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(21) International Application Number: PCT/US92/03251 (22) International Filing Date: 20 April 1992 (20.04.92) (30) Priority data: 695,188 3 May 1991 (03.05.91) US (71) Applicant: ASHLAND OIL, INC. [US/US]; P.O. Box 391, BL2, Ashland, KY 41114 (US). (72) Inventor: HETTINGER, William, P., Jr. ; 203 Meadowlark Road, Russel, KY 41169 (US). (74) Agents: WILLSON, Richard, C., Jr.; P.O. Box 391, BL2, Ashland, KY 41114 (US) et al.		(81) Designated States: AT, AT (European patent), AU, BB, BE (European patent), BF (OAPI patent), BG, BJ (OAPI patent), BR, CA, CF (OAPI patent), CG (OAPI patent), CH, CH (European patent), CI (OAPI patent), CM (OAPI patent), CS, DE, DE (European patent), DK, DK (European patent), ES, ES (European patent), FI, FR (European patent), GA (OAPI patent), GB, GB (European patent), GN (OAPI patent), GR (European patent), HU, IT (European patent), JP, KP, KR, LK, LU, LU (European patent), MC (European patent), MG, ML (OAPI patent), MN, MR (OAPI patent), MW, NL, NL (European patent), NO, PL, RO, RU, SD, SE, SE (European patent), SN (OAPI patent), TD (OAPI patent), TG (OAPI patent). Published <i>Without international search report and to be republished upon receipt of that report.</i>
(54) Title: COMBINATION MAGNETIC SEPARATION, CLASSIFICATION AND ATTRITION PROCESS FOR REFINING AND RECOVERING PARTICULATES (57) Abstract Optimized utilization of combinations of fluid catalyst magnetic separator, classifier, and/or attriter can be used to achieve lower catalyst cost, and better catalyst activity and selectivity through control of metal-on-catalyst, particle size and particle size distribution. This process is especially useful when processing high metal-containing feedstocks. This provides a catalyst recovery unit (RCUTM) ancillary to an FCC or similar unit.		

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COMBINATION MAGNETIC SEPARATION, CLASSIFICATION
AND ATTRITION PROCESS FOR RENEWING
AND RECOVERING PARTICULATES

Background of Invention

I. Field of the Invention

The present invention relates to the field of separation of catalysts and sorbents, generally classified in U.S. Patent Class 208, subclass 120.

In conventional fluid bed cracking of hydrocarbon feedstocks, it is the practice, because of the rapid loss in catalyst activity and selectivity, to add fresh catalyst continuously or periodically, usually daily, to an equilibrium mixture of catalyst particles circulating in the system. If metals, such as nickel and vanadium, are present in the feedstock, they accumulate almost completely on the catalyst, thus drastically reducing its activity, producing more undesirable coke and hydrogen, and reducing selective conversion to gasoline. In such cases, catalyst replacement additions may have to rise significantly.

Fluid cracking catalysts generally consist of small microspherical particles varying in size from 10 to 150 microns and represent a highly dispersed mixture of catalyst particles, some present in the unit for as little as one day, others there for as long as 60-90 days or more. Because these particles are so small, no process has been available to remove old catalysts from new. Therefore, it is customary to withdraw 1 to 10% or more of the equilibrium catalyst containing all of these variously aged particles, just prior to addition of fresh catalyst particles, thus providing room for the incoming fresh "makeup" catalyst. Unfortunately, the equilibrium catalyst withdrawn itself contains, 1-10% of the catalyst added 2 days ago, 1-10% of the catalyst added 3 days ago, and so forth. Therefore, unfortunately a large proportion of the withdrawn

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2 catalyst represents very active catalyst, which is
3 wasted.
4

5 Catalyst consumption can be high. The cost
6 associated therewith, especially when high nickel and
7 vanadium are present in any amount greater than, for
8 example, 0.1 ppm in the feedstock can, therefore, be
9 great. Depending on the level of metal content in feed
10 and desired catalyst activity, tons of catalyst must be
11 added daily. For example, the cost of a ton of catalyst
12 at the point of introduction to the unit can be \$2,000
13 or more. As a result, a unit consuming 20 tons/day of
14 "makeup" catalyst would require expenditures each day of
15 \$40,000. For a unit processing 40,000 barrels/day (B/D)
16 this would represent a processing cost of \$1/B or 2.5
17 cents/gallon, for makeup catalyst cost alone.
18

19 In addition to "makeup" catalyst costs, an aged
20 high nickel and vanadium-laden catalyst can also reduce
21 yield of preferred liquid fuel products, such as
22 gasoline and diesel fuel, and instead, produce more
23 undesirable, less valuable products, such as dry gas and
24 coke. Nickel and vanadium on catalyst also accelerate
25 catalyst deactivation, thus further reducing operating
26 profits, and reducing throughput capacity of the
27 conversion unit.
28

29 II. Description of the Prior Art

30 Patents related to processing metal-laden catalyst
31 feedstocks and involving magnetic separation,
32 classification and attrition include U.S. 4,359,379 and
33 U.S. 4,482,450 to Ushio.
34

35 "Magnetic Methods For The Treatment of Materials"
36 by J. Svovoda published by Elsevier Science Publishing
37 Company, Inc., New York (ISBN0-44-42811-9) Volume 8)
38 discloses both theoretical equations describing
39 separation by means of magnetic forces with the
40 corresponding types of equipment that may be so

employed. Specific reference at pages 135-137 is made to cross-belt magnetic separators and pages 144-149 refer to belt magnetic separators involving a permanent magnet roll separator, as well as pages 161-197 which refer to high gradient magnetic separators, all of which are efficient in separating magnetic particles. Svovoda teaches a number of magnetic separation techniques useful with this invention, including the preferred RERMS, HGMS and the drum-roller device.

Magnetic separation of catalyst is covered in U.S. patent 4,406,773 (1983) of W. P. Hettinger et.al, which prefers use of a high gradient magnetic field separator (HGMS) or a carrousel magnetic separator which uses multiple HGMS units to achieve selective separation.

Related Applications

Pending application USSN 07/332,079 (attorney docket 6324AUS) covers the concept of using a preferred device for magnetic separation.

USSN 601,965, (Attorney docket 6375AUS), covers the discovery of specie which, when present in aged equilibrium catalyst, further improves separation due to its very high magnetic susceptibility.

Pending application USSN 07/479,003 (Attorney docket 6345AUS) covers the concept of a "Magnetic Hook"TM.

Another preferred material also makes an additive as per USSN 602,455, filed October 19, 1990 (Attorney docket 6369AUS).

It has been discovered that another family of additives all of which have very high magnetic properties can also be added as "Magnetic Hooks"TM per USSN 332,079, filed April 3, 1989 (Attorney docket 6324AUS).

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contaminated by use with metal-laden feedstocks, reducing cost and enhancing hydrocarbon conversion.

The invention provides a new refinery unit ancillary to a hydrocarbon conversion (cracking, sorbent, etc.) unit. Like economizers, waste heat boilers, etc., this new "catalyst recovery unit" reduces costs and also pollutants.

This invention results from a number of observations on the undesirable properties of equilibrium catalyst and provides means by which to correct these properties.

Because catalyst ages with time in the hydrocarbon process, fresh catalyst must typically be added each day to maintain operating performance. But because of an inability to separate old catalyst from new, new catalyst is undesirably removed with the older catalyst.

The preferred Rare Earth Roller Magnetic Separator (RERMS), also has been discovered to have a particle size separation capability, which capability has now been combined with other processes and innovations to provide this invention, a new way of recovering and rejuvenating spent or equilibrium cracking catalyst or sorbent. A rare earth drum roll separator may also be employed here, although it is not as effective in achieving separation due to less efficient centrifugal forces being manifested.

One of the unusual and surprising findings of this particle size separation effect is that to some extent, metal deposition, especially iron, and the related magnetic susceptibility is also inversely related to particle size and is contributing to this somewhat contradictory observation.

Following is an non-limiting theoretical explanation of how this probably comes about.

Assume metal deposition from a feedstock is dependent only on the exposed outer surface of all catalyst particles and the accumulation of metal on a given particle after a given time is proportional to surface only and not the weight. Because a small particle has a greater surface to volume than a large particle, and because the number of small particles per given weight of catalyst is larger; it is possible to estimate the relative amount of metal to be found on catalyst particles of varying size.

Figure 4 shows the rate of buildup of metal as a function of time per unit of mass and particles of diameter D_1 , compared with D_2 where $D_2=2D_1$. The rate of buildup would be 1/2 as rapid. (Note also Example 2.)

Figure 2 shows the rate of metal buildup on catalyst per unit of time for the above particles as discussed.

For example, if after time t_1 , a 40 micron diameter particle has 5,000 ppm of metal on it, an 80 micron particle would only have 2,500 ppm of metal on it, and a 120 micron particle 1,666 ppm.

Because metal content is proportional to t , feed rate & metal content being constant, in 1/2, the 40 micron particle will have 10,000 ppm of metal, the 80 micron particle 5,000 ppm of metal, and the 120 micron particle 3,300 ppm. See Figure 3.

As a result, it will take three times as long for a 120 micron particle to buildup to the same metal level as a 40 micron particle, or 1 1/2 times as long for a 120 micron particle as a 80 micron particle.

II. Utility of the Invention

The present invention, preferably without need for recycle for high voltages, dangerous effluents or chemicals, can recover for recycle catalyst worth many times investment costs, which is conventionally wasted, e.g. in FCC and RCC® process hydrocarbon conversion processes.

Brief Description of the Drawings

Figure 1 shows schematically the preferred apparatus of the invention comprising magnetic separation means 20, size classification means 40, and attrition means 60 with feed 10 of catalyst or sorbent from a hydrocarbon conversion unit, and dump 56 of fines to waste and recovery and 58 high metal to waste, and recycle 76 back to the hydrocarbon conversion unit with intermediate recycles 32, 74, 54, 24 and 52, 72 between the components of the invention. These recycles may be optimized for maximum conversion of optimum catalyst.

Figure 1' shows the apparatus of Figure 1 in place in a conventional hydrocarbon conversion unit receiving residual feed 5 into riser 100 where it is cracked and recovered in product recovery unit 120 outputting products 122 for further separation and processing, and outputting coked metal-laden catalyst 130 to regenerator 140 where coke is burned off with input air 142, and regenerated catalyst 150 is outputted, principally for return to riser 100. A portion of the equilibrium regenerated catalyst 10 is removed (periodically or continuously) and fresh makeup catalyst 15 is added to supplement recycled catalyst 76 from the catalyst recovery unit.

Figure 2 is a plot of the ratio of magnetic susceptibility, x , and particle size (diameter), D and shows that magnetic susceptibility decreases by 50% as particle size doubles.

Figure 3 shows metal-on-catalyst at three different intervals of time t versus particle diameter in microns.

Figure 4 shows increase in magnetic susceptibility versus time for a smaller and a larger particle, confirming Figure 3.

