

(51) International Patent Classification:
G01N 15/14 (2006.01)

(21) International Application Number:

PCT/US2017/041613

(22) International Filing Date:

12 July 2017 (12.07.2017)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

62/361,273	12 July 2016 (12.07.2016)	US
15/642,533	06 July 2017 (06.07.2017)	US

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(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DJ, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IR, IS, JO, JP, KE, KG, KH, KN, KP, KR, KW, KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM,

(54) Title: METHODS FOR ANALYZING RESPIRABLE PARTICLES IN BULK MATERIALS

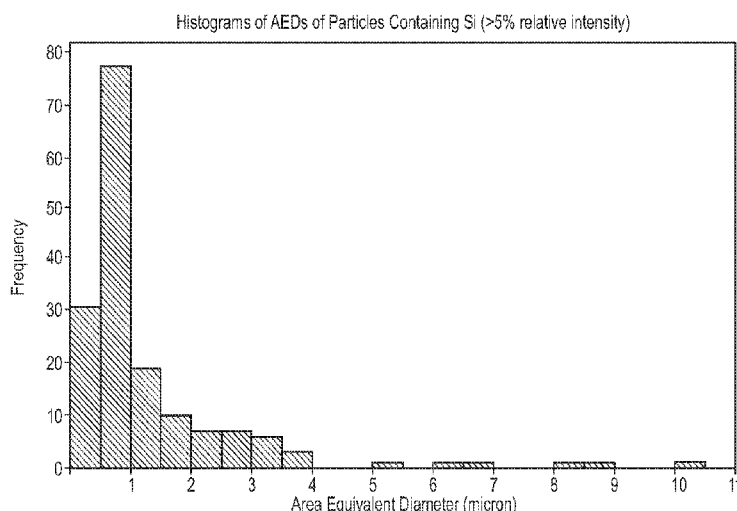


FIG. 21

(57) Abstract: Provided is a method for detecting respirable particulates in a bulk material comprising particles. The method comprises: analyzing morphology of the particles; analyzing chemical composition of the particles; creating a profile of the particles, wherein each particle in the profile is characterized by its shape, size and chemical composition; selecting particles from the profile which match the size and chemical composition of a respirable particle; and calculating a percentage of the respirable particles in the bulk material.



TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW,
KM, ML, MR, NE, SN, TD, TG).

Declarations under Rule 4.17:

- *as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii))*
- *as to the applicant's entitlement to claim the priority of the earlier application (Rule 4.17(iii))*

Published:

- *with international search report (Art. 21(3))*

METHODS FOR ANALYZING RESPIRABLE PARTICLES IN BULK MATERIALS

Technical Field

This invention provides methods for accurate and rapid detection of respirable particles in bulk materials.

Background

5 Many compounds used by the building construction industry are bulk materials, including, but not limited to, gypsum, calcined gypsum, mica, cement, calcium carbonate and sand. These dry compounds comprise a population of particles of different sizes.

10 Particles which are smaller than 20 microns are referred to respirable particles because these particles can be dispersed into the air. These particles can be then inhaled by workers, which should be avoided. Thus, there is a need to analyze a powder sample and provide an accurate estimate whether the sample comprises respirable particles and the percentage of such particles in the sample.

15 The standard procedure for respirable silica requires the sample in analysis to be treated with acid to eliminate most of the sample matrix. The remaining material is examined for crystalline silica. The weight of crystalline silica is determined using X-ray Diffraction or FTIR. This number is reported as Total Crystalline Silica. The second step requires the sample to be dispersed in alcohol and transferred to a silver membrane and the mass of crystalline silica determined
20 for the < 10 μ fraction. A determination is also provided for the < 5 μ fraction.

The criteria in the Globally Harmonized System (GHS) have the fine fraction of silica classified as specific target organ toxicity in this case, the lung. Generic cut-off values for products containing a fine fraction of crystalline silica trigger a need for a method for the quantification of the fine fraction of crystalline silica in bulk
25 materials.

The European Union has promoted an analysis for silica in bulk materials which culminated in the publication of a new standard for measuring the amounts of respirable particles in bulk materials. The standard has two parts:

1. Determination of Size-Weighted Potential Respirable Fraction (SWeRF); and
2. Size-Weighted Potential Respirable Fraction of Crystalline Silica (SWeRF_{CS})

The method is to be used for comparing the potential health risks of bulk materials. The method does not predict how a material will disperse in air, but quantifies the respirable fraction. The particles that present a larger health risk are weighed more in the calculation. The advantage of the method is it provides an unambiguous characterization of the bulk material. The term “potential” is used to indicate that the standard does not analyze airborne particles.

The standard describes a method using sedimentation and a calculation method based on particle size distribution (PSD). The calculation can only be used after the results are validated using the sedimentation data. The calculation method requires that the particles have the same density or in the case of mixture with different materials that they have the same PSD. A plot is made to compare the sedimentation PSD with the Stokes’ Law and the convention described in CSN EN 481 (European Standards EN 481 “Workplace atmospheres – size fraction definitions for measurement of airborne particles”). However, in this calculation method, the dynamic form factor is neglected where in the sedimentation method, the dynamic form factor is assumed to be equal in air and liquid. Thus, there remains a need for accurate and rapid detection of respirable particles in a bulk material.

Summary

At least some of these needs are addressed by the present methods which are based on analyzing particles for their morphology and chemical

composition and creating a profile for a sample in which each particle is characterized by its morphology and chemical composition.

This invention provides a method for detecting respirable particulates in a bulk material comprising particles. The method comprises:

- 5 - analyzing morphology of the particles;
- analyzing chemical composition of the particles;
- creating a profile of the particles, wherein each particle in the profile is characterized by its shape, size and chemical composition;
- selecting particles from the profile which match the size and
- 10 chemical composition of a respirable particle; and
- calculating a percentage of the respirable particles in the bulk material.

In this method, the morphology and chemical composition of the particles can be analyzed by a computer-controlled scanning electron microscope interfaced with
15 an energy dispersive X-ray spectrometer (SEM□EDS). The method may comprise a step of resuspending the particles of the bulk material, such as gypsum or calcium carbonate, in a medium (water or organic solvent), and filtering the suspension through a filter with a nominal pore size sufficiently small to retain the particles in the respirable size range. In the method, the particles can be retained on a filter. The morphology
20 and chemical composition of the particles are analyzed by an automated SEM□EDS. Various bulk materials can be analyzed, including mixtures of inorganic compounds.

The present method can be used to analyze respirable particles, such as for example silica (SiO_2), smaller than 20 microns. The present method can be also used to analyze respirable particles, such as for example silica (SiO_2), smaller than 10
25 microns.

Brief Description of the Drawings

Fig. 1 is a diagram of methods for respirable particle analysis.

Fig. 2A is a plot for a bulk material comprising a small respirable fraction.

Fig. 2B are calculations in connection with the plot of Fig. 2A.

Fig. 3A is a plot for bulk material which does not comprise detectable respirable silica.

Fig. 3B are calculations in connection with the plot of Fig. 3A.

5 **Fig. 4A** is a plot of a bulk material comprising a respirable fraction.

Fig. 4B are calculations in connection with the plot of Fig. 4A.

Fig. 5 is a scan of gypsum spiked with 0.5% of quartz.

Fig. 6 is a scan of gypsum spiked with 0.1% of quartz.

Fig. 7 is a plot with three calibration points.

10 **Fig. 8** is a scan of selenite comprising quartz.

Fig. 9 is a first plot of filler Microwhite 100.

Fig. 10 is a first plot of filler Pulpro-20.

Fig. 11 is a plot of filler #3.

Fig. 12 is a second plot of filler Microwhite 100.

15 **Fig. 13** is a second plot of filler Pulpro-20.

Fig. 14 is a plot of filler Snowwhite 21.

Fig. 15 is a plot of filler S-200.

Fig. 16 is a plot of filler Marblehill.

Fig. 17 is a plot of filler G260 RM 71778.

20 **Fig. 18** is an example of ESPRIT's Feature analysis workspace: a fraction of the filter area is imaged by SEM and converted to binary image, in which particles of interest (bright feature in the left frame) are identified for further EDS analysis (right frame).

Fig. 19 is an example of automated particle analysis workspace: EDS composition analyses of particles marked in Fig. 18 are in progress; note that results from particle sizing are tabulated below the field image.

Fig. 20 is the particle analysis workspace: an example EDS X-ray spectrum acquired for one particle (most likely dolomite) identified in Fig. 18; note that results from EDS are tabulated below the spectrum.

30 **Fig. 21** is a histogram of size (as AED) frequency of particles with Si relative intensity >5% (cf. Table 4).

Fig. 22 reports Si contents in particles (with relative intensity >5%) as a function of size.

Detailed Description

5 Provided is a method for examining the respirable fraction in bulk materials. The method comprises the following two steps. In step one, a sample is analyzed for particle size distribution and density. This step determines the total proportion of respirable particles in the sample. In step two, the amount of crystalline silica (also known as silicon dioxide or quartz) in the sample is determined. Various matrices can be
10 analyzed by this method, including gypsum, cement, mica, calcium carbonate, sand, etc. The method is illustrated in Fig. 1 in comparison to other methods.

 Step one can be performed by using a Quantachrome Pycnometer for a density measurement, followed by an analysis with a particle size analyzer (such as for example, Horiba LA-950V2) and the SWeRF equation which is validated for individual
15 matrices. In step two, the mass of silica in the respirable fraction can be estimated by using a scanning electron microscope which eliminates the need for X-Ray Diffraction Instrument. In further embodiments, a scanning electron microscope interfaced with an energy dispersive X-ray spectrometer can be used to analyze particles for their morphology, including shape and size, and also a chemical (elemental composition) of the particles. See
20 Fig. 1 in which the present method is compared to other methods.

 In the present method, a scanning electron microscope is used for crystalline identification and morphology. This analysis can be conducted with computer software which captures data for each particle individually, including the particle's shape, size and chemical composition.

25 In one embodiment of the method, the SWeRF equations are evaluated using the CIC particle size analysis and RJ Lee Total Crystalline Silica. A typical graphic output for plotting the PSD for the SWeRF calculation is shown in Fig 2A. The plot indicates the DuPont Richmond FGD (trimodal PSD) has a small respirable fraction (1.6 %). Using the SWeRF and SWeRF_{CS} equations as shown in the Table of Fig 2B, the RJ
30 Lee and SWeRF_{CS} estimate are in agreement and report 0.01 % respirable silica.

As shown in Fig. 3A and the Table of Fig. 3B, the Dayton Power Light FGD illustrates a scenario where the PSD and SWeRF equations indicate no respirable fraction (monomodal PSD) and therefore no respirable silica. The RJ Lee data is indicating total crystalline silica of 0.2 % and < 10 μ respirable silica of 0.2 %.

5 As shown in Fig. 4A and the Table of Fig. 4B, the Montreal Recycle material illustrates a scenario where the PSD (bimodal) and SWeRF equations indicate a small respirable fraction in contrast to the RJ Lee data indicating a respirable silica fraction of 1.3 %. This is significantly higher than the 0.8 % SWeRF estimate. This could require the sedimentation verification for SWeRF.

10 Table 1 is a summary of several different types of raw materials and how the SWeRF estimates correlate with the RJ Lee respirable silica.

As shown in Table 1, in some examples (Dayton Power FGD, Rodemacher Fly Ash) there are two outputs. This occurs when the SDS gives a range for the density. For example, the Rodemacher SDS provided a density range of 2200-
15 2800 kg/m³. The calculation for SWeRF was performed twice (2200 and 2800 kg/m³).

Table 1

Sample name Haycoke RM 818202	Date	8/4/10	Sample			Cryst. Silica cont.	33.9	%
Sample identification			Density =	613	kg/m ³	CG Density =	2650	kg/m ³
raw material (silica 52-65 %)			Si/AlRF =	45.2	%	Si/AlRFcs =	8.3	%
						RJ Lee Total Crystalline Silica	33.9	
						RJ Lee Respirable Silica < 10 µ	8.2	
						RJ Lee Respirable Silica < 5 µ	3.4	
Sample Lansing Fly ash RM81141	Date	8/20/10	Sample			Cryst. Silica cont.	9.5	%
Sample identification			Density =	2600.0	kg/m ³	CG Density =	2650.0	kg/m ³
flyash density 2-3.2			Si/AlRF =	25.4	%	Si/AlRFcs =	2.3	%
Sample Lansing Fly ash RM81141	Date	8/20/10	Sample			Cryst. Silica cont.	9.5	%
Sample identification			Density =	2600.0	kg/m ³	CG Density =	2650.0	kg/m ³
flyash density 2-3.2			Si/AlRF =	20.9	%	Si/AlRFcs =	2.3	%
						RJ Lee Total Crystalline Silica	9.5	
						RJ Lee Respirable Silica < 10 µ	2.6	
						RJ Lee Respirable Silica < 5 µ	1.2	
Sample slate RM80363	Date		Sample			Cryst. Silica cont.	16.4	%
Sample identification			Density =	1900	kg/m ³	CG Density =	2650	kg/m ³
slate density 1.47-1.53			Si/AlRF =	5.8	%	Si/AlRFcs =	0.7	%
						RJ Lee Total Crystalline Silica	16.4	
						RJ Lee Respirable Silica < 10 µ	0.3	
						RJ Lee Respirable Silica < 5 µ	0.4	
Sample mica RM79833	Date		Sample			Cryst. Silica cont.	2.3	%
Sample identification			Density =	1850	kg/m ³	CG Density =	2650	kg/m ³
slate density 1.50			Si/AlRF =	7.8	%	Si/AlRFcs =	0.3	%
						RJ Lee Total Crystalline Silica	2.3	
						RJ Lee Respirable Silica < 10 µ	0.3	
						RJ Lee Respirable Silica < 5 µ	0.2	
Sample Temorra perlite (Micron 120) RM81137	Date	8/18/2010	Sample			Cryst. Silica cont.	0.10	%
Sample identification			Density =	2350	kg/m ³	CG Density =	2650	kg/m ³
perlite specific gravity			Si/AlRF =	1.4	%	Si/AlRFcs =	0.003	%
						RJ Lee Total Crystalline Silica	< 0.1	
						RJ Lee Respirable Silica < 10 µ	< 0.01	
						RJ Lee Respirable Silica < 5 µ	N/A	
Sample Micron 200 & RM81249	Date	8/14/2011	Sample			Cryst. Silica cont.	0.3	%
Sample identification			Density =	2350	kg/m ³	CG Density =	2650	kg/m ³
perlite specific gravity 2.35			Si/AlRF =	0.8	%	Si/AlRFcs =	0.003	%
						RJ Lee Total Crystalline Silica	0.3	
						RJ Lee Respirable Silica < 10 µ	0.01	
						RJ Lee Respirable Silica < 5 µ	N/A	
DuPont Richmond RM80332	Date	11/21/2011	Sample			Cryst. Silica cont.	0.1	%
Sample identification FGD Gypsum			Density =	2325	kg/m ³	CG Density =	2650	kg/m ³
perlite specific gravity 2.32			Si/AlRF =	1.6	%	Si/AlRFcs =	0.001	%
						RJ Lee Total Crystalline Silica	0.1	
						RJ Lee Respirable Silica < 10 µ	< 0.01	
						RJ Lee Respirable Silica < 5 µ	< 0.01	
DuPont Richmond RM80332	Date	11/21/2011	Sample			Cryst. Silica cont.	0.1	%
Sample identification FGD Gypsum			Density =	2365	kg/m ³	CG Density =	2650	kg/m ³
perlite specific gravity 2.32			Si/AlRF =	1.16203643	%	Si/AlRFcs =	0.001	%
						RJ Lee Total Crystalline Silica	0.1	
						RJ Lee Respirable Silica < 10 µ	< 0.01	
						RJ Lee Respirable Silica < 5 µ	< 0.01	

