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Thickness-Controlled Polyamide Membranes via Centrifugal Thin-Film Deposition for Improved Fouling and High-Recovery Performance

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Abstract

Nanofiltration for desalination and water reuse demands fouling-resistant and high-recovery operation, but is often constrained by permeability–selectivity trade-offs and heterogeneous polyamide growth during interfacial polymerization. Here, we introduce centrifugal thin-film deposition (CTFD) as a controllable aqueous-phase delivery step that spreads piperazine uniformly before polymerization with trimesoyl chloride, limiting monomer infiltration into the porous support and suppressing nonuniform film growth. Molecular dynamics simulations show centrifugal confinement of piperazine near the reaction zone, consistent with experimentally improved film uniformity. CTFD produces ~10–50 nm polyamide layers with lower roughness (R_a ~40–45 nm) than a conventional membrane (R_a ~90 nm). The optimized membrane (0.1 wt.% piperazine; 3.198 kg m/s^2) delivers ~136 LMH flux and 94.3% Na_2SO_4 rejection at 6 bar, fully recovers flux after hydraulic cleaning of sodium alginate fouling, and maintains >85% Na_2SO_4 rejection at high recovery with higher flux. This work offers an effective strategy to tune polyamide layer formation and transport resistance under sulfate-rich nanofiltration conditions where high permeability, fouling reversibility, and high-recovery operation are prioritized.

Keywords: Polyamide Layer Engineering; Interfacial Polymerization; Nanofiltration; Desalination; Antifouling; High-Recovery

Introduction

Water scarcity continues to intensify reliance on desalination and water reuse as dependable water supplies for municipal and industrial demand [1,2]. In these applications, the practical bottleneck is often not the initial separation performance of the membrane, but the ability to maintain stable operation in the presence of organic foulants in saline waters containing divalent ions, which can intensify fouling and complicate cleaning [3]. Membrane fouling remains a primary operational constraint because it increases hydraulic resistance and drives flux decline, requiring more frequent cleaning and making fouling reversibility a key determinant of stable, cost-effective operation [4]. Therefore, for water reuse in particular, where feed composition can fluctuate, and organic loading can be high, membranes that foul reversibly and recover flux after mild hydraulic cleaning are more likely to sustain reliable operation and lower treatment costs [5,6].

In addition, desalination and reuse facilities increasingly pursue high-recovery operation to increase permeate yield and reduce concentrate (brine) volumes and associated management/disposal costs [7]. However, as recovery increases, salt concentrations rise, elevating osmotic pressure and concentration polarization and thereby reducing effective driving force and increasing the sensitivity of flux and rejection to selective-layer transport resistance and pressure-induced compaction [8,9]. Under these high-salinity conditions, even modest differences in selective-layer uniformity and hydraulic resistance can translate into meaningful differences in operating pressure requirements and flux stability over time [10]. Accordingly, pressure-driven membrane systems should be evaluated not only by initial flux and rejection, but also by (i) fouling reversibility under representative organic foulants and (ii) performance robustness during high-recovery operation under increasing salinity.

Thin-film composite (TFC) nanofiltration membranes are widely applied in desalination and water reuse because they offer high water recovery while selectively rejecting multivalent ions and natural organic matter [11,12]. In typical TFC fabrication, the polyamide selective layer is formed by interfacial polymerization (IP) using an immersion coating of the aqueous amine phase, followed by excess-liquid removal steps

before contacting the organic phase [13]. However, instability within the narrow interfacial zone, driven by rapid reaction kinetics and uncontrolled aqueous-phase retention in support pores, can lead to heterogeneous film growth that constrains performance [14,15]. Numerous approaches have been proposed to regulate IP dynamics (e.g., substrate or interlayer engineering [16,17], organic-phase tuning [18], electro-spray-assisted polymerization [19], and molecular layer-by-layer deposition [20]); nevertheless, they often add complexity and cost to membrane fabrication. In piperazine (PIP)-based TFC membranes, the PIP concentration can control the polyamide's thickness, surface morphology, and network structure—key parameters that govern selectivity and stability [21]. Higher PIP uptake can increase crosslinking density, but often promotes nodular growth and higher transport resistance. In contrast, lower PIP concentration can lead to incomplete film formation and heterogeneity [21,22].

However, concentration tuning alone cannot overcome nonuniform monomer distribution, underscoring the need for more precise aqueous-phase delivery to achieve structural control at sub-50 nm. To improve spatial control over the formation of the polyamide film, several alternative monomer delivery strategies have been proposed, including delayed IP via diffusion control [23], vacuum-assisted infiltration [24], reverse interfacial polymerization [25], and in situ additive distribution [26]. While these approaches can modulate interfacial transport, they often rely on imprecise excess-removal steps (such as gravity, rubber rollers, or air knives) that introduce variability and fail to control monomer retention within substrate pores, leading to inconsistent interfacial reactions and nonuniform polyamide morphologies, which are unfavorable for fouling resistance and stable operation under concentrated conditions [27-29].

Here, we introduce centrifugal thin-film deposition (CTFD) as a controllable aqueous-phase delivery step that utilizes radial acceleration to uniformly spread various PIP concentrations across the support before polymerization with trimesoyl chloride (TMC), enabling the formation of highly uniform polyamide selective layers with tunable thickness and morphology [30,31]. This approach can potentially shorten processing time and reduce chemical use by applying centrifugal force to confine and level the aqueous phase across the substrate surface [32]. Membrane performance is evaluated using (i) single-salt

filtration, (ii) sodium alginate fouling test emphasizing flux recovery after low-pressure hydraulic cleaning to quantify fouling reversibility, and (iii) high-recovery, open-loop cross-flow filtration to assess stability as concentration increases. Complementary molecular dynamics (MD) simulations provide mechanistic insight into how centrifugal force directs monomer distribution and promotes uniform polyamide formation on the support layer. Together, the experimental and computational results establish a robust structure–property–performance framework for next-generation TFC membranes with improved operability in desalination and water reuse systems.

Results

Optimization of Polymer Concentration and Centrifugal Force at Dead-End Filtration

In the first step, the applicability of the CTFD technique was tested for depositing both aqueous- and organic-phase monomers. Centrifugal application of the organic-phase monomer did not yield a detectable polyamide layer. This is likely due to the low viscosity of the TMC/n-hexane solution (≈ 0.3 mPa·s), which is substantially lower than that of the aqueous PIP phase (≈ 0.9–1.1 mPa·s), resulting in poor retention on the polyethersulfone (PES) surface during coating. Rapid radial displacement of the organic phase likely shortened residence time and limited stable interfacial contact with the aqueous phase, thereby hindering effective polyamide formation. Therefore, subsequent work focused on aqueous-phase deposition.

In conventional IP, the retained aqueous amine phase is strongly influenced by the porous support properties, including wettability, surface roughness, porosity, and pore size, which affect aqueous-solution retention on the surface and within support pores [33]. Additional processing factors, such as gravity drainage and excess-liquid removal, further determine the residual monomer inventory on and within the porous PES support. Consequently, when the organic TMC phase is introduced, local differences in PIP availability and diffusion pathways can lead to heterogeneous reaction zones and nonuniform polyamide growth. In contrast, CTFD modifies the pre-reaction aqueous-phase boundary condition before organic-phase contact,

rather than directly altering the intrinsic chemistry of the PIP–TMC reaction. Centrifugal acceleration promotes lateral redistribution of the aqueous phase while simultaneously removing excess solution from the surface and near-surface pores. This process reduces local pooling, limits excessive PIP retention within the porous support, and produces a more controlled residual monomer inventory at the reaction interface. Therefore, the role of CTFD is not simply uniform spreading, but regulation of aqueous-film thickness, monomer residence time, and near-surface PIP availability prior to IP [13,34]. Since polyamide formation is rapid and self-limiting, controlling monomer availability in this narrow time window is critical [35]. This controlled initial condition likely moderates local stoichiometric fluctuations during the subsequent PIP–TMC reaction, enabling thinner and more uniform polyamide formation.

To investigate the influence of monomer concentration and centrifugal force on polyamide structure, four representative membranes were selected to represent the lowest and highest centrifugal forces (A and D) and PIP concentrations (0.5 and 3). **Fig. 1C** schematically illustrates the application of centrifugal force during deposition and the formation of the polyamide layer on the PES substrate. As shown in **Fig. S2A** and **S2B$_1$–B$_4$** in the **Supporting Information (SI)**, the N 1s peak in XPS spectra of all membranes exhibited a prominent peak at 399 eV, which may be attributed to amide nitrogen (–N–C=O) [30]. The survey spectra also showed characteristic peaks at 285.0 eV (C 1s) and 532.0 eV (O 1s), which are consistent with typical polyamide chemistry [36]. Moreover, the deconvoluted C 1s spectra (**Fig. 1E$_1$–E$_4$**) displayed three dominant peaks at 285.2 eV, 286.8 eV, and 288.3 eV, corresponding to C=C/C–C/C–N (aromatic ring in TMC/aromatic ring in TMC/PIP), C–O (carboxylic group in TMC), and C–N/C–O (amide linkages), respectively [36,37].

Top-view FESEM images **(Fig. 1A$_1$–A$_4$** and **Fig. S4B$_1$–B$_3$, SI)** revealed clear surface-morphology differences as a function of PIP concentrations and centrifugal force. Higher PIP concentrations appeared to lead to more conventional ridge-valley film structures, whereas increased centrifugal forces yielded smoother, more uniform film surfaces. Apparent surface valleys or low-density regions observed in the CTFD images are interpreted as morphology-related features of ultrathin interfacially polymerized

polyamide films rather than direct evidence of defects, since top-view imaging alone cannot resolve the full three-dimensional selective-layer structure [38-40]. Accordingly, polyamide formation was evaluated in light of the XPS results presented earlier, together with the cross-sectional electron microscopy discussed below. Moreover, for comparison, the top-view FESEM images of the bare PES support and conventional polyamide membrane are provided in **Fig. S4A$_1$–A$_2$**.

Cross-sectional TEM results **(Fig. 1B$_1$–B$_4$** and their higher magnification TEM images in **Fig. S3A-D, Fig. 1D$_1$–D$_2$,** and **Fig. S4D$_1$–E$_3$, SI)** showed thin polyamide layers across all CTFD membranes (< 60 nm, **Table S1, SI**) in comparison to a thicker polyamide selective layer fabricated through the conventional method **(Fig. S4C$_1$, SI)** and no visible selective layer for pristine PES support **(Fig. S5, SI)**. At fixed force, increasing PIP concentration led to a two-fold increase in the polyamide layer thickness from 33.1 nm to 59.9 nm. In contrast, at fixed PIP concentrations, increasing centrifugal forces resulted in reduced film thickness. AFM topography **(Fig. 1D$_3$–D$_4$)** revealed minimal variations in surface roughness for the membranes fabricated via CTFD. At fixed centrifugal force, R_a increased slightly from 45.8 nm to 47.6 nm as PIP concentration increased. Similarly, in the centrifugal force series at fixed PIP concentrations, R_a values remained nearly constant at ≈ 44 nm. Notably, all CTFD membranes exhibited significantly lower roughness than the conventional membrane **(**$R_a \approx 90$ nm**)**, resulting in smoother surfaces that are hypothesized to promote more uniform flow distribution and enhance antifouling performance [41].