Figure 5 shows schematically a flow sheet for various particles moving through a series of magnetic separation and classification steps. These steps may be accomplished by multiple magnetic separators and/or classifiers in cascade or similar arrangement, or may represent internal recycles repeatedly back through a single magnetic separator or classifier. The end result is to provide particles beneficiated in metals for metals recovery or for discarding to suitable solid waste landfill, or other disposal, plus valuable optimum size, lower-metal content catalyst for recycle to the hydrocarbon conversion unit.

Figure 6 is a plot of average particle size in microns versus percent magnetic for three separation techniques: sieve separation; magnetic separation with most magnetic off first; and, less desirably, magnetic separation with low magnetic off first.

Figure 7 plots metal-on-catalyst, ppm metal versus percent magnetic for iron, vanadium, and nickel, respectively, and shows separate curves for sieve separation and for magnetic separation (RERMS).

Figure 8 shows, for the same sample as in Figures 6-13, magnetic susceptibility (EMU/gm) versus percent magnetic, and compares sieve separation with magnetic separation-high mag off first and magnetic separation-low mag off first.

Figure 9 shows for the same sample (preferred high mag off first), seven fractions from the RERMS versus their MAT conversion (volume %).

Figure 10 is a plot for the same sample of magnetic susceptibility for fractions separated by RERMS plotting magnetic susceptibility versus MAT conversion, and comparing dramatically the higher MAT achieved in the earlier fractions (lower magnetic susceptibility fractions) by using the high mag off first technique, which is preferred for the invention.

Figure 11 plots for the same sample, but separated by high gradient magnetic separator (HGMS), MAT conversion versus percent magnetic for five fractions and demonstrates that the most magnetic 20% is 11 points lower in MAT than is the least magnetic, so that discarding the most magnetic fraction (20%) can sharply increase the average activity of the remaining catalyst recycled to the conversion unit.

Figure 12 plots percent magnetic versus particle size (microns), and compares high gradient magnetic separation (relatively insensitive to particle size) with rare earth roller magnetic separation (RERMS) which is dramatically capable of separating particles by particle diameter.

Figure 13 is a plot of percent magnetic versus MAT (volume % conversion) and demonstrates dramatically the advantage of RERMS magnetic separation as compared to separation by sieve. Note that dropping off the most magnetic 35% of the catalyst will sharply increase the average MAT of the remainder recycled to the hydrocarbon conversion unit, whereas dropping the last 35% of the sieve separated catalyst will not.

Figure 14 is a plot from Zenn and Othmer, Fluidization and Fluid Particle Systems, Reinhold

1
2 Chemical Engineering Services (1966), page 251 showing
3 the particle size analysis of a typical FCC catalyst in
4 inches diameter and microns diameter versus cumulative
5 percent under.
6

7 Figure 15 is a schematic diagram of the preferred
8 alpine Turboplex ATP200 for use with the invention.
9 Additional literature and details are available from the
10 manufacturer.
11

12 Figure 16 is a schematic diagram of a metal-laden
13 equilibrium cracking catalyst particle before grinding
14 and after grinding which removes a substantial portion
15 of the metal coating as fines for disposal. These fines
16 may be separated in the classifier or magnetic
17 separation device.
18

19 Figure 17 is a computer aided evaluation of resid
20 cracking process performance based on daily data over a
21 period from 1984 through 1990, plotting the best
22 straight line (by computer-aided evaluation) of gasoline
23 selectivity (volume %) versus average particle size in
24 microns for the catalyst used in a resid cracking unit,
25 and demonstrating that gasoline selectivity drops from
26 74.8 at 76 microns to 71.4% at 90 microns average
27 particle size, a loss of 3.4 volume % gasoline.
28

29 Figure 18 is a plot obtained on a high resolution
30 energy dispersion x-ray instrument showing the high Fe
31 concentration on the outer peripheral surface of the
32 particle and the relatively uniform V concentration
33 across the particle, confirming that iron, as well as
34 nickel remain on the outside of the particle as shown in
35 Figure 16.
36

37 Figure 19 is a relatively detailed schematic
38 showing a complete grinding plant with compressed air
39 supply and embodying the Model AFG-100 Fine Grind Jet
40 Mill also manufactured by Alpine, which is a most

1
2 preferred attrition means for use with the present
3 invention because it tends to grind off the outer edge
4 or surface of the particle as shown in Figure 16 rather
5 than shattering the individual particles. Since, as
6 shown in Figure 18, metal is, to a large degree,
7 concentrated on the surface, removing the surface tends
8 to reduce the metal content without shattering the
9 catalyst particle into undesirable fines. Fluid energy
10 mills are particularly preferred attriters.
11

12 Description of the Preferred Embodiments

13 The invention will be understood by reference to
14 the following illustrative Examples:
15

16 Example 2A

17 (Effect of Particle Size on Metal Build-up
18 and Magnetic Susceptibility Xi)
19

20 Cuts of commercial catalysts are taken at 75
21 microns, 105 microns, and 150 microns, and assuming
22 equal time in the unit, and the midway point as
23 representative, i.e. 38 microns, 90 micron and 127
24 microns, then the metal content of the 90 micron
25 particle will be $38/90$ or 40% of the 38 micron particle.
26 A quick check of the RCC catalyst will be $38/90 = 40\%$,
27 and for the 127 micron particle, 30% of the value for
28 the 0-75 micron (38) cut. If we assume magnetic
29 susceptibility is proportional to metal content, then it
30 appears in the same ratio as metal content, namely, 100%
31 40%, and 30% respectively of the 38 micron particle.
32

33 To obtain support for this analysis, resid-cracking
34 catalyst from Catlettsburg and FCC catalyst from Canton
35 are separated into three fractions (simulating
36 classifier 40) by screening with 150 and 200 mesh
37 screens to give a 0-75 micron cut, a 75 to 104 micron
38 cut, and a 104 to 150 micron cut.
39
40

11

Table 1 shows the results on Catlettsburg resid-cracking sample. 900108

TABLE 1

Fraction	%	Xg X 10 ⁻⁶ emu/gm	% of Mag Susp.		Second Predicted Part.Size
			Actual	Predicted	
0-74 microns	54	33	100	100	100
75-104 microns	32	22	67	50	63
Greater than 105 microns	14	17	50	33	48

Table II shows the results on Canton sample 900115

TABLE 2

Fraction	%	Xg X 10 ⁻⁶ emu/gm	% of Mag Susp.		Second Predicted Part.Size
			Actual	Predicted	
0-74 microns	53	43	100	100	100
75-104 microns	37	30	70	50	63
Greater than 105 microns	10	23	53	33	48

In view of the assumptions regarding average particle size, the distribution of magnetic susceptibility is strikingly close to predicted. If it is assumed that the 0-75 micron fraction is mainly 40-75 microns, and the midpoint 57, then the second column gives the predicted values, and the values approach theoretical. With this confirmation of the effect of particle size on metal pickup, as related to magnetic susceptibility, we can now begin to devise a more sophisticated process for metals control through

1
2 magnetic separation, particle size separation, and
3 particle size reduction.
4

5 The above data shows that metal level on a catalyst
6 is in fact related to particle size, and therefore,
7 metal reduction may also be achieved by classification.
8 However, although coarse particles are, therefore,
9 expected to gain much less metal as a function of time,
10 and if metal content determines when a particle will
11 have sufficient magnetic properties to be removed, it is
12 apparent that large particles will be much older for the
13 same metal content. It is also known and demonstrated
14 by Zenn and Othmer, Fluidization and Fluid Particle
15 Systems, Reinhold Chemical Engineering Services, 1966,
16 that optimum particle size for fluid bed catalytic
17 cracking resides in the 40-80 micron range. If coarser
18 particles tend to preferentially remain, poorer
19 fluidization begins to appear, and a need arises to
20 control this increase in particle size. Also, in view
21 of environmental concerns related to particulate
22 emissions from catalytic cracking, catalyst
23 manufacturers have attempted to reduce this problem by
24 producing coarser catalyst, thus also causing an
25 increase in average particle size, which adds to this
26 problem of ever increasing particle size growth in an
27 operating unit, especially when running on metal-laden
28 feedstock, and especially when utilizing magnetic
29 separation.
30

31 Today's catalyst is also designed to resist
32 attrition which produces particulate fines, and this
33 also contributes to accumulation of coarse catalyst.
34

35 Another factor is the accessibility of the catalyst
36 to the oil and during the short contact times of today's
37 riser progressive flow reactor, where contact times
38 between oil and catalyst are as low as one second or
39 less. For a given catalyst to oil weight ratio within
40 the usual 4-10 or more range, a catalyst of a given

diameter has three times as much outer peripheral surface area, and 27 times as many particles per ton as compared with a catalyst particle having three times that diameter. For example, a 50 micron particle has two times as much outer exposed entrance surface area and eight times as many particles per ton as compared with a 100 micron particle. Obviously, the opportunity for catalytic action is much greater for the small particle, especially when much of the feedstock boils above the temperature of the incoming catalyst, and must flow as a liquid into an internal catalytic site. Example #5 demonstrates the particle size effect on selectivity.

With regard to metal deposition of nickel, vanadium, and iron, it is well known that under regenerator conditions, unless care is taken to keep vanadium in a plus 4 or plus 3 valence as described in our U.S. patent 4,377,470 (Attorney docket 6117BUS), it tends to migrate as V_2O_5 throughout the catalyst particles, destroying valuable molecular sieve as it proceeds. However, our studies by means of Energy Dispersive X-ray Fluorescence as described in Example 5 and Figure 18 show that iron is clearly deposited on the outer rim of the catalyst particle.

The present invention is a new three-legged (triangle) process which selectively removes very fine particles, high in metals and low in catalyst performance, by classification and/or magnetic separation, and to separate coarse catalyst also by either magnetic separation or classification or both and grinds coarse catalyst to reduce particle size while at the same time thus selectively removes iron and nickel from the outer shell.

