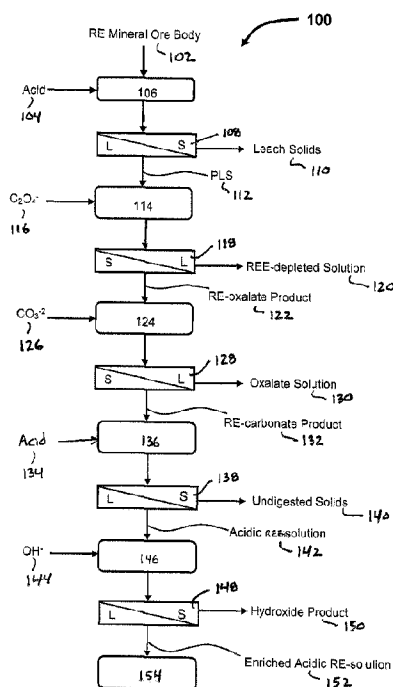




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(54) **Titre : TRAITEMENT POUR L'EXTRACTION D'ELEMENTS DES TERRES RARES**
(54) **Title: PROCESSING FOR THE EXTRACTION OF RARE EARTH ELEMENTS**



(57) **Abrégé/Abstract:**

A method is provided for separating thorium from an acidic solution including thorium and at least one rare earth element. The method involves contacting the acidic solution with a phosphinic acid-type extractant to extract at least a portion of the thorium from the acidic solution, thereby forming a thorium-depleted acidic solution and a thorium-loaded extractant. The thorium-loaded extractant is then contacted with oxalic acid to strip thorium from the thorium-loaded extractant and to form a thorium-depleted extractant. A method is also provided for separating thorium from an acidic solution including at least thorium, cerium, and lanthanum.

Abstract

A method is provided for separating thorium from an acidic solution including thorium and at least one rare earth element. The method involves contacting the acidic solution with a phosphinic acid-type extractant to extract at least a portion of the thorium from the acidic solution, thereby forming a thorium-depleted acidic solution and a thorium-loaded extractant. The thorium-loaded extractant is then contacted with oxalic acid to strip thorium from the thorium-loaded extractant and to form a thorium-depleted extractant. A method is also provided for separating thorium from an acidic solution including at least thorium, cerium, and lanthanum.

PROCESSING FOR THE EXTRACTION OF RARE EARTH ELEMENTS

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application claims priority to U.S. Provisional Patent Application No. 62/062,705 by Kasaini filed on October 10, 2014, to U.S. Provisional Patent Application No. 62/074,608 by Kasaini filed on November 3, 2014 and U.S. Provisional Patent Application No. 62/165,155 by Kasaini filed on May 21, 2015.

FIELD

[0002] This disclosure relates to the field of extractive metallurgy, particularly the extraction of rare earth metals from feedstocks such as mineral ore bodies containing these elements.

BACKGROUND

[0001] Rare earth elements (REEs) comprise seventeen elements in the periodic table, specifically the 15 lanthanide elements plus scandium and yttrium. REEs are a group of metallic elements with unique chemical, catalytic, magnetic, metallurgical and phosphorescent properties, and as such find use in a wide variety of modern devices including high-strength magnets, batteries, displays, lighting, and high performance metal alloys.

[0002] REEs are relatively plentiful in the earth's crust. However, REEs are typically highly dispersed and are not often found as concentrated rare earth minerals in economically exploitable ore deposits. The extraction of REEs from mineral deposits is also challenging because mineral deposits containing REEs typically also contain appreciable levels of radioactive elements such as thorium (Th) and uranium (U) that must be safely and economically separated from the REEs during processing of the ore.

[0003] REEs may be further categorized based upon their value and/or their molecular weight. As used herein, the term critical rare earth element ("CREE") includes neodymium (Nd), europium (Eu), terbium (Tb), dysprosium (Dy), praseodymium (Pr) and yttrium (Y). The term heavy rare earth element

("HREE") includes terbium (Tb), dysprosium (Dy), holmium (Ho), erbium (Er), thulium (Tm), ytterbium (Yb) and lutetium (Lu). The term light rare earth element ("LREE") refers to lanthanum (La), cerium (Ce), praseodymium (Pr) and neodymium (Nd). Samarium (Sm), europium (Eu) and gadolinium (Gd) are collectively referred to herein as "SEG."

[0004] As is noted above, many growing industries utilize REEs in the manufacture of myriad products. However, most of these products require that the REEs are of exceptionally high purity. Despite this industrial demand, many mineral deposits containing REEs are not fully exploited due to the costs associated with processing the ore to recover the REEs in a very high purity form.

SUMMARY

[0005] Accordingly, it has been realized that there is a need for a method for the extraction of REEs from mineral ore bodies, such as bastnaesite-based mineral ore bodies, that leads to a reduced overall cost for the process, *e.g.*, reduced capital expenditures ("capex") and/or reduced operating expenditures ("opex"). It would be advantageous if such an economical process nonetheless was able to produce very high purity REE-containing end products that have significant value in many industrial uses.

[0006] In one embodiment, the present disclosure relates to a method for leaching a mineral ore body comprising rare earth elements, the method including the steps of contacting the mineral ore body with a hydrochloric acid (HCl) solution for a period of time that is sufficient to solubilize at least a portion of the rare earth elements and form a pregnant liquor solution and a solid residue. During the contacting of the hydrochloric acid solution and the mineral ore body, the leach temperature remains relatively low, and in one embodiment the leach temperature does not exceed about 60°C. After a desirable amount of REEs have been solubilized, a pregnant liquor solution, *e.g.*, containing the solubilized REEs, is separated from the solid residue, *e.g.*, from the unsolubilized minerals.

[0007] In another embodiment disclosed herein, a method for the extraction of thorium is provided that includes precipitating the thorium as thorium hydroxide under controlled pH conditions so that the thorium precipitates without precipitating substantial amounts of rare earth metals. The resulting rare earth solutions are of extremely high purity and may be processed in a solvent extraction circuit for the recovery of high purity rare earth metals, or may be treated to convert the solutions to rare earth oxides. The thorium may be precipitated separately from cerium, or may be co-precipitated with cerium.

[0008] In another embodiment, a method for the extraction of cerium from a cerium-containing acidic solution is provided. The method includes the steps of contacting the cerium-containing acidic solution with ammonium hydroxide to precipitate at least a portion of the cerium as cerium hydroxide and form a cerium-depleted solution and a cerium hydroxide product, and separating at least a portion of the cerium hydroxide product from the cerium depleted solution.

[0009] In yet another embodiment, the present disclosure is directed to solvent extraction processes for separating thorium and/or cerium from a RE-oxide product by solvent extraction.

[0010] In yet another embodiment, the present disclosure is directed to solvent extraction processes for separating rare earth elements, individually or as "baskets," from a RE-oxide product. The process may advantageously require fewer mixer/settler tanks than known processes, and/or may produce little to no effluent. The processes may be used, for example, to separate Ce, La, Nd and Pr, SEG and HREEs. Some of the processes disclosed herein may also be used to remove non-REEs from the RE-oxide product such as thorium (Th), uranium (U) and base metals.

[0011] For example, in one embodiment of this disclosure, a process for the removal of thorium from rare earth elements is disclosed. In another embodiment, a process for the separation of cerium from other rare earth elements is disclosed. In yet another embodiment, the process for the separation of lanthanum from other rare earth elements is disclosed. The foregoing processes for the removal of thorium, the separation of cerium and the separation of lanthanum may be utilized in combination to produce a high purity and reduced volume rare earth element product which may be subjected to further solvent extraction processes to separate the remaining rare earth elements.

[0012] In other embodiments, processes for stripping extractants (e.g., organic extractants) that are loaded with REEs or other elements such as thorium is disclosed. These processes entail the use of an organic acid (e.g., oxalic acid) to rapidly precipitate compounds of the metals (e.g., oxalate compounds) from the extractant. These processes may enable the recycling of both the stripped extractant and the raffinate within the circuit. The need for large excesses of acids (e.g., mineral acids) that are normally required for stripping extractants may be significantly minimized, and in some cases may be eliminated.

[0013] In some characterizations, the foregoing processes may advantageously reduce or even eliminate the need for large excesses of organic extractant inventory. These processes may also reduce the operating plant footprint (size) by first separating the bulk REEs (e.g., Ce and La) to decrease the

solvent extraction capacity (e.g., the number of mixer settlers) that is required for separating the more valuable rare earths (e.g., CREEs) that constitute a smaller proportion of the REO powder.

[0014] Another objective of this disclosure is to provide a cost effective method of removing thorium from the REEs, such as at an early stage (e.g., a first stage) of a process. In one characterization, the thorium is removed first in a single contact solvent extraction step. In one refinement, after removal of the thorium, cerium is separated from the mixed REE product, which may reduce the required solvent extraction capacity for separation of other REEs by up to one-half (50%) or more. The subsequent removal of lanthanum may further reduce the required solvent extraction capacity for separation of other REEs by up to two-thirds (66%) or more.

[0015] The processes disclosed herein, implemented alone or in combination, may advantageously reduce the operating expenses ("opex") of an REE recovery plant by reducing the amounts of reagents, energy, and/or water, etc. that are used. The processes may also advantageously reduce the capital expenditures ("capex") to construct and REE recovery plant by reducing the equipment requirements such as motors, pumps, mixer impellers, piping, mixers settlers, etc..., as compared to traditional solvent extraction processes.

[0016] Another objective of certain embodiments of this disclosure is to provide end products that are of extremely high purity. By way of example, the separated end products disclosed herein may include cerium at a purity of 99.999 wt. % cerium on a metals basis, lanthanum at a purity of 99.999 wt. % La on a metals basis, combined neodymium and praseodymium at a purity of 99.999% Nd/Pr on a metals basis, combined SEG at a purity of 99.999 wt. % on a metals basis, and/or 99.999% HREEs on a metals basis.

[0017] Additional embodiments of processes for the treatment extraction of REEs will become apparent from the following description, as well as a number of characterizations, refinements and additional features that are applicable to the disclosed embodiments, alone or in any combination.

DESCRIPTION OF THE DRAWINGS

[0018] **Fig. 1** is a schematic flowsheet illustrating a method for the recovery of rare earth elements from a rare earth ore concentrate.

[0019] **Fig. 2** is a schematic flowsheet illustrating a method for the leaching of a mineral ore body.

[0020] Fig. 3 is a schematic flowsheet illustrating a method for the precipitation of rare earth elements as rare earth oxalates from a pregnant liquor solution.

[0021] Fig. 4 is a schematic flowsheet illustrating a method for the conversion of a rare earth oxalate product to a rare earth carbonate product by metathesis.

[0022] Fig. 5 is a schematic flowsheet illustrating a method for the selective precipitation of thorium from an acidic solution.

[0023] Fig. 6 is a schematic flowsheet illustrating a method for the selective precipitation of thorium from an acidic solution using multiple hydroxylation steps.

[0024] Fig. 7 is a schematic flowsheet illustrating a method for the precipitation of thorium as thorium hydroxide from an acidic solution including the recycle of acid from a solvent extraction circuit.

[0025] Fig. 8 is a schematic flowsheet illustrating a method for the precipitation of thorium as thorium hydroxide from an acidic solution including the precipitation of rare earth element hydroxides from a nitric acid solution.

[0026] Fig. 9 is a schematic flowsheet illustrating a method for the extraction of cerium as cerium hydroxide from a cerium-containing acidic solution that includes a cerium species.

[0027] Fig. 10 is a schematic flowsheet illustrating a method for the extraction of cerium as cerium hydroxide from a cerium-containing acidic solution using multiple hydroxylation steps.

[0028] Fig. 11 is a schematic flowsheet illustrating a method for the chemical separation of rare earth elements and thorium from a rare earth element product.

[0029] Fig. 12 is a schematic flowsheet illustrating the chemical separation of rare earth elements and thorium to produce three rare earth element baskets from a rare earth element product.

[0030] Fig. 13 is a schematic flowsheet illustrating the chemical separation of rare earth elements and thorium to produce four rare earth element baskets from a rare earth element product.

[0031] Figs. 14A to 14C are schematic flowsheets illustrating solvent extraction methods that may be applied to precipitation products comprising rare earth elements.

[0032] Fig. 15 is a schematic flowsheet illustrating the separation of thorium from an REE-containing product by solvent extraction.

[0033] Fig. 16 is a schematic flowsheet illustrating the separation of cerium from an REE-containing product by solvent extraction.

[0034] Fig. 17 is a schematic flowsheet illustrating the removal of base metals from an REE-containing product in a purification circuit.

[0035] Fig. 18 is a schematic flowsheet illustrating the separation of lanthanum and the separation of Nd/Pr from an REE-containing product by solvent extraction.

[0036] Fig. 19 is a schematic flowsheet illustrating the separation of HREEs and SEG from an REE-containing product by solvent extraction.

[0037] Fig. 20 is a schematic flowsheet illustrating a scavenger circuit to recover traces of REEs from other bulk REEs by selective precipitation.

[0038] Fig. 21 illustrates acid leach results for leaching a high-grade (HG) bastnaesite-based mineral ore where the rare earth elements are predominately in the form of rare earth oxides.

[0039] Fig. 22 illustrates acid leach results for leaching a high-grade (HG) bastnaesite-based mineral ore where the rare earth elements are predominately in the form of rare earth carbonates.

[0040] Fig. 23 illustrates the acid leach results for leaching a high-grade (HG) bastnaesite-based mineral ore where the rare earth elements are in the form of rare earth carbonates and rare earth oxides.

[0041] Fig. 24-30 illustrate different acid leach results for leaching a mid-grade bastnaesite-based mineral ore where the rare earth elements are in the form of rare earth carbonates and rare earth oxides.

[0042] Figs. 31 and 32 illustrate the effect of pH on selective thorium precipitation when using a hydroxide precipitant to precipitate thorium as thorium hydroxide.

[0043] Fig. 33 illustrates the selective precipitation of cerium and thorium from a cerium-containing acidic solution in the first stage of a cerium extraction method according to one embodiment.

[0044] Fig. 34 illustrates the selective precipitation of cerium and thorium from a cerium depleted solution in the second stage of a cerium extraction method according to one embodiment.

[0045] Fig. 35 illustrates the net precipitation of cerium and thorium from a cerium-containing acidic solution in a two-stage cerium extraction method according to one embodiment.

[0046] Figs. 36A – 36B illustrate the selective solvent extraction of both Ce and Th from other REEs using TPB as an extractant.

[0047] Fig. 37 illustrates the effect of tributyl phosphate (TBP) dosage on selectivity for Ce in a single contact solvent extraction process.

[0048] Fig. 38 illustrates the separation of LREEs and HREEs in a two contact solvent extraction process.

[0049] Figs. 39A-39E illustrate the effect of solvent extraction variables during the selective separation of Th from REEs using solvent extraction.

DETAILED DESCRIPTION

[0050] Broadly characterized, this disclosure is directed to the processing of REE-containing products to extract REEs of high purity from the REE-containing products. Disclosed are several processing steps that may be combined in whole or in part, or may be applied independently to REE-containing products.

[0051] Throughout this disclosure, including in the claims, a percentage (%) of one or more elements or compounds refers to percentage by mass (*i.e.*, wt. %) unless otherwise indicated. Further, the percentages of metals that are specified in this disclosure are relative to the total metals content of a particular product (a "metals basis"), *e.g.*, without accounting for non-metallic elements in the product such as oxygen in the case of metal oxides.

[0052] Fig. 1 is a flowsheet illustrating an exemplary process for the extraction of REEs having a high purity from a rare earth (RE) mineral ore body. Fig. 1 illustrates a method for the extraction of REEs from the RE mineral ore body that integrally combines several sub-methods to achieve the extraction of high purity REEs from the RE mineral ore body. These sub-methods may be separable from the integrated flowsheet, or may be integrated in various combinations to complete the flowsheet or any portion of the flowsheet.

[0053] Referring to Fig. 1, the method 100 may begin with a RE mineral ore body 102. The mineral ore body 102 may be derived from one or more rare earth containing minerals such as bastnaesite, monazite, carbonatite, loparite, or similar rare earth containing minerals. For example, the RE mineral ore body 102 may be formed by separating rare earth minerals from waste rock and other debris, and

beneficiating the rare earth minerals (e.g., milling) to reduce the particle size and increase the surface area of the minerals before further separation of the minerals from the waste, such as by flotation and/or magnetic separation. Other methods for the preparation of mineral ore bodies for subsequent leaching are known to those skilled in the art, and the present disclosure is not limited to any particular methods for preparation of the mineral ore body **102** for leaching. A typical mineral ore body will include from about 30 wt.% to about 70 wt.% rare earth oxides, although the present disclosure is not limited to the treatment of mineral ore bodies having this concentration or type of rare earth compounds.

[0054] In a leaching step **106**, the mineral ore body **102** is contacted with an acid **104** (e.g., in a reactor) for a period of time to solubilize (e.g., digest) at least a portion of the metallic compounds in the mineral ore body **102**, including the solubilization of a substantial portion of RE compounds (e.g., RE-oxides and/or RE-carbonates) in the mineral ore body **102**. As is described below with respect to **Fig. 2**, in one characterization of the methods disclosed herein, the leaching step **106** may advantageously be carried out at a relatively low temperature and at ambient pressure.

[0055] After leaching **106**, pregnant liquor solution **112** ("PLS") comprising solubilized REEs is separated from the leach solids **110** in a PLS separation step **108**, i.e., the PLS **112** is separated from the components of the mineral ore body **102** that are not solubilized by the acid **104**. The PLS **112** may then be treated in an oxalate formation step **114** where the PLS **112** is contacted with a source of oxalate ions (C_2O_4^-) **116**. For example, the oxalate ion source **116** may comprise oxalic acid ($\text{H}_2\text{C}_2\text{O}_4$), oxalate salts (e.g., sodium oxalate ($\text{Na}_2\text{C}_2\text{O}_4$)), or combinations of oxalic acid and oxalate salt(s). The oxalate formation step **114** forms an RE-oxalate product **122** comprising at least a portion of the REEs from the PLS **112** in the form of RE-oxalate compounds (e.g., $\text{ReC}_2\text{O}_4 \cdot 10\text{H}_2\text{O}$, where Re is a rare earth element). The solid RE-oxalate product **122** may be separated from an REE-depleted solution **120** in a RE-oxalate separation step **118**.

[0056] The RE-oxalate product **122** contains a relatively high concentration of REEs in the form of RE-oxalate compounds. The RE-oxalate product **122** may then be contacted with a source of hydroxide (OH^-) or carbonate (CO_3^-) **126** in a metathesis step **124** to convert (e.g., metathesize) the REEs to carbonate compounds (e.g., $\text{Re}_2\text{CO}_3 \cdot x\text{H}_2\text{O}$ or ReOH) and form an RE-hydroxide or RE-carbonate solid product **132**. The RE-carbonate product **132** may be separated from an oxalate solution **130** in a separation step **128**.

[0057] Thereafter, the RE=hydroxide or RE-carbonate product **132** is contacted with an acid, e.g., with nitric acid (HNO_3), in an acid digestion step **136** for a period of time to solubilize a substantial portion of the REEs in an acidic RE-solution **142**. The acidic RE-solution **142** is separated from undigested solids **140** in a RE-solution separation step **138**.

[0058] The acidic RE-solution **142** may then be contacted with a source of hydroxide ions (OH^-) **144** in a hydroxylation step **146** to selectively precipitate certain elements (e.g., thorium and/or cerium) from the acidic RE-solution **142**, e.g., through pH control during precipitation of metal hydroxides. For example, the hydroxide ion source **144** may comprise a hydroxide salt, and in one characterization comprises ammonium hydroxide (NH_4OH). Various embodiments of this hydroxylation step **146** are described in more detail below with respect to **Figs. 5-10**. After contacting the acidic RE-solution **142** with the hydroxide ion source **144**, a hydroxide product **150** is separated from an enriched acidic REE-solution **152** in an enriched REE-solution separation step **148**. The hydroxylation step **146** may advantageously separate appreciable quantities of undesirable elements such as thorium (e.g., as thorium hydroxide) and/or iron (e.g., as iron (III) hydroxide) from the acidic RE solution **142**, thus enriching the acidic RE solution with respect to REEs. The hydroxylation step **146** may also be utilized to separate lower value REEs such as cerium from the acidic REE solution **142**.

[0059] The hydroxylation step, carried out at about pH 9, may also be utilized to precipitate all REEs to the exclusion of highly soluble base metals, e.g., calcium, potassium, magnesium, phosphorus, zinc, manganese, strontium, lead, chromium and titanium. The REE-rich hydroxide precipitate may subsequently be dissolved in acid to produce REE-solution for advanced separation.

[0060] The enriched REE-solution **152** can then be subjected to an REE-separation step **154** to separate individual REEs and/or to separate the REEs into groups ("baskets"). The REE-separation step **154** may include the selective precipitation of REEs (e.g., as RE-oxides and/or RE-hydroxides) and/or the solvent extraction of REEs from solution, as is discussed in more detail below with respect to **Figs. 11-20**.

[0061] In accordance with the foregoing, one embodiment of a method for the extraction of REEs from a REE-containing product includes leaching a RE mineral ore body to form a PLS containing REEs, forming an RE-oxalate product from the PLS, metathesizing the RE-oxalate product to form an RE-hydroxide or RE-carbonate product, digesting the RE-hydroxide or RE-carbonate product in an acid to form an acidic REE solution, and hydroxylating the acidic REE solution to precipitate certain elements

from the acidic REE solution, forming an enriched REE solution. The enriched REE solution may be subjected to a separation step to separate one or more REEs or groups of REEs from the REE solution.

[0062] In addition to the complete processing scheme described above and with respect to **Fig. 1**, the present disclosure is directed to specific embodiments of the individual process steps that are integrated in the complete processing scheme. The individual steps may be practiced independently (e.g., on REE-containing products sourced from outside of the above-described method) or may be practiced in any combination.

[0063] As is discussed above with respect to **Fig. 1**, the methods disclosed herein may be applied to a mineral ore body to extract individual rare earth elements from the ore. Among the major minerals that contain appreciable quantities of REEs are monazite and bastnaesite. Monazite is a phosphate mineral that is commonly found in India, Madagascar and South Africa. In contrast, bastnaesite is a carbonate mineral that may be found in parts of Europe, the United States, Pakistan and Russia, among other regions. Bastnaesite is a fluorocarbonate, e.g., with a general formula of $(\text{Ce,Lu})\text{CO}_3\text{F}$, where the cerium is often substituted by light REEs, lanthanum, yttrium and/or thorium.

[0064] Bastnaesite is often associated with quartz, feldspars, mica, apatite and pyroxenes. The clays, feldspars and pyroxenes (e.g., $\text{XY}(\text{Si,Al})_2\text{O}_6$ where X represents calcium, sodium, iron II and magnesium and occasionally zinc, manganese and lithium, and where Y represents ions of smaller size, such as chromium, aluminum, iron III, magnesium, manganese, scandium, titanium, vanadium and even iron II) are major sources of numerous heavy and alkaline metal impurities. Bastnaesite may also be associated with other rare-earth-bearing minerals such as allanite, cerite and tysonite.

[0065] Although bastnaesite is a carbonate mineral, bastnaesite ores found near the surface may be completely or partially oxidized. Fully oxidized bastnaesite ores contain less calcite (CaCO_3) and are rich in oxides of rare earths and oxides of base metals such as iron oxides and manganese oxide. Partially oxidized ores contain the carbonates (e.g., carbonatite) and fewer metal oxides.

[0066] Thus, a bastnaesite-based ore may comprise fully oxidized bastnaesite, partially oxidized bastnaesite that comprises a mixture of metal oxides and metal carbonates, or a substantially pure bastnaesite which comprises substantially 100% of the metals as metal carbonates. The total REE concentration in a typical raw (chemically untreated) bastnaesite-based ore may be from about 2 wt.% to about 12 wt.% calculated as the rare earth oxides (REOs). Although the composition of ore bodies

from different geographic regions may vary dramatically, typical distributions of individual REEs, *i.e.*, as a percentage of total REEs (TREEs) are illustrated in **Table I**.

Table I

REE	Distribution (wt.%)
Ce	40 – 43
La	24 – 27
Nd	15 – 18
Pr	4 – 5
Sm	2.6 – 3.0
Gd	1.4 – 1.7
Eu	0.04 – 0.7
Dy	0.3 – 0.5
Tb	0.11 – 0.14
Y	1.1 – 1.3
Er	0.06 – 0.08
Others	0.07 – 0.09

[0067] As can be seen in **Table I**, the primary REE components of the ore body are lanthanum and cerium, with smaller proportions of the other REEs.

[0068] Processes which attempt to extract REEs from bastnaesite-based ores at high temperature and with strong acid conditions also extract large amounts of acid soluble metal impurities, and consequently consume excess acid reagent. Further, the excess metal impurities that report to the PLS may negatively impact the quality of downstream REE-containing products and of recycled plant effluents. The cost of purifying an impure PLS by chemical precipitation, ion exchange and solvent extraction is significantly high and significantly impacts the economics of an REE recovery project. For

example, the removal of Fe (e.g., Fe^{3+}) from a PLS by precipitation typically leads to significant losses of valuable HREEs, while other elements such as Zn, Fe^{2+} , K, Na, Al and Mn are not precipitated out of the PLS at low temperature and moderate pH conditions using alkaline solutions or oxalic acid.

[0069] Bastnaesite-based ores may be beneficiated by combinations of screens, gravity and magnetic separators. In robust beneficiation plants, froth flotation techniques are applied to a warm fine pulp to separate rare earth-bearing minerals from gangue minerals using a suite of reagents such as pH control reagents, depressants, frothers and collectors. The upgraded ore may contain REEs locked in calcites, silicates and/or apatite or completely liberated in oxide and carbonate form. For bastnaesite-based ores in which REEs are locked in excess calcites, silicates and apatite, the ores are typically decomposed or oxidized in reactors under strong alkaline conditions. In some cases, the oxidized bastnaesite-based ores are sulfated at high temperature and later digested in water such that the REE-sulfates dissolve in water with an advantage that oxidized cerium remains in the leach residue. The benefits of removing cerium far ahead in the hydrometallurgical process impacts positively on the economics of downstream individual REE separation. However, the cost of beneficiation and high temperature oxidation leads to excess energy and reagent usage together with department of heavy metal impurities in the final PLS. This means that additional purification processes are required to remove Fe, Mn and other base metals from the PLS.

[0070] Accordingly, there is a need for a method for the leaching of REEs from mineral ore bodies, such as bastnaesite-based mineral ore bodies, that leads to a reduced overall cost for the process, e.g., reduced capital expenditures (“capex”) and/or reduced operating expenditures (“opex”).

[0071] In one embodiment, the present disclosure relates to a method for leaching a mineral ore body comprising REEs. One such method is schematically illustrated in **Fig. 2**. The leaching method **200** may include contacting a mineral ore body **202** with an acid, e.g., an acid comprising hydrochloric acid (HCl) **204** in a reactor **206** for a period of time that is sufficient to solubilize at least a portion of the REEs from the mineral ore body **202**.

[0072] In accordance with this embodiment, during the contacting of the HCl **204** and the mineral ore body **202** in the reactor **206**, the leach temperature may advantageously remain relatively low. In one characterization, leach temperature during this contacting step does not exceed about 60°C. In further characterizations, the leach temperature during this contacting step does not exceed about 50°C, such as where the leach temperature does not exceed about 45°C, does not exceed about 40°C, or

even does not exceed about 35°C. However the leach temperature should be sufficiently high to solubilize a substantial portion of the REEs from the Mineral ore body **202**. For example, the leach temperature within the reactor **206** may be at least about 15°C, such as at least about 20°C. The leaching step 206 may also be carried out at ambient or substantially ambient pressure conditions, eliminating the need for a pressurized vessel such as an autoclave.

[0073] As is discussed above, the mineral ore body **202** may be, for example, a bastnaesite-based mineral ore body that includes fully oxidized bastnaesite (e.g., where the rare earth elements are in metal oxide form), partially oxidized bastnaesite (e.g., where the REEs are found in both metal oxide and metal carbonate form) or substantially pure bastnaesite (e.g., where the REEs are all found in metal carbonate form). In another embodiment, the mineral ore body **202** comprises little or no phosphate-based mineral, e.g., as may be found in a monazite-based mineral ore body.

[0074] The mineral ore body **202** may be a raw mineral ore body. As used herein, a raw mineral ore body is a mineral body that has not been substantially chemically altered after extraction of the ore from the ground, *i.e.*, in the form of a rare earth ore concentrate. For example, a raw mineral ore body is one that has not been subjected to roasting, e.g., has not been heated to an elevated temperature to convert carbonates to oxides. Such treatment steps are often applied in known processes to concentrate the ore body, e.g., such that the concentration of rare earth oxides in the ore that is leached with the mineral acid is 50% or even higher. The elimination of roasting and similar pretreatment steps to materially alter the chemistry of the mineral ore body according to this embodiment the present disclosure may result in substantial cost savings.

[0075] The mineral ore body **202** that is contacted with the HCl **204** may include appreciable quantities of minerals and compounds in addition to the rare earth compounds (RE-oxides and/or RE-carbonates), referred to herein as gangue minerals. For example, the mineral ore body **202** may comprise an appreciable quantity of silicates, and in one characterization may include at least about at least about 20 wt.% elemental silicon (Si).

[0076] Because the mineral ore body **202** may comprise substantial quantities of gangue minerals, it may also have a relatively low concentration of rare earth compounds, e.g., as compared to rare earth ore concentrates. In one characterization, the mineral ore body fed to the leaching step may comprise not greater than about 16 wt.% rare earth elements, such as not greater than about 10 wt.% rare earth elements, or even not greater than about 6 wt.% rare earth elements. In another characterization, the

mineral ore body **202** may comprise at least about 84 wt.% gangue minerals, such as at least about 90 wt.% gangue minerals or even at least about 94 wt.% gangue minerals. It is an advantage of the leaching process disclosed herein that such mineral ore bodies may be leached in an economical manner while extracting a very high percentage of the valuable metals from the ore.

[0077] For example, according to this embodiment, by exercising careful control over the leach conditions in the reactor **206**, iron in the mineral ore body **202** may be inhibited from solubilizing in the PLS **212**. This is a particular advantage when the PLS **212** is subsequently treated to precipitate the REEs as oxalate compounds as is discussed in more detail below. In one characterization, the mineral ore body **202** comprises iron, and not greater than about 30% of the iron in the mineral ore body **202** reports to the PLS **212**, *e.g.*, not greater than about 30% of the iron is solubilized in the PLS **212**. For example, not greater than about 22% of the iron in the mineral ore body **202** may report to the PLS **212**, or even not greater than about 10% of the iron in the mineral ore body **202** or even not greater than about 4% of the iron reports to the PLS **212**. Thus, the PLS **212** may have a relatively low concentration of iron, and in one characterization the PLS **212** comprises not greater than about 9 g/L iron, such as not greater than about 4 g/L iron, not greater than about 2 g/L iron or even not greater than about 1 g/L iron.

[0078] In another aspect, the leach conditions disclosed herein (*e.g.*, at temperatures of not greater than about 60°C) may also inhibit thorium (Th) from solubilizing in the PLS **212**, which may also lead to subsequent cost savings as thorium is undesirable in the PLS **212**. For example, in one characterization, not greater than about 70 wt.% of the thorium in the mineral ore body **202** reports to the PLS **212**, such as not greater than about 60% of the thorium in the mineral ore body **202** or even not greater than about 50% of the thorium in the mineral ore body. In another characterization, the PLS **212** may comprise not greater than about 125 g/L thorium, such as not greater than about 70 g/L thorium or even not greater than about 7 g/L thorium.

[0079] Despite the relatively moderate (*e.g.*, low temperature) leach conditions, which may reduce the digestion of metals such as iron and thorium, it has been found that relatively high concentrations of REEs from the mineral ore body **202** may report to the PLS **212**, particularly as compared to the low concentrations of gangue minerals that report to the PLS **212**. That is, it has been found that the relatively low leach temperatures lead to a highly selective extraction of the REEs from the mineral ore body **202**. In one characterization, at least about 65% of critical rare earth elements (CREEs) in the mineral ore body **202** report to the PLS **212**. As is noted above, the CREEs include praseodymium (Pr), neodymium

(Nd), europium (Eu), terbium (Tb), dysprosium (Dy) and yttrium (Y). In another characterization, at least about 75 wt.% of the CREEs in the mineral ore body **202** report to the PLS **212**, such as at least about 85 wt.% of the CREEs in the mineral ore body **202** or even at least about 95 wt.% of the CREEs in the mineral ore body **202** report to the PLS **212**. In another characterization, the PLS **212** that is separated from the leach solids **210** comprises at least about 30 g/L CREEs, such as at least about 15 g/L CREEs.

[0080] Although the mineral ore body **202** may be a raw ore body (e.g., not substantially chemically modified such as by roasting), the mineral ore body **202** may be comminuted before the leaching step to reduce the size of the mineral particles. In one characterization, prior to leaching the mineral ore body **202** is comminuted to reduce the particle size to about -48 mesh, or even smaller. A -48 mesh size means that substantially all of the particles are not greater than about 320 μm in size.

[0081] In another aspect of the method illustrated in **Fig. 2**, the quantity of mineral acid (HCl) **204** that is contacted with the mineral ore body **202** is relatively low. In one characterization, the leaching step comprises contacting the mineral ore body **202** with not greater than about 310 kg of HCl per tonne of (dry) mineral ore body **202**. In another characterization, the leaching step comprises contacting the mineral ore body **202** with at least about 50 kg of HCl per tonne of (dry) mineral ore body **202**. The HCl may be in the form of an aqueous solution having a concentration of from about 22 wt.% HCl to about 33 wt.% HCl, for example. These relatively low concentrations of HCl during the leaching step **206** may advantageously reduce the opex of the process.

[0082] The leaching step **206** may be carried out using virtually any leach configuration known to those skilled in the art. In one particular characterization, the leaching step **206** comprises contacting the mineral ore body **202** with the HCl in a counter-current leach configuration (CCL). A counter-current leach configuration may advantageously increase the efficiency of the leaching step. Nonetheless, the leaching step may also comprise contacting the mineral ore body **202** with the HCl in a static leach configuration. A static leach configuration may advantageously reduce or eliminate the need to comminute the mineral ore body **202** prior to leaching. For example, the mineral ore body **202** may comprise ore body particles having a particle size of at least about 1 nominal inch and not greater than about 2 nominal inch. In another characterization, the ore body particles may have a size of -10 mesh. In another characterization, the ore body particles may have a size of +3 mesh.

[0083] The methods disclosed with respect to **Fig. 2** may also reduce or eliminate the need for the addition of other chemical(s) to the leaching step, *i.e.*, in addition to the mineral acid. For example, many

known leaching methods require the addition of an additive such as sodium sulfate (Na_2SO_4) to precipitate undesirable barium (Ba) from the PLS **212**. The low temperature leach conditions described with respect to **Fig. 2** may reduce or even eliminate the need for such an additive to the leach as the solubilization of barium is significantly reduced at the lower leaching temperatures.

[0084] Further, the method **200** described with respect to **Fig. 2** may lead to a significantly reduced consumption of mineral acid (e.g., HCl), thus reducing opex and reducing the generation of toxic fumes. The resulting PLS **212** may require little or no further downstream processing to remove impurities such as base metals (e.g., Fe, Mg, Mn etc.) from the PLS **212**.

[0085] Thus, the low temperature leaching method **200** may provide one or more of the following advantages:

- (i) reduced digestion (solubilization) of impurities such as Fe, Mn, Al, Mg, Ba, Sr, Th and the like;
- (ii) reduced evolution of flue gases and toxic vapors;
- (iii) reduction or elimination of precipitation agents such as sodium sulfate for Ba precipitation;
- (iv) the use of a low acid dosage in the leaching step, reducing or eliminating the need for sodium carbonate to neutralize the acid;
- (v) low amounts of wash water for the solids residue since the acid volume in the leach residue may be relatively low;
- (vi) reduced reagent costs;
- (vii) reduced capex due to the use of smaller scrubbers and smaller filters;
- (viii) reduced footprint due to a smaller amount of metal residue to be neutralized for disposal; and
- (ix) enhanced purity of the REEs in the PLS, e.g., reduced Th, Ca and/or Ba in the PLS.

[0086] As is disclosed with respect to **Fig. 1**, the PLS may be treated in an oxalate formation step to convert REEs in the PLS to RE-oxalates. While the oxalate formation step disclosed herein may be applied to a PLS formed by a low temperature leaching process such as that described above, it will be

appreciated that the oxalate formation step may be applied to any PLS, including those resulting from a higher temperature leaching step.

[0087] An embodiment of an oxalate formation step is illustrated in **Fig. 3**. **Fig. 3** schematically illustrates one such method for the formation of an RE-oxalate product having low concentrations of non-REEs. As illustrated in **Fig. 3**, a PLS **312** is contacted with an oxalate ion source such as oxalic acid ($\text{H}_2\text{C}_2\text{O}_4 \cdot 2\text{H}_2\text{O}$) **316** in an oxalate formation step **314**. The PLS **312** may include one or more REEs, *i.e.*, REEs that have been dissolved (*e.g.*, solubilized) in the PLS **312**. For example, the PLS **190** may be an acidic solution (*e.g.*, from a chloride leach) and the REEs may be present as dissolved salts, such as dissolved chloride salts. In one example, the PLS **312** includes a concentration of REEs of at least about 20 g/l. For example, the PLS **312** may include at least about 25 g/l REEs, such as at least about 30 g/l REEs, at least about 35 g/l REEs, or even at least about 40 g/l REEs.

[0088] The PLS **312** may also include non-REE elements that are solubilized in the PLS **312**. The non-RE elements may include metallic elements, particularly: alkali metals such as sodium (Na) and potassium (K); alkaline earth metals such as magnesium (Mg), calcium (Ca), strontium (Sr) and barium (Ba); transition metals such as nickel (Ni), copper (Cu), zirconium (Zr), iron (Fe), manganese (Mn) and titanium (Ti); post-transition metals such as lead (Pb) and aluminum (Al); metalloids such as silicon (Si); and radioactive metals (*e.g.*, actinides) such as thorium (Th) and uranium (U). The non-RE elements may also include non-metallic elements such as sulfur (S) and phosphorous (P). Among the foregoing, and in certain characterizations, the PLS **312** may particularly include Mn in concentrations of at least about 10 g/l and/or may include Fe in concentrations of at least about 20 g/l. As is discussed above, the PLS **312** may have a relatively low concentration of non-RE elements, such as a PLS that is formed in accordance with the low temperature leaching process above.

[0089] It is a particular advantage of the oxalate formation step **314** of this embodiment that a substantial majority of the non-REEs do not report with (precipitate with) the RE-oxalate product **322**, *i.e.*, they remain solubilized in an REE-depleted solution **320**.

[0090] Exemplary compositions of pregnant liquor solutions that may be treated to form RE-oxalates are illustrated in **Table II**.

Table II

Element	PLS Example 1 (mg/l)	PLS Example 2 (mg/l)	PLS Exemplary Range (mg/l)
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F	3610	3380	3000 – 4000
Al	4555	4593	4000 – 5000
Ba	2126	2147	2000 – 2500
Ca	3045	3151	3000 – 3200
Fe	22838	22733	22000 – 30000
K	1638	1653	1000 – 2000
Mg	1892	1995	1000 – 2000
Mn	13349	13514	10000 – 14000
Na	17733	--	10000 – 180000
P	70	71	60 - 80
Pb	1011	1058	1000 – 1200
S	<100	<100	10 – 80
Si	47	49	40-50
Th	40	70	40-70
Ti	296	309	250-350
U	40	34	30-60
Zn	1210	1297	1000-3000
REEs	35737	36369	> 35000

[0091] As can be seen from **Table II**, pregnant liquor solutions, *e.g.*, from the leaching of a REE-containing product with HCl, may also contain appreciable amounts of non-RE elements, including base metals and other undesirable metals such as uranium and thorium. It is an advantage of this embodiment that RE-oxalates may be precipitated from the PLS **312**, while a substantial majority of the non-REEs remain in solution, *i.e.*, do not form oxalate compounds during the oxalate formation step **314**. Particularly, the method may result in very low concentrations of elements such as Al, Fe, Ca, Mg, Mn, P, Pb, S, Ti, U and/or Zn precipitating in the RE-oxalate product **322**. As a result, the RE-oxalate product **322** is of high purity with respect to REEs and a substantial proportion of the base metals and other metals such as uranium may be removed prior to subsequent extraction and/or separation of the REEs, *e.g.*, in a solvent extraction process.

[0092] The oxalate formation method of this embodiment to extract REEs may include contacting the PLS **312** with oxalic acid **316** in an oxalate formation step **314**, such as by contacting the reactants in a reactor (*e.g.*, a sealed reactor) under conditions such that RE-oxalate compounds (*e.g.*, $\text{RE}_2(\text{C}_2\text{O}_4)_3$, where RE = rare earth) precipitate from the PLS **312** as an RE-oxalate product **322**. It will be appreciated that the RE-oxalate compounds may also be hydrated compounds, *e.g.*, $\text{RE}_2(\text{C}_2\text{O}_4)_3 \cdot x\text{H}_2\text{O}$. The PLS **312** is an acidic solution and may, for example, include free chloride ions. For example, the PLS **312** may

comprise hydrochloric acid (HCl) and may be obtained from the leaching of rare earth minerals (e.g., a mineral ore body or a rare earth ore concentrate) with HCl. In one example, the PLS **312** has a free acid concentration (HCl) in the range of from about 0.5M to about 1M (e.g., from about 18.2 g/l to about 35.5 g/l HCl).

[0093] A sufficient amount of oxalic acid **316** is contacted with the PLS **312** in the reactor to precipitate a majority of the REEs as RE-oxalates in an RE-oxalate product **322**. For example, the oxalic acid **316** (e.g., fresh oxalic acid) input to the oxalate formation step **314** may be an aqueous solution having a concentration of fresh oxalic acid of at least about 38.4 g/l. Further, the concentration of oxalic acid may be not greater than about 52.5 g/l. Excess oxalic acid may be required and may be obtained by recycling various product streams within the process as is described herein.

