FINAL REPORT

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ENGINEERING DEVELOPMENT OF ADVANCED PHYSICAL FINE COAL CLEANING TECHNOLOGIES –

FROTH FLOTATION

Prepared for
U.S. DEPARTMENT OF ENERGY
PITTSBURGH ENERGY TECHNOLOGY CENTER
Pittsburgh, Pennsylvania

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***ICF KAISER
ENGINEERS***

With

Ohio Coal Development Office

Babcock & Wilcox

Consolidation Coal Company

Center for Research on Sulfur in Coal

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Illinois State Geologic Survey

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ADVANCED FROTH FLOTATION

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MARCH 1995

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Task 15 Report
Table of Contents

<u>Section</u>	<u>Page</u>
1.0 EXECUTIVE SUMMARY	1
1.1 Bench-Scale Test Results	1
1.2 Proof-Of-Concept (POC) Scale Test Results	3
1.3 Conceptual Design	11
1.4 200 TPH Commercial Plant Economic Analysis	12
1.5 Conclusions	13
2.0 INTRODUCTION	15
2.1 Objectives of the Report	16
2.2 Scope of the Report	19
2.3 Report Organization	19
3.0 BENCH-SCALE AND 100 POUNDS-PER-HOUR TESTING	20
3.1 Gravity-Based Precleaning	20
3.2 Conventional Froth Flotation Testing	22
3.3 Grinding Circuit Testing	23
3.4 Advanced Column Flotation Testing	24
3.5 Cleaning Circuit Projections	31
3.6 Thickening and Dewatering	31
3.7 Application of Bench-Scale and 100 Pounds-Per-Hour Test Results to the Preparation of the Revised Conceptual Semi- Works Flowsheet	33
4.0 PROOF-OF-CONCEPT (POC) SCALE TEST RESULTS	37
4.1 POC Configuration	37
4.2 Test Coals	40
4.3 POC Test Plan	40
4.4 POC Operations Summary	42
4.5 POC Results Summary	50
4.6 Application of POC Results to the Preparation of the Final Conceptual Flowsheet	84
4.7 Summary of Kelsey Centrifugal Jig and Multi-Gravity Separator Testing	93
4.8 Summary of Trace Element Removal Study	97
5.0 FINAL SEMI-WORKS CONCEPTUAL DESIGN	100
5.1 Design Philosophy	100
5.2 Preparation of Conceptual Flowsheets and Material Balances	100
5.3 Capital Cost Estimate	120
6.0 ECONOMICS OF THE ADVANCED FROTH FLOTATION PROCESS	123
6.1 Direct Processing Costs	124
6.2 Working Capital Requirement	124
6.3 Fixed Operating and Maintenance Costs	125
6.4 Variable Operating and Maintenance Costs	125
6.5 Economic Evaluations	125

Task 15 Report
Table of Contents

<u>Section</u>	<u>Page</u>
7.0 PROJECT CONCLUSIONS AND RECOMMENDATIONS	13
7.1 Bench-Scale and 100 Pounds Per Hour Testing	13
7.2 Proof-Of-Concept Module Testing	13
7.3 Economics	13
7.4 Recommendations for Future Technology Development	13
8.0 REFERENCES	13

APPENDIX A: LABORATORY COLUMN FLOTATION DATA

APPENDIX B: POC-SCALE DATA

APPENDIX C: SEMI-WORKS PLANT COST DATA AND DRAWINGS

APPENDIX D: ECONOMIC EVALUATIONS

Task 15 Report
List of Tables

	<u>Title</u>	<u>Page</u>
Table 1.01	Head Analysis for Washability Samples	5
Table 1.02	Contributions to Energy Loss and Pyritic Sulfur Removal During 24-Hour Demonstration Runs	11
Table 1.03	Capital Requirements and 1st Year Operating and Maintenance Costs for a 200 TPH Advanced Froth Flotation Plant (7560 Hours)	12
Table 1.04	Advanced Froth Flotation Economics (Annualized Basis)	13
Table 2.01	DOE Established Goals For Product Characteristics	15
Table 2.02	Team Organized For Advanced Froth Flotation Development Project	16
Table 3.01	Coarse Gravity-Based Cleaning Performance During 100 Pounds-Per-Hour Tests	21
Table 3.02	Fine Gravity-Based Cleaning Performance During 100 Pounds-Per-Hour Tests	22
Table 3.03	Comparison of Split Feed to Single-Size Feed Conventional Froth Flotation Performance	22
Table 3.04	"Grab" Product Ash Values From Conventional Froth Flotation	23
Table 3.05	Final 100 Pounds-Per-Hour Conventional Froth Flotation Performance	24
Table 3.06	Grind Size Comparison Using Pittsburgh No. 8 Seam Coal: Laboratory Froth Flotation of 200 mesh x 0 and 325 mesh x 0 Grinds	24
Table 3.07	Test Levels Utilized for Parametric Test Program	29
Table 3.08	Best Column Flotation Performance from 100 Pounds-Per-Hour Testing	30
Table 3.09	Estimated Process Performance of 100 Pounds-Per-Hour Testing	33
Table 4.01	Head Analyses for Washability Samples	40
Table 4.02	POC Test Schedule	43
Table 4.03	Laboratory Comparison	45
Table 4.04	Operational Downtime During 24-Hour Demonstration Runs	49
Table 4.05	Pittsburgh No. 8 Seam Coal, Average Raw Coal Quality	50
Table 4.06	Pittsburgh No. 8 Seam Coal, Heavy-Media Cyclone Performance	51
Table 4.07	Pittsburgh No. 8 Seam Coal, Water-Only Cyclone Configurations and Performance Results	52
Table 4.08	Pittsburgh No. 8 Seam Coal, Attempts At Grab-and-Run, Conventional Flotation	54
Table 4.09	Pittsburgh No. 8 Seam Coal, Conventional Single-Stage Froth Flotation Results	55
Table 4.10	Pittsburgh No. 8 Seam Coal, Best Mill Classifying Cyclone Configuration	56
Table 4.11	Pittsburgh No. 8 Seam Coal, Best Operating Region Based on Factorial Matrix Results	57
Table 4.12	Pittsburgh No. 8 Coal, Box-Behnken Text Matrix	58

Task 15 Report
List of Tables

	<u>Title</u>	<u>Page</u>
Table 4.13	Pittsburgh No. 8 Seam Coal, Coded Coefficients for the Linear Regression Model	6
Table 4.14	Pittsburgh No. 8 Seam Coal, Column Operating Conditions Established for the Demonstration Run	6
Table 4.15	Pittsburgh No. 8 Seam Coal, Demonstration Run Project Goals Versus Average Results	6
Table 4.16	Upper Freeport Seam Coal, Average Raw Coal Quality	6
Table 4.17	Upper Freeport Seam Coal, Heavy-Media Cyclone Performance	6
Table 4.18	Upper Freeport Seam Coal, Water-Only Cyclone Configurations and Performance Results	6
Table 4.19	Upper Freeport Seam Coal, Attempts at Grab-and-Run, Conventional Flotation	6
Table 4.20	Upper Freeport Seam Coal, Conventional Single-Stage Froth Flotation Results	6
Table 4.21	Upper Freeport Coal, Box-Behnken Text Matrix	7
Table 4.22	Upper Freeport Seam Coal, Coded Coefficients for the Linear Regression Model	7
Table 4.23	Upper Freeport Seam Coal, Column Operating Conditions Established for the Demonstration Run	7
Table 4.24	Illinois No. 6 Seam Coal, Average Raw Coal Quality	7
Table 4.25	Illinois No. 6 Seam Coal, Heavy-Media Cyclone Performance	7
Table 4.26	Illinois No. 6 Seam Coal, Water-Only Cyclone Configurations and Performance Results	7
Table 4.27	Illinois No. 6 Seam Coal, Conventional Single-Stage Froth Flotation Results	7
Table 4.28	Illinois No. 6 Coal, Box-Behnken Text Matrix	7
Table 4.29	Illinois No. 6 Seam Coal, Coded Coefficients for the Linear Regression Model	8
Table 4.30	Illinois No. 6 Seam Coal, Column Operating Conditions Established for the Demonstration Run	8
Table 4.31	Illinois No. 6 Seam Coal, Average Adjustments to Ash Values for Bilmat Material Balance	8
Table 4.32	Column Flotation Operating Conditions	8
Table 4.33	Column Design Criteria	8
Table 4.34	Chemical and Magnetite Consumption Rates During 24-Hour Demonstration Runs	9
Table 4.35	Kelsey Centrifugal Jig, Best-Test Performance	9
Table 4.36	Carpco Multi-Gravity Separator, Best-Test Performance	9
Table 5.01	Plant Control Summary	11
Table 5.02	Total Estimated Capital Cost for Semi-Works Flowsheet	12
Table 6.01	Standard Economic Assumptions	12
Table 6.02	Operating and Maintenance Labor Costs for Various Operating Philosophies	12

Task 15 Report
List of Tables

	<u>Title</u>	<u>Page</u>
Table 6.03	Capital Requirements for 200 TPH (Product) Plants Operating 7560 Hours per Year	127
Table 6.04	Annual Operating and Maintenance Costs for 200 TPH (Product) Plants Operating 7560 Hours per Year	128
Table 6.05	Advanced Froth Flotation Process Economics 200 TPH Commercial Plant Operating 7560 Hours per Year	129
Table 6.06	Estimated Annual Desulfurization Costs Per Ton of SO ₂ Equivalent For 200 TPH (Product) Advanced Process Plant Addition	132

Task 15 Report
List of Figures

<u>Title</u>	<u>Page</u>
Figure 1.01 Simplified Block Diagram of the POC Process	
Figure 1.02 Pittsburgh No. 8 Seam Coal, Box-Behnken Matrix Results	
Figure 1.03 Upper Freeport Seam Coal, Box-Behnken Matrix Results	
Figure 1.04 Illinois No. 6 Seam Coal, Box-Behnken Test Matrix Results	
Figure 1.05 Pittsburgh No. 8 Seam Coal, Average Performance During 24-Hour Demonstration Run	
Figure 1.06 Upper Freeport Seam Coal, Average Performance During 24-Hour Demonstration Run	
Figure 1.07 Illinois No. 6 Seam Coal, Average Performance During 24-Hour Demonstration Run	1
Figure 2.01 John P. Apel Ohio Coal Testing and Development Center	1
Figure 2.02 Advanced Froth Flotation Proof-of-Concept Module Addition	1
Figure 2.03 Ball Mill Installed in the Proof-of-Concept Module (under construction)	1
Figure 2.04 Column Flotation Cell Installed in Proof-of-Concept Module	1
Figure 3.01 Typical microcel™ Column Flotation Configuration	2
Figure 3.02 Schematic Representations of the Single- and Multiple-Stage Column Flotation Circuits That Were Tested	2
Figure 3.03 Performance Comparison, Single Versus Multiple Stage Laboratory Column Flotation	2
Figure 3.04 Laboratory Column Flotation, Parametric Study Test Results	3
Figure 3.05 Commercial microcel™ Column Flotation Cell	3
Figure 4.01 Flowsheet for Proof-of-Concept Module	3
Figure 4.02 Pittsburgh No. 8 Seam Coal, Heavy-Media Cyclone Performance Curve	5
Figure 4.03 Water-Only Cyclone Performance Curve	5
Figure 4.04 Pittsburgh No. 8 Seam Coal, Mill Circuit Performance	5
Figure 4.05 Pittsburgh No. 8 Seam Coal, Column Flotation Factorial Matrix Results	5
Figure 4.06 Pittsburgh No. 8 Seam Coal, Box-Behnken Matrix Results	5
Figure 4.07 Pittsburgh No. 8 Seam Coal, Average Performance During 24-Hour Demonstration Run	6
Figure 4.08 Pittsburgh No. 8 Seam Coal, Average Mill Circuit Feed and Product Size	6
Figure 4.09 Upper Freeport Seam Coal, Mill Circuit Performance	6
Figure 4.10 Upper Freeport Seam Coal, Box-Behnken Matrix Results	7

Task 15 Report
List of Figures

<u>Title</u>	<u>Page</u>
Figure 4.11 Upper Freeport Seam Coal, Average Performance During 24-Hour Demonstration Run	74
Figure 4.12 Upper Freeport Seam Coal, Average Mill Circuit Feed and Product Size	75
Figure 4.13 Illinois No. 6 Seam Coal, Box-Behnken Test Matrix Results	79
Figure 4.14 Illinois No. 6 Seam Coal, Average Performance During 24-Hour Demonstration Run	83
Figure 4.15 Illinois No. 6 Seam Coal, Average Mill Circuit Feed and Product Size	82
Figure 4.16 Kelsey Centrifugal Jig	94
Figure 4.17 Carpco Multi-Gravity Separator	96
Figure 5.01 Pittsburgh No. 8 Seam Coal, 20 TPH Semi-Works Plant Flowsheet	101
Figure 5.02 Pittsburgh No. 8 Seam Coal, Semi-Works Plant Material Balance	102
Figure 5.03 Upper Freeport Seam Coal, 20 TPH Semi-Works Plant Flowsheet	103
Figure 5.04 Upper Freeport Seam Coal, Semi-Works Plant Material Balance	104
Figure 5.05 Illinois No. 6 Seam Coal, 20 TPH Semi-Works Plant Flowsheet	105
Figure 5.06 Illinois No. 6 Seam Coal, Semi-Works Plant Material Balance	106
Figure 6.01 Sensitivity of Process Economics to Expected, After Tax Rate of Return	130
Figure 6.02 Sensitivity of Process Economics to Operations Schedule	131
Figure 6.03 Sensitivity of Process Economics to Plant Capacity	131

1.0 EXECUTIVE SUMMARY

In 1988, ICF Kaiser Engineers was awarded DOE Contract No. DE-AC22-88PC88881 to research, develop, engineer and design a commercially acceptable advanced froth flotation coal cleaning technology. The DOE initiative is in support of the continued utilization of our most abundant energy resource. Besides the goal of commercialability, coal cleaning performance and product quality goals were established by the DOE for this and similar projects. Primary among these were the goals of 85 percent energy recovery and 85 percent pyrite rejection. Three nationally important coal resources were used for this project: the Pittsburgh No. 8 coal, the Upper Freeport coal, and the Illinois No. 6 coal. Following is a summary of the key findings of this project.

1.1 Bench-Scale Test Results

Bench-scale testing was conducted in order to reduce the technical and engineering related design deficiencies of the proposed advanced froth flotation process. For bench-scale testing, the coarse fraction (1/4 in. x 48 mesh) of the Pittsburgh No. 8 seam coal was precleaned in a water-only cyclone while the Upper Freeport and Illinois No. 6 coals were precleaned in a heavy-media cyclone. The heavy-media cyclone achieved energy recoveries of 95 percent or greater while the water-only cyclone performance was poor, with an energy recovery of only 85 percent.

The clean coal from the coarse gravity-based cleaning circuit was then crushed to 48 mesh x zero and, in the case of heavy-media cyclone cleaning, combined with the natural 48 mesh x zero size fractions of the raw coal. The coarse water-only cyclone clean coal already contained the 48 mesh x zero material. The resulting 48 mesh x zero streams for all three coals were then cleaned in a water-only cyclone. For each coal, water-only cyclone energy recoveries were greater than 95 percent. Pyrite rejections were 28 percent and 31 percent for the Pittsburgh No. 8 and Upper Freeport coal seams, but only 13 percent for the Illinois No. 6 coal seam.

The clean coal from the water-only cyclone operation was classified into 48 mesh x 200 mesh and 200 mesh x zero size fractions for conventional froth flotation testing. Investigators evaluated "grab-and-run" flotation in an effort to produce a clean coal from the flotation "grab" stage of six percent ash or less for all three coals. The Upper Freeport "grab" product met the clean coal ash target while the Illinois No. 6 seam coal "grab" product clearly did not meet the six percent ash criteria. No firm conclusions were reached regarding the "grab" product for the Pittsburgh No. 8 seam coal as the "grab" product ash slightly exceeded six percent.

Grinding circuit evaluations conducted for this project included the comparison of the cleaning performance potential at two different coal grinds, 200 mesh and 325 mesh, using the Pittsburgh No. 8 seam coal. Each of these samples were then cleaned in a 2-inch diameter column flotation cell in order to compare the separation characteristics of the two coal grinds. The results from the column tests indicated that the 325 mesh x zero size fraction liberates significantly more pyrite than the 200 mesh x zero grind. At roughly identical energy recoveries of nearly 96

percent, 36 percent of the pyrite was rejected with the 325 mesh grind while only 25 percent was rejected with the 200 mesh grind.

Column flotation testing at the bench-scale level included extensive testing in a laboratory size column flotation unit followed by 100 pounds-per-hour testing in larger units. At the laboratory level, investigators evaluated whether multiple-stage column flotation could significantly outperform single-stage column flotation. In addition, a 54-point test matrix was developed using a composite Box-Behnken design and conducted on single-stage column flotation. All data obtained during the single versus multiple-stage flotation testing form a relatively narrow band of potential grade-versus-recovery results. Therefore, investigators ruled out a multiple-stage approach for POC operations. The data from the 54-point test matrix indicate that the best results between energy recovery and pyrite rejection occurred between 55 and 63 percent pyrite rejection with energy recoveries of up to 92 percent.

Using the best results from the 100 pounds-per-hour testing of each unit operation and Bilmat, a computer-based material balance program, investigators next developed overall cleaning circuit performance projections in order to assess the potential for meeting the major coal cleaning performance goals. For the Pittsburgh No. 8 seam coal, neither the energy recovery nor the pyritic-sulfur-rejection target of 85 percent was achieved, primarily due to the poor coarse water-only cyclone performance. The Illinois No. 6 seam coal projection indicated a 91 percent pyritic sulfur rejection with a nearly 81 percent energy recovery. For the Upper Freeport seam coal, the projections indicated 78 percent pyrite rejection and 91 percent energy recovery were possible.

Clean coal and refuse slurries were subjected to dewatering tests using pressure filtration, vacuum filtration, and belt filter press techniques. The target moisture for the clean coal was 30 percent while the refuse moisture target was 35 percent. The bench-scale dewatering test results indicated that the clean-coal-moisture goal could be achieved with the Pittsburgh No. 8 and Upper Freeport seam coals using pressure filtration techniques. The Illinois No. 6 seam coal could only be dewatered to 38 percent moisture. Neither the vacuum filtration techniques nor the belt filter press could produce 30 percent clean coal moistures for any of the three coals.

Tests on the refuse samples of each coal indicated that the fine Upper Freeport seam refuse could be dewatered to less than 35 percent moisture using vacuum filtration, pressure filtration, or the belt filter press. Only vacuum filtration could meet the 35 percent target on the Illinois No. 6 refuse, and only pressure filtration was successful on the Pittsburgh No. 8 seam refuse. Despite the lack of success of the belt filter press on these two coals, the belt filter press was recommended for dewatering the refuse stream for all three coals, primarily due to the superior handleability of the belt press refuse cake.

Based on the bench-scale and 100 pounds-per-hour test results, the following conclusions were drawn for the Semi-Works flowsheet:

- The coarse water-only cyclone (1/4 inch x 48 mesh) continued to be included in the plant design. However, a heavy-media cyclone would

be used in the POC and, if successful, be considered for the final Semi-Works plant design.

- The fine (48 mesh x zero) water-only cyclone circuit was maintained in the Semi-Works plant design.
- Conventional froth flotation should be applied separately on the 48 mesh by 200 mesh and the 200 mesh x zero size fractions.
- The raw coal crusher, the precleaned or middlings coal crusher, and ball-mill were to be sized by the equipment manufacturers based on the maximum particle size, the Hardgrove grindability of the feed, the top size requirements for the crushed products, and the throughput tonnage.
- A multiple-stage column flotation circuit was not warranted due to the relatively slight improvement in grade-versus-recovery results when compared to single-stage column flotation results.
- A clean-coal thickener would need to be included in the design to concentrate the advanced froth flotation concentrate.
- A batch-type recessed plate pressure filter would achieve the lowest clean-coal-product moisture. However, a final decision regarding the dewatering of clean coal for the Semi-Works plant design will occur after POC testing is completed on a hyperbaric disk filter.
- Dewatering of the refuse thickener underflow will be accomplished using a belt-filter press.

1.2 Proof-Of-Concept (POC) Scale Test Results

Figure 1.01 presents a simplified block diagram of the POC flowsheet.

As can be seen from Figure 1.01, the 1/4 inch x 48 mesh was cleaned using a heavy-media cyclone with the objectives of recovering 97 percent of the feed coal's energy. The heavy-media-cyclone clean coal was crushed to 48 mesh by zero using a cagepactor crusher, combined with the raw 48 mesh by zero and fed to a water-only cyclone. The water-only cyclone was maximized to recover 97 percent of its feed energy. The water-only cyclone clean coal reported to the ball-mill where it was crushed to 200 mesh by zero and fed to the column flotation cell for final cleaning. Primary performance goals of the POC flowsheet were to achieve 85 percent energy recovery with 85 percent pyritic sulfur removal when compared to the raw coal feed of the plant.

The Pittsburgh No. 8 seam coal from Brooke County, West Virginia; the Upper Freeport seam coal from Somerset County, Pennsylvania; and the Illinois No. 6 seam coal from Salome County, Illinois were the three coals tested. Table 1.01 contains the washability head analyses on a dry basis for the three coals.

Figure 1.01 Simplified Block Diagram of the POC Process

Table 1.01 Head Analysis for Washability Samples				
Coal Seam	% Ash	% Sulfur	% Pyritic Sulfur	Btu/lb
Pittsburgh No. 8	40.38	3.14	2.16	8,292
Upper Freeport	18.12	3.99	2.81	11,975
Illinois No. 6	36.23	4.11	2.75	8,866

Once the heavy-media cyclone, water-only cyclone, and grinding circuits were maximized, testing began to determine the best conditions at which to operate the advanced column flotation cell. The critical operating variables that were evaluated for the column cell included feed rate, aeration rate, frother rate, wash-water rate, frother type, and collector rate. A 16 point, resolution IV fractional factorial experiment was conducted on the Pittsburgh No. 8 seam coal to determine the best conditions for aeration rate, wash-water rate and frother type for the column cell. Results from the fractional matrix testing concluded that the following parameters should remain constant for the column cell throughout the remainder of the POC operations.

- MIBC reagent should be used as the frothing agent.
- An aeration rate of 140 SCFM should be maintained.
- A wash-water rate of 100 gallons per minute should be maintained.

With the heavy-media cyclone and water-only cyclone maximized, and with the best conditions for aeration rate, wash-water rate, and frother type determined for the column flotation cell, investigators conducted a Box-Behnken test matrix on each of the three coals. Figures 1.02, 1.03, and 1.04 show the energy recoveries as a function of ash rejection, pyritic sulfur rejection, and total sulfur rejection for the overall POC circuit while conducting the Box-Behnken test matrices for the Pittsburgh No. 8, Upper Freeport, and Illinois No. 6 coal seams.

After completing the Box-Behnken matrix for each of the three coals, all equipment was configured and all variables were set at the maximum values to conduct the 24-hour demonstration tests. The Pittsburgh No. 8 seam was processed for four days during the first and second week of the demonstration run. Both the Upper Freeport and Illinois No. 6 seams were processed for five days during both the first and second week of the demonstration runs. During the 24-hour demonstration runs, a complete set of samples were collected every eight hours for all the pertinent circuits in operation. Figure 1.05, 1.06, and 1.07 present the Bilmat-adjusted data for the average of all eight-hour sampling periods for the Pittsburgh No. 8, Upper Freeport, and Illinois No. 6 coal seams.

Figure 1.02 Pittsburgh No. 8 Seam Coal, Box-Behnken Matrix Results

Figure 1.03 Upper Freeport Seam Coal, Box-Behnken Matrix Results

For the Pittsburgh No. 8 Seam, the POC recovered 89.5 percent of the raw coal's energy while removing 73.6 percent of the coal's pyritic sulfur. Performance evaluations for the Upper Freeport Seam indicated an overall energy recovery of 87.5 percent, while 76.2 percent of the raw coal's

Figure 1.04 Illinois No. 6 Seam Coal, Box-Behnken Test Matrix Results

pyritic sulfur was removed. For the Upper Freeport Seam, the POC recovered 85.8 percent of the energy and removed 79.4 percent of the pyritic sulfur in the raw coal.

Table 1.02 presents the contributions of each coal-cleaning circuit to total energy loss and pyritic-sulfur removal for each of the three coals. These values are based on the average results obtained during the 24-hour demonstration runs. The heavy-media cyclone circuit for each coal removed the bulk of the pyritic sulfur while losing relatively low amounts of energy. Depending on the coal, the heavy-media cyclone circuit removed 60 to 70 percent of the total amount of pyrite that was removed. Meanwhile, the energy content in the heavy-media cyclone circuit refuse was only 32 to 36 percent of the total energy losses.

Since large amounts of pyrite have been removed prior to the water-only cyclone and the advanced froth flotation circuit, the ratio of pyrite rejection to energy loss is significantly lower for these circuits. For the Upper Freeport Seam, for example, the advanced froth flotation removed 25 percent of the total amount of pyrite that was rejected, and the energy content in the flotation tailings accounted for 71 percent of the total energy losses. Contributing to the lower ratios is the more-difficult-to-clean nature of fine- and ultrafine-particle streams.

Figure 1.05
Pittsburgh No. 8 Seam Coal
Average Performance
During 24-Hour Demonstration Run

Figure 1.06
Upper Freeport Seam Coal
Average Performance
During 24-Hour Demonstration Run

Figure 1.07
Illinois No. 6 Seam Coal
Average Performance
During 24-Hour Demonstration Run

Table 1.02 Contributions to Energy Loss and Pyritic Sulfur Removal* During 24-Hour Demonstration Runs						
Circuit (Size Cleaned)	Pittsburgh No. 8 Coal		Upper Freeport Coal		Illinois-No. 6 Coal	
	Energy Loss	Pyrite Removal	Energy Loss	Pyrite Removal	Energy Loss	Pyrite Removal
Heavy-Media Cyclone Circuit (+48 mesh)	3.8	44.3	2.7	49.4	4.5	55.4
Water-Only Cyclone Circuit (48 mesh x 0)	4.0	16.6	0.9	7.9	2.2	10.4
Advanced Froth Flotation Circuit (200 mesh x 0)	2.7	12.7	8.9	18.9	7.5	13.6
* Values represent the percentages of the raw coal energy content and pyritic sulfur content found in the refuse stream of each circuit.						

Cumulative plant availability during 24-hour demonstration runs for the three coals was 94.9 percent. Individually, plant availabilities for the Pittsburgh No. 8, the Upper Freeport and the Illinois No. 6 coals were 98.0, 97.4, and 89.9 percent, respectively. No downtime encountered during the demonstration runs was attributed to the advanced process equipment.

1.3 Conceptual Design for 20 TPH Semi-Works Plant

The bench-scale and POC-scale test plans were designed to provide investigators with the information necessary to design and engineer a 20 tons-per-hour Semi-Works Facility that incorporates the proposed advanced froth flotation technology and achieves the objectives established for the process. The coal cleaning philosophy that was applied to the project was twofold: first, to remove sulfur and mineral matter at the coarsest size consistent with low subsequent energy losses; and to utilize multiple coal comminution stages to liberate mineral matter and impurities from the desirable coal portion of the raw coal feed stream.

To accomplish this and to meet project goals, the Semi-Works facility includes three stages of coal crushing and grinding operations each followed by a cleaning operation designed to remove the liberated impurities generated by the comminution efforts. Raw coal received at the facility will be crushed to 1/2 inch by zero. The crushed product is separated into two sizes and the 1/2 inch by 48 mesh size fraction is efficiently cleaned in a heavy-media cyclone circuit. The heavy-media cyclone will be configured to effect a high (1.85 to 1.90 S.G.) specific gravity of separation on the coal feed so that little energy is lost.

The heavy-media cyclone clean coal is crushed, in closed circuit, to 48 mesh by zero, combined with the raw 48 mesh by zero size fraction and cleaned in a water-only cyclone circuit to remove impurities liberated by the crushing stage or present in the raw fraction. Again, the water-only cyclone circuit is configured to minimize energy losses, yet remove both pyritic sulfur and mineral matter prior to fine grinding.

The heavy-media- and water-only-cyclone circuits represent commercial proven and available technologies that are practical and effective for their intended use in the process. Significant pyritic sulfur rejection at low energy loss can be expected at this point in the process. The material removed from these operations would be, for many coals, the hardest materials and the most expensive to grind on a per-pound basis.

The water-only cyclone clean coal is introduced into a closed, wet grinding circuit utilizing classification ahead of a horizontal ball mill to prepare a proper ball-mill feed and improve circuit effectiveness. The mill circuit will produce a product of approximately 83 to 85 percent passing 200 mesh that will finally be cleaned in the advanced froth flotation circuit. Thickening, dewatering, and recovery techniques for all circuit products will use commercially available technologies.

The Semi-Works facility will be a fully automated continuous process. State-of-the-art instrumentations and control technologies are included in the proposed design. Five samplers will be provided in order to monitor the plant products as well as internal process streams.

The Semi-Works capital cost estimate of the plant proper is approximately \$10,915,000. Another \$750,000 will be required for the purchase of land, start-up modifications, and working capital.

1.4 200 TPH Commercial Plant Economic Analysis

Based on the capital cost of the Semi-Works plant, the cost for 200 and 500 tons-per-hour facilities were extrapolated. In addition, fixed and variable, first-year operating-and-maintenance costs were estimated for these commercial plants. Table 1.03 presents a summary of these costs for a 200 tons-per-hour (TPH) facility operating 7560 hours per year.

Table 1.03 Capital Requirements and 1st Year Operating and Maintenance Costs for a 200 TPH Advanced Froth Flotation Plant (7560 Hours)			
Construction Capital Requirement	\$59,624,735	\$59,547,893	\$59,669,206
Working Capital Requirement	\$467,723	\$449,603	\$478,500
Fixed Operating and Maintenance Costs	\$5,892,451	\$5,892,451	\$5,892,451
Variable Operating and Maintenance Costs	12,080,238	\$11,158,134	\$12,613,895

In order to compare these values to those of existing facilities and evaluate them on an investment basis, these values were input into an economic model developed by Eos Technologies, Inc. for the U.S. Department of Energy. Based on the above costs and a set of economic assumptions, the model generates the clean coal price required for the investment to generate a user-established, after-tax rate of return. Also, the cost to remove sulfur, on a dollars per ton of SO₂ equivalent, is determined. Table 1.04 presents these values for 200 and 500 TPH commercial facilities as well as the economic assumptions on which the estimates are based.

Table 1.04 Advanced Froth Flotation Economics (Annualized Basis)			
200 TPH Commercial Plant Operating 7,560 Hours per Year			
Cost Item	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Clean Coal Price (\$/MMBtu)	1.49	1.50	1.55
Clean Coal Price (\$/Ton)	40.65	40.27	41.96
Annualized Desulfurization Cost*	\$326.82	\$305.42	\$304.60
200 TPH Commercial Plant Operating 3,456 Hours per Year			
Cost Item	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Clean Coal Price (\$/MMBtu)	1.81	1.81	1.87
Clean Coal Price (\$/Ton)	49.32	48.68	50.63
Annual Desulfurization Cost*	\$477.08	\$442.49	\$435.09
500 TPH Commercial Plant Operating 7,560 Hours per Year			
Cost Item	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Clean Coal Price (\$/MMBtu)	1.38	1.39	1.44
Clean Coal Price (\$/Ton)	37.68	37.30	38.99
Annualized Desulfurization Cost	\$275.27	\$256.95	\$259.84
ECONOMIC ASSUMPTIONS			
Plant Life	20 Years	Inflation Rate	4.0 %
Royalties	None	Corporate Tax Rate	38.0 %
Financing	100% Equity	Rate of Return	10.0 %
* Annual Desulfurization Costs are per ton of SO ₂ equivalent.			

As the table indicates, plant size and operating schedule both significantly affect the costs of coal production and thus, the desulfurization costs. For the Pittsburgh No. 8 coal, for example, desulfurization costs for a 200 TPH (product) plant operating 7,560 hours per year are estimated at \$327 per ton of SO₂ equivalent. For a 500 TPH plant with the same operating schedule, desulfurization costs drop to \$275 per ton. On an average, desulfurization costs decrease by 15 percent for the 500 TPH plants.

Due to the large capital requirements for these advanced plants, operating schedule affects costs to a greater extent than plant size. A typical coal preparation facility operates five days per week, two shifts per day. Maintenance is conducted on the third shift. This operating schedule results in 3456 hours of operation per year and, as the cost estimates reveal, a gross under utilization of facilities. For the Illinois No. 6 coal, a 200 TPH plant operating 7560 hours per year can remove sulfur for about \$305 per ton of SO₂ equivalent. When the same size plant operates, only 3456 hours per year, the desulfurization cost climbs to \$435 per ton.

1.5 Conclusions

Based on the findings of this project, the following conclusions may be drawn.

- The proposed process technology is ready for commercialization. However, the product from the process may require reconstitution in order to be marketable.
- The proposed technology can recover 85 percent of the energy in each of the raw coals while removing 75 to 80 percent of the raw coal pyritic sulfur.
- Clean coal ash values of 7.2 to 10.3 percent, on a dry basis, were achieved with the proposed technology.
- Grinding to levels finer than 85 percent passing 200 mesh will be required to remove 85 percent of the raw coal's pyrite while maintaining 85 percent energy recovery.
- Based on raw coal costs of \$0.80 per million Btu, clean coal price of \$1.50 per million Btu will be required for investments in the proposed technology to earn a 10 percent after-tax rate of return.
- Desulfurization costs, on a dollars per ton of SO_2 equivalent, \$255 to \$275 are estimated for a 500 tons-per-hour commercial facility incorporating the proposed advanced froth flotation process.

2.0 INTRODUCTION

In 1987, the United States Department of Energy's (DOE) Pittsburgh Energy Technology Center completed a study¹ of sulfur emissions from 1300 U.S. coal fired utility boilers. The study found that the bulk of sulfur emissions are attributable to coal produced in areas of Illinois, Indiana, Kentucky, Ohio, West Virginia, and Pennsylvania. These areas contain nationally important coal resources that, in many cases, contain high sulfur levels. Pyritic sulfur content of coals in these areas range from 55 percent to 80 percent according to the DOE study. Since physical coal cleaning can be a cost effective way of removing pyrite from coal, it follows that major reductions in sulfur emissions may be possible by advancing the state-of-the-art of physical coal cleaning technologies.

Partly in response to the findings of this study, the U.S. DOE began the Acid Rain Control Initiative. As part of this initiative, three promising physical coal cleaning technologies were identified for their potential for pyrite removal from coal. Subsequently, the DOE requested proposals from industry, academia, and the research community in order to develop these technologies. In 1988, ICF Kaiser Engineers, Inc. (ICF KE) was awarded DOE Contract No. DE-AC22-88PC88881, to research, develop, engineer and design a commercially acceptable advanced froth flotation technology. A similar project for selective agglomeration technology was completed by the Southern Company Services, Inc. in 1993. Coal Technology Corporation is scheduled to complete the engineering development of advanced cycloning technology in 1996.

The DOE established goals for the characteristics of the products and for the coal cleaning performance of the processes. Primary of these goals were the ability of the processes to recover 85 percent of the raw coal's energy while removing 85 percent of the raw coal's pyritic sulfur. In addition, substantial ash rejections were expected, thus resulting in a low-ash clean-coal product. Table 2.01 presents the goals for the characteristics of the process products. Three nationally important coals were to be used in each of the projects: the Pittsburgh No. 8 seam coal from Ohio, the Upper Freeport Seam coal from Pennsylvania, and the Illinois No. 6 seam coal from Illinois.

Table 2.01 DOE Established Goals For Product Characteristics	
Clean Coal Ash (%)	Less than 6% (dry basis)
Clean Coal Moisture (%)	Less than 30% Surface Moisture
Refuse Moisture (%)	Less than 35% Surface Moisture

In order to accomplish these ambitious goals, ICF KE developed a coal cleaning approach that would utilize already commercial conventional coal cleaning operations followed by a novel application of fine coal grinding and, finally, advanced froth flotation. Commercial coal cleaning approaches could cost effectively remove coarse mineral matter and pyrite with little loss of the coal's heating value. Subsequently, the capacity of the required grinding circuit could be reduced, decreasing the capital, operating and maintenance costs of the proposed process.

In order to properly perform the work required for this project, ICF assembled a team of organizations. Table 2.02 presents this team. Each of these team members provided their valuable expertise in the areas where their experience proved most useful. The cooperation and effort by these organizations was greatly appreciated.

Table 2.02 Team Organized For Advanced Froth Flotation Development Project	
Ohio Coal Development Office (OCDO)	
CONSOL Inc. (CONSOL)	
Babcock and Wilcox (B&W)	
Virginia Polytechnic Institute (VPI)	
EIMCO Process Equipment Company (EIMCO)	
Center for Research on Sulfur in Coal	
Illinois State Geological Survey	
Kentucky Energy Cabinet Laboratory	

The engineering and development effort for the advanced froth flotation process took a task-oriented approach. In Tasks 1 through 8, a project plan was submitted, and a preliminary conceptual design and cost estimates were developed for a 20 tons-per-hour (TPH) Semi-Works facility incorporating the advanced process. Next, critical areas of design-related deficiencies were identified, and a bench-scale test plan was developed in order to address those deficiencies that were most appropriately handled at a small scale. Additionally, component development efforts included extensive column flotation evaluations at the bench-scale. In Task 7, the results of bench-scale and component development efforts were reported and in Task 8, these results were applied to the original process and a Semi-Works design; an updated process design and cost estimate were subsequently developed.

In Task 9, a proof-of-concept (POC) test module was designed in order to address the design deficiencies that could not be appropriately investigated with bench-level testing. The POC was constructed as an addition to the John P. Apel Ohio Coal Testing and Development Center which is located between McConnellsville and Beverly, Ohio. Selected POC related photographs are presented in Figures 2.01 through 2.04. In Tasks 10 through 13, the POC was fabricated and three project coals were tested in the fully automated and integrated facility. The results of POC testing were reported in a Task 14 report. This Task 15 report is the final report related to the advanced froth flotation process-development effort.

2.1 Objectives of the Report

This report is an account of findings related to the Engineering and Development of Advanced Froth Flotation project. The results from bench scale and POC level testing are presented and the important results from this testing are used to refine a conceptual design and cost estimate for a 20 TPH Semi-Works Facility incorporating the final proposed technology.

Figure 2.02 – Advanced Froth Flotation Proof-of-Concept Module Addition

Figure 2.01 – John P. Apel Ohio Coal Testing and Development Center

Figure 2.03 – Ball Mill Installed in the Proof-of-Concept Module (under construction)

Figure 2.04 – Column Flotation Cell Installed in the Proof-of-Concept Module

A flowsheet, design drawings, equipment list, estimated capital costs, operating costs, and maintenance costs are presented for the Semi-Works facility. Economic analyses are developed for the investment potential of implementing 200 and 500 TPH commercial facilities incorporating the final proposed design. Finally, conclusions and recommendations are presented.

2.2 Scope of the Report

This report is a summary of the important findings related to all work conducted in order to develop the advanced froth flotation process. Detailed task related reports are available under separate cover for both the bench-scale test program and the POC-test program. In addition, separate topical reports are available for work conducted as part of this project, but not fully detailed in any of the previously mentioned reports. These are listed below:

- Topical Report No. 1 - Raw Coal Pyrite Liberation Study (Pittsburgh No. 8)
- Topical Report No. 2 - Controlled Comparison of Advanced Froth Flotation Technologies
- Topical Report No. 3 - Pyrite Liberation Study, Illinois No. 6 Seam Coal
- Topical Report No. 4 - Pyrite Liberation Study, Upper Freeport Seam Coal
- Topical Report No. 5 - Trace Element Removal Study
- Topical Report No. 6 - Kelsey Jig and Multi-Gravity-Separator Testing

Finally, a stand-alone "Executive Summary" of this report has also been issued.

2.3 Report Organization

This report is organized into seven sections. Section 1.0 is an executive summary providing all pertinent project information covered in this report.

Section 2.0 is a concise introduction which includes the objectives, scope, and organization of the final report.

Sections 3.0 and 4.0 present the results of bench- and POC-scale testing.

Sections 5.0 and 6.0 present the final conceptual designs of a Semi-Works plant and a 200 TPH commercial plant. The designs include: design philosophy, conceptual flowsheets, material balances, equipment lists, engineering drawings, cost estimates, and economic models.

Section 7.0 summarizes the results of the project and provides recommendations to industry.

3.0 BENCH-SCALE AND 100 POUNDS-PER-HOUR TESTING

Bench-scale and 100 pounds-per-hour testing were conducted in order to reduce the potential for technical and engineering related design deficiencies of the proposed advanced froth flotation process. At the bench-scale level, investigators determined that:

- The potential existed for each coal to be cleaned to a level consistent with the basic project objectives.
- Conventional froth flotation attempts should be conducted separately on 48 mesh by 200 mesh and 200 mesh by zero size fractions.
- Grinding to 325 mesh by zero improved the state of liberation of the coal compared to 200 mesh by zero grinding. Laboratory column flotation results indicated that this difference could be exploited in order to improve the chances of attaining the basic project objectives.
- A number of column flotation units being developed by various groups were equally promising for further study.
- Thickening and dewatering operations of the advanced froth flotation process could be accomplished using commercially available equipment.

Based on the bench-scale test results, investigators felt confident that the proposed advanced froth flotation process had a reasonable chance to succeed. Thus, larger 100 pounds-per-hour testing was then conducted on the major coal cleaning, grinding, and sizing operations envisioned for the process. During this testing, the product from each unit operation was saved, if needed, in order to become the feed for the next unit operation, following the proposed flowscheme of the overall process. At the end of these operations, investigators had a high level of confidence in the potential of the process, and what needed to be accomplished in order to design the fully integrated proof-of-concept (POC) module. The following is a review of the bench-scale and 100 pounds-per-hour testing grouped by major circuits envisioned for the final plant design.

3.1 Gravity-Based Precleaning

Commercial coal cleaning process philosophies for the most part utilize specific-gravity-based coal cleaning approaches in order to clean coal particles larger than 150 microns (100 mesh). On this size material, specific-gravity-based cleaning can be relied on to efficiently remove liberated mineral matter and pyrite. When operating at high specific gravities of separation, removal of mineral matter and pyrite can be accomplished with little loss of the coal's heating value.

On a 100 pounds-per-hour level, investigators evaluated gravity-based coal cleaning separately on two different size fractions: 1/4-inch by 48 mesh and 48 mesh by zero. For the plus 48 mesh size fraction, the originally proposed Semi-Works plant design included a water-only cyclone circuit. While a heavy-media cyclone circuit would more efficiently separate 1/4-inch by 48 mesh coal, there was concern that the high media specific

gravity required for this project would cause media viscosity problem. For the most part, magnetite-based, dense-media systems are limited to recirculating media densities of 1.30 to 1.75 specific gravity. Investigators believed that separations on the order of 1.85 to 2.0 specific gravity would be required for the project, and this range is well suited to water-only cyclone operations.

For bench-scale testing, the coarse fraction of the Pittsburgh No. 8 seam coal was pre-cleaned in a water-only cyclone while the Upper Freeport and Illinois No. 6 coals were pre-cleaned in a heavy-media cyclone. Table 3.01 summarizes the cleaning performance achieved during these tests. The heavy-media cyclone achieved energy recoveries of 95 percent or greater while removing close to 30 percent or more of the pyritic sulfur of the unit operation feed. This was very encouraging and subsequently led investigators to utilize a heavy-media cyclone in the POC plant design. The water-only cyclone performance was poor with an energy recovery of only 85 percent. This was due to the misapplication of a six inch water-only cyclone to the 1/4-inch by 0 coal feedstock. In commercial practice a minimum 14-inch diameter cyclone would be used for this size fraction.

Table 3.01 Coarse Gravity-Based Cleaning Performance During 100 Pounds-Per-Hour Tests			
Coal	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Unit Operation	Water-Only Cyclone	Heavy-Media Cyclone	Heavy-Media Cyclone
Size Fraction	1/4-inch x 0	1/4-inch x 48 mesh	1/4-inch x 48 mesh
Energy Recovery (%)	85.2	99.2	95.6
Pyritic Sulfur Rejection (%)	42.9	29.5	71.1
Ash Rejection (%)	23.6	30.2	49.1

The clean coal from the coarse-gravity-based cleaning circuit was then crushed to 48 mesh by zero and, in the cases of heavy-media cyclone cleaning, combined with the natural 48 mesh by zero size fraction of the raw coal. The coarse-water-only-cyclone clean coal already contained the 48 mesh by zero material. The crushing stage was applied to increase the state of liberation of the coal and impurities in the coarser size fraction.

The resulting 48 mesh by zero streams were then cleaned in a water-only cyclone. Table 3.02 presents the coal cleaning performance of the fine water-only cyclone cleaning circuit for each of the three coals. Energy recoveries for the circuit were greater than 95 percent for each of the three coals. Pyrite rejections were 28 and 31 percent on the Pittsburgh and Upper Freeport seam coals, but only 12 percent on the Illinois No. 6 coal. The fine water-only cyclone operation was maintained in the Semi-Water plant design and included in the POC module. The clean coal from the water-only cyclone operation was classified into 48 mesh by 200 mesh and 200 mesh by zero size fractions for subsequent 100 pounds-per-hour conventional froth flotation testing.

Table 3.02 Fine Gravity-Based Cleaning Performance During 100 Pounds-Per-Hour Tests			
Coal	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Unit Operation	Water-Only Cyclone	Water-Only Cyclone	Water-Only Cyclone
Size Fraction	48 mesh x 0	48 mesh x 0	48 mesh x 0
Energy Recovery (%)	95.5	97.9	99.0
Pyritic Sulfur Rejection (%)	28.2	31.1	12.5
Ash Rejection (%)	7.2	11.6	4.0

3.2 Conventional Froth Flotation Testing

To evaluate the application of conventional froth flotation techniques, laboratory flotation techniques were used to evaluate whether the 48 mesh by zero coal should be cleaned as one size fraction or whether split 48 mesh x 200 mesh/200 mesh x 0 flotation should be employed. Table 3.03 presents results on the Pittsburgh No. 8 seam coal that support the concept of split flotation. Based on these results, all remaining conventional flotation tests for this project were conducted using split flotation.

Table 3.03 Comparison of Split Feed to Single-Size Feed Conventional Froth Flotation Performance		
Flotation Size	48 mesh x 0	Split 48 mesh x 200 mesh/200 mesh x 0
Performance Size	48 mesh x 0	48 mesh x 0 composite
Yield (%)	72.7	81.7
Energy Recovery (%)	93.8	98.3
Clean Coal Ash (%)	9.30	8.20
Total Sulfur (%)	3.70	3.78
Btu per pound	13,180	13,290

Once it was determined that split flotation should be used, 100 pounds-per-hour scale testing was conducted for each coal in order to determine whether the grab-and-run conventional flotation approach could be successful. In grab-and-run flotation, two stages of flotation were attempted. In the first stage, gentle flotation conditions were applied in order to produce a clean coal at or below the plant clean coal specification. Investigators applied the clean coal ash specification of 6 percent in order to judge the success or failure of this stage. The second stage of the grab-and-run would be operated such that a tailings stream of low energy content would be produced. If this approach was successfully applied, the first-stage froth concentrate could be immediately dewatered and directed to product, thus improving the handleability and the dewaterability of the final composite clean coal product. Also by removing the first-stage clean coal and the tailings stream, the subsequent grinding circuit throughput requirements would be reduced, improving the economics of the entire process.

Table 3.04 presents the clean-coal ash values produced in the first stage of conventional froth flotation for each size fraction of the three coals. Based on these results, the grab-and-run flotation approach was abandoned for the Illinois No. 6 coal since the grab product ash content for the two size fractions were well above the six percent target. The Upper Freeport results, on the other hand, clearly exceeded the target ash specification while the results on the Pittsburgh No. 8 seam were borderline in this regard. Based on these results, the grab-and-run flotation approach would only be applied to the Upper Freeport coal for the remainder of bench scale testing. If time permitted, this approach could be tested on both the Upper Freeport and the Pittsburgh No. 8 coals during POC operation.

Table 3.04 "Grab" Product Ash Values From Conventional Froth Flotation						
Coal	Pittsburgh No. 8		Upper Freeport		Illinois No. 6	
Size Fraction	48 x 200	200 x 0	48 x 200	200 x 0	48 x 200	200 x 0
"Grab" Clean Coal Ash (%)	6.55	6.32	4.62	6.09	9.81	14.84
48 x 200 = 48 mesh by 200 mesh; 200 x 0 = 200 mesh by zero						

With the conventional froth flotation circuit configuration determined for each coal, the sized product from the fine water-only cyclone circuit was next processed in 100 pounds-per-hour scale conventional froth flotation utilizing the predetermined circuit configuration. The Upper Freeport middlings concentrate, and the Pittsburgh No. 8 and Illinois No. 6 coal total concentrates were saved for further processing in the 100 pound per-hour grinding circuit. Table 3.05 presents the 100 pounds-per-hour conventional flotation performance results. The results confirmed that conventional froth flotation remained a viable option in regard to minimizing energy loss while gaining some measure of impurities removal, thus reducing the capacity requirements of downstream grinding in advanced froth flotation operations. Conventional froth flotation would be applied to all three coals during POC testing.

3.3 Grinding Circuit Testing

Grinding circuit evaluations conducted for this project included a comparison of the cleaning performance potential with two different coal grinds, 200 mesh and 325 mesh. On a small laboratory scale, a 325 mesh zero sample was produced from the Pittsburgh No. 8 seam coal, conventional froth flotation products using a 2.5 gallon attritor mill. Using a split of the same feedstock, a 200 mesh by zero sample was produced using a 2 gallon laboratory rod mill.

Each of these samples were then cleaned in a 2-inch diameter column flotation cell in order to compare the separation characteristics of the two coal grinds. Table 3.06 presents the results of these tests. It is clear from the data that the 325 mesh by zero coal grind is at an increased state of liberation. At roughly identical energy recoveries of nearly 96 percent, 36 percent of the pyrite was rejected with the 325 mesh grind while only 25 percent was rejected with the 200 mesh grind.

Table 3.05 Final 100 Pounds-Per-Hour Conventional Froth Flotation Performance				
48 mesh by 200 mesh Size Fraction				
Coal	Pittsburgh No. 8	Upper Freeport		Illinois No. 6
Circuit	Rougher Only	Grab-and-Run		Rougher Only
		Grab	Scavenger	
Energy Recovery (%)	98.6	52.5	47.4	99.9
Pyritic Sulfur Rejection (%)	16.6	5.2		1.8
200 mesh by zero Size Fraction				
Coal	Pittsburgh No. 8	Upper Freeport		Illinois No. 6
Circuit	Rougher Only	Grab-and-Run		Rougher Only
		Grab	Scavenger	
Energy Recovery (%)	98.6	38.4	60.9	96.9
Pyritic Sulfur Rejection (%)	37.9	15.4		33.3

The Pittsburgh No. 8 and the Illinois No. 6 coals were the first two coals tested at the 100 pounds-per-hour scale. These coals were each ground to 325 mesh by zero in an effort to maximize the liberation of impurities. Based on conflicts with other DOE-sponsored test programs, however, the DOE and project investigators agreed to change the target grind for all three coals to 200 mesh by zero prior to the Upper Freeport coal grinding efforts at the 100 pounds-per-hour scale. The 100 pounds-per-hour grinding and advanced-froth-flotation testing on the Pittsburgh No. 8 and Illinois No. 6 coals were not repeated at the 200 mesh target grind. The conventional froth flotation concentrates from 100 pounds-per hour testing were used as the feed to mill circuits in all cases. These ground products were saved for column flotation testing, the last unit operation to be tested at 100 pounds-per-hour.

Table 3.06 Grind Size Comparison Using Pittsburgh No. 8 Seam Coal: Laboratory Froth Flotation of 200 mesh x 0 and 325 mesh x 0 Grinds		
Grind Size	200 mesh x 0	325 mesh x 0
Clean Coal		
Ash (%)	4.99	4.05
Total Sulfur (%)	3.30	3.19
Pyritic Sulfur (%)	0.91	0.74
Btu per Pound	13,587	13,567
Energy Recovery (%)	95.9	95.5
Pyritic Sulfur Rejection (%)	26.2	36.4
Ash Rejection (%)	49.7	56.9

3.4 Advanced Column Flotation Testing

Column flotation operations use relatively tall vessels and different bubble generation schemes than conventional froth flotation operations.

The increased vessel height serves to allow higher residence times which also enabling deeper froth layers. Most column flotation cell manufacturers have by now also added froth washing capabilities where clean water flows are introduced into the froth layer in order to reduce entrainment of fine clay particles in the froth concentrate. Bubble generation schemes used in column flotation usually are designed to produce smaller bubbles, or microbubbles, that theoretically allow for improved process selectivity.

Figure 3.01 presents a schematic showing features of the microcel™ column flotation unit developed by the Virginia Institute of Technology. The coal slurry enters the microcel™ through the feed inlet and is introduced at a point below the froth layer, and in a downward direction. Solids then encounter a flow of pulp and air bubbles moving upward, helping to promote efficient bubble-to-particle contact. A downward flow of light spray water is introduced, usually in the froth layer, to minimize entrainment of clay particles in the froth.

A centrifugal pump extracts a predominantly tailings stream from a point near the bottom of the vessel to provide a liquid medium into which a frother and flocculant are introduced. The entire flow passes through external mounted static mixers, whose shearing force produces microbubbles that are then introduced into the column. The use of recirculated tailings as the liquid medium here and the agitation caused by the introduced stream allows for improved recovery of coal particles that have yet to attach to the rising volume of bubbles.

Column flotation testing at the bench-scale level included extensive testing in a laboratory size column flotation unit followed by 100 pound per-hour testing in larger units. At the laboratory level, investigators evaluated whether multiple-stage column flotation was preferential to a single stage. Also, a 54-point test matrix was developed using composite Box-Behnken design and conducted on single-stage column flotation. The results from these two sets of tests allowed investigators to configure the 100 pounds-per-hour tests in order to optimize column flotation performance.

Figure 3.02 presents flow schematics for the six different column flotation circuit configurations evaluated in the laboratory. In the Rougher-Scavenger (RS) configuration, the tailings from the first stage unit are recleaned in a second stage. The concentrates from both stages are combined as circuit product. In the rougher-cleaner (RC) configuration, the first stage concentrate is repulped and then recleaned in the second stage unit, which produces the circuit clean-coal product. The tailings streams from each stage are combined and rejected.

In the rougher-scavenger-scavenger cleaner (RSSC) circuit, the tailings from the rougher stages are recleaned in the second, scavenger stage. The concentrate from the second stage is then repulped and recleaned in the third, scavenger-cleaner, operation.

The rougher-scavenger-cleaner (RSC) configuration also has three stages of cleaning. The rougher tailings are recleaned in the scavenger stage, and the concentrates from these two stages are combined, repulped, and recleaned in a cleaner stage. The cleaner produces the circuit product.

Figure 3.01 Typical microcel™ Column Flotation Configuration.

SINGLE STAGE (SS)

ROUGHER-SCAVENGER (RS)

ROUGHER-CLEANER (RC)

ROUGHER-SCAVENGER-SCAVENGER CLEANER (RSSC)

ROUGHER-SCAVENGER-CLEANER (RSC)

ROUGHER-CLEANER-RECLEANER

Figure 3.02
Schematic representations of the single and multiple stage column flotation circuits that were tested

Finally, in the rougher-cleaner-recleaner configuration, the rougher concentrate is repulped and recleaned in the cleaner stage. The cleaner stage concentrate is again repulped and then cleaned in recleaner stage.

Figure 3.03 compares, for the Pittsburgh No. 8 coal, the energy recovery versus pyritic sulfur rejection relationships for the six circuit configurations. These results were also typical of that produced for the Upper Freeport and the Illinois No. 6 coals.

The data for all of the circuit configurations form a relatively narrow band of potential grade-versus-recovery results. That is, for any level of energy recovery, pyrite rejection may vary by up to six percent depending on the circuit configuration utilized. While the single-stage performance results for the most part fall at the lower end of the grade-recovery band, investigators judged that there was not sufficient increases in pyrite rejections to warrant a multiple-stage column flotation approach.

The fact that all of the column circuits behaved essentially the same, in terms of trade-offs between energy recovery and pyrite rejection, can be explained by developing a complete understanding of the fine particle recovery mechanisms. In conventional flotation circuits, differences in performance can frequently be attributed to wide variations in the nonselective entrainment of fine particles of mineral matter into the froth product. Multiple cleaning stages are generally capable of reducing entrainment, thereby improving the final separation. However, since most flotation columns utilize a counter-current flow of wash-water to prevent entrainment of fines, multiple-column circuits have little advantage for improving performance. The use of wash-water also explains why various columns are capable of achieving similar results. When wash water is properly applied and bubble size distributions are similar, the effectiveness of the separation is primarily controlled by the characteristics of the coal and is relatively independent of the cell used to perform the separation. The results obtained in the present work suggest that single-stage column units are capable of achieving essentially the same metallurgical performance as multiple-stage circuit configurations.

Based upon the previous results, investigators next concentrated efforts on optimizing single-stage laboratory scale column flotation. For this phase of testing, a 54-point parametric test matrix was established using the composite Box-Behnken design principles. Table 3.07 presents the parameters varied during these tests and the levels for each parameter. The full test matrix and detailed results obtained from these tests appear in Appendix A. Feed for these tests was the precleaned Pittsburgh No. 8 coal produced during the 100 pounds-per-hour grinding tests.

Figure 3.03 Performance Comparison, Single Versus Multiple Stage Laboratory Column Flotation

Table 3.07 Test Levels Utilized for Parametric Test Program			
Parameter	Low	Medium	High
Feed Solids (%)	5	10	5
Frother Dosage (#/ton)	0.5	1.5	2.5
Collector Dosage (#/ton)	0.5	1.0	1.5
Feed Rate (ml/min)	50	150	250
Aeration Rate (ml/min)	500	1000	1500
Wash-water Rate (ml/min)	200	400	600

Figure 3.04 presents the energy recovery versus pyritic sulfur rejection relationship revealed from the 54-point test matrix. The separation efficiency, for the separation of energy from pyrite, is also shown versus pyrite rejection. The separation efficiency curve indicates that the best trade-off between energy recovery occurs between 55 and 63 percent pyritic rejection. In this range, energy recoveries up to 92 percent were achieved.

With these promising laboratory results in hand, investigators proceeded with larger scale, 100 pounds-per-hour testing on the three coals. Three different column flotation units were utilized for this stage of the test program. The Pittsburgh No. 8 seam coal was cleaned in an 11.5-inch diameter cell built by the Center for Applied Energy Research (CAER). The Upper Freeport and Illinois No. 6 coals were processed in a 7-inch square column flotation unit built at Michigan Technological University (MTU). After a number of shakedown and optimization tests conducted for each coal, best-test conditions were established. Tests were conducted under these conditions using ground product streams saved from the 100 pound

Figure 3.04 Laboratory Column Flotation, Parametric Study Test Results

per-hour grinding circuit tests. Table 3.08 presents the best results from these tests. These results were somewhat inferior to that achieved in the laboratory flotation units, but promising nonetheless.

Table 3.08 Best Column Flotation Performance from 100 Pounds-Per-Hour Testing			
Coal	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Column Cell Design	CAER	MTU	MTU
Energy Recovery (%)	95.7	94.6	90.2
Pyrite Rejection (%)	40.4	61.2	54.1
Clean Coal			
Ash (%)	4.79	6.15	7.2
Pyritic Sulfur (%)	0.77	0.48	0.36
Btu per pound	13,588	14,664	13,016

During the bench-scale and 100 pounds-per-hour testing previously summarized, different designs of column flotation units were used for testing. In addition, a bench-scale, Round-Robin Test program was completed in order to test on a head-to-head basis competing designs that are either commercially available or in development. The Round Robin evaluation² resulted in the selection of the MTU and the CAER column flotation designs for scale-up and testing at the 100 pounds-per-hour level. The performance of these units, however, could not be maintained

when the units were scaled up from bench-scale to the 100 pounds-per-hour level.

Due to the difficulties experienced with the scale-up of the MTU and CA designs, investigators chose the microcel™ column flotation cell for installation at the POC facility. The microcel™ unit was developed by the Virginia Institute of Technology, and had been successfully scaled up from 2-inch diameter bench-scale units to 10-foot diameter commercial unit. Figure 3.05 presents a commercially applied microcel™ column flotation cell. The microcel™ ranked third in the Round Robin evaluation.

3.5 Cleaning Circuit Projections

Using the best results from the 100 pounds-per-hour testing of each unit operation and Bilmat, a computer-based material balance program, investigators developed overall cleaning circuit performance projections in order to assess the current potential for meeting the major coal cleaning performance goals. Table 3.09 presents these performance predictions compared with the predictions based on washability analyses of the coals. As expected, in each case, the actual coal cleaning results did not match the theoretical performance limits established by the washabilities. For the Pittsburgh No. 8 seam coal, neither the energy recovery nor the pyritic sulfur rejection target of 85 percent was achieved. This can primarily be attributed to the poor coarse water-on-cyclone performance discussed previously. Coarse coal performance problems were subsequently corrected at the POC level.

For the other two coals, one of the performance goals was surpassed in each case by a substantial margin. The Illinois No. 6 projection indicated a 91 percent pyritic sulfur rejection and nearly 81 percent energy recovery. For the Upper Freeport seam coal, the projection indicated that 78 percent pyrite rejection and 91 percent energy recovery were possible. Investigators felt confident that 85 percent energy recovery could be achieved at the POC level for each of the coals and that would result in pyrite rejection closer to 85 percent.

3.6 Thickening and Dewatering

Clean coal and refuse samples generated from the 100 pounds-per-hour testing were subjected to bench-scale testing in order to verify that the fine coal slurries could be adequately thickened and dewatered using commercially-available equipment. The slurries were found to require both cationic and anionic flocculant additions in order to settle the solids and produce a clear supernatant in a reasonable time period. The flocculants used were commercially available with prior applications at coal cleaning plants. These results also indicated that conventional-type thickeners could be utilized. The design criteria developed from the bench-scale tests were used to successfully size the clean coal thickener installed in the POC. The results also allowed verification that the existing refuse thickener was adequately sized for POC operations.

The clean coal and refuse slurries were also subjected to dewatering tests using pressure-filtration, vacuum-filtration, and belt-filter-press techniques. The target moisture for the clean coal was 30 percent compared to a 35 percent target for the refuse. The plant refuse, because

Figure 3.05 – Commercial microcelTM Column Flotation Cell

of coarse and intermediate size cleaning operations, was expected to be 1/4 inch by zero with little concern in meeting the refuse moisture target. The greatest concern was material handleability since very fine refuse tends to stick to chutework.

Table 3.09 Estimated Process Performance of 100 Pounds-Per-Hour Testing						
Performance Parameter	Pittsburgh No. 8		Upper Freeport		Illinois No. 6	
	Bilmat Projection	Wash-ability Limit	Bilmat Projection	Wash-ability Limit	Bilmat Projection	Wash-ability Limit
Energy Recovery (%)	78.1	93.1	91.2	93.0	80.7	90.3
Pyrite Sulfur Rejection (%)	78.1	93.7	78.1	91.6	91.2	93.9
Separation Efficiency (%)	59.6	86.8	69.3	84.6	71.9	84.2
Ash Rejection (%)	89.5	-	75.7	-	87.7	-
Sulfur Rejection (%)	55.9	-	61.1	-	58.6	-

The bench-scale dewatering test results indicated that the clean-coal-moisture goal could be achieved with the Pittsburgh No. 8 seam coal and the Upper Freeport seam coal using pressure-filtration techniques. The Illinois No. 6 seam coal could only be dewatered to 38 percent moisture. Pressure filtration cycles for each of the three clean coals were reasonable at approximately 30 minutes.

The belt press filtration attempts could not produce 30 percent clean coal moistures for any of the coals. Likewise, vacuum filtration was unable to reach the target moisture level except in one case when a steam drying cycle was added during Upper Freeport seam coal testing.

Tests on the refuse samples of each coal indicated that the fine Upper Freeport Seam refuse could be dewatered to less than 35 percent moisture using vacuum filtration, pressure filtration or the belt press. Only vacuum filtration could meet the 35 percent target on the Illinois No. 6 refuse, and only pressure filtration was successful on the Pittsburgh No. 8 seam refuse. Despite the lack of success of the belt press on these two latter coals, investigators recommended the belt press for dewatering the fine refuse stream during POC operations. This was primarily due to the superior handleability of the belt-press refuse cake.

3.7 Application of Bench-Scale and 100 Pounds-Per-Hour Test Results to the Preparation of the Revised Conceptual Semi-Works Flowsheet

Based on the bench-scale and 100 pounds-per-hour test results, investigators revised the originally proposed Semi-Works flowsheet. The basic findings and the conclusions drawn from these findings are summarized below, grouped by the major circuits then envisioned for the Semi-Works plant and the subsequently constructed POC module.

3.7.1 Gravity-Based Coal Cleaning Operations

Investigators were increasingly uncomfortable with water-only cyclone performance characteristics for the 1/4-inch by 48 mesh size fraction and continued to include the coarse water-only cyclone operation in the Semi-Works plant design. A heavy-media cyclone would be used in the POC module, however, and if successfully employed at the required recirculating media conditions, would be considered for the final Semi-Works plant design.

The fine water-only cyclone operation was successfully employed at the 100 pounds-per-hour scale and was maintained in the Semi-Works plant design. The POC module would also contain this unit operation. Each of the above discussed, gravity-based coal cleaning devices could be scaled up to either the POC scale or the Semi-Works scale using established industrial design principles.

3.7.2 Conventional Froth Flotation

Based on bench-scale and 100 pounds-per-hour testing, investigators decided that conventional froth flotation should be applied separately to the 48 mesh by 200 mesh and the 200 mesh by zero size fractions.

3.7.3 Crushing and Grinding

The raw coal crusher and the precleaned or middlings coal crusher were sized based on the maximum particle size and the Hardgrove grindability of the feed, the top size requirements for the crushed products, and the throughput tonnage. In addition, the precleaned or middlings coal crusher design must take into account the high surface moisture content of the feed.

The Gundlach Crusher Company was contacted and given design parameters for each of the three base coals and specific units were proposed. Since conflicting design criteria were obtained during the laboratory-bench-scale testing, a final verification of their applicability would be attempted at the POC module testing.

The grinding circuit was a wet, closed-circuit system with integrated classifying cyclones used to achieve positive control of the ground product top size while minimizing throughput requirements of the mill proper. A wet grinding system has the advantage of lower power requirements compared to dry grinding while a reversed grinding circuit configuration allows the preparation of a proper mill feed in regard to percent solids.

While laboratory tests indicated that increased pyrite rejection was possible without additional energy loss by grinding to 325 mesh (60 microns) prior to advanced froth flotation, the project team and the client agreed, near the end of bench-scale testing, to limit future comminution efforts to a 200 mesh (75 microns) grind. Due to this change in target grind, a tumbling ball-mill replaced the stirred ball-mill operation that was previously proposed for the Semi-Works plant design.

Laboratory test results provided key information that was required for the sizing of the POC ball-mill installation. The Hardgrove Grindability Index of the hardest project coal was provided to the ball-mill manufacturer. In addition, the manufacturer was supplied the coarsest size distribution encountered for the mill circuit feed during bench-scale testing. Finally, a circuit throughput rate of 3.4 TPH was established along with a target grind of 95 percent passing 200 mesh.

Investigators relied on the ball-mill manufacturer to size the ball-mill based on the supplied design criteria. It was hoped at the time that the subsequent ball-mill installation could be operated at reduced throughputs in order to produce a 325 mesh grind for one coal. The grinding circuit design for the final Semi-Works plant would be subject to the findings of the POC mill circuit test program.

3.7.4 Advanced Froth Flotation

The advanced froth flotation approach in this project utilized conventional feed slurry preparation. This began with the repulp of the grinding mill product to 4-6 percent solids. This slurry was delivered to a conditioning tank with two minutes retention time in which chemical reagents were added to condition the column feed. Task 6 results indicated that only conditioner (fuel oil, pine oil, or kerosene) would be required at this stage. Additionally, testing had indicated that a single stage flotation configuration was reasonably effective based on the slight performance improvement measured in multiple-stage configurations. A two-stage flotation system was proposed in the preliminary conceptual design.

Continuous testing of advanced froth flotation in Task 5 provided effective solutions to most required hardware and operational parameters related to advanced froth flotation. Additional POC testing would allow continued refinement of selected operational conditions such as reagent dosage, wash-water, and aeration rates.

3.7.5 Product and Refuse Dewatering

Laboratory and bench-scale testing results indicated that advanced froth flotation concentrate may be too dilute to introduce directly to a final dewatering device. For this reason, a clean coal thickener was included in the POC for verification tests. Clean coal dewatering tests indicated that a batch-type, recessed-plate pressure filter achieved the lowest product moisture of the units tested. These units were also the most costly. In order to achieve the project dewatering goal of 30 percent clean coal moisture, the pressure filter may be the only option. For the POC module, investigators planned to field test a relatively new dewatering unit, the hyperbaric disk filter, which had the potential to approach the clean coal moisture target. A final clean coal dewatering method for the Semi-Works plant would be based on the POC results.

Proper clean coal and refuse thickener performance required the addition of both anionic and cationic polymers. Dewatering of the refuse thickener underflow was accomplished in continuous belt filters as opposed to the batch-type pressure filters proposed in the preliminary conceptual design. Belt pressure filtration required polymer addition in order to improve throughput rates. While not achieving final moisture objectives, testing

indicated that the belt press was the only dewatering unit of those test that could produce a reasonably handleable cake. Combined with coarse refuse products that would be generated in precleaning operations, total plant refuse product moisture would not exceed 35 percent, thus meeting this dewatering objective. Finally, thickening and dewatering test results indicated that the above discussed performance levels could be achieved on both the clean coal and refuse products while also producing clean, recyclable supernatant and effluent streams. Given that the related Coal Surface Control Project results³ did not suggest a significant surface control schemes related to improving process performance, no such advanced techniques were proposed in the POC. Subsequently, the success of conventional thickening and dewatering techniques indicated that there was no need for water purification systems and these were not used in the POC.

1.0 PROOF-OF-CONCEPT (POC) SCALE TEST RESULTS

Based on the results and analysis of bench-scale testing, investigators felt confident that sufficient information was available to proceed with the development of a proof-of-concept (POC) test module. The basic objectives of the POC test module were to verify, on a larger and continuous basis, the findings of bench-scale testing and to try to resolve any remaining design deficiencies related to the advance froth flotation process. Results from POC testing could then be used to finalize the conceptual design for a 20 TPH Semi-Works plant incorporating this technology.

The POC plant was constructed as an addition to the State of Ohio's John P. Apel Ohio Coal Testing and Development Facility (OCTAD) located between Beverly and McConnellsville, Ohio. OCTAD is a 30-50 TPH coal cleaning research facility that contained much of the pre-cleaning circuitry required for the POC. A separate bay was added to OCTAD to house additional equipment required for the POC module. Additionally, modifications were made to OCTAD equipment and process streams in order to accommodate and tie in all required unit operations.

1.1 POC Configuration

Figure 4.01 presents the POC flowsheet, and distinguishes the equipment added to the OCTAD facility in order to complete the POC configuration.

1.1.1 Raw Coal Crushing and Sizing

Raw coal was crushed in three stages from as large as 6-inch by zero to 1/4-inch by zero and then stored in a 200 ton capacity raw coal bin. A weigh feeder metered the raw coal at pre-selected rates to a bucket elevator that raised the coal to the top of the plant and dropped the coal onto a raw coal screen utilized for oversize protection. The raw coal screen, fitted with 1/4" square opening panels, diverted coarse oversize to a two-roll crusher. The 1/4 inch x 0 screen underflow reported along with the roll crusher throughput to the raw coal sump.

1.1.2 Gravity-Based Cleaning and Intermediate Crushing

The raw coal pump pumped 1/4" x 0 material to a deslime sieve/screen combination for sizing at 48 mesh. The plus 48 mesh material was mixed with recirculating media and pumped to a 15-inch diameter heavy-media cyclone. The cyclone products passed over drain and rinse sieve/screen combinations in order to recover magnetite for reuse. The refuse screen discharge was dewatered in a vertical, basket-type centrifuge and reported to the refuse conveyor. The heavy-media cyclone clean coal was crushed to 48 mesh by zero in a double-cage, hammer mill. The mill product was recirculated to the raw coal sump, forming a closed crushing circuit whereby the deslime screen underflow, sized at 48 mesh by zero, was the eventual outlet.

The 48 mesh x 0 deslime screen underflow reported to the water-only cyclone feed sump and was pumped to two six-inch diameter water-only cyclones. The cyclone overflow reported to the classifying cyclone sump while the cyclone underflow reported to the refuse thickener.

4.1.3 Conventional Froth Flotation

The classifying cyclone sump could pump either to the mill classifying cyclone sump, when by-passing conventional froth flotation, or to a ten-inch classifying cyclone modified to make a 200 mesh separation. The classifying cyclone overflow and underflow reported to separate sumps so that split froth flotation could be utilized. The 48 mesh x 200 mesh/200 mesh x 0 split flotation circuitry provided the option of grab-and-run flotation or normal single-stage flotation on each size fraction. In grab-and-run flotation, clean coal, middlings, and refuse streams were generated. In single stage flotation, only middlings and refuse streams were generated. Clean coal and refuse streams were directed to separate thickeners. The middlings stream, in either case, was directed to the mill classifying cyclone sump.

4.1.4 Fine-Grinding Circuit

Primary components of the fine-grinding circuit were three six-inch diameter classifying cyclones and a 6 feet diameter by 4 feet conical ball-mill. The ball-mill discharge combined with new feed in the mill classifying cyclone sump to effectively close the grinding circuit. The sump contents were pumped to the classifying cyclones to effect a 200 mesh size separation. The cyclone overflow reported to the column flotation feed sump, and the cyclone underflow reported to the conical ball-mill.

4.1.5 Advanced Froth Flotation

The column flotation feed sump contents were pumped to a conditioning tank where kerosene was added as a collector. The tank drained by gravity to the 6-feet diameter advanced column flotation cell where air and frother reagent were introduced into a re-circulated tailings stream. Clean coal exited the top of the column cell and reported to a clean-coal thickener. Refuse discharged near the bottom of the cell through an automatic level control valve. This flow reported to a refuse thickener.

4.1.6 Thickening and Dewatering

As described earlier, coarse (1/4" x 48 mesh) refuse reported to a basket-type centrifuge and discharged to a collecting conveyor. Clean-coal and refuse (48 mesh x 0) product streams were collected in separate thickeners. The clean-coal thickener underflow was pumped to either a high-G, solid bowl centrifuge, or a hyperbaric disk filter. Due to the inability to get the hyperbaric filter running continuously, it was only used during early stages of the Pittsburgh No. 8 seam coal testing and not during any of the demonstration runs.

The refuse-thickener underflow was pumped to the refuse thickener of a nearby commercial coal cleaning plant. The commercial plant refuse thickener underflow was pumped to fine refuse settling ponds. These ponds were periodically dredged and the settled solids were disposed of in an approved refuse impoundment system.

4.2 Test Coals

The three coals (Pittsburgh No. 8, Upper Freeport, and Illinois No. 6) that were tested for the POC were not acquired from the same mining operations as those tested during the bench-scale work. For the POC test work, the Pittsburgh No. 8 seam coal was obtained from the Windsor Coal company located in Brooke County, West Virginia. The Upper Freeport seam coal was supplied by Camelot Coal Company located in Somerset County, Pennsylvania, and the Illinois No. 6 coal was obtained from the Kerr-McGee Coal Corporation located in Saline County, Illinois. Different mining operations were used for the POC test coals due to mine closures, UMWA contract disputes, or logistic problems. Table 4.01 contains the washability head analyses of the three coals used for the POC testing. Complete washabilities for the coals may be found in Appendix B.

Table 4.01 Head Analyses for Washability Samples (Dry Basis)				
Coal Seam	% Ash	% Sulfur	% Pyritic Sulfur	Btu/lb
Pittsburgh No. 8	40.38	3.14	2.16	8,292
Upper Freeport	18.12	3.99	2.81	11,975
Illinois No. 6	36.23	4.11	2.75	8,866

In addition, Appendix B presents washability data regarding weight recovery, ash, total sulfur, and pyritic sulfur for the three coals used for the POC testing.

4.3 POC Test Plan

The primary objective of the POC test plan was to demonstrate 85 percent energy recovery with 85 weight percent pyritic sulfur rejection on the Pittsburgh No. 8, Upper Freeport, and Illinois No. 6 coal seams based on run-of-mine coal quality. Other objectives include:

- Obtaining pyritic-sulfur rejection, ash rejection, and coal recovery data of conventional precleaning processes.
- Obtaining material balance data for scale-up design purposes.
- Demonstrating the ability to dewater fine coal product to 30 weight percent surface moisture and refuse product to 35 weight percent surface moisture.
- Demonstrating extended operability and reliability of the process facility.
- Measuring power requirements and reagent usage to estimate operating costs.
- Determining operating cost of the process in order to support estimates for commercial-scale plants.

All three coals were tested with minus 200 mesh material as feed to the column flotation cell. The Pittsburgh No. 8 seam coal was also to be tested on minus 325 mesh material as feed to the advanced column flotation cell, however, the ball-mill circuit was unable to produce this fine-size material.

Precleaning was conducted on all three coal seams with each unit operation maximized, if possible, to recover 97 percent (± 1 percent) of the size fraction energy value. Specifically, the following unit operations were maximized:

4.3.1 Heavy-Media Cyclone (1/4 in. x 48 mesh)

The heavy-media cyclone circuit was maximized for all three coal seams by varying the circulating media gravity. Tests were conducted using four different circulating gravities for the Pittsburgh No. 8 and Upper Freeport coals. Based on experience gained from the first two test coals, it was only necessary to test three different circulating gravities on the Illinois No. 6 coal seam to maximize the performance of the cyclone.

4.3.2 Water-Only Cyclone Circuit (48 mesh x 0)

The water-only cyclone circuit was maximized for the Pittsburgh No. 8 seam coal by varying the water-only cyclones apex diameters, the vortex finder diameters, and the vortex finder lengths. Once the proper vortex finder diameter and length were determined for the Pittsburgh No. 8 seam coal, it was only necessary to vary the apex diameters on the Upper Freeport and Illinois No. 6 coals.

4.3.3 Split Conventional Flotation (48 mesh x 0)

Split conventional flotation (48 mesh x 200 mesh and 200 mesh x 0) was conducted on all three coal seams. Frother and collector dosages were varied in an effort to maximize this circuit. However, this circuit was eventually by-passed. The decision to by-pass this circuit is further discussed in Section 4.4, POC Operations Summary.

4.3.4 Ball-Mill/Classifying-Cyclone Circuit

Tests to optimize the ball-mill/classifying-cyclone circuit to produce the desired coal grind were conducted on the Pittsburgh No. 8 and Upper Freeport seam coals. Ball-mill RPM, media size, feed rate, and percent solids were varied. In addition, classifying cyclone feed rate, vortex finder diameter, and apex diameter were varied in an effort to obtain the desired size distribution of 95 percent minus 200 mesh at 20-25 micron mass mean particle size. Despite the many tests and numerous parameters that were varied, the circuit was unable to produce the desired size distribution. The inability to produce the target grind in the ball-mill circuit is further discussed in Section 4.4, POC Operations summary.

4.3.5 Advanced Column Flotation Circuit

Once the precleaning and grinding circuits were maximized, testing was conducted on the column flotation cell with the objective of obtaining at least 85 percent pyritic sulfur rejection at 85 percent total plant energy

recovery based on run-of-mine coal quality for each of the three coal seams. For the Pittsburgh No. 8 seam coal, a fractional factorial experiment matrix and a Box-Behnken design matrix were conducted on the column flotation cell. A total of 33 column flotation tests were conducted varying feed rate, air rate, frother rate, collector rate, and wash-water rate. On the Upper Freeport and Illinois No. 6 seam coals, only a Box-Behnken design matrix was performed. Twenty-one column flotation tests were conducted on the Upper Freeport seam coal and 19 column flotation tests were conducted on the Illinois No. 6 seam coal. During the column flotation testing on the Upper Freeport and Illinois No. 6 coal seams, feed rate, collector dosage, and gas hold-up were varied.

After evaluating all the column flotation test data for each of the three coals, the best unit operation parameters were determined and the plant was configured to match these parameters for the extended operability and reliability demonstration run. The extended demonstration run for the Pittsburgh No. 8 seam consisted of two back-to-back, four days-per-week, 24 hours-per-day operation for a total of eight 24-hour operating days. The extended demonstration run for both the Upper Freeport and Illinois No. 6 coal seams consisted of two back-to-back, five days-per-week, 24 hours-per-day operation for a total of ten 24-hour operating days. During the extended demonstration run, the following parameters were recorded:

- Mill classifying cyclone feed flowrate
- Column flotation cell feed flowrate
- Column wash-water flowrate
- Pressure readings on the mill classifying cyclones, water-only cyclones, and heavy-media cyclone
- All reagent rates
- Circulating media specific gravity on the heavy-media cyclone circuit
- Plant feed rate
- Number of sample increments collected for each sample

One of the secondary objectives of the test program was to demonstrate the ability to dewater fine coal to 30 weight percent surface moisture using a hyperbaric filter and to dewater refuse product to 35 weight percent surface moisture using a belt-filter press. However, neither the hyperbaric filter nor the belt-filter press was used during the 24-hour demonstration runs. The decision not to use these units is further discussed in Section 4.4, POC Operations Summary.

4.4 POC Operations Summary

Modifications to the OCTAD facility started the first week in August 1992 and were completed at the end of January 1993. A summary of the POC operations follows. A schedule of activities for the operating phase is shown in Table 4.02.

Table 4.02 POC Test Schedule		
Activity	Begin	End
Start-up Activities	4 Feb 1993	2 March 1993
Pittsburgh No. 8 Seam Precleaning Maximization	2 March 1993	26 March 1993
Pittsburgh No. 8 Seam Column Testing	29 March 1993	24 August 1993
Pittsburgh No. 8 Seam Demonstration Run	31 March 1993	14 Sept. 1993
Upper Freeport Seam Precleaning Maximization	27 Sept. 1993	6 Oct. 1993
Upper Freeport Seam Column Testing	7 Oct. 1993	29 Oct. 1993
Upper Freeport Seam Demonstration Run	7 Nov. 1993	19 Nov. 1993
Illinois No. 6 Seam Precleaning Maximization	6 Dec. 1993	7 Dec. 1993
Illinois No. 6 Seam Column Testing	8 Dec. 1993	20 Dec. 1993
Illinois No. 6 Seam Demonstration Run	3 Jan. 1994	14 Jan. 1994

The test procedure used for the operating phase of the POC testing first consisted of allowing the test facility to stabilize to assure steady-state operation. For the heavy-media cyclone and water-only cyclone maximization tests, the test facility was allowed to stabilize 30 minutes before sampling the appropriate streams. The conventional flotation circuit was allowed to stabilize for 60 minutes before sampling was conducted. A longer stabilization time of 120 minutes was required for the grinding circuit to reach steady-state operation. The column flotation circuit was allowed to stabilize for 60 minutes if only the collector dosage was adjusted. If the grinding circuit was changed, or if the frother dosage to the column was adjusted, this circuit was given 120 minutes to stabilize. Once the various circuits reached steady-state operations, sampling was conducted per ASTM requirements. The heavy-media cyclone, water-only cyclone, and grinding circuits were sampled for 45 minutes while the conventional flotation circuits were sampled for 60 minutes. A minimum of 13 sample increments were collected for each sample stream.

The testing schedule developed for the POC was extremely aggressive. In many cases, three to four tests were performed during one day of testing generating numerous samples to be analyzed by the laboratory. The laboratory was required to have the samples that were collected from the previous day analyzed by 7:00 a.m. each morning in order to determine what testing should be conducted that day. At the beginning of the Pittsburgh No. 8 seam program, numerous analytical errors were suspected by the team members. As a result, it was decided to stop the test program to determine what could be done to improve the laboratory results and still maintain the overnight analytical results. The team came to the following conclusions.

- In many instances, the amount of material that was being collected was quite large, especially for the slurry samples. To solve this problem, it was decided to take less sample increments without compromising ASTM standards.

- The 8 mm thick plastic drum liners that were used to line the 55-gallon drums in which the samples were collected proved to be, in many cases, not strong enough to resist rough handling of the samples, resulting in the breakage of many of the drum liners. In addition, the plastic drum liners were bulky and presented handling difficulties for the laboratory technicians. To eliminate this problem, 20-gallon plastic drums were purchased that did not require drum liners.
- Certain sample preparation procedures were not being performed adequately. These procedures were evaluated and corrected by Standard Laboratory.

Once the above measures were implemented, a test was conducted to determine if the results from the laboratory were now accurate. This test consisted of collecting three sub-samples from six main samples from the POC process. Specifically, three sub-samples were collected from the following process streams:

- Deslime Screen Underflow (702)
- Water-Only-Cyclone Overflow (708)
- Water-Only-Cyclone Underflow (717B)
- Conventional Flotation Feed (712B)
- Conventional Flotation Concentrate (713B)
- Conventional Flotation Tailings (714B)

These samples were then shipped to Standard (STD), CONSOL Inc. (CONSOL), and American Electric Power (AEP) laboratories for comparison. As can be seen from Table 4.03, STD results do not compare favorably with CONSOL or AEP results. However, there is a good comparison between CONSOL and AEP results.

Based on this laboratory comparison, an engineer from ICF KE visited Standard Laboratory to observe their laboratory procedures. From the visit, it was determined that Standard Laboratory needed to change their QA/QC program. In doing so, Standard Laboratory began incorporating additional "check" samples of known quality into their QA/QC program, especially "check" samples that contained high percentages of ash, total sulfur, and pyrite sulfur. After these changes, laboratory results improved and the test program was resumed.

During testing on the Pittsburgh No. 8 coal, concerns regarding the steady-state operation of the various POC circuits were raised by team members. As a result, the test program was once again stopped to evaluate these concerns. Tests were conducted on the heavy-media cyclone, water-only cyclone, and ball-mill/classifying cyclone circuits to determine whether additional time was required for these circuits to reach steady-state operation. To evaluate this, the test facility was operated for four continuous hours. After each hour of operation, a complete set of samples was collected around the circuits in question. This resulted in four sets of samples taken at one hour intervals. Each of the four sets of samples was analyzed to determine if the performance of the circuits changed from one hour to the next hour. The performance of both the heavy-media cyclone and water-only cyclone were compared, using probable error plots, after one hour and after four hours of operation. The

probable error plots showed that the performance of both the heavy-media cyclone and the water-only cyclone were virtually the same after one hour of operation and after four hours of operation.

Table 4.03 Laboratory Comparison				
Analysis	Sampler	STD/CONSOL	CONSOL/AEP	STD/AEP
ASH %	702	-1.14/(-)	1.07/(-)	-0.07/(+)
	708	-0.85/(+)	0.31/(+)	-0.54/(+)
	712B	-2.58/(-)	0.57/(+)	-2.02/(-)
	713B	-1.57/(-)	-0.41/(+)	-1.98/(-)
	714B	-3.71/(-)	0.52/(+)	-3.19/(-)
	717B	-2.23/(-)	1.10/(-)	-1.13/(-)
SULFUR%	702	0.29/(-)	0.05/(+)	0.34/(-)
	708	0.18/(+)	-0.01/(+)	0.08/(+)
	712B	0.34/(-)	-0.11/(+)	0.23/(-)
	713B	0.48/(-)	-0.16/(+)	0.32/(-)
	714B	0.20/(+)	-0.08/(+)	0.15/(+)
	717B	0.07/(+)	0.24/(-)	0.31/(-)
BTU PER POUND	702	194.0/(-)	-151.0/(-)	43.0/(+)
	708	249.0/(-)	17.0/(+)	266.0/(-)
	712B	172.0/(-)	24.0/(+)	148.0/(-)
	713B	-167.0/(-)	15.0/(+)	-182.0/(-)
	714B	480.0/(-)	-148.0/(-)	332.0/(-)
	717B	333.0/(-)	-325.0/(-)	8.0/(+)
STD - Standard Laboratories, Inc. CONSOL - CONSOL Inc. Laboratory AEP - American Electric Power Central Coal Lab				

Samples taken of the ball-mill/classifying-cyclone circuit over the four hour period indicated that pyritic sulfur was being concentrated in the classifying-cyclone underflow. This was due to the nature of the separating device.

A classifying cyclone makes its separation based on particle size and specific gravity. Denser particles of the same size will be classified at a finer cutpoint in classifying cyclones. The difference between the specific gravity of coal and pyrite is approximately four specific gravity units. Therefore, if coal is being sized by the classifying cyclones at 74 microns, then the pyrite is being sized significantly finer. In essence, the ball-mill became a "holding tank" for liberated pyritic sulfur since the classifying cyclone underflow is recirculated to the ball-mill. To remedy this problem, a Krebs Varisieve was installed and used in conjunction with the classifying cyclones. Since the Varisieve

makes a separation based on size alone, fine pyrite could be bled away from the ball-mill and to the advanced flotation circuit.

With the conclusion of the testing for steady state, the unit operation testing restarted. Conventional flotation tests were conducted on the Pittsburgh No. 8, Upper Freeport, and Illinois No. 6 coal seams. Testing indicated that no "grab-and-run" product (product that met or exceeded the quality requirements of the final facility product) could be produced on either the 48 mesh x 200 mesh or the 200 mesh x zero size fractions for any of the three coals. Tests were also conducted on the 48 mesh x 200 mesh and the 200 mesh x zero to determine if 95 percent energy recovery could be realized. On the Pittsburgh No. 8 seam coal, only one test on the 48 mesh x 200 mesh size fraction produced the desired energy recovery. For the Upper Freeport coal seam, none of the tests on the 48 mesh x 200 mesh size fraction produced the desired energy recovery, while on the 200 mesh x zero size fraction, one test produced the desired energy recovery. Two tests on the 48 mesh x 200 mesh size fraction for the Illinois No. 6 coal seam produced the desired results. However, no tests on the 200 mesh x zero size fraction produced the desired energy recovery. Even though on a few of the tests it was possible to produce 97 percent energy recovery, the team decided to eliminate the conventional flotation cells from the flowsheet for the following reasons:

- Residual frother and collector in the froth products which eventually reported to the column flotation cell resulted in the inability to control the column flotation cell. In fact, the column cell, in most cases, was producing a froth product with no reagent addition.
- There was concern that the conventional flotation cells could not consistently produce the required 97 percent energy recovery.
- The large amounts of collector and frother being used was being concentrated in the facilities' clarified water resulting in operational problems with other circuits.

The desired grind from the ball-mill circuit of 95 percent minus 200 mesh and 90 percent minus 325 mesh was never achieved on any of the coals tested. Tests to improve the grind were conducted on both the Pittsburgh No. 8 and Upper Freeport coal seams by varying ball-mill rotational speed, ball charge, and feed rate. Ball-mill rotational speed and ball charge proved to have very little influence on the fineness of grind. However, the feed rate to the ball-mill had a significant impact on the fineness of the ball-mill grind. Testing revealed that to obtain 90 percent minus 200 mesh, less than one TPH would have to be fed to the column flotation cell. It was decided by the team that this low feed rate was not practical to demonstrate the POC properly. A more practical column feed rate of approximately 2 TPH was chosen. At this feed rate, a grind of 82 percent to 85 percent minus 200 mesh was achieved. Considering the results that were obtained from the ball-mill circuit, the test work that was originally planned on 90 percent minus 325 mesh was eliminated. The poor grinding results that were obtained from the ball-mill can be attributed to the larger than anticipated recirculating load from the classifying cyclones. A larger ball-mill would have been required to produce the desired grinding of 95 percent minus 200 mesh.

The advanced column flotation cell was tested in detail for the Pittsburgh No. 8 seam coal. A fractional factorial experimental matrix was conducted to determine the major parameters that influenced the operation of the column flotation cell. The major parameters were determined to be: feed rate, air holdup, and collector rate.

After the factorial tests determined the major parameters, a Box-Behnken test matrix was conducted on all three of the coals. The results of each Box-Behnken matrix was then analyzed and the best operating parameters were used for the demonstration operation for each of the three coals.

The clean-coal filter that was to be used in the POC was a hyperbaric-type disc filter. The filter was leased from KHD and was not suited for continuous 8 hour-per-day operation. After the filter was installed, numerous modifications to seals and the filter discharge system were completed. The discharge system on the filter, which originally consisted of a rotating valve, was replaced by a double knife gate system. This work was completed by POC operations staff with the support and guidance of KHD service personnel. The two knife gates on the filter discharge system form a separate chamber that could be pressurized and depressurized in isolation from the main filter chamber for the purposes of solids removal.

With both knife gates closed, dewatered coal is collected above the top knife gate while the discharge chamber is pressurized through a link with the vessel chamber. Using timer sequencing, the top gate opens allowing the coal to fall by gravity into the discharge chamber. The top gate closes, and the discharge chamber is depressurized before the bottom gate opens to allow the coal to discharge to a collecting conveyor. The bottom gate closes and the batch cycle is repeated.

Proper sealing around both knife gates is critical to the continuous, successful operation of this operation. Leakage of the lower seal during discharge-chamber pressurization or leakage of the top seal during filter cake discharge each result in high compressed-air consumption and, subsequently, a loss in chamber pressures. Reduction of chamber pressures normally result in higher cake moistures, and a downward spiral in performance is virtually unavoidable.

Generally after short periods of operation (five to 20 minutes), either or both of the seals would begin leaking. Leakage continued even with manpower-intensive efforts to keep the seals clean during cycling. With the seals leaking, the internal pressure within the filter decreased to as low as 1 bar (15 PSI) resulting in an increase in cake moisture. Eventually, the wet cake would bridge over the discharge chute plugging the unit. Representatives from KHD were at the site numerous times in an effort to repair the seal problems within the unit and the discharge system. Different valve seals were tried with little success. In fact, the valve seals on average may have lasted five hours before they would need replaced. The installation of new valves seals would require approximately eight hours. Under the best operating conditions with new valve seals, grab samples indicated that the filter cake surface moisture was in the range of 25 to 28 percent. After many weeks of work trying to correct the problems with the hyperbaric filter, it was decided by the team to discontinue its operation and use the Sharples solid bowl

centrifuge to dewater the clean coal. The resultant clean coal moisture using the Sharples centrifuge was in the 35 to 40 percent range.

A refuse belt-filter press was to be used in the POC testing to dewater the refuse thickener underflow. The start-up of the belt-filter press progressed smoothly after a larger anionic flocculant pump and a new cationic pump were installed. After the belt-filter press was operational, researchers discovered that the performance of the column flotation cell began to deteriorate. Upon further investigation, it was discovered that the feed to the column flotation cell was flocculated. The large amount of flocculant that was required for proper operation of the belt-filter press was resulting in residual flocculant being retained in the circulating clarified water, affecting the performance of the column flotation cell. To remedy the problem, the team decided to eliminate the belt-filter press from the POC circuit and pump the refuse thickener underflow to AEP's refuse impoundment.

During the 24-hour demonstration runs, a complete set of samples was collected every eight hours for all the pertinent circuits in operation. Samples of the plant feed, plant clean coal, and plant refuse were also collected. Specifically, the following samples were collected during the demonstration runs.

- Plant Feed
- Deslime Screen Underflow
- Heavy-Media-Cyclone Clean Coal
- Heavy-Media-Cyclone Refuse
- Water-Only-Cyclone Overflow
- Water-Only-Cyclone Underflow
- Clean Coal-Thickener Overflow
- Plant Clean Coal
- Refuse Thickener Feed
- Ball-Mill Feed
- Ball-Mill Discharge
- Column Flotation Feed
- Column Flotation Concentrate
- Column Flotation Tailings

In addition, all downtime and the reason for the downtime was recorded. Table 4.04 lists the number of minutes lost and the reason for the outage for all three coals.

The availability of the POC was calculated by subtracting downtime from total available minutes, multiplying by 100, and dividing by the total available minutes. The Pittsburgh No. 8 seam was processed for four days for both weeks of the demonstration run. Both the Upper Freeport and Illinois No. 6 seams were processed for five days during both weeks of the demonstration run. A total of 40,320 total minutes were thus available for operations. The availability of the POC for each coal seam was as follows: Pittsburgh No. 8 - 98.0 percent; Upper Freeport - 97.4 percent; and Illinois No. 6 - 89.9 percent. The POC availability for the combination of all three periods was 94.9 percent. The advanced process equipment, including the ball mill, the advanced flotation cell, and ancillary operations related to these units did not cause any of the downtime experienced during POC operations.

Table 4.04
Operational Downtime During 24-Hour Demonstration Runs

COAL SEAM	DATE	MINUTES LOST	DESCRIPTION
Pittsburgh No. 8	8/31/93	6	Miscommunication with operator.
Pittsburgh No. 8	9/02/93	2	Refuse belt misalignment switch.
Pittsburgh No. 8	9/03/93	56	Bucket elevator feed chute plugged.
Pittsburgh No. 8	9/07/93	69	Plant start-up.
Pittsburgh No. 8	9/07/93	5	Heavy-media pump not pumping.
Pittsburgh No. 8	9/08/93	3	Raw coal conveyor down.
Pittsburgh No. 8	9/10/93	89	D&R screen motor grounded.
Upper Freeport	11/07/93	36	Plant start-up.
Upper Freeport	11/07/93	10	Bucket elevator feed chute plugged.
Upper Freeport	11/08/93	116	Coal thickener full feed rate too high.
Upper Freeport	11/09/93	34	Bucket elevator plugged.
Upper Freeport	11/11/93	9	Bucket elevator feed chute plugged.
Upper Freeport	11/12/93	52	Bucket elevator feed chute plugged.
Upper Freeport	11/14/93	42	Plant start-up.
Upper Freeport	11/16/93	2	Raw coal belt misalignment switch.
Upper Freeport	11/17/93	35	Power failure (storm).
Upper Freeport	11/18/93	4	Bucket elevator feed chute plugged.
Upper Freeport	11/18/93	32	Cagepactor jog-button grounded.
Upper Freeport	11/18/93	5	Cagepactor jog-button grounded.
Illinois No. 6	01/02/94	18	Plant start-up.
Illinois No. 6	01/04/94	2	Timer tripped.
Illinois No. 6	01/04/94	4	Timer tripped.
Illinois No. 6	01/04/94	4	Timer tripped.
Illinois No. 6	01/04/94	5	Interlock shut down - no faults.
Illinois No. 6	01/05/94	2	Operator error.
Illinois No. 6	01/06/94	12	Power failure (very cold).
Illinois No. 6	01/09/94	72	Start-up and H.M. pump down.
Illinois No. 6	01/09/94	476	Cagepactor motor grounded.
Illinois No. 6	01/10/94	4	Raw coal belt - MCC fault.
Illinois No. 6	01/11/94	188	Raw coal pump plugged.
Illinois No. 6	01/11/94	21	Raw coal chute plugged.
Illinois No. 6	01/11/94	123	Oversize in raw coal pump.
Illinois No. 6	01/12/94	71	Oversize in raw coal pump.
Illinois No. 6	01/12/94	109	Oversize in raw coal pump.
Illinois No. 6	01/12/94	80	Heavy-media pump failed.
Illinois No. 6	01/12/94	169	Oversize in raw coal pump
Illinois No. 6	01/14/94	85	Oversize in raw coal pump.

4.5 POC Results Summary

Investigators developed a very ambitious test plan for the POC operations that included a step-by-step approach that basically followed the coal through the POC plant. For each coal, the heavy-media cyclone was first tested to determine the lowest specific gravity at which this unit could be operated while maintaining a target performance level of 97 percent energy recovery. Next, while operating the heavy-media cyclone at this pre-determined specific gravity, the water-only cyclone configuration was varied in order to achieve the highest pyrite rejection consistent, again, with a performance target of 97 percent energy recovery.

The heavy-media cyclone and the water-only cyclone operations were then operated at those pre-determined operating parameters, and conventional froth flotation testing was initiated. For reasons previously discussed in Section 4.4, conventional froth flotation was eventually dropped from the POC process for all three coals. Subsequently, grinding circuit testing was completed followed by advanced froth flotation testing. Finally with the maximized process configuration defined by the above described testing, demonstration testing was completed at or near the end of each coal's testing period. Following are the results of these tests for each coal.

4.5.1 Pittsburgh No. 8 Seam Coal Testing

The Pittsburgh No. 8 seam coal was the primary testing coal used for POC operations. Because of the ambitious test plan established for POC operations, certain tests could only be performed with one coal and the results of these specific tests were used to guide investigators in the conduct of related work on the other two coals. The Pittsburgh No. 8 Seam was thus used to verify the heavy-media cyclone hardware configuration, the water-only cyclone vortex configuration, and the air rate, wash-water rate, and frother type related to the advanced froth flotation process. Also, the clean-coal hyperbaric filter and the refuse filter press were only tested on this coal.