Fig. 2 compares the molecular distribution of PIP monomers on PES substrates for conventional dip-coating and CTFD methods, as simulated in LAMMPS. The simulation was designed not to replicate the full IP reaction but to isolate the mechanical influence of centrifugal acceleration on monomer transport and surface distribution. In the conventional deposition model, PIP molecules displayed a disordered, subsurface arrangement, characteristic of diffusion-dominated transport and random aggregation, conditions that may lead to nonuniform reaction zones and heterogeneous polyamide structures [42]. In contrast, centrifugal deposition directed PIP molecules radially into a compact, homogeneous boundary layer, enhancing monomer confinement and improving surface coverage. These results align with SEM,

TEM, and AFM observations, which showed that CTFD membranes possessed uniform, thin selective layers with reduced surface roughness. More information on the MD simulation can be found in the **SI**.

To summarize, characterization results for CTFD membranes showed that increasing PIP concentration led to thicker polyamide layers with ridge structures, whereas increasing centrifugal force mainly reduced film thickness and yielded more uniform films. Furthermore, surface roughness remained largely unchanged as long as a centrigufal force was applied. Centrifugal acceleration in the CTFD process may stabilize the interface in IP by balancing monomer diffusion and polymerization rates, minimizing concentration fluctuations, and ensuring uniform, thin polyamide formation [43]. To assess the influence of these structural changes on membrane performance, CTFD membranes were first evaluated in a dead-end filtration setup.

Fig. 3 summarizes normalized water flux and observed salt rejection results for Na_2SO_4, $MgSO_4$, and NaCl as functions of PIP concentration and centrifugal force. At fixed centrifugal force (**Fig. 3A_1–A_4**), all membranes showed maximum normalized flux at the lowest PIP loading, followed by a steady decline as PIP concentration increased. At the same time, salt rejection for Na_2SO_4, $MgSO_4$, and NaCl all increased with higher PIP concentrations. For example, in Na_2SO_4 filtration, increasing PIP from 0.5 wt.% to 3 wt.% at a fixed 0.199 kg m/s^2 **(Fig. 3A_2)** reduced normalized flux by 43.1% (from 1.00 to 0.569), while increasing rejection by 24.4% (from 73.2% to 97.6%). These trends reflect the classic permeability–selectivity trade-off, likely driven by the formation of thicker polyamide layers at higher PIP concentrations, which enhance salt rejection but increase transport resistance [44]. At fixed PIP concentration **(Fig. 3B_1–B_4)**, higher centrifugal force generally enhanced normalized flux, consistent with resulting in a thinner film, as observed in TEM analyses. For example, in Na_2SO_4 filtration, increasing centrifugal force from 0.012 kg m/s^2 to 29.985 kg m/s^2 at a fixed 2 wt.% PIP **(Fig. 3B_3)** increased the normalized flux by approximately 54% (from 0.65 to 1.00). Rejection trends, however, varied across salts and PIP loadings, reflecting an interplay between reduced thickness, which may translate into lower selectivity [12].

Evaluation of Cross-Flow Filtration and Extended Characterization

The dead-end filtration tests revealed general trends in permeability and salt rejection across the investigated PIP concentrations and centrifugal forces, while also highlighting the expected trade-off between reduced transport resistance and salt selectivity. To clarify the selection logic, a trade-off matrix summarizing water flux, Na_2SO_4 rejection, TEM-derived polyamide thickness, and AFM roughness is provided in **Table S6, SI**. This screening did not identify a universally superior centrifugal force based on rejection alone; rather, it showed that 3.198 kg m/s^2 provided a suitable baseline condition for the next-stage PIP optimization because it generally produced thinner and smoother polyamide layers with lower transport resistance, while allowing the effect of monomer concentration on film formation to be more clearly resolved. Therefore, 3.198 kg m/s^2 was selected as the baseline centrifugal force for the refined cross-flow study. Unlike the dead-end filtration tests, which employed four PIP concentrations (0.5, 1, 2, and 3 wt.%), the cross-flow filtration study explored a lower and more finely resolved PIP concentration range (0.05–2 wt.%) to capture subtle effects of monomer availability on membrane formation and performance.

XPS analysis was performed to examine the surface elemental composition and chemical bonding of the conventional membrane and two CTFD membranes prepared with low (0.1 wt.%) and high (2 wt.%) PIP concentrations. The survey spectra **(Fig. S6A, SI)** showed peaks at 285 eV (C 1s), 532 eV (O 1s), and 399 eV (N 1s), characteristic of polyamide chemistry. High-resolution C 1s spectra **(Fig. 4A_1–A_3)** displayed peaks at 285 eV (C–C/C=C from TMC/aromatic rings and C–N from PIP), 286.5 eV (C–O from carboxylic acid groups in unreacted or hydrolyzed TMC), and 288.1 eV (C–N and C–O in amide linkages) [36,37]. High-resolution O 1s spectra **(Fig. 4B_1–B_3)** exhibited peaks at 531.8 eV from carbonyl groups in amides (N–C=O) and possibly hydroxyls, and at ~533.3 eV from O–C=O in carboxylic acids, likely formed via hydrolysis of residual TMC acyl chlorides [45]. High-resolution N 1s spectra **(Fig. 4C_1–C_3)** revealed two components at 399.9 eV from terminal amine groups (R–NH_2) and 400.8 eV from amide nitrogen (N–C=O)

[46]. High-resolution C1s, N1s, and O1s spectra for the remaining membranes are provided in **Fig. S6B$_1$–D$_5$, SI.**

Table S4, SI presents the atomic composition of the conventional and CTFD membranes, from which O/N ratios were calculated to assess the crosslinking degree, as determined by XPS analysis. A fully crosslinked polyamide has an ideal O/N ratio of 1.00. The conventional membrane exhibited an O/N ratio of 2.11, indicating incomplete crosslinking and the presence of hydrolyzed species. The membrane prepared with low PIP concentration (0.1 wt.%) showed an even higher O/N ratio (2.49), suggesting a relatively low apparent crosslinking degree, likely due to limited monomer availability. In contrast, the membrane fabricated with high PIP concentration (2 wt.%) exhibited a lower ratio (1.78), indicating a more highly crosslinked network. Complementary EDX analysis **(Table S5, SI)** aligned with these findings, showing increased nitrogen content and reduced oxygen content at higher PIP concentrations, consistent with enhanced crosslinking.

The impact of PIP concentration on membrane performance was evaluated via closed-loop cross-flow filtration using Na_2SO_4 as a model salt **(Fig. 5A)**. Consistent with dead-end filtration results, a clear inverse relationship between PIP concentration and water flux was observed. At low PIP concentration (0.1 wt.%), the water flux reached 136.1 ± 8.7 LMH, approximately 184% higher than the conventional membrane (47.9 ± 6.2 LMH) and 25.5% higher than the NF270 benchmark (108.4 ± 5.8 LMH). These high permeabilities are primarily attributed to the thinner selective layers formed at low PIP concentrations, as evidenced by cross-sectional TEM **(Fig. 5E$_1$–E$_3$)**, which showed that the membrane prepared with low PIP concentration (0.1 wt.%) formed a ~15 nm layer, compared to the thicker (~92 nm), nonuniform film observed in the conventional membrane [47]. Cross-sectional FESEM images **(Fig. 5D$_1$–D$_3$)** showed a comparable difference in polyamide thickness, in agreement with the TEM observations. AFM results **(Fig. 5F)** revealed a smoother surface (R_a: 54.5 nm) for the CTFD membrane (C-0.1), compared to the conventional membrane (R_a: 88.9 nm). The reduced roughness likely reflects moderated local monomer excess and more uniform early-stage interfacial polymerization under centrifugal deposition. Top-view

FESEM images **(Fig. 5C_1–C_3)** also showed minimal ridge formation at low PIP loading, in contrast to the rough, ridge-rich surface of the conventional membrane. Collectively, the thin and smooth layer formed at lower monomer concentrations likely reduced transport resistance and facilitated water passage [43,48].

As PIP concentration increased, water flux declined steadily, dropping to 61.8 ± 10.9 LMH at 2 wt.%, approximately 54.6% lower than the flux observed at 0.1 wt.% PIP. TEM analysis of the membrane prepared with 2 wt.% PIP revealed a thicker (~47 nm) film. Supplementary data **(Fig. S6E_1–E_5** and **Table S1, SI)** showed a monotonic increase in film thickness with increasing PIP concentration, likely driven by intensified monomer reactivity and crosslinking. AFM analysis revealed a non-monotonic roughness trend with R_a peaking at ~0.5 wt.% PIP before declining at higher loadings (R_a: 58.3 nm at 2 wt.%), likely due to smoother polyamide deposition once surface reactivity became saturated, limiting further ridge development [49].

To further assess filtration performance, the optimized CTFD membrane (0.1 wt.% PIP) and the conventional membrane were evaluated in cross-flow filtration using individual $MgSO_4$, $CaCl_2$, and NaCl as representative divalent and monovalent salts. The CTFD membrane exhibited more than twice the water flux of the conventional membrane across all three salts **(Fig. 5B)**, reflecting its thin, smooth, and uniform selective layer.

The crosslinking and morphological differences help explain the observed trends in salt rejection **(Fig. 5A and B)**. For Na_2SO_4, rejection remained high at ~93–94.5% across low to moderate PIP concentrations, suggesting that even with reduced apparent crosslinking, the thin selective layers maintained sufficient structural integrity to reject sulfate ions effectively. Sulfate behaves as the co-ion and experiences strong Donnan exclusion because of its divalent charge and hydrated nature, making its transport through the negatively charged polyamide layer unfavorable. The slight decrease in Na_2SO_4 rejection to ~90.3% for the membrane fabricated at 2 wt.% PIP, despite its higher apparent crosslinking degree, indicates that sulfate rejection was not governed by crosslinking degree alone. At excessive PIP concentration, the IP reaction may proceed too rapidly, promoting polyamide overgrowth and a more

pronounced ridge-structured morphology, which may generate a less favorable nanoscale selective network despite the thicker and more crosslinked average structure [38,50]. $MgSO_4$ rejection decreased moderately (from 98.1 % in the conventional membrane vs. 84.9 % in the CTFD membrane). In contrast to Na_2SO_4, Mg^{2+} can reduce the effective electrostatic exclusion of sulfate by locally screening membrane charge and changing the Donnan potential within the active layer. $MgSO_4$ rejection is thus more sensitive to the morphology and thickness of the selective layer [51].