[0094] Sodium oxalate ($\text{Na}_2\text{C}_2\text{O}_4$) **317** may also be contacted with the PLS **312** in the oxalate formation step **314**, such as by adding the sodium oxalate **317** to the oxalic acid **316**, or by adding the sodium oxalate **317** directly to the PLS **312**. As is illustrated in **Fig. 3**, the sodium oxalate **317** may advantageously be recycled from a subsequent process step, such as from crystallization step **315**, describe below. Alternatively, or in addition to, fresh sodium oxalate may be added to the oxalate formation step **314**. In one example, the ratio of (fresh) oxalic acid **316** to sodium oxalate **317** may be greater than 1, and in one particular characterization, the ratio of oxalic acid **316** to sodium oxalate **317** may be at least about 3:1 and not greater than about 4:1, such about 3.5:1. The addition of recycled sodium oxalate **317** to the oxalate formation step **314** may advantageously reduce the total consumption of oxalic acid by the process, and may represent a significant opex cost savings for the process.

[0095] The oxalate formation step **314** may be carried out under reaction conditions such that the formation of RE-oxalates is favored over the formation of most non-RE oxalates from the PLS **312**. In one characterization, the oxalate formation step **314** is carried out by maintaining the reactants (e.g., PLS **312**, oxalic acid **316** and optionally sodium oxalate **317**) at an elevated precipitation temperature (e.g., a controlled precipitation temperature above ambient) of at least about 50°C such as at least about 60°C or at least about 70°C. Further, the precipitation temperature may be not greater than about 90°C, such as not greater than about 85°C. It has been found that a very high proportion of the REEs dissolved in the PLS **312** will precipitate as RE-oxalate particulates at such precipitation temperatures, while a comparatively low quantity of most non-RE elements, with the possible exception of thorium, will precipitate from the PLS **312**. Precipitation temperatures at the higher end of this range (e.g., from about

75°C to about 85°C) may result in higher purity RE-oxalates, *i.e.*, a high content of RE-oxalates in the RE-oxalate product **322** and a relatively low concentration of non-RE oxalates in the RE-oxalate product **322**. In one characterization, the oxalate formation step **314** may be carried out by maintaining a precipitation temperature (e.g., in a reactor **313**) for a sufficient amount of time to precipitate at least about 75 at.% of the REEs in the PLS **312** as particulate RE-oxalates, such as at least about 85 at.% of the REEs, at least about 90 at.% of the REEs, at least about 95 at.% of the REEs, or even at least about 98 at.%, at least about 99 at.% or at least about 99.5 at.% of the REEs. In one example, the oxalate formation step **314** may be carried out for at least about 30 minutes and not greater than about 120 minutes, such as for about 60 minutes. The reactants may also be agitated (e.g., mixed) in the reactor **313** during the oxalate formation step **314**.

[0096] After formation of oxalate precipitates in the reactor **313**, the metal oxalate precipitates may be allowed to crystallize (e.g., to grow) over a period of time and the RE-oxalate product **322** may then be separated from an REE-depleted solution **320** in a RE-oxalate separation step **318**. For example, the mixture **319** of RE-oxalate product **322** and REE-depleted solution **320** may be allowed to cool over a period of time to allow crystallization (e.g., size increase) of the solid metal oxalates.

[0097] If the mixture **319** (e.g., slurry) from the oxalate formation step **314** is allowed to cool, it may take a long period of time (e.g., several days) for the metal oxalate precipitates to completely crystallize so that the RE-oxalate product **322** may be readily and economically separated from the REE-depleted solution **320**. Alternatively, the temperature of the reactants may be increased to a second (crystallization) temperature (e.g., greater than the first precipitation temperature) to enhance (e.g., to accelerate) crystallization and growth of the metal oxalate precipitates, particularly of the RE-oxalates. It has been found that because a majority of the initially available oxalate ion ($C_2O_4^{2-}$) is consumed in the formation step **314** at the precipitation temperature, the increase in temperature in the crystallization step will not cause a substantial amount of non-RE elements to precipitate from the PLS **312**. The crystallization temperature is greater than the precipitation temperature, and in one characterization, the crystallization temperature is at least about 5°C greater than the precipitation temperature, such as at least about 7°C greater than the precipitation temperature. In another characterization, the crystallization temperature is at least about 90°C, such as at least about 92°C and is not greater than about 100°C, such as not greater than about 98°C. The crystallization of the oxalates may be carried out in the same

reactor as the precipitation of the oxalates (e.g., in reactor **313**), or may be carried out in a separate reactor (not illustrated).

[0098] The crystallization temperature may be maintained for a time sufficient to grow the RE-oxalate particulates to a size that is suitable for subsequent separation **318** from the remaining REE-depleted solution **320**. In one characterization, the crystallization temperature is maintained for a period of time sufficient to grow the RE-oxalate precipitates to a mean average size (e.g., diameter) of at least about 100 μm , such as at least about 200 μm , for example at least about 250 μm . In one particular characterization, the RE-oxalate precipitates are crystallized to a mean average size of from about 400 μm to about 450 μm . For example, the crystallization temperature may be maintained for at least about 4 hours and not greater than about 8 hours, such as for about 6 hours.

[0099] After crystallization, the RE-oxalate product **322** may be separated from the REE-depleted solution **320** in a separation step **318**. For example, the separation step **318** may include the use of a micro-filter **321** to separate the RE-oxalate product **322** from the REE-depleted solution **320**.

[00100] The RE-oxalate product **322** comprises predominately RE-oxalates. It is an advantage of the oxalate formation step **314** that the RE-oxalate product **322** may be of very high purity with respect to REEs. For example, the total non-REEs (e.g., Ba, Na, K, Si, Sr and/or Th) may constitute not greater than about 5 wt.% of the RE-oxalate product **322**, such as not greater than about 3 wt.% or even not greater than 1 wt.% of the RE-oxalate product **322**. **Table III** illustrates the elemental metal concentrations of exemplary RE-oxalate products, *i.e.*, expressed as percentages of the total metal content, as determined by inductively coupled plasma (ICP) analysis.

Table III

Element	Ex. 1 Concentration (at.% of total metals)	Ex. 2 Concentration (at.% of total metals)
TREEs	~98.2	~92.5
F	0.00	0.00
Al	<0.01	<0.01
Ba	0.44	1.00
Ca	0.16	<0.10
Fe	0.16	0.58
K	0.14	<1.00

Mg	<0.01	<0.01
Mn	<0.1	<0.1
Na	0.08	<0.1
P	0.04	0.24
Pb	0.04	<0.10
S	0.04	0.04
Si	0.02	<0.50
Th	0.52	0.58
Ti	0.02	<0.10
U	0.00	0.00
Zn	<0.01	<0.10
Total Non-REEs	~1.74	~7.04
Th + U	~0.52	~0.58

[00101] As is illustrated by **Table III**, the oxalate formation step **314** may advantageously precipitate RE-oxalates in a highly selective manner from the PLS **312**, e.g., to the exclusion of non-REEs such as base metals.

[00102] Thus, the REE-depleted solution **320** may be an acidic solution that includes solubilized metals that did not precipitate, e.g., to form a metal oxalate, during the oxalate formation step **314**. For example, the REE-depleted solution **320** may include solubilized elements as listed in **Table III** such as Fe, Mn, Th, U, F, Al, Ca, K, Mg, Na, Sr, Zn, P, S, Pb and Ti. In one characterization, the REE-depleted solution **320** includes not greater than about 0.5 g/l REEs, such as no greater than about 0.25 g/l REEs. In another characterization, the REE-depleted solution **320** contains no greater than about 10 ppm thorium, such as from about 1 ppm to 10 ppm thorium. The REE-depleted solution **320** may have high free acid content, and the free acid content may be higher than the free acid content of the PLS **312**. For example, the free acid content (e.g., HCl) of the REE-depleted solution **320** may be at least about 100 g/l, such as at least about 110 g/l. In another characterization, the free acid content of the REE-depleted solution **320** may be at least about 1.5 times greater than the free acid content of the PLS **312**, such as at least about 2 times greater than the free acid content of the PLS **312**.

[00103] As is disclosed above, the RE-oxalate product **322** may include a high concentration of the REEs in the form of RE-oxalates. In one characterization, at least about 95 wt.% of the total metallic elements in the RE-oxalate product **322** are REEs, such as at least about 97 wt.% and even at least about 99 wt.% of the total metallic elements. Any remaining non-REE metal oxalates (*i.e.*, impurities) may comprise, for example, oxalates of Ba, Na, K, Si and Th. Stated another way, based on the total metals content of the RE-oxalate product **322**, the product **322** may include not greater than about 5 at.% non-REE metals, such as not greater than about 3 at.% non-REE metals and even not greater than about 1 at.% non-REE metals.

[00104] The REE-depleted solution **320** may be recycled to conserve acid (*e.g.*, HCl acid), which may be particularly advantageous due to the relatively high free acid content of the REE-depleted solution **320**. For example, as illustrated in **Fig. 3**, the REE-depleted solution **320** may be transferred to a thickening step **323** such as in a thickener **325**. After thickening **323**, a separation step **327** may be carried out to separate metal oxalates **322b**, which then may be recycled to the oxalate formation step **314**, from an acidic solution **320b**, *e.g.*, an acidic solution that includes a high concentration of chloride ions. The solution **320b** may be subjected to a distillation step **329** using a distiller **331** to recover water **333**, which may be used as process water in other process steps, and acid **335**, which may also be recycled to other process steps such as a leaching step described above (**Fig. 2**). Residue **337** from the distillation step **329** may be further treated in a crystallization step **339** to recover and recycle oxalic acid crystals **316b** and a by-product **341** that contains metals. The by-product **341** may be processed to recover further metals of value, such as gold, uranium, aluminum, manganese, iron, magnesium, strontium and zinc.

[00105] As is discussed above with respect to **Fig. 1**, certain embodiments of the present disclosure are directed to metathesizing a RE-containing product (*e.g.*, RE-oxalates described above) to a second RE-containing product (*e.g.*, RE-hydroxides or RE-carbonates). The metathesis may be carried out in combination with one or more steps disclosed herein (*e.g.*, with a low temperature leach and/or an oxalate formation step), or may be carried out independently.

[00106] Although the methods described above for the formation of RE-oxalates may advantageously reduce the concentration of impurities associated with the REEs, the solubility of REE-oxalates in acid is very low. Thus, one embodiment of this disclosure specifically provides for the

conversion of the RE-oxalates to a more soluble form, e.g. RE-carbonates, by a metathesis reaction to render the REEs soluble in an acid such as nitric acid (HNO₃).

[00107] In the embodiment illustrated in **Fig. 4**, an RE-oxalate product **422** is converted in a metathesis step **424** to a RE-carbonate product **432** for subsequent dissolution of the REE-carbonate product **432** in an acid, e.g., to solubilize the REEs and thorium in an acidic solution, as is discussed below. In this embodiment, an RE-oxalate product **422** is contacted with a carbonate ion source **426** such as sodium carbonate (Na₂CO₃) in the metathesis step **424**, along with a solvent **443** such as water (e.g., fresh or recycled water), which may be introduced with the other reactants or introduced separately. For example, the metathesis step **424** may include contacting the reactants in a reactor **445** for a period of time sufficient to convert at least about 98%, such as at least about 98.5% of the REEs in the RE-oxalate product **422** to RE-carbonates in the RE-carbonate product **432**. In one characterization, the reactants are maintained at an elevated temperature e.g., at least about 70°C, such as at least about 90°C, or at least about 100°C, to ensure that very little or substantially no sodium oxalate precipitates from the solution. When sodium hydroxide (NaOH) is utilized for metathesis, e.g., to form RE-hydroxides from the RE-oxalates, the reactants may advantageously be maintained at a temperature of at least about 90°C, such as at least about 100°C or even at least about 110°C.

[00108] The metathesis step **424** may be carried out for a period of time sufficient to convert at least about 98%, such as at least about 98.5% of thorium in the RE-oxalate product **422** from thorium oxalate to thorium carbonate in the RE-carbonate product **432**. The only by-product of the metathesis step **424** is a high-purity carbon dioxide stream **447** which may be captured as a by-product.

[00109] In a separation step **428**, the RE-carbonate product **432** (e.g., RE-carbonate particulates) are separated from an oxalate solution **430** such as by using a filter **449**. The separation step **428** may be maintained at an elevated temperature to prevent substantial amounts of sodium oxalate from precipitating out of the solution. For example, heated water (e.g., heated to a temperature of at least about 50°C, such as at least about 70°C) may be passed through the filter **449** to maintain the sodium oxalate in solution if desired.

[00110] The oxalate solution **430** may therefore include substantial amounts of dissolved oxalates (e.g., Na₂C₂O₄·yH₂O when the carbonate source **426** is sodium carbonate) and the oxalate solution **430** may advantageously be recycled to a step where the REEs are precipitated as the RE-oxalate product **422** (see **Fig. 3**).

[00111] Fig. 5 illustrates a schematic flowsheet of a method for the precipitation of thorium from an acidic solution according to one embodiment of the present disclosure. As is disclosed above, the hydroxylation steps may be carried out independently or may be carried out in combination with one or more of the foregoing embodiments for processing REE-containing products.

[00112] As illustrated in Fig. 5, an acidic solution 502 containing at least solubilized thorium is contacted with a hydroxide ion source 504 (e.g., a hydroxide salt) in a hydroxylation (*i.e.*, precipitation) step 510, e.g., by contacting the acidic solution 502 and hydroxide ion source 504 in a reactor 512 to cause thorium in the acidic solution 502 to precipitate as thorium hydroxide. After at least a portion of thorium in the acidic solution 502 has precipitated from the acidic solution 502 as thorium hydroxide, a thorium depleted solution 506 may be separated from a thorium hydroxide product 508 in a separating step 514, e.g., using a filter 516.

[00113] The acidic solution 502 contains at least solubilized thorium. The acidic solution 502 may be derived from the leaching of a raw mineral ore or an ore concentrate containing REEs or other high-value metals. Thorium is among the elements that are commonly found in mineral deposits containing REEs and the resulting acidic leach solutions typically contain undesirable concentrations of thorium. In one example of this embodiment, the concentration of solubilized thorium in the acidic solution 502 may be at least about 50 mg/l (milligrams per liter), such as at least about 100 mg/l of solubilized thorium in the acidic solution 502, or even at least about 200 mg/l of solubilized thorium. Typically, the acidic solution will comprise not greater than about 1500 mg/l thorium, such as not greater than about 850 mg/l thorium.

[00114] The acidic solution 502 may also include one or more REEs, *i.e.*, REEs that are also solubilized in the acidic solution 502. For example, the acidic solution 502 may include REEs in a concentration of at least about 10 grams per liter (g/l). In certain characterizations, the acidic solution 502 includes a relatively high concentration of REEs, such as at least about 15 g/l REEs, at least about 20 g/l REEs, at least about 30 g/l or even at least about 50 g/l REEs, where the REEs are solubilized (e.g., dissolved) into the acidic solution 502. Typically, the acidic solution 502 will include not greater than about 100 g/l REEs. In one particular characterization of this example, the acidic solution 502 includes at least one or more REEs of particularly high value, such as one or more of the CREEs, namely praseodymium, neodymium, europium, terbium, dysprosium and yttrium.

[00115] The solution **502** is acidic and may have a pH of not greater than about pH 3.0, such as not greater than about pH 1.0, prior to being contacted with the hydroxide ion source **504**. In one example, the acidic solution includes nitric acid (HNO_3), although other acids such as sulfuric acid (H_2SO_4) may also be useful in the embodiments disclosed herein. For example, the acidic solution **502** may comprise nitric acid and may be obtained from the acid digestion of rare earth compounds, *e.g.*, the acid digestion of RE-oxides, RE-hydroxides, RE-oxalates and/or RE-carbonates with nitric acid to form solubilized nitrate compounds of the REEs. In one characterization, the free acid in the acidic REE solution is obtained from the acid digestion of a RE-hydroxide product or RE-carbonate product, such as a RE-hydroxide or RE-carbonate product formed in accordance with the metathesis step described above. Nitric acid is particularly useful, as the thorium hydroxide precipitated during hydroxylation **510** will become stable and thus will not substantially dissolve, even at a relatively low pH (*e.g.*, at a relatively high acidity).

[00116] The acidic solution **502** comprises nitric acid, and in one particular example, the acidic solution **502** has a free acid concentration in the range of from about 0.5 g/l to about 55 g/l HNO_3 . When the acidic solution **502** comprises nitric acid, the solubilized elements (*e.g.*, thorium and REEs) may be in the form of solubilized nitrate salts. It is an advantage of this embodiment that the acidic solution **502** may have a relatively low free acid concentration, and therefore may require relatively small quantities of the hydroxide ion source **504** to precipitate thorium hydroxide and to avoid diluting metal species in solution, which favors crystallization to precipitate thorium.

[00117] The acidic solution **502** may also include traces of non-REEs that are solubilized in the acidic solution **502**. For example, the non-REEs may include metallic elements, such as: alkali metals such as sodium (Na) and potassium (K); alkaline earth metals such as magnesium (Mg), calcium (Ca), strontium (Sr) and barium (Ba); transition metals (*e.g.*, base metals) such as nickel (Ni), copper (Cu), zirconium (Zr), iron (Fe), manganese (Mn) and titanium (Ti); post-transition metals such as lead (Pb) and aluminum (Al); metalloids such as silicon (Si); and other radioactive metals (*e.g.*, actinides) such as uranium (U). The non-REEs may also include non-metallic elements such as sulfur (S) and phosphorous (P). The acidic solution may also contain other base metals, such as lead (Pb) or zinc (Zn).

[00118] In one example, the acidic solution **502** includes primarily REEs and thorium, with little or no other non-RE elements (*e.g.*, base metals) that are solubilized in the acidic solution **502**. For example,

the acidic solution **502** may comprise not greater than about 5 wt.% non-RE elements, such as not greater than about 3 wt.% non-RE elements on a metals basis.

[00119] The hydroxylation step **510** includes contacting the thorium-containing acidic solution **502** with a hydroxide ion source **504**, such as sodium hydroxide or ammonium hydroxide, to precipitate a thorium hydroxide product **508** (e.g., predominately containing particulate thorium hydroxide). For example, the reactants may be contacted in a reactor **112** under conditions such that at least a portion of the thorium solubilized in the acidic solution **502** precipitates as a thorium hydroxide product **508**.

[00120] It is an advantage of the method of this embodiment that the thorium may be precipitated from the acidic solution **502**, while a substantial majority of the REEs contained in the acidic solution **502** remain solubilized in a thorium depleted solution **506** that is separated from the thorium hydroxide product **508**. To ensure that sufficient quantities of thorium precipitate from the acidic solution **502** and that a substantial majority of REEs in the acidic solution **502** remains solubilized, it has been found that the pH during the hydroxylation step **510** should be maintained at a pH that enables high selectivity for thorium, *i.e.*, to preferentially precipitate thorium from the acidic solution **502**. In one characterization, the pH during the hydroxylation step **510** is within the range of at least about pH 3 and not greater than about pH 6.0. It has been found that increasing the pH within this range may increase the amount of thorium precipitated from the acidic solution **502** as a thorium hydroxide product **508**. In one characterization, the pH during the hydroxylation step **110** is maintained at a pH of at least about pH 3.1, such as at least about pH 3.2, at least about pH 3.3, at least about pH 3.4 or even at least about pH 3.5, such as at least about pH 3.6. However, as the pH approaches higher levels, an increasing quantity of REEs may also precipitate from the acidic solution **502** (e.g., as particulate RE-hydroxides). In the embodiment illustrated in **Fig. 5**, to avoid the precipitation of undesirable quantities of REEs from the solution, the pH may be maintained at less than about pH 4, such as not greater than pH 3.9 or not greater than pH 3.8. In one example, the pH during the hydroxylation step **510** may be maintained at the desired pH level by controlling the quantity of hydroxide precipitant **504** that is added to the reactor **512** during the hydroxylation step **510**, e.g., during the precipitation of thorium from the thorium-containing acidic solution **502**.

[00121] It has also been found that the desirable range of pH values for the selective precipitation of thorium is dependent upon the concentration of solubilized thorium in the acidic solution **502**. In particular, it has been found that increased pH values within the range of about pH 3.5 to pH 4 or slightly

higher may be utilized to selectively precipitate thorium as a thorium hydroxide product **508** without precipitating significant amounts of REEs when the concentration of thorium in the acidic solution **502** is relatively low. That is, as the concentration of the thorium in the acidic solution **502** decreases, the pH during the hydroxylation step **510** may be increased to remove additional thorium without removing substantial quantities of REEs. In one example, the acidic solution **502** can be diluted (e.g., with water) to reduce the thorium concentration, and the hydroxylation step **510** may be carried out at a higher pH (e.g., pH 3.5 to pH 3.9) without precipitating undesirable quantities of REEs. In one characterization, the acidic solution **502** comprises not greater than about 800 mg/l of thorium, such as not greater than 500 mg/l, or even not greater than about 200 mg/l thorium, and the contacting step is carried out at a pH of at least about pH 3.5, such as at least about pH 3.6, at least about pH 3.7, and even at least about pH 3.8, but typically not greater than pH 4, such as not greater than pH 3.9. However, it is believed that at least about 50 mg/l of thorium is required in the solution for precipitation of thorium to occur.

[00122] The thorium-containing acidic solution **502** and the hydroxide ion source **504** should remain in contact (e.g., in reactor **512**) for a period of time sufficient to precipitate a majority (e.g., at least about 50%) of the thorium from the acidic solution **502** and form a thorium depleted solution **506** and a thorium hydroxide product **508**. In one characterization, the time of contact (e.g., the average residence time in the reactor) during the hydroxylation step **510** may be at least about 30 minutes and may be not greater than about 90 minutes. It is an advantage of this embodiment that the hydroxylation step **510** may be carried out at ambient temperatures, e.g., the step does not typically require the reactor **512** to be heated or cooled. Further, the hydroxylation step **510** may be carried out at ambient pressures, e.g., the hydroxylation step **510** does not require a sealed or otherwise pressure-controlled reactor **512**.

[00123] After the contacting step **510**, the thorium hydroxide product **508** may be separated from the thorium depleted solution **506** in a separating step **514**. For example, a filter **516** may be used to filter the output stream **507** containing thorium hydroxide and the thorium depleted solution **506** from the reactor **512** and retain the thorium hydroxide product **508** on the filter **516**. The thorium depleted solution **506** (i.e., the filtrate), containing high levels of REEs and very low levels of thorium, may be further treated as is discussed below to extract cerium. The thorium hydroxide product **508** may advantageously be of high purity, i.e., the product may comprise at least about 99 wt. % thorium hydroxide, such as at least about 99.9 wt.% thorium hydroxide. The thorium hydroxide product **508** may be disposed of, or may be a salable commodity particularly in view of the ability to form a high purity thorium hydroxide product **508**.

[00124] As is noted above, thorium precipitation from the acidic solution may be enhanced with increased pH (e.g., up to about pH 4) and with a decreased concentration of thorium in the acidic solution and with low free acid content. In one example of this embodiment, this finding may be applied in a multi-step (e.g., two-step) process for the separation of thorium. Specifically, the thorium extraction method of this embodiment may include a first hydroxylation step that includes contacting an acidic solution with a hydroxide precipitant at a first pH, e.g., of at least about pH 3 and not greater than about pH 4, to precipitate a thorium hydroxide product containing very low amounts of REEs and form an intermediate thorium depleted solution, *i.e.*, having a lower concentration of thorium than the acidic solution. The intermediate thorium depleted solution may then be subjected to a second hydroxylation step where the intermediate thorium depleted solution is contacted with a hydroxide precipitant at a second pH of at least about pH 3.1 and not greater than about pH 6, such as not greater than about pH 4.2, where the second pH is greater than the first pH to remove additional thorium. In one particular characterization of this method, the pH during the first hydroxylation step is from about pH 3.0 to about pH 3.3, and the pH during a second hydroxylation step is from about pH 3.5 to about pH 4. In this regard, the pH in the second hydroxylation step may be carried out at such higher pH to aggressively remove thorium, even if some REEs precipitate with the thorium hydroxide product. In the event that some valuable REEs are precipitated with the thorium, the resulting hydroxide product may be recycled, e.g., recycled back to the first hydroxylation step at lower pH.

[00125] Referring now to **Fig. 6**, this exemplary method may include a first hydroxylation step **610a** where the acidic solution **602** is contacted with a first hydroxide ion source **604a**, such as in a first reactor **612a**, under conditions such that at least a portion of the thorium in the acidic solution **602** precipitates as a first thorium hydroxide product **608a** and a substantial majority of the REEs (e.g., at least about 99 at.% of the REEs on a metals basis) remain solubilized in an intermediate thorium depleted acidic solution **606a**. For example, at least about 50% of the thorium in the acidic solution **602** may be precipitated in reactor **612a** and removed in a first separation step **614a**, e.g., using a filter **616a**. In one particular characterization, at least about 60% and not greater than about 90% of the thorium in the acidic solution **602** is separated from the intermediate thorium depleted solution **606a** in the separation step **614a** as a thorium hydroxide product **608a**. As a result, the intermediate thorium depleted solution **606a** recovered from the separation step **614a** has a lower concentration of thorium than the acidic solution **602**.

[00126] As is discussed above, the lower concentration of thorium in the intermediate thorium depleted solution **606a** advantageously enables a higher pH to be utilized in a second hydroxylation step

610b (*i.e.*, as compared to the first hydroxylation step **610a**), *e.g.*, in a second reactor **612b**. Thus, in a second separation step **614b**, a second thorium hydroxide product **608b** is separated from the thorium depleted solution **606**. The thorium depleted solution **606** from the separation step **614b** may advantageously include not greater than about 5% of thorium contained in the acidic solution **602**, such as not greater than about 2% of the thorium contained in the acidic solution **602**. Further, due to the high selectivity of the process, at least about 95%, such as at least about 98%, of REEs in the acidic solution **602** may remain solubilized in the thorium depleted solution **606**. Although illustrated as a two-step process in **Fig. 6** (*e.g.*, including two hydroxylation steps), the method may include additional incremental steps if desired for enhanced thorium precipitation and/or enhanced REE recovery.

[00127] Further, the amount of thorium hydroxide product **608b** that is separated to form the thorium depleted solution **606** may be relatively small, as compared to the amount of thorium hydroxide product **608a** that is separated to form the intermediate thorium depleted solution **606a**. Further, the thorium hydroxide product **608b** may include some REEs (due to the higher pH used in hydroxylation step **610b**). In one characterization, the thorium hydroxide product **608b** may include up to about 20 wt.% REEs on a metals basis. Therefore, in one example, the thorium hydroxide product **608b** may be recycled back to the first hydroxylation step **610a**, so that the recovery of REEs from the thorium depleted solution **606** is increased. That is, any increase in the amount of REEs precipitated as REE-hydroxides in hydroxylation step **610b** may be mitigated by recycling the thorium hydroxide product **608b** to hydroxylation step **610a**, keeping the REEs within the circuit. Thus, in this example, substantially all of the thorium hydroxide may be extracted from the circuit with the thorium hydroxide product **608a** while reducing losses of REEs.

[00128] In one example of the foregoing embodiments, ammonium hydroxide (NH_4OH) is utilized as a hydroxide ion source **604a/604b** to precipitate thorium as thorium hydroxide. For example, ammonium hydroxide may be added as an aqueous solution having a concentration of from about 10 wt.% to about 20 wt.% ammonium hydroxide, *e.g.*, about 15 wt.% ammonium hydroxide. As a result, the thorium depleted solution **606** recovered from the separation step(s) **614a/614b** may contain substantial amounts of ammonium nitrate (NH_4NO_3), dissolved in the thorium depleted solution **606**. It may be desirable to continuously or intermittently extract the ammonium nitrate, which is a valuable and salable by-product.

[00129] In some examples, it may be advantageous to integrate the method(s) described above for the precipitation of thorium from an acidic solution (*e.g.*, an REE-containing acidic solution) with a solvent

extraction circuit for extracting REEs, e.g., from the thorium depleted solution. It may also be advantageous to integrate a method for the formation of the acidic solution, before hydroxylation, by acid digestion of rare earth compounds, such as the acid digestion of RE-oxides. In one particular embodiment, reagent consumption may be reduced and overall operating expenses of the process reduced by recycling nitric acid from a solvent extraction circuit to an acid digestion step to form the above-described acidic solution. In one characterization, nitric acid consumption may be reduced to almost zero, with only make-up nitric acid being added to the process to compensate for normal evaporation and leakage losses.

[00130] In one example, the acidic solution is formed by the acid digestion of an RE-oxide product or RE-carbonate product, such as one that has a high purity with respect to REEs. As illustrated in **Fig. 7**, an RE-oxide product **774** may be contacted with an acid **720** (e.g., fresh nitric acid and/or sulfuric acid) in an acid digestion step **722**, such as in a reactor **724**. The acidic solution **702** may be contacted in a first hydroxylation step **710a** with a hydroxide ion source **704a** to precipitate a thorium hydroxide product **708a** from the acidic solution **702**. The thorium hydroxide product **708a** may be separated from the thorium depleted solution **706b** in a separation step **714a**. Thereafter, as illustrated with respect to **Fig. 6**, the intermediate thorium depleted solution **706b** may be contacted in a second hydroxylation step **710b** with a second hydroxide precipitant **704b** to form the thorium depleted solution **706**. The thorium depleted solution **706** may then be separated from the second thorium hydroxide product **708b** in a separation step **714b**.

[00131] As is noted above, the amount of thorium hydroxide product **708b** may be relatively small and there may be appreciable quantities of REEs in the thorium hydroxide product **708b**. To reduce losses of REEs, the thorium hydroxide product **708b** may be recycled back to the process, and as illustrated in **Fig. 7**, the second thorium hydroxide product **708b** is recycled back to the acid digestion step **722** where the thorium is re-digested with the RE-oxide product **774**. In this manner, all of the thorium hydroxide is removed from the acidic solution **702** with the first thorium hydroxide product **708a**. When the thorium hydroxide product **708b** is separated in separating step **714b**, the resulting thorium depleted solution **706** is a relatively high purity RE-nitrate solution.

[00132] The high purity RE-nitrate solution **706** may then be subjected to a solvent extraction circuit **726** to extract REEs from the thorium depleted solution **106**. One example of such a solvent extraction circuit is described below with respect to **Figs. 14-20**. It is an advantage of this embodiment that having

the REEs solubilized in nitrate media may reduce the expenses associated with a solvent extraction circuit. The solvent extraction circuit **726** may include the steps of solvent extraction **728** and solvent stripping **730** with a stripping solvent **732**. Because the thorium depleted solution **706** described herein is of extremely high purity, the solvent extraction circuit **726** may advantageously be operated at a reduced capital expense and reduced operating expense. The resulting products are very high purity and high value REEs **734**.

[00133] As is noted above, the thorium depleted solution **706** may include substantial quantities of highly salable ammonium nitrate. Thus, an ammonium nitrate removal step **736** may be utilized to continuously or intermittently remove ammonium nitrate **738** from the solution **706**. As illustrated in **Fig. 7**, the ammonium nitrate is removed after the solvent extraction circuit **726**, as the presence of ammonium nitrate in the thorium depleted solution **706** is not believed to impair the efficacy of the solvent extraction circuit **726**. However, it will be appreciated that the ammonium nitrate separation step may also occur before the solvent extraction circuit **726** if desired.

[00134] The ammonium nitrate separation step **736** may include cooling the thorium depleted solution to a reduced temperature (e.g., below about 10°C) to crystallize ammonium nitrate **738**. Because ammonium nitrate **738** is highly soluble in acid, it may only be necessary to intermittently operate the separation step **736** to remove ammonium nitrate **738**. Ammonium nitrate is valuable and salable by-product that is widely used in the fertilizer industry and may represent a significant source of revenue from the process.

[00135] As illustrated in **Fig. 7**, after separation of the ammonium nitrate **738** (intermittently or continuously), the nitric acid **740** (e.g., recycled nitric acid) may be recycled back to the process, e.g., back to the acid digestion step **722**. Thus, the acid (e.g., input at **720**) may be contained in an essentially "closed loop" within the process. Additional nitric acid may be generated during the solvent extraction circuit due to cationic ion exchange releasing protons into solution. In this regard, a substantial quantity of the nitric acid required for the acid digestion step may be provided by the recycled nitric acid **740**, and only a small amount of fresh nitric acid **720** may be required for the process once steady state and continuous operations are achieved and maintained.

[00136] **Fig. 7** illustrates the integration of a solvent extraction circuit for the extraction of high purity REEs as metals from the nitrate solution containing the REEs. In other embodiments, it may be

advantageous to integrate the method(s) described herein for the precipitation of thorium from an acidic solution with a circuit for precipitating the REEs, e.g., as REE-oxides and/or REE-hydroxides.

[00137] In this regard, **Fig. 8** illustrates an example of an integrated process similar to the process illustrated in **Fig. 7**, but where an REE precipitation circuit replaces the solvent extraction circuit of **Fig. 7**. Thus, the thorium depleted and REE-nitrate rich solution can be treated to precipitate high purity REE-compounds such as REE-oxides and/or REE-hydroxides which, for example, may be shipped to a separate facility for extraction of the REEs as metals.

[00138] Referring to **Fig. 8**, the thorium depleted solution **806** from the separation step **814b** will typically have a pH in the range of about pH 3.6 to about pH 4 (e.g., about pH 3.8) and will be rich in RE-nitrates and may contain no, or extremely low levels of, thorium and/or uranium. For example, the thorium depleted solution **806** may include not greater than about 1 ppm thorium and/or uranium. As illustrated in **Fig. 8**, this solution **806** is conveyed to an REE precipitation step **842**, where the solution **806** is contacted with an REE precipitation agent **844**. In one characterization, ammonium hydroxide is used for precipitation in both the precipitation step **844** to precipitate REEs and in the hydroxylation step(s) **810a/810b** to precipitate thorium. The REE precipitation agent **844** (e.g., a hydroxide ion source) may be added to the solution **806** in sufficient quantities to increase the pH of the solution, such as by increasing the pH to at least about pH 8, such as at least about pH 9. At these pH levels, the REEs will precipitate from the solution **806** as REE-hydroxides **846**, which may be separated from an REE-depleted nitrate solution **848** in a separation step **850**.

[00139] The RE-hydroxides **846** may then be converted from the RE-hydroxides to RE-oxides. As illustrated in **Fig. 8**, the RE-hydroxides **846** are conveyed to a drying step **852** where the RE-hydroxides are heated to a drying temperature that is sufficient to convert a substantial majority of the RE-hydroxides **846** to RE-oxides **854**. For example, the drying step **852** may include heating the RE-hydroxides **846** to a temperature of at least about 100°C, such as at least about 120°C, and not greater than about 160°C, such as not greater than about 150°C. In one example, the RE-hydroxides **846** are conveyed to a screw feed dryer for the substantially continuous production of the RE-oxides **854**. In another example, the RE-hydroxides **846** may be stockpiled as necessary and dried.

[00140] It is an advantage of this embodiment that the resulting RE-oxide product **854** will have a very high purity, particularly with respect to base metals and radioactive metals such as uranium and thorium. In one example, the RE-oxide product **854** has a REE purity of at least about 99.8% on a metals

basis, *i.e.*, the RE-oxide product **854** comprises at least about 99.8% RE-oxides, such as a purity of at least about 99.9% RE-oxides. For example, the RE-oxide product **854** may comprise not greater than about 1 ppm thorium. The uranium content may be not greater than 0.1 ppm, for example, such as not greater than about 0.01 ppm.

[00141] An REE-depleted nitrate solution **848** may also be recovered from the separation step **858**, and may have a high content of ammonium nitrate, such as from about 30 g/l to about 50 g/l ammonium nitrate. The solution **848** may be recycled to preserve nitrates and in particular to preserve ammonium in the process. As illustrated in **Fig. 8**, the REE-depleted nitrate solution **848** may be conveyed to a vessel **856** where ammonium hydroxide is stored for use in the process, *i.e.*, where the recycled nitrate solution **848** is added to fresh ammonium hydroxide **858**. An ammonium hydroxide product **860** such as an ammonium hydroxide solution may then be conveyed as needed to the process, *e.g.*, to hydroxylation steps **810a/810b** and/or to REE precipitation step **842**. Because the recycled REE-depleted nitrate solution will contain ammonium nitrates, it may be desirable to remove the ammonium nitrates from the ammonium hydroxide vessel **856** on a continuous or intermittent basis. In this regard, a portion **862** of the solution contained within vessel **856** may be periodically bled off from the vessel **856** and subjected to an ammonium nitrate precipitation step **864** to crystallize an ammonium nitrate by-product **866** and recycle an ammonium nitrate depleted solution **868** back to the vessel **856**. The ammonium nitrate by-product **866** will be of high purity and a valuable by-product of the process.

[00142] While one example for the precipitation of REE compounds from the thorium depleted solution have been described in detail, it will be appreciated that other methods may be applied. For example, in some examples, it may be desirable to directly precipitate the REEs as REE-nitrates from the thorium depleted solution.

[00143] As is noted above, the thorium-containing acidic solution **802** may contain REEs in addition to thorium, and may be formed by the dissolution of a variety of compounds in an acid (*e.g.*, dissolution by acid digestion). In some of the embodiments disclosed herein, and as is disclosed above, it is desirable that the REEs are in the form of RE-oxalates, *e.g.*, $\text{RE}_2(\text{C}_2\text{O}_4)_3$ or $\text{RE}_3(\text{C}_2\text{O}_4)_3$. Further, the acidic solution **802** may be formed by the dissolution of carbonate compounds, such as $\text{RE}_2(\text{CO})_3 \cdot x\text{H}_2\text{O}$, formed from RE-oxalates by a metathesis reaction to render the REEs soluble in an acid such as nitric acid, as is disclosed above. In addition, the RE-oxalates and/or the RE-carbonates may be converted to

RE-oxides, *e.g.*, by heating (calcining) at an elevated temperature in the presence of an oxidizing gas such as air.

[00144] As is disclosed above, many REE-containing ores include a relatively high concentration of cerium (Ce) as compared to other REEs. For example, in some RE-ore bodies cerium may comprise close to 50 wt.% of the total REEs on a metals basis. However, cerium has a lower value than many other REEs and it may be advantageous to separate the cerium from the other REEs, for example to reduce the size of the subsequent solvent extraction circuit and produce an REE-containing end product that has a higher value.

[00145] In this regard, one embodiment of the present disclosure is directed to the extraction of cerium from a Ce-containing product. The cerium may be extracted from the Ce-containing product by leaching the Ce-containing product in nitric acid (HNO_3) to dissolve (*e.g.*, solubilize) at least a portion (*e.g.*, at least a majority) of the Ce-containing product to form a cerium-containing acidic solution. The cerium-containing acidic solution may then be contacted with a hydroxide precipitant, *e.g.* ammonium hydroxide (NH_4OH), to precipitate at least a portion of the cerium as cerium (IV) hydroxide (*e.g.*, $\text{Ce}(\text{OH})_4$) and form a Ce-depleted solution and a Ce-hydroxide product. The cerium-depleted solution, which may contain high levels of valuable non-cerium REEs, may be separated from the Ce-hydroxide product. In some embodiments, the selectivity of the cerium precipitation may be enhanced by the use of a further precipitation step on the Ce-depleted solution step to further reduce the cerium concentration in the Ce-depleted solution.

[00146] By way of example, **Fig. 9** schematically illustrates a method for the extraction of cerium as cerium hydroxide ($\text{Ce}(\text{OH})_4$) from a cerium-containing acidic solution that includes a cerium species. Referring to **Fig. 9**, a Ce-containing product **902** is contacted with an acid solution **904** (*e.g.*, nitric acid) in a leaching step **910** that may be carried out in a reactor vessel **912a**. The Ce-containing product **902** may be any product (*e.g.*, a particulate solid product) that contains a cerium compound. The Ce-containing product **902** may also comprise other REEs whose subsequent recovery is desirable. For example, the Ce-containing product **902** may be derived from an ore (*e.g.*, from an ore concentrate) that includes cerium and at least one other REE. Often, the Ce-containing product **902** will comprise other REEs of relatively high value, *e.g.*, CREEs such as dysprosium, europium, terbium, lanthanum, neodymium, praseodymium and yttrium. The Ce-containing product **902** may be a product resulting from the processing of an ore concentrate to produce rare earth compounds, such as a rare earth oxide

product, a rare earth oxalate product, a rare earth carbonate product, or other rare earth compound(s) that are amenable to dissolution in an acid such as nitric acid. In one particular characterization, the Ce-containing product **902** comprises RE-oxalates and/or RE-oxides including cerium and non-Ce REEs. According to this embodiment, it is desirable to have the cerium in the Ce-containing product **902** in the Ce^{4+} oxidation state. In one example, at least about 90% of the cerium in the Ce-containing product **902** is in the Ce^{4+} oxidation state, such as where at least about 95% of the cerium, at least about 98% of the cerium, at least about 99% of the cerium or even at least about 99.5% of the cerium is in the Ce^{4+} oxidation state. In one particular embodiment, the Ce-containing product **902** is an RE-oxide product comprising cerium oxide. For example, the RE-oxide product may be formed by calcining (e.g., roasting) a cerium-containing oxide precursor (e.g., RE-carbonates and/or RE-oxalates) at a temperature and under conditions to form RE-oxides and convert a majority (e.g., substantially all) of the cerium to Ce^{4+} (e.g., as CeO_2). In one example, RE-oxides are formed by calcining the cerium-containing oxide precursor at a temperature of at least about 700°C , such as at least about 710°C to convert and/or maintain substantially all of the cerium as Ce^{4+} .

[00147] The Ce-containing product **902** may or may not comprise thorium. In this regard, the Ce-containing product may have been previously treated to remove thorium, such as by using the methods described above with respect to **Figs. 5-8**. Alternatively, the thorium may be precipitated before or may be co-precipitated with the cerium.

