.01 wt % SHMP through SCCO<sub>2</sub> under the conditions of 35 °C, 1200 psi, and a saturation time of 30 min.

particles' surface. In other words, with an increase in the pH value, the  $\text{TiO}^-$  formation on the surface of  $\text{TiO}_2$  particles would couple with the adsorbed phosphate ion to enhance negative charges on  $\text{TiO}_2$  particles' surfaces, thus inducing dispersed solution stabilization. The  $\text{Na}^+$  ion in the solution would also increase and absorb the negative charge on the  $\text{TiO}_2$  surface, causing a decrease in the electrical double layer thickness and resulting in an unstable  $\text{TiO}_2$  dispersion solution.

**2.2. Effects of Near SCCO<sub>2</sub> Conditions on Dispersion of TiO<sub>2</sub> in Water.** **2.2.1. Temperature.** In this study, we changed the SCCO<sub>2</sub> temperature in the dispersion process at a pressure of 1200 psi and the saturation time of 30 min followed by CO<sub>2</sub> removal in the dispersion solution using an ultrasonic bath for 10 min after depressurization. As seen in Figure 3, the temperature



**Figure 3.** Secondary average particle size estimated from DLS of 0.005 wt %  $\text{TiO}_2$  dispersion solution involving 0.01 wt % SHMP as a function of temperature of SCCO<sub>2</sub> under a pressure of 1200 psi and a saturation time of 30 min.

had a significant effect on the secondary average particle size of the dispersed  $\text{TiO}_2$  in solution. As the temperature increased, the secondary average particle size of  $\text{TiO}_2$  was decreased to  $292 \pm 4$  nm at 55 °C followed by an increase in particle size to  $325 \pm 16$  nm at 65 °C, indicating that the temperature should be optimized for  $\text{TiO}_2$  dispersion in water through near SCCO<sub>2</sub>. This process occurs because the elevated temperature can input energy and disrupt van der Waals forces between the particles followed by enhancement of particle mobility in the solution leading to formation of smaller and more uniform secondary average particle sizes; in contrast, an increase in temperature would reduce carbon dioxide solubility in water,<sup>30</sup> which would yield in weakening of aggregated  $\text{TiO}_2$  particle dispersion by near SCCO<sub>2</sub>.

In order to further understand the temperature effects of near SCCO<sub>2</sub>, we increased the  $\text{TiO}_2$  concentrations in solution from 0.005 to 0.1 wt % in addition to selecting three different temperatures: (1) 25; (2) 55; and (3) 65 °C. As estimated from the TEM images shown in Figure 4, the secondary average particle sizes of dispersed  $\text{TiO}_2$  in water by near SCCO<sub>2</sub> were  $210 \pm 135$ ,  $184 \pm 81$ , and  $207 \pm 153$  nm at the temperatures of 25, 55, and 65 °C, respectively. This suggests that applying energy to enhance separation of aggregated particles and solubility of near SCCO<sub>2</sub> in water would be traded for a smaller secondary average particle size of dispersed  $\text{TiO}_2$  in solution.