For $CaCl_2$, the rejection decline was more pronounced (85.47% for the conventional membrane vs. 17.83% for the CTFD membrane). $CaCl_2$ behaves differently because the co-ion is now Cl^-, which is monovalent and therefore experiences much weaker Donnan exclusion than sulfate. Once co-ion exclusion is weak, any reduction in size exclusion mechanisms can cause a large increase in $CaCl_2$ passage [52]. Furthermore, zeta potential measurements **(Fig. S7)** showed that both the conventional and C-0.1 membranes remained negatively charged across the tested pH range, with the C-0.1 membrane exhibiting slightly more negative values than the conventional membrane. This indicates that the lower $MgSO_4$ and $CaCl_2$ rejection of C-0.1 did not arise from loss of surface charge. Instead, the results support a combined mechanism in which preserved electrostatic exclusion maintains sulfate rejection, whereas the thinner and lower-crosslinked selective layer exerts a stronger influence on salts subject to weaker Donnan exclusion. In contrast, NaCl rejection was enhanced modestly, increasing from 24.97% for the conventional membrane to 37.6% for the CTFD membrane. For NaCl, size- and charge-based discrimination is weak because both ions are small and monovalent. The measured NaCl rejection is therefore strongly influenced by defect-mediated transport, e.g., pinholes, locally under-formed regions, ridge–valley hot spots, and other non-selective pathways. A thinner but more uniform film can thus reject NaCl better than a more heterogeneous film [38 48].

High-Recovery and Fouling Performance

To further assess performance under practical desalination conditions, both the conventional and CTFD membranes were tested in a high-recovery, open-loop cross-flow filtration system. As shown in **Fig.**

6A, B, D, and E, measured flux, observed rejection, and salt concentrations were monitored as cumulative permeate volume and system recovery increased. The CTFD membrane exhibited a high initial flux (~103 LMH), which gradually declined as osmotic pressure and concentration polarization increased in the open-loop filtration setup [8]. Despite this moderate decline at higher recoveries, the CTFD membrane consistently maintained a higher flux than the conventional membrane (~47.6 LMH initially), which remained relatively stable throughout the test **(Fig. 6A)**, highlighting the advantage of the ultrathin and uniform polyamide layer, which, despite its lower apparent crosslinking degree, maintained adequate selectivity while reducing transport resistance.

For observed rejection **(Fig. 6B)**, both membranes maintained high Na_2SO_4 rejection (>85%) throughout the test. The conventional membrane showed a slight upward trend, increasing from roughly 90.6% to ~96.8%, indicating a gradual enhancement in rejection attributed to reduced effective pore size as the test progressed, due to compaction and reduced electrostatic swelling at higher ionic strength. In contrast, the CTFD membrane showed greater variability, with rejection decreasing from 95.8% to 88% before partially recovering to 89.8%, due to a different balance among concentration polarization, osmotic pressure rise, and mechanical compaction. A smoother, more uniform film should distribute transmembrane pressure more evenly, avoiding localized stress at thin ridge valleys. While this would not reduce compaction per se, it may reduce localized over-compaction of the smoother film obtained through CTFD. As shown in **Fig. 6D**, retentate salt concentration increased with cumulative permeate volume for both membranes, reflecting progressive feed concentration. However, the conventional membrane exhibited a steeper rise, reaching ~20 g/L compared to ~13 g/L for the CTFD membrane, consistent with its lower water flux and slower dilution of retained salts. **Fig. 6E** shows that permeate salt concentration remained generally low for both membranes but was slightly higher for the CTFD membrane, particularly at higher recoveries (≥60%), indicating a modest trade-off between its enhanced permeability and ion selectivity. Overall, the CTFD membrane maintained a more stable and elevated flux while sustaining high rejection

performance and suitable permeate quality, demonstrating superior hydraulic performance and reduced concentration polarization, despite minor selectivity fluctuations at higher recoveries.

To verify the structural stability of the ultrathin C-0.1 selective layer after high-recovery operation, post-mortem TEM and AFM analyses were performed before and after Na_2SO_4 high-recovery test **(Fig. S8, SI)**. Cross-sectional TEM confirmed that the C-0.1 polyamide layer remained continuous and retained its ultrathin thickness after testing, with no obvious delamination, collapse, or measurable thinning in the examined regions. AFM analysis further showed that the C-0.1 surface did not undergo roughening after high-recovery filtration. These post-mortem results support that the observed flux and rejection variations were mainly associated with transport-related effects, including concentration polarization, increased osmotic pressure, and possible compaction, rather than selective-layer damage.

The fouling behavior of the conventional and CTFD membranes was preliminarily assessed using sodium alginate as a model foulant. As shown in **Fig. 6C**, the CTFD membrane exhibited full flux recovery after low-pressure hydraulic cleaning, indicating minimal irreversible foulant adhesion and enhanced flux due to the removal of weakly bound foulants [53]. Because the operating pressure for each membrane was adjusted to achieve the same initial flux, differences in fouling behavior can be attributed primarily to surface and structural properties rather than hydraulic loading. The high flux recovery ratio of the CTFD membrane indicates that foulant accumulation was predominantly reversible, suggesting weak foulant adhesion and limited pore or surface blockage. This behavior is consistent with the smooth and structurally uniform polyamide layer formed via the CTFD technique, which reduced the presence of localized high-flux regions and surface valleys that may act as fouling initiation sites. [54-57] [3]. To further address fouling resistance under a more representative organic-fouling condition, an additional mixed-foulant test was conducted using sodium alginate, bovine serum albumin, and humic acid in the presence of NaCl and $CaCl_2$ **(Fig. S9, SI)**. The C-0.1 membrane again showed substantially improved fouling reversibility, with an FRR of 99.4% and irreversible fouling of only 0.6%, compared with 83.5% FRR and 16.5% irreversible fouling

for the conventional membrane. These results confirm that the improved antifouling behavior of C-0.1 was retained under a more complex synthetic organic-fouling challenge.

Discussion

In conclusion, this work demonstrates CTFD as a simple aqueous-phase delivery step to improve the uniformity of IP-formed polyamide layers in NF membranes. By controlling PIP distribution before reaction with TMC, CTFD produced thinner and smoother selective layers and enabled systematic tuning by centrifugal force and PIP concentration. Under the optimized condition (0.1 wt.% PIP, 3.198 kg m/s^2), the membrane delivered high flux (~136 LMH at 6 bar) with high Na_2SO_4 rejection. Importantly for desalination and reuse applications, performance was evaluated beyond initial flux–rejection: (i) in sodium alginate fouling tests, the CTFD membrane showed full flux recovery after mild hydraulic cleaning, indicating predominantly reversible fouling consistent with a smoother, more uniform surface; and (ii) in high-recovery cross-flow operation with increasing Na_2SO_4 concentration, the CTFD membrane sustained substantially higher flux than the conventional membrane while maintaining >85% observed rejection. Molecular dynamics simulations supported the mechanism by indicating centrifugal confinement of PIP near the interface, consistent with the reduced heterogeneity observed experimentally. While the present CTFD configuration is batch-based, the underlying principle of force-regulated monomer confinement is compatible with emerging coating-assisted and roll-to-roll interfacial polymerization strategies, providing a pathway toward scalable membrane fabrication [58-60]. Overall, CTFD provides a practical route to improve fouling reversibility and high-recovery robustness under sulfate-dominated nanofiltration conditions, while also highlighting the permeability–selectivity tradeoff that can emerge for salts such as $MgSO_4$ and $CaCl_2$ when ultrathin, lower-crosslinked polyamide layers are formed.

Methods

Materials

PIP (>99%) anhydrous, TMC (>98%), triethylamine (TEA), and n-hexane (>95%) were purchased from Sigma-Aldrich for the synthesis of the polyamide selective layer by IP reaction. A commercial PES membrane (Sterlitech Co., pore size 0.03 µm, thickness 110–150 µm) was used as received. A commercial NF270 membrane (DuPont, DE, USA) was purchased and used as a benchmark for performance comparison. Sodium sulfate (Na_2SO_4, 99.5%), sodium chloride (NaCl, >99.5%), calcium chloride ($CaCl_2$, 96%), magnesium sulfate ($MgSO_4 \cdot 6H_2O$, 99%), sodium bicarbonate ($NaHCO_3$), and sodium alginate ($NaC_6H_7O_6$) were also purchased from Sigma-Aldrich and used to prepare the feed solutions for filtration tests. All solutions and rinsing steps were prepared using deionized (DI) water.

Membrane Fabrication and Characterization

The conventional TFC membrane (control) was fabricated on a commercial PES substrate. The substrate was immersed in an aqueous amine solution containing 2 wt.% PIP and 0.4 wt.% TEA, in DI water for two minutes. TEA concentration was kept constant at 0.4 wt.% across all membranes to isolate the effects of PIP concentration and centrifugal force, which were the only variables investigated in this study. TEA served as an acid scavenger to neutralize the HCl generated during the IP reaction, and maintaining a constant concentration minimized additional effects on polyamide formation [61]. After immersion, the excess amine solution was removed using a rubber roller three times. The membrane was subsequently immersed in n-hexane containing 0.1 wt.% TMC, and left for 30 seconds to allow for the formation of the polyamide selective layer via IP reaction. The resulting membrane was heat-treated at 70°C for 10 minutes to promote crosslinking and stabilize the polyamide network.