[00148] In one particular characterization, the Ce-containing product **902** is dispersed in an aqueous medium (e.g., water) to form a pulp (e.g., a slurry) of solid REE compounds (e.g., RE-oxalate and/or RE-oxide compounds), such as an aqueous pulp comprising at least about 20 wt.% solids and not greater than about 50 wt.% solids. Thus, a solid Ce-containing product (e.g., comprising solid particulate oxalate or oxide compounds) may be mixed with water to form the pulp, for example before leaching with a nitric acid solution **904**.

[00149] The nitric acid solution **904** is contacted with the Ce-containing product **902** for a period of time sufficient to dissolve (e.g., solubilize) at least a portion of the Ce-containing product **902**, such as for a period of time to dissolve a majority of the Ce-containing product **902**. In one characterization, at least about 95% of the Ce-containing product **902** is dissolved in the nitric acid solution **904** during the leaching step **910**. The leaching step **910** may be carried out at ambient temperature, although elevated temperatures such as in the range of at least about 80°C and not greater than about 90°C may be useful. Although slight overpressures may be used if desired, the leaching step **910** may be carried out at

ambient pressure, *e.g.*, of about 1 atm. During the leaching step **1110**, it is desirable for the nitric acid solution **904** to dissolve the Ce-containing product and to maintain a majority of the cerium from the Ce-containing product **902** in the Ce^{4+} oxidation state. To facilitate dissolving and maintaining the cerium in the Ce^{4+} oxidation state, the nitric acid solution **904** may be selected to be of relatively high strength. For example, upon dissolution of the cerium from the Ce-containing product **902**, the strength of the nitric acid solution **904** should be sufficient to provide a sufficient quantity of protons (H^+) in the solution **904** to maintain a majority of the cerium in the Ce^{4+} oxidation state, such as at least about 95% of the cerium in the Ce^{4+} oxidation state. According to this embodiment, it is desirable to maintain the cerium in the Ce^{4+} oxidation state, and although weaker acids may be able to dissolve the Ce-containing product **902**, the dissolved cerium may form in the Ce^{3+} oxidation state if the acid strength is not sufficiently high. For example, the nitric acid solution **904** may comprise at least about 65 wt.% HNO_3 , such as at least about 68 wt.% HNO_3 or even at least about 70 wt.% HNO_3 . Characterized another way, at least about 1.9 grams of HNO_3 may be added to the leaching step per gram of solid Ce-containing product (1.9 g HNO_3 /g Ce-product). In another characterization, not greater than about 2.4 g HNO_3 /g Ce-product may be added to the leaching step **910**. Characterized yet another way, the nitric acid liquor **906** may have a free acid content of at least about 18% and not greater than about 21% upon completion of the leaching step **910**.

[00150] The leaching step **910** will result in a leach product **907** comprising solids residue **908** and a cerium-containing acidic solution **906** that can be separated from the solids residue **908** (*e.g.*, undissolved matter) in a separating step **914a**, such as by using a filter **916a**. The solids residue **908** may be disposed as waste, or may be subjected to further treatment if valuable products (*e.g.*, non-REEs) are contained in the solids residue **908**.

[00151] The cerium-containing acidic solution **906** is then conveyed to a reactor **912b** where the cerium-containing acidic solution **906** is contacted with ammonium hydroxide **905** to precipitate at least a portion of the cerium as cerium hydroxide and form a precipitation stream **907b** comprising a cerium depleted solution **922** and a cerium hydroxide product **924**.

[00152] The precipitation step **918** (*e.g.*, contacting the cerium-containing acidic solution **906** with ammonium hydroxide **905**) may advantageously be carried out at ambient temperature and pressure, although elevated temperatures and/or pressures may be employed if desired. As is noted above, the cerium-containing acidic solution **906** coming into the reactor **912b** may have a relatively high free acid content (*e.g.*, at least about 18% free acid) to maintain the cerium as Ce^{4+} . As the cerium-containing

acidic solution **906** is contacted with the ammonium hydroxide **905**, the Ce^{4+} will begin to form a cerium (IV) ammonium nitrate complex that stabilizes the cerium in the Ce^{4+} state. Once the complex forms, and more ammonium hydroxide is added, the pH of the cerium-containing acidic solution **906** will increase. As the pH increases to about pH 3.5 or higher, the cerium (IV) ammonium nitrate complex will break down and the Ce^{4+} will begin to precipitate as cerium (IV) hydroxide, *i.e.*, as $\text{Ce}(\text{OH})_4$ and/or as highly insoluble cerium tetrahydroxide hydrate, *i.e.*, $\text{Ce}(\text{OH})_4 \cdot x\text{H}_2\text{O}$. However, a vast majority of the non-Ce REEs will advantageously remain dissolved in the cerium-containing acidic solution **906**, thereby separating a majority of the cerium from the other REEs.

[00153] The ammonium hydroxide **905** may be added to raise the pH of the cerium-containing acidic solution **906** in the reactor **912b** to a pH of at least about pH 3.5, such as at least about pH 4.0, at least about pH 4.5, or even at least about pH 5.0. Typically, the pH should not exceed about pH 6.0. In this manner, and in one example, a majority of the cerium originally contained in the cerium-containing acidic solution **906** may precipitate as Ce-hydroxide. The ammonium hydroxide **905** may be added as a solution to the cerium-containing acidic solution **906**, *e.g.*, as a solution having a strength of at least about 2.5M. In another characterization, the mass ratio of ammonium hydroxide **905** to cerium-containing acidic solution **906** in the reactor **912b** may be at least about 0.065 and may be not greater than about 0.087.

[00154] In one characterization, at least about 61% of the cerium originally in the cerium-containing acidic solution **906** will precipitate as Ce-hydroxide in the Ce-hydroxide product **924**, such as at least about 70% or even at least about 85% precipitating as Ce-hydroxide. Further, it is an advantage that the Ce-hydroxide product **924** comprises relatively low concentrations of non-Ce REEs (*e.g.*, as RE-hydroxides) and that a vast majority of the non-Ce REEs remain solubilized in the Ce-depleted solution **922**. In this regard, the Ce-hydroxide product **924** may comprise not greater than about 8 at.% of non-Ce REEs on a metals basis, such as not greater than about 4 at.% of non-Ce REEs on a metals basis. In another characterization, at least about 90 at.% of the non-Ce REEs from the cerium-containing acidic solution **906** may remain solubilized in the Ce-depleted solution **922**, such as at least about 96 at.%. Nonetheless, it may be desirable to recover additional REEs of high value, such as Nd, from the Ce-hydroxide product **924**, such as by subjecting the Ce-hydroxide product **924** to solvent extraction (discussed below).

[00155] Although a majority of the cerium may be extracted from the Ce-containing product **902** in the Ce-hydroxide product **924**, it may be desirable to increase the recovery of cerium and form an even purer (*i.e.*, lower cerium concentration) Ce-depleted solution **922** by conducting a two-step process for cerium precipitation. As is illustrated in **Fig. 10**, the step of contacting the cerium-containing acidic solution with ammonium hydroxide to precipitate cerium may include first contacting the cerium-containing acidic solution with ammonium hydroxide to raise the pH to a first pH to precipitate cerium as cerium hydroxide and form an intermediate cerium depleted solution and a first cerium hydroxide product, and second contacting the intermediate cerium depleted solution with the ammonium hydroxide to raise the pH to a second pH, wherein the second pH is greater than the first pH, to precipitate additional solubilized cerium as cerium hydroxide and form the cerium depleted solution and a second cerium hydroxide product.

[00156] Referring to **Fig. 10**, such a two-stage precipitation process is schematically illustrated. A cerium-containing acidic solution **1006** comprising dissolved cerium, and possibly appreciable quantities of other REEs, is contacted with ammonium hydroxide **1005b** in a reactor **1012b** in a first contacting step **1018b**. A first precipitation product **1020b** is removed from the reactor **1012b** and may be subjected to a separation step **1014b**, *e.g.*, using a filter **1016b**. A Ce-hydroxide product **1024b** is separated from an intermediate Ce-depleted solution **1026**. The Ce-depleted solution **1026** may then be contacted with additional ammonium hydroxide **1005c** in a second contacting step **1018c**, such as in a second reactor **1012c**. After the precipitation of additional cerium from the intermediate Ce-depleted solution **1026**, a second precipitation product **1020c** may be recovered and separated **1014c** into a final Ce-depleted solution **1022c** and a second Ce-hydroxide product **1024c**.

[00157] In accordance with the embodiment illustrated in **Fig. 10**, the second pH (*e.g.*, in reactor **1016c**) is higher than the first pH (*e.g.*, in reactor **1016b**). In one example, sufficient ammonium hydroxide **1005b** is added to the first reactor **1012b** to raise the pH of the cerium-containing acidic solution to at least about pH 3.5, such as at least about pH 4, and not greater than about pH 4.5. In the second precipitation step **1018c**, sufficient ammonium hydroxide **1005c** is added to the reactor **1018c** to further increase the pH of the intermediate cerium-depleted solution to at least about pH 5, such as at least about pH 5.5, and not greater than about pH 6.

[00158] As is noted above, the Ce-containing product may also include appreciable amounts of thorium. For example, in some characterizations, the cerium-containing acidic solution may include at

least about 50 mg/l thorium, such as at least about 100 mg/l thorium, and not greater than about 2000 mg/l thorium, such as not greater than about 1600 mg/l thorium. In any event, in some embodiments, the precipitation process for the precipitation of cerium may also co-precipitate the thorium such that at least about 98%, at least about 99%, at least about 99.5%, at least about 99.98% or even at least about 99.999% of the thorium in the cerium-containing acidic solution is removed with the Ce-hydroxide product, e.g., as thorium hydroxide. Thus, the cerium depleted solution may comprise not greater than about 0.01 at.% thorium, such as not greater than about 0.002 at.% thorium.

[00159] Thus, when the cerium-containing acidic solution comprises thorium, the thorium may precipitate with the cerium (IV) hydroxide as thorium hydroxide. The thorium hydroxide may then be optionally separated from the cerium (IV) hydroxide in the manner noted above (e.g., as illustrated in **Figs. 5 and 6**) for the selective precipitation of thorium hydroxide. That is, the Ce-containing product may be redissolved into acid under conditions that a majority of the cerium exists in the Ce^{3+} oxidation state such that cerium will not co-precipitate with thorium - the cerium and any traces of other REEs will remain in solution.

[00160] The following embodiments of the present disclosure relates to a method for the selective separation of REEs from a product containing a plurality of REEs, which may also contain other elements such as thorium (Th) and uranium (U). The REE-containing product may be a solution and/or a solid containing the REEs, where the product is derived from naturally occurring minerals by chemical processing of the minerals to separate the valuable elements from the ore, e.g., as is disclosed in detail above.

[00161] Before separation of valuable REEs from the REE-containing product, the REE-containing product may be treated to partially or completely remove thorium and/or cerium from the REE-containing product. Some methods for the selective extraction of thorium and/or cerium are described above. In some characterizations, the REE-containing product may also include uranium, and the uranium may also be completely or partially removed with the thorium and/or cerium. In accordance with the following embodiments, thorium and/or cerium removal may be carried out by selective precipitation and/or by solvent extraction to increase the purity of the REE-containing product with respect to non-Ce REEs, thorium and possibly uranium.

[00162] The processes for thorium and/or cerium removal may be initiated from a rare earth oxide (RE-oxide) product. When the RE-oxide product comprises thorium it has been found to be

advantageous if substantially all of the thorium in the RE-oxide product is present as Th(IV), *i.e.*, in the Th⁴⁺ oxidation state. As is discussed in more detail below, starting with the thorium in the Th⁴⁺ oxidation state in the RE-oxide product and in the REE-containing acidic solution will facilitate the selective extraction of the thorium from the REEs and other elements in the REE-containing acidic solution. One method to ensure that a substantial proportion (*e.g.*, greater than 99%) of the thorium in the RE-oxide product is in the 4+ oxidation state is to calcine the RE-oxide product at an elevated temperature. In one characterization, the RE-oxide product is calcined at a temperature of at least about 710°C, such as at least about 750°C, *e.g.*, in an oxidizing environment such as in air. For example, an RE-oxalate powder or an RE-carbonate powder can be calcined under these conditions to form the RE-oxide product. It is believed that these temperatures in combination with an oxygen-containing gas (*e.g.*, air) will be sufficient to ensure substantially complete conversion of the thorium to the Th(IV) oxidation state in the solid state.

[00163] To sustain this high oxidation state achieved in the solid state for thorium, the calcined RE-oxide product may advantageously be dissolved in a stabilizing acidic solution having sufficient excess protons (H⁺) and nitrates (NO₃⁻), but with less reducing ions such as OH⁻.

[00164] Thus, referring to **Fig. 11**, the REE-containing product may be a RE-oxide product **1102**, *e.g.*, that is predominately comprised of rare earth oxide compounds. The RE-oxide product **1102** is digested **1106** in an acid, for example nitric acid **1104** (H⁺, NO₃⁻), to form a first REE solution **1108** comprising solubilized REEs. The RE-oxide product **1102** may be of relatively high purity with respect to REEs. In one example, the RE-oxide product **1102** comprises at least about 90% REEs, such as at least about 95% REEs or even at least about 98% REEs on a metals basis. The methods disclosed above are capable of producing an RE-oxide product **1102** of such high purity. For example, the RE-oxide product **1102** may be contacted with a 70% solution of HNO₃ to digest all or substantially all of the REEs in the RE-oxide product **1102** (*e.g.*, digest at least about 95% of the REEs) and form a (first) acidic REE solution **1108** comprising dissolved (solubilized) REEs. In one characterization, at least about 98% of the REEs in the RE-oxide product **1102** are digested by the nitric acid. The resulting REE acidic solution **1108** may include REEs in a concentration of at least about 10 grams per liter (g/l). In certain characterizations, the REE acidic solution **1108** includes a relatively high concentration of REEs, such as at least about 15 g/l REEs, at least about 20 g/l REEs, at least about 30 g/l or even at least about 50 g/l REEs, where the REEs are solubilized in the REE-containing acidic solution **1108**. Typically, the REE-containing acidic solution **1108** will include not greater than about 100 g/l REEs. Further, the REE-containing acidic solution **1108** may have, for example, a relatively high acid concentration of at least

about 18% HNO_3 (*i.e.*, at least about 4.5M), or even at least about 22% HNO_3 (*i.e.*, at least about 6M). It may be desirable to add a sufficient amount of acid to the REE-containing acidic solution **1108** to ensure such high levels of acidity, *e.g.*, by adding additional acid beyond the amount that is stoichiometrically required to digest all of the RE-oxide product **1102**.

[00165] Thus, the RE-oxide product **1102** may contain thorium and in one example the RE-oxide product **1102** comprises at least about 0.5% thorium, such as at least about 1% thorium, and not greater than about 5% thorium, such as not greater than about 3% thorium on a metals basis.

[00166] With respect to cerium, and merely by way of example, the RE-oxide product **1102** may contain a significant proportion of cerium. For example, the RE-oxide product **1102** may contain at least about 35% cerium, at least about 40% cerium, or even at least about 50% cerium on a metals basis.

[00167] Importantly, the RE-oxide product **1102** may comprise a plurality of CREEs. For example, the RE-oxide product **1102** may comprise at least about 15 at.% CREEs such as at least about 20 at.% CREEs or even at least about 25 at.% CREEs on a metals basis. Among these, the RE-oxide product **1102** may comprise at least about 15 at.% combined Pr and Nd, such as at least about 22 at.% combined Pr and Nd.

[00168] The RE-oxide product **1102** may also contain some HREEs. By way of example, the RE-oxide product **1102** may contain at least about 0.1 at.% HREEs and not greater than about 1 at.% HREEs on a metals basis.

[00169] Further, the RE-oxide product **1102** may also comprise LREEs. For example, the RE-oxide product **1102** may comprise at least about 85 at.% LREEs, such as at least about 90 at.% LREEs, and typically not greater than about 95 at.% LREEs on a metals basis. The majority of the LREEs will typically be cerium. Among the other LREEs, the RE-oxide product **1102** may contain at least about 10% La, such as at least about 18% La, and typically may contain not greater than about 30% La. Further, the RE-oxide product **1102** may also contain gadolinium (Gd) – a HREE, and in one example contains at least about 3% of combined Gd and Sm.

[00170] The RE-oxide product **1102** may contain other metallic elements; however it is generally desirable that other metallic elements in the RE-oxide product be present in very low concentrations. For example, it is desirable that the RE-oxide product **1102** contain no greater than about 0.05 at.% base metals on a metals basis, such as not greater than about 0.02 at.% base metals, *e.g.*, no detectable

concentrations of base metals. Non-metallic trace elements in the RE-oxide product **1102** may include silica (SiO_2) and unburnt carbon (C), e.g., from the rare earth oxalate powder in a kiln.

[00171] It will be recognized by those skilled in the art that the foregoing description of the constituents of the RE-oxide product **1102** are merely by way of example, and the methods described herein are not limited to any specific REE-containing product.

[00172] Referring back to **Fig. 11**, the RE-oxide product **1102** is digested in an acid, such as nitric acid **1104**. For example, the RE-oxide product **1102** may be contacted with a 70% solution of HNO_3 to digest all or substantially all of the REE's in the RE-oxide product **1102** (e.g., at least about 95% of the REEs) and form a first REE solution **1108**. In one characterization, at least about 98% of the REEs in the RE-oxide product **1102** are digested by the nitric acid. The resulting REE solution **1108** may include REEs in a concentration of at least about 10 g/l. In certain characterizations, the REE solution **1108** includes a relatively high concentration of REEs, such as at least about 15 g/l REEs, at least about 20 g/l REEs, at least about 30 g/l or even at least about 50 g/l REEs, where the REEs are solubilized (e.g., dissolved) into the REE solution **1108**. Typically, the REE solution **1108** will include not greater than about 100 g/l REEs. Further, the REE solution **1108** may have, for example, a relatively high acid concentration of at least about 18% HNO_3 (i.e., at least about 4.5M), or even at least about 22% HNO_3 (i.e., at least about 6M). It may be desirable to add a sufficient amount of acid to the RE-oxide product **1102** to ensure such high levels of acidity, e.g., by adding additional acid beyond the amount that is stoichiometrically required to digest all of the RE-oxide product **1102**. While not wishing to be bound by any particular theory, it is believed that such high acidity levels will assist to maintain the +4 oxidation state of cerium and thorium species in the REE solution **1108**, and that this oxidation state facilitates the complexation and subsequent removal of cerium and thorium from REE solutions by chemical precipitation.

[00173] The first REE solution **1108** is then contacted with a compound to increase the pH of the first REE solution **1108**. Particularly, the REE solution **1108** is contacted **1112** with a hydroxide ion source such as ammonium hydroxide (NH_4OH) **1110** to precipitate a first precipitation product **1116** and form a second REE solution **1118**. A sufficient amount of NH_4OH **1110** is contacted with the first REE solution **1108** to raise the pH of the first REE solution **1108** to a sufficient level to selectively precipitate thorium and cerium from the first REE solution **1108**. For example, a quantity of an aqueous solution of NH_4OH (e.g., 58% NH_4OH in water) may be added to the first REE solution **1108** until the pH increases

to a point that appreciable quantities of thorium and/or cerium precipitate from the first REE solution **1108** as Th-hydroxide and/or Ce-hydroxide. In one characterization, a sufficient amount of NH_4OH **1110** is added to the first REE solution **1108** to increase the pH to at least about pH 4, such as at least about pH 4.2, at least about pH 4.4, or even at least about pH 4.6. In one particular characterization, a sufficient amount of NH_4OH is added to the first REE solution **1108** to increase the pH to about pH 4.8. However, it is desirable to not increase the pH to a point where appreciable quantities of CREEs also precipitate from the first REE solution **1108**. As such, in one example, the addition of NH_4OH **1110** to the first REE solution **1108** does not increase the pH to above about pH 5.5, such as to not greater than about pH 5.0. In one particular characterization, a sufficient amount of NH_4OH **1110** is added to the first REE solution **1108** to increase the pH to within the range of about pH 4.2 to about pH 5.0. Within the foregoing pH ranges, certain elements (e.g., Ce and Th) will selectively report to the first precipitation product **1116** relative to other elements (REEs) from the RE-oxide product **1102**.

[00174] The first precipitation product **1116** is then separated **1114** from a second REE solution **1118**, e.g., using a filter. It has been found that the first precipitation product **1116** will advantageously have a relatively low mass as compared to the mass of the RE-oxide product **1102**. In one example, the mass of the first precipitation product **1116** will be not greater than about 40% of the mass of the RE-oxide product **1102**, such as not greater than about 30%, not greater than about 20% or even not greater than about 15% of the mass of the RE-oxide product **1102**. Stated another way, not greater than about 30% of the metallic elements from the RE-oxide product **1102** will report to (*i.e.*, will precipitate in) the first precipitation product **1116**, such as not greater than about 25%, not greater than about 20% or even not greater than about 15% of the metallic elements from the RE-oxide product **1102**.

[00175] Despite having a relatively low mass as compared to the RE-oxide product **1102** that is input to the process, the first precipitation product **1116** may comprise a substantial amount of the thorium that is contained in the RE-oxide product **1102**. In one example, the first precipitation product **1116** includes at least about 95% of the thorium from the RE-oxide product **1102**, and in certain examples may include at least about 98% of the thorium from the RE-oxide product **1102**, such as at least about 99% or event at least 99.5% of the thorium from the RE-oxide product **1102**. It is of particular advantage that such a high level of the thorium from the RE-oxide product **1102** reports to a precipitation product having a low mass as compared to the mass of the RE-oxide product **1102**. Thus, the first precipitation product **1116** may have a thorium content of at least about 8%, such as at least about 12% or even at least about 15%.

Although the first precipitation product **1116** may have even higher concentrations of thorium, typically the thorium content will not exceed about 25%.

[00176] The first precipitation product **1116** may also contain cerium that co-precipitates with the thorium during the contacting step **1112**. For example, the first precipitation product may contain at least about 50% of the cerium from the RE-oxide product **1102**, such as at least about 60% of the cerium from the RE-oxide product **1102**. In another characterization the first precipitation product **1116** may contain at least about 50% cerium, such as at least about 60% cerium or even at least about 70% cerium. Typically, the first precipitation product will contain not greater than about 80% cerium.

[00177] As is noted above, the RE-oxide product **1102** may also contain CREEs, and the first precipitation product **1116** may contain some CREEs, *i.e.*, a relatively small amount of CREEs may co-precipitate with the thorium and cerium during the contacting step **1112**. For example, the first precipitation product **1116** may include not greater than about 15% of the CREEs from the RE-oxide product **1102**, or even not greater than about 10%, such as not greater than about 8% of the CREEs from the RE-oxide product **1102**. In another characterization, the first precipitation product **1116** may include not greater than about 20% CREEs, such as not greater than about 15% CREEs. Typically, the first precipitation product **1116** will contain at least about 1% CREEs, such as at least about 3% CREEs.

[00178] The RE-oxide product **1102** may also contain HREEs, and the first precipitation product **1116** may include some of these HREEs, *i.e.*, a relatively small amount of HREEs may co-precipitate with the thorium and cerium during the contacting step **1112**. For example, the first precipitation product **1102** may include at least about 25% of the HREEs from the RE-oxide product **1102**, and may include not greater than about 40% of the HREEs from the RE-oxide product **1102**. In another characterization, the first precipitation product **1116** may contain not greater than about 4% HREEs, such as not greater than about 3% HREEs. Typically, the first precipitation product **1116** will contain at least about 1% HREEs, such as at least about 1.5% HREEs.

[00179] The RE-oxide product **1102** may also contain LREEs, and the first precipitation product **1116** may include these LREEs, particularly cerium as is discussed above. For example, the first precipitation product **1116** may include at least about 8% of the LREEs from the RE-oxide product **1102**, such as at least about 10%, and typically will include not greater than about 15% of the LREEs from the RE-oxide product **1102**, such as not greater than about 12%. In another characterization, the first precipitation product **1116** may contain at least about 70% LREEs, such as at least about 75% LREEs. Typically, the

first precipitation product **1116** will contain not greater than about 85% LREEs. Among the LREEs in addition to cerium, at least about 0.5% of the La and not greater than about 1.5% of the La from the RE-oxide product **1102** may precipitate with the first precipitation product **1116**. In another characterization, the first precipitation product may contain at least about 0.8% and not greater than about 1.5% La.

[00180] Also, among the CREEs, Pr and Nd are of a particularly high value. Accordingly, it is an advantage that a relatively low proportion of the Pr and Nd report to the first precipitation product **1116**. For example, not greater than about 8%, such as not greater than about 6% of the combined Pr and Nd from the RE-oxide product **1102** will typically precipitate with the first precipitation product **1116**. Typically, at least about 3% of the combined Pr and Nd will precipitate with the first precipitation product **1116**. In another characterization, the first precipitation product **1116** will typically include not greater than about 15% combined Pr and Nd, such as not greater than about 12% combined Pr and Nd, such as not greater than about 10% combined Pr and Nd. Typically, the first precipitation product **1116** will include at least about 5% combined Pr and Nd.

[00181] Further, Gd and Sm may be of particular value for many applications, and it is an advantage that a relatively small proportion of the Gd and Sm report to the first precipitation product **1116**. For example, the first precipitation product **1116** may include not greater than about 15% of the combined Gd and Sm from the RE-oxide product **1102**. Typically, the first precipitation product **1116** will include at least about 8% of the Gd and Sm from the RE-oxide product **1102**. In another characterization, the first precipitation product **1116** will include not greater than about 0.5% combined Gd and Sm, such as not greater than about 0.1% or even not greater than about 0.05% combined Gd and Sm.

[00182] It will be appreciated that the foregoing ranges of elements in the RE-oxide product **1102** and the first precipitation product **1116** are provided by way of example only, and are intended to illustrate the general proportions of the different elements that precipitate in the first precipitation product **1116**. The actual compositions will depend upon the mineral ore from which the RE-oxide product **1102** is derived, and the process conditions of the contacting step **1112** to precipitate the first precipitation product **1116**.

[00183] After separation **1114** of the first precipitation product **1116** from the second REE solution **1118**, the second REE solution **1118** includes the REEs and other elements that did not precipitate during the contacting step **1112**. The pH of the second REE solution **1118** is increased **1120** by adding additional NH_4OH **1122** to the second REE solution **1118**. A sufficient amount of NH_4OH **1122** should

be added to the second REE solution precipitate substantially all (e.g., at least about 99.5%) of the metallic elements in the second REE solution **1120** as a first REE digestion feed **1128**. For example, the first REE digestion feed **1128** may comprise solid hydroxide compounds of the metallic elements from the second REE solution **1118**.

[00184] The first REE digestion feed **1128** is then separated from a barren solution **1126**. The barren solution **1126** may be recycled to conserve OH⁻ values in the circuit. After separation, the first REE digestion feed **1128** is digested **1132** in nitric acid **1130** to re-solubilize the metallic elements into a third REE solution **1134**. A sufficient amount of acid **1130** should be contacted with the first REE digestion feed **1128** to digest (solubilize) substantially all (e.g., at least 99.5%) of the metallic elements in the first REE digestion feed **1128**. The conditions of the digestion step **1132** may be similar to the digesting step **1106** described above. For example, the first REE digestion feed **1128** may be contacted with a 70% solution of HNO₃ to digest all or substantially all of the REEs in the first REE digestion feed **1128** and form a third REE solution **1134**. The third REE solution **1134** may have, for example, a relatively high acid concentration of at least about 18% HNO₃ (i.e., at least about 5M), or even at least about 20% HNO₃ (i.e., at least about 8M). It may be desirable to add a sufficient amount of acid to the first REE digestion feed **1128** to ensure such high levels of acidity, e.g., by adding additional acid beyond the amount that is stoichiometrically required to digest all of the first REE digestion feed **1128**.

[00185] The third REE solution **1134** is then contacted **1136** with additional NH₄OH **1138** to precipitate a second precipitation product **1142** and form a fourth REE solution **1144**. The conditions of the contacting step **1136** may be similar to the conditions described above with respect to the contacting step **1112**. For example, a sufficient amount of NH₄OH **1138** may be contacted with the third REE solution **1134** to raise the pH of the third REE solution **1134** to a sufficient level to selectively precipitate additional cerium and traces of thorium from the third REE solution **1134**. For example, a quantity of an aqueous solution of NH₄OH (e.g., 58% NH₄OH in water) may be added to the third REE solution **1134** until the pH increases to a point that appreciable quantities of cerium precipitate from the third REE solution **1134**, e.g., as Ce-hydroxide. In one characterization, a sufficient amount of NH₄OH **1138** is added to the third REE solution **1134** to increase the pH to at least about pH 4, such as at least about pH 4.2, at least about pH 4.4, or even at least about pH 4.6. In one particular characterization, a sufficient amount of NH₄OH is added to the third REE solution **1134** to increase the pH to about pH 4.8. However, it is desirable to not increase the pH to a point where appreciable quantities of CREEs also precipitate from the third REE solution **1134**. As such, in one example, the addition of NH₄OH to the third REE

solution **1134** does not increase the pH to above about pH 5.5, such as to not greater than about pH 5.0. In one particular characterization, a sufficient amount of NH_4OH **1138** is added to the third REE solution **1134** to increase the pH to within the range of about pH 4.2 to about pH 5.0. Within the foregoing pH ranges, certain elements (e.g., Ce) will selectively report to the second precipitation product **1142** relative to other elements.

[00186] The second precipitation product **1142** is then separated **1140** from a fourth REE solution **1144**, e.g., using a filter. The second precipitation product **1142** may have a mass that is approximately 25% of the mass of the RE-oxide product **1102** that is input to circuit, and approximately twice the mass of the first precipitation product **1116**. In one example, the mass of the second precipitation product **1142** will be not greater than about 40% of the mass of the RE-oxide product **1102**, such as not greater than about 35%, or even not greater than about 30% of the mass of the RE-oxide product **1102**. Stated another way, not greater than about 40% of the metallic elements from the RE-oxide product **1102** will report to (*i.e.*, will precipitate in) the second precipitation product **1142**, such as not greater than about 35%, or even not greater than about 30%. Typically, the mass of the second precipitation product **1142** will be at least about 15% of the mass of the RE-oxide product **1102**, such as at least about 20%.

[00187] Although a significant amount of the thorium from the RE-oxide product **1102** will report to the first precipitation product **1116**, some thorium may remain in the second REE solution **1118** and report to the second precipitation product **1142**. In one example, the second precipitation product **1142** includes at least about 0.001% thorium and not greater than about 0.05% thorium, such as not greater than about 0.03% thorium. As such, all or substantially all of the thorium may advantageously report to either the first precipitation product **1116** or the second precipitation product **1142**.

[00188] The second precipitation product **1142** may also include a substantial concentration of cerium. For example, the second precipitation product **1142** may comprise at least about 75% cerium, such as at least about 80% cerium or even at least about 85% cerium on a metals basis. Typically, the second precipitation product **1142** will include not greater than about 90% cerium. Thus, it can be seen that a significant portion of the cerium from the REO 102 may advantageously report to either the first precipitation product **1116** or the second precipitation product **1142**. For example, at least about 70%, or even at least about 75% of the cerium from the RE-oxide product **1102** may report to either the first precipitation product **1116** or the second precipitation product **1142**.

[00189] As is noted above, the RE-oxide product **1102** may also include CREEs, and it is an advantage that a majority of the CREEs may remain un-solubilized (*i.e.*, remain in the fourth REE solution **1144**). As such, the second precipitation product **1142** may include not greater than about 10% of the CREEs from the RE-oxide product **1102**, or even not greater than about 8% of the CREEs from the RE-oxide product **1102**. In another characterization, the second precipitation product **1142** may include not greater than about 15% CREEs, such as not greater than about 10% CREEs. Typically, the second precipitation product **1142** will include at least about 3% CREEs, such as at least about 5% CREEs.

[00190] The second precipitation product **1142** may include some HREEs, *i.e.*, a relatively small amount of HREEs. For example, the second precipitation product **1142** may include at least about 15% of the HREEs from the RE-oxide product **1102**, such as at least about 20% of the HREEs from the RE-oxide product **1102**, and may include not greater than about 40% of the HREEs from the RE-oxide product **1102**, such as not greater than about 30% of the HREEs from the RE-oxide product **1102**. In another characterization, the second precipitation product **1142** may include not greater than about 2% HREEs, such as not greater than about 1% HREEs. Typically, the second precipitation product **1142** will include at least about 0.1% HREEs, such as at least about 0.5% HREEs.

[00191] The RE-oxide product **1102** may also include LREEs, and the second precipitation product **1142** may include a substantial amount of LREEs, particularly cerium. For example, the second precipitation product **1142** may include at least about 20% of the LREEs from the RE-oxide product **1102**, such as at least about 22%, or even at least about 25%, and typically will include not greater than about 35% of the LREEs from the RE-oxide product **1102**, such as not greater than about 30%. In another characterization, the second precipitation product **1142** may include at least about 90% LREEs, such as at least about 95% LREEs. Typically, the second precipitation product **1142** will include not greater than about 99% LREEs. Among the LREEs in addition to cerium, at least about 1% of the La and not greater than about 4% of the La from the RE-oxide product **1102**, such as from about 2% to about 3% of the La from the RE-oxide product **1102**, may precipitate with the second precipitation product **1142**. In another characterization, the second precipitation product **1142** may include at least about 2% and not greater than about 3% La.

[00192] Also, among the CREEs, Pr and Nd are of a particularly high value. Accordingly, it is an advantage that a relatively low proportion of the Pr and Nd report to the second precipitation product **1142**. For example, not greater than about 10%, such as not greater than about 8% of the combined Pr

and Nd from the RE-oxide product **1102** will typically precipitate with the second precipitation product **1142**. Typically, at least about 3% of the combined Pr and Nd from the RE-oxide product **1102** will precipitate with the second precipitation product **1142**. In another characterization, the second precipitation product **1142** will typically include not greater than about 12% combined Pr and Nd, such as not greater than about 10% combined Pr and Nd, such as not greater than about 8% combined Pr and Nd. Typically, the second precipitation product **1142** will include at least about 3% combined Pr and Nd.

[00193] Further, Gd and Sm may be of particular value for many applications, and it is an advantage that a relatively small proportion of the Gd and Sm report to the second precipitation product **1142** and that substantial concentrations of the Gd and Sm remain in solution, *e.g.*, in the fourth REE solution **1144**. For example, the second precipitation product **1142** may include not greater than about 18% of the combined Gd and Sm from the RE-oxide product **1102**, such as not greater than about 15%. Typically, the second precipitation product **1142** will include at least about 8% of the Gd and Sm from the RE-oxide product **1102**. In another characterization, the second precipitation product **1142** will include not greater than about 4% combined Gd and Sm, such as not greater than about 3% or even not greater than about 2.5% combined Gd and Sm.

[00194] It will be appreciated that the foregoing ranges of elements in the second precipitation product **1142** are provided by way of example only, and are intended to illustrate the general proportions of the different elements that precipitate in the second precipitation product **1142**. The actual compositions will depend upon the mineral ore from which the RE-oxide product **1102** is derived, and the process conditions (*e.g.*, pH) of the (first) contacting step **1112** to precipitate the first precipitation product **1116**, and the process conditions of the (second) contacting step **1136** to precipitate second precipitation product **1142**.

[00195] The fourth REE solution **1144** is a high purity REE solution and is a salable product that may be taken directly to a solvent extraction circuit to selectively remove REEs from the solution **1144**. Alternatively, the fourth REE solution **1144** may be treated **1146** to increase the pH of the fourth REE solution **1144**, such as by adding additional NH_4OH to the fourth REE solution, to precipitate REEs, *e.g.*, as RE-hydroxides, that may be separated **1150** from a barren solution **1154** in the form of a very high purity third precipitation product **1152**. Thus, although the characteristics of the third precipitation product **1152** are provided below, it is to be appreciated that the same characteristics with respect to product

purity and the presence or absence of particular metallic elements will also apply to the fourth REE solution **1144**.

[00196] In one characterization, a sufficient amount of additional NH_4OH **1148** is added to the fourth REE solution **1144** to precipitate substantially all, e.g., at least about 99.5%, of the REEs from the fourth REE solution **1144** and form a very high purity solid REE-containing product.

[00197] In any event, the third precipitation product **1152** is separated **1140** from a fourth REE solution **1144**, e.g., using a filter. The third precipitation product **1152** may have a mass that is approximately 50% or more of the mass of the RE-oxide product **1102** that is input to circuit illustrated in **Fig. 11**, and approximately twice the mass of the second precipitation product **1142**. In one example, the mass of the third precipitation product **1152** will be at least about 50% of the mass of the RE-oxide product **1102**, such as at least about 55% of the mass of the RE-oxide product **1102**. Stated another way, at least about 50% of the metallic elements from the RE-oxide product **1102** will report to (*i.e.*, will precipitate in) the second precipitation product **1142**, such as at least about 55%. Typically, not greater than about 65% of the metallic elements from the RE-oxide product **1102** will report to the third precipitation product **1152**.

[00198] It is of a particular advantage that the third precipitation product **1152** may have an extremely high purity with respect to total REEs (TREEs). In one characterization, the third precipitation product **1152** comprises at least about 99% TREEs. Even higher purities may be obtained, and in some examples the third precipitation product **1152** comprises at least 99.9% TREEs, or even at least 99.99% TREEs, or even at least about 99.999% TREEs.

[00199] In one example, as is described above, substantially all of the thorium from the RE-oxide product **1102** may be removed with the first precipitation product **1116** and the second precipitation product **1142**. Thus, the third precipitation product **1152** may include little or no thorium. In one example, not greater than 0.01% of the thorium from the RE-oxide product **1102** reports to the third precipitation product **1152**. In another example, the third precipitation product **1152** includes not greater than 0.001% thorium, such as not greater than 0.0005% thorium. In one example, the level of thorium in the third precipitation product **1152** is undetectable, *i.e.*, is undetectable using inductively coupled plasma mass spectrometry ("ICP-MS").

[00200] The third precipitation product **1152** may also include relatively low levels of cerium. For example, the third precipitation product **1152** may comprise not greater than about 20% cerium such as

not greater than about 15% cerium, not greater than about 10% cerium, or even not greater than about 5% cerium. In another example, the third precipitation product **1152** will include not greater than about 30% of the cerium from the RE-oxide product **1102**, such as not greater than about 20%, or even not greater than about 15% of the cerium from the RE-oxide product **1102**.

[00201] As is noted above, the RE-oxide product **1102** may also include CREEs, and it is an advantage that a majority of the CREEs may report to the third precipitation product **1152**. In one example, the third precipitation product **1152** may contain at least about 30% CREEs, such as at least about 35% CREEs, or even at least about 38% CREEs. Typically, the third precipitation product **1152** will contain not greater than about 50% CREEs. In another example, at least about 75% of the CREEs from the RE-oxide product **1102** will report to the third precipitation product **1152**, such as at least about 80%, at least about 83% or even at least about 86% of the CREEs from the RE-oxide product **1102**. Thus, it can be seen that the third precipitation product **1152** may be rich in CREEs while including little or no thorium.

[00202] The third precipitation product **1152** may include some HREEs, *i.e.*, a relatively small amount of HREEs. For example, the third precipitation product **1152** may include not greater than about 50% of the HREEs from the RE-oxide product **1102**, such as not greater than about 45% of the HREEs from the RE-oxide product **1102**. In another characterization, the third precipitation product **1152** may include not greater than about 1% HREEs, such as not greater than about 0.8% HREEs.

[00203] The third precipitation product **1152** may include a substantial amount of LREEs. For example, the third precipitation product **1152** may contain at least about 40% of the LREEs from the RE-oxide product **1102**, such as at least about 50%, or even at least about 55% of the LREEs from the RE-oxide product **1102**, and typically will include not greater than about 70% of the LREEs from the RE-oxide product **1102**. In another characterization, the third precipitation product **1152** may include at least about 88% LREEs, such as at least about 90% LREEs, or even at least about 92% LREEs. Typically, the third precipitation product **1152** will include not greater than about 99% LREEs. Among the LREEs, at least about 85% of the La from the RE-oxide product **1102** may report to the third precipitation product **1152**, such as at least about 90% of the La, or even at least about 95% of the La from the RE-oxide product **1102** may report to the third precipitation product **1152**. Typically, not greater than about 99% of the La from the RE-oxide product **1102** will report to the third precipitation product **1152**. In another

characterization, the third precipitation product **1152** may contain at least about 30% La, such as at least about 35% La, and will typically include not greater than about 40% La.

[00204] Also, among the CREEs, a substantial majority of the Pr and Nd from the RE-oxide product **1102** may advantageously report to the third precipitation product **1152**. In one example, at least about 75%, such as at least about 80% or even at least about 85% of the combined Pr and Nd from the RE-oxide product **1102** may precipitate with the third precipitation product **1152**. In another characterization, the third precipitation product **1152** may contain at least about 30% combined Pr and Nd, such as at least about 35% combined Pr and Nd. Typically, the third precipitation product **1152** will include not greater than about 50% combined Pr and Nd.

[00205] Further, it may be an advantage that a relatively large proportion of the Gd and Sm from the RE-oxide product **1102** report to the third precipitation product **1152**. For example, the third precipitation product **1152** may include at least about 65% of the combined Gd and Sm from the RE-oxide product **1102**, such as at least about 70% of the combined Gd and Sm from the RE-oxide product **1102**. Typically, the third precipitation product **1152** will contain not greater than about 85% of the Gd and Sm from the RE-oxide product **1102**. In another characterization, the third precipitation product **1152** may contain at least about 4% combined Gd and Sm, such as at least about 6% combined Gd and Sm. Typically, the third precipitation product **1152** will include not greater than about 12% of the Gd and Sm from the RE-oxide product **1102**.

[00206] It will be appreciated that the foregoing ranges of elements in the first precipitation product **1116**, the second precipitation product **1142** and the third precipitation product **1152**, as well as in the intermediate products and solutions, are provided by way of example only, and are intended to illustrate the general proportions of the different elements that precipitate in the different precipitation products. The actual compositions will depend upon the mineral ore from which the RE-oxide product **1102** is derived, and the process conditions of the various contacting (precipitation) steps.