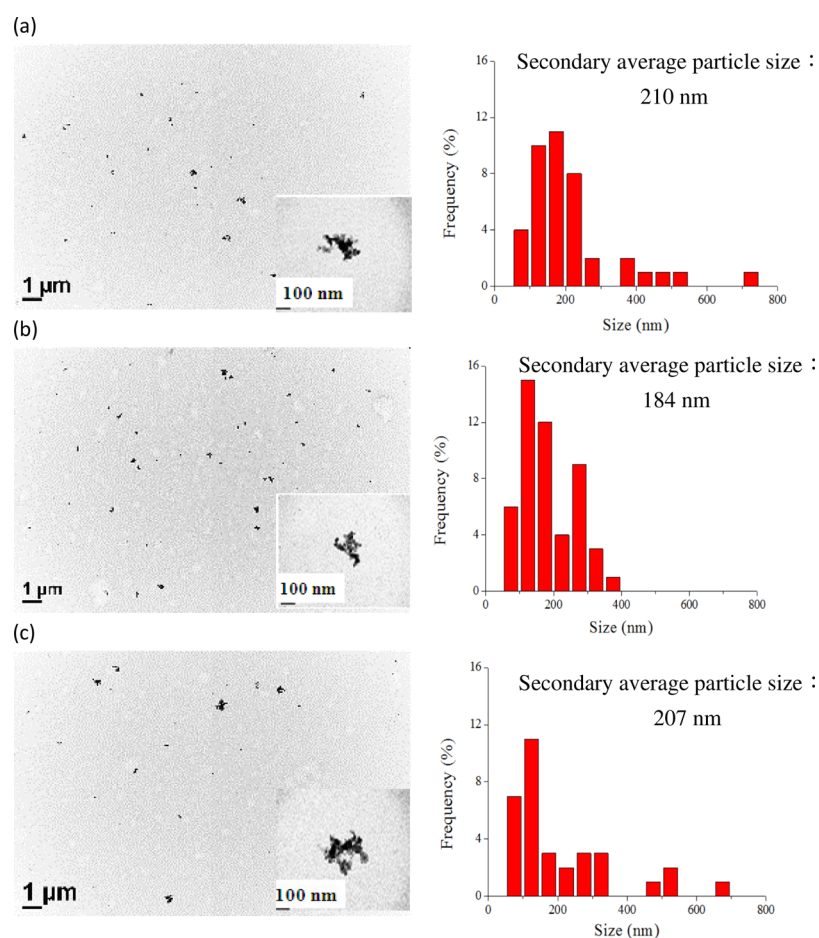
**2.2.2. Pressure.** At a temperature of 55 °C and a saturation time of 30 min, we changed the pressure of near SCCO<sub>2</sub> in the dispersion process followed by CO<sub>2</sub> removal from the dispersion solution using an ultrasonic bath for 10 min. As shown in Figure 5, with an increase in pressure from 1200 to 4000 psi, the secondary average particle size was reduced from  $292 \pm 4$  to  $237$

$\pm 6$  nm as measured by DLS. It was indicated that higher near SCCO<sub>2</sub> pressure was favorable for the formation of smaller  $\text{TiO}_2$  particles in solution. This process probably occurs because an elevation in pressure leads to an increase in CO<sub>2</sub> solubility in water, resulting in facilitating near SCCO<sub>2</sub> penetration into the pores of aggregated particles in solution. Additionally, Figure 6 shows the TEM of dispersed  $\text{TiO}_2$  particles in solution under different near SCCO<sub>2</sub> pressures. As exhibited in the images, the secondary average particle size of the dispersed  $\text{TiO}_2$  particle decreases with increasing near SCCO<sub>2</sub> pressure. When the pressure was increased from 2000 to 4000 psi, the secondary average particle size of dispersed  $\text{TiO}_2$  particle was reduced from  $165 \pm 98$  to  $148 \pm 68$  nm. The standard deviation was decreased, indicating that the narrow particle size distribution of dispersed  $\text{TiO}_2$  in solution could be obtained by increasing the pressure of near SCCO<sub>2</sub>.

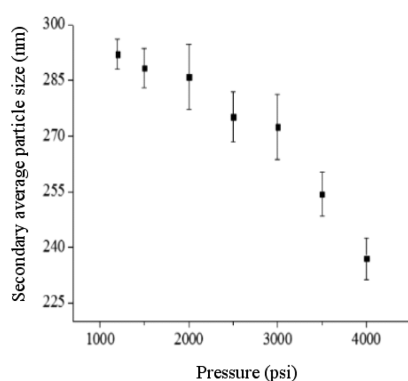
**2.2.3. Saturation Time.** Figure 7 illustrates the effect of near SCCO<sub>2</sub> saturation time on the secondary average particle size of dispersed  $\text{TiO}_2$  particles in water, in which CO<sub>2</sub> pressure and temperature in addition to the time of CO<sub>2</sub> removal from the dispersion solution after ultrasonication were 4000 psi, 55 °C, and 10 min, respectively. As determined from the figure, an increase in saturation time from 0 to 120 min led to a reduction in the secondary average particle sizes of dispersed  $\text{TiO}_2$  in solution from  $418 \pm 22$  to  $237 \pm 9$  nm as determined by DLS. This finding indicated that more of the near SCCO<sub>2</sub> permeated the pores in-between  $\text{TiO}_2$  particles as the saturation time increased, resulting in full wetting of aggregated particles in solution. Meanwhile, we also found that the secondary average particle size of  $\text{TiO}_2$  in solution would present a constant trend when the saturation time of near SCCO<sub>2</sub> reached 30 min, indicating that the agglomerated particle pores were completely filled with near SCCO<sub>2</sub>. Figure 8 shows the TEM of dispersed  $\text{TiO}_2$  in solution with near SCCO<sub>2</sub> at different saturation times. As observed from the figure, the secondary average particle size of dispersed  $\text{TiO}_2$  in solution containing near SCCO<sub>2</sub> decreased with an increase in saturation time. When the saturation time was increased from 5 to 120 min, the average particle size of dispersed  $\text{TiO}_2$  particles in solution through near SCCO<sub>2</sub> was reduced from  $201 \pm 135$  to  $149 \pm 65$  nm as estimated by TEM.