For the fabrication of CTFD membranes, a commercial PES substrate was first fixed onto the stationary disc of a coating device **(Fig. S1, SI)**. To investigate the effect of centrifugal force, an aqueous solution containing various concentrations of PIP at the selected concentrations, with TEA fixed at 0.4

wt.%, was deposited onto the substrate. Then, the disc was set into rotation to enable centrifugal spreading. Once the desired centrifugal force was applied, it spread the aqueous monomer solution radially outward, promoting uniform monomer distribution and efficient removal of excess solution without the need for mechanical rolling. Following centrifugal deposition, the membrane was immediately immersed in an organic solution comprising 0.1 wt.% TMC dissolved in n-hexane for 30 seconds to initiate the IP reaction. After polymerization, the membrane underwent thermal treatment at 70 ℃ for 10 minutes to enhance crosslinking and ensure structural stability. All fabricated membranes were then stored in DI water at 4 °C for further characterization and performance evaluation. **Fig. 7** presents the schematic illustration of the IP process utilized for fabricating polyamide membranes. In this study, the centrifugal force values (kg m/s^2) and PIP concentration were considered as variables to fully optimize the CTFD Process **(Table S2, SI).**

The surface and cross-sectional morphology of the membranes were examined using field-emission scanning electron microscopy (FESEM; Apreo, Thermo Fisher Scientific, USA) equipped with an energy-dispersive X-ray (EDX) spectrometer, operated at 30 kV. Before imaging, the membranes were coated with a 5 nm gold layer using a sputter coater (Leica EM ACE600, USA). Transmission electron microscopy (TEM; Philips/FEI Morgagni 268, USA) was used to analyze the cross-sectional morphology of the membranes. The surface chemistry of the membranes was investigated using X-ray photoelectron spectroscopy (XPS) using a Kratos AXIS ULTRA system. The surface topography was characterized using atomic force microscopy (AFM; Bruker Dimension Icon, USA) over a 10 µm × 10 µm area. Moreover, the roughness parameters (average roughness, R_a, and root-mean-square roughness, RMS) were calculated using Gwyddion software, version 2.62. Zeta potential was determined using Anton Paar SurPASS electrokinetic solid surface potential analyzer (Anton Paar USA, Ashland, VA).

Filtration Experiments

Membrane performance was assessed using both dead-end and cross-flow filtration systems. Dead-end tests were performed at five bar using a stirred cell (47 mm diameter) and 1000 mg/L solutions of Na_2SO_4, $MgSO_4$, and NaCl. Membranes were pre-compacted with DI water at six bar for 30 minutes

before testing. Although membranes fabricated at lower centrifugal forces exhibited comparable rejection performance, operation at 3.198 kg m/s^2 yielded the most consistent flux and rejection across replicate samples. Therefore, this value was chosen as the baseline centrifugal force for systematic evaluation under cross-flow conditions, where operational stability and reproducibility are critical. Cross-flow filtration was performed using a lab-scale system with a 22 cm^2 membrane cell. The cross-flow rate was one LPM, the operating pressure was six bar, and the feed temperature was maintained at 25 ± 1 °C. Membranes were pre-compacted at eight bar for six hours. Permeate flux (J_W) and salt rejection were measured using 1000 mg/L aqueous solutions of Na_2SO_4, $MgSO_4$, $CaCl_2$, and NaCl. Permeate flux was calculated using [8]:

$$J_W = {}^{V}/_{A\,t} \quad (1)$$

where J_W is the saltwater flux (LMH), V is the volume of permeate collected (L), A is the effective membrane area (m^2), and t is the filtration time (h). Salt rejection was calculated as [8]:

$$R = 1 - {}^{c_p}/_{c_f} \quad (2)$$

where C_f and C_p are the solute concentrations (mg/L) in the feed and permeate, respectively. Tests were performed in closed-loop (no recovery, 24 h) and open-loop (high recovery, 60 h) modes.

Fouling experiments were conducted using 200 mg/L sodium alginate in a solution containing 950 mg/L NaCl, 50 mg/L $CaCl_2$, at pH 7.0, following protocols from our previous studies [62,63]. To further evaluate fouling resistance under a more complex organic-fouling condition, mixed-organic-foulant tests were also performed using sodium alginate, bovine serum albumin, and humic acid in the presence of NaCl and $CaCl_2$, as described in **Fig. S9, SI** [64]. The operating pressure for each modified membrane was adjusted to match the initial flux of the control membrane. Pressure normalization ensures differences in fouling behavior arise from surface properties rather than hydraulic loading. Tests were run for 96 hours at one LPM in a cross-flow system. Afterward, membranes were washed with DI water under one bar pressure for 1 hour. Permeate flux during fouling (J_{w1}) and pure water fluxes before fouling (J_{w0}) and after cleaning (J_{w2}) were recorded. To assess the antifouling performance, the following parameters were calculated: flux

recovery ratio (FRR), reversible fouling resistance (R_r), irreversible fouling resistance (R_{ir}), and total flux decline ratio (R_t). Fouling parameters were calculated using the following equations [63]:

$$FRR\ (\%) = \left(\frac{J_{W2}}{J_{W0}}\right) \times 100 \quad (3)$$

$$R_r\ (\%) = \left(\frac{J_{W2} - J_{W1}}{J_{W0}}\right) \times 100 \quad (4)$$

$$R_{ir}\ (\%) = \left(\frac{J_{W0} - J_{W2}}{J_{W0}}\right) \times 100 \quad (5)$$

$$R_t\ (\%) = R_r + R_{ir} = \left(\frac{J_{W0} - J_{W1}}{J_{W0}}\right) \times 100 \quad (6)$$

Molecular Dynamics Simulations of Thin Film Deposition

Atomistic MD simulations were performed using LAMMPS to compare the relative spatial distribution of PIP near the PES substrate under gravity-driven and centrifugal deposition conditions during the pre-reaction stage of the IP [65]. Because the model was intended to isolate deposition-driven monomer transport, explicit solvent molecules and the PIP–TMC polymerization reaction were not included. Therefore, the results are interpreted as qualitative mechanistic support rather than a quantitative representation of the full IP process or final polyamide structure. Molecular structures of PIP and PES were initially constructed in ArgusLab and subsequently packed into a simulation box using Packmol, ensuring realistic atomic ratios and spatial distributions. The assembled system was then processed in the Visual Molecular Dynamics (VMD 1.9) using its TKConsole extension to generate LAMMPS-compatible input files. Topology generation and force field assignments were performed using the TopoTools plugin.

The final system consisted of a rigid, atomistically modeled PES substrate and an overlying layer of PIP monomers. The simulation box dimensions were 201 Å × 201 Å × 101 Å, comprising 17,600 atoms. Periodic boundary conditions were applied in the ***x*** and ***y*** directions, with fixed boundaries in the ***z*** direction. Implicit repulsive walls were added at the top and bottom to confine atoms and prevent escape along the ***z***-axis. All atomic interactions were described using the OPLS-AA force field. Lennard-Jones (LJ) and

Coulombic interactions, specified via lj/cut/coul/cut pair style, with cutoffs of 12 Å and 8 Å, respectively [66]. Bonded interactions, including bonds, angles, and dihedrals, were defined according to the molecular connectivity of the PIP monomer and PES.

Two deposition scenarios were modeled to compare the monomer's fate at the interface under different deposition conditions. In the conventional mode, only gravitational acceleration was considered. PIP monomers underwent Brownian motion and diffused toward the substrate solely under the influence of gravity, simulating a dip-coating deposition. In the centrifugal deposition mode, a radially outward force proportional to atomic position was applied to a predefined group of PIP atoms to emulate centrifugal acceleration during membrane fabrication. This setup simulated the enhanced radial transport of monomers away from the rotational center. Each system was equilibrated using the NVT ensemble at 300 K using the Nosé–Hoover thermostat, at a timestep of 1 fs over a total simulation time of 5 ns [67]. Trajectories were recorded every 100 steps to capture the evolution of monomer spatial distribution. Visualization and post-processing were conducted using OVITO, including top-view, cross-sectional, and 3D renderings of monomer arrangements. Comparative analysis of the two scenarios focused on evaluating monomer coverage, spatial uniformity, and deposition dynamics across the substrate. Additional simulation parameters and force group definitions are detailed in **Table S3, SI**.

Declaration Statements

Data Availability

The datasets generated and/or analyzed during the current study are not publicly available due to file-size limitations and because they are maintained as internal research records, but are available from the corresponding author on reasonable request.

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Author Contributions

M.D.F , H.J. and N.B. conducted the membrane fabrication and performance experiments. S.A.A., S.E.M. and Z.Z. performed characterization tests and data interpretation. Y.M. contributed to the conceptual design. A.A.S. and A.R. provided theoretical insights and guidance on polyamide formation chemistry. S.N. and A.T. contributed to analysis of membrane transport mechanisms and manuscript editing. M.S. supervised the membrane fabrication and performance testing. M.E. supervised the environmental engineering aspects and guided the overall experimental design. M.D.F. conceptualized the study, coordinated the collaboration across institutions, processed and analyzed data, and wrote the main manuscript text with input from all co-authors. All authors reviewed and approved the final manuscript.

Competing Interests

The authors declare no competing financial or non-financial interests.

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Figure Legends

Fig. 1. Morphological, topographical, and surface chemical characterization of polyamide membranes fabricated with varying piperazine (PIP) concentrations and centrifugal forces (B-0.5, B-3, A-2, and D-2). (A_1–A_4) Top-view FESEM images showing textured morphology of diffusion-limited interfacial polymerization (IP). **(B_1–B_4)** Cross-sectional TEM images illustrating the formation of thin polyamide selective layers across all CTFD membranes. Thicker layers appeared at higher PIP concentrations, while higher centrifugal forces yielded slightly thinner films. **(C)** Schematic illustration of the PES substrate showing the application of various centrifugal forces during deposition and the formation of the polyamide selective layer on top. **(D_1 and D_2)** Quantitative analysis of polyamide layer thickness obtained from TEM images using ImageJ, corroborating the observed trend of increasing thickness with PIP concentration and slight reduction with higher centrifugal forces. **(D_3 and D_4)** AFM analysis showing minor roughness variations with increasing PIP concentration (R_a: 45.8–47.6 nm) and negligible changes across different

centrifugal forces ($R_a \approx 44$ nm). **(E_1–E_4)** High-resolution C 1s spectra deconvoluted into peaks for C=C/C–C/C–N, C–O, and C–N/C–O, indicating amide bond formation across all fabrication conditions.

Fig. 2. Molecular dynamics simulation. Final distribution of piperazine (PIP) monomers on the polyethersulfone (PES) substrate after molecular dynamic simulation for CTFD and conventional techniques. The centrifugal deposition configuration appeared to promote enhanced monomer uniformity and surface coverage compared to the disordered distribution observed in the conventional approach.