Table 1 cont'd

Dayton Power Light R0880570	Date: 7/2/1997	Sample		Cryst. Silica cont.	3.3
Sample identification F30 Gypsum		Density =	2305 kg/m ³	CG Density =	2650
particle specific gravity 2.3		SWeRF =	0.6 %	SWeRFcs =	0.6
				R/L Lee Total Crystalline Silica	3.3
				R/L Lee Respirable Silica < 10 µ	< 0.05
Dayton Power Light R0880570	Date: 7/2/1997	Sample		Cryst. Silica cont.	0.2
Sample identification F30 Gypsum		Density =	2660 kg/m ³	CG Density =	2650
particle specific gravity 2.3		SWeRF =	0.6 %	SWeRFcs =	0.6
				R/L Lee Total Crystalline Silica	0.2
				R/L Lee Respirable Silica < 10 µ	< 0.05
Naphthalene Dye R0880574	Date: 7/2/1997	Sample		Cryst. Silica cont.	0.1
Sample identification		Density =	2610 kg/m ³	CG Density =	2650
particle specific gravity 2.3		SWeRF =	44.6 %	SWeRFcs =	0.0
				R/L Lee Total Crystalline Silica	0.1
				R/L Lee Respirable Silica < 10 µ	< 0.1
2015-134 Rademacher fly ash 0	Date: 4/24/2015	Sample		Cryst. Silica cont.	2
Sample identification fly ash		Density =	2280 kg/m ³	CG Density =	2650
specific gravity 2.2		SWeRF =	13.6 %	SWeRFcs =	0.19
				R/L Lee Total Crystalline Silica	2
				R/L Lee Respirable Silica < 10 µ	0.13
2015-134 Rademacher fly ash 0	Date: 4/24/2015	Sample		Cryst. Silica cont.	2
Sample identification fly ash		Density =	2680 kg/m ³	CG Density =	2650
specific gravity 2.8		SWeRF =	9.3 %	SWeRFcs =	0.19
				R/L Lee Total Crystalline Silica	2
				R/L Lee Respirable Silica < 10 µ	0.13
2015-137 Termisto penite #1	Date: 4/27/2015	Sample		Cryst. Silica cont.	1.8
Sample identification penite		Density =	2390 kg/m ³	CG Density =	2650
specific gravity 2.35		SWeRF =	0.6 %	SWeRFcs =	0.01
				R/L Lee Total Crystalline Silica	1.8
				R/L Lee Respirable Silica < 10 µ	0.15
2015-137 Termisto penite #2	Date: 4/27/2015	Sample		Cryst. Silica cont.	1.8
Sample identification penite		Density =	2390 kg/m ³	CG Density =	2650
specific gravity 2.35		SWeRF =	0.6 %	SWeRFcs =	0.01
				R/L Lee Total Crystalline Silica	1.8
				R/L Lee Respirable Silica < 10 µ	0.3
R/L 100126 Gypsum	Date: 8/14/2016	Sample		Cryst. Silica cont.	3.8
Sample identification recycle wastewater		Density =	2325 kg/m ³	CG Density =	2650
specific gravity 2.32		SWeRF =	0.90 %	SWeRFcs =	0.03
				R/L Lee Total Crystalline Silica	3.8
				R/L Lee Respirable Silica < 10 µ	1.31

The XRD experiment on gypsum spiked with 0.5 % and 0.1 % quartz shows excellent initial sensitivity, as shown in Figs. 5 and 6. Even though this only is three calibration points (Fig. 7), a scan of selenite indicates the material is 0.056 % quartz (Fig. 8).

Various carbonates which can be used as a filler were tested for SWeRF and SWeRFcs by the method described above. These values are provided in Table 2 below. See also Figs. 9-17 for supporting plots.

Table 2 Estimated Respirable Fractions

	SWeRF =	SWeRFcs =
2016-148 #1 80388-CP Filler	7.34	0.09
2016-148 #2 Marblewhite 310	8.30	0.030
2016-148 #3 70283-BP-U	7.02	0.052
2016-159 #1 62303-Microwhite 100 Sylacauga	9.63	0.12
2016-159 #2 66342-Pulpro-20	6.69	0.37
2016-159 #3 63305-Snowwhite 21	8.73	0.33
2016-159 #4 70999 S-200	8.21	0.020
2016-159 #5 60208 Microwhite 100 Marblehill	9.07	0.027
2016-182 #1 G260 RM 71778	7.75	0.024

Table 3 lists the particle size distribution for the carbonates.

Table 3.

Omya BP-LU			SMI Marblewhite 310			Imerys CP-Filler		
RUN	VOLUME (cc)	DENSITY (g/cc)	RUN	VOLUME (cc)	DENSITY (g/cc)	RUN	VOLUME (cc)	DENSITY (g/cc)
1	0.3353	2.9871	1	0.3569	2.8116	1	0.3603	2.7781
2	0.3332	3.0063	2	0.4005	2.5052	2	0.3588	2.7903
3	0.3366	2.9757	3	0.3612	2.7779	3	0.3603	2.7789
4	0.3354	2.9858	4	0.3621	2.7711	4	0.3639	2.7507
5	0.3392	2.9528	5	0.3642	2.7551	5	0.3667	2.7299
6	0.3384	2.9596	6	0.3646	2.7523	6	0.3689	2.7135
7	0.3397	2.9485	7	0.3659	2.7420	7	0.3707	2.7005
8	0.3391	2.9534	8	0.3257	3.0811	8	0.3727	2.6863
9	0.3413	2.9347	9	0.3703	2.7096	9	0.3745	2.6734
10	0.3405	2.9414	10	0.3700	2.7121	10	0.3722	2.6894
average	0.3379	2.9645	average	0.3641	2.7618	average	0.3669	2.7291
std. dev.	0.0026	0.0231	std. dev.	0.0181	0.1400	std. dev.	0.0058	0.0430

Table 3 cont'd

Imerys Microwhite 100- Sylacauga			Imerys Microwhite 100- Marblehill			Huber G260		
RUN	VOLUME (cc)	DENSITY (g/cc)	RUN	VOLUME (cc)	DENSITY (g/cc)	RUN	VOLUME (cc)	DENSITY (g/cc)
1	0.3666	2.7324	1	0.3694	2.7272	1	0.3683	2.7211
2	0.3670	2.7295	2	0.3711	2.7141	2	0.3689	2.7172
3	0.3700	2.7073	3	0.3741	2.6927	3	0.3691	2.7159
4	0.3702	2.7058	4	0.3768	2.6735	4	0.3699	2.7098
5	0.3705	2.7042	5	0.3789	2.6587	5	0.3688	2.7174
6	0.3731	2.6853	6	0.3804	2.6483	6	0.3714	2.6985
7	0.3731	2.6849	7	0.3822	2.6354	7	0.3682	2.7220
8	0.3742	2.6775	8	0.3815	2.6406	8	0.3709	2.7026
9	0.3729	2.6864	9	0.3820	2.6370	9	0.3675	2.7274
10	0.3744	2.6759	10	0.3789	2.6582	10	0.3683	2.7215
average	0.3712	2.6989	average	0.3775	2.6686	average	0.3691	2.7153
std. dev.	0.0028	0.0204	std. dev.	0.0046	0.0327	std. dev.	0.0012	0.0091

JaJack S- 200			Omya Snowwhite 21			Omya Pulpro 20		
RUN	VOLUME (cc)	DENSITY (g/cc)	RUN	VOLUME (cc)	DENSITY (g/cc)	RUN	VOLUME (cc)	DENSITY (g/cc)
1	0.3581	2.7958	1	0.3615	2.8165	1	0.3596	2.8497
2	0.3572	2.8031	2	0.3609	2.8212	2	0.3555	2.8826
3	0.3595	2.7851	3	0.3643	2.7949	3	0.3583	2.8598
4	0.3594	2.7854	4	0.3647	2.7913	4	0.3713	2.7598
5	0.3631	2.7573	5	0.3676	2.7693	5	0.3574	2.8677
6	0.3618	2.7672	6	0.3680	2.7663	6	0.3593	2.8518
7	0.3607	2.7758	7	0.3701	2.7512	7	0.3594	2.8513
8	0.3597	2.7831	8	0.3701	2.7508	8	0.3649	2.8083
9	0.3630	2.7583	9	0.3694	2.7562	9	0.3597	2.8487
10	0.3619	2.7668	10	0.3714	2.7415	10	0.3619	2.8320
average	0.3604	2.7778	average	0.3668	2.7759	average	0.3607	2.8412
std. dev.	0.0020	0.0154	std. dev.	0.0037	0.0284	std. dev.	0.0045	0.0348

Figs. 9-17 provide plots supporting the data in Table 3.

The data in Table 3 indicate that 5 carbonates out of all carbonates listed in Table 2 meet the new silica limit. A person of skill will also readily understand that the final contribution to the product of the respirable fraction depends on the formulation level.

Further embodiments provide a method in which particles are analyzed individually to measure concentrations of respirable particles (such as for example, silica, silicate minerals, asbestos, and any other particles that may be hazardous to a human if inhaled) in a bulk material for safety assessment.

In this method, a sample of bulk material is dispersed and

resuspended in a suitable medium. The sample can be resuspended in water or in an organic solvent, including, but not limited to, isopropanol or ethanol. The choice of a medium depends on the water solubility for a particular material to be analyzed. For materials soluble in water, an organic solvent is used.

5 A bulk material suspended in a medium can be subjected to filtration through a membrane filter with pore sizes suitable for retaining particles in the respirable size range. The respirable size range can be less than 20 μm in some applications, whereas in other applications, it can be less than 10 μm . This method can be performed with 0.4- μm pore-sized polycarbonate filter to ensure all particles
10 in the respirable size range are captured.

 In one application of the present method, particles retained on the membrane filter by filtration are air-dried and coated with a thin layer of carbon before being subjected to analysis.

 In the present method, an analysis of respirable particles is conducted
15 by a scanning electron microscope (abbreviated as SEM) interfaced with an energy dispersive X-ray spectrometer (abbreviated as EDS). In this analysis, individual particles in a sample are analyzed for two different properties:

- a) morphological characteristics, including the particle's size and shape; and
- 20 b) chemical (elemental) composition.

 One suitable instrumental setup for the present method includes a computer-controlled scanning electron microscope (SEM) interfaced with an energy dispersive X-ray spectrometer (EDS). This technique can be used to obtain accurate morphological (size, shape, etc.) and (elemental) compositional
25 characterizations of thousands of individual particles.

 Morphology filters can be used to select a subset of detected particles for further EDS compositional analyses—only particles in the respirable size range (e.g., <10 μm) can be selected if needed. This allows an adequate sampling and counting of deposited particles on the filter in a time-efficient manner.

30 Results of this analysis are shown in Figs. 18–20. Fig. 18 depicts a fraction of the filter area imaged by SEM and converted to a binary image, in which

particles of interest (bright feature in the left frame) are identified for further EDS analysis (right frame).

Fig. 19 provides the EDS composition analysis of particles marked in Fig. 18. The results from particle sizing are tabulated below the field image in Fig. 19.

Fig. 20 is an example of the EDS X-ray spectrum acquired for one particle (most likely dolomite) identified in Fig. 18. The results from the EDS analysis are tabulated below the spectrum in Fig.20.

In the present method, a large number of particles can be accurately analyzed for each particle's morphology and chemical composition. The present method creates a multi-dimensional raw dataset (or a profile) of the particles for the sample. In this method, each particle is characterized by its morphological parameters (such as shape and size) and chemical composition.

In one application of the present method, a sample comprising 10% (by weight) respirable silica mixed in gypsum is analyzed for morphology and chemical composition of individual particles. A profile for this sample is shown in Table 4 below. As can be seen from Table 4, the raw dataset may include the following morphological characteristics of a particle: the area, aspect ratio, volume and diameter. In addition, the particle's chemical characteristics are represented by its elemental composition. This is particularly important for identifying different particle types (e.g., gypsum, quartz, calcium carbonate). In this example, each particle was analyzed for the presence of calcium (Ca), sulfur (S) and silicon (Si).

Table 4. Selected output parameters from a computer-controlled SEM–EDS analysis, for a sample made with known quantities of gypsum and respirable silica mixed together.

Particle ID	Area (μm^2)	Aspect Ratio ^a	Volume (μm^3) ^b		Area Equivalent Diameter (μm)	Relative Elemental X-ray Intensity ^c		
			Sphere	Prolate Spheroid		Ca%	S%	Si%
P4939	2.60	1.63	9.93	2.09	1.82	28.59	25.13	46.28
P4940	0.23	1.74	0.26	0.05	0.54	5.51	6.09	88.40
P4969	1.33	1.82	3.64	0.76	1.30	11.06	11.18	77.76
P4973	3.20	1.56	13.54	2.72	2.02	24.57	21.71	53.72
P4975	2.01	1.40	6.71	1.70	1.60	44.10	43.48	12.42
P4979	0.17	1.52	0.16	0.03	0.46	37.26	42.31	20.43
P4990	0.15	1.35	0.13	0.03	0.43	20.18	17.71	62.11
P4998	0.45	1.17	0.72	0.19	0.76	44.35	44.08	11.57
P5008	0.30	1.42	0.40	0.09	0.62	9.42	7.65	82.93
P5011	0.43	1.86	0.67	0.14	0.74	15.32	15.67	69.02
P5020	1.11	1.48	2.77	0.65	1.19	6.84	5.40	87.76
P5024	8.51	1.41	58.72	11.18	3.29	11.26	10.60	78.14
P5025	0.18	1.23	0.18	0.04	0.48	14.14	14.23	71.63
P5031	0.37	1.85	0.53	0.10	0.68	18.05	18.92	63.03
P5036	0.36	1.28	0.50	0.12	0.67	32.83	30.99	36.18
P5043	0.30	1.84	0.40	0.08	0.62	13.98	15.15	70.87
P5047	0.14	1.46	0.12	0.03	0.42	17.67	16.55	65.78
P5058	0.20	1.68	0.21	0.05	0.50	42.49	42.56	14.95
P5073	0.16	1.58	0.15	0.03	0.45	12.31	10.66	77.03
P5076	0.49	1.75	0.82	0.15	0.79	9.93	10.71	79.36
P5090	10.24	1.95	77.40	15.98	3.61	47.22	41.82	10.95

^a Aspect ratio = length/width, dimensionless; a measure of sphericity of a particle—1 for spheres, >1 for irregular particles.

^b Particle volumes estimated for two different shapes (later to be used for mass approximation with density values for different composition).

^c Only relevant elements are shown; due to the use of polycarbonate filter membrane for sample preparation, oxygen (O) was not included in semi-quantification, and gypsum was represented by the elemental presence of Ca and S. Silica was represented by Si.

The large amount of information obtained for morphology and chemical makeup of particles affords a plethora of ways in which the raw data can be analyzed. The following example (Fig. 21) presents the frequency distribution of sizes (as area equivalent diameter, AED) of particles with values of Si X-ray relative intensity >5%, for the same sample as in Table 4. Another way to present these

The present method may also include a step of further characterizing and grouping particles according to a combination of particle characteristics listed

(but not limited to) in Table 4. For example, normalized X-ray counts (net counts divided by particle size) can be used to differentiate crystalline and amorphous SiO₂.