Example 1
(The Invention)

1
2 Referring to Figure 1, high metal equilibrium
3 catalyst 10 is introduced in either continuous or batch
4 manner to the process. In one example, not necessarily
5 limiting, catalyst is sent to a magnetic separator 20
6 where a high-magnetic cut is taken and discarded or sent
7 for chemical reclamation or reactivation 58. This
8 fraction can be anywhere between 1 and 30% by weight or
9 more. A second cut 76 representing a major portion of
10 the catalyst, now higher in activity and lower in metals
11 than equilibrium catalyst, perhaps as low as 20% and as
12 high as 95%, is returned to the unit via 76 or passed
13 through classifier 40 and returned to the unit via 76.
14 Coarse catalyst containing catalyst greater than 104
15 microns (150 mesh sieve) amounting to 1-20% or more, is
16 sent via 24 to the classifier 40 for enrichment of the
17 coarse fraction. The collected fines can also be
18 returned to the unit or discarded via 56. The coarse
19 fraction 52 from classification is then sent to the
20 attrition unit 60 which reduces it in size, removes the
21 outer shell of metal, and the finished product also
22 returns to the unit. For catalyst with high loadings of
23 fines, the process can be reversed, with equilibrium
24 catalyst going to the classifier 40 to remove fines and
25 on through 54 to the magnetic separator, where the above
26 process is repeated. A catalyst very high in a coarse
27 fraction, can be sent to the classifier 40 first with
28 coarse catalyst being sent via 52 to the attriter 60 and
29 the second fraction 54 being sent on to magnetic
30 separation. Where extremely coarse catalyst is
31 encountered, or where equilibrium catalyst is purchased
32 to add to virgin catalyst, and if this catalyst is very
33 coarse, it can be sent to the attriter 60 first. Figure
34 5 shows several possible flow schemes.
35

36 This invention now provides a new process which
37 allows a refiner many options in his objective of
38 minimizing catalyst cost while optimizing catalyst size,
39 activity and selectivity. By judicious use of this
40 combination process which can operate either in batch or

1
2 continuous operation, the refiner is in a position to
3 minimize catalyst cost, control metal and catalyst
4 particle size all at the same time and very
5 inexpensively.
6

7 Example 2B

8 (Coarse Particle Size Removal by 9 Magnetic Separation)

10 Equilibrium RCC catalyst was taken and subjected to
11 coarse particle size separation by two methods; Rare
12 Earth Roller (RERMS); and High Gradient Magnetic
13 Separation (HGMS).
14

15 In RERMS, separation is made with the most magnetic
16 fraction taken off first, followed by as many as six
17 additional magnetic cuts, each one lower in magnetic
18 susceptibility than the previous cut. Figure 6 shows
19 how average particle size in microns varies for each
20 cut. It is apparent that the more magnetic the
21 particle, the smaller its average particle size. How
22 this relationship between metal content, magnetic
23 susceptibility, and particle size manifests itself was
24 described in an earlier section.
25

26 If more than one cut is desired, the Rare Earth
27 Roller can be employed in reverse manner by taking off
28 the least magnetic portion first followed by taking off
29 increasingly magnetic particles to achieve similar
30 separation. However, as shown in Figure 6, if more than
31 one cut is taken, reverse separation is not necessarily
32 as effective. This is confirmed not only by particle
33 size analysis as shown in Figure 6, but also confirmed
34 by chemical analysis and magnetic susceptibility of
35 these cuts as shown in Figures 7 and 8. Figure 9 shows
36 that for the RERMS method, catalyst MAT vol.%
37 conversion, a key catalytic property and an objective of
38 magnetic separation, is highest for the lowest magnetic
39 fraction. In this experiment, the seven cuts are shown
40 as block diagrams and a single point represents the

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midpoint of this cut. For all further presentations, each graph was derived from such cuts, with only the location of the midpoint shown for ease of presentation.

The relationship between MAT activity and magnetic susceptibility is clearly shown in Figure 10 where MAT conversion is shown to relate inversely to magnetic susceptibility. I.e., the lower the magnetic susceptibility, the higher the catalyst activity or MAT conversion. Note how much higher MAT conversion extends for the preferred high magnetic cut off first.

Figure 11 shows that HGMS can also be used to achieve a similar increase in MAT activity as a result of separation, but other studies show that the HGMS method is not as effective in using magnetic separation to remove coarse particles. Figure 12 shows a very slight sensitivity to particle size in the HGMS method as compared with the RERMS size sensitivity of the method. In the RERMS method, it appears that magnetic properties are balanced against gravitational and centrifugal forces, which are related to particle size; not the case in the HGMS method.

Examples 2A and 2B show that not only can magnetic separation create fractions of high and low catalytic activity, but the RERMS can also separate particles by size, an important advantage of preferred embodiments of this invention.

Example 3

(Sieve or Screening Separation of Equilibrium Catalyst to Control Particle Size Distribution and Metal Content)

This example demonstrates that metal content, especially iron, as well as magnetic properties of spent cracking catalyst as previously shown, are also related to particle size.

Reverse separation by screens or sieves, shows that separation by particle size also leads to differences in metal and magnetic properties, as also seen in Figures 7, 8, and 9. Unfortunately, clean, close separation of particles by size is a theoretical ideal, but in practice, a very difficult and expensive operation. The data show there are changes in magnetic susceptibility, and to a certain extent, chemical composition, which is desirable. But screening or classification is still not effective in terms of the critical measure, namely MAT activity, although other Examples show that economically acceptable classification methods presently available on a commercial scale, can enable separation on a particle size basis. However, attrition, the third leg of this invention (described in Example 6), can also be used for particle size and metal control of circulating catalyst, allowing partial recovery of the significant coarse fraction, which otherwise would have to be discarded, or at least diluted by large addition of costly fresh catalyst.

Figure 13 shows that particle size separation even by "ideal" sieve separation does not give any meaningful change in catalyst activity, and therefore, even if an "ideal" separation could be made in a practical manner (none to my knowledge is presently available), the desired change in activity accomplished by magnetic separation, would not result. Figure 7 also shows that although beneficiation in iron analysis with "ideal" sieve separation is partially effective, sieving is not effective for nickel and vanadium as both pass through a maximum in the 50% fraction.

Tables 3, 4, and 5 provide actual data from which most of these curves were derived. These data show that particle size separation in an "ideal" situation, does achieve some mild chemical separation, but not nearly enough to be useful commercially and certainly not from an activity change standpoint. However, by a somewhat

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less exacting, less costly, commercially available classification method to be described in Example 4, it is possible to separate, to some extent, satisfactory for our process, fine and coarse fractions, which can be profitably utilized in this invention.

TABLE 3

MAGNETIC SEPARATION RERMS METHOD - HIGH MAG OFF FIRST
Equilibrium RCC Catalyst

Wt. %	Magnetic Sample #	Average Particle Size Range Microns	Mag Suscept. Xg X 10 ⁻⁶ emu/ gm	Fe ppm	Ni ppm	V ppm
13.8	M ₁	40	72	9160	2545	5191
14.0	M ₂	42	44	7910	2386	5193
15.2	M ₃	70	39	7200	2192	5085
14.1	M ₄	80	34	-	-	-
12.6	M ₅	90	28	6080	1565	3996
14.9	M ₆	105	22	5900	1409	3784
16.3	NM ₆	125	15	5700	1113	3212

19

TABLE 4

MAGNETIC SEPARATION REMS METHOD - LEAST MAGNETIC OFF FIRST
Equilibrium RCC Catalyst

Wt. %	Magnetic Sample #	Average Particle Size Range Microns	Mag Suscept. Xg X 10 ⁻⁶ emu/ gm	Iron ppm	Ni ppm	V ppm
10.8	M ₆	40	55	8900	2614	5354
9.0	NM ₆	40	33	8100	2323	5181
12.0	NM ₅	50	29	-	-	-
15.0	NM ₄	70	24	-	-	-
19.8	NM ₃	80	20	-	-	-
23.6	NM ₂	90	19	6600	1691	4292
9.8	NM ₁	105	19	6800	1718	4272

TABLE 5

SIEVE SEPARATION
Equilibrium RCC Catalyst

Wt. %	Sieve Size	Average Particle Size Range Microns	Mag Suscept. Xg X 10 ⁻⁶ emu/ gm	Iron ppm	Ni ppm	V ppm
2.5	on 100	+150	24	6430	1358	2857
13.6	on 150	+130	17	6011	1440	2985
51.8	on 200	+ 90	25	6511	1602	3243

20

1								
2	27.5	on 325	+ 60	38	7619	1571	3061	
3	4.2	thru 325	- 40	63	9506	1541	2882	
4								

5 Example 2B, however, shows that magnetic separation
 6 can also be effectively utilized to achieve particle
 7 size separations, including fine and coarse cuts. Why
 8 the "ideal" sieve separation, yielding crisp particle
 9 size fractions does not give the equivalent chemical and
 10 MAT activity separations as does magnetic separation, is
 11 not yet clear. However, this inability to give a
 12 theoretical explanation, should not be construed as
 13 inhibiting the practical application of this invention.

14
 15 This Example 3 does demonstrate, however, that
 16 removal of fines (by "ideal" sieve separation, and
 17 commercially by classification), offers a supplemental
 18 means to remove metals and fines as well. This
 19 invention provides, by a combination of three
 20 operations; magnetic separation; mechanical
 21 classification for removal of both fines (-40 microns)
 22 and coarse (+104 micron particles) sequentially; and
 23 attrition of coarse catalyst particles from either
 24 process to a lower particle size, closer size
 25 distribution, lower metal content, and increased
 26 catalyst activity particle. It provides a preferred
 27 high activity, highly fluidizable and high performing
 28 catalyst with particle size generally falling in the
 29 30-105 micron and preferably 40-80 micron range. This
 30 size range is considered the ideal particle distribution
 31 for FCC and RCC® operation in terms of activity,
 32 selectivity, and fluidizability. See Figure 14.

33 Example 4

34
 35 (Mechanical Method of Obtaining Classification
 36 and Removal of Fine Particle Size Fractions)

37 This example demonstrates the availability of
 38 equipment for classifier 40 which can separate or remove
 39 fines and therefore metal from equilibrium catalyst.
 40

Classifiers for sharp separation of particles (as obtained by sieve separation) of varying size and size distribution in the 5-200 micron range are not readily available, and where available, are of borderline effectiveness, and are costly to operate and of low capacity. A Buell (G.E.) Classifier was evaluated and found to be inefficient.

In this Example, a preferred Turboplex 200 ATP (Alpine Turbo-Plex) classifier (see Figure 15), an intermediate size unit of a family of larger ATP classifiers from Micron Powders, Inc. of Summit, NJ, is utilized for fine particle separation.

Twenty-six pounds of equilibrium RCC catalyst, 72% of which passes through 140 mesh sieve is fed in two minutes, 45 seconds to a 200 ATP Turbo-Plex separator operating at 1,000 rpm with blower air of 730 cubic feet per minute (CFM) and at a rate of 621 pounds/hour to produce six pounds of fines (23 wt.%) 100% of which passes through a 140 mesh sieve and 77 wt.% of average particle size greater than the feed catalyst. This coarser fraction is then processed much more efficiently on the magnetic separator (which reportedly, does not operate well on very fine particles). Thus, this example demonstrates that fines with composition approaching that shown in Figure 6 for 77 wt% recovery of coarse particles (APS of 90 microns at 39% magnetics) and 23 wt% recovery of fine particles (APS of 50 microns at 89% magnetics) respectively as compared to sieve separation, are removed from equilibrium catalyst for disposal, thus reducing the load on the magnetic separator. This example demonstrates the operability of one leg of the three-legged magnetic separation 20, classification 40, and attrition 60 process described here and shown in Figure 1.

Example 5

(Utilizing Classification to Remove Coarse
Particle Size Fractions for Particle Size
Reduction by Attrition)

This example demonstrates use of a commercial classifier for removing coarse catalyst larger than 104 microns in diameter.

Two hundred and fifty pounds of resid-cracking equilibrium catalyst with an APS of 84 microns is subjected to classification on the previously described 200 ATP Alpine Turboplex Classifier to remove a coarse fraction representing 15 wt.% with an APS of 114 microns and a remaining fraction representing 85% with an APS of 74 microns. The magnetic susceptibility of the equilibrium catalyst is 20.8×10^{-6} emu/gm., while the 15% coarse fraction has a magnetic susceptibility of 12.7×10^{-6} emu/gm., and the fines have a magnetic susceptibility of 22.7×10^{-6} emu/gm. Table 6 shows the particle size analysis and magnetic susceptibility of the feedstock and the two fractions. These runs are made in 37 minutes, 20 seconds at a feed rate of 321 pounds/hour at an RPM of 712 at a total air flow of 706 CFM.