Table 4.05 presents the average Pittsburgh No. 8 raw coal quality of samples extracted during POC operations.

Table 4.05 Pittsburgh No. 8 Seam Coal, Average Raw Coal Quality		
Analysis	Basis of Analysis	
	As-Received	Dry
Moisture (%)	6.92	-
Ash (%)	37.80	40.61
Total Sulfur	2.76	2.97
Pyritic Sulfur	1.92	2.06
Btu Per Pound	7,675	8,246

Heavy-Media Cyclone

The heavy-media cyclone maximization was a relatively simple process since the cyclone performance was previously verified during OCDO test operations. The heavy-media cyclone performance is independent of the feed coal characteristics as long as operations are within solids throughput limitations. Tonnage throughputs during all POC operations were at the low end of these limits.

The investigators' goal was to operate the recirculating media at the lowest specific gravity that recovered 97 percent of the energy that was introduced into the heavy-media cyclone. Four different recirculating media specific gravities were tested on the Pittsburgh No. 8 seam coal. Table 4.06 presents the results of these heavy-media cyclone maximization tests. At a 1.70 specific gravity, the cyclone recovered 97 percent of the feed coal's energy. Significantly, 70 percent of the feed ash was rejected to the cyclone reject, and the clean coal ash was 11.2 percent. Based on these results, a 1.70 recirculating media specific gravity was used for all remaining Pittsburgh No. 8 seam coal POC operations. Figure 4.02 presents the performance curve for the heavy-media cyclone at a 1.70 recirculating media specific gravity.

Table 4.06 Pittsburgh No. 8 Seam Coal, Heavy-Media Cyclone Performance		
Run Number	Specific Gravity	Energy Recovery (%)
93030803	1.70	97.0
93030804	1.75	97.8
93030805	1.80	98.9
93030806	1.85	98.2

Figure 4.02 Pittsburgh No. 8 Seam Coal, Heavy-Media Cyclone Performance Curve

The Ep curve indicates excellent performance for the heavy-media cyclone and a high differential specific gravity, the difference between the recirculating and the separation specific gravities. While the low Ep of 0.03 was expected, the 0.18 differential specific gravity was somewhat surprising. The high differential explains the resulting high energy recovery that was achieved at the relatively low recirculating density. Based on these excellent results, investigators concluded that the existing cyclone hardware configuration would suffice for all three project coals.

Water-Only Cyclone

With the heavy-media cyclone recirculating media being controlled at a 1.70 specific gravity, the water-only cyclone was maximized next. The performance of a water-only cyclone can be varied by changing various cyclone hardware including the vortex finder length and diameter, the apex diameter, and the feed inlet size. For the Pittsburgh No. 8 seam coal, all except the feed inlet were varied in order to find the best combination of cyclone orifices. On the two subsequent base coals, only the apex diameter was varied.

Table 4.07 presents the cyclone configuration installed during the Pittsburgh No. 8 seam coal testing and select results for these configurations. Investigators targeted a 97 percent energy recovery for this unit operation. From these results, investigators selected the configuration installed during test 7 for the remainder of the Pittsburgh No. 8 seam coal testing. This configuration was selected due to the 98 percent energy recovery and the superior clean-coal ash result. The vortex installed during this test was used for all remaining POC operations.

Table 4.07 Pittsburgh No. 8 Seam Coal, Water-Only Cyclone Configurations and Performance Results							
ID #	Run Number	Vortex Length (inch)	Vortex Diameter (inch)	Apex Diameter (inch)	Energy Recovery (%)	Clean Coal	
						Ash (%)	Total Sulfur (%)
1	93031002	7.0	3.0	1.0	98.0	20.0	2.64
2	93031701	14.0	2.5	1.0	89.6	17.6	2.80
3	93031901	10.5	3.0	1.0	99.9	21.3	2.94
4	93032201	14.0	2.5	1.0	49.1	19.4	2.48
5	93032202	14.0	2.5	1.0	*	19.7	2.56
6	93032302	7.0	3.0	1.0	77.6	17.0	2.67
7	93032501	7.0	3.0	0.625	98.0	15.8	2.93
8	93032502	7.0	3.0	0.050	*	17.6	2.81
* Yield determined by Ash balance greater than 100 percent, could not calculate							

Figure 4.03 presents the water-only cyclone performance curve achieved with the selected cyclone configuration. The specific gravity of separation was 1.73 and the resulting E_p was 0.23. These were acceptable results and were consistent with general expectations of water-only cyclone performance on 48 mesh by zero sized material.

Figure 4.03 Water-Only Cyclone Performance Curve

Conventional Froth Flotation

From the bench-scale test results investigators concluded that split 48 mesh x 200 mesh/200 mesh x 0 froth flotation would be employed for all three coals in POC operations.

At the bench-scale, tests on the grab-and-run approach to conventional froth flotation on the Pittsburgh No. 8 seam coal were inconclusive, and investigators conducted POC scale tests in order to further investigate this possibility. Two runs were attempted, and the results are summarized in Table 4.08. In order to judge the success of grab-and-run flotation, investigators targeted a grab product quantity of 6 percent coal ash, which is consistent with the overall clean coal product quality target for this project. As you can see from the table, this ash level was not approached for the Pittsburgh No. 8 seam coal and thus the grab-and-run flotation approach was dropped from consideration.

Investigators next attempted to run rougher only conventional froth flotation in order to produce a middling product for further processing in the advanced grinding and flotation circuits, and a high ash refuse stream to be rejected from the process. Split flotation was again used and five tests were conducted. The results from these tests are summarized in

Table 4.09. On the 48 mesh x 200 mesh size fraction, investigators were successful in achieving the 97 percent energy recovery target in test number 4. Despite high flotation reagent dosages, however, this energy recovery target could not be realized on the 200 mesh x 0 size fraction. At this point in the test program, investigators re-evaluated the practicality of utilizing conventional froth flotation in this advanced process. Since the grab-and-run configuration was not successfully employed, and due to concerns that the high reagents dosages required in conventional froth flotation may affect downstream performance of the advanced column flotation cell, conventional flotation was dropped from further consideration for the Pittsburgh No. 8 seam coal. These and other problems with the conventional froth flotation operations of the POC were previously described in the POC operations summary section of this report.

Table 4.08 Pittsburgh No. 8 Seam Coal, Attempts At Grab-and-Run, Conventional Flotation					
A Bank: 48 mesh x 200 mesh Size Fraction					
Run Number	Frother Dosage (ml/min)	Collector Dosage (ml/min)	Air Rate	Product Quality	
				Ash (%)	Sulfur (%)
93031001	1.8	2.3	Low	11.4	3.19
93031002	0.0	3.5	Low	10.1	3.45
B Bank: 200 mesh x 0 Size Fraction					
Run Number	Frother Dosage (ml/min)	Collector Dosage (ml/min)	Air Rate	Product Quality	
				Ash (%)	Sulfur (%)
93031001	1.8	2.3	Low	25.7	2.39
93031002	0.0	3.5	Low	20.1	2.26

Grinding Circuit

With the heavy-media cyclone and water-only cyclone operating at the predetermined conditions and the conventional froth flotation cells bypassed, investigators next attempted to maximize the grinding circuit configuration. During these tests, the mill classifying cyclone vortex and apex diameters, the mill cyclone inlet pressure, the mill circuit feedrate and the ball-mill charge were all varied. The detailed results from these tests are presented in Appendix B.

None of the variations that were tested were successful in achieving the target grind of 95 percent passing 200 mesh. Figure 4.04 presents the relationship between mill circuit feedrate and the product mean particle size. There was a strong relationship between these variables, unfortunately indicating that the target grind was only possible at very low ball-mill feedrates. This would, in turn, require a substantial reduction in the POC plant capacity. Investigators decided to maintain at least two tons-per-hour feed to the advanced column flotation unit.

Figure 4.04 Pittsburgh No. 8 Seam Coal, Mill Circuit Performance

Table 4.09 Pittsburgh No. 8 Seam Coal, Conventional Single-Stage Froth Flotation Results						
A Bank: 48 mesh x 200 mesh Size Fraction						
Test I.D. #	Run Number	Frother Dosage (ml/min)	Collector Dosage (ml/min)	Energy Recovery (%)	Clean Coal	
					Ash (%)	Sulfur (%)
1	93032201	5.2	20	60.0	11.4	3.03
2	93032202	5.2	30	63.0	10.4	2.95
3	93032302	5.2	41	95.6	9.7	2.88
4	93032501	2.5	30	98.2	10.4	3.18
5	93032503	2.5	30	96.6	9.5	2.96
B Bank: 200 mesh x 0 Size Fraction						
Test I.D. #	Run Number	Frother Dosage (ml/min)	Collector Dosage (ml/min)	Energy Recovery (%)	Clean Coal	
					Ash (%)	Sulfur (%)
1	93032201	5.2	15	33.5	26.2	2.02
2	93032202	5.2	20	60.7	30.2	2.08
3	93032302	5.2	60	89.9	24.2	2.42
4	93032501	2.5	40	55.8	15.0	2.00
5	93032503	5.0	40	84.3	18.3	1.96

Table 4.10 presents the circuit configuration selected for subsequent POC testing. The cyclone configuration was maintained for the remainder of POC operations with all three test coals.

Table 4.10 Pittsburgh No. 8 Seam Coal, Best Mill Classifying Cyclone Configuration	
Vortex Diameter (inches)	1½
Apex Diameter (inches)	5/8
Cyclone Feed Pressure (psig)	36

Advanced Froth Flotation

Investigators determined that the critical operating variables that should be evaluated during POC operations were: feed rate, aeration rate, frother rate, wash-water rate, frother type, and collector rate. In order to find the best conditions at which to operate the column flotation unit, a 16-point, resolution IV fractional factorial experiment was designed to evaluate the major interactions between these six variables. This factorial test matrix was used to determine the best conditions for aeration rate, wash-water rate, and frother type during the Pittsburgh No. 8 coal testing. These identified conditions would then become standard for all remaining column testing during POC operations including that of the two subsequent coals.

Figure 4.05 Pittsburgh No. 8 Seam Coal, Column Flotation Factorial Matrix Results

While conducting the factorial matrix, samples were collected such that total plant performance could be evaluated. All data from the factorial matrix and the subsequent Box-Behnken test matrices were metallurgically balanced using the commercially available Bilmat Material Balance program developed by the Canadian Center for Mineral and Energy Technology. Figure 4.05 presents the energy recovery versus pyrite rejection relationship for the overall plant. Complete test data for these tests may be found in Appendix B. Test points number 16 and 13 on the figure were considered suspect as major data adjustments were required to balance the data set. Of the remaining tests, test number 18 appeared to result in the best balance between energy recovery and pyrite rejection. Table 4.11 presents the conditions at which test 18 was conducted.

Table 4.11 Pittsburgh No. 8 Seam Coal, Best Operating Region Based on Factorial Matrix Results	
Column Cell Feed Rate (TPH)	4
Aeration Rate (SCFM)	140
Frother Rate #/ton	1.4
Wash-water Rate (GPM)	130
Frother Type	MIBC
Collector Rate #/TON	0.5

Based on the results of the factorial matrix testing, investigators concluded that MIBC frother reagent should be used throughout the remainder of POC operations and an aeration rate of 140 SCFM should be maintained. While test 18 utilized a wash-water rate of 130 gallons per minute, investigators observed generally slight performance changes between this level and 40 gallons per minute. Therefore, a rate of 100 gallons per minute was used for the remainder of POC operations. With these three parameters set for the remainder of POC operations, including the next two coals, a second experiment was designed to determine the best operating levels for frother rate, collector rate, and feed rate.

Statistical analyses of the test data obtained during the factorial matrix was carried out using a commercially available software package from the Stat-Ease Corporation known as Design-Expert. This program was subsequently used to design the Box-Behnken test matrix for the Pittsburgh No. 8 coal. In this second, statistically-designed test matrix, column feed rate, frother rate and collector rate were each varied at three levels. All other operating variables were held constant during these tests. Table 4.12 presents the Box-Behnken test matrix experimental conditions. The statistical matrix design program suggested that three tons-per-hour should be the center point for feed rate. Due to concerns of poor mill grind, however, investigators modified this variable's center point to two tons-per-hour as shown in the table. This would allow a finer coal grind and, subsequently, increased pyrite liberation.

Table 4.12 Pittsburgh No. 8 Coal, Box-Behnken Text Matrix			
Run Number	Column Feed Rate (tph)	Collector Dosage (lb/ton)	Frother Dosage (lb/ton)
1	1.0	1.00	1.12
2	2.0	0.50	1.92
3	2.0	1.50	1.12
4	3.0	1.50	1.52
5	3.0	1.00	1.12
6	2.0	1.00	1.52
7	1.0	1.00	1.92
8	2.0	1.00	1.52
9	1.0	1.50	1.52
10	1.0	0.50	1.52
11	3.0	0.50	1.52
12	2.0	1.50	1.92
13	3.0	1.00	1.92
14	2.0	0.50	1.12
15	2.0	1.00	1.52

With other unit operations operating at the best predetermined conditions, the Box-Behnken matrix was implemented for the Pittsburgh No. 8 seam coal in the advanced froth flotation cell. During these tests, sampling was conducted throughout the plant so that performance of each major circuit and overall plant performance could be evaluated. All test runs were performed in random order to minimize experimental bias. Several replicate tests were also conducted to provide a check on the reproducibility of test procedures and assay determinations.

In order to obtain a fully consistent data set prior to statistical analyses, analytical data were evaluated and adjusted using the BILMAT material balance program.

Figure 4.06 shows the energy recoveries as a function of ash rejection, pyritic sulfur rejection, and total sulfur rejection for the column flotation cell. Complete data for these tests appear in Appendix B. Although the flotation tests were conducted over a wide range of operating conditions, most of the experimental data points were found to fall within a single grouping of data. These results indicate that several different combinations of operating parameters can be used to achieve the same level of separation performance. This implies that other factors (e.g., column capacity, operating cost, maintenance considerations, etc.) should be used to select the preferred column operating point. In any case, the Box-Behnken test data indicate that a clean coal concentrate can be readily obtained at a 75 percent ash rejection, 35 percent pyritic sulfur rejection and 95 percent energy recovery.

Figure 4.06 Pittsburgh No. 8 Seam Coal, Box-Behnken Matrix Results

For mathematical modeling purposes, the test levels for each variable were coded as -1, 0 and +1 to represent the lower, middle and upper settings. The coded factors were obtained using the expression:

$$\text{Coded Factor} = 2 [\text{Uncoded Value} - \text{Middle Value}] / [\text{Upper value} - \text{Lower Value}]$$

For example, feed rate settings of 1, 2 and 3 TPH would be represented by the following coded factors using this nomenclature system.

$$\begin{aligned} \text{Low} &= 2 [1-2] / [3-1] = -1 \\ \text{Middle} &= 2 [2-2] / [3-1] = 0 \\ \text{Upper} &= 2 [3-2] / [3-1] = +1 \end{aligned}$$

Bilmat-adjusted data sets were input into the Design-Expert software package. The first step in the statistical analyses involved the development of empirical relationships between the column operating parameters and column response (e.g., energy recovery, ash rejection, pyritic sulfur rejection). Only quadratic or linear models were selected since they reduced model complexity and generally provided good correlations. In general, the fitting coefficients obtained from the linear regression models were found to be statistically more significant than those obtained using the quadratic models. The linear coefficients tended to provide a better indication of the overall magnitude of the influence of each test variable on column performance; however, as indicated by higher correlation coefficients, the quadratic regression model typically provided a better overall fit to the experimental data. For this reason, the quadratic expression was deemed to be the most appropriate model for constructing the response surface plots.

Full details of the statistical analysis of the column flotation matrices for all three coals is presented in the Task 14 Report⁴ related to this project. The coefficients for the linear regression model are summarized for the Pittsburgh No. 8 coal in Table 4.13. These coefficients have been reported in terms of coded factors so that their magnitudes can be easily compared. According to these data, energy recovery was found to increase with feed rate, frother dosage and collector dosage. Ash rejection increased with feed rate and collector dosage, but decreased with frother dosage. In contrast, pyritic sulfur rejection increased with frother dosage, and decreased with feed rate and collector dosage. These results indicate that changes in feed solids rate had the largest impact on energy recovery, ash rejection and pyritic sulfur rejection.

Table 4.13 Pittsburgh No. 8 Seam Coal, Coded Coefficients for the Linear Regression Model						
Test Variable	Units	Low Value	High Value	Energy Recovery	Ash Rejection	Pyritic Rejection
Main	***	***	***	+94.695	+70.23	+32.68
Feed Rate	tph	1.0	3.0	+1.516	+3.28	-2.68
Frother	lb/ton	1.12	1.92	+0.389	-1.04	+1.17
Collector	lb/ton	0.50	1.50	+1.055	+0.26	-1.49

The next step in the statistical analysis involved the development of quadratic regression models relating energy recovery, ash rejection and pyritic sulfur rejection as functions of the independent variables of the Box-Behnken test matrix. These expressions are presented below.

$$\begin{aligned} \text{Energy Recovery} = & 72.743 + 12.449 (\text{Feed Rate}) + 7.4415 (\text{Frother}) + \\ & 3.8987 (\text{Collector}) - 1.7746 (\text{Feed Rate})^2 - 2.8724 (\text{Frother})^2 - 1.6483 (\text{Collector})^2 - 0.94375 (\text{Feed Rate}) (\text{Frother}) - 2.4000 (\text{Feed Rate}) (\text{Collector}) + \\ & 4.1500 (\text{Frother}) (\text{Collector}) \end{aligned}$$

$$\begin{aligned} \text{Ash Rejection} = & 118.56 - 12.537 (\text{Feed Rate}) - 33.651 (\text{Frother}) - \\ & 27.167 (\text{Collector}) - 1.5775 (\text{Feed Rate})^2 + 0.56250 (\text{Frother})^2 + 19.520 (\text{Collector})^2 + 16.481 (\text{Feed Rate}) (\text{Frother}) - 2.9250 (\text{Feed Rate}) (\text{Collector}) - 3.6250 (\text{Frother}) (\text{Collector}) \end{aligned}$$

$$\begin{aligned} \text{Pyritic Rejection} = & 84.19 - 23.411 (\text{Feed Rate}) - 7.3731 (\text{Frother}) - \\ & 48.838 (\text{Collector}) + 3.8787 (\text{Feed Rate})^2 - 4.6172 (\text{Frother})^2 + 16.465 (\text{Collector})^2 + 5.6750 (\text{Feed Rate}) (\text{Frother}) - 3.4100 (\text{Feed Rate}) (\text{Collector}) + 12.988 (\text{Frother}) (\text{Collector}) \end{aligned}$$

In these expressions, feed solids rate is reported in units of TPH and the dosages of collector and frother are given in units of lb/ton. As compared to the linear regression models, these quadratic expressions tended to provide a much better fit between the predicted responses and the experimentally-measured responses.

From the quadratic models, three separate response-surface plots were constructed for each of the dependent variables, representing feed rates of 1.0, 2.0 and 3.0 TPH. These plots are presented in Appendix B. At the lowest feed rate, an increase in either frother or collector dosage increased the energy recovery. The increase in recovery with increasing collector dosage can be attributed to an enhancement in coal hydrophobicity produced by the collector adsorption. The increase in recovery with frother dosage can be attributed to either (i) a decrease in bubble size which improved the flotation kinetics or (ii) an increase in froth stability which improved the ability of the column to carry particles into the froth launder. However, as the feed rate increased from 1.0 to 3.0 TPH, the energy recovery actually increased and became relatively insensitive to changes in reagent conditions. Since higher feed rates typically reduce coal recovery, other phenomena are believed to be responsible for the increase in recovery with increasing feed rate. It is possible that the higher feed rates to the grinding circuit resulted in a slightly coarser grind size which responded better to froth flotation. Unfortunately, no particle size measurements were taken during the parametric study to evaluate this possibility.

Response surface plots for ash rejection and pyritic sulfur rejection obtained during the parametric testing indicates that the relationship between column response and the various operating parameters is non-linear and very complex. In general, the best overall rejections of mineral matter were typically obtained at the highest and lowest collector dosages. These trends appear to contradict previous work which indicated that high collector dosages would be detrimental to pyrite rejection. The data also indicate that mineral matter rejection increased with frother dosage, particularly at the highest feed rate of 3.0 TPH. This trend became much less pronounced at the middle feed rate of 2.0 TPH, and nearly disappeared (or reversed slightly) at the lowest feed rate of 1.0 TPH. An increase in either the frother or collector dosage would normally increase the coal recovery and decrease the overall rejection of mineral matter. Unfortunately, no direct correlation could be established in the present work between energy recovery and the rejections of ash and pyritic sulfur for the Pittsburgh No. 8 coal. An explanation for these unexpected trends could not be found.

The project team assembled at the POC facility in order to discuss the results from the Box-Behnken experiment and to establish the operating conditions for the 24-hour demonstration run. Table 4.14 presents the teams recommendation, which was subsequently implemented. Gas holdup was substituted for frother dose as a controlled variable for the Pittsburgh No. 8 demonstration run.

Table 4.14 Pittsburgh No. 8 Seam Coal, Column Operating Conditions Established for the Demonstration Run			
Plant Feed Rate (tph)	Column Feed Rate (tph)	Collector Dosage (lb/ton)	Gas Hold-up Rate (%)
3.1	2.0	1.0	24

Gas holdup is the fraction of the volume between two different levels in the column cell that is comprised of air. Gas holdup is a function of the

physical characteristics of the slurry (which may be simplified to percent solids for all practical purposes in column cell applications), the gas rate, and bubble size. If the gas rate and the slurry characteristics remain constant, gas holdup is directly proportional to frother dosage. Investigators decided, immediately prior to the Pittsburgh No. 8 coal 24-hour demonstration run, to control gas holdup rather than frother dosage in the column cell. This was admittedly a risk since both column flotation test matrices varied frother dosage rather than gas holdup rate. Investigators felt, however, that since some difficulty in maintaining consistent frother rates had been experienced during the column cell testing, column flotation performance may be more consistent by controlling gas holdup in an automated, closed-loop control scheme. This was judged a good alternative to simply setting a single frother pump speed, and then assuming that frother addition, on a pounds per ton basis, would remain constant.

24-Hour Demonstration Run

After completing the Box-Behnken experiments on the key operating parameters of the column flotation operation, investigators had all the information required in order to configure the POC for the 24-hour demonstration tests. For the Pittsburgh No. 8 seam coal, the plant was operated continuously for two 4-day periods separated by a 3-day weekend. Sampling periods for the demonstration tests were eight hours long and three samples were collected each day. Thus, over the eight days of operation 24 complete sets of data were obtained. Each set of data included the information necessary to verify the performance of each coal cleaning device as well as the total plant performance. Detailed logs were taken in order to account for any plant downtime so that plant availability could be assessed. All equipment was configured and all variables were set at the maximum values as described previously in this section.

The analytical data from the demonstration tests were entered into the Bilmat Material Balance program in order to establish an estimated material balance for each test and an average for the entire eight day period. This program adjusted the values of all analytical results in order to arrive at a strict metallurgical balance for all measured parameters. For the Pittsburgh No. 8 seam coal, only small ash value adjustments were made, on average, for all measured process streams except for the column flotation feed. This average value was reduced by eight percent. All other ash values were adjusted, on average, by two percent or less. This indicates a very good fit of the ash data and investigators thus feel confident in the final results.

Figure 4.07 presents the Bilmat-adjusted data for the average of all 24 sampling periods. Data for each of the test periods are provided in Appendix B. The coarse and fine gravity-based coal cleaning circuits performed as expected with energy recoveries of 96.2 and 95.9 percent. Pyrite rejection in the coarse cleaning circuit was 44.3 percent while 29.8 percent pyrite rejection was achieved in the fine-cleaning circuit. The average grind for the mill-circuit feed and product samples are shown graphically in Figure 4.08. Similar data for all 24 test periods are presented in Appendix B. The mill circuit feed sample had a mean particle size of 193 microns and a D_{50} of 161 microns. The mill-circuit product

Figure 4.07
Pittsburgh No. 8 Seam Coal
Average Performance
During 24-Hour Demonstration Run

particle size averaged 85 percent passing 200 mesh with a D_{50} of 23 microns.

Figure 4.08 Pittsburgh No. 8 Seam Coal, Average Mill Circuit Feed and Product Size

The energy recovery in the advanced column flotation cell was 97.1 percent and 32.4 percent of the pyrite was rejected. Overall, the plant recovered 89.5 percent of the raw coal's energy and rejected 73.6 percent of the pyritic sulfur of the raw coal. This performance obviously does not meet the target of 85 percent energy recovery, 85 percent pyrite rejection. Contributing to the non-performance was the coarser grind from the ball-mill circuit. Also, it is obvious that, had the energy recovery been lowered to the target of 85 percent, more pyrite would have been rejected. In fact, by throwing away 5 percent of the raw coal, energy recovery would drop to 85 percent, and pyrite rejection would increase to 74.9 percent. This would be an inefficient way of removing sulfur, compared with lowering the specific gravity of the heavy-media cyclone circuit for instance. It follows then, that at the target energy recovery of 85 percent, at least 74.9 percent pyrite rejection can be achieved. Unfortunately, this still does not meet the project target.

Table 4.15 compares the basic performance targets established for this project and the results achieved for the Pittsburgh No. 8 seam coal. Energy recovery was the only parameter for which the target was achieved. Laboratory grinding and froth flotations results (Table 3.06) indicated that finer mill-circuit grind will likely improve the pyritic sulfur rejection results and the product ash. It is not likely, however, that the project goals would have been reached even if the target coal grind had been achieved. In order to reach the targets for the Pittsburgh No. 8 seam coal, it may be necessary to grind to 325 mesh or finer.

Unfortunately, though investigators had hoped to attempt a 325 mesh grind during this project, the mill circuit purchased for the POC operation could not achieve this grind, and this part of the project was not carried out.

Operation of a hyperbaric disk filter during the Pittsburgh No. 8 seam phase of the POC operations indicated that the clean-coal product moisture target of 30 percent may be attainable. The hyperbaric filter produced a clean-coal cake with moisture values ranging between 25 percent and 30 percent. Unfortunately, operating problems with this system would not allow continuous operation and also required excessive manpower to maintain and operate the filter. For these reasons, the operation of the hyperbaric disk filter was abandoned before any demonstration runs were initiated. The clean-coal moisture in Table 4.15 resulted from the operation of the high-g centrifuge, which is not recommended for the final Semi-Works plant design.

Table 4.15 Pittsburgh No. 8 Seam Coal, Demonstration Run Project Goals Versus Average Results		
	TARGET	ACTUAL (AVERAGE)
Energy Recovery (%)	85	89.5 (85 ¹)
Pyritic Sulfur Rejection (%)	85	73.5 (74.9 ¹)
Clean-Coal Ash (%)	6	7.7
Clean-Coal Moisture (%) - dry basis	30	36.4
Refuse Moisture (%)	35	10.0 ²
¹ By rejecting 5 percent of the raw coal, these results would be achieved.		
² Plus 48 mesh refuse only; minus 48 mesh refuse was slurried to impoundment.		

The reject moisture presented on Table 4.15 is that of the coarse heavy-media cyclone reject only. The 48 mesh x 0 refuse streams reported to the refuse thickener and the thickener underflow was pumped to the thickener of a nearby coal cleaning plant. As previously stated, the belt press designed to dewater the refuse and allow a closed-water circuit could not be operated due to the high chemical dosages required. The flocculants used were interfering with the advanced column flotation performance, and the operation was subsequently abandoned for the POC operations as well as the Semi-Works plant design.

4.5.2 Upper Freeport Seam Coal Testing

The Upper Freeport seam coal was the second coal tested at the POC. The coal was received from Camelot Coal Company of Somerset County, Pennsylvania. Because of a mine closing, the Upper Freeport seam coal that was used for bench-scale testing was not available at the time of POC testing.

Table 4.16 presents the average raw coal quality for samples extracted during POC testing. Results from unit operations and plant performance testing follows.

Table 4.16 Upper Freeport Seam Coal, Average Raw Coal Quality		
Analysis	Basis of Analysis	
	As-Received	Dry
Moisture (%)	8.16	---
Ash (%)	21.51	23.42
Total Sulfur (%)	4.11	4.47
Pyritic Sulfur (%)	2.78	3.03
Btu Per Pound	10,262	11,174

Heavy-Media Cyclone

Four tests were conducted on the heavy-media cyclone at specific gravities ranging from 1.70 to 1.85. Table 4.17 presents the results from this work. The data indicates that a 1.75 specific gravity will result in greater than 97 percent energy recovery, the goal for the unit operation. This specific gravity was used for all remaining Upper Freeport seam testing.

Table 4.17 Upper Freeport Seam Coal, Heavy-Media Cyclone Performance		
Run Number	Specific Gravity	Energy Recovery (%)
93092301	1.70	96.2
93092302	1.75	99.1
93092303	1.80	99.7
93092304	1.85	97.6

Water-Only Cyclone

The water-only cyclone vortex finder configuration was determined during Pittsburgh No. 8 seam testing. Two tests were conducted on the water-only cyclone during Upper Freeport seam testing in order to determine the proper apex diameter. Table 4.18 presents the results from these tests. Using a 3/4" diameter apex resulted in a 97.8 percent energy recovery on the Upper Freeport seam coal, and this apex was used for the remainder of testing on this coal. The lower energy recovery found in the test using a 5/8-inch apex could not be explained.

Table 4.18 Upper Freeport Seam Coal, Water-Only Cyclone Configurations and Performance Results				
Run Number	Vortex Length (inches)	Vortex Diameter (inches)	Apex Diameter (inches)	Energy Recovery (%)
93100402	7.0	3.0	5/8"	88.5
93100401	7.0	3.0	3/4"	97.8

Conventional Froth Flotation

Bench-scale testing indicated that, for the Upper Freeport seam coal, a 48 mesh x 0 plant clean coal may be possible. At the POC level, investigators set a target for the success of the grab-and-run conventional flotation of 6 percent clean coal ash of the grab product. This value matches the overall clean coal product ash goal.

Table 4.19 presents the results of testing the grab-and-run circuit on the Upper Freeport seam coal. The 48 mesh x 200 mesh size fraction was cleaned in the "A" bank of flotation cells and the 200 mesh x 0 size fraction was cleaned in the "B" bank. Data for the coarser size fraction indicate that a 6 percent clean coal ash could not be produced. For the fine, 200 mesh x 0 size fraction, similar flotation conditions resulted in a 8 percent product ash during one test and a 5 percent product ash during the second test. With no good explanation for this changing performance, investigators decided that the grab-and-run, conventional flotation philosophy would not be employed for the Upper Freeport seam coal.

Table 4.19 Upper Freeport Seam Coal, Attempts at Grab-and-Run, Conventional Flotation					
A Bank: 48 mesh x 200 mesh Size Fraction					
Run Number	Frother Dosage (ml/min)	Collector Dosage (ml/min)	Air Rate	Grab Product Quality	
				Ash (%)	Sulfur (%)
93092901	1.3	0	Low	9.2	3.01
93092902	0.9	0	Low	9.8	2.79
B Bank: 200 mesh x 0 Size Fraction					
Run Number	Frother Dosage (ml/min)	Collector Dosage (ml/min)	Air Rate	Grab Product Quality	
				Ash (%)	Sulfur (%)
93092901	0.3	0	Low	8.0	3.39
93092902	0.3	0	Low	5.1	1.83

With this decided, one more conventional flotation test was conducted in order to determine the results when attempting to maximize energy recovery for the Upper Freeport seam coal. Again, split flotation was employed. Table 4.20 presents the results from this test. For the coarse size fraction, the target energy recovery could not be achieved. The target of 97 percent energy recovery was achieved for the 200 mesh x 0 size fraction, but the frother dosages applied during this test affected the control of the column flotation cell. Excess froth was being produced in the column cell even though no reagents were being added. Conventional flotation was thus eliminated for this coal.

Table 4.20 Upper Freeport Seam Coal, Conventional Single-Stage Froth Flotation Results					
A BANK: 48 mesh x 200 mesh Size Fraction					
Run Number	Frother Dose (ml/min)	Collection Dose (ml/min)	Energy Recovery (%)	Clean Coal	
				Ash (%)	Sulfur (%)
93092303	9.8	6.5	88.0	12.31	2.80
B BANK: 200 mesh x 0 Size Fraction					
Run Number	Frother Dose (ml/min)	Collection Dose (ml/min)	Energy Recovery (%)	Clean Coal	
				Ash (%)	Sulfur (%)
93092303	6.5	4.0	99.9	16.19	2.0

Grind Circuit Testing

With the heavy-media cyclone and the water-only cyclone operating at the pre-determined conditions, and the conventional flotation cells bypassed, eight tests were next conducted on the grinding circuit. Feedrate to the grinding circuit was varied during these tests by changing the plant feedrate and holding all other conditions constant. During one test, the ball-mill speed was reduced to 18 rpm as compared to nearly 28 rpm during all other tests. Figure 4.09 compares the mill circuit throughput and the grinding circuit product mean particle size. Complete microtrac data for the mill product sample is presented in Appendix B. As expected, there is a very strong relationship between the two parameters: increased mill

Figure 4.09 Upper Freeport Seam Coal, Mill Circuit Performance

throughput increased the product particle size. The speed change did not affect this relationship, though the higher speed was maintained during the remainder of POC testing, in order to maintain consistency between the coals.

Unfortunately, as with the Pittsburgh No. 8 seam coal, the target grind for the project was not achieved at even the lowest tested circuit throughput rate. With only 0.9 TPH throughput, the circuit produced a product of 89 percent passing 200 mesh as compared to a target of 95 percent. Again, investigators were presented with a dilemma: either the target grind had to be relaxed or the POC would have to be operated at very low throughput, compromising the target of 2 tons-per-hour plant production rate. Since the economics of the circuit could be greatly affected by the production rate, investigators decided not to substantially decrease column feedrate targets in order to improve grinding performance.

Advanced Column Flotation

A Box-Behnken test matrix was established for the Upper Freeport seam coal varying the column flotation feedrate, the collector dosage, and the air gas holdup rate. Gas holdup rate is the measure of the air volume present between two levels in the column, and, for a specific input air volume is related directly to the frother dosage. Frother dosage is increased to increase gas holdup.

The Box-Behnken test matrix for the Upper Freeport coal is given in Table 4.21. Appendix B provides a summary of the test data, operating conditions and performance calculations for this series of tests.

Figure 4.10 presents the relationship between energy recovery and ash and pyritic sulfur rejection for the advanced column flotation unit. All of the data points fall along unique grade-recovery curves that represent the tradeoff between energy recovery and product quality. Maximum separation efficiencies were found to occur at about 90 percent energy recovery, where ash and pyritic sulfur rejection rates of 50 percent and 38 percent can be expected. A number of test points fall in this area, indicating that the test matrix conditions were centered in the region most likely to produce maximum column flotation performance. Also, various combinations of the variables can result in similar performance so some economic considerations can be accounted for in deciding the best operating conditions for the variables.

In the same manner as that described previously in the "Advanced Froth Flotation" section of 4.5.1 (Pittsburgh No. 8 coal), statistical analysis of the Upper Freeport coal flotation data resulted in the development of both linear and quadratic regression models. The coded coefficients for the linear regression model are provided in Table 4.22. In this case, energy recovery was found to decrease with increasing feed rate, and increase with increasing air holdup and collector dosage. Ash rejection increased with feed rate, and decreased with air holdup and collector dosage. Pyritic sulfur rejection followed the same trend. The statistical analyses also indicate that air holdup is the dominant factor controlling column recovery, ash rejection and pyritic sulfur rejection. In contrast

to the Pittsburgh No. 8 results, feed solids rate was found to have only a small impact on column performance for this particular coal.

Table 4.21 Upper Freeport Coal, Box-Behnken Text Matrix			
Run Number	Feed Rate (tph)	Collector Dosage (lb/ton)	Air Holdup (%)
1	2.50	0.20	18
2	2.50	1.00	24
3	1.00	0.60	24
4	1.00	0.20	21
5	1.00	0.60	18
6	1.00	1.00	21
7	4.00	0.60	18
8	2.50	0.20	18
9	2.50	1.00	24
10	2.50	0.20	24
11	2.50	0.60	21
12	2.50	1.00	18
13	2.50	0.20	18
14	2.50	1.00	24
15	2.50	0.20	24
16	2.50	0.60	21
17	4.00	0.20	21
18	4.00	1.00	21
19	2.50	1.00	28
20	2.50	0.60	21
21	4.00	0.60	24

The general trends observed for upgrading of the Upper Freeport coal are in good agreement with those typically observed for the column flotation of fine coal. For example, an increase in feed solids rate generally produces a lower coal recovery because of inadequate bubble surface area for the attachment of hydrophobic particles. This also improves the quality of clean coal since middlings particles containing mineral matter are less likely to attach under these conditions. Likewise, an increase in air holdup typically enhances coal recovery by increasing the availability of bubble surface area. This also lowers the quality of the clean coal because of the increased likelihood that middlings particles would also be collected. An increase in collector dosage also enhances the collection of middling particles, leading to an improved coal recovery and poorer clean coal quality. These phenomena are responsible for the trade-off between energy recovery and product quality observed in Figure 4.10.

Figure 4.10 Upper Freeport Seam Coal, Box-Behnken Matrix Results

Table 4.22 Upper Freeport Seam Coal, Coded Coefficients for the Linear Regression Model						
Test Variable	Units	Low Value	High Value	Energy Recovery	Ash Rejection	Pyritic Rejection
Main	***	***	***	+78.53	+59.71	+44.48
Feed Rate	tph	1.0	4.0	-3.28	+2.22	+0.46
Air Holdup	%	18	24	+13.84	-12.62	-13.14
Collector	lb/ton	0.20	1.00	+6.22	-4.98	-6.72

Response surface plots for the Upper Freeport coal were constructed using the quadratic regression models and are presented in Appendix B. Separate plots were constructed for predicting energy recovery, ash rejection and pyritic sulfur rejection as functions of collector dosage, air holdup and feed rate. The quadratic expressions are given by:

$$\begin{aligned} \text{Energy Recovery} = & -604.67 - 5.1711 (\text{Feed Rate}) + 59.520 (\text{Air Holdup}) \\ & + 69.211 (\text{Collector}) - 1.2128 (\text{Feed Rate})^2 - 1.2674 (\text{Air Holdup})^2 \\ & + 25.242 (\text{Collector})^2 + 0.36000 (\text{Feed Rate}) (\text{Air Holdup}) + 2.4833 (\text{Feed Rate}) (\text{Collector}) \\ & - 4.2938 (\text{Air Holdup}) (\text{Collector}) \end{aligned}$$

$$\begin{aligned} \text{Ash Rejection} = & 568.69 - 1.6964 (\text{Feed Rate}) - 44.244 (\text{Air Holdup}) - 1.7203 (\text{Collector}) \\ & + 0.75778 (\text{Feed Rate})^2 + 0.94102 (\text{Air Holdup})^2 - 19.755 (\text{Collector})^2 + 1.389 \times 10^{-2} (\text{Feed Rate}) (\text{Air Holdup}) \\ & - 1.5042 (\text{Feed Rate}) (\text{Collector}) + 0.79722 (\text{Air Holdup}) (\text{Collector}) \end{aligned}$$

$$\begin{aligned} \text{Pyritic Rejection} = & 575.03 + 3.1976 (\text{Feed Rate}) - 45.484 (\text{Air Holdup}) - \\ & 35.623 (\text{Collector}) + 0.94898 (\text{Feed Rate})^2 + 0.96544 \\ & (\text{Air Holdup})^2 - 23.335 (\text{Collector})^2 - 0.33833 (\text{Feed} \\ & \text{Rate}) (\text{Air Holdup}) - 0.88333 (\text{Feed Rate}) (\text{Collector}) \\ & + 2.3344 (\text{Air Holdup}) (\text{Collector}) \end{aligned}$$

where feed solids rate is reported in units of TPH, collector dosage in units of lb/ton, and air holdup is reported as a percentage. In general, the quadratic expressions provided a much better fit to the experimental data than the linear models.

Response surface plots were constructed for feed rates of 1.0, 2.5 and 4.0 TPH. In general, the observed trends are consistent with those predicted by the linear regression model. An increase in air holdup sharply increased coal recovery due to the increased availability of bubble surface area passing through the column. The impact of air holdup was most notable at the higher feed rates where the increased population of floatable particles tended to overload the carrying capacity of the air bubbles. An increase in collector dosage also improved coal recovery, particularly when the air holdup was low. The increase in recovery with increasing dosage can be attributed to an enhancement in coal hydrophobicity produced by the collector adsorption. However, collector dosage had a smaller effect on column performance than air holdup. This implies that aeration rate and frother dosage (the main factors which control the air holdup) have a stronger effect on column performance than parameters which change the coal hydrophobicity (i.e., collector dosage). This suggests that the Upper Freeport coal sampled used in the present work was already sufficiently hydrophobic.

The response surface plots indicate that, as expected, factors which tended to improve coal recovery had the reverse effect on the rejections of ash and pyritic sulfur. These general trends are consistent with the recovery-grade curves shown previously in Figure 4.10. The ash and pyritic sulfur rejections tended to increase with increasing feed solids rate and decrease with increasing collector dosage and/or air holdup. These observations are consistent with those obtained from previous studies which suggest that high reagent dosages are often detrimental to achieving high rejections of pyritic sulfur.

Based on the Box-Behnken test results, investigators established the optimum column flotation condition for the 24-hour demonstration run. These conditions are presented in Table 4.23.

Table 4.23 Upper Freeport Seam Coal, Column Operating Conditions Established for the Demonstration Run			
Plant Feedrate (TPH)	Column Feed Rate (TPH)	Collector Dosage (#/ton)	Gas Holdup (%)
2.3	2.0	1.0	21

24-Hour Demonstration Run

The POC module was configured based on the previously described unit operations optimization tests and readied for the 24-hour demonstration run. Ten 24-hour days of operation were completed on the Upper Freeport

seam coal as planned. The sampling program was as described for the Pittsburgh No. 8 seam coal in Section 4.5.1. Over the ten days of operation, 30 complete sets of samples were collected and submitted to the laboratory for analysis. The results from the laboratory were input into the Bilmat Material Balance program in order to estimate a metallurgical balance around the plant and for the major cleaning circuits in the plant.

One of the thirty data sets was thrown out due to the extremely high adjustments required. The complete data sets for the remaining tests are provided in Appendix B.

As with the Pittsburgh No. 8 seam coal, for the most part, only small adjustments were made on the remaining ash data. Out of the nine samples used for the plant balance, the average adjustment was greater than three percent of the measured value on only two samples, the column reject and the refuse thickener feed. As with the Pittsburgh No. 8 seam coal, the ash adjustment data again indicate reasonable accuracy of the original data set. Investigators are thus confident that the adjusted data provides good estimations of actual plant and equipment performance.

Figure 4.11 presents the average qualities and performance calculations for the ten-day period. Overall, the process recovered 87.5 percent of the energy and rejected 76.2 percent of the pyritic sulfur of the raw coal feed. By throwing away enough raw coal to result to an 85 percent energy recovery, 77 percent of the pyritic sulfur would have been rejected. As with the Pittsburgh No. 8 coal, the 85/85 performance goals were not achieved.

Of the energy lost in the overall process, 22 percent was lost with the heavy-media-cyclone reject, seven percent was lost with the water-only cyclone reject, and 71 percent was lost with the column flotation reject. Corresponding proportions of rejected pyritic sulfur were 65 percent, 10 percent, and 25 percent. The high energy loss with a relatively small pyrite rejection in the advanced column flotation cell possibly indicates marginal improvement in the state of liberation of this coal when grinding from a 48 mesh top size to a 200 mesh top size. In order to achieve the overall pyritic sulfur rejection goal (of 85 percent), 27.7 percent of the raw coal's pyrite would have to be removed by the column or 65 percent of the pyrite in the column feed (compare to 44 percent actual).

Figure 4.12 presents the average particle size distribution for the mill-circuit feed and the column-flotation feed during the 24-hour demonstration run. Similar data for the 29 sample periods are presented in Appendix B. The mean particle size of the mill-circuit feed was 165 microns and the mean particle size of the column-flotation feed was 45 microns. The column flotation feed was 82.6 percent passing 200 mesh compared to a target of 95 percent passing.

Grinding finer would certainly improve the chances of meeting the 85/85 cleaning performance goals. It is unclear, however, whether the target grind for this project, 95 percent passing 200 mesh, is fine enough to meet the cleaning performance goals.

Figure 4.11
Upper Freeport Seam Coal
Average Performance
During 24-Hour Demonstration Run

Figure 4.12 Upper Freeport Seam Coal, Average Mill Circuit Feed and Product Size

4.5.3 Illinois No. 6 Seam Coal

The Illinois No. 6 coal was the third and final project coal tested at the POC facility. The coal was supplied by the Kerr-McGee Coal Corporation of Saline County, Illinois. One barge shipment of about 1500 tons was procured from Kerr-McGee for POC testing. Table 4.24 presents the average quality of raw coal samples extracted during POC tests. Important results of POC testing follows.

Table 4.24 Illinois No. 6 Seam Coal, Average Raw Coal Quality		
Analysis	Basis of Analysis	
	As-Received	Dry
Moisture (%)	15.18	---
Ash (%)	30.34	35.77
Total Sulfur (%)	3.34	3.93
Pyritic Sulfur (%)	2.01	2.37
Btu Per Pound	7,672	9,046

Heavy-Media Cyclone

The heavy-media cyclone was tested at three specific gravities ranging from 1.70 to 1.80 specific gravity. As with the previous coals, the goal

established for this unit was to identify the lowest circulating media specific gravity that would result in a 97 percent energy recovery. Table 4.25 presents the recoveries for each specific gravity tested. The target energy recovery was not achieved at any of the three specific gravities tested. Because of visually observed clay buildup in the recirculating media and possible related troubles with the heavy-media- pumping system, a higher specific gravity was not attempted for this coal. The results subsequently justified this decision as the energy recovery uncharacteristically remained constant or dropped when the specific gravity was increased. The clean coal ash values, which also remained constant or dropped when the media specific gravity was increased, provided additional evidence that further increases in the media specific gravity was unwarranted. Based on this data, investigators selected a 1.75 specific gravity for all remaining Illinois No. 6 seam testing.

Table 4.25 Illinois No. 6 Seam Coal, Heavy-Media Cyclone Performance			
Run Number	Specific Gravity	Energy Recovery (%)	Clean Coal Ash (%)
93112901	1.70	95.0	11.90
93112902	1.75	95.1	11.34
93112903	1.80	90.7	11.69

Water-Only Cyclone

Based on experience with the two previous coals, conventional froth flotation held little promise for inclusion with the advanced froth flotation process. Poor performance and operating problems associated with the required high frother reagent dosages led investigators to remove conventional frother flotation from the process for both the Pittsburgh No. 8 and the Upper Freeport coals. For this reason as well as to improve the operations schedule, the water-only cyclone and the conventional froth flotation units were sampled during the same test runs during Illinois No. 6 seam optimization tests.

Table 4.26 presents the water-only cyclone performance results using 5/8-inch and 3/4-inch cyclone apices. The larger cyclone apex resulted in a higher energy recovery as well as an improved clean-coal-ash content. Since the target recovery was achieved with the 3/4-inch apex, this was used for the remainder of Illinois No. 6 coal testing. As with the Upper Freeport coal, the lower energy recovery in the test with the smaller apex is contrary to normal expectations. This cannot be explained with available data.

Conventional Froth Flotation

Conventional froth flotation results for the Illinois No. 6 seam coal are presented in Table 4.27. While the energy recovery target of 97 percent was exceeded on the coarser-size fraction and approached on the finer size fraction, it was already decided that conventional froth flotation would be removed from the proposed Semi-Works design. A review of the data in the table illustrates very good reasons for eliminating conventional froth flotation. On the coarse size fraction (48 mesh x 200 mesh), only 2.5 to

3.4 percent of the pyritic sulfur is rejected along with similar percentages of feed solids. The primary philosophy of using conventional coal cleaning approaches in this project were to try to make some "cream" coal to coarsen the plant product; to remove significant amounts of liberated impurities with low cost conventional cleaning; and to reduce grinding circuit capacity, and thus capital requirements. Once grab-and-run flotation was discounted, and after precleaning in the water-only cyclone, none of these objectives could be accomplished in the coarse flotation stage.

Table 4.26 Illinois No. 6 Seam Coal, Water-Only Cyclone Configurations and Performance Results					
Run Number	Vortex Used	Apex Diameter (inch)	Energy Recovery (%)	Clean Coal	
				Ash (%)	Total Sulfur (%)
93120201	7/3 ¹	5/8	92.9	22.13	3.21
93120202	7/3 ¹	3/4	98.6	18.82	3.01
¹ Seven inch length, 3-inch diameter Vortex finder used for all tests.					

Similarly for the finer size fraction, once grab-and-run flotation was discounted, the only real feasible benefit was ash removal prior to the grinding circuit and advanced froth flotation. This benefit would be somewhat dubious, as the ash would be easily diverted away from the ball-mill by the grinding-circuit classifying cyclones. Also, since the critical sizing parameter for the advanced froth flotation column is related to froth carrying capacity, no real benefit could be realized by minus 200 mesh ash removal.

Table 4.27 Illinois No. 6 Seam Coal, Conventional Single-Stage Froth Flotation Results					
A Bank: 48 mesh x 200 mesh Size Fraction					
Run Number	Frother Dosage (ml/min)	Collector Dosage (ml/min)	Energy Recovery (%)	Clean Coal	
				Ash (%)	Sulfur (%)
93120201	3	13	99.7	15.03	3.70
93120202	3	25	99.3	12.45	3.42
B Bank: 200 mesh x 0 Size Fraction					
Run Number	Frother Dosage (ml/min)	Collector Dosage (ml/min)	Energy Recovery (%)	Clean Coal	
				Ash (%)	Sulfur (%)
93120201	9	8	92.4	13.30	2.88
93120202	9	16	93.3	8.79	3.01

Grinding Circuit

No formal mill circuit testing was conducted for the Illinois No. 6 coal. Data from the previous coals indicated that grinding performance was mainly a function of feedrate and thus the same circuit configuration was eventually used for all three coals.

Advanced Froth Flotation

The heavy-media cyclone and the water-only were operated at the condition determined during the previously described maximization tests, and a Box-Behnken experimental program was conducted on the advanced column flotation operation.

The Box-Behnken test matrix for the Illinois No. 6 coal is given in Table 4.28. The same operating variables were examined in this series of tests as examined for the Upper Freeport coal, i.e., feed solids rate, collector dosage and air holdup. However, a slightly narrower range of feed solid rates (i.e., 1 to 3 TPH) and somewhat higher range of collector dosages (i.e., 0.5 to 1.5 lb/ton) were examined for the Illinois No. 6 coal. The test data, operating conditions and performance calculations for this series of tests are summarized in Appendix B.

Table 4.28 Illinois No. 6 Coal, Box-Behnken Text Matrix			
Run Number	Feed Rate (tph)	Collector Dosage (lb/ton)	Air Holdup (%)
1	2.00	1.50	24
2	2.00	1.00	21
3	2.00	0.50	18
4	2.00	1.50	24
5	2.00	0.50	18
6	1.00	1.00	24
7	3.00	1.00	24
8	3.00	1.50	21
9	2.00	1.00	21
10	2.00	0.50	24
11	3.00	1.00	18
12	1.00	0.50	21
13	3.00	0.50	21
14	2.00	1.50	18
15	2.00	1.00	21
16	1.00	1.50	21
17	1.00	1.00	18
18	2.00	1.50	18
19	2.00	0.50	24

Figure 4.13 presents energy recovery versus ash and pyrite rejection for the column flotation cell. The data form unique grade-recovery curves for each of the measured characteristics. Between 90 and 95 percent energy recovery, where the column will need to operate in order to achieve an overall plant energy recovery of 85 percent, pyrite rejection of 28 to 35

Figure 4.13 Illinois No. 6 Seam Coal, Box-Behnken Test Matrix Results

percent resulted. These results could be obtained at several different combinations of operating conditions. This again suggests that other conditions such as reagents costs, column capacity, maintenance considerations, etc. should be considered in the selection of the preferred operation point for the advanced column flotation circuit.

As with the other two coals, linear and quadratic regression models were developed for predicting energy recovery, ash rejection and pyritic sulfur rejection. Table 4.29 provides a summary of the coded coefficients for the linear regression model. As shown the statistical analyses indicate that energy recovery decreased with feed rate, and increased with air holdup and collector dosage. These trends were expected for the reasons given previously within this report. The rejections of both ash and pyritic sulfur also decreased as the air holdup and collector dosages increased. These trends were also anticipated and were considered to be normal in view of the characteristic recovery-rejection curves. However, an increase in feed solids rate was actually found to have an adverse impact on the rejections of ash and pyritic sulfur. This finding is contrary to that obtained during the testing of other fine coals by column flotation. These unexpected trends may be related to variations in the population of middlings particles for each coal brought on by differences in their liberation characteristics. It is also worth noting that air holdup was again found to be the primary factor controlling the performance of the column in terms of energy recovery and pyritic sulfur rejection. This variable also had a large influence on ash rejection, although collector dosage was found to have a slightly larger influence.

Table 4.29 Illinois No. 6 Seam Coal, Coded Coefficients for the Linear Regression Model						
Test Variable	Units	Low Value	High Value	Energy Recovery	Ash Rejection	Pyritic Rejection
Main	***	***	***	+90.04	+69.72	+33.58
Feed Rate	tph	1.0	3.0	-0.30	-0.14	-2.67
Air Holdup	%	18	24	+4.02	-2.66	-7.09
Collector	lb/ton	0.50	1.50	+3.21	-4.03	-4.10

Response surface plots for the Illinois No. 6 seam are provided in Appendix B for energy recovery, ash rejection and pyritic sulfur rejection, respectively. These plots were constructed using the following quadratic regression models.

$$\text{Energy Recovery} = -66.61 - 12.387 (\text{Feed Rate}) + 12.631 (\text{Air Holdup}) + 42.026 (\text{Collector}) + 1.0781 (\text{Feed Rate})^2 - 0.2484 (\text{Air Holdup})^2 - 1.1825 (\text{Collector})^2 + 0.35417 (\text{Feed Rate}) (\text{Air Holdup}) + 0.33500 (\text{Feed Rate}) (\text{Collector}) - 1.6042 (\text{Air Holdup}) (\text{Collector})$$

$$\text{Ash Rejection} = 38.98 - 32.709 (\text{Feed Rate}) + 2.5091 (\text{Air Holdup}) - 20.945 (\text{Collector}) - 6.0101 (\text{Feed Rate})^2 - 8.555 \times 10^{-2} (\text{Air Holdup})^2 - 6.7696 (\text{Collector})^2 - 0.47667 (\text{Feed Rate}) (\text{Air Holdup}) + 1.2050 (\text{Feed Rate}) (\text{Collector}) + 1.1449 (\text{Air Holdup}) (\text{Collector})$$

$$\text{Pyritic Rejection} = 244.28 - 2.7668 (\text{Feed Rate}) + 16.812 (\text{Air Holdup}) - 0.58762 (\text{Collector}) - 1.4964 (\text{Feed Rate})^2 + 0.33405 (\text{Air Holdup})^2 - 1.4143 (\text{Collector})^2 + 0.28500 (\text{Feed Rate}) (\text{Air Holdup}) + 0.10000 (\text{Feed Rate}) (\text{Collector}) - 0.21857 (\text{Air Holdup}) (\text{Collector})$$

where feed solids rate is reported in units of TPH, collector dosage in units of lb/ton, and air holdup is reported as a percentage. The trends observed in these plots are consistent with those predicted from the linear model. In general, energy recovery increased with increasing collector dosage and air holdup. A reverse trend was observed in the rejections of ash and pyritic sulfur. The effect of feed rate on energy recovery and ash rejection was somewhat more complicated. A higher feed rate could either increase or decrease recovery and/or rejection, depending on the specific combination of air holdup and collector dosage employed. However, the overall effect of feed rate was relatively small, which makes it difficult to draw definitive conclusions about the effects of this parameter on column performance. Feed rate had a slightly larger impact on pyritic sulfur rejection, although the magnitude of this effect was still much smaller than that obtained by changing the collector dosage or air holdup.

Based on the results of the Box-Behnken experiments, the operating conditions for the column flotation unit during the 24-hour demonstration run were selected. Table 4.30 presents these conditions.

Table 4.30 Illinois No. 6 Seam Coal, Column Operating Conditions Established for the Demonstration Run			
Plant Feed Rate (TPH)	Column Feed Rate (TPH)	Collector Dosage (lb/ton)	Air Hold-Up Rate (%)
2.6	2.0	1.0	21

24-Hour Demonstration Run

The POC module was configured based on the previously discussed unit operations optimization tests and readied for the 24-hour demonstration run. Ten complete 24-hour days of operation were attempted for the Illinois No. 6 coal. The sampling program was as described for the Pittsburgh No. 8 seam coal in section 4.5.1. Due to equipment failure, no samples were collected for one shift of operation and, therefore, 29 complete data sets were collected and submitted to the laboratory for analyses. Eight data sets were not considered for Bilmatic evaluations because of data irregularities. Of the eight eliminated data sets, three were collected during shifts in which sampler problems were experienced, and in two of those shifts, the plant feed sampler was inoperable for a time. Three of the eliminated data sets were collected during shifts in which forced outages occurred, and the final two data sets were collected during shifts in which no problems could be identified from the plant records. The remaining results from the laboratory were input into the Bilmatic Material Balance program in order to estimate a metallurgical balance around the plant and for the major cleaning circuits in the plant. Complete data for these 21 sample periods are provided in Appendix B.

The Bilmatic computer program had to make relatively large adjustments to the ash data set (compared to the previous coals) in order to arrive at metallurgical balances. On average, the adjustments were greater than three percent of the measured values for five of the nine samples used for the plant balance. Table 4.31 presents the average measured and adjusted ash values for these nine samples. High clay content of the Illinois No. 6 coal was likely one factor contributing to the relatively large adjustments required. Interestingly, the average Btu adjustment was greater than three percent of the measured value for only two samples, the column-flotation reject and the refuse-thickener feed.

Figure 4.14 presents the average quality information and related performance data for both the overall plant and for the major plant circuits. Overall, the plant recovered 85.8 percent of the raw coal's energy content and rejected 79.4 percent of the pyritic sulfur. While this does not meet the performance goals, these results more closely approached the goals than those for the two previous coals.

Of the energy lost in the process, 32 percent was lost to the heavy-media cyclone reject, 15 percent was lost to the water-only cyclone reject, and 53 percent was lost to the column flotation tailings stream. Corresponding proportions of rejected pyritic sulfur in these streams were 70 percent, 13 percent and 17 percent. In order to achieve the goal for pyritic rejection, the advance froth flotation circuit would have to have removed nearly 19.2 percent of the raw coal's pyrite. On a unit

performance basis, the column would have had to remove 56 percent of the column flotation feed pyritic sulfur, in order to achieve this result.

Table 4.31 Illinois No. 6 Seam Coal, Average Adjustments to Ash Values for Bilmat Material Balance				
Sampled Stream	Ash %		Adjustment	
	Average Measured	Average Adjusted	Average Magnitude	% of Measured
Plant Feed	35.69	34.49	1.68	4.63
Deslime Screen Underflow	23.93	23.32	0.65	2.65
Heavy-Media Cyclone Refuse	77.10	78.00	1.48	1.93
Water-Only Cyclone Clean Coal	21.06	22.02	1.06	5.17
Water-Only Cyclone Refuse	52.74	54.15	1.76	7.41
Column Flotation Feed	22.37	22.02	0.66	2.97
Column Flotation Feed	7.20	7.20	<0.01	0.10
Column Flotation Tails	72.38	68.61	3.77	5.20
Refuse Thickener Feed	63.25	66.44	3.26	5.22

Figure 4.15 Illinois No. 6 Seam Coal, Average Mill Circuit Feed and Product Size

Figure 4.14
Illinois No. 6 Seam Coal
Average Performance
During 24-Hour Demonstration Run

Figure 4.15 presents the average particle size distributions of the mill-circuit feed and the column-flotation feed. Similar data for 21 test periods are presented in Appendix B. The mean particle size of the mill-circuit feed was 143 microns and the mean particle size of the column-flotation feed was 42 microns. Compared to a target of 95 percent passing 200 mesh, or 75 microns, the column-flotation feed was nearly 84 percent passing this size. Given the fact that, on a unit performance basis, the column removed 40 percent of the pyritic sulfur, and that it would have had to remove 56 percent to meet the overall goal (of 85 percent), it is possible that the goal may have been met if the mill circuit had ground the column feed to 95 percent passing 200 mesh.

4.6 Application of POC Results to the Preparation of the Final Conceptual Flowsheet

The engineering performance of the unit operations in the precleaning and advanced circuits were according to the initial design except for the grinding mill. A unit-operation-by-unit-operation discussion follows that describes the initial design criteria and whether or not the unit operation conformed to the criteria or not and, then, what would be done in order to obtain the design criteria.

4.6.1 Raw Coal Storage

Although not part of the design consideration, the raw coal storage requires careful consideration for a commercial preparation plant. At the POC, an existing open storage system was utilized to receive the raw coal. This presented operational problems when processing the Pittsburgh No. 8 and the Illinois No. 6 coals. Both of these coals contained clay and/or shale that deteriorated when wet. Resultant handling problems from the reclaim feeders up to the raw coal screen were labor intensive. This could not be tolerated in a commercial preparation plant. For this reason it is recommended that each raw coal's handling characteristics be determined before selection of the raw-coal-storage system. In the case of the Pittsburgh No. 8 and Illinois No. 6 coals, closed storage would be considered.

4.6.2 Raw Coal Crushing

The POC included two (2) double-roll crushers. The first crusher reduced the raw coal top size from six (6) inch to two (2) inch. The second crusher reduced the raw coal from two (2) inch top size to one-quarter ($\frac{1}{4}$) inch top size. There was a problem with the second crusher maintaining the gap between the crusher rolls to produce a one-quarter inch final product. Modifications were made to the rolls by adding a welded bead spaced every inch across the face of the roll. This improved the operation but still did not produce 90 percent minus one-quarter inch product. In addition, because of the clay-type material, the second crusher had a tendency to plug when wet material was being crushed. To overcome these problems in the Semi-Works preparation plant, it is recommended to increase the top size of the final crushed product to nominal one-half ($\frac{1}{2}$) inch. Although some liberation of material will be sacrificed, the continuous operation of the crusher would more than offset this problem. This loss of liberation will be offset by slightly

increased liberation performance in the 48 mesh by zero and 200 mesh by zero grinding circuits.

4.6.3 Oversize Protection and Initial Raw Coal Sizing

The oversize-protection screen unit operation worked as planned, and the design for the Semi-Works unit was based on criteria established by the Vibrating Screen Manufacturers Association⁵. The only problem with the unit in the POC facility was the inability to completely wet the raw coal before entering the screening area. This will be easily designed for in the Semi-Works preparation plant by adding raw coal pushwater ahead of the screen and improving the spray-water header design on the screen.

The deslime sieve bend design was based on Dutch State Mines (DSM) capacity charts. There were no surprises in the design and the sieve bend with 0.5 mm opening of the proper width was more than adequate for removing water and natural fines ahead of the deslime screen.

The deslime screen design was based on capacity calculations developed by the Dutch State Mines (DSM). The calculations are conservative and are adequate for determining the width of the deslime screen which determines capacity. The POC deslime screen was dressed with wedge wire panels with 0.3 mm openings and no problems were experienced in the operation.

4.6.4 Coarse Conventional Cleaning and Secondary Crushing

In the original POC design, a coarse water-only cyclone was proposed for primary precleaning. This unit operation was selected to reduce operating cost of the precleaning circuit. The final Semi-Works design will not use the coarse water-only cyclone. Instead, a heavy-media cyclone will be used to preclean the coarse raw coal. The magnetite loss was determined to be within commercial values and the high (1.75) specific gravity of separation was not an operational problem.

The heavy-media cyclone unit operation design was based on probable error calculations. The unit operation performed adequately in the POC and there is little doubt that the same will occur in the Semi-Works preparation plant.

The clean-coal and refuse-sieve-bend designs were based on the DSM capacity charts. Again, there were no surprises in the operation of these sieve bends with 0.5 mm opening. The proper width can be determined from the capacity charts and the units were adequate for removal of media ahead of the drain-and-rinse screens.

The clean-coal, middlings and refuse drain-and-rinse screen designs were based on capacity calculations developed by DSM. The calculations produced a conservative design and were adequate for determining the width of the drain-and-rinse screens. The POC drain-and-rinse screen was dressed with wedge-wire screen panels with 0.3 mm openings and experienced no problem in operation.

The fine crushing machine in the POC was a Gundlach cagepactor. This unit was partially refurbished after ten (10) years of storage. The machine was originally designed to produce minus 1/8 inch material. The POC

design required a size reduction to minus 48 mesh. In order to accomplish this, the existing machine was operated at 1000 rpm. Although this speed was not the upper limit of the manufacturer's recommended speed, the vibration generated at this speed caused several failures of the machine during the operation of the POC facility. The unit required the addition of vibration detectors to prevent catastrophic failure. In addition, structural support steel needed to be increased. With these changes and a more stringent maintenance program, the failure rate of the machine decreased to less than 1.0 percent of operating time.

In the Semi-Works size preparation plant, the unit would be properly sized for the application. The unit would include vibration detection and adequate structural support to minimize vibration. In the Semi-Works plant, this crusher is in closed circuit with the oversize protection sieve bend. The size distribution of the product was consistently 70 - 100 percent minus 48 mesh (297 microns) with a top size of 95 percent or greater minus 28 mesh (595 microns).

The oversize protection sieve bend design was based on the DSM capacity charts. Although this sieve bend was not included in the POC facility, it is anticipated that no design problems will be encountered for the Semi-Works plant.

4.6.5 Fine Conventional Coal Cleaning

The fine water-only cyclone unit operation design was based on probable error calculations. The unit performed as expected in the POC and there is little doubt that the same performance will occur in the Semi-Works preparation plant.

The above discussions conclude the precleaning circuit of the POC. The product (overflow) of the POC became the feed to the advanced circuit of the POC. The advanced circuit incorporated a reversed-closed circuit, ball-mill grinding circuit, column flotation, clean-coal and refuse thickener, and clean-coal and refuse dewatering.

4.6.6 Ultrafine Coal Grinding Circuit

The grinding circuit consisted of three unit operations, the classifying cyclones, the Varisieve, and the ball-mill. The classifying cyclones and the Varisieve were size-separating devices and the ball-mill was a size reduction device. The classifying cyclone separated into sizes based on particle size and particle specific gravity. The Varisieve separated based on size. The feed rate to the ball-mill of a given size and horsepower controlled the size reduction capability of the machine.

During the operation of the grinding circuit, while processing the Pittsburgh No. 8 seam coal, numerous combinations of feed, vortex finder, and apex diameters were tested to produce the best classification point for the cyclone. Two problems were discovered in the grinding circuit. First, the mill was not producing a fine grind and second, the quality of the feed to the mill circuit was higher in pyritic sulfur than the product from the mill circuit.

The problem with the ball-mill was the original design. The recirculating load to the mill was more than the design. Therefore, for the given ball-mill size the higher the feed rate the coarser the grind. In addition, the percent solids in the feed was lower than design and this also influenced the grind size. The lower the percent solids in the feed the coarser the grind. This problem will be remedied for the Semi-Works plant by providing the data required for the ball-mill manufacture to properly size the mill based on the manufacturer's calculated recirculating load. Then the mill will be of the proper size to handle the input and produce the 95 percent minus -200 mesh as required by the original design.

The ball-mill installed at the POC, though undersized, performed without any major problems. The only maintenance problems experience was the seal around the inlet to the mill. After one (1) year of daily operation it was a very reliable unit operation.

After considerable testing, the mill classifying cyclone orifice configuration and pressure drop were arrived at, which produced a size cut of d_{95} of approximately 120 mesh with a d_{50} of less than 325 mesh. The classifying cyclones operated without any problems. The classification point was for coal particles with a specific gravity of 1.40. As previously stated, a problem developed with respect to quality in the feed to the mill circuit being different than the product from the mill circuit. Basically, this quality problem was the pyrite difference. This was a direct result of the classification characteristics of the cyclone. The pyrite, having a specific gravity of around 5.0 was classifying at a finer size than the coal particles and hence was being recycled back to the ball-mill. The ball-mill circuit was concentrating the liberated pyrite.

Based on the above classification size differential, a Varisieve was incorporated into the mill-classification system. The Varisieve can handle a high volume flow rate per foot of width and was capable of making finer size separations than a static sieve. This unit received its feed from the classifying-cyclone underflow. The feed was diluted with a portion of the classifying-cyclone overflow. The over product of the Varisieve returned to the ball-mill. The sieve-effluent containing the fine pyrite was recombined with the classifying-cyclone overflow and became the feed to the advanced column flotation cell.

After the installation of the Varisieve the feed to the grinding circuit statistically matched the product of the grinding circuit. Based on the above information, the Semi-Works installation would incorporate a classifying cyclone with a Varisieve for fines removal from the cyclone underflow.

The grinding circuit, as described above, produced the fine grind with input and output quality being similar. The operation and maintenance of the circuit was minimal.

4.6.7 Advanced Column Flotation Circuit

The advanced column flotation devices had extensive experimentation conducted first by a factorial experimental design to determine major interacting variables and lastly by a Box-Behnken experimental design to

determine the exact rates for the major interactive variables. From these experiments the best conditions for operation are shown in Table 4.32. These conditions then become the basis for future design.

Table 4.32 Column Flotation Operating Conditions					
Coal Seam	Feed Rate	Collector Rate	Air Holdup	Air Rate	Water Rate
Pittsburgh No. 8	2.0 tph	1.0 #/T	24%	140 cfm	100 gpm
Upper Freeport	2.0 tph	1.0 #/T	21%	150 cfm	100 gpm
Illinois No. 6	2.0 tph	1.0 #/T	21%	140 cfm	100 gpm

The design criteria that can be determined from the above data is presented in Table 4.33

Table 4.33 Column Design Criteria	
FEED RATE = 0.0708 TPH/FT ² WASH-WATER RATE = 0.4730 FT/MIN VELOCITY DOWN AIR RATE = 4.95 cfm/FT ² OF CELL AREA	

These numbers agree closely with the scale-up values for larger commercial units.

4.6.8 Clarification and Dewatering

The product from the column flotation cell contains solids concentrations of around 10-15 percent by weight. The dewatering capacity of a filter can be increased by increasing the feed percent solids. This was accomplished at the POC by using a static thickener with standard flocculating reagents to increase the solids in the feed to the final dewatering device. An operational problem experienced with the clean-coal thickener was froth carryover in the clarified water. The problem was remedied by the addition of water spray nozzles mounted on the feed box and over the surface of the thickener.

In the Semi-Works installation the design criteria of 0.5-1.0 gpm/ft² of surface area is appropriate for design along with low-volume sprays to eliminate froth build up. The sprays are fed from the overflow pump of the clean-coal thickener and the remaining water is recycled for water use throughout the plant.

Tailings or refuse from the column flotation cell is very dilute with percent solids in the range of 0.1-3 percent solids by weight. It is necessary to increase the percent solids for final dewatering. This was accomplished in a conventional static thickener at the POC. There were no operating problems with the static thickener during the operation of the POC. The design criteria of 0.5-1.0 gpm/ft² of surface area is appropriate for scale-up to the Semi-Works size.

The final dewatering of the clean coal and the fine refuse in the POC were not successful. The unit operation selected for clean coal dewatering was the hyperbaric filter. The unit operation selected for fine-refuse dewatering was the belt press. Both of these machines experienced operating problems that required removal from the operating circuit.

The clean-coal hyperbaric filter installed at the POC was the first prototype developed for hyperbaric filtration by the equipment supplier. The unit was not specifically designed for continuous operation. The unit was capable of operating at 4 bars of pressure. However, at no time could the POC operation attain any greater than 1.2 bars of pressure. The problem was the direct result of the valve head design and the discharge system used to remove the clean coal from the pressure vessel to atmosphere.

Numerous modifications and attempts to operate the filter were unsuccessful. The primary problem was the discharge system employed on this small-scale device. The discharge system was a double knife gate arrangement. The knife gates experienced seal failures after only several hours of operation, and severe leakage sometimes after only five to ten minutes of operation.

The hyperbaric filter was operated several hours at a time producing a product that was low in moisture (25-28 percent) and very handleable. For this reason the Semi-Works installation would be equipped with the hyperbaric filter for final dewatering. The commercial-size filters are very successful and the problems experienced in the POC are not operating problems in commercial installations.

Because the hyperbaric filter was not operational no design data were acquired for this unit operation. However, literature supplied by two of the major manufacturers is available that provides design data that would be used in the final Semi-Works design.

The refuse belt press used to dewater the fine-refuse worked as designed. No operational problems occurred with the machine. The product generated from this machine was 30-32 percent moisture and very handleable. However, the belt press requires a large amount of flocculant to operate properly. This flocculant was recycled throughout the water system in the plant and interfered with the selectivity of the coal in the column flotation cell. For this reason the unit was removed from the circuit.

Because the belt press had only limited operation no design data were obtained. Instead a change in philosophy of fine-refuse dewatering resulted. The change in philosophy was to not close the water system with a mechanical device, but to close the water system by using a large refuse impoundment. The fine refuse would be thickened in a refuse thickener and pumped in a slurry to an impoundment built to current Federal, state, and local regulations for final dewatering. The clear water would be returned to the preparation plant for reuse.

4.6.9 Plant Process Control and Automation

The instrumentation in the POC was a mix of proven instruments and instruments that have not been previously incorporated into a coal

preparation plant. The proven instruments included speed controls, level detectors, specific gravity measurement devices, and flowmeters. The new instruments incorporated into the POC were an ash analyzer, a particle size analyzer, a novel automatic flocculant control system, and a thermal air flow meter.

The proven instrumentation in the POC worked as designed with no problem except with the nuclear density gauges measuring specific gravity at low-percent solids.

The problem was the short duration of exposure to the nuclear source through a small diameter pipe. To improve the length of exposure, a "z" section of pipe was installed into each of the small diameter pipes. It was then discovered that the nuclear source had to be replaced with a stronger source to maintain accuracy. After these changes were made, the specific gravity was measured properly.

A condition developed in the air flow measurement device that caused a failure in the unit. The condition was water in the thermal air flow measurement instrument. Even though air dryers were supplied in the compressed air lines, moisture developed in the air lines these instruments were to measure. The change made was to replace the thermal units with an orifice plate pressure drop flow meter. The orifice plate instruments performed properly after installation.

There were three instruments that had not been proven in a coal preparation plant environment. These three instruments were a slurry-ash analyzer, an on-line particle size analyzer, and an automated flocculant control system. All three of these instruments had been laboratory proven, prototype field proven, and in the case of the ash analyzer and particle size analyzer, commercially installed. However, except for the particle size analyzer the instruments had not demonstrated reliability. This was also the case with the POC installation.

The particle size analyzer was installed to measure the size distribution of the feed to the advanced column flotation cell. Any variations measured from a set point would be adjusted by modifying the feed pressure, to the mill-classifying cyclone. During the initial calibration process it was discovered that the sensing unit was very sensitive to alignment. After the alignment problem was corrected it was discovered that the size analyzer measured did not match sampled size measurements. The differences were random so no correction factor could be applied to make up a correlation. It is suspected that during the time of calibration, flocculation of the feed was occurring at different rates. The sample collected for calibration was subjected to dispersant that would break the flocculated particles and result in a finer size distribution. This would explain the problem of calibration.

During the operation of the mill-classifying circuit, it was discovered that for a given feed rate, cyclone orifice arrangement, and feed pressure the size distribution remained quite constant and did not require accurate control to maintain a size analysis. For this reason no further tests and/or calibrations were made for this instrument. The unit worked properly and with additional time and effort could have been made to

operate. The POC was installed not to demonstrate instruments but a circuit; therefore time and effort was not expended on this instrument.

The slurry-ash analyzer also experienced calibration problems and electronic failures. The unit was brought on line and an immediate electronic failure occurred in the radiation detector. When the unit did operate the calibration would drift causing poor readings. The electronic failure was corrected but the drift problem was never corrected.

This unit was to have an experimental pyritic sulfur detector based on readings from an iron peak and inferring the pyritic sulfur content in the sample streams. The laboratory experiments could not justify a full-scale sensor development and the ash analyzer company subsequently dropped development of a pyritic sulfur detector. Therefore, no test work was conducted in the POC installation.

The automatic flocculant control system was comprised of two systems. The first system was the settling rate control instrument and the second system was a water clarity control instrument. The settling rate control instrument was based on measuring density changes as the flocculated material settled in a standpipe. The water clarity control instrument measured the turbidity of the overflow water.

The settling rate instrument went through a series of debugging steps and calibration steps and in one case a complete redesign of the software was accomplished. However, the settling rate portion of the control system never functioned properly. The manufacturer attributed the problem to the low percent solids by weight in the feed to the thickeners. The settling rate system was not used to automatically control the anionic system but was used manually from time to time to determine settling rate and manually adjust the flocculant addition rate.

The water clarity control instrument worked as designed and was utilized to monitor and control the cationic flocculant addition to the water clarification circuits. This unit was not operated in automatic because of the failure of the settling rate instrument, but there is no reason why this instrument would not work when coupled with an operational settling rate instrument.

The conclusions that were drawn from the operation of the POC can be divided into three topics: the precleaning circuit, the advanced circuit, and the instrumentation. The precleaning equipment was composed of conventionally-designed coal preparation equipment and no problem to scale-up to the Semi-Works size plant. The advanced circuit had the only equipment design consideration and this concerned designing for increased recirculated load to the ball-mill. Otherwise this circuit had no problems in scale-up. The conventional instrumentations presented no problems and did scale-up to the Semi-Works plant. The advanced instruments would not be included in the Semi-Works plant because of operating problems and/or reliability with the instruments. The only instrument to be included would be the automatic flocculant control system. The modification made was that the settling rate instrument was changed to a Ramsey clarometer instead of the density measurement device.

The Semi-Works plant was easily scaled-up based on the experience gained in the POC operation. In fact, there were no major surprises. A philosophical adjustment developed in the disposal of the fine refuse in that an impoundment would be incorporated in the final design. Otherwise all other unit operations are scaleable to the Semi-Works size or greater.

4.6.10 Process Consumables

In addition to the engineering design data for the unit operations, several operational variables were also determined from the POC operation. These variables were the rates of reagent usage for flotation, rates of flocculant for dewatering, and the amount of magnetite used during operation. Table 4.34 presents the average usage rates for process consumables determined during POC testing. For the most part, these values are used to estimate the yearly costs of process consumables in the economics section of this report. The magnetite usage rates shown in the table, however, cannot be used. A systematic method for all three coals was developed to reach the actual usage of the consumables during the 24-hour demonstration runs. The data collected is discussed in the following paragraphs.

Magnetite consumption during operation is a function of the loss of magnetite on the refuse stream and the tailings of the magnetic separator. During the 24-hour demonstration runs, samples of the refuse streams for all three coals were analyzed for magnetite adhering to the material as it was discharged out of the media circuit. In addition, the feed to the refuse static thickener was also analyzed for magnetite. This stream would contain magnetite lost from the heavy-media cyclone clean coal and the tailings from the magnetic separator.

Magnetite loss is determined generally on a pounds-per-ton-of-coal feed to the media circuit. Losses are a direct measurement of the efficiency of rinsing the magnetite from the products and the efficiency of operation of the magnetic separator. The best efficiency of a magnetic separator is 99.8 percent magnetic recovery under the best operating conditions. This means for every one thousand pounds of magnetite processed in the magnetic separator, two pounds is lost to the tailings.

The normal feed rate of media to the magnetic separators during the 24-hour demonstration tests was 10,000-12,000 pounds-per-hour. Therefore, the loss of magnetite at peak efficiency would run 20-24 pounds-per-hour. If the efficiency of the magnetic separator would be less than this, magnetite loss would increase. An example would be if the efficiency dropped to 99.7 percent, the loss would be 30-36 pounds-per-hour. The purpose of this discussion is to explain the loss of magnetite when expressed in pounds per ton of feed appears to be totally out of control, when in fact, it is not. The POC circuit was processing 1.5-2.0 tph of feed, and the circuit was capable of processing 40-45 tph. If the same magnetite losses are assumed for both feed rates to the circuit, the pounds of magnetite loss per ton of feed changes from 9 pounds per ton to 0.45 pounds per ton.

Because of this problem, the POC results cannot be used to predict the magnetite usage of a heavy-media circuit properly sized for the tonnage capacity. Therefore, a value of 1.2 #/ton of feed, which is a more

realistic value, will be applied for magnetite losses in the Semi-Works plant design.

Table 4.34 Chemical and Magnetite Consumption Rates During 24-Hour Demonstration Runs			
Process Consumable	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Clean Coal Thickener			
Anionic Flocculant (#/ton)	0.07	0.16	0.17
Refuse Thickener			
Anionic Flocculant (#/ton)	0.32	0.18	0.21
Cationic Flocculant (#/ton)	0.00	0.00	0.88
Sodium Hydroxide (#/ton)	0.0	10.1	0.0
Column Flotation Cell			
Frother (#/ton)	1.43	0.51	0.93
Collector (#/ton)	1.19	1.04	1.21
Magnetite (#/ton)	5.6	30.1	18.5

4.7 Summary of Kelsey Centrifugal Jig and Multi-Gravity Separator Testing

After completing the planned POC test program, investigators conducted short test programs on the Kelsey Centrifugal Jig and the Carpco Multi-Gravity Separator using column flotation concentrate as feed to each of the units. Detailed results of these tests are available under separate cover in Topical Report No. 6 related to the present project⁶. Pilot scale units were used in each case and a slip stream of column flotation concentrate was fed to the units while the POC was operated at the same conditioned employed during the 24-hour demonstration runs. Only the Pittsburgh No. 8 and the Illinois No. 6 coals were tested on these advanced gravity-based separation devices. Since pyritic sulfur is hydrophobic and can thus be recovered with the clean coal concentrate of froth flotation devices, investigators hoped to test whether significant improvements in pyrite rejection could be achieved with these units. Following is a description of these advanced coal-cleaning devices and a summary of the test-program results for each.

Kelsey Centrifugal Jig (JIG)

The Kelsey centrifugal jig engineering concept is a departure from the conventional jig configurations presently being used. The concept of the Kelsey centrifugal jig utilizes all the parameters of a conventional jig, as well as the additional feature of being able to vary the apparent gravitational field. This allows improved separation characteristics for fine- and ultra-fine particle applications. A cross-sectional drawing of the Kelsey centrifugal jig is shown in Figure 4.16.

In a conventional jig, the dynamics involve only specific induced movements. The centrifugal jig takes a conventional jig and spins it in a centrifuge. This is achieved by variable speed control of the spinning rotor. Inside the rotor a screen of parabolic shape is spun coaxially

Figure 4.16 – Kelsey Centrifugal Jig

together with the rotor. The screen is lined inside with the ragging spread coaxially by centrifugal force evenly over the inside surface of the screen.

The feed pulp passes down the fixed center annular pipe and is distributed over the ragging. The feed flows upward over the ragging causing the coal concentrate to overflow the retention plate and then to the discharge orifice while the tailings pass through the ragging and screen and is discharged through the rotating spigots. Hutch makeup (the additional clean water required for the pulsing flow) is fed through the spinning center pipe.

The pulsator is driven to create a water pulse inwardly through the screen and ragging sequentially, while differentially accelerating the feed and ragging particles according to their specific gravity. The particles then settle under centrifugal force (or induced apparent gravitational force) causing the heavy mineral separation from the lighter fraction.

Table 4.35 presents select performance results of the JIG on the Pittsburgh No. 8 and the Illinois No. 6 coals. Seven tests were conducted on each of the coals and the results presented are the best-case results as determined by the separation efficiency. The definition of separation efficiency is also presented in Table 4.35.

Significant additional pyrite rejections resulted for each coal when the advanced column flotation concentrate was reprocessed in the JIG. Pyrite rejections ranged from 13.3 to 40.0 percent for the Pittsburgh No. 8 coal and from 18.9 to 29.0 percent for the Illinois No. 6 coal. Minimum energy recoveries were 93.2 percent for the Pittsburgh No. 8 coal and 90.1 percent for the Illinois No. 6 coal. These results indicate that, for each coal, significant amounts of liberated pyrite were recovered to clean coal in the advanced froth flotation cell. Importantly, these results also indicate that some combination of flotation-based and gravity-based separations on finely ground coals may improve the chances of achieving the 85/85 performance goals of the present work.

Table 4.35 Kelsey Centrifugal Jig, Best-Test Performance*			
Coal	Energy Recovery (%)	Ash Rejection (%)	Pyritic Sulfur Rejection (%)
Pittsburgh No. 8	93.2	23.1	40.0
Illinois No. 6	93.6	15.0	27.8
* Best-Test Performance as Measured by Separation Efficiency: Separation Efficiency = % Energy Recovery - (100 - % Pyritic Sulfur Rejection)			

Carpco Multi-Gravity Separator (MGS)

The MGS was developed by Richard Mozley Limited, U.K., for the selective separation of fine particles based on differences in density. The MGS unit is distributed in North America by Carpco, Inc., of Jacksonville, Florida. A drawing of the pilot-scale version of this device is shown in Figure 4.17. The operating principle of the MGS is similar to that of a conventional concentrating table. However, by placing the carrying

Shake:
Oscillation speed 4 - 6 cps
Amplitude 10 - 20mm

Drum rotation
speed:
100 - 280rpm

Figure 4.17 – Carpco Multi–Gravity Separator

surface inside a rotating drum, it is possible to achieve many times the normal gravitational pull on the particles as they move across this surface in a film of water flowing along the internal surface of the drum. The centrifugal field allows finer particles to be selectively separated compared to conventional flowing-film separators.

Successful applications of the MGS technology include the concentration of cassiterite, chromite, wolframite, graphite, mixed sulfides, and gold. For these application, MGS can treat particles in the range of 1-1000 μm with high separation efficiencies. On the other hand, shaking tables are generally effective over a particle size range of 200-1200 μm . The capacity of the MGS is also very high because of the centrifugal force. According to the manufacturer, a double drum MGS unit is equivalent to a dozen conventional shaking tables in terms of throughput.

Table 4.36 presents select performance results of the MGS on the Pittsburgh No. 8 and the Illinois No. 6 coals. Five tests were conducted on each of the coals, and the results presented are the best-case results as determined by the separation efficiency. This term was previously defined and presented in Table 4.35.

Pyrite rejections were poor for the MGS on both coals tested, and investigators believe that this was a result of low solids content in the feed to the MGS. Unfortunately, schedule and time constraints did not allow additional MGS testing at high feed-solids levels. Nonetheless, 4.3 percent pyrite rejection was achieved on the Pittsburgh No. 8 coal and 12.2 percent on the Illinois No. 6 coal, each at energy recoveries exceeding 99 percent.

Table 4.36 Carpco Multi-Gravity Separator, Best-Test Performance*		
Coal	Energy Recovery (%)	Pyritic Sulfur Rejection (%)
Pittsburgh No. 8	99.8	4.3
Illinois No. 6	99.6	12.2

Summary

In summary, the short jig and MGS test programs conducted on the Pittsburgh No. 8 and Illinois No. 6 coals resulted in some findings that may be useful to future coal process-related research. Each unit rejected additional pyritic sulfur from advanced froth flotation concentrates that had been vigorously cleaned in the POC process of the present work. These promising results were accomplished without a thorough effort to maximize the jig and MGS operations. Integration of advanced froth flotation and gravity-based separation techniques on coals ground to 200 mesh or finer may be required to achieve the goals of high pyritic sulfur rejection and high energy recovery that were set for this project.

4.8 Summary of Trace Element Removal Study

Plant feed, plant clean coal and plant refuse samples collected during the 24-hour demonstration runs for each coal were analyzed for trace element content. This was done in order to evaluate the ability of the advanced

froth flotation process to remove trace elements prior to coal utilization. Detailed results and the evaluation of these results are presented under separate cover in Topical Report No. 5 - Trace Element Removal Study⁷.

Coal cleaning is an effective strategy for reducing the amount of trace elements in coal. However, the degree of trace element removal is related to the amount of ash removed from the coal source. Results from Topical Report No. 5 show that advanced coal cleaning, in conjunction with conventional coal cleaning, can provide significant ash removal and trace element removal from a raw coal source.

For the Pittsburgh No. 8 seam coal, rejections in excess of 60 percent were observed for all trace elements analyzed. For some trace elements, such as arsenic, barium, cadmium, cobalt, chromium, copper, fluorine, lithium, manganese, nickel, lead, tin, thorium, thallium, uranium, vanadium and zinc, rejections of 80 percent and above were achieved. Due to the high ash content of the raw coal source, more than half of this rejection was achieved by conventional coal cleaning. After extensive additional grinding, advanced coal cleaning contributed an additional 20 percent to 30 percent rejection in most cases. Overall, nearly 83 percent of the total ash was rejected along with 91 percent of the total trace element weight.

For the Upper Freeport seam coal, the overall total rejections were not as significant. However, the ash content of the raw coal source in this case was significantly lower than the other two coal sources. As a result, the expectations for overall ash and trace element removal should be lower. In fact, about 61 percent of the ash was rejected in the POC demonstration runs along with 70 percent of the total trace element weight. In addition, significant rejections for all trace elements except for beryllium (24 percent) and vanadium (34 percent) occur. More than half of the total rejection for most elements was achieved by advanced coal cleaning. On the other hand, more than half of the total rejection for arsenic, mercury, lead, thallium, and uranium occurs by conventional coal cleaning. Perhaps this indicates a preferential association between certain elements and ash-forming mineral matter.

The results for the Illinois No. 6 seam coal were similar to the Pittsburgh No. 8 coal results. Nearly 80 percent of the total ash was rejected along with 88 percent of the total trace element weight. Significant rejections in excess of 60 percent were observed for all trace elements analyzed and rejections were above 80 percent for the following individual trace elements: arsenic, barium, cadmium, chromium, copper, fluorine, manganese, nickel, antimony, selenium, thallium and zinc. For most elements, conventional coal cleaning contributed a greater proportion of the total rejection than advanced coal cleaning.

For all three coal tests, a general linear relationship between ash rejection and trace element rejection has been shown. This observation is in general conclusion with other studies on the subject matter^{8, 9, 10, 11}. In addition, the additive effect of conventional coal cleaning combined with advanced froth flotation has allowed for high trace element rejections to be achieved by physical coal cleaning processes. The

combined ability of these technologies to result in high trace element rejections is enhanced where the amount of ash in the parent coal is high.

5.0 FINAL SEMI-WORKS CONCEPTUAL DESIGN

This task involved the final revision of the conceptual flowsheet for a 20 TPH Semi-Works facility that incorporates advanced froth flotation technology. The design of this flowsheet incorporates important findings from both bench-scale and POC-level testing, and the final design represents a significant change from the original conceptual design. These design modifications and the reasons for the changes were addressed in Section 3.7 and 4.6 of this report. The performance of the final conceptual flowsheet is based on the raw coals procured for the POC operations and the process performance achieved during these operations.

5.1 Design Philosophy

The design philosophy applied to achieving the goals of the project was to utilize conventional coal cleaning methods ahead of applications of fine coal grinding, advanced beneficiation, and product-recovery schemes. Conventional cleaning approaches can cost effectively remove fractions of the raw coal that contain high percentages of both ash and pyritic sulfur so as to eliminate the need for their comminution. While it is inevitable that some energy will be lost in the process, it was held to a minimum.

Utilizing this concept of conventional precleaning then, natural size fractions of the crushed ROM coals are separately processed, in the conceptual flowsheets, to reject high-ash streams before any further comminution efforts are completed on those fractions. The 1/4-inch by 48 mesh size fraction of the raw coal is cleaned in a heavy-media cyclone circuit at a high specific gravity of separation, in order to produce a reject stream that is low in energy content but high in both mineral matter and sulfur content. The precleaned product from this operation is crushed to 48 mesh by zero, combined with the like-sized fraction of the raw coal, and this combined stream is cleaned in water-only cyclones configured, again to make a high specific gravity of separation. From these two conventional cleaning stages, relatively easy-to-remove mineral matter and pyrites are excluded from the fine-grinding circuit, which next reduces the particle size of the water-only cyclone product from 48 mesh by zero to approximately 85 percent passing 200 mesh. This grinding stage liberates additional pyrite and mineral matter from the coal particles, and the advanced froth flotation process is used to exploit this in the final coal cleaning stage. Following is a description of the individual unit operations required in order to build an integrated and fully-automated advanced froth flotation plant.

5.2 Preparation of Conceptual Flowsheets and Material Balances

5.2.1 Revised Flowsheet Description

A final process flowsheet and a separate material balance schematic were developed for each of the three coals of the project. These are provided in Figures 5.01 through 5.06. The flowsheets describe the entire process and define the plant battery limits for which an equipment list, engineering drawings, and a capital cost estimate are later provided. The plant battery limits do not include any raw coal storage, reclaim system or plant feed belt. In addition they do not include any clean-coal-belt conveyors. Clean coal size reconstitution, clean-coal storage and clean-

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CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION MATERIAL BALANCE PITTSBURGH No. 8	<small>ICF KAISER ENGINEERS, INC. 1000 CALHOUN BLVD. PITTSBURGH, PA 15222-1207 (412) 437-2000</small>
			DESIGNED BY: D. FERRIS	7/1/94			
			DRAWN BY: E. ZIEGLER	7/6/94			
			CHECKED BY:				
			APPROVED BY:				
ACCOUNT COUNT REVIEW	<small>INFORMATION CONFIDENTIAL: ALL PUMPS, DRUMS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE KEPT CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.</small>				JOB NO. 88107-240	DWG. NO. 10-50-0201	REVISION R-

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			DESIGNED BY: D. FERRIS	7/1/94			
ACCOUNT			DRAWN BY: E. ZIEGLER	7/5/94		JOB NO. 88107-240	DWG. NO. 10500102
			CHECKED BY:				
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Figure 5.04 Upper Freeport Seam Coal, Semi-Works Plant Material Balance

NO	DATE	REVISION	BY	CHK	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST
										WORK COVERED BY THIS PLAN	
										CHARGED TO COST ACCOUNT

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION MATERIAL BALANCE UPPER FREEPORT	ICF KAISER ENGINEERS, INC. 1000 CALIFORNIA DRIVE PITTSBURGH, PA 15222-1207 (412) 497-2500
	DESIGNED BY: D. FERRIS		7/1/94				
	DRAWN BY: E. ZIEGLER		7/6/94				
	CHECKED BY:						
	APPROVED BY:						
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ACCOUNT	INFORMATION CONFIDENTIAL: ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE KEPT CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.						
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MATERIAL BALANCE				
NAME	SIZE	TPH	GPM	SM
CLEAN COAL	24" x 8"	28	27	25.2
TOTAL CLEAN COAL	24" x 8"	28	27	25.2
REFUSE	48" x 8"	6.6	2	7.8
TOTAL REFUSE	48" x 8"	14.5	130	—
TOTAL PRODUCTS FEED	48" x 8"	34.5	163	—
MAKE-UP	—	—	154	—

- LEGEND**
- RAW COAL
 - CLEAN COAL
 - REFUSE
 - MIDDINGS
 - HEAVY MEDIA
 - DILUTE MEDIA
 - CLARIFIED WATER
 - BLACK WATER
 - TPH TONS PER HOUR
 - GPM GALLONS PER MINUTE
 - GPM GALLONS PER MINUTE TOTAL
 - (CW) CLARIFIED WATER
 - (R) REAGENT
 - (F) FLOCCULANT
 - [] DENOTES MAX. TPH FOR DESIGN
 - (O) DENOTES AUTOMATIC SAMPLER
 - SM SURFACE MOISTURE
 - % SOLIDS BY WEIGHT

Figure 5.05 Illinois No. 6 Seam Coal, 20 TPH Semi-Works Plant Flowsheet

NO	DATE	REVISION	BY	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST
									WORK COVERED BY THIS R-CHARGED TO COST ACCOUNT

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL	<div>➡ ICF KAISER</div> <div>100 KAISER ENGINEERS, INC. 100% KAISER ENGINEERS, INC. PITTSBURGH, PA 15222-1007 (412) 497-2000</div> <div>UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS FLOW DIAGRAM ILLINOIS No. 6</div>	
			DESIGNED BY: D. FERRIS	7/1/94			
			DRAWN BY: E. ZIEGLER	7/5/95			
			CHECKED BY:				
			APPROVED BY:				
			APPROVED BY:				
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JOB NO. 88107-240						DWG. NO. 10-50-0103	REVISION R-
/s/ E. Ziegler 8/2/95

Figure 5.06 Illinois No. 6 Seam Coal, Semi-Works Plant Material Balance

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									WORK COVERED BY THIS AC	
									CHARGED TO COST ACCOUNT

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL	ICF KAISER	ICF KAISER ENGINEERS, INC. 1000 CALIFORNIA DRIVE PITTSBURGH, PA 15220-1207 412-437-2800
	DESIGNED BY:	D. FERRIS	7/11/94			UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION MATERIAL BALANCE ILLINOIS No. 6	
	DRAWN BY:	E. ZIEGLER	7/6/94				
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coal shipment systems are also not included. Likewise, the plant battery limits do not include any refuse belt conveyors. Refuse storage and final refuse disposal systems are not included.

The utilities required by the preparation plant are fresh water, power of correct voltage (480 volt and 4160 volt, 3 phase, 60 cycle), magnetite, flotation reagents, and flocculants. These would have to be purchased from outside suppliers.

The Semi-Works plant receives run-of-mine coal from the plant feed belt, removing tramp iron by the tramp iron magnet and crushing the coal by the raw-coal crusher to minus 1/2 inch top size. The crusher product is pulped with water and wet screened on the oversize protection screen at 1/2 inch. Any material larger than 1/2 inch is recycled to the raw-coal crusher. The material that is smaller than 1/2 inch is pulped with additional water until the desired percent solids is obtained.

The pulped 1/2 inch x zero raw coal is pumped to a deslime sieve/screen combination fitted with panels to effect a nominal 48 mesh (300 microns) size separation. The coarse-screen discharge is pulped with magnetite-based media and flows to a heavy-media cyclone feed sump where additional recirculating and overdense media are added. This recirculating media is monitored by a nuclear density gauge for specific gravity and the overdense media is added if needed to maintain a specific gravity of 1.70 or 1.75, depending on the coal.

The sump contents are pumped to a heavy-media cyclone and the cyclone products are passed over drain-and-rinse sieve/screen combinations used for magnetite recovery. The refuse screen discharge is dewatered in a vertical basket centrifuge and is discharged to the refuse conveyor. The clean coal screen discharge is directed to an impact crusher to reduce the material to 48 mesh by zero. The crusher throughput is collected in a sump, pulped with water and pumped to an oversize protection sieve bend that effectively closes the coarse-grinding circuit. The sieve bend discharge is recycled to the deslime screen feed while the sieve effluent reports to the fine water-only cyclone feed sump.

The fine water-only cyclone is configured to produce a high specific gravity separation. The overflow is precleaned coal and the underflow is high-ash, high-sulfur, low-BTU refuse material. The refuse material is directed to the refuse-static thickener. The coal becomes the feed to the fine coal grinding circuit.

New grinding circuit feed and the ball-mill discharge are combined, sumped, and pumped to a thickening cyclone configured to make a size classification at 200 mesh. The minus 200 mesh will be sent to the advanced flotation circuit. The plus 200 mesh material will be processed in the ball-mill to produce a minus 200 mesh product. The ball-mill will be in reverse closed circuit with the cyclone.

The single-stage advanced froth flotation circuit produces a clean-coal and refuse stream. The clean coal reports to the clean-coal static thickener. This unit produces a concentrated solids underflow which is pumped to a hyperbaric disk filter for final dewatering and a low solid supernatant that is recycled to the plant process.

The refuse stream from the water-only cyclone and the advanced froth flotation units report to a refuse static thickener that produces a concentrated solids underflow and a low solid supernatant that is recycled to the plant process. The underflow is pumped to a refuse impoundment.

ICF KE developed the flowscheme presented above to comply with DOE requirements and ICF KE team member's design philosophy. Unit operations were evaluated and selected based upon economic and technological advantages.

5.2.2 Unit Operations Description

The following is a description of the individual unit operations:

- Primary Crushing

In order to maximize pyrite reduction, it will be necessary to reduce the run-of-mine coal in size to liberate the pyrite. A minus 1/2" size was selected as a first stage, as this is a good feed size to conventional gravity separation equipment and provides some liberation of ash and pyrite to permit rejection of low Btu content material.

Roll-type crushers are used for this application since they do not generate a lot of fines compared to ring- or hammer-type granulators. A large percentage of the roll-crusher product remains in the plus 48 mesh sizes.