Additional data analyses can be conducted with a specifically compiled code program to selectively group particles according to their characteristics, including shape, size, chemical composition and any combinations of parameters from the raw dataset.

The invention will be now described in more detail by the following non-limiting Examples.

Example 1.

A small amount of weighed bulk material was well-mixed and suspended in known volume (50–100 ml) of deionized water or isopropanol depending on the water solubility of the material. An aliquot (generally <10 ml) was pressure filtered through 25-mm diameter, 0.4- μ m pore-sized polycarbonate filter. Particles deposited on the membrane filter were air-dried and coated with a thin layer of carbon before being subject to instrument analysis.

An automated, computer-controlled particle analysis was conducted by a scanning electron microscope (SEM) interfaced with an energy dispersive X-ray spectrometer (EDS). The automated particle analysis was used to provide morphological (size, shape, etc.) and (elemental) compositional characterizations of individual particles, results of which are shown in Figs. 18–20. Morphology filters were used to select a subset of detected particles for further EDS compositional analyses. In this example, only particles in the respirable size range (<10 μ m) were selected.

Example 2.

A sample comprising 10% (mass concentration) respirable silica mixed in gypsum (micronizing mill was used to homogenize the mixture) was prepared. 8.4 mg of the mixture was suspended in 50 ml isopropanol; and 3 ml of the

suspension was filtered through 25-mm diameter, 0.4- μm pore-sized polycarbonate filter, resulting in 0.504 mg of material retained on a deposition area of 3.14 cm^2 .

The sample was analyzed as described in Example 1 and the particle analysis data was tabulated in Table 4 and were also presented in Figs. 21 and 22.

5 In this analysis, particles containing $\geq 10\%$ Si (relative intensity) and $\leq 10 \mu\text{m}$ were included in the calculation as respirable silica, and density value of 2.65 g/cm^3 was used to estimate a particle mass, assuming a prolate spheroid particle shape. Knowing the fraction of the deposition area analyzed by SEM-EDS, the mass concentration of respirable silica determined by the analysis was 9.8%,
10 which is consistent with that of the prepared sample mixture.

CLAIMS:

What is claimed is:

1. A method for detecting respirable particulates in a bulk material comprising particles, the method comprising:
 - analyzing morphology of the particles;
 - analyzing chemical composition of the particles;
 - creating a profile of the particles, wherein each particle in the profile is characterized by its shape, size and chemical composition;
 - selecting particles from the profile which match the size and chemical composition of a respirable particle; and
 - calculating a percentage of the respirable particles in the bulk material.
2. The method of claim 1, wherein the morphology and chemical composition of the particles are analyzed by a scanning electron microscope interfaced with an energy dispersive X-ray spectrometer.
3. The method of claim 1, wherein the method comprises a step of resuspending the particles of the bulk material in a medium selected from water and/or organic solvent, and filtering the suspension through a filter with a nominal pore size sufficiently small to retain the particles in the respirable size range.
4. The method of claim 1, wherein the particles are retained on a filter, and wherein the morphology and chemical composition of the particles are analyzed by a scanning electron microscope interfaced with an energy dispersive X-ray spectrometer.
5. The method of claim 1, wherein the bulk material is a mixture of inorganic compounds.

6. The method of claim 1, wherein the respirable particles are smaller than 20 microns.
7. The method of claim 1, wherein the respirable particles are smaller than 10 microns.
8. The method of claim 1, wherein the bulk material is selected from the group consisting of gypsum and calcium carbonate.
9. The method of claim 3, wherein the filter is a polycarbonate filter.
10. The method of claim 1, wherein the respirable particles comprise silica (SiO_2).

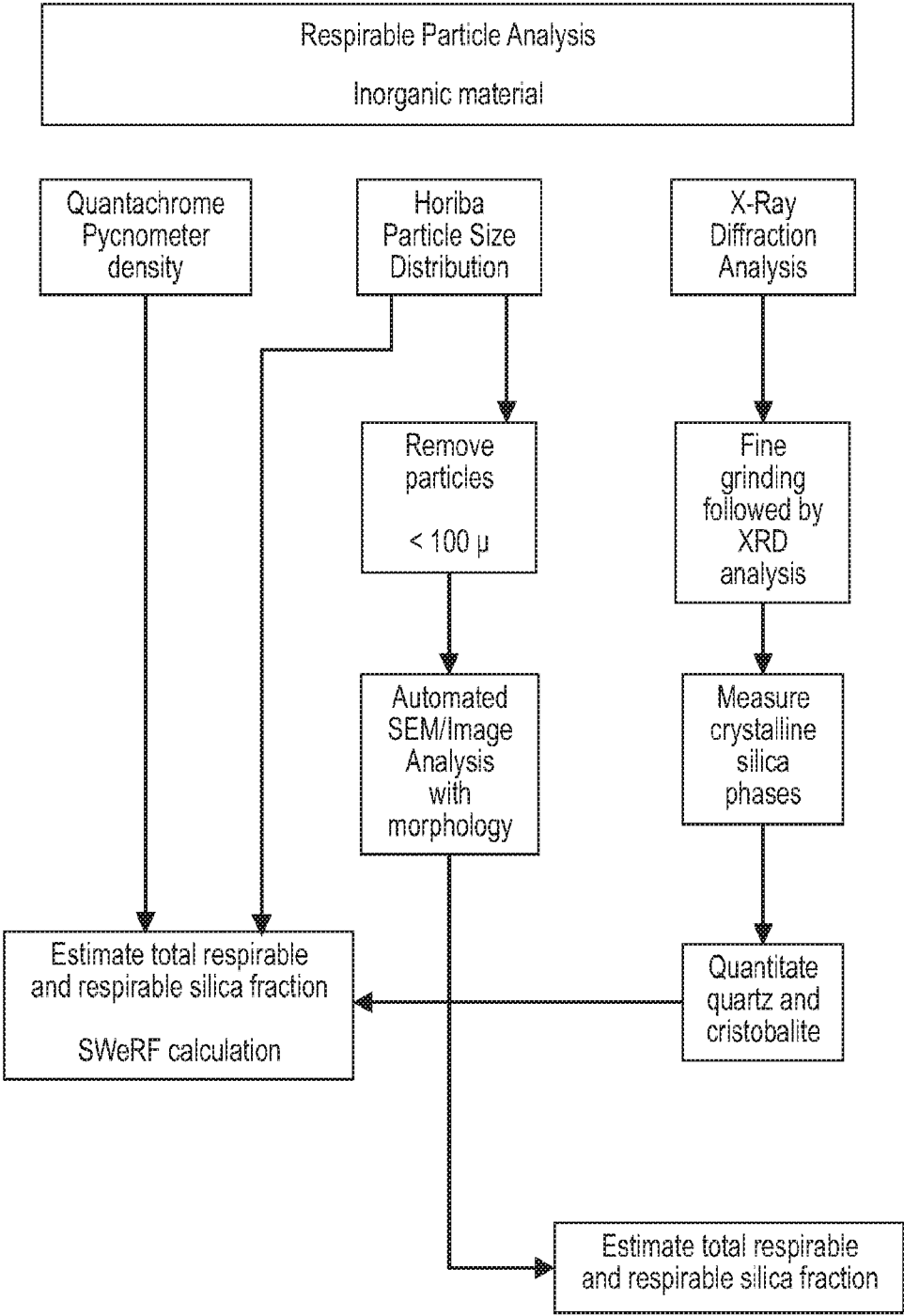


FIG. 1

DuPont Richmond RM 80332

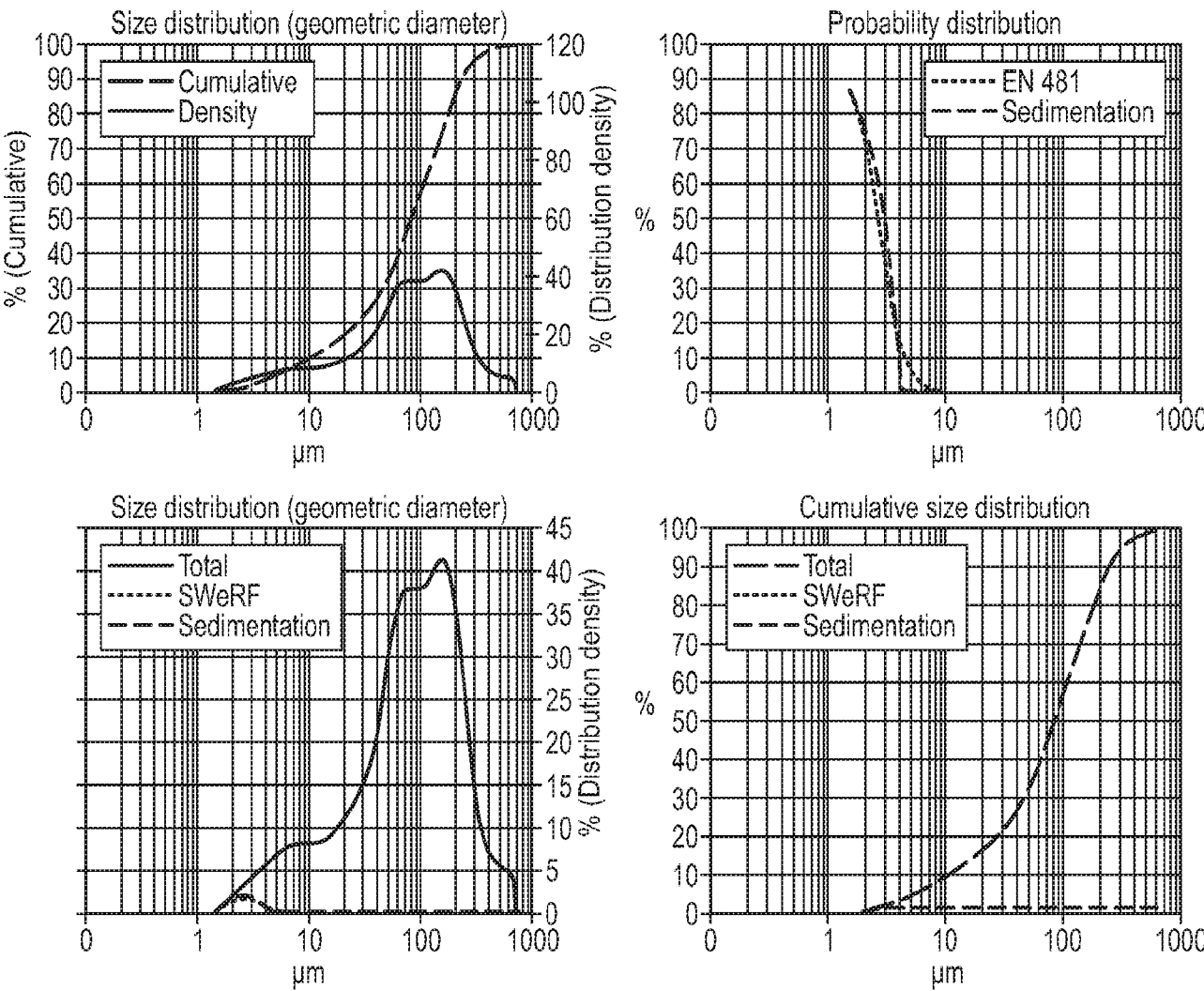
Sample Identification FGD Gypsum
perlite specific gravity 2.32

Date: 31/03/2015

Sample

Density = 2320 kg/m³
SWeRF = 1.6 %

Cryst. Silica cont. 0.1 %
CS Density = 2650 kg/m³
SWeRF_{CS} = 0.0 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The — — — curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

The — — — curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

Method of size distribution analysis:

Different methods will result in a different size distributions which consequently will result in different results for the SWeRF.

It is the responsibility of the manufacturer to determine which method represents the sample most accurately with regard to its behavior in air. Use the same sample preparation for determination of size distribution as for sedimentation test.

FIG. 2A

DuPont Richmond RM 80332 Sample identification FGD Gypsum perlite specific gravity 2.32	Date: 11/21/2011	Sample Density = 2320 kg/m ³ SWeRF = 1.6 %	Cryst. Silica cont.		0.1
			CS Density =		2650
			SWeRFcs =		0.001
			RJ Lee Total Crystalline Silica		0.1
			RJ Lee Respirable Silica < 10µ		< 0.01
			RJ Lee Respirable Silica < 5µ		< 0.01

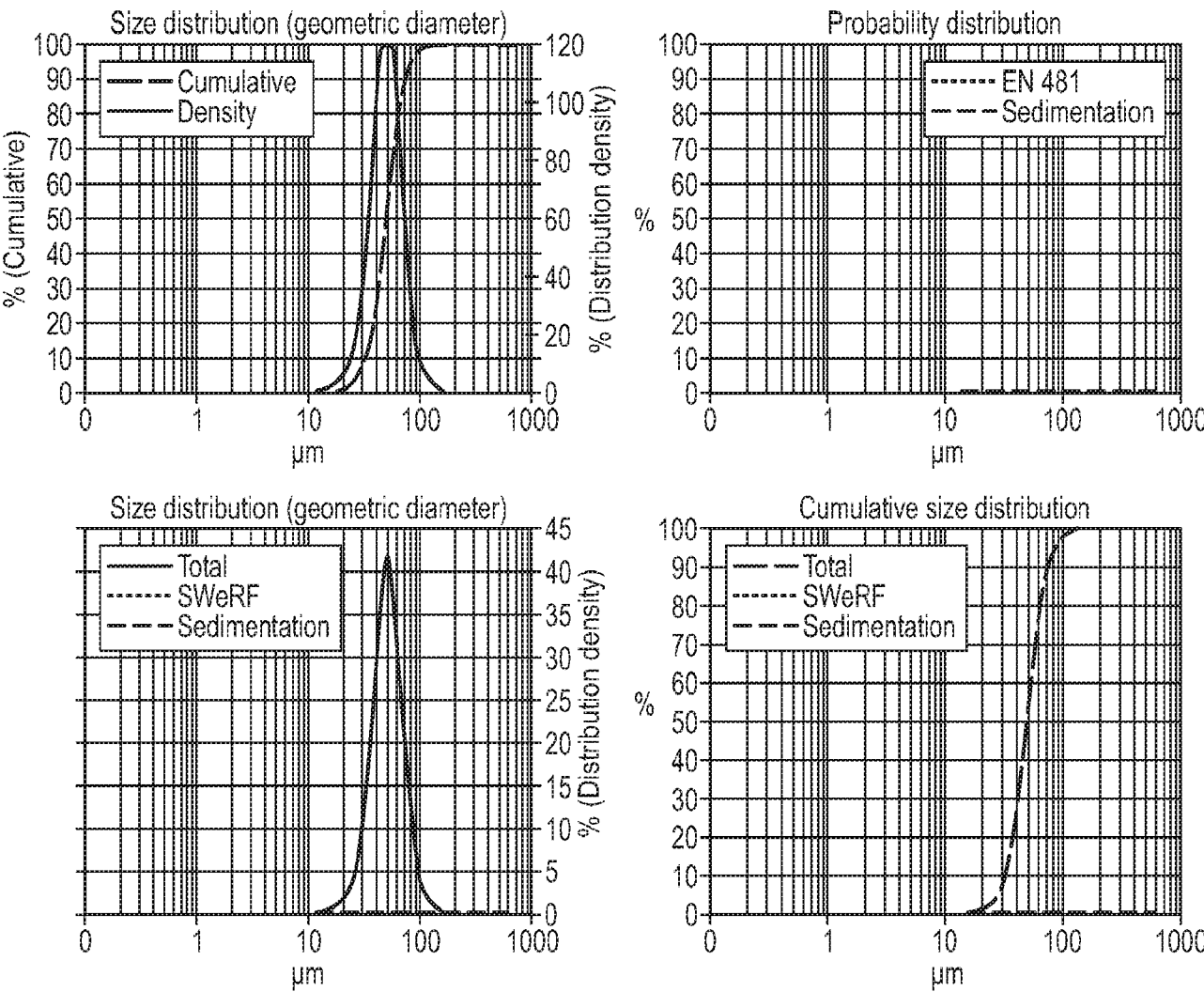
FIG. 2B

Dayton Power Light RM 80570
Sample Identification FGD Gypsum
perlite specific gravity 2.5

Date: 31/03/2015

Sample
Density = 2500 kg/m³
SWeRF = 0.0 %

Cryst. Silica cont. 0.2 %
CS Density = 2650 kg/m³
SWeRF_{CS} = 0.0 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The — — — curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

The — — — curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

Method of size distribution analysis:

Different methods will result in a different size distributions which consequently will result in different results for the SWeRF.