TABLE 6

		Wt.% 85 Fines	Wt.% 15 Coarse
Yield	Feed		
Wt.% +104 microns (140 mesh)	22	14	68
Mag Suscept $\times 10^{-6}$ emu/gm	20.7	22.7	12.7

The result, while showing some overlap of particle size, shows a yield of a coarse fraction containing over 68 wt.% of coarse material greater than 104 microns, (140 mesh) while producing 85 wt.% of product only 14

1
2 wt.% of which is greater than 104 microns (140 mesh).
3 Theoretically, a second pass of this coarse first pass
4 product, although greatly increasing cost, could yield
5 product of which almost 90% should be greater than 104
6 microns. Note that coarse classification does also
7 serve to split the feed into a higher and lower magnetic
8 susceptibility, thus confirming that classification
9 (even if not at theoretical or "ideal" level for
10 sieving), does generate an enriched fraction of
11 104-micron-plus particles and a lesser content of these
12 particles in a second fraction, and because of this
13 separation, classification does also show some
14 enrichment of metals in one fraction and reduction of
15 metal levels in the other and thereby magnetic
16 susceptibility, as shown in Figure 8.
17

18 Example 6

19 (Attrition Grinding of Coarse Catalyst to
20 Lower Particle Size and Nickel and Iron
21 Content, and to Raise Catalyst Activity)

22 This example shows how attrition grinding 80 is
23 used to reduce particle size. As will be shown,
24 however, this grinding is preferably of a special kind.
25 It does not reduce particle size by crushing particles
26 but only by wearing off the outer shell of the catalyst
27 particle to yield a lower metal, higher activity
28 catalyst with reduced diameter (Figure 16).
29

30 Studies of fluid flow behavior of FCC particles,
31 see Zenn and Othmer, Fluidization and Fluid Particle
32 Systems, Reinhold Chemical Engineering Services, 1966,
33 have shown that there is a narrow range of particle size
34 acceptable for best catalytic cracking processing
35 (Figure 10). Too coarse a material results in difficult
36 particle flow and distribution and burping of the bed
37 and poor oil contact. On the other hand, very fine
38 particle size makes it operationally difficult to retain
39 catalyst. Further, it has been established by
40 experience over many years by many refiners, that a

particle distribution most preferably in the 40-80 micron range, as mentioned above, gives best overall performance.

These studies show that at least for heavy residual processing in a catalytic cracking operation, average particle size (APS) can adversely affect selective conversion to gasoline. Figure 17 shows a plot of APS for runs on a resid cracker over a period of eight years, wherein the average particle size (APS) varied from as low as 67 microns for one year and as high as 89 for another of these years. It can be seen that the selectivity (i.e. the amount of gasoline produced at a given conversion of feedstock) dropped from 74.8% at 67 microns to 71.4% at an APS of 90. This represents a very significant economic penalty for coarse catalyst, as the objective of catalytic cracking is to produce gasoline, and here there is a loss of 3.4 vol.% gasoline for the same conversion of oil, thus indicating the need to keep particle size at a lower average value.

However, Figure 9 shows in contradiction, that best catalyst activity is found in the coarser catalyst fractions. This then indicates that although there is a need to continually reduce catalyst particle size to keep it in a desired range, there is also an opportunity of maintaining or even increasing activity or selectivity.

As previously described, metal accumulates on a particle, both directly with time and inversely to particle size. Separate studies of cross-sectional distribution of metal throughout catalyst microspheres have shown that iron and, to a certain extent nickel, accumulate in the outer shell, while vanadium distributes rather uniformly throughout. See Figure 18, which shows an Energy Dispersive X-ray Analysis of a typical particle showing this typical metal distribution.

Careful grinding and attrition of the outer shell, can remove this outer shell. This means coarse catalyst can be reduced in size while, at the same time, removing metal. As a consequence, catalyst activity and performance are also enhanced, and highly valuable catalyst reclaimed and recycled to the unit, thus further reducing operating cost. As mentioned, it is an object of this invention to utilize a combination of three processes, namely, magnetic separation, classification, and attrition (see Figure 4) to achieve maximum metal removal, maximum activity and selectivity and proper catalyst size distribution, while also recapturing coarse catalyst for reuse.

This preferred three-unit process can either be used as a part of a magnetic separation process to recover and return preferred catalyst to the unit, or can be added onto the larger magnetic separation unit so as to control coarse catalyst, or the attriter-classifier can less preferably and less effectively be employed without magnetic separation.

This Example 6 demonstrates the use of a commercially available attriting or grinding device, which when properly operated according to our conditions, achieves a reduction in particle size of coarse catalyst, a reduction in metal content, and an enhanced activity catalyst (see Figure 16), for an idealized portrayal of this operation.

In this Example 6, coarse product resulting from a similar classification run on the same high metal equilibrium catalyst described in the previous example yields 23% coarse catalyst with a particle size distribution 62% greater than 104 microns. This coarse cut had a magnetic susceptibility of 15.1×10^{-6} emu/gm. Three grinding runs are made on a 100 Alpine Fine Grinder (AFG) Jet Mill unit (See Figure 19). Table 7

summarizes the results of these runs and the conditions used.

TABLE 7
Particle Grinding

Example	6A	6B	6C
Run #	11	12	13
Grinding Chamber Pressure	-5MBAR	0	0
Product Fine # (Cyclone)	0.3634	0.595	0.4295
Grind Air Psig	4 bar	6 bar	3 bar
Product Coarse #	1.0	0.694	0.903
Gap Rinse Air	0.6 BAR	0.6 BAR	0.6 BAR
Baghouse Product #	0.066	0.044	0.077
Bearing Rinse Air	0.5 BAR	0.5 BAR	0.5 BAR
Percent Fine	26.3	46.5	32.3
Percent Coarse	73.0	53.5	67.7
Nozzle Size	1.9MM	1.9MM	1.9MM
Time, min.	10	10	10
RPM	10,000	10,000	10,000
Feed Rate #/hr.	8.22	7.74	7.98
Amps Empty	1.2	1.2	1.2
Relative Humidity %	13	13	13
Amps Full	1.5	1.5	1.4
Temp. °F	74	74	74
Grinding Air Temp	Ambient	Ambient	Ambient
Baghouse Pressure	0	0	0
Feed (lbs.)	1.37	1.29	1.33
% Recovery of Ground Product	73.0	53.5	67.7

Table 8 shows the yield and magnetic properties of the product. As can be seen, in each run there was a reduction in coarse product, but magnetic susceptibility also was significantly reduced, confirming that magnetic generating metals, such as nickel and iron, had been reduced in concentration.

27

TABLE 8

Product Composition

5		Feed	11		12		13	
6	Yield	Xg	Wt.%	Xg	Wt.%	Xg	Wt.%	Xg
7								
8	Coarse Chamber	16.8	73.0	11.4	53.5	10.0	67.3	11.6
9	Cyclone		26.5	51.1	46.1	25.2	32.2	25.5
10	Baghouse		0.5	32.0	0.4	21.9	0.5	23.6

Extensive dry sieving of chamber product from Run 13, Xg dropped to 9.2. Further washing of dry sieve product from Run 13, Xg dropped to 8.1.

In Table 9 is shown the results of particle size analysis of the chamber or coarse product of runs #11, #12, and #13. As can be seen, there is an appreciable drop in particle size (APS) along with the drop in magnetic susceptibility confirming that this careful grinding technique has not shattered the particles, but simply reduced them in size. Microscopic examination of the chamber product showed over 95% remaining as microspheres.

TABLE 9

Run #	Feed	11	12	13
Wt.%				
+ 100 Mesh	15	10	11	8
+ 150	47	33	35	26
+ 200	20	32	29	28
+ 325	17	12	13	15
- 325	1	13	13	23
% > 150 mesh	62	43	46	34
APS microns	116	99	96	91

1		28			
2	Chamber Yield	73.0	53.5	67.7	
3					
4	Wt.% Yield of +325	63.5	46.5	52.0	
5					
6	Wt.% Yield-Equil.				
7	Cat.	23.0	14.6	10.6	12.0
8					
9	% of Original Coarse				
10	Feed	100.0	63.4	46.1	52.2
11					
12					

Table 10 shows how effective grinding is. Chemical analysis for iron, nickel and vanadium is shown for the feed and for each of the fractions resulting from grinding. As can be seen there is a drop in iron, nickel and vanadium from the feed to the chamber product, with the attrition product fines showing up with much higher metals level, proving that the metal removal from the outer shell was very effective.

TABLE 10

Run #	Feed	11	12	13	#13 Chamber Water Washed
Feed	ppm Fe 7,339				
	ppm Ni 1,794				
	ppm V <u>3,875</u>				
	13,008				
Chamber	ppm Fe	6,640	6,430	6,850	6,570
	ppm Ni	1,594	1,559	1,643	1,595
	ppm V	<u>3,639</u>	<u>3,532</u>	<u>3,689</u>	<u>3,409</u>
		11,873	11,521	12,162	11,564
Cyclone	ppm Fe	9,017	8,038	7,967	

1		29		
2	ppm Ni	2,115	1,978	1,965
3	ppm V	<u>4,040</u>	<u>3,941</u>	<u>3,831</u>
4		15,172	13,957	13,763
5				

6 Table 11 shows the percent reduction of nickel,
7 iron, and vanadium for the recovered +325 mesh product
8 for these three runs. Microscopic examination of the
9 chamber product showed some very fine ground dust
10 clinging to the surface, apparently electrostatically,
11 making final interpretation a little cloudy.
12 Reexamination of these particles after water washing on
13 a +325 sieve showed them to be mainly very spherical
14 particles (over 95%) and appearing to be somewhat cloudy
15 in appearance as against the glossy appearance of the
16 feed, again suggesting that a scouring of the surface
17 had been achieved.

TABLE 11

19					#13
20					Chamber
21					Water
22	Run #	11	12	13	Washed
23					
24					
25					
26					
27	% Fe Reduction	10	12	7	11
28					
29	% Ni Reduction	11	13	8	11
30					
31	% V Reduction	6	9	5	12
32					

33 Because of the small particle size of the cyclone
34 and baghouse fines, catalyst activity testing of fines
35 would be meaningless, but run T-7 coarse feed and
36 chamber product from runs #11, #12, and #13 are also
37 submitted for activity testing. Table 12 shows the
38 results of these tests.

30

TABLE 12

Run #	Feed	11	12	13
Vol.% Conversion	67.9	69.7	69.2	69.8
Relative Activity	49	59	56	60
Vol.% Gasoline	59.2	59.7	59.9	60.2
Wt.% Coke	4.52	4.49	4.40	4.58
Wt.% H ₂	0.32	0.32	0.33	0.33
Coke Selectivity	2.14	1.97	1.97	2.00

The significant increase in catalyst activity and reduction in coke selectivity confirm the uniqueness of this method and the potential savings. The original coarse catalyst with a relative activity of 49 was cleansed of metal, reduced in size and increased some 22% in activity, while also improving coke selectivity, and recovering of 53.5 to 73 wt.% of very desirable catalyst and corresponding reduction in disposal costs.