The primary roll crusher is in closed circuit with an oversize protection screen. Screen oversize discharges to a belt conveyor that recirculates + 1/2" material to the crusher feed. Screen underflow reports to the raw coal sump.

- Screening at 48 Mesh

The next step in the flowsheet provides a size separation at 48 mesh (or 300 microns) in order to prepare a heavy-media cyclone feed. This size was selected instead of the more conventional size of 28 mesh in order to increase the tons going to the heavy-media cyclone. At 48 mesh, conventional coal and media recovery techniques can be applied and were successfully tested at the POC.

- Heavy-Media-Cyclone Circuit

The heavy-media cyclone is presently the most efficient separating device for processing plus 48 mesh coal. The unit has been proven to efficiently separate coal down to 100 mesh. The heavy-media cyclone product is directed to a secondary crushing operation. Magnetite is removed on conventional drain-and-rinse screens and recovered in a conventional dilute media circuit.

- Secondary Crushing

The heavy-media cyclone product will be directed to a crusher in closed circuit with a screening device for crushing and further

liberation at 48 mesh. The cagepactor crusher in closed circuit is used commercially to produce finely ground material while minimizing the generation of ultra-fines. This unit operation will produce the desired size product with the minimum amount of energy. Crusher discharge reports to the oversize protection sump.

- Fine Water-Only Cyclone

After the secondary crushing step, the material has been reduced to minus 48 mesh and there will be additional liberated pyrite and mineral matter. The water-only cyclone offers an economical solution to the removal of these unwashed impurities.

In order to remove the liberated pyrite and mineral matter the minus 48 mesh material will be processed in the fine water-only cyclone, again at a very high gravity in the 1.90 - 2.00 gravity range in order to maximize Btu recovery. The fine water-only cyclone underflow reject, which contains liberated pyrite, reports to the refuse static thickener. The water-only cyclone overflow reports to the mill classifying cyclone feed sump.

- Microgrinding/Classification

To maximize energy recovery and pyrite rejection, ultrafine grinding to liberate the majority of the mineral matter in the coal is required. POC results indicate that a significant percentage of the pyrite can be liberated by grinding to 85 percent passing 200 mesh although finer grinding would increase the chances of meeting the 85/85 performance goals of this project.

The ultrafine coal required for advanced flotation will be prepared using a tumbling-ball mill. The revised conceptual flowsheet incorporates a closed-classification circuit. This will prevent the generation of excess minus 5 micron ultrafines and provide a means of adjusting the final size consist of the feed to the advanced flotation circuit.

While the generation of fine and ultrafine coal particles is an intended and mostly beneficial result of coal grinding efforts, generation of excess submicron material can result in a number of operational problems. Poor thickener performance, higher filter-cake moisture, and impaired rejection of ultrafine refuse particles in the column flotation cell may each result from excess fines generation. For each coal, there is a unique level of fineness that will result in the best balance between the positive and negative aspects of ultrafines generation. Also, for any given coal, this relationship can vary with the current mining location. The closed grinding circuit provides a means for basic adjustments (screen apertures and cyclone configuration changes) in response to medium- to long-term changes in coal characteristics.

A classifying cyclone and Varisieve combination (in series) will adequately separate the precleaned coal streams at 200 mesh. The plus 200 mesh is returned to the ball-mill. The minus 200 mesh becomes the feed to advanced flotation.

- Advanced Flotation

Column flotation was selected for the advanced flotation process because of the improved selectivity that column flotation cells exhibit in regard to minus 200 mesh particle separations (relative to conventional flotation cells). Column cells also improve coal recovery compared to conventional flotation operations, so that improved product quality is possible at higher energy recoveries. The essential features of column flotation are a countercurrent feeding arrangement, wash-water (sprinkling) additions, and generation and use of microbubbles.

Due to the superior efficiency of column flotation, the final advanced circuitry configuration only requires a single stage. Task 5 and 6 results indicated limited performance improvement with additional stages.

- Final Dewatering

The clean coal from the advanced flotation process is first thickened in a conventional static thickener with the addition of flocculant chemicals. The static thickener underflow is pumped to the hyperbaric filter. The clarified water is recycled back into the plant.

The final dewatering of the clean coal is by a hyperbaric filter. This unit operation is incorporated into the final design because despite the fact that the hyperbaric filter tested at the POC was not operated during the extended-duration tests. A number of factors contributed to the decision to recommend the hyperbaric filter for the Semi-Works facility. The hyperbaric filter tested at the POC produced very handleable filter cakes, and filter cake samples that were extracted at the POC indicated likely compliance with the project goal of 30 percent surface moisture. Also, project investigators observed first-hand a competing hyperbaric filter test unit at a coal preparation plant in northern West Virginia. Using a variation of the double knife gate discharge system with critical improvements to the gate sealing approach, no evidence of seal leakage or subsequent pressure losses was found during four hours of observation. Both Andritz and KHD Humboldt Wedag claim to have sold successfully-operated commercial size units in Europe, albeit for coarser-coal applications (28 mesh and 100 mesh by zero). These commercial installations, reportedly, are not plagued by the problems associated with the unit that was utilized in the POC. The product of the filter, clean coal, is discharged to the clean coal conveyor and the filtrate is discharged to the static thickener for recycle.

The POC underflow and the advanced flotation cell tailings are first thickened in a conventional static thickener with the addition of flocculant chemicals. The static thickener underflow is pumped to an impoundment. The impoundment is large enough to permit the solids to separate from the water. The solids are retained in the impoundment and the water is recycled back to the plant. The

clarified water from the static thickener is recycled into the plant.

5.2.3 Distributed Process Control System

- Control System Description

The Semi-Works coal preparation facility is organized and controlled on the basis of one control room containing a complete stand-alone control system. The control system shall include all the hardware and software required to provide regulatory control and sequential control of the process, motors, and monitoring.

The Programmable-Logic-Controller (PLC) based process-distributed control system is capable of performing data acquisition functions, supervisory setpoint control, operator control, and facilities for programming.

The major parts of the system includes:

Data Acquisition Computer System (DACS)

The DACS functions are:

- Real time relational database management
- Network communication with PLC's
- Generation and handling of process alarms
- Custom report generation
- Real time and historic trending
- Storage of operating system
- Storage of programs and displays
- Storage of process trend data
- Program loading

Operator Station

An operator station is provided with a 19-inch high resolution color graphic screen, custom membrane keyboard, and engineering keyboard. The main functions are:

- Configuration of database
- Generation of standard and custom displays
- Operator interaction for process control
- Graphical programming on-line and off-line program documentation.
- Reports to be user configurable to any desired format.
- User custom programming area, "C" language with full access to real time database.
- Loop tuning

- Instrumentation & Control

Process operational control can be summarized under the following physical parameters being measured.

- A. Fluid Level (pressure)
- B. Density
- C. Flow
- D. Moisture
- E. Weight
- F. Torque
- G. Settling Rate
- H. Turbidity (light transmittance)
- I. pH

Nearly all unit operations throughout the entire flowsheet will have some combination of the above physical parameters measured and/or controlled.

There is an exception and special consideration for the heavy-media cyclone sump, since there are occasions when higher moisture on the incoming feed or excessive solids passing through the drain-and-rinse screen cause the sump level to increase instead of decrease.

The controller compares the transmitted level value with a preset high set point. When the transmitted value is higher than the preset value, the high level is annunciated and a bleed control valve is activated to bleed media out of the circuit and thus lower the sump level. This bleed valve is located at the level control box and the discharge reports to the dilute media system where the magnetite is recovered, concentrated, and returned to the overdense system.

A process instrumentation and control diagram for the Semi-Works plant is presented in Appendix C. Below is a functional description for the control of the various plant systems.

- Heavy-Media-Cyclone Density

The heavy-media cyclone cleaning process is based on the difference in specific gravities of the desired product (coal) and the undesired product (refuse). A portion of the processing media (magnetite suspension) is diverted to the density measuring chamber where a slurry density determination is obtained with a nuclear density gauge.

The nuclear density gauge transmits a reading back to the supervisory controller that compares this reading to a preset value. Adjustments are determined by the computer and output signals are transmitted to the appropriate control device. Specifically, the controller sends a signal to an air-motor-operated proportioning valve located in the overdense media distribution box. This valve either opens to raise the measured specific gravity or closes to maintain the current measurement.

This system is basically designed to make-up for magnetite lost in the process and, in fact, anticipates that magnetite will be lost and measured density will decrease. The controller also retransmits this signal to a printer for periodic recording. A low-density condition is alarmed.

- Overdense Media Density

A separate system is necessary to introduce magnetite into the heavy-media cyclone in order to make-up for what is being lost during processing. This system incorporates an overdense media sump and pump that recirculates a high-density-magnetite suspension to a media-distribution box. The heavy-media-cyclone circuit obtains make-up media from this distribution box as required.

A nuclear density gauge on the pumped recirculation line makes a slurry density determination and transmits this value to the controller that, in turn, compares this value to a preset value. If the transmitted density value is lower than the preset point, an output signal is transmitted and will start a feeder. The feeder then introduces dry bulk magnetite into the overdense media sump. A low-density condition is alarmed.

- Fine Grinding/Classification

Based on POC results, investigators believe that it would be very difficult to control the mill-circuit-product grind through online adjustments to operating conditions of the mill circuit. Thus, the online particle size analyzer, the mill classifying cyclone feed pressure gauge, and the variable cyclone feed pump motor have been removed from the Semi-Works plant design. Upon plant start-up, operators will fine-tune the mill circuit by making slight adjustments to the cyclone configuration and, potentially, ball-mill-feed dilution water. Measurements for product particle size will then be taken, and this process will be repeated until the proper mill circuit performance is achieved. A nuclear density gauge and a flowmeter will be installed on the cyclone feed pump in order to determine feed solids flowrate.

- Flotation Cells (Advanced)

The advanced column flotation cell is equipped with a pressure measuring instrument to maintain a controlled level in the column. This pressure measuring instrument is located near the top of the column and transmits a level signal to the supervisory controller. The controller in turn compares this value with a preset value. When the transmitted value drops below the preset value, the controller sends a proportional signal to a pneumatically operated discharge valve on the column cell tailings line. The valve will gradually close in order to maintain the desired column level. By operating the column at the proper level, recovery and efficiency are maximized. A low level condition is alarmed.

Another pressure cell located near the bottom of the column is used with the upper level-control transmitter to determine the gas hold-up. This measurement, along with the aeration rate, determines the amount of bubbles at any given time in the column. There is also a direct relationship to this value and the size of the bubbles. The gas hold-up in the column must be maintained at a critical value to guarantee high recovery.

The two pressure cells transmit signals to the supervisory controller which compares the differential between these two pressure values and divides it by the preset actual difference in fluid level height between the two pressure cells to yield the fractional gas hold-up. If this value decreases, there are insufficient microbubbles in the column. The controller then sends out a proportional signal to the frother reagent feed increasing its feedrate. This reduces the surface tension of the water and increase microbubble generation. Values outside the high and low preset ranges are alarmed.

- Clarification

Both clean-coal and refuse thickeners are provided with torque instrumentation to protect the mechanisms from damage. In either thickener, as solids build up in the bottom of the vessel, it becomes more difficult for the thickener rake-arms to travel through this sludge, thereby increasing torque. A motorized lift mechanism automatically raises the rake-arms once a preset torque is reached. Rakes must be lowered manually. Should torque continue to increase, a high-torque level is annunciated. If no remedial action is taken, the thickener drive will automatically be stopped. Additionally, the lift drive will be interlocked so that the lift drive will not operate unless the rake drive motor is running in automatic mode.

Automatic anionic flocculant control is being provided to improve thickener performance. The clarometer automatically obtains a sample of the thickener feed from the feedwell. The sample is taken into a device that photoelectrically obtains a settling-rate value. Based on the difference between the desired preset and actual settling time, the clarometer automatically adjusts the anionic chemical flocculant feedrates.

Automatic cationic flocculant control is also provided. It is very important to maintain the highest clarity to the recirculated process water. Water clarity is essential for effective wash-water application in the advance column cell.

A portion of the clarifier process water is taken into a turbidity measuring device. Upon reaching undesirable amounts of suspended solids a control signal will be transmitted to control the cationic flocculant feeder.

The flocculant preparation and dilution system is fully automated. The flocculant emulsions are pumped from delivery trucks into bulk storage tanks. When the low level in the batch-day tank is reached, a preset amount of chemical is withdrawn from the bulk tank and pumped into the day tank. Simultaneously, dilution water is added and mixed with the flocculant until the "HI" level in the day tank is reached. A low level in either the bulk tank or the day tank is annunciated.

- Belt Scales

Electronic-type belt scales are mounted on the raw coal, clean-coal, and refuse belts. Each of these units transmits a signal to the controller and indicator, the printer, and a totalizer which cumulates tonnages on these belts. These belt scales are not included in the Semi-Works capital estimate.

- Quality Calculation Section Pyritic Sulfur Rejection/BTU Recovery

Online determination of pyritic sulfur or energy content will not be attempted since there are no proven methods of determining the pyritic sulfur content of slurry or dry flow streams.

- pH Control

A pH probe is installed on the thickener feed. Output from this probe is used to either add pH elevating or pH depressing chemicals such that the clarification/thickening process can be conducted under optimum pH conditions. When the resultant clarified water is recirculated it causes the advanced flotation process to be conducted under the best pH conditions.

- Automatic Sampling

Automatic slurry samplers are located to obtain periodic samples of various flowstreams for analytical purposes. Sampling and weighing points are indicated on previously presented flowsheets. Cutter speeds and openings are mechanically preset. Cutter frequencies are controlled by preset values in the supervisory controller. The running number of cuts are totalized and stored within the controller's logic for access. Cutter operations are indicated on the panel. Slurry samples are as follows:

1. Water-Only Cyclone Underflow
2. Advanced Flotation Tails
3. Advanced Flotation Product

Automatic "dry type" samplers (primary cutter only) are located at the discharge of the refuse centrifuge and clean-coal filter. Cutter speeds and openings are mechanically preset. Cutter frequencies are controlled by preset values in the supervisory controller. The running number of cuts are totalized and stored within the controller's logic for access. Cutter operation are indicated on a panel.

Plant process control and instrumentation functions are summarized in Table 5.01

- Discussion of Start-Up and Shutdown Procedures

Automatic start or stop of the Semi-Works cleaning facility occurs in a predetermined order. That sequence is dependent upon operator selection, and is defined by a functional control specification, the flow diagram, and the interlocking diagram.

Table 5.01 Plant Control Summary					
# AND ITEM	IND.	REC.	ALARM	ON-OFF	COMMENT
1. Sump Levels	Y			Y	Controls Make-up
2. H.M. Cyclone Sump Level	Y	-	Y	Y	Controls Make-up & Bleed
3. H.M. Cyclone Density	Y	Y	Y	-	Controls Recirculating Media
4. Overdense Media Density	Y	-	Y	Y	Controls Magnetite Feeder
5. Advanced Column Level	Y	-	Y	-	Controls Column Level
6. Advanced Column-Gas Hold-Up	Y	-	Y	-	Controls Frother Feeder
7. Advanced Feed-Flow Rate	Y	-	-	-	
8. Thickener Hi Torque	-	-	Y	Y	
9. Thickener Settling Rate	Y	-	-	-	Controls Anionic Floc.
10. Turbidity Meter	-	-	-	Y	Controls Cationic Floc.
11. Thickener Underflow Density	Y	-	-	-	Controls Speed of Underflow Pump
12. TPH - Plant Feed	Y	Y	-	-	
13. TPH - Product	Y	Y	-	-	
14. TPH - Refuse	Y	Y	-	-	
15. pH Thickener Feed	Y	-	-	Y	Controls Acid/Base Addition Feeders
16. Low Level in Anionic Floc Tank	-	-	Y	-	
17. Low level in Cationic Floc. Tank	-	-	Y	Y	
18. Slurry Samplers (3 total)	-	-	-	Y	
19. Dry Samplers (2 total)	-	-	-	Y	

The PLC contains the necessary process and safety interlocking functions. Interlocking prohibits a process or piece of equipment from running unless all conditions related to the proper and safe operation of that process or piece of equipment are met. Interlocking therefore ensures that operational values are within the operator defined ranges and that all devices are safe and the process is correctly configured.

If a failure occurs on a running piece of equipment the PLC initiates a shut down of that equipment and all pieces of equipment dependent upon that failed equipment in accordance with the interlock requirements.

Under normal shut down sequencing, the PLC takes a predefined adjustable time period for purging each of the major pieces of equipment.

Functional Criteria

Pilot devices will be furnished according to the following criteria:

- Alarm and shutdown circuits designed to be activated by devices such as pressure switches, relays, current switches, thermostats, PLC output cards, limit switches, pushbuttons, etc., are designed to fail safe; that is, the protective device will open under abnormal conditions to break continuity in the circuit.
- Stop functions are initiated by de-energizing the controlled device.
- Start pushbuttons has normally open contacts; that is, a contact closure will initiate the ON or START function.
- Jog pushbuttons has normally open contacts; that is, a contact closure will initiate the jog function.
- Stop pushbuttons have normally closed contacts; that is, a contact opening will initiate the OFF or STOP function.
- Selector switches have all normally open contacts and a contact closure will be indicative of the selected switch position.
- End of travel limit switches have normally closed contacts; that is at end of travel the electrical contact will be opened and closed at all other positions of travel.

Control Modes

The Semi-Works plant can be started in automatic or manual modes. In automatic mode, motors are started by the PLC in a preset sequence with all interlocks requirements in place. The operator has the capability of manual mode that allows him to start and stop any piece of equipment controlled by the system. The process interlocks are enforced unless the bypass mode has been invoked by the operator. Selecting between an automatic start sequence and manual mode of control does not stop or disrupt any equipment currently running.

Bypass Mode

In the normal bypass mode the operator can bypass the process interlocks required for the process pumps. These pumps are typically started in recirculation mode before most plant equipment in order to stabilize material consistency. In addition to the normal bypass mode, a special equipment bypass is available which allows the operator to select any piece of equipment to operate in the bypass mode. If a piece of equipment is selected in bypass mode, the interlocking required to operate it is no longer valid. The operator then has the capability to run that particular piece of equipment irrespective of the status of any other piece of equipment.

Whenever any start sequence is initiated by an operator, the status of the special bypass mode is checked. If any piece of equipment is in bypass, it is annunciated and the operator will be asked whether to take all the equipment out of bypass mode or to proceed with the requested start sequence.

Operator Interface

- The operator interacts with the PLC-based process control system via color video terminals with keyboards. These units are located in the operator control station (OCS).
- The OCS allows the operator to manipulate various process control variables and equipment operation by means of keyboard input. This includes but is not limited to adjustment of controller mode of operation (automatic, manual, cascade, etc.), setpoint value, control output value, alarm levels, timing constraints, remote start/stop of motors or other equipment and control system mode of operation (automatic, semi-automatic and manual).
- All system displays are accessible from any of the video terminals.
- Any real time process variable values displayed on any screen shall be updated at least every 2 seconds.
- The operator control station provides for the following control screens as a minimum:

1) Overview Display

All discrete analog or digital points displayed with indication of status (auto, manual, energized, de-energized, running, stopped, etc.), or alarm condition.

2) Group Display

A user configurable group of control or indication points including: the group identification, the individual point identification; process or control variables/parameters (i.e., setpoint, output, process variable, stations, etc.) and alarm conditions.

The operator is able to select any point from the group and manipulate the appropriate control parameters (i.e., setpoint, controller mode, start/stop, etc.).

The system allows for any individual point to be displayed in multiple group displays.

3) Individual Point Display

The individual loop display presents detailed information for any operator selected control or indication point. This information shall include the following as a minimum:

- Indication of all process variable or control parameter variables
- Point identification
- Tuning constants
- Alarm settings

This system provides a security system to prevent unauthorized changes to control or indication parameters except for set-point adjustments, auto-manual selection, and output value under keylock operation.

4) Alarm Displays

The system has an alarm display system to alert the operator to any abnormal process or equipment condition.

When an alarm condition occurs, the operator is informed by audible horn and visual indication on the screen, regardless of which display screen the operator is viewing at the time.

The operator is able to acknowledge and silence an alarm through a simple keyboard entry.

The system has a chronological alarm summary display. The summary display shows all unacknowledged alarms and all active alarms which have been acknowledged, in a tabular format. This display includes the tag number of the alarm point, type of alarm (hi/lo process variable, deviation, etc.) and time the alarm condition occurred. When an individual point has been acknowledged and the condition has returned to within normal ranges, the alarm is automatically removed from the alarm summary.

The system provides a hard copy of all alarms by means of a printer. All alarms are logged with the alarm point tag number, type of alarm, time of alarm, time of acknowledgement, short description of alarm point and time the alarm condition returns to normal.

The operator control station is provided with the following graphic display screens:

1) Overview Display

An interactive color graphic display of the overall process operation with visual indication of equipment status (i.e. visual differentiation between running and non-running equipment) as well as dynamic display of selected process variable setpoints and controller outputs values as well as mode of operation.

2) Subsystem Displays

An interactive color graphic display of selected subsystem or equipment display screens with visual indication of equipment status as well as dynamic display of critical process variable values.

3) Auto Start Displays

A custom auto start screen, consisting of all text, provides the following:

- All major processing units arranged in start-up sequence.
- Each line showing equipment number, equipment description, current amp reading if available.
- Color of text changes to indicate status of equipment including, but not limited to, running, stopped, and failed.
- Indication of units being operated out of interlock.
- Indication of current operating status of levels, densities, and torques, if available.
- Indication of which equipment is in bypass mode and the ability to select interlocking mode or bypass mode.

5.3 Capital Cost Estimate

Based upon POC test results and all previous testing and evaluations, a final flowsheet, plant layout, and process and instrumentation diagram were developed for the Semi-Works facility. A process, sampling and laboratory equipment list, general arrangement drawings, and structural, electrical and piping drawings were also prepared. The process and instrumentation diagram, the equipment list and all engineering drawings may be found in Appendix C. These documents form the basis for defining the plant battery limits, upon which a detailed capital cost estimate was prepared.

The capital cost estimate for the Semi-Works facility is an ICF KE Type 3 preliminary estimate with an expected level of accuracy of ± 10 percent. Besides the information described above, this type of estimate required the knowledge of product capacity and plant location. Craft wage rates and fringe benefits, payroll taxes and insurance, local sales and other taxes, design and construction work durations, and facility insurance requirements were estimated based on locating the facility in the area of Pittsburgh, Pennsylvania.

One capital cost estimate was prepared to cover all three of the test coals. A summary of the capital cost breakdown is presented in Table 5.02. The costs in this table are broken down into four areas: General contractor costs, construction contractor costs, engineering contractor costs and electrical contractor costs. It is assumed in this breakdown that the general contractor purchases all equipment and arranges the contracts for the three other subcontractors.

A detailed cost estimate for the Semi-Works facility appears in Appendix C. Information from this detailed estimate was grouped in order to prepare Table 5.02. The detailed estimate breaks all work down into the following elements:

200	Concrete and foundations
300	Structural steel
400	Architectural work
500	Equipment installation
600	Piping
675	Mechanical
700	Electrical and instrumentation
900	Indirect and distributable
901	Engineering
902	Project/construction management
903	Field office expenses
904	Insurance/taxes/permits

Costs in items 200 through 675 less the equipment costs in these areas were assigned to the construction contractor costs appearing in Table 5.02. Item 700 less equipment was the responsibility of the electrical contractor, and item 901 was set aside for the engineering contractor. All other costs including all equipment costs for all areas were contained in the costs presented for the general contractor.

The general contractor profit was calculated as five percent of the total costs for all the elements listed above. An additional five percent was added to these two costs for contingencies which are then spread between all contractors on a proportional basis.

Lump sums costs are provided in the detailed estimate for elements 901, 902 and 904. For each of the remaining work elements, required manhours were estimated. Costs were then estimated for labor, equipment usage, material, subcontracts, equipment, and element subcontractor overhead and profit for each work element.

Material quantities were developed based on the preliminary design drawings. Material pricing was based for the most part on vendor quotations with some complementary estimator judgement. Vendor quotations were received for all equipment. For the labor estimates, crew rates were established for each of the erection work elements assuming a crew of journeymen, a foreman and a general foreman. Crew rates included base wages, fringe benefits, payroll taxes and insurance, small tools, and overhead and profit.

Equipment usage was based on the blue book rental cost and includes fuel and maintenance. Finally, the construction and electrical contractors' overhead and profit is based on 10 percent each of equipment usage, material, and construction indirects.

Table 5.02 Total Estimated Capital Cost for Semi-Works Flowsheet	
CONSTRUCTION CONTRACTOR	
Construction Contractor Cost	2,639,059
Contingency	138,778
Overhead and Profit	136,508
TOTAL CONSTRUCTION ESTIMATE	2,914,345
Basis for Estimate: Cost	ICF KE Type 3, Preliminary Estimate
Contingency	5% of (Construction Cost + Overhead and Profit)
Overhead & Profit	10% of (Equipment Usage + Material + Construction Indirects)
GENERAL CONTRACTOR	
General Contractor Cost	5,600,892
Contingency	304,797
Overhead and Profit	495,027
TOTAL GENERAL CONTRACTOR ESTIMATE	6,400,716
Basis for Estimate: Cost	ICF KE Type 3, Preliminary Estimate
Contingency	5% of (Other Contractors' Total Costs Less Contingencies + General Contractor's Costs)
Overhead & Profit	5% of (All Contractors' Costs Less Contingencies) - Other Contractors' Contingencies
ENGINEERING CONTRACTOR	
Engineering Contractor Cost	545,455
Contingency	30,000
Overhead and Profit	54,545
TOTAL ENGINEERING CONTRACTOR ESTIMATE	630,000
Basis for Estimate: Cost	ICF KE Type 3, Preliminary Estimate
Contingency	5% of (Engineering Cost + Overhead and Profit)
Overhead & Profit	10% of Engineering Cost
ELECTRICAL CONTRACTOR	
Electrical Cost	896,813
Contingency	46,204
Overhead and Profit	27,274
TOTAL ELECTRICAL CONTRACTOR ESTIMATE	970,291
Basis for Estimate: Cost	ICF KE Type 3, Preliminary Estimate
Contingency	5% of (Electrical Cost + Overhead and Profit)
Overhead & Profit	10% of (Equipment Usage + Material + Construction Indirects)
TOTAL PROJECT ESTIMATE	
\$10,915,352	

6.0 ECONOMICS OF THE ADVANCED FROTH FLOTATION PROCESS

Using the Semi-Works plant design and capital cost estimate as a base, economics for the advanced froth flotation process were evaluated for a number of different scenarios, varying plant size, hours of operation, and expected rates of return. A standard set of economic assumptions and unit supply costs are presented in Table 6.01. These assumptions were used in the development of nine economic case studies for each coal.

Table 6.01 Standard Economic Assumptions			
Capital Cost of Plant = Capital Cost of 20 TPH Plant x (new plant size/20) ^{0.70}			
Equipment Cost = Equipment Cost of 20 TPH Plant x (new plant size/20) ^{0.70}			
Plant Availability = 90 percent		Financing	100 percent equity
Plant Life = 20 years		Inflation Rate	4.0 percent
Royalties None		Corporate Tax Rate	38.0 percent
Construction Period 2 years (50% investment each year)			
Standard Unit Supply Costs			
Land	\$5,000 per acre	Kerosene	\$0.09 per pound
Electric Power	\$0.06 per kilowatt-hour	Grinding Media	\$0.36 per pound
Flocculants	\$2.00 per pound	Magnetite	\$0.06 per pound
Frother Reagent	\$0.55 per pound	Sodium Hydroxide	\$0.07 per pound
Make-up Process Water	\$0.05 per 1000 gallons		

The primary case for each coal involves a 200 tons-per-hour (product) commercial plant operating 7,560 hours per year. This plant operates 350 days per year and three shifts per day. An assumed 90 percent availability results in the total hours of operation. Economics were next calculated for similar 200 tons-per-hour plants with operating schedules of 5040 hours and 3456 hours per year. Each of these schedules included two operating and one maintenance shift each day. The former schedules, however, included seven days per week of operations while the latter includes only five. Sensitivity of the process economics to operating schedule is illustrated using these first three cases.

Economics were also evaluated for a 20 tons-per-hour Semi-Works plant and a 500 tons-per-hour commercial facility, each with an operating schedule of 7560 hours per year. While the Semi-Works size plant is not meant to be economically viable, these cases along with the primary 200 tons-per-hour case allow the evaluation of the sensitivity of process economics to plant capacity. Each of the five cases described above were evaluated based on an expected 10 percent, after-tax rate of return. For the primary case, additional economic evaluations are presented using 15 and 20 percent expected investment returns.

The last two economic evaluations for each coal break out the cost of the advanced froth flotation circuitry in order to evaluate the feasibility of adding this circuitry to existing commercial coal cleaning facilities. An advanced process equipment list is presented in Appendix D. This list is a subset of the process, sampling and laboratory equipment list that was

developed for work element 500 of the detailed, Semi-Works plant cost element. This subset includes coal comminution equipment, advanced froth flotation equipment, and ancillary equipment required for the support of these operations.

In the detailed cost estimate, equipment costs appear in cost elements 675 (Mechanical) and 700 (Electrical and Instrumentation) in addition to element 500. The advanced equipment subset developed from cost element 500 was responsible for 77.4 percent of the cost and 73.3 percent of the horsepower requirements for all element 500 equipment. These percentages were used to assign a portion of element 675 and 700 costs to the advanced froth flotation addition. Thus, 77.4 percent of the mechanical equipment cost and 73.3 percent of the electrical and instrumentation equipment costs were required for the advanced process equipment. For the 200 TPH Semi-Works plant, then \$3,592,174 or 76.8 percent of the total equipment cost of \$4,675,561 was due to the advanced equipment. Total estimated capital cost of the 20 TPH plant addition is estimated, then as 76.8 percent of the 20 TPH Semi-Works plant. Economics of a 200 TPH plant addition was evaluated at an expected 10 percent after-tax rate of return and operating schedules of 7560 and 3456 hours per year.

In all, 27 case studies were evaluated covering all three base coals. The economics were analyzed for these cases using the Coal Preparation Plant Evaluation Model developed by Eos Technologies, Inc. under DOE Contract No. DE-AC22-87PC79338, Subcontract No. PTS-88-8244. For each case study, a coal cost, a direct processing cost, a working capital cost, and fixed and variable yearly operating and maintenance costs were input into the computer model. Input and output tonnages and qualities were required as well as the plant capacity factor: the estimated operating hours divided by the total hours available in a year (8760 hours). The cost for raw coal in every case was assumed to be \$0.80 per million Btu.

6.1 Direct Processing Costs

Direct processing costs for each of the case studies included the capital cost of the plant, land purchase, preproduction costs, and costs for start-up modifications. The capital cost of the plant was calculated for the high capacity plants by extrapolating the cost of the 20 tons-per-hour Semi-Works plant or the 20 TPH plant addition using the formula in Table 6.01. The cost of land was based on the estimated requirements of 50, 500, and 1000 acres required for 20, 200, and 500 tons-per-hour plants, respectively. The cost of land for a 200 TPH plant addition was estimated as 76.8 percent of that for the entire 200 TPH plant. Preproduction costs included a month's supply of each of the following: power, process consumables, lubricants, manpower and maintenance supplies. Finally, a cost for start-up modifications was estimated for each case as 2 percent of the capital cost of the plant. Direct processing costs were unique for each base case evaluated.

6.2 Working Capital Requirement

Working capital requirements included a week's supply of flocculants, flotation reagents (frother and kerosene), grinding media, lubricants and magnetite. Also, two percent of the equipment cost, less electrical equipment, was added for a spare parts inventory.

6.3 Fixed Operating and Maintenance Costs

Fixed operating and maintenance costs included costs for operations and maintenance labor, administrative costs, yearly maintenance supply costs, and plant insurance and taxes. Operating and maintenance labor costs included plant supervision and classified workers. Table 6.02 presents these labor costs for the various operating schedules evaluated. For a 200 TPH plant addition, it was estimated that, on an incremental basis, the addition would require three men for a 7560 hour schedule and two men for a 3456 hour schedule. Administrative costs were calculated as 30 percent of the costs shown in Table 6.02. Yearly maintenance supply costs were estimated at 10 percent of the equipment cost. Finally, plant insurance and taxes were estimated as 3 percent of the capital cost of the plant in each case.

Table 6.02 Operating and Maintenance Labor Costs for Various Operating Philosophies			
	7560 Hours/Year 20, 200 & 500 TPH	5040 Hours/Year 200 TPH	3456 Hours/Year 200 TPH
Superintendent	\$89,114 (1)	\$89,114 (1)	\$89,114 (1)
Foreman	\$249,522 (4)	187,141 (3)	124,760 (2)
Classified	\$1,129,003 (21)	\$752,699 (14)	672,036 (13)
Total	\$1,467,639 (26)	1,028,924 (18)	\$886,110 (16)
Note: Value in parentheses represents number of men required.			

6.4 Variable Operating and Maintenance Costs

These costs included the yearly costs for flocculants, flotation reagents, grinding media, lubricants, magnetite, power, and process water. Costs for flocculants and flotation reagents are extrapolated based on the unit supply costs in Table 6.01, the usage rates, on a pound per ton of circuit feed, determined during POC testing, and the estimated circuit feed tonnage for each size plant.

Grinding media usage was estimated based on available mineral industry data. Magnetite usage was based on 1.2 pounds per ton of heavy-media-circuit feed. Equipment lubrication costs were estimated as \$0.02 per clean coal ton.

6.5 Economic Evaluations

The costs described above were developed for 7 base cases for each of the three coals. For each of these cases, a ten percent rate-of-return was assumed. For the primary case of a 200 tons-per-hour plant operating 7560 hours per year, two additional cases were also run using 15 percent and 20 percent rates-of-return. This was completed for all three coals, making 27 total economic evaluations.

- 200 Tons-Per-Hour Advanced Froth Flotation Plant

The primary case study for each coal involved a plant that produces 200 tons-per-hour of clean coal product at the average quality produced during the 24-hour demonstration periods of POC testing. In these cases, the plant operation schedule is 350 days-per-year and 24 hours-per-day. Assuming 90 percent availability, these plants are operated for 7560 total hours-per-year.

These 200 tons-per-hour plants are estimated to cost \$54,706,000 (capital cost). Including land, preproduction costs and expected start-up modifications, a total plant capital requirement of approximately \$59,600,000 is expected. In addition \$450,000 to \$580,000 of working capital is required, depending on the coal, at plant start-up. Table 6.03 presents these capital requirements for the three base coals. Similar costs for the other base cases are presented in Appendix D.

Fixed annual operating and maintenance costs for these 200 TPH plants approach \$5,900,000. Maintenance supplies represent the bulk of these costs at \$2,340,000. Variable annual operating and maintenance costs range from \$11,160,000 for the Upper Freeport coal to \$12,610,000 for the Illinois No. 6 coal. Increased consumption of flocculants and flotation reagents account for the increased operating costs for the Illinois No. 6 coal. Table 6.04 provides a breakdown of the annual operating and maintenance costs for the three coals. Similar costs for the other base cases are presented in Appendix D.

Based on the costs presented in Tables 6.03 and 6.04, the raw coal cost, the assumptions presented in Table 6.01, and a ten percent expected after-tax rate-of-return, the Eos economics model calculates incremental coal cleaning costs and total coal product costs on annualized and levelized bases. In addition, the model calculates the present value for all costs, the investment payback period, and the annualized desulfurization costs.

Table 6.03
Capital Requirements for 200 TPH (Product) Plants
Operating 7560 Hours per Year

DIRECT PROCESSING COSTS ESTIMATION			
COST ITEM	ALL THREE COALS		
A - Capital Cost of Plant	54,706,371		
B - Capital Cost of Equipment	23,433,315		
C - Mechanical Equipment Cost	19,988,023		
D - Land Purchase	2,500,000		
E - Start-up Modifications	1,094,127		
F - Preproduction Costs	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Power	720,166	720,166	720,166
Flocculants	55,138	76,572	151,339
Flotation Reagents	150,312	58,449	103,185
Water	3,345	2,003	2,911
Grinding Media	54,425	51,296	53,881
Lubricants	5,882	3,940	4,890
Magnetite	17,418	17,418	14,787
Manpower	122,303	122,303	122,303
Maintenance Supplies	195,278	195,278	195,278
DIRECT PROCESSING COSTS (A+D+E+F)	59,624,735	59,547,893	59,669,206
WORKING CAPITAL REQUIREMENT ESTIMATION			
COST ITEM	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Flocculants	13,233	18,377	36,321
Flotation Reagents	36,075	14,028	24,764
Grinding Media	13,062	12,311	12,931
Lubricants	1,412	946	1,174
Magnetite	4,180	4,180	3,549
Spare Parts = 2% of Mech. Equip.	399,760	399,760	399,760
TOTAL WORKING CAPITAL REQUIRED	467,723	449,603	478,500

Table 6.04 Annual Operating and Maintenance Costs for 200 TPH (Product) Plants Operating 7560 Hours per Year			
YEARLY FIXED OPERATING AND MAINTENANCE COSTS			
Cost Item	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Plant Labor Costs	1,467,639	1,467,639	1,467,639
Administrative Labor and Costs	440,282	440,282	440,282
Maintenance Supplies	2,343,330	2,343,330	2,343,330
Insurance and Taxes	1,641,190	1,641,190	1,641,190
Yearly Fixed O&M Costs	5,892,451	5,892,451	5,892,451
YEARLY VARIABLE OPERATING AND MAINTENANCE COSTS			
Cost Item	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Flocculants	661,651	918,861	1,816,063
Flotation Reagents	1,803,749	701,393	1,238,219
Grinding Media	653,105	615,551	646,574
Lubricants	70,583	47,282	58,677
Magnetite	209,019	209,019	177,448
Power	8,641,987	8,641,987	8,641,987
Process Water	40,144	24,041	34,927
TOTAL YEARLY VARIABLE O&M COSTS	12,080,238	11,158,134	12,613,895

The incremental clean coal cost is the costs associated with the plant investment, operating and maintenance costs, and the cost of lost Btu. This cost is added to the raw coal cost and the subsequent total clean coal cost is the price of clean coal required to achieve the designated after-tax rate-of-return on investment. The annualized total clean coal cost may be interpreted as the real coal product selling price, in dollars relevant to the first year of operations, required during each operating year in order for the investment in the plant to realize the specified after-tax rate-of-return. Refer to the Eos Model User Guide and Technical Manual for additional information and the calculations completed for the annualized and leveled cost evaluations.

Table 6.05 presents the economic summary for each of the base case, 200 TPH preparation plants. Based on raw coal costs of \$0.80 per million Btu, clean-coal prices of \$40.27 to \$41.96 per ton, on an annualized basis, are required for the three coals in order to earn a ten percent after-tax rate-of-return. Annualized desulfurization costs (dollars-per-ton of SO₂ equivalent) range from \$304.60 for the Illinois No. 6 coal to \$326.82 for the Pittsburgh No. 8 coal. Appendix D presents the results of economic evaluation for the different operating philosophies, plant sizes, and rates-of-return. Figure 6.01 presents the effect that expected rates of return have on the annualized desulfurization costs for the 200 TPH plants (7560 operating hours). For the Pittsburgh No. 8 coal, for instance, the

annualized desulfurization cost increases by \$91.32 per ton to \$418.14 when the expected rate of return increases from 10 to 20 percent. Similar increases of \$85.75 and \$79.38 are estimated for the Upper Freeport and the Illinois No. 6 coals.

Table 6.05 Advanced Froth Flotation Process Economics 200 TPH Commercial Plant Operating 7560 Hours per Year			
Cost Item	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
Annualized Costs			
Raw Coal \$/MM Btu	0.80	0.80	0.80
\$/ton	11.73	11.73	11.73
Clean Coal			
Incremental \$/MM Btu	0.69	0.70	0.75
Total \$/MM Btu	1.49	1.50	1.55
Total \$/ton	40.65	40.27	41.96
Levelized Costs			
Raw Coal \$/MM Btu	1.06	1.06	1.06
\$/ton	15.48	15.48	15.48
Clean Coal			
Incremental \$/MM Btu	0.91	0.92	0.98
Total \$/MM Btu	1.97	1.98	2.04
Total \$/ton	53.66	53.16	55.39
Other Costs			
Present Value of Costs	\$180,642,000	\$179,495,000	\$193,879,000
Payback Period	7.9 Years	7.9 Years	7.9 Years
Annualized Desulfurization Costs	\$326.82	\$305.42	\$304.60

- Economic Sensitivity to Plant Operating Hours

Economics of plant investment and the annualized desulfurization costs can be significantly affected by the plant operating schedule also. The previous examples presented the results for a plant operating virtually every day of the year (350 days) and three shifts every day. A two-shift operation scheduled the same number of days would have a significantly reduced plant capacity factor and, subsequently, the capital costs associated with the plant investment are then spread over significantly less tons of clean coal product. This assumes, of course, that the operating life of the plant remains unchanged. In order to illustrate this, the two-shift operating schedule and a third, five-day, two-shift schedule were evaluated. This third operating schedule is similar to that commonly employed in the coal industry. In this case, the plant is operated two shifts per day, five days-per-week. Due to a two-week summer shutdown period and scheduled holidays, 240 days per year are available. Maintenance is conducted on the third shift of every operating day. Based on 90 percent availability, the plant operates

Figure 6.01 Sensitivity of Process Economics to Expected, After Tax Rate of Return

3456 hours per year. One less supervisor is required and one less classified worker is required to operate the plant, but the maintenance shift require six classified employees. Figure 6.02 presents the annualized desulfurization costs versus the plant operating hours for each of the three operating schedules. As expected, costs of desulfurization increase dramatically when the plant capital investment has to be spread over a smaller tonnage base.

- Economic Sensitivity to Plant Size

In addition to operating philosophy, plant size can significantly affect investment economics. To illustrate this point, the economic evaluations were also conducted on the 20 tons-per-hour Semi-Works plant and a 500 tons-per-hour commercial plant. In each case, the plant operating schedule was similar to the primary, 200 tons-per-hour case (i.e., 7560 operating hours per year). The capital cost estimate for the 20 tons-per-hour plant was presented in Section 5 of this report. The capital cost of the 500 tons-per-hour plant was extrapolated from the Semi-Works plant capital cost estimate using the formula in Table 6.01. Figure 6.03 presents the sensitivity of annualized desulfurization costs to plant size for the three plant sizes studied. The cost-per-ton-of-SO₂ removed drops dramatically between 20 and 200 tons-per-hour. For the Pittsburgh No. 8 coal, the 20 tons-per-hour plant investment scenario results in a desulfurization cost of \$675.33 per ton, compared to \$326.82 for the 200 tons-per-hour plant. Desulfurization costs decrease another 16

Figure 6.02 Sensitivity of Process Economics to Operations Schedule

percent to \$275.27 by investing in a 500 tons-per-hour plant. The need to build a larger plant is obviously dependent on the demand of the coal product. If there are no long-term contracts in place to guarantee this demand, there is additional risk associated with the larger investment required for high-capacity plants.

- Economics of a 200 TPH Plant Addition

The process philosophy embraced for this project uses conventional coal cleaning techniques in order to remove the coarse and easy-to-

Figure 6.03 Sensitivity of Process Economics to Plant Capacity

remove sulfur and mineral matter prior to coal comminution efforts. This reduces the capacity of the crushing and grinding equipment as

well as the advanced froth flotation equipment in two ways. The first of these is simply related to feed tonnage removed by the precleaning. Secondly, the high ash matter removed in precleaning would likely be comprised of harder, more-difficult-to-crush particles, which if not eliminated would increase recirculating loads in the coal communication circuits and thus reduce their capacity. The characterization of these intermediate streams as to their grindability was not studied as part of this project.

However, to gain an understanding of the incremental benefit of the advanced circuitry, a simplified economic evaluation was conducted. The capital, operating, and maintenance requirements for a 200 TPH advanced plant addition was developed as described in sections 6.1. through 6.4. Desulfurization costs were then estimated based on these costs applied to the sulfur removed by only the advanced froth flotation circuit. A portion of the sulfur removed in the water-only cyclone circuit is attributable to the advanced process equipment. The data obtained during POC testing does not allow the isolation of this portion, however, and thus was not included in the evaluation.

Table 6.06 presents the annualized desulfurization costs estimated for a plant addition based on two different operating schedules. The economics for the plant addition are much less favorable relative to the entire process due to the high capital cost of the advanced process equipment and the relatively small amount of sulfur removed in the advanced froth flotation cell. These factors will serve to restrict the application of the advanced froth flotation process primarily to new, greenfield, projects, or to cases where there are few or no alternatives to the physical removal of sulfur in the coal.

<p>Table 6.06 Estimated Annual Desulfurization Costs Per Ton of SO₂ Equivalent For 200 TPH (Product) Advanced Process Plant Addition</p>			
Operating Schedule	Pittsburgh No. 8	Upper Freeport	Illinois No. 6
7560 hours per year	\$1148	\$969	\$1460
3456 hours per year	\$1721	\$1419	\$2111

7.0 PROJECT CONCLUSIONS AND RECOMMENDATIONS

Important findings resulted from the conduct of bench-scale and 100 pounds-per-hour testing and the POC testing. From these results, a commercially-viable process incorporating conventional coal cleaning circuitry, the novel application of fine coal grinding, and an advanced froth flotation operation was developed in an attempt to meet process performance and product quality goals established by the U.S. Department of Energy. Finally a detailed capital cost estimate was determined for a 20 tons-per-hour Semi-Works advanced froth flotation plant. Economic evaluations were completed for this plant and 200 and 500 tons-per-hour commercial plants employing the proposed process. Following are the conclusions derived from testwork and evaluation as well as recommendations for future process development efforts.

7.1 Bench-Scale and 100 Pounds Per Hour Testing

- The Pittsburgh No. 8, Upper Freeport, and Illinois No. 6 coals all have the potential, when ground to the proper size, to be cleaned such that 85 percent of the pyritic sulfur is removed while 85 percent of the energy is recovered.
- Significant pyritic sulfur rejection can be achieved for these coals with conventional coal cleaning processes and with little energy loss. These operations should be employed prior to ultrafine grinding and advanced ultrafine coal cleaning processes. More effective application of the ultrafine grinding operation results since a large portion of unwanted impurities is already removed. Smaller grinding circuits are required due to lower tonnages and softer, easier-to-grind feedstock.
- Advanced column froth flotation can exploit the increased state of liberation imparted to the coal, mineral matter, and pyritic sulfur particles when reducing grinding size from 200 mesh by zero to 325 mesh by zero.
- Only slight metallurgical advantage is achieved with multiple stage column flotation, as compared with single stage, if wash-water is properly utilized.

7.2 Proof-Of-Concept Module Testing

- The proposed advanced froth flotation unit can be integrated with the proposed, commercial-ready unit operations to construct an overall commercially viable and continuous process.
- At the achieved final grind of about 85 percent passing 200 mesh, the proposed process can remove between 73 and 79 percent of the raw coals' pyritic sulfur while recovering 85 percent or more of the raw coals' energy content.
- The proposed process did not achieve 85 percent pyritic sulfur rejections at the goal of 85 percent energy recovery. Also, the target ash of 6 percent, on a dry basis, was not achieved. Grinding to a final product particle size finer than 85 percent passing 200

mesh is necessary to achieve the process performance goals and product quality targets.

- The high-g solid bowl centrifuge could not dewater the plant clean coal to the desired level of 30 percent surface moisture. The hyperbaric disk filter, commercially operated in Germany, likely can achieve the moisture target.
- Conventional thickening and dewatering techniques can be used to recover the advanced froth flotation products.
- The advanced froth flotation process can be adversely affected by high residual levels of flocculants in plant recirculating water.

7.3 Economics

- The capital cost of a 20 tons-per-hour Semi-Works plant incorporating the proposed advanced froth flotation process will approach \$11,000,000 in 1994 dollars.
- Extrapolation of the costs for larger 200 and 500 tons-per-hour plants indicate the capital requirements will approach \$60 million and \$115 million respectively.
- Economic modelling indicates clean coal prices, F.O.B., the preparation plant, of \$40 to \$42 per ton (or \$1.50 per MM Btu) will be required for investments in a 200 tons-per-hour (product) plant to earn a ten percent, after-tax rate of return.
- The larger, 500 tons-per-hour plant reduces required coal prices by \$3 per ton or \$0.12 per MM Btu.
- Desulfurization costs, on a dollar per ton of SO₂ equivalent, for the 500 tons-per-hour plant are \$275.27 for the Pittsburgh No. 8 coal, \$256.95 for the Upper Freeport coal, and \$259.84 for the Illinois No. 6 coal.

7.4 Recommendations for Future Technology Development

- POC-scale or larger scale testing should be conducted on gravimetric treatment of the advanced froth flotation concentrate.
- POC-scale or larger-scale testing should be completed on the proposed advanced froth flotation process at grinds finer than that achieved during the present work. Grinds of 270 mesh or finer will likely be necessary in order to achieve 85 percent pyritic sulfur rejection and 85 percent energy recovery.
- Further development efforts on the cost-effective reconstitution of advanced froth flotation concentrate will be necessary in order to facilitate the commercialization of advanced coal cleaning technology.
- Additional testing of the hyperbaric disk filter is warranted based on the promising results achieved during the POC testing. Other

dewatering options such as the Larox pressure filter also hold potential for dewatering coal products sized at 85 percent passing 200 mesh to levels near 30 percent surface moisture.

8.0 REFERENCES

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APPENDIX A

LABORATORY COLUMN FLOTATION DATA

**LABORATORY COLUMN FLOTATION RESULTS
PARAMETRIC TEST MATRIX**

Test No.	Coll. Dose #/ton	Froth. Dose #/ton	Air Rate ml/min	Feed Solids (%)	Feed Rate ml/min	Wasewater Rate ml/min	Meas. Yield (%)	Ash (%)			Sulfur (%)			Btu per Pound			Pyritic Sulfur (%)			Adj. Yield (%)
								Feed	Conc.	Reject	Feed	Conc.	Reject	Feed	Conc.	Reject	Feed	Conc.	Reject	
1	1.5	2.5	1000	15	150	400	92.7	9.63	4.36	78.13	3.56	3.36	6.17	13205	14055	2147	1.28	0.92	5.82	92.9
2	0.5	2.5	1000	15	150	400	92.8	8.88	4.27	73.17	3.45	3.22	6.58	13265	14060	2170	1.23	0.88	6.18	93.3
3	1.5	0.5	1000	15	150	400	85.9	9.61	3.94	44.11	3.46	3.19	5.11	13205	14100	7760	1.23	0.81	3.89	85.9
4	1.5	2.5	1000	5	150	400	92.2	9.60	4.18	70.00	3.40	3.13	6.36	13240	13365	11847	1.22	0.80	5.85	91.8
5	0.5	0.5	1000	15	150	400	76.1	8.85	3.80	29.54	3.38	3.14	4.37	13265	14074	9948	1.17	0.83	2.83	80.4
6	1.5	0.5	1000	5	150	400	76.3	9.60	3.72	28.49	3.46	3.02	4.86	13240	14162	10280	1.25	0.64	3.15	76.3
7	0.5	2.5	1000	5	150	400	92.6	9.36	4.31	69.14	3.67	3.46	6.20	13130	13983	3037	1.32	0.95	5.62	92.2
8	0.5	0.5	1000	5	150	400	61.5	9.36	3.15	18.40	3.62	3.20	4.23	13130	14170	11614	1.30	0.70	2.19	59.3
9	1.0	2.5	1500	10	250	400	68.4	9.55	3.76	20.97	3.37	2.98	4.15	13175	14098	11355	1.21	0.66	2.30	66.4
10	1.0	0.5	1500	10	250	400	87.5	9.67	3.89	53.81	3.44	3.17	5.50	13158	13279	12233	1.24	0.80	4.50	88.4
11	1.0	2.5	500	10	250	400	29.4	9.54	3.16	11.98	3.38	2.95	3.54	13175	14223	12776	1.21	0.61	1.43	27.7
12	1.0	2.5	1500	10	50	400	100.0	9.68	7.12	87.66	3.49	3.38	6.82	13159	13590	12266	1.25	1.07	6.78	96.8
13	1.0	0.5	500	10	250	400	63.6	10.57	3.45	16.05	3.59	2.92	4.10	13056	14204	12173	1.24	0.41	2.08	43.5
14	1.0	2.5	500	10	50	400	89.6	9.66	3.52	61.29	3.33	3.04	5.78	13158	14085	5370	1.20	0.74	4.99	89.4
15	1.0	0.5	1500	10	50	400	98.2	10.52	6.10	79.63	3.67	3.15	11.80	13056	13775	5706	1.11	0.67	6.05	94.0
16	1.0	0.5	500	10	50	400	83.4	11.09	3.41	32.08	3.55	2.99	5.09	13056	14243	9810	1.27	0.48	3.40	73.2
17	1.0	1.5	1500	15	150	600	92.5	9.78	4.47	73.28	3.48	3.24	6.32	13202	14053	3026	1.25	0.86	5.89	92.3
18	1.0	1.5	500	15	150	600	84.9	9.77	3.68	43.23	3.64	3.32	5.37	13202	14140	8051	1.29	0.81	4.05	84.6
19	1.0	1.5	1500	5	150	600	93.5	9.28	5.63	63.69	3.80	3.61	6.69	13159	13754	4293	1.37	1.06	5.91	93.7
20	1.0	1.5	1500	15	150	200	97.5	9.77	7.07	86.74	3.59	3.51	5.93	13202	13592	2104	1.29	1.13	5.85	96.6
21	1.0	1.5	500	5	150	600	80.4	9.28	3.43	33.56	3.71	3.27	5.51	13159	14154	9033	1.33	0.72	3.88	80.6
22	1.0	1.5	1500	5	150	200	98.3	9.29	6.90	74.88	3.78	3.73	5.09	13159	13622	439	1.37	1.25	4.63	96.5
23	1.0	1.5	500	15	150	200	90.7	9.70	4.13	65.74	3.57	3.36	5.72	13202	13672	8475	1.31	0.91	4.95	91.0
24	1.0	1.5	500	5	150	200	90.6	9.29	3.59	49.06	3.71	3.37	6.05	13159	14103	6573	1.35	0.82	4.81	87.5
25	1.5	1.5	1000	15	250	400	93.5	9.62	3.98	69.83	3.38	3.14	5.96	13205	14144	3172	1.22	0.82	5.40	91.4
26	0.5	1.5	1000	15	250	400	89.7	8.88	4.05	53.27	3.42	3.16	5.82	13265	14088	5702	1.22	0.83	4.88	90.2
27	1.5	1.5	1000	5	250	400	90.5	9.63	3.80	55.17	3.48	3.12	6.24	13240	14206	5691	1.23	0.73	5.36	88.7

**LABORATORY COLUMN FLOTATION RESULTS
PARAMETRIC TEST MATRIX**

Test No.	Coll. Dose #/ton	Froth. Dose #/ton	Air Rate ml/min	Feed Solids (%)	Feed Rate ml/min	Waswater Rate ml/min	Meas. Yield (%)	Ash (%)			Sulfur (%)			Btu per Pound			Pyritic Sulfur (%)			Adj. Yield (%)
								Feed	Conc.	Reject	Feed	Conc.	Reject	Feed	Conc.	Reject	Feed	Conc.	Reject	
28	1.5	1.5	1000	15	50	400	91.9	9.68	4.55	57.13	3.73	3.50	5.90	13205	14060	5298	1.31	0.95	5.02	90.2
29	0.5	1.5	1000	5	250	400	86.0	9.36	3.60	41.38	3.59	3.18	5.84	13130	14099	7744	1.29	0.71	4.49	84.8
30	1.5	1.5	1000	5	50	400	93.7	9.60	4.23	68.31	3.50	3.09	8.00	13240	14302	1625				91.6
31	0.5	1.5	1000	15	50	400	91.9	8.85	3.89	57.75	3.35	3.06	6.18	13265	14161	4434	1.17	0.78	5.45	90.8
32	0.5	1.5	1000	5	50	400	90.6	9.38	4.45	58.68	3.68	3.30	7.43	13130	13945	4974	1.31	0.79	6.61	90.9
33	1.0	2.5	1000	10	250	600	50.6	9.55	3.46	15.09	3.40	2.92	3.83	13175	14173	12266	1.22	0.57	1.82	47.6
34	1.0	0.5	1000	10	250	600	80.0	10.52	3.79	33.92	3.47	3.03	4.99	13056	14138	9294	1.24	0.61	3.43	77.7
35	1.0	2.5	1000	10	50	600	92.6	9.70	4.01	56.94	3.37	3.17	5.03	13158	14056	5706	1.19	0.85	4.18	89.3
36	1.0	2.5	1000	10	250	200	55.3	9.55	3.71	15.96	3.31	2.98	3.68	13175	14145	12110	1.19	0.70	1.73	52.3
37	1.0	0.5	1000	10	50	600	87.9	10.55	3.87	42.84	3.34	2.92	5.34	13056	14140	7819	1.25	0.60	3.87	82.9
38	1.0	2.5	1000	10	50	200	95.4	9.64	4.93	79.86	3.41	3.29	5.26	13158	13853	2786	1.22	0.95	4.99	93.7
39	1.0	0.5	1000	10	250	200	91.2	10.53	4.14	54.97	3.39	3.06	5.70	13056	14063	6053	1.23	0.71	4.70	87.4
40	1.0	0.5	1000	10	50	200	93.7	10.53	3.89	64.59	3.36	3.03	6.03	13056	14091	4635	1.22	0.69	5.26	89.1
41	1.5	1.5	1500	10	150	600	91.5	9.75	4.42	68.90	3.51	3.24	6.52	13129	14005	3416	1.27	0.84	5.92	91.7
42	0.5	1.5	1500	10	150	600	90.8	9.73	4.33	59.96	3.27	2.94	6.29	13184	14048	5145	1.15	0.70	5.61	90.3
43	1.5	1.5	500	10	150	600	72.8	9.74	3.43	26.38	3.49	3.01	4.90	13129	14131	10172	1.24	0.59	3.23	74.7
44	1.5	1.5	1500	10	150	200	96.7	9.64	6.16	94.53	3.48	3.35	6.66	12129	13580	2118	1.27	1.02	6.77	96.1
45	0.5	1.5	500	10	150	600	72.1	9.70	3.41	27.57	3.30	2.80	4.70	13184	14238	10187	1.18	0.52	3.07	74.0
46	1.5	1.5	500	10	150	200	87.1	9.73	3.83	45.17	3.45	3.07	5.77	13129	14063	7517	1.25	0.69	4.51	85.7
47	0.5	1.5	1500	10	150	200	96.2	9.67	6.32	87.21	3.31	3.19	6.04	13184	13700	1207	1.19	0.98	5.98	95.9
48	0.5	1.5	500	10	150	200	85.4	9.69	3.72	42.56	3.27	2.89	5.37	13184	14172	7748	1.18	0.63	4.12	84.6
49	1.0	1.5	1000	10	150	400	90.1	9.72	3.92	59.66	3.47	3.10	6.65	12882	14100	2391	1.25	0.71	5.80	89.6
50	1.0	1.5	1000	10	150	400	92.3	9.60	3.86	71.06	3.42	3.15	6.21	12882	14072	141	1.26	0.80	5.54	91.5
51	1.0	1.5	1000	10	150	400	90.3	9.73	3.98	61.88	3.54	3.21	6.53	12882	14119	1669	1.27	0.77	5.75	90.1
52	1.0	1.5	1000	10	150	400	90.3	9.69	3.84	66.34	3.48	3.19	6.36	12882	13790	4089	1.27	0.79	5.65	90.6
53	1.0	1.5	1000	10	150	400	90.3	9.73	3.89	61.54	3.55	3.24	6.26	12882	14033	2675	1.37	0.91	5.45	89.9
54	1.0	1.5	1000	10	150	400	90.2	9.66	3.93	72.34	3.40	3.13	6.35	12882	13870	2070	1.24	0.79	5.79	91.6

APPENDIX B

POC—SCALE DATA

PITTSBURGH NO. 8 SEAM WASHABILITY

PITTSBURGH NO. 8 SEAM WASHABILITY GRAPH

% ASH

CUMULATIVE RECOVERY CUMULATIVE ASH

PITTSBURGH NO. 8 SEAM WASHABILITY GRAPH % TOTAL SULFUR

PITTSBURGH NO. 8 SEAM WASHABILITY GRAPH % PYRITIC SULFUR

CUMULATIVE RECOVERY CUMULATIVE PYRITIC SULFUR

147 Eleventh Avenue, South Charleston, WV 25303
Telephone: (304) 744-5472 • Fax# (304) 744-4319

FOR: ICF KAISER ENGINEERS LAB NO. 31017901
P.O. BOX 1488
BEVERLY, OHIO 45715

SAMPLE ID: RUN NO: 93101501
COAL SEAM: PITTSBURGH SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

SAMPLED BY: ICF KAISER ENGINEERS

	<u>SIZE</u>	<u>ELEMENTARY</u> <u>% WEIGHT</u>	<u>CUMULATIVE</u> <u>% WEIGHT</u>
	+ 1/4" RD	51.37	51.37
	1/4" RD X 48 MESH	33.48	84.85
	48 MESH X 200 MESH	5.07	89.92
	200 MESH X 0	10.08	100.00

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FOR: ICF KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OH 45715

CALCULATED COMPOSITE
Top x 0 = 100% OF TOTAL SAMPLE

SAMPLE ID:
RUN NO: 93101501
COAL SEAM: PITTSBURGH SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

LAB NO.: 31017901

SAMPLED BY: ICF-KE

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU
	1.25	0.00				0.00				100.00	40.38	3.14	8292
1.25	1.30	10.05	3.42	1.76	14408	10.05	3.42	1.76	14408	89.95	44.51	3.29	7608
1.30	1.40	34.66	7.68	2.95	13658	44.71	6.72	2.68	13826	55.29	67.59	3.50	3816
1.40	1.50	6.96	16.14	4.91	12231	51.67	7.99	2.98	13611	48.33	75.00	3.30	2605
1.50	1.80	5.40	30.05	6.19	9992	57.07	10.08	3.29	13269	42.93	80.66	2.94	1675
1.80	2.20	11.91	66.42	2.62	4172	68.98	19.81	3.17	11698	31.02	86.12	3.06	717
2.20		31.02	86.12	3.06	717	100.00	40.38	3.14	8292				

% PYRITE

	1.25	0.00
1.25	1.30	0.65
1.30	1.40	1.59
1.40	1.50	3.20
1.50	1.80	4.60
1.80	2.20	2.08
2.20		2.66

% PYRITE

0.00
0.65
1.38
1.62
1.90
1.93
2.16

% PYRITE

0.00
2.16
2.33
2.79
2.73
2.50
2.66

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FOR: ICF KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OH 45715

+1/4" RD = 51.37% OF TOTAL SAMPLE

SAMPLE ID:
RUN NO: 93101501
COAL SEAM: PITTSBURGH SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

LAB NO.: 31017901

SAMPLED BY: ICF-KE

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU
	1.25	0.00				0.00				100.00	37.25	3.43	8753
1.25	1.30	6.49	4.00	1.71	14274	6.49	4.00	1.71	14274	93.51	39.56	3.55	8370
1.30	1.40	41.16	7.87	2.98	13636	47.65	7.34	2.81	13723	52.35	64.47	4.00	4229
1.40	1.50	8.67	16.27	5.12	12229	56.32	8.72	3.16	13493	43.68	74.04	3.77	2642
1.50	1.80	6.49	31.01	6.38	9887	62.81	11.02	3.50	13120	37.19	81.55	3.32	1377
1.80	2.20	5.66	57.42	4.38	5506	68.47	14.86	3.57	12491	31.53	85.88	3.13	636
2.20		31.53	85.88	3.13	636	100.00	37.25	3.43	8753				

% PYRITE

% PYRITE

% PYRITE

	1.25	0.00
1.25	1.30	0.72
1.30	1.40	1.64
1.40	1.50	3.34
1.50	1.80	4.95
1.80	2.20	3.66
2.20		2.75

	0.00
0.72	
1.51	
1.80	
2.12	
2.25	
2.41	

0.00
2.41
2.52
3.22
3.19
2.89
2.75

STANDARD LABORATORIES, INC.

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FOR: ICF KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OH 45715

1/4" RD X 48 MESH = 33.48% OF TOTAL SAMPLE

SAMPLE ID:
RUN NO: 93101501
COAL SEAM: PITTSBURGH SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

LAB NO.: 31017901

SAMPLED BY: ICF-KE

ea 9

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL	BTU	% WT.	% ASH	% SUL	BTU	% WT.	% ASH	% SUL	BTU
	1.25	0.00				0.00				100.00	34.95	3.16	9178
1.25	1.30	18.78	3.20	1.80	14469	18.78	3.20	1.80	14469	81.22	42.30	3.48	7955
1.30	1.40	35.21	7.64	3.01	13661	53.99	6.10	2.59	13942	46.01	68.82	3.83	3588
1.40	1.50	6.51	16.46	4.73	12156	60.50	7.21	2.82	13750	39.50	77.45	3.69	2176
1.50	1.80	4.98	29.36	6.27	10006	65.48	8.90	3.08	13465	34.52	84.39	3.31	1046
1.80	2.20	4.12	51.01	5.55	6338	69.60	11.39	3.23	13043	30.40	88.91	3.01	329
2.20		30.40	88.91	3.01	329	100.00	34.95	3.16	9178				
		% PYRITE				% PYRITE				% PYRITE			
	1.25	0.00				0.00				0.00			
1.25	1.30	0.64				0.64				2.06			
1.30	1.40	1.57				1.25				2.38			
1.40	1.50	3.10				1.45				3.01			
1.50	1.80	4.29				1.66				2.99			
1.80	2.20	4.07				1.80				2.80			
2.20		2.63				2.06				2.63

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FOR: ICF KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OH 45715

48 MESH X 200 MESH = 5.07% OF TOTAL SAMPLE

SAMPLE ID:
RUN NO: 93101501
COAL SEAM: PITTSBURGH SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

LAB NO.: 31017901

SAMPLED BY: ICF-KE

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU
	1.25	0.00				0.00				100.00	42.08	3.41	8011
1.25	1.30	8.43	2.13	1.60	14553	8.43	2.13	1.60	14553	91.57	45.76	3.58	7409
1.30	1.40	34.10	5.66	2.19	13898	42.53	4.96	2.07	14028	57.47	69.55	4.41	3558
1.40	1.50	6.45	12.26	3.26	12765	48.98	5.92	2.23	13862	51.02	76.79	4.55	2394
1.50	1.80	7.79	24.92	4.25	10815	56.77	8.53	2.51	13443	43.23	86.14	4.61	877
1.80	2.20	2.75	49.07	5.90	6807	59.52	10.40	2.66	13137	40.48	88.66	4.52	474
2.20		40.48	88.66	4.52	474	100.00	42.08	3.41	8011				

% PYRITE

% PYRITE

% PYRITE

	1.25	0.00
1.25	1.30	0.31
1.30	1.40	1.03
1.40	1.50	1.99
1.50	1.80	2.98
1.80	2.20	4.08
2.20		3.85

0.00
0.31
0.89
1.03
1.30
1.43
2.41

0.00
2.41
2.60
3.53
3.73
3.86
3.85

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FOR: ICF KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OH 45715

200 MESH X 0 = 10.08% OF TOTAL SAMPLE

SAMPLE ID:
RUN NO: 93101501
COAL SEAM: PITTSBURGH SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

LAB NO: 31017901

SAMPLED BY: ICF-KE

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU
	1.25	0.00				0.00							
1.25	1.30	0.00				0.00							
1.30	1.40	0.00				0.00							
1.40	1.50	0.00				0.00							
1.50	1.80	0.00				0.00				100.00	73.50	1.41	3135
1.80	2.20	74.22	73.09	1.34	3205	74.22	73.09	1.34	3205	25.78	74.69	1.61	2932
2.20		25.78	74.69	1.61	2932	100.00	73.50	1.41	3135				

% PYRITE

	1.25	0.00
1.25	1.30	0.00
1.30	1.40	0.00
1.40	1.50	0.00
1.50	1.80	0.00
1.80	2.20	1.06
2.20		1.29

% PYRITE

0.00
0.00
0.00
0.00
0.00
1.06
1.12

% PYRITE

0.00
0.00
0.00
0.00
0.00
1.12
1.29

PITTSBURGH NO. 8 SEAM GRINDING OPTIMIZATION TESTS

Mill Circuit Testing Pittsburgh No. 8

Note: Ball mill charge changed to finer media prior to run number - 93041901

TEST NUMBER	93040101	93040102	93040701	93040702	93040801	93040802	93040803	93041201	93041301	93041401	93041402	93041901	93041902	93041903	93042201
MILL SPEED - RPM	27.70	27.70	27.70	27.70	27.70	27.70	27.70	27.70	27.70	27.70	27.70	27.70	27.70	27.70	27.70
MILL FEED - TPH	4.42	2.08	1.25	2.79	3.01	2.76	2.48	9.30	5.84	4.45	2.72	2.61	6.52	1.99	3.80
MILL FEED - % SOLIDS	53.27	53.49	27.62	45.96	49.44	47.48	44.97	18.86	32.24	29.16	47.61	42.43	53.55	37.49	53.76
CYC FEED - TPH	8.35	4.29	2.28	4.74	5.64	4.92	4.23	11.56	8.11	6.47	4.96	5.07	13.46	3.28	7.06
CYC FEED - GPM	250.10	241.12	272.34	275.95	232.84	243.45	239.14	429.64	303.86	342.56	242.45	252.45	282.78	238.35	237.14
CYC FEED - % SOLIDS	12.92	6.99	3.32	6.76	9.47	7.93	6.96	10.48	10.39	7.41	8.03	7.87	18.18	5.42	11.56
NO. OF CYCLONES	2	2	2	2	2	2	2	3	2	3	2	2	2	2	2
VORTEX FINDER - DIA	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.25	1.25	1.25	1.25	1.25	1.25
APEX - DIA	0.75	0.63	0.75	0.75	0.75	0.75	0.75	1.25	1.00	0.75	0.63	0.63	0.63	0.63	0.63
PRESSURE	27.40	22.20	34.10	34.10	20.00	37.80	15.50	22.20	39.30	31.00	36.00	35.50	35.00	35.00	34.00
COLUMN FEED															
MEAN SIZE - MICRONS	38.22	40.65	36.47	39.26	42.24	41.69	38.25	75.42	41.44	39.01	35.29	65.35	118.53	37.02	43.66
D 95 - MICRONS	126.58	113.83	100.95	109.21	122.12	123.00	109.96	230.53	119.62	115.08	112.60	205.03	285.73	112.54	107.45
MICROTAC +200	15.76	16.11	11.41	13.75	16.78	16.16	13.54	37.32	16.08	14.20	13.08	48.02	68.96	11.93	16.66
200 x 325	15.13	19.99	18.61	19.85	20.47	19.52	18.88	17.64	19.48	18.21	15.81	24.79	18.39	16.33	25.23
325 x 0	69.11	63.90	69.98	66.40	62.75	64.32	67.58	45.04	64.44	67.59	71.11	27.19	12.65	71.74	58.11
SCREEN +200	-	-	8.62	9.19	8.79	10.10	12.90	22.00	11.84	14.11	12.12	6.22	31.79	9.34	14.57
ANALYSIS 200 x 325	-	-	17.07	15.72	11.57	14.62	19.86	17.08	17.60	15.84	17.63	19.75	15.60	15.66	18.18
325 x 0	-	-	74.31	75.09	79.64	75.28	67.24	60.92	70.56	70.05	70.25	74.03	52.61	75.00	67.25
BALL MILL FEED															
MEAN SIZE - MICRONS	174.50	170.55	128.47	144.31	154.57	175.61	163.27	121.12	127.92	102.18	108.33	184.07	243.64	83.45	174.53
D 95 - MICRONS	402.34	387.12	307.09	335.74	342.61	413.16	396.46	278.26	305.21	222.63	228.00	430.83	494.96	181.74	389.61
MICROTAC +200	81.75	82.09	68.65	76.28	80.30	82.07	77.86	66.60	69.68	61.95	65.04	84.93	95.32	49.64	84.98
200 x 325	9.70	10.86	18.68	16.25	12.86	12.22	14.82	18.92	19.21	23.73	23.28	11.67	3.83	27.57	11.01
325 x 0	8.55	7.05	12.67	7.47	6.84	5.71	7.32	14.48	11.11	14.32	11.68	3.40	0.85	22.79	4.01
SCREEN +200	-	-	67.29	69.40	76.05	71.96	70.56	58.17	57.11	58.82	73.85	62.93	84.28	75.55	74.79
ANALYSIS 200 x 325	-	-	18.17	16.34	12.19	14.07	14.73	20.07	21.68	21.77	11.99	21.01	5.58	8.11	10.97
325 x 0	-	-	14.54	14.26	11.76	13.97	14.71	21.76	21.21	19.41	14.16	16.06	10.14	16.34	14.24
BALL MILL DISCHARGE															
MEAN SIZE - MICRONS	94.24	50.46	75.85	78.92	96.65	87.96	80.42	62.61	112.69	79.75	61.20	101.51	116.20	70.76	83.76
D 95 - MICRONS	240.15	156.46	208.72	209.47	237.51	231.13	212.03	207.17	264.12	179.54	163.72	206.49	242.00	163.16	169.42
MICROTAC +200	52.40	24.42	40.27	43.28	55.21	47.95	44.44	45.16	63.46	46.93	32.30	64.71	70.11	39.28	52.51
200 x 325	18.37	17.26	21.10	21.24	18.52	19.69	19.27	23.68	19.72	27.04	22.54	22.29	18.53	28.28	29.26
325 x 0	29.23	58.32	38.63	35.48	26.27	32.36	36.29	31.16	16.82	26.03	45.16	13.00	11.36	32.44	18.23
SCREEN +200	-	-	25.95	30.98	35.95	30.83	27.92	45.09	47.01	32.47	24.61	18.48	44.69	31.22	35.87
ANALYSIS 200 x 325	-	-	21.56	22.57	21.68	21.18	21.06	18.44	22.96	28.49	26.46	32.89	14.02	21.16	18.19
325 x 0	-	-	52.49	46.45	42.37	47.99	51.02	36.47	30.03	39.04	48.93	48.63	41.29	47.62	45.94
REDUCTION RATIO	1.85	3.38	1.69	1.83	1.60	2.00	2.03	1.93	1.14	1.28	1.77	1.81	2.10	1.18	2.08

**PITTSBURGH NO. 8 SEAM
COLUMN FLOTATION
FACTORIAL TEST MATRIX RESULTS**

The following pages contain the Factorial Matrix Test Results conducted on the Pittsburgh No. 8 coal seam. The tables below present the test conditions and sample stream identifications.

Pittsburgh No. 8 Factorial Matrix Test Conditions

Run Number	Feed Rate (tph)	Air Rate (SCFM)	Wash Water Rate (GPM)	Frother Name	Collector Type	Frother Dosage (ml/min)	Collector Dosage (ml/min)
609	2	84	127	CM-642	Kerosene	23	10
611	4	84	127	CM-642	Kerosene	23	19
612	4	139	42	CM-642	Kerosene	23	19
613	4	84	42	CM-642	Kerosene	46	38
614	2	84	42	CM-642	Kerosene	12	19
615	2	139	127	CM-642	Kerosene	12	19
616	2	139	42	CM-642	Kerosene	23	10
617	4	139	127	CM-642	Kerosene	46	38
618	4	139	127	CM-642	Kerosene	52	19
619	4	84	127	MIBC	Kerosene	26	38
620	4	139	42	MIBC	Kerosene	26	38
621	4	84	42	MIBC	Kerosene	52	19
622	2	84	42	MIBC	Kerosene	13	10
623	2	139	127	MIBC	Kerosene	13	10
624	2	84	127	MIBC	Kerosene	26	19
625	2	139	42	MIBC	Kerosene	26	19
626	4	84	42	MIBC	Kerosene	52	19
627	4	84	127	CM-642	Kerosene	23	19

Sample Stream Identification

Sample Identification No.	Sample Name
1	Plant Feed
8	Heavy-Media Cyclone Reject
11	Deslime Screen Underflow
13	Water-Only Cyclone Underflow
17	Water-Only Cyclone Overflow
19	Column Flotation Tailings
18	Column Flotation Concentrate
20	Refuse Thickener Feed

RUN NUMBER: 609

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	4.25	4.42	41.57	41.46	8204	8220
8	1.33	1.47	84.54	84.69	1157	1159
11	3.05	2.95	20.17	20.00	11621	11727
13	0.21	0.06	29.10	29.20	7821	7797
17	2.84	2.89	19.51	19.80	11902	11809
19	0.91	0.97	43.93	46.95	7782	7442
18	2.17	1.92	6.01	6.00	14063	14029
20	1.69	1.03	50.43	45.91	7167	7463

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	4.25	4.42	2.93	2.85	2.03	1.90
8	1.33	1.47	3.01	3.04	2.65	2.72
11	3.05	2.95	3.08	2.75	1.84	1.49
13	0.21	0.06	8.76	8.68	6.84	6.85
17	2.84	2.89	2.66	2.63	1.47	1.38
19	0.91	0.97	3.37	3.21	2.32	2.41
18	2.17	1.92	2.19	2.33	0.79	0.86
20	1.69	1.03	3.21	3.53	2.44	2.67

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	96.25	100.00	100.00	100.00	100.00	100.00
8	30.12	33.19	67.49	67.73	4.68	4.68
11	69.08	66.81	32.42	32.22	94.64	95.32
13	4.76	1.37	0.96	0.97	1.31	1.30
17	64.32	65.44	30.71	31.25	94.94	94.02
19	20.61	22.06	23.31	24.97	20.92	19.97
18	49.15	43.39	6.27	6.28	74.37	74.05
20	38.28	23.43	28.42	25.84	20.47	21.27

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	96.25	100.00	100.00	100.00	100.00	100.00
8	30.12	33.19	34.09	35.42	43.32	47.51
11	69.08	66.81	70.24	64.53	60.56	52.49
13	4.76	1.37	4.11	4.19	4.63	4.95
17	64.32	65.44	59.41	60.39	47.39	47.54
19	20.61	22.06	25.37	24.86	25.21	28.00
18	49.15	43.39	32.43	35.54	16.88	19.55
20	38.28	23.43	25.67	29.05	28.16	32.94

RUN NUMBER: 611

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	1.95	2.25	37.86	37.74	8786	8770
8	0.61	0.66	83.77	84.03	1335	1330
11	1.48	1.59	18.23	18.38	11916	11883
13	0.23	0.19	45.22	45.12	7638	7641
17	1.40	1.39	14.69	14.68	12426	12470
19	0.33	0.28	51.09	51.02	6455	6448
18	1.06	1.12	5.69	5.68	13967	13961
20	0.56	0.47	48.68	48.06	6941	6938

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	1.95	2.25	2.76	2.82	1.89	1.86
8	0.61	0.66	2.75	2.73	2.32	2.33
11	1.48	1.59	2.94	2.85	1.72	1.66
13	0.23	0.19	4.55	4.56	3.09	3.11
17	1.40	1.39	2.60	2.61	1.48	1.46
19	0.33	0.28	4.94	4.95	3.94	4.00
18	1.06	1.12	2.03	2.04	0.82	0.84
20	0.56	0.47	4.78	4.79	3.59	3.63

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	86.61	100.00	100.00	100.00	100.00	100.00
8	27.09	29.50	65.28	65.68	4.48	4.47
11	65.73	70.50	33.95	34.32	95.61	95.53
13	10.22	8.57	10.23	10.24	7.45	7.47
17	62.18	61.93	24.03	24.08	87.59	88.06
19	14.66	12.28	16.58	16.60	9.02	9.03
18	47.08	49.65	7.46	7.47	78.92	79.03
20	24.87	20.85	26.81	26.85	16.47	16.50

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	86.61	100.00	100.00	100.00	100.00	100.00
8	27.09	29.50	29.39	28.63	36.21	36.99
11	65.73	70.50	75.10	71.37	64.16	63.01
13	10.22	8.57	14.13	13.87	14.01	14.30
17	62.18	61.93	58.34	57.49	48.50	48.71
19	14.66	12.28	21.99	21.57	25.61	26.41
18	47.08	49.65	36.52	35.92	21.54	22.30
20	24.87	20.85	36.11	35.45	39.61	40.71

RUN NUMBER: 612

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	5.67	5.29	41.24	41.31	8020	8151
8	1.49	1.80	84.59	84.43	1159	1159
11	3.29	3.49	17.10	19.03	12184	11764
13	0.78	0.13	59.30	58.71	5805	5807
17	3.52	3.36	19.26	17.51	11816	11994
19	0.88	0.71	53.72	53.98	5586	5622
18	2.99	2.64	7.74	7.67	13737	13712
20	1.66	0.84	56.34	54.71	5689	5650

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	5.67	5.29	2.83	2.58	1.91	1.68
8	1.49	1.80	2.75	2.83	2.32	2.44
11	3.29	3.49	2.78	2.45	1.60	1.29
13	0.78	0.13	3.57	3.60	2.34	2.36
17	3.52	3.36	2.24	2.40	1.21	1.25
19	0.88	0.71	3.25	3.34	2.36	2.45
18	2.99	2.64	2.05	2.15	0.85	0.92
20	1.66	0.84	3.40	3.38	2.35	2.43

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	107.26	100.00	100.00	100.00	100.0	100.00
8	28.19	34.07	69.88	69.63	4.92	4.84
11	62.24	65.93	27.34	30.37	100.16	95.16
13	14.76	2.44	3.51	3.47	1.77	1.74
17	66.59	63.49	29.65	26.90	93.54	93.42
19	16.65	13.49	17.57	17.62	9.40	9.30
18	56.56	50.00	9.38	9.28	85.64	84.11
20	31.04	15.93	21.76	21.09	11.30	11.04

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	107.26	100.00	100.00	100.00	100.00	100.00
8	28.19	34.07	33.11	37.44	41.38	49.40
11	62.24	65.93	64.77	62.56	55.23	50.60
13	14.76	2.44	3.08	3.42	2.99	3.43
17	66.59	63.49	50.23	59.15	40.22	47.16
19	16.65	13.49	15.49	17.46	16.67	19.64
18	56.56	50.00	36.22	41.69	22.25	27.53
20	31.40	15.93	19.14	20.87	19.60	23.07

RUN NUMBER: 613

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	5.42	5.77	40.93	41.24	8062	8050
8	1.60	1.81	83.55	83.13	1086	1090
11	3.56	3.96	19.63	22.08	11471	11236
13	0.78	0.19	59.30	58.22	5805	5802
17	3.88	3.77	22.43	20.25	11309	11511
19	1.24	0.67	69.27	67.75	3530	3529
18	3.31	3.10	10.10	9.93	13250	13244
20	1.10	0.86	65.85	65.64	4031	4032

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	5.42	5.77	2.69	2.64	1.01	1.27
8	1.60	1.81	2.64	2.65	2.43	1.95
11	3.56	3.96	2.87	2.63	0.91	0.97
13	0.78	0.19	3.57	3.60	2.34	2.31
17	3.88	3.77	2.60	2.59	0.88	0.90
19	1.24	0.67	3.10	3.18	2.62	2.45
18	3.31	3.10	2.31	2.46	0.65	0.56
20	1.10	0.86	3.30	3.27	2.59	2.42

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	93.90	100.00	100.00	100.00	100.00	100.00
8	27.72	31.40	64.09	63.28	4.23	4.25
11	61.68	68.60	32.90	36.72	97.61	95.75
13	13.51	3.31	4.80	4.67	2.38	2.39
17	67.22	65.29	35.78	32.05	91.59	93.36
19	21.48	11.64	19.71	19.13	5.10	5.10
18	57.35	53.65	13.24	12.92	88.17	88.26
20	19.06	14.95	24.06	23.80	7.48	7.49

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	93.90	100.00	100.00	100.00	100.00	100.00
8	27.72	31.40	30.81	31.56	75.54	48.03
11	61.68	68.60	73.19	68.44	61.81	51.97
13	13.51	3.31	4.39	4.51	7.67	5.99
17	67.22	65.29	63.11	63.93	56.89	45.98
19	21.48	11.64	13.42	14.01	30.21	22.35
18	57.35	53.65	46.07	49.92	34.53	23.63
20	19.06	14.95	18.35	18.52	38.35	28.34

RUN NUMBER: 514

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	1.62	1.45	41.62	40.54	8464	8420
8	0.30	0.47	84.00	85.40	1343	1340
11	1.02	0.98	18.87	19.02	11730	11816
13	0.10	0.09	42.73	42.72	9056	9053
17	1.18	0.89	16.46	16.54	11982	12105
19	0.44	0.22	49.97	49.96	6779	6763
18	0.78	0.67	5.83	5.83	14037	13818
20	1.98	0.31	47.83	47.78	7452	7453

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	1.62	1.45	2.76	2.66	1.06	1.38
8	0.30	0.47	2.49	2.52	2.20	1.75
11	1.02	0.98	2.74	2.74	1.12	1.20
13	0.10	0.09	5.30	5.31	3.85	3.69
17	1.18	0.89	2.51	2.47	0.83	0.94
19	0.44	0.22	3.78	3.81	3.31	2.61
18	0.78	0.67	1.99	2.04	0.47	0.40
20	1.98	0.31	4.23	4.26	3.47	2.93

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	111.78	100.00	100.00	100.00	100.00	100.00
8	20.70	32.41	65.42	68.23	5.14	5.16
11	70.38	67.59	30.64	31.72	93.67	94.84
13	6.90	6.41	6.58	6.75	6.86	6.89
17	81.42	61.18	24.20	24.96	86.61	87.95
19	30.36	14.85	17.83	18.30	11.89	11.93
18	53.82	46.33	6.49	6.66	76.83	76.02
20	136.62	21.26	24.43	25.06	18.72	18.82

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	111.78	100.00	100.00	100.00	100.00	100.00
8	20.70	32.41	29.24	30.60	67.27	41.20
11	70.38	67.59	67.10	69.40	71.41	58.80
13	6.90	6.41	12.31	12.77	23.27	17.13
17	81.42	61.18	55.64	56.64	47.90	41.67
19	30.36	14.85	20.34	21.25	46.37	28.09
18	53.82	46.33	33.40	35.33	20.54	13.58
20	136.62	21.26	32.58	34.02	69.59	45.22

RUN NUMBER: 615

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	2.07	2.64	42.97	42.33	8028	7994
8	0.70	0.86	84.61	85.44	1300	1300
11	1.48	1.78	19.44	21.54	11798	11222
13	0.55	0.09	52.29	17.64	6270	6297
17	1.45	1.69	24.48	21.77	10875	11502
19	0.60	0.45	57.33	59.36	5756	5823
18	1.84	1.24	8.03	8.00	13716	13581
20	1.15	0.55	54.92	52.05	6002	5906

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	2.07	2.64	2.70	2.51	1.10	1.33
8	0.70	0.86	2.43	2.48	2.27	1.95
11	1.48	1.78	2.64	2.52	0.90	1.03
13	0.55	0.09	4.11	4.19	3.28	3.22
17	1.45	1.69	2.44	2.42	0.85	0.90
19	0.60	0.45	2.83	3.02	2.40	2.14
18	1.84	1.24	2.09	2.20	0.52	0.45
20	1.15	0.55	3.44	3.23	2.82	2.33

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	78.30	100.00	100.00	100.00	100.00	100.00
8	26.48	32.53	64.06	65.66	5.27	5.29
11	55.98	67.47	30.52	34.34	99.15	94.71
13	20.80	3.64	4.42	1.52	2.84	2.86
17	54.85	63.83	36.36	32.82	86.47	91.84
19	22.70	17.11	22.82	23.99	12.27	12.46
18	69.60	46.72	8.73	8.83	79.83	79.38
20	43.50	20.74	26.51	25.50	15.51	15.33

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	78.30	100.00	100.00	100.00	100.00	100.00
8	26.48	32.53	29.28	32.19	67.14	47.82
11	55.98	67.47	65.97	67.81	54.59	52.18
13	20.80	3.64	5.53	6.08	10.84	8.82
17	54.85	63.83	57.69	61.73	49.32	43.36
19	22.70	17.11	17.93	20.64	37.32	27.56
18	69.60	46.72	36.17	41.09	22.09	15.80
20	43.50	20.74	26.43	26.72	53.18	36.38

RUN NUMBER: 616

ASSAYS:

Stream	Weight ton:		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	2.46	3.15	41.44	40.70	8169	7808
8	0.69	0.90	84.18	85.02	1041	1041
11	1.53	2.25	20.92	22.96	11484	10516
13	0.53	0.24	60.62	36.59	1779	1757
17	1.68	2.01	22.87	21.36	10465	11545
19	0.44	0.40	74.97	77.63	2927	2811
18	1.26	1.62	7.66	7.61	13598	13680
20	0.97	0.63	67.13	62.27	2300	2417

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	2.46	3.15	2.63	2.52	2.07	1.85
8	0.69	0.90	2.55	2.58	2.44	2.53
11	1.53	2.25	2.57	2.50	1.63	1.58
13	0.53	0.24	3.14	3.14	2.49	2.50
17	1.68	2.01	2.34	2.42	1.46	1.47
19	0.44	0.40	3.52	3.49	3.04	3.04
18	1.26	1.62	2.15	2.16	1.05	1.09
20	0.97	0.63	3.31	3.36	2.74	2.84

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	78.17	100.00	100.00	100.00	100.00	100.00
8	21.92	28.58	58.06	59.71	3.64	3.81
11	48.62	71.42	36.05	40.29	100.40	96.19
13	16.84	7.51	10.98	6.75	1.63	1.69
17	53.38	63.91	35.27	33.55	81.87	94.50
19	13.98	12.55	22.71	23.94	4.50	4.52
18	40.04	51.36	9.49	9.60	85.49	89.98
20	30.82	20.06	32.5	30.69	5.65	6.21

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	78.17	100.00	100.00	100.00	100.00	100.00
8	21.92	28.58	27.71	29.21	33.69	39.03
11	48.62	71.42	69.79	70.79	56.24	60.97
13	16.84	7.51	8.96	9.36	9.03	10.12
17	53.38	63.91	56.86	61.43	45.08	50.85
19	13.98	12.55	16.8	17.38	18.44	20.64
18	40.04	51.36	41.98	44.05	26.05	30.21
20	30.82	20.06	25.25	26.73	26.55	30.77

RUN NUMBER: 617

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	5.95	6.66	39.85	39.75	8417	8135
8	1.83	1.85	84.31	84.36	1205	1201
11	4.03	4.81	22.58	22.58	11183	10804
13	0.66	0.73	62.48	62.35	4360	4383
17	4.67	4.08	15.38	15.52	10945	11944
19	1.26	0.33	77.25	76.95	2257	2259
18	3.72	3.75	10.13	10.06	13362	12807
20	1.50	1.06	66.95	66.95	3724	3713

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	5.95	6.66	3.07	2.51	2.20	1.78
8	1.83	1.85	2.54	2.65	2.37	2.51
11	4.03	4.81	2.23	2.46	1.37	1.50
13	0.66	0.73	3.16	3.16	2.98	2.98
17	4.67	4.08	2.40	2.34	1.54	1.23
19	1.26	0.33	3.15	3.16	1.86	1.90
18	3.72	3.75	2.23	2.26	1.05	1.18
20	1.50	1.06	3.16	3.16	2.64	2.64

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	89.32	100.00	100.00	100.00	100.00	100.00
8	27.47	27.79	58.80	58.98	3.98	4.10
11	60.49	72.21	40.91	41.02	95.94	95.90
13	9.91	10.89	17.07	17.08	5.64	5.87
17	70.10	61.32	23.67	23.94	79.74	90.03
19	18.91	5.01	9.72	9.70	1.34	1.39
18	55.84	56.31	14.31	14.24	89.39	88.64
20	22.52	15.90	26.71	26.78	7.03	7.26

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	89.32	100.00	100.00	100.00	100.00	100.00
8	27.47	27.79	22.99	29.27	29.94	39.18
11	60.49	72.21	52.45	70.73	44.97	60.82
13	9.91	10.89	11.21	13.68	14.75	18.23
17	70.01	61.32	47.94	57.05	42.92	42.59
19	18.91	5.01	5.14	6.30	4.24	5.35
18	55.84	56.31	40.90	50.75	26.87	37.25
20	22.52	15.90	16.37	19.98	19.08	23.58

RUN NUMBER: 618

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	6.17	6.12	39.66	39.53	8313	8505
8	1.64	2.00	84.89	84.90	1081	1078
11	3.19	4.12	16.13	17.55	12368	12103
13	0.70	0.30	40.66	39.55	10230	11396
17	4.05	3.82	17.40	15.84	12377	12157
19	0.69	0.59	69.77	66.98	1135	1159
18	3.44	3.24	6.55	6.55	13908	14156
20	1.39	0.89	55.11	57.77	5715	4597

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	6.17	6.12	2.84	2.64	2.20	1.91
8	1.64	2.00	2.53	2.58	2.45	2.57
11	3.19	4.12	2.77	2.66	1.62	1.59
13	0.70	0.30	4.42	4.46	3.06	3.07
17	4.05	3.82	2.47	2.52	1.49	1.47
19	0.69	0.59	4.10	4.15	3.52	3.55
18	3.44	3.24	2.15	2.23	1.04	1.09
20	1.39	0.89	4.26	4.26	3.29	3.39

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	100.86	100.00	100.00	100.00	100.00	100.00
8	26.81	32.63	69.85	70.09	4.24	4.14
11	52.15	67.37	27.40	29.91	100.23	95.86
13	11.44	4.86	4.98	4.86	5.98	6.51
17	66.21	62.51	27.42	25.05	93.06	89.35
19	11.28	9.61	16.91	16.29	1.31	1.31
18	56.23	52.90	8.74	8.77	88.5	88.04
20	22.72	14.47	20.11	21.15	9.95	7.82

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	100.86	100.00	100.00	100.00	100.00	100.00
8	26.81	32.63	29.07	31.96	36.34	43.95
11	52.15	67.37	65.71	68.04	49.61	56.05
13	11.44	4.86	7.56	8.23	6.76	7.82
17	66.21	62.51	54.36	59.81	42.33	48.23
19	11.28	9.61	13.88	15.14	15.38	17.91
18	56.23	52.90	40.04	44.68	25.01	30.32
20	22.72	14.47	21.71	23.36	21.64	25.73

RUN NUMBER: 619

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	6.37	6.44	34.45	34.45	9257	9293
8	1.66	1.77	23.44	83.49	1204	1199
11	4.07	4.67	15.36	15.86	12413	12361
13	0.35	0.30	35.13	34.87	10426	10494
17	4.19	4.37	14.98	14.56	12538	12488
19	0.73	0.76	55.09	54.7	5261	5322
18	4.87	3.61	6.10	6.10	13986	13999
20	1.08	1.06	48.62	49.12	6935	6779

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	6.37	6.44	2.81	2.76	2.08	1.82
8	1.66	1.77	2.68	2.69	2.42	2.52
11	4.07	4.67	3.02	2.79	1.81	1.56
13	0.35	0.30	5.65	5.72	4.47	4.60
17	4.19	4.37	2.58	2.59	1.33	1.35
19	0.73	0.76	3.61	3.68	2.77	2.88
18	4.87	3.61	2.25	2.36	0.95	1.03
20	1.08	1.06	4.27	4.25	3.32	3.37

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	98.97	100.00	100.00	100.00	100.00	100.00
8	25.79	27.48	66.56	66.61	3.57	3.55
11	63.24	72.52	32.33	33.39	97.24	96.45
13	5.44	4.63	4.73	4.69	5.22	5.23
17	65.10	67.88	29.52	28.70	91.94	91.22
19	11.34	11.82	18.90	18.77	6.72	6.77
18	75.67	56.07	9.93	9.94	84.71	84.45
20	16.79	16.45	23.22	23.46	12.32	12.00

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	98.97	100.00	100.00	100.00	100.00	100.00
8	25.79	27.48	26.21	26.78	31.98	37.98
11	63.24	72.52	77.94	73.22	63.10	62.02
13	5.44	4.63	9.32	9.59	9.96	11.71
17	65.10	67.88	62.33	63.63	43.41	50.31
19	11.34	11.82	15.18	15.73	15.74	18.71
18	75.67	56.07	44.89	47.90	25.61	31.60
20	16.78	16.45	25.00	25.33	26.26	30.42

RUN NUMBER: 520

ASSAYS:

Stream	Weight (ton)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	6.64	6.53	38.06	38.08	8569	8790
8	1.89	1.96	84.37	84.42	1227	1228
11	3.17	4.56	18.11	18.17	12017	12040
13	0.35	0.35	26.77	26.80	10339	10302
17	4.45	4.22	17.40	17.45	12131	12184
19	0.74	0.59	72.61	72.43	3315	3309
18	5.61	3.63	8.59	8.57	14070	13619
20	1.34	0.94	55.49	55.41	5938	5918

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	6.64	6.53	2.95	2.83	2.24	1.92
8	1.89	1.96	2.60	2.63	2.48	2.60
11	3.17	4.56	3.32	2.91	1.99	1.64
13	0.35	0.35	4.10	4.14	2.40	2.44
17	4.45	4.22	2.74	2.81	1.52	1.57
19	0.74	0.59	3.86	3.90	3.20	3.29
18	5.61	3.63	2.46	2.64	1.17	1.29
20	1.34	0.94	3.95	3.99	2.90	2.97

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	101.75	100.00	100.00	100.00	100.00	100.00
8	28.96	30.06	66.63	66.63	4.30	4.20
11	48.58	69.94	33.28	33.37	98.09	95.80
13	5.36	5.35	3.76	3.76	6.46	6.27
17	68.19	64.59	29.53	29.60	91.44	89.53
19	11.34	8.99	17.15	17.10	3.48	3.38
18	85.96	55.60	12.55	12.51	91.3	86.14
20	20.53	14.34	20.91	20.86	9.94	9.65

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	101.75	100.00	100.00	100.00	100.00	100.00
8	28.96	30.06	26.49	27.94	33.28	40.56
11	48.58	69.94	78.71	72.06	62.14	59.44
13	5.36	5.35	7.44	7.84	5.73	6.78
17	68.19	64.59	59.99	64.22	43.83	52.66
19	11.34	8.99	11.76	12.41	12.84	15.37
18	85.96	55.60	46.37	51.81	29.04	37.29
20	20.53	14.34	19.20	20.25	18.56	22.15

RUN NUMBER: 521

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	5.89	6.45	38.53	38.38	8712	8757
8	1.82	1.98	82.32	82.47	1578	1579
11	3.97	4.47	19.36	18.82	11791	11941
13	0.35	0.40	26.77	26.91	10339	10296
17	4.07	4.07	17.52	18.04	12268	12100
19	0.74	0.66	72.61	72.47	3315	3311
18	5.02	3.42	7.57	7.56	13835	13793
20	5.89	1.05	55.49	55.39	5938	5930

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	5.89	6.45	2.83	2.68	2.12	1.83
8	1.82	1.98	2.64	2.68	2.57	2.70
11	3.97	4.47	3.44	2.68	2.10	1.45
13	0.35	0.40	4.10	4.18	2.40	2.45
17	4.07	4.07	2.50	2.53	1.47	1.35
19	0.74	0.66	3.86	3.96	3.20	3.45
18	5.02	3.42	2.03	2.26	0.82	0.95
20	5.89	1.05	3.95	4.04	2.90	3.07

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	91.34	100.00	100.00	100.00	100.00	100.00
8	28.22	30.73	65.65	66.03	5.57	5.54
11	61.56	69.27	34.81	33.97	93.75	94.46
13	5.43	6.12	4.25	4.29	7.26	7.19
17	63.11	63.16	28.72	29.68	88.93	87.27
19	11.48	10.20	19.22	19.26	3.88	3.86
18	77.84	52.96	10.40	10.43	84.10	83.41
20	20.78	16.31	23.49	23.54	11.12	11.05

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	91.34	100.00	100.00	100.00	100.00	100.00
8	28.22	30.73	28.67	30.75	37.25	45.24
11	61.56	69.27	84.20	69.25	68.62	54.76
13	5.43	6.12	8.86	9.54	6.92	8.18
17	63.11	63.16	55.79	59.71	43.79	46.58
19	11.48	10.20	13.91	15.09	15.39	19.17
18	77.84	52.96	37.99	44.62	20.48	27.41
20	20.78	16.31	22.77	24.62	22.31	27.35

RUN NUMBER: 522

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	2.42	2.64	38.01	37.50	8761	8765
8	0.57	0.76	83.66	84.39	1111	1109
11	1.54	1.89	18.63	18.68	11765	11837
13	0.02	0.03	26.77	26.80	10339	10286
17	1.67	1.85	18.43	18.52	11906	11867
19	0.67	0.43	54.95	54.85	5850	5803
18	3.00	1.42	7.67	7.66	13661	13681
20	0.69	0.46	52.78	52.73	6093	6142