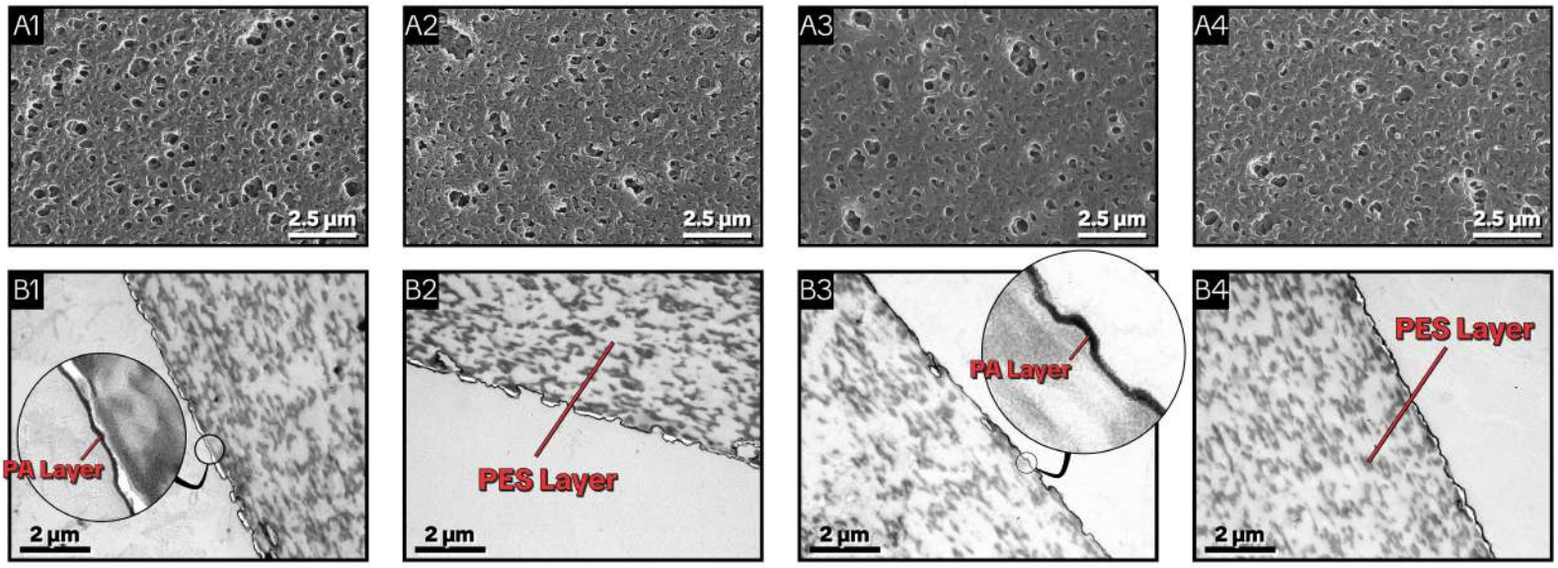
Fig. 3. Dead-end filtration performance of TFC membranes under varying fabrication parameters. (A_1–A_4) Normalized water flux and salt rejection for Na_2SO_4, $MgSO_4$, and NaCl as a function of piperazine (PIP) concentration at fixed centrifugal forces. **(B_1–B_4)** Normalized water flux and salt rejection for Na_2SO_4, $MgSO_4$, and NaCl as a function of centrifugal force at fixed PIP concentrations. Increasing PIP concentration decreased flux but enhanced rejection, whereas increasing centrifugal force generally improved flux, with rejection trends depending on salt type and PIP loading.

Fig. 4. Surface chemistry analysis of the conventional, C-0.1, and C-2 membranes, respectively. Deconvoluted high-resolution XPS spectra of **(A_1–A_3)** C 1s, **(B_1–B_3)** O 1s, and **(C_1–C_3)** N 1s show the characteristic chemical bonding associated with amide formation.

Fig. 5. Filtration performance and structural analysis of membranes fabricated under a centrifugal force of 3.198 kg m/s^2 with varying piperazine (PIP) concentrations. (A) Water flux and Na_2SO_4 rejection for all membranes. **(B)** Salt water flux and rejection for other salts ($MgSO_4$, $CaCl_2$, and NaCl) were evaluated only for the conventional membrane and the optimized CTFD membrane (C-0.1). **(C_1–C_3)** Top-view FESEM images for the conventional, C-0.1, and C-2 membranes, respectively, showing smoother, less textured surfaces at lower PIP loadings (e.g., 0.1 wt.%) and ridge-like patterns at higher concentration (2 wt.%); **(D_1–D_3)** Cross-sectional FESEM images and **(E_1–E_3)** cross-sectional TEM images for the conventional, C-0.1, and C-2 membranes, respectively, showing a significantly thinner selective layer for membrane fabricated at 0.1 wt.% (14.7 nm) versus the conventional membrane (91.7 nm); **(F)** AFM parameters showing reduced surface roughness for membrane fabricated at 0.1 wt.% compared to conventional membrane, with corresponding R_a and RMS values.

Fig. 6. (A, B, D, and E) High-recovery open-loop cross-flow filtration performance of conventional and CTFD membranes using Na_2SO_4 feed solution. **(A)** Measured flux as a function of recovery, showing the higher and more stable flux of the CTFD membrane compared to the conventional one. **(B)** Observed rejection as a function of cumulative permeate volume, where the conventional membrane exhibits a gradual increase in rejection while the CTFD membrane shows minor variability. **(C)** Antifouling performance of the conventional and CTFD membranes during sodium alginate (200 mg/L) filtration, showing fouling parameters following a complete low-pressure cleaning cycle. **(D)** Retentate salt concentration as a function of cumulative permeate volume, illustrating faster concentration buildup for the conventional membrane. **(E)** Permeate salt concentration as a function of recovery, showing slightly higher values for the CTFD membrane at elevated recoveries due to its higher permeability.

Fig. 7. Fabrication process for a polyamide thin-film composite (TFC) membrane. A polyethersulfone (PES) substrate is first coated with an aqueous piperazine (PIP) solution, followed by contact with an organic phase containing trimesoyl chloride (TMC) at the interface, where interfacial polymerization occurs. The reaction between PIP and TMC forms a crosslinked polyamide network with HCl as a byproduct, resulting in the formation of a polyamide selective layer at the top of the PES support. Moreover, a schematic illustration of the CTFD process is compared with conventional dip-coating. In CTFD, centrifugal acceleration drives radial spreading and rapid excess-liquid removal, promoting uniform lateral coverage and more controlled interfacial polymerization.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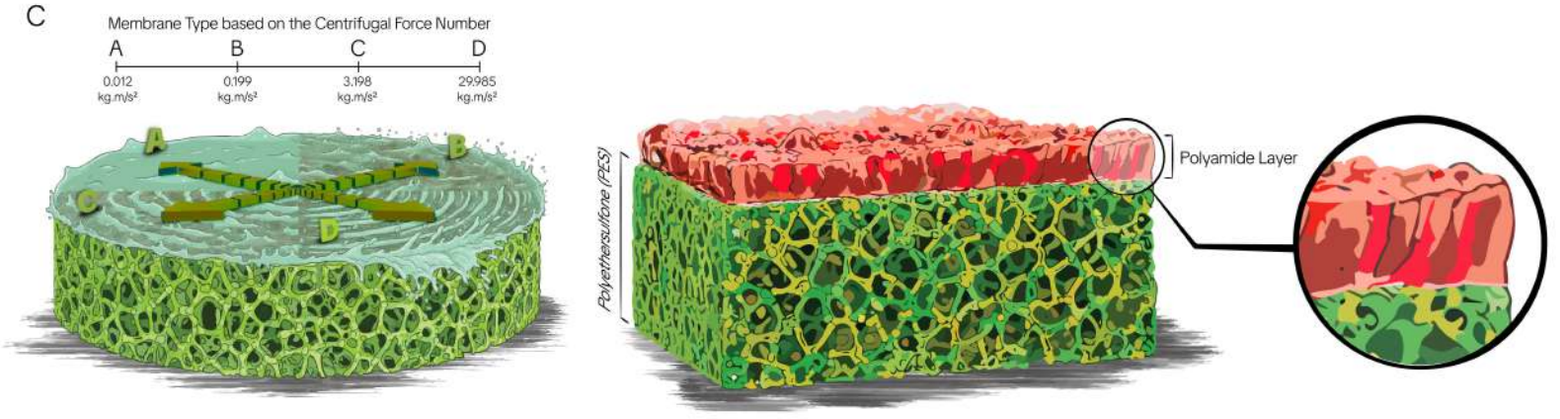
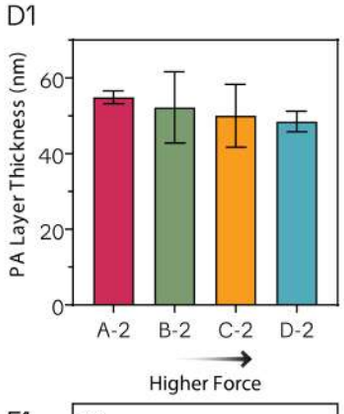
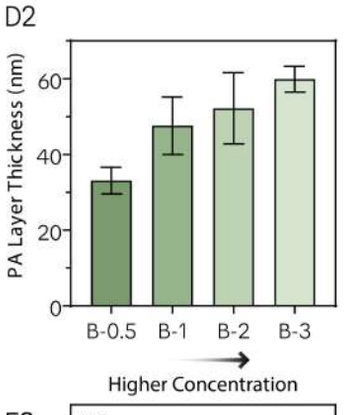
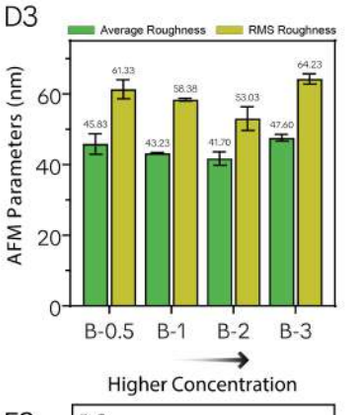
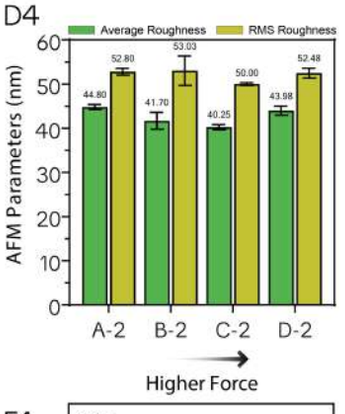
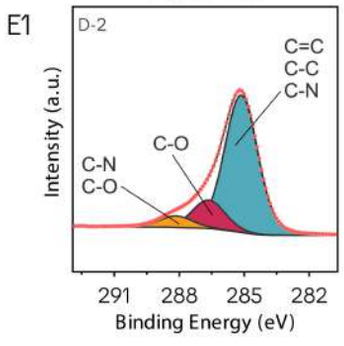

C
Membrane Type based on the Centrifugal Force Number
A
0.012 kg.m/s²
B
0.199 kg.m/s²
C
3.198 kg.m/s²
D
29.985 kg.m/s²
Polyethersulfone (PES)
Polyamide Layer