It is the responsibility of the manufacturer to determine which method represents the sample most accurately with regard to its behavior in air. Use the same sample preparation for determination of size distribution as for sedimentation test.

FIG. 3A

Dayton Power Light RM 80570 Sample identification FGD Gypsum perlite specific gravity 2.3	Date: 7/2/1997	Sample	Cryst. Silica cont.	0.2
	Density = 2300 kg/m ³		CS Density =	2650
	SWeRF = 0.0 %		SWeRFCs =	0.0
			RJ Lee Total Crystalline Silica	0.2
			RJ Lee Respirable Silica < 10µ	< 0.05

FIG. 3B

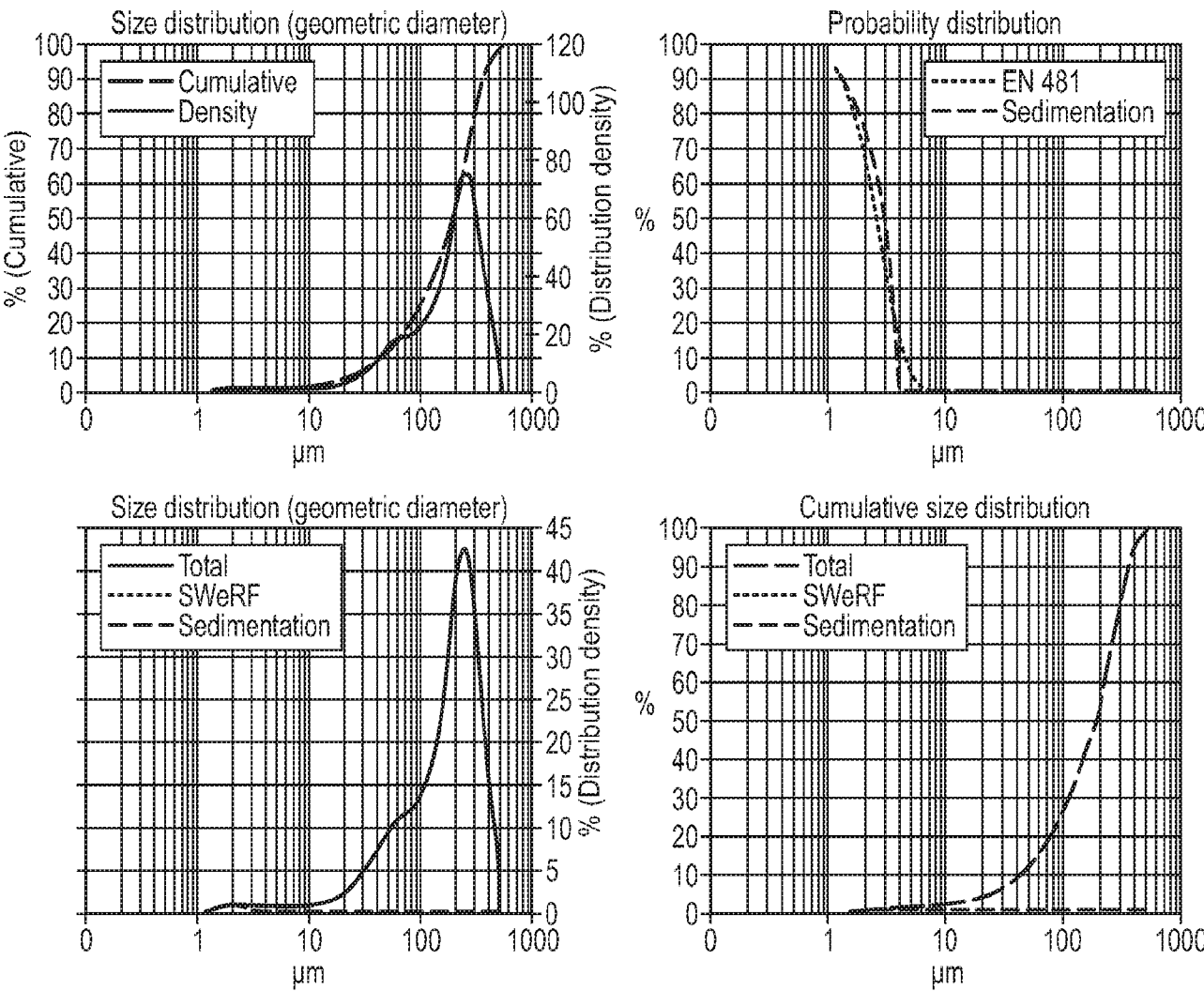
RM 100125 Gypsum

Date: 14/05/2015

Sample identification recycle wallboard
perlite specific gravity 2.32

Density = 2320 kg/m³
SWeRF = 0.8 %

Cryst. Silica cont. 3.6 %
CS Density = 2650 kg/m³
SWeRF_{CS} = 0.0 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The — — — curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

The — — — curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

FIG. 4A

SUBSTITUTE SHEET (RULE 26)

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RM 100125 Gypsum Sample identification recycle wallboard perlite specific gravity 2.32	Date: 5/14/2015	Sample Density = 2320 kg/m ³ SWeRF = 0.80 %	Cryst. Silica cont.	3.6					
					CS Density = 2650				
					SWeRFcs = 0.03				
					RJ Lee Total Crystalline Silica 3.6				
					RJ Lee Respirable Silica < 10µ 1.31				

FIG. 4B

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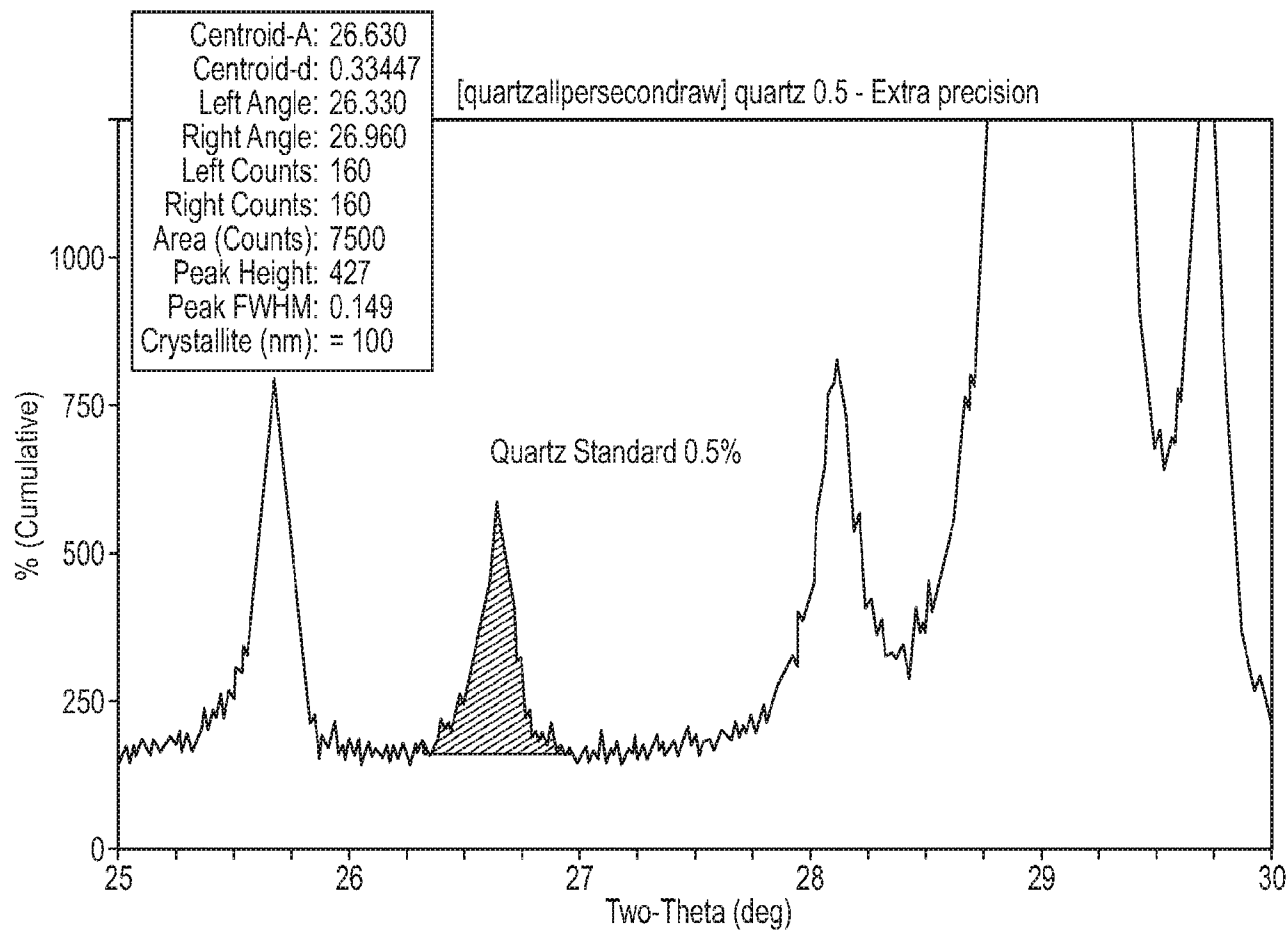