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	2.42	2.64	3.15	3.29	2.32	2.43
8	0.57	0.76	2.92	2.89	2.89	2.84
11	1.54	1.89	3.39	3.45	2.16	2.27
13	0.02	0.03	4.10	4.09	2.40	2.39
17	1.67	1.85	3.54	3.44	2.45	2.27
19	0.67	0.43	6.45	6.09	5.51	5.14
18	3.00	1.42	2.68	2.64	1.42	1.41
20	0.69	0.46	5.69	5.94	4.69	4.93

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	91.56	100.00	100.00	100.00	100.00	100.00
8	21.57	28.64	63.04	64.46	3.63	3.63
11	58.27	71.36	34.98	35.54	95.83	96.37
13	0.76	1.32	0.93	0.94	1.56	1.55
17	63.18	70.04	33.96	34.60	95.18	94.83
19	25.35	16.13	23.32	23.59	10.77	10.68
18	113.50	53.91	10.88	11.01	84.06	84.15
20	26.11	17.45	24.23	24.53	12.14	12.23

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	91.56	100.00	100.00	100.00	100.00	100.00
8	21.57	28.64	26.55	25.14	35.68	33.44
11	58.27	71.36	76.79	74.86	66.44	66.56
13	0.76	1.32	1.72	1.64	1.36	1.30
17	63.18	70.04	78.71	73.22	73.96	65.27
19	25.35	16.13	33.03	29.88	38.31	34.09
18	113.50	53.91	45.87	43.34	33.00	31.18
20	26.11	17.45	31.52	31.52	35.27	35.38

RUN NUMBER: 523

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	3.10	2.80	39.62	39.54	8550	8501
8	0.88	0.95	77.63	77.67	2314	2311
11	2.12	1.85	19.40	20.06	11678	11664
13	0.40	0.06	49.84	49.65	7262	7296
17	1.25	1.80	19.84	19.16	11887	11798
19	0.47	0.50	51.06	50.85	5892	6114
18	3.04	1.30	6.96	6.96	13839	13986
20	0.87	0.56	50.50	50.73	6522	6231

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	3.10	2.80	3.25	3.03	2.38	2.22
8	0.88	0.95	2.91	2.97	2.74	2.81
11	2.12	1.85	3.28	3.06	2.10	1.92
13	0.40	0.06	5.35	5.42	3.88	3.92
17	1.25	1.80	2.82	2.99	1.71	1.85
19	0.47	0.50	3.96	4.20	3.34	3.45
18	3.04	1.30	2.48	2.53	1.23	1.24
20	0.87	0.56	4.60	4.32	3.59	3.49

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	110.61	100.00	100.00	100.00	100.00	100.00
8	31.40	33.82	66.26	66.42	9.15	9.19
11	75.64	66.18	32.41	33.58	90.40	90.81
13	14.27	1.97	2.47	2.47	1.67	1.69
17	44.60	64.22	32.16	31.11	89.28	89.12
19	16.77	17.85	23.00	22.95	12.30	12.84
18	108.47	46.37	8.15	8.16	75.05	76.28
20	31.04	19.82	25.26	25.42	15.12	14.52

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	110.61	100.00	100.00	100.00	100.00	100.00
8	31.40	33.82	30.28	33.11	38.93	42.87
11	75.64	66.18	66.80	66.89	58.40	57.13
13	14.27	1.97	3.24	3.51	3.21	3.47
17	44.60	64.22	55.72	63.38	46.14	53.66
19	16.77	17.85	21.75	24.70	25.05	27.73
18	108.47	46.37	35.38	38.67	23.96	25.93
20	31.04	19.82	28.05	28.22	29.89	31.20

RUN NUMBER: 624

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	1.83	2.36	38.50	38.03	8677	8775
8	0.52	0.64	83.01	83.59	1286	1289
11	1.34	1.72	20.40	21.06	11649	11564
13	0.33	0.21	34.94	34.68	9582	9619
17	1.75	1.51	19.45	19.14	11938	1183
19	0.44	0.30	71.97	71.67	3093	3096
18	3.00	1.21	6.34	6.33	13968	13970
20	0.77	0.51	56.10	56.19	5874	5826

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	1.83	2.36	3.15	3.10	2.31	2.33
8	0.52	0.64	2.86	2.87	3.03	3.02
11	1.34	1.72	3.28	3.18	2.17	2.07
13	0.33	0.21	4.54	4.55	3.36	3.36
17	1.75	1.51	3.09	2.99	2.04	1.89
19	0.44	0.30	4.77	4.84	4.53	4.67
18	3.00	1.21	2.43	2.54	1.16	1.22
20	0.77	0.51	4.67	4.72	4.03	4.12

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	77.41	100.00	100.00	100.00	100.00	100.00
8	22.00	27.14	58.52	59.65	4.02	3.99
11	56.68	72.86	38.61	40.35	97.81	96.01
13	13.96	9.01	8.18	8.22	9.95	9.88
17	74.03	63.85	32.26	32.13	87.84	86.13
19	18.61	12.52	23.40	23.58	4.46	4.42
18	126.90	51.33	8.45	8.55	82.63	81.72
20	32.57	21.53	31.37	31.80	14.57	14.29

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	77.41	100.00	100.00	100.00	100.00	100.00
8	22.00	27.14	24.64	25.17	35.60	35.18
11	56.68	72.86	75.86	74.83	68.44	64.82
13	13.96	9.01	12.99	13.25	13.11	12.98
17	74.03	63.85	62.63	61.58	56.38	51.84
19	18.61	12.52	18.95	0.95	24.54	25.07
18	126.90	51.33	39.60	42.03	25.78	26.77
20	32.57	21.53	31.91	32.90	37.55	38.06

RUN NUMBER: 525

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	1.83	1.88	38.52	38.18	8732	8496
8	0.44	0.53	82.37	82.81	747	747
11	1.12	1.35	20.03	20.51	11586	11564
13	0.18	0.13	41.48	41.29	8545	8601
17	1.17	1.21	18.53	18.23	11481	11890
19	0.25	0.19	76.48	76.19	2441	2444
18	1.03	1.02	7.29	7.28	13769	13674
20	0.43	0.32	61.83	61.91	4996	4962

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	1.83	1.88	3.25	3.33	2.33	2.45
8	0.44	0.53	3.25	3.23	2.93	2.88
11	1.12	1.35	3.31	3.37	2.21	2.28
13	0.18	0.13	5.48	5.46	4.47	4.42
17	1.17	1.21	3.16	3.14	2.14	2.04
19	0.25	0.19	5.91	5.88	5.31	5.30
18	1.03	1.02	2.68	2.63	1.44	1.43
20	0.43	0.32	5.73	5.71	4.96	4.94

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	97.42	100.00	100.00	100.00	100.00	100.00
8	23.42	28.36	60.65	61.51	2.43	2.50
11	59.62	71.64	37.25	38.49	95.05	97.50
13	9.58	7.10	7.64	7.68	6.95	7.19
17	62.29	64.54	31.05	30.81	84.86	90.32
19	13.31	10.26	20.36	20.46	2.87	2.95
18	54.83	54.29	10.27	10.35	85.60	87.37
20	22.89	17.35	27.86	28.14	9.93	10.14

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	97.42	100.00	100.00	100.00	100.00	100.00
8	23.42	28.36	28.36	27.47	35.66	33.32
11	59.62	71.64	72.96	72.53	67.95	66.68
13	9.58	7.10	11.97	11.62	13.62	12.81
17	62.29	64.54	62.75	60.91	59.28	53.88
19	13.31	10.26	18.65	18.09	23.37	22.19
18	54.83	54.29	44.76	42.82	33.55	31.69
20	22.89	17.35	30.60	29.72	36.94	34.99

RUN NUMBER: 526

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	4.39	4.83	38.13	37.93	8922	8970
8	1.20	1.33	82.85	83.02	1542	1539
11	3.03	3.50	19.81	20.72	11856	11806
13	0.33	0.32	51.63	51.72	9064	8939
17	3.16	3.17	17.55	17.58	12209	12097
19	0.59	0.52	71.93	72.06	2710	2693
18	3.76	2.66	6.95	6.94	13839	13932
20	0.92	0.84	64.65	64.27	4989	5085

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	4.39	4.83	2.98	2.89	2.38	2.20
8	1.20	1.33	2.94	2.97	2.92	2.99
11	3.03	3.50	3.05	2.86	2.07	1.90
13	0.33	0.32	5.59	5.62	5.05	5.12
17	3.16	3.17	2.55	2.58	1.62	1.57
19	0.59	0.52	3.47	3.48	3.24	3.32
18	3.76	2.66	2.30	2.40	1.15	1.23
20	0.92	0.84	4.23	4.30	3.89	4.01

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	90.87	100.00	100.00	100.00	100.00	100.00
8	24.84	27.63	60.03	60.47	4.77	4.74
11	62.72	72.37	37.60	39.53	96.17	95.26
13	6.83	6.66	9.02	9.08	6.76	6.64
17	65.41	65.71	30.25	30.45	89.92	88.62
19	12.21	10.73	20.24	20.39	3.26	3.22
18	77.83	54.98	10.02	10.06	85.29	85.40
20	19.04	17.39	29.48	29.47	9.72	9.86

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	90.87	100.00	100.00	100.00	100.00	100.00
8	24.84	27.63	27.26	28.39	33.90	37.57
11	62.72	72.37	74.07	71.61	62.95	62.43
13	6.83	6.66	12.49	12.98	14.13	15.49
17	65.41	65.71	56.23	58.64	44.73	46.95
19	12.21	10.73	12.49	12.95	14.61	16.17
18	77.83	54.98	42.44	45.68	26.57	30.78
20	19.04	17.39	24.68	25.93	28.42	31.65

RUN NUMBER: 527

ASSAYS:

Stream	Weight (tph)		Ash (%)		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	5.40	6.05	40.82	40.31	8493	8473
8	1.57	2.06	93.62	94.29	1375	1370
11	3.53	3.99	16.50	17.65	12309	12134
13	0.56	0.09	53.56	36.04	6707	6726
17	3.78	3.90	18.44	17.22	12115	12260
19	0.86	0.74	55.89	56.40	5944	6040
18	4.05	3.17	8.11	8.09	13748	13710
20	1.42	0.83	54.97	54.17	6245	6115

Stream	Weight (tph)		Total Sulfur (%)		Pyritic Sulfur (%)	
	Exp	Calc	Exp	Calc	Exp	Calc
1	5.40	6.05	3.35	2.95	2.65	2.34
8	1.57	2.06	2.89	2.99	3.14	3.29
11	3.53	3.99	3.06	2.92	2.04	1.85
13	0.56	0.09	3.98	3.99	3.33	3.33
17	3.78	3.90	2.80	2.90	1.86	1.82
19	0.86	0.74	4.18	4.20	3.63	3.70
18	4.05	3.17	2.47	2.59	1.27	1.38
20	1.42	0.83	4.10	4.17	3.51	3.66

RECOVERIES:

Stream	Weight %		Ash		Btu/lb	
	Exp	Calc	Exp	Calc	Exp	Calc
1	89.22	100.00	100.00	100.00	100.00	100.00
8	25.94	34.01	69.67	71.11	5.51	5.50
11	58.32	65.99	26.67	28.89	95.64	94.50
13	9.25	1.49	1.96	1.34	1.18	1.19
17	62.45	64.50	29.14	27.55	92.00	93.31
19	14.21	12.20	16.70	17.06	8.54	8.69
18	66.91	52.30	10.39	10.49	84.66	84.62
20	23.46	13.69	18.44	18.40	10.07	9.88

Stream	Weight %		Total Sulfur		Pyritic Sulfur	
	Exp	Calc	Exp	Calc	Exp	Calc
1	89.22	100.00	100.00	100.00	100.00	100.00
8	25.94	34.01	29.34	34.54	40.30	47.76
11	58.32	65.99	60.28	65.46	50.80	52.24
13	9.25	1.49	1.78	2.02	1.88	2.13
17	62.45	64.50	53.91	63.43	45.27	50.11
19	14.21	12.20	15.22	17.37	16.71	19.27
18	66.91	52.30	38.56	46.06	25.07	30.84
20	23.46	13.69	16.76	19.39	18.13	21.40

**PITTSBURGH NO. 8 SEAM
COLUMN FLOTATION
BOX-BEHNKEN TEST MATRIX RESULTS**

a)

Model:
Quadratic
Response:
Pyritic Rej
Actual variables:
X = Frother
Y = Collector
Actual constants:
Feed Rate = 1.000

b)

Model:
Quadratic
Response:
Pyritic Rej
Actual variables:
X = Frother
Y = Collector
Actual constants:
Feed Rate = 2.000

c)

Model:
Quadratic
Response:
Pyritic Rej
Actual variables:
X = Frother
Y = Collector
Actual constants:
Feed Rate = 3.000

Figure 2.25

Effects of Collector Dosage and Frother Dosage on Pyritic Sulfur Rejection for the Pittsburgh No. 8 Coal at Feed Rates of (a) 1.0, (b) 2.0, and (c) 3.0 tph

a)

Model:
Quadratic
Response:
Ash Rej
Actual variables:
X = Frother
Y = Collector
Actual constants:
Feed Rate = 1.000

b)

Model:
Quadratic
Response:
Ash Rej
Actual variables:
X = Frother
Y = Collector
Actual constants:
Feed Rate = 2.000

c)

Model:
Quadratic
Response:
Ash Rej
Actual variables:
X = Frother
Y = Collector
Actual constants:
Feed Rate = 3.000

Figure 2.24

Effects of Collector Dosage and Frother Dosage on Ash Rejection for the Pittsburgh No. 8 Coal at Feed Rates of (a) 1.0, (b) 2.0, and (c) 3.0 tph

a)

Model:
Quadratic
Response:
Recovery
Actual variables:
X = Frother
Y = Collector
Actual constants:
Feed Rate = 2.000

b)

Model:
Quadratic
Response:
Recovery
Actual variables:
X = Frother
Y = Collector
Actual constants:
Feed Rate = 1.000

c)

Model:
Quadratic
Response:
Recovery
Actual variables:
X = Frother
Y = Collector
Actual constants:
Feed Rate = 3.000

Figure 2.23

Effects of Collector Dosage and Frother Dosage on Energy Recovery for the Pittsburgh No. 8 Coal at Feed Rates of (a) 1.0, (b) 2.0, and (c) 3.0 tph

Pittsburgh No. 8 Seam					
Box-Behnken Tests					
Test Number	Design Number	Goodness-of-Fit			Material Balance
		Ash	Other	Total	
93081601	1	23.71	14.44	38.15	Poor
93081602	10	7.43	5.83	13.26	Fair
93081603	11	1.16	4.60	5.76	Good
93081604	8	1.87	7.65	9.52	Good
93081605	2	7.92	4.41	12.33	Fair
93081606	0	9.86	18.65	28.51	Poor
93081607	3	17.66	4.56	22.22	Poor
93081608	0	2.93	4.67	7.60	Good
93081609	7	3.02	3.07	6.09	Good
93081610	5	4.74	2.39	7.13	Good
93081611	6	5.53	5.39	10.92	Fair
93081612	12	8.20	14.40	22.60	Poor
93081613	4	12.14	13.73	25.87	Poor
93081614	9	6.93	6.07	13.00	Fair
93081615	0	0.62	4.66	5.28	Good
Average		7.58	7.63	15.22	

Pittsburgh No. 8 Seam Box-Behnken Tests										
	Planned	Planned	Planned	Planned	Planned	Planned	Planned	Planned	Planned	Planned
	Plant	Column	Column	Column	Column	Column	Column	Column	Column	Column
	Feed	Feed	Aeration	Wash	Air	Frother	Frother	Collector	Frother	Collector
Test	Rate	Rate	Rate	Rate	Holdup	Type	Dosage	Dosage	Dosage	Dosage
Number	(tph)	(tph)	(scfm)	(gpm)	(%)	(")	(lb/ton)	(lb/ton)	(ml/min)	(ml/min)
93081601	1.50	1.00	140	100	N/A	MIBC	1.12	1.00	10.50	9.50
93081602	3.10	2.00	140	100	N/A	MIBC	1.92	0.50	36.00	9.50
93081603	3.10	2.00	140	100	N/A	MIBC	1.12	1.50	21.00	28.40
93081604	4.70	3.00	140	100	N/A	MIBC	1.52	1.50	42.70	42.60
93081605	4.70	3.00	140	100	N/A	MIBC	1.12	1.00	31.50	28.40
93081606	3.10	2.00	140	100	N/A	MIBC	1.52	1.00	28.50	18.90
93081607	1.50	1.00	140	100	N/A	MIBC	1.92	1.00	18.00	9.50
93081608	3.10	2.00	140	100	N/A	MIBC	1.52	1.00	28.50	18.90
93081609	1.50	1.00	140	100	N/A	MIBC	1.52	1.50	14.20	14.20
93081610	1.50	1.00	140	100	N/A	MIBC	1.52	0.50	14.20	4.70
93081611	4.70	3.00	140	100	N/A	MIBC	1.52	0.50	42.70	14.20
93081612	3.10	2.00	140	100	N/A	MIBC	1.92	1.50	36.00	28.40
93081613	4.70	3.00	140	100	N/A	MIBC	1.92	1.00	54.00	28.40
93081614	3.10	2.00	140	100	N/A	MIBC	1.12	0.50	21.00	9.50
93081615	3.10	2.00	140	100	N/A	MIBC	1.52	1.00	28.50	18.90
Average	3.10	2.00	140	100	N/A	MIBC	1.52	1.00	28.49	18.93

Pittsburgh No. 8 Seam									
Box-Behnken Tests									
	Relative	Relative	Relative	Relative	Relative	Relative	Relative	Relative	Relative
	Plant	Deslime	HMC	WOC	WOC	Column	Column	Column	Thickener
Test	Feed	U/F	Reject	O/F	U/F	Feed	Product	Reject	Feed
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93081601	100.00	73.57	26.43	66.75	6.81	66.75	51.46	15.29	22.10
93081602	100.00	66.76	33.24	63.19	3.57	63.19	49.43	13.76	17.33
93081603	100.00	78.73	21.27	75.63	3.10	75.63	60.19	15.44	18.53
93081604	100.00	75.21	24.79	71.78	3.43	71.78	56.75	15.03	18.46
93081605	100.00	73.50	26.50	67.66	5.84	67.66	54.04	13.62	19.46
93081606	100.00	72.64	27.36	67.68	4.96	67.68	54.64	13.04	18.00
93081607	100.00	75.18	24.82	69.50	5.68	69.50	58.82	10.68	16.36
93081608	100.00	73.78	26.22	68.76	5.02	68.76	56.65	12.11	17.13
93081609	100.00	73.14	26.86	69.14	4.00	69.14	54.45	14.69	18.70
93081610	100.00	67.75	32.25	64.08	3.67	64.08	49.70	14.39	18.05
93081611	100.00	72.35	27.65	69.62	2.73	69.62	55.88	13.74	16.47
93081612	100.00	71.96	28.04	67.21	4.75	67.21	55.52	11.69	16.44
93081613	100.00	72.07	27.93	65.90	6.17	65.90	52.28	13.62	19.79
93081614	100.00	73.32	26.68	68.23	5.09	68.23	55.62	12.61	17.69
93081615	100.00	77.06	22.94	70.54	6.52	70.54	58.94	11.60	18.12
Average	100.00	73.13	26.87	68.38	4.76	68.38	54.96	13.42	18.18

Pittsburgh No. 8 Seam										
Box-Behnken Tests										
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Plant	Plant	Deslime	Deslime	HMC	HMC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	U/F	Reject	Reject	O/F	O/F	U/F	U/F
Test	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93081601	35.89	35.86	19.28	19.86	80.33	80.37	16.83	18.06	39.26	37.56
93081602	41.38	41.65	22.52	21.59	82.29	81.94	22.24	20.42	42.17	42.30
93081603	34.94	35.29	23.38	22.71	82.26	81.85	20.85	21.65	48.42	48.46
93081604	38.10	38.31	24.72	23.76	82.67	82.43	22.18	22.43	51.64	51.57
93081605	39.22	39.00	24.45	23.08	82.87	83.13	19.00	20.88	48.63	48.66
93081606	38.84	38.48	22.80	22.08	81.56	82.00	18.29	20.26	47.16	47.02
93081607	35.84	35.90	19.59	20.43	82.84	82.76	16.91	18.74	41.41	41.06
93081608	37.41	37.46	20.92	20.56	85.10	85.03	17.73	18.75	45.50	45.30
93081609	38.28	38.51	23.89	22.81	81.53	81.25	20.27	21.62	73.31	43.44
93081610	40.92	40.93	19.97	20.46	83.95	93.94	18.15	19.26	41.49	41.42
93081611	37.82	38.20	21.93	20.96	83.85	83.33	18.27	19.94	46.77	46.89
93081612	37.08	36.96	17.80	19.07	82.70	82.87	16.72	17.35	44.34	43.51
93081613	40.66	40.70	26.78	24.12	83.54	83.49	18.77	21.17	54.29	55.54
93081614	37.92	38.00	20.14	21.25	84.13	84.03	21.53	19.22	49.18	48.47
93081615	35.70	35.71	20.86	21.17	84.61	84.59	19.41	18.87	46.08	45.96
Average	38.00	38.06	21.94	21.59	82.95	83.53	19.14	19.91	47.98	45.81

Pittsburgh No. 8 Seam		Box-Behtken Tests							
	Measured	Adjusted	Column	Feed	Ash				
	Measured	Adjusted	Column	Feed	Ash	Test	Number		
93081601	20.76	18.06	7.21	7.23	62.39	54.50	43.42	49.28	
93081602	18.56	20.42	6.66	70.24	69.84	63.82	72.51	64.16	
93081603	21.94	21.65	7.16	79.29	78.21	72.51	73.24	71.19	
93081604	21.91	22.43	8.35	78.45	75.67	68.82	62.70	65.04	
93081605	22.38	20.88	7.98	74.38	72.07	68.82	63.51	66.01	
93081606	22.39	20.26	7.62	76.02	73.23	63.51	54.69	55.01	
93081607	22.69	18.74	10.89	63.21	72.65	62.44	62.63	64.63	
93081608	19.48	18.75	7.26	75.30	75.29	67.89	68.47	66.04	
93081609	22.25	21.62	7.15	76.26	75.93	56.60	56.17	68.77	
93081610	21.08	19.26	7.50	59.88	73.13	68.33	62.09	64.25	
93081611	21.11	19.94	6.89	74.23	79.82	74.15	66.10	67.62	
93081612	19.38	17.35	5.71	75.48	77.32	66.09	63.56	64.81	
93081613	22.37	21.17	5.93	79.70	77.75	66.04	63.56	64.81	
93081614	18.45	19.22	6.49	76.64	77.32	66.09	63.56	64.81	
93081615	18.45	18.87	7.39	77.75	77.32	66.09	63.56	64.81	
Average	20.88	19.91	7.35	73.28	71.48	63.56	64.81	64.81	

Pittsburgh No. 8 Seam										
Box-Behnken Tests										
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Plant	Plant	Deslime	Deslime	HMC	HMC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	U/F	Reject	Reject	O/F	O/F	U/F	U/F
Test	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93081601	3.50	3.49	3.24	3.37	3.84	3.84	2.97	2.99	8.00	7.09
93081602	3.27	3.13	3.06	3.09	3.17	3.21	2.74	2.88	6.78	6.68
93081603	3.37	3.01	3.00	2.92	3.29	3.36	2.73	2.71	8.23	7.97
93081604	3.44	3.21	3.19	3.04	3.66	3.72	2.64	2.81	8.14	7.75
93081605	3.12	3.15	1.55	1.77	3.34	3.33	2.81	2.66	8.44	8.03
93081606	3.14	3.08	3.23	2.97	3.37	3.39	2.68	2.63	7.98	7.61
93081607	3.15	2.98	3.23	2.90	3.17	3.21	2.61	2.53	7.36	7.35
93081608	2.78	2.69	2.89	2.76	2.49	2.51	2.67	2.43	7.41	7.17
93081609	2.71	2.73	2.66	2.65	2.95	2.94	2.50	2.44	6.40	6.18
93081610	2.71	2.60	2.55	2.51	2.75	2.79	2.49	2.29	6.31	6.35
93081611	2.78	2.64	2.71	2.56	2.82	2.86	2.52	2.41	6.61	6.44
93081612	2.89	2.53	2.97	2.61	2.25	2.31	2.61	2.38	6.22	5.90
93081613	2.70	2.96	2.98	2.79	3.55	3.42	2.74	2.42	7.35	6.74
93081614	2.76	2.58	2.59	2.62	2.44	2.48	2.51	2.34	6.59	6.34
93081615	2.87	2.90	3.44	2.88	2.96	2.95	2.59	2.54	6.57	6.54
Average	3.01	2.91	2.89	2.76	3.07	3.09	2.65	2.56	7.23	6.94

Pittsburgh No. 8 Seam								
Box-Behnken Tests								
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Column	Column	Column	Column	Column	Column	Thickener	Thickener
	Feed	Feed	Product	Product	Reject	Reject	Feed	Feed
Test	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93081601	3.04	2.99	3.05	3.00	3.31	2.97	3.67	4.24
93081602	3.33	2.88	2.82	2.99	2.54	2.51	3.24	3.37
93081603	2.71	2.71	2.64	2.83	2.36	2.25	2.94	3.21
93081604	3.13	2.81	2.74	2.95	2.45	2.30	2.97	3.32
93081605	2.75	2.66	2.71	2.68	2.62	2.57	4.06	4.21
93081606	2.61	2.63	2.53	2.70	2.40	2.32	3.44	3.78
93081607	2.56	2.53	2.20	2.43	3.09	3.11	4.39	4.58
93081608	2.41	2.43	2.20	2.41	2.58	2.54	3.63	3.90
93081609	2.66	2.44	2.18	2.33	2.96	2.86	3.30	3.57
93081610	2.32	2.29	1.97	2.13	2.75	2.85	3.57	3.56
93081611	2.35	2.41	2.21	2.36	2.72	2.58	2.95	3.22
93081612	2.39	2.38	2.00	2.33	2.72	2.61	3.12	3.56
93081613	2.74	2.42	2.11	2.40	2.52	2.47	3.40	3.81
93081614	2.23	2.34	2.20	2.27	2.73	2.63	3.42	3.70
93081615	2.47	2.54	2.30	2.46	2.99	2.97	4.05	4.25
Average	2.65	2.56	2.39	2.55	2.72	2.64	3.48	3.75

Pittsburgh No. 8 Seam									
Box-Behnken Tests									
	Measured	Adjusted	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Plant	Plant	Deslime	HMC	HMC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	Reject	Reject	O/F	O/F	U/F	U/F
Test	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93081601	2.10	2.21	1.78	3.47	3.39	1.46	1.48	5.82	4.77
93081602	2.10	1.98	1.61	2.66	2.72	1.31	1.41	5.18	5.17
93081603	2.13	1.93	1.62	2.98	3.06	1.35	1.40	7.14	6.97
93081604	2.19	2.10	1.67	3.35	3.40	1.40	1.43	7.13	6.74
93081605	2.08	2.13	1.77	3.16	3.13	1.45	1.38	7.35	6.33
93081606	1.14	1.62	1.42	3.26	2.18	1.30	1.17	7.18	4.78
93081607	2.22	2.06	1.74	2.94	3.01	1.42	1.35	6.25	6.46
93081608	2.05	1.87	1.66	2.39	2.45	1.58	1.36	6.07	5.81
93081609	1.89	1.88	1.55	2.76	2.77	1.36	1.35	5.22	5.05
93081610	1.99	1.92	1.55	2.66	2.70	1.39	1.32	5.32	5.42
93081611	2.02	1.78	1.44	2.58	2.69	1.45	1.28	5.72	5.63
93081612	1.96	1.69	1.46	2.19	2.28	1.48	1.21	5.08	5.01
93081613	1.90	2.06	1.62	3.34	3.20	1.51	1.26	6.03	5.54
93081614	1.92	1.65	1.41	2.23	2.33	1.30	1.14	5.10	4.98
93081615	1.86	1.90	1.64	2.78	2.76	1.39	1.33	4.91	4.96
Average	1.97	1.92	1.60	2.85	2.80	1.41	1.32	5.97	5.57

Pittsburgh No. 8 Seam								
Box-Behnken Tests								
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Column	Column	Column	Column	Column	Column	Thickener	Thickener
	Feed	Feed	Product	Product	Reject	Reject	Feed	Feed
Test	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93081601	1.48	1.48	1.38	1.30	2.55	2.09	2.42	2.91
93081602	2.01	1.41	1.15	1.25	1.93	2.00	2.63	2.65
93081603	1.44	1.40	1.18	1.26	2.01	1.94	2.52	2.78
93081604	1.37	1.43	1.28	1.32	1.99	1.82	2.39	2.74
93081605	1.49	1.38	1.25	1.23	2.09	1.97	2.96	3.28
93081606	1.31	1.17	1.09	1.08	1.89	1.56	1.97	2.45
93081607	1.50	1.35	0.97	1.11	2.53	2.69	3.95	4.00
93081608	1.34	1.36	1.01	1.14	2.40	2.38	2.99	3.39
93081609	1.58	1.35	0.94	1.00	2.66	2.65	2.94	3.16
93081610	1.40	1.32	0.89	0.96	2.39	2.56	3.18	3.14
93081611	1.30	1.28	0.88	1.03	2.26	2.29	2.52	2.84
93081612	1.33	1.21	0.78	0.94	2.31	2.46	2.86	3.19
93081613	1.67	1.26	0.84	1.01	2.10	2.20	2.80	3.25
93081614	1.06	1.14	0.87	0.92	2.15	2.11	2.70	2.94
93081615	1.31	1.33	1.03	1.11	2.38	2.42	3.20	3.34
Average	1.44	1.32	1.04	1.11	2.24	2.21	2.80	3.07

Pittsburgh No. 8 Seam													
Box-Behnken Tests													
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured
	Plant	Plant	Deslime	Deslime	HMC	HMC	HMC	HMC	WOC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	U/F	Reject	Reject	Reject	Reject	O/F	O/F	O/F	O/F	U/F
Test	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy
Number	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)
93081601	8790	8820	11810	11550	1230	1230	1230	1230	12100	11820	11820	11820	8280
93081602	7720	7880	11310	11200	1220	1220	1210	1210	11500	11390	11390	11390	7890
93081603	9170	9080	11160	11200	1250	1250	1250	1250	11260	11370	11370	11370	6830
93081604	8800	8650	10810	11070	1300	1300	1300	1300	11370	11290	11290	11290	6230
93081605	8700	8470	10930	11070	1280	1280	1280	1280	11080	11430	11430	11430	6680
93081606	8550	8620	11300	11270	1600	1600	1600	1600	11840	11580	11580	11580	6720
93081607	9010	8970	11720	11510	1300	1300	1300	1300	12040	11800	11800	11800	7880
93081608	8770	8810	11500	11510	1200	1200	1200	1200	11980	11830	11830	11830	7270
93081609	8630	8620	11070	11230	1510	1510	1510	1510	11680	11420	11420	11420	7750
93081610	8300	8240	11600	11580	1240	1240	1240	1240	12090	11790	11790	11790	7830
93081611	8730	8670	11290	11490	1290	1290	1290	1290	11950	11650	11650	11650	7170
93081612	8950	8770	11540	11750	1110	1110	1110	1110	12250	12000	12000	12000	7840
93081613	7970	8160	10610	10860	1200	1200	1200	1200	11940	11360	11360	11360	5560
93081614	8790	8760	11720	11520	1190	1190	1190	1190	11550	11850	11850	11850	6730
93081615	9110	9160	11400	11510	1290	1290	1290	1290	11970	11890	11890	11890	7460
Average	8666	8645	11318	11355	1281	1281	1280	1280	11773	11631	11631	11631	7208

Pittsburgh No. 8 Seam									
Box-Behnken Tests									
	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	WOC	Column	Column	Column	Column	Column	Column	Thickener	Thickener
	U/F	Feed	Feed	Product	Product	Reject	Reject	Feed	Feed
Test	Energy	Btu/lb	Btu/lb	Btu/lb	Btu/lb	Btu/lb	Btu/lb	Btu/lb	Btu/lb
Number	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)
93081601	8880	11500	11820	13690	13830	4620	5030	8010	6220
93081602	7860	11830	11390	13150	13550	3660	3640	4460	4510
93081603	7000	11360	11370	13750	13680	2260	2350	3370	3130
93081604	6440	11360	11290	13580	13620	2370	2500	3630	3240
93081605	6880	11300	11430	13960	13540	2960	3050	4520	4200
93081606	7110	11310	11580	13800	13690	2570	2720	4590	3930
93081607	7900	11280	11800	13200	13090	4710	4710	5830	5820
93081608	7210	11920	11830	13630	13810	2590	2570	3870	3930
93081609	7830	11350	11420	13800	13830	2480	2520	3740	3650
93081610	7840	11460	11790	13670	13690	5210	5220	5780	5750
93081611	7210	11580	11650	13670	13770	2990	3030	3790	3720
93081612	8230	11780	12000	13940	13950	2640	2750	4840	4330
93081613	5600	11280	11360	13940	13860	1740	1760	3010	2960
93081614	7130	11950	11850	13960	13970	2370	2490	4410	3820
93081615	7420	12020	11890	13720	13760	2350	2340	4140	4170
Average	7369	11552	11631	13697	13709	3035	3112	4533	4225

Pittsburgh No. 8 Seam							
Box-Behnken Tests							
	Plant	Plant	Plant	Plant	Plant	Plant	Plant
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93081601	51.46	48.54	80.69	89.63	55.77	69.73	50.42
93081602	49.43	50.57	85.00	92.04	52.78	68.79	53.79
93081603	60.19	39.81	90.68	87.68	43.41	60.70	51.39
93081604	56.75	43.25	89.36	87.58	47.85	64.33	53.69
93081605	54.04	45.96	86.39	89.00	54.02	68.79	55.18
93081606	54.64	45.36	86.78	89.29	52.10	63.57	50.35
93081607	58.82	41.18	85.84	82.26	52.04	68.31	54.14
93081608	56.65	43.35	88.80	89.05	49.25	65.46	54.27
93081609	54.45	45.55	87.36	89.84	53.53	71.04	58.40
93081610	49.70	50.30	82.57	90.92	59.28	75.15	57.72
93081611	55.88	44.12	88.75	89.85	50.05	67.66	56.42
93081612	55.52	44.48	88.31	91.47	48.87	69.12	57.43
93081613	52.28	47.72	88.80	92.41	57.61	74.37	63.17
93081614	55.62	44.38	88.70	90.47	51.06	68.99	57.69
93081615	58.94	41.06	88.54	87.83	50.00	65.57	54.11
Average	54.96	45.04	87.10	89.29	51.84	68.11	55.21

Pittsburgh No. 8 Seam							
Box-Behnken Tests							
	HMC	HMC	HMC	HMC	HMC	HMC	HMC
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93081601	73.57	26.43	96.34	3.69	29.08	40.54	36.88
93081602	66.76	33.24	94.89	5.10	34.09	45.66	40.55
93081603	78.73	21.27	97.11	2.93	23.74	33.72	30.84
93081604	75.21	24.79	96.25	3.73	28.73	40.14	36.39
93081605	73.50	26.50	96.06	4.00	28.01	38.94	35.00
93081606	72.64	27.36	94.97	5.08	30.11	36.82	31.79
93081607	75.18	24.82	96.47	3.60	26.74	36.27	32.73
93081608	73.78	26.22	96.39	3.57	24.47	34.35	30.74
93081609	73.14	26.86	95.29	4.71	28.93	39.58	34.86
93081610	67.75	32.25	95.21	4.85	34.61	45.35	40.56
93081611	72.35	27.65	95.88	4.11	29.95	41.79	37.67
93081612	71.96	28.04	96.41	3.55	25.60	37.83	34.24
93081613	72.07	27.93	95.92	4.11	32.27	43.39	39.30
93081614	73.32	26.68	96.42	3.62	25.65	37.68	34.10
93081615	77.06	22.94	96.83	3.23	23.34	33.32	30.15
Average	73.13	26.87	96.03	3.99	28.35	39.02	35.05

Pittsburgh No. 8 Seam							
Box-Behnken Tests							
	WOC	WOC	WOC	WOC	WOC	WOC	WOC
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93081601	90.73	9.27	92.85	17.51	19.47	24.81	17.66
93081602	94.65	5.35	96.26	10.48	11.56	17.17	13.43
93081603	96.06	3.94	97.52	8.40	10.75	16.94	14.46
93081604	95.44	4.56	97.34	9.90	11.63	18.41	15.74
93081605	92.05	7.95	95.05	16.75	36.05	28.42	23.46
93081606	93.17	6.83	95.73	14.54	17.50	22.99	18.72
93081607	92.44	7.56	94.77	15.18	19.15	28.05	22.82
93081608	93.20	6.80	95.79	14.99	17.68	23.81	19.60
93081609	94.53	5.47	96.13	10.42	12.75	17.82	13.95
93081610	94.58	5.42	96.30	10.97	13.70	18.94	15.24
93081611	96.23	3.77	97.57	8.44	9.49	14.75	12.32
93081612	93.40	6.60	95.39	15.06	14.92	22.65	18.04
93081613	91.44	8.56	95.65	19.71	20.68	29.28	24.93
93081614	93.06	6.94	95.72	15.83	16.80	24.52	20.24
93081615	91.54	8.46	94.56	18.37	19.21	25.59	20.15
Average	93.50	6.50	95.77	13.77	16.76	22.28	18.05

Pittsburgh No. 8 Seam							
Box-Behnken Tests							
	Column	Column	Column	Column	Column	Column	Column
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93081601	77.09	22.91	90.20	69.12	22.75	32.35	22.55
93081602	78.22	21.78	93.06	74.48	18.98	30.89	23.95
93081603	79.58	20.42	95.75	73.75	16.95	28.29	24.04
93081604	79.06	20.94	95.38	70.64	17.14	26.65	22.03
93081605	79.87	20.13	94.61	69.48	19.45	28.74	23.35
93081606	80.73	19.27	95.44	69.64	17.00	25.69	21.13
93081607	84.63	15.37	93.89	51.20	18.89	30.62	24.51
93081608	82.39	17.61	96.18	68.24	18.41	30.82	27.00
93081609	78.75	21.25	95.37	73.99	24.90	41.71	37.08
93081610	77.56	22.44	90.06	69.88	27.95	43.55	33.61
93081611	80.26	19.74	94.87	72.38	21.13	35.31	30.18
93081612	82.61	17.39	96.03	72.87	19.07	35.36	31.39
93081613	79.33	20.67	96.79	77.93	21.09	36.09	32.88
93081614	81.52	18.48	96.10	72.46	20.77	34.21	30.31
93081615	83.56	16.44	96.70	67.38	19.23	29.92	26.62
Average	80.35	19.65	94.70	70.23	20.25	32.68	27.37

PITTSBURGH NO. 8 SEAM 24-HOUR GRIND RESULTS

PITTSBURGH SEAM 24-HOUR RUN DATA: MICROTRAC OF MILL CIRCUIT FEED

Shift >	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17
Microns																	
296.0		76.3	69.2	84.8	62.2	60.3			69.0	77.1	80.9	75.9	70.4	79.2	79.3	79.7	73.2
209.3		63.0	52.8	70.2	45.6	41.8			55.3	63.4	66.8	60.6	56.3	61.7	63.9	64.6	55.4
148.0		51.6	39.7	55.7	34.0	29.1			44.3	52.2	53.9	46.8	45.0	45.5	51.4	51.0	40.1
104.7		43.3	30.0	44.4	26.9	21.4			36.3	43.4	43.6	36.7	37.2	33.7	42.6	40.4	28.6
74.0		36.7	22.5	36.2	22.8	16.5			30.2	36.0	34.9	29.3	31.3	25.9	35.0	31.6	20.2
52.3		31.2	17.0	30.0	19.6	13.2			25.2	30.7	28.1	23.7	25.8	20.5	29.1	24.9	14.1
37.0		26.9	13.4	24.7	16.9	10.6			21.3	26.6	23.2	19.3	21.6	16.6	24.8	20.1	9.7
26.2		23.3	10.6	20.7	14.9	8.8			18.3	22.6	19.2	16.1	18.3	13.3	21.0	16.6	7.0
18.5		19.8	8.3	17.7	12.9	7.4			15.2	19.0	15.6	13.5	15.2	10.7	17.6	13.6	5.2
13.1		16.0	6.2	14.3	10.5	5.8			11.7	15.2	12.0	10.4	11.8	8.1	13.8	10.5	3.3
9.3		12.4	4.5	11.1	8.3	4.4			8.7	11.7	8.8	7.8	8.7	5.9	10.6	7.8	1.8
6.5		9.5	3.2	8.5	6.4	3.3			6.5	8.9	6.4	5.8	6.5	4.2	8.0	5.6	0.9
4.6		6.5	1.9	5.9	4.3	2.0			4.3	6.2	4.2	3.8	4.3	2.6	5.4	3.7	0.3
3.3		4.0	1.0	3.7	2.6	1.0			2.6	3.9	2.4	2.2	2.6	1.4	3.3	2.1	0.1
dv		0.091	0.093	0.100	0.122	0.145			0.107	0.093	0.096	0.119	0.097	0.113	0.100	0.109	0.118
05%		3.9	10.4	4.1	5.2	11.0			5.1	3.9	5.2	5.6	5.2	7.8	4.4	5.9	18.0
50%		139.9	195.9	125.9	232.4	247.3			179.7	136.6	131.1	162.0	174.5	164.3	140.8	143.8	187.0
95%		519.0	558.0	449.5	572.2	586.0			586.6	510.9	476.0	534.0	540.2	468.0	491.0	473.1	531.3
mv		181.1	225.2	157.0	246.2	263.7			219.1	178.8	168.8	195.3	207.2	187.2	174.7	176.5	216.0

PITTSBURGH SEAM 24-HOUR RUN DATA: MICROTRAC OF MILL CIRCUIT FEED

Shift >	18	19	20	21	22	23	24						
Microns													
296.0	86.9	81.8	87.1	74.3		70.6	63.1	296.0					
209.3	77.8	68.2	76.0	56.4		53.9	43.7	209.3					
148.0	69.0	56.0	64.9	43.0		41.2	31.5	148.0					
104.7	62.8	47.4	54.7	34.9		32.7	24.6	104.7					
74.0	59.5	41.4	45.4	28.7		27.2	19.7	74.0					
52.3	55.6	35.8	37.4	24.1		22.9	16.0	52.3					
37.0	50.6	30.8	30.7	20.9		19.3	13.3	37.0					
26.2	46.7	27.1	25.1	18.1		16.5	11.1	26.2					
18.5	42.4	23.4	19.9	15.4		13.9	9.2	18.5					
13.1	36.4	19.1	14.7	12.4		11.0	6.9	13.1					
9.3	30.5	15.3	10.4	9.8		8.3	5.1	9.3					
6.5	25.0	12.0	7.3	7.5		6.2	3.7	6.5					
4.6	18.4	8.4	4.6	4.9		4.0	2.1	4.6					
3.3	12.5	5.3	2.7	3.0		2.3	1.1	3.3					
dv	0.047	0.076	0.132	0.104		0.105	0.104						
05%	1.8	3.1	4.9	4.7		5.4	9.2						
50%	35.5	118.1	88.1	181.4		190.4	237.5						
95%	457.5	486.5	428.7	511.2		538.6	555.3						
mv	116.1	158.9	135.7	199.6		213.2	247.1						

avg	max	min	std
75.1	87.1	60.3	7.6
59.9	77.8	41.8	9.5
47.3	69.0	29.1	10.0
38.3	62.8	21.4	9.8
31.6	59.5	16.5	9.7
26.2	55.6	13.2	9.4
22.1	50.6	9.7	8.8
18.8	46.7	7.0	8.2
15.8	42.4	5.2	7.6
12.5	36.4	3.3	6.6
9.6	30.5	1.8	5.7
7.3	25.0	0.9	4.7
4.9	18.4	0.3	3.6
3.0	12.5	0.1	2.5
0.104	0.145	0.047	0.020
6.2	18.0	1.8	3.5
160.6	247.3	35.5	49.5
513.7	586.6	428.7	45.1
193.4	263.7	116.1	36.7

PITTSBURGH SEAM 24-HOUR RUN DATA: MICROTRAC OF COLUMN FLOTATION FEED

Shift >	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17
Microns																	
296.0	100.0	100.0	100.0	100.0	100.0	100.0	99.7	100.0	99.8	100.0	99.7	100.0	100.0	99.8	100.0	99.9	99.8
209.3	100.0	99.8	99.6	99.3	99.4	99.8	97.7	99.1	98.6	98.8	97.6	99.2	99.5	98.1	99.2	98.5	98.2
148.0	99.8	98.7	97.9	97.1	97.8	98.9	94.2	97.2	96.5	96.3	93.8	97.8	97.8	94.5	97.3	95.4	95.0
104.7	98.5	95.9	94.0	93.0	94.9	96.3	89.6	94.1	93.0	92.2	88.7	95.3	94.2	88.4	94.0	90.7	90.2
74.0	94.5	90.0	86.4	85.2	89.2	90.6	82.3	88.0	86.3	84.6	80.4	89.2	87.5	79.1	87.8	83.1	82.6
52.3	86.8	80.4	75.6	74.7	80.3	81.6	72.6	78.5	76.5	74.4	69.4	79.6	77.5	68.0	78.4	72.9	72.4
37.0	76.3	68.8	63.4	63.4	69.0	70.4	61.9	66.8	65.1	63.0	57.7	67.8	65.7	56.6	67.0	61.8	61.0
26.2	65.3	58.2	52.4	53.0	58.1	59.5	51.9	56.0	54.5	52.5	47.4	56.6	54.9	46.9	56.4	51.9	50.4
18.5	54.2	48.3	42.6	43.7	47.9	49.3	42.7	46.1	44.7	43.0	38.4	46.4	45.0	38.2	46.4	42.8	41.0
13.1	42.5	37.8	32.9	34.2	37.5	38.7	33.3	35.8	34.8	33.4	29.4	36.0	34.9	29.4	36.0	33.4	31.4
9.3	32.6	28.9	24.7	26.1	28.5	29.7	25.4	27.3	26.3	25.3	22.0	27.2	26.5	22.0	27.3	25.5	23.4
6.5	24.7	22.0	18.5	19.8	21.4	22.6	19.1	20.7	19.7	19.0	16.4	20.4	19.9	16.4	20.6	19.1	17.4
4.6	17.4	15.4	12.8	13.8	14.9	15.9	13.3	14.5	13.6	13.1	11.2	14.1	13.8	11.3	14.4	13.3	12.0
3.3	11.7	10.2	8.4	9.1	9.8	10.5	8.7	9.6	8.9	8.5	7.2	9.2	9.0	7.2	9.5	8.8	7.7
dv	0.126	0.152	0.152	0.152	0.161	0.124	0.136	0.156	0.136	0.169	0.158	0.139	0.162	0.163	0.150	0.164	0.162
05%	1.8	2.0	2.3	2.2	2.1	2.0	2.2	2.1	2.2	2.3	2.5	2.2	2.2	2.5	2.2	2.3	2.4
50%	16.4	19.6	24.0	23.4	19.8	18.9	24.4	21.1	22.2	23.9	28.8	20.9	22.0	29.6	20.9	24.3	25.8
95%	76.5	97.2	112.2	120.4	105.5	94.9	159.6	113.1	123.9	129.2	164.6	102.2	111.0	154.1	113.8	143.1	148.2
mv	25.0	31.5	36.6	37.7	32.9	30.3	43.5	35.0	37.6	39.3	46.8	33.5	35.1	46.9	35.0	41.5	43.0

PITTSBURGH SEAM 24-HOUR RUN DATA: MICROTRAC OF COLUMN FLOTATION FEED

Shift >	18	19	20	21	22	23	24						
Microns													
296.0	100.0	99.8	99.8	100.0	100.0	99.9	99.5						
209.3	99.5	98.1	97.9	99.7	99.3	98.4	97.0						
148.0	97.7	94.4	94.0	98.2	97.1	95.5	92.3						
104.7	93.8	89.2	88.7	94.4	93.2	90.8	86.0						
74.0	86.5	81.2	80.6	87.9	86.0	82.8	77.8						
52.3	76.1	70.5	69.9	78.3	76.2	72.4	67.1						
37.0	64.4	58.7	58.2	66.8	65.3	61.1	55.7						
26.2	53.9	48.5	48.0	56.4	55.1	51.1	46.1						
18.5	44.5	39.6	38.9	46.8	45.7	42.0	37.5						
13.1	34.9	30.6	29.8	36.7	35.9	32.6	28.5						
9.3	26.8	23.0	22.3	28.0	27.4	24.7	21.2						
6.5	20.4	17.1	16.6	21.2	20.7	18.6	15.7						
4.6	14.2	11.6	11.4	14.7	14.4	12.8	10.6						
3.3	9.3	7.5	7.4	9.5	9.4	8.3	6.7						
dv	0.137	0.188	0.158	0.139	0.155	0.150	0.158						
05%	2.1	2.5	2.4	2.1	2.1	2.3	2.6						
50%	22.6	27.8	28.2	20.7	21.6	25.1	30.5						
95%	114.0	155.2	160.9	108.0	119.6	141.2	177.4						
mv	36.1	45.0	46.1	33.8	36.4	41.9	50.8						

avg	max	min	std
99.9	100.0	99.5	0.1
98.8	100.0	97.0	0.8
96.5	99.8	92.3	1.9
92.4	98.5	86.0	3.0
85.4	94.5	77.8	4.0
75.4	86.8	67.1	4.6
64.0	76.3	55.7	4.7
53.5	65.3	46.1	4.4
44.0	54.2	37.5	3.9
34.2	42.5	28.5	3.3
25.9	32.6	21.2	2.7
19.5	24.7	15.7	2.1
13.5	17.4	10.6	1.6
8.8	11.7	6.7	1.1
0.152	0.188	0.124	0.014
2.2	2.6	1.8	0.2
23.4	30.5	16.4	3.5
126.9	177.4	76.5	25.5
38.4	50.8	25.0	6.1

**PITTSBURGH NO. 8 SEAM
24-HOUR DEMONSTRATION RUN RESULTS**

**Pittsburgh No. 8 Seam
Long-Duration Tests**

Test Number	Goodness-of-Fit		
	Ash	Other	Total
93082401	7.05	3.56	10.61
93082402	19.98	12.78	32.76
93082403	15.26	20.87	36.13
93082404	3.35	3.88	7.23
93082405	10.52	3.64	14.16
93082406	18.81	5.83	24.64
93082407	13.40	16.77	30.17
93082408	98.53	24.44	122.97
93082409	4.18	41.42	45.60
93082410	5.14	7.02	12.16
93082411	1.47	16.77	18.24
93082412	2.65	20.62	23.27
93082413	1.76	47.34	49.10
93082414	13.53	17.36	30.89
93082415	4.05	9.12	13.17
93082416	5.00	20.81	25.81
93082417	49.24	9.31	58.55
93082418	31.07	47.45	78.52
93082419	11.30	23.16	34.46
93082420	11.33	14.52	25.85
93082421	12.84	25.08	37.92
93082422	8.74	11.83	20.57
93082423	7.56	8.57	16.13
93082424	29.75	20.28	50.03
Average	16.1	18.0	34.1

Pittsburgh No. 8 Seam
Long-Duration Tests

Test Number	Relative Plant Feed (%)	Relative Deslime U/F (%)	Relative HMC Reject (%)	Relative WOC O/F (%)	Relative WOC U/F (%)	Relative Column Feed (%)	Relative Column Product (%)	Relative Column Reject (%)	Relative Thickener Feed (%)
93082401	100.00	71.98	28.02	69.05	2.93	69.05	54.38	14.67	1
93082402	100.00	69.83	30.17	66.42	3.41	66.42	53.52	12.90	1
93082403	100.00	70.07	29.93	65.71	4.36	65.71	51.49	14.22	1
93082404	100.00	66.89	33.11	62.73	4.16	62.73	48.48	14.25	1
93082405	100.00	63.60	36.40	62.08	1.52	62.08	46.96	15.12	1
93082406	100.00	63.07	36.93	59.23	3.83	59.23	47.61	11.62	1
93082407	100.00	57.98	42.02	55.75	2.22	55.75	41.43	14.32	1
93082408	100.00	57.01	42.99	53.70	3.31	53.70	43.88	9.82	1
93082409	100.00	71.13	28.87	60.66	10.47	60.66	42.76	17.90	2
93082410	100.00	74.79	25.21	69.41	5.38	69.41	51.58	17.83	2
93082411	100.00	64.71	35.29	57.58	7.13	57.58	43.46	14.12	2
93082412	100.00	68.31	31.69	65.92	2.39	65.92	51.13	14.79	1
93082413	100.00	63.52	36.48	60.17	3.35	60.17	43.94	16.23	1
93082414	100.00	62.87	37.13	58.24	4.63	58.24	44.24	14.00	1
93082415	100.00	72.80	27.20	64.56	8.24	64.56	46.89	17.67	2
93082416	100.00	70.06	29.94	64.54	5.52	64.54	46.18	18.36	2
93082417	100.00	55.26	44.74	53.83	1.43	53.83	45.13	8.71	1
93082418	100.00	75.09	24.91	70.76	4.32	70.76	49.11	21.66	2
93082419	100.00	79.17	20.83	72.81	6.37	72.81	50.02	22.79	2
93082420	100.00	76.64	23.36	70.28	6.36	70.28	49.81	20.47	2
93082421	100.00	69.57	30.43	65.51	4.06	65.51	50.23	15.28	1
93082422	100.00	74.13	25.87	68.27	5.86	68.27	45.55	22.72	2
93082423	100.00	79.47	20.53	75.36	4.11	75.36	54.53	20.83	2
93082424	100.00	75.54	24.46	72.66	2.88	72.66	54.36	18.30	2

Average	100.0	68.9	31.1	64.4	4.5	64.4	48.2	16.2	2
Maximum	100.0	79.5	44.7	75.4	10.5	75.4	54.5	22.8	2
Minimum	100.0	55.3	20.5	53.7	1.4	53.7	41.4	8.7	1
Range	0.0	24.2	24.2	21.7	9.0	21.7	13.1	14.1	1
Std.Deviation	0.0	6.6	6.6	6.0	2.1	6.0	3.9	3.7	
# of Points	24	24	24	24	24	24	24	24	

**Pittsburgh No. 8 Seam
Long-Duration Tests**

Test Number	Measured Plant Feed Ash (%)	Adjusted Plant Feed Ash (%)	Measured Deslime U/F Ash (%)	Adjusted Deslime U/F Ash (%)	Measured HMC Reject Ash (%)	Adjusted HMC Reject Ash (%)	Measured WOC O/F Ash (%)	Adjusted WOC O/F Ash (%)	Measured WOC U/F Ash (%)	Adjusted WOC U/F Ash (%)
93082401	40.42	40.33	21.61	23.65	83.07	83.17	22.76	22.51	50.99	50.58
93082402	40.11	40.24	22.12	22.16	82.24	82.08	18.43	20.92	46.26	46.23
93082403	42.01	42.01	27.04	24.19	83.76	83.76	19.96	22.89	43.39	43.79
93082404	46.32	46.22	26.17	26.65	85.64	85.76	23.80	24.95	52.54	52.29
93082405	45.63	46.72	25.46	26.21	83.90	82.56	23.74	25.57	52.63	52.52
93082406	47.36	47.20	27.38	24.81	85.26	85.45	20.02	23.20	49.21	49.66
93082407	50.64	51.37	24.79	27.79	84.76	83.90	28.02	26.83	52.51	51.69
93082408	51.52	50.88	32.59	23.36	86.59	87.37	16.41	21.48	52.30	53.80
93082409	49.22	48.89	31.77	33.59	86.26	86.56	30.98	30.05	55.81	54.09
93082410	44.15	43.77	27.01	29.40	86.01	86.37	29.38	27.74	51.58	50.86
93082411	50.57	50.34	31.22	30.16	87.11	87.35	26.23	27.43	51.95	52.25
93082412	43.42	43.95	25.33	25.07	85.29	84.64	22.80	24.11	51.46	51.43
93082413	47.46	48.27	27.99	27.79	84.86	83.92	26.10	26.32	54.48	54.26
93082414	48.85	49.44	26.07	29.20	84.35	83.70	27.89	27.45	52.45	51.29
93082415	46.43	46.38	29.45	31.63	85.80	85.85	29.37	29.15	51.98	51.04
93082416	48.19	47.92	29.53	31.60	85.86	86.11	29.50	29.73	54.29	53.53
93082417	48.37	49.63	21.92	22.39	85.02	83.28	18.51	21.50	56.18	55.96
93082418	44.57	44.81	27.73	31.95	83.78	83.57	39.82	30.62	54.61	53.67
93082419	44.07	44.35	34.73	33.73	84.93	84.71	36.68	32.04	53.32	53.12
93082420	44.99	45.11	30.11	33.30	83.91	83.82	35.57	31.64	52.96	51.67
93082421	43.74	44.37	28.40	27.56	83.48	82.78	23.01	25.90	54.33	54.38
93082422	49.25	48.49	40.11	35.49	85.18	85.76	30.69	33.39	59.14	59.93
93082423	42.05	42.02	32.25	30.75	85.62	85.65	26.71	29.33	56.72	56.79
93082424	42.39	42.42	33.37	28.29	86.08	86.05	23.02	27.28	53.65	53.95

Average	45.91	46.05	28.51	28.36	84.95	84.76	26.23	26.75	52.70	52.45
Maximum	51.52	51.37	40.11	35.49	87.11	87.37	39.82	33.39	59.14	59.93
Minimum	40.11	40.24	21.61	22.16	82.24	82.08	16.41	20.92	43.39	43.79
Range	11.41	11.13	18.50	13.33	4.87	5.29	23.41	12.47	15.75	16.14
Std.Deviation	3.22	3.22	4.25	3.80	1.17	1.50	5.82	3.49	3.16	3.14
# of Points	24	24	24	24	24	24	24	24	24	24

Pittsburgh No. 8 Seam
Long – Duration Tests

Test Number	Measured Column Feed Ash (%)	Adjusted Column Feed Ash (%)	Measured Column Product Ash (%)	Adjusted Column Product Ash (%)	Measured Column Reject Ash (%)	Adjusted Column Reject Ash (%)	Measured Thickener Feed Ash (%)	Adjusted Thickener Feed Ash (%)
93082401	24.78	22.51	7.63	7.63	77.10	77.66	73.74	71.92
93082402	25.44	20.92	6.30	6.28	82.50	81.65	74.00	71.92
93082403	24.59	22.89	6.77	6.74	83.26	81.33	71.92	71.92
93082404	26.89	24.95	7.50	7.50	85.50	84.31	75.79	71.92
93082405	29.61	25.57	7.32	7.32	82.68	82.27	79.28	71.92
93082406	26.14	23.20	7.61	7.59	88.26	87.12	77.24	71.92
93082407	29.79	26.83	7.65	7.65	87.44	82.33	73.98	71.92
93082408	29.14	21.48	7.08	7.02	87.33	86.07	78.85	71.92
93082409	30.62	30.05	7.41	7.41	87.84	84.14	69.17	71.92
93082410	28.79	27.74	7.56	7.57	86.74	86.10	76.78	71.92
93082411	27.95	27.43	7.95	7.95	87.71	87.39	75.35	71.92
93082412	25.43	24.11	6.50	6.49	86.31	85.03	79.54	81.33
93082413	26.00	26.32	5.73	5.71	86.49	82.13	74.84	71.92
93082414	31.68	27.45	8.95	8.97	86.78	85.84	75.62	71.92
93082415	31.09	29.15	7.23	7.23	88.32	87.32	74.61	71.92
93082416	32.25	29.73	7.18	7.18	88.37	86.43	76.83	71.92
93082417	31.06	21.50	10.51	10.51	79.91	78.45	73.87	71.92
93082418	29.79	30.62	6.71	6.70	85.53	84.87	79.89	71.92
93082419	29.25	32.04	7.90	7.94	86.42	84.95	74.69	71.92
93082420	32.68	31.64	9.92	9.98	86.58	84.36	72.91	71.92
93082421	29.46	25.90	7.94	7.91	86.88	85.02	77.76	71.92
93082422	33.08	33.39	7.63	7.62	86.34	85.05	79.31	71.92
93082423	31.82	29.33	8.11	8.12	86.51	84.85	78.27	81.33
93082424	31.00	27.28	8.56	8.57	85.65	82.83	75.96	71.92

Average	29.10	26.75	7.65	7.65	85.69	84.06	75.84	71.92
Maximum	33.08	33.39	10.51	10.51	88.37	87.39	79.89	81.33
Minimum	24.59	20.92	5.73	5.71	77.10	77.66	69.17	71.92
Range	8.49	12.47	4.78	4.80	11.27	9.73	10.72	71.92
Std.Deviation	2.57	3.49	1.04	1.05	2.70	2.50	2.62	2.62
# of Points	24	24	24	24	24	24	24	

Pittsburgh No. 8 Seam
Long-Duration Tests

Test Number	Measured Plant Feed Sulfur (%)	Adjusted Plant Feed Sulfur (%)	Measured Deslime U/F Sulfur (%)	Adjusted Deslime U/F Sulfur (%)	Measured HMC Reject Sulfur (%)	Adjusted HMC Reject Sulfur (%)	Measured WOC O/F Sulfur (%)	Adjusted WOC O/F Sulfur (%)	Measured WOC U/F Sulfur (%)	Adjusted WOC U/F Sulfur (%)
93082401	3.04	2.90	2.93	2.79	3.14	3.18	2.61	2.55	8.43	8.44
93082402	3.14	3.12	3.22	2.68	4.14	4.15	2.84	2.42	7.85	7.76
93082403	3.18	3.05	3.88	2.82	3.54	3.59	2.88	2.50	7.43	7.66
93082404	2.88	2.91	3.12	2.96	2.83	2.82	2.67	2.55	9.57	9.09
93082405	2.70	2.80	2.81	2.55	3.29	3.24	2.44	2.39	9.26	9.21
93082406	2.70	2.75	2.62	2.68	2.88	2.86	2.62	2.31	8.87	8.40
93082407	2.86	2.65	3.18	2.64	2.60	2.67	2.34	2.35	9.32	10.09
93082408	2.63	2.79	3.00	2.65	3.07	2.98	2.91	2.31	9.83	8.21
93082409	2.73	2.99	3.04	2.93	3.23	3.13	2.89	2.04	9.46	8.11
93082410	2.87	2.91	2.93	2.85	3.10	3.09	2.67	2.39	9.16	8.72
93082411	2.88	3.35	3.99	3.36	3.57	3.32	3.16	2.72	9.15	8.57
93082412	2.93	2.78	2.74	2.51	3.30	3.36	2.43	2.25	10.34	9.61
93082413	3.02	2.80	2.88	2.58	3.10	3.18	2.97	2.21	10.95	9.32
93082414	2.83	3.19	3.36	2.97	3.81	3.57	2.17	2.54	8.58	8.45
93082415	2.83	2.88	3.15	2.93	2.76	2.75	2.34	2.22	9.11	8.54
93082416	2.92	3.04	2.95	2.74	3.80	3.74	2.29	2.15	10.42	9.64
93082417	2.71	2.90	3.01	2.92	2.96	2.86	2.62	2.73	10.21	10.08
93082418	2.71	2.54	2.91	2.20	3.50	3.57	1.27	1.75	9.60	9.59
93082419	2.84	2.65	1.94	2.40	3.56	3.62	1.64	1.84	9.32	8.77
93082420	2.74	3.11	3.20	3.32	2.48	2.41	3.26	2.86	9.10	8.38
93082421	2.82	2.86	3.32	2.58	3.52	3.50	1.90	2.16	10.31	9.28
93082422	2.66	2.97	3.22	2.81	3.60	3.45	2.36	2.25	10.05	9.27
93082423	2.72	2.89	2.52	2.71	3.67	3.61	2.57	2.30	10.85	10.20
93082424	3.06	2.81	2.17	2.66	3.20	3.27	2.67	2.37	10.76	10.09

Average	2.85	2.90	3.00	2.76	3.28	3.25	2.52	2.34	9.50	8.98
Maximum	3.18	3.35	3.99	3.36	4.14	4.15	3.26	2.86	10.95	10.20
Minimum	2.63	2.54	1.94	2.20	2.48	2.41	1.27	1.75	7.43	7.66
Range	0.55	0.81	2.05	1.16	1.66	1.74	1.99	1.11	3.52	2.54
Std.Deviation	0.15	0.18	0.43	0.25	0.40	0.39	0.45	0.25	0.88	0.74
# of Points	24	24	24	24	24	24	24	24	24	24

Pittsburgh No. 8 Seam
Long-Duration Tests

Test Number	Measured Column Feed Sulfur (%)	Adjusted Column Feed Sulfur (%)	Measured Column Product Sulfur (%)	Adjusted Column Product Sulfur (%)	Measured Column Reject Sulfur (%)	Adjusted Column Reject Sulfur (%)	Measured Thickener Feed Sulfur (%)	Adjusted Thickener Feed Sulfur (%)
93082401	2.38	2.55	2.62	2.66	2.16	2.14	3.13	
93082402	2.38	2.42	2.12	2.47	2.18	2.20	3.17	
93082403	2.36	2.50	2.22	2.58	2.12	2.20	3.44	
93082404	2.41	2.55	2.64	2.67	2.23	2.13	3.39	
93082405	2.36	2.39	2.37	2.48	2.13	2.11	2.67	
93082406	2.13	2.31	2.51	2.47	1.71	1.66	3.13	
93082407	2.17	2.35	2.39	2.50	1.74	1.88	3.58	
93082408	2.13	2.31	2.23	2.46	1.78	1.64	2.75	
93082409	2.41	2.04	1.77	2.12	1.77	1.84	3.67	
93082410	2.36	2.39	2.40	2.57	1.91	1.88	3.21	
93082411	2.74	2.72	2.72	3.00	1.85	1.84	3.79	
93082412	2.14	2.25	2.22	2.39	1.92	1.77	2.49	
93082413	2.29	2.21	1.85	2.22	2.39	2.17	2.70	
93082414	3.10	2.54	2.92	2.83	1.64	1.61	3.22	
93082415	2.23	2.22	2.29	2.44	1.63	1.61	3.48	
93082416	2.67	2.15	2.00	2.32	1.70	1.71	3.18	
93082417	2.60	2.73	3.26	2.90	1.94	1.89	2.97	
93082418	2.38	1.75	2.09	1.82	1.74	1.57	2.65	
93082419	2.30	1.84	2.21	1.94	1.67	1.62	3.27	
93082420	3.21	2.86	3.11	3.29	1.83	1.81	3.17	
93082421	2.24	2.16	2.36	2.38	1.56	1.44	2.64	
93082422	2.40	2.25	2.23	2.40	2.01	1.95	3.07	
93082423	2.27	2.30	2.54	2.50	1.82	1.76	2.99	
93082424	2.78	2.37	2.45	2.52	1.98	1.93	2.88	

Average	2.43	2.34	2.40	2.50	1.89	1.85	3.11	3
Maximum	3.21	2.86	3.26	3.29	2.39	2.20	3.79	4
Minimum	2.13	1.75	1.77	1.82	1.56	1.44	2.49	2
Range	1.08	1.11	1.49	1.47	0.83	0.76	1.30	1
Std.Deviation	0.28	0.25	0.35	0.31	0.21	0.22	0.34	0
# of Points	24	24	24	24	24	24	24	

Pittsburgh No. 8 Seam
Long-Duration Tests

Test Number	Measured Plant Feed Pyritic (%)	Adjusted Plant Feed Pyritic (%)	Measured Deslime U/F Pyritic (%)	Adjusted Deslime U/F Pyritic (%)	Measured HMC Reject Pyritic (%)	Adjusted HMC Reject Pyritic (%)	Measured WOC O/F Pyritic (%)	Adjusted WOC O/F Pyritic (%)	Measured WOC U/F Pyritic (%)	Adjusted WOC U/F Pyritic (%)
93082401	1.94	1.88	1.47	1.60	2.55	2.58	1.54	1.41	6.34	6.25
93082402	2.14	2.22	2.06	1.57	3.81	3.73	1.63	1.33	6.52	6.27
93082403	1.79	2.00	2.50	1.55	3.25	3.04	1.53	1.19	7.30	7.08
93082404	1.99	1.94	1.60	1.71	2.40	2.42	1.27	1.34	7.45	7.25
93082405	1.92	2.05	1.83	1.47	3.20	3.07	1.44	1.31	7.83	7.87
93082406	1.85	2.12	1.91	1.83	2.86	2.62	1.76	1.45	8.11	7.79
93082407	2.00	1.95	1.90	1.75	2.20	2.23	1.53	1.44	8.56	9.32
93082408	2.11	2.15	2.24	1.62	2.89	2.86	1.74	1.30	7.64	6.90
93082409	1.92	2.11	1.89	1.80	3.00	2.87	1.80	0.89	9.18	7.11
93082410	1.92	1.94	1.64	1.66	2.81	2.80	1.57	1.20	8.01	7.57
93082411	1.92	2.32	2.75	2.05	3.21	2.81	1.85	1.41	8.00	7.24
93082412	2.08	1.76	1.66	1.29	2.62	2.78	1.47	1.07	9.33	7.46
93082413	2.02	1.88	1.74	1.28	2.84	2.94	1.73	0.88	9.53	8.41
93082414	2.06	2.31	1.96	1.84	3.37	3.12	1.20	1.44	7.54	6.90
93082415	2.08	1.99	2.15	1.92	2.18	2.21	1.35	1.21	8.71	7.44
93082416	2.11	2.19	1.81	1.65	3.52	3.45	1.31	1.10	9.44	8.11
93082417	2.08	2.25	1.96	1.96	2.75	2.61	1.64	1.78	9.18	8.96
93082418	1.91	1.81	1.88	1.24	3.46	3.54	0.55	0.77	9.03	9.04
93082419	1.84	1.76	0.97	1.29	3.48	3.54	0.74	0.80	8.54	6.92
93082420	1.90	2.16	1.94	2.12	2.38	2.28	2.07	1.60	8.49	7.92
93082421	1.93	1.94	2.07	1.40	3.19	3.18	0.73	0.96	9.23	8.40
93082422	1.88	2.14	2.35	1.76	3.47	3.24	1.47	1.27	7.93	7.45
93082423	1.98	2.02	1.77	1.65	3.45	3.43	1.58	1.27	9.53	8.62
93082424	1.96	2.01	1.26	1.67	3.10	3.07	1.51	1.40	9.53	8.32

Average	1.97	2.04	1.89	1.65	3.00	2.93	1.46	1.24	8.37	7.69
Maximum	2.14	2.32	2.75	2.12	3.81	3.73	2.07	1.78	9.53	9.32
Minimum	1.79	1.76	0.97	1.24	2.18	2.21	0.55	0.77	6.34	6.25
Range	0.35	0.56	1.78	0.88	1.63	1.52	1.52	1.01	3.19	3.07
Std.Deviation	0.09	0.16	0.37	0.24	0.44	0.42	0.35	0.25	0.92	0.81
# of Points	24	24	24	24	24	24	24	24	24	24

Pittsburgh No. 8 Seam
Long-Duration Tests

Test Number	Measured Column Feed Pyritic (%)	Adjusted Column Feed Pyritic (%)	Measured Column Product Pyritic (%)	Adjusted Column Product Pyritic (%)	Measured Column Reject Pyritic (%)	Adjusted Column Reject Pyritic (%)	Measured Thickener Feed Pyritic (%)	Adjusted Thickener Feed Pyritic (%)
93082401	1.32	1.41	1.34	1.28	1.89	1.86	2.58	
93082402	1.43	1.33	0.97	1.16	1.99	2.02	2.57	
93082403	1.19	1.19	0.88	1.03	1.70	1.75	2.68	
93082404	1.49	1.34	1.14	1.13	2.08	2.05	3.16	
93082405	1.32	1.31	1.03	1.15	1.72	1.79	2.26	
93082406	1.28	1.45	1.46	1.41	1.62	1.58	3.01	
93082407	1.44	1.44	1.27	1.37	1.49	1.66	3.43	
93082408	1.25	1.30	1.02	1.21	1.73	1.68	2.51	
93082409	1.35	0.89	0.48	0.57	1.42	1.65	3.08	
93082410	1.24	1.20	0.97	1.09	1.46	1.51	2.72	
93082411	1.59	1.41	1.18	1.41	1.37	1.42	2.99	
93082412	1.13	1.07	0.80	1.00	1.48	1.30	1.63	
93082413	1.04	0.88	0.49	0.59	1.52	1.65	2.20	
93082414	2.03	1.44	1.52	1.47	1.42	1.34	2.46	
93082415	1.32	1.21	0.94	1.07	1.58	1.59	2.84	
93082416	1.73	1.10	0.74	0.88	1.53	1.64	2.61	
93082417	1.73	1.78	2.15	1.80	1.72	1.64	2.58	
93082418	1.31	0.77	0.61	0.55	1.54	1.25	2.21	
93082419	1.03	0.80	0.66	0.60	1.33	1.25	2.61	
93082420	1.74	1.60	1.51	1.61	1.53	1.58	3.11	
93082421	1.18	0.96	1.03	0.92	1.29	1.12	2.21	
93082422	1.24	1.27	0.89	0.96	1.91	1.89	2.63	
93082423	1.17	1.27	1.14	1.21	1.52	1.43	2.26	
93082424	1.89	1.40	1.45	1.33	1.74	1.62	2.40	

Average	1.39	1.24	1.07	1.12	1.61	1.59	2.61	
Maximum	2.03	1.78	2.15	1.80	2.08	2.05	3.43	
Minimum	1.03	0.77	0.48	0.55	1.29	1.12	1.63	
Range	1.00	1.01	1.67	1.25	0.79	0.93	1.80	
Std.Deviation	0.26	0.25	0.37	0.32	0.20	0.23	0.39	
# of Points	24	24	24	24	24	24	24	

Pittsburgh No. 8 Seam
Long-Duration Tests

Test Number	Measured Plant Feed Btu/lb	Adjusted Plant Feed Btu/lb	Measured Deslime U/F Btu/lb	Adjusted Deslime U/F Btu/lb	Measured HMC Reject Btu/lb	Adjusted HMC Reject Btu/lb	Measured WOC O/F Btu/lb	Adjusted WOC O/F Btu/lb	Measured WOC U/F Btu/lb	Adjusted WOC U/F Btu/lb
93082401	8270	8260	11340	11020	1170	1170	11200	11210	6280	6510
93082402	8000	8160	11100	11110	1330	1330	11960	11310	7160	7250
93082403	8020	8120	10530	11000	1370	1370	11700	11060	10910	10140
93082404	7490	7410	10500	10600	960	960	11080	10880	6110	6400
93082405	7440	7420	10780	10640	1800	1800	11090	10760	5760	5810
93082406	7140	7180	10530	10860	890	890	11730	11140	6430	6540
93082407	6560	6340	10870	10410	710	710	10510	10630	5700	5050
93082408	6490	6270	9680	10590	550	550	12170	10860	5890	6150
93082409	6950	6890	9650	9380	770	770	9830	9990	5160	5870
93082410	7730	7740	10510	10100	750	750	10060	10370	6150	6600
93082411	6760	6750	9790	9970	830	840	10470	10400	6200	6480
93082412	7890	7700	10900	10850	910	910	11090	11000	6150	6680
93082413	7200	6990	10500	10430	990	990	10700	10680	5310	5900
93082414	7030	6750	10680	10180	950	950	10360	10480	5910	6340
93082415	7370	7320	10080	9790	720	720	10200	10240	5690	6240
93082416	7100	7080	10020	9800	730	730	10260	10120	5570	6100
93082417	7360	6690	11450	11190	1120	1120	11950	11340	5220	5390
93082418	7540	7390	10470	9510	1030	1030	8620	9740	5500	5700
93082419	7740	7640	9230	9360	1110	1110	9110	9630	5780	6250
93082420	7650	7460	10070	9460	910	910	9180	9740	5790	6350
93082421	7650	7490	10050	10320	1040	1040	11080	10600	5330	5800
93082422	7070	7030	8630	9130	990	990	10010	9480	4900	5080
93082423	7920	8040	9750	9890	910	910	10560	10130	5050	5340
93082424	7820	7770	9240	10030	800	800	10930	10190	5630	5930

Average	7,425	7,329	10,265	10,234	973	973	10,660	10,499	5,983	6,246
Maximum	8,270	8,260	11,450	11,190	1,800	1,800	12,170	11,340	10,910	10,140
Minimum	6,490	6,270	8,630	9,130	550	550	8,620	9,480	4,900	5,050
Range	1,780	1,990	2,820	2,060	1,250	1,250	3,550	1,860	6,010	5,090
Std.Deviation	463	540	677	600	257	257	906	537	1,138	961
# of Points	24	24	24	24	24	24	24	24	24	24

Pittsburgh No. 8 Seam
Long-Duration Tests

Test Number	Measured Column Feed Btu/lb	Adjusted Column Feed Btu/lb	Measured Column Product Btu/lb	Adjusted Column Product Btu/lb	Measured Column Reject Btu/lb	Adjusted Column Reject Btu/lb	Measured Thickener Feed Btu/lb	Adjusted Thickener Feed Btu/lb
93082401	10890	11210	13720	13660	2030	2150	3230	
93082402	10790	11310	13930	13640	1650	1660	2900	
93082403	11020	11060	13840	13740	1410	1370	3160	
93082404	10680	10880	13740	13720	1170	1200	2620	
93082405	10320	10760	13710	13730	1500	1530	1980	
93082406	10700	11140	14000	13580	1130	1140	2560	
93082407	10260	10630	13730	14030	910	800	1170	
93082408	10170	10860	13770	13090	910	930	2440	
93082409	9990	9990	13670	13860	710	730	3470	
93082410	10310	10370	13720	13670	810	830	2470	
93082411	10450	10400	13600	13530	760	770	2860	
93082412	10680	11000	13890	13950	760	810	2040	
93082413	10650	10680	13870	14270	880	970	2700	
93082414	9870	10480	13450	13440	109	113	2800	
93082415	9990	10240	13780	13800	780	810	3000	
93082416	9760	10120	13830	13820	770	810	2480	
93082417	9980	11340	13210	13090	2150	2320	3180	
93082418	10080	9740	13720	13530	1100	1140	2060	
93082419	10190	9630	13740	13580	930	970	2540	
93082420	9640	9740	13240	13270	1090	1150	2970	
93082421	9970	10600	13680	13510	950	1000	2500	
93082422	9680	9480	13380	13590	1200	1240	2220	
93082423	9980	10130	13630	13560	1100	1170	2200	
93082424	10090	10190	13580	13160	1270	1360	2380	

Average	10,256	10,499	13,685	13,618	1,087	1,124	2,580	2,
Maximum	11,020	11,340	14,000	14,270	2,150	2,320	3,470	3,
Minimum	9,640	9,480	13,210	13,090	109	113	1,170	1,
Range	1,380	1,860	790	1,180	2,041	2,207	2,300	2,
Std.Deviation	386	537	194	276	428	455	490	,
# of Points	24	24	24	24	24	24	24	

**Pittsburgh No. 8 Seam
Long-Duration Tests**

Test Number	Plant Product Yield (%)	Plant Reject Yield (%)	Plant Energy Recovery (%)	Plant Ash Rejection (%)	Plant Sulfur Rejection (%)	Plant Pyritic Rejection (%)	Plant Separate Efficiency (%)
93082401	54.38	45.62	89.93	89.73	50.12	62.98	52.91
93082402	53.52	46.48	89.46	91.62	57.63	72.03	61.50
93082403	51.49	48.51	87.13	91.74	56.44	73.48	60.61
93082404	48.48	51.52	89.76	92.15	55.52	71.76	61.52
93082405	46.96	53.04	86.89	92.47	58.41	73.66	60.55
93082406	47.61	52.39	90.05	92.37	57.24	68.33	58.38
93082407	41.43	58.57	91.68	93.74	60.92	70.89	62.57
93082408	43.88	56.12	91.61	94.02	61.31	75.30	66.91
93082409	42.76	57.24	86.02	93.56	69.68	88.45	74.47
93082410	51.58	48.42	91.10	91.16	54.45	71.02	62.12
93082411	43.46	56.54	87.11	93.17	61.08	73.59	60.70
93082412	51.13	48.87	92.63	92.36	56.04	70.95	63.58
93082413	43.94	56.06	89.70	94.71	65.16	86.21	75.91
93082414	44.24	55.76	88.09	91.88	60.75	71.85	59.93
93082415	46.89	53.11	88.40	92.70	60.27	74.79	63.19
93082416	46.18	53.82	90.14	93.12	64.76	81.44	71.59
93082417	45.13	54.87	88.30	90.19	54.87	63.90	52.20
93082418	49.11	50.89	89.91	92.62	64.81	85.08	74.99
93082419	50.02	49.98	88.91	90.99	63.38	82.95	71.86
93082420	49.81	50.19	88.60	88.95	47.31	62.87	51.48
93082421	50.23	49.77	90.60	90.92	58.20	76.18	66.78
93082422	45.55	54.45	88.05	92.95	63.19	79.57	67.62
93082423	54.53	45.47	91.97	89.47	52.83	67.34	59.30
93082424	54.36	45.64	92.07	89.01	51.25	64.03	56.10

Average	48.2	51.8	89.5	91.9	58.6	73.7	63.2
Maximum	54.5	58.6	92.6	94.7	69.7	88.4	75.9
Minimum	41.4	45.5	86.0	89.0	47.3	62.9	51.5
Range	13.1	13.1	6.6	5.8	22.4	25.6	24.4
Std.Deviation	3.9	3.9	1.8	1.6	5.2	7.1	6.8
# of Points	24	24	24	24	24	24	24

Pittsburgh No. 8 Seam
Long-Duration Tests

Test Number	HMC Product Yield (%)	HMC Reject Yield (%)	HMC Energy Recovery (%)	HMC Ash Rejection (%)	HMC Sulfur Rejection (%)	HMC Pyritic Rejection (%)	HMC Separation Efficiency (%)
93082401	71.98	28.02	96.03	3.97	30.73	38.45	
93082402	69.83	30.17	95.07	4.92	40.13	50.69	
93082403	70.07	29.93	94.92	5.05	35.23	45.49	
93082404	66.89	33.11	95.69	4.29	32.09	41.30	
93082405	63.60	36.40	91.20	8.83	42.12	54.51	
93082406	63.07	36.93	95.40	4.58	38.41	45.64	
93082407	57.98	42.02	95.20	4.71	42.34	48.05	
93082408	57.01	42.99	96.29	3.77	45.92	57.19	
93082409	71.13	28.87	96.84	3.23	30.22	39.27	
93082410	74.79	25.21	97.59	2.44	26.77	36.39	
93082411	64.71	35.29	95.58	4.39	34.97	42.74	
93082412	68.31	31.69	96.26	3.75	38.30	50.06	
93082413	63.52	36.48	94.78	5.17	41.43	57.05	
93082414	62.87	37.13	94.82	5.23	41.55	50.15	
93082415	72.80	27.20	97.37	2.68	25.97	30.21	
93082416	70.06	29.94	96.98	3.09	36.83	47.17	
93082417	55.26	44.74	92.43	7.49	44.12	51.90	
93082418	75.09	24.91	96.63	3.47	35.01	48.72	
93082419	79.17	20.83	96.99	3.03	28.45	41.90	
93082420	76.64	23.36	97.19	2.85	18.10	24.66	
93082421	69.57	30.43	95.86	4.23	37.24	49.88	
93082422	74.13	25.87	96.27	3.64	30.05	39.17	
93082423	79.47	20.53	97.76	2.32	25.64	34.86	
93082424	75.54	24.46	97.51	2.52	28.46	37.36	

Average	68.9	31.1	95.9	4.2	34.6	44.3	
Maximum	79.5	44.7	97.8	8.8	45.9	57.2	
Minimum	55.3	20.5	91.2	2.3	18.1	24.7	
Range	24.2	24.2	6.6	6.5	27.8	32.5	
Std.Deviation	6.6	6.6	1.5	1.5	6.9	8.1	
# of Points	24	24	24	24	24	24	

Average	93.5	6.5	96.0	11.7	20.5	29.6	25.6
Maximum	97.6	14.7	98.7	23.7	40.7	58.1	49.0
Minimum	85.3	2.4	90.8	4.8	8.6	11.8	10.5
Range	12.3	12.3	7.9	18.9	32.1	46.3	38.4
Std.Deviation	2.8	2.8	1.9	4.1	7.5	10.9	9.3
# of Points	24	24	24	24	24	24	24

Pittsburgh No. 8 Seam
Long-Duration Tests

Test Number	Column Product Yield (%)	Column Reject Yield (%)	Column Energy Recovery (%)	Column Ash Rejection (%)	Column Sulfur Rejection (%)	Column Pyritic Rejection (%)	Column Separation Efficiency (%)
93082401	78.75	21.25	95.97	73.30	17.83	28.03	
93082402	80.58	19.42	97.18	75.80	17.66	29.50	
93082403	78.36	21.64	97.35	76.89	19.04	31.82	
93082404	77.28	22.72	97.46	76.76	18.97	34.75	
93082405	75.64	24.36	96.52	78.36	21.50	33.28	
93082406	80.38	19.62	97.99	73.67	14.10	21.38	
93082407	74.31	25.69	98.08	78.82	20.55	29.61	
93082408	81.71	18.29	98.49	73.27	12.98	23.63	
93082409	70.49	29.51	97.80	82.62	26.62	54.71	
93082410	74.31	25.69	97.96	79.73	20.21	32.32	
93082411	75.48	24.52	98.19	78.13	16.59	24.70	
93082412	77.56	22.44	98.36	79.13	17.65	27.26	
93082413	73.03	26.97	97.57	84.17	26.49	50.58	
93082414	75.96	24.04	97.42	75.17	15.24	22.37	1
93082415	72.63	27.37	97.88	81.99	19.85	35.97	3
93082416	71.55	28.45	97.71	82.70	22.63	42.41	4
93082417	83.84	16.16	96.78	59.04	11.20	14.91	1
93082418	69.40	30.60	96.41	84.84	27.46	49.69	4
93082419	68.70	31.30	96.88	82.99	27.56	48.91	4
93082420	70.87	29.13	96.56	77.66	18.43	28.76	2
93082421	76.68	23.32	97.72	76.57	15.55	27.21	2
93082422	66.72	33.28	95.65	84.77	28.84	49.53	4
93082423	72.36	27.64	96.86	79.96	21.15	31.12	2
93082424	74.81	25.19	96.62	76.47	20.51	29.14	2

Average	75.1	24.9	97.3	78.0	19.9	33.4	
Maximum	83.8	33.3	98.5	84.8	28.8	54.7	
Minimum	66.7	16.2	95.6	59.0	11.2	14.9	
Range	17.1	17.1	2.8	25.8	17.6	39.8	
Std.Deviation	4.2	4.2	0.8	5.3	4.7	10.3	
# of Points	24	24	24	24	24	24	

**Pittsburgh No. 8 Seam
Long-Duration Tests**

Test Number	% (abs.) of Raw Coal's Energy to:			% (abs.) of Raw Coal's Pyrite to:		
	HMC Reject	WOC Reject	Column Reject	HMC Reject	WOC Reject	Column Reject
93082401	4.0	2.3	3.8	38.7	9.5	14.8
93082402	4.9	3.0	2.6	50.6	9.6	11.8
93082403	5.1	5.4	2.4	45.7	15.2	12.6
93082404	4.3	3.6	2.3	41.0	15.6	15.1
93082405	8.8	1.2	3.1	54.4	5.9	13.3
93082406	4.6	3.5	1.9	45.6	13.9	8.8
93082407	4.8	1.8	1.8	48.0	10.9	12.1
93082408	3.7	3.2	1.4	57.0	10.5	7.8
93082409	3.2	8.9	1.9	39.3	35.1	14.0
93082410	2.4	4.6	1.9	36.0	21.1	14.0
93082411	4.4	6.8	1.6	42.8	22.2	8.6
93082412	3.7	2.1	1.5	49.9	10.0	11.0
93082413	5.2	2.8	2.2	56.8	15.1	14.4
93082414	5.2	4.3	2.4	49.9	13.8	8.2
93082415	2.6	7.0	1.9	29.8	31.0	14.0
93082416	3.0	4.8	2.1	47.2	20.4	13.9
93082417	7.6	1.2	3.0	51.9	5.6	6.5
93082418	3.4	3.3	3.4	48.6	21.3	15.2
93082419	3.0	5.2	2.9	42.0	24.9	16.0
93082420	2.8	5.4	3.2	24.8	23.2	14.9
93082421	4.1	3.1	2.1	49.8	17.8	8.6
93082422	3.7	4.2	4.0	39.0	20.5	20.1
93082423	2.2	2.7	3.1	35.1	17.5	14.7
93082424	2.5	2.2	3.2	37.2	12.2	14.6

Average	4.1	3.9	2.5	44.2	16.8	12.7
Maximum	8.8	8.9	4.0	57.0	35.1	20.1
Minimum	2.2	1.2	1.4	24.8	5.6	6.5
Range	6.6	7.8	2.6	32.3	29.5	13.6
Std.Deviation	1.5	1.9	0.7	8.0	7.2	3.2
# of Points	24	24	24	24	24	24

**Pittsburgh No. 8 Seam
Long-Duration Tests**

Test Number	% of Total Energy Losses			% of Total Pyrite Rejection		
	HMC Reject	WOC Reject	Column Reject	HMC Reject	WOC Reject	Col Re
93082401	39.4	22.9	37.7	61.5	15.0	
93082402	46.7	28.8	24.5	70.3	13.3	
93082403	39.4	42.3	18.3	62.2	20.7	
93082404	42.1	35.1	22.8	57.2	21.8	
93082405	67.1	9.1	23.8	73.8	8.1	
93082406	46.3	35.1	18.7	66.7	20.4	
93082407	57.7	21.3	21.0	67.7	15.3	
93082408	44.2	38.7	17.1	75.8	13.9	
93082409	22.6	63.8	13.6	44.5	39.7	
93082410	27.0	51.5	21.4	50.7	29.7	
93082411	34.3	53.1	12.6	58.2	30.1	
93082412	50.8	28.1	21.0	70.4	14.1	
93082413	50.7	27.5	21.8	65.8	17.5	
93082414	43.5	36.5	20.0	69.5	19.2	
93082415	22.7	60.5	16.7	39.8	41.4	
93082416	30.7	48.2	21.1	58.0	25.0	
93082417	64.7	9.9	25.4	81.2	8.7	
93082418	33.4	33.0	33.6	57.1	25.1	
93082419	27.1	47.0	25.9	50.6	30.1	
93082420	24.7	47.5	27.8	39.4	36.8	
93082421	44.1	33.5	22.5	65.4	23.3	
93082422	31.2	35.4	33.4	49.1	25.7	
93082423	27.9	34.0	38.1	52.1	26.0	
93082424	31.4	27.7	40.9	58.2	19.0	

Average	39.6	36.3	24.1	60.2	22.5	
Maximum	67.1	63.8	40.9	81.2	41.4	
Minimum	22.6	9.1	12.6	39.4	8.1	
Range	44.5	54.7	28.3	41.8	33.4	
Std.Deviation	12.3	13.6	7.4	10.8	8.8	
# of Points	24	24	24	24	24	

UPPER FREEPORT SEAM WASHABILITY

UPPER FREEPORT SEAM WASHABILITY GRAPH

% ASH

CUMULATIVE RECOVERY CUMULATIVE ASH

UPPER FREEPORT SEAM WASHABILITY GRAPH % TOTAL SULFUR

CUMULATIVE RECOVERY CUMULATIVE TOTAL SULFUR

UPPER FREEPORT SEAM WASHABILITY GRAPH % PYRITIC SULFUR

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FOR: ICF KAISER ENGINEERS LAB NO. 31017902
P.O. BOX 1488
BEVERLY, OHIO 45715

SAMPLE ID: RUN NO: 93101501
COAL SEAM: UPPER FREEPORT SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

SAMPLED BY: ICF KAISER ENGINEERS

<u>SIZE</u>	<u>ELEMENTARY % WEIGHT</u>	<u>CUMULATIVE % WEIGHT</u>
+ 1/4" RD	86.14	86.14
1/4" RD X 48 MESH	7.80	93.94
48 MESH X 200 MESH	1.65	95.59
200 MESH X 0	4.41	100.00

STANDARD LABORATORIES, INC.

147 Eleventh Avenue, South Charleston, WV 25303
Telephone (304) 744-5472 • FAX # (304) 744-4319

FOR: ICF KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OH 45715

CALCULATED COMPOSITE
Top x 0 = 100% OF TOTAL SAMPLE

SAMPLE ID:
RUN NO: 93101501
COAL SEAM: UPPER FREEPORT SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

LAB NO: 31017902

SAMPLED BY: ICF-KE

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL	BTU	% WT.	% ASH	% SUL	BTU	% WT.	% ASH	% SUL	BTU
	1.25	0.00				0.00				100.00	18.12	3.99	11975
1.25	1.30	4.01	3.98	1.90	14397	4.01	3.98	1.90	14397	95.99	18.71	4.08	11873
1.30	1.40	57.85	10.76	2.75	13205	61.86	10.32	2.70	13282	38.14	30.78	6.09	9854
1.40	1.50	18.53	20.57	3.88	11614	80.39	12.68	2.97	12897	19.61	40.42	8.18	8192
1.50	1.80	12.30	30.02	4.80	10048	92.69	14.98	3.21	12519	7.31	57.91	13.86	5068
1.80	2.20	3.22	41.06	7.03	7971	95.91	15.86	3.34	12367	4.09	71.17	19.23	2782
2.20		4.09	71.17	19.23	2782	100.00	18.12	3.99	11975				
		% PYRITE				% PYRITE				% PYRITE			
	1.25	0.00				0.00				0.00			
1.25	1.30	0.60				0.60				2.81			
1.30	1.40	1.60				1.53				2.91			
1.40	1.50	2.61				1.78				4.89			
1.50	1.80	3.43				2.00				7.05			
1.80	2.20	6.15				2.14				13.14			
2.20		18.64				2.81				18.64

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FOR: ICF KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OH 45715

+1/4" RD = 86.14% OF TOTAL SAMPLE

SAMPLE ID:
RUN NO: 93101501
COAL SEAM: UPPER FREEPORT SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

LAB NO: 31017902

SAMPLED BY: ICF-KE

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL	BTU	% WT.	% ASH	% SUL	BTU	% WT.	% ASH	% SUL	BTU
	1.25	0.00				0.00				100.00	17.07	4.05	12173
1.25	1.30	2.46	4.65	2.13	14337	2.46	4.65	2.13	14337	97.54	17.39	4.10	12118
1.30	1.40	62.98	10.98	2.79	13180	65.44	10.74	2.77	13223	34.56	29.06	6.48	10183
1.40	1.50	20.11	20.94	3.96	11577	85.55	13.14	3.05	12836	14.45	40.37	9.98	8243
1.50	1.80	9.91	29.19	5.67	10262	95.46	14.81	3.32	12569	4.54	64.76	19.39	3837
1.80	2.20	1.07	48.40	17.08	6543	96.53	15.18	3.47	12502	3.47	69.81	20.10	3003
2.20		3.47	69.81	20.10	3003	100.00	17.07	4.05	12173				
		% PYRITE				% PYRITE				% PYRITE			
	1.25	0.00				0.00				0.00			
1.25	1.30	0.79				0.79				2.85			
1.30	1.40	1.65				1.62				2.90			
1.40	1.50	2.68				1.87				5.19			
1.50	1.80	4.09				2.10				8.68			
1.80	2.20	15.76				2.25				18.70			
2.20		19.61				2.85				19.61

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FOR: ICF KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OH 45715

1/4" RD X 48 MESH = 7.80% OF TOTAL SAMPLE

SAMPLE ID:
RUN NO: 93101501
COAL SEAM: UPPER FREEPORT SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

LAB NO.: 31017902

SAMPLED BY: ICF-KE

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU
	1.25	0.00				0.00				100.00	18.07	4.22	11796
	1.25	21.31	3.44	1.69	14427	21.31	3.44	1.69	14427	78.69	22.03	4.90	11083
	1.30	40.09	7.82	2.26	13495	61.40	6.30	2.06	13818	38.60	36.78	7.65	8578
	1.40	13.26	16.18	2.85	11979	74.66	8.05	2.20	13492	25.34	47.56	10.16	6798
	1.50	12.43	27.86	5.10	10211	87.09	10.88	2.62	13024	12.91	66.54	15.03	3513
	1.80	3.64	49.67	9.09	6510	90.73	12.44	2.88	12762	9.27	73.16	17.36	2336
	2.20	9.27	73.16	17.36	2336	100.00	18.07	4.22	11796				

% PYRITE

	1.25	0.00
1.25	1.30	0.43
1.30	1.40	0.87
1.40	1.50	1.76
1.50	1.80	3.41
1.80	2.20	7.43
2.20		16.73

% PYRITE

	0.00
	0.43
	0.72
	0.90
	1.26
	1.51
	2.92

% PYRITE

	0.00
	2.92
	3.59
	6.42
	8.86
	14.11
	16.73

1 Pes

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FOR: ICF KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OH 45715

48 MESH X 200 MESH = 1.65% OF TOTAL SAMPLE

SAMPLE ID:

LAB NO.: 31017902

RUN NO: 93101501

COAL SEAM: UPPER FREEPORT SEAM

SAMPLE NAME: AS RECEIVED RAW COAL

OCTOBER 15, 1993

SAMPLED BY: ICF-KE

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL	BTU	% WT.	% ASH	% SUL	BTU	% WT.	% ASH	% SUL	BTU
	1.25	0.00				0.00				100.00	25.07	3.90	10709
1.25	1.30	13.91	1.63	1.32	14739	13.91	1.63	1.32	14739	86.09	28.85	4.32	10058
1.30	1.40	28.44	4.46	1.57	14117	42.35	3.53	1.49	14321	57.65	40.89	5.67	8055
1.40	1.50	10.63	10.34	1.77	13071	52.98	4.90	1.54	14070	47.02	47.80	6.56	6921
1.50	1.80	18.47	20.54	1.69	11314	71.45	8.94	1.58	13358	28.55	65.43	9.70	4079
1.80	2.20	9.82	38.34	2.65	8466	81.27	12.49	1.71	12767	18.73	79.63	13.40	1779
2.20		18.73	79.63	13.40	1779	100.00	25.07	3.90	10709				

		% PYRITE
	1.25	0.00
1.25	1.30	0.15
1.30	1.40	0.35
1.40	1.50	0.67
1.50	1.80	0.90
1.80	2.20	1.99
2.20		11.92

% PYRITE
0.00
0.15
0.28
0.36
0.50
0.68
2.79

% PYRITE
0.00
2.79
3.21
4.62
5.52
8.50
11.92

STANDARD LABORATORIES, INC.