**2.3. Stability of TiO<sub>2</sub> Dispersion Solution.** The UV–vis light absorption associated with centrifugation was used to examine stability of dispersed  $\text{TiO}_2$  in solution without and with inorganic dispersants via near SCCO<sub>2</sub> in this study. Figure 9 presents the UV–vis light absorption spectra of four samples before and after centrifugation at a rotational speed of 3000 rpm for 30 min. As observed from Figure 9d, the UV–vis light absorption value of dispersed  $\text{TiO}_2$  in water without dispersants by only magnetic stirring for one day was the lowest because of aggregation seriously leading to particle precipitation. The UV–vis light absorption spectra of the sample dispersed by near SCCO<sub>2</sub> in the absence of dispersants is shown in Figure 9c, in which the absorption value was obviously higher than the sample without dispersion by SCCO<sub>2</sub>, resulting from  $\text{TiO}_2$  particles suspended in water stably.

We further investigated the UV–vis light absorption of  $\text{TiO}_2$  with and without dispersion by near SCCO<sub>2</sub> in the presence of SHMP. As shown in Figure 9a,b, the absorption peak was blue-shifted<sup>31</sup> for the sample dispersion by near SCCO<sub>2</sub>, indicating that the secondary average particle size of dispersed  $\text{TiO}_2$  in water was reduced in order to induce an absorption peak shift to a shorter wavelength. This could be used to demonstrate that the



**Figure 4.** TEM images (1) and particle size distribution (2) calculated from TEM of dispersed 0.1 wt %  $\text{TiO}_2$  in water containing 0.2 wt % SHMP through  $\text{SCCO}_2$  under temperatures of (a) 25, (b) 55, and (c) 65 °C, respectively, as well as at a pressure of 1200 psi and a saturation time of 30 min. The inset is the morphology of aggregated  $\text{TiO}_2$  particles in solution.



**Figure 5.** Secondary average particle size estimated from DLS of 0.005 wt %  $\text{TiO}_2$  dispersion solution involving 0.01 wt % SHMP varying with pressure of  $\text{SCCO}_2$  under a temperature of 55 °C and a saturation time of 30 min.

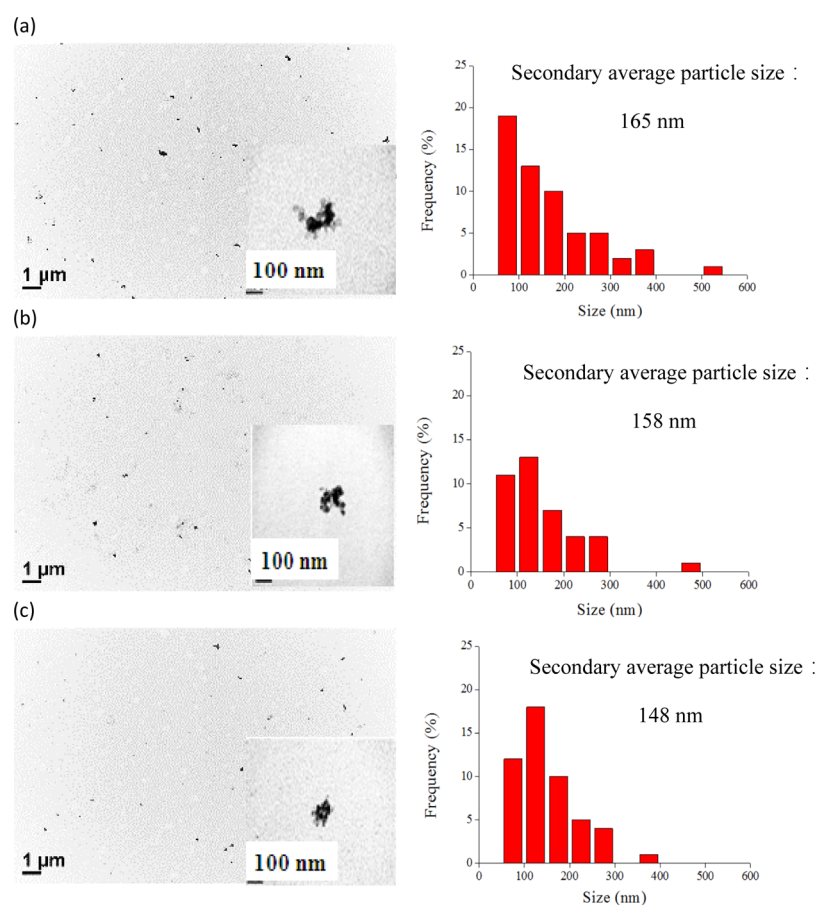
near  $\text{SCCO}_2$  is an effective method for  $\text{TiO}_2$  dispersion in water with inorganic dispersants.