[00207] **Fig. 12** illustrates a flowsheet that is similar to the flowsheet illustrated in **Fig. 11**. Referring to **Fig. 12**, a RE-oxide product **1202** is digested in nitric acid **1204** in a digestion step **1206** to form a pregnant liquor solution ("PLS1") **1208**. The PLS1 **1208** may have, for example, a relatively high acid concentration of at least about 18% HNO₃ (*i.e.*, at least about 5M), or even at least about 20% HNO₃ (*i.e.*, at least about 8M). It may be desirable to add a sufficient amount of acid to the RE-oxide product

1202 to ensure such high levels of acidity, e.g., by adding additional acid beyond the amount that is stoichiometrically required to digest all of the RE-oxide product **1202**.

[00208] PLS1 **1208** is then contacted with ammonium hydroxide (NH₄OH) **1210** to precipitate a first precipitation product as Basket1 **1216** and form a filtrate ("Fil1") **1218**. A sufficient amount of NHO₄ **1210** is contacted with PLS1 **1208** to raise the pH to about pH 4.8 and selectively precipitate thorium and cerium from PLS1 **1208**. For example, a quantity of the aqueous solution of NH₄OH **1210** (e.g., 58% NH₄OH in water) may be slowly added to PLS1 **1208** until the pH increases to about pH 4.8.

[00209] Basket1 **1216** is separated **1214** from Filtrate1 **1218**, e.g., using a filter. As is noted above, Basket1 **1216** will have a relatively low mass as compared to the RE-oxide product **1202**. Despite having a relatively low mass as compared to the RE-oxide product **1202** that is input to the process, Basket1 **1216** may include a substantial amount of the thorium that is contained in the RE-oxide product **1202**. Basket1 **1216** may also contain cerium that co-precipitates with the thorium during the precipitation step **1212**. The REO **1202** may also contain HREEs, and Basket1 **1216** may include some of these HREEs. The REO **1202** may also contain LREEs, and Basket1 **1216** may include some of these LREEs, particularly cerium as is discussed above. Also, among the LREEs, Pr and Nd are of a particularly high value, and it is an advantage that a relatively low proportion of the Pr and Nd report to Basket1 **1216**. Further, it is an advantage that a relatively small proportion of the Gd and Sm report to Basket1 **1216**. An assay for Basket1 is provided below in Table IV:

Table IV

Element	Basket1	
	(g)	(% Grade)
La	1.3911	1.251
Ce	73.8444	66.409
Pr	1.9668	1.769
Nd	8.046	7.236
Sm	2.9144	2.621
Eu	0.8243	0.741
Gd	1.8416	1.656
Tb	0.3147	0.283
Dy	1.2731	1.145
Ho	0.1475	0.133
Y	1.1819	1.063
Er	0.2932	0.264

Tm	0.0374	0.034
Yb	0.2289	0.206
Lu	0.0293	0.026
Th	16.843	15.147005
U	0.0193	0.017357
Total	111.1969	100

[00210] After separation **1214** of Basket1 **1216** from Filtrate1 **1218**, Filtrate1 **1218** includes the REEs and other elements that did not precipitate during precipitation **1212**. The pH of Filtrate1 **1218** is increased in a further precipitation step **1220** by adding NH_4OH **1222** to Filtrate1 **1218** to raise the pH to about pH 9. As a result, an $\text{RE}(\text{OH})_3$ product **1228** is formed and is separated **1224** from a barren PLS1 **1226**, which may be recycled to conserve OH^- values in the circuit. After separation **1224**, $\text{RE}(\text{OH})_3$ product **1228** is digested **1232** in nitric acid **1230** to re-solubilize the metallic elements into PLS2 **1234**.

[00211] PLS2 **1234** is then subjected to a precipitation step **1236** by contacting with a sufficient amount of ammonium hydroxide **1238** to raise the pH to about pH 4.8 to precipitate Basket2 **1242** and form Filtrate2 **1244**. Basket2 **1242** is then separated **1240** from Filtrate2 **1244**, e.g., using a filter. As is discussed above, Basket2 **1242** may have a mass that is roughly 25% of the mass of the RE-oxide product **1202** that is input to circuit, and roughly twice the mass of Basket1 **1216**.

[00212] Although a significant amount of the thorium from the RE-oxide product **1202** will report to Basket1 **1216**, some thorium may remain in Filtrate1 **1218** and report to Basket2 **1242**. Basket2 **1242** may also include a substantial concentration of cerium, and a significant portion of the cerium from the RE-oxide product **1202** may advantageously report to either Basket1 **1216** or Basket2 **1242**. As is noted above, the RE-oxide product **1202** may also include CREEs, and it is an advantage that a majority of the CREEs may remain un-solubilized (*i.e.*, in Filtrate2 **1244**). Basket2 **1242** may include some HREEs, *i.e.*, a relatively small amount of HREEs, and may also include a substantial amount of LREEs, particularly cerium. Among the LREEs in addition to cerium, a relatively small proportion of La will report to Basket2 **1242**. Also, a relatively low proportion of the Pr and Nd report to Basket2 **1242**. Further, a relatively small proportion of the Gd and Sm will report to Basket2 **1242**.

[00213] An assay for Basket2 is given below in Table V:

Table V

Element	Basket 2	
	(g)	(%Grade)
La	4.9856	2.262
Ce	190.5588	86.455
Pr	3.6154	1.640
Nd	12.4085	5.630
Sm	3.2868	1.491
Eu	0.842	0.382
Gd	1.7616	0.799
Tb	0.2792	0.127
Dy	1.0451	0.474
Ho	0.1156	0.052
Y	1.1596	0.526
Er	0.2057	0.093
Tm	0.0187	0.008
Yb	0.0691	0.031
Lu	0.0134	0.006
Th	0.0476	0.021596
U	0.0002	0.000091
Total	220.4129	100

[00214] Filtrate2 **1244** is the precipitated **1250** by increasing the pH of Filtrate2 **1244**, such as by adding NH_4OH **1248**, to precipitate Basket3 **1252** that may be separated from barren PLS2 **1254**. Basket3 **1252** may have a mass that is roughly twice the mass of Basket2 **1242**. It is of a particular advantage that Basket3 **1252** may have an extremely high purity with respect to total REEs (TREEs), and may include little or no thorium. Basket3 **1252** may also include relatively low levels of cerium. It is an advantage that a majority of the CREEs may report to Basket3 **1252**. Basket3 **1252** may include some HREEs, *i.e.*, a relatively small amount of HREEs. Basket3 **1252** may include a substantial amount of LREEs. Among the LREEs, a majority of the La from the REO **1202** may report to Basket3 **1252**. Also, among the LREEs, a substantial majority of the Pr and Nd from the REO **1202** may advantageously report to Basket3 **1252**. Further, it may be an advantage that a relatively large proportion of the Gd and Sm from the REO **1202** report to Basket3 **1252**.

[00215] An assay for Basket3 is given below in Table VI:

Table VI

Element	Basket 3	
	(g)	(% Grade)
La	166	35.798
Ce	81	17.468
Pr	36.4362	7.857
Nd	135.9218	29.311
Sm	19.4174	4.187
Eu	4.3289	0.934
Gd	12.45	2.685
Tb	0.7835	0.169
Dy	1.759	0.379
Ho	0.1668	0.036
Y	5.2541	1.133
Er	0.1759	0.038
Tm	0.0072	0.002
Yb	0.0123	0.003
Lu	0.0024	0.001
Th	0.0000	0.0000
U	0.0000	0.0000
Total	463.7155	100

[00216] Table VII below also illustrates the distribution of REEs, Th and U across **Basket1**, **Basket2** and **Basket3** when applying a methodology substantially similar to that described with respect to **Fig. 12**. The numbers listed in **Table VII** are the percentages of total in the RE-oxide. For example, 99.4% of the La from the RE-oxide dissolves in the first digestion step **1206** and 0.6% remains undissolved. During precipitation **1212**, another 0.6% reports to the solids **1216** and 98.8% remains in Filtrate1 **1218**.

Table VII

Element	1st Digestion 206		Precipitation 212		Precipitation 220		Digestion 232		Precipitation 236		Precipitation 250	
			Basket 1						Basket 2		Basket 3	
	Solids	PLS1 208	Solids 216	Filtrate1 218	Solids 228	Barren Solution 226	Solids 234		Solids 242	Filtrate2 244	Solids 252	Barren Solution 254
La	0.6	99.4	0.6	98.8	98.6	0.2	0	98.6	3	95.6	95.5	0.1
Ce	0.6	99.4	18.6	80.7	80.7	0	0	80.7	57.3	23.4	23.4	0
Pr	0.6	99.4	3.9	95.5	95.5	0	0	95.5	9.1	86.4	86.4	0
Nd	0.6	99.4	4.3	95.1	95.1	0	0	95.1	8.5	86.6	86.6	0
Sm	0.6	99.4	9.4	90.1	90.1	0	0	90.1	13.3	76.7	76.7	0
Eu	0.6	99.4	11.4	88	88	0	0	88	15.2	72.9	72.8	0
Gd	0.7	99.3	10.9	88.4	88.4	0	1.7	86.7	12.5	74.3	74.3	0
Tb	0.7	99.3	22	77.3	77.3	0.1	1.1	76.2	22.5	53.7	53.6	0
Dy	0.7	99.3	31.2	68.1	68.1	0	2.2	65.9	27.9	38	38	0
Ho	0.7	99.3	32.9	66.4	66.3	0.1	2	64.3	29.1	35.2	35.1	0.1
Y	0.6	99.4	13.2	86.1	86.1	0	0	86.1	16.8	69.3	69.3	0
Er	0.7	99.3	41.6	57.7	57.6	0.1	0.4	57.2	33.3	23.8	23.7	0.1
Tm	0.7	99.3	58.3	41	39.5	1.5	1.6	37.9	28.6	9.3	8.4	0.8
Yb	0.7	99.3	72.5	26.9	26.7	0.2	1.3	25.4	22.4	3	3	0.1
Lu	0.7	99.3	70.8	28.5	27.3	1.2	10	17.4	15.4	2	1.6	0.4
Sc	2.2	97.8	96.5	1.3	1.3	0	1.3	0	0	0	0	0
Th	0.6	99.4	99.2	0.2	0.2	0	0.1	0.1	0.1	0	0	0
U	1	99	97.9	1.1	0.6	0.4	0.6	0.1	0	0.1	0	0

[00217] It is noteworthy that **Table VII** also illustrates that the digestion steps do not necessarily solubilize all of the metals in the solids and that relatively small concentrations of unsolubilized metals may remain. These solids may be disposed of as waste, or may be recycled to conserve metal values if economically practical.

[00218] **Fig. 13** is a flowsheet illustrating a similar methodology as that illustrated in **Fig. 12**. However, in **Fig. 13** the precipitation steps for precipitation of the metal baskets increases from pH 3.7 to pH 5.0. Further, as compared to **Fig. 12**, an additional metal basket (*i.e.*, **Basket3** in **Fig. 13**) is incorporated. Thus, it can be seen that the methods disclosed herein are not limited to any particular number of chemical precipitation steps or to the formation of any particular number of metal “baskets.” The assay for each Metal Basket is listed in **Fig. 13**.

[00219] As can be seen above, the foregoing method enables the creation of at least three precipitation products from a RE-oxide feed that contains various REEs, along with Th and possibly U. In particular, chemical precipitation may advantageously be used to form a precipitation product (*e.g.*, the third precipitation product described above), that has an extremely high purity with respect to REEs, in particular high value REEs. thorium is removed from the RE-oxide product and substantially all of the thorium is removed with the first and second precipitation products. Further, a substantial majority of the relatively low value cerium also reports to the first and second precipitation products, leaving a much smaller concentration of the low value cerium in the third precipitation product. Thus, the dominate species in the first and second precipitation products are cerium and thorium, and these elements are present in a high concentration in a relatively low mass product. As a result, a smaller separation plant for isolating cerium and thorium may be required, thereby eliminating the potential of thorium contamination of a larger separation plant during thorium extraction, stripping, precipitation and packaging. The creation of these products by chemical precipitation may greatly simplify the subsequent steps (*e.g.*, solvent extraction steps) that further separate the individual REE elements. Further, owing to the high concentration of cerium and thorium in the first precipitation product, it is advantageous to prepare concentrated solutions prior to solvent extraction without the need to reflux or upgrade dilute solutions for efficient separation and ultimate precipitation.

[00220] It is also a particular advantage that the first and second precipitation steps essentially separate Ce from La. That is, over 90% of the La may report to the third precipitation product, whereas only about 7% to 25% of the cerium may report to the third precipitation product, and may result in the

third precipitation product being highly enriched in La, Y, Sm/Gd and CREEs and thus of a higher value than the first precipitation product and the second precipitation product. As is discussed below, the third precipitation product may be further upgraded by the selective removal of excess cerium.

[00221] Any one or more of the foregoing precipitation products ("metal baskets") may be further treated using solvent extraction to separate the constituent elements from each other. Advantageously, some of these solvent extraction methods may utilize a greatly reduced number of extraction steps to form a pure end product, and in some cases a single solvent extraction step may be used to completely separate certain elements from other(s).

[00222] In accordance with the foregoing disclosure, and merely by way of example, **Table VIII** illustrates typical ranges for the various elements in the precipitation products described above with respect to **Figs. 11-13**.

Table VIII

Element(s)	First PPT Product (e.g., Basket1)	Second PPT Product (e.g., Basket2)	Third PPT Product (e.g., Basket3)
TREEs	85 – 95 wt. %	>99 wt. %	>99.999 wt. %
CREEs	3 – 5 wt. %	5 – 8 wt. %	39 – 50 wt. %
HREEs	0.5 – 6 wt. %	<2.5 wt. %	0.3 – 6.0 wt. %
LREEs	75% - 90 wt. %	97 – 99 wt. %	92 - 96 wt. %
Sm + Gd	0.4 – 0.6 wt. %	0.7 – 0.9 wt. %	6 - 9 wt. %
Pr + Nd	3.5-9.0 wt. %	4 – 7.5 wt. %	37 - 43 wt. %
Ce	50 -76 wt. %	86 - 96 wt. %	7 - 20 wt. %
La	0.5 - 1.5 wt. %	2.3 - 2.8 wt. %	35 - 38 wt. %
Th	15 - 25 wt. %	0.001 - 0.023 wt. %	≤0.00005 wt. %

[00223] As can be seen in **Table VIII**, the first precipitation product contains a large proportion of thorium and cerium, and also contains a substantial amount of HREEs. Although the first precipitation product only includes 0.5% to 4% HREEs, this may represent greater than 30% of the total HREEs from

the RE-oxide product, and is contained in a product that has a relatively small mass as compared to the RE-oxide product. Thus, it may be economically desirable to separate the HREEs in the first precipitation product from the cerium and the thorium. Further, it may be desirable to further separate the thorium from the cerium so that a single Th-rich product is produced for ease of disposal.

[00224] Referring to **Fig. 14A**, the first precipitation product may be subjected to a first solvent extraction step ("**SX1**") to separate HREEs from both the cerium and thorium. In one example, it has been found that a single solvent extraction step **SX1** may be utilized to selectively separate cerium and thorium from the HREEs. In this example, the first precipitation product is dissolved (solubilized) in nitric acid (HNO_3). It is desirable to use a sufficient amount of HNO_3 to digest substantially all (e.g., at least about 99.5%) of the first precipitation product, and to form an aqueous solution (**Aqu1**) having an excess of acid. The amount of acid in **Aqu1** should be sufficient to maintain the +4 oxidation state of substantially all of the cerium and the thorium in **Aqu1**. For example, the solution **Aqu1** may have an acidity of at least about 15% HNO_3 , such as at least about 18% HNO_3 , or even at least about 20% HNO_3 . In one characterization, an initial acidity of from about 18% to about 22% HNO_3 may be sufficient.

[00225] Ammonium hydroxide may then be added to the solution **Aqu1** to decrease the acidity of the solution. For example, a sufficient amount of NH_4OH may be added to the solution **Aqu1** to reduce the acidity of the solution to not greater than about 6% HNO_3 , such as not greater than about 5% HNO_3 , or even not greater than about 4% HNO_3 . In one characterization, the acidity of the solution **Aqu1** is reduced to within the range of at least about 3% and not greater than about 4% HNO_3 , such as about 3.8% (about 0.9M). Again, while not wishing to be bound by any theory, it is believed that the addition of NH_4OH to the highly acidic solution **Aqu1** complexes the cerium and the thorium as ammonium nitrate complex metal species, and that these species are stable at lower acidities. Therefore, just prior to solvent extraction, a majority of the cerium in the solution **Aqu1** will be "locked" in the nitrate-ammonium complex where cerium is in +4 oxidation state.

[00226] A solvent extraction step **SX1** may then be carried out on the solution **Aqu1**. In this regard, the organic (**Org1**) may be selected from known organic compounds typically used of solvent extraction of REEs or similar elements, such as tributyl phosphate ("TBP") or Di-(2-ethylhexyl)phosphoric acid ("D2EHPA"). For example, the organic **Org1** may be TBP in a solvent (e.g., kerosene) at concentrations such as from about 10% to about 40% TBP. The solvent extraction step **SX1** may be carried out under

ambient conditions, e.g., ambient temperature and pressure at an organic to aqueous ratio of about 1.1:1 (**Org1:Aqu1**).

[00227] By applying the foregoing methodology, it has been found that a substantial majority of the cerium and the thorium from the solution **Aqu1** may be extracted with the organic, while a vast majority of the REEs (e.g., HREEs) will stay in the aqueous raffinate. In one example at least about 80%, such as at least about 85% or even at least about 90% of the cerium and thorium from the solution **Aqu1** is extracted with the organic, such as at least about 92% of the cerium. In contrast, no greater than about 5%, such as not greater than about 3% or even no greater than about 1% of the other REEs will be extracted with the organic. The resulting raffinate has a very high purity with respect to REEs, and the raffinate may be recycled through the solvent extraction step **SX1** to achieve a purity of at least about 98% REEs, such as at least about 99% REEs, or even at least about 99.5% REEs or 99.9% REEs.

[00228] A further solvent extraction step (**SX2**) may be carried out to separate thorium from cerium. When cerium and thorium are jointly extracted by an organic (e.g., TBP) in **SX1**, they exist in an organic solution. This organic may be stripped of the cerium and thorium by contacting the organic with a highly acidic solution, for example at least about 7M, such as about 8M. The thorium and cerium will be transferred to the aqueous acidic liquor and the organic, now substantially free of metals, may be recycled to the initial extraction step **SX1**. The resulting aqueous strip solution will carry substantially all of the cerium and thorium.

[00229] It is believed that in a nitrate solution at about pH 4.8, before acidity is increased, (e.g., from about 0.5M to about 7M), substantially all of the cerium species will exist in solution as Ce^{3+} , but after adjusting the acidity of the rare earth nitrate solution upwards, a limited amount of cerium will be oxidized to Ce^{4+} . At lower acidity, it is believed that a majority of the thorium will exist in the Th^{4+} oxidation state, e.g., as a relatively stable Th (IV) nitrate. Simply explained, it is difficult to oxidize all Ce^{3+} to Ce^{4+} by adjusting acidity from pH 4.8 with 3M or 6.8M HNO_3 . Thus, an organic (**Org2**) such as TBP or D2EPHA may be utilized to selectively extract Th (IV) nitrate species from Ce (III) nitrate species, where the cerium reports to the aqueous raffinate.

[00230] The same methodology described above with respect to solvent extraction steps **SX1** and **SX2** may also be utilized to separate REEs (e.g., CREEs) from cerium and thorium from the second precipitation product in solvent extraction step **SX3** and to separate cerium from the trace amounts of thorium in solvent extraction step **SX4** (**Fig. 14B**).

[00231] Further, the same methodology described above with respect to solvent extraction steps **SX1** and **SX2** may also be utilized with respect to the third precipitation product to separate non-Ce REEs (e.g., CREEs and La) from Ce (and possibly Th) in solvent extraction step **SX5** and to separate cerium from the trace amounts of thorium, if any, in solvent extraction step **SX6** (**Fig. 14C**).

[00232] Other methods for the removal of thorium and cerium from an RE-containing product may also be employed, independently or in combination with one or more of the foregoing processes. For example, thorium and/or cerium may be selectively removed from the RE-containing product (e.g., from RE-oxides) using solvent extraction techniques.

[00233] For example, the method for the removal of thorium may include contacting an REE-containing acidic solution with a thorium selective extractant to extract at least a portion of the thorium from the REE-containing acidic solution, whereby a thorium-depleted raffinate and a thorium-loaded extractant phase are formed. The thorium may then be stripped from the thorium-loaded extractant phase to form a thorium-depleted extractant. Various characteristics and refinements of this process for the use of solvent extraction to remove thorium will now be described in more detail.

[00234] As with the foregoing precipitation methods, it has been found to be advantageous if substantially all of the thorium in the RE-oxide product is present as Th(IV), *i.e.*, in the Th⁴⁺ oxidation state. Starting with the thorium in the Th⁴⁺ oxidation state in the RE-oxide product and in the REE-containing acidic solution will facilitate the selective extraction of the thorium from the REEs and other elements in the REE-containing acidic solution. One method to ensure that a substantial proportion (e.g., greater than 99%) of the thorium in the RE-oxide product is in the 4+ oxidation state is to calcine the REO product at an elevated temperature. In one characterization, the REO product is calcined at a temperature of at least about 710°C, such as at least about 750°C, e.g., in an oxidizing environment such as in air. For example, an REE-oxalate powder or an REE-carbonate powder can be calcined under these conditions to form the REO product. It is believed that these temperatures in combination with oxygen gas or air will be sufficient to ensure substantially complete conversion of the thorium to the Th(IV) oxidation state in the solid state. To sustain this high oxidation state achieved in the solid state for thorium, the calcined REO product may advantageously be dissolved in a stabilizing acidic solution having sufficient excess protons (H⁺) and nitrates (NO₃⁻), but with less reducing ions such as OH⁻.

[00235] Referring now to **Fig. 15**, the REE-containing acidic solution may be formed by digesting the RE-oxide product (e.g., having about 98 wt. % total REEs on a metals basis) in an acid, e.g., in a mineral

acid such as nitric acid (H^+ , NO_3^-). For example, the RE-oxide product may be contacted with a 70% solution of HNO_3 to digest all or substantially all of the REEs in the RE-oxide product (e.g., digest at least about 95% of the REEs) and form an acidic REE solution comprising dissolved (solubilized) REEs. In one characterization, at least about 98% of the REEs in the RE-oxide product are digested by the nitric acid. The resulting REE acidic solution may include REEs in a concentration of at least about 10 grams per liter (g/l). In certain characterizations, the REE acidic solution includes a relatively high concentration of REEs, such as at least about 15 g/l REEs, at least about 20 g/l REEs, at least about 30 g/l or even at least about 50 g/l REEs, where the REEs are solubilized in the REE-containing acidic solution. Typically, the REE-containing acidic solution will include not greater than about 100 g/l REEs. Further, the REE-containing acidic solution may have, for example, a relatively high acid concentration of at least about 18% HNO_3 (i.e., at least about 4.5M), or even at least about 22% HNO_3 (i.e., at least about 6M). It may be desirable to add a sufficient amount of acid to the REE-containing acidic solution to ensure such high levels of acidity, e.g., by adding additional acid beyond the amount that is stoichiometrically required to digest all of the RE-oxide product.

[00236] As is illustrated in **Fig. 15**, at least a portion of the nitric acid may be recovered from a recycled stream. After digestion of the RE-oxide product, any remaining (undigested) solids may be separated from the REE-containing acidic solution and returned to the digestion reactor. The REE-containing acidic solution exiting the solid/liquid separation unit will typically have an acidity of at least about 0.001M, at least about 0.01M, at least about 0.1M, such as at least about 0.5M. Typically, the acidity of REE-containing acidic solution will not exceed about 8M, such as not greater than about 5M. Advantageously, thorium will remain in the desired Th^{4+} oxidation state over a wide range of acidity. Optionally, as is discussed in more detail below with respect to a cerium solvent extraction separation circuit, the REE-containing acidic solution may be neutralized after digestion (e.g., to a reduced acidity) by adding a neutralizing agent such as ammonium hydroxide (NH_4OH) to the REE-containing acidic solution. In one characterization, the REE-containing acidic solution is contacted with a neutralizing agent to reduce the acidity to at least about 0.5M, such as at least about 0.7M, and not greater than about 1.0 M. Also, at this stage of the process, the REE-containing acidic solution may advantageously have an oxidation reduction potential (ORP) of at least about 1500 mV, such as at least about 1600 mV, and not greater than about 1790 mV, such as not greater than about 1665 mV. As with the adjustment of the acidity, such an oxidation reduction potential may be particularly advantageous when the REE-

containing acidic solution will also be treated by solvent extraction to separate cerium, as is discussed below.

[00237] In any event, the REE-containing acidic solution is contacted with a thorium selective extractant in at least a first contacting step (E1) to extract thorium from the REE-containing acidic solution. In one characterization, the thorium selective extractant is a phosphinic-type acid. For example, the thorium selective extractant may comprise bis(2,4,4-trimethylpentyl)phosphinic acid, which is sold under the name CYANEX 272 and is available from Cytec Industries Inc. of Woodland Park, NJ, USA. It has been found that under the general conditions described herein, the phosphinic-type acid will selectively extract thorium from the REE-containing acidic solution when the thorium is in the Th⁴⁺ oxidation state, while a substantial portion of the REEs will remain in the raffinate from the contacting step. The thorium selective extractant will typically be dispersed within a diluent, typically a hydrocarbon diluent such as kerosene. In one characterization, it has been found to be particularly advantageous to use an extractant concentration in the diluent of at least about 10% and not greater than about 35%, and particularly at least about 20% and not greater than about 30%, such as from about 22% to about 28%. It has been found that the phosphinic-type acid extractant can also provide good results (e.g., high selectivity) over a wide range of acidities, such as from about 1M to about 8M HMO₃.

[00238] It may also be advantageous to ensure that the concentrations of metals that may interfere with the thorium extraction are sufficiently low so that they are not detrimental to the selective thorium extraction. Examples of such metals include calcium and manganese. For example, it may be advantageous if the weight ratio of Ca:Th is not greater than about 250. It may also be advantageous if the weight ratio of Mn:Th is not greater than about 50.

[00239] As illustrated in **Fig. 15**, the thorium selective extractant is contacted with the REE-containing acidic solution in counter-current flow. In one characterization, the thorium selective extractant is contacted with the REE-containing acidic solution in a mixer-settler. A mixer-settler includes a first section that mixes the components (e.g., using mechanical agitation) and a second section that permits settling and separation of the mixed phases by gravity. In one characterization, the total contact time may be at least about 3 minutes and not greater than about 15 minutes total time. For example, the residence time (contact time) in a mixer-settler may be such that the mixing of the REE-containing acidic solution and the thorium selective extractant is carried out for about 3 minutes and that the total time in the mixer-settler is about 15 minutes.

[00240] As illustrated in **Fig. 15**, the step of contacting the REE-containing acidic solution with the thorium selective extractant is carried out in two separate contacting steps (**E1** and **E2**). Thus, the step of contacting the REE-containing acidic solution with the thorium selective extractant may include a first contacting step wherein the REE-containing acidic solution is contacted with the thorium selective extractant to extract at least a (first) portion of the thorium from the REE-containing acidic solution, whereby a first thorium-depleted raffinate and a first thorium-loaded extractant phase are formed. The first thorium-depleted raffinate may then be contacted with additional thorium selective extractant in a second contacting step (e.g., in counter-current flow) to extract at least a further portion of the thorium from the first thorium-depleted raffinate. It will be appreciated that additional contacting steps may be utilized, if desired.

[00241] However, the extraction of thorium from the REE-containing acidic solution may advantageously be carried out in a single contacting step, e.g., in a single mixer-settler. It is an advantage that this method permits the utilization of a single contacting step, which may reduce capital equipment costs and also may reduce operating costs for the extraction and removal of thorium from the REE-containing acidic solution by reducing reagent requirements, *etc.*

[00242] In either case, the thorium-loaded extractant phase (e.g., loaded CYANEX 272) is then conveyed (e.g., pumped) to a circuit for the removal of the extracted thorium from the thorium-loaded extractant phase, resulting in the formation of a thorium-depleted extractant. In one characterization, the thorium may be removed from the thorium-loaded extractant phase by stripping the thorium from the thorium-loaded extractant phase, e.g., by stripping at a very high acidity.

[00243] In another refinement of this process for the removal of thorium, the thorium may be removed from the thorium-loaded extractant phase by contacting the thorium loaded extractant phase with a precipitative medium, such as an organic acid, to precipitate the thorium from the thorium-loaded extractant phase and form a thorium-depleted extractant. One particularly useful organic acid that may be utilized for this purpose is oxalic acid ($\text{H}_2\text{C}_2\text{O}_4$). In this embodiment, and as illustrated in **Fig. 15**, the thorium-loaded extractant phase is contacted with oxalic acid (e.g., in water and/or in nitric acid) to precipitate thorium from the extractant as thorium oxalate (e.g., $\text{Th}_2(\text{C}_2\text{O}_4)_3 \cdot 10\text{H}_2\text{O}$). Advantageously, this reaction to form thorium oxalate may occur very rapidly and may even be characterized as being essentially instantaneous. Characterized another way, the thorium may be completely precipitated from the thorium loaded extractant phase in less than about 1 minute, less than about 30 seconds, and even

less than about 10 seconds. It should be noted that some amounts of cerium may also be extracted from the REE-containing solution by the thorium selective extractant. This cerium will also precipitate as cerium oxalate (e.g., $\text{Ce}_2(\text{C}_2\text{O}_4)_3 \cdot 10\text{H}_2\text{O}$) with the thorium oxalate. Thus, upon liquid/solid separation, the thorium oxalate and cerium oxalate are eliminated from the thorium removal circuit.

[00244] After solid/liquid separation, the now thorium-depleted extractant will be dispersed in the organic acid, e.g., in the oxalic acid. It is an advantage that the thorium depleted extractant may be scrubbed from the oxalic acid so that the oxalic acid and the thorium depleted extractant may be recycled. In this regard, it is noteworthy that the circuit illustrated in **Fig. 15** may be considered as a closed circuit, e.g., having no undesirable effluents from the circuit. In this regard, the thorium depleted extractant dispersed in the oxalic acid may be conveyed from the solid/liquid separation step to a stripping step (**S1**) where the thorium-depleted extractant (e.g., thorium-depleted CYANEX 272) is separated from the oxalic acid. The oxalic acid may then be recycled back to the precipitation step, e.g., to precipitate thorium. The extractant phase may then be scrubbed, e.g., with water or an acid, which may be recycled back to the contacting step.

[00245] The thorium-depleted raffinate may advantageously include not greater than about 0.1 wt.% thorium on a metals basis, such as not greater than about 0.05 wt.% thorium, or even not greater than about 0.01 wt.% thorium on a metals basis. Characterized another way, the thorium-depleted raffinate may comprise at least about 99% REEs on a metals basis, such as at least about 99.5% REEs on a metals basis or even at least about 99.9% REEs on a metals basis.

[00246] It is noteworthy to examine input streams and output streams from the thorium removal circuit illustrated in **Fig. 15**. Inputs to the process may include an RE-oxide product (e.g., RE-oxide powder that is about 98% pure with respect to REEs), fresh acid (e.g., nitric acid), water and optionally ammonium hydroxide. Inputs to the thorium precipitation step include oxalic acid and water. The output from the thorium precipitation circuit is thorium oxalate, possibly with some cerium oxalate and water. The output from the solvent extraction step includes an essentially thorium-free raffinate that includes a high concentration of REEs (e.g., greater the 99% REEs on a metals basis) and possibly ammonium nitrate in an acid.

[00247] Additionally, it has been found that phosphinic-type acid extractants such as bis(2,4,4-trimethylpentyl)phosphinic acid may also advantageously remove uranium (U) from the REE-containing acidic solution with the thorium, and in one characterization the thorium removal solvent extraction circuit

illustrated in **Fig. 15** will advantageously remove substantially all uranium from the REE-containing acidic solution. Further, as is illustrated in **Fig. 15**, phosphinic-type acid extractants may also remove a substantial portion of cerium from the REE-containing acidic solution with the thorium, while rejecting substantially all other REEs. It has also been found that phosphinic-type acid extractants may also remove a substantial portion of iron (*e.g.*, traces of iron) from the REE-containing acidic solution with the thorium.

[00248] Thus, the use of a phosphinic-type acid extractant such as CYANEX 272 as described with respect to **Fig. 15** may provide at least one or more of the following advantages: (i) the ability to extract substantially all of the toxic and radioactive elements at once and in a single mixer settler; (ii) the ability to function at a high acidity (*e.g.*, about 1M to 8M HNO₃) while maintaining selectivity; (iii) because iron and thorium are removed, the chemical precipitation circuit is reduced in complexity as there is no need to set ~pH 3.2 to remove Fe and Th – the REEs left in solution are free from iron and thorium and therefore can be precipitated at a single pH of about pH 9 to secure a bulk REO powder for advanced separation, and the base metals such as Ca, Mg, Zn, Mn, Sr, K, Na, Ti, Cr, Ni, Co *etc.* remain in solution at pH 9; and (iv) the extractant cannot be stripped with any acid, but can be stripped with oxalic acid.

[00249] In any event, the process may also include a solvent extraction cerium removal circuit, in addition to or independent of the thorium removal solvent extraction circuit. Thus, according to another embodiment of this disclosure, a circuit for the separation and recovery of cerium from other REEs is disclosed. One advantage to separating the cerium from the other REEs prior to separation of the other REEs from each other is that cerium typically constitutes the largest concentration of metals in the REE-containing product. Thus, by first separating the cerium, the subsequent equipment and reagents for the separation of the other REEs may be substantially reduced. Further, cerium is of relatively low value as compared to many other REEs, *e.g.*, as compared to the CREEs.

[00250] This cerium separation circuit may be implemented as a stand-alone process to separate cerium from other REEs. Also, the cerium separation circuit may be implemented before the use of the thorium removal circuit described above with respect to **Fig. 15**. Thus, for example, the RE-oxide product input to the cerium solvent extraction circuit may still have a relatively high level of thorium, such as up to about 2.5 wt. % on a metals basis. In one particular embodiment, the cerium separation circuit is implemented on the essentially thorium-free raffinate that is produced by the thorium removal circuit, *e.g.*, as illustrated in **Fig. 15** and described above.

[00251] In any case, it has been found to be advantageous if substantially all of the cerium in the RE-oxide product and the REE-containing acid is present as Ce(IV), *i.e.*, in the Ce⁴⁺ oxidation state. Starting with the cerium in the Ce⁴⁺ oxidation state in the RE-oxide product and in the REE-containing acidic solution (*e.g.*, in the thorium-depleted raffinate) will facilitate the selective extraction of the cerium from the other REEs and other elements in the REE-containing acidic solution. One method to ensure that a substantial proportion (*e.g.*, greater than 99%) of the cerium in the RE-oxide product is in the 4+ oxidation state is to calcine an RE-containing product at an elevated temperature. In one characterization, the an RE-containing product is calcined at a temperature of at least about 710°C, such as at least about 750°C, *e.g.*, in an oxidizing environment such as in air. For example, an REE-oxalate powder or an REE-carbonate powder may be calcined under these conditions to form the RE-oxide product. As with the thorium solvent extraction circuit discussed above, it is believed that these temperatures in combination with oxygen gas or air will be sufficient to ensure substantially complete conversion of the cerium to the Ce(IV) oxidation state in the solid state. To sustain this high oxidation state achieved in solid state, the RE-oxide product is dissolved in a stabilizing acidic solution having sufficient excess protons (H⁺) and nitrates (NO₃⁻).

[00252] Broadly stated, the method for the separation of cerium from the REE-containing acidic solution comprising cerium and at least one other rare earth element in addition to cerium, comprises the steps of contacting the REE-containing acidic solution with a cerium selective extractant to extract at least a portion of the cerium from the REE-containing acidic solution, whereby a cerium-depleted raffinate and a cerium-loaded extractant phase are formed. The extracted cerium is then recovered from the cerium-loaded extractant phase to form a cerium-depleted extractant. Various characteristics and refinements of this process will now be described in more detail with respect to **Fig. 16**.

[00253] The REE-containing acidic solution may be formed by digesting the RE-oxide product in an acid, *e.g.*, in a mineral acid such as nitric acid in a manner discussed above with respect to **Fig. 15**. With respect to the recovery of cerium, it is desirable to adjust the acidity of the REE-containing acidic solution, if necessary, to adjust the acidity to the range of at least about 0.7M and not greater than about 3.0M, such as not greater than about 2.0M or even not greater than about 1.0M. Further, it has been found that the oxidation reduction potential (ORP) of the REE-containing acidic solution may have an impact on the efficacy of the cerium recovery process. In this regard, it is desirable that the ORP of the REE-containing acidic solution (*e.g.*, during the contacting step) be at least about 1500 mV, such as at least about 1600 mV, and not greater than about 1790 mV, such as not greater than about 1665 mV.

[00254] Referring now to **Fig. 16**, an embodiment of the cerium solvent extraction separation circuit is illustrated where the REE-containing acidic solution that is fed to the cerium separation circuit is the thorium-depleted raffinate from the thorium removal circuit (**Fig. 15**). As is indicated in **Fig. 16**, the REE-containing acidic solution is contacted with a cerium selective extractant in at least a first contacting step (**E1**) to extract cerium from the REE-containing acidic solution. In one characterization, the cerium selective extractant is an organophosphorus compound. For example, the cerium selective extractant may comprise tributyl phosphate ("TBP"). It has been found that under the general conditions described herein, organophosphorus extractant will selectively extract cerium from the REE-containing acidic solution when the cerium is in the Ce^{4+} oxidation state, while a substantial portion of the other REEs (e.g., the CREEs) remain in the (cerium-depleted) raffinate from the contacting step. The cerium selective extractant will typically be dispersed within a diluent, typically a hydrocarbon diluent such as kerosene.

[00255] As illustrated in **Fig. 16**, the cerium selective extractant is contacted with the REE-containing acidic solution in counter-current flow. In another characterization, the cerium selective extractant may be contacted with the REE-containing acidic solution in a mixer-settler apparatus. The total contact time of the acidic solution and the extractant may be at least about 3 minutes and not greater than about 30 minutes total time, for example. In one characterization, the residence time (contact time) in a mixer-settler apparatus may be such that the mixing of the REE-containing acidic solution and the cerium selective extractant is carried out for about 3 minutes and that the total time in the mixer-settler apparatus is about 30 minutes.

[00256] As illustrated in **Fig. 16**, the step of contacting the REE-containing acidic solution with the cerium selective extractant is carried out in two separate contacting steps (**E1** and **E2**). Thus, the step of contacting the REE-containing acidic solution with the cerium selective extractant may include a first contacting step wherein the REE-containing acidic solution is contacted with the cerium selective extractant to extract at least a (first) portion of the cerium from the REE-containing acidic solution, whereby a first cerium-depleted raffinate and a first cerium-loaded extractant phase are formed. The first cerium-depleted raffinate may then be contacted with additional cerium selective extractant in a second contacting step (e.g., in counter-current flow) to extract at least a further portion of the cerium from the first cerium-depleted raffinate. It will be appreciated that additional contacting steps may be utilized, if desired.

[00257] However, the extraction of cerium from the REE-containing acidic solution may also be carried out in a single contacting step, e.g., in a single mixer-settler apparatus. It may be an advantage to utilize a single contacting step to reduce capital equipment costs and also to reduce operating costs for the extraction and removal of cerium from the REE-containing acidic solution.

[00258] In either case, the cerium-loaded extractant phase (e.g., cerium-loaded TBP) is then conveyed (e.g., pumped) to a circuit for the recovery of the extracted cerium from the cerium-loaded extractant phase, resulting in the formation of a cerium-depleted extractant. In one characterization, the cerium may be removed from the cerium-loaded extractant phase by stripping the cerium from the cerium-loaded extractant phase, e.g., using water.

[00259] In another refinement of this process for the recovery of cerium, the cerium may be recovered from the cerium-loaded extractant phase by contacting the cerium loaded extractant phase with a precipitative medium, such as an organic acid, to precipitate the cerium from the cerium-loaded extractant phase and form a cerium-depleted extractant. One particularly useful organic acid that may be utilized for this purpose is oxalic acid ($\text{H}_2\text{C}_2\text{O}_4$). In this embodiment, and as illustrated in **Fig. 16**, the cerium-loaded extractant phase is contacted with oxalic acid (e.g., in water and/or in nitric acid) to precipitate cerium as cerium oxalate (e.g., $\text{Ce}_2(\text{C}_2\text{O}_4)_3 \cdot 10\text{H}_2\text{O}$). Advantageously, this reaction to form cerium oxalate may occur very rapidly and may even be characterized as being essentially instantaneous. Thus, upon liquid/solid separation, the cerium is recovered from the circuit as high purity cerium oxalate.

[00260] After solid/liquid separation, the now cerium depleted extractant will be dispersed in the organic acid, e.g., in the oxalic acid. It is an advantage that the cerium-depleted extractant may be scrubbed from the oxalic acid so that the oxalic acid and the cerium depleted extractant may be recycled. In this regard, it is noteworthy that the solvent extraction circuit illustrated in **Fig. 16** may be considered as a closed circuit, e.g., having no undesirable effluents from the circuit. In this regard, the cerium-depleted extractant dispersed in the oxalic acid may be conveyed from the solid/liquid separation step to a stripping step (**S1**) where the cerium-depleted extractant (e.g., cerium-depleted TBP) is separated from the oxalic acid. The oxalic acid may then be recycled back to the precipitation step. The extractant may be scrubbed, e.g., with water, and then recycled back to the contacting step.

[00261] The cerium-depleted raffinate may advantageously include not greater than about 1 wt. % cerium on a metals basis, such as not greater than about 0.1 wt. % cerium, or even not greater than

about 0.05 wt. % cerium on a metals basis. In another characterization, this process enables the separation of at least about 60% of the cerium from the REE-containing acidic solution, such as at least about 85% of the cerium or even at least about 95 wt. % of the cerium from the REE-containing acidic solution. The cerium-depleted raffinate may comprise at least 99 wt. % REEs on a metals basis, such as at least 99.5 wt. % REEs on a metals basis or even at least 99.9 wt. % REEs on a metals basis.