147 Eleventh Avenue, South Charleston, WV 25303
Telephone (304) 744-5472 • FAX # (304) 744-4319

F.O. BOX 1400
BEVERLY, OH 45715

200 MESH X 0 = 4.41% OF TOTAL SAMPLE

SAMPLE ID:
RUN NO: 93101501
COAL SEAM: UPPER FREEPORT SEAM
SAMPLE NAME: AS RECEIVED RAW COAL
OCTOBER 15, 1993

LAB NO.: 31017902

SAMPLED BY: ICF-KE

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU
	1.25	0.00				0.00							
	1.25	0.00				0.00							
	1.30	0.00				0.00							
	1.40	0.00				0.00				100.00	36.00	2.46	8903
	1.50	56.50	34.87	2.09	9098	56.50	34.87	2.09	9098	43.50	37.47	2.95	8651
	1.80	42.10	36.33	2.11	8860	98.60	35.49	2.10	8996	1.40	71.61	28.26	2355
	2.20	1.40	71.61	28.26	2355	100.00	36.00	2.46	8903				

% PYRITE

% PYRITE

% PYRITE

	1.25	0.00	0.00
1.25	1.30	0.00	0.00
1.30	1.40	0.00	0.00
1.40	1.50	0.00	0.00
1.50	1.80	1.51	1.51
1.80	2.20	1.55	1.53
2.20		27.48	1.89
			0.00
			0.00
			0.00
			0.00
			1.89
			2.38
			27.48

UPPER FREEPORT SEAM GRINDING OPTIMIZATION RESULTS

Mill Circuit Test Results - Upper Freeport

TEST NUMBER	93100701	93100702	93100601	93100602	93100603	93100604	93100605	93100606
MILL SPEED - RPM	27.7	18.0	27.7	27.7	27.7	27.7	27.7	27.7
COL. FD. RATE - TPH	3.86	4.76	0.89	3.35	1.72	2.76	1.12	1.82

SIZE FRACTION MICRONS	WT% PASSING	WT% PASSING	WT% PASSING	WT% PASSING	WT% PASSING	WT% PASSING	WT% PASSING	WT% PASSING
296.00	92.56	98.78	100.00	98.94	99.79	99.24	99.92	100.00
248.90	87.32	96.16	100.00	97.04	99.22	98.46	99.61	99.89
209.30	81.10	91.52	99.60	94.00	97.98	96.57	98.73	98.99
176.00	74.02	85.01	98.93	90.04	96.24	93.63	97.41	97.33
148.00	66.31	76.80	98.07	85.46	94.20	89.66	95.76	94.81
124.45	57.47	67.40	96.84	80.24	91.53	84.68	93.54	91.33
104.65	51.02	57.42	95.02	74.42	87.89	78.73	90.49	86.77
88.00	44.06	47.51	92.47	68.06	83.17	72.08	86.53	81.16
74.00	37.71	38.30	89.00	61.20	77.22	65.00	81.52	74.51
62.23	31.99	30.32	84.57	54.23	70.41	57.81	75.75	67.19
52.33	26.88	24.09	79.17	47.53	63.14	50.83	69.53	59.56
44.00	22.49	19.26	73.00	41.30	55.78	44.32	63.01	52.04
37.00	18.88	15.51	66.26	35.72	48.67	38.47	56.34	45.02
31.11	15.96	12.66	59.54	31.00	42.27	33.45	50.01	38.85
26.16	13.64	10.52	53.45	27.36	37.01	29.41	44.51	33.91
22.00	11.65	8.78	47.67	24.14	32.39	25.88	39.44	29.60
18.50	9.73	7.19	41.91	20.73	27.93	22.41	34.46	25.39
15.56	7.95	5.75	36.32	17.41	23.73	19.10	29.65	21.39
13.08	6.37	4.46	31.00	14.41	19.80	15.98	25.01	17.66
11.00	5.02	3.39	26.26	11.82	16.38	13.28	20.91	14.47
9.25	3.97	2.64	22.40	9.79	13.71	11.23	17.70	12.11
7.78	3.12	2.06	19.12	8.13	11.51	9.56	15.02	10.21
6.54	2.40	1.55	16.19	6.71	9.53	8.06	12.58	8.48
5.50	1.74	1.08	13.42	5.37	7.69	6.59	10.26	6.86
4.62	1.06	0.58	10.59	3.90	5.85	4.96	7.86	5.25
3.89	0.52	0.19	8.15	2.64	4.29	3.54	5.80	3.88
3.27	0.27	0.04	6.52	1.92	3.30	2.72	4.50	3.01
2.75	0.15	0.00	5.27	1.49	2.58	2.18	3.57	2.35
2.31	0.06	0.00	4.05	1.17	1.87	1.71	2.68	1.68
1.94	0.00	0.00	2.95	0.89	1.26	1.28	1.90	1.09
1.64	0.00	0.00	2.06	0.59	0.80	0.87	1.27	0.67
1.38	0.00	0.00	1.31	0.32	0.45	0.50	0.74	0.37
1.16	0.00	0.00	0.65	0.12	0.17	0.19	0.29	0.14
0.97	0.00	0.00	0.19	0.00	0.00	0.00	0.00	0.00
0.82	0.00	0.00	0.04	0.00	0.00	0.00	0.00	0.00

SUMMARY DATA								
dv	0.1035	0.1346	0.1711	0.0790	0.2287	0.0672	0.1458	0.1831
5%	10.97	14.11	2.65	5.27	4.23	4.64	3.53	4.50
50%	102.12	91.99	23.60	55.85	38.26	51.23	31.10	41.90
95%	328.69	236.70	104.47	220.34	157.75	189.50	138.66	149.70
mv	128.69	104.30	34.64	75.78	52.25	67.75	45.00	53.83
ma	43.43	49.38	10.62	21.64	16.25	18.99	13.33	17.61
cs	0.1380	0.1220	0.5650	0.2770	0.3690	0.3160	0.4500	0.3410
sd	97.53	67.06	27.29	63.17	39.88	54.40	36.01	41.83

**UPPER FREEPORT SEAM
COLUMN FLOTATION
BOX-BEHNKEN TEST MATRIX RESULTS**

a)

Model:
Quadratic
Response:
Pyritic Rej
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 1.000

b)

Model:
Quadratic
Response:
Pyritic Rej
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 2.000

c)

Model:
Quadratic
Response:
Pyritic Rej
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 3.000

Figure 3.6

Effects of Collector Dosage and Air Holdup on Pyritic Sulfur Rejection for the Upper Freeport Coal at Feed Rates of (a) 1.0, (b) 2.0, and (c) 3.0 tph

a)

Model:
Quadratic
Response:
Ash Rej
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 1.000

b)

Model:
Quadratic
Response:
Ash Rej
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 2.000

c)

Model:
Quadratic
Response:
Ash Rej
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 3.000

Figure 3.5

Effects of Collector Dosage and Air Holdup on Ash Rejection for the Upper Freeport Coal at Feed Rates of (a) 1.0, (b) 2.0, and (c) 3.0 tph

a)

Model:
Quadratic
Response:
Recovery
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 1.000

b)

Model:
Quadratic
Response:
Recovery
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 2.000

c)

Model:
Quadratic
Response:
Recovery
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 3.000

Figure 3.4

Effects of Collector Dosage and Air Holdup on Energy Recovery for the Upper Freeport Coal at Feed Rates of (a) 1.0, (b) 2.0, and (c) 3.0 tph

Upper Freeport Seam					
Box-Behnken Tests					
Test	Design	Goodness-of-Fit			Material
Number	Number	Ash	Other	Total	Balance
93100606	9	4.40	0.75	5.15	Good
93100607	12	27.25	7.73	34.98	Poor
93100608	3	10.65	8.09	18.74	Fair
93100609	5	10.25	5.86	16.11	Fair
93100610	1	4.04	2.81	6.85	Good
93100611	7	4.01	4.54	8.55	Good
93100612	2	4.24	2.75	6.99	Good
93100613	9	6.65	3.36	10.01	Good
93100614	12	5.94	5.23	11.17	Fair
93100615	10	0.54	4.47	5.01	Good
93100616	0	1.21	4.40	5.61	Good
93100617	11	2.82	10.32	13.14	Fair
93100618	9	0.46	4.13	4.59	Good
93100619	12	23.39	19.29	42.68	Poor
93100620	10	2.35	11.69	14.04	Fair
93100621	0	3.09	2.20	5.29	Good
93100622	6	0.65	3.19	3.84	Good
93100623	8	0.66	2.17	2.83	Good
93100624	11	0.54	3.52	4.06	Good
93100625	0	3.19	5.88	9.07	Good
93100626	4	4.35	7.68	12.03	Fair
Average		5.75	5.72	11.46	

Upper Freeport Seam										
Box-Behnken Tests										
	Planned	Planned	Planned	Planned	Planned	Planned	Planned	Planned	Planned	Planned
	Plant	Column	Column	Column	Column	Column	Column	Column	Column	Column
	Feed	Feed	Aeration	Wash	Air	Frother	Frother	Collector	Frother	Collector
Test	Rate	Rate	Rate	Rate	Holdup	Type	Dosage	Dosage	Dosage	Dosage
Number	(tph)	(tph)	(scfm)	(gpm)	(%)	(*)	(lb/ton)	(lb/ton)	(ml/min)	(ml/min)
93100606	3.00	2.50	140	100	18	MIBC	N/A	0.20	N/A	4.70
93100607	3.00	2.50	140	100	24	MIBC	N/A	1.00	N/A	23.60
93100608	1.25	1.00	140	100	24	MIBC	N/A	0.60	N/A	5.70
93100609	1.25	1.00	140	100	21	MIBC	N/A	0.20	N/A	1.90
93100610	1.25	1.00	140	100	18	MIBC	N/A	0.60	N/A	5.70
93100611	1.25	1.00	140	100	21	MIBC	N/A	1.00	N/A	9.50
93100612	4.80	4.00	140	100	18	MIBC	N/A	0.60	N/A	22.70
93100613	3.00	2.50	140	100	18	MIBC	N/A	0.20	N/A	4.70
93100614	3.00	2.50	140	100	24	MIBC	N/A	1.00	N/A	23.60
93100615	3.00	2.50	140	100	24	MIBC	N/A	0.20	N/A	4.70
93100616	3.00	2.50	140	100	21	MIBC	N/A	0.60	N/A	14.20
93100617	3.00	2.50	140	100	18	MIBC	N/A	1.00	N/A	23.60
93100618	3.00	2.50	140	100	18	MIBC	N/A	0.20	N/A	4.70
93100619	3.00	2.50	140	100	24	MIBC	N/A	1.00	N/A	23.60
93100620	3.00	2.50	140	100	24	MIBC	N/A	0.20	N/A	4.70
93100621	3.00	2.50	140	100	21	MIBC	N/A	0.60	N/A	14.20
93100622	4.80	4.00	140	100	21	MIBC	N/A	0.20	N/A	7.60
93100623	4.80	4.00	140	100	21	MIBC	N/A	1.00	N/A	37.80
93100624	3.00	2.50	140	100	18	MIBC	N/A	1.00	N/A	23.60
93100625	3.00	2.50	140	100	21	MIBC	N/A	0.60	N/A	14.20
93100626	4.80	4.00	140	100	24	MIBC	N/A	0.60	N/A	22.70
Average	3.01	2.50	140	100	21	MIBC	N/A	0.60	N/A	14.18

Upper Freeport Seam									
Box-Behnken Tests									
	Relative	Relative	Relative	Relative	Relative	Relative	Relative	Relative	Relative
	Plant	Deslime	HMC	WOC	WOC	Column	Column	Column	Thickener
Test	Feed	U/F	Reject	O/F	U/F	Feed	Product	Reject	Feed
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	100.00	90.98	9.02	87.51	3.47	87.51	30.19	57.32	60.79
93100607	100.00	88.84	11.16	88.50	0.34	88.50	79.45	9.05	9.39
93100608	100.00	85.11	14.89	83.86	1.25	83.86	70.81	13.05	14.30
93100609	100.00	85.31	14.69	83.71	1.59	83.71	67.37	16.35	17.94
93100610	100.00	89.78	10.22	88.05	1.73	88.05	43.29	44.76	46.49
93100611	100.00	85.67	14.33	85.20	0.47	85.20	71.19	14.01	14.48
93100612	100.00	88.50	11.50	86.47	2.03	86.47	34.73	51.74	53.77
93100613	100.00	89.79	10.21	89.69	0.10	89.69	47.64	42.05	42.15
93100614	100.00	94.02	5.98	93.26	0.76	93.26	75.12	18.14	18.90
93100615	100.00	92.02	7.98	91.83	0.20	91.83	69.22	22.61	22.80
93100616	100.00	93.36	6.64	92.79	0.57	92.79	64.15	28.64	29.21
93100617	100.00	90.09	9.91	88.69	1.40	88.69	63.18	25.51	26.91
93100618	100.00	95.33	4.67	92.92	2.41	92.92	50.29	42.63	45.04
93100619	100.00	88.33	11.67	87.28	1.05	87.28	71.51	15.77	16.82
93100620	100.00	87.67	12.33	87.22	0.45	87.22	70.05	17.16	17.62
93100621	100.00	87.52	12.48	86.04	1.48	86.04	70.19	15.85	17.33
93100622	100.00	90.00	10.00	88.43	1.57	88.43	62.92	25.50	27.08
93100623	100.00	89.45	10.55	87.97	1.48	87.97	70.28	17.69	19.17
93100624	100.00	87.67	12.33	86.30	1.37	86.30	60.82	25.48	26.85
93100625	100.00	88.98	11.02	88.08	0.90	88.08	71.32	16.76	17.66
93100626	100.00	88.76	11.24	87.65	1.12	87.65	70.54	17.10	18.22
Average	100.00	89.39	10.61	88.16	1.23	88.16	62.58	25.58	26.81

Upper Freeport Seam									
Box-Behnken Tests									
	Relative	Relative	Relative	Relative	Relative	Relative	Relative	Relative	Relative
	Plant	Deslime	HMC	WOC	WOC	Column	Column	Column	Thickener
Test	Feed	U/F	Reject	O/F	U/F	Feed	Product	Reject	Feed
Number	(tph)	(tph)	(tph)	(tph)	(tph)	(tph)	(tph)	(tph)	(tph)
93100606	3.00	2.73	0.27	2.63	0.10	2.63	0.91	1.72	1.82
93100607	3.00	2.67	0.33	2.66	0.01	2.66	2.38	0.27	0.28
93100608	1.25	1.06	0.19	1.05	0.02	1.05	0.89	0.16	0.18
93100609	1.25	1.07	0.18	1.05	0.02	1.05	0.84	0.20	0.22
93100610	1.25	1.12	0.13	1.10	0.02	1.10	0.54	0.56	0.58
93100611	1.25	1.07	0.18	1.07	0.01	1.07	0.89	0.18	0.18
93100612	4.80	4.25	0.55	4.15	0.10	4.15	1.67	2.48	2.58
93100613	3.00	2.69	0.31	2.69	0.00	2.69	1.43	1.26	1.26
93100614	3.00	2.82	0.18	2.80	0.02	2.80	2.25	0.54	0.57
93100615	3.00	2.76	0.24	2.75	0.01	2.75	2.08	0.68	0.68
93100616	3.00	2.80	0.20	2.78	0.02	2.78	1.92	0.86	0.88
93100617	3.00	2.70	0.30	2.66	0.04	2.66	1.90	0.77	0.81
93100618	3.00	2.86	0.14	2.79	0.07	2.79	1.51	1.28	1.35
93100619	3.00	2.65	0.35	2.62	0.03	2.62	2.15	0.47	0.50
93100620	3.00	2.63	0.37	2.62	0.01	2.62	2.10	0.51	0.53
93100621	3.00	2.63	0.37	2.58	0.04	2.58	2.11	0.48	0.52
93100622	4.80	4.32	0.48	4.24	0.08	4.24	3.02	1.22	1.30
93100623	4.80	4.29	0.51	4.22	0.07	4.22	3.37	0.85	0.92
93100624	3.00	2.63	0.37	2.59	0.04	2.59	1.82	0.76	0.81
93100625	3.00	2.67	0.33	2.64	0.03	2.64	2.14	0.50	0.53
93100626	4.80	4.26	0.54	4.21	0.05	4.21	3.39	0.82	0.87
Average	3.01	2.70	0.31	2.66	0.04	2.66	1.87	0.79	0.83

Upper Freeport Seam										
Box-Behnken Tests										
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Plant	Plant	Deslime	Deslime	HMC	HMC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	U/F	Reject	Reject	O/F	O/F	U/F	U/F
Test	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	22.55	22.44	18.25	18.17	65.47	65.55	16.08	16.82	51.86	52.30
93100607	23.12	23.22	15.51	17.69	67.33	67.24	17.86	17.56	51.93	51.70
93100608	23.73	24.54	17.72	17.85	63.64	62.78	16.27	17.41	47.27	46.95
93100609	22.87	23.61	15.99	16.72	64.48	63.62	15.31	16.09	49.93	49.60
93100610	22.72	22.30	16.75	17.35	65.41	65.76	15.97	16.71	50.08	50.13
93100611	23.10	23.58	16.32	16.90	64.10	63.57	16.27	16.72	48.84	48.76
93100612	24.24	24.03	19.01	18.48	66.52	66.70	16.74	17.71	51.04	51.39
93100613	21.85	22.72	17.04	17.97	65.23	64.44	18.11	17.93	53.73	53.72
93100614	19.79	20.16	17.12	17.45	63.01	62.79	16.68	17.20	48.47	48.28
93100615	20.37	20.51	16.65	16.93	61.91	61.81	17.21	16.86	51.98	51.97
93100616	19.86	20.07	17.06	17.10	61.89	61.76	16.53	16.91	47.48	47.44
93100617	21.32	21.95	17.64	17.39	63.95	63.39	16.15	16.90	48.69	48.58
93100618	21.06	20.56	17.98	18.34	65.47	65.70	17.34	17.37	55.97	55.92
93100619	22.88	23.42	18.18	17.61	67.89	67.34	15.84	17.20	52.26	51.77
93100620	23.81	24.33	18.91	18.39	67.04	66.53	17.23	18.21	54.30	54.33
93100621	23.24	23.63	17.71	17.65	65.96	65.57	16.80	17.02	53.44	53.74
93100622	22.93	23.15	18.02	18.26	67.35	67.16	17.64	17.66	52.13	52.19
93100623	23.97	24.11	18.56	19.00	67.56	67.45	18.23	18.43	52.66	52.61
93100624	24.33	24.80	19.46	19.11	65.69	65.26	18.20	18.59	52.20	52.21
93100625	22.94	23.43	17.66	18.07	67.19	66.73	17.19	17.72	52.79	52.64
93100626	24.55	24.82	19.16	19.60	66.26	66.04	19.55	19.18	52.30	52.03
Average	22.63	22.92	17.65	17.91	65.40	65.10	17.01	17.44	51.40	51.35

Upper Freeport Seam								
Box-Behnken Tests								
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Column	Column	Column	Column	Column	Column	Thickener	Thickener
	Feed	Feed	Product	Product	Reject	Reject	Feed	Feed
Test	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	17.59	16.82	7.36	7.36	20.73	21.80	25.17	23.54
93100607	21.46	17.56	12.52	12.55	67.72	61.50	56.56	61.14
93100608	19.28	17.41	10.79	10.70	58.48	53.82	49.89	53.22
93100609	18.61	16.09	9.43	9.43	44.72	43.57	42.96	44.10
93100610	17.89	16.71	7.07	7.06	25.43	26.05	27.97	26.94
93100611	18.14	16.72	10.03	10.00	52.33	50.87	49.58	50.80
93100612	17.93	17.71	7.53	7.51	23.59	24.56	27.41	25.57
93100613	19.69	17.93	8.33	8.34	27.61	28.81	30.21	28.87
93100614	18.10	17.20	10.99	10.88	47.15	43.35	40.94	43.55
93100615	16.69	16.86	9.75	9.70	39.50	38.78	38.48	38.90
93100616	17.21	16.91	9.17	9.11	35.72	34.39	33.79	34.64
93100617	17.54	16.90	9.72	9.64	36.35	34.90	34.67	35.61
93100618	17.38	17.37	7.24	7.24	29.60	29.32	30.48	30.74
93100619	18.05	17.20	11.19	10.98	55.21	45.41	40.76	45.81
93100620	18.87	18.21	10.68	10.61	49.10	49.22	49.87	49.35
93100621	17.19	17.02	10.22	10.16	45.18	47.41	51.45	47.95
93100622	17.90	17.66	10.02	9.99	35.87	36.58	38.55	37.49
93100623	19.00	18.43	10.83	10.78	48.86	48.81	49.31	49.11
93100624	18.59	18.59	7.97	7.93	44.55	44.03	44.49	44.45
93100625	18.86	17.72	10.52	10.46	50.50	48.63	47.42	48.83
93100626	19.10	19.18	11.51	11.42	55.46	51.21	48.25	51.26
Average	18.34	17.44	9.66	9.61	42.56	41.10	40.87	41.52

Upper Freeport Seam										
Box-Behnken Tests										
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Plant	Plant	Deslime	Deslime	HMC	HMC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	U/F	Reject	Reject	O/F	O/F	U/F	U/F
Test	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	4.95	4.99	3.44	3.47	20.46	20.39	2.87	2.87	18.94	18.64
93100607	4.61	4.74	2.71	2.87	19.83	19.57	3.08	2.81	19.63	19.67
93100608	4.75	5.33	3.18	2.86	21.13	19.43	2.68	2.68	15.21	14.97
93100609	4.62	5.22	2.88	2.89	20.52	18.77	2.71	2.61	17.80	17.78
93100610	4.49	4.65	3.25	2.93	20.10	19.77	2.82	2.65	17.23	17.21
93100611	4.53	5.01	2.91	2.74	19.91	18.58	2.65	2.67	15.12	15.00
93100612	4.75	4.78	3.06	2.89	19.31	19.26	2.70	2.53	18.54	18.35
93100613	4.41	4.43	2.98	2.91	17.84	17.81	2.63	2.89	20.76	20.75
93100614	4.01	3.93	3.30	2.93	19.43	19.55	2.79	2.81	17.81	17.63
93100615	4.46	4.40	3.08	3.02	20.28	20.38	3.23	2.97	22.19	22.20
93100616	4.29	4.01	3.07	2.75	21.21	21.66	2.85	2.68	15.58	15.61
93100617	4.54	4.77	3.14	2.89	22.47	21.91	2.73	2.65	18.34	18.07
93100618	3.57	3.81	3.00	3.04	19.72	19.38	2.92	2.61	19.99	19.83
93100619	3.81	4.44	3.17	2.75	19.19	17.31	2.62	2.59	16.50	15.82
93100620	4.80	4.97	3.38	2.75	21.17	20.77	2.74	2.68	15.42	15.33
93100621	4.59	4.73	2.67	2.61	19.97	19.63	2.48	2.34	18.14	18.00
93100622	4.66	4.68	3.20	2.98	19.96	19.93	2.96	2.70	18.72	18.74
93100623	4.90	4.75	3.19	3.07	18.80	19.03	2.92	2.81	18.28	18.42
93100624	4.53	4.59	2.67	2.57	19.09	18.96	2.35	2.39	14.46	14.15
93100625	4.31	4.53	3.09	2.76	19.38	18.89	2.88	2.61	17.00	17.00
93100626	4.53	4.41	3.06	2.76	17.22	17.42	2.96	2.59	15.72	15.80
Average	4.48	4.63	3.07	2.88	19.86	19.45	2.79	2.67	17.68	17.57

Upper Freeport Seam								
Box-Behnken Tests								
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Column	Column	Column	Column	Column	Column	Thickener	Thickener
	Feed	Feed	Product	Product	Reject	Reject	Feed	Feed
Test	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	2.87	2.87	2.43	2.42	3.24	3.10	3.81	3.99
93100607	2.89	2.81	2.61	2.68	3.83	3.93	4.63	4.50
93100608	2.85	2.68	2.30	2.43	4.18	4.04	4.70	5.00
93100609	2.84	2.61	2.18	2.25	3.96	4.08	5.43	5.30
93100610	2.59	2.65	2.22	2.30	2.95	2.99	3.36	3.52
93100611	2.70	2.67	2.35	2.35	4.64	4.30	4.34	4.65
93100612	2.62	2.53	2.11	2.20	2.70	2.75	3.10	3.34
93100613	3.17	2.89	2.35	2.35	3.62	3.50	3.44	3.54
93100614	2.82	2.81	2.43	2.60	3.90	3.69	3.91	4.25
93100615	3.19	2.97	2.35	2.58	3.97	4.18	4.33	4.34
93100616	2.64	2.68	2.19	2.40	3.17	3.29	3.44	3.53
93100617	2.74	2.65	2.20	2.33	3.54	3.44	3.89	4.20
93100618	2.45	2.61	2.11	2.08	3.26	3.23	4.17	4.12
93100619	2.64	2.59	2.30	2.37	4.21	3.58	3.77	4.35
93100620	2.60	2.68	2.33	2.52	3.51	3.33	3.36	3.63
93100621	2.28	2.34	2.08	2.12	3.36	3.33	4.47	4.58
93100622	2.65	2.70	2.39	2.56	2.98	3.05	3.88	3.96
93100623	2.90	2.81	2.45	2.64	3.39	3.50	4.69	4.65
93100624	2.47	2.39	2.00	2.05	3.51	3.19	3.37	3.75
93100625	2.69	2.61	2.15	2.40	3.39	3.48	4.09	4.17
93100626	2.47	2.59	2.20	2.43	3.16	3.25	3.98	4.02
Average	2.72	2.67	2.27	2.38	3.55	3.49	4.01	4.16

Upper Freeport Seam									
Box-Behnken Tests									
	Measured	Adjusted	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Plant	Plant	Deslime	HMC	HMC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	Reject	Reject	O/F	O/F	U/F	U/F
Test	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	3.72	3.78	2.21	19.79	19.64	1.63	1.62	17.76	17.09
93100607	3.42	3.60	1.68	19.53	18.88	1.94	1.62	17.89	17.91
93100608	3.66	4.16	1.75	20.18	17.93	1.58	1.58	13.63	13.43
93100609	3.40	3.99	1.76	19.91	16.94	1.51	1.49	16.14	16.12
93100610	3.40	3.46	1.72	19.00	18.80	1.63	1.44	15.80	15.68
93100611	3.41	3.82	1.60	18.90	17.09	1.53	1.53	14.62	14.47
93100612	3.53	3.67	1.78	18.71	18.25	1.58	1.41	18.05	17.45
93100613	3.20	3.26	1.75	16.76	16.58	1.59	1.73	18.82	18.80
93100614	2.58	2.64	1.67	18.09	17.91	1.42	1.55	16.28	15.86
93100615	3.06	3.06	1.67	19.08	19.09	1.35	1.62	20.96	20.98
93100616	2.64	2.80	1.56	20.95	20.26	1.65	1.48	14.51	14.46
93100617	3.07	3.50	1.72	21.82	19.67	1.61	1.49	16.28	16.65
93100618	3.30	3.09	2.23	20.37	20.74	2.22	1.77	19.24	19.99
93100619	3.05	3.42	1.61	18.80	17.15	1.40	1.45	15.93	15.18
93100620	3.45	3.83	1.73	20.42	18.77	1.70	1.66	14.90	14.96
93100621	3.28	3.67	1.66	19.43	17.73	1.50	1.39	17.80	17.55
93100622	3.06	3.40	1.85	18.69	17.41	1.89	1.57	17.95	17.67
93100623	3.99	3.84	2.08	18.47	18.81	2.01	1.81	17.95	17.84
93100624	3.77	3.80	1.76	18.37	18.30	1.59	1.57	13.98	13.76
93100625	2.87	3.24	1.60	18.05	16.45	1.35	1.46	15.14	15.03
93100626	3.34	3.35	1.65	16.75	16.73	1.88	1.48	14.86	14.73
Average	3.30	3.49	1.76	19.15	18.24	1.65	1.56	16.59	16.46

Upper Freeport Seam								
Box-Behnken Tests								
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Column	Column	Column	Column	Column	Column	Thickener	Thickener
	Feed	Feed	Product	Product	Reject	Reject	Feed	Feed
Test	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	1.68	1.62	1.10	1.11	1.95	1.89	2.58	2.75
93100607	1.74	1.62	1.35	1.41	3.28	3.44	4.15	3.96
93100608	1.72	1.58	1.15	1.24	3.45	3.41	4.02	4.29
93100609	1.73	1.49	1.04	1.06	3.09	3.25	4.71	4.39
93100610	1.36	1.44	1.02	1.05	1.82	1.82	2.17	2.34
93100611	1.56	1.53	1.14	1.16	3.66	3.40	3.48	3.76
93100612	1.50	1.41	0.96	1.01	1.63	1.68	2.02	2.27
93100613	2.07	1.73	1.19	1.16	2.48	2.38	2.44	2.42
93100614	1.80	1.55	1.25	1.30	2.92	2.61	2.79	3.15
93100615	1.89	1.62	1.20	1.19	3.09	2.96	3.02	3.12
93100616	1.49	1.48	1.05	1.14	2.21	2.25	2.33	2.49
93100617	2.61	1.49	1.10	1.32	1.66	1.90	2.77	2.67
93100618	1.71	1.77	1.17	1.25	2.08	2.38	3.56	3.32
93100619	1.54	1.45	1.17	1.23	2.72	2.41	2.78	3.21
93100620	1.62	1.66	1.24	1.38	2.76	2.83	3.03	3.15
93100621	1.43	1.39	0.98	1.05	2.83	2.87	3.91	4.12
93100622	1.59	1.57	1.21	1.28	2.19	2.26	3.10	3.16
93100623	1.85	1.81	1.38	1.51	2.93	3.00	3.98	4.15
93100624	1.64	1.57	0.96	1.02	2.95	2.86	3.04	3.42
93100625	1.64	1.46	1.16	1.17	2.78	2.71	3.22	3.34
93100626	1.40	1.48	1.08	1.21	2.59	2.62	3.13	3.36
Average	1.69	1.56	1.14	1.20	2.62	2.62	3.15	3.28

<i>Upper Freeport Seam</i>									
<i>Box-Behnken Tests</i>									
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured
	Plant	Plant	Deslime	Deslime	HMC	HMC	WOC	WOC	WOC
	Feed	Feed	U/F	U/F	Reject	Reject	O/F	O/F	U/F
Test	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy
Number	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)
93100606	11220	11240	11990	11990	3740	3740	12310	12210	6450
93100607	11300	11150	12410	12080	3800	3800	12150	12100	6280
93100608	11050	10860	12080	12080	3870	3870	12390	12150	7060
93100609	11150	11010	12380	12240	3870	3870	12470	12350	6730
93100610	11350	11350	12330	12220	3700	3700	12410	12340	6350
93100611	11300	11120	12340	12310	4010	4010	12360	12340	6670
93100612	11090	11100	11980	12090	3460	3460	12430	12230	5950
93100613	11450	11240	12140	12110	3570	3570	12210	12110	5720
93100614	11860	11740	12190	12230	4050	4050	12520	12270	6580
93100615	11500	11590	12280	12220	4220	4220	12240	12240	5710
93100616	11600	11660	12190	12190	4160	4160	12300	12220	6780
93100617	11460	11370	12180	12220	3680	3680	12400	12300	6660
93100618	11630	11640	11990	12040	3510	3510	12200	12210	5260
93100619	11180	11070	11920	12100	3280	3280	12430	12180	5870
93100620	11060	10960	11870	12020	3490	3490	12150	12050	5690
93100621	10910	11030	12090	12110	3450	3450	12340	12220	5830
93100622	11210	11190	12080	12050	3430	3430	12180	12150	6330
93100623	11130	11070	12050	11980	3350	3350	12030	12080	6300
93100624	11080	10930	11860	11950	3660	3670	12100	12050	6000
93100625	11360	11130	11980	12090	3370	3370	12250	12160	6000
93100626	10980	10890	11840	11820	3580	3580	11770	11890	6230
Average	11280	11207	12103	12102	3678	3679	12269	12183	6212

Upper Freeport Seam									
Box-Behnken Tests									
Test	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	WOC	Column	Column	Column	Column	Column	Column	Column	Column
	U/F	Feed	Feed	Feed	Feed	Feed	Feed	Feed	Feed
	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy
Number	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)
93100606	6450	12120	12210	13810	13810	11560	11360	10900	11080
93100607	6320	11620	12100	12930	12910	4410	4940	6050	4990
93100608	7140	11770	12150	13330	13360	5180	5610	6490	5750
93100609	6740	11970	12350	13450	13460	7560	7760	7900	7670
93100610	6350	12130	12340	13950	13930	10980	10800	10470	10630
93100611	6690	12140	12340	13460	13480	6230	6530	6910	6540
93100612	5940	12210	12230	13860	13880	11250	11120	10780	10930
93100613	5720	11900	12110	13660	13750	10480	10260	10000	10250
93100614	6590	12140	12270	13220	13400	7200	7610	8080	7560
93100615	5710	12260	12240	13420	13400	8460	8670	8870	8640
93100616	6780	12190	12220	13610	13590	8920	9150	9370	9110
93100617	6670	12260	12300	13470	13570	8940	9180	9320	9050
93100618	5260	12180	12210	13910	13840	10350	10290	9980	10020
93100619	5930	12100	12180	13340	13420	5730	6530	8270	6490
93100620	5690	11910	12050	13420	13330	6930	6830	6710	6800
93100621	5810	12260	12220	13340	13360	7420	7130	6750	7020
93100622	6330	12210	12150	13260	13370	9120	9140	8980	8980
93100623	6310	12000	12080	13290	13280	7050	7320	7580	7240
93100624	6000	12040	12050	13760	13860	7820	7720	7520	7630
93100625	6010	11930	12160	13380	13340	6800	7100	7440	7050
93100626	6260	11850	11890	13260	13210	6010	6460	7120	6450
Average	6224	12057	12183	13482	13502	8019	8167	8357	8090

Upper Freeport Seam							
Box-Behnken Tests							
	Plant	Plant	Plant	Plant	Plant	Plant	Plant
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	30.19	69.81	37.09	90.15	85.36	91.13	28.23
93100607	79.45	20.55	91.99	56.87	55.08	68.88	60.87
93100608	70.81	29.19	87.11	68.07	67.72	78.89	66.00
93100609	67.37	32.63	82.36	72.22	70.96	82.10	64.46
93100610	43.29	56.71	53.13	86.55	78.59	86.86	39.99
93100611	71.19	28.81	86.30	69.18	66.61	78.38	64.68
93100612	34.73	65.27	43.43	89.24	84.02	90.44	33.87
93100613	47.64	52.36	58.28	81.82	74.73	83.05	41.33
93100614	75.12	24.88	85.74	58.70	50.30	63.01	48.75
93100615	69.22	30.78	80.03	67.04	59.41	73.08	53.11
93100616	64.15	35.85	74.77	70.57	61.61	73.88	48.65
93100617	63.18	36.82	75.40	71.43	69.14	76.17	51.58
93100618	50.29	49.71	59.79	82.71	72.55	79.66	39.45
93100619	71.51	28.49	86.69	65.68	61.83	74.28	60.97
93100620	70.05	29.95	85.20	68.78	64.48	74.76	59.96
93100621	70.19	29.81	85.02	69.31	68.54	79.92	64.94
93100622	62.92	37.08	75.18	72.59	65.58	76.31	51.49
93100623	70.28	29.72	84.31	68.39	60.94	72.36	56.67
93100624	60.82	39.18	77.12	80.18	72.84	83.67	60.80
93100625	71.32	28.68	85.48	67.48	62.21	74.25	59.73
93100626	70.54	29.46	85.57	67.19	61.13	74.52	60.09
Average	62.58	37.42	75.24	72.58	67.31	77.89	53.12

Upper Freeport Seam							
Box-Behnken Tests							
	HMC	HMC	HMC	HMC	HMC	HMC	HMC
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	90.98	9.02	97.05	3.00	36.86	46.87	43.92
93100607	88.84	11.16	96.25	3.80	46.08	58.53	54.78
93100608	85.11	14.89	94.67	5.31	54.28	64.18	58.85
93100609	85.31	14.69	94.84	5.16	52.82	62.37	57.21
93100610	89.78	10.22	96.66	3.33	43.45	55.53	52.19
93100611	85.67	14.33	94.84	5.17	53.14	64.11	58.95
93100612	88.50	11.50	96.39	3.58	46.34	57.19	53.58
93100613	89.79	10.21	96.74	3.24	41.05	51.93	48.67
93100614	94.02	5.98	97.94	2.06	29.75	40.57	38.51
93100615	92.02	7.98	97.02	2.91	36.96	49.78	46.81
93100616	93.36	6.64	97.60	2.37	35.87	48.05	45.65
93100617	90.09	9.91	96.82	3.21	45.52	55.69	52.52
93100618	95.33	4.67	98.61	1.41	23.75	31.34	29.95
93100619	88.33	11.67	96.55	3.46	45.50	58.52	55.07
93100620	87.67	12.33	96.15	3.93	51.53	60.43	56.58
93100620	87.52	12.48	96.09	3.90	51.79	60.29	56.38
93100620	90.00	10.00	96.92	3.07	42.59	51.21	48.12
93100620	89.45	10.55	96.80	3.19	42.27	51.68	48.48
93100620	87.67	12.33	95.85	4.14	50.93	59.38	55.23
93100620	88.98	11.02	96.65	3.34	45.95	55.95	52.61
93100620	88.76	11.24	96.34	3.70	44.40	56.13	52.47
Average	89.39	10.61	96.51	3.49	43.85	54.27	50.79

Upper Freeport Seam							
Box-Behnken Tests							
	WOC	WOC	WOC	WOC	WOC	WOC	WOC
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	96.19	3.81	97.95	10.98	20.49	29.49	27.44
93100607	99.62	0.38	99.78	1.12	2.62	4.08	3.86
93100608	98.53	1.47	99.10	3.86	7.69	11.27	10.37
93100609	98.12	1.88	99.01	5.53	11.47	17.07	16.08
93100610	98.07	1.93	99.04	5.57	11.32	17.57	16.60
93100611	99.45	0.55	99.69	1.58	3.00	4.96	4.66
93100612	97.71	2.29	98.84	6.38	14.56	22.49	21.32
93100613	99.89	0.11	99.89	0.33	0.79	1.20	1.09
93100614	99.19	0.81	99.52	2.24	4.86	7.68	7.19
93100615	99.79	0.21	99.96	0.67	1.60	2.73	2.69
93100616	99.39	0.61	99.63	1.69	3.47	5.66	5.29
93100617	98.45	1.55	99.09	4.34	9.72	15.04	14.13
93100618	97.47	2.53	98.85	7.71	16.49	22.66	21.51
93100619	98.81	1.19	99.46	3.49	6.84	11.21	10.67
93100620	99.49	0.51	99.74	1.52	2.86	4.44	4.17
93100620	98.31	1.69	99.20	5.15	11.66	17.88	17.08
93100620	98.26	1.74	99.07	4.99	10.97	16.66	15.73
93100620	98.35	1.65	99.17	4.58	9.93	14.19	13.36
93100620	98.44	1.56	99.26	4.27	8.60	12.22	11.48
93100620	98.99	1.01	99.56	2.95	6.23	9.50	9.06
93100620	98.75	1.25	99.33	3.35	7.22	11.26	10.60
Average	98.63	1.37	99.29	3.92	8.21	12.35	11.64

Upper Freeport Seam							
Box-Behnken Tests							
	Column	Column	Column	Column	Column	Column	Column
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93100606	34.50	65.50	39.02	84.89	70.75	76.42	15.44
93100607	89.77	10.23	95.78	35.81	14.30	21.71	17.50
93100608	84.44	15.56	92.85	48.11	23.46	33.59	26.43
93100609	80.48	19.52	87.71	52.89	30.53	42.60	30.32
93100610	49.17	50.83	55.50	79.25	57.36	64.25	19.75
93100611	83.56	16.44	91.28	50.03	26.48	36.54	27.82
93100612	40.16	59.84	45.58	82.98	65.04	71.29	16.88
93100613	53.12	46.88	60.31	75.33	56.78	64.50	24.81
93100614	80.55	19.45	87.97	49.02	25.54	32.75	20.72
93100615	75.38	24.62	82.52	56.63	34.65	44.99	27.51
93100616	69.13	30.87	76.89	62.77	37.89	46.92	23.81
93100617	71.24	28.76	78.59	59.40	37.34	36.68	15.27
93100618	54.12	45.88	61.35	77.44	56.78	61.69	23.04
93100619	81.93	18.07	90.27	47.70	24.97	30.03	20.30
93100620	80.31	19.69	88.85	53.18	24.45	33.54	22.39
93100620	81.58	18.42	89.19	51.31	26.22	38.04	27.22
93100620	71.15	28.85	78.30	59.73	32.57	41.51	19.81
93100620	79.89	20.11	87.83	53.26	25.05	33.33	21.16
93100620	70.48	29.52	81.06	69.93	39.41	53.78	34.85
93100620	80.97	19.03	88.83	52.22	25.37	35.32	24.15
93100620	80.48	19.52	89.41	52.09	24.48	34.54	23.95
Average	71.07	28.93	78.53	59.71	36.16	44.48	23.01

UPPER FREEPORT SEAM 24-HOUR GRIND RESULTS

UPPER FREEPORT SEAM 24-HOUR RUN DATA: MICROTRAC OF MILL CIRCUIT FEED

Shift >	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17
Microns																	
296.0	70.8	70.6	65.4	75.2	72.0			69.9	67.3		73.0	74.6	100.0	100.0	68.8	100.0	100.0
209.3	54.6	52.7	47.5	61.3	56.3			53.7	52.1		55.8	59.5	77.7	75.9	50.5	79.7	77.7
148.0	41.8	37.2	34.5	49.3	43.3			40.7	40.9		41.2	46.1	58.4	55.7	35.8	60.1	59.0
104.7	33.0	25.6	25.9	40.2	33.8			31.6	32.7		30.9	35.7	44.1	41.7	26.1	44.3	45.3
74.0	26.5	17.1	19.5	32.6	26.4			24.8	26.1		23.1	27.6	33.6	31.6	19.4	32.2	35.0
52.3	21.6	11.2	14.7	25.9	20.5			19.2	20.8		17.1	21.0	25.4	23.6	14.4	22.6	26.8
37.0	17.8	6.9	11.2	20.1	15.5			14.8	16.1		12.5	15.6	18.9	17.2	10.5	15.6	20.0
26.2	14.5	4.3	8.4	15.4	11.6			11.3	12.3		9.1	11.6	13.9	12.8	7.6	11.2	14.8
18.5	11.4	2.7	6.1	11.6	8.7			8.6	9.4		6.6	8.5	10.1	9.7	5.5	8.0	10.6
13.1	8.4	1.3	3.9	8.0	5.8			5.9	6.5		4.2	5.4	6.4	6.4	3.5	5.1	6.8
9.3	5.9	0.6	2.3	5.1	3.7			3.7	4.1		2.4	3.1	3.6	3.8	1.9	3.1	4.0
6.5	4.1	0.3	1.3	3.3	2.4			2.3	2.5		1.4	1.7	2.0	2.1	1.0	1.9	2.2
4.6	2.5	0.1	0.3	1.5	1.2			1.1	1.2		0.5	0.6	0.6	0.8	0.3	0.7	0.8
3.3	1.2	0.0	0.0	0.5	0.4			0.3	0.4		0.0	0.0	0.0	0.1	0.0	0.1	0.1
dv	0.094	0.139	0.123	0.127	0.129			0.137	0.117		0.164	0.131	0.141	0.119	0.129	0.121	0.114
05%	7.9	29.7	15.7	9.0	11.7			11.5	10.8		14.8	12.5	11.3	11.1	17.0	12.9	10.7
50%	187.2	198.1	221.0	151.4	179.6			191.5	197.8		184.8	165.2	122.7	130.5	207.3	119.8	119.5
95%	508.7	515.0	536.9	504.3	518.3			532.2	547.4		506.7	502.8	273.9	275.8	509.2	270.7	274.4
mv	210.1	225.2	238.0	189.8	208.5			218.1	224.0		210.3	198.3	129.3	134.2	227.0	128.3	127.6

UPPER FREEPORT SEAM 24-HOUR RUN DATA: MICROTRAC OF MILL CIRCUIT FEED

Shift >	18	19	20	21	22	23	24	25	26	27	28	29	30
Microns													
296.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0			100.0	100.0	100
209.3	74.9	75.0	76.6	75.8	81.4	76.2	83.0	79.3			80.7	75.8	73.2
148.0	53.1	53.2	57.1	54.7	64.2	56.8	65.4	60.7			62.8	53.1	50.8
104.7	37.9	38.4	42.9	39.8	51.0	43.3	49.7	46.4			48.7	36.3	34
74.0	27.2	27.5	32.7	29.3	40.6	33.4	36.8	35.5			38.0	23.8	22
52.3	19.5	19.2	24.9	21.2	31.9	25.2	26.9	26.9			29.5	15.1	14
37.0	13.9	13.6	18.6	14.7	24.4	18.9	19.3	20.5			22.5	9.7	8.59
26.2	10.2	9.9	13.7	10.5	18.5	14.4	14.1	15.9			17.5	6.1	5.36
18.5	7.5	7.0	10.1	7.5	13.8	10.6	10.2	12.1			13.5	3.9	3.34
13.1	4.8	4.3	6.5	4.4	9.2	7.0	6.5	8.2			9.1	2.1	1.65
9.3	2.8	2.5	3.8	2.3	5.7	4.1	3.8	5.1			5.8	0.9	0.6
6.5	1.7	1.4	2.2	1.2	3.5	2.4	2.2	3.0			3.6	0.5	0.21
4.6	0.5	0.4	0.9	0.3	1.5	1.0	0.9	1.2			1.6	0.2	0.06
3.3	0.0	0.0	0.1	0.0	0.3	0.1	0.1	0.1			0.4	0.0	0
dv	0.112	0.126	0.138	0.186	0.139	0.145	0.143	0.14			0.14	0.14	0.21
05%	13.5	14.4	11.1	14.0	8.3	10.5	11.1	9.16			8.27	22.5	24.8
50%	139.2	138.7	126.6	134.5	101.4	126.4	105.4	115			108	140	146
95%	275.9	275.6	275.4	275.4	268.5	275.8	265.5	272			270	275	278
mv	140.3	140.2	131.7	137.3	116.0	131.6	118.0	124			120	143	149

avg	max	min	std
88.3	100.0	65.4	14.4
68.3	83.0	47.5	11.8
51.0	65.4	34.5	9.2
38.4	51.0	25.6	7.3
28.9	40.6	17.1	6.1
21.6	31.9	11.2	5.1
15.9	24.4	6.9	4.3
11.8	18.5	4.3	3.6
8.7	13.8	2.7	2.9
5.6	9.2	1.3	2.1
3.4	5.9	0.6	1.5
2.0	4.1	0.2	1.0
0.8	2.5	0.1	0.6
0.2	1.2	0.0	0.3
0.136	0.207	0.094	0.023
13.4	29.7	7.9	5.2
150.3	221.0	101.4	34.8
371.3	547.4	265.5	120.3
164.8	238.0	116.0	42.5

UPPER FREEPORT SEAM 24-HOUR RUN DATA: MICROTRAC OF COLUMN FLOTATION FEED

Shift >	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17
Microns																	
296.0	100.0	100.0	99.9	99.6	99.2	100.0	99.7	100.0	100.0	100.0	99.0	99.9	100.0	100.0	100.0	100.0	100.0
209.3	99.4	99.2	99.3	98.3	97.3	99.1	97.8	99.3	99.8	99.6	96.0	99.0	99.3	99.4	99.4	98.6	96.1
148.0	97.9	95.9	97.3	95.9	94.0	97.4	95.0	97.9	98.6	98.7	91.6	96.4	97.1	96.9	97.0	95.5	91.1
104.7	95.1	89.1	93.1	92.5	89.0	94.3	91.6	95.3	95.5	96.8	86.5	91.5	92.4	91.0	92.7	90.7	85.3
74.0	88.0	76.7	84.4	85.8	79.5	87.5	84.9	89.3	88.4	91.4	78.1	82.4	83.2	79.7	84.5	81.4	76.3
52.3	76.7	60.9	72.1	74.7	65.9	76.9	74.4	79.4	77.2	82.0	66.5	69.5	70.9	64.1	72.4	68.9	64.5
37.0	63.3	45.5	58.8	61.6	51.2	64.0	61.8	66.4	63.9	69.6	53.9	55.4	57.4	48.3	59.2	55.6	51.8
26.2	51.3	33.9	46.7	49.6	38.7	51.7	49.8	53.6	51.4	57.0	42.6	43.5	45.6	35.9	47.5	43.7	40.7
18.5	41.2	25.7	36.5	39.2	29.2	40.7	39.4	42.8	40.5	45.5	32.9	33.9	35.9	27.0	37.5	33.9	31.6
13.1	31.1	18.5	26.9	29.0	20.7	29.7	29.3	32.1	30.0	33.9	23.6	24.7	26.5	19.2	27.7	24.6	22.8
9.3	22.9	13.0	19.3	21.0	14.2	20.8	21.1	23.3	21.4	24.4	16.2	17.3	18.8	13.2	19.8	17.3	15.8
6.5	16.9	9.3	14.0	15.3	9.8	14.6	15.2	17.0	15.2	17.4	11.2	12.2	13.4	9.3	14.2	12.3	11.0
4.6	11.4	6.0	9.2	10.0	6.1	9.2	9.8	11.3	9.8	11.1	7.0	7.7	8.7	5.8	9.1	7.7	6.9
3.3	7.2	3.6	5.7	6.1	3.5	5.3	5.9	7.1	5.9	6.6	3.9	4.5	5.2	3.3	5.4	4.5	4.0
dv	0.129	0.222	0.166	0.181	0.192	0.148	0.193	0.152	0.163	0.180	0.168	0.151	0.170	0.173	0.149	0.150	0.199
05%	2.5	4.1	3.0	2.8	4.1	3.1	2.9	2.5	2.9	2.7	3.8	3.6	3.2	4.3	3.1	3.5	3.8
50%	25.1	41.1	29.1	26.5	35.9	24.8	26.4	23.4	25.1	21.2	33.2	32.0	30.1	38.5	28.4	31.8	35.2
95%	103.9	138.5	119.9	133.4	163.8	110.7	148.5	102.1	100.9	89.7	194.2	130.4	121.9	128.7	122.4	140.8	194.6
mv	36.1	51.2	40.9	41.1	51.6	37.2	42.2	34.5	35.3	31.3	53.8	44.3	42.0	48.0	40.6	45.5	55.0

UPPER FREEPORT SEAM 24-HOUR RUN DATA: MICROTRAC OF COLUMN FLOTATION FEED

Shift >	18	19	20	21	22	23	24	25	26	27	28	29	30	avg	max	min	std
Microns																	
296.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100	99.9	100.0	99.0	0.2
209.3	98.0	99.0	97.4	98.6	98.6	97.9	98.6	98.1	99.3	97.7	97.9	98.1	96.4	98.4	99.8	96.0	1.0
148.0	95.3	96.8	93.7	96.0	95.9	94.8	95.8	95.3	97.0	93.7	94.1	93.6	90.1	95.5	98.7	90.1	2.1
104.7	91.7	93.2	89.1	91.3	91.8	90.3	91.6	91.1	93.0	87.9	88.0	86.2	83.1	91.0	96.8	83.1	3.1
74.0	84.7	85.8	81.4	82.3	83.9	82.3	83.2	83.3	85.2	78.0	77.5	74.8	73.6	82.6	91.4	73.6	4.3
52.3	74.1	74.2	70.1	69.5	72.2	71.0	70.8	72.1	73.3	64.8	63.7	60.6	61.7	70.5	82.0	60.6	5.4
37.0	61.3	60.6	57.1	55.2	58.5	58.0	57.3	59.3	59.2	51.2	49.5	46.8	49.6	57.0	69.6	45.5	5.8
26.2	49.3	48.3	45.5	43.0	46.2	46.1	45.4	47.5	46.8	39.6	38.1	36.2	39	45.1	57.0	33.9	5.5
18.5	39.0	38.2	35.5	33.2	35.9	35.9	35.6	37.5	36.5	30.4	29.2	28.1	30.3	35.3	45.5	25.7	4.8
13.1	29.0	28.3	25.8	24.1	26.0	26.1	26.2	27.7	26.6	21.9	20.8	20.5	22.2	25.8	33.9	18.5	3.8
9.3	20.8	20.3	18.2	16.8	18.1	18.2	18.6	19.8	18.7	15.1	14.2	14.4	15.8	18.3	24.4	13.0	3.0
6.5	15.1	14.8	12.8	11.8	12.7	12.8	13.2	14.1	13.3	10.5	9.9	10.3	11.4	13.0	17.4	9.3	2.3
4.6	9.9	9.7	8.1	7.4	8.0	8.1	8.3	9.1	8.5	6.5	6.0	6.5	7.31	8.3	11.4	5.8	1.6
3.3	6.0	6.0	4.8	4.2	4.6	4.7	4.8	5.4	5.1	3.7	3.4	3.8	4.38	4.9	7.2	3.3	1.1
dv	0.167	0.166	0.161	0.174	0.164	0.151	0.158	0.17	0.15	0.17	0.16	0.16	0.17	0.167	0.222	0.129	0.018
05%	2.8	2.9	3.4	3.7	3.5	3.4	3.4	3.07	3.25	3.99	4.19	3.97	3.6	3.4	4.3	2.5	0.5
50%	26.8	27.6	30.3	32.4	29.5	29.7	30.3	28.4	28.9	35.9	37.4	40.3	37.5	30.8	41.1	21.2	5.0
95%	142.0	121.4	167.0	134.7	134.2	152.0	136.0	143	121	165	160	162	194	139.2	194.6	89.7	26.8
mv	41.9	39.8	47.2	44.9	42.9	45.2	43.6	43.5	40.5	51.3	51.6	54.3	57.7	44.5	57.7	31.3	6.5

UPPER FREEPORT SEAM 24-HOUR DEMONSTRATION RUN RESULTS

*Upper Freeport Seam
Long Duration Tests*

Test Number	Goodness-of-Fit		
	Ash	Other	Total
93110801	0.72	2.38	3.10
93110802	18.46	14.92	33.38
93110803	1.30	3.00	4.30
93110804	1.18	2.01	3.19
93110805	2.41	8.49	10.90
93110806	3.12	5.70	8.82
93110807	1.71	4.34	6.05
93110808	2.73	1.54	4.27
93110809	1.73	1.70	3.43
93110810	2.53	11.45	13.98
93110811	2.83	2.22	5.05
93110812	2.41	2.57	4.98
93110813	3.78	6.10	9.88
93110814	3.13	4.84	7.97
93110815	1.10	1.61	2.71
93110816	2.69	1.88	4.57
93110817	1.30	2.76	4.06
93110818	3.67	2.17	5.84
93110819	4.80	2.98	7.78
93110820	11.64	7.16	18.80
93110821	3.94	3.49	7.43
93110822	9.57	6.35	15.92
93110823	4.66	4.36	9.02
93110824	4.97	4.78	9.75
93110825	5.36	3.83	9.19
93110826	18.48	11.34	29.82
93110827	4.09	8.85	12.94
93110828	2.37	3.34	5.71
93110830	3.34	6.18	9.52

Average	4.5	4.9	9.4

**Upper Freeport Seam
Long Duration Tests**

Test Number	Relative Plant Feed (%)	Relative Deslime U/F (%)	Relative HMC Reject (%)	Relative WOC O/F (%)	Relative WOC U/F (%)	Relative Column Feed (%)	Relative Column Product (%)	Relative Column Reject (%)	Rel. Thick Fe (%)
93110801	100.00	89.16	10.84	87.47	1.68	87.47	69.52	17.95	1
93110802	100.00	87.61	12.39	86.61	1.00	86.61	70.41	16.20	1
93110803	100.00	88.71	11.29	87.23	1.48	87.23	66.58	20.65	2
93110804	100.00	90.52	9.48	89.06	1.46	89.06	71.07	17.99	1
93110805	100.00	92.97	7.03	91.66	1.31	91.66	73.73	17.93	1
93110806	100.00	89.10	10.90	87.08	2.03	87.08	71.05	16.03	1
93110807	100.00	90.40	9.60	89.91	0.49	89.91	71.98	17.93	1
93110808	100.00	90.46	9.54	89.63	0.82	89.63	71.05	18.58	1
93110809	100.00	91.41	8.59	89.72	1.69	89.72	74.39	15.33	1
93110810	100.00	91.40	8.60	88.74	2.66	88.74	73.49	15.24	1
93110811	100.00	91.43	8.57	88.81	2.62	88.81	69.59	19.22	2
93110812	100.00	92.43	7.57	90.59	1.85	90.59	75.01	15.58	1
93110813	100.00	90.28	9.72	89.84	0.44	89.84	71.07	18.77	1
93110814	100.00	89.84	10.16	88.42	1.42	88.42	69.78	18.65	2
93110815	100.00	91.65	8.35	89.52	2.13	89.52	74.41	15.10	1
93110816	100.00	88.93	11.07	87.33	1.60	87.33	72.04	15.28	1
93110817	100.00	89.07	10.93	87.71	1.36	87.71	72.89	14.82	1
93110818	100.00	89.66	10.34	88.06	1.59	88.06	74.13	13.93	1
93110819	100.00	93.67	6.33	91.56	2.11	91.56	75.67	15.88	1
93110820	100.00	92.53	7.47	90.73	1.80	90.73	71.58	19.14	2
93110821	100.00	90.51	9.49	88.81	1.71	88.81	72.79	16.02	1
93110822	100.00	91.69	8.31	89.58	2.12	89.58	72.51	17.07	1
93110823	100.00	90.68	9.32	88.53	2.15	88.53	71.46	17.07	1
93110824	100.00	89.98	10.02	88.46	1.52	88.46	70.68	17.78	1
93110825	100.00	92.27	7.73	90.93	1.34	90.93	73.01	17.92	1
93110826	100.00	94.05	5.95	92.32	1.73	92.32	70.50	21.83	2
93110827	100.00	92.33	7.67	90.56	1.76	90.56	69.18	21.38	2
93110828	100.00	91.66	8.34	89.73	1.94	89.73	69.67	20.06	2
93110830	100.00	92.95	7.05	91.92	1.02	91.92	74.50	17.42	1

Average	100.0	90.9	9.1	89.3	1.6	89.3	71.9	17.5	1
Maximum	100.0	94.1	12.4	92.3	2.7	92.3	75.7	21.8	2
Minimum	100.0	87.6	6.0	86.6	0.4	86.6	66.6	13.9	1
Range	0.0	6.4	6.4	5.7	2.2	5.7	9.1	7.9	
Std.Deviation	0.0	1.6	1.6	1.5	0.5	1.5	2.1	2.0	
# of Points	29	29	29	29	29	29	29	29	

**Upper Freeport Seam
Long Duration Tests**

Test	Number	Measured	Adjusted	Plant	Feed	Ash	(%)	Plant	Feed	Ash	(%)	WOC	U/F	Ash	(%)	Adjusted
93110801	26.00	25.73	19.96	20.20	71.01	71.23	19.70	19.54	54.17	54.02						
93110802	23.92	25.37	19.09	19.33	69.59	68.07	17.55	18.94	54.21	53.85						
93110803	23.57	24.29	18.97	18.61	69.55	68.84	17.68	18.08	50.32	50.26						
93110804	23.20	23.44	18.45	19.15	64.57	64.39	19.03	18.64	50.61	50.45						
93110805	23.21	23.59	19.57	20.38	66.28	66.06	21.06	19.93	52.12	51.93						
93110806	24.23	24.19	20.38	19.37	63.54	63.57	18.11	18.48	57.51	57.42						
93110807	22.97	23.53	19.74	19.13	65.39	64.96	18.69	18.96	51.06	51.03						
93110808	24.05	23.69	19.08	19.17	66.21	66.47	18.90	18.86	53.38	53.25						
93110809	23.54	23.54	19.21	19.46	66.94	66.94	18.95	18.87	50.77	50.53						
93110810	23.52	23.59	20.42	19.43	67.80	67.75	18.06	18.44	52.64	52.55						
93110811	24.60	24.62	20.86	20.57	67.86	67.85	18.48	19.54	55.67	55.51						
93110812	23.48	23.34	19.43	19.59	69.06	69.15	18.99	18.90	54.01	53.70						
93110813	23.68	24.21	19.36	19.32	70.06	69.61	19.05	19.15	55.12	55.04						
93110814	25.18	25.42	20.06	20.53	68.89	68.71	19.24	19.99	54.23	54.05						
93110815	23.54	23.36	19.66	19.17	69.23	69.36	17.88	18.32	55.01	54.95						
93110816	24.92	24.49	18.82	18.93	68.81	69.17	17.80	18.27	55.07	54.81						
93110817	23.90	24.26	19.28	19.00	67.50	67.18	18.32	18.48	52.63	52.49						
93110818	23.63	23.36	18.43	18.27	67.27	67.50	16.96	17.64	53.10	52.83						
93110819	22.64	22.54	19.58	19.34	69.96	70.02	17.97	18.56	53.18	52.76						
93110820	23.34	23.19	19.18	19.57	67.98	68.07	18.66	18.95	51.27	50.70						
93110821	22.96	23.37	18.53	18.75	67.80	67.46	17.77	18.10	52.87	52.50						
93110822	23.51	23.46	19.58	19.55	66.51	66.55	17.64	18.78	52.75	52.25						
93110823	25.27	24.86	20.30	20.38	68.28	68.56	19.25	19.67	49.56	49.21						
93110824	24.69	24.84	19.67	20.05	68.00	67.88	19.31	19.48	53.33	52.97						
93110825	24.03	24.12	19.87	20.44	68.01	67.96	19.54	19.97	52.76	52.47						
93110826	25.02	24.36	20.70	21.51	69.17	69.47	19.75	20.97	50.41	49.94						
93110827	25.92	25.89	22.07	22.29	69.15	69.17	21.76	21.67	54.64	54.35						
93110828	26.11	26.30	23.07	22.46	68.66	68.55	21.26	21.78	54.04	53.90						
93110830	24.03	24.20	20.77	21.10	65.25	65.16	20.74	20.73	53.88	53.68						
Average	24.09	24.18	19.80	19.83	67.87	67.78	18.90	19.23	53.11	52.88						
Maximum	26.11	26.30	23.07	22.46	71.01	71.23	21.76	21.78	57.51	57.42						
Minimum	22.64	22.54	18.43	18.27	63.54	63.57	16.96	17.64	49.56	49.21						
Range	3.47	3.76	4.64	4.19	7.47	7.66	4.80	4.14	7.95	8.21						
Std.Deviation	0.93	0.89	1.01	1.01	1.72	1.72	1.16	1.02	1.80	1.85						
# of Points	29	29	29	29	29	29	29	29	29	29						

Upper Freeport Seam
Long Duration Tests

Test Number	Measured Column Feed Ash (%)	Adjusted Column Feed Ash (%)	Measured Column Product Ash (%)	Adjusted Column Product Ash (%)	Measured Column Reject Ash (%)	Adjusted Column Reject Ash (%)	Measured Thickeners Feed Ash (%)	Adjusted Thickeners Feed Ash (%)
93110801	19.71	19.54	10.16	10.21	56.95	55.71	53.95	53.95
93110802	21.99	18.94	10.99	10.89	59.90	53.90	49.98	49.98
93110803	18.07	18.08	7.66	7.60	53.64	51.88	51.02	51.02
93110804	18.99	18.64	9.60	9.57	55.55	54.47	53.34	53.34
93110805	19.90	19.93	11.75	11.72	55.03	53.66	52.35	52.35
93110806	17.86	18.48	10.34	10.28	57.43	54.82	52.99	52.99
93110807	18.87	18.96	10.09	10.06	56.83	54.67	52.89	52.89
93110808	18.89	18.86	9.23	9.27	58.84	55.54	52.40	52.40
93110809	19.01	18.87	10.95	10.94	60.07	57.35	54.24	54.24
93110810	17.94	18.44	10.50	10.45	59.22	56.95	54.36	54.36
93110811	20.27	19.54	10.11	10.05	55.94	53.88	52.50	52.50
93110812	18.78	18.39	10.95	10.92	60.64	57.28	54.06	54.06
93110813	18.98	19.15	9.18	9.08	62.03	57.24	54.35	54.35
93110814	21.23	19.99	10.07	10.01	59.59	57.35	55.55	55.55
93110815	18.18	18.32	10.34	10.31	59.37	57.77	55.97	55.97
93110816	18.71	18.27	10.52	10.53	57.64	54.76	52.11	52.11
93110817	18.48	18.48	10.58	10.56	59.69	57.42	55.05	55.05
93110818	18.13	17.64	10.54	10.54	58.79	55.41	52.16	52.16
93110819	18.93	18.56	11.17	11.17	58.01	53.80	50.12	50.12
93110820	19.81	18.95	10.12	10.17	58.84	51.80	46.59	46.59
93110821	18.96	18.10	9.95	9.95	58.61	55.14	51.86	51.86
93110822	20.28	18.78	10.41	10.42	59.38	54.29	49.94	49.94
93110823	19.92	19.67	10.85	10.84	61.29	56.67	52.15	52.15
93110824	20.18	19.48	10.37	10.38	60.23	55.70	51.81	51.81
93110825	21.04	19.97	10.52	10.49	63.21	58.60	54.66	54.66
93110826	23.24	20.97	10.40	10.41	63.54	55.08	49.14	49.14
93110827	21.58	21.67	10.19	10.16	63.75	58.90	54.96	54.96
93110828	21.72	21.78	10.30	10.27	65.06	61.76	58.47	58.47
93110830	21.01	20.73	11.32	11.28	65.56	61.16	57.42	57.42

Average	19.68	19.21	10.32	10.29	59.47	55.96	52.98	52.98
Maximum	23.24	21.78	11.75	11.72	65.56	61.76	58.47	58.47
Minimum	17.86	17.64	7.66	7.60	53.64	51.80	46.59	46.59
Range	5.38	4.14	4.09	4.12	11.92	9.96	11.88	11.88
Std.Deviation	1.36	1.03	0.74	0.75	2.85	2.31	2.46	2.46
# of Points	29	29	29	29	29	29	29	29

**Upper Freeport Seam
Long Duration Tests**

Test Number	Measured Plant Feed Sulfur (%)	Adjusted Plant Feed Sulfur (%)	Measured Deslime U/F Sulfur (%)	Adjusted Deslime U/F Sulfur (%)	Measured HMC Reject Sulfur (%)	Adjusted HMC Reject Sulfur (%)	Measured WOC O/F Sulfur (%)	Adjusted WOC O/F Sulfur (%)	Measured WOC U/F Sulfur (%)	Adjusted WOC U/F Sulfur (%)
93110801	4.34	4.30	2.50	2.64	17.90	17.97	2.28	2.35	17.95	18.05
93110802	4.52	4.96	3.32	2.90	20.70	19.56	2.74	2.74	16.50	16.36
93110803	4.79	4.71	2.91	2.69	20.42	20.59	2.65	2.45	16.66	16.58
93110804	4.46	4.32	2.71	2.74	19.11	19.36	2.69	2.54	15.37	15.47
93110805	4.45	4.33	2.80	3.00	21.72	21.92	3.48	2.79	17.57	17.69
93110806	4.93	4.96	3.25	2.91	21.83	21.76	2.68	2.57	17.73	17.49
93110807	4.44	4.57	2.95	2.67	22.79	22.46	2.71	2.58	18.21	18.16
93110808	4.67	4.75	2.91	2.94	22.04	21.88	2.68	2.78	20.75	20.73
93110809	4.36	4.33	2.75	2.83	20.19	20.25	2.71	2.56	17.09	17.02
93110810	4.41	4.35	3.11	2.81	20.68	20.79	2.47	2.39	17.27	16.72
93110811	5.06	5.03	3.43	3.51	21.12	21.17	3.14	2.98	21.68	21.75
93110812	4.02	4.17	3.19	2.99	18.90	18.65	2.69	2.68	18.22	18.14
93110813	4.38	4.19	3.00	2.76	17.25	17.53	2.73	2.68	19.09	19.08
93110814	4.67	4.53	3.06	3.03	17.56	17.76	2.71	2.79	17.96	18.00
93110815	4.38	4.44	3.24	3.06	19.71	19.61	2.70	2.71	17.82	17.65
93110816	4.68	4.77	2.90	2.88	20.12	19.94	2.65	2.60	18.12	18.14
93110817	4.53	4.51	2.90	2.86	17.98	18.01	2.61	2.61	18.86	18.81
93110818	4.45	4.56	2.87	2.89	19.25	19.04	2.66	2.61	18.60	18.41
93110819	4.03	4.07	3.05	3.10	18.54	18.48	2.77	2.75	18.56	18.42
93110820	4.21	4.33	3.09	3.11	19.67	19.47	2.84	2.80	18.85	18.80
93110821	4.80	4.47	2.84	2.97	18.28	18.74	2.66	2.65	19.50	19.70
93110822	4.36	4.38	3.03	3.10	18.60	18.57	2.53	2.70	19.82	19.88
93110823	4.41	4.46	3.02	3.02	18.55	18.47	2.84	2.67	17.71	17.61
93110824	4.86	4.57	2.84	2.92	18.96	19.40	2.80	2.69	16.26	16.43
93110825	3.87	3.86	3.03	2.91	15.13	15.15	2.69	2.73	14.92	14.88
93110826	3.96	3.90	2.94	3.06	17.21	17.27	2.74	2.81	16.44	16.36
93110827	4.00	4.16	3.08	3.14	16.67	16.46	2.97	2.84	18.77	18.74
93110828	4.36	4.20	3.11	3.12	15.92	16.10	2.85	2.77	19.26	19.26
93110830	3.79	3.63	2.96	2.81	14.40	14.56	2.91	2.68	14.49	14.50

Average	4.42	4.41	2.99	2.94	19.01	19.00	2.74	2.67	17.93	17.89
Maximum	5.06	5.03	3.43	3.51	22.79	22.46	3.48	2.98	21.68	21.75
Minimum	3.79	3.63	2.50	2.64	14.40	14.56	2.28	2.35	14.49	14.50
Range	1.27	1.40	0.93	0.87	8.39	7.90	1.20	0.63	7.19	7.25
Std.Deviation	0.31	0.32	0.19	0.17	2.01	1.94	0.21	0.13	1.58	1.60
# of Points	29	29	29	29	29	29	29	29	29	29

**Upper Freeport Seam
Long Duration Tests**

Test Number	Measured Column Feed Sulfur (%)	Adjusted Column Feed Sulfur (%)	Measured Column Product Sulfur (%)	Adjusted Column Product Sulfur (%)	Measured Column Reject Sulfur (%)	Adjusted Column Reject Sulfur (%)	Measured Thickener Feed Sulfur (%)	Adjusted Thickener Feed Sulfur (%)
93110801	2.40	2.35	2.25	2.15	3.07	3.10	4.55	
93110802	3.15	2.74	2.32	2.59	3.42	3.41	3.96	
93110803	2.43	2.45	1.76	1.89	4.24	4.27	4.82	
93110804	2.50	2.54	2.10	2.16	3.88	4.01	5.00	
93110805	1.69	1.75	2.28	2.39	4.15	4.40	5.62	
93110806	2.31	2.57	2.19	2.18	4.54	4.29	5.39	
93110807	2.44	2.58	2.07	2.14	4.54	4.39	4.52	
93110808	2.82	2.78	2.22	2.17	5.18	5.11	5.78	
93110809	2.48	2.56	2.26	2.25	4.11	4.09	5.36	
93110810	2.10	2.39	2.13	2.06	4.37	3.99	5.34	
93110811	3.13	2.98	2.37	2.49	4.57	4.74	6.91	
93110812	2.60	2.68	2.31	2.32	4.49	4.41	5.72	
93110813	2.65	2.68	2.03	2.16	4.67	4.65	4.78	
93110814	3.24	2.79	2.21	2.37	4.23	4.38	5.34	
93110815	2.64	2.71	2.28	2.29	4.90	4.76	6.10	
93110816	2.52	2.60	2.31	2.29	4.06	4.06	5.41	
93110817	2.56	2.61	2.26	2.25	4.40	4.35	5.48	
93110818	2.57	2.61	2.33	2.31	4.26	4.18	5.52	
93110819	2.79	2.75	2.42	2.43	4.30	4.27	5.87	
93110820	2.83	2.80	2.24	2.24	4.87	4.88	6.08	
93110821	2.68	2.65	2.23	2.24	4.43	4.55	6.25	
93110822	2.89	2.70	2.31	2.26	4.59	4.60	6.41	
93110823	2.54	2.67	2.37	2.36	3.98	3.95	5.41	
93110824	2.65	2.69	2.28	2.32	3.97	4.12	5.32	
93110825	2.79	2.73	2.36	2.43	4.03	3.99	4.63	
93110826	3.06	2.81	2.40	2.43	4.02	4.03	4.90	
93110827	3.44	2.84	2.28	2.48	3.77	3.98	5.17	
93110828	2.85	2.77	2.33	2.44	3.85	3.91	5.22	
93110830	2.51	2.68	2.37	2.50	3.41	3.42	3.96	

Average	2.66	2.64	2.25	2.30	4.22	4.22	5.34	5.34
Maximum	3.44	2.98	2.42	2.59	5.18	5.11	6.91	6.91
Minimum	1.69	1.75	1.76	1.89	3.07	3.10	3.96	3.96
Range	1.75	1.23	0.66	0.70	2.11	2.01	2.95	2.95
Std.Deviation	0.34	0.21	0.13	0.15	0.45	0.43	0.67	0.67
# of Points	29	29	29	29	29	29	29	29

**Upper Freeport Seam
Long Duration Tests**

Test Number	Measured Plant Feed Pyritic (%)	Adjusted Plant Feed Pyritic (%)	Measured Deslime U/F Pyritic (%)	Adjusted Deslime U/F Pyritic (%)	Measured HMC Reject Pyritic (%)	Adjusted HMC Reject Pyritic (%)	Measured WOC O/F Pyritic (%)	Adjusted WOC O/F Pyritic (%)	Measured WOC U/F Pyritic (%)	Adjusted WOC U/F Pyritic (%)
93110801	3.11	3.09	1.46	1.52	15.93	15.98	1.07	1.25	15.92	15.82
93110802	2.97	3.37	1.99	1.57	17.83	16.06	1.38	1.41	15.83	15.80
93110803	3.40	3.55	1.71	1.55	19.84	19.27	1.39	1.32	15.07	14.87
93110804	3.09	3.14	1.51	1.54	18.52	18.36	1.55	1.33	14.72	14.69
93110805	3.33	3.27	1.80	1.94	20.75	20.90	2.44	1.75	15.67	15.73
93110806	3.81	3.80	2.00	1.74	20.70	20.72	1.50	1.40	16.34	16.13
93110807	3.39	3.53	1.89	1.61	22.19	21.62	1.57	1.52	16.78	16.84
93110808	3.38	3.51	1.75	1.76	20.54	20.09	1.48	1.62	17.24	17.25
93110809	3.00	3.15	1.91	1.78	18.29	17.80	1.65	1.52	15.28	15.32
93110810	3.19	3.25	2.41	1.73	19.53	19.34	1.55	1.33	14.94	15.20
93110811	3.64	3.68	2.21	2.18	19.87	19.76	1.84	1.69	18.94	18.54
93110812	3.06	3.13	2.13	1.94	17.83	17.66	1.70	1.64	16.28	16.32
93110813	3.22	3.04	1.92	1.58	16.17	16.60	1.69	1.51	16.00	15.98
93110814	3.35	3.38	1.90	1.84	17.00	16.93	1.59	1.62	15.65	15.72
93110815	3.28	3.32	1.94	1.91	18.83	18.73	1.73	1.57	16.37	16.20
93110816	3.52	3.73	1.83	1.84	19.71	18.97	1.68	1.57	16.78	16.60
93110817	2.96	3.34	1.86	1.84	17.30	15.88	1.75	1.59	16.11	15.88
93110818	3.37	3.39	1.87	1.78	17.47	17.40	1.46	1.53	15.52	15.77
93110819	2.93	2.95	1.99	2.01	16.88	16.85	1.71	1.70	15.24	15.40
93110820	3.01	2.84	1.79	1.82	15.10	15.43	1.60	1.57	14.27	14.47
93110821	3.06	3.22	1.83	1.85	16.67	16.23	1.66	1.59	16.01	15.52
93110822	3.32	3.32	1.99	2.01	17.80	17.80	1.60	1.68	16.44	16.08
93110823	3.04	3.26	1.95	1.89	17.21	16.55	1.86	1.60	14.28	13.93
93110824	3.00	3.27	1.64	1.71	18.20	17.22	1.62	1.48	15.57	15.16
93110825	2.70	2.66	1.81	1.70	13.93	14.02	1.49	1.52	14.17	14.20
93110826	2.15	2.52	1.68	1.76	15.74	14.56	1.54	1.55	12.75	12.73
93110827	2.62	2.77	2.02	1.86	14.06	13.73	1.72	1.60	15.28	15.22
93110828	2.77	2.91	1.95	1.89	14.39	14.08	1.67	1.59	16.43	15.89
93110830	2.19	2.31	1.73	1.57	12.33	12.07	1.67	1.44	12.74	12.58

Average	3.10	3.20	1.88	1.78	17.61	17.26	1.63	1.53	15.61	15.51
Maximum	3.81	3.80	2.41	2.18	22.19	21.62	2.44	1.75	18.94	18.54
Minimum	2.15	2.31	1.46	1.52	12.33	12.07	1.07	1.25	12.74	12.58
Range	1.66	1.49	0.95	0.66	9.86	9.55	1.37	0.50	6.20	5.96
Std.Deviation	0.36	0.34	0.19	0.16	2.29	2.29	0.22	0.12	1.23	1.19
# of Points	29	29	29	29	29	29	29	29	29	29

**Upper Freeport Seam
Long Duration Tests**

Test Number	Measured Column Feed Pyritic (%)	Adjusted Column Feed Pyritic (%)	Measured Column Product Pyritic (%)	Adjusted Column Product Pyritic (%)	Measured Column Reject Pyritic (%)	Adjusted Column Reject Pyritic (%)	Measured Thickener Feed Pyritic (%)	Adjusted Thickener Feed Pyritic (%)
93110801	1.46	1.25	1.03	0.96	2.45	2.36	3.53	
93110802	1.94	1.41	0.96	1.11	2.56	2.71	3.30	
93110803	1.39	1.32	0.61	0.64	3.46	3.51	3.91	
93110804	1.43	1.33	0.79	0.85	2.97	3.21	4.10	
93110805	1.69	1.75	1.22	1.29	3.36	3.61	4.70	
93110806	1.20	1.40	0.95	0.93	3.85	3.50	4.50	
93110807	1.43	1.52	0.95	0.98	3.67	3.70	3.96	
93110808	1.66	1.62	1.02	0.97	4.25	4.09	4.74	
93110809	1.43	1.52	1.15	1.17	3.21	3.23	4.39	
93110810	1.01	1.33	1.04	0.94	3.61	3.20	4.68	
93110811	1.88	1.69	1.04	1.12	3.59	3.75	5.25	
93110812	1.59	1.64	1.17	1.21	3.74	3.75	4.96	
93110813	1.56	1.51	0.71	0.78	4.05	4.28	4.11	
93110814	2.00	1.62	0.93	1.00	3.67	3.96	4.81	
93110815	1.43	1.57	1.09	1.08	4.16	4.03	5.37	
93110816	1.51	1.57	1.14	1.14	3.64	3.59	4.75	
93110817	1.69	1.59	1.15	1.22	3.30	3.36	4.29	
93110818	1.47	1.53	1.17	1.13	3.63	3.63	5.02	
93110819	1.72	1.70	1.24	1.25	3.75	3.85	5.41	
93110820	1.36	1.57	1.01	0.94	4.11	3.93	5.07	
93110821	1.69	1.59	1.02	1.05	4.16	4.03	4.78	
93110822	1.92	1.68	1.12	1.15	3.95	3.89	4.96	
93110823	1.55	1.60	1.14	1.19	3.38	3.34	4.27	
93110824	1.51	1.48	1.02	1.03	3.34	3.27	4.04	
93110825	1.64	1.52	1.05	1.11	3.12	3.20	3.87	
93110826	2.03	1.55	1.02	1.03	3.03	3.26	4.43	
93110827	1.64	1.60	1.02	1.08	3.19	3.29	4.06	
93110828	1.71	1.59	1.08	1.14	3.21	3.15	3.93	
93110830	1.40	1.44	1.08	1.16	2.69	2.65	2.98	

Average	1.58	1.53	1.03	1.06	3.49	3.49	4.42	
Maximum	2.03	1.75	1.24	1.29	4.25	4.28	5.41	
Minimum	1.01	1.25	0.61	0.64	2.45	2.36	2.98	
Range	1.02	0.50	0.63	0.65	1.80	1.92	2.43	
Std.Deviation	0.23	0.12	0.14	0.14	0.47	0.44	0.59	
# of Points	29	29	29	29	29	29	29	

**Upper Freeport Seam
Long Duration Tests**

Test Number	Measured Plant Feed Btu/lb	Adjusted Plant Feed Btu/lb	Measured Deslime U/F Btu/lb	Adjusted Deslime U/F Btu/lb	Measured HMC Reject Btu/lb	Adjusted HMC Reject Btu/lb	Measured WOC O/F Btu/lb	Adjusted WOC O/F Btu/lb	Measured WOC U/F Btu/lb	Adjusted WOC U/F Btu/lb
93110801	10790	10750	11850	11760	2470	2470	11830	11870	6040	6060
93110802	11020	10740	11990	11840	2930	2930	12210	11910	5730	5780
93110803	11190	10920	11980	11960	2730	2730	12080	12060	6510	6530
93110804	11090	11120	12150	11890	3840	3840	11990	11980	6410	6430
93110805	11230	11060	11590	11630	3480	3480	11500	11710	6250	6270
93110806	10920	11060	11720	11830	4780	4770	12020	11980	5210	5240
93110807	11240	11150	11740	11920	3910	3920	12030	11950	6360	6380
93110808	11250	11210	12020	11980	3900	3900	12030	12040	6150	6170
93110809	11210	11190	12040	11910	3420	3430	11980	12020	6370	6420
93110810	11240	11200	11620	11930	3440	3450	12090	12100	6240	6300
93110811	11090	11050	11730	11770	3380	3380	12110	11950	5700	5730
93110812	11210	11210	11970	11880	3000	3000	12030	12000	5780	5840
93110813	11200	11120	11890	11980	3110	3110	12030	12010	5510	5530
93110814	11110	10930	11920	11800	3200	3200	11850	11900	5660	5680
93110815	11230	11250	11930	11980	3210	3210	12200	12120	6090	6130
93110816	10900	10980	11910	11970	3080	3080	12100	12080	6030	6070
93110817	11170	11050	11970	12000	3350	3360	12100	12090	6160	6210
93110818	11080	11100	11840	12000	3320	3320	12270	12110	5820	5870
93110819	11150	11300	11870	11860	3060	3060	12200	11990	6000	6080
93110820	11260	11200	11990	11850	3210	3210	11950	11950	6440	6540
93110821	11270	11240	12080	12020	3780	3780	12190	12130	6110	6180
93110822	11190	11180	11820	11860	3650	3650	12200	12000	6010	6110
93110823	10820	10900	11750	11670	3330	3330	11770	11790	6660	6760
93110824	11050	10930	11840	11790	3260	3260	11910	11880	6010	6080
93110825	11110	11040	11860	11710	3050	3050	11790	11790	6190	6250
93110826	10950	11000	11760	11510	3010	3010	11870	11600	6570	6680
93110827	10840	10750	11450	11390	3050	3050	11430	11490	6020	6090
93110828	10900	10700	11350	11400	2960	2960	11540	11520	5970	6040
93110830	11050	11070	11580	11630	3620	3620	11780	11690	6020	6070

Average	11,095	11,048	11,835	11,818	3,329	3,330	11,968	11,921	6,070	6,121
Maximum	11,270	11,300	12,150	12,020	4,780	4,770	12,270	12,130	6,660	6,760
Minimum	10,790	10,700	11,350	11,390	2,470	2,470	11,430	11,490	5,210	5,240
Range	480	600	800	630	2,310	2,300	840	640	1,450	1,520
Std.Deviation	143	163	183	170	434	433	212	173	320	330
# of Points	29	29	29	29	29	29	29	29	29	29

Upper Freeport Seam
Long Duration Tests

Test Number	Measured Column Feed Btu/lb	Adjusted Column Feed Btu/lb	Measured Column Product Btu/lb	Adjusted Column Product Btu/lb	Measured Column Reject Btu/lb	Adjusted Column Reject Btu/lb	Measured Thickeners Feed Btu/lb	Adjusted Thickeners Feed Btu/lb
93110801	11900	11870	13320	13440	5640	5780	5970	
93110802	11440	11910	13200	13390	4910	5480	6570	
93110803	11940	12060	13620	13820	6190	6360	6560	
93110804	11950	11980	13350	13550	5590	5760	6010	
93110805	11650	11710	13230	13080	5870	6080	6380	
93110806	12140	11980	13460	13400	5410	5670	5990	
93110807	11980	11950	13480	13510	5280	5690	6300	
93110808	11950	12040	13630	13610	5680	6020	6490	
93110809	11850	12020	13380	13330	5390	5670	6140	
93110810	12350	12100	13480	13430	5370	5640	6150	
93110811	11830	11950	13490	13540	5950	6210	6500	
93110812	11870	12000	13390	13360	5090	5460	6090	
93110813	12070	12010	13670	13750	4920	5420	6260	
93110814	11710	11900	13520	13590	5260	5560	5980	
93110815	12160	12120	13450	13500	5150	5350	5730	
93110816	12070	12080	13490	13360	5620	6020	6650	
93110817	12050	12090	13350	13420	5150	5540	6220	
93110818	12020	12110	13440	13300	5400	5810	6490	
93110819	11920	11990	13320	13290	5290	5790	6740	
93110820	11920	11950	13400	13560	5230	5920	7540	
93110821	12030	12130	13460	13520	5340	5800	6590	
93110822	11800	12000	13500	13470	5160	5760	7080	
93110823	11750	11790	13390	13310	4960	5430	6480	
93110824	11750	11880	13390	13470	5060	5580	6560	
93110825	11650	11790	13360	13440	4610	5080	6010	
93110826	11320	11600	13370	13540	4660	5330	7070	
93110827	11520	11490	13350	13490	4530	5030	6060	
93110828	11440	11520	13410	13500	4280	4650	5410	
93110830	11680	11690	13240	13250	4540	5020	5940	

Average	11,852	11,921	13,419	13,456	5,225	5,618	6,343	5,160
Maximum	12,350	12,130	13,670	13,820	6,190	6,360	7,540	6,590
Minimum	11,320	11,490	13,200	13,080	4,280	4,650	5,410	4,280
Range	1,030	640	470	740	1,910	1,710	2,130	1,650
Std.Deviation	232	173	109	145	437	368	428	330
# of Points	29	29	29	29	29	29	29	29

**Upper Freeport Seam
Long Duration Tests**

Test Number	Plant Product Yield (%)	Plant Reject Yield (%)	Plant Energy Recovery (%)	Plant Ash Rejection (%)	Plant Sulfur Rejection (%)	Plant Pyritic Rejection (%)	Plant Separation Efficiency (%)
93110801	69.52	30.48	86.92	72.70	65.24	78.40	65.32
93110802	70.41	29.59	87.78	67.94	63.23	76.81	64.59
93110803	66.58	33.42	84.26	78.53	73.28	88.00	72.26
93110804	71.07	28.93	86.60	70.68	64.47	80.76	67.36
93110805	73.73	26.27	87.20	62.77	59.30	70.91	58.11
93110806	71.05	28.95	86.08	69.86	68.77	82.61	68.69
93110807	71.98	28.02	87.22	68.48	66.29	80.02	67.23
93110808	71.05	28.95	86.26	72.61	67.54	80.37	66.63
93110809	74.39	25.61	88.62	65.43	61.34	72.37	60.99
93110810	73.49	26.51	88.12	67.35	65.20	78.74	66.87
93110811	69.59	30.41	85.27	71.57	65.55	78.82	64.09
93110812	75.01	24.99	89.40	65.11	58.27	71.00	60.40
93110813	71.07	28.93	87.88	72.75	63.36	81.76	69.64
93110814	69.78	30.22	86.76	72.26	63.49	79.36	66.12
93110815	74.41	25.59	89.29	67.41	61.62	75.79	65.09
93110816	72.04	27.96	87.66	69.56	65.41	77.98	65.64
93110817	72.89	27.11	88.52	67.79	63.64	73.38	61.90
93110818	74.13	25.87	88.82	66.93	62.45	75.29	64.11
93110819	75.67	24.33	89.00	62.67	54.82	67.94	56.93
93110820	71.58	28.42	86.66	68.81	62.97	76.31	62.97
93110821	72.79	27.21	87.56	68.46	63.52	76.26	63.82
93110822	72.51	27.49	87.36	67.86	62.59	74.88	62.25
93110823	71.46	28.54	87.26	69.35	62.19	73.91	61.17
93110824	70.68	29.32	87.11	70.29	64.12	77.74	64.84
93110825	73.01	26.99	88.88	68.13	54.04	69.53	58.42
93110826	70.50	29.50	86.78	70.67	56.07	71.18	57.96
93110827	69.18	30.82	86.81	72.88	58.76	73.03	59.84
93110828	69.67	30.33	87.90	72.60	59.53	72.71	60.61
93110830	74.50	25.50	89.17	65.03	48.69	62.59	51.76

Average	71.9	28.1	87.5	69.2	62.3	75.8	63.3
Maximum	75.7	33.4	89.4	78.5	73.3	88.0	72.3
Minimum	66.6	24.3	84.3	62.7	48.7	62.6	51.8
Range	9.1	9.1	5.1	15.9	24.6	25.4	20.5
Std.Deviation	2.1	2.1	1.2	3.3	4.7	5.0	4.3
# of Points	29	29	29	29	29	29	29

**Upper Freeport Seam
Long Duration Tests**

Test Number	HMC Product Yield (%)	HMC Reject Yield (%)	HMC Energy Recovery (%)	HMC Ash Rejection (%)	HMC Sulfur Rejection (%)	HMC Pyritic Rejection (%)	HMC Separ. Efficiency (%)
93110801	89.16	10.84	97.54	2.49	45.30	56.06	4.1
93110802	87.61	12.39	96.58	3.38	48.86	59.05	4.1
93110803	88.71	11.29	97.16	2.82	49.35	61.28	4.1
93110804	90.52	9.48	96.79	3.27	42.48	55.43	4.1
93110805	92.97	7.03	97.76	2.21	35.59	44.93	4.1
93110806	89.10	10.90	95.30	4.70	47.82	59.43	4.1
93110807	90.40	9.60	96.64	3.38	47.18	58.80	4.1
93110808	90.46	9.54	96.67	3.32	43.94	54.60	4.1
93110809	91.41	8.59	97.29	2.63	40.17	48.54	4.1
93110810	91.40	8.60	97.36	2.65	41.10	51.18	4.1
93110811	91.43	8.57	97.39	2.62	36.07	46.02	4.1
93110812	92.43	7.57	97.95	2.03	33.86	42.71	4.1
93110813	90.28	9.72	97.26	2.72	40.67	53.08	4.1
93110814	89.84	10.16	96.99	2.97	39.83	50.89	4.1
93110815	91.65	8.35	97.60	2.38	36.88	47.11	4.1
93110816	88.93	11.07	96.95	3.11	46.28	56.30	4.1
93110817	89.07	10.93	96.73	3.32	43.65	51.97	4.1
93110818	89.66	10.34	96.93	3.09	43.17	53.07	4.1
93110819	93.67	6.33	98.31	1.71	28.74	36.16	3.1
93110820	92.53	7.47	97.90	2.14	33.59	40.59	3.1
93110821	90.51	9.49	96.79	3.19	39.79	47.83	4.1
93110822	91.69	8.31	97.27	2.71	35.23	44.55	4.1
93110823	90.68	9.32	97.09	2.85	38.60	47.31	4.1
93110824	89.98	10.02	97.06	2.99	42.54	52.77	4.1
93110825	92.27	7.73	97.87	2.14	30.34	40.74	3.1
93110826	94.05	5.95	98.41	1.63	26.35	34.38	3.1
93110827	92.33	7.67	97.83	2.18	30.35	38.02	3.1
93110828	91.66	8.34	97.66	2.31	31.97	40.35	3.1
93110830	92.95	7.05	97.65	2.31	28.28	36.84	3.1

Average	90.9	9.1	97.3	2.7	38.9	48.6	4.1
Maximum	94.1	12.4	98.4	4.7	49.4	61.3	5.1
Minimum	87.6	6.0	95.3	1.6	26.3	34.4	3.1
Range	6.4	6.4	3.1	3.1	23.0	26.9	2.1
Std.Deviation	1.6	1.6	0.6	0.6	6.5	7.5	
# of Points	29	29	29	29	29	29	

**Upper Freeport Seam
Long Duration Tests**

Test	WOC Product Yield (%)	WOC Reject Yield (%)	WOC Energy Recovery (%)	WOC Ash Rejection (%)	WOC Sulfur Rejection (%)	WOC Pyritic Rejection (%)	WOC Separation Efficiency (%)
93110801	98.10	1.90	99.02	5.04	12.88	19.61	18.63
93110802	98.86	1.14	99.44	3.18	6.44	11.49	10.93
93110803	98.33	1.67	99.15	4.51	10.28	16.01	15.16
93110804	98.39	1.61	99.13	4.25	9.11	15.39	14.52
93110805	98.59	1.41	99.27	3.59	8.31	11.42	10.69
93110806	97.73	2.27	98.97	6.75	13.69	21.12	20.09
93110807	99.46	0.54	99.71	1.45	3.69	5.67	5.38
93110808	99.08	0.92	99.58	2.52	6.39	8.88	8.46
93110809	98.15	1.85	99.06	4.80	11.12	15.91	14.97
93110810	97.09	2.91	98.47	7.87	17.32	25.57	24.04
93110811	97.13	2.87	98.62	7.73	17.76	24.37	22.99
93110812	98.01	1.99	99.00	5.49	12.14	16.84	15.84
93110813	99.51	0.49	99.76	1.39	3.37	4.93	4.69
93110814	98.42	1.58	99.25	4.16	9.39	13.50	12.76
93110815	97.68	2.32	98.82	6.66	13.41	19.71	18.53
93110816	98.20	1.80	99.10	5.21	11.33	16.23	15.33
93110817	98.47	1.53	99.21	4.22	10.04	13.18	12.39
93110818	98.22	1.78	99.12	5.13	11.30	15.71	14.83
93110819	97.75	2.25	98.82	6.15	13.38	17.26	16.08
93110820	98.05	1.95	98.88	5.04	11.76	15.47	14.35
93110821	98.12	1.88	99.02	5.29	12.53	15.85	14.87
93110822	97.70	2.30	98.85	6.18	14.83	18.50	17.35
93110823	97.63	2.37	98.63	5.73	13.83	17.47	16.11
93110824	98.31	1.69	99.06	4.46	9.51	14.98	14.04
93110825	98.55	1.45	99.22	3.73	7.43	12.13	11.35
93110826	98.16	1.84	98.93	4.27	9.83	13.30	12.23
93110827	98.08	1.92	98.94	4.65	11.38	15.60	14.54
93110828	97.89	2.11	98.92	5.08	13.07	17.79	16.72
93110830	98.89	1.11	99.40	2.79	5.66	8.79	8.19
Average	98.2	1.8	99.1	4.7	10.7	15.3	14.3
Maximum	99.5	2.9	99.8	7.9	17.8	25.6	24.0
Minimum	97.1	0.5	98.5	1.4	3.4	4.9	4.7
Range	2.4	2.4	1.3	6.5	14.4	20.6	19.4
Std.Deviation	0.6	0.6	0.3	1.6	3.5	4.6	4.4
# of Points	29	29	29	29	29	29	29

**Upper Freeport Seam
Long Duration Tests**

Test Number	Column Product Yield (%)	Column Reject Yield (%)	Column Energy Recovery (%)	Column Ash Rejection (%)	Column Sulfur Rejection (%)	Column Pyritic Rejection (%)	Column Separation Efficiency (%)
93110801	79.48	20.52	89.99	58.51	27.07	38.74	2
93110802	81.30	18.70	91.40	53.23	23.28	35.95	2
93110803	76.33	23.67	87.47	67.93	41.26	62.95	5
93110804	79.80	20.20	90.26	59.03	31.89	48.75	3
93110805	80.44	19.56	89.85	52.67	49.18	40.35	3
93110806	81.59	18.41	91.26	54.61	30.73	46.02	3
93110807	80.06	19.94	90.51	57.50	33.93	48.54	3
93110808	79.27	20.73	89.61	61.05	38.10	52.34	4
93110809	82.91	17.09	91.95	51.93	27.30	36.31	2
93110810	82.81	17.19	91.92	53.04	28.67	41.32	3
93110811	78.36	21.64	88.78	59.68	34.42	48.02	3
93110812	82.80	17.20	92.19	53.57	28.30	39.33	3
93110813	79.11	20.89	90.57	62.45	36.25	59.22	4
93110814	78.92	21.08	90.13	60.51	33.11	51.56	4
93110815	83.12	16.88	92.59	53.19	29.63	43.30	3
93110816	82.49	17.51	91.23	52.44	27.32	40.01	3
93110817	83.10	16.90	92.25	52.50	28.16	35.71	2
93110818	84.18	15.82	92.45	49.69	25.33	37.53	2
93110819	82.65	17.35	91.61	50.27	26.93	39.28	3
93110820	78.89	21.11	89.52	57.66	36.77	52.81	4
93110821	81.96	18.04	91.35	54.95	30.97	45.72	3
93110822	80.94	19.06	90.86	55.09	32.47	44.12	3
93110823	80.72	19.28	91.12	55.55	28.53	40.25	3
93110824	79.90	20.10	90.59	57.47	30.78	44.41	3
93110825	80.29	19.71	91.53	57.83	28.80	41.49	3
93110826	76.36	23.64	89.14	62.11	33.91	49.73	3
93110827	76.39	23.61	89.69	64.17	33.09	48.55	3
93110828	77.64	22.36	90.99	63.39	31.56	44.29	3
93110830	81.05	18.95	91.86	55.91	24.18	34.88	2

Average	80.4	19.6	90.8	56.8	31.4	44.5	3
Maximum	84.2	23.7	92.6	67.9	49.2	62.9	5
Minimum	76.3	15.8	87.5	49.7	23.3	34.9	2
Range	7.9	7.9	5.1	18.2	25.9	28.1	2
Std.Deviation	2.1	2.1	1.2	4.4	5.3	6.8	1
# of Points	29	29	29	29	29	29	

**Upper Freeport Seam
Long Duration Tests**

Test Number	% (abs.) of Raw Coal's Energy to:			% (abs.) of Raw Coal's Pyrite to:		
	HMC Reject	WOC Reject	Column Reject	HMC Reject	WOC Reject	Column Reject
93110801	2.5	0.9	9.7	56.1	8.5	13.8
93110802	3.4	0.5	8.3	59.2	4.6	13.0
93110803	2.8	0.9	12.0	61.3	6.3	20.4
93110804	3.2	0.8	9.3	55.6	6.7	18.5
93110805	2.2	0.7	9.8	44.8	6.1	20.0
93110806	4.7	1.0	8.3	59.2	8.7	14.7
93110807	3.4	0.3	9.1	58.8	2.5	18.7
93110808	3.3	0.5	10.0	54.6	4.0	21.7
93110809	2.7	1.0	7.7	48.3	8.4	15.7
93110810	2.6	1.5	7.7	51.3	12.3	15.1
93110811	2.6	1.4	10.8	45.8	13.4	19.6
93110812	2.0	1.0	7.6	42.7	9.8	18.5
93110813	2.7	0.2	9.2	53.1	2.3	26.4
93110814	3.0	0.7	9.5	51.1	6.5	21.7
93110815	2.4	1.2	7.1	47.3	10.4	18.1
93110816	3.1	0.9	8.4	56.1	7.1	14.7
93110817	3.3	0.8	7.4	50.9	7.3	15.1
93110818	3.1	0.8	7.3	52.9	7.3	15.0
93110819	1.7	1.1	8.2	36.2	11.1	20.7
93110820	2.1	1.1	10.2	40.7	9.1	26.5
93110821	3.2	0.9	8.3	48.0	8.1	20.1
93110822	2.7	1.2	8.7	44.5	10.2	20.2
93110823	2.9	1.3	8.5	47.4	9.1	17.4
93110824	2.9	0.8	9.1	52.9	7.0	17.8
93110825	2.1	0.8	8.2	41.0	7.0	21.5
93110826	1.6	1.1	10.6	34.3	8.9	28.0
93110827	2.2	1.0	10.0	38.0	9.7	25.3
93110828	2.3	1.1	8.7	40.5	10.5	21.7
93110830	2.3	0.6	7.9	36.8	5.9	19.9

Average	2.7	0.9	8.9	48.6	7.9	19.3
Maximum	4.7	1.5	12.0	61.3	13.4	28.0
Minimum	1.6	0.2	7.1	34.3	2.3	13.0
Range	3.1	1.3	4.9	27.0	11.1	14.9
Std.Deviation	0.6	0.3	1.1	7.5	2.6	3.8
# of Points	29	29	29	29	29	29

**Upper Freeport Seam
Long Duration Tests**

Test Number	% of Total Energy Losses			% of Total Pyrite Rejection		
	HMC Reject	WOC Reject	Column Reject	HMC Reject	WOC Reject	Colt Rej
93110801	18.8	7.2	73.9	71.6	10.8	
93110802	28.0	4.4	67.6	77.1	6.0	
93110803	18.1	5.6	76.3	69.6	7.2	
93110804	24.0	6.3	69.7	68.9	8.3	
93110805	17.5	5.8	76.7	63.2	8.6	
93110806	33.7	6.9	59.3	71.7	10.6	
93110807	26.3	2.2	71.5	73.4	3.1	
93110808	24.2	3.3	72.5	68.0	5.0	
93110809	23.8	8.5	67.7	66.8	11.6	
93110810	22.2	12.6	65.2	65.2	15.7	
93110811	17.7	9.2	73.0	58.2	17.0	
93110812	19.3	9.1	71.6	60.2	13.8	
93110813	22.6	1.8	75.6	64.9	2.8	
93110814	22.7	5.6	71.7	64.4	8.2	
93110815	22.4	10.8	66.7	62.4	13.7	
93110816	24.7	7.2	68.1	72.0	9.1	
93110817	28.5	6.7	64.8	69.4	10.0	
93110818	27.5	7.5	65.0	70.3	9.7	
93110819	15.3	10.3	74.3	53.3	16.3	
93110820	15.7	7.9	76.4	53.3	12.0	
93110821	25.8	7.6	66.7	62.9	10.7	
93110822	21.6	9.2	69.2	59.4	13.6	
93110823	22.9	10.5	66.7	64.2	12.3	
93110824	22.8	6.6	70.6	68.1	9.0	
93110825	19.2	6.8	74.0	59.0	10.1	
93110826	12.0	7.9	80.0	48.2	12.5	
93110827	16.5	7.6	76.0	52.0	13.3	
93110828	19.4	9.1	71.6	55.7	14.4	
93110830	21.7	5.2	73.2	58.8	9.4	

Average	21.9	7.2	70.9	63.9	10.5	2
Maximum	33.7	12.6	80.0	77.1	17.0	3
Minimum	12.0	1.8	59.3	48.2	2.8	1
Range	21.7	10.8	20.7	28.9	14.2	2
Std.Deviation	4.5	2.4	4.5	7.0	3.5	
# of Points	29	29	29	29	29	

ILLINOIS NO. 6 SEAM WASHABILITY

ILLINOIS NO. 6 SEAM WASHABILITY GRAPH

% ASH

CUMULATIVE RECOVERY CUMULATIVE ASH

ILLINOIS NO. 6 SEAM WASHABILITY GRAPH % TOTAL SULFUR

CUMULATIVE RECOVERY CUMULATIVE TOTAL SULFUR

ILLINOIS NO. 6 SEAM WASHABILITY GRAPH % PYRITIC SULFUR

CUMULATIVE RECOVERY CUMULATIVE PYRITIC SULFUR

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ICF-KAISER ENGINEERS

WASHABILITY TEST
LAB NO. 31220927
JANUARY 20, 1994

47 Eleventh Avenue, South Charleston, WV 25303
Telephone: (304) 744-5472 • Fax# (304) 744-4319

TABLE OF CONTENTS

PAGE

		DESCRIPTION OF TEST	1
LAB NO. 31220927	ILLINOIS NO. 6	SIZE CONSIST	2
	RUN # 94010401	CALCULATED COMPOSITE	3
		WASHABILITY TABLES	4-7

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DESCRIPTION OF TEST

THE FOLLOWING TEST PROGRAM WAS PERFORMED FOR ICF-KAISER ENGINEERS IN ACCORDANCE WITH THE WRITTEN INSTRUCTIONS ENCLOSED WITH THE SAMPLE. THE RAW COAL SAMPLE DESCRIBED IN THIS REPORT (LAB NO. 31220927) WAS PICKED UP BY STANDARD LABORATORIES, INC. ON DECEMBER 20, 1993.