FIG. 5

9/25

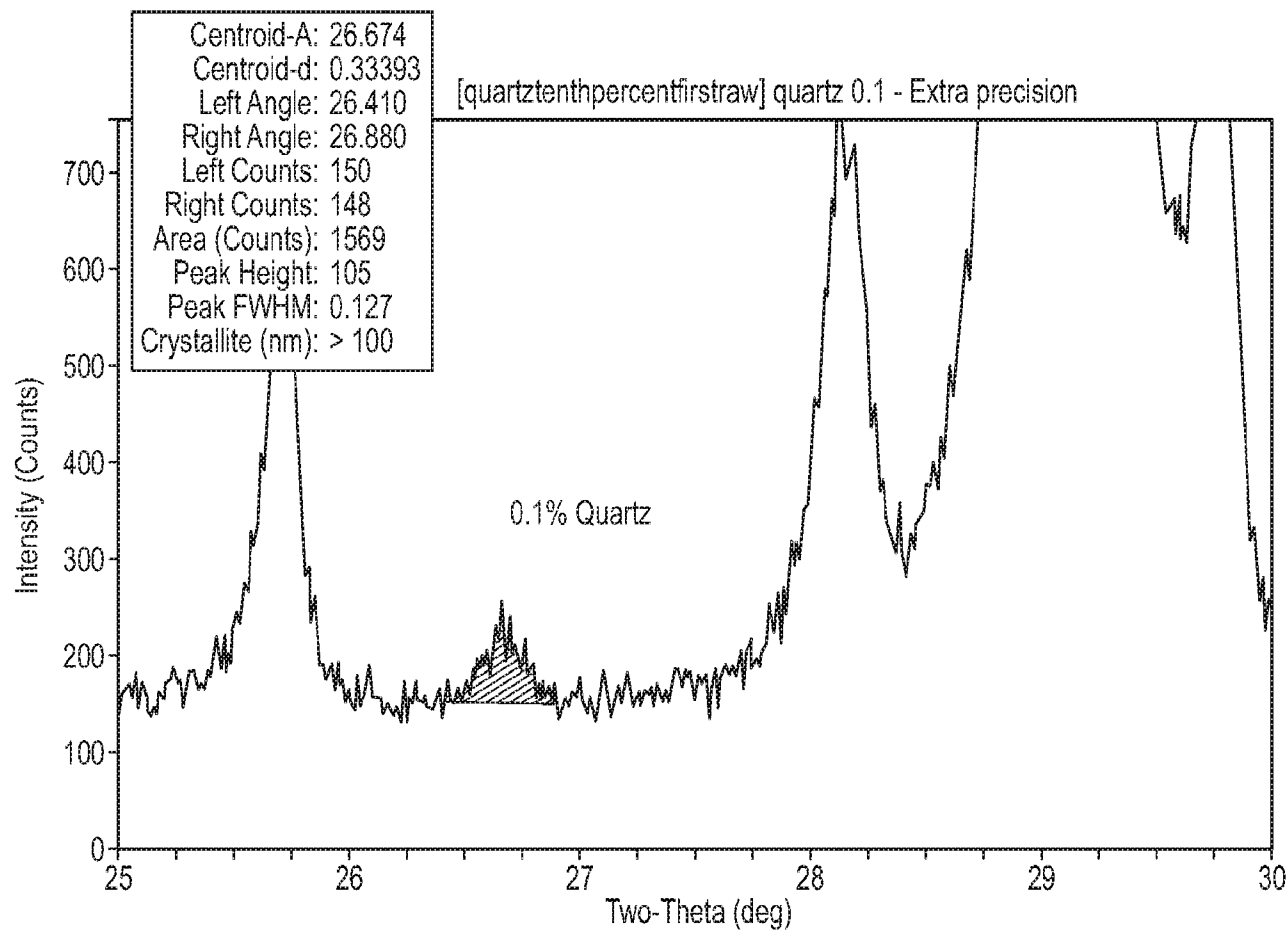


FIG. 6

10/25

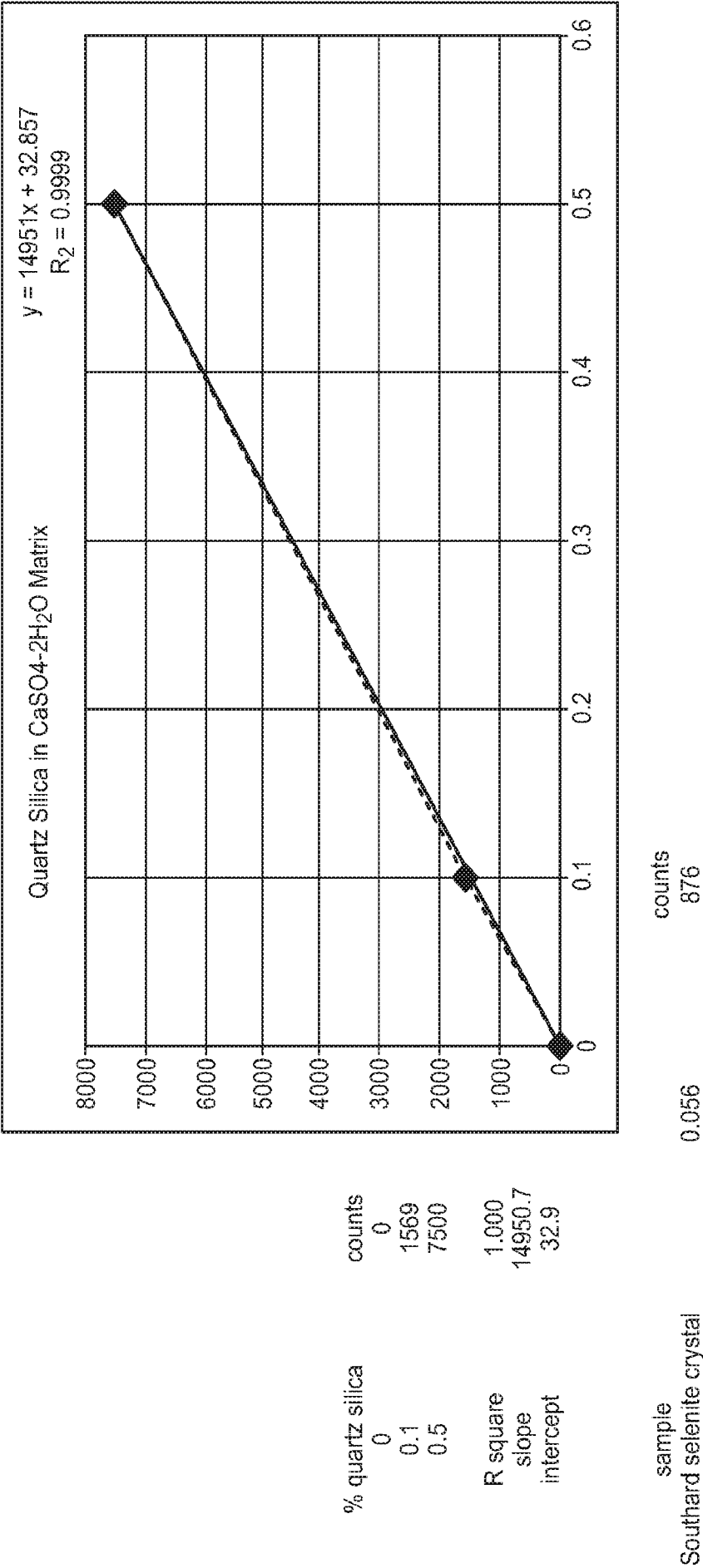


FIG. 7

11/25

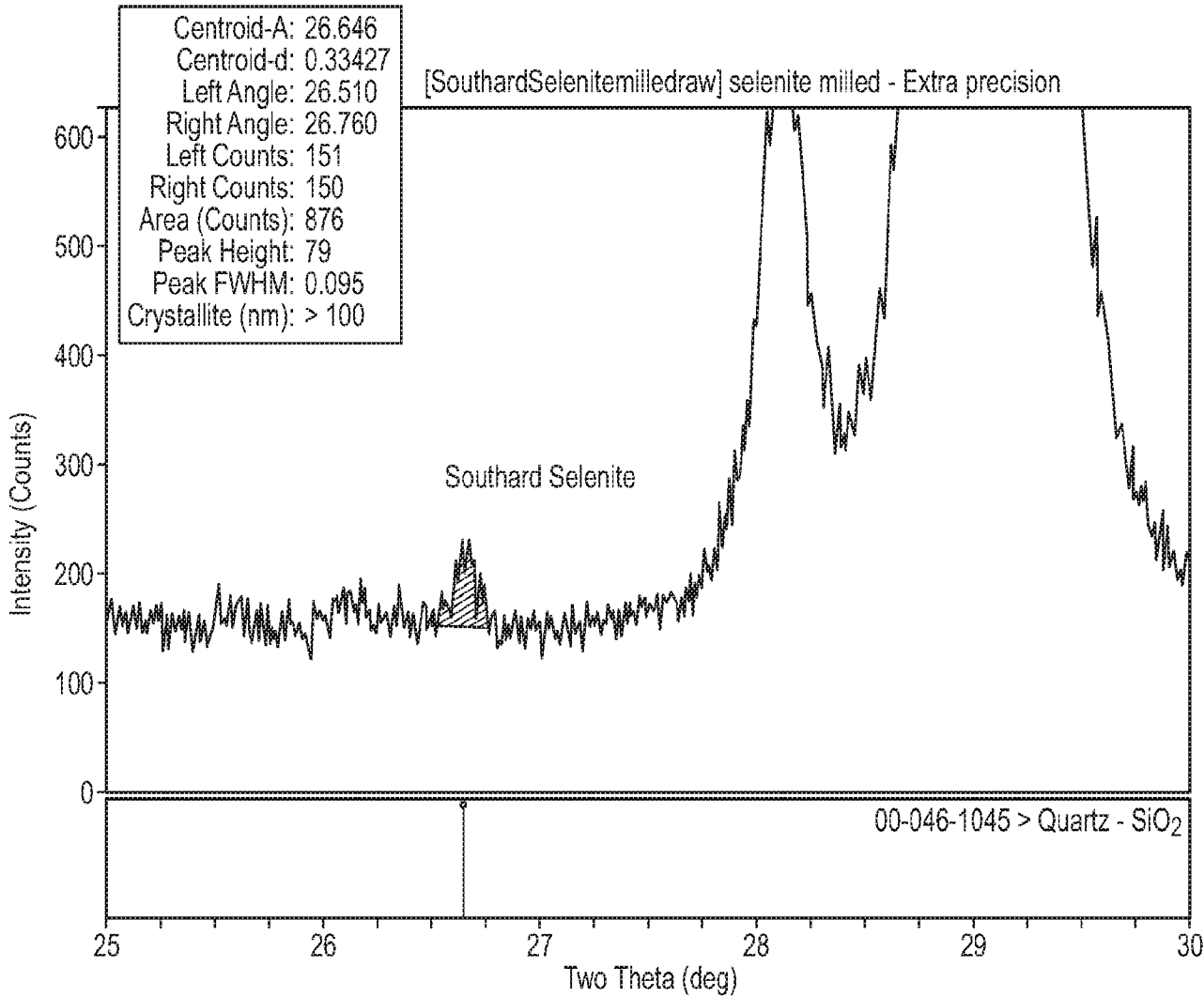


FIG. 8

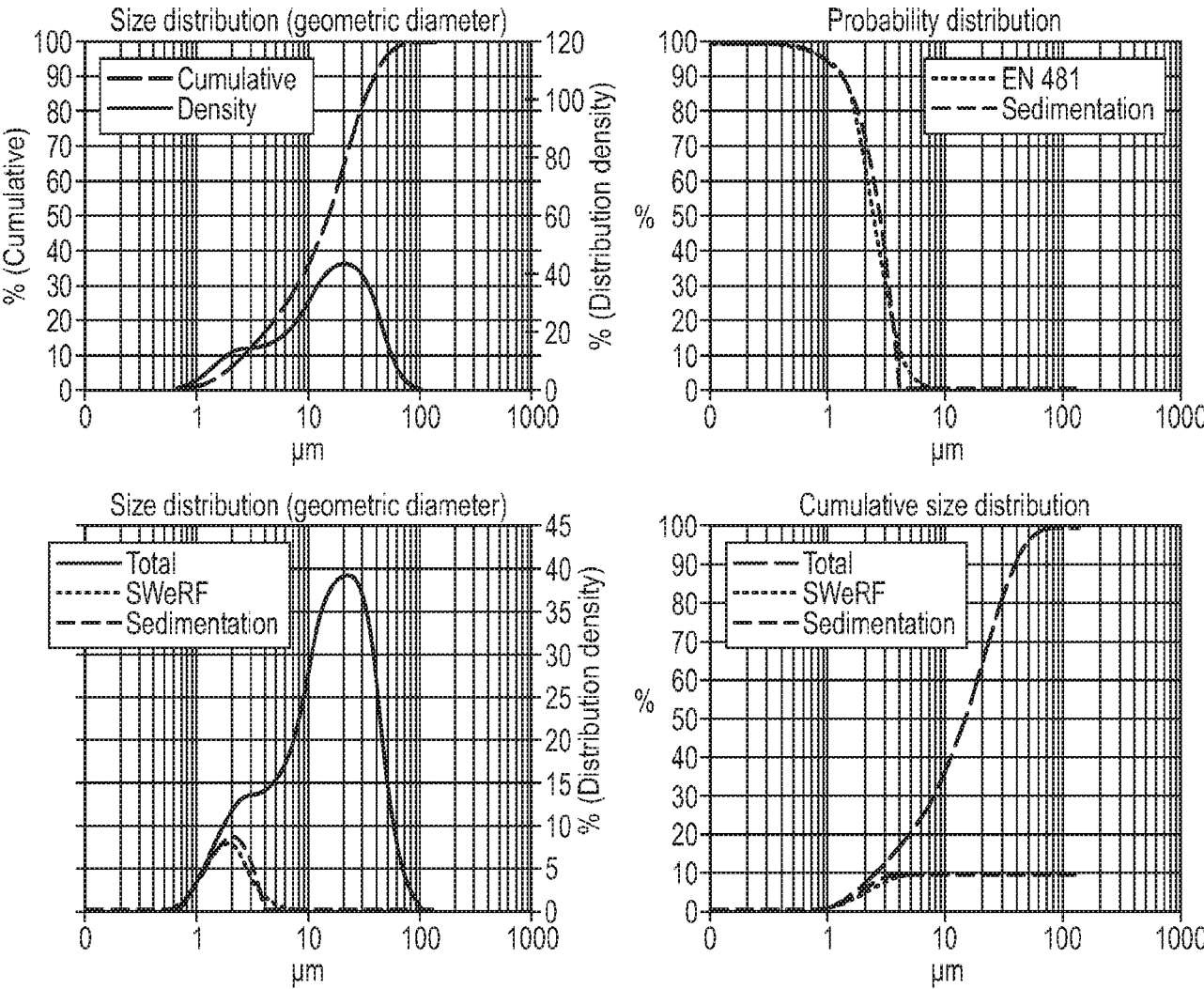
12/25

2016-159 #1 62303-Microwhite 100

Date:
20/06/2016

carbonate
Pycnometer specific gravity 2.6989

Sample	Cryst. Silica cont. 1.3 %
Density = 2689 kg/m ³	CS Density = 2650 kg/m ³
SWeRF = 9.6 %	SWeRF _{CS} = 0.1 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The - - - - curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

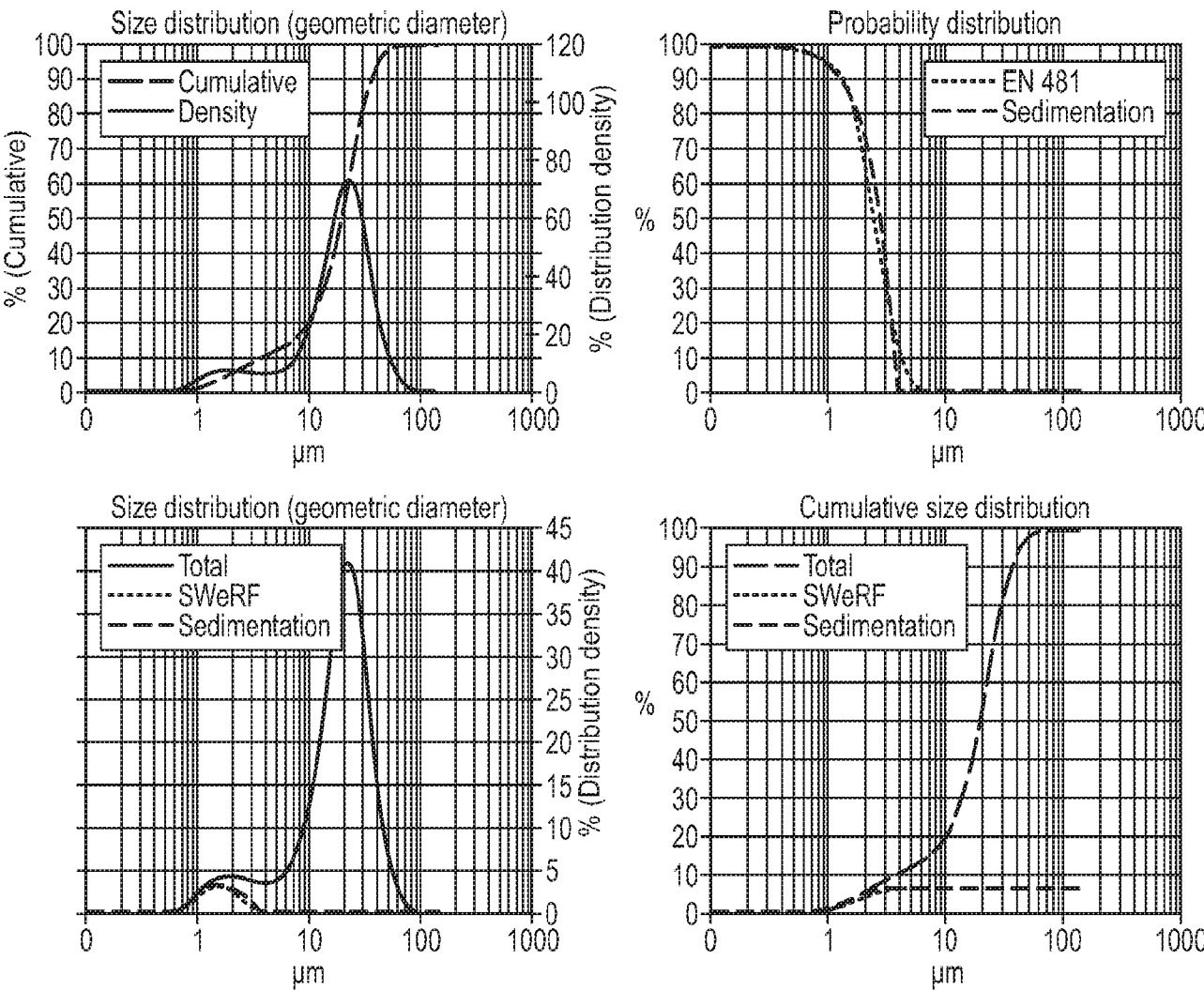
The - - - - curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

FIG. 9

2016-159 #2 66342-Pulpro-20
carbonate
Pycnometer specific gravity 2.8412

Date: 20/06/2016

Sample	Cryst. Silica cont. 5.3 %
Density = 2841 kg/m ³	CS Density = 2650 kg/m ³
SWeRF = 6.7 %	SWeRF _{CS} = 0.4 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The — — — curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

The — — — curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

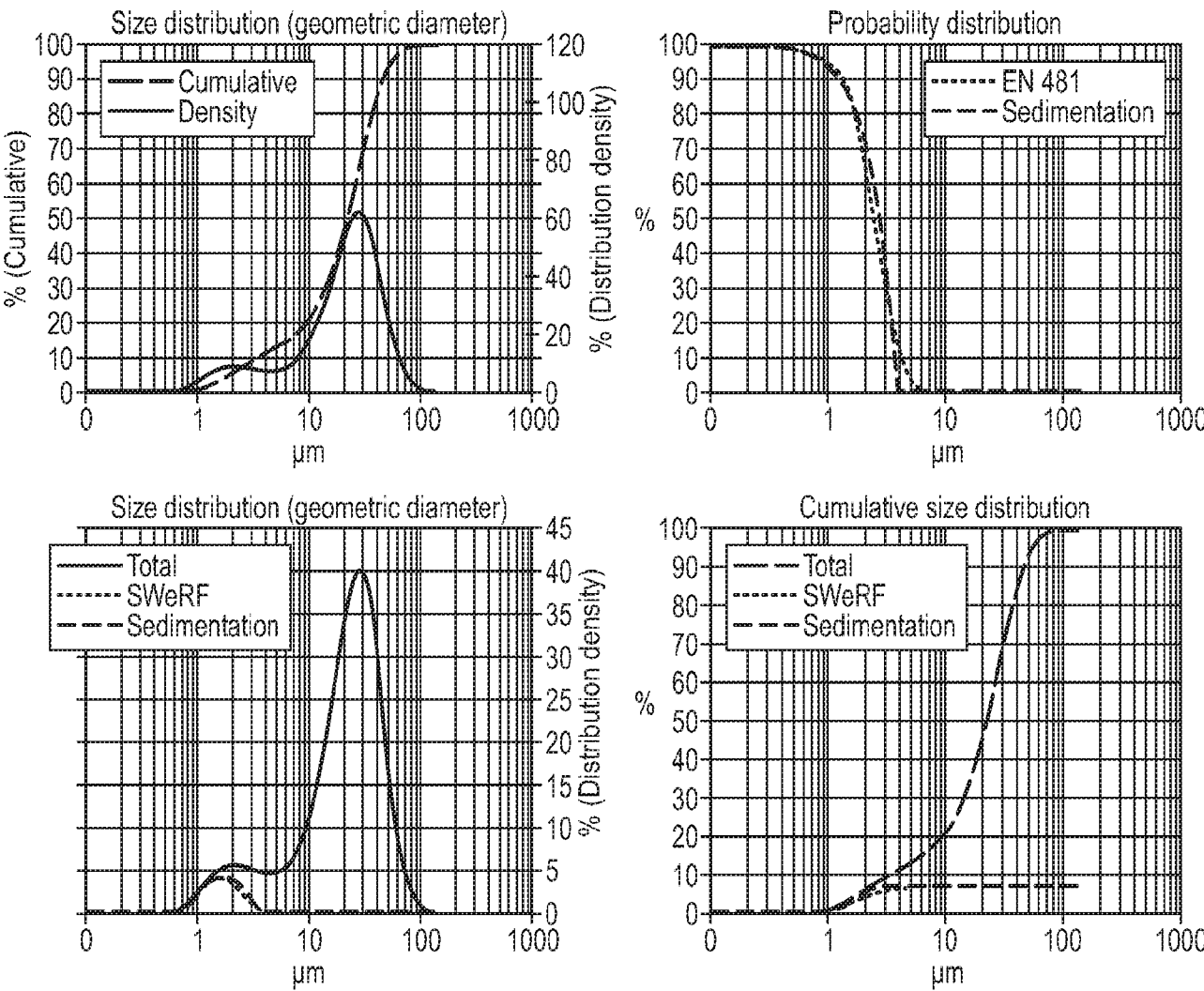
FIG. 10

2016-148 #3 70283-BP-LU

Date: 20/06/2016

carbonate
Pycnometer specific gravity 2.9645

Sample	Cryst. Silica cont. 0.7 %
Density = 2965 kg/m ³	CS Density = 2650 kg/m ³
SWeRF = 7.0 %	SWeRF _{CS} = 0.1 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The — — — curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

The — — — curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

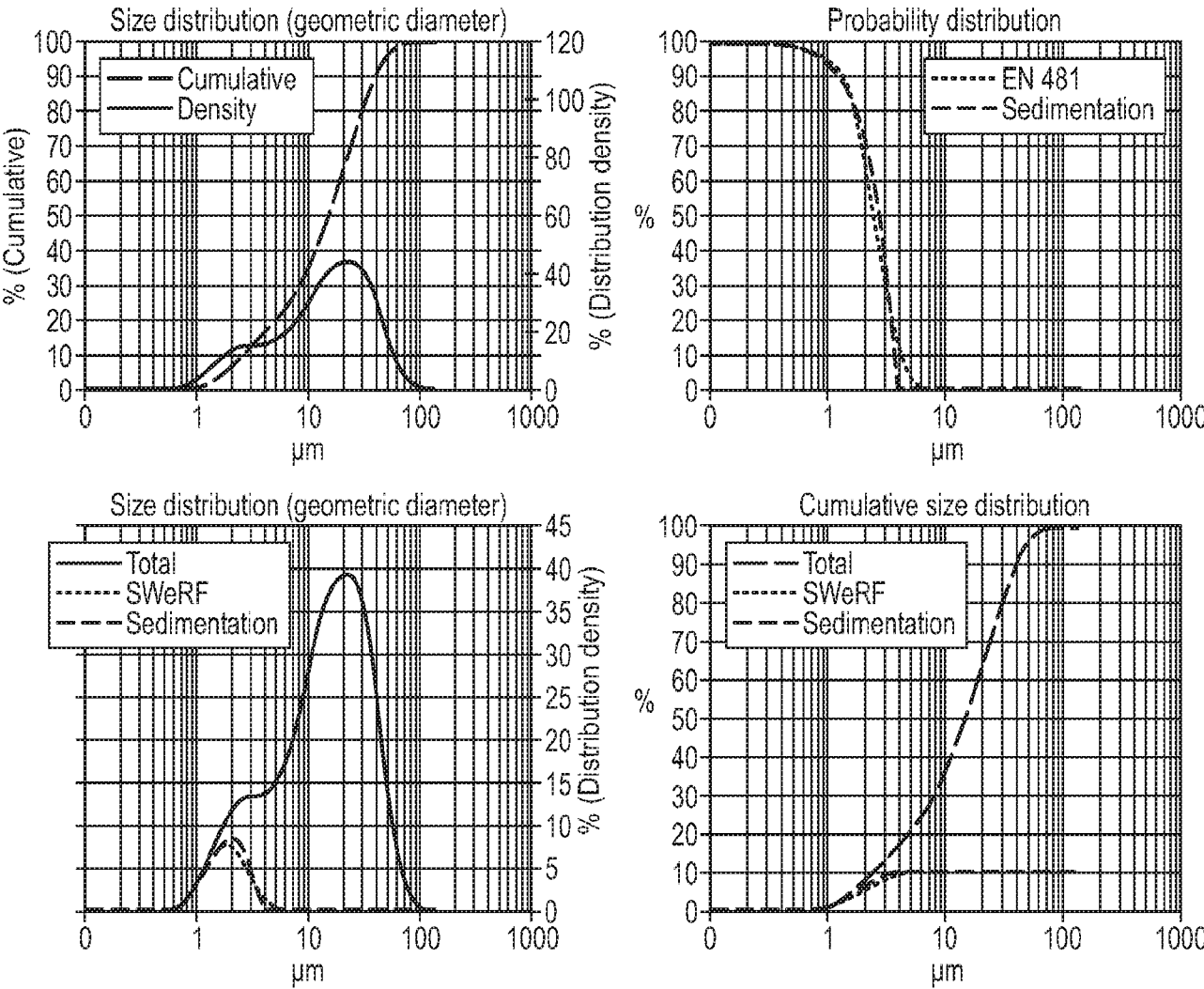
FIG. 11

2016-159 #1 62303-Microwhite 100

Date:
20/06/2016

carbonate
Pycnometer specific gravity 2.8545

Sample	Cryst. Silica cont. 1.3 %
Density = 2689 kg/m ³	CS Density = 2650 kg/m ³
SWeRF = 9.6 %	SWeRF _{CS} = 0.1 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The — — — curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

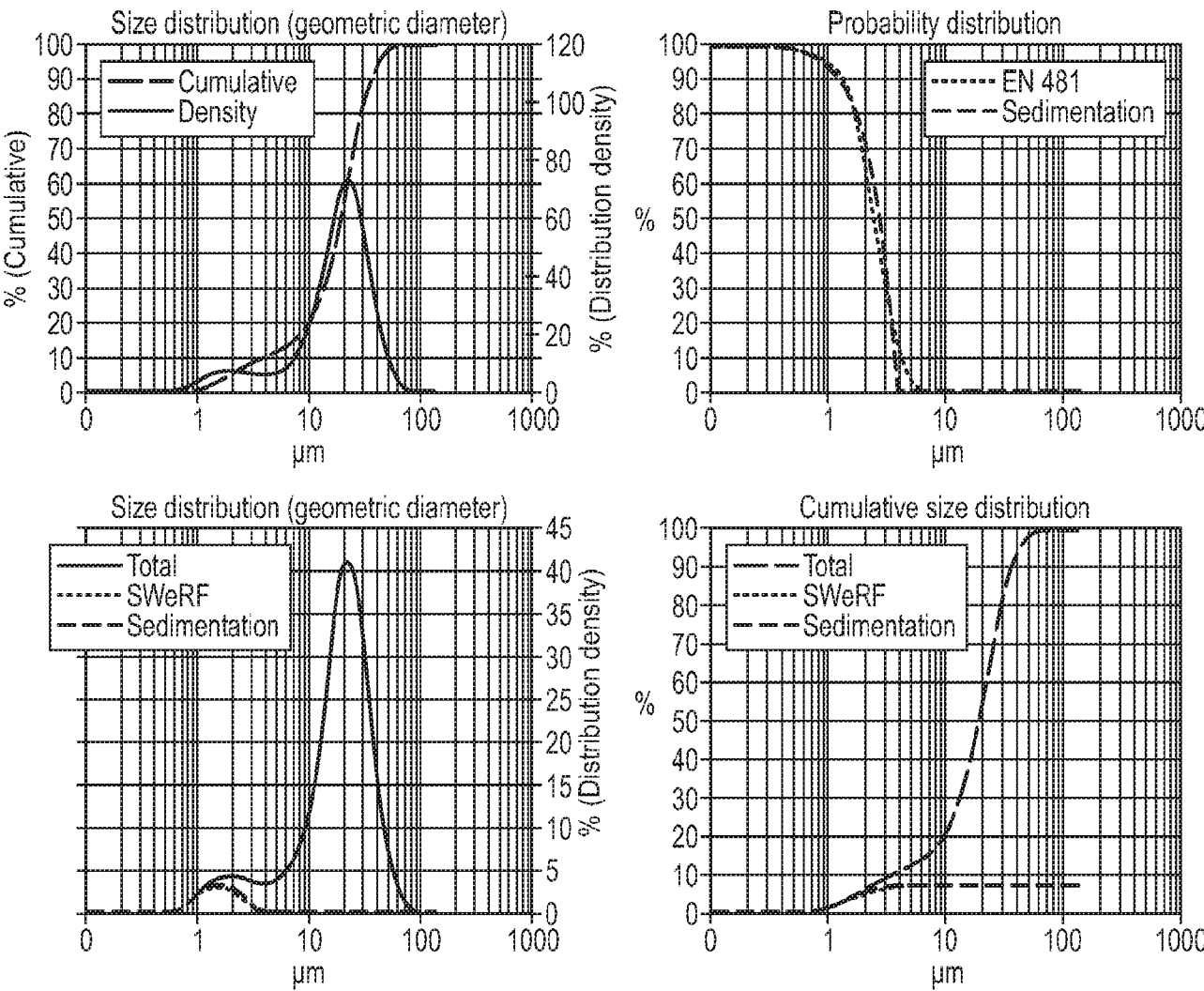
The — — — curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

FIG. 12

2016-159 #2 66342-Pulpro-20
carbonate
Pycnometer specific gravity 2.8412

Date: 20/06/2016

Sample	Cryst. Silica cont. 5.3 %
Density = 2841 kg/m ³	CS Density = 2650 kg/m ³
SWeRF = 6.7 %	SWeRF _{CS} = 0.4 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The — — — curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

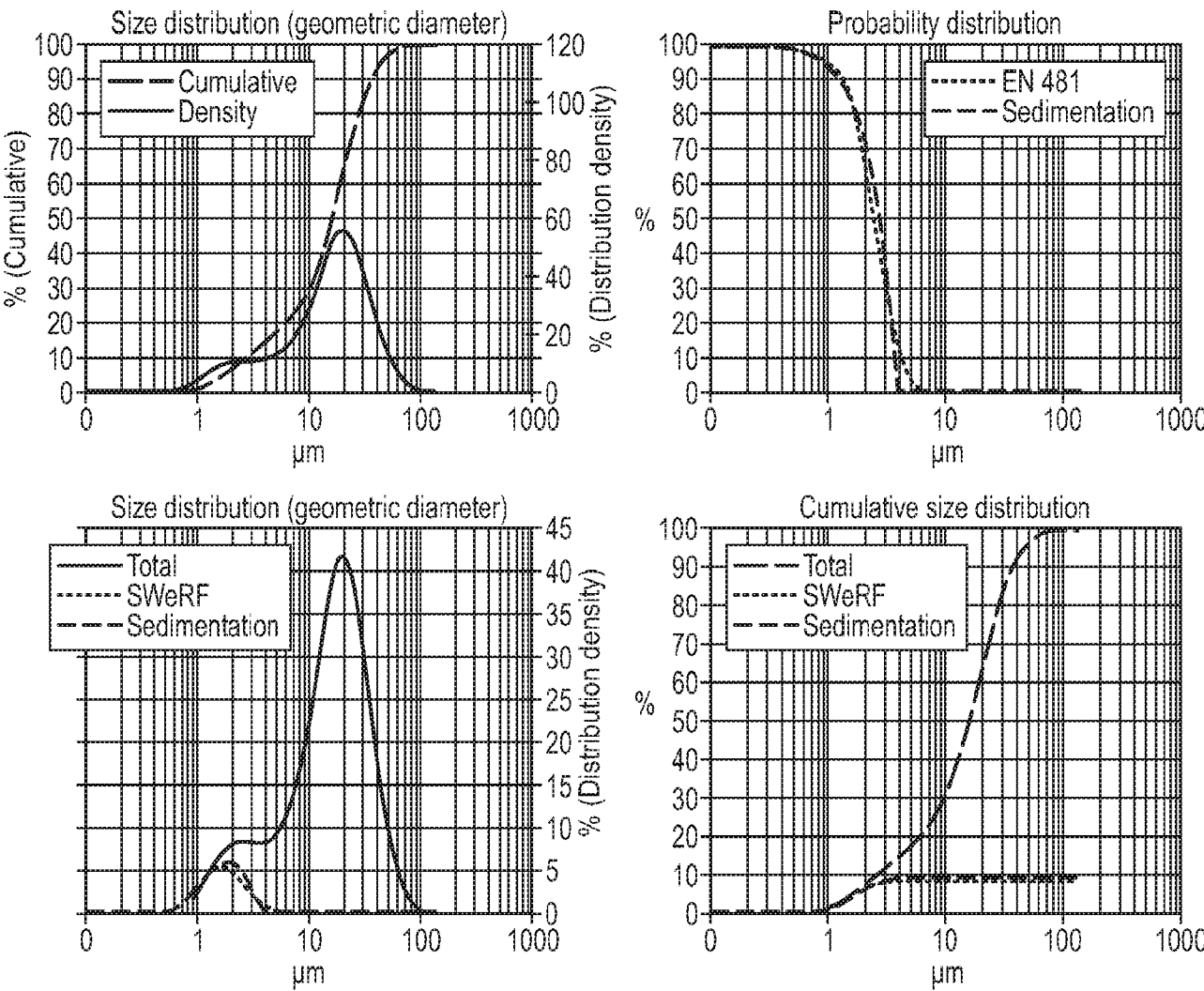
The — — — curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