[00262] As with the thorium removal circuit disclosed above and in **Fig. 15**, it is noteworthy to point out the input streams and output streams from the cerium removal circuit illustrated in **Fig. 16**. Inputs to the process may include an REO product (e.g., the thorium depleted raffinate), fresh acid (e.g., nitric acid), water and ammonium hydroxide. Inputs to the cerium recovery (precipitation) step include oxalic acid and water. The output from the cerium precipitation circuit is high purity cerium oxalate. The output from the solvent extraction step(s) includes an essentially cerium-free raffinate that includes a high concentration of REEs (e.g., greater the 99% REEs on a metals basis) and possibly ammonium nitrate in an acid.

REE Purification Circuit

[00263] In another embodiment, a method for the purification of an REE-containing product, such as an REE-containing acidic solution, is disclosed. For example, this method may be applied to the output REE-containing acidic solution from the thorium removal solvent extraction circuit (**Fig. 15**) and/or the output REE-containing acidic solution from the cerium removal solvent extraction circuit (**Fig. 16**).

[00264] Broadly stated, the method for the purification of an REE-containing acidic solution may be applied to remove non-REE metals (e.g., Th, U and/or base metals) and form a high purity REE-rich product. Broadly speaking, the method may include the step of precipitating non-REEs from the REE-containing acidic solution to form the very high purity REE-rich product. The precipitation may occur in one stage, two stages, three stages or more where the pH (e.g., the acidity) of the REE-containing acidic solution is different at each stage. In one characterization, a first stage precipitation occurs at a first pH at which some non-REE elements (e.g., Th, U, Al, Fe and/or Ba) are precipitated. This may be followed by a second stage precipitation at a second pH that is higher than the first pH to remove (precipitate) cerium (e.g., traces of cerium) from the REE-containing acidic solution. This may be followed by yet a third stage precipitation at a third pH that is higher than the second pH to recover (precipitate) the REE

elements while leaving base metals (e.g., Ca, Mg, K, Na, Sr, Zn, Ti and/or Mn) in solution, thereby further purifying the REE-containing product.

[00265] As illustrated in **Fig. 17**, the step of precipitating non-REEs from the REE-containing acidic solution includes contacting the REE-containing acidic solution with a hydroxide compound, such as ammonium hydroxide, to increase the pH of the REE-containing acidic solution to a first pH and precipitate at least one element selected from the group consisting of thorium, iron, aluminum, barium and uranium and form a first treated REE-containing acidic solution. The first pH may be at least about pH 2.8 and not greater than about pH 3.6. As illustrated in **Fig. 17**, the first pH is about pH 3.2. In one particular characterization, the REE-containing acidic solution includes uranium (e.g., traces of uranium) and substantially all of the uranium precipitates from the REE-containing acidic solution when contacted with the hydroxide compound in the first precipitation stage.

[00266] The method illustrated in **Fig. 17** also includes contacting the first treated REE-containing acidic solution (*i.e.*, after the first stage) with a hydroxide compound to further increase the pH of the REE-containing acidic solution and precipitate cerium from the REE-containing acidic solution and form a second treated REE-containing acidic solution. The second pH may be at least about pH 4.5 and may be not greater than about pH 6.0. As illustrated in **Fig. 17**, the second pH is about pH 6.0.

[00267] The purification method may also include the step of contacting the second treated REE-containing acidic solution (*i.e.*, from the second precipitation stage) with a hydroxide compound to further increase the pH of the REE-containing acidic solution to a third pH of at least about pH 8.5 and not greater than about pH 9 to precipitate a high purity REE-rich product and form a raffinate comprising at least one metal selected from the group consisting of calcium, magnesium, potassium, sodium, strontium, zinc, titanium and manganese. It is believed that increasing the pH substantially above about pH 9 will result in the precipitation of some base metals with the REEs, thus reducing the purity of the REE-rich precipitation product. As illustrated in **Fig. 17**, the third pH is about pH 9.0.

[00268] The output from the process illustrated in **Fig. 17** includes a very high purity REE-containing product, e.g., REE-hydroxide ($\text{RE}(\text{OH})_3$) precipitates. The high purity REE-rich product may comprise at least 99.9 wt. % REEs on metals basis, such as at least 99.95 wt. % REEs, or even at least 99.99 wt. % REEs or higher on metals basis. In other characterizations, the high purity REE product that is output from this purification process may comprise not substantially no Th, U, Ce and/or base metals. For

example, the high purity REE-containing product may comprise not greater than 0.2 wt. % cerium on metals basis, such as not greater than about 0.1 wt. % cerium on a metals basis. This product may serve as a feed for the ultimate separation of one or more REEs from the REE-containing product.

[00269] Thus, according to another embodiment of the present disclosure, a method for the separation of lanthanum from an REE-containing acidic solution is disclosed. In one characterization, the REE-containing acidic solution may comprise or be derived from the purification circuit illustrated in **Fig. 17** (e.g., from the REE-hydroxide solid precipitates produced by the purification circuit), and/or may be derived from the thorium removal and/or cerium solvent extraction separation circuits illustrated in **Figs. 15 and 16**, respectively. Thus, in certain characterizations, the REE-containing acidic solution may comprise not greater than about 0.2 wt. % cerium on a metals basis. In another characterization, the REE-containing acidic solution may comprise not greater than about 0.01 wt. % thorium on a metals basis. In yet another characterization, the REE-containing acidic solution may comprise not greater than about 1 wt. % total base metals on a metals basis, such as not greater than about 0.1 wt. % base metals on a metals basis.

[00270] Such low levels of these undesirable elements may be achieved by applying one or more of the processes illustrated above. However, it is to be understood that the method for the separation of lanthanum may be applied to a variety of REE-containing acidic solutions that may or may not comprise thorium, base metals and/or cerium. Thus, in another characterization, the REE-containing acidic solution that is treated in the lanthanum separation circuit may comprise at least about 10 wt.% cerium, and may comprise not greater than about 60 wt.% cerium on a metals basis. The REE-containing acidic solution that is treated in the lanthanum separation circuit may also comprise up to about 2.5 wt. % thorium on a metals basis. In a further characterization, the REE-containing acidic solution that is treated in the lanthanum separation circuit may have a relatively high purity with respect to REEs. Thus, the REE-containing solution may comprise at least 99 weight % REEs on a metals basis, such as at least about 99.8 weight % or even at least 99.99 weight % REEs on a metals basis. Among the REEs, the REE-containing acidic solution may comprise at least about 25 weight % lanthanum on a metals basis, and may even comprise at least about 50 weight % lanthanum on a metals basis. As is noted above with respect to cerium, lanthanum may constitute a relatively large proportion of the REEs, particularly if cerium has been previously removed, and the separation of lanthanum before separation of the other REEs (e.g., the CREEs) may be advantageous with respect to the capital expenditures and/or operating expenses associated with REE separation.

[00271] Broadly stated, the method for the separation of lanthanum may include contacting an REE-containing acidic solution with a SEG/HREE selective extractant to selectively extract at least a portion of the other REEs from the REE-containing acidic solution and leave substantially all of the lanthanum in the REE-containing acidic solution. The other REEs may include SEG (samarium, europium and gadolinium) and/or HREEs (terbium, dysprosium, holmium, erbium, thulium, ytterbium, lutetium, and yttrium). The contacting step thus forms a lanthanum-rich raffinate and a SEG/HREE loaded extractant phase. The method may include recovering the extracted other REEs from the SEG/HREE loaded extractant phase to form a SEG/HREE-depleted extractant, and may include recovering lanthanum from the lanthanum-rich raffinate.

[00272] Referring now to **Fig. 18**, a circuit for the separation of lanthanum from other REEs, and also for the separation of Nd/Pr (neodymium and/or praseodymium) is illustrated. As is illustrated in **Fig. 18**, a REE-containing product, such as REE-hydroxides or REE-oxides, is digested in a digestion step to solubilize the REEs. If necessary, the acidity of the REE-containing acidic solution may be adjusted (e.g., may be decreased), such as by contacting the REE-containing acidic solution with a neutralizing agent, e.g., with ammonium hydroxide (NH₄OH). In any event, in one characterization the REE-containing acidic solution that is conveyed (e.g., pumped) to the contacting step may have an acidity of at least about 0.0008M, such as at least about 0.01M. In another characterization, the REE-containing acidic solution that is conveyed to the contacting step may have an acidity of not greater than about 0.15M, such as not greater than about 0.1M. It is believed that these acidity levels are desirable for selectively extracting SEG and HREEs from the REE-containing acidic solution.

[00273] As is illustrated in **Fig. 18**, the REE-containing acidic solution is contacted with the SEG/HREE selective extractant in at least a first contacting step (**E1**) to extract SEG and/or HREEs from the REE-containing acidic solution. In one characterization, the SEG/HREE selective extractant is phosphoorganic compound. For example, the SEG/HREE selective extractant may comprise Di(2-ethylhexyl) phosphate ("DEHPA" or "D₂EHPA"). The SEG/HREE selective extractant will typically be dispersed within a diluent, e.g., a hydrocarbon diluent such as kerosene. It has been found that under the general conditions described herein, a phosphoorganic extractant will selectively extract SEG and HREEs from the REE-containing acidic solution, while a substantial portion of other REEs (e.g., La, Nd and Pr) remain in the (lanthanum-depleted) raffinate exiting the contacting step.

[00274] The step of contacting the REE-containing acidic solution with the SEG/HREE selective extractant may be carried out in a single contacting step, e.g., in a single mixer-settler apparatus. As is illustrated in **Fig. 18**, the step of contacting the REE-containing acidic solution with the SEG/HREE selective extractant includes multiple contacting steps, e.g., using two or more mixer-settlers that are fluidly connected in series (e.g., **E1**, **E2**, etc.). For example, a first contacting step may be utilized wherein the REE-containing acidic solution is contacted with the SEG/HREE selective extractant to extract a first portion of the other REEs from the REE-containing acidic solution and leave substantially all of the lanthanum in the acidic solution, whereby a first lanthanum-rich raffinate and a first SEG/HREE loaded extractant phase are formed. A second contacting step (e.g., in a second mixer-settler apparatus) may then be utilized, wherein the first lanthanum-rich raffinate is contacted with the SEG/HREE selective extractant to extract at least a second portion of the other REEs from the first lanthanum-rich raffinate, whereby a second lanthanum-rich raffinate and a second SEG/HREE loaded extractant phase are formed.

[00275] While more than two separate contacting steps may be utilized, on one characterization the step of contacting the REE-containing acidic solution with the SEG/HREE selective extractant comprises no more than three separate contacting steps (e.g., employing no more than 3 separate mixer settlers fluidly connected in series).

[00276] The step of recovering the extracted SEG and HREEs from the SEG/HREE loaded extractant phase may include stripping the SEG and HREEs from the SEG/HREE loaded extractant phase. For example, the SEG/HREE loaded extractant phase may be contacted with SEG/HREE loaded extractant phase with an acid.

[00277] Alternatively, the step of recovering the extracted other REEs from the SEG/HREE loaded extractant phase may comprise contacting the SEG/HREE loaded extractant phase with a precipitative medium to precipitate the other REEs (e.g., SEG and HREEs) from the SEG/HREE loaded extractant phase and form a SEG/HREE depleted extractant. In one characterization, the precipitative medium is an organic acid, and in one particular refinement the precipitative medium comprises oxalic acid ($\text{H}_2\text{C}_2\text{O}_4$). In this manner, the other REEs (e.g., SEGs and HREEs) are precipitated as REE-oxalates. Advantageously, this reaction to form REE-oxalates may occur very rapidly and may even be characterized as being essentially instantaneous. Characterized another way, the SEG and HREEs may

be completely precipitated from the SEG/HREE loaded extractant phase in less than about 1 minute, less than about 30 seconds, and even less than about 10 seconds.

[00278] After contacting the SEG/HREE loaded extractant phase with the precipitative medium (oxalic acid) to precipitate the other REEs from the SEG/HREE loaded extractant phase, the oxalate precipitates are separated in a liquid/solid separation step. As illustrated in **Fig. 18**, in addition to SEG and HREEs, the oxalate precipitate may also include small amounts (trace amounts) of LREEs. After separation, the SEG/HREE depleted extractant is dispersed in oxalic acid. The SEG/HREE depleted extractant may then be scrubbed with, e.g., with water. After scrubbing, the SEG/HREE depleted extractant (e.g., stripped DE2PHA) may advantageously be recycled back to the step of contacting the REE-containing acidic solution with a SEG/HREE selective extractant. Further, the oxalic acid may be recycled back to the step of contacting the SEG/HREE loaded extractant phase with the precipitative medium, where it is combined with fresh oxalic acid. Fresh (make-up) oxalic acid is only necessary to replace the oxalic acid that is output with the REE-oxalates.

[00279] As is discussed above, the lanthanum-rich raffinate comprises La and may also comprise at least one LREE selected from Nd, Pr and combinations thereof. Typically, the lanthanum-rich raffinate will comprise valuable quantities of both Nd and Pr.

[00280] Referring to the lower one-half of **Fig. 18**, a process for separating neodymium and praseodymium (Nd/Pr) from the La is schematically illustrated. Broadly speaking, the method may include contacting the lanthanum-rich raffinate with a Nd/Pr selective extractant to extract at least a portion of the Nd/Pr from the lanthanum-rich raffinate, whereby a Nd/Pr-depleted raffinate and an Nd/Pr-loaded extractant phase are formed. The extracted Nd/Pr may then be recovered from the Nd/Pr-loaded extractant phase to form a Nd/Pr-depleted extractant.

[00281] The Nd/Pr-depleted raffinate will comprise appreciable quantities of lanthanum and will also comprise nitric acid. To recover lanthanum, the Nd/Pr-depleted raffinate may be contacted with a hydroxide precipitant (e.g., ammonium hydroxide) to precipitate a lanthanum product having a high purity. The step of contacting the Nd/Pr-depleted raffinate with a hydroxide precipitant may be a multi-step process where the Nd/Pr-depleted raffinate is first contacted with the hydroxide precipitant to increase the pH of the lanthanum-rich raffinate to a first pH (e.g., at least about pH 5.0 and not greater than about pH 6.0) to selectively precipitate other REEs from the Nd/Pr-depleted raffinate. In this manner, any trace REEs in the Nd/Pr-depleted raffinate may be recovered (e.g., may be recycled to acid digestion), and the

purity of the lanthanum end-product may be increased. After separating the other REE precipitates from the Nd/Pr-depleted raffinate, the Nd/Pr depleted raffinate may again be contacted with the hydroxide precipitant to further increase the pH of the Nd/Pr depleted raffinate to a second pH (e.g., at least about pH 8.5 and is not greater than about pH 10), where the second pH is greater than the first pH, to precipitate the lanthanum product of high purity. For example, on a metals basis, the lanthanum product may comprise at least 99 wt. % lanthanum, at least 99.5 wt. % lanthanum, or event at least 99.9 wt. % lanthanum.

[00282] Referring back to the Nd/Pr portion of the circuit (*i.e.*, the lower right quadrant of **Fig. 18**), the Nd/Pr selective extractant may comprise a phosphinic-type acid, such as bis(2,4,4-trimethylpentyl)phosphinic acid, and the extractant will typically be dispersed in an inert hydrocarbon diluent such as kerosene. During the step of contacting the lanthanum-rich raffinate with the Nd/Pr selective extractant, the acidity of the lanthanum-rich raffinate may be at least about 0.0002M, and is typically not greater than about 0.018M. The contacting of the lanthanum-rich raffinate with the Nd/Pr selective extractant may be carried out in counter-current flow in one or more mixer-settlers. In one characterization, the contacting of the lanthanum-rich raffinate with the Nd/Pr selective extractant is carried out in a single contacting step, e.g., in a single mixer-settler. Alternatively, and as illustrated in **Fig. 18**, the step of contacting the lanthanum-rich raffinate with the Nd/Pr selective extractant includes a first contacting step wherein the lanthanum-rich raffinate is contacted with the Nd/Pr selective extractant to extract at least a first portion of the Nd/Pr from the lanthanum-rich raffinate, whereby a first Nd/Pr-depleted raffinate and a first Nd/Pr-loaded extractant phase are formed. The method then includes at least a second contacting step, wherein the first Nd/Pr-depleted raffinate is contacted with the Nd/Pr selective extractant to extract at least a second portion of the Nd/Pr from the first Nd/Pr-depleted raffinate, whereby the Nd/Pr-depleted raffinate and a second Nd/Pr loaded extractant phase are formed.

[00283] The Nd/Pr may then be recovered from the Nd/Pr loaded extractant phase. In one characterization, the recovering of the extracted Nd/Pr from the Nd/Pr-loaded extractant phase includes the step of stripping the Nd/Pr from the Nd/Pr-loaded extractant phase, *e.g.*, using an acid. In another characterization, the method includes contacting the Nd/Pr-loaded extractant phase with a precipitative medium to precipitate Nd/Pr from the Nd/Pr-loaded extractant phase and form a Nd/Pr -depleted extractant. As with the SEG and HREE circuit illustrated in the top right quadrant of **Fig. 18**, the precipitative medium may be an organic acid, such as oxalic acid, wherein the Nd/Pr is precipitated as Nd-oxalate and Pr-oxalate. Again, this precipitation step may advantageously occur very rapidly and

may even be characterized as being essentially instantaneous. Characterized another way, the Nd/Pr may be completely precipitated from the Nd/Pr loaded extractant phase in less than about 1 minute, less than about 30 seconds, and even less than about 10 seconds.

[00284] The Nd/Pr-depleted extractant will be dispersed in oxalic acid. The method may therefore include separating the Nd/Pr depleted extractant from the oxalic acid and recycling the Nd/Pr depleted extractant to the step of contacting the lanthanum-rich raffinate with the Nd/Pr selective extractant. The oxalic acid may be recycled, *e.g.*, to the step of precipitating Nd/Pr from the Nd/Pr-loaded extractant phase. Again, it is noteworthy that these reagents remain in a closed loop circuit and the only input required to the circuit is additional oxalic acid to replace the oxalic acid that is lost with the precipitation of the Nd/Pr as oxalates.

[00285] In accordance with the foregoing method, at least about 95% of the Nd/Pr in the lanthanum-rich raffinate may be separated from the lanthanum-rich raffinate. For example, at least about 99% of the Nd/Pr, or even at least about 99.5% of the Nd/Pr in the lanthanum-rich raffinate may be separated from the lanthanum-rich raffinate. Further, the Nd/Pr may advantageously be of very high purity. In one particular characterization, the REE-containing acidic solution that is contacted with the SEG/HREE selective extractant comprises or is derived from the high purity REE-rich product produced by the circuit illustrated in **Figs. 15-17**, either alone or in any or sub-combination.

[00286] The circuit illustrated in **Fig. 18** produces SEG and HREEs (possibly with some traces of LREEs such as Nd/Pr) as an output from the circuit, *e.g.*, as a mixed powder of REE-oxalates. See the upper right quadrant of **Fig. 18**. In accordance with another embodiment of the present disclosure, the SEG and the HREES may be refined to remove traces of LREEs and may be separated from each other in a further separation circuit.

[00287] **Fig. 19** illustrates a circuit for the separation of Nd/Pr (*e.g.*, traces) from SEGs and HREEs contained in an REE-containing acidic solution. Referring generally to the lower left quadrant of **Fig. 19**, the process may include an optional first step of contacting the REE-containing acidic solution with a SEG/HREE selective extractant to extract at least a portion of the SEGs and HREEs from the REE-containing acidic solution and leave substantially all Nd/Pr in the REE-containing acidic solution, whereby a Nd/Pr raffinate and a SEG/HREE loaded extractant phase are formed. The Nd/Pr may be recovered from the Nd/Pr raffinate. At least a portion of the SEGs and HREEs may be recovered from the SEG/HREE loaded extractant phase.

[00288] In one characterization, the SEG/HREE selective extractant comprises a phosphoorganic compound, such as Di(2-ethylhexyl) phosphate (D2PHA), which is typically dispersed in an inert hydrocarbon diluent such as kerosene. The REE-containing acidic solution may comprise nitric acid and may have an acidity of at least about 0.0008M (about pH 3.1), such as at least about 0.01M (about pH 2) to facilitate the selective extraction of the SEG/HREEs from the LREEs. Further, the acidic solution may have an acidity of not greater than about 0.15M (about pH 0.82), such as not greater than about 0.1M (about pH 1). The REE-containing acidic solution may comprise or be derived from circuits illustrated in **Figs. 15-18**, and in one example is derived from the mixture of SEG-oxalates and HREE-oxalates formed as an output from **Fig. 18**. Thus, the REE-containing acidic solution may have a very high purity with respect to REEs. In certain characterizations, the REE-containing acidic solution comprises at least 99 wt.% REEs on a metals basis, such as at least 99.8 wt.% REEs on a metals basis, or even at least about 99.99 wt.% REEs on a metals basis.

[00289] The step of contacting the REE-containing acidic solution with the SEG/HREE selective extractant may be carried out in counter-current flow, such as in one or more mixer-settlers. Contacting of the REE-containing acidic solution with the SEG/HREE selective extractant may be carried out in a single contacting step (e.g., in a single mixer-settler apparatus), or may be carried out in multiple contacting steps (e.g., in two or more mixer-settlers that are fluidly connected in series). For example, the REE-containing acidic solution may be first contacted with the SEG/HREE selective extractant to extract a first portion of the SEG/HREEs from the REE-containing acidic solution and leave substantially all of the Nd/Pr in the acidic solution, whereby a first Nd/Pr raffinate and a first SEG/HREE loaded extractant phase are formed. The first Nd/Pr-rich raffinate may then be contacted with the SEG/HREE selective extractant to extract at least a second portion of the SEG/HREEs from the first Nd/Pr raffinate, whereby a second Nd/Pr raffinate and a second SEG/HREE loaded extractant phase are formed.

[00290] As is noted above, the solvent extraction circuit may also include recovering the SEG/HREEs from the SEG/HREE loaded extractant phase, and may include separating the SEG and the HREEs. Separating the SEGs and the HREEs may comprise stripping the SEG/HREE loaded extractant phase, e.g., with an acid, to selectively strip the SEG from the SEG/HREE loaded extractant phase.

[00291] After the step of stripping the SEG/HREE loaded extractant phase to extract SEG, the resulting HREE loaded extractant phase may be contacted with a precipitative medium to precipitate the HREEs from the HREE loaded extractant phase and form an SEG/HREE depleted extractant. The

precipitative medium may be an organic acid, such as oxalic acid. When the organic acid is oxalic acid, the HREEs are precipitated as HREE-oxalates. The resulting SEG/HREE depleted extractant will be dispersed in oxalic acid and the two phases may be separated for recycling within the circuit. For example, the SEG/HREE depleted extractant may be recycled to the step of contacting the REE-containing acidic solution with the SEG/HREE selective extractant, and the oxalic acid may be recycled back to the step of contacting the SEG/HREE loaded extractant phase with the precipitative medium.

[00292] Again, it is noteworthy that the foregoing solvent extraction circuits may operate as essentially closed circuits, wherein the only required inputs are fresh oxalic acid (e.g., to replace oxalic acid lost with REE-oxalate precipitates) and water. The outputs from the system include a "basket" of very high purity HREES and a "basket" of very high purity SEG. Further, trace amounts of Nd/Pr of very high purity may also be recovered.

[00293] Another embodiment of the present disclosure is directed to a "scavenger" circuit (e.g., a process) for the removal/extraction of trace metals from a bulk metal. That is, the scavenger method is useful for recovering the small amounts of valuable elements from a different bulk metal, and/or for purifying the bulk metal by the removal of the trace metal.

[00294] As illustrated in **Fig. 20**, a method for the separation of at least one trace metal from at least one bulk metal is schematically illustrated. The method includes contacting an REE-containing acidic solution that includes at least one trace metal and at least one bulk metal with a trace metal selective extractant to extract at least a portion of the at least one trace metal from the REE-containing acidic solution and form a trace metal loaded extractant phase. This leaves substantially all of the bulk metal in the REE-containing acidic solution in the form of a bulk metal rich raffinate. The trace metal may then be recovered from the trace metal loaded extractant phase, and the at least one bulk metal may be recovered from the bulk metal rich raffinate.

[00295] In one characterization, the bulk metal is selected from the group consisting of samarium, europium, gadolinium and mixtures thereof. In another characterization, the bulk metal is selected from the group consisting of neodymium, praseodymium and mixtures thereof. In yet another characterization, the trace metals comprise one or more HREEs, e.g., terbium, dysprosium, holmium, erbium, thulium, ytterbium, lutetium, yttrium and combinations thereof.

[00296] Although it may be possible to utilize various extractants (e.g., organic extractants), the trace metal selective extractant may comprise a phosphoorganic compound, such as Di(2-ethylhexyl)

phosphate. The trace metal selective extractant will typically be dispersed in an inert hydrocarbon diluent such as kerosene for solvent extraction.

[00297] In certain characterizations, the REE-containing acidic solution comprises nitric acid. For example, the REE-containing acidic solution may have an acidity of at least about 0.0008M (about pH 3.1), such as at least about 0.01M (about pH 2). The acidity may also be not greater than about 0.15M (about pH 0.82), such as not greater than about 0.1M (about pH 1). The REE-containing acidic solution may be of high purity with respect to REEs and in one characterization may comprise at least 99 wt. % REEs on a metals basis, such as at least 99.9 wt. % REEs, or even at least 99.99 wt. % REEs on a metals basis.

[00298] The step of contacting the REE-containing acidic solution with the trace metal selective extractant may be carried out in counter-current flow in a mixer-settler apparatus, and advantageously may be carried out in a single contacting step, although the contacting step may also be carried out in multiple steps (e.g., using multiple mixer-settlers that are fluidly connected in series). In one characterization, the contacting step may include a first contacting step wherein the REE-containing acidic solution is contacted with the trace metal selective extractant to extract a first portion of the trace metals from the REE-containing acidic solution and leave substantially all of the bulk metals in the acidic solution, whereby a first bulk metal rich raffinate and a first trace metal loaded extractant phase are formed. The first bulk metal rich raffinate may then be contacted with the trace metal selective extractant in a second step (e.g., in a second mixer-settler) to extract at least a second portion of the trace metals from the first bulk metal rich raffinate, whereby a second bulk metal rich raffinate and a second trace metal loaded extractant phase are formed.

[00299] The recovery of the trace metals from the trace metal loaded extractant phase may advantageously include contacting the trace metal loaded extractant phase with a precipitative medium to precipitate the trace metals from the trace metal loaded extractant phase and form a trace metal depleted extractant. The precipitative medium may be an organic acid such as oxalic acid, whereby the trace metals are precipitated as oxalate compounds. This method may further include separating the trace metal depleted extractant from the oxalic acid, such that the trace metal depleted extractant may be recycled to the step of contacting the REE-containing acidic solution with the trace metal selective extractant, and the oxalic acid may be recycled back to the step of contacting the trace metal loaded extractant phase with the precipitative medium. Thus, the recovery of such trace metals can be achieved

in an essentially closed-loop circuit where the only reagent inputs beyond the startup phase are water and relatively small amounts of oxalic acid to replace the oxalic acid that is lost with the trace metal oxalates.

[00300] Another process according to the present disclosure may be applied to certain products to increase the purity of the products and/or to recover traces of valuable metals from the products. In one embodiment, a method for the purification of an acidic REE-rich acidic solution is disclosed. The method may include three distinct precipitation steps, namely:

first contacting an REE-rich acidic solution (e.g., comprising solubilized metals in a nitric acid solution) with a precipitant to increase the pH to at least about pH 2.8 and to not greater than about pH 3.1 to precipitate at least a first metal from the REE-rich acidic solution, the first metal being selected from the group consisting of Th, Fe, Al, Ba, U and mixtures thereof;

second contacting, after the first contacting, the REE-rich acidic solution with a precipitant to further increase the pH to at least about pH 4.8 and to not greater than about pH 6.5 to precipitate at least a second metal from the REE-rich acidic solution, the second metal being selected from the group consisting of cerium, terbium, dysprosium, holmium, erbium, thulium, ytterbium, lutetium, yttrium and mixtures thereof; and

third contacting, after the second contacting, the REE-rich acidic solution with a precipitant to further increase the pH to at least about pH 8.5 and to not greater than about pH 9 to precipitate at least a third metal from the REE-rich acidic solution, the third metal being selected from the group consisting of calcium, magnesium, potassium, sodium, strontium, zinc, titanium, manganese and mixtures thereof.

[00301] In one characterization, the REE-rich acidic solution comprises at least about 98 wt. % lanthanum on a metals basis. In another characterization, the REE-rich acidic solution comprises at least about 98 wt. % Nd/Pr on a metals basis.

[00302] In accordance with the foregoing disclosure, the various methods and circuits may be implemented as stand-alone processes, or may be integrated into a complete process for the separation of REEs and the removal of non-REEs (e.g., Th, U and/or base metals). In this integrated process, the products which are produced as high purity oxalates are Ce-oxalate, Th-oxalate and HREE-oxalates. The products that are recovered as hydroxides are high purity REE(OH)₃, La(OH)₃, Nd(OH)₃ and Pr(OH)₃. It can be seen that the portion of oxalic acid that is constantly being lost is due to cerium (e.g.,

about 38% to 43% of the feed REO product), thorium (e.g., up to about 2.4% of the feed REO product) and HREEs (e.g., up to about 3% of the feed REO product). This represents almost 50% of total feed REO product solids being removed as oxalates. If the consumption of oxalates becomes a cost concern, a metathesis reaction such as $\text{Na}_2\text{CO}_3 + \text{REE-oxalates} \rightarrow \text{Na-oxalates} + \text{REECO}_3$ may be utilized to store Na-oxalates and consume the less expensive sodium carbonate. The Na-oxalate powder may be stored as it has ~2.5 times the value of Na_2CO_3 and can be sold to offset the cost of oxalic acid. Thus, the only consumed reagent in the extraction plant would be sodium carbonate, a diluent (e.g., kerosene) and extractants plus ammonium hydroxide and HNO_3 .

Examples

Low Temperature Leach

[00303] Fig. 21 illustrates the acid leach results for leaching a high-grade (HG) bastnaesite-based mineral ore where the rare earth elements are predominately in the form of rare earth oxides. In this comparative example, the leaching is carried out with a 22% HCl solution at 90°C. In one test, 788 kg of acid per tonne of ore (kg/t) is utilized and in another test 654 kg/t of the acid is used. As can be seen in Fig. 21, the recovery of total rare earth elements (TREEs) is high (83% to 87%), however the selectivity is poor and substantial quantities of Al, Fe, Mg and Mn also report to the PLS. Further, 60% to 71% of the thorium also reports to the PLS.

[00304] Fig. 22 illustrates the acid leach results for leaching a high-grade (HG) bastnaesite-based mineral ore where the rare earth elements are in the form of rare earth carbonates. In this comparative example, the leaching is carried out with a 22% HCl solution at 90°C and 750 kg /t of acid is utilized. As can be seen in Fig. 22, the recovery of TREEs is high (~96%), however the selectivity is poor and substantial quantities of Al, Fe, Mg and Mn also report to the PLS. Further, 83% of the thorium also reports to the PLS.

[00305] Fig. 23 illustrates the acid leach results for leaching a high-grade (HG) bastnaesite-based mineral ore where the rare earth elements are in the form of rare earth carbonates and rare earth oxides. In this comparative example, the leaching is carried out with a 22% HCl solution at 90°C. In one test, 769 kg/t of acid is utilized and in another test 728 kg/t of the acid is used. As can be seen in Fig. 23, the recovery of TREEs is high (93% to 95.7%), however the selectivity is poor and substantial quantities of Al, Fe, Mg and Mn also report to the PLS. Further, 85% to 92% of the thorium also reports to the PLS.

[00306] **Fig. 24** illustrates the acid leach results for leaching a mid-grade bastnaesite-based mineral ore where the rare earth elements are in the form of rare earth carbonates and rare earth oxides. In this comparative example, the leaching is carried out with a 22% HCl solution at 90°C and in each test 680 kg/t of acid is utilized. In one test, a co-current leach configuration is utilized and in a second test a counter-current leach configuration is used. As can be seen in **Fig. 24**, digestion of REEs and gangue minerals in HCl is relatively high irrespective of the leach configuration.

[00307] **Figs. 25-30** illustrate the results of various leaching tests in accordance with the low temperature leaching step of the present disclosure. **Fig. 25** illustrates the results from leaching a mid-grade bastnaesite mineral ore body (Composition B) comprising REEs in the form of oxides and carbonates. In this example, the leaching is carried out with a 22% HCl solution at 20°C. 112 kg/t of the acid is utilized. As can be seen in **Fig. 25**, the recovery of TREEs is relatively high (80%), and the selectivity is good. Notably, less than 10% of the Fe reports to the PLS and reduced quantities of other elements such as Mg and Mn also report to the PLS. Further, the amount of thorium reporting to the PLS is only about 55%.

[00308] **Fig. 26** illustrates the results from leaching the mid-grade bastnaesite mineral ore body (Composition B) comprising REEs in the form of oxides and carbonates. In this example, the leaching is carried out with a 22% HCl solution at 35°C. 126 kg/t of the acid is utilized. As can be seen in **Fig. 26**, the recovery of TREEs is relatively high (~85%), and the selectivity is good. Notably, only about 10% of the Fe reports to the PLS and reduced quantities of other elements such as Mg and Mn also report to the PLS. Further, the amount of thorium reporting to the PLS is only about 51%.

[00309] **Fig. 27** illustrates the results from leaching a mid-grade bastnaesite mineral ore body (Composition B) comprising REEs in the form of oxides and carbonates. In this example, the leaching is carried out with a 22% HCl solution at 20°C. 155 kg/t of the acid is utilized. As can be seen in **Fig. 27**, the results are similar to those obtained at 112 kg/t acid (**Fig. 25**).

[00310] **Fig. 28** illustrates the results from leaching a mid-grade bastnaesite mineral ore body (Composition B) comprising REEs in the form of oxides and carbonates. In this example, the leaching is carried out with a 22% HCl solution at 20°C. 178 kg/t of the acid is utilized. As can be seen in **Fig. 28**, the results are similar to those obtained at 112 kg/t acid (**Fig. 26**).

[00311] **Fig. 29** illustrates the results from leaching a mid-grade bastnaesite mineral ore body (Composition B) comprising REEs in the form of oxides and carbonates. In this example, the leaching

is carried out with a 22% HCl solution at 20°C. The acid was reduced to 82 kg/t. As can be seen in **Fig. 29**, even at these low acid levels, a substantial quantity of TREEs (~76%) are solubilized in the PLS. Less than 10% of the Fe reports to the PLS and reduced quantities of other elements such as Mg and Mn also report to the PLS. Further, the amount of thorium reporting to the PLS is only about 59%.

[00312] **Fig. 30** illustrates the results from leaching a mid-grade bastnaesite mineral ore body (Composition B) comprising REEs in the form of oxides and carbonates. In this example, the leaching is carried out with a 22% HCl solution at 20°C. Only 56 kg/t of the acid is utilized. As can be seen in **Fig. 30**, over 80% of the critical REEs are recovered in the PLS and less than about 10% of the Fe reports to the PLS. Further, only about 60% of the thorium reports to the PLS.

[00313] The foregoing examples demonstrate the ability of the leaching method of the present disclosure to produce a high grade PLS containing a high percentage of the available TREEs while reducing the solubilization of undesirable metals (e.g., base metals) such as Fe.

Oxalate Formation

[00314] A PLS containing REEs is contacted with oxalic acid to precipitate metal oxalates. The precipitation temperature is about 70°C. No sulfite was added to the PLS, and therefore Fe³⁺ was present. No recycle was performed. The concentration of oxalic acid is varied from 90 g/l to 115 g/l to 140 g/l to assess the effect of oxalic acid concentration on the purity of the precipitate product (i.e., the metal oxalates). Results are shown in **Table IX**.

Table IX

Element	Oxalate @ 90 g/l H ₂ C ₂ O ₄ (wt.%)	Oxalate @ 115 g/l H ₂ C ₂ O ₄ (wt.%)	Oxalate @ 140 g/l H ₂ C ₂ O ₄ (wt.%)
REEs ¹			
Ce	16.511467	16.61625	16.36584
La	8.549287	8.323717	7.840823
Nd	5.490483	5.67714	5.908091
Pr	1.594311	1.635.82	1.66676
Y	0.075021	0.075069	0.7525
TOTAL REEs	32.220569	30.6922	32.534
Impurity Elements			

Th		0.193692	0.218965
U	0.001687	0.001574	0.001865
Si	0.491763	0.46509	0.470356
Au	< LOD	< LOD	0.002628
As	0.002351	0.0011.58	0.002418
Se	< LOD	< LOD	< LOD
Pb	< LOD	< LOD	< LOD
Zn	< LOD	< LOD	< LOD
Cu	0.012393	0.012785	0.013937
Ni	0.032589	0.034371	0.03619
Co	0.071752	0.070868	0.070785
Fe	0.513656	0.530995	0.564361
Mn	< LOD	< LOD	< LOD
Cr	< LOD	< LOD	< LOD
V	< LOD	< LOD	< LOD
Ti	< LOD	< LOD	< LOD
Ca	< LOD	< LOD	< LOD
K	< LOD	< LOD	< LOD
Zr	< LOD	< LOD	< LOD
Mo	0.000372	0.000516	0.000781
Nb	0.000466	0.000678	<LOD
Sr	0.00376	<LOD	<LOD
Mn	< LOD	< LOD	< LOD
Cr	< LOD	< LOD	< LOD
V	< LOD	< LOD	< LOD
Ti	< LOD	< LOD	< LOD
Ca	< LOD	< LOD	< LOD
K	< LOD	< LOD	< LOD
Al	< LOD	< LOD	< LOD
Mg	< LOD	< LOD	< LOD
Zr	< LOD	< LOD	< LOD

1 – other REEs not analyzed

<LOD = below the limits of detection

[00315] As illustrated by **Table IX**, REE-oxalates with a high proportion of REEs and a relatively low proportion of non-REEs can be obtained by oxalate precipitation over a range of oxalic acid concentrations, even at a precipitation temperature of about 70°C. In particular, it is noteworthy that in comparison the foregoing, many prior processes for separation of REEs from a PLS also precipitate

many non-REE elements with the REEs, for example U, Si, As, Pb, Zn, Fe, Mn, Mo, Nb, Cr, Ti, Ca, K, Al and Zr.

Hydroxylation

[00316] In the following Example, thorium is precipitated from an acidic solution using a hydroxide precipitant at various pH levels to observe the effect of pH on the precipitation of thorium and of REEs.

[00317] For these tests, 400 grams (326 ml) of a nitric acid solution having a free acid content of about 5 g/l and a specific gravity of 1.227 is added to a one liter vessel having a mixer. A 1M solution of ammonium hydroxide (NH₄OH) is added dropwise to the vessel until the target pH level is reached, and the target pH is maintained for one hour. A temperature of about 25°C is maintained during the precipitation step. After 60 minutes, the vessel contents are filtered and the weight, specific gravity and free acid content of the filtrate are measured. The retentate is washed with deionized water and dried. The results are illustrated in **Table X**.

Table X

Element	Acidic Solution Assay (mg/l or g/tonne)	% Precipitated @ pH 1.0	% Precipitated @ pH 2.0	% Precipitated @ pH 2.5	% Precipitated @ pH 3.0	% Precipitated @ pH 3.5
La	20000	7	5	4	0	2
Ce	13500	7	5	3	0	2
Pr	3150	3	0	7	0	19
Nd	11000	4	1	3	0	3
Sm	1580	4	0	8	0	19
Eu	352	3	0	7	0	19
Gd	814	2	0	5	0	15
Tb	62	3	0	8	4	22
Dy	204	2	0	5	0	17
Ho	24	2	0	4	1	19

Y	494	5	0	7	0	18
Er	40	3	0	7	0	15
Tm	4	4	4	3	0	18
Yb	19	7	6	5	2	21
Lu	3	5	5	5	2	21
Sc	<5	0	0	3	22	70
Th	734	4	1	8	62	95
U	1	0	0	0	0	24

[00318] The foregoing data is graphically illustrated in **Fig. 31**. This data demonstrates that at pH 3.0, 62% of the thorium in the acidic solution may be precipitated as thorium hydroxide. When the pH is increased to pH 3.5, 95% of thorium is precipitated; however increasing amounts of REEs also begin to precipitate from the solution.

[00319] However, if thorium concentration in the solution is decreased, it is found that the pH can be increased without precipitating significant quantities of REEs from the solution. **Fig. 32** illustrates the results of increasing the pH of a solution over a range from pH 3.0 to pH 3.8, where the initial thorium concentration is decreased to 117 mg/l. As is illustrated in **Fig. 32**, pH levels at least as high as pH 3.8 can be utilized to extract a high percentage of the thorium without precipitating significant amounts of the REEs. The results for the tests at pH 3.5, pH 3.6 and pH 3.8 for a solution containing 117 mg/l thorium are given in **Table XI**.

Table XI

Element	Feed Assay (mg/l or g/tonne)	Final Solution Assay @ pH 3.5 (mg/l or g/tonne)	Percent Removed @ pH 3.5	Final Solution Assay @ pH 3.6 (mg/l or g/tonne)	Percent Removed @ pH 3.6	Final Solution Assay @ pH 3.8 (mg/l or g/tonne)	Percent Removed @ pH 3.8
La	2710	2200	1	2220	0	2160	2

Ce	1870	1520	1	1540	0	1500	2
Pr	473	386	0	390	0	380	2
Nd	1630	1344	0	1364	0	1332	0
Sm	232	189	0	191	0	187	1
Eu	51.0	42	0	42	0	41	1
Gd	122	99	0	102	0	100	0
Tb	9.8	8	0	8	0	8	0
Dy	30.8	23	1	25	0	25	0
Ho	3.52	5	1	3	0	3	0
Y	74.4	60	1	61	0	59	3
Er	6.15	5.06	0	4.84	4	4.96	1
Tm	0.58	0.46	3	0.5	0	0.48	0
Yb	2.83	2.32	0	2.30	1	2.22	4
Lu	0.35	0.30	0	0.28	2	0.28	2
Sc	0.71	0.62	0	0.40	31	0.48	17
Th	117	69	28	65	32	51	46
U	0.22	0.18	0	0.18	0	0.18	0

[00320] As is illustrated in this Example, high levels of thorium can be extracted from a relatively dilute solution at increased pH levels, without extracting high levels of REEs from the solution.