Figure 10 shows photographs of the natural sedimentation experiment in which sample (a) was made from 0.1 wt %  $\text{TiO}_2$  in water; sample (b) was prepared from blending 0.1 wt %  $\text{TiO}_2$  and 0.2 wt % SHMP in water; sample (c) was fabricated by mixing 0.1 wt %  $\text{TiO}_2$  and 0.2 wt % SHMP and dispersed by near  $\text{SCCO}_2$ ; and sample (d) was water for comparison, as well as the  $\text{SCCO}_2$  dispersion conditions were 55 °C, 4000 psi, and 30 min

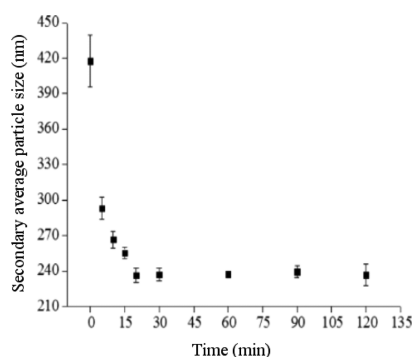
saturation time. As observed from the photographs, without inorganic dispersants in water, the  $\text{TiO}_2$  particles had completely precipitated in the bottom of the scintillation flask after dispersion for about one day; on the other hand, adding SHMP could significantly enhance dispersed  $\text{TiO}_2$  stability in solution, which clearly indicated that the  $\text{TiO}_2$  dispersion solution with dispersants was more stable than that without dispersants. This difference resulted from smaller secondary average particle size of dispersed  $\text{TiO}_2$  in solution through near  $\text{SCCO}_2$  in the presence of dispersants. The lifetime of dispersed  $\text{TiO}_2$  in water-containing SHMP was over two weeks in this study.

### 3. CONCLUSIONS

In this study, near  $\text{SCCO}_2$  was successfully employed to disperse  $\text{TiO}_2$  particles in water involving inorganic dispersants. First, the amount of the SHMP dispersant was determined by zeta potential analysis. The effects of different temperatures, pressures, and saturation times on the dispersed  $\text{TiO}_2$  in solution through near  $\text{SCCO}_2$  were then examined by DLS and TEM. Finally, the stability of dispersed  $\text{TiO}_2$  in solution was characterized via UV–vis light absorption associated with centrifugation and natural sedimentation method. As shown in the results, we summarize the study by highlighting several significant findings:



**Figure 6.** TEM images (1) and particle size distribution (2) calculated from TEM of dispersed 0.1 wt %  $\text{TiO}_2$  in water containing 0.2 wt % SHMP through  $\text{SCCO}_2$  under pressures of (a) 2000, (b) 3000, and (c) 4000 psi, respectively, as well as at a temperature of  $55^\circ\text{C}$  and a saturation time of 30. The inset is the morphology of aggregated  $\text{TiO}_2$  particles in solution.



**Figure 7.** Secondary average particle size estimated from DLS of 0.005 wt %  $\text{TiO}_2$  dispersion solution involving 0.01 wt % SHMP varying with saturation time of  $\text{SCCO}_2$  under a temperature of  $55^\circ\text{C}$  and a pressure of 4000 psi.