FIG. 13

17/25

2016-159 #3 63305-Snowwhite 21 Date: 20/06/2016
carbonate
Pycnometer specific gravity 2.7759

Sample Cryst. Silica cont. 3.7 %
Density = 2776 kg/m³ CS Density = 2650 kg/m³
SWeRF = 8.7 % SWeRF_{CS} = 0.3 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The - - - - curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

The - - - - curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

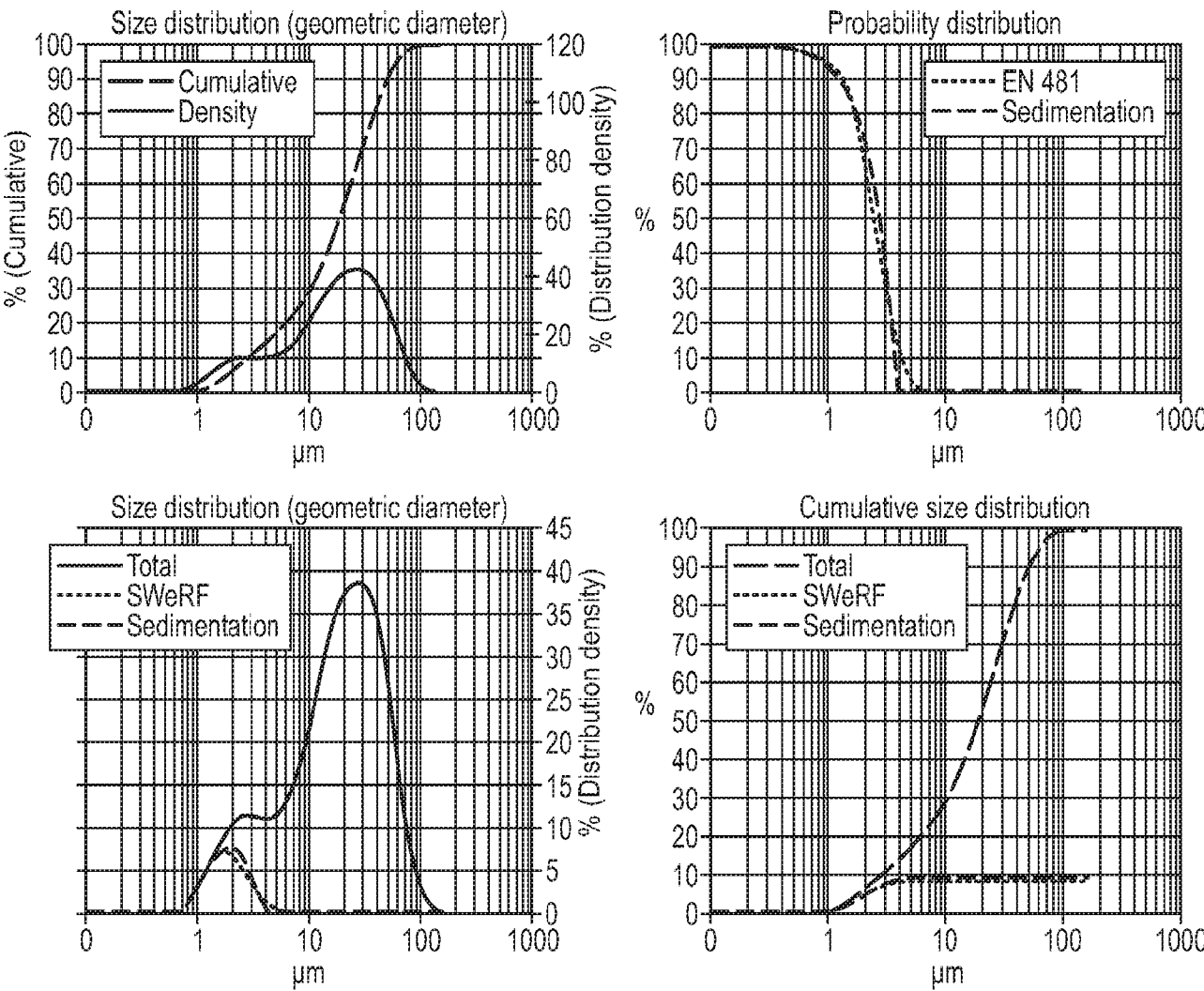
FIG. 14

2016-159 #4 70999 S-200

Date: 20/06/2016

carbonate
Pycnometer specific gravity 2.7778

Sample	Cryst. Silica cont. 0.2 %
Density = 2778 kg/m ³	CS Density = 2650 kg/m ³
SWeRF = 8.2 %	SWeRF _{CS} = 0.0 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The — — — curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

The — — — curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

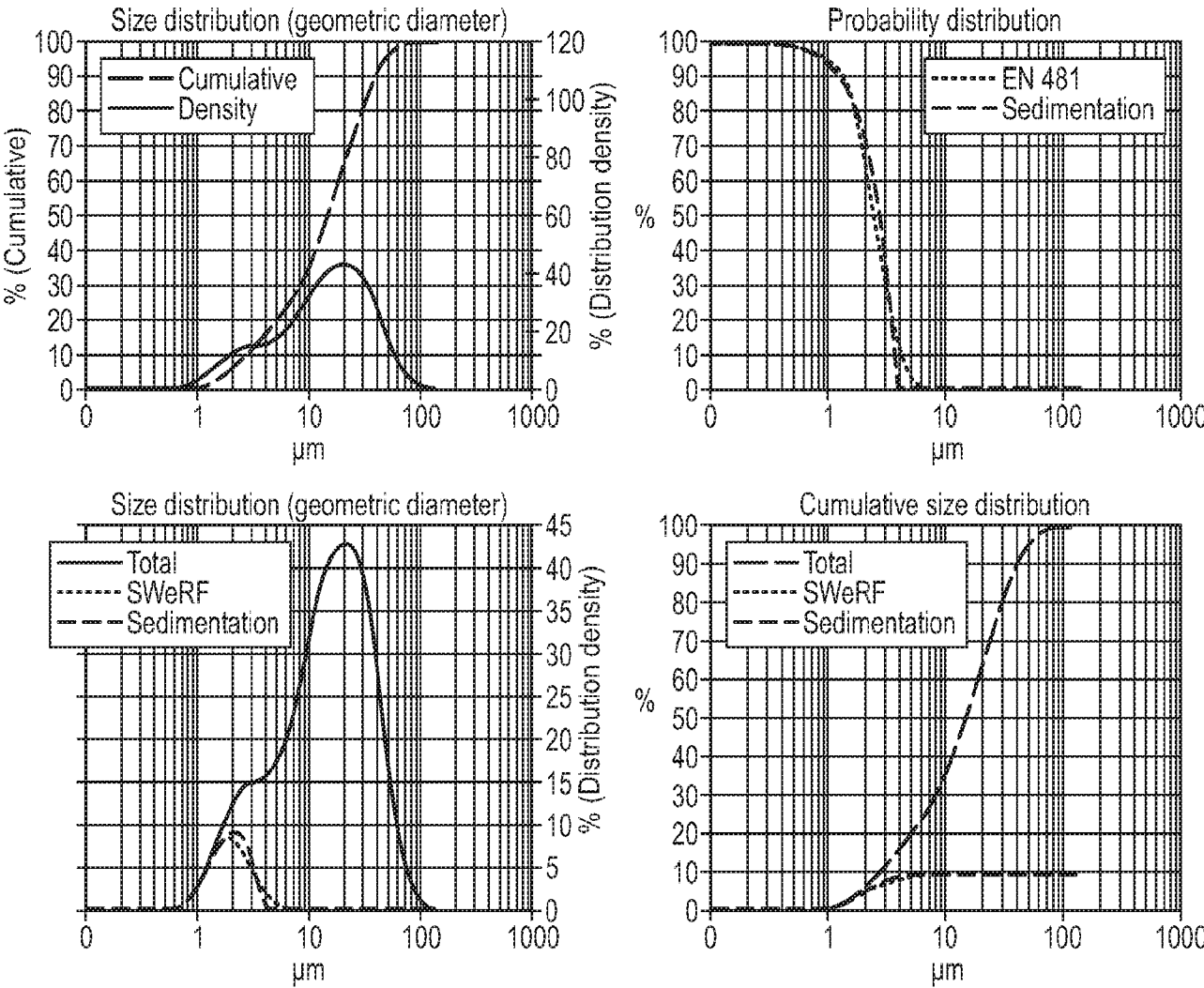
FIG. 15

19/25

2016-159 #5 60208-Microwhite-100-Marblehill
Date: 20/06/2016

carbonate
Pycnometer specific gravity 2.6686

Sample	Cryst. Silica cont. 0.3 %
Density = 2669 kg/m ³	CS Density = 2650 kg/m ³
SWeRF = 9.1 %	SWeRF _{CS} = 0.0 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The — — — curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

The — — — curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

FIG. 16

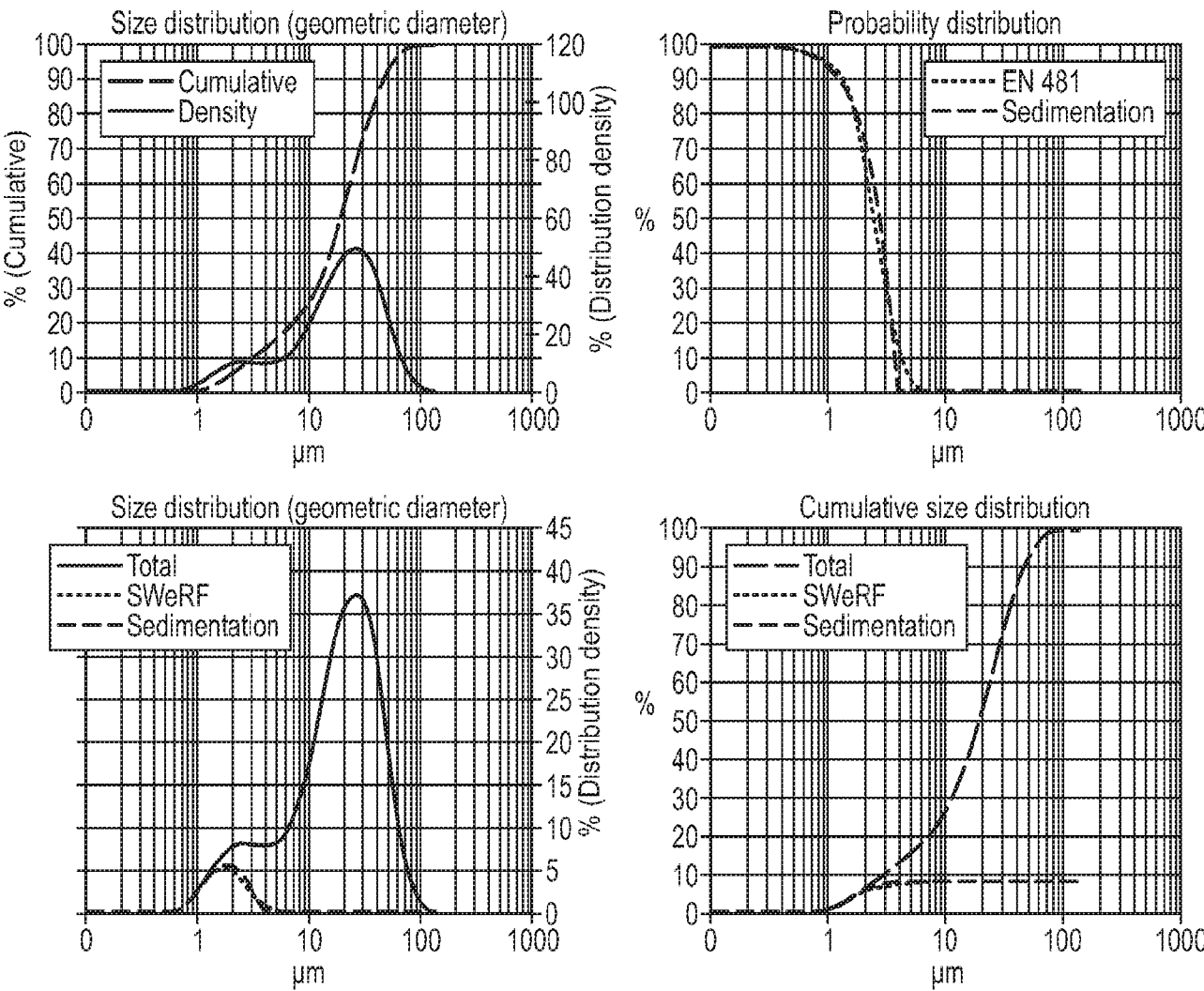
20/25

2016-182 #1 G260 RM 71778

Date: 20/06/2016

carbonate
Pycnometer specific gravity 2.7153

Sample	Cryst. Silica cont. 0.3 %
Density = 2715 kg/m ³	CS Density = 2650 kg/m ³
SWeRF = 7.8 %	SWeRF _{CS} = 0.0 %



The ——— curve (Total) represents the density distribution of all the particles of the sample.

The curve (SWeRF) represents the respirable fraction in the sample as calculated according to EN 481.

The — — — curve (Sedimentation) represents the distribution of the particles that remain in the supernatant after sedimentation.

The ——— curve (Total) represents the cumulative size distribution of the sample.

The curve (SWeRF) represents the cumulative (size weighted) amount of respirable particles in the sample.

The — — — curve (Sedimentation) represents the cumulative amount of the particles that remain in the supernatant after sedimentation.