This example shows the value of including grinding/attrition in the total three process rejuvenation/reconditioning/refreshing scheme.

These results, together with particle size separations and magnetic separation, show that an appreciable amount of catalyst can be rejuvenated and/or cleaned mechanically, with highly attractive economic incentives and without requiring chemicals or conventional replacement with expensive new catalyst.

Washing and more thorough screening of chamber catalyst to remove small amounts of very fine (< 5 microns) high metal fines apparently electrostatically attached to the surface of large spheres, shows magnetic susceptibility drops to 9.2 from 11.5, and after water washing to further remove catalyst fines, magnetic

1
2 susceptibility dropped to 8.1, adding further proof that
3 attrition grinding is an attractive and vital part of
4 the process.
5

6 Modifications

7 Specific compositions, methods, or embodiments
8 discussed are intended to be only illustrative of the
9 invention disclosed by this specification. Variation on
10 these compositions, methods, or embodiments are readily
11 apparent to a person of skill in the art based upon the
12 teachings of this specification and are therefore
13 intended to be included as part of the inventions
14 disclosed herein. For example, the invention can be
15 applied to sorbents such as those used in U.S.
16 4,309,274, 4,263,128, and 4,256,567, as well as to
17 cracking catalysts, and both are included within the
18 claims. The attriter 60 and the classifier 40 can be
19 used as a pair for some catalyst recovery, and the
20 magnetic separator 20 plus attriter or plus classifier
21

22 can also be used as a pair, though the three component
23 "triangle" of Figure 1 is most preferred.
24

25 More than one separator or attriter or classifier
26 may be employed in cascade or other arrangement.
27

28 Reference to documents made in the specification is
29 intended to result in such patents or literature being
30 expressly incorporated herein by reference including any
31 patents or other literature references cited within such
32 documents.
33

34
35
36
37 What is claimed is:
38
39
40

CLAIMS

1. A multi-step process for recovering and reconditioning used metal-laden particulate, said process comprising:
 - a. passing metal-containing particulate from a hydrocarbon conversion process through magnetic separator means to separate out high metal, low activity particulate;
 - b. passing particulate through a particle size classifier means so as to separate out larger particles, contaminated with metal;
 - c. passing at least a portion of said larger particles therefrom to attriting means wherein said larger particles are reduced in size and metal content, cleansed of fines in said classifier means, and returned to the process.
2. A process according to Claim 1 in which at least a portion of said particles possessing magnetic susceptibility greater than 5×10^{-6} emu's per gram are separated out for disposal or transport to said attrition means.
3. A process according to Claim 1 in which at least a portion of particles larger than 100 microns are removed by said classifier means and transported to said attrition means to remove metal and reduce said particles to less than 100 microns in diameter, and at least a portion are recycled to said hydrocarbon conversion process.
4. A process according to Claim 1, in which coarse particles from the classifier are ground to a diameter of less than 90 microns and recycled to the operating unit.
5. A process according to Claim 1 in which at least a portion of the fine particulate from said attriting means is collected via cyclone and/or filter

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means and thereafter disposed of and/or subjected to chemical processing for nickel and vanadium recovery.

6. A process according to Claim 1 in which said magnetic separator means comprises a continuous or cyclic electromagnetic separator.
7. A process according to Claim 1 in which particles are separated by passing through the field of a magnetic separation means.
8. A process according to Claim 7 in which at least a portion of said particulates are first sent through said classifier means to remove coarse fractions, then through said attriter means to reduce average particle size and metal content by attrition and finally thereafter sent through said magnetic separation means to remove high magnetic particulate, and the remaining portion is recycled to said hydrocarbon conversion process.
9. A process according to Claim 1, whereby the feed to said magnetic separation means comprises used catalyst contaminated with at least 500 ppm nickel-plus-vanadium.
10. A process according to Claim 1 whereby particulate exiting from said attrition means has at least 10% less metal contamination than the feed.
11. A process according to Claim 1 whereby the coarse catalyst separated in the particle size classifier has an activity at least 20% above the remainder of the classified catalyst before attrition.
12. A process according to Claim 1 for separating metal-laden particles by particle size comprising passing said particles through magnetic separation means after exposing said particles to depositing metal over a period of time, whereby relatively larger diameter particles are less affected by said magnetic separation means than are relatively smaller

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particles.

13. A process for magnetic separation of particulates containing magnetic metals, comprising removal of the higher magnetic fraction before removal of the relatively lower magnetic fractions.
14. A process according to Claim 1 wherein the lower magnetic particles are thereafter recycled to circulate in a hydrocarbon conversion unit.
15. A process for converting hydrocarbons containing at least 1 ppm of nickel and vanadium and 1% Ramsbottom Carbon, in which process metal accumulates to at least 750 ppm of total metal on catalyst, comprising in a utilizing process of Claim 1, and wherein the separation of high metal from low metal containing catalyst utilizes a rare earth roller magnetic separator to make the separation.
16. A process according to Claim 15 in which the hydrocarbon feedstock contains at least 2% Ramsbottom Carbon and 3 ppm nickel-plus-vanadium.
17. A process according to Claim 15 wherein about 1-25% by weight of said particles is removed by said magnetic separation means and/or said classification means and at least a portion of the remainder is recycled back to said hydrocarbon conversion process.
18. A process according to Claim 15, wherein the particulate to be treated comprises at least 2,000 ppm total metal.
19. Apparatus for raising the average activity and decreasing the average metal-on-particles of a fluidizable particulate comprising in combination:
 - (a) magnetic separation means;

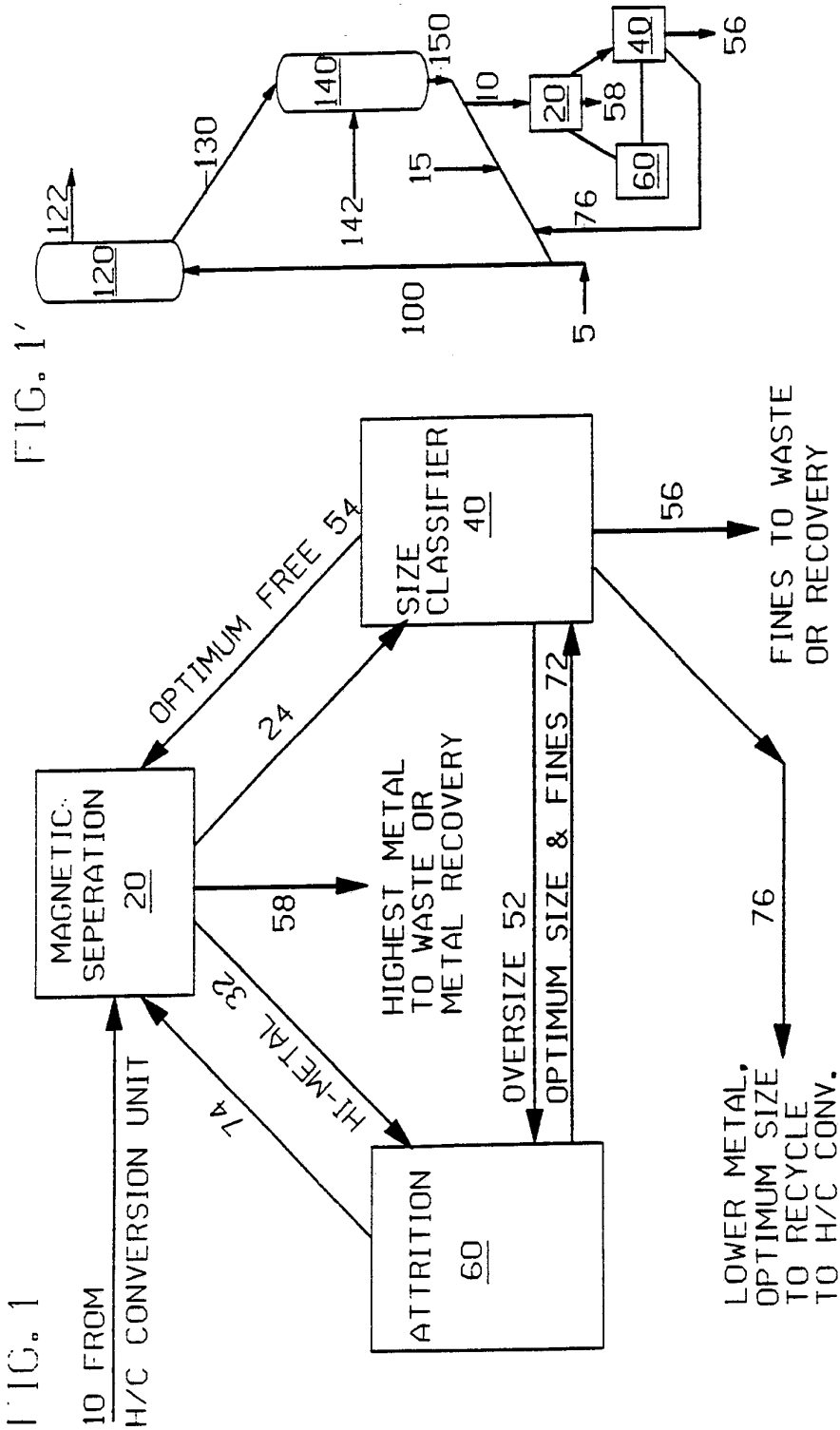
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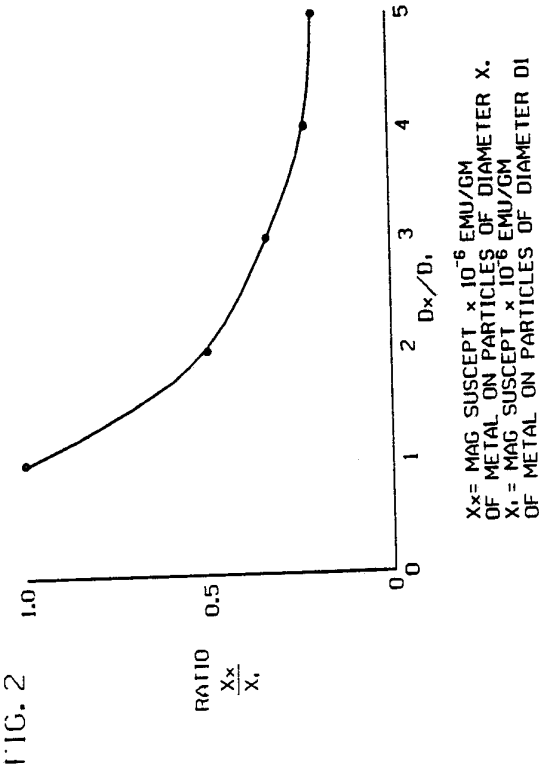
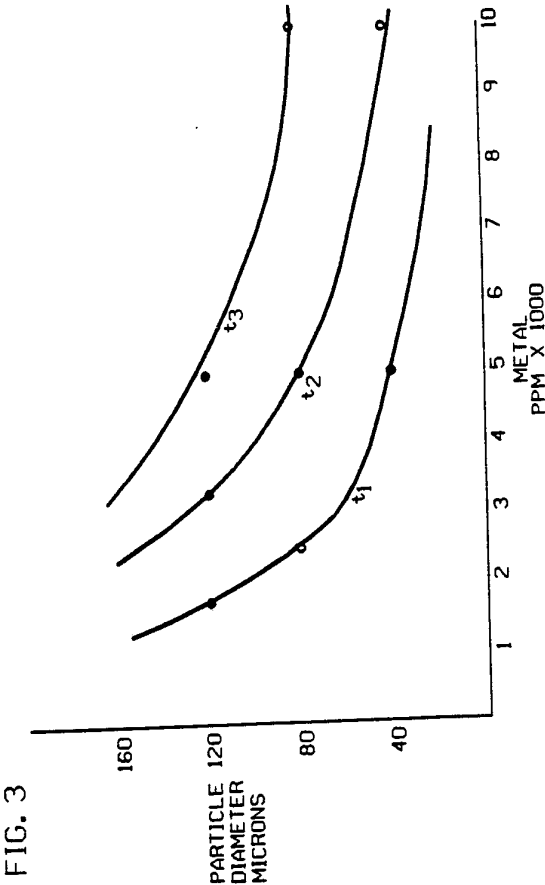
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(b) size classification means; and

(c) particle size reduction means.