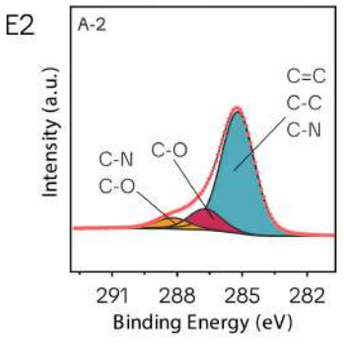

D1
PA Layer Thickness (nm)
A-2
B-2
C-2
D-2
Higher Force

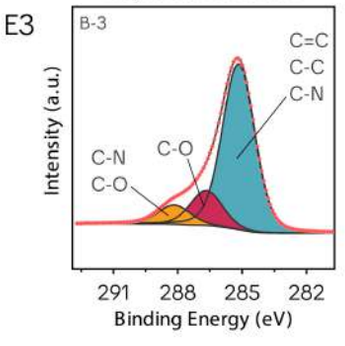

D2
PA Layer Thickness (nm)
B-0.5
B-1
B-2
B-3
Higher Concentration

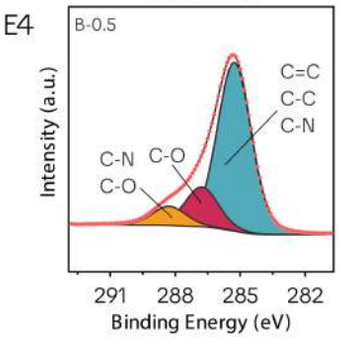

D3
Average Roughness
RMS Roughness
AFM Parameters (nm)
45.83
61.33
43.23
58.38
41.70
53.03
47.66
64.23
B-0.5
B-1
B-2
B-3
Higher Concentration

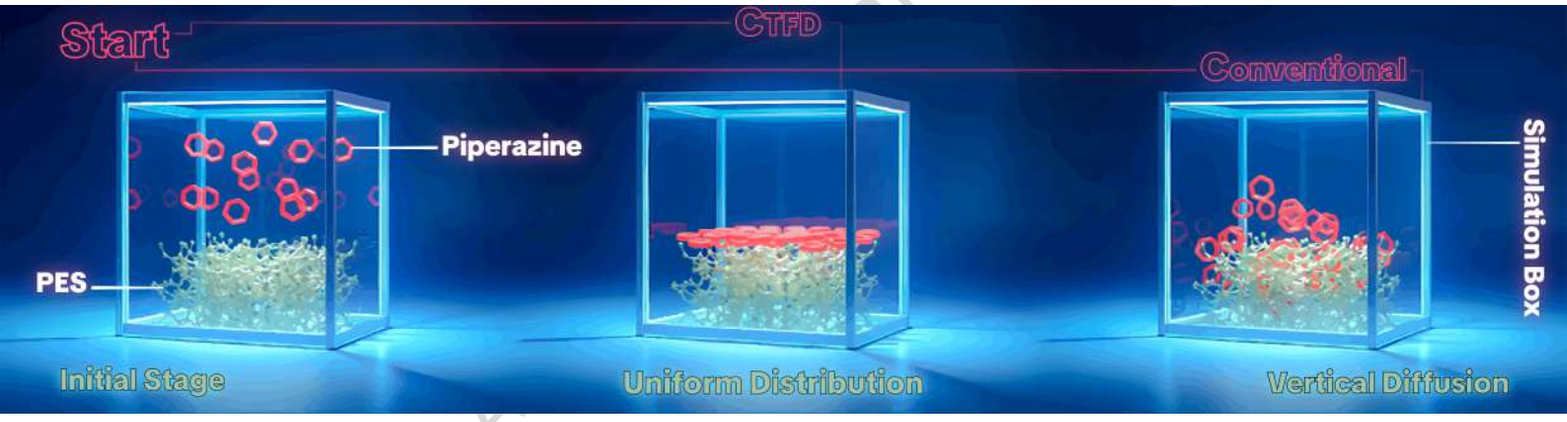

D4
Average Roughness
RMS Roughness
AFM Parameters (nm)
44.80
52.80
41.70
53.03
40.25
50.00
43.98
52.48
A-2
B-2
C-2
D-2
Higher Force

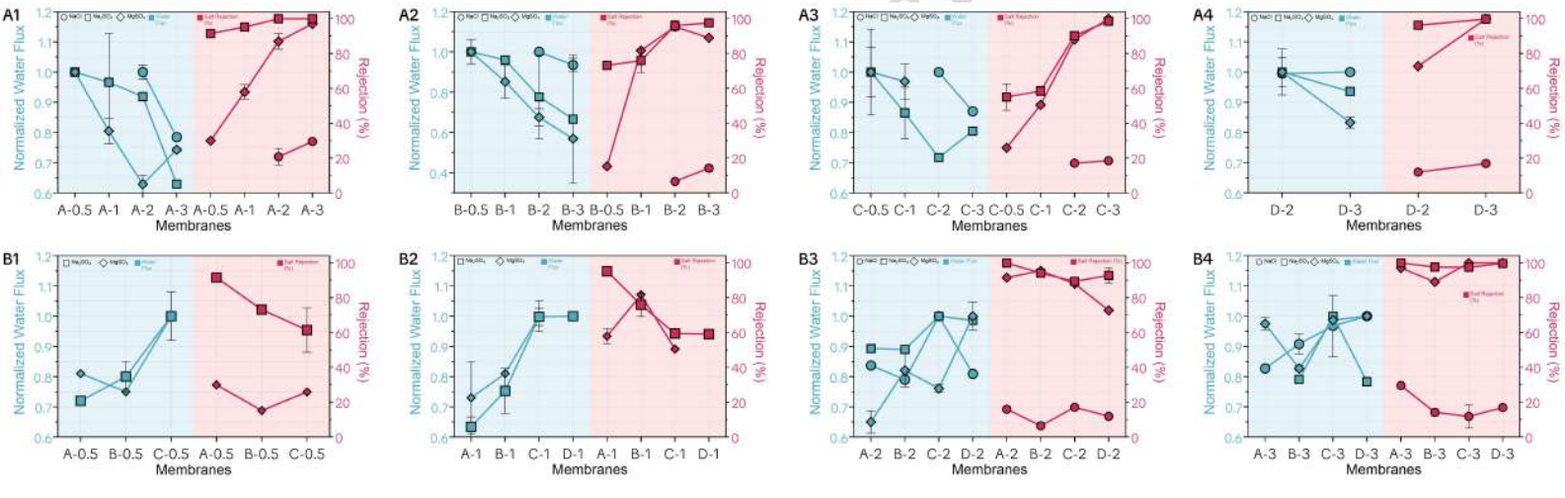

E1
D-2
Intensity (a.u.)
C=C
C-C
C-N
C-O
C-N
C-O
291
288
285
282
Binding Energy (eV)

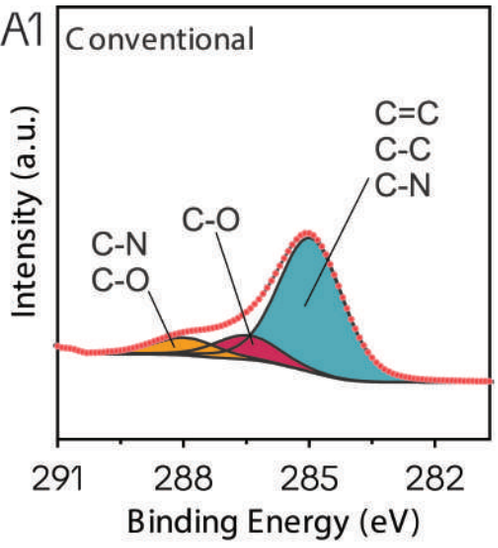

E2
A-2
Intensity (a.u.)
C=C
C-C
C-N
C-N
C-O
291
288
285
282
Binding Energy (eV)

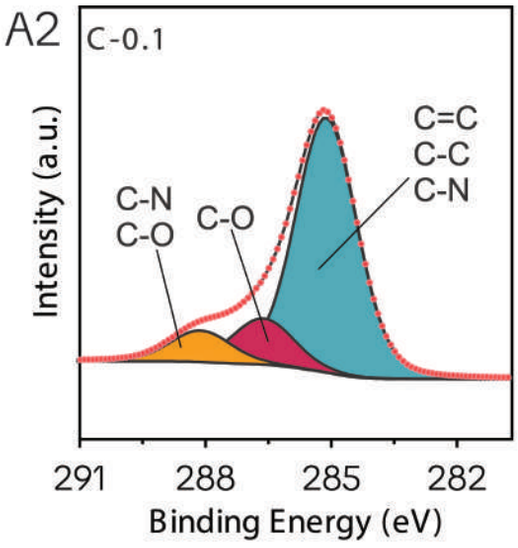

E3
B-3
Intensity (a.u.)
C=C
C-C
C-N
C-N
C-O
291
288
285
282
Binding Energy (eV)

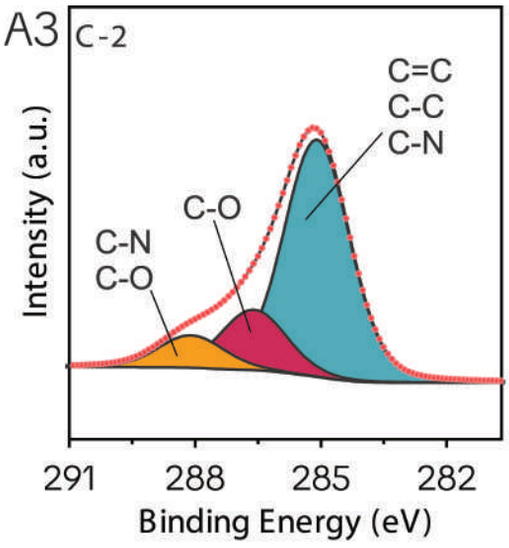

E4
B-0.5
Intensity (a.u.)
C=C
C-C
C-N
C-N
C-O
291
288
285
282
Binding Energy (eV)

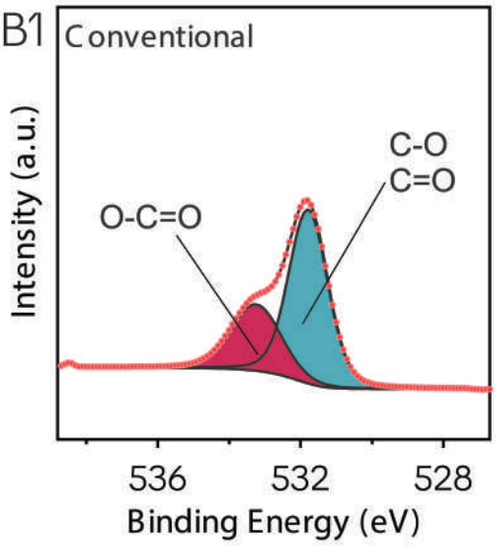

Start
CTFD
Conventional
Piperazine
PES
Simulation Box
Initial Stage
Uniform Distribution
Vertical Diffusion