[00321] In another Example, the co-precipitation of cerium and thorium from a cerium-containing product is demonstrated. The cerium containing REE-product may contain a very high proportion of lower value cerium as compared to other REEs. In this example, to precipitate cerium, cerium-containing acidic solutions (e.g., nitric acid liquors) containing dissolved cerium and other REEs, as well as thorium, are subjected to a two-step precipitation process where the pH of the two precipitation steps is varied to

assess the effect of pH on the selectivity for Ce and Th. The parameters for the first stage precipitation at 3 different pH values are given in **Table XII** below. In each instance, the cerium-containing acidic solution comprised from about 18% to about 20% HNO₃ and the total contact time was about 1 hour at ambient temperature.

Table XII

Parameter	1 st Stage Precipitation		
	Example 3A	Example 3B	Example 3C
Cerium-containing solution (g)	4,210	4,710	3,720
Free HNO ₃ (wt.%)	20.7	18.3	18.3
NH ₄ OH Added (g NH ₄ OH/g solution)	0.080	0.065	0.087
1st stage final pH	3.7	3.3	4.0
Precipitated Elements			
	wt. %	wt. %	wt. %
Ce	60.2	61.3	62.4
Nd	4.2	6.16	3.62
Gd	5.9	7.55	5.47
Y	5.9	8.87	5.62
Th	98.5	77.1	99.9

[00322] These results are also illustrated in **Fig. 33**. As illustrated by this data, the precipitation process is highly selective for the precipitation of Ce and Th, to the exclusion of other REEs such as Nd, Gd and Y, particularly at pH values approaching pH 4.

[00323] However, the data also illustrates that significant amounts (e.g., about 37% or more) of the cerium remains in the Ce-depleted acidic solution under these conditions. Therefore, a second precipitation step is performed on the Ce-depleted solution from the first precipitation step to extract additional cerium, and possibly thorium, from the first Ce-depleted solution. This second precipitation step is also performed by contacting the (first) Ce-depleted solution with additional ammonium hydroxide to precipitate a (second) portion of Ce from the nitric acid liquor.

[00324] Table XIII illustrates the data for the second stage precipitation.

Table XIII

Parameter	2nd Stage Precipitation		
	Example 3A	Example 3B	Example 3C
1st stage Filtrate (g)	6620	5112	6308
Initial pH	3.7	3.3	4.0
NH ₄ OH added 1M-NH ₄ OH solution (g)	8	46	6
Target pH	4.83	4.30	5.02
Elements Precipitated	wt. %	wt. %	wt. %
Ce	6.26	46.5	0.82
Nd	< 0	1.92	0
Gd	< 0	2.68	0
Y	< 0	2.66	0.00
Th	96.6	99.5	0

[00325] The data for the second precipitation step is also illustrated in **Fig. 34**. By adjusting the pH of the precipitation steps (e.g., by controlling the addition of NH₄OH), the filtrate (e.g., the cerium depleted solution from the second precipitation step) may be substantially free of cerium and thorium.

[00326] Table IXX illustrates the combined results of the two-stage precipitation process.

Table IXX

Parameter	Overall Precipitation		
	Example 3A pH 3.7 & pH 4.8	Example 3B pH 3.3 & pH 4.3	Example 3C pH 4.0 & pH 5.0
Elements Precipitated	wt. %	wt. %	wt. %
Ce	63	80.0	63
Nd	4.18	7.96	5.47
Gd	8.38	9.48	5.37
Y	8.38	9.73	5.62
Th	99.95	99.89	99.91

[00327] This data is also graphically illustrated in **Fig. 35**. It can be seen that the two-stage process may result in the removal of one filtrate (solution) that is 80% cerium free and essentially 100% thorium free. A majority of the Ce and essentially all of the Th report to the solid residue.

[00328] As can be understood from the above description, the methods disclosed herein also encompass the utilization of chemical precipitation to separate rare earth elements from each other and from thorium and/or uranium. This separation can advantageously be utilized to simplify the subsequent solvent extraction steps that are necessary to separate one or more of the rare earth elements and/or thorium and uranium from each other. In one particular embodiment, chemical precipitation can be utilized to form a plurality of “baskets,” where each basket of REEs includes a group of metallic elements that may be efficiently separated by solvent extraction.

[00329] Throughout the following examples, the percentage (%) refers to percentage by mass, unless otherwise indicated. Further, the mass percentage of the REEs is given relative to the total REEs, whereas the percentage of non-REEs (notably Th and U) is given relative to the total metals mass (REEs plus non-REEs) of a particular product.

Preparation of a First Precipitation Product

[00330] A rare earth oxide product (e.g., powder) is obtained. The rare earth oxide product is produced from a rare earth containing ore (e.g., bastnaesite ore) The rare earth oxide product is a rare earth oxide powder having the approximate composition listed in **Table XX**.

Table XX

Element(s)	Wt.% of the Metals in the Rare Earth Oxide Product
La	21.674
Ce	40.866
Pr	5.283
Nd	19.662
Sm	3.221
Eu	2.759
Gd	2.018
Tb	0.174
Dy	0.513
Ho	0.198
Er	0.084
Tm	0.008
Yb	0.039
Lu	0.006
Y	3.495
Total REEs	100.00
Th	2.124
U	0.003

REE Groups	
LREEs	90.706
HREEs	9.294
CREEs	31.886

[00331] As listed in **Table XX**, and noted above, the term Critical Rare Earth Elements (“CREEs”) includes neodymium (Nd), europium (Eu), terbium (Tb), dysprosium (Dy), praseodymium (Pr) and yttrium (Y). The term Heavy Rare Earth Elements (“HREEs”) includes europium (Eu), gadolinium (Gd), terbium (Tb), dysprosium (Dy), holmium (Ho), erbium (Er), thulium (Tm), ytterbium (Yb), lutetium (Lu) and yttrium (Y). The term Light Rare Earth Elements (“LREEs”) refers to lanthanum (La), cerium (Ce), praseodymium (Pr), neodymium (Nd) and samarium (Sm). It is notable that the rare earth oxide product advantageously has a total rare earth element content of over 97%, namely 97.873%. That is, 97.873% of the metals in the rare earth oxide product are rare earth elements, with the non-REEs being Th and a trace of U. The rare earth oxide product is substantially free of base metals.

[00332] The rare earth oxide product is digested in nitric acid at 80°C to 90°C to form a first rare earth solution. A sufficient amount of a 70% HNO₃ acidic solution is added to the rare earth oxide product to solubilize substantially all of the metals in the rare earth oxide product, wherein the first rare earth solution has a metals composition that is substantially identical to the metals composition of **Table XX**. After dissolution of substantially all of the metals, the first rare earth solution has a free acid content of about 22% HNO₃ (about 5M HNO₃).

[00333] To selectively precipitate certain metals from the first rare earth solution, the solution is then contacted with ammonium hydroxide (NH₄OH) in the form an aqueous solution of 58% ammonium hydroxide. Sufficient ammonium hydroxide is added to the first rare earth solution to increase the pH to about pH 4.8. During the addition of the ammonium hydroxide, a first precipitation product forms. The first precipitation product comprises hydroxide precipitates having the metals composition given in **Table XXI**. **Table XXI** also lists the percentage of the elements from the rare earth oxide product that precipitate in the first precipitation product, and the metals composition of the solution (*i.e.*, the second rare earth solution) that is separated from the first precipitation product.

Table XXI

Element(s)	Wt.% of the Metals in the First Precipitation Product	Wt.% of the Element from the Rare Earth Oxide Powder Reporting to the First Precipitation Product	Wt.% of the Total Metals in the Second Rare Earth Solution
La	1.251	0.807	24.993
Ce	66.409	21.379	39.693
Pr	1.769	4.681	5.855
Nd	7.236	5.145	21.682
Sm	2.621	11.376	3.319
Eu	0.741	13.738	0.757
Gd	1.656	11.474	2.077
Tb	0.283	22.804	0.156
Dy	1.145	31.202	0.410
Ho	0.133	34.305	0.041
Er	0.264	43.766	0.055
Tm	0.034	62.283	0.003
Yb	0.206	73.826	0.012
Lu	0.026	58.640	0.003
Y	1.063	15.551	0.938
Th	15.147	99.721	0.007
U	0.017	96.550	0.000
REE Grouping Content			

REEs	Wt.% of the Total Metals in the First Precipitation Product	Wt.% of the Elements from the Rare Earth Oxide Powder Reporting to the First Precipitation Product	Wt.% of the Total Metals in the Second Rare Earth Solution
TREEs	84.837	12.119	99.993
LREEs	79.286	11.885	95.542
HREEs	5.551	16.85	4.452
CREEs	12.237	6.257	29.798

[00334] A number of observations can be made from the data in **Table XXI**. First, it is notable that substantially all of the thorium from the rare earth oxide product reports to the first precipitation product. Specifically, 99.721% of the thorium from the rare earth oxide product reports to the first precipitation product. Thus, substantially all of the thorium is separated from the rare earth elements by this single precipitation step. A substantial amount (96.550%) of the uranium, which was only present in trace amounts to begin with, also reports to the first precipitation product.

[00335] As a result, the second rare earth solution that is separated from the first precipitation product has a very high purity with respect to rare earth elements. Specifically, rare earth metals advantageously constitute 99.993% of the total metals in the second rare earth solution, and the mass % of thorium and uranium is only 0.007%.

[00336] It is also notable that only about 13.981% of the total metal elements from the rare earth oxide product precipitate in the first precipitation product. Thus, not only does the first precipitation product effectively separate substantially all of the thorium and the trace uranium from the rare earth oxide product, but the mass of the first precipitation product is small as compared to the mass of the rare earth oxide product that is input. Because substantially all of the thorium is extracted in a relatively small mass, the plant for subsequently treating the first precipitation product (e.g., to dispose of thorium and uranium) can be relatively small.

Preparation of a Second Precipitation Product

[00337] The second rare earth solution that is separated from the first precipitation product is then treated to precipitate the remaining metal elements from the solution. Specifically, the second rare earth

solution is contacted with additional ammonium hydroxide to increase the pH of the second rare earth solution to about pH 9. At this pH, substantially all of the metal elements in the second rare earth solution will precipitate from the second rare earth solution to form a first intermediate feed, e.g., comprising metal hydroxides having substantially the same metals composition as the second rare earth solution. The first intermediate feed is separated from the remaining barren acidic solution, and the barren acidic solution may be recycled to conserve water and OH⁻ values.

[00338] The first intermediate feed precipitated from the second rare earth solution is then digested in nitric acid, in a manner similar to that described above for the rare earth oxide product, to re-digest substantially all of the metal elements into an acidic solution. After dissolution of substantially all of the metals, the solution has a free acid content of about 8M HNO₃. In a manner similar to that described above, the acidic solution is contacted with ammonium hydroxide in the form an aqueous solution of 58% ammonium hydroxide. Sufficient ammonium hydroxide is again added to increase the pH to about pH 4.8. During the addition of the ammonium hydroxide, a second precipitation product forms. The second precipitation product comprises rare earth element hydroxide precipitates, and has the composition given in **Table XXII**. **Table XXII** also lists the percentage of the elements from the rare earth oxide product that precipitate in the second precipitation product, and the composition of the solution (the third rare earth solution) that is separated from the second precipitation product.

Table XXII

Element(s)	Wt.% of the Metals in the Second Precipitation Product	Wt.% of Element from the Rare Earth Oxide Powder Reporting to the Second Precipitation Product
La	2.262	2.892
Ce	86.455	55.170
Pr	1.640	8.604
Nd	5.630	7.935
Sm	1.491	12.829
Eu	0.382	14.033
Gd	0.799	10.975

Tb	0.127	20.231
Dy	0.474	25.616
Ho	0.052	26.881
Er	0.093	30.701
Tm	0.008	31.150
Yb	0.031	22.277
Lu	0.006	26.820
Y	0.526	15.258
Th	0.022	0.282
U	0.000	0.900
REE Grouping Content		
REEs	Wt.% of the Metals in the Second Precipitation Product	Wt.% of Element from the Rare Earth Oxide Powder Reporting to the Second Precipitation Product
TREEs	99.976	28.309
LREEs	97.478	28.964
HREEs	2.498	25.025
CREEs	8.779	8.898

[00339] As can be seen from **Table XXII**, the second precipitation product is a rich in Ce and is predominately comprised of the LREEs. Further, the mass of the metals in the second precipitation product is about 27.713 mass % of the metals in the rare earth oxide powder. Thus, a majority of the Ce (55.170%) from the rare earth oxide product is sequestered in a relatively low mass second precipitation product.

Preparation of a Third Precipitation Product

[00340] The fourth rare earth solution that is separated from the second precipitation product has a pH of about 4.8 and is comprised primarily of solubilized rare earth elements. The composition of the fourth rare earth solution is shown in **Table XXIII**.

Table XXIII

Element	Wt.% of the Metals in the Fourth Rare Earth Solution
La	35.797
Ce	17.466
Pr	7.858
Nd	29.311
Sm	4.188
Eu	0.935
Gd	2.684
Tb	0.170
Dy	0.380
Ho	0.036
Er	0.037
Tm	0.001
Yb	0.003
Lu	0.002
Y	1.134
TREEs	100.002
Th	0.0006
U	0.0006

REE Grouping Content	
REEs	Wt.% of the Metals in the Fourth Rare Earth Solution
LREEs	94.620
HREEs	5.382
CREEs	39.788

[00341] The fourth rare earth solution has a pH of about 4.8 and is a salable product that has an extremely high purity with respect to rare earth elements. Here, the fourth rare earth solution is treated to convert the rare earth elements in the solution to a solid product (e.g., a third precipitation product) having substantially the same metals composition as the fourth rare earth solution. In this regard, the third precipitation product is formed by increasing the pH of the fourth rare earth solution (e.g., to about pH 9) through the addition of ammonium hydroxide to precipitate the rare earth elements as a hydroxide precipitate. As with the fourth rare earth solution, this third precipitation product has an extremely high purity with respect to rare earth metals. Further, the cerium content of the third precipitation product is relatively low (17.466%), the concentration of critical rare earth elements is relatively high (39.787%) and the lanthanum content is relatively high (35.797%).

Solvent Extraction

[00342] The three “baskets” described above (the first, second and third precipitation products) are further treated in various solvent extraction steps to further separate rare earth elements and/or thorium and uranium. The creation of the three precipitation products advantageously enables the number and/or complexity of the solvent extraction steps to be greatly reduced.

Solvent Extraction of the Third Precipitation Product

[00343] As is noted above, the third precipitation product comprises a relatively small percent mass fraction of thorium, cerium (17%) and heavy rare earth elements (1.67%). However, the third precipitation product is rich in critical rare earths (39.787%), praseodymium and neodymium (37.169% combined), and samarium and gadolinium (7.052% total) It is desirable to remove the thorium and cerium from the

product to upgrade the critical rare earth elements, and it is further desirable to separate the thorium from the cerium downstream in a dedicated facility for radioactive element separation.

[00344] The third rare earth precipitation product is dissolved in nitric acid at a temperature of 80°C to 90°C, where the final acidity after substantially all of the metals have been solubilized is about 8M HNO₃. Ammonium hydroxide is then added to the acidic solution such that the mass ratio of ammonium hydroxide to the nitrate solution is about 1:6.75 and the water added (through the 58% NH₄OH solution) is about 1:6.47 in relation to the nitric acid solution. This procedure effectively adjusts the pH of the solution downward to about 3.8% HNO₃ (0.9M). Further, while not wishing to be bound by any theory, it is believed that elevating the acidity after the digestion of the metal elements from the first precipitation product puts the cerium and the thorium into the 4+ oxidation, *i.e.*, Ce⁴⁺ and Th⁴⁺. Upon addition of the ammonium hydroxide (58% NH₄OH in water), the Ce⁴⁺ and Th⁴⁺ each form a complex with the NH₄⁺ in solution. These ammonium complexes are believed to remain stable down to the lower pH values such as down to about 0.9M or lower.

[00345] As a result, the cerium and all traces of thorium can be selectively extracted from the solution. **Table XXIV** illustrates these results for a sample of the third precipitation product having a metals mass of 465.03 grams, where the solvent extraction was carried out at a nitric acid concentration of about 1M with 15% TBP (tributyl phosphate) in kerosene at ambient temperature (about 20°C) for about 7.5 minutes.

Table XXIV

Element	Third Precipitation Product (grams)	Amount Extracted from Aqueous with TBP Organic (grams)	Percentage Extracted from Aqueous with TBP Organic	Amount Remaining in Aqueous Phase (grams)
La	166.76	1.688	1.01	165.07
Ce	81.55	75.165	92.17	6.39
Pr	36.44	0.579	1.59	35.86
Nd	135.92	2.683	1.97	133.24
Sm	19.42	0.607	3.13	18.81
Eu	4.33	0.154	3.56	4.17
Gd	12.45	0.408	3.28	12.04
Tb	0.78	0.033	4.23	0.75
Dy	1.76	0.071	4.03	1.69
Ho	0.17	0.000	0	0.17
Er	5.25	0.125	2.38	5.13
Tm	0.18	0.000	0	0.18
Yb	0.0072	0.000	0	0.0072
Lu	0.0123	0.000	0	0.0123
Y	0.0024	0.000	0	0.0024
Th	0.0037	0.0029	78.38	0.0001
U	0.0006	0.0006	100	0.0000

[00346] As can be seen from **Table XXIV**, this single solvent extraction step advantageously separates cerium and thorium from the rare earth elements. By removing almost 92% of cerium and 78% of thorium, the purity of the product increases to 99.9998% total rare earth elements, and the critical rare earths content is upgraded from 39.6% to 47.2%. Praseodymium and neodymium are the dominant elements in the critical rare earth group, and their concentration increases from 37.1% to 44.1%. The organic extractant extracts about 92.2% of total cerium and greater than 78% of total thorium, and the aqueous phase contained about 99.9998% rare earth elements with a very low concentration of cerium and almost undetectable thorium (< 0.3 ppm Th).

[00347] **Fig. 36A** illustrates the effect of acidity levels of 1M HNO₃ (**E1** as reported in **Table XXIV**), 3M HNO₃ (**E2**) and 6M HNO₃ on the selectivity of Ce extraction. As is illustrated in **Fig. 36A**, as the acidity increases, the selectivity for Ce decreases, and the amount of other REEs begins to increase. As a result, it is desirable to conduct the solvent extraction at a relatively low acidity, such as around 1M HNO₃ or slightly less, such as from about 0.7M to about 1M HNO₃. **Fig. 36B** illustrates the selective extraction of Th at 1M and 3M during the same test that is illustrated in **Fig. 36A**. It can be seen that Th is also selectively extracted with the Ce.

[00348] The extracted composition that predominately contains cerium and thorium can be further processed to separate the cerium from the thorium. In this regard, it has been found that cerium can be selectively separated from thorium by the methodology described above.

[00349] **Fig. 37** illustrates the effect of solvent extraction variables, such as TBP dosage, on the selectivity for Ce during solvent extraction. As is illustrated in **Fig. 37**, very high selectivity for Ce can be achieved at relatively low TBP concentrations (% in kerosene) such as 15% TBP and in an acid concentration of 0.8M HNO₃ in a single contact solvent extraction step.

[00350] **Fig. 38** illustrates the separation of LREEs and HREEs using solvent extraction at a pH of pH 2, using 20% D2EHPA. For the data illustrated in **Fig. 38**, the solvent extraction is carried out at ambient temperature (about 20°C) and an organic:aqueous ration of 1.1:1. The feed was an acidic HNO₃ solution comprising the REEs, and before solvent extraction the acidity of the HNO₃ was increased to pH 2 through the addition of NH₄OH.

[00351] **Figs. 39A to 39E** illustrate the conditions under which the actinides Th and U can be selectively separated from REEs. In each case, the NH₄OH is at 2M. This set of solvent extraction data at 0.5N, 1.0N, 3.0N, 6.0 and 6.8 N HNO₃ illustrates that Ce extraction is very low and above 3N HNO₃

no or substantially no Ce is extracted. This is believed to be due to the Ce being in the +3 oxidation state and not forming a cerium III ammonium nitrate complex in solution. This means that evaporating 68% of liquor at 80°C and concentrating NH_4NO_3 up to about 2M had no effect on the Ce III species. Hence reaction with 20%TBP is very limited as seen by the low recoveries at < 3.0N HNO_3 .

[00352] Thus, as is illustrated in **Figs. 39A to 39E**, at relatively high acid concentrations (*e.g.*, about 6M or higher), Th and U can be selectively separated from REEs, including from Ce. This methodology may be particularly effective for separating Th and U from Ce, such as in the first precipitation product (Basket1) and/or the second precipitation product (Basket2).

[00353] A comprehensive flowsheet illustrating a process for the processing of rare earth containing products to obtain very high purity REEs is illustrated in **Fig. 40**.

[00354] While various embodiments of a processing technique for the extraction of rare earth elements have been described in detail, it is apparent that modifications and adaptations of those embodiments will occur to those skilled in the art. However, it is to be expressly understood that such modifications and adaptations are within the spirit and scope of the present disclosure, including the appended claims.

What is Claimed is:

1. A method for the separation of thorium from an acidic solution comprising thorium and at least one rare earth element, comprising the steps of:
 contacting the acidic solution with a phosphinic acid-type extractant to extract at least a portion of the thorium from the acidic solution, forming a thorium-depleted acidic solution and a thorium-loaded extractant; and
 contacting the thorium-loaded extractant with oxalic acid to strip thorium from the thorium-loaded extractant and form a thorium-depleted extractant.
2. The method according to Claim 1, wherein the acidic solution is formed by digesting a rare earth oxide product in an acid.
3. The method according to any one of Claims 1 or 2, wherein the acidic solution comprises nitric acid.
4. The method according to any one of Claims 1 to 3, wherein, during the contacting of the acidic solution with the extractant, the acidic solution has an acidity of not greater than 1.0 M.
5. The method according to any one of Claims 1 to 4, wherein the extractant is dispersed in a hydrocarbon diluent.
6. The method according to any one of Claims 1 to 5, wherein the extractant comprises bis(2,4,4-trimethylpentyl)phosphinic acid.
7. The method according to any one of Claims 5 or 6, wherein the concentration of extractant in the diluent is at least 20% and is not greater than 30%.
8. The method according to any one of Claims 1 to 7, wherein the extractant is contacted with the acidic solution in countercurrent flow.

9. The method according to Claim 1, further comprising the step of separating the thorium-depleted extractant from the oxalic acid and recycling the thorium-depleted extractant to the contacting step.
10. The method according to any one of Claims 1 to 9, wherein the thorium-depleted acidic solution comprises not greater than 0.05 wt.% thorium.
11. The method according to any one of Claims 1 to 10, wherein the thorium-depleted acidic solution comprises at least 99% rare earth elements on a metals basis.
12. The method according to any one of Claims 1 to 11, wherein substantially all of the thorium in the acidic solution is in the +4 oxidation state.
13. The method according to Claim 12, wherein the acidic solution is formed by digesting a rare earth oxide product in an acid and wherein the rare earth oxide product is formed by calcining a thorium-containing compound at a temperature of at least 710°C in an oxidizing environment.
14. The method according to any one of Claims 1 to 13, further comprising the step of separating cerium from the acidic solution before the step of contacting the acidic solution with a phosphinic acid-type extractant to extract thorium to form a cerium-depleted acidic solution.
15. The method according to Claim 14, further comprising the step of contacting the cerium-depleted acidic solution with a phosphoorganic extractant to separate at least a portion of lanthanum from the cerium-depleted acidic solution.
16. The method according to Claim 15, wherein the phosphoorganic extractant comprises Di(2-ethylhexyl) phosphate.

17. The method according to any one of Claims 15 to 16, comprising the step of decreasing the acidity of the cerium-depleted acidic solution before contacting the cerium-depleted acidic solution with the phosphoorganic extractant.

18. A method for the separation of thorium from an acidic solution comprising thorium and at least one rare earth element, comprising the step of:

contacting the acidic solution with a phosphinic acid-type extractant to extract at least a portion of the thorium from the acidic solution, wherein the concentration of extractant in the diluent is at least 20% and is not greater than 30%, forming a thorium-depleted acidic solution and a thorium-loaded extractant,

wherein the acidic solution is formed by digesting a rare earth oxide product in an acid and wherein the rare earth oxide product is formed by calcining a thorium-containing compound at a temperature of at least 710°C in an oxidizing environment, and

wherein substantially all of the thorium in the acidic solution is in the +4 oxidation state.

19. The method according to Claim 18, wherein the acidic solution comprises nitric acid.

20. The method according to any one of Claims 18 to 19, wherein, during the contacting of the acidic solution with the extractant, the acidic solution has an acidity of not greater than 1.0 M.

21. The method according to any one of Claims 18 to 20, wherein the extractant is dispersed in a hydrocarbon diluent.

22. The method according to any one of Claims 18 to 21, wherein the extractant comprises bis(2,4,4-trimethylpentyl)phosphinic acid.

23. The method according to any one of Claims 18 to 22, wherein the extractant

is contacted with the acidic solution in countercurrent flow.

24. The method according to any one of Claims 18 to 23, further comprising the step of contacting the thorium-loaded extractant with an organic acid to strip thorium from the thorium-loaded extractant and form a thorium-depleted extractant.

25. The method according to Claim 24, wherein the organic acid comprises oxalic acid.

26. The method recited in any one of Claims 24 to 25, further comprising the step of separating the thorium-depleted extractant from the organic acid and recycling the thorium-depleted extractant to the contacting step.

27. The method according to any one of Claims 18 to 26, wherein the thorium-depleted acidic solution comprises not greater than 0.05 wt.% thorium.

28. The method according to Claim 27, wherein the thorium-depleted acidic solution comprises at least 99% rare earth elements on a metals basis.

29. The method according to any one of Claims 18 to 28, further comprising the step of separating cerium from the acidic solution before the step of contacting the acidic solution with a phosphinic acid-type extractant to extract thorium to form a cerium-depleted acidic solution.

30. The method according to Claim 29, further comprising the step of contacting the cerium-depleted acidic solution with a phosphoorganic extractant to separate at least a portion of lanthanum from the cerium-depleted acidic solution.

31. The method according to Claim 30, wherein the phosphoorganic extractant comprises Di(2-ethylhexyl) phosphate.

32. The method according to any one of Claims 30 to 31, comprising the step of decreasing the acidity of the cerium-depleted acidic solution before contacting the cerium-depleted acidic solution with the phosphoorganic extractant.

33. A method for the separation of thorium from an acidic solution comprising at least thorium, cerium and lanthanum, comprising the step of:

separating cerium from the acidic solution to form a cerium-depleted acidic solution;

contacting the cerium-depleted acidic solution with a phosphoorganic extractant to separate at least a portion of lanthanum from the cerium-depleted acidic solution;

contacting the cerium-depleted acidic solution with a phosphinic acid-type extractant to extract at least a portion of the thorium from the acidic solution forming a thorium-depleted acidic solution and a thorium-loaded extractant,

wherein the acidic solution is formed by digesting a rare earth oxide product in an acid and wherein the rare earth oxide product is formed by calcining a thorium-containing compound at a temperature of at least 710°C in an oxidizing environment, and

wherein substantially all of the thorium in the acidic solution is in the +4 oxidation state.

34. The method according to Claim 33, wherein the phosphoorganic extractant comprises Di(2-ethylhexyl) phosphate.

35. The method according to any one of Claims 33 to 34, comprising the step of decreasing the acidity of the cerium-depleted acidic solution before contacting the cerium-depleted acidic solution with the phosphoorganic extractant.

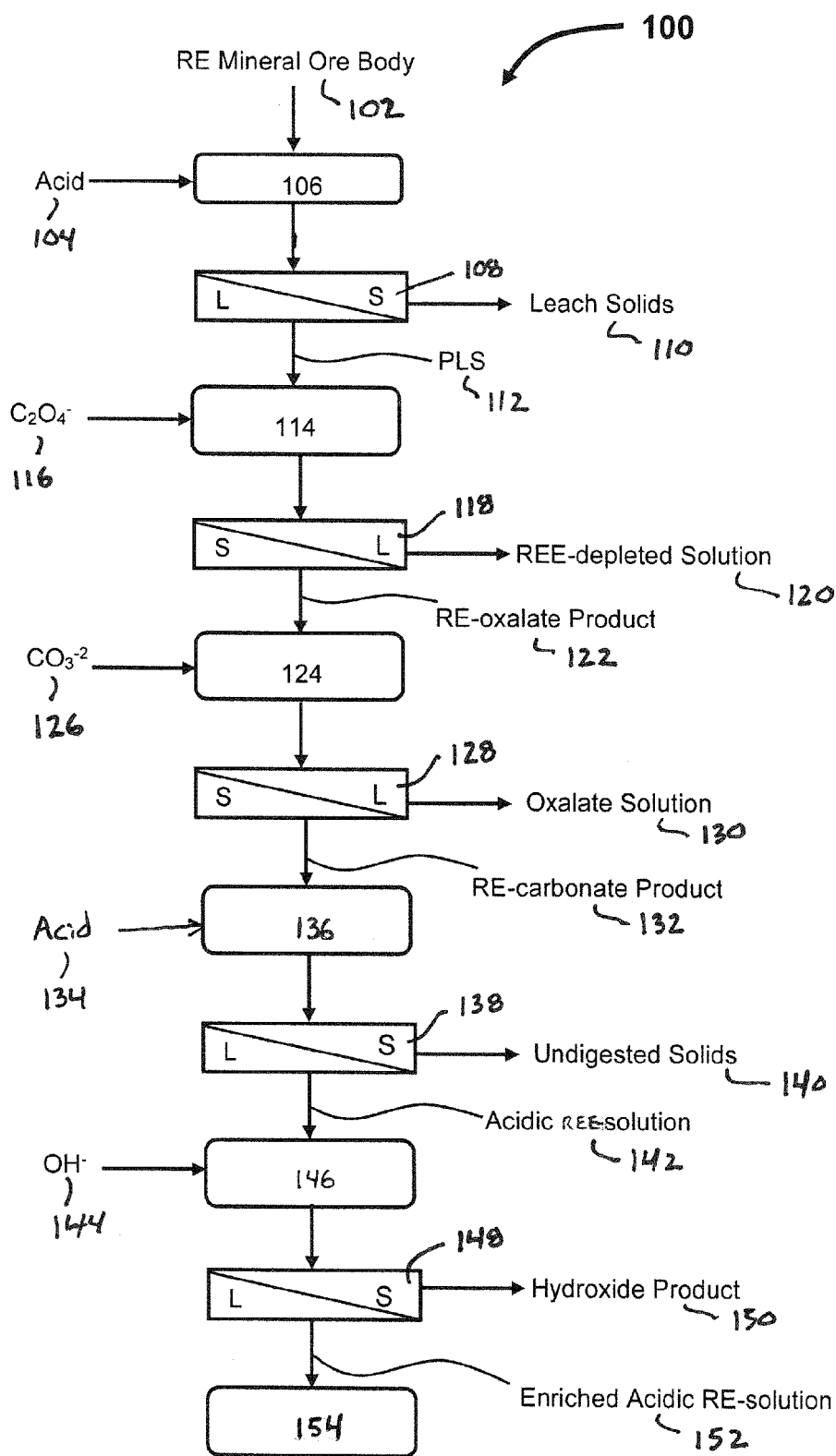
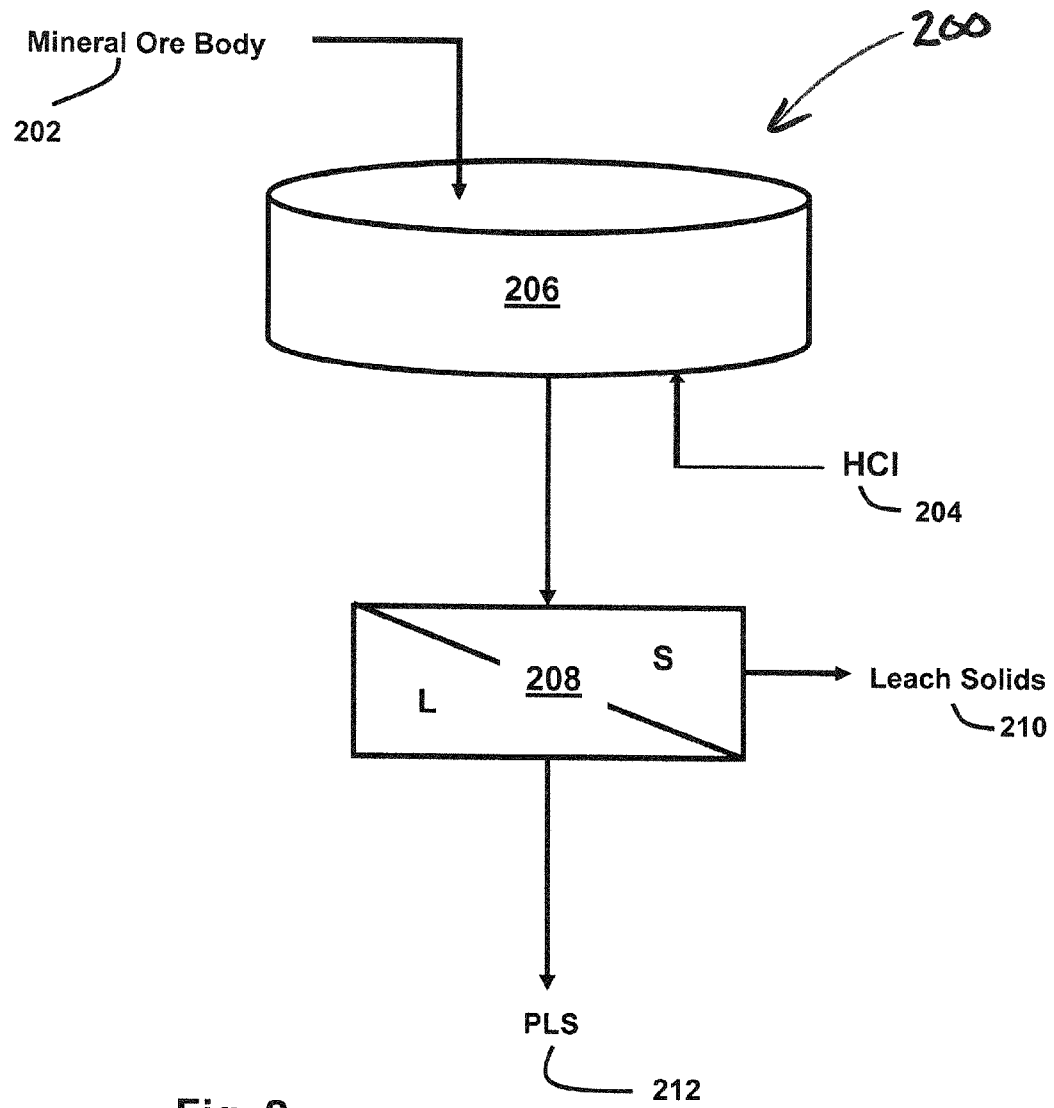


Fig. 1



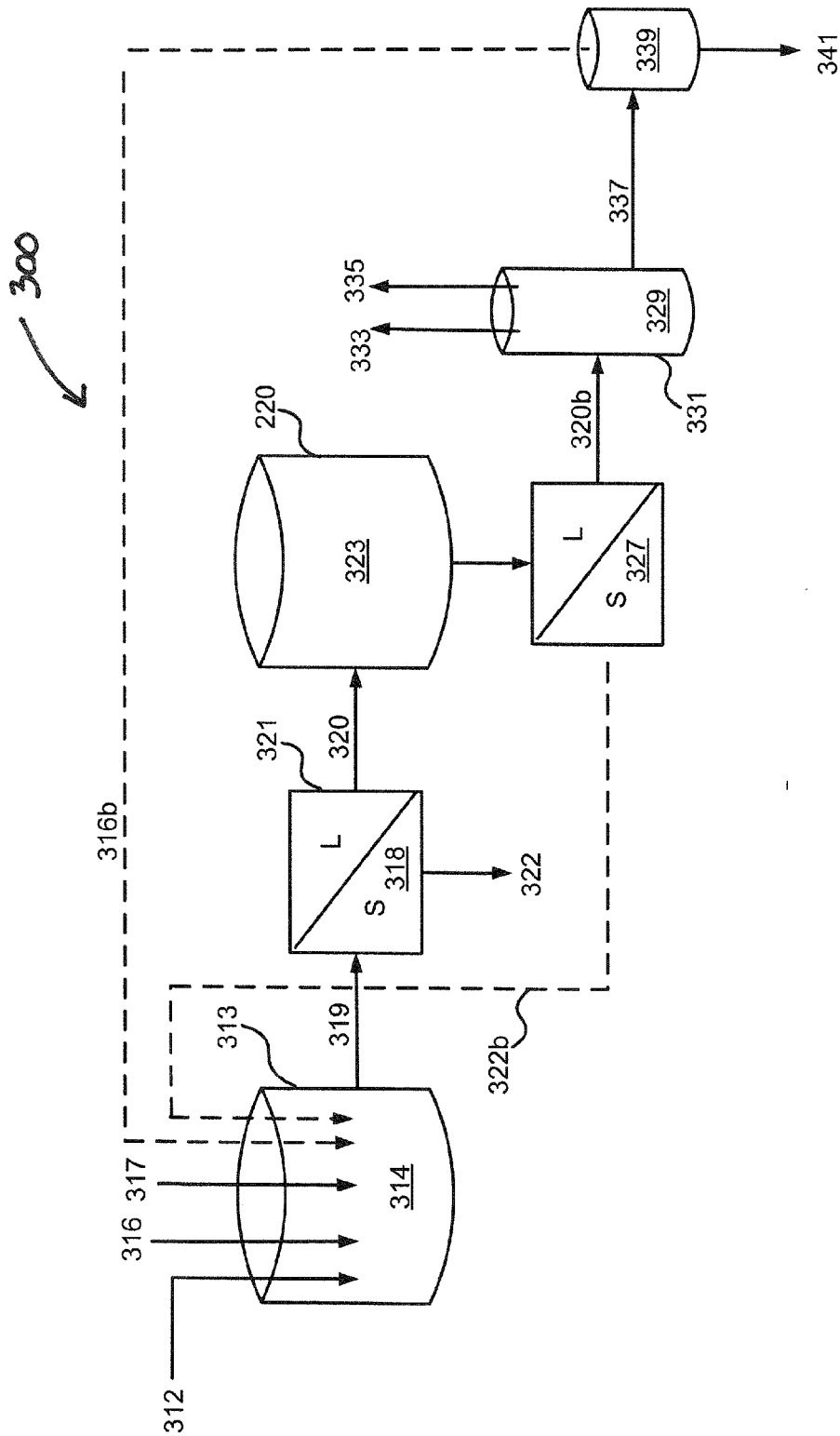
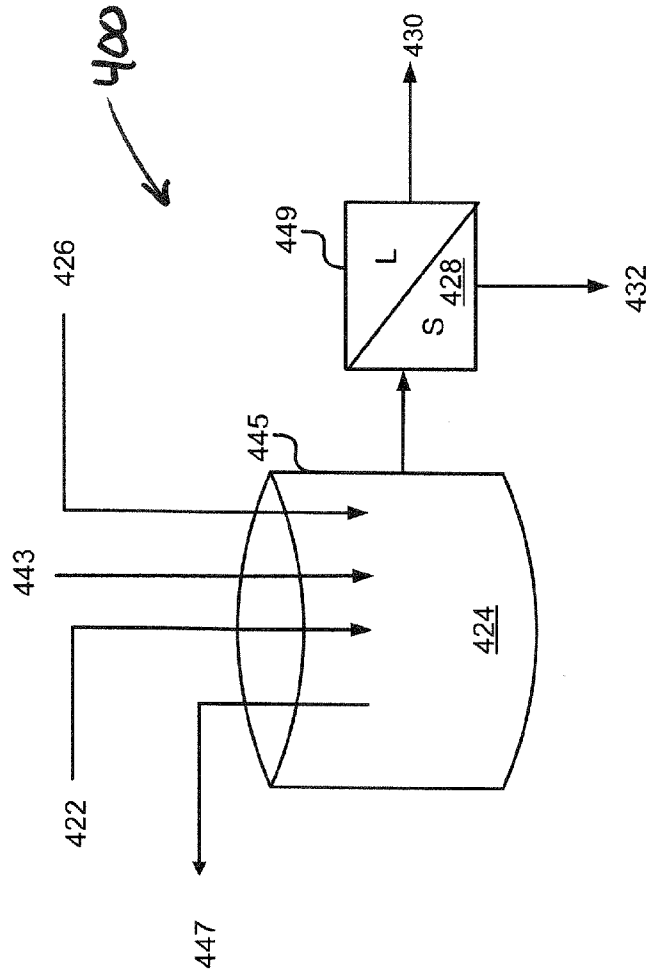
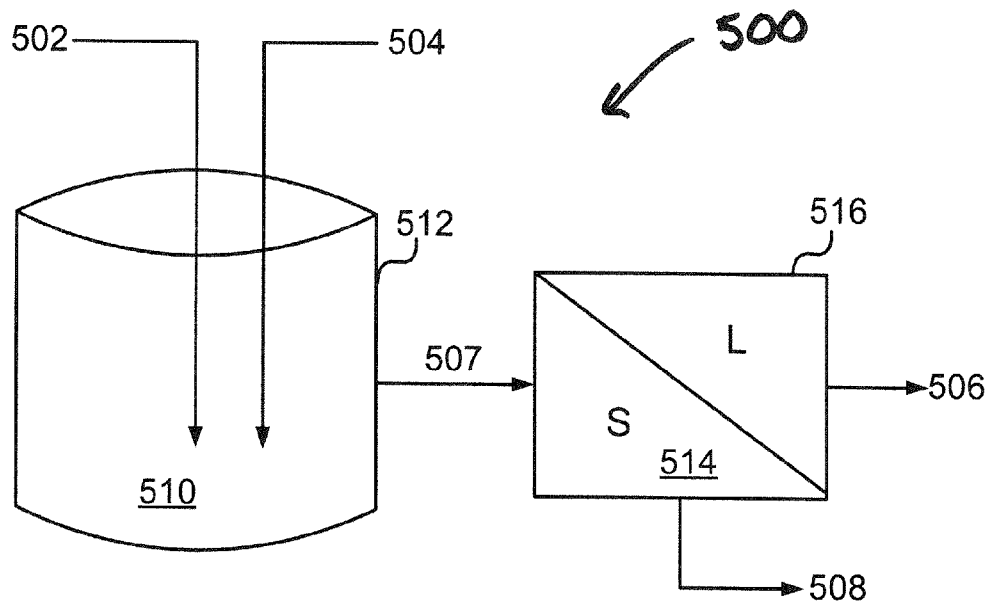