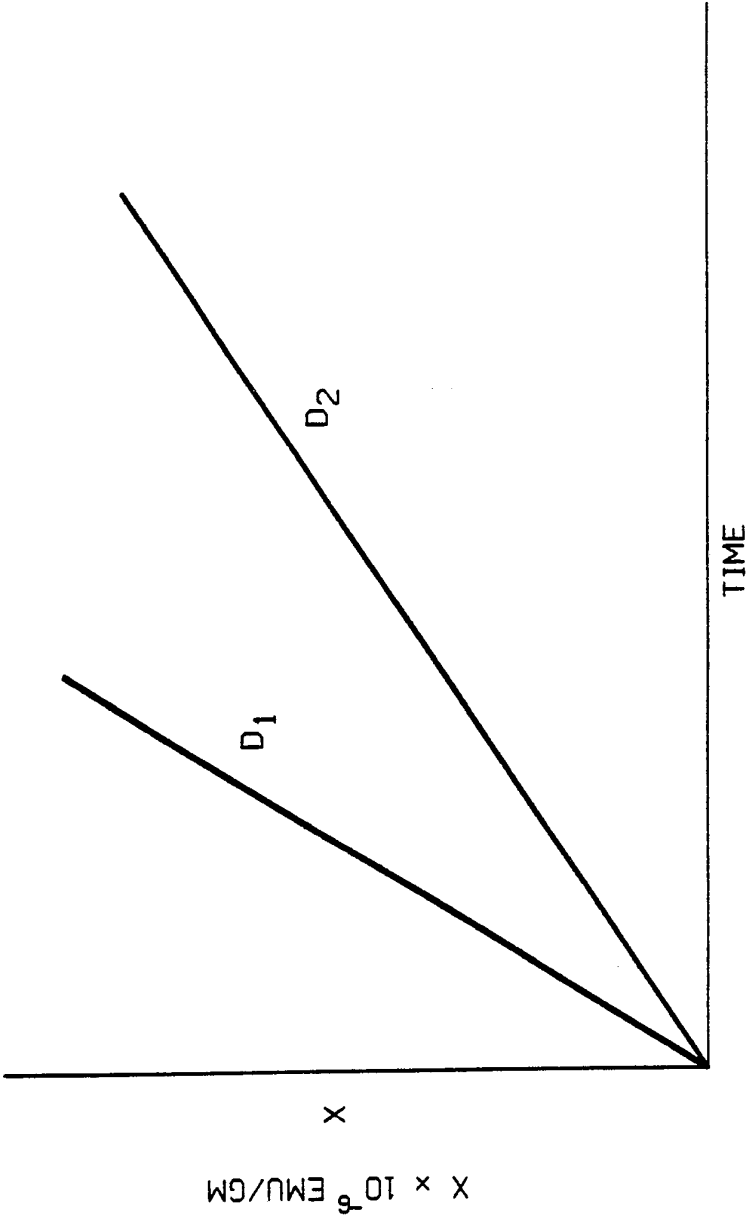
20. An apparatus according to Claim 19 in which the magnetic separator means comprises a roller-belt magnetic separator, or a drum roll magnetic separator, or high gradient electromagnetic magnetic separator.





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FIG. 4



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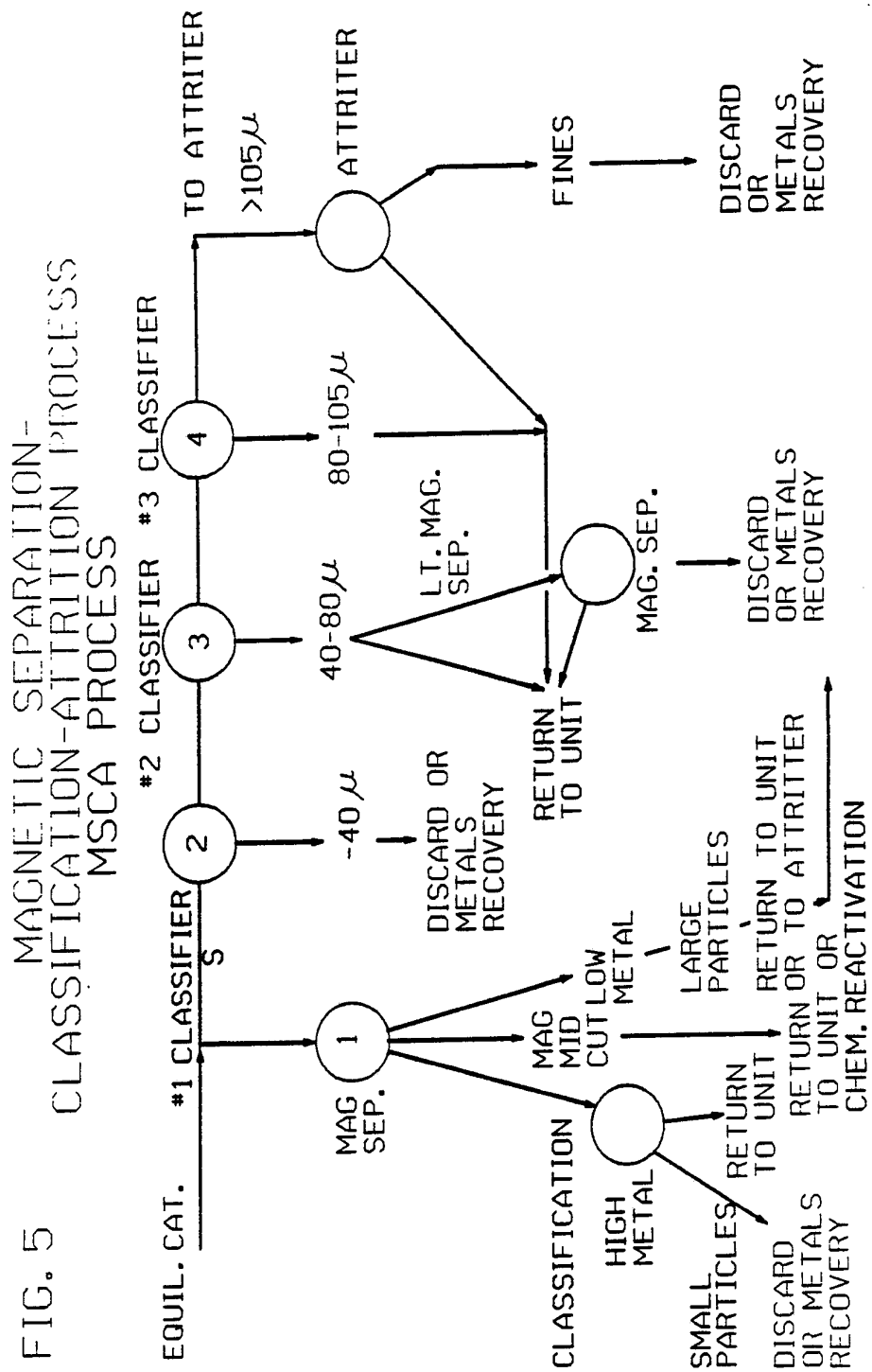