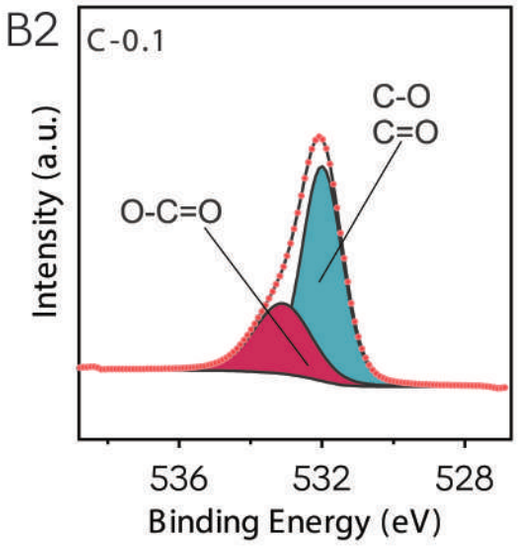

A1
A2
A3
A4
B1
B2
B3
B4
Normalized Water Flux
Rejection (%)
Membranes
A-0.5 A-1 A-2 A-3 A-0.5 A-1 A-2 A-3
B-0.5 B-1 B-2 B-3 B-0.5 B-1 B-2 B-3
C-0.5 C-1 C-2 C-3 C-0.5 C-1 C-2 C-3
D-2 D-3 D-2 D-3
A-0.5 B-0.5 C-0.5 A-0.5 B-0.5 C-0.5
A-1 B-1 C-1 D-1 A-1 B-1 C-1 D-1
A-2 B-2 C-2 D-2 A-2 B-2 C-2 D-2
A-3 B-3 C-3 D-3 A-3 B-3 C-3 D-3

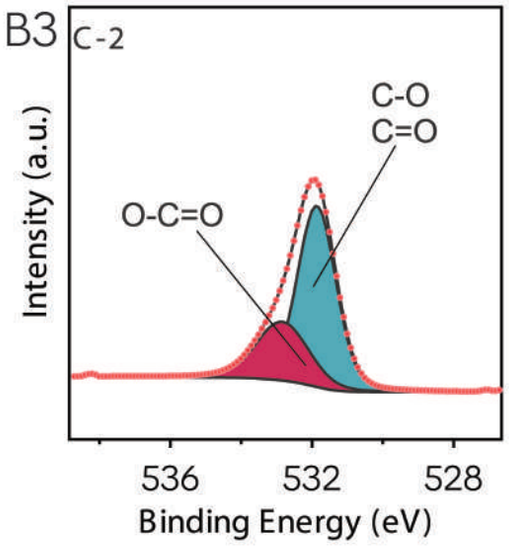

A1
Conventional
C=C
C-C
C-N
C-O
C-N
C-O
Intensity (a.u.)
291
288
285
282
Binding Energy (eV)

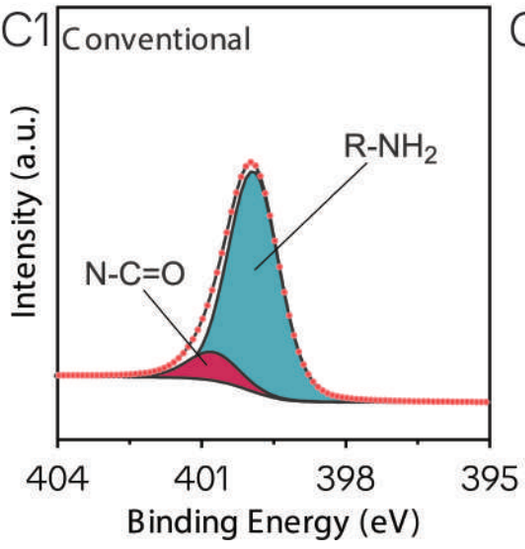

A2
C-0.1
C=C
C-C
C-N
C-N
C-O
C-O
Intensity (a.u.)
291
288
285
282
Binding Energy (eV)

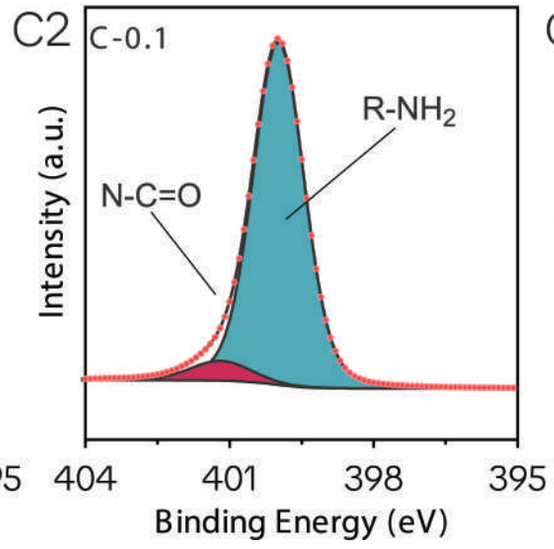

A3
C-2
C=C
C-C
C-N
C-O
C-N
C-O
Intensity (a.u.)
291
288
285
282
Binding Energy (eV)

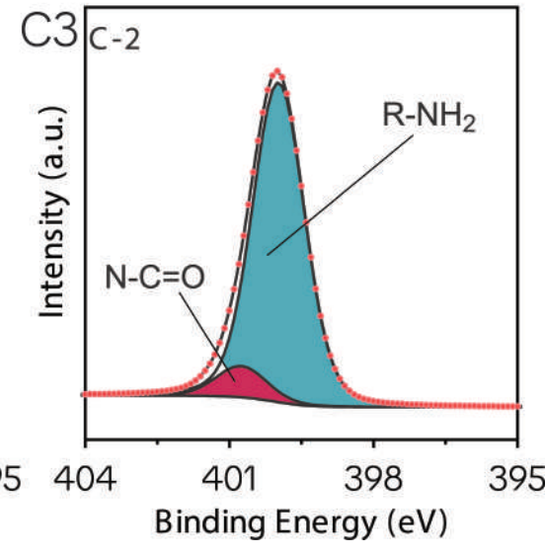

B1
Conventional
C-O
C=O
O-C=O
Intensity (a.u.)
536
532
528
Binding Energy (eV)

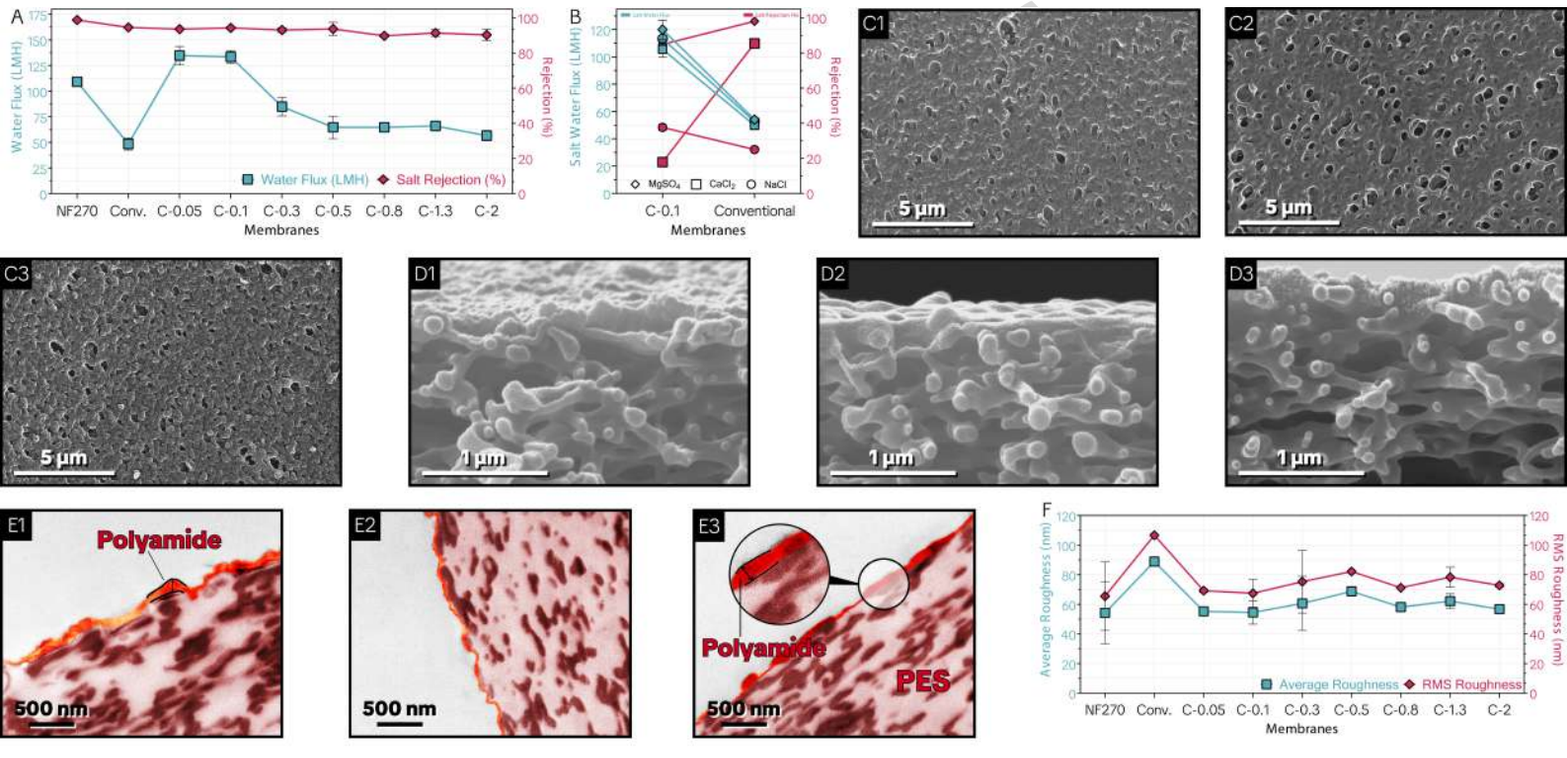

B2
C-0.1
C-O
C=O
O-C=O
Intensity (a.u.)
536
532
528
Binding Energy (eV)