(1) As the addition of SHMP was twice the concentration of  $\text{TiO}_2$  in weight, the maximum zeta potential of the dispersion solution was  $-53.7$  mV as measured by a zeta potential instrument, suggesting that the SHMP as a dispersant was well dissociated from the phosphate ions and adsorbed on the surface of the  $\text{TiO}_2$  particles. This finding implied that  $\text{TiO}_2$  dispersion in solution had a large negative charge from the electrostatic repulsive force and had good stability at a pH of 6.25 in order to prevent  $\text{TiO}_2$  particle precipitation under operating conditions of near  $\text{SCCO}_2$ .

(2) When the concentration of  $\text{TiO}_2$  in solution with SHMP was 0.1 wt %, the secondary average particle size was  $366 \pm 295$  and  $148 \pm 68$  nm as measured by TEM before and after dispersion by near  $\text{SCCO}_2$ , respectively, indicating that near  $\text{SCCO}_2$  was validated as having penetrated the pores of aggregated particles, and then rapidly depressurized to effectively separate aggregated particles in solution.

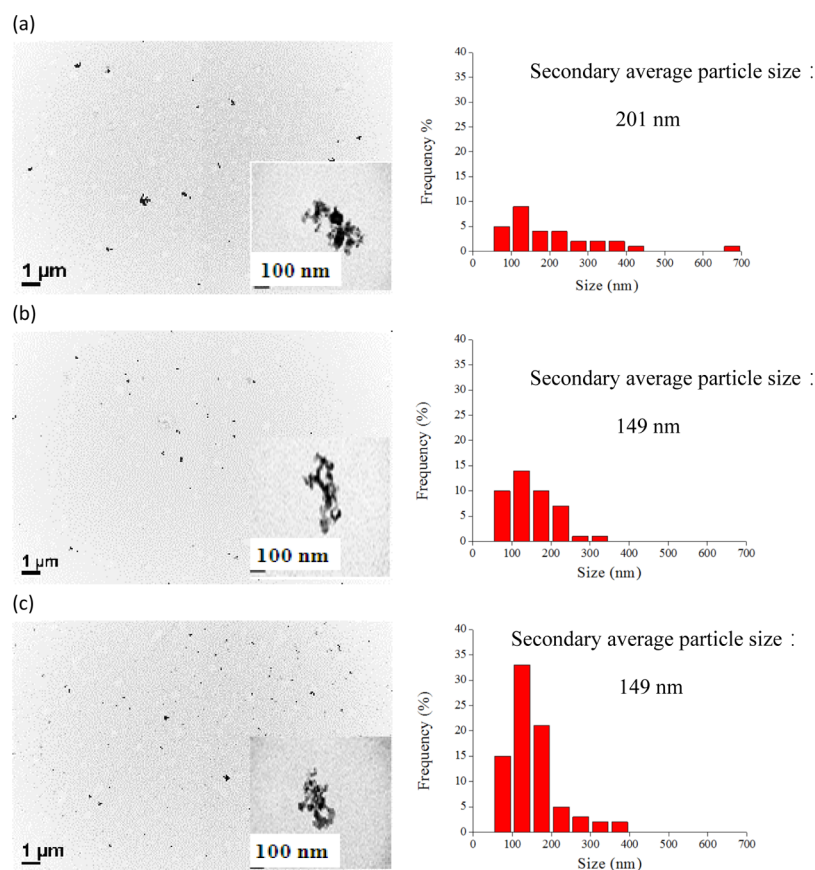
(3) It was found that applying energy to promote separation of aggregated  $\text{TiO}_2$  particles and solubility of  $\text{CO}_2$  in water should be compromised, namely, the temperature of near  $\text{SCCO}_2$  must be optimized in this work.

(4) Raising the pressure could increase the density of near  $\text{SCCO}_2$  in order to elevate wettability of the near SCF on the surface of particles and enhance the separation of aggregated  $\text{TiO}_2$  particles during the rapid depressurization process.