FIG. 6 PARTICLE SIZE DISTRIBUTION
RCC

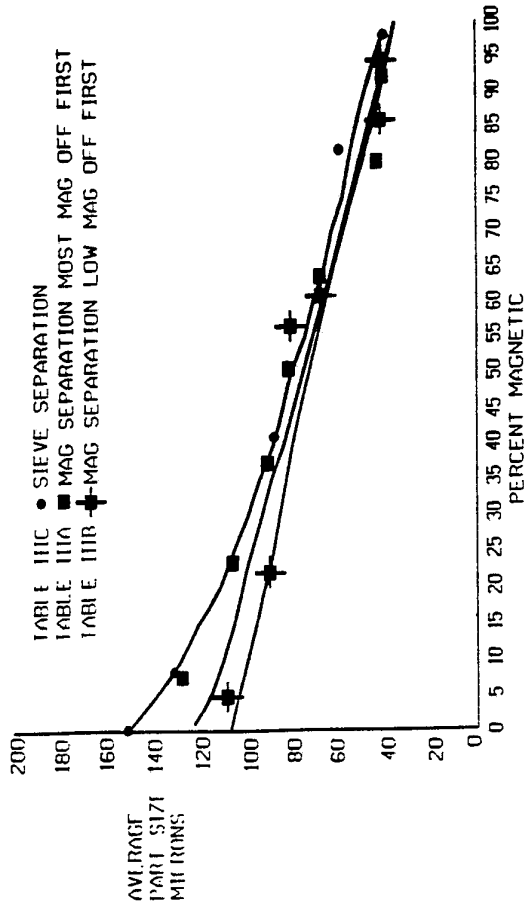


FIG. 7

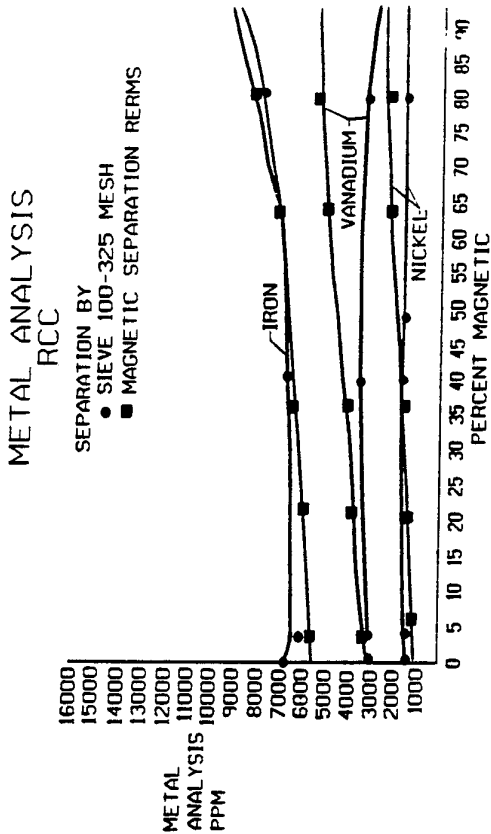


FIG. 8
MAGNETIC SUSCEPTIBILITY
RCC

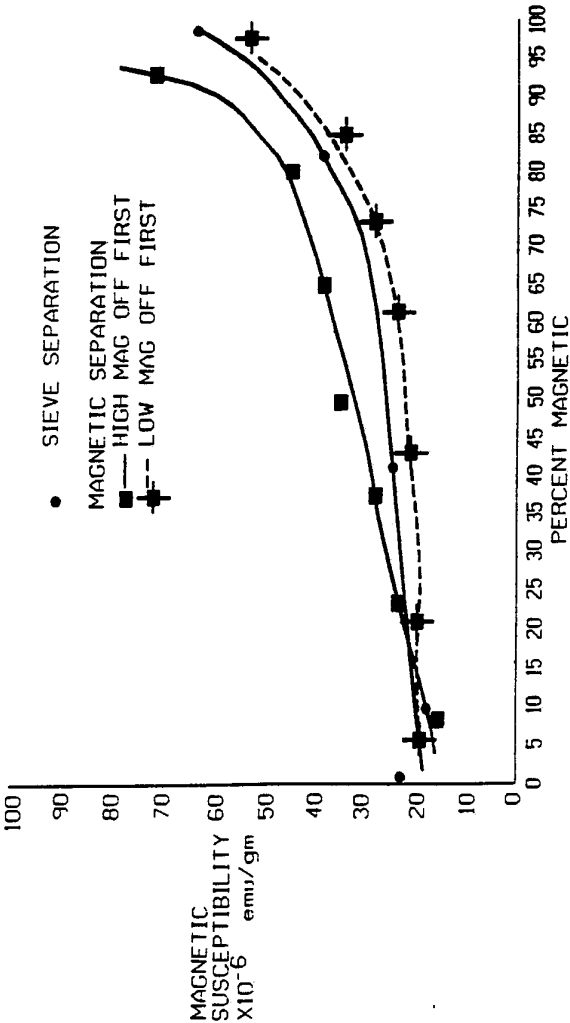
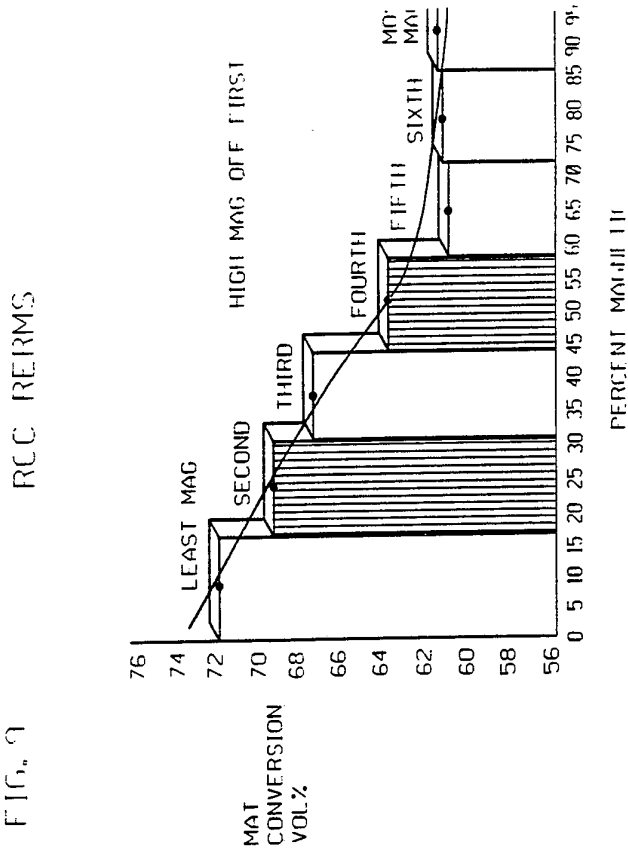
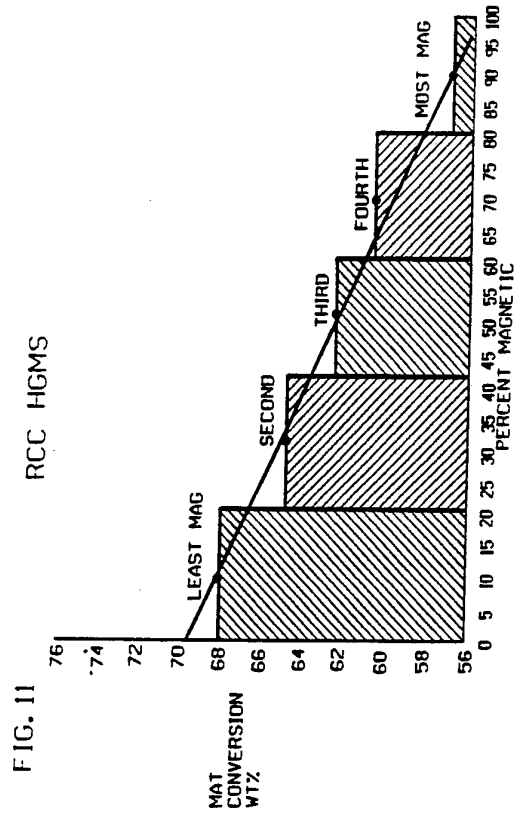
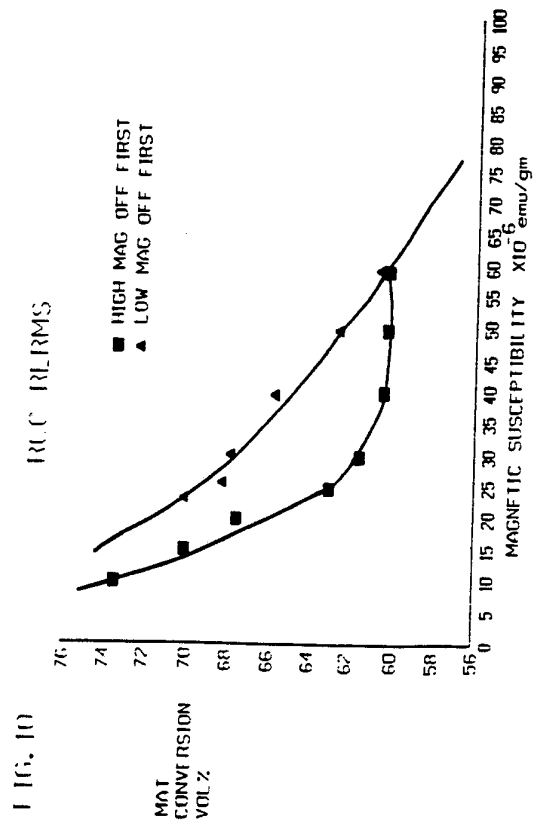


FIG. 9



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FIG. 13

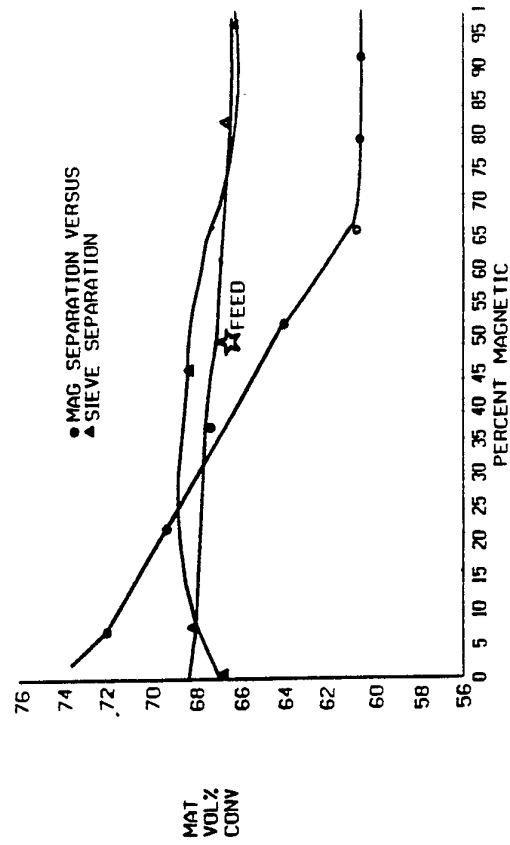
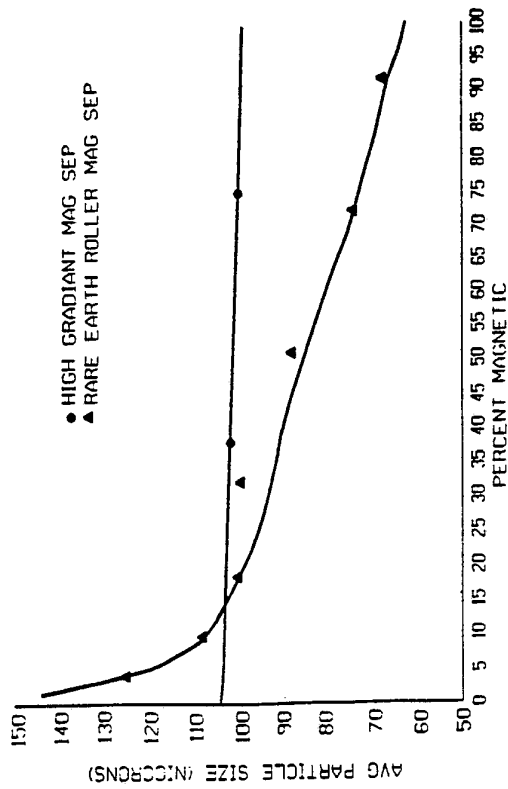