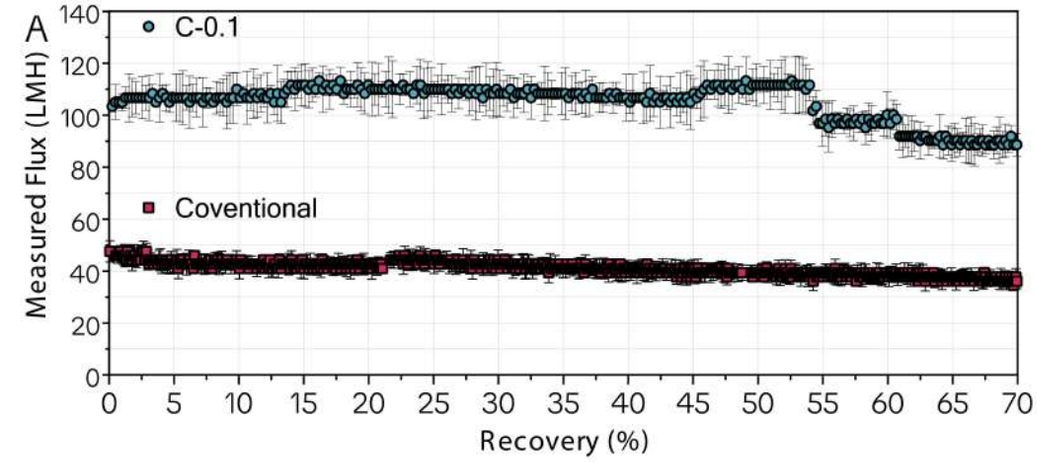

B3
C-2
C-O
C=O
O-C=O
Intensity (a.u.)
536
532
528
Binding Energy (eV)

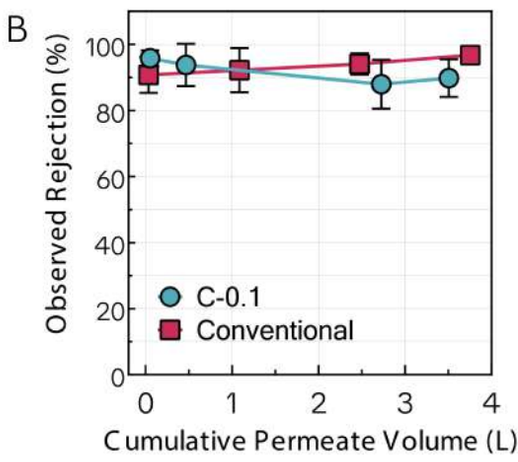

C1
Conventional
R-NH2
N-C=O
Intensity (a.u.)
404
401
398
395
Binding Energy (eV)

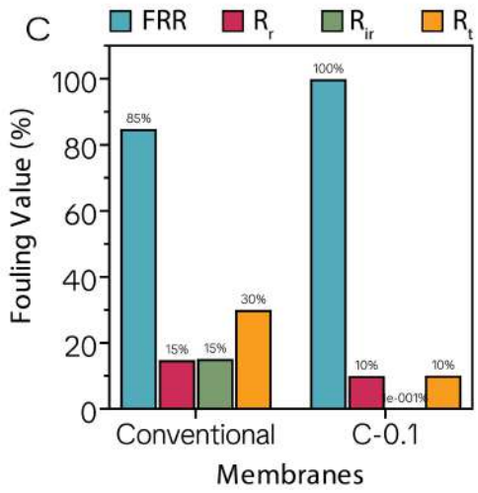

C2
C-0.1
R-NH2
N-C=O
Intensity (a.u.)
404
401
398
395
Binding Energy (eV)

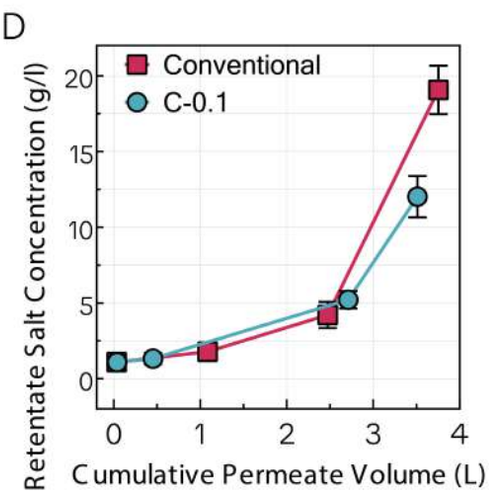

C3
C-2
R-NH2
N-C=O
Intensity (a.u.)
404
401
398
395
Binding Energy (eV)

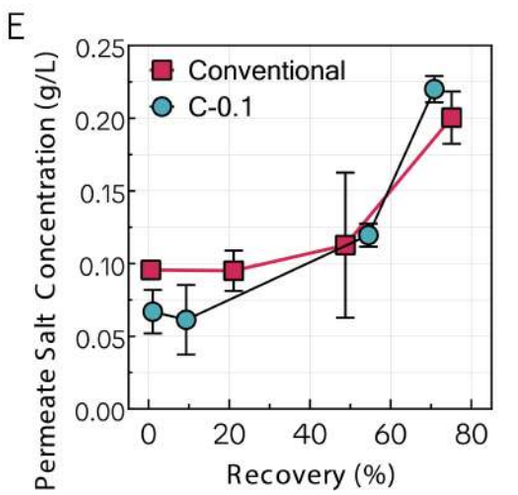

A
Water Flux (LMH)
Salt Rejection (%)
Water Flux (LMH)
Salt Rejection (%)
NF270
Conv.
C-0.05
C-0.1
C-0.3
C-0.5
C-0.8
C-1.3
C-2
Membranes
B
Salt Water Flux (LMH)
Rejection (%)
MgSO4
CaCl2
NaCl
C-0.1
Conventional
Membranes
C1
5 µm
C2
5 µm
C3
5 µm
D1
1 µm
D2
1 µm
D3
1 µm
E1
Polyamide
500 nm
E2
500 nm
E3
Polyamide
PES
500 nm
F
Average Roughness (nm)
RMS Roughness (nm)
Average Roughness
RMS Roughness
NF270
Conv.
C-0.05
C-0.1
C-0.3
C-0.5
C-0.8
C-1.3
C-2
Membranes

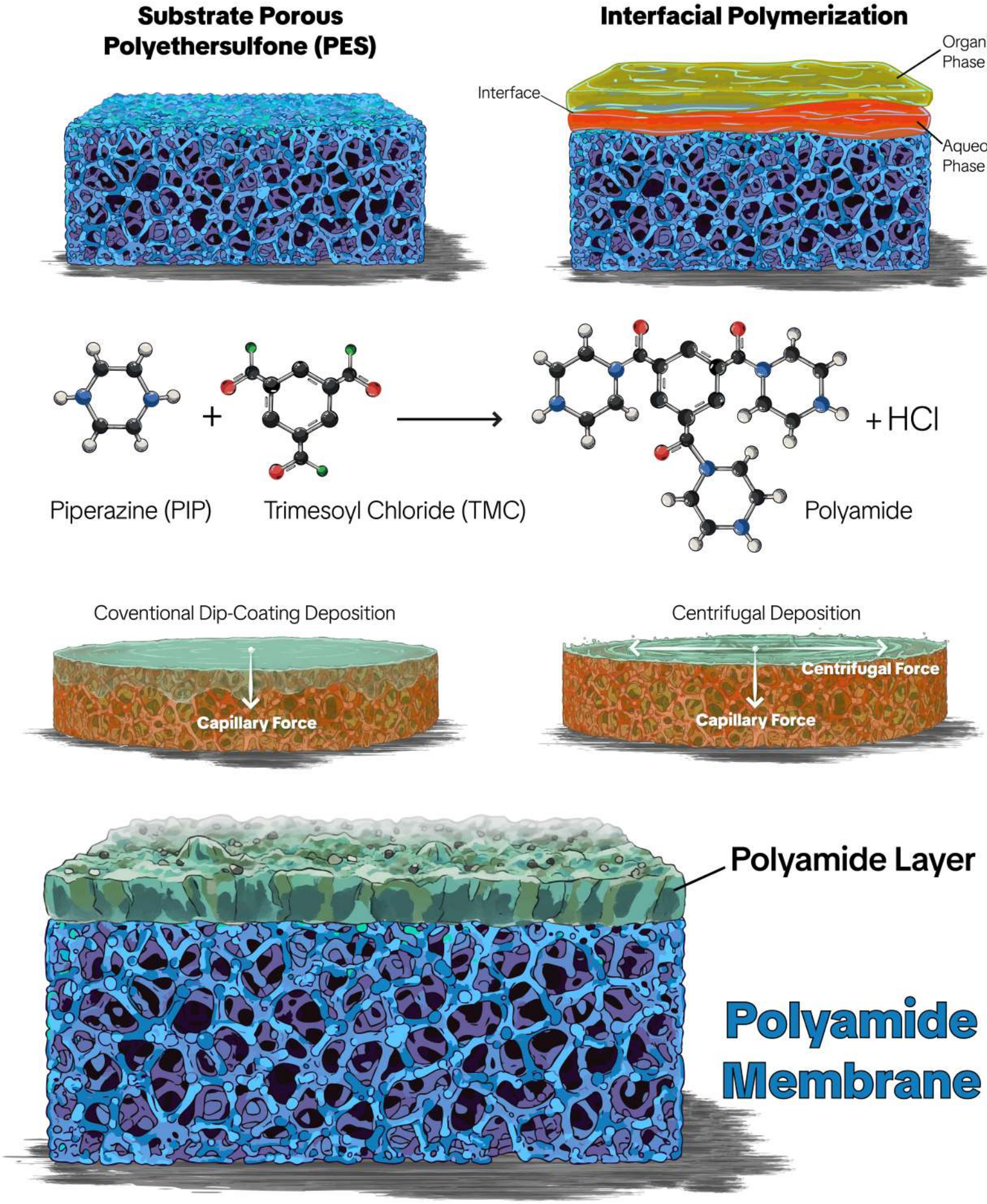

A
C-0.1
Coventional
Measured Flux (LMH)
Recovery (%)


B
C-0.1
Conventional
Observed Rejection (%)
Cumulative Permeate Volume (L)


C
FRR
R_r
R_ir
R_t
85%
15%
15%
30%
100%
10%
10%
Conventional
C-0.1
Membranes
Fouling Value (%)


D
Conventional
C-0.1
Retentate Salt Concentration (g/l)
Cumulative Permeate Volume (L)


E
Conventional
C-0.1
Permeate Salt Concentration (g/L)
Recovery (%)


Substrate Porous
Polyethersulfone (PES)
Interfacial Polymerization
Organic
Phase
Interface
Aqueous
Phase
+
+ HCl
Piperazine (PIP)
Trimesoyl Chloride (TMC)
Polyamide
Coventional Dip-Coating Deposition
Capillary Force
Centrifugal Deposition
Centrifugal Force
Capillary Force
Polyamide Layer
Polyamide
Membrane