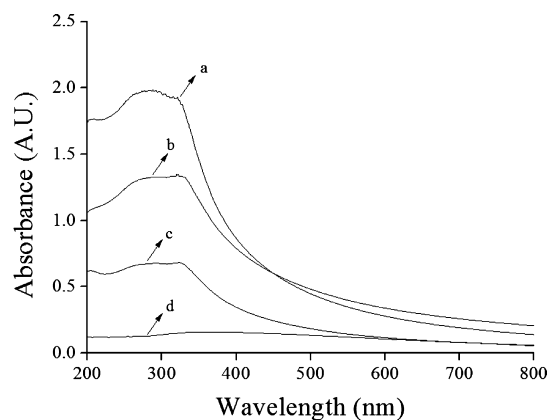
(5) As analyzed from DLS, when the concentration of  $\text{TiO}_2$  ranged from 0.005 to 0.1 wt %, a 30 min  $\text{SCCO}_2$  saturation time was enough to completely wet the surface of the aggregated particles.

(6) As measured by natural sedimentation, the storage time of the as-prepared 0.1 wt %  $\text{TiO}_2$  dispersion solution could be over two weeks.

Hopefully, the above results promise to facilitate fabrication of colloid inorganic oxide suspension through a green process.



**Figure 8.** TEM images (1) and particle size distribution (2) calculated from TEM of dispersed 0.1 wt %  $\text{TiO}_2$  in water containing 0.2 wt % SHMP through  $\text{SCCO}_2$  under the saturation times of (a) 5, (b) 20, and (c) 120 min, respectively, as well as at a temperature of 55 °C and a pressure of 4000 psi. The inset is the morphology of aggregated  $\text{TiO}_2$  particles in solution.



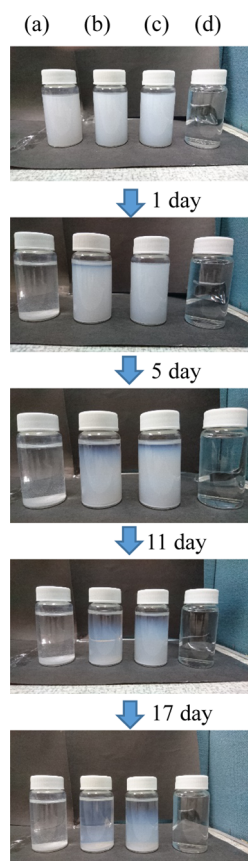
**Figure 9.** UV–vis light absorption spectra of 0.005 wt %  $\text{TiO}_2$  in water (a) with both 0.01 wt % SHMP and dispersion by  $\text{SCCO}_2$ , (b) with 0.01 wt % SHMP but without dispersion by  $\text{SCCO}_2$ , (c) without SHMP but with dispersion by  $\text{SCCO}_2$ , and (d) without both SHMP and dispersion by  $\text{SCCO}_2$ . The conditions of  $\text{SCCO}_2$  are a temperature of 55 °C, a pressure of 4000 psi, and a saturation time of 30 min.

## 4. MATERIALS AND METHOD

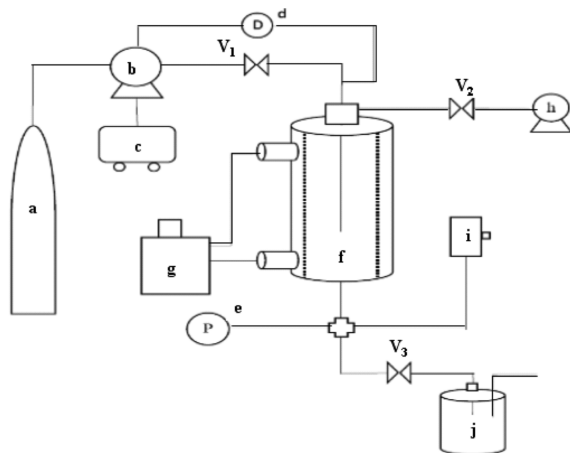
**4.1. Chemicals.**  $\text{TiO}_2$  powder (P25) with a primary average particle size of 21 nm and a spherical shape was purchased from Degussa. SHMP (99%) was used as an inorganic surfactant (SHOWA) in order to enhance dispersion stability. Deionized water (18.1 Ω), which was mechanically filtered and processed to remove impurities, was used as a continuous phase.

Hydrochloric acid (32.4%) and sodium hydroxide (96%) were obtained from Choneye Pure Chemicals and SHOWA, respectively. Both were diluted to 0.1 wt % for adjusting the pH values of the dispersion solutions.