TESTS PERFORMED ON THE SAMPLE WERE AS FOLLOWS:

1. THE SAMPLE WAS SCREENED AT SIZES OF +1/4" RD, 1/4" RD X 48 MESH, 48 MESH X 200 MESH AND 200 MESH X 0 AND PERCENT WEIGHT WAS DETERMINED.
2. EACH SIZE FRACTION FROM ITEM #1 WAS FLOATED IN ORGANIC LIQUIDS AT SPECIFIC GRAVITIES OF 1.25, 1.30, 1.40, 1.50, 1.80 AND 2.20. PERCENT RECOVERY WAS DETERMINED AND EACH FLOAT AND THE 2.20 SINK FRACTION WAS ANALYZED FOR BTU PER POUND, PERCENT ASH, SULFUR AND PYRITIC SULFUR.
3. A CALCULATED COMPOSITE OF THE +1/4" RD X 200 MESH MATERIAL WAS PREPARED AND IS INCLUDED IN THIS REPORT. THE 200 MESH X 0 MATERIAL WAS NOT INCLUDED IN THIS CALCULATED COMPOSITE, DUE TO LACK OF MATERIAL RECOVERY ON NUMEROUS GRAVITIES.

RESPECTFULLY SUBMITTED,

SHARON BLANKENSHIP
ASSISTANT MANAGER

147 Eleventh Avenue, South Charleston, WV 25303
Telephone: (304) 744-5472 • Fax# (304) 744-4319

FOR: ICF-KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OHIO 45715

LAB NO: 31220927

SAMPLE ID: ILLINOIS NO. 6 SEAM
AS RECEIVED RAW COAL
RUN # 94010401
SAMPLE WEIGHT: 684.3 LBS

SAMPLED BY: ICF-KE

SIZE CONSIST

<u>SIZE</u>	<u>ELEMENTARY</u> <u>% WEIGHT</u>	<u>CUMULATIVE</u> <u>% WEIGHT</u>
+ 1/4" RD	61.65	61.65
1/4" RD X 48 MESH	23.78	85.43
48 MESH X 200 MESH	4.50	89.93
200 MESH X 0	10.07	100.00

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BEVERLY, OH 45715

+1/4" RD = 61.65% OF TOTAL SAMPLE

SAMPLE ID:
ILLINOIS NO. 6 SEAM
AS RECEIVED RAW COAL
RUN # 94010401

LAB NO.: 31220927

SAMPLED BY: ICF

4
B-138

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU
	1.25	0.00				0.00				100.00			
1.25	1.30	12.44	3.82	2.59	14188	12.44	3.82	2.59	14188	87.56	39.81	5.05	8196
1.30	1.40	38.19	9.07	3.15	13270	50.63	7.78	3.01	13496	49.37	63.59	6.52	4270
1.40	1.50	5.70	19.22	5.48	11612	56.33	8.94	3.26	13305	43.67	69.38	6.66	3312
1.50	1.80	6.38	33.33	6.96	9010	62.71	11.42	3.64	12868	37.29	75.55	6.60	2337
1.80	2.20	9.44	64.61	4.73	4642	72.15	18.38	3.78	11792	27.85	79.26	7.24	1556
2.20		27.85	79.26	7.24	1556	100.00	35.33	4.74	8941				

		<u>%Pyrite, Dry Basis</u>		<u>%Pyrite, Dry Basis</u>		<u>%Pyrite, Dry Basis</u>	
	1.25	0.00		0.00		0.00	
1.25	1.30	0.54		0.54		3.27	
1.30	1.40	1.18		1.02		3.66	
1.40	1.50	3.39		1.26		5.58	
1.50	1.80	5.23		1.67		5.87	
1.80	2.20	3.88		1.96		5.98	
2.20		6.69		3.27		6.69

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1/4" RD X 48 MESH = 23.78% OF TOTAL SAMPLE

SAMPLE ID:
ILLINOIS NO. 6 SEAM
AS RECEIVED RAW COAL
RUN # 94010401

LAB NO.: 31220927

SAMPLED BY: ICF

5

BTU

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU
	1.25	3.70	1.93	2.08	14437	3.70	1.93	2.08	14437	100.00	26.25	3.64	10489
1.25	1.30	26.50	2.85	2.47	14264	30.20	2.74	2.42	14285	96.30	27.18	3.70	10337
1.30	1.40	33.99	7.24	2.98	13607	64.19	5.12	2.72	13926	69.80	36.42	4.16	8847
1.40	1.50	4.95	17.16	4.23	11889	69.14	5.98	2.83	13780	35.81	64.12	5.29	4328
1.50	1.80	4.80	26.16	5.64	10399	73.94	7.29	3.01	13561	30.86	71.65	5.46	3115
1.80	2.20	3.73	54.73	5.93	5830	77.67	9.57	3.15	13189	26.06	80.03	5.42	1774
2.20		22.33	84.26	5.34	1096	100.00	26.25	3.64	10489	22.33	84.26	5.34	1096

%Pyrite, Dry Basis

%Pyrite, Dry Basis

%Pyrite, Dry Basis

1.25
1.25 1.30
1.30 1.40
1.40 1.50
1.50 1.80
1.80 2.20
2.20

0.37
0.48
1.05
2.74
3.83
4.70
4.96

0.37
0.47
0.78
0.92
1.11
1.28
2.10

2.10
2.17
2.81
4.47
4.75
4.92
4.96

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48 MESH X 200 MESH = 4.50% OF TOTAL SAMPLE

SAMPLE ID:
ILLINOIS NO. 6 SEAM
AS RECEIVED RAW COAL
RUN # 94010401

LAB NO.: 31220927

SAMPLED BY: ICF

6

BTU

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU
	1.25	9.78	1.76	1.90	14453	9.78	1.76	1.90	14453	100.00	37.07	3.61	8716
1.25	1.30	20.34	2.57	2.16	14266	30.12	2.31	2.08	14327	90.22	40.90	3.80	8094
1.30	1.40	16.40	5.75	2.67	13750	46.52	3.52	2.29	14123	69.88	52.05	4.27	6298
1.40	1.50	7.15	10.76	2.81	12846	53.67	4.49	2.36	13953	53.48	66.25	4.76	4012
1.50	1.80	5.86	23.45	3.32	10931	59.53	6.35	2.45	13656	46.33	74.82	5.06	2649
1.80	2.20	2.80	48.52	4.73	7006	59.53	6.35	2.45	13656	40.47	82.25	5.32	1450
2.20		37.67	84.76	5.36	1037	62.33	8.25	2.55	13357	37.67	84.76	5.36	1037
						100.00	37.07	3.61	8716				

%Pyrite, Dry Basis

%Pyrite, Dry Basis

%Pyrite, Dry Basis

	1.25	0.25
1.25	1.30	0.37
1.30	1.40	0.71
1.40	1.50	1.21
1.50	1.80	2.15
1.80	2.20	3.85
2.20		4.83

0.25
0.33
0.46
0.56
0.72
0.86
2.36

2.36
2.58
3.23
4.00
4.43
4.76
4.83

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FOR: ICF KAISER ENGINEERS
P.O. BOX 1488
BEVERLY, OH 45715

200 MESH X 0 = 10.07% OF TOTAL SAMPLE

SAMPLE ID:
ILLINOIS NO. 6 SEAM
AS RECEIVED RAW COAL
RUN # 94010401

LAB NO.: 31220927

SAMPLED BY: ICF

SPECIFIC GRAVITY		ELEMENTARY DRY BASIS				CUMULATIVE RETAINED DRY BASIS				CUMULATIVE REJECT DRY BASIS			
SINK	FLOAT	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU	% WT.	% ASH	% SUL.	BTU
										100.00			
	1.25	0.04	*	*	*	0.04				99.96			
1.25	1.30	0.06	*	*	*	0.10				99.90			
1.30	1.40	0.02	*	*	*	0.12				99.88			
1.40	1.50	0.09	*	*	*	0.21				99.79	64.96	1.67	4650
1.50	1.80	2.18	23.39	1.76	11091	2.39	21.33	1.61	10116	97.61	65.89	1.67	4507
1.80	2.20	96.87	65.85	1.63	4518	99.26	64.78	1.63	4653	0.74	70.99	7.31	3010
2.20		0.74	70.99	7.31	3010	100.00	64.82	1.67	4641				

%Pyrite, Dry Basis

%Pyrite, Dry Basis

%Pyrite, Dry Basis

1.25
1.25 1.30
1.30 1.40
1.40 1.50
1.50 1.80
1.80 2.20
2.20

0.47
1.29
6.50 **

0.43
1.27
1.31

1.31
1.33
6.50

*INSUFFICIENT MATERIAL TO DETERMINE ANALYSIS
**ESTIMATED VALUE

**ILLINOIS NO. 6 SEAM
COLUMN FLOTATION
BOX-BEHNKEN TEST MATRIX RESULTS**

a)

Model:
Quadratic
Response:
Pyritic Rej
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 1.000

b)

Model:
Quadratic
Response:
Pyritic Rej
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 2.000

c)

Model:
Quadratic
Response:
Pyritic Rej
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 3.000

Figure 4.6

Effects of Collector Dosage and Air Holdup on Pyritic Sulfur Rejection for the Illinois No. 6 Coal at Feed Rates of (a) 1.0, (b) 2.0, and (c) 3.0 tph

Figure 4.5
Effects of Collector Dosage and Air Holdup on Ash Rejection
for the Illinois No. 6 Coal at Feed Rates of (a) 1.0, (b) 2.0, and (c) 3.0 tph

a)

Model:
Quadratic
Response:
Recovery
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 1.000

b)

Model:
Quadratic
Response:
Recovery
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 2.000

c)

Model:
Quadratic
Response:
Recovery
Actual variables:
X = Air Holdup
Y = Collector
Actual constants:
Feed Rate = 3.000

Figure 4.4

Effects of Collector Dosage and Air Holdup on Energy Recovery
For the Illinois No. 6 Coal at Feed Rates of (a) 1.0, (b) 2.0, and (c) 3.0 tph

Illinois No. 6 Seam					
Box-Behnken Tests					
Test	Design	Goodness-of-Fit			Material
Number	Number	Ash	Other	Total	Balance
93120301	12	2.19	5.02	7.21	Good
93120302	0	1.32	3.05	4.37	Good
93120303	9	17.70	3.03	20.73	Poor
93120304	12	10.91	18.67	29.58	Poor
93120305	9	52.85	10.36	63.21	Poor
93120306	3	6.69	22.11	28.80	Poor
93120307	4	7.76	1.43	9.19	Good
93120308	8	11.14	21.19	32.33	Poor
93120309	0	6.05	4.18	10.23	Fair
93120310	10	23.52	19.12	42.64	Poor
93120311	2	3.91	2.95	6.86	Good
93120312	5	4.67	4.06	8.73	Good
93120313	6	4.99	13.52	18.51	Fair
93120314	11	1.85	19.83	21.68	Poor
93120315	0	6.77	11.09	17.86	Fair
93120316	7	3.11	19.88	22.99	Poor
93120317	1	11.83	7.67	19.50	Fair
93120318	11	30.11	9.00	39.11	Poor
93120319	10	2.72	6.26	8.98	Good
Average		11.06	10.65	21.71	

Illinois No. 6 Seam										
Box-Behnken Tests										
	Planned	Planned	Planned	Planned	Planned	Planned	Planned	Planned	Planned	Planned
	Plant	Column	Column	Column	Column	Column	Column	Column	Column	Column
	Feed	Feed	Aeration	Wash	Air	Frother	Frother	Collector	Frother	Collector
Test	Rate	Rate	Rate	Rate	Holdup	Type	Dosage	Dosage	Dosage	Dosage
Number	(tph)	(tph)	(scfm)	(gpm)	(%)	(*)	(lb/ton)	(lb/ton)	(ml/min)	(ml/min)
93120301	2.60	2.00	140	100	24	MIBC	N/A	1.50	N/A	28.40
93120302	2.60	2.00	140	100	21	MIBC	N/A	1.00	N/A	18.90
93120303	2.60	2.00	140	100	18	MIBC	N/A	0.50	N/A	9.50
93120304	2.60	2.00	140	100	24	MIBC	N/A	1.50	N/A	28.40
93120305	2.60	2.00	140	100	18	MIBC	N/A	0.50	N/A	9.50
93120306	1.30	1.00	140	100	24	MIBC	N/A	1.00	N/A	9.50
93120307	3.90	3.00	140	100	24	MIBC	N/A	1.00	N/A	28.40
93120308	3.90	3.00	140	100	21	MIBC	N/A	1.50	N/A	42.60
93120309	2.60	2.00	140	100	21	MIBC	N/A	1.00	N/A	18.90
93120310	2.60	2.00	140	100	24	MIBC	N/A	0.50	N/A	9.50
93120311	3.90	3.00	140	100	18	MIBC	N/A	1.00	N/A	28.40
93120312	1.30	1.00	140	100	21	MIBC	N/A	0.50	N/A	4.70
93120313	3.90	3.00	140	100	21	MIBC	N/A	0.50	N/A	14.20
93120314	2.60	2.00	140	100	18	MIBC	N/A	1.50	N/A	28.40
93120315	2.60	2.00	140	100	21	MIBC	N/A	1.00	N/A	18.90
93120316	1.30	1.00	140	100	21	MIBC	N/A	1.50	N/A	14.20
93120317	1.30	1.00	140	100	18	MIBC	N/A	1.00	N/A	9.50
93120318	2.60	2.00	140	100	18	MIBC	N/A	1.50	N/A	28.40
93120319	2.60	2.00	140	100	24	MIBC	N/A	0.50	N/A	9.50
Average	2.60	2.00	140	100	21	MIBC	N/A	1.00	N/A	18.94

Illinois No. 6 Seam									
Box-Behnken Tests									
	Relative	Relative	Relative	Relative	Relative	Relative	Relative	Relative	Relative
	Plant	Deslime	HMC	WOC	WOC	Column	Column	Column	Thickener
Test	Feed	U/F	Reject	O/F	U/F	Feed	Product	Reject	Feed
Number	(tph)	(tph)	(tph)	(tph)	(tph)	(tph)	(tph)	(tph)	(tph)
93120301	2.60	1.96	0.64	1.81	0.15	1.81	1.45	0.35	0.46
93120302	2.60	1.96	0.64	1.88	0.08	1.88	1.43	0.44	0.53
93120303	2.60	1.91	0.69	1.77	0.14	1.77	1.17	0.60	0.74
93120304	2.60	1.91	0.69	1.81	0.09	1.81	1.42	0.40	0.49
93120305	2.60	2.03	0.57	1.86	0.18	1.86	1.27	0.59	0.76
93120306	1.30	1.04	0.26	0.99	0.04	0.99	0.80	0.20	0.24
93120307	3.90	2.93	0.97	2.86	0.07	2.86	2.38	0.48	0.55
93120308	3.90	2.96	0.94	2.90	0.07	2.90	2.37	0.53	0.59
93120309	2.60	2.10	0.50	2.01	0.09	2.01	1.54	0.47	0.56
93120310	2.60	2.16	0.44	1.95	0.21	1.95	1.44	0.50	0.71
93120311	3.90	2.83	1.07	2.72	0.11	2.72	1.94	0.78	0.89
93120312	1.30	0.94	0.36	0.91	0.03	0.91	0.71	0.21	0.23
93120313	3.90	2.62	1.28	2.54	0.07	2.54	1.96	0.58	0.66
93120314	2.60	1.81	0.79	1.73	0.09	1.73	1.41	0.32	0.41
93120315									
93120316	1.30	1.03	0.27	1.01	0.02	1.01	0.83	0.18	0.20
93120317	1.30	1.01	0.29	0.98	0.03	0.98	0.71	0.27	0.30
93120318									
93120319	2.60	2.09	0.51	2.04	0.06	2.04	1.56	0.48	0.53
Average	2.60	1.96	0.64	1.87	0.09	1.87	1.43	0.43	0.52

Illinois No. 6 Seam										
Box-Behnken Tests										
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Plant	Plant	Deslime	Deslime	HMC	HMC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	U/F	Reject	Reject	O/F	O/F	U/F	U/F
Test	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93120301	35.52	35.28	21.84	21.31	77.55	77.83	19.63	20.21	51.43	51.28
93120302	37.03	36.17	21.45	21.95	78.89	79.85	20.19	20.56	53.49	53.28
93120303	36.60	36.68	21.41	22.01	77.40	77.31	18.28	19.71	52.81	51.28
93120304	40.66	38.22	21.47	23.34	76.73	79.05	21.93	21.70	56.89	55.69
93120305	34.32	33.13	23.47	20.16	78.23	78.58	13.66	16.96	55.29	53.97
93120306	34.68	33.83	23.22	22.37	78.16	79.03	20.43	21.31	47.71	47.38
93120307	35.98	35.71	19.67	21.70	77.77	78.09	22.45	21.00	48.96	48.52
93120308	36.80	34.33	18.78	19.39	78.87	81.60	18.42	18.62	53.83	53.26
93120309	34.96	34.05	24.97	23.46	78.01	78.88	20.33	22.16	51.63	51.80
93120310	35.76	33.83	22.53	24.29	78.66	80.25	22.75	21.66	51.75	48.66
93120311	38.68	37.79	21.30	21.36	80.50	81.30	20.38	20.05	54.58	54.12
93120312	37.83	37.17	19.91	21.14	78.34	79.12	20.98	20.37	47.18	46.76
93120313	37.64	39.17	19.42	20.41	79.64	77.38	19.98	19.48	52.46	51.91
93120314	37.11	37.32	20.14	19.45	78.83	78.55	17.81	17.84	51.98	51.88
93120315										
93120316	34.82	32.06	20.70	20.26	78.05	80.34	19.04	19.85	40.74	40.77
93120317	36.17	33.93	21.26	21.39	75.77	77.95	18.44	20.47	48.03	48.02
93120318										
93120319	36.30	34.26	22.04	22.95	79.25	81.14	22.49	22.06	54.36	54.20
Average	36.52	35.47	21.39	21.58	78.27	79.19	19.83	20.24	51.36	50.75

Illinois No. 6 Seam								
Box-Behnken Tests								
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Column	Column	Column	Column	Column	Column	Thickener	Thickener
	Feed	Feed	Product	Product	Reject	Reject	Feed	Feed
Test	Ash	Ash	Ash	Ash	Ash	Ash	Ash	Ash
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93120301	20.23	20.21	7.61	7.60	71.78	68.51	63.19	65.91
93120302	21.27	20.56	6.96	6.96	65.55	64.51	61.59	62.74
93120303	22.61	19.71	6.01	6.01	51.08	46.11	42.69	47.08
93120304	23.46	21.70	8.34	8.38	73.72	69.41	62.19	66.83
93120305	21.92	16.96	5.67	5.65	41.85	41.38	44.51	44.28
93120306	21.30	21.31	9.81	9.80	74.50	68.45	60.00	64.71
93120307	22.25	21.00	9.91	9.94	77.34	75.66	70.30	72.03
93120308	19.05	18.62	8.55	8.56	71.48	64.02	57.26	62.82
93120309	22.81	22.16	7.56	7.55	75.25	70.03	65.23	67.04
93120310	22.42	21.66	7.63	7.70	70.81	61.59	49.85	57.79
93120311	19.66	20.05	7.20	7.20	55.75	52.20	49.22	52.44
93120312	21.09	20.37	7.49	7.50	67.50	64.14	58.94	62.12
93120313	20.29	19.48	7.75	7.75	62.19	59.03	55.42	58.22
93120314	17.24	17.84	7.50	7.47	65.44	63.19	58.95	60.80
93120315								
93120316	19.92	19.85	9.14	9.16	69.72	68.72	64.68	65.93
93120317	22.96	22.47	6.21	6.20	59.97	58.57	56.22	57.38
93120318								
93120319	21.96	22.06	8.23	8.23	68.94	67.50	64.59	66.05
Average	21.20	20.35	7.74	7.74	66.05	62.53	57.93	60.83

Illinois No. 6 Seam										
Box-Behnken Tests										
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Plant	Plant	Deslime	Deslime	HMC	HMC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	U/F	Reject	Reject	O/F	O/F	U/F	U/F
Test	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93120301	4.10	4.29	3.37	3.27	7.58	7.42	3.14	2.98	11.49	11.12
93120302	4.18	4.62	3.27	3.19	9.57	9.01	2.95	2.86	10.59	10.57
93120303	4.77	4.68	3.60	3.49	7.89	7.96	3.06	3.00	9.44	9.72
93120304	3.77	4.68	3.56	3.56	9.22	7.76	3.12	3.09	13.02	12.88
93120305	3.81	4.34	3.19	3.40	8.23	7.69	3.23	2.84	10.60	9.32
93120306	3.85	4.19	3.07	3.27	8.11	7.81	2.97	3.04	9.20	9.65
93120307	4.29	4.40	3.34	3.34	7.73	7.64	3.14	3.15	10.40	10.42
93120308	3.33	4.21	3.32	3.18	9.07	7.50	3.09	3.02	10.07	9.90
93120309	3.63	3.99	3.16	3.09	8.18	7.83	2.89	2.83	9.10	8.76
93120310	3.53	4.20	3.19	3.43	8.65	7.96	2.96	2.76	9.80	9.62
93120311	4.44	4.86	3.19	3.27	9.64	9.09	3.08	2.97	10.68	10.68
93120312	4.16	4.45	3.31	3.19	8.04	7.74	2.94	2.99	9.86	9.82
93120313	6.78	5.26	3.68	3.30	8.47	9.25	3.03	3.11	9.61	9.67
93120314	5.73	5.44	3.84	3.29	10.11	10.39	3.21	2.95	10.57	10.14
93120315										
93120316	3.28	4.02	3.23	3.12	8.57	7.53	3.08	3.01	8.51	8.35
93120317	3.84	4.53	3.29	3.08	10.82	9.61	3.06	2.86	9.64	9.51
93120318										
93120319	3.96	4.60	3.45	3.24	11.20	10.21	3.11	3.04	10.39	10.36
Average	4.20	4.52	3.36	3.28	8.89	8.38	3.06	2.97	10.17	10.03

Illinois No. 6 Seam								
Box-Behnken Tests								
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Column	Column	Column	Column	Column	Column	Thickener	Thickener
	Feed	Feed	Product	Product	Reject	Reject	Feed	Feed
Test	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur	Sulfur
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93120301	2.89	2.98	3.08	3.12	2.52	2.43	3.51	3.74
93120302	2.97	2.86	3.02	3.11	2.03	2.05	3.42	3.40
93120303	2.86	3.00	3.04	3.04	2.85	2.93	4.45	4.20
93120304	3.35	3.09	3.37	3.21	2.62	2.64	4.74	4.57
93120305	2.83	2.84	3.01	2.96	2.78	2.57	3.70	4.13
93120306	2.90	3.04	4.08	3.24	2.45	2.24	3.11	3.38
93120307	3.17	3.15	3.38	3.35	2.19	2.20	3.32	3.30
93120308	3.17	3.02	3.38	3.14	2.55	2.49	3.26	3.32
93120309	2.86	2.83	3.07	3.05	2.17	2.08	2.99	3.18
93120310	2.79	2.76	3.18	2.93	2.26	2.27	4.80	4.43
93120311	3.06	2.97	3.08	3.08	2.64	2.69	3.78	3.67
93120312	2.89	2.99	3.21	3.05	2.84	2.78	3.57	3.61
93120313	2.86	3.11	3.16	3.23	2.72	2.69	3.41	3.49
93120314	2.48	2.95	3.11	3.04	2.74	2.56	3.76	4.16
93120315								
93120316	2.84	3.01	3.67	3.03	3.16	2.94	3.33	3.48
93120317	2.85	2.86	2.93	2.95	2.67	2.63	3.32	3.40
93120318								
93120319	2.93	3.04	3.38	3.21	2.49	2.47	3.35	3.33
Average	2.92	2.97	3.24	3.10	2.57	2.51	3.64	3.69

Illinois No. 6 Seam										
Box-Behnken Tests										
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Plant	Plant	Deslime	Deslime	HMC	HMC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	U/F	Reject	Reject	O/F	O/F	U/F	U/F
Test	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93120301	2.47	2.46	1.67	1.45	5.49	5.51	1.35	1.19	8.60	8.50
93120302	2.66	2.73	1.50	1.39	6.97	6.85	1.29	1.12	7.51	7.52
93120303	3.37	3.23	1.85	1.85	6.87	7.03	1.34	1.37	7.76	7.97
93120304	2.45	3.02	1.83	1.83	7.89	6.30	1.34	1.39	10.17	10.41
93120305	2.37	2.73	1.56	1.63	7.45	6.67	1.24	1.11	8.31	7.15
93120306	2.25	2.52	1.44	1.48	7.22	6.65	1.17	1.25	7.54	6.77
93120307	2.61	2.74	1.33	1.48	6.75	6.54	1.33	1.30	8.47	8.47
93120308	2.10	2.60	1.51	1.44	8.03	6.27	1.21	1.28	8.61	8.48
93120309	2.26	2.45	1.47	1.37	7.38	7.00	1.11	1.10	7.56	7.33
93120310	2.14	2.57	1.47	1.70	7.75	6.79	1.21	1.10	7.87	7.32
93120311	3.08	3.30	1.42	1.43	8.73	8.25	1.18	1.13	8.78	8.81
93120312	2.83	2.97	1.46	1.45	7.17	6.93	1.19	1.25	8.10	8.05
93120313	5.09	3.83	1.91	1.50	7.67	8.61	1.35	1.29	8.05	8.17
93120314	3.87	3.86	1.78	1.32	9.73	9.74	1.30	0.95	8.64	8.75
93120315										
93120316	1.69	2.13	1.26	1.25	7.10	5.52	1.08	1.15	6.27	6.17
93120317	2.30	2.64	1.36	1.17	8.96	7.81	1.07	0.96	7.21	7.32
93120318										
93120319	2.34	2.72	1.57	1.46	8.99	7.91	1.41	1.28	7.85	7.87
Average	2.70	2.85	1.55	1.48	7.66	7.08	1.25	1.19	8.08	7.94

Illinois No. 6 Seam								
Box-Behnken Tests								
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Column	Column	Column	Column	Column	Column	Thickener	Thickener
	Feed	Feed	Product	Product	Reject	Reject	Feed	Feed
Test	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic	Pyritic
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93120301	1.15	1.19	0.96	1.05	1.72	1.73	2.57	2.75
93120302	1.02	1.12	0.94	0.97	1.61	1.61	2.49	2.55
93120303	1.35	1.37	1.10	1.08	1.90	1.92	3.21	3.05
93120304	1.67	1.39	1.38	1.39	1.36	1.41	3.46	3.10
93120305	1.13	1.11	0.94	0.95	1.51	1.45	2.50	2.76
93120306	1.10	1.25	1.86	1.18	1.91	1.55	2.18	2.48
93120307	1.33	1.30	1.33	1.24	1.58	1.59	2.64	2.51
93120308	1.32	1.28	1.27	1.16	1.88	1.81	2.53	2.56
93120309	1.16	1.10	0.93	0.98	1.49	1.47	2.28	2.43
93120310	1.02	1.10	1.09	0.95	1.58	1.53	3.64	3.23
93120311	1.18	1.13	0.89	0.92	1.61	1.67	2.62	2.55
93120312	1.16	1.25	1.17	1.04	2.13	1.98	2.66	2.69
93120313	1.15	1.29	1.10	1.16	1.74	1.73	2.35	2.46
93120314	0.66	0.95	1.08	0.78	2.03	1.70	2.96	3.19
93120315								
93120316	1.02	1.15	1.62	0.97	2.26	1.97	2.37	2.39
93120317	0.95	0.96	0.62	0.66	1.63	1.74	2.39	2.37
93120318								
93120319	1.19	1.28	1.11	1.10	1.86	1.87	2.56	2.52
Average	1.15	1.19	1.14	1.03	1.75	1.69	2.67	2.68

Illinois No. 6 Seam										
Box-Behnken Tests										
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Plant	Plant	Deslime	Deslime	HMC	HMC	WOC	WOC	WOC	WOC
	Feed	Feed	U/F	U/F	Reject	Reject	O/F	O/F	U/F	U/F
Test	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy
Number	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)
93120301	9000	9015	11270	11281	2110	2110	11440	11454	6410	6581
93120302	8830	8947	11130	11159	2150	2148	11460	11379	6160	6210
93120303	8950	8760	11240	11213	1960	1962	11850	11618	5970	6066
93120304	8260	8649	11310	10902	2470	2461	11290	11168	5430	5663
93120305	9360	9331	11020	11330	2170	2170	12490	11820	6200	6158
93120306	9230	9357	11190	11168	2220	2219	11490	11342	6690	7058
93120307	8950	8973	11600	11245	2100	2098	11210	11357	6790	6901
93120308	9060	9287	11770	11644	1830	1828	12000	11770	5930	6086
93120309	9060	9206	10800	10909	1990	1989	11320	11123	6120	6253
93120310	9000	9240	11100	10743	1930	1928	11190	11180	6240	6693
93120311	8520	8676	11380	11294	1740	1738	11490	11522	5580	5621
93120312	8880	8820	11720	11426	2000	2000	11420	11556	6970	7093
93120313	8590	8307	11600	11529	1740	1744	11580	11687	6070	6148
93120314	8860	8624	11440	11546	1880	1883	11640	11808	6210	6279
93120315										
93120316	9190	9444	11450	11385	1940	1938	11670	11450	8000	8111
93120317	8990	9028	11410	11218	2150	2147	11700	11380	6510	6526
93120318										
93120319	8950	9240	11220	10975	2050	2047	11080	11124	5700	5739
Average	8922	8994	11332	11233	2025	2024	11548	11455	6293	6423

Illinois No. 6 Seam								
Box-Behnken Tests								
	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted	Measured	Adjusted
	Column	Column	Column	Column	Column	Column	Thickener	Thickener
	Feed	Feed	Product	Product	Reject	Reject	Feed	Feed
Test	Energy	Energy	Energy	Energy	Energy	Energy	Energy	Energy
Number	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)	(Btu/lb)
93120301	11500	11454	13470	13475	3440	3718	4780	4149
93120302	11320	11379	13620	13457	4520	4665	5140	4909
93120303	11230	11618	13800	13849	6800	7317	7940	7083
93120304	11130	11168	13360	13322	3120	3453	4870	3869
93120305	11310	11820	13930	13694	8000	7773	7200	7401
93120306	11380	11342	13210	13270	3080	3444	5490	4086
93120307	11170	11357	13140	13096	2660	2767	3540	3320
93120308	11740	11770	13420	13452	3690	4175	5680	4388
93120309	11090	11123	13550	13409	3420	3635	4520	4065
93120310	11230	11180	13450	13576	3900	4327	6900	5022
93120311	11700	11522	13550	13575	6030	6834	6800	6290
93120312	11450	11556	13500	13607	4240	4577	5510	4871
93120313	11570	11687	13410	13595	4880	5261	6000	5362
93120314	11840	11808	13470	13501	4280	4399	5000	4795
93120315								
93120316	11420	11450	13210	13142	3520	3717	4520	4157
93120317	11120	11380	13590	13541	5520	5610	5830	5713
93120318								
93120319	11270	11125	13250	13227	4050	4214	4620	4380
Average	11381	11455	13466	13458	4421	4699	5549	4933

Illinois No. 6 Seam							
Box-Behnken Tests							
	Plant	Plant	Plant	Plant	Plant	Plant	Plant
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93120301	55.95	44.05	83.63	87.95	59.31	76.12	59.75
93120302	55.17	44.83	82.98	89.38	62.86	80.40	63.38
93120303	44.85	55.15	70.90	92.65	70.87	85.00	55.91
93120304	54.53	45.47	83.99	88.04	62.60	74.90	58.89
93120305	48.80	51.20	71.62	91.68	66.72	83.02	54.64
93120306	61.51	38.49	87.23	82.18	52.44	71.20	58.43
93120307	60.93	39.07	88.93	83.04	53.61	72.43	61.35
93120308	60.83	39.17	88.11	84.83	54.63	72.86	60.97
93120309	59.26	40.74	86.32	86.86	54.70	76.30	62.61
93120310	55.47	44.53	81.50	87.37	61.30	79.50	61.00
93120311	49.87	50.13	78.03	90.50	68.40	86.10	64.13
93120312	54.28	45.72	83.74	89.05	62.80	80.99	64.73
93120313	50.25	49.75	82.24	90.06	69.14	84.78	67.02
93120314	54.10	45.90	84.69	89.17	69.77	89.07	73.76
93120315							
93120316	63.92	36.08	88.95	81.74	51.82	70.89	59.84
93120317	54.74	45.26	82.10	90.00	64.35	86.32	68.42
93120318							
93120319	60.06	39.94	85.97	85.57	58.09	75.71	61.68
Average	55.56	44.44	83.00	87.65	61.38	79.15	62.15

Illinois No. 6 Seam							
Box-Behnken Tests							
	HMC	HMC	HMC	HMC	HMC	HMC	HMC
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93120301	75.43	24.57	94.39	54.01	43.41	55.03	49.42
93120302	75.46	24.54	94.12	53.52	50.83	61.57	55.69
93120303	73.48	26.52	94.06	55.96	44.71	57.72	51.78
93120304	73.29	26.71	92.38	53.62	52.62	55.72	48.10
93120305	78.17	21.83	94.92	51.55	41.40	53.34	48.25
93120306	79.77	20.23	95.21	46.74	39.16	53.38	48.59
93120307	75.16	24.84	94.19	54.10	43.64	59.29	53.48
93120308	75.99	24.01	95.28	55.16	51.73	57.90	53.18
93120309	80.90	19.10	95.87	43.76	39.16	54.57	50.44
93120310	82.94	17.06	96.43	39.67	35.14	45.07	41.50
93120311	72.60	27.40	94.51	58.37	54.35	68.50	63.01
93120312	72.35	27.65	93.73	58.28	49.96	64.52	58.24
93120313	67.07	32.93	93.08	66.95	53.03	74.03	67.11
93120314	69.76	30.24	93.40	63.88	56.20	76.31	69.70
93120315							
93120316	79.46	20.54	95.79	50.00	43.79	53.23	49.02
93120317	77.84	22.16	96.72	49.49	52.93	65.56	62.28
93120318							
93120319	80.57	19.43	95.69	44.95	47.31	56.50	52.20
Average	75.90	24.10	94.69	52.94	47.02	59.54	54.24

Illinois No. 6 Seam							
Box-Behnken Tests							
	WOC	WOC	WOC	WOC	WOC	WOC	WOC
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93120301	92.18	7.82	93.59	18.82	26.60	45.85	39.44
93120302	95.75	4.25	97.63	10.33	14.10	23.01	20.65
93120303	92.69	7.31	96.04	17.03	20.35	31.48	27.52
93120304	95.18	4.82	97.51	11.49	17.43	27.40	24.90
93120305	91.35	8.65	95.30	23.15	23.71	37.93	33.24
93120306	95.94	4.06	97.43	8.60	11.99	18.58	16.01
93120307	97.47	2.53	98.44	5.65	7.89	14.47	12.91
93120308	97.78	2.22	98.83	6.11	6.92	13.10	11.93
93120309	95.61	4.39	97.49	9.69	12.44	23.48	20.97
93120310	90.27	9.73	93.94	19.49	27.29	41.90	35.84
93120311	96.14	3.86	98.08	9.77	12.60	23.76	21.84
93120312	97.08	2.92	98.19	6.45	8.98	16.19	14.38
93120313	97.15	2.85	98.48	7.24	8.34	15.51	13.99
93120314	95.27	4.73	97.43	12.62	14.58	31.36	28.79
93120315							
93120316	98.04	1.96	98.60	3.95	5.25	9.69	8.29
93120317	96.66	3.34	98.06	7.50	10.31	20.90	18.95
93120318							
93120319	97.22	2.78	98.54	6.57	8.89	14.99	13.53
Average	95.40	4.60	97.27	10.85	13.98	24.09	21.36

Illinois No. 6 Seam							
Box-Behnken Tests							
	Column	Column	Column	Column	Column	Column	Column
	Product	Reject	Energy	Ash	Sulfur	Pyritic	Separate
Test	Yield	Yield	Recovery	Rejection	Rejection	Rejection	Efficiency
Number	(%)	(%)	(%)	(%)	(%)	(%)	(%)
93120301	80.47	19.53	94.67	66.21	15.93	28.39	23.06
93120302	76.36	23.64	90.30	74.17	16.94	33.98	24.29
93120303	65.85	34.15	78.49	79.89	33.35	47.86	26.36
93120304	78.17	21.83	93.24	69.83	18.65	22.15	15.39
93120305	68.34	31.66	79.17	77.25	28.65	41.36	20.53
93120306	80.37	19.63	94.04	63.04	14.46	24.34	18.37
93120307	83.17	16.83	95.90	60.64	11.75	20.58	16.49
93120308	81.87	18.13	93.57	62.33	14.95	25.64	19.21
93120309	76.61	23.39	92.36	73.91	17.19	31.25	23.61
93120310	74.09	25.91	89.97	73.68	21.31	36.04	26.01
93120311	71.45	28.55	84.18	74.34	25.86	42.20	26.38
93120312	77.28	22.72	90.99	71.55	21.13	35.99	26.99
93120313	77.12	22.88	89.71	69.34	19.79	30.69	20.39
93120314	81.40	18.60	93.07	65.87	16.14	33.28	26.35
93120315							
93120316	82.05	17.95	94.18	62.13	17.53	30.74	24.92
93120317	72.75	27.25	86.57	71.02	25.06	49.38	35.95
93120318							
93120319	76.68	23.32	91.16	71.37	18.95	34.08	25.24
Average	76.71	23.29	90.09	69.80	19.86	33.41	23.50

ILLINOIS NO. 6 SEAM 24-HOUR GRIND RESULTS

ILLINOIS NO. 6 SEAM 24-HOUR RUN DATA: MICROTRAC OF MILL CIRCUIT FEED

Shift >	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17
Microns																	
296.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0		100.0	100.0	100.0			80.5
209.3	76.2	82.4	81.1	76.1	76.3	75.9	78.8	82.9	81.0	83.6		79.0	84.3	76.6			66.2
148.0	54.7	65.3	63.6	52.5	55.3	55.5	59.9	66.4	63.2	66.6		60.9	65.3	57.7			53.7
104.7	38.3	51.7	50.1	35.3	39.8	40.8	45.8	53.2	49.3	53.0		48.7	50.6	44.1			43.4
74.0	26.8	41.3	39.6	23.6	28.8	30.1	35.4	42.9	38.3	42.6		39.7	40.1	34.2			35.4
52.3	17.8	33.7	31.6	15.6	20.3	22.2	27.4	34.5	29.6	33.7		32.3	31.1	26.9			29.3
37.0	11.1	27.8	25.7	10.4	14.5	16.6	21.3	27.8	23.2	26.6		26.8	24.5	21.4			24.2
26.2	8.0	23.2	21.2	7.1	11.0	12.5	16.8	22.5	18.9	21.1		22.1	19.3	17.2			19.9
18.5	6.1	19.1	17.2	4.8	8.4	9.7	13.4	17.9	15.2	16.4		17.4	14.7	14.1			15.8
13.1	3.8	14.5	13.0	3.0	6.1	7.2	9.9	13.1	11.6	11.8		12.8	10.1	11.0			11.2
9.3	2.3	10.6	9.4	1.8	4.3	5.2	7.0	9.0	8.8	8.2		8.9	6.5	8.4			7.7
6.5	1.6	7.7	6.9	1.3	3.1	3.8	4.9	6.2	6.5	5.7		6.2	4.3	6.5			5.2
4.6	0.7	4.8	4.3	0.6	1.8	2.2	2.7	3.6	4.1	3.4		3.5	2.1	4.4			2.8
3.3	0.1	2.6	2.3	0.1	0.9	1.0	1.2	1.7	2.2	1.6		1.6	0.6	2.6			1.3
dv	0.117	0.102	0.105	0.126	0.132	0.119	0.139	0.123	0.111	0.123		0.125	0.100	0.113			0.118
05%	15.9	4.7	5.0	19.0	10.9	8.9	6.6	5.5	5.2	5.8		5.6	7.4	5.1			6.3
50%	135.7	99.6	104.4	141.9	133.5	131.9	117.9	94.4	106.9	95.3		109.7	102.7	123.4			131.6
95%	275.2	267.0	269.4	273.5	275.3	276.0	273.1	266.5	269.2	264.5		272.5	260.3	275.6			472.6
mv	139.5	112.1	116.3	143.1	136.6	135.3	125.0	110.3	118.2	110.5		119.6	113.1	128.7			169.1

ILLINOIS NO. 6 SEAM 24-HOUR RUN DATA: MICROTRAC OF MILL CIRCUIT FEED

Shift >	18	19	20	21	22	23	24	25	26	27	28	29	30
Microns													
296.0	83.8	84.9	84.2	80.2	86.3	84.0	80.6		79.8	79.9	82.9		82
209.3	69.4	72.5	70.6	65.3	73.9	69.7	64.4		65.0	64.4	67.9		64.2
148.0	56.8	58.7	55.8	52.3	61.5	56.1	49.6		52.0	50.8	53.4		46.3
104.7	46.7	47.6	44.1	42.0	50.9	44.1	39.2		41.7	40.4	42.8		32
74.0	37.9	39.5	34.8	33.7	41.8	34.7	31.5		33.6	32.6	34.9		21.6
52.3	31.0	31.7	26.5	27.0	33.1	29.2	24.3		27.4	26.4	28.0		15
37.0	25.7	25.7	20.2	21.5	26.1	24.1	19.5		22.4	21.8	22.9		10.3
26.2	21.5	21.8	15.8	17.5	21.3	20.0	16.7		18.5	17.9	19.2		6.99
18.5	17.6	18.2	12.0	14.1	17.2	16.9	14.0		15.1	14.1	15.6		4.92
13.1	13.5	14.2	8.3	10.5	13.1	13.5	11.1		11.4	10.2	11.9		3.19
9.3	10.1	11.0	5.3	7.6	10.0	10.6	8.7		8.6	7.1	8.7		2.05
6.5	7.4	8.5	3.4	5.4	7.6	8.2	6.7		6.5	5.0	6.4		1.42
4.6	4.6	5.6	1.8	3.2	5.1	5.4	4.4		4.2	3.0	3.9		0.7
3.3	2.6	3.3	0.7	1.7	3.1	3.2	2.6		2.4	1.5	2.1		0.2
dv	0.109	0.091	0.130	0.118	0.097	0.095	0.103		0.1	0.11	0.1		0.16
05%	4.8	4.4	8.8	6.2	4.6	4.4	5.0		5.2	6.51	5.34		18.8
50%	117.6	114.6	126.8	137.9	101.1	123.9	149.7		139	145	135		160
95%	433.1	408.9	448.1	497.3	402.1	433.2	447.4		462	437	453		439
mv	154.9	145.6	160.3	174.9	140.2	157.2	174.0		172	171	164		184

avg	max	min	std
91.6	100.0	79.8	8.9
73.9	84.3	64.2	6.7
57.3	66.6	46.3	5.5
44.6	53.2	32.0	5.5
35.0	42.9	21.6	5.6
27.4	34.5	15.0	5.4
21.7	27.8	10.3	5.2
17.5	23.2	7.0	4.7
14.0	19.1	4.8	4.1
10.4	14.5	3.0	3.3
7.5	11.0	1.8	2.6
5.5	8.5	1.3	2.0
3.3	5.6	0.6	1.4
1.7	3.3	0.1	1.0
0.115	0.158	0.091	0.015
7.4	19.0	4.4	4.2
123.2	160.1	94.4	17.8
354.1	497.3	260.3	88.6
143.0	183.9	110.3	23.3

ILLINOIS NO. 6 SEAM 24-HOUR RUN DATA: MICROTRAC OF COLUMN FLOTATION FEED

Shift >	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17
Microns																	
296.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	99.8		99.7
209.3	98.9	98.3	98.8	99.4	98.6	99.6	98.9	99.6	98.1	99.3	97.9	98.2	99.3	98.4	98.1		98.3
148.0	96.4	95.2	96.2	97.7	95.6	97.9	96.3	98.2	94.9	97.3	94.7	95.4	97.3	95.4	95.4		97.1
104.7	92.5	90.8	92.4	94.3	91.2	94.5	92.3	95.1	90.7	93.8	90.1	91.7	93.7	91.1	91.7		95.5
74.0	85.1	83.4	85.6	87.1	83.4	87.5	84.7	88.2	83.0	86.5	82.3	84.8	86.3	83.4	84.9		91.2
52.3	73.9	72.4	74.8	76.0	71.9	76.5	73.1	76.9	71.3	75.3	71.2	74.2	75.3	72.2	74.5		83.9
37.0	61.1	59.4	62.1	62.8	58.5	63.6	59.8	63.5	57.6	62.1	58.3	61.8	52.5	59.4	62.0		73.8
26.2	49.2	47.4	50.2	50.8	46.5	51.7	47.9	51.4	44.9	49.6	46.4	50.3	50.7	48.0	50.4		62.9
18.5	38.5	36.8	39.8	40.0	36.3	41.1	37.4	40.7	33.5	38.2	35.7	40.2	40.2	38.4	40.0		51.6
13.1	28.5	26.5	29.5	29.6	26.4	30.9	27.1	30.2	22.6	27.1	24.9	30.2	29.8	29.1	29.8		40.0
9.3	20.6	18.4	21.1	21.3	18.7	22.6	19.1	21.9	14.6	18.5	16.7	21.9	21.4	21.7	21.5		30.4
6.5	14.9	13.0	15.2	15.3	13.3	16.6	13.5	16.0	9.6	12.8	11.4	15.8	15.4	16.3	15.6		23.1
4.6	10.0	8.3	10.1	10.0	8.5	11.1	8.6	10.8	5.6	8.0	6.8	10.3	10.1	11.3	10.3		16.1
3.3	6.3	5.0	6.2	6.1	5.1	7.0	5.1	6.9	3.0	4.6	3.7	6.2	7.7	7.4	6.4		10.6
dv	0.145	0.210	0.158	0.177	0.162	0.179	0.157	0.183	0.190	0.218	0.159	0.174	0.177	0.182	0.178		0.137
05%	2.7	3.3	2.8	2.8	3.2	2.6	3.2	2.6	4.4	3.5	3.9	2.8	2.8	2.4	2.7		2.0
50%	26.9	28.5	26.0	25.5	29.2	24.8	28.0	25.0	30.4	26.5	29.4	25.9	25.6	28.0	25.8		17.6
95%	128.3	145.4	131.1	109.9	139.1	108.8	129.8	103.8	150.1	114.8	153.5	141.1	115.8	141.8	141.7		98.9
mv	40.4	43.6	39.9	37.2	43.2	36.3	41.4	35.8	45.4	38.6	45.5	41.3	38.1	42.8	41.5		31.3

ILLINOIS NO. 6 SEAM 24-HOUR RUN DATA: MICROTRAC OF COLUMN FLOTATION FEED

Shift >	18	19	20	21	22	23	24	25	26	27	28	29	30
Microns													
296.0	100.0	100.0	99.7	100.0	99.7	100.0	99.9	100.0	98.7	100.0	99.8	99.9	99.8
209.3	99.4	99.3	97.6	99.1	97.9	99.2	97.8	98.9	94.9	98.9	97.7	98.5	98.7
148.0	97.7	97.7	94.2	96.5	95.0	96.1	93.5	96.0	90.1	96.2	93.7	94.9	96.2
104.7	94.8	95.0	90.0	93.3	90.6	90.6	88.7	91.1	84.6	91.3	87.4	88.5	91.2
74.0	88.8	88.9	82.8	86.9	82.0	81.0	81.4	82.1	76.3	81.1	76.8	77.5	81.9
52.3	78.6	78.5	71.7	75.8	69.4	67.5	70.0	69.4	64.9	67.2	63.4	63.8	69.5
37.0	66.0	65.5	58.9	63.0	56.4	53.1	57.7	55.9	52.8	53.3	50.4	50.3	56.3
26.2	54.3	53.2	47.4	51.6	45.2	41.6	47.3	44.7	42.5	41.9	39.6	39.4	44.9
18.5	43.5	42.2	37.2	40.7	35.5	32.4	33.8	35.3	33.2	32.7	30.7	30.6	35.4
13.1	32.9	31.3	27.4	29.8	26.3	23.5	28.3	26.3	24.3	24.0	22.4	22.5	26.5
9.3	24.6	22.9	19.7	21.3	19.1	16.6	20.8	19.3	17.4	17.4	16.0	16.4	19.6
6.5	18.5	16.9	14.3	15.2	14.0	11.8	15.3	14.3	12.7	12.9	11.7	12.2	14.7
4.6	12.8	11.6	9.5	9.8	9.5	7.6	10.3	9.8	8.4	8.7	7.7	8.3	10.1
3.3	8.4	7.5	5.9	6.0	6.1	4.5	6.5	6.3	5.2	5.5	4.8	5.2	6.58
dv	0.183	0.185	0.174	0.164	0.192	0.208	0.181	0.15	0.16	0.17	0.16	0.15	0.15
05%	2.2	2.4	2.9	2.9	2.8	3.5	2.7	2.72	3.17	3.03	3.38	3.15	2.61
50%	22.7	23.6	28.5	24.9	30.7	34.1	28.9	31.3	34	33.9	36.6	36.7	31
95%	106.5	104.5	160.2	124.5	148.7	135.6	165.7	135	211	132	164	149	133
mv	34.8	35.3	45.3	38.4	45.8	45.8	46.5	44.1	57	45.6	52	50.1	44.2

avg	max	min	std
99.9	100.0	98.7	0.2
98.5	99.6	94.9	0.9
95.8	98.2	90.1	1.6
91.7	95.5	84.6	2.4
83.9	91.2	76.3	3.5
72.5	83.9	63.4	4.6
59.2	73.8	50.3	5.1
48.0	62.9	39.4	4.8
37.6	51.6	30.6	4.3
27.8	40.0	22.4	3.6
20.1	30.4	14.6	3.0
14.6	23.1	9.6	2.5
9.7	16.1	5.6	1.9
6.1	10.6	3.0	1.4
0.173	0.218	0.137	0.019
2.9	4.4	2.0	0.5
28.3	36.7	17.6	4.2
135.3	210.8	98.9	23.3
42.3	57.0	31.3	5.4

**ILLINOIS NO. 6 SEAM
24-HOUR DEMONSTRATION RUN RESULTS**

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	Goodness-of-Fit		
	Ash	Other	Total
94010301	15.70	11.07	26.77
94010302	6.98	20.96	27.94
94010303	3.98	5.96	9.94
94010304	3.16	6.23	9.39
94010305	8.84	12.02	20.86
94010307	5.53	10.78	16.31
94010308	4.32	9.33	13.65
94010309	6.05	10.33	16.38
94010310	2.45	4.08	6.53
94010313	5.29	9.39	14.68
94010315	5.41	5.61	11.02
94010317	5.54	17.85	23.39
94010318	5.76	15.84	21.60
94010320	5.57	21.79	27.36
94010322	11.81	18.65	30.46
94010323	8.06	22.74	30.80
94010325	2.23	8.01	10.24
94010326	13.13	11.73	24.86
94010327	4.77	18.74	23.51
94010328	3.55	5.08	8.63
94010329	4.52	8.10	12.62
Average	6.3	12.1	18.4

Illinois No. 6 Seam Long Duration Tests

[illegible]

Average	100.0	79.7	20.3	76.4	3.3	76.4	57.9	18.5
Maximum	100.0	87.3	27.7	84.1	6.0	84.1	64.2	21.6
Minimum	100.0	72.3	12.7	70.5	1.3	70.5	53.5	12.9
Range	0.0	15.0	15.0	13.7	4.7	13.7	10.8	8.7
Std.Deviation	0.0	4.3	4.3	3.8	1.3	3.8	2.8	2.1
# of Points	21	21	21	21	21	21	21	21

Long Duration Tests

Long Duration Tests

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**Illinois No. 6 Seam
Long Duration Tests**

Test Number	Measured Column Feed Ash (%)	Adjusted Column Feed Ash (%)	Measured Column Product Ash (%)	Adjusted Column Product Ash (%)	Measured Column Reject Ash (%)	Adjusted Column Reject Ash (%)	Measured Thickener Feed Ash (%)	Adj Thic Fr A (
94010301	21.22	20.40	7.13	7.11	71.04	66.88	61.86	
94010302	23.13	21.88	7.09	7.06	68.65	68.44	67.61	
94010303	22.84	22.01	7.45	7.45	73.54	69.75	64.52	
94010304	21.97	21.52	7.14	7.14	73.43	69.39	63.00	
94010305	21.54	20.39	7.31	7.29	72.65	67.83	61.46	
94010307	22.76	21.80	6.97	6.97	72.03	67.74	62.42	
94010308	22.18	21.73	7.34	7.34	72.45	69.29	63.72	
94010309	21.36	20.84	7.00	6.99	71.11	65.64	60.82	
94010310	23.20	22.47	7.02	7.03	74.29	71.16	65.03	
94010313	21.11	21.85	8.53	8.54	67.70	64.79	60.23	
94010315	23.84	23.61	6.99	6.99	74.00	69.89	62.05	
94010317	24.49	24.40	7.83	7.84	72.45	69.05	64.12	
94010318	23.22	23.08	6.21	6.20	73.84	67.81	61.10	
94010320	19.43	19.08	8.16	8.16	69.65	68.14	65.19	
94010322	24.17	23.42	7.54	7.54	74.12	69.90	64.01	
94010323	23.61	23.10	7.12	7.12	73.98	68.68	63.39	
94010325	22.49	22.18	6.54	6.53	75.08	73.35	66.97	
94010326	21.13	22.89	6.77	6.77	71.08	63.94	55.84	
94010327	21.65	21.79	7.02	7.02	73.51	70.78	66.50	
94010328	22.66	23.25	7.21	7.20	74.42	71.31	66.22	
94010329	21.77	20.74	6.81	6.82	70.92	66.96	62.23	

Average	22.37	22.02	7.20	7.20	72.38	68.61	63.25	
Maximum	24.49	24.40	8.53	8.54	75.08	73.35	67.61	
Minimum	19.43	19.08	6.21	6.20	67.70	63.94	55.84	
Range	5.06	5.32	2.32	2.34	7.38	9.41	11.77	
Std.Deviation	1.19	1.24	0.50	0.50	1.95	2.18	2.63	
# of Points	21	21	21	21	21	21	21	

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	Measured Plant Feed Sulfur (%)	Adjusted Plant Feed Sulfur (%)	Measured Deslime U/F Sulfur (%)	Adjusted Deslime U/F Sulfur (%)	Measured HMC Reject Sulfur (%)	Adjusted HMC Reject Sulfur (%)	Measured WOC O/F Sulfur (%)	Adjusted WOC O/F Sulfur (%)	Measured WOC U/F Sulfur (%)	Adjusted WOC U/F Sulfur (%)
94010301	3.81	4.45	3.10	3.24	9.05	8.17	3.31	3.03	10.30	9.74
94010302	7.57	4.97	3.12	3.08	9.00	10.00	2.80	2.80	11.95	11.81
94010303	3.63	3.85	3.14	2.99	7.00	6.82	2.82	2.77	9.34	9.21
94010304	5.88	5.56	3.09	3.13	13.21	13.59	2.77	2.75	11.79	11.43
94010305	3.90	4.35	3.34	3.21	9.59	9.06	2.92	2.85	12.25	11.48
94010307	3.45	3.96	3.23	3.11	8.01	7.48	3.04	2.89	9.67	9.43
94010308	3.61	4.12	3.26	3.19	9.16	8.59	2.96	2.84	11.87	11.44
94010309	3.68	4.10	3.42	3.11	9.28	8.81	3.06	2.96	10.91	10.80
94010310	3.90	3.90	3.11	3.24	8.07	8.07	2.99	2.85	10.74	10.55
94010313	3.53	4.12	3.35	3.25	10.80	10.09	3.00	2.92	12.53	12.24
94010315	3.79	4.47	3.41	3.44	10.22	9.37	2.97	2.81	12.14	11.54
94010317	4.00	3.85	2.83	3.09	7.24	7.33	3.04	2.86	11.22	10.96
94010318	5.29	4.22	2.95	3.30	7.81	8.24	3.10	2.87	11.48	11.05
94010320	3.32	4.26	3.26	3.15	9.09	7.14	3.35	3.00	11.62	11.40
94010322	3.27	4.16	3.27	3.23	11.01	9.51	3.17	2.97	10.24	10.06
94010323	3.20	4.10	3.40	3.12	9.22	7.58	3.14	2.85	13.44	13.21
94010325	3.90	4.47	3.01	3.13	10.42	9.56	3.04	2.74	8.80	8.35
94010326	3.65	4.17	3.00	3.16	9.32	8.70	2.97	2.73	9.36	8.76
94010327	3.56	4.50	3.20	3.17	10.33	8.29	3.06	2.87	11.06	10.82
94010328	4.38	4.10	3.15	3.29	7.32	7.47	2.88	2.92	9.97	9.48
94010329	3.74	4.08	3.00	3.06	7.22	6.89	2.89	2.88	10.53	10.39

Average	4.05	4.27	3.17	3.18	9.16	8.61	3.01	2.86	11.01	10.67
Maximum	7.57	5.56	3.42	3.44	13.21	13.59	3.35	3.03	13.44	13.21
Minimum	3.20	3.85	2.83	2.99	7.00	6.82	2.77	2.73	8.80	8.35
Range	4.37	1.71	0.59	0.45	6.21	6.77	0.58	0.30	4.64	4.86
Std.Deviation	1.00	0.38	0.16	0.10	1.49	1.48	0.15	0.08	1.17	1.18
# of Points	21	21	21	21	21	21	21	21	21	21

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	Measured Column Feed Sulfur (%)	Adjusted Column Feed Sulfur (%)	Measured Column Product Sulfur (%)	Adjusted Column Product Sulfur (%)	Measured Column Reject Sulfur (%)	Adjusted Column Reject Sulfur (%)	Measured Thickener Feed Sulfur (%)	Ad Thic F S I
94010301	3.22	3.03	3.27	3.25	2.37	2.23	2.97	
94010302	2.87	2.80	2.66	2.90	2.50	2.50	3.45	
94010303	2.65	2.77	2.97	2.91	2.39	2.32	3.09	
94010304	2.63	2.75	2.97	2.89	2.40	2.31	3.61	
94010305	2.89	2.85	2.97	2.97	2.58	2.43	3.58	
94010307	2.99	2.89	2.99	3.02	2.55	2.48	3.22	
94010308	2.76	2.84	3.15	2.99	2.40	2.31	3.56	
94010309	2.96	2.96	2.99	3.07	2.66	2.60	3.11	
94010310	2.84	2.85	2.97	2.97	2.49	2.46	3.86	
94010313	2.93	2.92	3.16	3.00	2.71	2.64	3.88	
94010315	2.88	2.81	3.03	2.94	2.49	2.45	4.42	
94010317	2.55	2.86	3.34	2.92	2.92	2.69	3.34	
94010318	2.93	2.87	2.92	3.06	2.38	2.34	3.61	
94010320	3.02	3.00	3.18	3.03	2.94	2.86	3.55	
94010322	3.25	2.97	3.30	3.15	2.42	2.42	3.50	
94010323	3.00	2.85	2.97	2.99	2.46	2.46	3.42	
94010325	2.91	2.74	2.86	2.94	2.13	2.10	3.47	
94010326	2.81	2.73	2.90	2.85	2.51	2.42	3.58	
94010327	3.03	2.87	3.06	2.97	2.55	2.53	3.73	
94010328	3.04	2.92	3.03	3.06	2.64	2.51	3.54	
94010329	3.02	2.88	3.06	3.02	2.47	2.42	3.10	

Average	2.91	2.86	3.04	3.00	2.52	2.45	3.50	
Maximum	3.25	3.03	3.34	3.25	2.94	2.86	4.42	
Minimum	2.55	2.73	2.66	2.85	2.13	2.10	2.97	
Range	0.70	0.30	0.68	0.40	0.81	0.76	1.45	
Std.Deviation	0.17	0.08	0.15	0.09	0.18	0.16	0.32	
# of Points	21	21	21	21	21	21	21	

**Illinois No. 6 Seam
Long Duration Tests**

Test	Number	Measured	Plant	Feed	Pyritic (%)	Adjusted	Plant	Feed	Pyritic (%)	Adjusted	HMC	Reject	O/F	WOC	Adjusted	HMC	Reject	O/F	WOC	Adjusted	Pyritic (%)	U/F	WOC	Adjusted
94010301	2.37	2.60	1.48	1.24	7.35	6.80	1.12	1.03	7.73	7.66														
94010302	4.02	2.57	1.44	1.14	5.63	6.40	0.98	0.90	8.74	8.59														
94010303	2.02	2.23	1.40	1.28	5.87	5.48	1.05	1.06	8.15	7.71														
94010304	3.45	3.54	1.60	1.45	10.70	10.49	0.97	1.09	8.97	9.07														
94010305	2.09	2.28	1.72	1.26	6.92	6.51	1.21	1.12	4.30	4.43														
94010307	2.15	2.47	1.56	1.47	7.31	6.60	1.32	1.23	8.67	8.34														
94010308	2.11	2.51	1.63	1.47	8.61	7.46	1.27	1.19	8.17	8.10														
94010309	2.09	2.18	1.66	1.22	6.90	6.73	1.29	1.07	9.07	8.81														
94010310	2.12	2.16	1.36	1.46	6.59	6.54	1.20	1.07	9.14	8.77														
94010313	1.54	2.00	1.56	1.41	7.38	6.04	1.19	1.14	8.61	8.53														
94010315	2.27	2.45	1.71	1.58	6.89	6.60	1.16	1.07	8.25	8.16														
94010317	2.15	1.99	1.12	1.28	5.13	5.29	1.17	1.08	7.92	7.84														
94010318	2.82	2.36	1.58	1.37	6.29	6.71	1.16	1.00	8.02	8.02														
94010320	1.74	2.24	1.53	1.29	6.82	4.70	1.24	1.16	8.45	4.49														
94010322	1.51	1.96	1.34	1.38	6.59	5.32	1.27	1.17	7.63	6.69														
94010323	1.93	2.29	1.48	1.31	6.80	5.81	1.26	1.12	8.44	8.34														
94010325	2.82	2.86	1.38	1.33	8.76	8.68	1.21	0.95	6.48	6.37														
94010326	2.38	2.51	1.28	1.36	7.95	7.68	0.97	0.97	6.99	6.42														
94010327	2.12	2.60	1.26	1.36	7.86	6.16	1.26	1.09	8.26	8.17														
94010328	2.61	2.45	1.44	1.50	6.18	6.36	1.17	1.11	8.13	8.04														
94010329	2.00	2.27	1.13	1.17	5.92	5.30	1.04	1.02	7.21	7.18														

Average	2.30	2.41	1.46	1.35	7.07	6.56	1.17	1.08	7.97	7.61														
Maximum	4.02	3.54	1.72	1.58	10.70	10.49	1.32	1.23	9.14	9.07														
Minimum	1.51	1.96	1.12	1.14	5.13	4.70	0.97	0.90	4.30	4.43														
Range	2.51	1.58	0.60	0.44	5.57	5.79	0.35	0.33	4.84	4.64														
Std.Deviation	0.58	0.34	0.17	0.11	1.21	1.24	0.11	0.08	1.05	1.25														
# of Points	21	21	21	21	21	21	21	21	21	21														

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	Measured Column Feed Pyritic (%)	Adjusted Column Feed Pyritic (%)	Measured Column Product Pyritic (%)	Adjusted Column Product Pyritic (%)	Measured Column Reject Pyritic (%)	Adjusted Column Reject Pyritic (%)	Measured Thickener Feed Pyritic (%)	Adj Thic Fi Py (
94010301	0.96	1.03	0.84	0.88	1.57	1.55	2.22	
94010302	1.00	0.90	0.52	0.60	1.74	1.83	2.26	
94010303	1.00	1.06	0.93	0.89	1.82	1.61	2.14	
94010304	1.03	1.09	1.01	0.90	1.87	1.74	2.90	
94010305	1.22	1.12	0.71	0.80	2.03	2.28	2.73	
94010307	1.32	1.23	0.93	0.99	2.00	1.98	2.59	
94010308	1.07	1.19	1.10	1.04	1.74	1.69	2.66	
94010309	1.04	1.07	0.78	0.89	1.70	1.66	1.92	
94010310	1.05	1.07	0.81	0.82	1.89	1.88	3.07	
94010313	1.13	1.14	1.04	0.98	1.67	1.67	2.76	
94010315	1.00	1.07	0.87	0.88	1.62	1.61	3.00	
94010317	0.84	1.08	1.88	0.91	1.88	1.57	2.25	
94010318	1.01	1.00	0.63	0.70	1.69	1.79	2.58	
94010320	0.99	1.16	1.13	0.99	1.99	1.93	2.60	
94010322	1.37	1.17	1.01	1.00	1.91	1.68	2.05	
94010323	1.29	1.12	0.76	0.84	1.80	1.91	2.41	
94010325	1.00	0.95	0.68	0.77	1.44	1.54	2.59	
94010326	0.96	0.97	0.74	0.71	1.80	1.65	2.48	
94010327	1.15	1.09	0.84	0.85	1.80	1.89	3.04	
94010328	1.19	1.11	0.81	0.86	1.81	1.87	3.02	
94010329	0.95	1.02	0.88	0.80	1.81	1.75	2.34	

Average	1.07	1.08	0.90	0.86	1.79	1.77	2.55	
Maximum	1.37	1.23	1.88	1.04	2.03	2.28	3.07	
Minimum	0.84	0.90	0.52	0.60	1.44	1.54	1.92	
Range	0.53	0.33	1.36	0.44	0.59	0.74	1.15	
Std.Deviation	0.13	0.08	0.27	0.11	0.14	0.17	0.33	
# of Points	21	21	21	21	21	21	21	

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	Measured Plant Feed Btu/lb	Adjusted Plant Feed Btu/lb	Measured Deslime U/F Btu/lb	Adjusted Deslime U/F Btu/lb	Measured HMC Reject Btu/lb	Adjusted HMC Reject Btu/lb	Measured WOC O/F Btu/lb	Adjusted WOC O/F Btu/lb	Measured WOC U/F Btu/lb	Adjusted WOC U/F Btu/lb
94010301	8700	8920	10840	11160	1990	1980	11800	11320	6110	6250
94010302	9030	8640	10950	11170	1860	1870	11450	11350	5650	5650
94010303	8970	9080	11080	11080	2190	2190	11410	11260	5660	5800
94010304	9170	9020	10980	11100	2120	2120	11380	11330	5870	6060
94010305	9340	9470	11110	11250	2110	2100	11850	11460	5990	6220
94010307	9050	9240	10990	10970	2060	2060	11450	11140	5830	6010
94010308	9310	9470	10890	10980	2240	2240	11430	11190	5910	6090
94010309	9520	9690	11220	11290	2060	2060	11670	11390	5890	5970
94010310	9780	9680	10860	10900	1930	1930	11360	11190	5360	5540
94010313	9710	10050	11160	11050	3260	3260	11440	11230	5870	5970
94010315	9050	9210	10800	10630	2440	2440	11140	10980	5950	6030
94010317	9090	9120	10480	10710	1830	1830	11200	10850	5920	6010
94010318	9310	9210	10720	10820	2110	2110	11120	11100	5600	5830
94010320	8490	8880	11630	11520	2030	2020	11760	11620	5810	5860
94010322	8810	9360	10800	10660	1910	1900	11200	10830	6040	6180
94010323	8620	8890	11070	10860	1890	1890	11120	10990	5450	5570
94010325	8820	8900	10660	10750	1910	1910	11190	11070	6200	6390
94010326	8800	9100	10680	10670	2070	2070	11000	11010	5880	6160
94010327	8270	8660	10960	11000	1990	1990	11360	11230	4850	4960
94010328	9240	9020	10350	10730	1920	1920	11080	11070	4970	5120
94010329	8580	8800	11340	11270	2010	2010	11570	11400	5530	5640

Average	9,031	9,162	10,932	10,980	2,092	2,090	11,380	11,191	5,730	5,872
Maximum	9,780	10,050	11,630	11,520	3,260	3,260	11,850	11,620	6,200	6,390
Minimum	8,270	8,640	10,350	10,630	1,830	1,830	11,000	10,830	4,850	4,960
Range	1,510	1,410	1,280	890	1,430	1,430	850	790	1,350	1,430
Std. Deviation	383	349	280	239	296	296	240	197	337	351
# of Points	21	21	21	21	21	21	21	21	21	21

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	Measured Column Feed Btu/lb	Adjusted Column Feed Btu/lb	Measured Column Product Btu/lb	Adjusted Column Product Btu/lb	Measured Column Reject Btu/lb	Adjusted Column Reject Btu/lb	Measured Thickener Feed Btu/lb	Adj Thic F Bt
94010301	11370	11320	13560	13410	3680	4010	5020	
94010302	11140	11350	13600	13690	4010	4020	4230	
94010303	11290	11260	13540	13600	3270	3580	4560	
94010304	11330	11330	13520	13610	3420	3750	4940	
94010305	11370	11460	13640	13610	3320	3670	5090	
94010307	11150	11140	13460	13570	3220	3610	4940	
94010308	11140	11190	13570	13460	3370	3700	4860	
94010309	11410	11390	13600	13620	3790	4200	5180	
94010310	11010	11190	13630	13690	3070	3330	4380	
94010313	11330	11230	13300	13320	4180	4500	5300	
94010315	10970	10980	13600	13740	3230	3310	4090	
94010317	10860	10850	13400	13480	3450	3730	4480	
94010318	11040	11100	13970	13940	3210	3580	5060	
94010320	11730	11620	13470	13280	3940	4180	4710	
94010322	10960	10830	13470	13390	3090	3330	4240	
94010323	11040	10990	13530	13570	3220	3650	4920	
94010325	10940	11070	13720	13480	3040	3190	4380	
94010326	11370	11010	13790	13750	3640	4040	5780	
94010327	11400	11230	13870	13550	3230	3540	4450	
94010328	11250	11070	13620	13660	3060	3300	4190	
94010329	11340	11400	13730	13630	3580	4020	5200	

Average	11,211	11,191	13,600	13,574	3,430	3,726	4,762	
Maximum	11,730	11,620	13,970	13,940	4,180	4,500	5,780	
Minimum	10,860	10,830	13,300	13,280	3,040	3,190	4,090	
Range	870	790	670	660	1,140	1,310	1,690	
Std.Deviation	207	197	151	151	324	341	431	
# of Points	21	21	21	21	21	21	21	

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	Plant Product Yield (%)	Plant Reject Yield (%)	Plant Energy Recovery (%)	Plant Ash Rejection (%)	Plant Sulfur Rejection (%)	Plant Pyritic Rejection (%)	Plant Separate Efficiency (%)
94010301	56.86	43.14	85.48	89.01	58.47	80.76	66.24
94010302	53.46	46.54	84.71	89.20	68.81	87.52	72.23
94010303	57.45	42.55	86.05	88.12	56.58	77.07	63.12
94010304	56.48	43.52	85.22	88.25	70.64	85.64	70.86
94010305	60.49	39.51	86.93	86.96	58.70	78.78	65.71
94010307	58.84	41.16	86.41	88.32	55.13	76.42	62.83
94010308	60.86	39.14	86.50	86.93	55.83	74.78	61.29
94010309	61.90	38.10	87.00	87.02	53.65	74.73	61.73
94010310	62.19	37.81	87.95	86.11	52.64	76.39	64.34
94010313	64.22	35.78	85.12	82.78	53.24	68.53	53.65
94010315	56.47	43.53	84.25	89.14	62.86	79.72	63.96
94010317	58.22	41.78	86.05	86.76	55.84	73.38	59.43
94010318	56.02	43.98	84.79	89.50	59.38	83.38	68.17
94010320	58.04	41.96	86.80	87.96	58.72	74.35	61.15
94010322	61.12	38.88	87.44	87.46	53.72	68.82	56.25
94010323	56.31	43.69	85.95	89.88	58.93	79.34	65.30
94010325	56.37	43.63	85.38	90.19	62.92	84.82	70.20
94010326	54.53	45.47	82.39	89.77	62.73	84.58	66.97
94010327	54.81	45.19	85.76	90.70	63.83	82.08	67.84
94010328	56.99	43.01	86.31	88.38	57.47	80.00	66.30
94010329	55.06	44.94	85.28	90.01	59.24	80.60	65.88

Average	57.9	42.1	85.8	88.2	59.0	78.7	64.4
Maximum	64.2	46.5	88.0	90.7	70.6	87.5	72.2
Minimum	53.5	35.8	82.4	82.8	52.6	68.5	53.6
Range	10.8	10.8	5.6	7.9	18.0	19.0	18.6
Std.Deviation	2.8	2.8	1.2	1.7	4.7	5.0	4.5
# of Points	21	21	21	21	21	21	21

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	HMC Product Yield (%)	HMC Reject Yield (%)	HMC Energy Recovery (%)	HMC Ash Rejection (%)	HMC Sulfur Rejection (%)	HMC Pyritic Rejection (%)	HMC Heat of Combustion (Btu/lb)
94010301	75.57	24.43	94.55	5.42	44.85	63.89	
94010302	72.74	27.26	94.04	5.90	54.85	67.88	
94010303	77.56	22.44	94.64	5.41	39.75	55.14	
94010304	76.82	23.18	94.53	5.45	56.66	68.69	
94010305	80.53	19.47	95.67	4.32	40.55	55.59	
94010307	80.59	19.41	95.68	4.33	36.66	51.86	
94010308	82.65	17.35	95.83	4.10	36.17	51.57	
94010309	82.62	17.38	96.26	3.69	37.35	53.65	
94010310	86.31	13.69	97.19	2.73	28.33	41.45	
94010313	87.26	12.74	95.94	4.13	31.20	38.47	
94010315	82.70	17.30	95.45	4.58	36.26	46.60	
94010317	82.12	17.88	96.44	3.59	34.04	47.53	
94010318	81.51	18.49	95.76	4.24	36.10	52.57	
94010320	72.26	27.74	93.74	6.31	46.49	58.20	
94010322	85.17	14.83	97.00	3.01	33.90	40.25	
94010323	78.03	21.97	95.32	4.67	40.62	55.74	
94010325	79.10	20.90	95.54	4.49	44.70	63.43	
94010326	81.77	18.23	95.88	4.15	38.03	55.78	
94010327	74.12	25.88	94.15	5.95	47.68	61.32	
94010328	80.55	19.45	95.82	4.14	35.44	50.49	
94010329	73.38	26.62	93.98	6.08	44.95	62.15	

Average	79.7	20.3	95.4	4.6	40.2	54.4	
Maximum	87.3	27.7	97.2	6.3	56.7	68.7	
Minimum	72.3	12.7	93.7	2.7	28.3	38.5	
Range	15.0	15.0	3.4	3.6	28.3	30.2	
Std.Deviation	4.3	4.3	1.0	1.0	7.0	8.3	
# of Points	21	21	21	21	21	21	

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	WOC Product Yield (%)	WOC Reject Yield (%)	WOC Energy Recovery (%)	WOC Ash Rejection (%)	WOC Sulfur Rejection (%)	WOC Pyritic Rejection (%)	WOC Separate Efficiency (%)
94010301	96.74	3.26	98.13	8.07	9.79	20.11	18.24
94010302	96.88	3.12	98.44	7.45	11.97	23.51	21.96
94010303	96.67	3.33	98.24	7.91	10.29	20.11	18.36
94010304	95.60	4.40	97.58	10.21	16.07	27.52	25.10
94010305	95.85	4.15	97.64	9.75	14.83	14.58	12.22
94010307	96.58	3.42	98.07	8.13	10.35	19.36	17.43
94010308	95.92	4.08	97.76	9.19	14.62	22.47	20.22
94010309	98.08	1.92	98.94	4.92	6.68	13.90	12.84
94010310	94.90	5.10	97.43	11.59	16.60	30.62	28.05
94010313	96.40	3.60	97.97	8.17	13.55	21.77	19.74
94010315	92.78	7.22	95.84	14.72	24.18	37.22	33.06
94010317	97.17	2.83	98.45	5.83	10.02	17.30	15.75
94010318	94.66	5.34	97.11	11.86	17.87	31.24	28.35
94010320	98.19	1.81	99.04	4.85	6.56	6.31	5.35
94010322	96.28	3.72	97.81	8.16	11.59	18.04	15.86
94010323	97.45	2.55	98.62	6.03	10.80	16.24	14.85
94010325	93.05	6.95	95.82	15.21	18.55	33.30	29.12
94010326	92.86	7.14	95.82	15.09	19.80	33.71	29.53
94010327	96.25	3.75	98.26	9.73	12.80	22.53	20.79
94010328	94.38	5.62	97.37	13.03	16.17	30.08	27.44
94010329	97.64	2.36	98.77	5.96	8.01	14.47	13.24

Average	95.9	4.1	97.8	9.3	13.4	22.6	20.4
Maximum	98.2	7.2	99.0	15.2	24.2	37.2	33.1
Minimum	92.8	1.8	95.8	4.8	6.6	6.3	5.3
Range	5.4	5.4	3.2	10.4	17.6	30.9	27.7
Std.Deviation	1.6	1.6	0.9	3.2	4.4	7.7	6.9
# of Points	21	21	21	21	21	21	21

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	Column Product Yield (%)	Column Reject Yield (%)	Column Energy Recovery (%)	Column Ash Rejection (%)	Column Sulfur Rejection (%)	Column Pyritic Rejection (%)	Column Sulfur Rejection (%)
94010301	77.77	22.23	92.13	72.87	16.36	33.45	
94010302	75.86	24.14	91.50	75.55	21.56	49.11	
94010303	76.62	23.38	92.54	74.09	19.58	35.51	
94010304	76.91	23.09	92.38	74.46	19.40	36.87	
94010305	78.37	21.63	93.07	71.97	18.45	44.04	
94010307	75.60	24.40	92.09	75.82	20.94	39.28	
94010308	76.77	23.23	92.34	74.09	18.90	33.00	
94010309	76.39	23.61	91.35	74.40	20.75	36.65	
94010310	75.92	24.08	92.89	76.24	20.78	42.30	
94010313	76.34	23.66	90.55	70.15	21.39	34.65	
94010315	73.60	26.40	92.10	78.20	23.03	39.75	
94010317	72.96	27.04	90.64	76.53	25.44	39.31	
94010318	72.60	27.40	91.18	80.50	22.34	49.04	
94010320	81.80	18.20	93.49	64.98	17.35	30.27	
94010322	74.54	25.46	92.16	75.96	20.74	36.55	
94010323	74.05	25.95	91.44	77.14	22.40	44.25	
94010325	76.59	23.41	93.26	77.42	17.94	37.95	
94010326	71.82	28.18	89.69	78.73	24.98	47.94	
94010327	76.83	23.17	92.70	75.22	20.41	40.15	
94010328	74.97	25.03	92.51	76.78	21.52	42.17	
94010329	76.85	23.15	91.88	74.75	19.46	39.73	

Average	75.9	24.1	92.0	75.0	20.7	39.6	
Maximum	81.8	28.2	93.5	80.5	25.4	49.1	
Minimum	71.8	18.2	89.7	65.0	16.4	30.3	
Range	10.0	10.0	3.8	15.5	9.1	18.8	
Std.Deviation	2.2	2.2	0.9	3.2	2.2	5.1	
# of Points	21	21	21	21	21	21	

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	% (abs.) of Raw Coal's Energy to:			% (abs.) of Raw Coal's Pyrite to:		
	HMC Reject	WOC Reject	Column Reject	HMC Reject	WOC Reject	Column Reject
94010301	5.5	1.7	7.3	64.0	7.1	9.7
94010302	6.0	1.5	7.8	67.7	7.6	12.2
94010303	5.4	1.7	6.9	55.5	8.9	12.7
94010304	5.5	2.3	7.0	68.5	8.9	8.3
94010305	4.3	2.2	6.5	55.5	6.6	16.7
94010307	4.3	1.8	7.5	52.0	9.2	15.2
94010308	4.2	2.2	7.2	51.6	10.8	12.4
94010309	3.7	1.0	8.3	53.8	6.5	14.5
94010310	2.8	2.5	6.7	41.7	17.8	17.0
94010313	4.1	1.9	9.0	38.5	13.6	16.5
94010315	4.5	3.9	7.3	46.7	19.8	13.2
94010317	3.6	1.5	8.9	47.2	9.5	16.7
94010318	4.2	2.8	8.2	52.7	14.6	16.1
94010320	6.3	0.9	6.1	58.4	4.9	11.1
94010322	3.0	2.1	7.5	40.0	11.0	17.8
94010323	4.7	1.2	8.1	55.4	7.4	16.5
94010325	4.5	3.9	6.2	63.2	12.3	9.3
94010326	4.1	4.0	9.5	55.7	15.0	13.9
94010327	5.9	1.6	6.8	61.2	8.9	12.0
94010328	4.2	2.6	6.9	50.7	14.9	14.4
94010329	6.0	1.1	7.6	62.2	5.6	12.8

Average	4.6	2.1	7.5	54.4	10.5	13.8
Maximum	6.3	4.0	9.5	68.5	19.8	17.8
Minimum	2.8	0.9	6.1	38.5	4.9	8.3
Range	3.4	3.1	3.5	30.1	15.0	9.5
Std.Deviation	1.0	0.9	0.9	8.3	4.0	2.7
# of Points	21	21	21	21	21	21

**Illinois No. 6 Seam
Long Duration Tests**

Test Number	% of Total Energy Losses			% of Total Pyrite Rejection		
	HMC Reject	WOC Reject	Column Reject	HMC Reject	WOC Reject	Co Re
94010301	37.6	11.9	50.6	79.2	8.8	
94010302	39.0	9.7	51.3	77.4	8.7	
94010303	38.4	11.9	49.7	72.0	11.5	
94010304	37.0	15.4	47.7	80.0	10.3	
94010305	33.2	16.8	50.0	70.4	8.4	
94010307	31.8	13.2	55.0	68.1	12.0	
94010308	30.9	16.1	53.0	69.0	14.5	
94010309	28.8	7.5	63.7	71.9	8.7	
94010310	23.3	20.9	55.8	54.5	23.3	
94010313	27.3	12.5	60.2	56.2	19.8	
94010315	28.9	24.8	46.4	58.5	24.9	
94010317	25.5	11.0	63.5	64.3	13.0	
94010318	27.9	18.1	54.0	63.2	17.5	
94010320	47.4	6.5	46.1	78.5	6.6	
94010322	23.9	16.7	59.5	58.2	16.0	
94010323	33.3	8.9	57.8	69.8	9.4	
94010325	30.5	27.0	42.5	74.5	14.5	
94010326	23.4	22.5	54.1	65.9	17.7	
94010327	41.1	11.2	47.7	74.6	10.8	
94010328	30.5	18.7	50.7	63.4	18.6	
94010329	40.9	7.5	51.5	77.1	7.0	

Average	32.4	14.7	52.9	68.9	13.4	
Maximum	47.4	27.0	63.7	80.0	24.9	
Minimum	23.3	6.5	42.5	54.5	6.6	
Range	24.1	20.5	21.2	25.5	18.3	
Std.Deviation	6.4	5.6	5.6	7.7	5.2	
# of Points	21	21	21	21	21	

APPENDIX C

SEMI-WORKS PLANT COST DATA AND DRAWINGS

PROCESS , SAMPLING , AND LABORATORY EQUIPMENT

FOR 20 TPH SEMI-WORKS PLANT

PROCESS, SAMPLING, AND LABORATORY EQUIPMENT (FACILITY 500)

20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN

ICF KAISER ENGINEERS PROJECT NUMBER 88107-250-00

EQUIPLST.wk3

TASK 15 : 20 TONS PER HOUR, SEMI-WORKS FLOWSHEET

EQUIP. NO.	DESCRIPTION	# OF UNITS	WEIGHT	PRICE	UNIT HP	TOTAL HP	ENCL	VOLTS	RPM	MOTOR SUPPLIED	COMMENTS
100	PLANT FEED CONVEYOR	-	-	by others	-	-	-	-	-	-	BY OTHERS
105	BELT MAGNET	1	1,615	4,934	-	-	-	-	-	-	ERIEZ MODEL SE7235MCI
105.1	BELT MAGNET RECTIFIER	1	210	1,771	-	-	-	-	-	-	ERIEZ MODEL 36C 1800 WATTS
110	RAW COAL CRUSHER	1	12,000	37,100	50.00	50.00	TEFC	480	1800	YES	GUNDLACH 45 DA
111	RAW COAL CRUSHER	1	12,000	79,500	50.00	50.00	TEFC	480	1800	YES	GUNDLACH 45 DA
112	RAW COAL SCREEN	1	5,000	16,960	7.50	7.50	TEFC	480	1800	YES	TABOR 4X12 VIBRAT. INCLINED
113	OVERSIZE BUCKET ELEVATOR	1	15,000	25,355	10.00	10.00	TEFC	480	1800	YES	GOODMAN
120	RAW COAL FEED PUMP	1	5,000	13,627	15.00	15.00	TEFC	480	1800	YES	GOYNE PUMP
135	REFUSE CENTRIFUGE DRIVE	1	5,000	86,920	10.00	10.00	TEFC	480	1800	YES	CMI HVC-20
135.1	REFUSE CENTRIFUGE VIBRATOR	1	-	Included	7.50	7.50	TEFC	480	1800	YES	CMI HVC-20
135.2	REFUSE CENTRIFUGE OIL PUMP	1	-	Included	0.50	0.50	TEFC	480	1800	YES	CMI HVC-20
140	DESLIME SIEVE BEND	2	3,360	9,752	-	-	-	-	-	-	3'W,80'R,60,.35 MM,3/32 ISO
145	DESLIME SCREEN	1	9,000	20,670	10.00	10.00	TEFC	480	1800	YES	TABOR 4X12 SD VIB. HORIZONTAL
150	MIDDINGS CRUSHER DRIVE 1	1	12,000	125,811	100.00	100.00	TEFC	480	1800	YES	GUNDLACH CAGEPACTOR
150.1	MIDDINGS CRUSHER DRIVE 2	1	-	Included	75.00	75.00	TEFC	480	1800	YES	SAME
152	OVERSIZE PROTECTION PUMP	1	5,000	12,912	40.00	40.00	TEFC	480	1800	YES	GOYNE PUMP
153	OVERSIZE PROTECTION SIEVE BEND	2	5,600	10,600	-	-	-	-	-	-	5'W,40'R,60,.35 MM,3/32 ISO
160	FINE HYDRO FEED PUMP	1	5,000	14,578	60.00	60.00	TEFC	480	1800	YES	GOYNE PUMP
165	FINE HYDROCYCLONES	5	15,600	83,475	-	-	-	-	-	-	KREBS 10' DIAMETER W/STAND
205	CLASSIFYING CYCLONE PUMP	1	5,000	30,493	200.00	200.00	TEFC	480	1800	YES	GOYNE PUMP
207	CLASSIFYING CYCLONES	8	17,640	127,624	-	-	-	-	-	-	KREBS 10' DIAMETER W/STAND
208	VARI-SIEVE	2	7,500	103,414	-	-	-	-	-	-	KREBS 5'W VARI-SIEVE
210	BALL MILL	1	186,000	606,320	750.00	750.00	TEFC	4160	900	YES	10' DIA. X 6' CONICAL BALL MILL
220	ADVANCED FLOTATION FEED PUMP	1	5,000	25,803	100.00	100.00	TEFC	480	1800	YES	GOYNE PUMP
230	ADVANCED FLOTATION CELL	4	46,000	466,400	-	-	-	-	-	-	ICF KE MICROCEL™ MODEL 12025
230.1	ADVANCED FLOTATION PUMP	4	5,000	Included	75.00	300.00	TEFC	480	1800	YES	GOYNE PUMP
240	COAL STATIC THICKENER DRIVE	1	17,000	68,900	3.00	3.00	TEFC	480	1800	YES	EIMCO 50' DIAMETER HIRATE
240.1	COAL STATIC THICKENER LIFTING DEVICE	1	-	Included	1.00	1.00	TEFC	480	900	YES	SAME
247	COAL THICK. CLARIFIED WATER PUMP	1	5,000	30,152	200.00	200.00	TEFC	480	1800	YES	GOYNE PUMP
249	COAL STATIC THICKENER U'FLOW PUMP	1	5,000	12,207	25.00	25.00	TEFC	480	1800	YES	GOYNE PUMP
260	CLEAN COAL FILTER DRIVE	1	122,000	1,228,710	10.00	10.00	TEFC	480	1800	YES	ANDRITZ RUTHNER, INC.
260.1	AGITATOR	3	-	Included	1.50	4.50	TEFC	480	1800	YES	SAME
260.2	DISCHARGE GATES	1	-	Included	30.00	30.00	TEFC	480	1800	YES	SAME
260.3	AIR COMPRESSOR	1	8,000	52,391	200.00	200.00	TEFC	480	1800	YES	AIRTEC
260.4	FILTRATE PUMP	1	5,000	8,509	5.00	5.00	TEFC	480	1800	YES	GOYNE PUMP

UNITED STATES DEPARTMENT OF ENERGY

REVISION 0

PROCESS, SAMPLING, AND LABORATORY EQUIPMENT (FACILITY 500)20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
ICF KAISER ENGINEERS PROJECT NUMBER 88107-250-00

EQUIPLST.wk3

TASK 15 : 20 TONS PER HOUR, SEMI-WORKS FLOWSHEET

EQUIP. NO.	DESCRIPTION	# OF UNITS	WEIGHT	PRICE	UNIT HP	TOTAL HP	ENCL	VOLTS	RPM	MOTOR SUPPLIED	COMMENTS
260.5	LUBRICATOR	1	—	included	1.00	1.00	TEFC	480	1800	YES	ANDRITZ RUTHNER, INC.
260.6	AUXILIARY AIR COMPRESSOR	1	5,000	included	7.50	7.50	TEFC	480	1800	YES	SAME
260.7	INTERNAL CONVEYOR	1	—	included	10.00	10.00	TEFC	480	1800	YES	SAME
265	CLEAN COAL BELT	—	—	by others	—	—	—	—	—	—	BY OTHERS
275	REFUSE STATIC THICKENER DRIVE	1	17,000	74,200	3.00	3.00	TEFC	480	1800	YES	EIMCO 60' DIAMETER HIRATE
275.1	REF. STATIC THICKENER LIFTING DEVICE	1	—	included	1.00	1.00	TEFC	480	900	YES	SAME
290	REF. STATIC THICKENER U'FLOW PUMP	1	5,000	13,928	30.00	30.00	TEFC	480	1800	YES	GOYNE PUMP
315	REFUSE CONVEYOR	—	—	by others	—	—	—	—	—	—	BY OTHERS
325	HEAVY MEDIA CYCLONE PUMP	1	5,000	16,797	75.00	75.00	TEFC	480	1800	YES	GOYNE PUMP
330	HEAVY MEDIA CYCLONE	1	1,350	79,394	—	—	—	—	—	—	KREBS 20' DIAMETER CERAMIC
335	MIDS SIEVE BEND	1	2,200	4,876	—	—	—	—	—	—	3'W,80'R,60,.5 MM,3/32 ISO
340	MIDS DRAIN & RINSE SCREEN	1	18,000	23,320	20.00	20.00	TEFC	480	1800	YES	TABOR 4X16 SD VIB. HORIZONTAL
345	REFUSE SIEVE BEND	1	2,800	2,332	—	—	—	—	—	—	3'W,40'R,60,.5 MM,3/32 ISO
350	REFUSE DRAIN & RINSE SCREEN	1	12,000	23,320	15.00	15.00	TEFC	480	1800	YES	TABOR 4X16 SD VIB. HORIZONTAL
375	DILUTE MEDIA PUMP	1	5,000	11,546	10.00	10.00	TEFC	480	1800	YES	GOYNE PUMP
380	MAGNETIC SEPARATOR	1	4,700	16,960	5.00	5.00	TEFC	480	1800	YES	ERIEZ 36' DIAMETER X 9'W
385.1	MAGNETITE BIN DUST COLLECTOR	1	1,000	7,579	2.00	2.00	TEFC	480	1800	YES	AAF
390	MAGNETITE ROTARY VALVE	1	1,000	2,899	5.00	5.00	TEFC	480	1800	YES	ANDRITZ SPROUT-BAUER
395	INSTRUMENT AIR COMPRESSOR	1	2,000	12,036	25.00	25.00	TEFC	480	1800	YES	AIRTEC
395.1	INSTRUMENT AIR DRYER	1	500	included	—	—	—	—	—	—	SAME
395.2	PREFILTERS	1	500	included	—	—	—	—	—	—	SAME
395.3	AFTER FILTERS	2	750	included	—	—	—	—	—	—	SAME
398	PLANT & COLUMN AIR COMPRESSOR	1	8,000	52,391	200.00	200.00	TEFC	480	1800	YES	AIRTEC
398.1	PREFILTERS	1	500	included	—	—	—	—	—	—	SAME
398.2	AFTER FILTERS	2	750	included	—	—	—	—	—	—	SAME
400	FLOCCULANT SYSTEM	1	—	see below	—	—	—	—	—	—	MINETEC
400.1	ANIONIC FEEDER	1	500	1,272	0.13	0.13	TEFC	110	1800	YES	SAME
400.2	ANIONIC MIXER	1	500	1,590	1.00	1.00	TEFC	480	1800	YES	SAME
400.3	ANIONIC MIX TANK	1	1,000	4,240	—	—	—	—	—	—	SAME
400.4	ANIONIC HOLDING TANK	1	1,000	5,300	—	—	—	—	—	—	SAME
400.5	ANIONIC METERING PUMP	2	450	3,721	0.50	1.50	TEFC	110	1800	YES	SAME
400.6	CATIONIC HOLDING TANK	1	1,000	6,360	—	—	—	—	—	—	SAME
400.7	CATIONIC METERING PUMP	2	200	3,721	0.25	0.50	TEFC	110	1800	YES	SAME
400.8	SETTLING RATE DETECTOR	2	2,000	38,775	—	—	—	110	—	—	SAME
400.9	WATER CLARITY MEASUREMENT	2	1,800	8,946	—	—	—	110	—	—	SAME

PROCESS, SAMPLING, AND LABORATORY EQUIPMENT (FACILITY 500)20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
ICF KAISER ENGINEERS PROJECT NUMBER 88107-250-00

EQUIPLST.wk3

TASK 15 : 20 TONS PER HOUR, SEMI-WORKS FLOWSHEET

EQUIP. NO.	DESCRIPTION	# OF UNITS	WEIGHT	PRICE	UNIT HP	TOTAL HP	ENCL	VOLTS	RPM	MOTOR SUPPLIED	COMMENTS
400.10	pH REAGENT PUMP	1	540	1,860	0.50	0.50	TEFC	110	1800	YES	SAME
405	REAGENT SYSTEM	1	—	see below	—	—	—	—	—	—	SAME
405.1	FROTHER BULK STORAGE	1	5,000	2,385	—	—	—	—	—	—	SAME
405.2	FROTHER TRANSFER PUMP	1	500	3,721	10.00	10.00	TEFC	480	1800	YES	SAME
405.3	FROTHER DAY TANK	1	—	3,180	—	—	—	—	—	—	SAME
405.4	FROTHER REAGENT PUMPS	4	1,400	7,441	0.25	1.00	TEFC	110	1800	YES	SAME
405.5	COLLECTOR BULK STORAGE	1	5,000	2,385	—	—	—	—	—	—	SAME
405.6	COLLECTOR TRANSFER PUMP	1	500	3,721	10.00	10.00	TEFC	480	1800	YES	SAME
405.7	COLLECTOR DAY TANK	1	—	3,180	—	—	—	—	—	—	SAME
405.8	COLLECTOR REAGENT FEEDERS	4	1,400	7,441	0.25	1.00	TEFC	110	1800	YES	SAME
415	OVERDENSE MEDIA PUMP	1	5,000	8,678	10.00	10.00	TEFC	480	1800	YES	GOYNE PUMP
430	BALL MILL OVERHEAD CRANE HOIST	1	5,000	44,520	25.00	25.00	TEFC	480	1800	YES	TERN
430.1	BALL MILL OVERHEAD CRANE TRAM	1	—	8,480	10.00	10.00	TEFC	480	1800	YES	TERN
435	LABORATORY EQUIPMENT	—	—	see below	—	—	—	—	—	—	PREISER SCIENTIFIC
435.1	OVEN	1	2,500	7,632	0.25	0.25	TEFC	480	1800	YES	SAME
435.2	OVEN	1	3,000	2,862	0.25	0.25	TEFC	480	1800	YES	SAME
435.3	TABLE	1	150	403	—	—	—	—	—	—	SAME
435.4	DESK	1	125	785	—	—	—	—	—	—	SAME
435.5	EXHAUST HOOD	1	450	2,424	0.75	0.75	TEFC	480	1800	YES	SAME
435.6	CABINETS	1	1,250	1,985	—	—	—	—	—	—	SAME
485	CLEAN-UP PUMP	1	5,000	5,599	7.50	7.50	TEFC	480	1800	YES	GOYNE PUMP
495	GLAND WATER PUMP	1	2,500	3,407	5.00	5.00	TEFC	480	1800	YES	GOYNE PUMP
500.1	SLURRY SAMPLERS	3	7,000	14,930	5.00	15.00	TEFC	480	1800	YES	ESTIMATED
500.2	DRY SAMPLERS	2	5,250	13,483	5.00	10.00	TEFC	480	1800	YES	ESTIMATED
500.13	AUTOMATIC FLOC MIXING SYSTEM	1	2,000	16,483	1.50	1.50	TEFC	480	1800	YES	ESTIMATED
	OTHER MOTORS				38.00	38.00					
TOTAL VALUES			700,590	3,887,376		2822					HEATING LOAD 715 KW

DETAILED CAPITAL COST ESTIMATE

**ESTIMATE CRITERIA
FOR
ENGINEERING DEVELOPMENT OF
ADVANCE PHYSICAL FINE COAL
CLEANING TECHNOLOGIES - FROTH FLOTATION
PREPARED FOR
U.S. DEPARTMENT OF ENERGY
PITTSBURGH ENERGY TECHNOLOGY CENTER
PITTSBURGH, PA.**

**TYPE 3 PRELIMINARY COST ESTIMATE
PREPARED BY
ICF KAISER ENGINEERS, INTERNATIONAL
PITTSBURGH, PA**

SCOPE OF WORK

The Department of Energy has commissioned ICF Kaiser Engineers International to develop generic facility for the cleaning of fine coal using the advance froth floatation technology. The facility is based on processing 41.5 tons of raw coal per hour.

PURPOSE

Provide a preliminary cost estimate for a generic advance froth flotation coal cleaning facility based on the plant being located in the Greater Pittsburgh Area. This plant could be built anywhere within the United States.