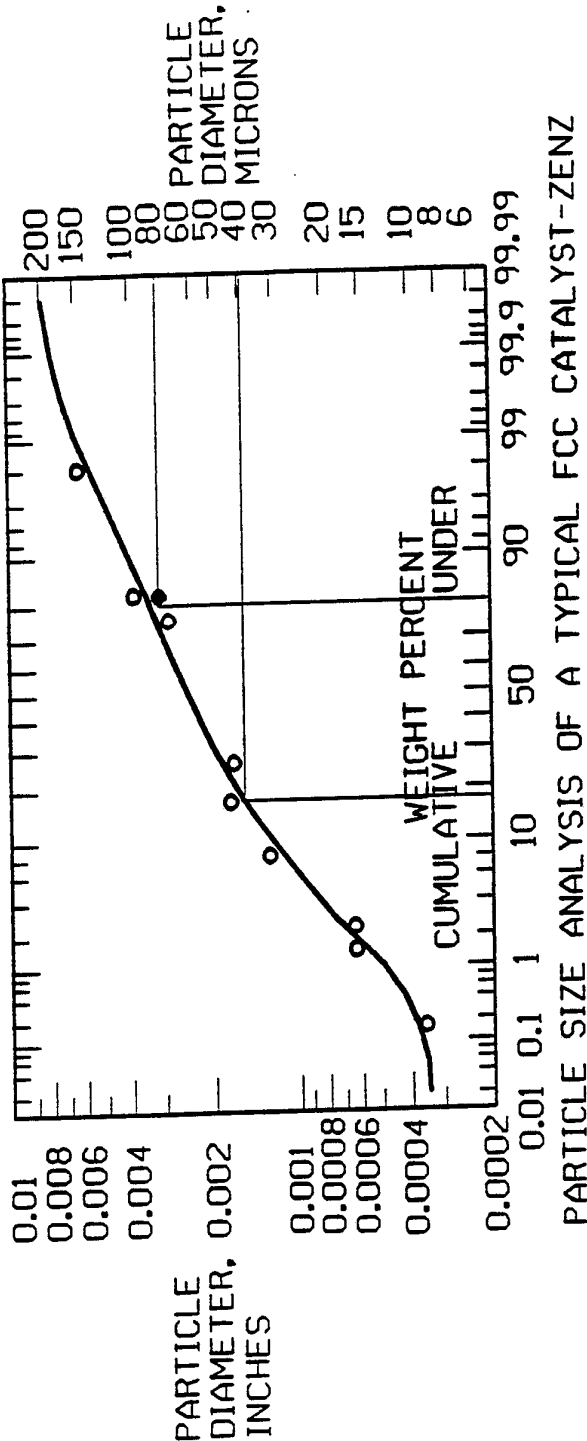
FIG. 12
RCC PARTICLE SIZE SEPARATION
BY MAGNETIC SEPARATION



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FIG. 14

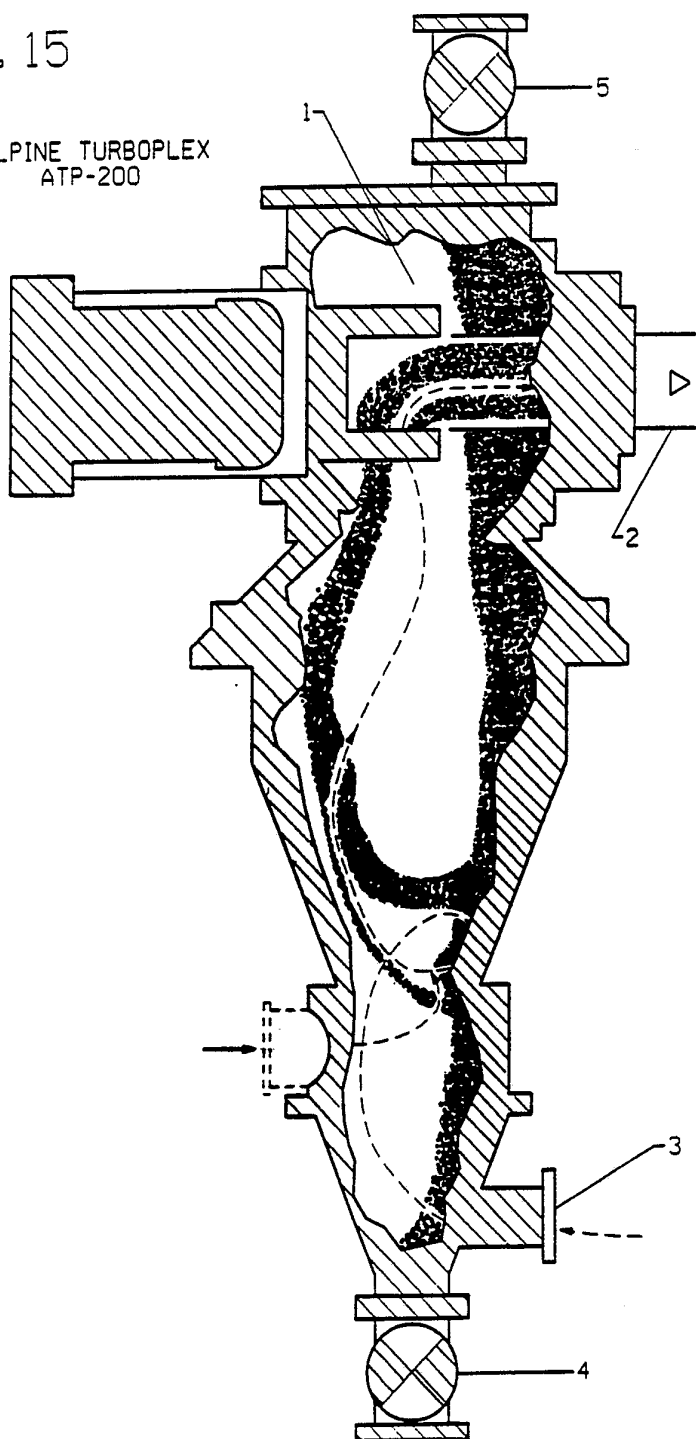
FLOW THROUGH FLUIDIZED BEDS



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FIG. 15

ALPINE TURBOPLEX
ATP-200



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FIG. 17
COMPUTER AIDED EVALUATIONS
PROCESS PERFORMANCE
DAILY DATA

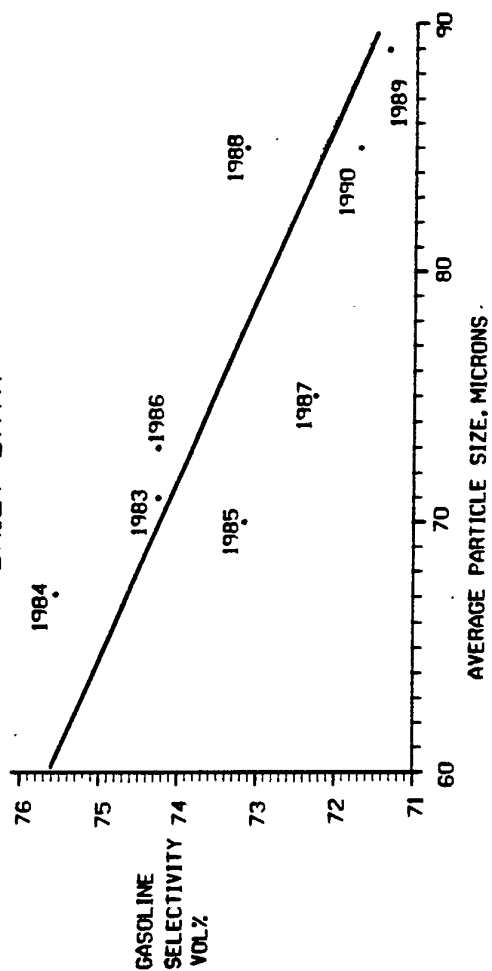
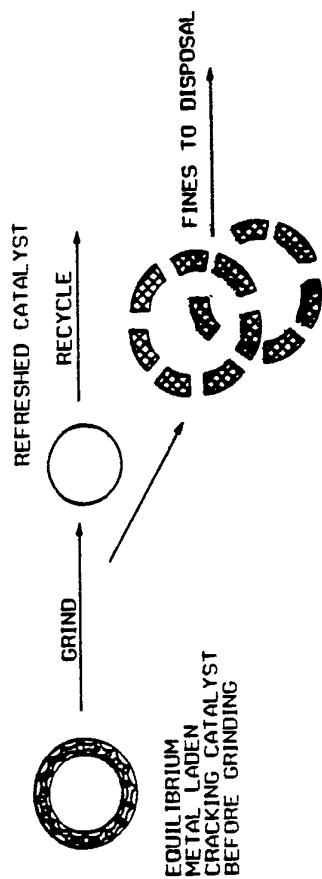
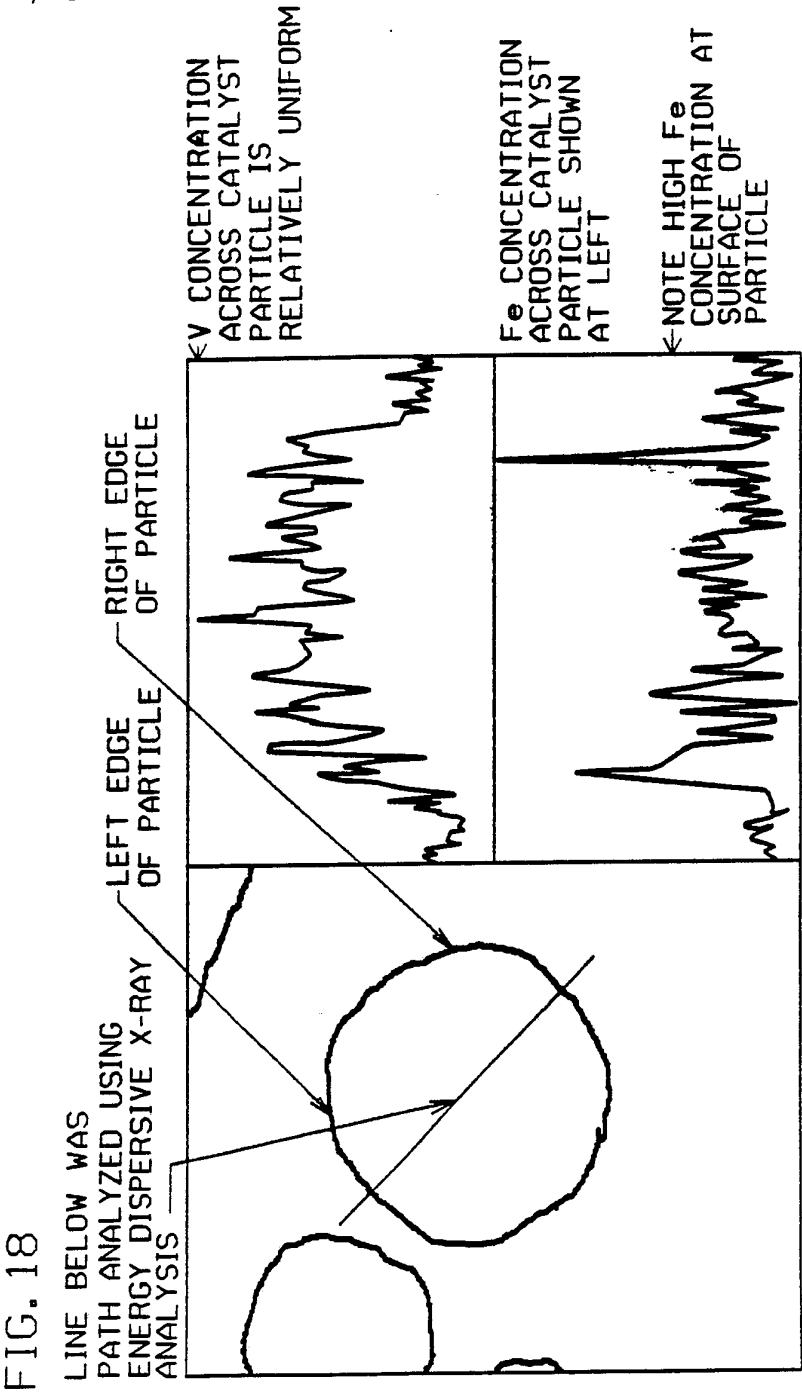


FIG. 16



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