FIG. 3

**FIG. 4**

**FIG. 5**

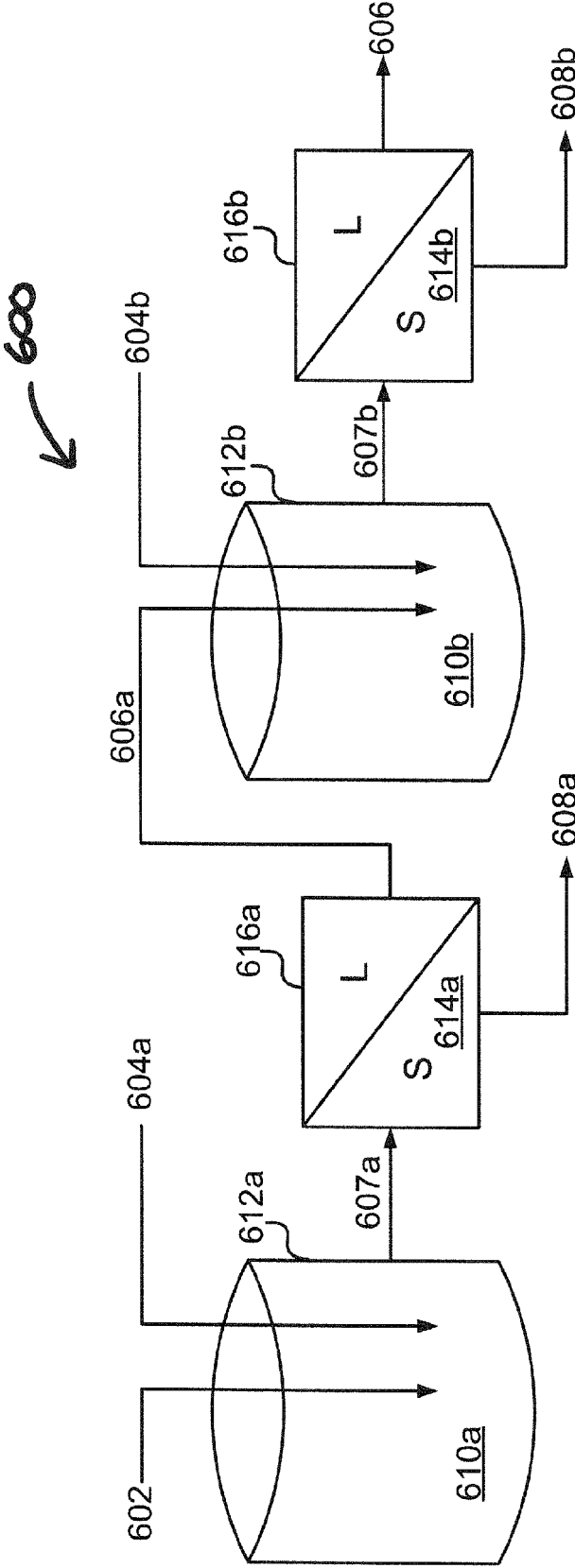


FIG. 6

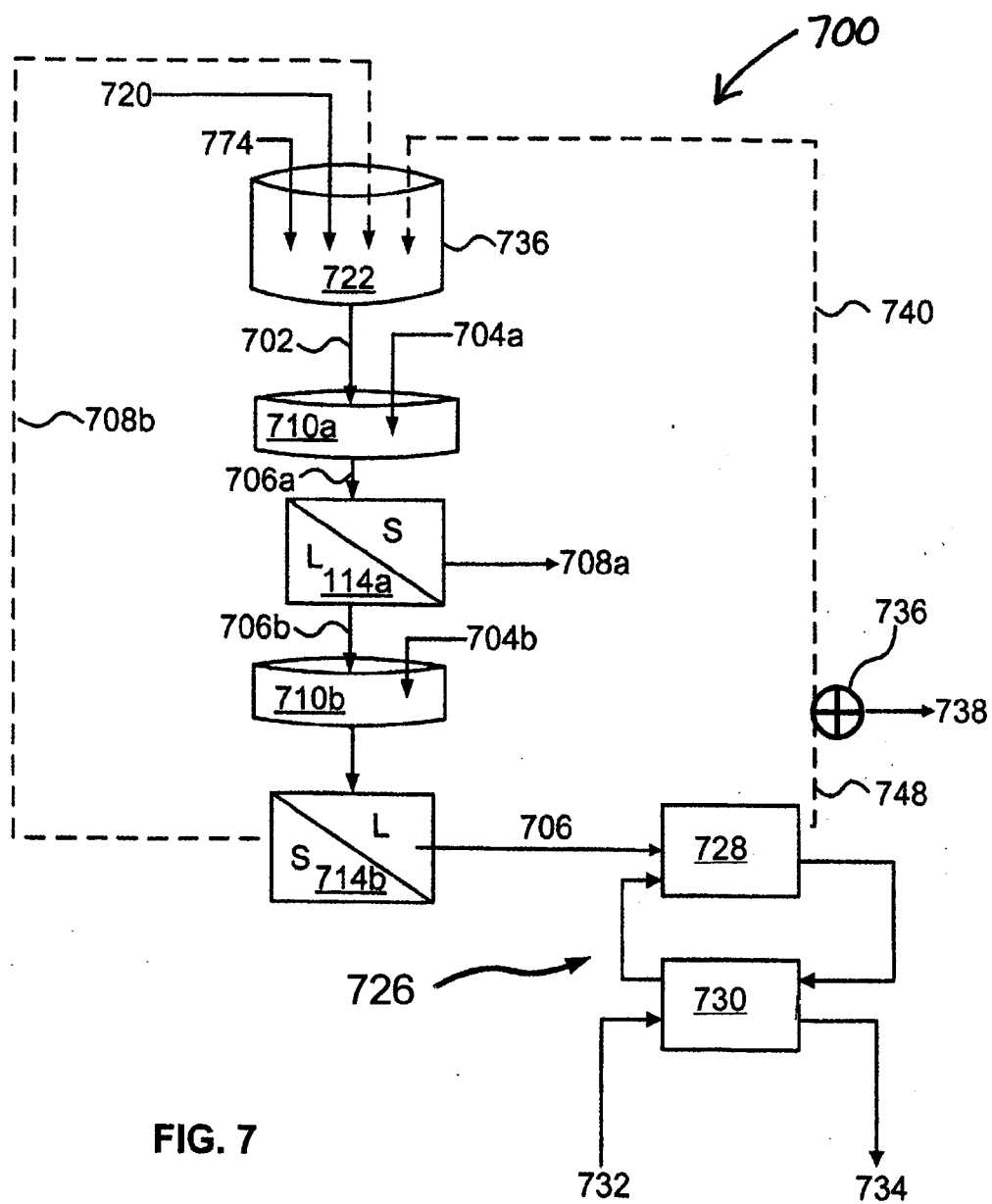
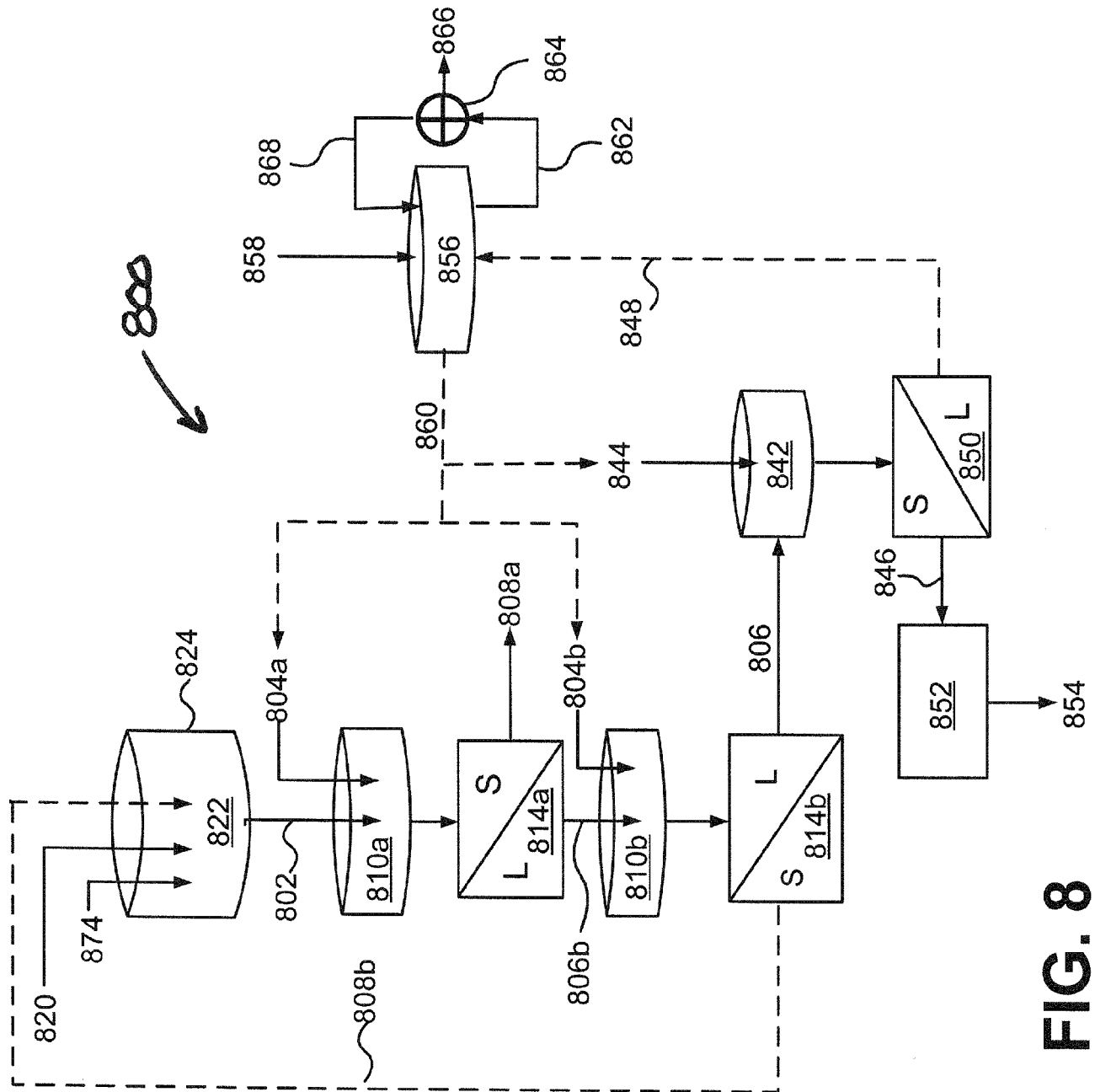


FIG. 7

**FIG. 8**

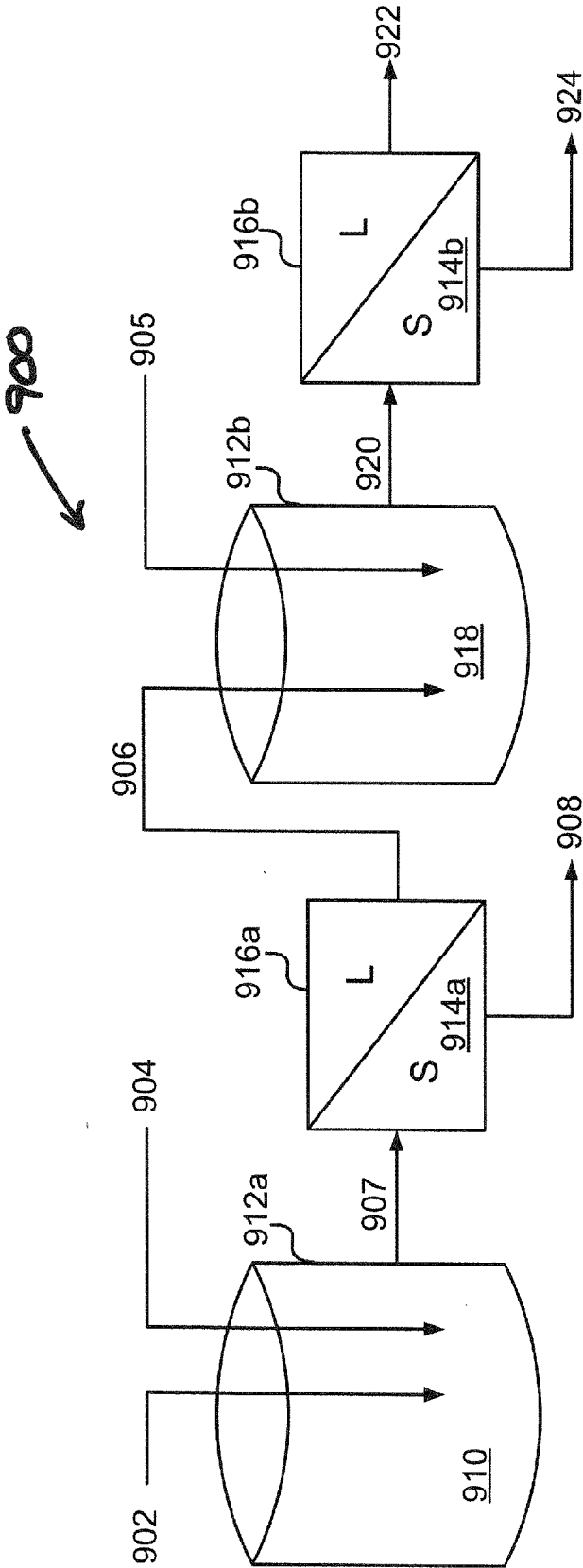


FIG. 9

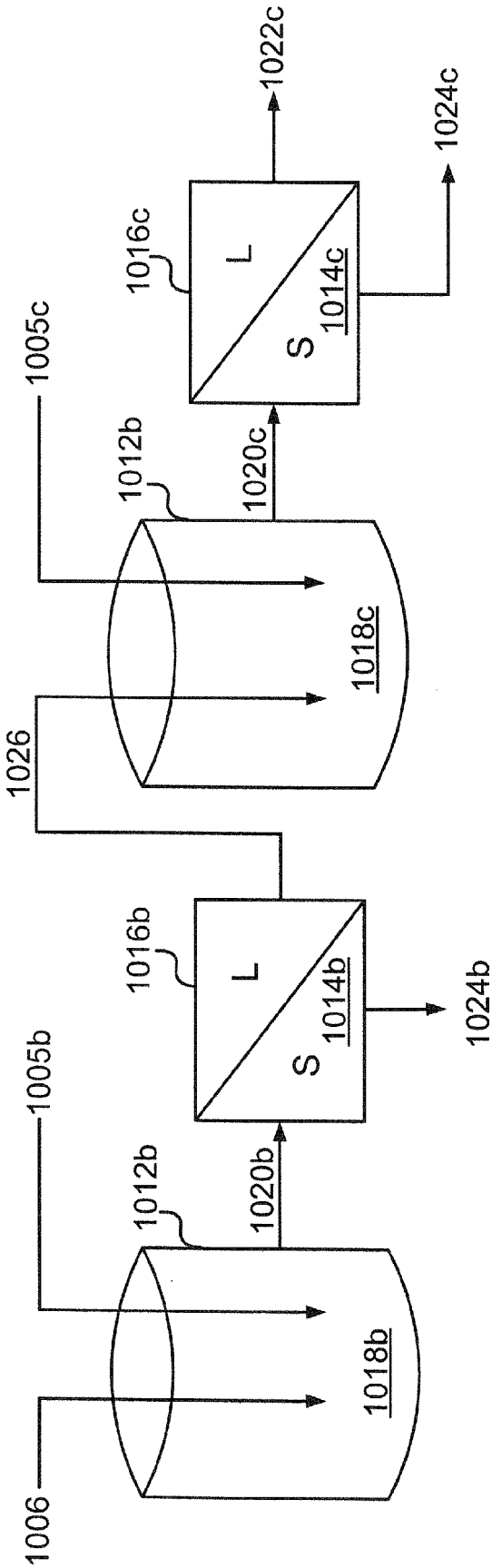
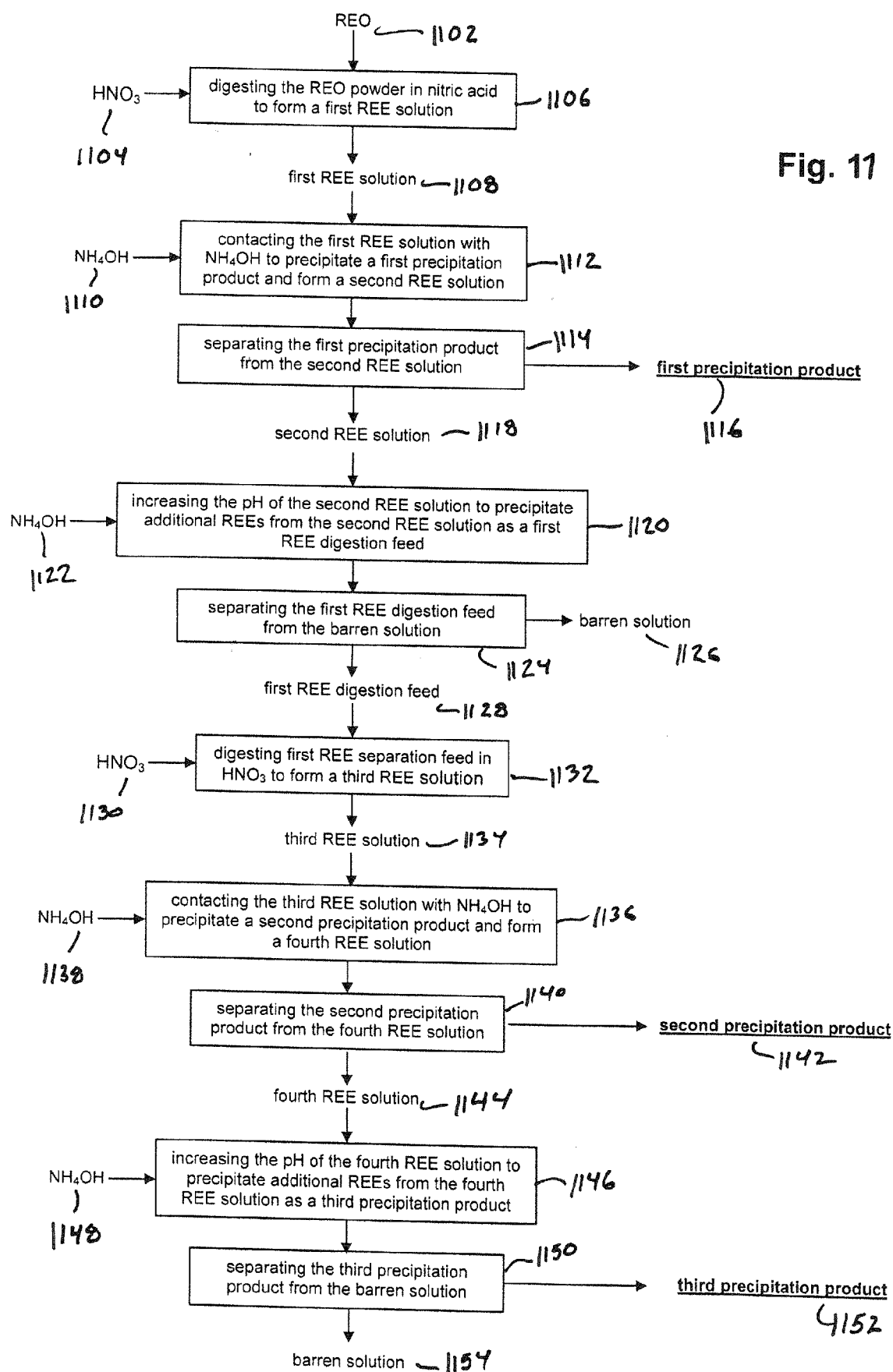


FIG. 10



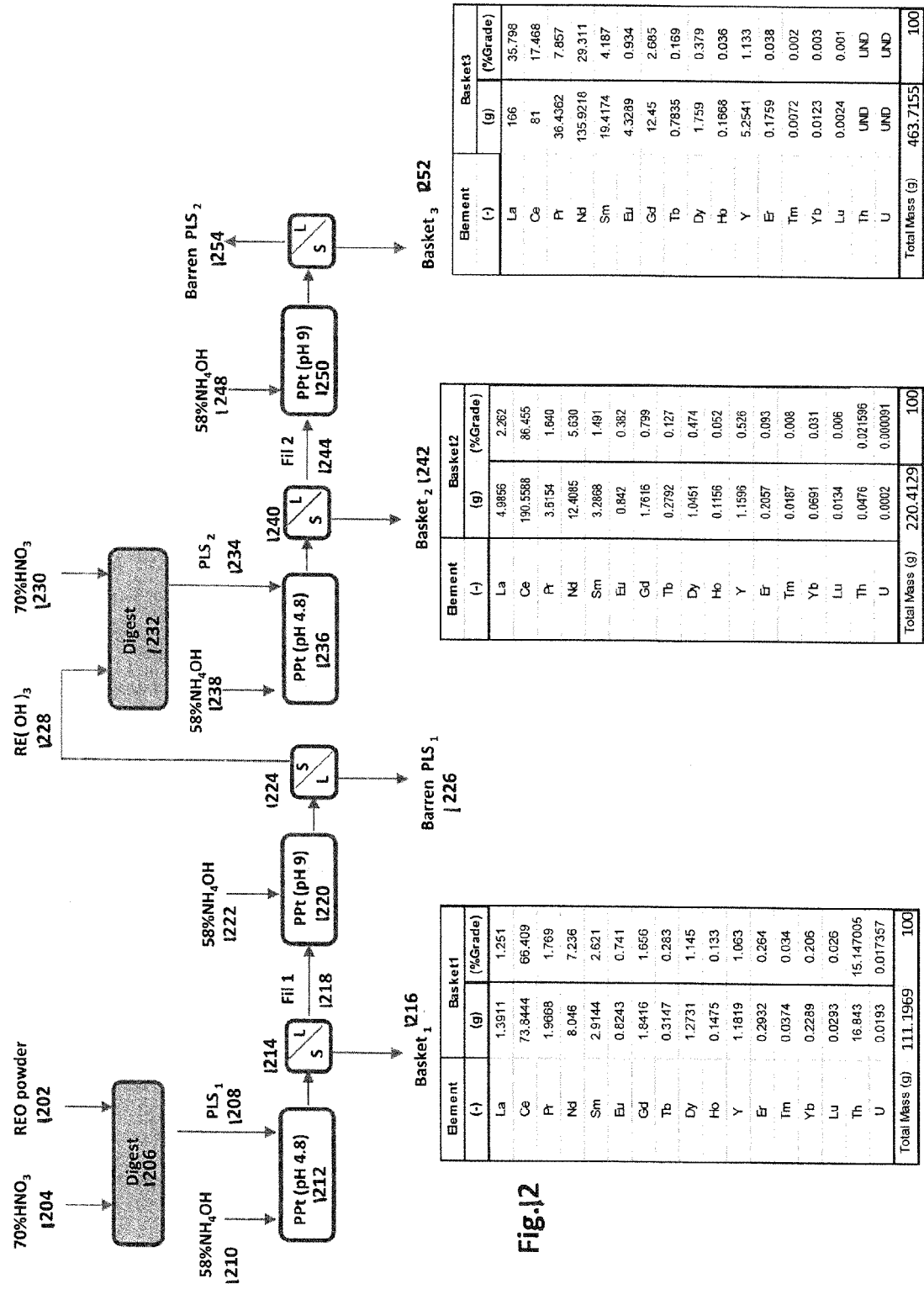


Fig.12

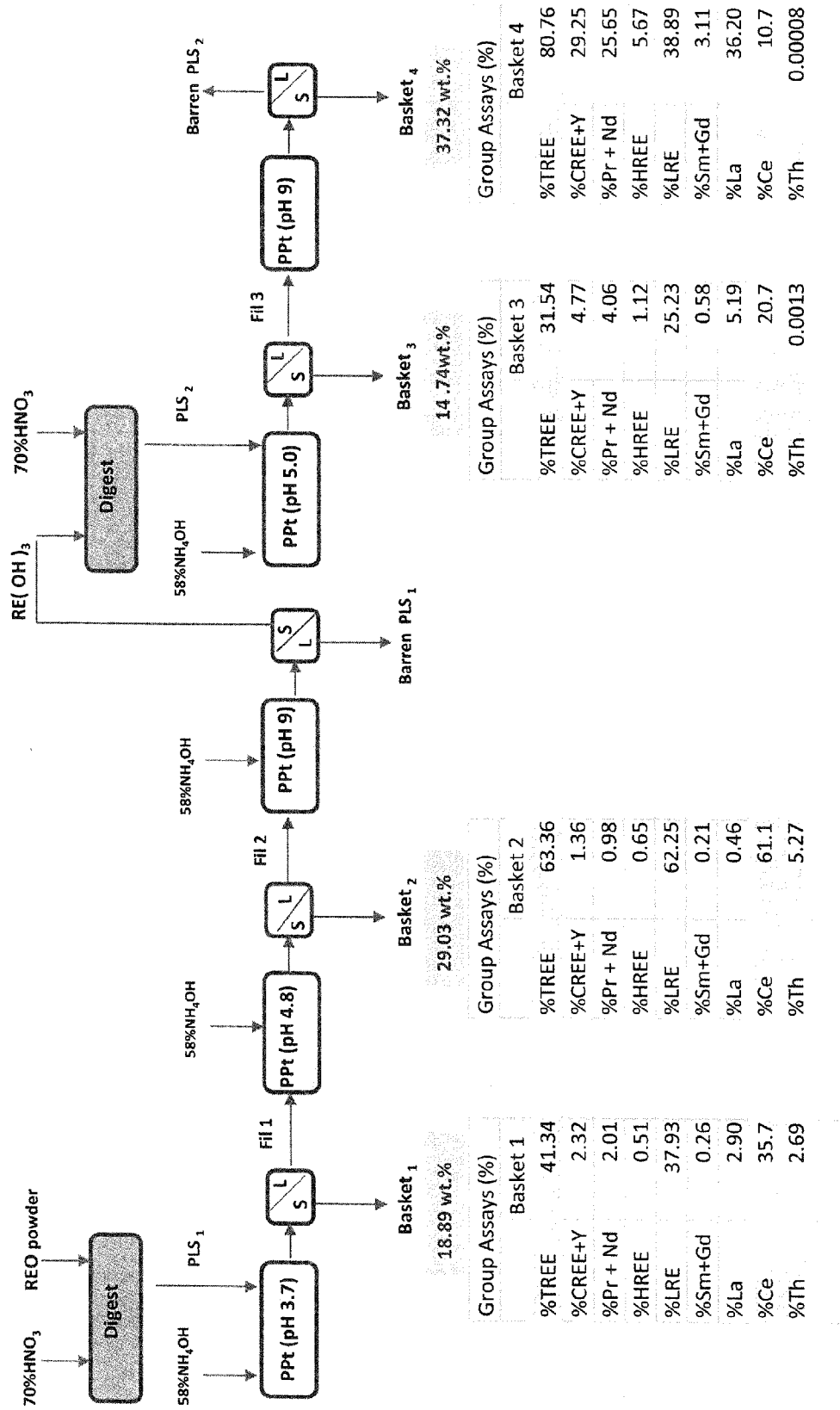


Fig.13

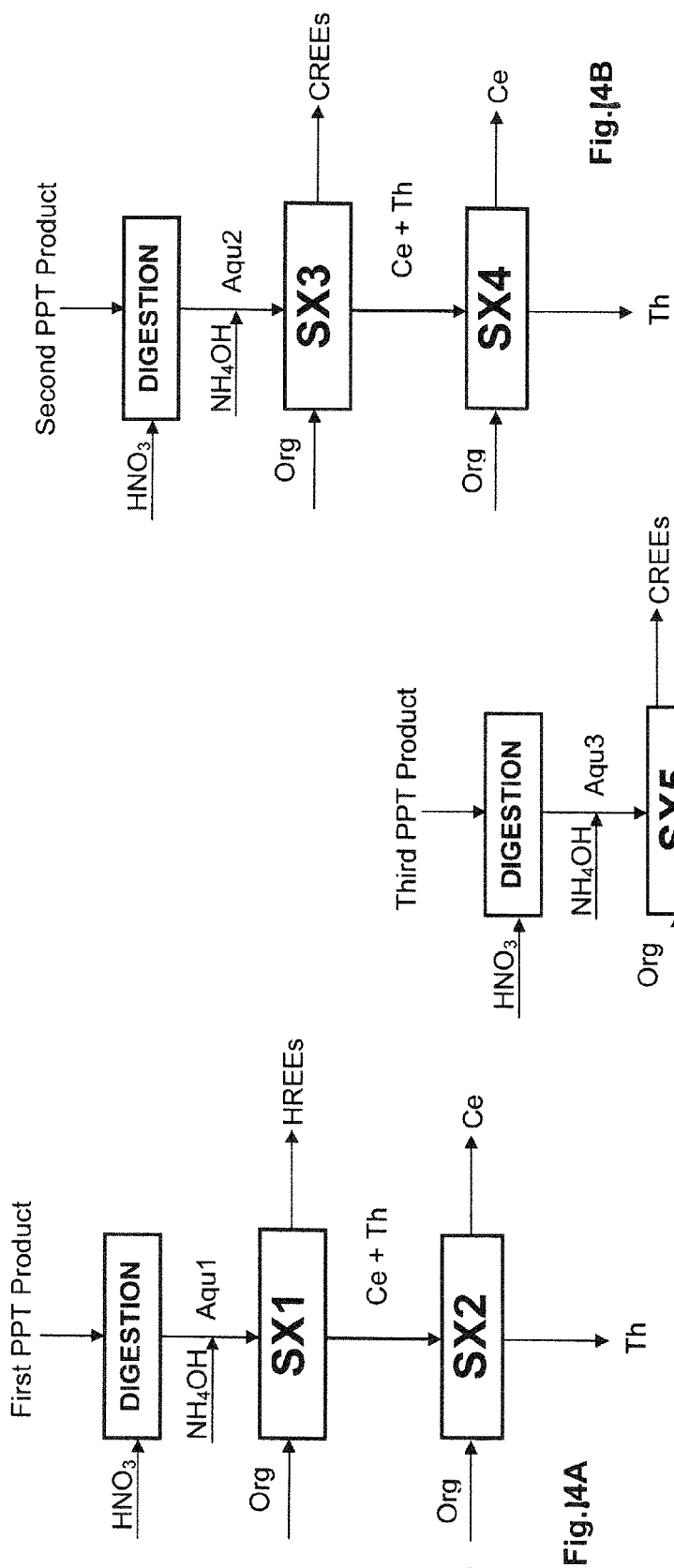


Fig.14B

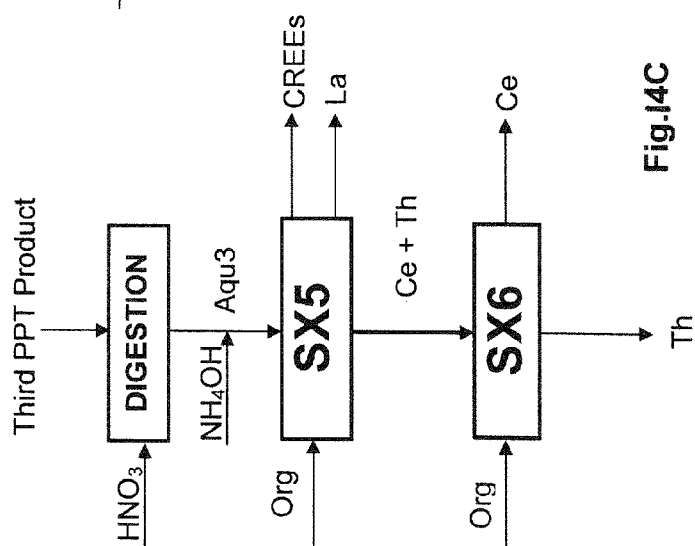
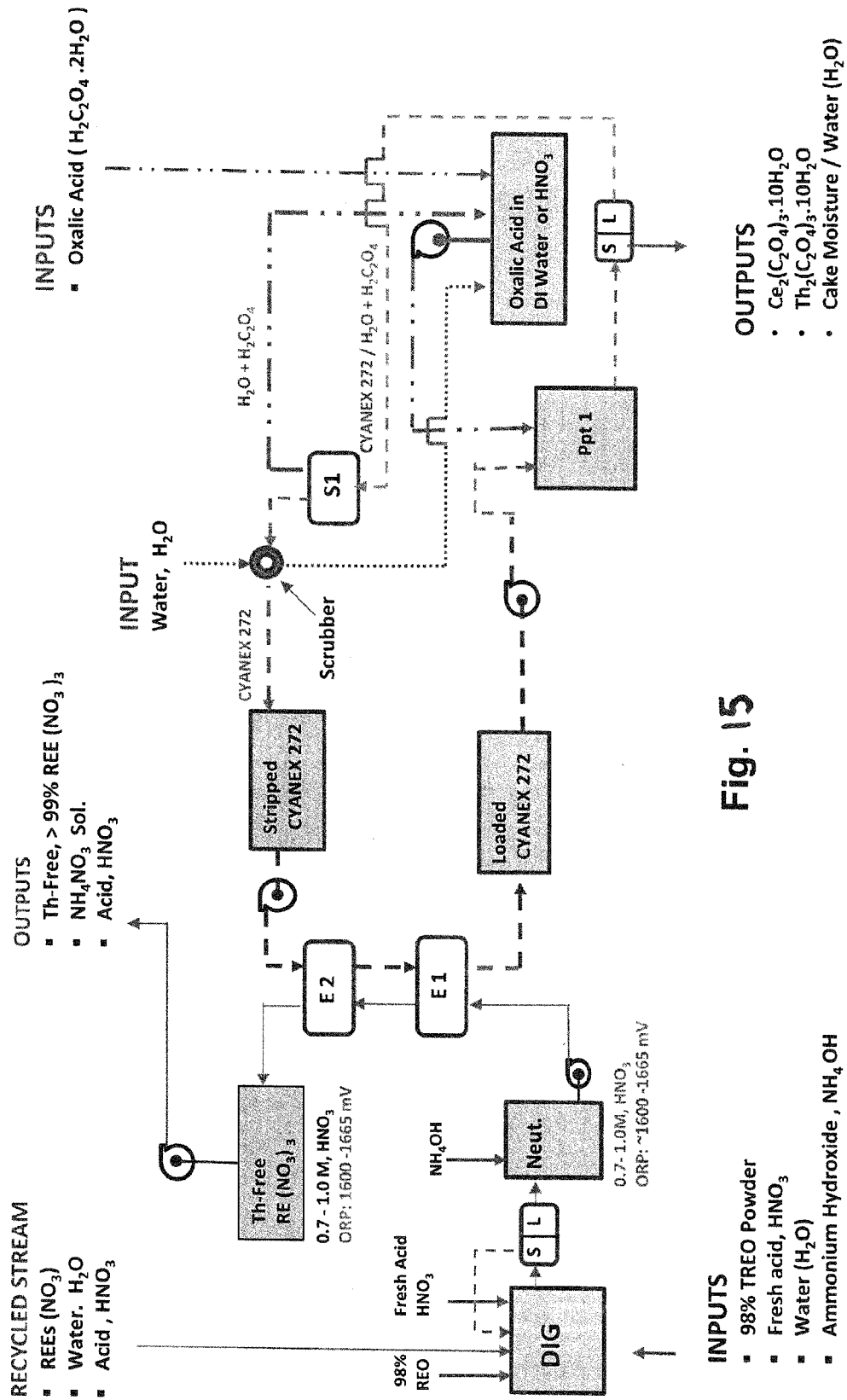
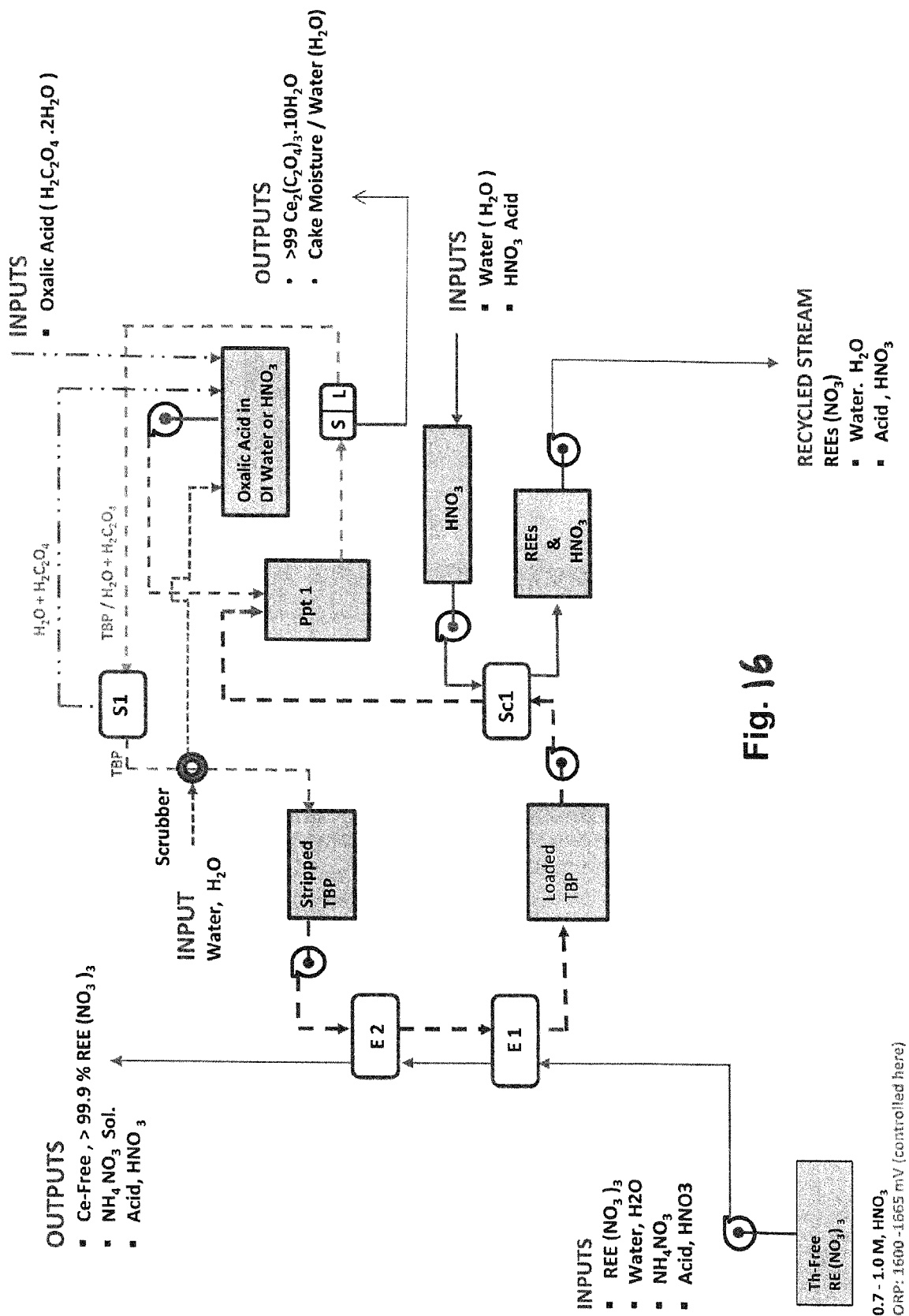