DRAWINGS AND SPECIFICATIONS

The specifications and drawings were prepared by ICF KE. The specifications and drawings are based on the test results from the laboratory and proof-of concept plant.

ESTIMATE FORMAT

The estimate utilizes ICF KE's interactive estimating system(UEST) and is formatted to show quantities, manhours, labor cost, construction equipment usage, material and equipment, subcontracts, indirect costs, contractor's overhead and profit, and total dollars for each cost element.

The estimate is an ICF KE Type 3, Preliminary Estimate as defined by the attached estimate type sheets.

QUANTITIES

Quantities for the estimate were developed from the drawings provided and estimators judgement.

DOE

MATERIALS

Material pricing is based on vendor quotes or in house information that was used to revise the IES estimating system.

EQUIPMENT

Quotation from vendors were received for all the equipment.

LABOR RATES

The IEST project database was updated using the UMW craft labor rates as quoted by Lincoln Contracting Company to establish a crew rate. Crew rate consist of journeymen, foreman, general foreman for the various types of erection work elements. These rates include:

- Base Rate
- Fringe Benefits
- Payroll Taxes and Insurance
- Small Tools
- Overhead and Profit

CONSTRUCTION EQUIPMENT USAGE

The cost of construction equipment rental is based on the blue book rental cost and includes fuel and maintenance. Equipment usage is included for each line item in the estimate.

SITE

This is a generic plant and no site has been selected.

SCHEDULE

A construction schedule has not been prepared, however the estimate is based on a twelve(12) month duration for construction.

PROJECT INDIRECT COSTS

Subcontractor's overhead and profit is included with each line item cost element as follows:

Labor Rates include OH &P
10 % on Equipment Usage
10% on material
10% on construction indirects

PROJECT DISTRIBUTABLE COST

The following distributables are included in this estimate:

Project Management
Construction Management
Allowance for Site Specific Engineering

DOE

SALE TAX

Sales tax has been excluded.

COST EXCLUSIONS

- Permits and Licenses
- Finance Charges
- Owner's Cost
- Land and Right of Way
- Soil Investigation
- Environmental Reports
- Legal Services
- Utilities

CONTINGENCY

The estimate contains contingency at 5% to provide for unforeseen events which statistically are bound to occur during the life of the project.

ESCALATION

Escalation has been excluded.

ESTIMATE DISCUSSION

The project was commissioned by the Department Of Energy to determine the feasibility of cleaning coal by the advance froth flotation process. A preliminary cost estimates was prepared with no specify site selected. Estimate cost were based on the plant being constructed in the Greater Pittsburgh Area.

DOE

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT S1 - ESTIMATE SUMMARY BY FACILITY

PAGE 1
DATE: 07/13/94 14:02
BY

WORK BREAKDWN FACIL.STANDRD	DESCRIPTION	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
200	CONCRETE AND FOUNDATIONS	6512	239827	24678	141066	0	0	16578	422149
300	STRUCTURAL STEEL	5236	204788	29719	489556	0	0	51928	775991
400	ARCHITECTURAL WORK	3148	113985	3126	187882	0	0	19103	324096
500	EQUIPMENT INSTALLATION	12080	469655	98705	187620	0	3887376	28632	4671988
600	PIPING	4835	188767	25478	157284	0	0	18286	389815
675	MECHANICAL	1465	57149	5449	14325	0	100759	1981	179663
700	ELECTRICAL AND INSTRUMENTATION	14003	624051	38033	234657	72	687426	27274	1611513
900	INDIRECTS AND DISTRIBUTABLES	960	35860	4205	57452	10000	0	6166	113683
901	ENGINEERING	0	0	0	0	600000	0	0	600000
902	PROJECT/CONSTRUCTION MANAGEMENT	0	0	0	0	600000	0	0	600000
903	FIELD OFFICE EXPENSES	80	2940	372	33496	1000	0	0	37808
904	INSURANCE/TAXES/PERMITS/	0	0	0	173840	0	0	0	173840
REPORT TOTAL		48,319	1,937,022	229,765	1,677,178	1,211,072	4,675,561	169,948	9,900,546
ICFKE PROFIT/FEE @ 5%									495,027
SUBTOTAL									10,395,573
PROJECT CONTINGENCY @ 5%									519,779
GRAND TOTAL									10,915,352

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
=====		=====	=====	=====	=====	=====	=====	=====	=====	=====	=====
200		CONCRETE AND FOUNDATIONS									
200	.131102 .	EXCAVATION MASS-1.5CY BACKHOE BUILDING FOUNDATION	880 CY	29	1060	339	0	0	0	34	1433
200	.1311021.	EXCAVATION MASS-1.5CY BACKHOE EQUIPMENT FOUNDATIONS	65 CY	2	73	25	0	0	0	3	101
200	.134910 .	DISPOSAL- 10 MI ROUND TRIP 10-12 CY TRUCK BUILDING FOUNDATION	880 CY	80	3106	1741	0	0	0	174	5021
200	.1349101.	DISPOSAL- 10 MI ROUND TRIP 10-12 CY TRUCK EQUIPMENT FOUNDATION	65 CY	6	233	129	0	0	0	13	375
200	.1349102.	DISPOSAL- 10 MI ROUND TRIP 10-12 CY TRUCK	57 CY	5	194	113	0	0	0	11	318
200	.141100 .	50' CLEAN COAL THICKENER EXCAVATION STRUCT. FOR MAT	95 CY	4	143	139	0	0	0	14	296
200	.1411001.	50' CLEAN COAL THICKENER EXCAVATION STRUCT. FOR MAT	114 CY	5	179	167	0	0	0	17	363
200	.142210 .	55' REFUSE THICKENER BACKFILL STRUCTURAL AGGREGATE	38 CY	8	290	40	367	0	0	41	738
200	.1422101.	50' CLEAN COAL THICKENER BACKFILL STRUCTURAL AGGREGATE	13 CY	3	109	14	125	0	0	14	262
200	.1422102.	EQUIPMENT FOUNDATIONS BACKFILL STRUCTURAL AGGREGATE	35 CY	7	253	37	338	0	0	38	666
200	.1422103.	OFFICE AREA BACKFILL STRUCTURAL AGGREGATE	46 CY	9	326	48	444	0	0	49	867
200	.142212 .	55' REFUSE THICKENER BACKFILL STRUCTURAL AGGREGATE	228 CY	46	1665	238	2199	0	0	244	4346
200	.211000 .	BUILDING FOUNDATION FORMS - BUILDING FOUNDATION	2500 SF	500	17043	308	1961	0	0	227	19539
200	.212300 .	REBAR-CONTINUOUS FOOTINGS BUILDING FOUNDATION	87500 LB	875	34322	5203	20405	0	0	2561	62491
200	.213000 .	EMBEDDED METALS-BLDG FDNS	1400 LB	85	3025	0	2226	0	0	223	5474
200	.214100 .	CONCRETE-FOOTINGS & PEDESTALS 3000 PSI BUILDING FOUNDATION	700 CY	862	31322	5240	37842	0	0	4308	78712
200	.220000 .	COLUMN CONCRETE OFFICE AREA	22 CY	220	8084	1023	2665	0	0	369	12141
200	.221000 .	FORMS-EQUIP FOUNDATIONS	340 SF	89	3034	55	551	0	0	61	3701
200	.221400 .	FORMS-RING FOUNDATIONS 50' CLEAN COAL THICKENER	4200 SF	788	30250	486	6455	0	0	694	37885
200	.221405 .	FORMS-RING FOUNDATIONS 55' REFUSE THICKENER	4600 SF	863	33129	532	7070	0	0	760	41491
200	.221500 .	FORMS-SMALL PIERS	805 SF	193	6579	119	1152	0	0	127	7977
200	.222000 .	REBAR-EQUIP FOUNDATIONS	6500 LB	55	2229	325	1516	0	0	184	4254

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 2
DATE: 07/13/94 13:27
BY

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
200	.222400	REBAR-RING FOUNDATIONS 50' CLEAN COAL THICKENER	7400 LB	71	2785	422	1726	0	0	215	5148
200	.222405	REBAR-RING FOUNDATIONS 55' REFUSE THICKENER	7800 LB	75	2942	445	1819	0	0	226	5432
200	.222500	REBAR-SMALL PIERS	3125 LB	31	1256	184	729	0	0	91	2260
200	.223000	EMBEDDED METALS-EQUIP FDNS	260 LB	13	463	0	413	0	0	41	917
200	.223400	EMB METALS-RING FOUNDATIONS 50' CLEAN COAL THICKENER	400 LB	20	786	0	636	0	0	64	1486
200	.223405	EMB METALS-RING FOUNDATIONS 55' REFUSE THICKENER	400 LB	20	786	0	636	0	0	64	1486
200	.223500	EMBEDDED METALS-SM PIERS	100 LB	5	178	0	159	0	0	16	353
200	.224000	CONCRETE-EQUIP FOUNDATIONS 3000 PSI	52 CY	90	2759	550	2811	0	0	336	6456
200	.224403	CONCRETE-RING FDNS-PUMPED 3000 PSI	75 CY	125	4528	692	4055	0	0	475	9750
200	.224404	CONCRETE-RING FDNS-PUMPED 3000 PSI	80 CY	133	4818	738	4325	0	0	506	10387
200	.224500	CONCRETE - SMALL PIERS, 3000 PSI	25 CY	45	1380	276	1352	0	0	163	3171
200	.231100	FORMS - MAT FOUNDATIONS 50' CLEAN COAL THICKENER	120 SF	20	768	12	93	0	0	11	884
200	.2311001	FORMS - MAT FOUNDATIONS 55' REFUSE THICKENER	132 SF	22	845	14	102	0	0	12	973
200	.232100	REBAR - MAT FOUNDATIONS 50' CLEAN COAL THICKENER	12875 LB	129	5060	766	3002	0	0	377	9205
200	.2321001	REBAR - MAT FOUNDATIONS 55' REFUSE THICKENER	15000 LB	150	5884	892	3498	0	0	439	10713
200	.233150	ANCHOR BOLTS-MAT FOUNDATIONS 50' CLEAN COAL THICKENER	120 LB	5	197	0	191	0	0	19	407
200	.2331501	ANCHOR BOLTS-MAT FOUNDATIONS 55' REFUSE THICKENER	120 LB	5	197	0	191	0	0	19	407
200	.234103	CONCRETE - MAT FDNS PUMPED 3000 PSI	105 CY	49	1775	269	5676	0	0	595	8315
200	.2341031	CONCRETE - MAT FDNS PUMPED 3000 PSI	120 CY	55	1992	307	6487	0	0	679	9465
200	.241300	FORMS - SUSPENDED SLAB	1420 SF	241	8262	195	1641	0	0	184	10282
200	.242300	REBAR - SUSPENDED SLAB	11400 LB	114	4617	673	2658	0	0	333	8281
200	.244303	CONCRETE - SUSPENDED SLAB PUMPED, 3000 PSI	230 CY	347	10455	1922	12434	0	0	1436	26247
200	.431306	VAPOR BARRIER-6 MIL POLY OFFICE AREA	1200 SF	3	103	0	22	0	0	2	127

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--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG			DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
200	.432212	.	F.G.INSULATION RIGID - WALL 2" THICK - R8.3 OFFICE AREA	1200 SF	10	343	0	1094	0	0	109	1546
TOTAL CONCRETE AND FOUNDATIONS					6,512	239,827	24,678	141,066	0	0	16,578	422,149
300			STRUCTURAL STEEL									
300	.310110	.	STRUCTURAL STEEL - LIGHT UP TO 25LB/LF	49 TON	980	38269	5669	110113	0	0	11578	165629
300	.3101101.		STRUCTURAL STEEL - LIGHT EQUIPMENT FOUNDATIONS	560 LB	8	312	45	712	0	0	76	1145
300	.310120	.	STRUCTURAL STEEL - MEDIUM 25 LB/LF TO 49LB/LF	190 TON	2850	111293	16486	314184	0	0	33067	475030
300	.310130	.	STRUCTURAL STEEL - HEAVY OVER 50 LB/LF	15 TON	180	7029	1041	20352	0	0	2139	30561
300	.321110	.	GRATING -PLATFORMS, GALV.STL	661 SF	99	4072	398	7882	0	0	828	13180
300	.322105	.	1/4" PLATEWORK @ SUMPS	690 LB	8	314	33	775	0	0	81	1203
300	.324000	.	STAIR INCLUDING SUPPORT STEEL & HANDRAIL	101 LF	162	6372	1385	8672	0	0	1006	17435
300	.325100	.	LADDERS WITH CAGE	10 LF	7	277	48	578	0	0	63	966
300	.331200	.	PLATEWORK	6 TON	240	9367	1364	15264	0	0	1663	27658
300	.399110	.		260 TON	702	27483	3250	11024	0	0	1427	43184
TOTAL STRUCTURAL STEEL					5,236	204,788	29,719	489,556	0	0	51,928	775,991
400			ARCHITECTURAL WORK									
400	.284109	.	10" THICK PRECAST DOOR LINTELS	93 LF	16	622	200	1949	0	0	215	2986
400	.353186	.	METAL STUDS AND JOISTS, GALV. 18 GA., 6"	572 LF	13	510	53	609	0	0	66	1238
400	.415210	.	CMU BLOCK WALLS, 10" EVERY OTHER CELL GROUTED 1 LB REBAR/SF	3871 SF	503	17921	394	12023	0	0	1242	31580
400	.4152101.		CMU BLOCK WALLS, 10" LINTEL BLOCK	437 LF	78	2779	61	5605	0	0	567	9012
400	.415406	.	CMU BLOCK WALLS, 6" LINTEL BLOCK AT TOP OF WALL	126 LF	22	784	17	821	0	0	84	1706
400	.432111	.	INSULATION, 3-1/2" BATT-R11 FOIL FACED	4187 SF	21	819	0	1021	0	0	102	1942
400	.434618	.	SIDING GALV RIBBED STL 18GA	16632 SF	685	23526	615	53189	0	0	5380	82710
400	.434622	.	SIDING GALV RIBBED STL 22GA	7863 SF	331	12191	298	20979	0	0	2128	35596
400	.434624	.	SIDING GALV RIBBED STL 24GA	20924 SF	871	32082	795	52565	0	0	5336	90778
400	.437100	.	FLASHING METAL, AVG.	1025 SF	62	2420	0	2499	0	0	250	5169

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 4
DATE: 07/13/94 13:27
BY

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG	DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
400 .441012 .	DOOR HM SINGLE, 20 GA.W/FRAME AND HEAVY HARDWARE AVG.	15 EA	67	2368	0	11852	0	0	1185	15405
400 .441062 .	DOOR, HM, DOUBLE, 18GA.W.FRAME & HEAVY HARDWARE AVG. FIRERATED	1 EA	4	141	0	1311	0	0	131	1583
400 .441065 .	DOUBLE HM DOOR W/HEAVY HARDWARE 4' X 10'	1 EA	8	313	0	1908	0	0	191	2412
400 .441214 .	DOUBLE HM DOOR W/HEAVY HARDWARE 4' X 7'	3 EA	15	586	0	4770	0	0	477	5833
400 .441603 .	TRANSOM REMOVABLE	34 SF	9	352	0	541	0	0	54	947
400 .443200 .	DOOR ROLL-UP (NO OPERATOR)	200 SF	32	1323	0	2258	0	0	226	3807
400 .443280 .	MOTOR OPERATOR AND SAFETY BAR FOR ROLL-UP DOOR	2 EA	8	331	0	2406	0	0	241	2978
400 .445220 .	WINDOW-STL INSULATED GLASS	32 SF	3	118	0	397	0	0	40	555
400 .446113 .	TEMPERED GLASS	13 SF	3	117	0	103	0	0	10	230
400 .454311 .	TERRAZZO CAST-IN-PLACE 1-3/4", GRAY CEMENT	1400 SF	98	3632	182	2834	0	0	302	6950
400 .454326 .	TERRAZZO BASE CAST-IN-PLACE 6"	247 SF	17	630	31	270	0	0	30	961
400 .455100 .	CEILING MINERAL FIBER SUSPEND	1470 SF	34	1329	0	1901	0	0	190	3420
400 .456186 .	FLR BASE VINYL/RUBBER 6"	62 LF	2	78	0	39	0	0	4	121
400 .459111 .	PAINTING - MASONRY BLOCK WALL 2 COATS BRUSHED	15000 SF	150	5265	480	1113	0	0	159	7017
400 .461505 .	WASTE RECEPTACLES W/SWING TOP 13 GAL. CAP. #2250	5 EA	20	782	0	806	0	0	81	1669
400 .461510 .	PAPER TOWEL DISPENSER W/MIRROR AND SOAP DISPENSER SURFACE MOUNTED #B3309	4 EA	16	625	0	1153	0	0	115	1893
400 .461515 .	PAPER TOWEL DISPENSER SURFACE MOUNTED #262	2 EA	4	156	0	87	0	0	9	252
400 .461520 .	SOAP DISPENSER (LIQUID) SURFACE MOUNTED #B150	2 EA	4	156	0	22	0	0	2	180
400 .461525 .	MIRROR (24 X 30) AND SHELF #B292	1 EA	4	156	0	131	0	0	13	300
400 .461530 .	TOILET TISSUE DISPENSER DOUBLE ROLL W/SHELF #B28407	2 EA	4	156	0	242	0	0	24	422
400 .461535 .	SANITARY NAPKIN DISPENSER /SURFACE MOUNTED #B282	1 EA	4	156	0	297	0	0	30	483
400 .461540 .	SANITARY NAPKIN DISPOSAL W/UTILITY SELF-SERVICE MOUNTED #B271	1 EA	4	156	0	38	0	0	4	198

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400	.461545	COAT HOOK STRIP (3 HOOK) B232X24	3 EA	6	234	0	116	0	0	12	362
400	.461550	MOP AND BROOM HOLDER W/SHELF B239X34	1 EA	2	78	0	155	0	0	16	249
400	.461555	STAINLESS STEEL SHELF B296X24	1 EA	2	78	0	33	0	0	3	114
400	.461560	SHOWER STALL CURTAIN ROD W/VINYL SHOWER CURTAIN AND HOOKS #204-2	3 EA	6	234	0	143	0	0	14	391
400	.461565	HEAVY DUTY ROBE HOOK B2116	3 EA	6	234	0	38	0	0	4	276
400	.465100	LOCKERS METAL - 60"-72" SINGLE TIER	16 EA	13	508	0	1526	0	0	153	2187
400	.465200	LOCKER BENCH WOOD W/ PIPE PEDESTALS	8 LF	1	39	0	132	0	0	13	184
TOTAL		ARCHITECTURAL WORK		3,148		3,126	187,882	0	0	19,103	324,096
500		EQUIPMENT INSTALLATION			113,985						
500	.100000	PLANT FEED CONVEYOR BY OTHERS-NOT PART OF THIS PROJECT	1 EA	0	0	0	0	0	0	0	0
500	.100100	PLANT FEED CONVEYOR HEAD END DISCHARGE HOPPER WT. 1300#	1 EA	32	1243	274	2120	0	0	239	3876
500	.100200	PLANT FEED CONVEYOR DISCHARGE CHUTE FROM HOPPER TO CRUSHER WT. 1100#	1 EA	32	1243	274	1855	0	0	213	3585
500	.105000	BELT MAGNET ERIEZ MODEL SE7235MC1	1 EA	24	933	206	0	0	4934	21	6094
500	.105100	BELT MAGNET RECTIFIER ERIEZ MODEL 36C-1800WATTS	1 EA	24	940	86	0	0	1771	9	2806
500	.110000	RAW COAL CRUSHER #1 GUNDLACH MODEL 45DA	1 EA	160	6217	1371	0	0	37100	137	44825
500	.110100	#1 RAW COAL CRUSHER DISCHARGE CHUTE TO RAW COAL CRUSHER #2 WT. 1100#	1 EA	32	1243	274	1855	0	0	213	3585
500	.111000	RAW COAL CRUSHER #2 GUNDLACH MODEL 45DA	1 EA	160	6217	1371	0	0	79500	137	87225
500	.111100	RAW COAL CRUSHER #2 DISCHARGE CHUTE TO RAW COAL SCREEN WT. 1500#	1 EA	32	1243	274	2385	0	0	266	4168
500	.112000	RAW COAL SCREEN TABOR 4' X 12' VIBRATING SCREEN INCLINED	1 EA	400	15543	3429	0	0	16960	343	36275

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 6
DATE: 07/13/94 13:27
BY

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
500	.112100	RAW COAL SCREEN UNDER FLOW PAN TO COLLECT FINES WT. 2000#	1 EA	64	2487	549	3180	0	0	373	6589
500	.112200	RAW COAL SCREEN OVER FLOW HOPPER AND CHUTE WT. 1400#	1 EA	32	1243	274	2226	0	0	250	3993
500	.113000	OVERSIZE BUCKET ELEVATOR GOODMAN	1 EA	400	15543	3429	0	0	25355	343	44670
500	.113200	OVERSIZE BUCKET ELEVATOR TOP DISCHARGE CHUTE WT. 600#	1 EA	24	933	206	1060	0	0	127	2326
500	.115000	RAW COAL FEED SUMP WT. 3000#	1 EA	120	4663	1029	5300	0	0	633	11625
500	.120000	RAW COAL FEED PUMP GOYNE PUMP	1 EA	32	1243	274	0	0	13627	27	15171
500	.135000	REFUSE CENTRIFUGE DRIVE MODEL CMI HVC-20	1 EA	32	1243	274	0	0	86920	27	88464
500	.135100	REFUSE CENTRIFUGE VIBRATOR MODEL CMI HVC-20	1 EA	24	933	206	0	0	0	21	1160
500	.135200	REFUSE CENTRIFUGE OIL PUMP MODEL CMI HVC-20	1 EA	24	933	206	0	0	0	21	1160
500	.135300	REFUSE CENTRIFUGE DRIVE DISCHARGECHUTE WT. 2000#	1 EA	48	1865	411	3392	0	0	380	6048
500	.140000	DESLIME SIEVE BEND 3'WIDE,80"RAD,60, .35MM, 3/32 ISO	2 EA	96	3730	823	0	0	9752	82	14387
500	.140100	DESLIME SIEVE BEND DISCHARGE CHUTE WT. 700#	2 EA	64	2487	549	2332	0	0	288	5656
500	.145000	DESLIME SCREEN TAPOR 4' X 12'STD. VIBRATING HORIZONTAL	1 EA	160	6217	1371	0	0	20670	137	28395
500	.145100	DESLIME SCREEN DISCHARGE CHUTE #1 WT. 600#	1 EA	32	1243	274	954	0	0	123	2594
500	.145200	DESLIME SCREEN DISCHARGE CHUTE #2 WT. 1000#	1 EA	32	1243	274	1590	0	0	186	3293
500	.145300	DESLIME SCREEN UNDERFLOW PAN WT. 1400#	1 EA	32	1243	274	2226	0	0	250	3993
500	.145400	DESLIME AND MIDLS DISCHARGE CHUTE WT. 1500#	1 EA	32	1243	274	2650	0	0	292	4459
500	.150000	MIDDLINGS CRUSHER DRIVE #1 GUNDLACH CAGEPACTOR	1 EA	240	9326	2057	0	0	125811	206	137400
500	.150100	MIDDLINGS CRUSHER DISCHARGE CHUTE WT. 500#	1 EA	24	933	206	954	0	0	116	2209
500	.150200	MIDDLINGS CRUSHER DRIVE #2 GUNDLACH CAGEPACTOR W/500.150000	1 EA	240	9326	2057	0	0	0	206	11589

--WORK BREAKDOWN-- FACIL.STANDRD.WPKKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
500	.150300	CRUSHER DISCHARGE CHUTE PLATEWORK WT. 1600#	1 EA	32	1243	274	2650	0	0	292	4459
500	.151000	OVERSIZE PROTECTION SUMP PLATEWORK WT. 2700#	1 EA	32	1243	274	5300	0	0	557	7374
500	.152000	OVERSIZE PROTECTION PUMP GOYNE PUMP	1 EA	32	1249	168	0	0	12912	17	14346
500	.153000	OVERSIZE PROTECTION SIEVE BEND 5'WIDE,40"R,60, .35MM, 3/32 ISO	2 EA	96	3730	823	0	0	10600	82	15235
500	.153100	OVERSIZE PROTECTION SIEVE BEND DISCHARGE HOPPER WT. 500#	1 EA	32	1243	274	954	0	0	123	2594
500	.153200	OVERSIZE PROTECTION SIEVE BEND DISCHARGE CHUTE WT.1100#	1 EA	32	1243	274	1908	0	0	218	3643
500	.155000	FINE HYDRO FEED SUMP PLATEWORK WT. 2700#	1 EA	48	1865	411	5300	0	0	571	8147
500	.160000	FINE HYDRO FEED PUMP GOYNE PUMP	1 EA	32	1249	168	0	0	14578	17	16012
500	.165000	FINE HYDROCLONES KREBS 10" DIAMETER WITH/STAND	5 EA	160	6217	1371	0	0	83475	137	91200
500	.165100	FINE CYCLONE HOPPER WT. 1800#	5 EA	120	4663	1029	15900	0	0	1693	23285
500	.202000	CLASSIFYING CYCLONE SUMP PLATEWORK WT. 2700#	1 EA	48	1865	411	5300	0	0	571	8147
500	.205000	CLASSIFYING CYCLONE PUMP GOYNE PUMP	1 EA	32	1249	168	0	0	30493	17	31927
500	.207000	CLASSIFYING CYCLONES KREBS 10" DIAMETER WITH/STAND	8 EA	256	9947	2194	0	0	127624	219	139984
500	.207100	CLASSIFYING CYCLONES HOPPER WT. 1800	8 EA	192	7460	1646	25440	0	0	2709	37255
500	.208000	VARI-SIEVE KREBS 5'WIDE VARI-SIEVE	2 EA	96	3730	823	0	0	103414	82	108049
500	.208100	VARI-SIEVE DISCHARGE CHUTE WT. 1000#	2 EA	48	1865	411	3180	0	0	359	5815
500	.210100	10' DIA. X 6' CONICAL BALL MILL	1 EA	800	31085	6857	0	0	606320	686	644948
500	.210200	BALL MILL DISCHARGE CHUTE WT. 3000#	1 EA	160	6217	1371	4770	0	0	614	12972
500	.215000	ADVANCED FLOTATION FEED SUMP PLATEWORK WT. 2700#	1 EA	32	1243	274	5300	0	0	557	7374
500	.220100	ADVANCED FLOTATION FEED PUMP GOYNE PUMP	1 EA	32	1249	168	0	0	25803	17	27237
500	.225000	FLOTATION FEED DISTRIBUTER PLATEWORK WT. 2500#	1 EA	32	1243	274	5300	0	0	557	7374
500	.230100	ADVANCED FLOTATION CELL ICFKE MICROCEL MODEL 12025	4 EA	1600	62171	13715	0	0	466400	1372	543658

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 8
DATE: 07/13/94 13:27
BY

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
=====		=====	=====	=====	=====	=====	=====	=====	=====	=====	=====
500	.230200	ADVANCED FLOTATION PUMP GOYNE PUMP	4 EA	128	4998	674	0	0	0	67	5739
500	.240000	COAL STATIC THICKENER DRIVE EIMCO 50' DIAMETER HIRATE	1 EA	400	15543	3429	0	0	68900	343	88215
500	.240100	COAL STATIC THICKENER LIFTING DEVICEC, EMICO 50' DIAMETER HIRATE	1 EA	128	4974	1097	0	0	0	110	6181
500	.245000	COAL THICKENER CLARIFIED WATER SUMP, PLATEWORK WT. 11000#	1 EA	64	2487	549	18550	0	0	1910	23496
500	.247000	COAL THICKENER CLARIFIED WATER PUMP, GOYNE PUMP	1 EA	64	2499	337	0	0	30152	34	33022
500	.249000	COAL STATIC THICKENER UNDER- FLOW PUMP, GOYNE PUMP	1 EA	32	1249	168	0	0	12207	17	13641
500	.260000	CLEAN COAL FILTER DRIVE, ANDRITZ RUTHNER, INC.	1 EA	400	15543	3429	0	0	1228710	343	1248025
500	.260100	AGITATORS ANDRITZ RUTHNER, INC. W/500.260000	3 EA	120	4663	1029	0	0	0	103	5795
500	.260200	DISCHARGE GATES, ANDRITZ RUTHNER, INC. W/500.260000	1 EA	64	2487	549	0	0	0	55	3091
500	.260300	AIR COMPRESSOR, AIRTEC	1 EA	200	7809	1053	0	0	52391	105	61358
500	.260400	FILTRATE PUMP GOYNE PUMP	1 EA	64	2499	337	0	0	8509	34	11379
500	.260500	LUBRICATOR, ANDRITZ RUTHNER, INC. W/500.260000	1 EA	32	1243	274	0	0	0	27	1544
500	.260600	AUXILLARY AIR COMPRESSOR ANDRITZ RUTHNER, INC. W/500.260000	1 EA	64	2499	337	0	0	0	34	2870
500	.260700	INTERNAL CONVEYOR, ANDRITZ RUTHNER, INC. W/500.260000	1 EA	64	2487	549	0	0	0	55	3091
500	.260800	CLEAN COAL FILTER DISCHARGE CHUTE, PLATEWORK WT.900#	1 EA	32	1243	274	1590	0	0	186	3293
500	.265000	CLEAN COAL BELT CONVEYOR BY OTHERS NOT INCLUDED IN THIS CONTRACT	1 EA	0	0	0	0	0	0	0	0
500	.275000	REFUSE STATIC THICKENER DRIVE EMICO 60' DIAMETER HIRATE	1 EA	400	15543	3429	0	0	74200	343	93515
500	.275100	REFUSE STATIC THICKENER LIFTING DEVICE, EMICO 60' DIAMETER HIRATE	1 EA	128	4974	1097	0	0	0	110	6181

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500	.290000	REFUSE STATIC THICKENER UNDERFLOW PUMP GOYNE PUMP	1 EA	64	2499	337	0	0	13928	34	16798
500	.315100	REFUSE CONVEYOR BY OTHERS NOT PART OF THIS CONTRACT	1 EA	0	0	0	0	0	0	0	0
500	.320100	HEAVY MEDIA CYCLONE SUMP PLATEWORK WT. 2500#	1 EA	32	1243	274	4240	0	0	451	6208
500	.325000	HEAVY MEDIA CYCLONE PUMP GOYNE PUMP	1 EA	32	1249	168	0	0	16797	17	18231
500	.330000	HEAVY MEDIA CYCLONE KREBS 20" DIAMETER CERAMIC	1 EA	40	1554	343	0	0	39697	34	41628
500	.330100	HEAVY MEDIA CYCLONE OVERFLOW BOX PLATEWORK WT. 2000#	1 EA	32	1243	274	3180	0	39697	345	44739
500	.335000	MIDS SIEVE BEND 3'WIDE,80"R,60, .5MM,3/32 ISO	1 EA	48	1865	411	0	0	4876	41	7193
500	.335100	MIDS SIEVE BEND DISCHARGE CHUTE PLATEWORK WT. 1000#	1 EA	24	933	206	1590	0	0	180	2909
500	.340000	MIDS DRAIN AND RINSE SCREEN TABOR 4'X16' SD VIBRATING, HORIZONTAL	1 EA	160	6217	1371	0	0	23320	137	31045
500	.340100	MIDS DRAIN AND RINSE SCREEN UNDERFLOW PAN PLATEWORK WT. 3500#	1 EA	160	6217	1371	6360	0	0	773	14721
500	.340200	MIDS DRAIN AND RINSE SCREEN DISCHARGE CHUTE PLATEWORK WT. 2000#	1 EA	32	1243	274	3180	0	0	345	5042
500	.340300	MIDS DESLIME DISCHARGE CHUTE PLATEWORK WT. 1600#	1 EA	32	1243	274	2650	0	0	292	4459
500	.345000	REFUSE SIEVE BEND 3'WIDE,40"R,60, .5MM,3/32 ISO	1 EA	64	2487	549	0	0	2332	55	5423
500	.345100	REFUSE SIEVE BEND DISCHARGE CHUTE PLATEWORK WT. 1000#	1 EA	24	933	206	0	0	0	21	1160
500	.350000	REFUSE DRAIN AND RINSE SCREEN TABOR 4'X16' SD VIBRATING HORIZONTAL	1 EA	160	6217	1371	0	0	23320	137	31045
500	.350100	REFUSE DRAIN AND RINSE SCREEN UNDERFLOW PAN PLATEWORK WT. 2200#	1 EA	160	6217	1371	3710	0	0	508	11806
500	.350200	REFUSE DRAIN AND RINSE SCREEN DISCHARGE CHUTE PLATEWORK WT. 1200#	1 EA	24	933	206	2120	0	0	233	3492
500	.350300	REFUSE DRAIN AND RINSE SCREEN DISCHARGE CHUTE TO REFUSE CENTRIFUGE DRIVE WT. 300#	1 EA	24	933	206	636	0	0	84	1859

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 10
DATE: 07/13/94 13:27
BY

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
500	.350400	REFUSE DRAIN AND RINSE SCREEN DISCHARGE CHUTE TO REFUSE CONVEYOR WT. 1000#	1 EA	24	933	206	1590	0	0	180	2909
500	.360000	HEAVY MEDIA CONTROL BOX PLATEWORK WT. 1000#	1 EA	32	1243	274	1855	0	0	213	3585
500	.365000	HEAVY MEDIA SENSOR BOX PLATEWORK WT. 400#	1 EA	16	622	137	795	0	0	93	1647
500	.370000	DILUTE MEDIA SUMP PLATEWORK WT. 2200#	1 EA	32	1243	274	4240	0	0	451	6208
500	.375100	DILUTE MEDIA PUMP GOYNE PUMP	1 EA	64	2499	337	0	0	11546	34	14416
500	.380000	MAGNETIC SEPARATOR ERIEZ 36" DIAMETER X 9'WIDE	1 EA	64	2487	549	0	0	16960	55	20051
500	.380100	MAGNETIC SEPARATOR TAILINGS CHUTE AND CONCENTRATE CHUTE PLATEWORK WT. 2600#	1 EA	48	1865	411	4240	0	0	465	6981
500	.385000	MAGNETITE BIN PLATEWORK WT. 3000#	1 EA	32	1243	274	5300	0	0	557	7374
500	.385100	MAGNETITE BIN DUST COLLECTOR AMERICAN AIR FILTER	1 EA	32	1243	274	0	0	7579	27	9123
500	.390000	MAGNETITE ROTARY VALVE ANDRITZ SPROUT-BAUER	1 EA	24	933	206	0	0	2899	21	4059
500	.390100	MAGNETIC ROTARY VALVE DISCHARGE CHUTE PLATEWORK WT. 60#	1 EA	16	622	137	318	0	0	46	1123
500	.395000	INSTRUMENT AIR COMPRESSOR AIRTEC	1 EA	64	2499	337	0	0	12036	34	14906
500	.395100	INSTRUMENT AIR COMPRESSOR DRYER AIRTEC	1 EA	24	937	126	0	0	0	13	1076
500	.395200	EQUIPMENT IN 395000 INSTRUMENT AIR COMPRESSOR PREFILTERS AIRTEC	1 EA	24	937	126	0	0	0	13	1076
500	.395300	EQUIPMENT IN 395000 INSTRUMENT AIR COMPRESSOR AFTERFILTERS AIRTEC	2 EA	48	1874	253	0	0	0	25	2152
500	.398000	EQUIPMENT IN 395000 PLANT AND COLUMN AIR COMPRESSOR AIRTEC	1 EA	64	2499	337	0	0	52391	34	55261
500	.398100	PLANT AND COLUMN AIR COMPRESSOR-PREFILTERS AIRTEC	1 EA	24	937	126	0	0	0	13	1076
500	.398200	EQUIPMENT IN 398000 PLANT AND COLUMN AIR COMPRESSOR AFTERFILTERS	2 EA	48	1874	253	0	0	0	25	2152
500	.400000	EQUIPMENT IN 398000 FLOCCULATION SYSTEM CONSIST OF ITEMS 400100 THRU 401000	1 EA	0	0	0	0	0	0	0	0

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--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
=====		=====	=====	=====	=====	=====	=====	=====	=====	=====	=====
500	.400100	FLOCCULANT SYSTEM ANIONIC FEEDER MINETEC	1 EA	32	1243	274	0	0	1272	27	2816
500	.400200	FLOCCULANT SYSTEM ANIONIC MIXER MINETEC	1 EA	24	933	206	0	0	1590	21	2750
500	.400300	FLOCCULANT SYSTEM ANIONIC MIX TANK MINETEC	1 EA	24	933	206	0	0	4240	21	5400
500	.400400	FLOCCULANT SYSTEM ANIONIC HOLDING TANK MINETEC	1 EA	32	1243	274	0	0	5300	27	6844
500	.400500	FLOCCULANT SYSTEM ANIONIC METERING PUMP MINETEC	2 EA	64	2499	337	0	0	3721	34	6591
500	.400600	FLOCCULANT SYSTEM CATIONIC HOLDING TANK MINETEC	1 EA	32	1243	274	0	0	6360	27	7904
500	.400700	FLOCCULANT SYSTEM CATIONIC METERING PUMP MINETEC	2 EA	48	1874	253	0	0	3721	25	5873
500	.400800	FLOCCULANT SYSTEM SETTLING RATE DETECTOR MINETEC	2 EA	32	1243	274	0	0	38775	27	40319
500	.400900	FLOCCULANT SYSTEM WATER CLARITY MEASUREMENT MINETEC	2 EA	32	1243	274	0	0	8946	27	10490
500	.401000	FLOCCULANT SYSTEM PH REAGENT PUMP MINETEC	1 EA	24	937	126	0	0	1860	13	2936
500	.405000	REAGENT SYSTEM COMPLETE INCLUDING ITEMS 405100 THRU 405800 MINETEC	1 LOT	0	0	0	0	0	0	0	0
500	.405100	REAGENT SYSTEM FROTHER BULK STORAGE MINETEC	1 EA	32	1243	274	0	0	2385	27	3929
500	.405200	REAGENT SYSTEM FROTHER TRANSFER PUMP MINETEC	1 EA	0	0	0	0	0	3721	0	3721
500	.405300	REAGENT SYSTEM FROTHER DAY TANK MINETEC	1 EA	32	1243	274	0	0	3180	27	4724
500	.405400	REAGENT SYSTEM FROTHER REAGENT PUMPS MINETEC	4 EA	96	3748	505	0	0	7441	51	11745
500	.405500	REAGENT SYSTEM COLLECTOR BULK STORAGE MINETEC	1 EA	32	1243	274	0	0	2385	27	3929
500	.405600	REAGENT SYSTEM COLLECTOR TRANSFER PUMPS MINETEC	1 EA	24	937	126	0	0	3721	13	4797
500	.405700	REAGENT SYSTEM COLLECTOR DAY TANK MINETEC	1 EA	32	1243	274	0	0	3180	27	4724
500	.405800	REAGENT SYSTEM COLLECTION REAGENT FEEDERS MINETEC	4 EA	96	3730	823	0	0	7441	82	12076
500	.410000	OVERDENSE MEDIA SUMP PLATEWORK WT. 2000#	1 EA	32	1243	274	3710	0	0	398	5625
500	.415000	OVERDENSE MEDIA PUMP GOYNE PUMP	1 EA	32	1249	168	0	0	8678	17	10112
500	.420000	OVERDENSE MEDIA CONTROL BOX PLATEWORK WT. 1000#	1 EA	32	1243	274	1590	0	0	186	3293

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 12
DATE: 07/13/94 15:27
BY

--WORK BREAKDOWN--		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
FACIL.	STANDRD.WKPKG										
500	.425000	OVERDENSE MEDIA SENSOR BOX PLATEWORK WT. 400#	1 EA	16	622	137	795	0	0	93	1647
500	.430000	BALL MILL OVERHEAD CRANE HOIST THERN	1 EA	24	933	206	0	0	44520	21	45680
500	.430100	BALL MILL OVERHEAD CRANE TRAM RUNWAY THERN	1 LOT	128	4974	1097	0	0	8480	110	14661
500	.481105	LAB EQUIPMENT - OVEN (91-2150-1) PREISER SCIENTIFIC	1 EA	0	0	0	0	0	7632	0	7632
500	.481110	LAB EQUIPMENT - OVEN (91-2290-83) PREISER SCIENTIFIC	1 EA	0	0	0	0	0	2862	0	2862
500	.481115	LAB EQUIPMENT - TABLE (80-1345-01) PREISER SCIENTIFIC	1 EA	0	0	0	0	0	403	0	403
500	.481120	LAB EQUIPMENT - DESK (80-1345-01) PREISER SCIENTIFIC	1 EA	0	0	0	0	0	785	0	785
500	.481125	LAB EQUIPMENT - EXHAUST HOOD (80-2200-03) PREISER SCIENTIFIC	1 EA	0	0	0	0	0	2424	0	2424
500	.481130	LAB EQUIPMENT - CABINETS PREISER SCIENTIFIC	1 LOT	0	0	0	0	0	1985	0	1985
500	.485000	CLEAN UP PUMP 7.5HP/TEFC/480V/1800RPM	1 EA	64	2487	549	0	0	5599	55	8690
500	.495000	GLAND WATER PUMP 5HP/TEFC/480V/1800RPM	1 EA	64	2487	549	0	0	3407	55	6498
500	.500100	SLURRY SAMPLERS - 5 HP/TEFC/ 480V/1800 RPM	3 EA	120	4663	1029	0	0	14930	103	20725
500	.500200	DRY SAMPLERS - 5 HP/TEFC/ 480V/1800 RPM	2 EA	80	3109	686	0	0	13483	69	17347
500	.501300	AUTOMATIC FLOC MIXING SYSTEM 1.50HP/TEFC/480V/1800RPM	1 EA	32	1243	274	0	0	16483	27	18027
TOTAL		EQUIPMENT INSTALLATION		12,080		98,705		0		28,632	
600		PIPING			469,655		187,620		3,887,376		4,671,988
600	.601056	PIPE BLK PE EW 53 S40 1-1/2"	100 LF	7	273	37	136	0	0	17	463
600	.601060	PIPE BLK TC EW 53 S40 1/2"	143 LF	3	117	15	84	0	0	10	226
600	.601062	PIPE BLK TC EW 53 S40 3/4"	281 LF	11	429	59	197	0	0	26	711
600	.601064	PIPE BLK TC EW 53 S40 1"	440 LF	22	859	116	430	0	0	55	1460
600	.601065	PIPE BLK TC EW 53 S80 1"	14 LF	1	39	4	24	0	0	3	70
600	.601069	PIPE BLK TC EW 53 S80 1-1/2"	7 LF	1	39	3	19	0	0	2	63
600	.601070	PIPE BLK TC EW 53 S40 2"	823 LF	82	3202	433	1685	0	0	212	5532

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--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
600	.601071 .	PIPE BLK TC EW 53 S80 2"	98 LF	12	469	62	375	0	0	44	950
600	.601375 .	90 EL FS SCR D 3000 1/2"	24 EA	3	117	18	102	0	0	12	249
600	.601376 .	90 EL FS SCR D 3000 3/4"	26 EA	5	195	25	142	0	0	17	379
600	.601377 .	90 EL FS SCR D 3000 1"	28 EA	6	234	29	221	0	0	25	509
600	.601379 .	90 EL FS SCR D 3000 1-1/2"	5 EA	2	78	8	100	0	0	11	197
600	.601380 .	90 EL FS SCR D 3000 2"	70 EA	23	898	122	1694	0	0	182	2896
600	.601386 .	45 EL FS SCR D 3000 2"	4 EA	1	39	7	105	0	0	11	162
600	.601388 .	TEE FS SCR D 3000 3/4"	4 EA	1	39	4	34	0	0	4	81
600	.601392 .	TEE FS SCR D 3000 2"	65 EA	26	1015	137	2134	0	0	227	3513
600	.601444 .	UNION FS SCR D 3000 1/2"	20 EA	2	78	13	132	0	0	15	238
600	.601445 .	UNION FS SCR D 3000 3/4"	20 EA	3	117	16	159	0	0	18	310
600	.601446 .	UNION FS SCR D 3000 1"	30 EA	5	195	28	311	0	0	34	568
600	.601449 .	UNION FS SCR D 3000 2"	20 EA	6	234	34	466	0	0	50	784
600	.601551 .	CAP FS SW 3000 1/2"	8 EA	1	39	5	22	0	0	3	69
600	.601554 .	CAP FS SW 6000 3/4"	4 EA	1	39	4	30	0	0	3	76
600	.601561 .	CAP FS SW 3000 2"	4 EA	1	39	6	48	0	0	5	98
600	.601587 .	COUPLING FS SW 3000 1/2"	11 EA	1	39	7	23	0	0	3	72
600	.601589 .	COUPLING FS SW 3000 3/4"	17 EA	2	78	13	48	0	0	6	145
600	.601591 .	COUPLING FS SW 3000 1"	4 EA	1	39	3	12	0	0	2	56
600	.601597 .	COUPLING FS SW 3000 2"	2 EA	1	39	3	21	0	0	2	65
600	.601672 .	THREDOLET FS 3000 1/2"	4 EA	0	0	0	21	0	0	2	23
600	.601673 .	THREDOLET FS 3000 3/4"	5 EA	0	0	0	31	0	0	3	34
600	.601674 .	THREDOLET FS 3000 1"	34 EA	0	0	0	235	0	0	24	259
600	.601677 .	THREDOLET FS 3000 2"	8 EA	0	0	0	98	0	0	10	108
600	.602044 .	PIPE BLK PE EW 53 S40 2-1/2"	16 LF	0	0	0	51	0	0	5	56
600	.602046 .	PIPE BLK PE EW 53 S40 3"	143 LF	0	0	0	586	0	0	59	645
600	.6020461 .	PIPE BLK PE EW 53 XS 3"	191 LF	44	1718	231	1324	0	0	156	3429
600	.602048 .	PIPE BLK PE EW 53 S40 4"	305 LF	0	0	0	1557	0	0	156	1713
600	.6020481 .	PIPE BLK PE EW 53 XS 4"	465 LF	135	5271	710	4057	0	0	477	10515
600	.602052 .	PIPE BLK PE EW 53 S40 6"	80 LF	0	0	0	693	0	0	69	762
600	.6020521 .	PIPE BLK PE EW 53 XS 6"	390 LF	179	6989	944	6528	0	0	747	15208
600	.602056 .	PIPE BLK PE EW 53 S40 8"	110 LF	0	0	0	1430	0	0	143	1573
600	.6020561 .	PIPE BLK PE EW 53 XS 8"	644 LF	399	15578	2102	16220	0	0	1832	35732
600	.602058 .	PIPE BLK PE EW 53 XS 10"	378 LF	0	0	0	17551	0	0	1755	19306
600	.602061 .	PIPE BLK PE EW 53 S40 10"	15 LF	0	0	0	275	0	0	28	303
600	.602062 .	PIPE BLK PE EW 53 S80 10"	28 LF	0	0	0	1778	0	0	178	1956
600	.602064 .	PIPE BLK PE EW 53 XS 12"	40 LF	0	0	0	2192	0	0	219	2411
600	.602067 .	PIPE BLK PE EW 53 S40 12"	25 LF	0	0	0	1121	0	0	112	1233
600	.602068 .	PIPE BLK PE EW 53 S80 12"	4 LF	0	0	0	343	0	0	34	377
600	.602070 .	PIPE BLK PE EW 53 XS 14"	45 LF	0	0	0	2849	0	0	285	3134
600	.602074 .	PIPE BLK PE EW 53 S40 14"	30 LF	0	0	0	1759	0	0	176	1935
600	.602075 .	PIPE BLK PE EW 53 S80 14"	4 LF	0	0	0	465	0	0	47	512
600	.602077 .	PIPE BLK PE EW 53 XS 16"	82 LF	0	0	0	5824	0	0	582	6406
600	.602251 .	LOOSE PIPE CS S40 2-1/2"	16 LF	2	78	10	0	0	0	1	89
600	.602254 .	LOOSE PIPE CS S40 3"	143 LF	21	820	113	0	0	0	11	944
600	.602255 .	LOOSE PIPE CS S80 3"	191 LF	34	1327	181	0	0	0	18	1526

ICF KAISER ENGINEERS, INC.
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JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 14
DATE: 07/13/94 13:27
BY

--WORK BREAKDOWN--		FACIL.STANDRD.WKPKG		DESCRIPTION		QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
=====		=====		=====		=====	=====	=====	=====	=====	=====	=====	=====	=====
600	.602257	.		LOOSE PIPE	CS S40 4"	305 LF	61	2382	321	0	0	0	32	2735
600	.602258	.		LOOSE PIPE	CS S80 4"	465 LF	112	4373	587	0	0	0	59	5019
600	.602263	.		LOOSE PIPE	CS S40 6"	80 LF	23	898	122	0	0	0	12	1032
600	.602264	.		LOOSE PIPE	CS S80 6"	390 LF	144	5622	760	0	0	0	76	6458
600	.602268	.		LOOSE PIPE	CS S40 8"	110 LF	43	1679	226	0	0	0	23	1928
600	.602270	.		LOOSE PIPE	CS S80 8"	672 LF	329	12845	1733	0	0	0	173	14751
600	.602272	.		LOOSE PIPE	CS XS 10"	378 LF	231	9019	1213	0	0	0	121	10353
600	.602275	.		LOOSE PIPE	CS S40 10"	15 LF	7	273	39	0	0	0	4	316
600	.602280	.		LOOSE PIPE	CS XS 12"	40 LF	29	1132	154	0	0	0	15	1301
600	.602283	.		LOOSE PIPE	CS S40 12"	25 LF	16	625	83	0	0	0	8	716
600	.602285	.		LOOSE PIPE	CS S80 12"	4 LF	4	156	21	0	0	0	2	179
600	.602288	.		LOOSE PIPE	CS XS 14"	45 LF	38	1484	201	0	0	0	20	1705
600	.602292	.		LOOSE PIPE	CS S40 14"	30 LF	23	898	123	0	0	0	12	1033
600	.602294	.		LOOSE PIPE	CS S80 14"	4 LF	5	195	27	0	0	0	3	225
600	.602296	.		LOOSE PIPE	CS XS 16"	82 LF	80	3123	423	0	0	0	42	3588
600	.602408	.		90 LR BUTTW.	CS S40 2-1/2"	8 EA	0	0	0	62	0	0	6	68
600	.602411	.		90 LR BUTTW.	CS S40 3"	15 EA	0	0	0	115	0	0	12	127
600	.602412	.		90 LR BUTTW.	CS S80 3"	12 EA	0	0	0	136	0	0	14	150
600	.602414	.		90 LR BUTTW.	CS S40 4"	19 EA	0	0	0	242	0	0	24	266
600	.602415	.		90 LR BUTTW.	CS S80 4"	32 EA	0	0	0	598	0	0	60	658
600	.602420	.		90 LR BUTTW.	CS S40 6"	12 EA	0	0	0	374	0	0	37	411
600	.602421	.		90 LR BUTTW.	CS S80 6"	19 EA	0	0	0	883	0	0	88	971
600	.602424	.		90 LR BUTTW.	CS S40 8"	1 EA	0	0	0	58	0	0	6	64
600	.602425	.		90 LR BUTTW.	CS S80 8"	52 EA	0	0	0	4508	0	0	451	4959
600	.602427	.		90 LR BUTTW.	CS XS 10"	30 EA	0	0	0	4648	0	0	465	5113
600	.602432	.		90 LR BUTTW.	CS STD 12"	3 EA	0	0	0	446	0	0	45	491
600	.602433	.		90 LR BUTTW.	CS XS 12"	3 EA	0	0	0	655	0	0	66	721
600	.602437	.		90 LR BUTTW.	CS STD 14"	1 EA	0	0	0	201	0	0	20	221
600	.602438	.		90 LR BUTTW.	CS XS 14"	1 EA	0	0	0	271	0	0	27	298
600	.602442	.		90 LR BUTTW.	CS XS 16"	2 EA	0	0	0	725	0	0	73	798
600	.602488	.		45 EL BUTTW.	CS S40 3"	5 EA	0	0	0	33	0	0	3	36
600	.602501	.		45 EL BUTTW.	CS S40 8"	25 EA	0	0	0	1017	0	0	102	1119
600	.602506	.		45 EL BUTTW.	CS S40 10"	5 EA	0	0	0	367	0	0	37	404
600	.602508	.		45 EL BUTTW.	CS STD 12"	1 EA	0	0	0	104	0	0	10	114
600	.602512	.		45 EL BUTTW.	CS STD 14"	4 EA	0	0	0	563	0	0	56	619
600	.602537	.		TEE BUTTW.	CS S40 3"	4 EA	0	0	0	68	0	0	7	75
600	.602538	.		TEE BUTTW.	CS S80 3"	1 EA	0	0	0	23	0	0	2	25
600	.602540	.		TEE BUTTW.	CS S40 4"	11 EA	0	0	0	259	0	0	26	285
600	.602546	.		TEE BUTTW.	CS S40 6"	2 EA	0	0	0	85	0	0	9	94
600	.602547	.		TEE BUTTW.	CS S80 6"	3 EA	0	0	0	181	0	0	18	199
600	.602550	.		TEE BUTTW.	CS S40 8"	1 EA	0	0	0	79	0	0	8	87
600	.602551	.		TEE BUTTW.	CS S80 8"	2 EA	0	0	0	244	0	0	24	268
600	.602553	.		TEE BUTTW.	CS XS 10"	1 EA	0	0	0	198	0	0	20	218
600	.602635	.		CON RED BUTTW	CS S40 3"	3 EA	0	0	0	21	0	0	2	23
600	.602638	.		CON RED BUTTW	CS S40 4"	5 EA	0	0	0	47	0	0	5	52
600	.602644	.		CON RED BUTTW	CS S40 6"	1 EA	0	0	0	19	0	0	2	21

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600	.602645	CON RED BUTTW CS S80 6"	6 EA	0	0	0	144	0	0	14	158
600	.602648	CON RED BUTTW CS S40 8"	2 EA	0	0	0	52	0	0	5	57
600	.602649	CON RED BUTTW CS S80 8"	10 EA	0	0	0	343	0	0	34	377
600	.602651	CON RED BUTTW CS XS 10"	6 EA	0	0	0	286	0	0	29	315
600	.602653	CON RED BUTTW CS S40 10"	1 EA	0	0	0	39	0	0	4	43
600	.602656	CON RED BUTTW CS STD 12"	1 EA	0	0	0	61	0	0	6	67
600	.602657	CON RED BUTTW CS XS 12"	1 EA	0	0	0	71	0	0	7	78
600	.602662	CON RED BUTTW CS XS 14"	2 EA	0	0	0	256	0	0	26	282
600	.602743	CAP BUTTWELD CS S40 3"	3 EA	0	0	0	12	0	0	1	13
600	.602746	CAP BUTTWELD CS S40 4"	5 EA	0	0	0	26	0	0	3	29
600	.602752	CAP BUTTWELD CS S40 6"	1 EA	0	0	0	10	0	0	1	11
600	.602761	CAP BUTTWELD CS S40 10"	1 EA	0	0	0	23	0	0	2	25
600	.602897	WELDOLET CS STD 3"	8 EA	0	0	0	288	0	0	29	317
600	.602992	SO FLANGE CS A181 150 2-1/2"	8 EA	0	0	0	84	0	0	8	92
600	.602995	SO FLANGE CS A181 150 3"	37 EA	0	0	0	396	0	0	40	436
600	.602998	SO FLANGE CS A181 150 4"	37 EA	0	0	0	506	0	0	51	557
600	.603004	SO FLANGE CS A181 150 6"	33 EA	0	0	0	737	0	0	74	811
600	.603007	SO FLANGE CS A181 150 8"	37 EA	0	0	0	1256	0	0	126	1382
600	.603010	SO FLANGE CS A181 150 10"	25 EA	0	0	0	1534	0	0	153	1687
600	.603012	SO FLANGE CS A181 150 12"	4 EA	0	0	0	362	0	0	36	398
600	.603014	SO FLANGE CS A181 150 14"	11 EA	0	0	0	1374	0	0	137	1511
600	.603016	SO FLANGE CS A181 150 16"	1 EA	0	0	0	166	0	0	17	183
600	.603026	THRD. FLG CS A181 150 2-1/2"	8 EA	2	78	10	118	0	0	13	219
600	.603027	THRD. FLG CS A181 150 3"	8 EA	2	78	12	136	0	0	15	241
600	.603059	BLIND FLG CS A181 150 3"	8 EA	2	78	12	99	0	0	11	200
600	.603062	BLIND FLG CS A181 150 4"	8 EA	3	117	16	133	0	0	15	281
600	.603068	BLIND FLG CS A181 150 6"	1 EA	1	39	3	26	0	0	3	71
600	.603080	BLIND FLG CS A181 150 16"	1 EA	1	39	8	217	0	0	23	287
600	.603607	FIELD JT BW CS S40 2-1/2"	24 EA	22	859	116	26	0	0	14	1015
600	.603610	FIELD JT BW CS S40 3"	117 EA	129	5037	678	156	0	0	83	5954
600	.603611	FIELD JT BW CS S80 3"	27 EA	37	1445	196	49	0	0	25	1715
600	.603613	FIELD JT BW CS S40 4"	136 EA	199	7770	1045	225	0	0	127	9167
600	.603619	FIELD JT BW CS S40 6"	67 EA	147	5739	776	229	0	0	101	6845
600	.603620	FIELD JT BW CS S80 6"	59 EA	162	6325	852	337	0	0	119	7633
600	.603624	FIELD JT BW CS S40 8"	96 EA	281	10971	1481	569	0	0	205	13226
600	.603626	FIELD JT BW CS S80 8"	130 EA	476	18585	2508	1333	0	0	384	22810
600	.603628	FIELD JT BW CS XS 10"	75 EA	344	13431	1808	962	0	0	277	16478
600	.603631	FIELD JT BW CS S40 10"	38 EA	139	5427	733	282	0	0	102	6544
600	.603634	FIELD JT BW CS STD 12"	14 EA	61	2382	323	137	0	0	46	2888
600	.603635	FIELD JT BW CS XS 12"	8 EA	44	1718	230	121	0	0	35	2104
600	.603642	FIELD JT BW CS STD 14"	21 EA	115	4490	605	227	0	0	83	5405
600	.603643	FIELD JT BW CS XS 14"	6 EA	42	1640	220	100	0	0	32	1992
600	.603648	FIELD JT BW CS XS 16"	6 EA	51	1991	269	114	0	0	38	2412
600	.605551	TUBING COPPER K 3/8"	680 LF	7	273	36	575	0	0	61	945
600	.605555	TUBING COPPER K 1/2"	217 LF	4	156	23	209	0	0	23	411
600	.607776	CPLG VICT + BOLTUP STD 4"	1 EA	1	39	4	12	0	0	2	57

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 16
DATE: 07/13/94 13:27
BY

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
=====		=====	=====	=====	=====	=====	=====	=====	=====	=====	=====
600	.607778	CPLG VICT + BOLTUP STD 6"	1 EA	1	39	5	21	0	0	3	68
600	.607779	CPLG VICT + BOLTUP STD 8"	4 EA	4	156	22	139	0	0	16	333
600	.607780	CPLG VICT+BOLTUP STD 10"	1 EA	1	39	6	49	0	0	6	100
600	.607781	CPLG VICT+BOLTUP STD 12"	2 EA	3	117	14	112	0	0	13	256
600	.651342	GATE VALVE, CAST STL 2-1/2" CRANE 47, CLASS 150, FLGD	8 EA	8	312	41	3821	0	0	386	4560
600	.651343	GATE VALVE, CAST STL 3" CRANE 47, CLASS 150, FLGD	21 EA	31	1210	161	10030	0	0	1019	12420
600	.651344	GATE VALVE, CAST STL 4" CRANE 47, CLASS 150, FLGD	13 EA	27	1054	142	7970	0	0	811	9977
600	.651347	GATE VALVE, CAST STL 8" CRANE 47, CLASS 150, FLGD	1 EA	3	117	18	1527	0	0	155	1817
600	.652103	GATE V VOGT FS 600 1" SW-12111	3 EA	1	39	8	137	0	0	15	199
600	.652106	GATE V VOGT FS 600 2" SW-12111	22 EA	22	859	113	2463	0	0	258	3693
600	.652283	BALL VALVE, CS 1/2" JAMESBURY A2236TT SCREWED ENDS, 2000 PSI	68 EA	28	1093	147	3822	0	0	397	5459
600	.652284	BALL VALVE, CS 3/4" JAMESBURY A2236TT SCREWED ENDS, 2000 PSI	15 EA	7	273	36	1132	0	0	117	1558
600	.652285	BALL VALVE, CS 1" JAMESBURY A2236TT SCREWED ENDS, 2000 PSI	50 EA	24	937	129	4889	0	0	502	6457
600	.653020	GATE VALVE, BRONZE 1-1/2" CRANE 1324, CLASS 150, SJ	2 EA	1	39	6	66	0	0	7	118
600	.653378	CHECK VALVE, BRONZE 2" CRANE 36, CLASS 200#, THD	1 EA	1	39	4	97	0	0	10	150
600	.653497	GATE VALVE, BRONZE 3" CRANE 431, CLASS 150, THD	4 EA	6	234	31	715	0	0	75	1055
600	.653716	CHECK VALVE, BRONZE 3" CRANE 36, CLASS 200, THD	1 EA	1	39	8	295	0	0	30	372
600	.655680	KNIFE GATE SS 150 4" DEZURIK 824 W/ HANDWHEEL OPER 304 SS WETTED PARTS, WAFER	3 EA	5	195	26	1084	0	0	111	1416
600	.655681	KNIFE GATE SS 150 6" DEZURIK 824 W/ HANDWHEEL OPER 304 SS WETTED PARTS, WAFER	4 EA	9	351	48	1772	0	0	182	2353
600	.655682	KNIFE GATE CI 150 8" DEZURIK 824 W/ HANDWHEEL OPER 304 SS WETTED PARTS, WAFER	2 EA	5	195	29	1208	0	0	124	1556
600	.655684	KNIFE GATE CI 150 12" DEZURIK 824 W/ HANDWHEEL OPER 304 SS WETTED PARTS, WAFER	4 EA	13	508	68	4181	0	0	425	5182

--WORK BREAKDOWN--
FACIL.STANDRD.WKPKG

		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
600	.655685	KNIFE GATE C1 150 14" DEZURIK 824 W/ BEVEL GEAR OPR 304 SS WETTED PARTS, WAFER	2 EA	7	273	37	3634	0	0	367	4311
600	.686001	TEST & CLEAN 1/2"	143 LF	4	156	23	23	0	0	5	207
600	.686002	TEST & CLEAN 3/4"	281 LF	8	312	44	45	0	0	9	410
600	.686003	TEST & CLEAN 1"	440 LF	13	508	70	70	0	0	14	662
600	.686004	TEST & CLEAN 1-1/4"	823 LF	25	976	130	174	0	0	30	1310
600	.686007	TEST & CLEAN 2-1/2"	16 LF	1	39	5	4	0	0	1	49
600	.686008	TEST & CLEAN 3"	143 LF	9	351	45	38	0	0	8	442
600	.686009	TEST & CLEAN 4"	305 LF	21	820	112	97	0	0	21	1050
600	.686011	TEST & CLEAN 6"	80 LF	6	234	34	25	0	0	6	299
600	.686012	TEST & CLEAN 8"	110 LF	9	351	46	35	0	0	8	440
600	.686013	TEST & CLEAN 10"	421 LF	42	1640	221	134	0	0	36	2031
600	.686014	TEST & CLEAN 12"	69 LF	8	312	40	26	0	0	7	385
600	.686015	TEST & CLEAN 14"	79 LF	9	351	50	29	0	0	8	438
600	.686016	TEST & CLEAN 16"	82 LF	11	429	60	30	0	0	9	528
TOTAL PIPING				4,835		25,478		0		18,286	
					188,767		157,284		0		389,815
675		MECHANICAL									
675	.605555	TUBING COPPER K 1/2"	80 LF	2	78	8	77	0	0	9	172
675	.605563	TUBING COPPER K 3/4"	120 LF	2	78	13	211	0	0	22	324
675	.605568	TUBING COPPER K 1"	200 LF	4	156	21	469	0	0	49	695
675	.605572	TUBING COPPER K 1-1/4"	80 LF	3	117	17	240	0	0	26	400
675	.605577	TUBING COPPER K 1-1/2"	10 LF	0	0	2	38	0	0	4	44
675	.605582	TUBING COPPER K 2"	20 LF	1	39	5	120	0	0	13	177
675	.605603	90 EL COPPER SOLDER 1/2"	60 EA	2	78	13	35	0	0	5	131
675	.605604	90 EL COPPER SOLDER 3/4"	25 EA	1	39	7	33	0	0	4	83
675	.605605	90 EL COPPER SOLDER 1"	40 EEE	2	78	13	127	0	0	14	232
675	.605606	90 EL COPPER SOLDER 1-1/4"	4 EA	0	0	2	20	0	0	2	24
675	.605607	90 EL COPPER SOLDER 1-1/2"	4 EA	0	0	2	31	0	0	3	36
675	.605608	90 EL COPPER SOLDER 2"	1 EA	0	0	1	14	0	0	2	17
675	.605617	TEE COPPER SOLDER 1/2"	6 EA	0	0	2	6	0	0	1	9
675	.605618	TEE COPPER SOLDER 3/4"	4 EA	0	0	2	10	0	0	1	13
675	.605619	TEE COPPER SOLDER 1"	6 EA	1	39	4	43	0	0	5	91
675	.605620	TEE COPPER SOLDER 1-1/4"	5 EA	1	39	4	57	0	0	6	106
675	.605621	TEE COPPER SOLDER 1-1/2"	1 EA	0	0	1	16	0	0	2	19
675	.605622	TEE COPPER SOLDER 2"	1 EA	0	0	1	25	0	0	3	29
675	.605659	CPLG COPPER SOLDER 1/2"	6 EA	0	0	1	3	0	0	0	4
675	.605660	CPLG COPPER SOLDER 3/4"	3 EA	0	0	1	3	0	0	0	4
675	.605661	CPLG COPPER SOLDER 1"	8 EA	0	0	3	15	0	0	2	20
675	.605662	CPLG COPPER SOLDER 1-1/4"	6 EA	1	39	3	19	0	0	2	63
675	.606020	PIPE NO HUB 10 FT 1-1/4"	40 LF	3	117	15	64	0	0	8	204
675	.606021	PIPE NO HUB 10 FT 1-1/2"	40 LF	3	117	15	67	0	0	8	207
675	.606022	PIPE NO HUB 10 FT 2"	30 LF	3	117	14	55	0	0	7	193

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 18
DATE: 07/13/94 13:27
BY

--WORK BREAKDOWN--
FACIL.STANDRD.WKPKG

		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
675	.606045	1/4 BEND CI NO HUB 1-1/2"	6 EA	1	39	5	15	0	0	2	61
675	.6060451	1/4 BEND CI NO HUB 1-1/4"	2 EA	0	0	1	5	0	0	1	7
675	.606046	1/4 BEND CI NO HUB 2"	14 EA	2	78	13	37	0	0	5	133
675	.606047	1/8 BEND CI NO HUB 1-1/2"	1 EA	0	0	0	2	0	0	0	2
675	.606048	1/8 BEND CI NO HUB 2"	6 EA	1	39	3	15	0	0	2	59
675	.606053	SAN TEE CI NO HUB 1-1/2"	8 EA	1	39	4	26	0	0	3	72
675	.6060531	SAN TEE CI NO HUB 1-1/4"	1 EA	1	39	6	10	0	0	2	57
675	.606054	SAN TEE CI NO HUB 2"	3 EA	0	0	1	11	0	0	1	13
675	.606063	P-TRAP CI NO HUB 1-1/2"	4 EA	1	39	4	15	0	0	2	60
675	.6060631	P-TRAP CI NO HUB 1-1/4"	1 EA	0	0	1	4	0	0	1	6
675	.606064	P-TRAP CI NO HUB 2"	3 EA	1	39	3	11	0	0	1	54
675	.606633	PIPE NO HUB 10 FT 3"	20 LF	3	117	18	51	0	0	7	193
675	.606634	PIPE NO HUB 10 FT 4"	320 LF	54	2108	286	1060	0	0	135	3589
675	.606806	1/4 BEND CI NO HUB 3"	8 EA	2	78	11	28	0	0	4	121
675	.606807	1/4 BEND CI NO HUB 4"	20 EA	7	273	36	104	0	0	14	427
675	.606812	1/8 BEND CI NO HUB 4"	4 EA	1	39	4	19	0	0	2	64
675	.606831	SAN TEE CI NO HUB 4"	14 EA	4	156	19	97	0	0	12	284
675	.606842	WYE CI NO HUB 4"	10 EA	3	117	18	78	0	0	10	223
675	.606867	P-TRAP CI NO HUB 3"	5 EA	1	39	7	42	0	0	5	93
675	.606868	P-TRAP CI NO HUB 4"	1 EA	1	39	3	14	0	0	2	58
675	.608007	PIPE PVC D1785 PE S40 1-1/4"	20 LF	1	39	4	10	0	0	1	54
675	.608009	PIPE PVC D1785 PE S40 1-1/2"	100 LF	4	156	21	58	0	0	8	243
675	.608011	PIPE PVC D1785 PE S40 2"	60 LF	3	117	16	47	0	0	6	186
675	.608027	90 EL PVC SOCKET S40 1-1/4"	4 EA	0	0	1	3	0	0	0	4
675	.608029	90 EL PVC SOCKET S40 1-1/2"	6 EA	1	39	3	5	0	0	1	48
675	.608031	90 EL PVC SOCKET S40 2"	10 EA	1	39	6	13	0	0	2	60
675	.608053	TEE PVC SOCKET S40 1-1/2"	4 EA	0	0	2	4	0	0	1	7
675	.608055	TEE PVC SOCKET S40 2"	2 EA	0	0	2	3	0	0	1	6
675	.608129	CPLG PVC SOCKET S40 1-1/4"	1 EA	0	0	0	0	0	0	0	0
675	.608131	CPLG PVC SOCKET S40 1-1/2"	4 EA	0	0	2	2	0	0	0	4
675	.608133	CPLG PVC SOCKET S40 2"	2 EA	0	0	1	2	0	0	0	3
675	.608270	PIPE PVC D1785 PE S40 2-1/2"	100 LF	6	234	32	123	0	0	16	405
675	.608321	90 EL PVC SOCKET S40 2-1/2"	4 EA	1	39	3	16	0	0	2	60
675	.608341	TEE PVC SOCKET S40 2-1/2"	4 EA	1	39	4	21	0	0	3	67
675	.608391	CPLG PVC SOCKET S40 2-1/2"	4 EA	1	39	3	7	0	0	1	50
675	.608970	FLOOR DRAINS 3"	5 EA	15	586	79	368	0	0	45	1078
675	.608975	FLOOR DRAINS 4"	9 EA	27	1054	142	944	0	0	109	2249
675	.653019	GATE VALVE, BRONZE 1-1/4"	3 EA	1	39	7	88	0	0	10	144
675	.653020	CRANE 1324, CLASS 150, SJ GATE VALVE, BRONZE 1-1/2"	2 EA	1	39	6	66	0	0	7	118
675	.653021	CRANE 1324, CLASS 150, SJ GATE VALVE, BRONZE 2"	1 EA	1	39	4	47	0	0	5	95
675	.653436	CRANE 1324, CLASS 150, SJ BALL VALVE, BRASS 1/2"	4 EA	2	78	9	209	0	0	22	318
		JAMESBURY A11MT SCREWED ENDS. 600 PSI									

--WORK BREAKDOWN-- FACIL.STANDRD.WPKPG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
675	.653437	BALL VALVE, BRASS 3/4" JAMESBURY A11MT SCREWED ENDS, 600 PSI	6 EA	3	117	14	449	0	0	46	626
675	.653438	BALL VALVE, BRASS 1" JAMESBURY A11MT SCREWED ENDS, 600 PSI	7 EA	3	117	18	634	0	0	65	834
675	.675100	EF-1 EXHAUST FAN .50 HP/TEFC/120V/1800RPM/ GREENHECK MODEL BCF-108	1 EA	8	312	30	0	0	1471	3	1816
675	.675102	EF-2 EXHAUST FAN 3HP/TEFC/480V/1800RPM/ GREENHECK MODEL SPNE-36	1 EA	8	312	30	0	0	742	3	1087
675	.675104	EF-3 EXHAUST FAN 5HP/TEFC/480V/1800RPM/ GREENHECK MODEL SPNE-42	1 EA	8	312	30	0	0	918	3	1263
675	.675106	EF-4 EXHAUST FAN 1HP/TEFC/480V/1800RPM/ GREENHECK MODEL SPNE-36	1 EA	8	312	30	0	0	584	3	929
675	.675108	EF-5 EXHAUST FAN 3HP/TEFC/480V/1800RPM/ GREENHECK MODEL SPNE-36	1 EA	8	312	30	0	0	742	3	1087
675	.675110	EF-6 EXHAUST FAN .75HP/TEFC/480V/1800RPM/ GREENHECK MODEL SPNE-30	1 EA	8	312	30	0	0	508	3	853
675	.675120	AC-1 AIR CONDITIONER FAN W/COMPRESSOR/HEATER UNIT CORRECT AIR CORP MODEL SC24	1 EA	48	1872	181	0	0	5724	18	7795
675	.675125	AC-2 AIR CONDITIONER FAN W/COMPRESSOR/HEATER UNIT ADDISON MODEL PC044	1 EA	48	1872	181	0	0	5724	18	7795
675	.675130	AC-3 AIR CONDITIONER FAN W/COMPRESSOR/HEATER UNIT ADDISON MODEL PC044	1 EA	48	1872	181	0	0	5724	18	7795
675	.675135	HV-1 HEATING/VENTILATING UNIT W/UNIT HEATER 16KW BROD & MCCLUNG MODEL CRP-22	1 EA	48	1872	181	0	0	11584	18	13655
675	.675140	HV-2 HEATING/VENT. UNIT FAN W/UNIT HEATER 34KW BROD & MCCLUNG MODEL CRP-12	1 EA	48	1872	181	0	0	7983	18	10054
675	.675150	UH-1 UNIT HEATER A-G 10KW Q-MARK MODEL MUH-10-4	7 EA	112	4368	422	0	0	6307	42	11139
675	.675152	UH-2 UNIT HEATER A-U 15KW Q-MARK MODEL MUH-15-4	21 EA	336	13105	1265	0	0	21370	127	35867

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 20
DATE: 07/13/94 13:27
BY

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
675	.675154	UH-3 UNIT HEATER A-N 20KW	14 EA	224	8737	843	0	0	16324	84	25988
675	.675156	Q-MARK MODEL MUH-20-4 LV-1 LOUVERS A-X	24 EA	96	3744	361	0	0	14399	36	18540
675	.675158	AM WARM & VENT MOD LF-31A-A PRD-1 PRESSURE RELIEF DAMPER	1 EA	16	624	60	0	0	655	6	1345
675	.675200	AM WARM & VENT MOD PR-10 DUCTWORK - FOR HEATING/VEN- TILATING AND AIR CONDITION- ING UNITS	2165 LB	128	4997	0	1033	0	0	103	6133
675	.695550	ALLOWANCE FOR HANGERS AND SUPPORTS	1 LOT	80	3123	421	6731	0	0	715	10990
TOTAL		MECHANICAL		1,465	57,149	5,449	14,325	0	100,759	1,981	179,663
700		ELECTRICAL AND INSTRUMENTATION									
700	.700000	5 KVA POWER CONDITIONER FOR UPS SYSTEM	1 EA	16	627	57	3180	0	0	324	4188
700	.700001	1.5 KW RECTIFIER PANEL	1 EA	16	627	57	0	0	0	6	690
700	.700002	10 KW ELECTRIC UNIT HEATER	27 EA	432	16928	1545	0	0	0	155	18628
700	.700003	20 KW ELECTRIC UNIT HEATERS	14 EA	224	8777	801	0	0	0	80	9658
700	.700004	PLC I/O PANELS	4 EA	192	7523	687	0	0	0	69	8279
700	.700005	PLC WORKSTATIONS COMPLETE	2 EA	128	5016	458	0	0	0	46	5520
700	.700006	CRT WORKSTATION PRINTERS	2 EA	8	313	29	0	0	0	3	345
700	.700007	LOCAL THERMOSTAT, NEMA #4	6 EA	48	1881	172	954	0	0	113	3120
700	.700008	EMERGENCY LIGHTING FIXTURE	10 EA	80	3135	286	3180	0	0	347	6948
700	.700009	ELECTRIC PHOTOCELL	1 EA	8	313	29	212	0	0	24	578
700	.700010	3/4" CONDUIT "T" FITTING	200 EA	200	7837	715	5300	0	0	602	14454
700	.700011	1" CONDUIT "T" FITTING	10 EA	10	392	36	371	0	0	41	840
700	.700012	1 1/4" CONDUIT "T" FITTING	25 EA	0	0	0	1855	0	0	186	2041
700	.700013	1 1/2" CONDUIT "T" FITTING	40 EA	40	1567	143	3604	0	0	375	5689
700	.700014	2" CONDUIT "T" FITTING	35 EA	35	1371	125	3154	0	0	328	4978
700	.700015	START-UP AND CHECK-OUT	1 LOT	800	31347	2861	1060	0	0	392	35660
700	.700016	TEMPORARY POWER AND LIGHT	1 LOT	800	31347	2861	31800	0	0	3466	69474
700	.713052	15KV LIGHTNING ARRESTER & MOUNTING HARDWARE TYPE LVBB	1 EA	2	78	7	65	0	0	7	157
700	.722121	3/4" GRS EXPOSED CONDUIT W/FITTINGS & SUPPORTS	14400 LF	1901	74489	6797	24941	0	0	3174	109401
700	.722122	1" GRS EXPOSED CONDUIT W/FITTINGS & SUPPORTS	2160 LF	324	12696	1158	4962	0	0	612	19428
700	.722123	1-1/4" GRS EXPOSED CONDUIT W/FITTINGS & SUPPORTS	2715 LF	440	17241	1572	9106	0	0	1068	28987
700	.722124	1-1/2" GRS EXPOSED CONDUIT W/FITTINGS & SUPPORTS	620 LF	125	4898	446	2571	0	0	302	8217

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700	.722125	2" GRS EXPOSED CONDUIT W/FITTINGS & SUPPORTS	1950 LF	478	18730	1708	10796	0	0	1250	32484
700	.722126	2-1/2" GRS EXPOSED CONDUIT W/FITTINGS & SUPPORTS	500 LF	162	6348	580	4812	0	0	539	12279
700	.722127	3" GRS EXPOSED CONDUIT W/FITTINGS & SUPPORTS	900 LF	363	14224	1297	10953	0	0	1225	27699
700	.731121	3/C #4 EPR 15KV SHIELDED COPPER CABLE	40 LF	3	118	9	354	0	0	36	517
700	.731124	3/C #1/0 EPR 15KV SHIELDED COPPER CABLE	70 LF	6	235	21	890	0	0	91	1237
700	.731125	3/C #2/0 EPR 15KV SHIELDED COPPER CABLE	100 LF	9	353	32	1431	0	0	146	1962
700	.732126	3/C #2/0 EPR 5KV SHIELDED COPPER CABLE	250 LF	20	784	72	2319	0	0	239	3414
700	.733042	#10 THHN, 1/C, CU, 600V WIRE	9500 LF	76	2978	276	1208	0	0	148	4610
700	.733201	3/C #12 600V PWR CBL TYPE TC	8000 LF	80	3135	288	4927	0	0	522	8872
700	.733202	3/C #10 600V PWR CBL TYPE TC	2200 LF	31	1215	110	1912	0	0	202	3439
700	.733203	3/C #8 600V PWR CBL TYPE TC	1000 LF	25	980	89	1408	0	0	150	2627
700	.733204	3/C #6 600V PWR CBL TYPE TC	700 LF	25	980	90	1288	0	0	138	2496
700	.733205	3/C #4 600V PWR CBL TYPE TC	200 LF	9	353	33	514	0	0	55	955
700	.733206	3/C #2 600V PWR CBL TYPE TC	130 LF	7	274	23	509	0	0	53	859
700	.733208	3/C #1/0 600V PWR CBL TYPE TC	670 LF	41	1607	146	3509	0	0	366	5628
700	.733209	3/C #2/0 600V PWR CBL TYPE TC	230 LF	16	627	57	1437	0	0	149	2270
700	.733213	3/C 350 MCM 600V PWR CBL TYPE TC	1200 LF	121	4741	433	17374	0	0	1781	24329
700	.733401	2/C #14 600V CONTROL CABLE TYPE TC	5500 LF	50	1959	176	2419	0	0	260	4814
700	.733402	3/C #14 600V CONTROL CABLE TYPE TC	1200 LF	12	470	43	613	0	0	66	1192
700	.733404	5/C #14 600V CONTROL CABLE TYPE TC	2200 LF	26	1019	95	1782	0	0	188	3084
700	.733407	8/C #14 600V CONTROL CABLE TYPE TC	600 LF	9	353	32	585	0	0	62	1032
700	.734121	1PR #16 SHIELDED CABLE	8500 LF	85	3331	306	1352	0	0	166	5155
700	.734512	COAXIAL CABLE, RG A/U 59 75 OHMS, FIRE RATED	200 LF	3	118	11	350	0	0	36	515
700	.741001	1/C #6 TO 1/0 15KV TERM INCL HI-POTTING	18 EA	72	2821	258	1431	0	0	169	4679
700	.742006	1/C #2/0 TO 4/0 5KV TERM. INCL HI-POTTING	12 EA	48	1881	172	890	0	0	106	3049
700	.743001	1/C #16 TO #10 SOLDERLESS TERMINAL LUGS,600V	2893 EA	463	18142	1655	1135	0	0	279	21211
700	.743002	1/C #8 TO #4 SOLDERLESS TERMINAL LUGS,600V	78 EA	21	823	75	103	0	0	18	1019

--- FACIL. STANDRD. WPKG	DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
700 .743003 .	1/C #2 TO #1 SOLDERLESS TERMINAL LUGS, 600V	6 EA	2	78	8	18	0	0	3	107
700 .743004 .	1/C #1/0 TO #2/0 SOLDERLESS TERMINAL LUGS, 600V	48 EA	24	940	86	285	0	0	37	1348
700 .743008 .	1/C 350 MCM SOLDERLESS TERMINAL LUGS, 600V	114 EA	130	5094	465	1601	0	0	207	7367
700 .743009 .	1/C 500 MCM SOLDERLESS TERMINAL LUGS, 600V	20 EA	27	1058	95	281	0	0	38	1472
700 .751021 .	FEEDER BREAKER DRAWOUT TYPE, 1200A, 500 MVA, 13.8KV	3 EA	180	7053	644	0	0	79500	64	87261
700 .751209 .	XFORMER, PAD MTD, OIL FILLED 13.8KV/480/277V, 3PH, 1000 KVA	1 EA	80	3135	286	0	0	15688	29	19138
700 .751228 .	XFORMER, PAD MTD, SILICON FLD 13.8KV/480/277V, 2500 KVA	1 EA	140	5486	501	0	0	48654	50	54691
700 .752050 .	STARTER FVNR 4.16KV TO 1250 HP CLASS E-2	1 EA	40	1567	143	0	0	13886	14	15610
700 .753006 .	480V DRAWOUT AIR CIRCUIT BRKR 800A (ELECTRIC)	8 EA	192	7523	687	0	64	61056	69	69399
700 .753010 .	480V DRAWOUT AIR CIRCUIT BRKR 4000A (ELECTRIC)	1 EA	60	2351	215	0	8	45707	22	48303
700 .753150 .	COMBINATION CKT BRKR STARTER MCC MOUNTED, NEMA 1, CLASS 2 TYPE B, 480V, FVNR SIZE 1	45 EA	135	5290	483	0	0	45792	48	51613
700 .753151 .	COMBINATION CKT BRKR STARTER MCC MOUNTED, NEMA 1, CLASS 2 TYPE B, 480V, FVNR SIZE 2	7 EA	42	1646	150	0	0	8533	15	10344
700 .753152 .	COMBINATION CKT BRKR STARTER MCC MOUNTED, NEMA 1, CLASS 2 TYPE B, 480V, FVNR SIZE 3	5 EA	40	1567	143	0	0	9275	14	10999
700 .753153 .	COMBINATION CKT BRKR STARTER MCC MOUNTED, NEMA 1, CLASS 2 TYPE B, 480V, FVNR SIZE 4	9 EA	108	4232	386	0	0	30910	39	35567
700 .753154 .	COMBINATION CKT BRKR STARTER MCC MOUNTED, NEMA 1, CLASS 2 TYPE B, 480V, FVNR SIZE 5	2 EA	36	1411	129	0	0	14034	13	15587
700 .753180 .	CKT BRKR MCC MTD, 480V-15-100A	75 EA	75	2939	268	0	0	29018	27	32252
700 .753182 .	CKT BRKR MCC MTD, 480V, 400A	2 EA	10	392	36	0	0	3328	4	3760
700 .753190 .	MCC, MAIN BRKR, 480V, 600A	2 EA	32	1254	114	0	0	4632	11	6011
700 .753191 .	MCC, MAIN BRKR, 480V, 800A	4 EA	72	2821	258	0	0	13059	26	16164
700 .753231 .	TRANSFORMER, DRY INDOOR 5 KVA, 480V-120/208V, 3PH	1 EA	11	431	39	0	0	413	4	887
700 .753234 .	TRANSFORMER, DRY INDOOR 30 KVA, 480V-120/208V, 3PH	1 EA	20	784	72	0	0	1060	7	1923
700 .753301 .	UPS 5 KVA 480V INCLUDING 30 MIN BATTERY BACKUP	1 EA	48	1881	172	0	0	21200	17	23270

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
700	.753412	36 CKT PANEL BOARD NEMA 1 277/480V, 4W, 225A/3P, MAIN LUGS INCL 20A/1P BKRS.	2 EA	45	1763	159	0	0	3286	16	5224
700	.761013	FLUO LTG FIXTURE, TROFFER, SURF MTD, 2'X 4', W/2-40W LAMPS (ACRYLIC LENS)	6 EA	8	313	28	382	0	0	41	764
700	.761015	FLUO LTG FIXTURE, TROFFER, SURF MTD, 2'X 4', W/4-40W LAMPS (ACRYLIC LENS)	18 EA	27	1058	97	1507	0	0	160	2822
700	.761063	HPS, SURFACE MOUNTED 2'X 2', 400W LAMP	2 EA	7	274	24	704	0	0	73	1075
700	.761066	HPS, LOW BAY, RECESSED MTD 150W LAMP	121 EA	303	11873	1082	41556	0	0	4264	58775
700	.762007	RECEPT CORROSION RESISTANT 15A, 125V INCL BOX & COVER	30 EA	26	1019	91	655	0	0	75	1840
700	.762022	WELDING RECEPT 100A 3PH 600V	5 EA	15	588	54	1174	0	0	123	1939
700	.762031	TOGGLE SWITCH SINGLE POLE 15A 120V INCL BOX & COVER	10 EA	7	274	25	74	0	0	10	383
700	.762303	PUSHBUTTON START/STOP, NEMA 4 CHANNEL MOUNTED	49 EA	196	7680	701	6441	0	0	714	15536
700	.762313	SELECTOR SW, HANDS-OFF-AUTO NEMA 4, CHANNEL MOUNTED	6 EA	24	940	86	731	0	0	82	1839
700	.763017	#4/0 STRANDED, BCW, 600V	500 LF	10	392	36	956	0	0	99	1483
700	.763021	500 MCM STRANDED, BCW, 600V	1200 LF	29	1136	103	4910	0	0	501	6650
700	.763081	GROUND ROD 5/8"X 10'	6 EA	6	235	21	82	0	0	10	348
700	.763212	500 MCM AWG CADWELD	60 EA	120	4702	429	684	0	0	111	5926
700	.772005	11-LINE PHONE	2 EA	9	353	33	0	0	721	3	1110
700	.772107	PAGING MICROPHONE	9 EA	9	353	32	0	0	2385	3	2773
700	.772111	WP HORN TYPE SPEAKER	9 EA	18	705	64	0	0	1431	6	2206
700	.794100	PROCESS CONTROLS - EQUIPMENT/ DESIGN/FIELD SERVICES	1 LOT	3380	207802	0	0	0	164258	0	372060
700	.800100	PRESSURE TRANSMITTERS - ELECTRICAL ROSEMOUNT 1151GP	3 EA	12	470	43	0	0	3180	4	3697
700	.800102	FLOW TRANSMITTERS - MAGNETIC/ ELECTRICAL	1 EA	4	157	14	0	0	6042	1	6214
700	.800104	LEVEL SWITCHES - FLOATS	2 EA	8	313	29	0	0	1272	3	1617
700	.800106	LEVEL TRANSMITTERS D/P FLANGE ROSEMOUNT 1151LT-4-E-GO-M- 12-D	9 EA	36	1411	129	0	0	14215	13	15768
700	.800110	BUTTERFLY CONTROL VALVES 2"	6 EA	12	469	63	0	0	6360	6	6898
700	.800112	BUTTERFLY CONTROL VALVES 3"	1 EA	2	78	11	0	0	1166	1	1256
700	.800114	BUTTERFLY CONTROL VALVES 6"	2 EA	8	312	42	0	0	2756	4	3114

ICF KAISER ENGINEERS, INC.
DEPARTMENT OF ENERGY
JOB NO. 88107-250-00

ICF KAISER ENGINEERS INTERACTIVE ESTIMATING
20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
GENERAL ESTIMATE FOR REFERENCE
REPORT D1 - ESTIMATE DETAIL BY FACILITY

PAGE 24
DATE: 07/13/94 13:27
BY

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
=====		=====	=====	=====	=====	=====	=====	=====	=====	=====	=====
700	.800116 .	BUTTERFLY CONTROL VALVES 14"	1 EA	8	312	42	0	0	2332	4	2690
700	.800120 .	ANALYZER - PH ROSEMOUNT 2000 1054PH	1 EA	8	313	29	0	0	2226	3	2571
700	.800122 .	ANALYZER - DENSITY-NUCLEAR	3 EA	24	940	86	0	0	18603	9	19638
700	.800124 .	ANALYZER - TURBIDITY	2 EA	16	627	57	0	0	7844	6	8534
700	.800126 .	POWER POSITIONER - PNEUMATIC	2 EA	32	1254	114	0	0	3604	11	4983
TOTAL		ELECTRICAL AND INSTRUMENTATION		14,003		38,033		72		27,274	
					624,051		234,657		687,426		1,611,513
900		INDIRECTS AND DISTRIBUTABLES									
900	.901005 .	SURVEY SERVICES	1 LOT	0	0	0	0	10000	0	0	10000
900	.901010 .	TEMPORARY FIELD FAB SHOP	1 LOT	240	8819	1116	5300	0	0	642	15877
900	.901015 .	TEMPORARY POWER	1 LOT	240	9404	858	10600	0	0	1146	22008
900	.901035 .	FIELD CONSTRUCTION TRAILERS (2 EA)	12 MO	0	0	0	6360	0	0	636	6996
900	.901040 .	TOOL TRAILERS (2 EA)	12 MO	0	0	0	5088	0	0	509	5597
900	.901045 .	PORT A JOHNS (3 EA)	12 MO	0	0	0	2862	0	0	286	3148
900	.901050 .	POTABLE DRINKING WATER	1 LOT	0	0	0	1060	0	0	106	1166
900	.901055 .	ALLOWANCE FOR BARRICADES AND LIGHTS	1 LOT	160	5879	744	1590	0	0	233	8446
900	.901060 .	PICK UP TRUCKS (2 EA) RENTAL	12 MO	0	0	0	7632	0	0	763	8395
900	.901065 .	ALLOWANCE FOR FUEL, OIL AND GREASE FOR PICK UP TRUCKS	1 LOT	0	0	0	4240	0	0	424	4664
900	.901070 .	FIELD WAREHOUSE	1 LOT	320	11758	1487	12720	0	0	1421	27386
TOTAL		INDIRECTS AND DISTRIBUTABLES		960		4,205		10,000		6,166	
					35,860		57,452		0		113,683
901		ENGINEERING									
901	.901015 .	DESIGN ENGINEERING SERVICES W/BURDEN AND EXPENSES FOR SITE SPECIFIC DESIGN	1 LOT	0	0	0	0	600000	0	0	600000
TOTAL		ENGINEERING		0		0		600,000		0	
					0		0		0		600,000
902		PROJECT/CONSTRUCTION MANAGEMENT									
902	.902005 .	CONSTRUCTION MANAGEMENT PERSONNEL W/BURDEN AND EXPENSES	1 LOT	0	0	0	0	250000	0	0	250000
902	.902020 .	PROJECT MANAGEMENT SERVICES W/BURDEN AND EXPENSES	1 LOT	0	0	0	0	350000	0	0	350000

--WORK BREAKDOWN-- FACIL.STANDRD.WKPKG		DESCRIPTION	QUANTITY	MANHOURS	LABOR	EQUIP USAGE	MATERIAL	SUB- CONTRACT	EQUIP- MENT	S/C OH&P	TOTAL DOLLARS
TOTAL		PROJECT/CONSTRUCTION MANAGEMENT		0	0	0	0	600,000	0	0	600,000
903		FIELD OFFICE EXPENSES									
903	.903005 .	ICFKE FIELD OFFICE TRAILER	12 MO	0	0	0	6360	0	0	0	6360
903	.903012 .	TRAILER HOOK UP AND REMOVAL	1 EA	80	2940	372	0	1000	0	0	4312
903	.903015 .	FIELD VEHICLE FOR CONSTR. MANAGEMENT	12 MO	0	0	0	5088	0	0	0	5088
903	.903020 .	OFFICE SUPPLIES	12 MO	0	0	0	2544	0	0	0	2544
903	.903022 .	COPY MACHINE	12 MO	0	0	0	1908	0	0	0	1908
903	.903025 .	COMPUTERS	2 EA	0	0	0	10600	0	0	0	10600
903	.903030 .	TELEPHONE/FAX SERVICE	12 MO	0	0	0	3816	0	0	0	3816
903	.903060 .	UTILITY SERVICE	12 MO	0	0	0	3180	0	0	0	3180
TOTAL		FIELD OFFICE EXPENSES		80	2,940	372	33,496	1,000	0	0	37,808
904		INSURANCE/TAXES/PERMITS/									
904	.904105 .	ALL RISK INSURANCE	1 LOT	0	0	0	74200	0	0	0	74200
904	.904110 .	1% BOND	1 LOT	0	0	0	99640	0	0	0	99640
TOTAL		INSURANCE/TAXES/PERMITS/		0	0	0	173,840	0	0	0	173,840
REPORT TOTAL				48,319	1,937,022	229,765	1,677,178	1,211,072	4,675,561	169,948	9,900,546

ENGINEERING DRAWINGS

[illegible]

R 50'0" Ø THK.
R 55'0" Ø THK.

SECTION A
SCALE: 3/8" = 1'-0"

SECTION B
SCALE: 3/8" = 1'-0"

PLAN
SECTION D

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 1/4" = 1'-0" U.N.	DATE	PROFESSIONAL SEAL	ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 281-8121, TELEX: 199121
	DESIGNED BY					
	DRAWN BY		E. JAMISON			
	CHECKED BY					
	APPROVED BY					
	APPROVED BY					
INFORMATION CONFIDENTIAL. ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE HELD CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.						UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS FOUNDATIONS 50'0" DIA. CLEAN COAL THICKENER AND 55'0" DIA. REFUSE THICKENER
						JOS No. 88107-250-00 DWG. No. 10-20-1004
						REVISION R.

SCALE: 1/8" = 1'-0"

SCALE: $\frac{1}{8}'' = 1'-0$

1. DESIGN FABRICATION AND ERECTION OF STRUCTURAL STEEL SHALL BE IN ACCORDANCE WITH THE LATEST ISSUE OF THE AMERICAN INSTITUTE OF STEEL CONSTRUCTION SPEC. FOR THE DESIGN, FABRICATION, AND ERECTION OF STRUCTURAL STEEL FOR BUILDINGS, LATEST AMENDMENT.
2. STRUCTURAL STEEL SHALL CONFORM TO ASTM DESIGNATION A-36.
3. BOLTED CONNECTIONS TO BE WITH 3/4" ASTM A325 BOLTS WITH ONE WASHER, SLIP-CRITICAL TYPE UNLESS NOTED. BOLTED CONNECTIONS SHALL HAVE MINIMUM 2 BOLTS.
4. ALL FIELD CONNECTIONS FOR NONSTRUCTURAL APPLICATIONS TO BE MADE WITH 3/4" DIA. ASTM A307 MACHINE BOLTS.
5. ALL WELDED CONNECTIONS TO BE IN ACCORDANCE WITH THE LATEST AWS STRUCTURAL WELDING CODE AWS D1.1. ALL ELECTRODES SHALL BE OF THE E-70 SERIES
6. GUSSET PLATES SHALL BE A MINIMUM 3/4" THICK UNLESS NOTED.
7. GRATING: WELDED STEEL GALVANIZED GRATING WITH 1" X 3/16 BEARING BARS AT 1 3/16" O.C. AND 1/4" CROSSBARS @ 4" O.C. ALL FREE EDGES OF GRATING SHALL BE Banded, AND COMPLETED WITH HOLD DOWN CLIPS.
8. STAIR TREADS SHALL BE WELDED STEEL GALVANIZED GRATING WITH 1 X 3/16" BEARING BARS FURNISHED WITH SAFETY NOSING.
9. HANDRAIL SHALL BE BAR AND ROD TYPE IN ACCORDANCE WITH OSHA STANDARDS.
10. LADDERS SHALL BE IN ACCORDANCE WITH OSHA STANDARDS.
11. METAL DECK SHALL BE GALV. 1 1/2" V-GRIP/20 GAGE.
12. FIBER GLASS-REINFORCED GRATING (FRP) SHALL BE 1" RECTANGULAR MESH.
13. FOR ROOFING AND SIDING NOTES SEE DWG. 10-40-1201.

WORK THIS DWG. WITH DWGS. 10-30-1102
THRU. 10-30-1106

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 1/8" = 1'-0"	DATE	PROFESSIONAL SEAL	ICF KAISER ENGINEERS	ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1307 (412) 281-8121, TELEX: 199121
	DRAWN BY	J. MICIKAS	6/17/94				
	CHECKED BY	E. JAMISON	6/17/94				
	CHECKED BY						
	APPROVED BY						
	APPROVED BY						
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UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS STRUCTURAL ROOF PLAN	JOS No. 88107-250-00		DWG. No. 10-30-1101		REVISION		

!

L. 54'-0 (T/6" CONC. FL.)
T/STL. (-) 6"

EL. 64'-0 (BOTT./LIFT BEAM)

NOTE:
WORK THIS DWG. WITH DWGS. 10-30-1101,
10-30-1102 & 10-30-1104 THRU. 10-30-1106

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 1/8"=1'-0	DATE	PROFESSIONAL SEAL	ICF KAISER ENGINEERS ENGINEERS	ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 281-8121, TELEX: 199121		
	DESIGNED BY	J. MICIKAS	6/17/94						
	DRAWN BY	E. JAMISON	6/17/94						
	CHECKED BY					UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS STRUCTURAL PLAN @ EL. 40'-0, 54'-0 & 64'-0			
	APPROVED BY								
	APPROVED BY								
	APPROVED BY								
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ELEVATION (B) 10-30-1101, 1102, 1103

SECTION (E) 10-30-1101

PLAN @ EL. 16'-0" (T/GRT'G) T/STL. (-) 14"

SECTION (F) 10-30-1101

WORK THIS DWG. WITH DWGS. 10-30-1101 THRU. 10-30-1103, 10-30-1105 & 10-30-1106

CONSTRUCTION APPROVAL APPROVAL DATE SCALE: 1/8" = 1'-0" DATE DESIGNED BY: J. MICIKAS 6/17/94 DRAWN BY: E. JAMISON 6/17/94 CHECKED BY: APPROVED BY: APPROVED BY:	PROFESSIONAL SEAL ICF KAISER ENGINEERS UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS STRUCTURAL ELEVATIONS & SECTIONS JOB No. 88107-250-00 DWG. No. 10-30-1104	ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 281-8121, TELEX: 189121 REVISION R.
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SECTION **K**
10-30-1101
1102
1103

SECTION **L**
10-30-1101

ELEVATION **N**
10-30-1101, 1102 & 1103

NOTE:
WORK THIS DWG. WITH DWGS.
10-30-1101 THRU. 10-30-1104 &
10-30-1106

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 1/8" = 1'-0"	DATE	PROFESSIONAL SEAL	ICF KAISER ENGINEERS UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS STRUCTURAL ELEVATION & SECTIONS	ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 281-8121, TELEX: 199121
	DESIGNED BY	J. MICIKAS	6/7/94				
	DRAWN BY	E. JAMISON	6/7/94				
	CHECKED BY						
	APPROVED BY						
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JOB No. 88107-250-00						DWG. No. 10-30-1105	
						REVISION R.	