FIG. 17

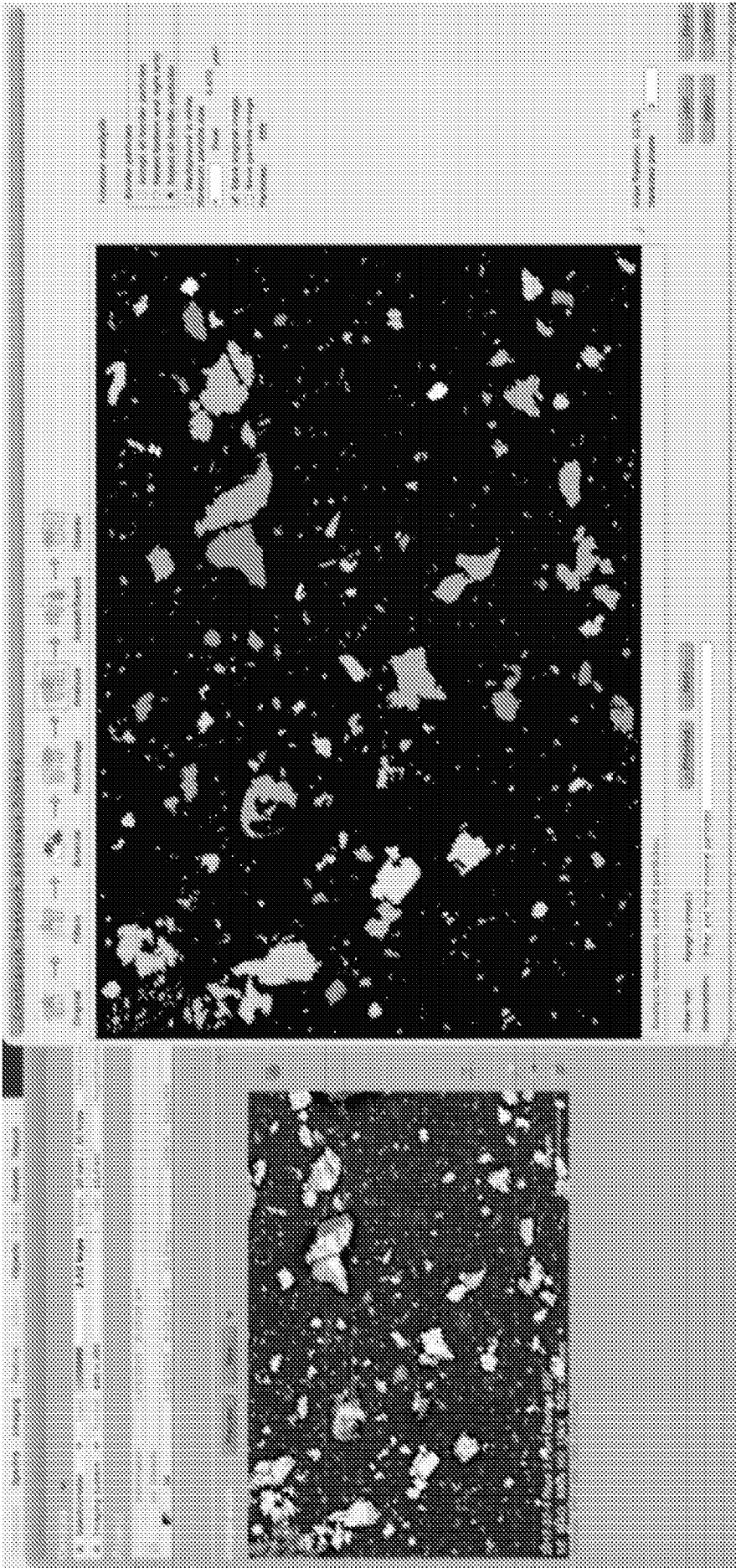
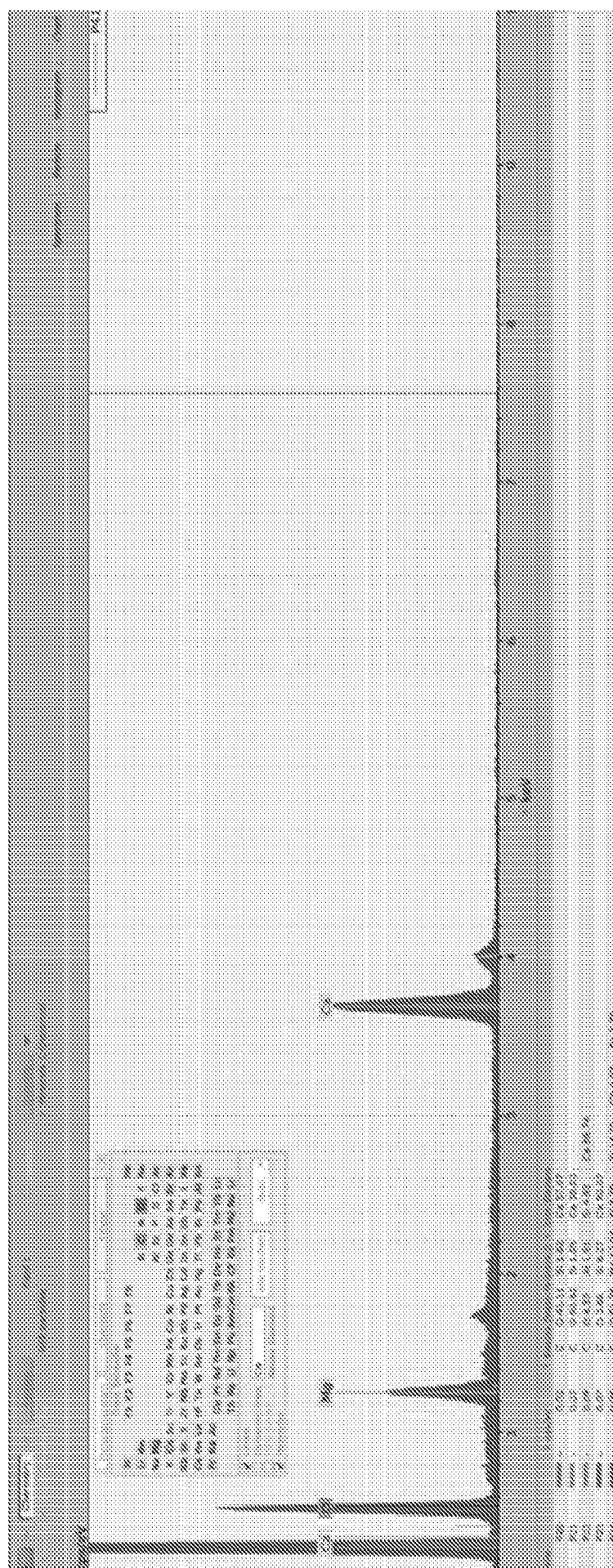


FIG. 18

FIG. 20



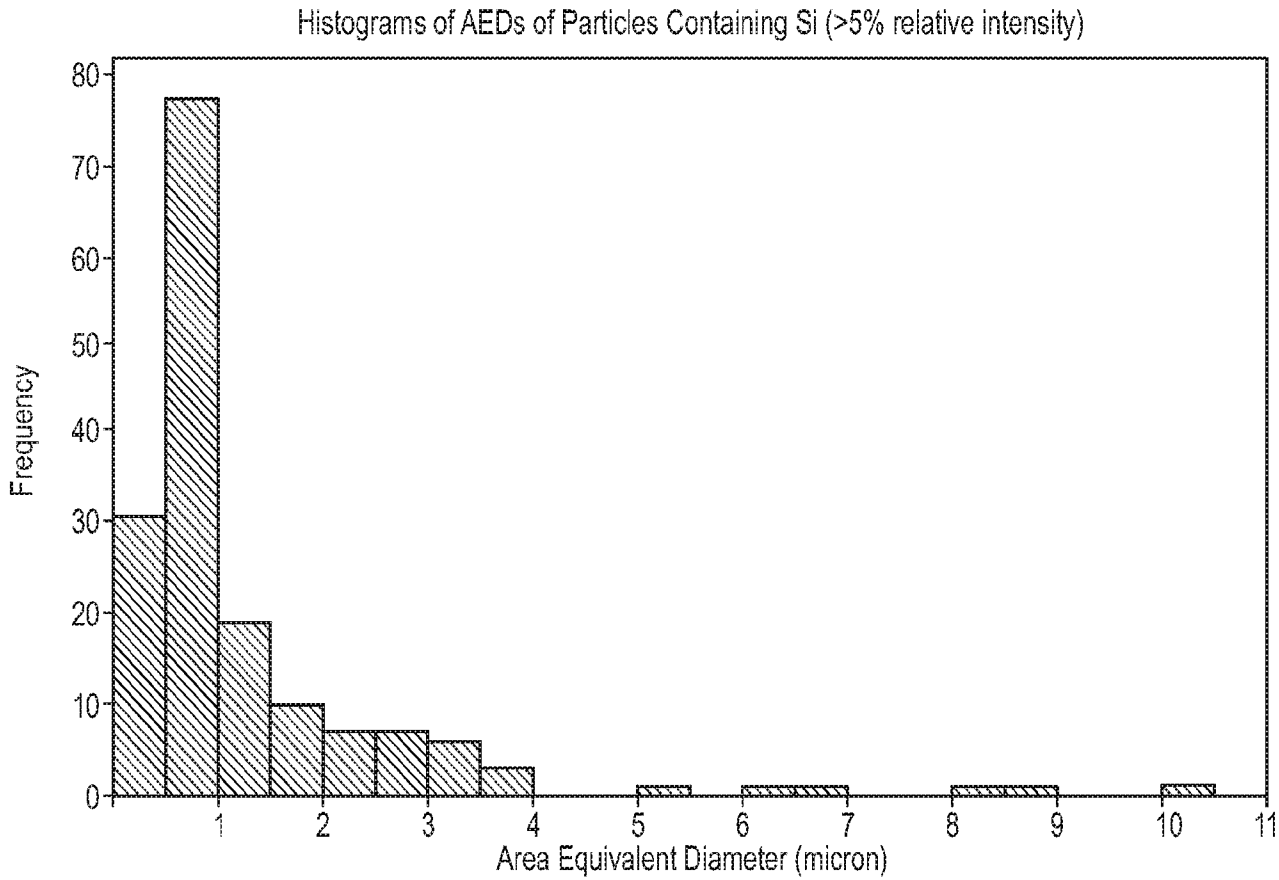


FIG. 21

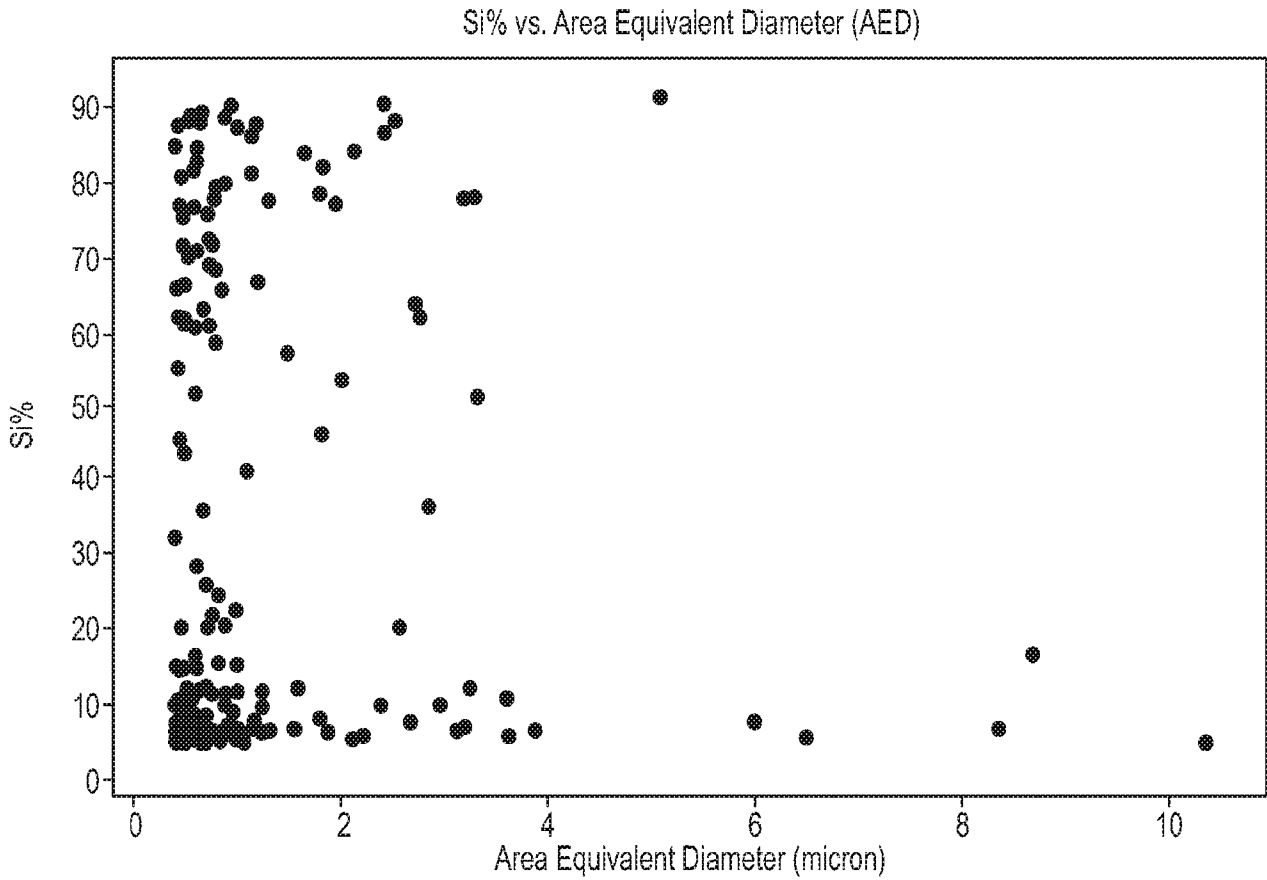


FIG. 22

INTERNATIONAL SEARCH REPORT

International application No

PCT/US2017/041613

A. CLASSIFICATION OF SUBJECT MATTER

INV. G01N15/14

ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

G01N

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	HUFFMAN GERALD P ET AL: "CCSEM investigation of respirable quartz in air samples collected during power plant maintenance activities", FUEL, vol. 95, 28 November 2011 (2011-11-28), pages 365-370, XP028889873, ISSN: 0016-2361, DOI: 10.1016/J.FUEL.2011.11.037 figures 2, 3a,3b, 4, 7-9 page 356, left-hand column, line 7 page 356, right-hand column, lines 15-17 p. 366, left column, point 2.2 CCSEM sample preparation p. 366, right column, point 2.4 CCSEM EDX analysis page 366, right-hand column, lines 24-26 page 368, left-hand column, lines 24-32 abstract -/--	1-10



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

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Date of the actual completion of the international search

25 September 2017

Date of mailing of the international search report

02/10/2017

Name and mailing address of the ISA/

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Dregely, Daniel

INTERNATIONAL SEARCH REPORT

International application No

PCT/US2017/041613

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	----- LE BLOND J S ET AL: "Production of potentially hazardous respirable silica airborne particulate from the burning of sugarcane", ATMOSPHERIC ENVIRONMENT, PERGAMON, GB, vol. 42, no. 22, 1 July 2008 (2008-07-01), pages 5558-5568, XP022833471, ISSN: 1352-2310, DOI: 10.1016/J.ATMOENV.2008.03.018 [retrieved on 2008-03-19] figures 3a,3b, 4,6-8 table 1 p.5562, left to right column bridging paragraph page 5566, right column, point 4.3 Composition of airborne particulate from sugarcane burning abstract	1,2,4-8, 10
X	----- HORWELL C J ET AL: "Characterization of respirable volcanic ash from the Soufrière Hills volcano, Montserrat, with implications for human health hazards", BULLETIN OF VOLCANOLOGY ; OFFICIAL JOURNAL OF THE INTERNATIONAL ASSOCIATION OF VOLCANOLOGY AND CHEMISTRY OF THE EARTH'S INTERIOR (IAVCEI), SPRINGER, BERLIN, DE, vol. 65, no. 5, 31 January 2003 (2003-01-31), pages 346-362, XP019941686, ISSN: 1432-0819, DOI: 10.1007/S00445-002-0266-6 figures 2, 3a,3b,4 tables 4,5 page 349, left-hand column, lines 34-58	1,2,4-8, 10
X	----- DE 10 2013 217157 A1 (SIEMENS HEALTHCARE DIAGNOSTICS [DE]) 5 March 2015 (2015-03-05) paragraph [0015] paragraph [0023] paragraphs [0038] - [0047]	1,8
X	----- US 2015/219547 A1 (TAKAKURA MASARU [JP]) 6 August 2015 (2015-08-06) paragraphs [0032] - [0033] paragraph [0045] paragraph [0060] -----	1,2,5,8

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2017/041613

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		WO 2015028365 A1	05-03-2015

US 2015219547 A1	06-08-2015	JP 2015148499 A	20-08-2015
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