**4.2. Determination of the Ratio of the Dispersant to  $\text{TiO}_2$  in Dispersion Solution.** In order to stabilize the dispersed  $\text{TiO}_2$  and prevent it from precipitating in water under near  $\text{SCCO}_2$  operating conditions, the experiments were conducted by varying the amounts of SHMP from 0.0025 to 0.025 wt % (0.0025, 0.005, 0.01, 0.015, and 0.025 wt %) in 50 mL deionized water containing 0.005 wt %  $\text{TiO}_2$  with continuous magnetic stirring (Ciamarec 2 Thermolyne, 950 rpm) for 24 h followed by transferring to a 300 mL supercritical vessel through a peristaltic pump (Cole-Parmer Masterflex L/S) at normal atmospheric pressure and ambient temperature. A schematic diagram of the experimental system used in this study is shown in Figure 11. For each experiment, the supercritical vessel was operated according to the following procedure; after introducing 50 mL of the dispersion solution, the supercritical vessel was closed, and the temperature was controlled at 35 °C via a circulating water bath (Deng Yang Water Bath D-606). The carbon dioxide concentration was then increased up to 1200 psi in the supercritical vessel using an air driven pump (Haskel ALG-60), followed by maintaining it at this pressure for 30 min, and then followed by rapid depressurization of the near  $\text{SCCO}_2$  to disperse the  $\text{TiO}_2$  particles in the solution. In order to remove the residual carbon dioxide in the  $\text{TiO}_2$  dispersion solution after the near  $\text{SCCO}_2$  dispersion process, an ultrasonic bath was used for 10 min before characterization. The pH of the  $\text{TiO}_2$



**Figure 10.** Photographs of the natural sedimentation experiment for the samples: (a)  $\text{TiO}_2$  in water; (b)  $\text{TiO}_2$  and SHMP in water; (c)  $\text{TiO}_2$  and SHMP in water after being dispersed by  $\text{SCCO}_2$ ; and (d) water for comparison.



#### Nomenclature:

a. $\text{CO}_2$ storage tank	b. $\text{CO}_2$ pump (ALG-60)	c. Air compressor
d. Digital multifunctional meter	e. Pressure meter	f. Pressure vessel
g. Water circulation bath	h. Peristaltic pump	i. Safety valve
j. Collection bottle	$V_1, V_2,$ and $V_3$ : Needle valve	

**Figure 11.** Schematic diagram of experimental apparatus in this study.

dispersion solution was varied by addition of sodium hydroxide or hydrochloric acid. In addition, a zeta potential instrument (Malvern Zetasizer Nano Series) was used for measuring the zeta potential of the  $\text{TiO}_2$  particles in the dispersion solution

after the pH was measured using a pH meter (SUNTEX SP-701).

**4.3. Effects of Near SCF Conditions on  $\text{TiO}_2$  Dispersed in Water with the SHMP Dispersant.** The experimental samples were prepared by using 0.01 wt % SHMP in 50 mL deionized water, followed by adding 0.005 wt %  $\text{TiO}_2$  with continuous magnetic stirring for 24 h. The subsequent procedure was similar to the dispersion method used in the previous experiment, but the near  $\text{SCCO}_2$  dispersion temperature was varied from 25 to 65 °C, the pressure was regulated from 1200 to 4000 psi, and the saturation time was limited between 0 and 120 min. We used the same conditions and steps to disperse  $\text{TiO}_2$  in solution in three separate experiments.

A DLS analyzer (Brookhaven 90Plus Particle Sizer) was used for measuring the secondary average particle size and dispersion solution distribution. For further validation, the dispersed  $\text{TiO}_2$  particles in solution were characterized by TEM (JEOL JEM-1200CX). The TEM images of dispersed  $\text{TiO}_2$  particles were analyzed with ImageJ.<sup>31</sup>

**4.4. Stability of As-Dispersed  $\text{TiO}_2$  in Water through Near  $\text{SCCO}_2$ .** The stability of the dispersed  $\text{TiO}_2$  in solutions with and without dispersants was evaluated by ultraviolet–visible absorption spectroscopy (UV-1800 SHIMADZU) together with high-speed centrifugation (CN-3302 HSIANG-TAI) in addition to natural sedimentation.

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### Notes

The authors declare no competing financial interest.

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