Fig.14C





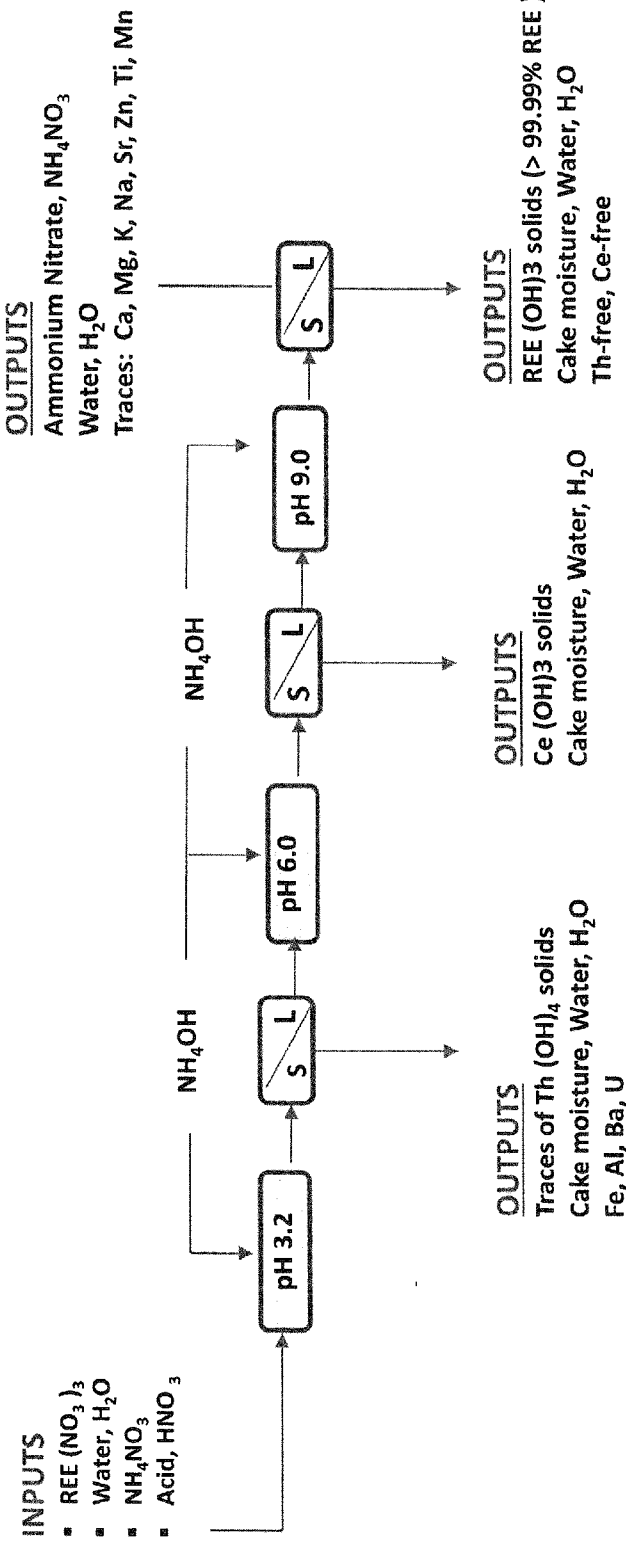


Fig. 17

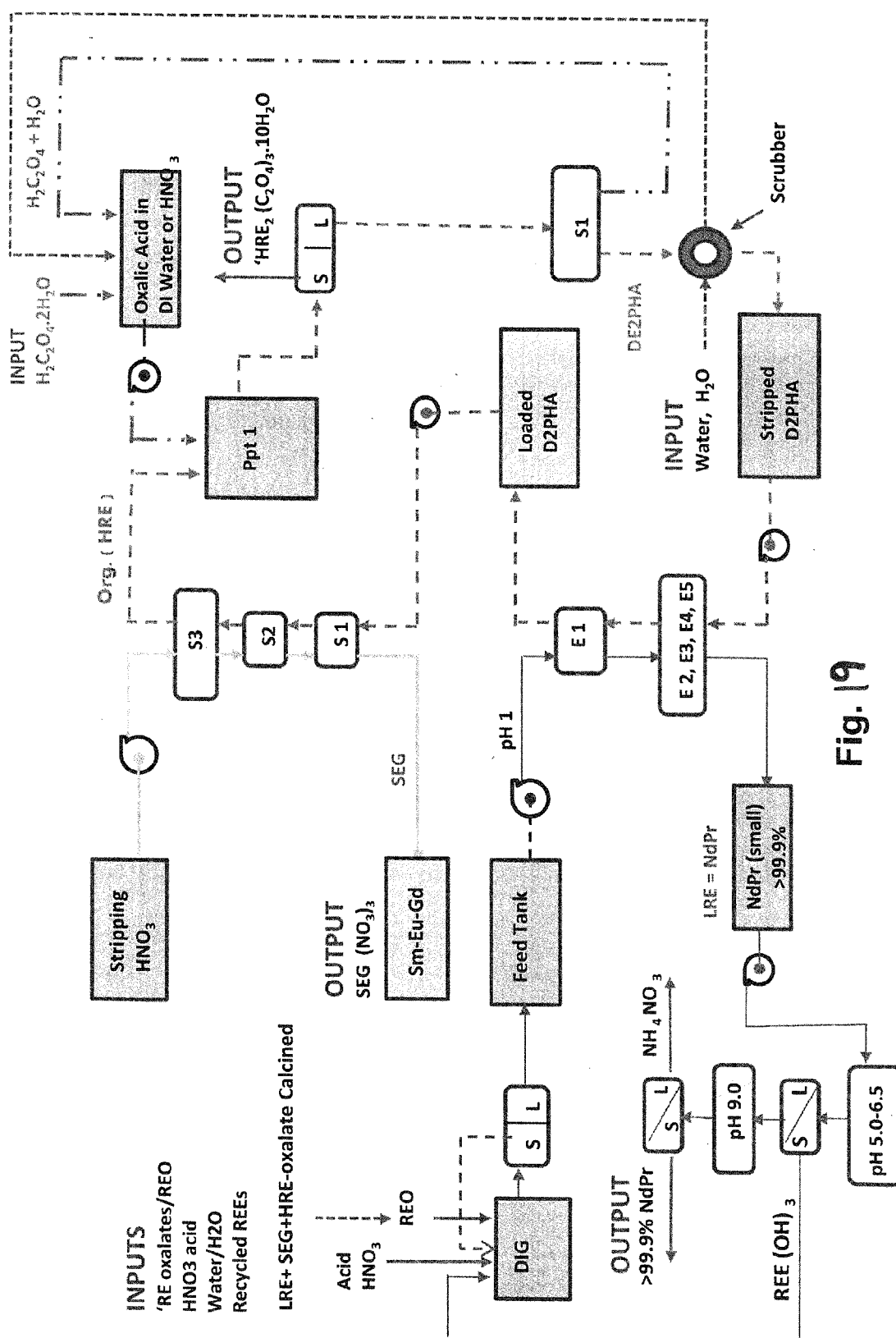


Fig. 19

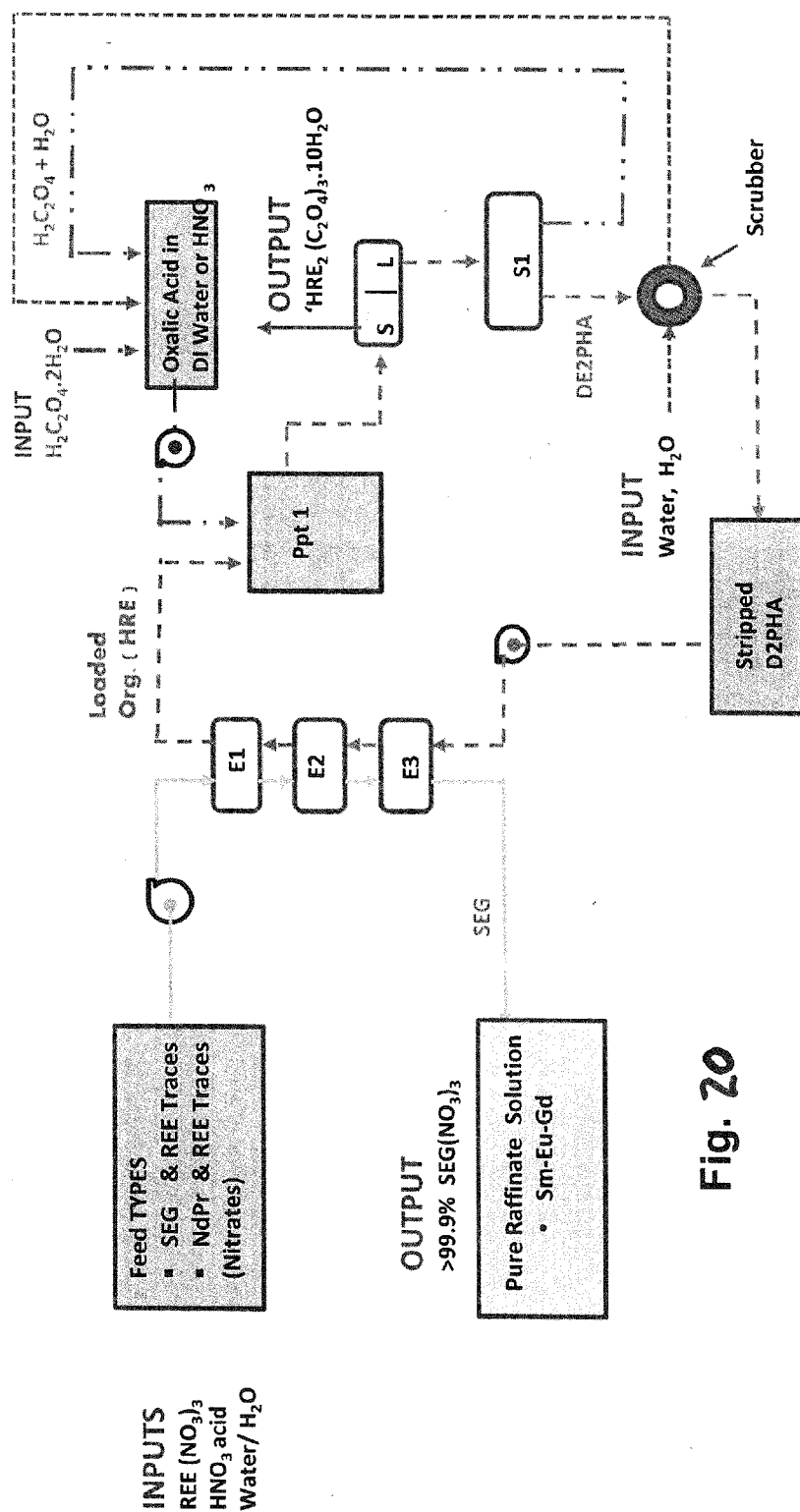


Fig. 20

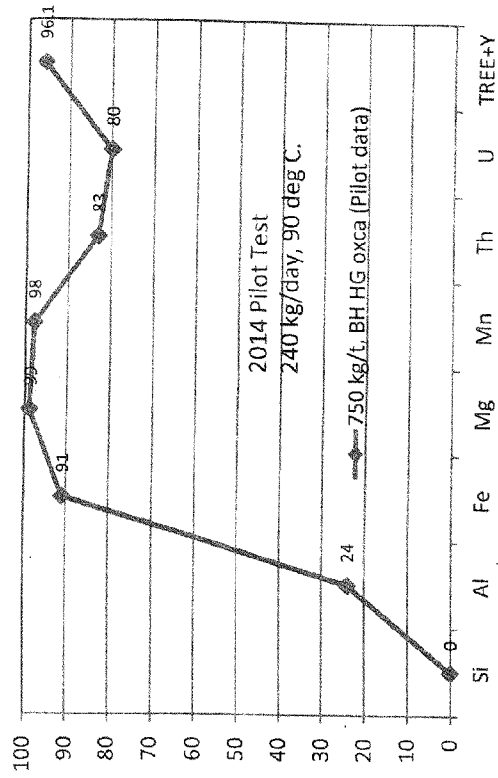


Fig. 22

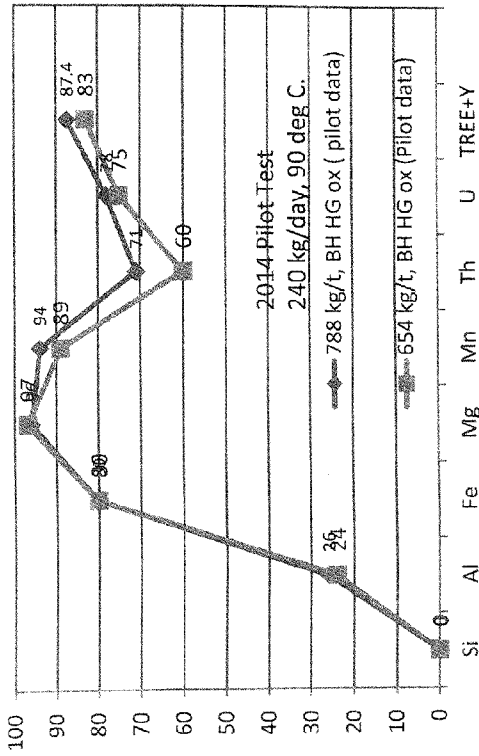


Fig. 21

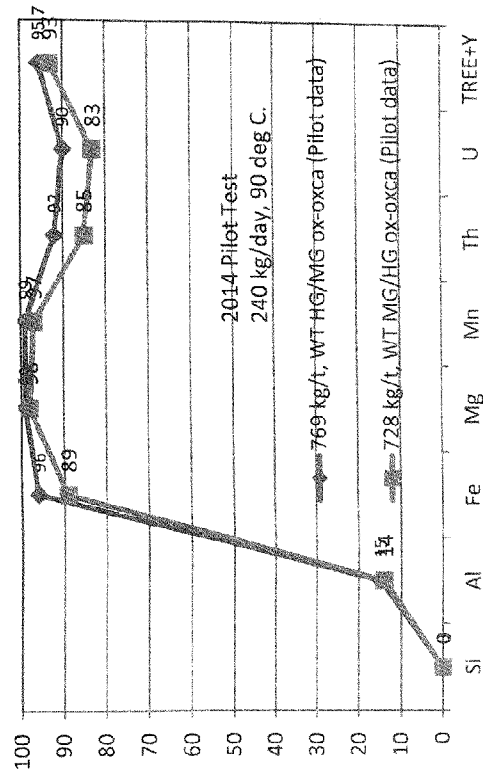


Fig. 23

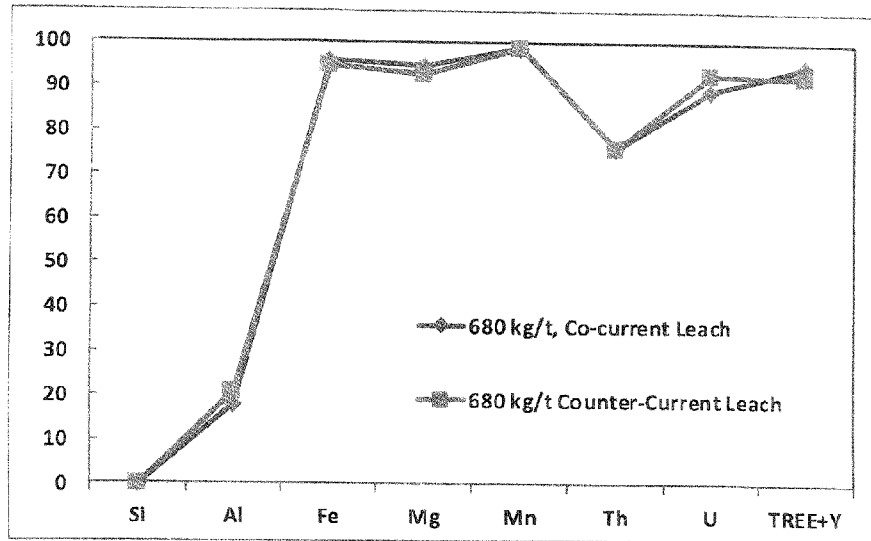


Fig. 24

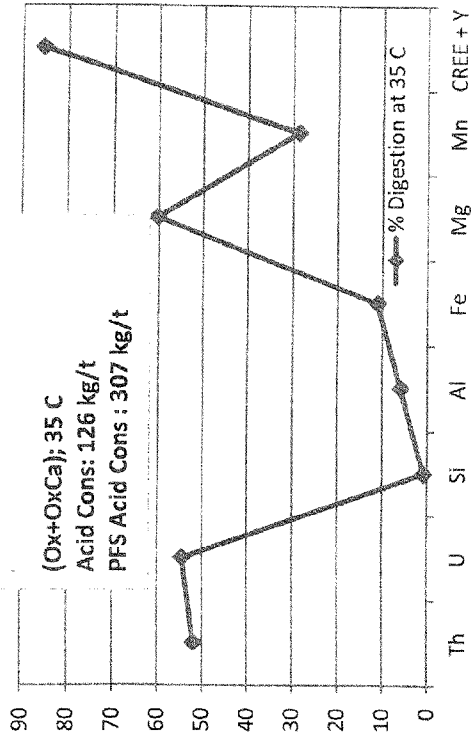


Fig. 26

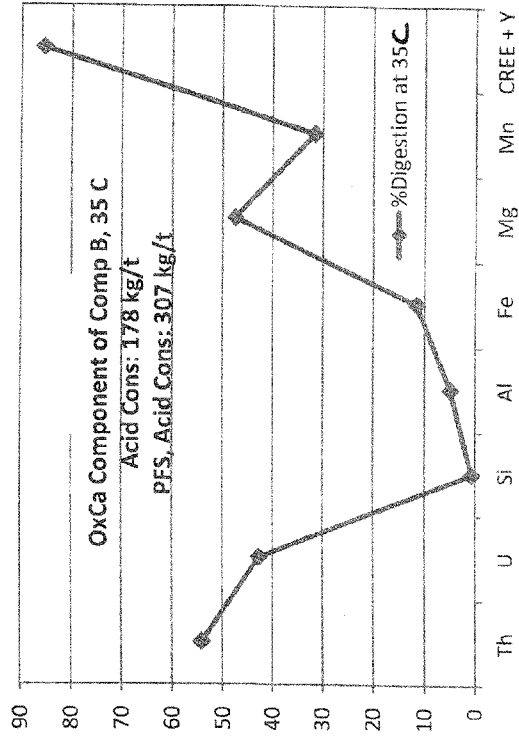


Fig. 28

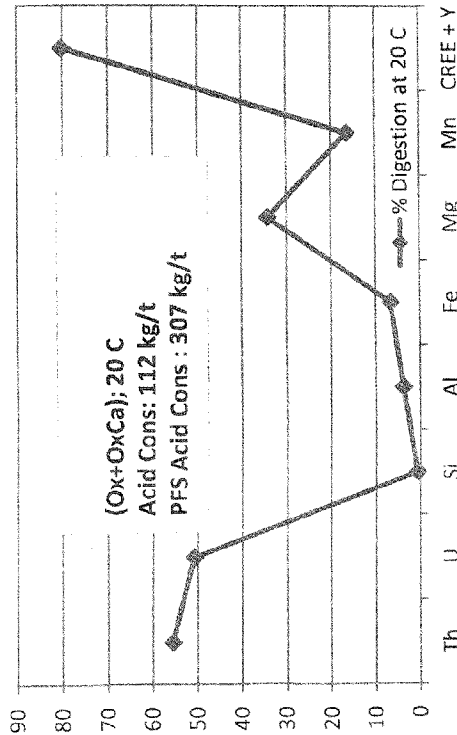


Fig. 25

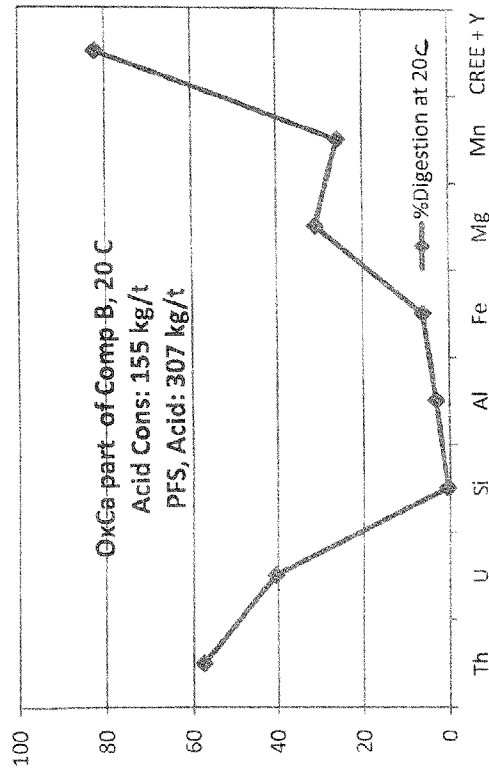


Fig. 27

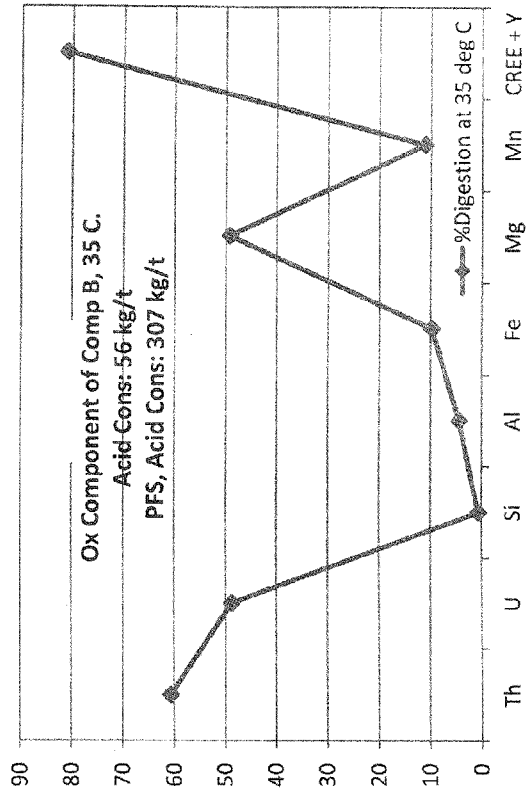


Fig. 30

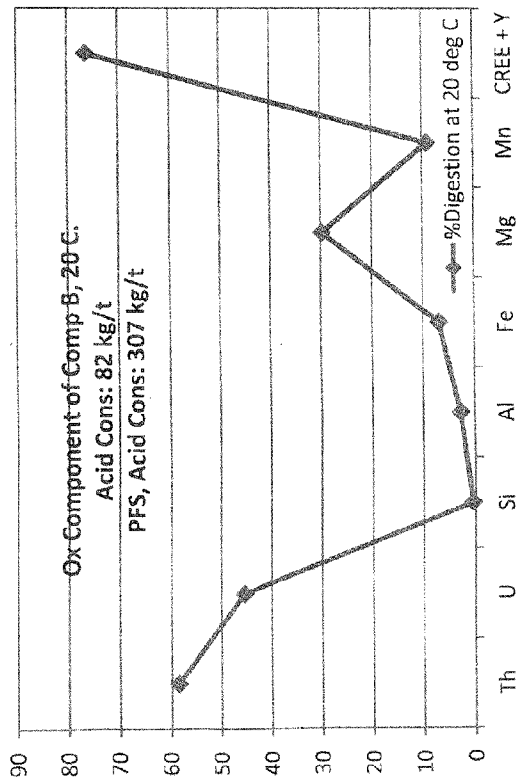


Fig. 29



FIG. 31

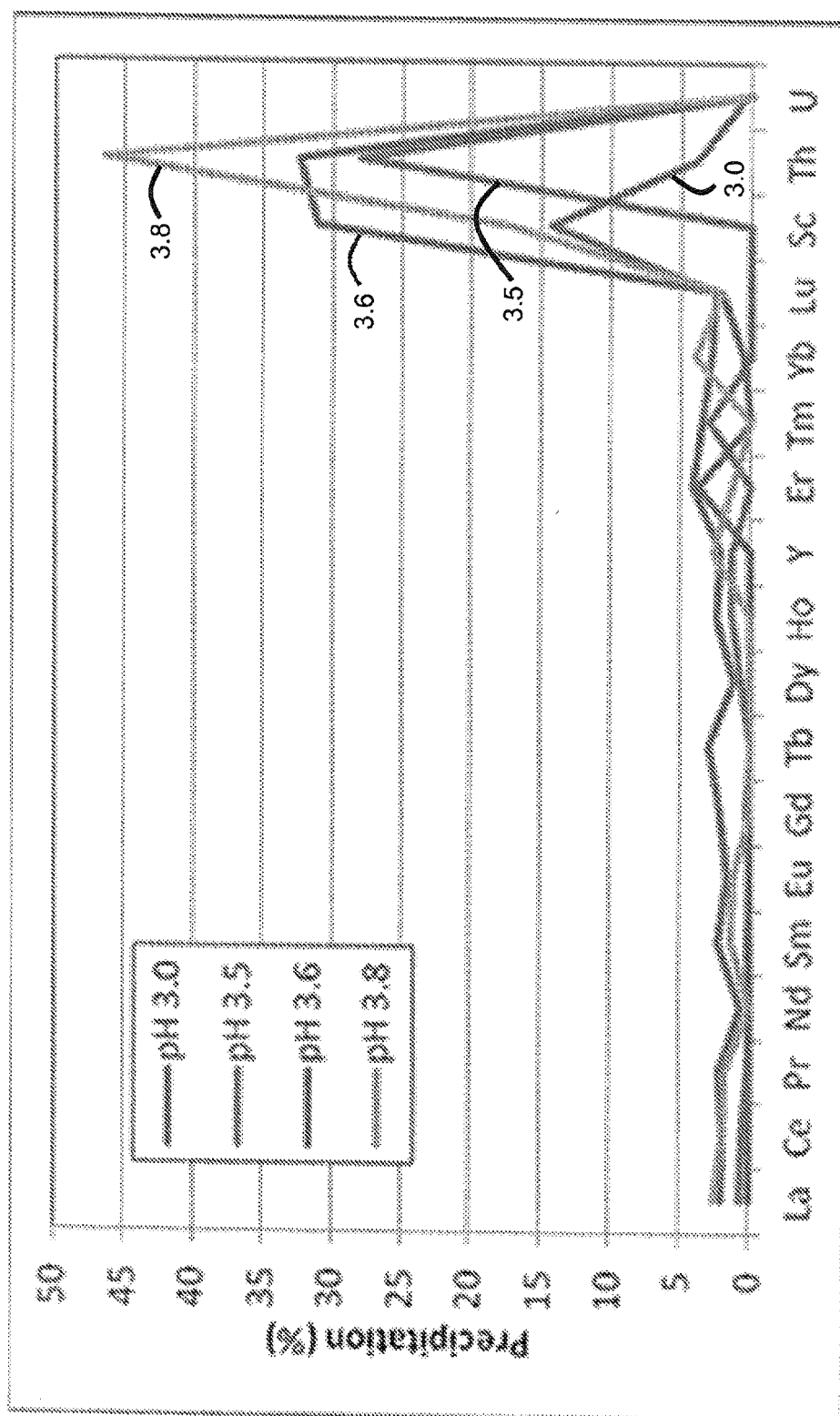
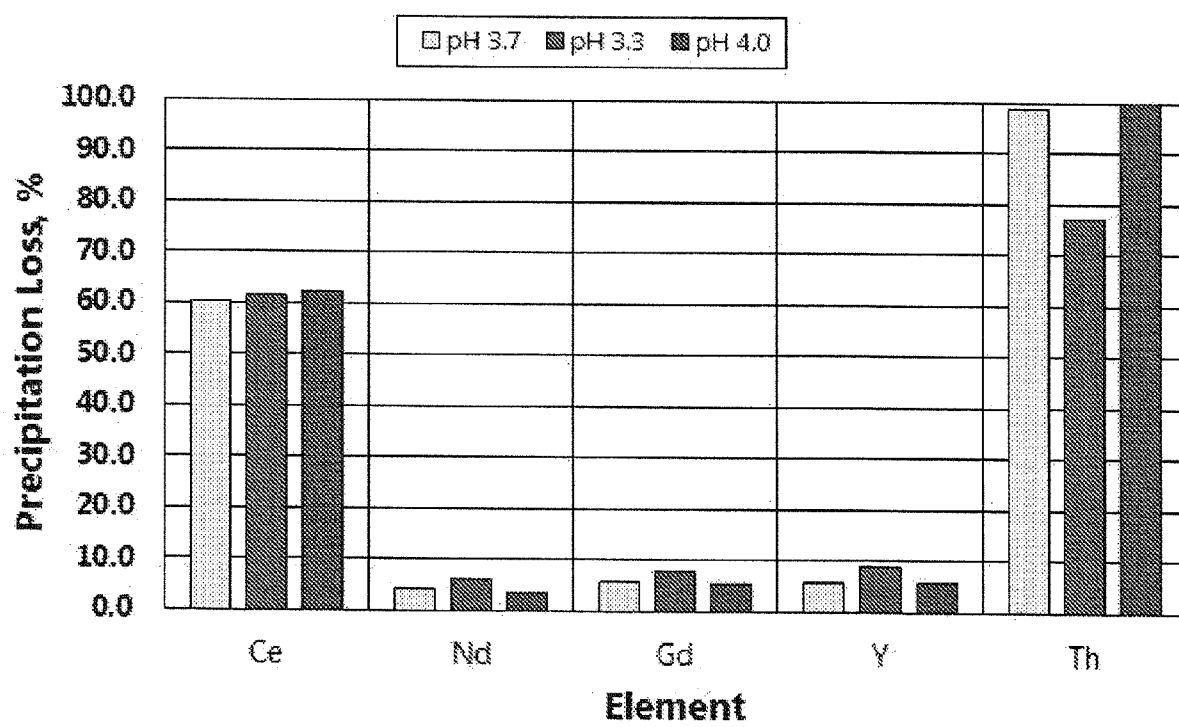


FIG. 32

**FIG. 33**

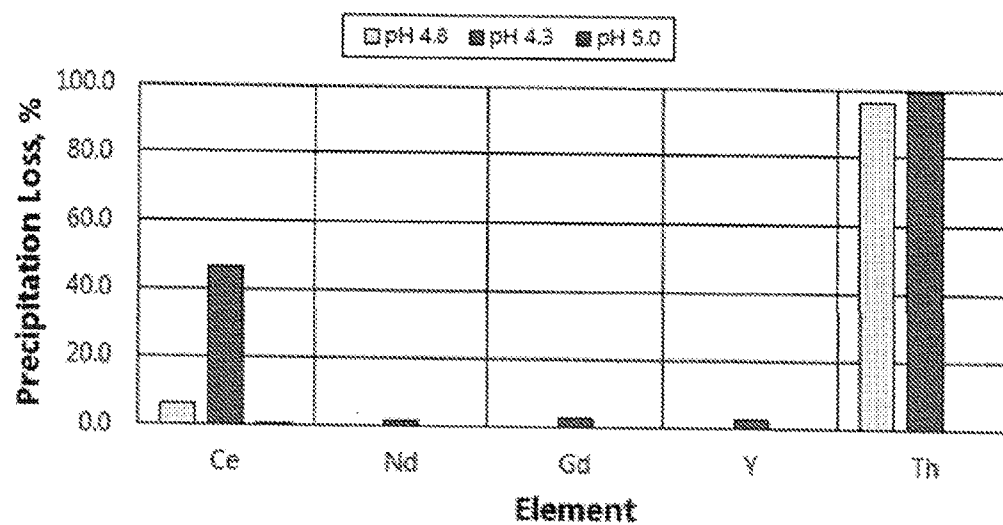


FIG. 34

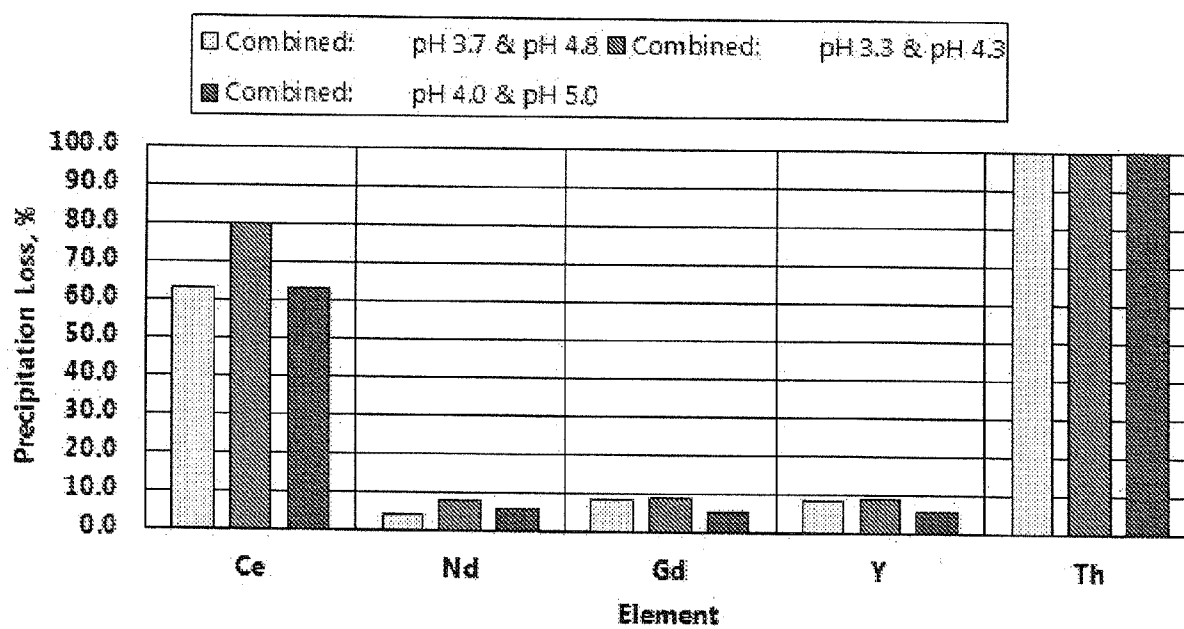


FIG. 35

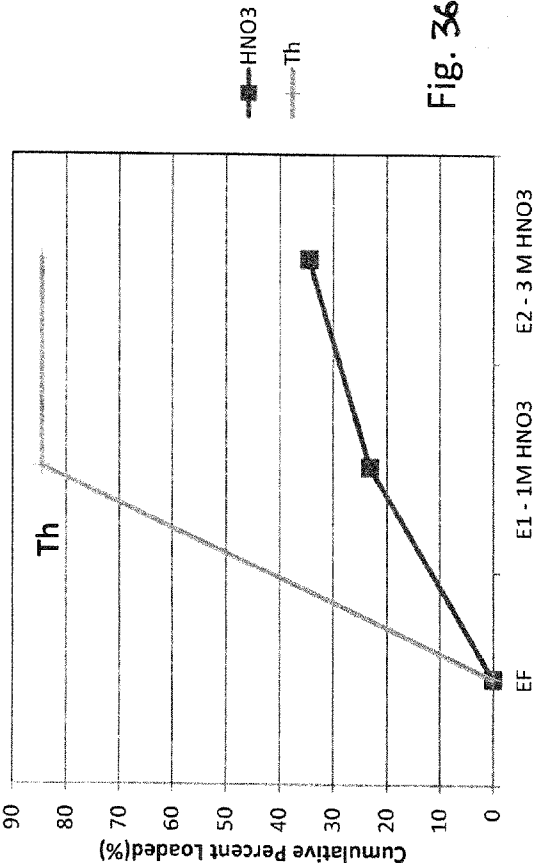


Fig. 36B

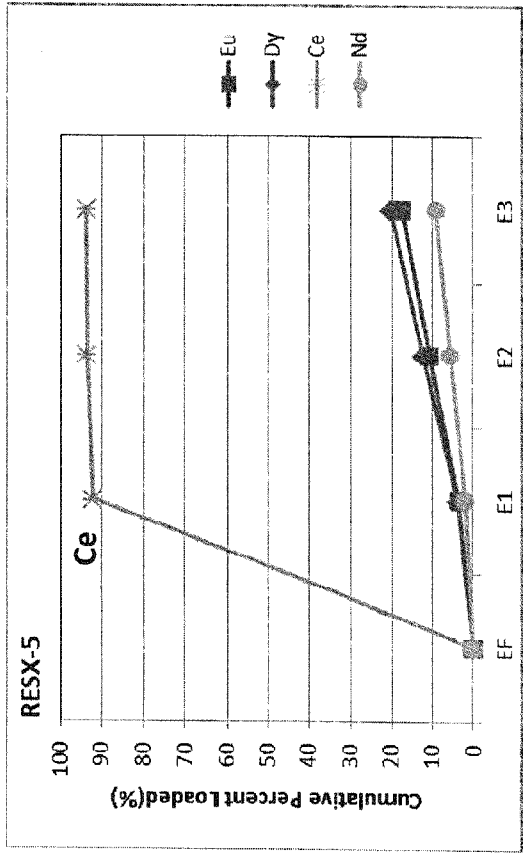


Fig. 36A

Element	Basket2 (-)	Extracted (g)	Unextracted (Org), (g)	Unextracted (Aque), (g)
La	4.98555	0.1756	4.8099	
Ce	190.55880	186.7476	3.8112	
Pr	3.61545	0.1989	3.4165	
Nd	12.40848	0.6784	11.7300	
Sm	3.28677	0.3595	2.9273	
Eu	0.84200	0.0987	0.7433	
Gd	1.76156	0.3857	1.3758	
Tb	0.27919	0.0524	0.2268	
Dy	1.04512	0.2321	0.8130	
Ho	0.11559	0.0242	0.0914	
Y	1.15960	0.2994	0.8602	
Er	0.20570	0.0363	0.1694	
Tm	0.01869	0.0030	0.0157	
Yb	0.06906	0.0077	0.0613	
Lu	0.01341	0.0017	0.0117	
Sc				
Th	0.04764	0.0467	0.0010	
U	0.00018	0.0002	0.0000	

Initial
Ce = 86.45%
Th = 0.021%
(220.41g)

Final
Ce = 98.62%
Th = 0.024%
(189.34g)

Final
CREE = 57.27%
Non-CREE = 42.72%
Th = 0.0000%
(31.06g)

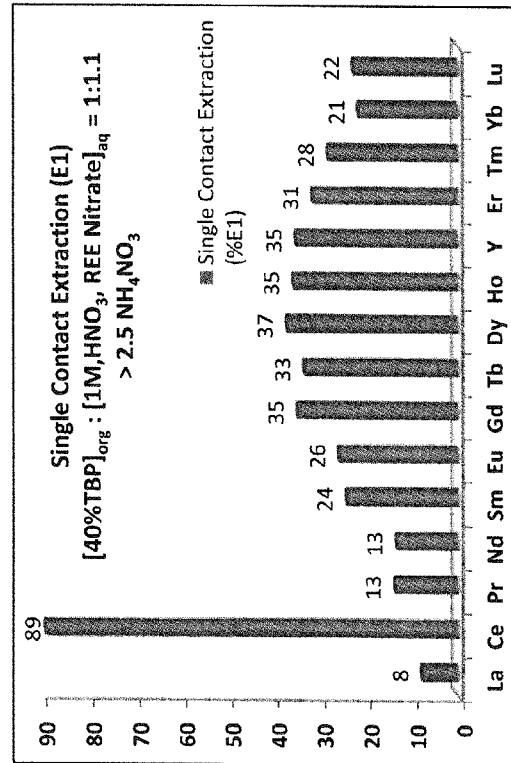
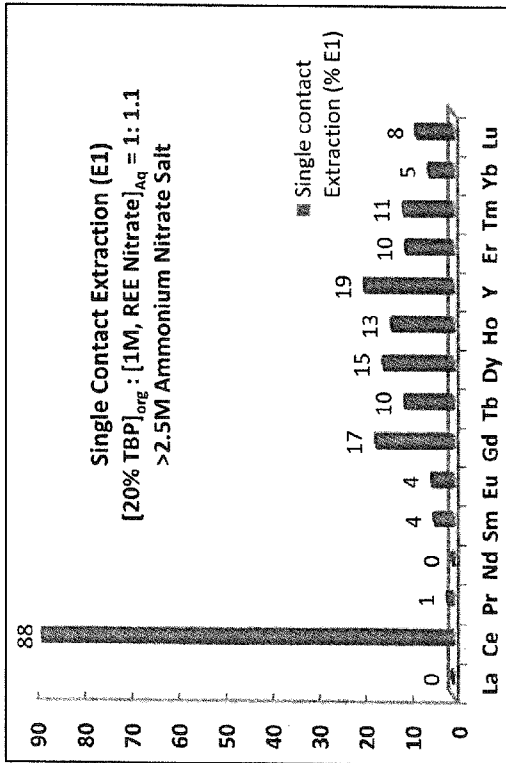
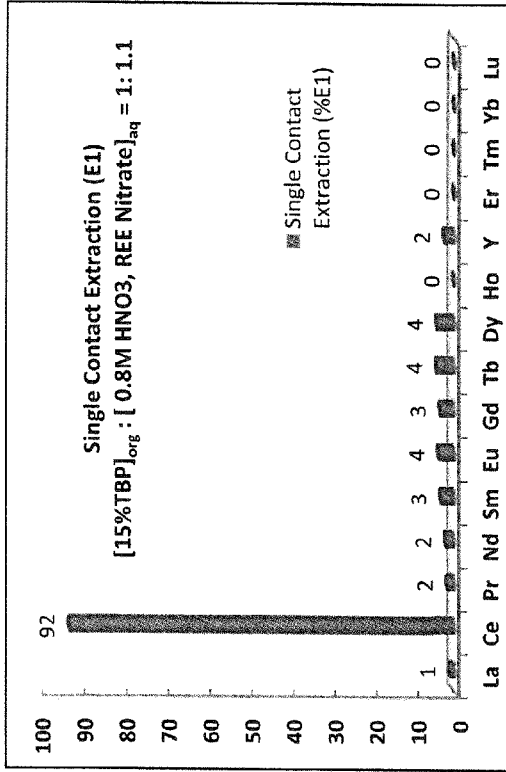


Fig. 37

Percent Loaded (Cumulative)			
	EF	E1	E2
HNO3	0		
La	0	1.96	3.23
Ce	0	4.14	8.05
Pr	0	9.09	13.03
Nd	0	6.98	17.43
Sm	0	25.90	57.26
Eu	0	43.25	79.60
Gd	0	59.53	90.90
Tb	0	87.65	97.30
Dy	0	96.23	99.26
Ho	0	97.97	99.29
Y	0	99.64	99.98
Er	0	97.12	97.87
Tm	0	95.32	97.03
Yb	0	99.26	99.26

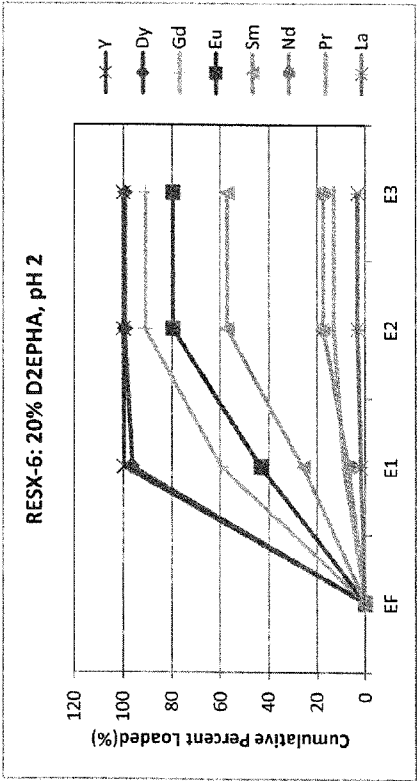


Fig. 38