7/21/9

* ALL FURNITURE & EQUIPMENT
MANUFACTURED BY PREISER SCIENTIFIC, INC.
OR APPROVED EQUAL.

PLAN - LABORATORY

SECTION (C)

NOTES:

1. WALL TYPE "A" (EXTERIOR BLDG. CORNER)

- EXTERIOR SIDING TO BE 1" x 22 GA./4" RIBBED GALV STEEL WITH "KYNAR" FINISH, ATTACHED TO C8x11.5 GIRT SYSTEM.
- GIRT SPACE TO BE INSULATED WITH 6" FIBERGLASS BATT BAGGED.
- INTERIOR PANEL TO BE 1 1/2" x 24 GA PERFORATED, GALV STEEL WITH "KYNAR" FINISH. INTERIOR PANEL TO BE SUPPLIED WITH SOUND ATTENUATION BLANKET.

2. WALL TYPE "B"

- 6" x 16 GA GALV METAL STUD @ 16" O.C. COMPLETE WITH TOP & BOTTOM RUNNER CHANNELS REINFORCED THRU CENTER WITH 3/4" x 3/4" STEEL CHANNEL AT 24" C/C WELDED TO THE WEB OF THE METAL STUDS. 3/4" HAT FURRING CHANNEL AT 24" CENTERS ARE ATTACHED TO METAL STUD FOR THE ATTACHMENT OF FINISHED SIDING PANELS. INSTALL 3 1/2" OF BAGGED BATT INSULATION.
- SIDING FACING PLANT TO BE 1" x 22 GA./4" RIBBED GALV STEEL WITH "KYNAR" FINISH.
- INTERIOR ROOM SIDING TO BE 1 1/2" x 24 GA PERFORATED, GALV STEEL W/"KYNAR" FINISH. INTERIOR PANEL TO BE SUPPLIED WITH SOUND ATTENUATION-BLANKET.
- FINISHED WALL TO ATTACH TO FLOOR STEEL ABOVE W/FINISH WALL HGT. OF 12'0".

3. WALL TYPE "C"

- CONSTRUCTION OF WALL STUD SYSTEM SAME AS WALL TYPE "B"
- FINISH PANEL ON ELECTRICAL ROOM SIDE TO BE 1 1/2" x 22 GA "C-WALL", GALV STEEL WITH "KYNAR" FINISH.
- FINISH PANEL ON CONTROL ROOM SIDE TO BE THE SAME PERFORATED PANEL AND SOUND INSULATION AS WALL TYPE "B"

4. ALL SIDING INSTALLED COMPLETE WITH ALL REQUIRED CLOSURES, CAULKING, METAL TRIM ITEMS FOR AN AIR TIGHT CONDITION.

ALL SIDING LISTED SHALL BE AS MANUFACTURED BY E.G. SMITH CONSTRUCTION PRODUCTS INC. OR APPROVED EQUAL.

5. FOR WINDOW SPEC. SEE GENERAL NOTES ON DRAWING 10-40-1201.

6. WORK THIS DWG. WITH DWGS. 10-40-1201, 10-40-1203, 10-40-1204.

7. FOR LISTING OF REFERENCE DRAWINGS AND LEGEND SEE DWG. 10-40-1201.

NOTE: 1.) BOTTOM OF LOW DUCT OPENINGS ARE 1'-4" ABOVE TOP OF SLAB.
2.) TOP OF HIGH DUCT OPENINGS ARE 7'-4" ABOVE TOP OF SLAB.

CONSTRUCTION APPROVAL

APPROVAL

DATE

SCALE: 1/4" = 1'-0"

DATE

PROFESSIONAL SEAL

ICF KAISER
ENGINEERS

ICF KAISER ENGINEERS INC.
Four Gateway Center
Pittsburgh, PA 15222-1207
(412) 281-8121, TELEX: 199121

UNITED STATES DEPARTMENT OF ENERGY
ADVANCED FROTH FLOTATION PROCESS
M.C.C. ROOM PLAN, LABORATORY PLAN, NOTES
AND SECTIONS

JOS No. 88107-250-00 DWG. No. 10-40-1202

REVISION
2.

INFORMATION CONFIDENTIAL: ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE HELD CONFIDENTIAL AND SHALL NOT

[illegible]

SECTION C
10-40-1201

SECTION D
10-40-1201

- 1L (2) AS SHOWN
10-40-1201
1L (3) SIMILAR
10-40-1201

COLUMN LOCATION	B.2	DS	B5,C5 E5	B4,E4
-----------------	-----	----	-------------	-------

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE 1/2" = 1'-0"	DATE	PROFESSIONAL SEAL
	DESIGNED BY	F. MINORONE	6/9/94		
	DRAWN BY	D.J. WALKOWSKI	6/9/94		
	CHECKED BY				
	APPROVED BY				
	APPROVED BY				

ICF KAISER
ENGINEERS

ICF KAISER ENGINEERS INC.
Four Gateway Center
Pittsburgh, PA 15222-1207
(412) 281-8121, TELEX: 199121

UNITED STATES DEPARTMENT OF ENERGY
ADVANCED FROTH FLOTATION PROCESS
WALL SECTIONS &
DETAILS

JOB No. 88107-250-00 DWG. No. 10-40-1203

REVISION
R.

ROOM FINISH SCHEDULE

BUILDING OR AREA	DRAWING NUMBER	ROOM NAME	ROOM NUMBER	CEILING	WALLS	FLOOR	BASE	DOOR FRAMES		WINDOW FRAMES		TOILET PARTITION	URINAL SCREEN	LOCKERS			
								INTERIOR	EXTERIOR	INTERIOR	EXTERIOR						
ADVANCED FORTH FLORATION PROCESSING BUILDING	GROUND FLOOR, OFFICE & LOCKER ROOMS	GRD. FLR.	100	C/1	C/1	A/2	-	1	1	-	-	-	-	-	-	-	-
		OFFICE	101	D	B/1	E	2	1	1	1	1	-	-	-	-	-	-
		CORRIDOR	102	D	B/1	E	2	1	1	-	-	-	-	-	-	-	-
		MEN'S LOCKER ROOM	103	D	B/3	E	G	1	1	-	-	1	1	1	-	-	-
		JANITOR'S CLOSET	104	D	B/3	E	G	1	1	-	-	-	-	-	-	-	-
		WOMEN'S LOCKER ROOM	105	D	B/3	E	G	1	1	-	-	1	-	1	-	-	-
	N.C.C. ROOM	LAB	106	D	B/3	E	G	1	1	-	-	-	-	-	-	-	-
		CONTROL RM.	200	D	H	I	F	1	1	1	1	-	-	-	-	-	-
		ELECT. RM.	201	C/1	H	A/2	-	1	1	-	-	-	-	-	-	-	-

COLOR SELECTED BY OWNER - 1

DOOR SCHEDULE

BUILDING OR AREA	DRAWING NUMBER	DOOR NUMBER	ROOM NUMBER	DOOR TYPE	DOOR SAVING	DOOR SIZE			DOOR MATERIAL	DETAILS			LOUVER SIZE	HARDWARE NUMBER	DOOR/FRAME FIRE RATING	DOOR FRAME		DOOR/FRAME FINISH	REMARKS
						WIDTH	HEIGHT	THICKNESS		HEAD	JAMB	SILL				MAT'L	SIZE		
ADVANCED FORTH FLORATION PROCESSING BUILDING	GROUND FLOOR, OFFICE & LOCKER ROOMS	1	100	A	-	10'-0"	10'-0"	-	-				-	1	-	-	-		OVERHEAD ROLL-UP DOOR
		2	100	C	LHRB	3'-0"	7'-0"	1 3/4"	H.M.				-	2	-	P.M.	2" JAMB & 4" HEAD		
		3	100	B	RHRB	PR. 4'-0"	7'-0"	1 3/4"	H.M.				-	3	-	P.M.	2" HEAD & SILL		w/REMOVABLE TRANSOM
		4	100	C	RHRB	3'-0"	7'-0"	1 3/4"	H.M.				-	2	-	P.M.	2" JAMB & 4" HEAD		
		5	100	B	RHRB	PR. 4'-0"	7'-0"	1 3/4"	H.M.				-	3	-	P.M.	2" JAMB & SILL		w/REMOVABLE TRANSOM
		6	106	C	RHRB	3'-0"	7'-0"	1 3/4"	H.M.				-	2	-	P.M.	2" JAMB & 4" HEAD		
		7	106	C	RA	3'-0"	7'-0"	1 3/4"	H.M.				-	4	1 1/2	P.M.	2" JAMB & 4" HEAD		
		8	100	B	RHRB	PR. 4'-0"	7'-0"	1 3/4"	H.M.				-	3	-	P.M.	2" JAMB & HEAD		w/REMOVABLE TRANSOM
		9	100	A	-	10'-0"	10'-0"	-	-				-	1	-	-	-		OVERHEAD ROLL-UP DOOR
		10	102	C	RHRB	3'-0"	7'-0"	1 3/4"	H.M.				-	2	-	P.M.	2" JAMB & 4" HEAD		
		11	101	C	RHRB	3'-0"	7'-0"	1 3/4"	H.M.				-	4	-	P.M.	2" JAMB & 4" HEAD		
		12	103	D	RA	3'-0"	7'-0"	1 3/4"	H.M.				-	5	-	P.M.	2" JAMB & 4" HEAD		
		13	103	D	LH	3'-0"	7'-0"	1 3/4"	H.M.				-	5	1 1/2	P.M.	2" JAMB & 4" HEAD		
		14	105	D	RA	3'-0"	7'-0"	1 3/4"	H.M.				-	5	1 1/2	P.M.	2" JAMB & 4" HEAD		
		15	102	C	RA	3'-0"	7'-0"	1 3/4"	H.M.				-	5	1 1/2	P.M.	2" JAMB & 4" HEAD		
		16	104	D	RHRB	3'-0"	7'-0"	1 3/4"	H.M.				-	4	-	P.M.	2" JAMB & 4" HEAD		
	N.C.C. ROOM	17	101	C	LHRB	3'-0"	7'-0"	1 3/4"	H.M.				-	5	1 1/2	P.M.	2" JAMB & 4" HEAD		
		18	200	C	LHRB	3'-0"	7'-0"	1 3/4"	H.M.				-	1	1 1/2	P.M.	2" JAMB & 4" HEAD		
		19	201	E	LH	3'-0"	7'-0"	1 3/4"	H.M.				-	4	1 1/2	P.M.	2" JAMB & HEAD		w/REMOVABLE TRANSOM
		20	201	BA	LHRB	PR. 2'-6"	7'-0"	1 3/4"	H.M.				-	6	1 1/2	P.M.	2" JAMB & SILL		w/REMOVABLE TRANSOM
		21	201	C	LHRB	3'-0"	7'-0"	1 3/4"	H.M.				-	1	1 1/2	P.M.	2" JAMB & 4" HEAD		
		22	ELEV. 40'-0"	F	LHRB	PR. 4'-0"	10'-0"	1 3/4"	H.M.				-	8	-	P.M.	2" JAMB & SILL		
	EL. 54'-0"			C	LHRB	3'-0"	7'-0"	1 3/4"	H.M.				-	7	1 1/2	P.M.	2" JAMB & 4" HEAD		

ON RIG ACT

LEF

LEI

D

OC

TYP. DOOR TYPES

NO	DATE	REVISION	BY	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST
									WORK COVERED BY THIS ACC	
									CHARGED TO COST ACCOUNT	

FINISH SCHEDULE KEYS:

MATERIALS

- A - CONCRETE
- B - CONCRETE BLOCK
- C - EXPOSED STRUCTURE
- D - 2" x 4" ACOUSTIC TILE, LAY IN TYPE w/ MYLAR FINISH INSTALLED IN 2' x 4' SUSPENDED FIRE RATED GRID (8'-0" CEILING HEIGHT A.F.F.)
- E - SEAMLESS EPOXY RESIN FLOOR
- F - 4" RUBBER w/ SANITARY COVE
- G - 4" SEAMLESS EPOXY RESIN BASE w/ SANITARY COVE
- H - PRE-FINISHED METAL PANEL
- I - COMPOSITION TILE (1/2" THK.)

FINISH

- 1 - PAINT
- 2 - STEEL TROWEL / PENETRATING SEALER
- 3 - EPOXY PAINT

HARDWARE SCHEDULE

DESCRIPTION	HARDWARE GROUP NUMBER										REMARKS
	1	2	3	4	5	6	7	8	9	10	
1 1/2" PAIR 4 1/2" x 4 1/2" B.G. PAINTED STEEL HINGES PER LEAF	•	•	•	•	•	•	•	•	•	•	
DOOR CLOSER	•	AL	•	•	•	•	•	•	•	•	
RIM TYPE EXIT DEVICE w/ OUTSIDE LEVER TRIM SET AND CYLINDER	•	AL	•	•	•	•	•	•	•	•	
RIM TYPE EXIT DEVICE w/ OUTSIDE LEVER TRIM SET	•	•	•	•	•	•	•	•	•	•	
LEVER LATCH SET	•	•	•	•	•	•	•	•	•	•	
LOCKSET w/ CYLINDER	•	•	•	•	•	•	•	•	•	•	
THRESHOLD	•	•	•	•	•	•	•	•	•	•	
5" ALUMINUM SADDLE	•	•	•	•	•	•	•	•	•	•	
HEAD AND JAMB WEATHER STRIPPING	•	•	•	•	•	•	•	•	•	•	
ASTRICAL STRIP (AT DOUBLE DOORS) WEATHER STRIPPING	•	•	•	•	•	•	•	•	•	•	
HARDWARE AS SUPPLIED BY DOOR MANUFACTURER	•	•	•	•	•	•	•	•	•	•	
PUSH/PULLS	•	•	•	•	•	•	•	•	•	•	
DEAD BOLTS - HEAD & SILL	•	•	•	•	•	•	•	•	•	•	
KICK PLATES, 8" HIGH S. STEEL (EACH FACE)	•	•	•	•	•	•	•	•	•	•	
DOOR STOP	•	•	•	•	•	•	•	•	•	•	
DOOR STOP w/ HOOK	•	•	•	•	•	•	•	•	•	•	
SAFETY BOTTOM BAR	•	•	•	•	•	•	•	•	•	•	
RUBBER SILENCERS	•	•	•	•	•	•	•	•	•	•	

HARDWARE SCHEDULE LEGEND:

- AL - ACTIVE LEAF
- IL - INACTIVE LEAF
- BL - BOTH LEAFS

ALL KEYING SHALL BE MASTER KEYED TO OWNERS SYSTEM.

SUPPLY NUMBER OF KEYS AS DIRECTED BY OWNER

PAIRS OF DOORS-KEY SIDE
HT HAND LEAF IS ALWAYS
IVE UNLESS SPECIFIED OTHERWISE.

DOOR SWING DESIGNATIONS

SEND

DOOR SYMBOL

DOOR / FRAME NOTES:

- DOORS SHALL BE 18 GA., INSULATED, GALVANIZED, PRIME PAINTED, REINF. FOR ALL HARDWARE ITEMS. SEE SCHEDULE FOR FIRE RATING.
- DOOR FRAMES SHALL BE 2x5 1/2 x 16 GA. OR 2x4 1/2 x 16 GA. GALVANIZED, PRIME PAINTED, REINF. FOR HARDWARE ITEMS. SEE SCHEDULE FOR FIRE RATING.

REMOVABLE
TRANSOM
PANEL

NOTE:

WORK THIS DRAWING WITH DRAWINGS
10-40-1201 & 10-40-1202

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION DOOR SCHEDULE AND FINISH SCHEDULE
			DESIGNED BY: F. HINGRONE	6/9/94		
			DRAWN BY: D. J. WALKOWSKI	6/9/94		
			CHECKED BY:			
			APPROVED BY:			
COUNT						JOB NO. 88107-250
PRINT						DWG. NO. 10-40-1204
						R-

[illegible]

ELEVATION **(B)**
10-50-0203 THRU 0205

WORK THIS DWG WITH DWG 10-50-0202
10-50-0203
10-50-0204
10-50-0205

CONSTRUCTION APPROVAL 	APPROVAL	DATE	SCALE: 1/8" = 1'-0"	DATE	PROFESSIONAL SEAL ICF KAISER ENGINEERS UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS ELEVATIONS A & B GENERAL ARRANGEMENT JOB No. 88107-250-00 DWG. No. 10-50-0201
	DESIGNED BY	S. FOGELSON	4/5/94		
	DRAWN BY	S. FOGELSON	9/10/94		
	CHECKED BY				
	APPROVED BY				
COUNT	INFORMATION CONFIDENTIAL. ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE HELD CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.				
	ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 281-8121, TELEX: 199121				
	REVISION R.

SECTION C-D
10-50-0203 THRU 0205

WORK THIS DWG WITH DWG 10-50-0201
10-50-0103
10-50-0204
10-50-0205

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 1/8" = 1'-0"	DATE	PROFESSIONAL SEAL	ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 281-8121, TELEX: 199121
	DESIGNED BY					
	DRAWN BY		R.L./E.Z.	5/10/94		
	CHECKED BY					
	APPROVED BY					
	APPROVED BY					
INFORMATION CONFIDENTIAL. ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE HELD CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.						
UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS SECTIONS C & D GENERAL ARRANGEMENT						
JOB No. 88107-250-00						DWG. No. 10-50-0202
						REVISION

UH-1
UH-2
UH-3

[illegible]

NO CYCLOPS

KEY PLAN

SCALE: 1" = 20'-0"

WORK THIS DWG WITH DWG 10-50-0201
10-50-0202
10-50-0203
10-50-0204

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 1/8" = 1'-0" U.N.	DATE	PROFESSIONAL SEAL	ICF KAISER ENGINEERS UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS PLAN AT ELEV. 54'-0" & KEY PLAN GENERAL ARRANGEMENT	ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 281-8121, TELEX: 199121
	DESIGNED BY			4/9/96			
	DRAWN BY			5/10/96			
	CHECKED BY						
	APPROVED BY						
	APPROVED BY						
INFORMATION CONFIDENTIAL. ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HERewith ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE HELD CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.							
JOB No. 88107-250-00						DWG. No. 10-50-0205	
						REVISION R.

SANITARY RISER DIAGRAM
N.T.S.

FL. ELEV. 40'-0" (LINE 833 NOTED)

WORK THIS DWG WITH DWG 10-55-0701
10-55-0703

CONSTRUCTION APPROVAL ACCOUNT DRAWING IT ABOVE	APPROVAL	DATE	SCALE: 1/8" = 1'-0"	DATE	PROFESSIONAL SEAL ICF KAISER ENGINEERS UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS PLAN AT ELEV. 28'-0" & 40'-0" AND PLUMBING DIAGRAMS JOB No. 88107-250-00 DWG. No. 10-55-0702 REVISED
	DESIGNED BY		W. L. COWHER	2/23/94	
	DRAWN BY		W. L. COWHER	2/23/94	
	CHECKED BY				
	APPROVED BY				
INFORMATION CONFIDENTIAL. ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE 100% CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSES NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.					

ELECTRIC UNIT HEATER SCHEDULE								
UNIT	KW	VOLTS	PHASE	NO. OF STAGES	BTU/HR OUTPUT	CFM AIR	MOUNTING HEIGHT	REMARKS
UH-1	10	480	3	1	34,150	650	8'-0"	Q-MARK, MODEL MUH-10-4, W/INTEGRAL T-STAT
UH-2	15	480	3	1	51,225	910	8'-0"	Q-MARK, MODEL MUH-15-4, W/INTEGRAL T-STAT
UH-3	20	480	3	1	68,300	1320	8'-0"	Q-MARK, MODEL MUH-20-4, W/INTEGRAL T-STAT

EXHAUST FAN SCHEDULE							
ITEM NO.	LOCATION	CFM	S. P.	RPM	MOTOR	DESCRIPTION	MODEL
EF-1	LOCKER ROOMS	1200	0.125	905	½ HP	120 V-1# BELT DRIVEN CABINET FAN, W/BIRD SCREEN	GREENHECK MODEL BCF-108
EF-2	ELEV. 0'-0"	20,100	0.125	804	3 HP	480 V-3# BELT DRIVEN SIDE WALL FAN, W/WEATHER HOOD, BACKDRAFT DAMPER, & T-STAT.	GREENHECK MODEL SPNE-36
EF-3	ELEV. 14'-0"	26,300	0.125	750	5 HP	480 V-3# BELT DRIVEN SIDE WALL FAN, W/WEATHER HOOD, BACKDRAFT DAMPER, & T-STAT.	GREENHECK MODEL SPNE-42
EF-4	ELEV. 28'-0"	13,000	0.125	560	1 HP	480 V-3# BELT DRIVEN SIDE WALL FAN, W/WEATHER HOOD, BACKDRAFT DAMPER, & T-STAT.	GREENHECK MODEL SPNE-36
EF-5	ELEV. 40'-0"	20,000	0.125	804	3 HP	480 V-3# BELT DRIVEN SIDE WALL FAN, W/WEATHER HOOD, BACKDRAFT DAMPER, & T-STAT.	GREENHECK MODEL SPNE-36
EF-6	ELEV. 54'-0"	9,000	0.125	680	¾ HP	480 V-3# BELT DRIVEN SIDE WALL FAN, W/WEATHER HOOD, BACKDRAFT DAMPER, & T-STAT.	GREENHECK MODEL SPNE-30

WALL LOUVER SCHEDULE		
ITEM NO.	SIZE	DESCRIPTION
LV-1	4'-0" X 4'-0" X 6" DEEP	GALV. LOUVERS W/SEALS, AMERICAN WARMING & VENT MODEL LF-31A-A

HV-1 ELECTRICAL ROOM

ONE FLOOR MOUNTED PACKAGED HEATING & VENTILATING UNIT RATED AT 9000 CFM, 480 V-3#, 60 HZ., 5 HP. WITH A 16 KW, 480 V-3#, 60 HZ, ELECTRIC HEAT STRIP. FULLY WIRED WITH DISCONNECT SWITCH AND THERMOSTAT. UNIT SHALL BE BROD & MCLUNG MODEL CRP-22 OR APPROVED EQUAL.

HV-2 LOCKER ROOMS

ONE FLOOR MOUNTED PACKAGED HEATING & VENTILATING UNIT RATED AT 1300 CFM, 480 V-3#, 60 HZ., 2 HP. WITH A 34 KW, 480 V-3#, 60 HZ, ELECTRIC HEAT STRIP. FULLY WIRED WITH DISCONNECT SWITCH AND THERMOSTAT. UNIT SHALL BE BROD & MCLUNG MODEL CRP-12 OR APPROVED EQUAL.

AC-1 OFFICE

ONE THRU. WALL PACKAGED AIR CONDITIONING UNIT RATED AT 24,000 BTUH, WITH A 3 KW ELECTRIC HEAT STRIP, 480 V-3#, 60 HZ & STARTER. UNIT SHALL BE CORRECT-AIR CORPORATION MODEL SC24 OR APPROVED EQUAL.

AC-2 CONTROL ROOM

ONE FLOOR MOUNTED PACKAGED AIR CONDITIONING UNIT RATED AT 31,000 BTUH SENSIBLE AND 46,200 BTUH TOTAL, WITH A 9KW ELECTRIC HEAT STRIP, 480V, 3#, 60HZ, STARTER & THERMOSTAT UNIT SHALL BE ADDISON MODEL PC044 OR APPROVED EQUAL.

AC-3 LAB

ONE FLOOR MOUNTED PACKAGED AIR CONDITIONING UNIT RATED AT 31,100 BTUH SENSIBLE AND 46,200 BTUH TOTAL, WITH AN 18 KW ELECTRIC HEAT STRIP, 480 V-3#, 60 HZ, STARTER AND THERMOSTAT. UNIT SHALL BE ADDISON MODEL PC044 OR APPROVED EQUAL.

DETAIL 1
105507C
INTERIOR SAFETY
SHOWER AND EYE WASH

NO	DATE	REVISION	BY	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST
									WORK COVERED BY THIS ACC	CHARGED TO COST ACCOUNT

SPECIFICATIONS

CONNECTION TO FIXTURES				
E	CW	HW	WASTE	VENT
1	1/2"	—	3" 4"	2"
1	1/2"	1/2"	1 1/2"	1 1/2"
1	1/2"	1/2"	2"	1 1/2"
-1	1/2"	—	1 1/2"	1 1/2"
-	1/2"	1/2"	3"	2"
1	3/4"	—	2"	1 1/2"

WATER CLOSET WC-1

FLOOR MOUNTED, SIPHON JET, VITREOUS CHINA, 18" HIGH, CLOSE-COUPLED CLOSET COMBINATION WITH ELONGATED RIM, VITREOUS CHINA CLOSET TANK WITH FITTINGS AND LEVER FLUSHING VALVE, BOLT CAPS, "AMERICAN STANDARD" CADET NO. 2108.408 OR EQUAL.

SOLID WHITE PLASTIC SEAT WITH OPEN FRONT AND COVER, BRASS BOLTS.

URINAL UR-1

EACH URINAL SHALL BE "AMERICAN STANDARD" NO. 6561.017 TRIMBROOK WHITE VITREOUS CHINA, WATER SAVER, SIPHON JET WITH 3/4" TOP SPUD, FLUSHING RIM, EXTENDED STALL SIDE, OUTLET CONNECTION THREADED 2" INSIDE, AND WALL HANGERS WITH FLUSH VALVE

LAVATORY L-1

LAVATORY SHALL BE "AMERICAN STANDARD" MODEL "AQUALYN" 0476.028.20" X 18" WITH CONCEALED ARMS, FLAT SLAB VITREOUS CHINA WITH FRONT OVERFLOW, FAUCET HOLES ON 4" CENTER, PROVIDE 4" CENTERSET FAUCET WITH VALVES WITH RENEWABLE SEATS, FITTINGS SHALL INCLUDE 1/2" MALE THREADED INLETS, COUPLING NUTS, 4 1/2" SPOUT WITH REATOR WITH 2.5 GPM FLOW RESTRICTOR, LESS POP-UP DRAIN.

FLOOR DRAIN FD-1

12" HEAVY DUTY DRAIN, DRAIN SHALL BE DUCO CAST IRON BODY AND FLASHING COLLAR WITH NICKEL BRONZE ADJUSTABLE STRAINER HEAD, BOTTOM OUTLET, "ZURN" Z-521 SERIES.

FLOOR DRAIN FD-2

10" MEDIUM DUTY DRAIN, DRAIN SHALL BE DUCO CAST IRON BODY AND FLASHING COLLAR WITH POLISHED BRONZE ADJUSTABLE STRAINER HEAD, "ZURN" ZB-525 SERIES.

ELECTRIC WATER HEATER WH-1

HEATER SHALL BE RATED AT 9 KW, 240V, 1 PHASE, 60 CYCLE. HEATER SHALL HAVE A MAXIMUM PRESSURE OF 150 PSI AND A NOMINAL STORAGE TANK CAPACITY OF 40 GAL. ALL INTERNAL SURFACES OF THE HEATER EXPOSED TO WATER SHALL BE GLASS LINED. ELECTRIC HEATING ELEMENT SHALL BE ZINC PLATED COPPER SHEATH, SCREW-IN DESIGN. HEATER SHALL HAVE 10-YEAR LIMITED WARRANTY. WATER HEATER SHALL BE LOCHINVAR MODEL ESA-040 OR APPROVED EQUAL.

ELECTRIC WATER HEATER WH-2

HEATER SHALL BE RATED AT 1.5 KW, 120V, 1 PHASE, 60 CYCLE. HEATER SHALL HAVE A MAXIMUM PRESSURE OF 150 PSI AND A NOMINAL STORAGE TANK CAPACITY OF 6 GAL. ALL INTERNAL SURFACES OF THE HEATER EXPOSED TO WATER SHALL BE GLASS LINED. ELECTRIC HEATING ELEMENT SHALL BE ZINC PLATED COPPER SHEATH, SCREW-IN DESIGN. HEATER SHALL HAVE 10-YEAR LIMITED WARRANTY. UNDER-COUNTER TYPE, LOCHINVAR MODEL JAC-600E OR APPROVED EQUAL.

SHOWER SH-1

CABINET SHALL BE SINGLE ACCESS, FRONT OPENING WITH A ONE PIECE, 6' HIGH TERRAZZO FLOOR. NOMINAL DIMENSIONS ARE 36" X 36" X 82". CABINET TO BE FURNISHED WITH PRESSURE-EQUALIZING VALVE WITH SHOWER HEAD, ARM AND FLANGE. STAINLESS STEEL CURTAIN ROD WITH CHROMIUM-PLATED BRASS BRACKETS, CURTAIN AND CHROMIUM-PLATED BRASS SOAP DISH. SHOWER HEAD RATED AT 4 GPM, FIAT PRODUCTS, INC., COMMANDER MODEL 86 OR APPROVED EQUAL.

HOP RECEPTOR H.R.

THE UNIT SHALL HAVE 10" HIGH WALLS WITH NOT LESS THAN 1" WIDE SHOULDERS AND AN INTEGRATED MOLDED SHELL 10 1/2" WIDE. THE FACTORY INSTALLED DRAIN BODY SHALL BE STAINLESS STEEL WITH LEAD CAULKED JOINT TO ACCEPT A 2" PIPE WITH OPTIONAL FLAT STRAINER. UNIT SHALL BE 36" X 24" X 10" HIGH UNIT SHALL BE MOLDED-STONE MSD-3624, FIAT PRODUCTS, INC. OR APPROVED EQUAL.

EMERGENCY SHOWER AND EYE WASH ESH-1

EMERGENCY SHOWER AND EYE WASHES TO BE ALL STAINLESS STEEL WITH FOOT OPERATED EYE-WASH. FREE-STANDING, SELF-CLEANING, NON-CLOGGING EYE AND FACE WASH WITH QUICK OPENING, FULL-FLOW VALVES RATED AT 22 GPM. VALVES SHALL BE SELF CLOSING TYPE, "HAWK" MODEL 8300 SERIES OR APPROVED EQUAL.

ELECTRIC WATER COOLER EMC-1

ELECTRIC WATER COOLER SHALL BE SELF-CONTAINED, WALL HUNG AND MECHANICALLY REFRIGERATED ELECTRIC WATER COOLER AND SHALL CONFORM TO ARI-1010. SHALL USE ONE OF THE HALOGENATED HYDROCARBONS AS A REFRIGERANT, AND SHALL HAVE A CAPACITY TO DELIVER A MINIMUM OF 9.2 GPM OF 50 DEGREE F WATER WHEN SUPPLIED WITH 80 DEGREE F INLET WATER AND A 90 DEGREE F ROOM TEMPERATURE. WATER COOLER SHALL BE 120V, 1 PHASE. UNIT SHALL BE "OASIS" ON-A-WALL COOLER MODEL OPL8FCM OR APPROVED EQUAL.

11, 0702

WORK THIS DWG WITH DWGS 10550701, & 10550702

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOATATION H. V. A. C. AND PLUMBING SCHEDULES & DETAILS JOB NO. 88107-250 DWG. NO. 10550703 REVISION R-
			DESIGNED BY: W. L. COMHER	05/01/93		
			DRAWN BY: W. L. COMHER	05/10/93		
			CHECKED BY:			
			APPROVED BY:			
COUNT	INFORMATION CONFIDENTIAL: ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE KEPT CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.					

MANUAL VALVES		PIPING		INSTRUMENT SIGNALS
ANGLE VALVE		UTILITY PIPING		CAPILLARY TUBING
BALL VALVE		PROCESS PIPING		ELECTRICAL SIGNAL
BUTTERFLY VALVE		CHUTEWORK		HYDRAULIC
CHECK VALVE		LINE BREAK; PIPING OR INSTR.		PNEUMATIC TUBING
DIAPHRAM VALVE		INSULATED PIPING (COLD CONSERVATION)		SOFTWARE
GATE VALVE		INSULATED PIPING (HEAT CONSERVATION)		ELECTROMAGNETIC OR NUCLEAR
GLOBE VALVE		INSULATED PIPING (PERSONNEL PROTECTION)
NEEDLE VALVE		INSULATED & ELECTRIC TRACED PIPING	INSTRUMENTS
PLUG VALVE		INSULATED & SOLVENT TRACED		PANEL MOUNTED INSTRUMENT
ROTARY VALVE		INSULATED & STEAM TRACED PIPING		REAR PANEL MOUNTED INSTRUMENT
3-WAY VALVE		INSULATED & JACKETED PIPING		LOCALLY MOUNTED INSTRUMENT
4-WAY VALVE				INSTRUMENT FURNISHED W/EQUIPMENT
KNIFE GATE VALVE				DISTRIBUTED CONTROL DISPLAYED ON CRT
PINCH VALVE				DISTRIBUTED CONTROL BLIND FUNCTION
NOTE: VALVES SHOWN SOLID ARE CLOSED					DISTRIBUTED CONTROL MANUAL BACKUP
CONTROL VALVES					DISTRIBUTED CONTROL H: HIGH ALARM L: LOW ALARM
DIAPHRAM ACTUATOR		INSTRUMENT AIR SUPPLY & FILTER/REGULATOR		LEVEL GAUGE BOARD (WITH SEAL)
DIAPHRAM ACTUATOR W/POSITIONER		SIGHT GLASS		LEVEL GAUGE BOARD (WITHOUT SEAL)
ELECTRIC MOTOR ACTUATOR		TRAP		HAND OPERATED SWITCH
HYDRAULIC ACTUATOR		AIR ELIMINATOR		LEVEL SIGHT GAUGE
PNEUMATIC ACTUATOR		POP DRAIN		ONE INSTRUMENT W/MULTIPLE FUNCTIONS
PNEUMATIC CYLINDER ACTUATOR		SAMPLE POINT		SELECTOR SWITCH
REGULATOR W/EXTERNAL TAP		VACUUM BREAKER		ORIFICE PLATE
SELF CONTAINED REGULATOR		BLIND FLANGE/FLANGES		RESTRICTING ORIFICE
2-WAY SOLENOID		THREADED CAP		VORTEX SHEDDING FLOW TRANSMITTER
3-WAY SOLENOID		DIAPHRAGM SEAL		ROTAMETER/PURGE METER
4-WAY SOLENOID		DRAIN		TARGET FLOW METER
PNEUMATIC KNIFE GATE		EDUCTOR
PNEUMATIC PINCH		EXPANSION JOINT		
FC INDICATES "FAIL CLOSED" FL INDICATES "FAIL LAST" FO INDICATES "FAIL OPEN"			FLEXIBLE CONNECTION
		HOSE CONNECTION
		REDUCER
		SLIP BLIND
		TIE-IN
		VENT TO ATMOSPHERE
		"Y" STRAINER
		FLAME ARRESTOR		
SAFETY RELIEFS
PRESSURE SAFETY VALVE (PSV)
RUPTURE DISK (PRESSURE)
VACUUM SAFETY VALVE (PSV)
VACUUM & PRESSURE SAFETY VALVE				

INSTRUMENTS	ABBREVIATIONS	LINE CODE																																																																																																																																																																																																				
PITOT TUBE (OR ANNUBAR)	e ENERGIZED de DE-ENERGIZED FC FAIL CLOSE FO FAIL OPEN NC NORMALLY CLOSED NO NORMALLY OPEN PV PROCESS VARIABLE RSP REMOTE SETPOINT (CASCADE) M/A MANUAL - AUTOMATIC FLP FAIL LAST POSITION S40 SCHEDULE 40 PIPE THK. S80 SCHEDULE 80 PIPE THK. XS EXTRA STRONG PIPE THK. CT 0.0625" TUBING WALL THK. A PIPING SPEC. - CS; S40 F FLEXIBLE HOSE B TUBING SPEC. - COPPER	<div style="text-align: center;"> LINE CODE </div> <div style="text-align: center;"> FLUID SYMBOLS <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>PREFIX</th> <th>SERVICE</th> <th>LINE SIZE</th> <th>COMMENTS</th> </tr> </thead> <tbody> <tr><td>BW</td><td>BLACK WATER</td><td>1" / FT.</td><td></td></tr> <tr><td>CC</td><td>CLEAN COAL</td><td>2" / FT.</td><td></td></tr> <tr><td>CW</td><td>CLARIFIED WATER</td><td>1/16" / FT.</td><td></td></tr> <tr><td>DM</td><td>DILUTE MEDIA</td><td>2" / FT.</td><td></td></tr> <tr><td>F</td><td>FLOCCULENT</td><td></td><td></td></tr> <tr><td>FW</td><td>FRESH WATER</td><td>1/16" / FT.</td><td></td></tr> <tr><td>HM</td><td>HEAVY MEDIA</td><td>2" / FT.</td><td></td></tr> <tr><td>IA</td><td>INSTRUMENT AIR</td><td></td><td></td></tr> <tr><td>M</td><td>MIDDINGS</td><td>2" / FT.</td><td></td></tr> <tr><td>PA</td><td>PLANT AIR</td><td></td><td></td></tr> <tr><td>R</td><td>REFUSE</td><td>1" / FT.</td><td></td></tr> <tr><td>RC</td><td>RAW COAL</td><td>3" / FT.</td><td></td></tr> <tr><td>RT</td><td>REAGENT</td><td></td><td></td></tr> </tbody> </table> </div> <div style="text-align: center; margin-top: 10px;"> INSTRUMENT FUNCTION IDENTIFICATION SYMBOLS <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>1st LETTER</th> <th>2nd LETTER</th> <th>3rd LETTER</th> <th>4th LETTER</th> <th>LAST LETTER</th> </tr> </thead> <tbody> <tr><td>A</td><td>ANALYZER</td><td>ALARM</td><td>ALARM</td><td>ALARM</td></tr> <tr><td>B</td><td>BURNER (FLAME)</td><td></td><td></td><td></td></tr> <tr><td>C</td><td>CONTROL (LOOP)</td><td>CONTROLLER</td><td>CONTROLLER</td><td>CONTROLLER</td></tr> <tr><td>D</td><td>DENSITY</td><td>DIFFERENTIAL</td><td></td><td>DRIVE OPERATOR ELEMENT</td></tr> <tr><td>E</td><td>VOLTAGE</td><td></td><td></td><td></td></tr> <tr><td>F</td><td>FLOW</td><td>RATIO</td><td>FLOW</td><td>FLOW</td></tr> <tr><td>G</td><td>GAUGE</td><td>GAUGE</td><td></td><td>GLASS</td></tr> <tr><td>H</td><td>HAND (MANUAL)</td><td></td><td>HIGH</td><td>HIGH</td></tr> <tr><td>I</td><td>AMPERES</td><td>INDICATOR</td><td></td><td>INDICATOR</td></tr> <tr><td>J</td><td>POWER</td><td></td><td></td><td>MTR. 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CONSTRUCTION APPROVAL

APPROVAL

DATE

SCALE: NONE

DATE

PROFESSIONAL SEAL

 ICF KAISER ENGINEERS INC.
 Four Gateway Center
 Pittsburgh, PA 15222-1207
 (412) 497-2000, FAX (412) 497-2212

 UNITED STATES DEPARTMENT OF ENERGY
 ADVANCED FROTH FLOTATION PROCESS
 P & ID SYMBOLS & LEGEND

JOB No. 88107-250

DWG. No. 10-60-0200

REVISION

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TYPICAL FLUSH & GLAN DETAIL 1

CLARIFIED WATER
FROM SUMP 245
SEE DWG. 10-60-0202

UNIT 153
OVERSIZE PROTECTION
SIEVE BEND

UNIT 105
BELT MAGNET

UNIT 100
PLANT FEED BELT
(BY OTHERS)

UNIT 110
RAW COAL CRUSHER

UNIT 111
RAW COAL CRUSHER

UNIT 112
RAW COAL SCREEN

UNIT 115
RAW COAL
FEED SUMP

UNIT 120
RAW COAL
FEED PUMP

UNIT 160
FINES HYDRO
FEED PUMP

UNIT 155
FINES HYDRO
FEED SUMP

UNIT 151
OVER SIZE
PROTECTION SUMP

UNIT 152
OVER SIZE
PROTECTION PUMP

UNIT 320
HEAVY MEDIA
COAL SUMP

UNIT 395
INSTRUMENT AIR COMPRESSOR

UNIT 398
PLANT AIR COMPRESSOR

NOTE:
1. FOR PUMP SUCTION PIPING AND PUMP
GLAND WATER PIPING SEE DETAIL 1 ON
THIS DWG.

PLID SYMBOLS & LEGEND 10-60-0200
PLID SHEET #2 OF 2 10-60-0202

DESCRIPTION COST ACCOUNT

CONSTRUCTION APPROVAL

APPROVAL	DATE	SCALE: NONE	DATE
DESIGNED BY	B. F. FINE		4/84
DRAWN BY	M. P. MCKINCH		4/26/84
CHECKED BY			
APPROVED BY			
APPROVED BY			

PROFESSIONAL SEAL

ICF KAISER

ICF KAISER ENGINEERS INC.
Four Gateway Center
Pittsburgh, PA 15222-1207
(412) 497-2000, FAX (412) 497-2212

UNITED STATES DEPARTMENT OF ENERGY
ADVANCED FROTH FLOTATION PROCESS
PIPING & INSTRUMENTATION DIAGRAM
SHEET 1 OF 2

JOB No. 88107-250

DWG. No. 10-60-0201

REVISION

NOTE:

1. FOR PUMP SUCTION PIPING AND PUMP GLAND
WATER PIPING SEE DETAIL 1 ON DRAWING
10-60-0201.

PLID SYMBOLS & LEGEND

10-60-0200

P&ID SHEET #1 OF 2

10-60-0201.

DESCRIPTION

COST ACCOUNT

NO	DATE	REVISION	BY	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST
									WORK COVERED BY THIS A	CHARGED TO COST ACCOUN

NOTES:

- SEE PIPING SPECIFICATION NO. 88107-99601101.
- WORK THIS DRAWING WITH DRAWINGS 10-60-0502 THRU 10-60-0508.

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 3/4" = 1'-0"	DATE	PROFESSIONAL SEAL	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS PLAN AT ELEV. 0'-0" PIPING ARRANGEMENT	JOB NO. 88107-250 DWG. NO. 10-60-0501 R-
ACCOUNT CROSS CROSS	DESIGNED BY: J. R. LARKIN CHECKED BY: J. R. LARKIN APPROVED BY: APPROVED BY:	6/8/94 6/8/94					

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ICF KAISER ENGINEERS, INC.
FOUR COUNTRY CENTER
PITTSBURGH, PA 15222-1011
(412) 487-7000

J:\prj\88107250\10600501.dgn rebor 19-JUL-1994 08

PLAN @ EL. 14' - 0"

NO	DATE	REVISION	BY	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST
									WORK COVERED BY IHS-A	CHARGED TO COST ACCOUNT

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 1/2" = 1'-0"	DATE
	DESIGNED BY:		J. R. LARKIN	5/8/94
	CHECKED BY:		J. R. LARKIN	5/8/94
	APPROVED BY:			
	APPROVED BY:			

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PROFESSIONAL SEAL

ICF KAISER

ICF KAISER ENGINEERING, INC.
FOUR CALUMET CENTER
PITTSBURGH, PA 15222-1222
(412) 497-7000

UNITED STATES DEPARTMENT OF ENERGY
ADVANCED FROTH FLOTATION PROCESS
PLAN AT ELEV. 14'-0"
PIPING ARRANGEMENT

JOB NO. 88107-250

DWG. NO. 10-60-0502

R-

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19-XX-1994 09:0

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 3/8" = 1'-0"	DATE	PROFESSIONAL SEAL	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS PLAN AT ELEV. 28'-0" PIPING ARRANGEMENT	ICF KAISER ENGINEERS, INC. FOUR SHILOH CENTER PITTSBURGH, PA 15222-1120 (412) 497-2000
	DESIGNED		BY: J. R. LARKIN	6/8/94			
	DRAWN		BY: J. R. LARKIN	6/8/94			
	CHECKED		BY:				
	APPROVED		BY:				
ACCOUNT	INFORMATION CONFIDENTIAL. ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE KEPT CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.				J:\pr\J\88107250\10600503.dgn	Feb 08	1004 10
ACCOUNT					JOB NO. 88107-250	DWG. NO. 10-60-0503	R-

SECTION

A

c COLUMN A

10-60-0501 THRU 10-60-0504

NO	DATE	REVISION	BY	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST A
									WORK COVERED BY THIS ACC	
									CHARGED TO COST ACCOUNT

NO	DATE	REVISION	BY	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST
									WORK COVERED BY THIS AC	
									CHARGED TO COST ACCOUNT

CONSTRUCTION APPROVAL APPROVAL DATE SCALE: 3/4" = 1'-0" DESIGNED BY: L. HARRIS DRAWN BY: L. HARRIS CHECKED BY: APPROVED BY: APPROVED BY:	APPROVAL DATE DATE DATE DATE DATE DATE	PROFESSIONAL SEAL 10-60-0501 THRU 10-60-0504	<div> <div> </div> <div> UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS SECTIONS C & D PIPING ARRANGEMENT </div> </div> <div> <div> JOB NO. 88107-250 </div> <div> DWG. NO. 10-60-0506 </div> <div> REVISION R- </div> </div>
--	--	---	---

SECTION

OF COLUMN 6

E

10-60-0501 THRU 10-60-0504

NO	DATE	REVISION	BY	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST
									WORK COVERED BY THIS A	
									CHARGED TO COST ACCOUNT

SECTION F-F

a COLUMN 6

F

10-60-0501 THRU 10-60-0504

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: $\frac{3}{8}" = 1' - 0"$	DATE	PROFESSIONAL SEAL	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS SECTIONS E & F PIPING ARRANGEMENT	100 KAISER ENGINEERS, INC. 1111 MARKET STREET, SUITE 1000 PITTSBURGH, PA 15222-1000 (412) 437-2600
	DESIGNED BY:	D. GROSS	7/1/94				
	DRAWN BY:	D. GROSS	7/1/94				
	CHECKED BY:						
	APPROVED BY:						
ACCOUNT	INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE KEPT CONFIDENTIAL, AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.				JOB NO. 88107-250	DWG. NO. 10-60-0507	REVISED R-

IT ACCOUNT ACCOUNT BY: ASDVE	CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOATATION ELECTRICAL POWER DISTRIBUTION SINGLE LINE DIAGRAM JOB NO. 88107-250 DWG. NO. 10-70-1601 R-
				DESIGNED BY: R. BURMETT	5/1/94	
				DRAWN BY: D.M. KISELICA	6/2/94	
				CHECKED BY:		
				APPROVED BY:		
INFORMATION CONTAINED HEREIN IS UNCLASSIFIED AND IS NOT TO BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN WRITING WITH ICF KAISER ENGINEERS, INC.						

480VAC, 3 ϕ , 60 HZ
FROM INDOOR SWITCHGEAR
SEE DWG. #10-70-1601

MCC#1

480V, 3 ϕ , 60HZ

EQUIP. #
105.1
RECTIFIER

1.8 KW
EQUIP. #
105
BELT MAGNET

50 HP
EQUIP. #
110
RAW COAL CRUSHERS

50 HP
EQUIP. #
111

7.5 HP
EQUIP. #
112
RAW COAL SCREEN

10 HP
EQUIP. #
113
OVERSIZE
BUCKET
ELEVATOR

15 HP
EQUIP. #
120
RAW COAL
FEED PUMP

10 HP
EQUIP. #
135
REFUSE
CENTRIFUGE
DRIVE

7.5 HP
EQUIP. #
135.1
REFUSE
CENTRIFUGE
VIBRATOR

1/2 HP
EQUIP. #
135.2
REFUSE
CENTRIFUGE
OIL PUMP

10 HP
EQUIP. #
145
DESLIME
SCREEN

CONTINUED
FROM ABOVE
RIGHT

5 KVA
UPS
DISTRIBUTION
PANEL

5 KVA
480-120/240
POWER
CONDITIONER
(UPS BY-PASS)

SPARE

SPARE

SPARE

SPARE

SPARE

SPARE

NO	DATE	REVISION	BY	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST
									WORK COVERED BY THIS	
									CHANGED TO COST ACCORD

ACCOUNT Y FRACTION	CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOATATION MOTOR CONTROL CENTER #1 SINGLE LINE DIAGRAM	JOB NO. 88107-250 DWG. NO. 10-70-1602 R-
				DESIGNED BY: R. BURTHETT	6/12/94			
				DRAWN BY: D. H. KISELICA	6/2/94			
				CHECKED BY:				
				APPROVED BY:				

INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE HELD CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.

J:\prj\88107250\10701602.dgn wslp13

MCC#2

480VAC, 3 ϕ , 60 HZ
FROM INDOOR SWITCHGEAR
SEE DWG. #10-70-1601

NO	DATE	REVISION	BY (in)	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES
								DESCRIPTION COST /
								WORK COVERED BY THIS RE- CHARGED TO COST ACCOUNT

FROM PROCESS POWER
PANEL LOCATED IN MCC #1

MCC#3

ACCOUNT COUNT ABOVE	CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOATATION MOTOR CONTROL CENTER #2, #3 & MISC. 120VAC SINGLE LINE DIAGRAM JOB NO. 88107-250 DWG. NO. 10-70-1603	ICF KAISER ENGINEERS, INC. 1000 GARDEN CITY BLVD. PITTSBURGH, PA 15222-1000 (412) 497-2900
				DESIGNED BY: R. BURTHETT	6/1/94		
				DRAWN BY: D.M. KISELICA	6/3/94		
				CHECKED BY:			
				APPROVED BY:			
				APPROVED BY:			
INFORMATION CONTAINED HEREIN IS UNCLASSIFIED AND/OR INFORMATION FURNISHED HEREWITH AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE KEPT CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.							

80V, 3 ϕ , 60HZ

CONSTRUCTION APPROVAL COUNT DATE	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOATATION MOTOR CONTROL CENTER #4 & MISC. 120VAC SINGLE LINE DIAGRAM JOB NO. 88107-250 DWG. NO. 10-70-1604 REVISION:
			DESIGNED BY: R. BURNETT	6/1/94	
			DRAWN BY: D. M. KISELICKA	6/3/94	
			CHECKED BY:		
			APPROVED BY:		
			APPROVED BY:		
INFORMATION CONFIDENTIAL. ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE KEPT CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSES NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS.					

MCC#

[illegible]

SPARE SPARE SPARE SPARE SPARE SPARE

ACCOUNT COUNT ABOVE	CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION MOTOR CONTROL CENTER #5 SINGLE LINE DIAGRAM JOB NO. 88107-250 DWG. NO. 10-70-1605 REVISION R-
				DESIGNED BY: R. BURMETT	6/1/94		
				DRAWN BY: D. M. KISELICA	6/10/94		
				CHECKED BY:			
				APPROVED BY:			
				APPROVED BY:			
<small>INFORMATION CONFIDENTIAL: ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE HELD CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.</small>							

MCC:#

CONTINUED
FROM
ABOVE
RIGHT

[illegible]

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOATATION MOTOR CONTROL CENTER #6 SINGLE LINE DIAGRAM JOB NO. 88107-250 DWG. NO. 10-70-1606	ICF KAISER ENGINEERS, INC. FOUR GILBERT CIRCLE PITTSBURGH, PA 15222-1207 (412) 437-7000
	DESIGNED BY: R. BURNETT		6/1/94			
	DRAWN BY: D. M. KISELICKA		6/18/94			
	CHECKED BY:					
	APPROVED BY:					
ACCOUNT ABOVE	INFORMATION CONFIDENTIAL: A L. PLANS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE KEPT CONFIDENTIAL, AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.			DIVISION R-		

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FL. ELEV. 14'-0' (UNLESS NOTED)

WORK THIS DWG. WITH DWG. 10-70-211
10-70-211

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE 1/8" = 1'-0"	DATE	PROFESSIONAL SEAL	ICF KAISER ENGINEERS ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 281-8121, TELEX: 199121	UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS "PLAN AT ELEV. 0'-0" & 14'-0" POWER, CONTROL & INSTR. LOCATION PLAN
	DESIGNED BY	K. MOOTS	5/15/94				
	DRAWN BY	K. MOOTS	7/16/94				
	CHECKED BY						
	APPROVED BY						
APPROVED BY							
<small>INFORMATION CONFIDENTIAL. ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE HELD CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.</small>						JOB No. 88107-250-00	DWG. No. 10-70-2101

WORK THIS DWG. WITH DWG. 10-70-2101
10-70-2102

FL. ELEV. 40'-0" (UNLESS NOTED)

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE 1/8" = 1'-0"	DATE	PROFESSIONAL SEAL	ICF KAISER ENGINEERS UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS PLAN AT ELEV. 28'-0" & 40'-0" POWER, CONTROL & INSTR. LOCATION PLA JOB No. 88107-250-00 DWG. No. 10-70-2102	ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 281-8121, TELE: 199121
	DESIGNED BY		K. MOOTS	8/15/94			
	DRAWN BY		K. MOOTS	8/17/94			
	CHECKED BY						
	APPROVED BY						
COUNT	INFORMATION CONFIDENTIAL. ALL PLANS, DRAWINGS, SPECS, ETC. ARE THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE HELD CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOR PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.						

[illegible]

ING CYCLOWES

ED

KEY PLAN

SCALE: 1" = 20'-0"

WORK THIS DWG. WITH DWG. 10-70-2101
10-70-2102

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 1/8" = 1'-0"	DATE	PROFESSIONAL SEAL	ICF KAISER ENGINEERS ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 381-8121, TELEX: 199121
	DESIGNED BY		K. MOOTS	6/15/94		
	DRAWN BY		K. MOOTS	9/17/94		
	CHECKED BY					
	APPROVED BY					
	APPROVED BY					
INFORMATION CONFIDENTIAL. ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE HELD CONFIDENTIAL AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.						UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOATATION PROCESS PLAN AT ELEV. 54'-0" & KEY PLAN POWER, CONTROL & INSTR. LOCATION PL/
JOB No. 88107-250-00					DWG. No. 10-70-2103	

JUNT
 1100
 0000

MOTOR CONTROL CENTER NO. 1

1A 800 AMP INCOMING LINE SECTION	2A 112 SIZE 1NR RAW COAL SCREEN	3A DIST PNL 15A CKT. BKR.	4A 105.1 30A CKT. BKR.	5A LTG PNL 45A CKT. BKR.	6A SPARE 45A CKT. BKR.	7A SPACE
		3B UPS TRANS 15A CKT. BKR.	4B SPARE 15A CKT. BKR.	5B PWR TRANS 15A CKT. BKR.	6B SPACE	
	2C 113 SIZE 1NR OVERSIZE BUCKET ELEVATOR	3C 120 SIZE 2NR RAW COAL FEED PUMP	4C 150 SIZE 4NR MIDDINGS CRUSHER DRIVE #1	5C SPARE 30A CKT. BKR. 5D 152 SIZE 3NR OVERSIZE PROTECTION PUMP	6C 120 VAC PROCESS POWER DISTRIB. PANEL	7C SPACE
	2E 110 SIZE 3NR RAW COAL CRUSHER #1	3E 135 SIZE 1NR REFUSE CENTRIFUGE DRIVE				7E SPACE
		3G 135.1 SIZE 1NR REFUSE CENTRIFUGE VIBRATOR	4H 150.1 SIZE 4NR MIDDINGS CRUSHER DRIVE #2	5H 160 SIZE 4NR FINE HYDRO FEED PUMP		7G SIZE 1NR SPARE
	2J 111 SIZE 3NR RAW COAL CRUSHER #2	3J 135.2 SIZE 1NR REFUSE CENTRIFUGE OIL PUMP			6J 5 KVA PROCESS POWER TRANSFORMER	7J SIZE 1NR SPARE
		3L 145 SIZE 1NR DESILIME SCREEN				7L SIZE 2NR SPARE

MOTOR CONT

1A	2A SPACI
800 AMP INCOMING LINE SECTION	2B SIZE 1 ADVANC FLOTAT FEED P
	2G SIZE 1 CLASSIF CYCLO PUMP

MOTOR CONTROL CENTER NO. 4

1A 800 AMP INCOMING LINE SECTION	2A 395 40A CKT. BKR.	3A 380 SIZE 1NR MAGNETIC SEPARATOR	4A 405.2 SIZE 1NR FROTHER TRANSFER PUMP	5A SPACE	6A SPACE
	2B 340 SIZE 2NR MIDS DRAIN & RINSE SCREEN	3C 385.1 SIZE 1NR MAGNETITE BIN DUST COLLECTOR	4C 405.6 SIZE 1NR COLLECTOR TRANSFER PUMP	5C SPACE	6C SPACE
	2D 350 SIZE 2NR REFUSE DRAIN & RINSE SCREEN	3E 390 SIZE 1NR MAGNETITE ROTARY VALVE	4E 415 SIZE 1NR OVERDENSE MEDIA PUMP	5E 500.1 30A CKT. BKR.	6E SPARE 30A CKT. BKR.
	2F 375 SIZE 1NR DILUTE MEDIA PUMP	3G 400.2 SIZE 1NR ANIONIC MIXER	4G 485 SIZE 1NR CLEAN-UP PUMP	5F 500.2A 30A CKT. BKR.	6F SPARE 40A CKT. BKR.
	2H 325 SIZE 4NR HEAVY MEDIA CYCLONE PUMP			5G WELD RCPT. 100A CKT. BKR.	6G SPARE 60A CKT. BKR.
				5H WELD RCPT. 100A CKT. BKR.	6H 430 60A CKT. BKR.
		3J 398 300A CKT. BKR. PLANT & COLUMN AIR COMPRESSOR	4J 495 SIZE 1NR GLAND WATER PUMP	5J SIZE 1NR SPARE	6J SIZE 1NR SPARE
			4L 500.13 SIZE 1NR AUTOMATIC FLOC MIXING SYSTEM	5L SIZE 1NR SPARE	6L SIZE 2NR SPARE

MOTOR CON

1A	2A 20A CKT
600 AMP INCOMING LINE SECTION	2B 20A LKT
	2C 20A CKT
	2D 20A CKT
	2E 20A CKT
	2F 20A CKT
	2G 20A CKT
	2H 30A CKT
	2J 30A CKT
	2K 30A CKT
	2L 30A CKT
	2M 30A CKT

NO	DATE	REVISION	BY	APP	APP	REFERENCE DRAWINGS	NUMBER	NOTES	DESCRIPTION	COST
									WORK COVERED BY THIS IS CHARGED TO COST ACCOUNT	

MOTOR CONTROL CENTER NO. 2

	3A	4A
	SPACE	SPACE
220 INR ED ION JMP	3C 230.1A SIZE 4NR ADVANCED FLOTATION PUMP "A"	4C 230.1C SIZE 4NR ADVANCED FLOTATION PUMP "C"
205 3NR RING WE	3H 230.1B SIZE 4NR ADVANCED FLOTATION PUMP "B"	4H 230.1D SIZE 4NR ADVANCED FLOTATION PUMP "D"

MOTOR CONTROL CENTER NO. 3

1A	2A 240 SIZE 1NR COAL STAT. THICK. DRIVE	3A 249 SIZE 2NR COAL. STATIC THICK. U' FLOW PUMP	4A 260.1A SIZE 1NR AGITATOR "A"	5A SIZE 1NR SPARE	6A SPACE
600 AMP INCOMING LINE SECTION	2C 260 SIZE 1NR CLEAN COAL FILTER DRIVE	3C 260.5 SIZE 1NR LUBRICATOR	4C 260.1B SIZE 1NR AGITATOR "B"	5C SIZE 1NR SPARE	6B SPACE
	2E 260.4 SIZE 1NR FILTRATE PUMP	3E 260.6 SIZE 1NR AUX. AIR COMPRESSOR	4E 260.1C SIZE 1NR AGITATOR "C"	5E SIZE 2NR SPARE	6D SPACE
	2G 240.1 SIZE 1R COAL. STATIC THICK. LIFT. DEVICE	3G 247 SIZE 5NR COAL. THICK. CLARIFIED WATER PUMP	4G 260.7 SIZE 1NR INTERNAL CONVEYOR	5G 275 SIZE 1NR REFUSE STATIC THICK. DRIVE	6F SIZE 1R SPARE
	2K 275.1 SIZE 1R REFUSE STATIC THICK. LIFT. DEVICE		4J 260.2 SIZE 3NR DISCHARGE GATES	5J 260.3 300A CKT. BKR. AIR COMPRESSOR	6J 290 SIZE 3NR REFUSE STATIC THICK. U' FLOW PUMP

MOTOR CONTROL CENTER NO. 5

UH-1A	3A	UH-3F	4A	SPARE
BKR.	30A CKT. BKR.		40A CKT. BKR.	
UH-1B	3B	UH-3G	4B	SPARE
BKR.	30A CKT. BKR.		30A CKT. BKR.	
UH-1C	3C	UH-3H	4C	SPARE
BKR.	30A CKT. BKR.		30A CKT. BKR.	
UH-1D	3D	UH-3I	4D	SPARE
BKR.	30A CKT. BKR.		30A CKT. BKR.	
UH-1E	3E	UH-3J	4E	SPARE
BKR.	30A CKT. BKR.		30A CKT. BKR.	
UH-1F	3F	UH-3K	4F	SPARE
BKR.	30A CKT. BKR.		20A CKT. BKR.	
UH-1G	3G	UH-3L	4G	SPARE
BKR.	30A CKT. BKR.		20A CKT. BKR.	
UH-3A	3H	UH-3M	4H	
BKR.	30A CKT. BKR.		SPACE	
UH-3B	3J	UH-3N	4J	
BKR.	30A CKT. BKR.		SPACE	
UH-3C	3K	AC-1	4K	
BKR.	30A CKT. BKR.		SPACE	
UH-3D	3L	AC-2	4L	
BKR.	30A CKT. BKR.		SPACE	
UH-3E	3M	AC-3	4M	
BKR.	40A CKT. BKR.		SPACE	

MOTOR CONTROL CENTER NO. 6

1A	2A UH-2A 30A CKT. BKR.	3A UH-2I 30A CKT. BKR.	4A UH-2R 30A CKT. BKR.	5A SPACE
600 AMP INCOMING LINE SECTION	2B UH-2B 30A CKT. BKR.	3B UH-2J 30A CKT. BKR.	4B UH-2S 30A CKT. BKR.	
	2C UH-2C 30A CKT. BKR.	3C UH-2K 30A CKT. BKR.	4C UH-2T 30A CKT. BKR.	5C
	2D UH-2D 30A CKT. BKR.	3D UH-2L 30A CKT. BKR.	4D UH-2U 30A CKT. BKR.	SPACE
	2E UH-2E 30A CKT. BKR.	3E UH-2M 30A CKT. BKR.	4E HV-1 40A CKT. BKR.	5E SPARE
	2F UH-2F 30A CKT. BKR.	3F UH-2N 30A CKT. BKR.	4F HV-2 60A CKT. BKR.	5F SPARE
	2G UH-2G 30A CKT. BKR.	3G UH-2P 30A CKT. BKR.	4G SPARE 60A CKT. BKR.	5G SPARE
	2H UH-2H 30A CKT. BKR.	3H UH-2Q 30A CKT. BKR.	4H SPARE 40A CKT. BKR.	5H SPARE
	2J EF-1 SIZE 1NR BLDG. EXHAUST FAN #1	3J EF-2 SIZE 1NR BLDG. EXHAUST FAN #2	4J EF-3 SIZE 1NR BLDG. EXHAUST FAN #3	5J SIZE 1NR SPARE
	2L EF-4 SIZE 1NR BLDG. EXHAUST FAN #4	3L EF-5 SIZE 1NR BLDG. EXHAUST FAN #5	4L EF-6 SIZE 1NR BLDG. EXHAUST FAN #6	5L SIZE 1NR SPARE

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL	ICF KAISER UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION MOTOR CONTROL CENTERS #1, #2, #3, #4, #5 & #6 FRONT VIEW LAYOUTS	JOB NO. 88107-250 DWG. NO. 10-70-2201 R-
			DESIGNED BY: R. BURNETT	5/31/94			
			DRAWN BY: D.M. KISELICA	6/6/94			
			CHECKED BY:				
			APPROVED BY:				
ACCOUNT	INFORMATION CONFIDENTIAL: ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE KEPT CONFIDENTIAL, AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.				ICF KAISER ENGINEERS, INC. FOUR MILLWAY CENTER PITTSBURGH, PA 15222-1007 (412) 407-2000		

ING CYCLOPES

ED

KEY PLAN

SCALE: 1" = 20'-0"

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: 1/8" = 1'-0"	DATE	PROFESSIONAL SEAL	ICF KAISER ENGINEERS ICF KAISER ENGINEERS INC. Four Gateway Center Pittsburgh, PA 15222-1207 (412) 281-8121, TELEX: 109121	
	DESIGNED BY		R. SABOL	6/15/74			
	DRAWN BY		R. SABOL	6/15/74			
	CHECKED BY						
	APPROVED BY						
	APPROVED BY						
COUNT	INFORMATION CONTAINED HEREIN IS UNCLASSIFIED AND IS NOT TO BE RELEASED TO THE PUBLIC WITHOUT THE WRITTEN AUTHORIZATION OF THE U.S. DEPARTMENT OF ENERGY.					UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS PLAN AT ELEV. 54'-0" & KEY PLAN LIGHTING PLANS	
					JOB No. 88107-250-00 DWG. No. 10-70-2403

[illegible]

T
HIGH PRESSURE
SODIUM FIXTURE
WALL MOUNT

OR
ACTUAL MEMBER

TAIL #4

EMERGENCY LIGHTING
UNIT
MOUNTING BRACKET
EXIDE CAT#H88

TAIL #8

3/4" CONDUIT

CROUSE-HINDS
CAST BOX #FD2
& COVER PLATE
#DS326 WITH
GASKET #GASK91

115 AC
H. TOGGLE TYPE
20/277 VOLT
1/2" POLE #1201
1/2" POLE #1202
EE-WAY #1203

DETAIL #12

LIGHTING FIXTURE SCHEDULE

LTA CODE	LAMP		FIXTURE		MTG. DET.	START CURRL.	RUN CURRL.	REMARKS
	WATTS	TYPE	MFR.	CAT. NO.				
A	4-40 W	F40- RS/CW	DAYBRITE OR EQUAL	CG244-C02D -120V	1	1.67A	1.67A	FLUORESCENT (120VAC) 2'x4' RECESSED FOR GRID INVERTED CEILING
B	2-40 W	F40- RS/CW	DAYBRITE OR EQUAL	45267-4	2	0.83A	0.83A	FLUORESCENT (120VAC) 1'x4' RECESSED FOR STEN MOUNTED
C	100	G.E. LU100	GENERAL ELECTRIC OR EQUAL	H211053PGG	3	0.7A	1.2A	PENDANT MOUNTED HIGH PRESSURE SODIUM, 1/2" HUBS (120 VAC)
D	100	G.E. LU100	GENERAL ELECTRIC OR EQUAL	H211053WGG	4	0.7A	1.2A	WALL MOUNTED HIGH PRESSURE SODIUM, 1/2" HUBS (120 VAC)
E			LITHONIA OR EQUAL	XS3R-EL120	5			EMERGENCY EXIT SIGN (120V)
F	100	G.E. LU100	GENERAL ELECTRIC OR EQUAL	H211056JGG	6	0.7A	1.2A	STANCHION MOUNTED HIGH PRESSURE SODIUM, 1/2" HUBS (120 VAC)
G	400	LU400	WIDELITE OR EQUAL	FS-400C-QV	7		4.3A	FLOOD LIGHT, 2' HUBS (120 VAC)
H	2-25W		EXIDE OR EQUAL	NX-4002WPS256	8			EMERGENCY LIGHT: TWO HEAD, 120/277V, 2-25W, 6V LAMPS

LIGHTING CONTROL SCHEDULE

LTA CODE	CONTROL DEVICE		DESCRIPTION
	MANUFACTURER	CAT. NO.	
P	CROUSE-HINDS	PHOTOCELL-ND560 BOX-#FD2	PHOTOCELL: 120V, 1000W, 50HZ, OPERATING TEMPERATURE OF -40°F TO 120°F ENCLOSED IN FD CAST BOX WITH ALUMINUM COVER.

LIGHTING LEGEND

- FLUORESCENT LIGHTING FIXTURE (1'x4')
BALLAST TO BE UL & CBM CERTIFIED - SEE DETAIL #2.
- FLUORESCENT LIGHTING FIXTURE (2'x4')
BALLAST TO BE UL & CBM CERTIFIED - SEE DETAIL #1.
- FLOODLIGHT, LETTERS 'AC' INDICATE PHASE CONNECTION WHERE APPLICABLE.
SEE DETAIL #7.
- TYPICAL DESIGNATION OF LIGHT FIXTURE, LETTER 'C' INSIDE SYMBOL
INDICATES FIXTURE TYPE (SEE LIGHTING FIXTURE SCHEDULE).
A10a INDICATES CIRCUIT #10 FROM PANEL 'A' CONTROLLED FROM SWITCH 'a'
(NO SWITCH DENOTES FIXTURE IS CONTROLLED AT PANEL)
- DENOTES CONVENIENCE RECEPTACLE, 3 WIRE, 2 POLE, 20 AMP, 125VAC
SEE DETAIL #10.
- "WP" & SYMBOL DENOTES WEATHER PROOF RECEPTACLE - SEE DETAIL #11.
- "GFI" & SYMBOL DENOTES GROUND FAULT INTERRUPTER - SEE DETAIL #9.
- DENOTES SINGLE POLE NEMA 12 TYPE TOGGLE SWITCH,
WHICH CONTROLS ALL FIXTURES MARKED 'a' - SEE DETAIL #12.
- DENOTES THREE-WAY TOGGLE SWITCH NEMA 12
WHICH CONTROLS ALL FIXTURES MARKED 'a' - SEE DETAIL #12.
- INDICATES CEILING OR WALL MOUNTED EXIT LIGHT
SEE DETAIL #5.
- CROUSE-HINDS TYPE 'GUR' SERIES CONDUIT FITTING-DOME COVERS
TO BE USED WHERE ADDITIONAL WIRING SPACE IS REQUIRED.
- SLASH MARKS INDICATE NUMBER OF WIRES IN CONDUIT, SHORT
SLASH MARKS REPRESENT PHASE WIRES, LONG SLASH MARK
REPRESENTS THE NEUTRAL WIRE AND G INDICATES GREEN
GROUND WIRE.
- (—○) DENOTES CONDUIT TURNING UP AND (—●) DENOTES CONDUIT
TURNING DOWN.
- (—) DENOTES CONDUIT RUNNING EXPOSED AND (—) DENOTES CONDUIT
RUNNING EMBEDDED OR UNDER A FLOOR, BEHIND A WALL, ETC.
- DENOTES EMERGENCY LIGHTING WALL MOUNTED UNIT
SEE DETAIL #8.

GENERAL LIGHTING NOTES

- ALL WORK SHALL BE DONE IN STRICT CONFORMANCE WITH ALL
REQUIREMENTS SET FORTH BY ANY MUNICIPAL ORDINANCE,
PUBLIC UTILITIES, STATE CODES, NATIONAL ELECTRICAL SAFETY
CODES, ALL O.S.H.A. REQUIREMENTS AND ICF KAISER ENGINEERS
INSTALLATION, CONSTRUCTION, PLANS AND DETAIL DRAWINGS.
- ALL UNDERGROUND LIGHTING CONDUIT RUNS TO BE RIGID GAL. STEEL
CONDUIT (MIN. 1") ENCASED IN CONCRETE 3" MIN. COVER.
- EXACT LOCATION OF CONDUITS AND LIGHTING FIXTURES TO BE
DETERMINED BY FIELD.
- ALL FIXTURES TO BE GROUNDED.
- ALL CONDUIT CONNECTIONS TO BE MADE TIGHT, TO FORM A
CONTINUOUS PATH FOR GROUND CURRENTS TO EARTH.
- FIXTURE MOUNTING HEIGHT WILL BE INDICATED ON DRAWING.
MOUNTING HEIGHT WILL BE FROM TOP OF FLOOR TO BOTTOM
OF FIXTURE.
- MOUNT RECEPTACLES 3'-0" ABOVE FINISHED FLOOR.
- MOUNT SWITCHES 4'-6" ABOVE FINISHED FLOOR.
- ALL LIGHTING CONDUITS WILL BE 3/4", WITH 1/C #12
AWG. CU THIN/THIN, 600V, 90°C WIRE UNLESS OTHERWISE NOTED.
- ALL WIRING TO BE COLOR CODED AS FOLLOWS:
PHASE 'A'-BLACK, PHASE 'B'-RED, PHASE 'C'-BLUE
NEUTRAL-WHITE, GROUND-GREEN.

CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE		DATE	PROFESSIONAL SEAL
			DESIGNED BY:	A. SABOL	05/16/94	
			DRAWN BY:	A. SABOL	05/23/94	
			CHECKED BY:			
			APPROVED BY:			
			BY:			
			BY:			

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ICF KAISER

ICF KAISER ENGINEERS, INC.
1000 GARDEN CITY
PITTSBURGH, PA 15222-1000
(412) 497-7000

UNITED STATES DEPARTMENT OF ENERGY
ADVANCED FROTH FLOTATION ENERGY
LIGHTING DETAILS, NOTES AND LEGEND

JOB NO. 88107-250

DWG. NO. 10-70-2405

R-

us-5/pr/j/88107250/10702405.dg sabol

PANEL TYPE: 208/120V, 3ø, 4W
MAINS: 100 AMP
MINIMUM AIC: 14,000 AMP

SERVICE	CONNECTED LOAD (KVA)			CIRCUIT BREAKER		CKT NO.	<div> <div>TO 30KVA XFMR</div> </div>	CONNECTED LOAD (KVA)			SERVICE			
	#A	#B	#C	TYPE	TRIP			TRIP	TYPE	#A		#B	#C	
PROCESS AREA - EL. 0'-0"	1.58			1P	20A	1	<div> <div>TO 30KVA XFMR</div> </div>	2	20A	1P	1.44			PROCESS AREA - EL. 14'-0"
PROCESS AREA - EL. 0'-0"		1.44		1P	20A	3		4	20A	1P		1.44	PROCESS AREA - EL. 14'-0"	
PROCESS AREA - EL. 0'-0"			1.15	1P	20A	5		6	20A	1P			1.44	PROCESS AREA - EL. 14'-0"
RECEPTACLES (LAB)				1P	20A	7		8	20A	1P	1.20			FLOURESCENT LIGHTS - OFFICE & HALLWAY
RECEPTACLES (LAB)				1P	20A	9		10	20A	1P		1.00		FLOURESCENT LIGHTS - MEN'S AND WOMEN'S RESTROOMS
FLOURESCENT LIGHTS (LAB)			1.20	1P	20A	11		12	20A	1P				OFFICE & RESTROOMS
RECEPTACLES (LEFT COLUMN)				1P	20A	13		14	20A	1P				RECEPTACLE - RIGHT COLUMN
RECEPTACLES-CHIL/ELEC RM				1P	20A	15		16	20A	1P		1.58		PROCESS AREA - EL. 28'-0"
FLOURESCENT LIGHTS - CONTROL/ELECTRIC ROOM			1.00	1P	20A	17		18	20A	1P			1.73	PROCESS AREA - EL. 28'-0"
PROCESS AREA - EL. 42'-0"	1.87			1P	20A	19		20	20A	1P	1.15			PROCESS AREA - EL. 54'-0"
PROCESS AREA - EL. 42'-0"		1.87		1P	20A	21		22	20A	1P		1.03		OUTDOOR FLOODLIGHTS @ ELEV. 20'-0" ☉
OUTDOOR FLOODLIGHTS @ ELEV. 12'-0" ☉			1.03	1P	20A	23		24	20A	1P			0.72	OUTDOOR LIGHTS ☉
WALKWAYS - THICKENER AREA	0.86			1P	20A	25		26	20A	1P				SPARE
SPARE				1P	20A	27		28	20A	1P				SPARE
SPARE				1P	20A	29		30	20A	1P				SPARE
	4.31	3.31	4.38	SUBTOTAL CONNECTED LOAD						3.79	5.05	3.69	SUBTOTAL CONNECTED LOAD	
CONNECTED LOAD PHASE A <u>8.10</u> KVA PHASE B <u>8.26</u> KVA PHASE C <u>8.27</u> KVA TOTAL <u>24.73</u> KVA														

⊗ PHOTOCELL CONTROLLED

[illegible]

	CONSTRUCTION APPROVAL	APPROVAL	DATE	SCALE: NONE	DATE	PROFESSIONAL SEAL	ICF KAISER		ICF KAISER ENGINEERS, INC. 100 GILBERT STREET PITTSBURGH, PA 15212-1147 TEL: 412-781-1000	
				DESIGNED BY: R. SABOL	05/16/94		UNITED STATES DEPARTMENT OF ENERGY ADVANCED FROTH FLOTATION PROCESS			
				DRAWN BY: R. SABOL	05/23/94		LIGHTING PANEL 'LPA'			
				CHECKED BY:			CIRCUIT SCHEDULE			
				BY:			JOB NO. 88107-250		DWG. NO. 10-70-2406	REVISION
				APPROVED BY:						R-
ACCOUNT		INFORMATION CONTAINED IN ALL PLANS, DRAWINGS, SPECIFICATIONS AND/OR INFORMATION FURNISHED HEREWITH ARE AND SHALL REMAIN THE PROPERTY OF ICF KAISER ENGINEERS, INC. AND SHALL BE KEPT CONFIDENTIAL, AND SHALL NOT BE USED FOR ANY PURPOSE NOT PROVIDED FOR IN AGREEMENTS WITH ICF KAISER ENGINEERS, INC.								
ACCOUNT ABOVE		/usr5/prj/88107250/10702406.dg sabol								

APPENDIX D

ECONOMIC EVALUATIONS

ADVANCED FROTH FLOTATION ECONOMICS 200 TPH COMMERCIAL PLANT

3 CASE STUDIES

- 1) 7560 HOURS PER YEAR OPERATION**
 - A) AT 10 % RATE OF RETURN**
 - B) AT 15 % RATE OF RETURN**
 - C) AT 20 % RATE OF RETURN**
- 2) 5040 HOURS PER YEAR OPERATION**
- 3) 3456 HOURS PER YEAR OPERATION**

**ADVANCED FROTH FLOTATION ECONOMICS AT 10 PERCENT RATE OF RETURN
200 TPH COMMERCIAL PLANT OPERATING 7560 HOURS PER YEAR**

Cost Item	PITTSBURGH NO. 8 COAL	UPPER FREEPORT COAL	ILLNOIS NO. 6 COAL
Annualized Costs			
Raw Coal \$/MMBtu	0.80	0.80	0.80
Raw Coal \$/Ton	11.73	17.68	14.66
Clean Coal Incremental \$/MMBtu	0.69	0.70	0.75
Clean Coal Total \$/MMBtu	1.49	1.50	1.55
Clean Coal Total \$/Ton	40.65	40.27	41.96
Levelized Costs			
Raw Coal \$/MMBtu	1.06	1.06	1.06
Raw Coal \$/Ton	15.48	23.33	19.35
Clean Coal Incremental \$/MMBtu	0.91	0.92	0.98
Clean Coal Total \$/MMBtu	1.97	1.98	2.04
Clean Coal Total \$/Ton	53.66	53.16	55.39
Other Costs			
Present Value Of Costs	\$180,642,000	\$179,495,000	\$193,879,000
Annualized Desulfurization Cost	\$326.82	\$305.42	\$304.60
Payback Period (years)	7.9	7.9	7.9

**ADVANCED FROTH FLOTATION ECONOMICS AT 15 PERCENT RATE OF RETURN
200 TPH COMMERCIAL PLANT OPERATING 7560 HOURS PER YEAR**

Cost Item	PITTSBURGH NO. 8 COAL	UPPER FREEPORT COAL	ILLNOIS NO. 6 COAL
Annualized Costs			
Raw Coal \$/MMBtu	0.80	0.80	0.80
Raw Coal \$/Ton	11.73	17.68	14.66
Clean Coal Incremental \$/MMBtu	0.78	0.79	0.83
Clean Coal Total \$/MMBtu	1.58	1.59	1.63
Clean Coal Total \$/Ton	43.04	42.66	44.36
Levelized Costs			
Raw Coal \$/MMBtu	1.01	1.01	1.01
Raw Coal \$/Ton	14.75	22.24	18.44
Clean Coal Incremental \$/MMBtu	0.98	0.99	1.05
Clean Coal Total \$/MMBtu	1.99	1.99	2.06
Clean Coal Total \$/Ton	54.14	53.66	55.80
Other Costs			
Present Value Of Costs	\$136,415,000	\$135,621,000	\$145,301,000
Annualized Desulfurization Cost	\$368.27	\$344.35	\$340.64
Payback Period (years)	5.8	5.8	5.8

**ADVANCED FROTH FLOTATION ECONOMICS AT 20 PERCENT RATE OF RETURN
200 TPH COMMERCIAL PLANT OPERATING 7560 HOURS PER YEAR**

Cost Item	PITTSBURGH NO. 8 COAL	UPPER FREEPORT COAL	ILLNOIS NO. 6 COAL
Annualized Costs			
Raw Coal \$/MMBtu	0.80	0.80	0.80
Raw Coal \$/Ton	11.73	17.68	14.66
Clean Coal Incremental \$/MMBtu	0.89	0.89	0.94
Clean Coal Total \$/MMBtu	1.69	1.69	1.74
Clean Coal Total \$/Ton	45.92	45.53	47.24
Levelized Costs			
Raw Coal \$/MMBtu	0.97	0.97	0.97
Raw Coal \$/Ton	14.19	21.39	17.74
Clean Coal Incremental \$/MMBtu	1.07	1.08	1.14
Clean Coal Total \$/MMBtu	2.04	2.05	2.11
Clean Coal Total \$/Ton	55.57	55.10	57.16
Other Costs			
Present Value Of Costs	\$111,087,000	\$110,496,000	\$117,473,000
Annualized Desulfurization Cost	\$418.14	\$391.17	\$383.98
Payback Period (years)	4.5	4.5	4.5

CAPITAL REQUIREMENTS FOR 200 TPH (PRODUCT) PLANTS OPERATING 7560 HOURS PER YEAR			
DIRECT PROCESSING COSTS ESTIMATION			
COST ITEM	ALL THREE COALS		
A-CAPITAL COST OF PLANT	54,706,341		
B-CAPITAL COST OF EQUIPMENT	23,433,315		
C-MECHANICAL EQUIPMENT COST	19,988,023		
D-LAND PURCHASE	2,500,000		
E-STARTUP MODIFICATIONS	1,094,127		
F-PREPRODUCTION COSTS	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
POWER	720,166	720,166	720,166
FLOCCULANTS	55,138	76,572	151,339
FLOTATION REAGENTS	150,312	58,449	103,185
WATER	3,345	2,003	2,911
GRINDING MEDIA	54,425	51,296	53,881
LUBRICANTS	5,882	3,940	4,890
MAGNETITE	17,418	17,418	14,787
MANPOWER	122,303	122,303	122,303
MAINTENANCE SUPPLIES	195,278	195,278	195,278
DIRECT PROCESSING COSTS (A+D+E+F)	59,624,735	59,547,893	59,669,206
WORKING CAPITAL REQUIREMENT ESTIMATION			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	13,233	18,377	36,321
FLOTATION REAGENTS	36,075	14,028	24,764
GRINDING MEDIA	13,062	12,311	12,931
LUBRICANTS	1,412	946	1,174
MAGNETITE	4,180	4,180	3,549
SPARE PARTS= 2 % OF MECH. EQUIP.	399,760	399,760	399,760
TOTAL WORKING CAPITAL REQUIRED	467,723	449,603	478,500

ANNUAL OPERATING AND MAINTENANCE COSTS FOR 200 TPH (PRODUCT) PLANTS OPERATING 7560 HOURS PER YEAR			
YEARLY FIXED OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
PLANT LABOR COSTS	1,467,639	1,467,639	1,467,639
ADMINISTRATIVE LABOR AND COSTS	440,292	440,292	440,292
MAINTENANCE SUPPLIES	2,343,330	2,343,330	2,343,330
INSURANCE AND TAXES	1,641,190	1,641,190	1,641,190
TOTAL YEARLY FIXED O&M COSTS	5,892,451	5,892,451	5,892,451
YEARLY VARIABLE OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	661,651	918,861	1,816,063
FLOTATION REAGENTS	1,803,749	701,393	1,238,219
GRINDING MEDIA	653,105	615,551	646,574
LUBRICANTS	70,583	47,282	58,677
MAGNETITE	209,019	209,019	177,448
POWER	8,641,987	8,641,987	8,641,987
PROCESS WATER	40,144	24,041	34,927
TOTAL YEARLY VARIABLE O&M COSTS	12,080,238	11,158,134	12,613,895

OPERATING AND MAINTENANCE COSTS FOR PITTSBURGH SEAM FLOWSHEET

BASIC PLANT DATA AND COST RELATED ASSUMPTIONS

OPERATING CRITERIA

CONNECTED HORSEPOWER	22,415	HP
WATER REQUIREMENTS	1770.00	GPM
PLANT FEED RATE	415.00	TPH
PLANT RECOVERY	48.19%	
PRODUCTION RATE	200.00	TPH
PLANT AVAILABILITY	90.00%	

UNIT SUPPLY COSTS

ELECTRIC POWER	0.06	\$/KW HR
ANIONIC FLOC	2.00	\$/#
CATIONIC FLOC	2.00	\$/#
MIBC	0.55	\$/#
KEROSENE	0.09	\$/#
MAKE UP WATER	0.05	\$/1000 GAL
LUBRICANTS	0.02	PER TON CLEAN COAL
GRINDING MEDIA	0.36	\$/#
MAGNETITE	0.06	\$/#
SODIUM HYDROXIDE	0.07	\$/#

SUPERINTENDENT

61,458 PER YEAR

BENEFITS

27,656 0.45 TIMES SALARY

FOREMAN

43,021 PER YEAR

BENEFITS

19,359 0.45 TIMES SALARY

LABOR

CLASS A

17.46 PER HOUR

BENEFITS

9.61 0.55 TIMES RATE

CLASS B

16.86

BENEFITS

9.27 0.55 TIMES RATE

YEARLY OPERATING HOURS

HOURS/SHIFT	8
SHIFTS/DAY	3
DAYS/YEAR	350
HOURS/YEAR	7,560

RAW COAL/YEAR	3,137,400
CLEAN COAL/YEAR	1,512,000

OPERATING AND MAINTENANCE COSTS FOR PITTSBURGH SEAM FLOWSHEET

FLOTATION REAGENT COSTS PER YEAR

ADVANCED FLOTATION			
FEED RATE	267.00	TPH	
MIBC RATE	1.43	#/TON	
KEROSENE RATE	1.19	#/TON	
TOTAL MIBC	1,587,566	\$/YEAR	
TOTAL KEROSENE	216,183	\$/YEAR	
TOTAL FLOTATION REAGENTS COST	1,803,749	\$/YEAR	

FLOCCULATION AND pH CONTROL COSTS PER YEAR

CLEAN COAL STATIC THICKENER			
FEED RATE	200.00	TPH	
ANIONIC RATE	0.07	#/TON	
CATIONIC RATE	0.00	#/TON	
REFUSE STATIC THICKENER			
FEED RATE	93.00	TPH	
ANIONIC RATE	0.32	#/TON	
CATIONIC RATE	0.00	#/TON	
SODIUM HYDROXIDE RATE	0.00	#/TON	
TOTAL ANIONIC COST	661,651	\$/YEAR	
TOTAL CATIONIC COST	0	\$/YEAR	
TOTAL SODIUM HYDROXIDE COST	0	\$/YEAR	
TOTAL THICKENER CHEMICAL COST	661,651	\$/YEAR	

MAGNETITE COSTS PER YEAR

HEAVY MEDIA CYCLONE FEED RATE	384.00	TPH	
MAGNETITE CONSUMPTION RATE	1.20	#/TON	
TOTAL MAGNETITE COSTS	209,019	\$/YEAR	

GRINDING MEDIA COSTS PER YEAR

BALL MILL FEED RATE	400.00	TPH	
GRINDING MEDIA CONSUMPTION RATE	0.60	#/TON	
TOTAL GRINDING MEDIA COSTS	653,105	\$/YEAR	

OPERATING AND MAINTENANCE COSTS FOR PITTSBURGH SEAM FLOWSHEET

I. ESTIMATED OPERATING COSTS

A. OPERATING SUPPLIES

1. POWER		
DIVERSITY	0.80	FACTOR
CONNECTED HP	22,415	KWH
HEAT AND LIGHT	1,400	KWH
POWER COST	8,641,987	\$/YEAR
ASSUME 1HP=1KVA=1KWH		
2. FLOCCULANT / pH CONTROL COST	661,651	\$/YEAR
3. FLOTATION REAGENT COST	1,803,749	\$/YEAR
4. WATER COST	40,144	\$/YEAR
5. GRINDING MEDIA COST	653,105	\$/YEAR
6. LUBRICANTS	70,583	\$/YEAR
7. MAGNETITE COST	209,019	\$/YEAR
TOTAL OPERATING SUPPLIES	12,080,238	\$/YEAR

B. TOTAL MANPOWER

1. SUPERVISION		
SUPERINTENDENT	1	PER YEAR
SALARY	61,458	\$/YEAR
BENEFITS	27,656	\$/YEAR
FOREMAN	4	PER YEAR
SALARY	172,084	\$/YEAR
BENEFITS	77,438	\$/YEAR
2. LABOR		PER SHIFT
CLASS A		
PLANT OPERATER	1	PER SHIFT
EQUIPMENT OPERATOR	1	PER SHIFT
MECHANIC-ELECTRIAN	2	PER SHIFT
TOTAL CLASS A	586,790	\$/YEAR
BENEFITS	322,735	\$/YEAR
CLASS B		
UTILITY	1	PER SHIFT
TOTAL CLASS B	141,599	\$/YEAR
BENEFITS	77,879	\$/YEAR
TOTAL MANPOWER	1,467,639	\$/YEAR
TOTAL OPERATING COST	13,547,878	\$/YEAR

OPERATING AND MAINTENANCE COSTS FOR PITTSBURGH SEAM FLOWSHEET

II. ESTIMATED MAINTENANCE COST

A. MAINTENANCE SUPPLIES

EQUIPMENT COST	23,433,304	TOTAL DOLLARS
PER CENT MULTIPLIER	10.00%	
 TOTAL MAINTENANCE SUPPLIES	 2,343,330	 \$/YEAR

B. MAINTENANCE SUPERVISION AND LABOR

1. SUPERVISION

FOREMAN	0	PER YEAR
SALARY	0	\$/YEAR
BENEFITS	0	\$/YEAR

2. LABOR

0 SHIFT

CLASS A

MECHANICS	2	PER SHIFT
WELDERS	2	PER SHIFT
ELECTRICIAN	1	PER SHIFT
TOTAL CLASS A	0	\$/YEAR
BENEFITS	0	\$/YEAR

TOTAL MAINTENANCE MANPOWER 0 \$/YEAR

TOTAL MAINTENANCE COST 2,343,330 \$/YEAR

OPERATING AND MAINTENANCE COSTS FOR PITTSBURGH SEAM FLOWSHEET

ESTIMATED OPERATING AND MAINTENANCE COSTS

	PER YEAR	PER RAW TON	PER CLEAN TON
I. OPERATING SUPPLIES			
POWER	8,641,987	2.755	5.716
FLOCCULANTS	661,651	0.211	0.438
FLOTATION REAGENTS	1,803,749	0.575	1.193
WATER	40,144	0.013	0.027
GRINDING MEDIA	653,105	0.208	0.432
LUBRICANTS	70,583	0.022	0.047
MAGNETITE	209,019	0.067	0.138
TOTAL OPERATING SUPPLIES	12,080,238	3.850	7.990
II. SUPERVISION AND LABOR			
SUPERVISION	233,542	0.074	0.154
BENEFITS	105,094	0.033	0.070
LABOR	728,389	0.232	0.482
BENEFITS	400,614	0.128	0.265
TOTAL MANPOWER	1,467,639	0.468	0.971
TOTAL OPERATING COSTS	13,547,878	4.318	8.960
III. MAINTENANCE SUPPLIES	2,343,330	0.747	1.550
IV. MAINTENANCE SUPERVISION AND LABOR			
SUPERVISION	0	0.000	0.000
BENEFITS	0	0.000	0.000
LABOR	0	0.000	0.000
BENEFITS	0	0.000	0.000
TOTAL MAINTENANCE MANPOWER	0	0.000	0.000
TOTAL MAINTENANCE COST	2,343,330	0.747	1.550
TOTAL OPERATING & MAINTENANCE COST	\$15,891,208	5.065	10.510

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 59625	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 5892
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 13998
*Working Capital	\$ 468	*Ins.&prop. tax/yr.	0 %
*Coal Input	415 tons/hr	*Heating Value	7329 Btu,
*Primary Coal output	200 tons/hr	*Heating Value	13618 Btu
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/h
*Sulfur-Input	2.9 %	*Sulfur-Primary	2.5 %
*Sulfur-Secondary	0 %		

File Record # 7 File code 200PGH-7560
PITTSBURGH 200 TPH COMMERCIAL @7560

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 59548	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 5892
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 12929
*Working Capital	\$ 450	*Ins.&prop. tax/yr.	0 %
*Coal Input	278 tons/hr	*Heating Value	11048 Btu
*Primary Coal output	200 tons/hr	*Heating Value	13456 Btu
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/h
*Sulfur-Input	4.41 %	*Sulfur-Primary	2.3 %
*Sulfur-Secondary	0 %		

File Record # 8 File code 200FRE-7560
UPPER FREEPORT 200 TPH COMMERCIAL @7560

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 59669	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 5892
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 14616
*Working Capital	\$ 479	*Ins.&prop. tax/yr.	0 %
*Coal Input	345 tons/hr	*Heating Value	9162 Btu
*Primary Coal output	200 tons/hr	*Heating Value	13574 Btu
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/h
*Sulfur-Input	4.27 %	*Sulfur-Primary	3 %
*Sulfur-Secondary	0 %		

File Record # 9 File code 200ILL-7560
ILLINOIS NO. 6 200 TPH COMMERCIAL @7560

**ADVANCED FROTH FLOTATION ECONOMICS AT 10 PERCENT RATE OF RETURN
200 TPH COMMERCIAL PLANT OPERATING 5040 HOURS PER YEAR**

Cost Item	PITTSBURGH NO. 8 COAL	UPPER FREEPORT COAL	ILLNOIS NO. 6 COAL
Annualized Costs			
Raw Coal \$/MMBtu	0.80	0.80	0.80
Raw Coal \$/Ton	11.73	17.68	14.66
Clean Coal Incremental \$/MMBtu	0.82	0.82	0.88
Clean Coal Total \$/MMBtu	1.62	1.62	1.68
Clean Coal Total \$/Ton	44.21	43.56	45.52
Levelized Costs			
Raw Coal \$/MMBtu	1.06	1.06	1.06
Raw Coal \$/Ton	15.48	23.33	19.35
Clean Coal Incremental \$/MMBtu	1.09	1.08	1.16
Clean Coal Total \$/MMBtu	2.14	2.14	2.21
Clean Coal Total \$/Ton	58.35	57.51	60.08
Other Costs			
Present Value Of Costs	\$143,119,000	\$140,685,000	\$151,943,000
Annualized Desulfurization Cost	\$388.42	\$359.10	\$358.10
Payback Period (years)	7.9	7.9	7.9

CAPITAL REQUIREMENTS FOR 200 TPH (PRODUCT) PLANTS OPERATING 5040 HOURS PER YEAR			
DIRECT PROCESSING COSTS ESTIMATION			
COST ITEM	ALL THREE COALS		
A-CAPITAL COST OF PLANT	54,706,341		
B-CAPITAL COST OF EQUIPMENT	23,433,315		
C-MECHANICAL EQUIPMENT COST	19,988,023		
D-LAND PURCHASE	2,500,000		
E-STARTUP MODIFICATIONS	1,094,127		
F-PREPRODUCTION COSTS	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
POWER	480,110	480,110	480,110
FLOCCULANTS	36,758	29,297	100,892
FLOTATION REAGENTS	100,208	38,966	68,790
WATER	2,230	1,336	1,940
GRINDING MEDIA	36,284	34,197	35,921
LUBRICANTS	3,921	2,627	3,260
MAGNETITE	11,612	11,612	9,858
MANPOWER	85,744	85,744	85,744
MAINTENANCE SUPPLIES	195,278	195,278	195,278
DIRECT PROCESSING COSTS (A+D+E+F)	59,252,613	59,179,634	59,282,261
WORKING CAPITAL REQUIREMENT ESTIMATION			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	8,822	7,031	24,214
FLOTATION REAGENTS	24,050	9,352	16,510
GRINDING MEDIA	8,708	8,207	8,621
LUBRICANTS	941	630	782
MAGNETITE	2,787	2,787	2,366
SPARE PARTS= 2 % OF MECH. EQUIP.	399,760	399,760	399,760
TOTAL WORKING CAPITAL REQUIRED	445,069	427,768	452,254

ANNUAL OPERATING AND MAINTENANCE COSTS FOR 200 TPH (PRODUCT) PLANTS OPERATING 5040 HOURS PER YEAR			
YEARLY FIXED OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
PLANT LABOR COSTS	1,028,924	1,028,924	1,028,924
ADMINISTRATIVE LABOR AND COSTS	308,677	308,677	308,677
MAINTENANCE SUPPLIES	2,343,330	2,343,330	2,343,330
INSURANCE AND TAXES	1,641,190	1,641,190	1,641,190
TOTAL YEARLY FIXED O&M COSTS	5,322,121	5,322,121	5,322,121
YEARLY VARIABLE OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	441,101	351,561	1,210,709
FLOTATION REAGENTS	1,202,500	467,595	825,479
GRINDING MEDIA	435,403	410,368	431,049
LUBRICANTS	47,055	31,521	39,118
MAGNETITE	139,346	139,346	118,299
POWER	5,761,325	5,761,325	5,761,325
PROCESS WATER	26,762	16,027	23,285
TOTAL YEARLY VARIABLE O&M COSTS	8,053,492	7,177,743	8,409,264

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 59253	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 5322
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 13998
*Working Capital	\$ 445	*Ins.&prop. tax/yr.	0 %
*Coal Input	415 tons/hr	*Heating Value	7329 Btu/lb
*Primary Coal output	200 tons/hr	*Heating Value	13618 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	2.9 %	*Sulfur-Primary	2.5 %
*Sulfur-Secondary	0 %		

File Record # 13 File code 200PGH-5040
 PITTSBURGH 200 TPH COMMERCIAL @5040

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 59180	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 5322
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 12476
*Working Capital	\$ 428	*Ins.&prop. tax/yr.	0 %
*Coal Input	278 tons/hr	*Heating Value	11048 Btu/lb
*Primary Coal output	200 tons/hr	*Heating Value	13456 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	4.41 %	*Sulfur-Primary	2.3 %
*Sulfur-Secondary	0 %		

File Record # 14 File code 200FRE-5040
 UPPER FREEPORT 200 TPH COMMERCIAL @5040

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 59282	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 5322
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 14616
*Working Capital	\$ 452	*Ins.&prop. tax/yr.	0 %
*Coal Input	345 tons/hr	*Heating Value	9162 Btu/lb
*Primary Coal output	200 tons/hr	*Heating Value	13574 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	4.27 %	*Sulfur-Primary	3 %
*Sulfur-Secondary	0 %		

File Record # 15 File code 200ILL-5040
 ILLINOIS NO. 6 200 TPH COMMERCIAL @5040

ADVANCED FROTH FLOTATION ECONOMICS AT 10 PERCENT RATE OF RETURN 200 TPH COMMERCIAL PLANT OPERATING 3456 HOURS PER YEAR			
Cost Item	PITTSBURGH NO. 8 COAL	UPPER FREEPORT COAL	ILLNOIS NO. 6 COAL
Annualized Costs			
Raw Coal \$/MMBtu	0.80	0.80	0
Raw Coal \$/Ton	11.73	17.68	14
Clean Coal Incremental \$/MMBtu	1.01	1.01	1
Clean Coal Total \$/MMBtu	1.81	1.81	1
Clean Coal Total \$/Ton	49.32	48.68	50
Levelized Costs			
Raw Coal \$/MMBtu	1.06	1.06	1
Raw Coal \$/Ton	15.48	23.33	19
Clean Coal Incremental \$/MMBtu	1.33	1.33	1
Clean Coal Total \$/MMBtu	2.39	2.39	2
Clean Coal Total \$/Ton	65.11	64.26	66
Other Costs			
Present Value Of Costs	\$120,697,000	\$119,025,000	\$126,755,000
Annualized Desulfurization Cost	\$477.08	\$442.49	\$435.00
Payback Period (years)	7.9	7.9	

CAPITAL REQUIREMENTS FOR 200 TPH (PRODUCT) PLANTS OPERATING 3456 HOURS PER YEAR			
DIRECT PROCESSING COSTS ESTIMATION			
COST ITEM	ALL THREE COALS		
A-CAPITAL COST OF PLANT	54,706,341		
B-CAPITAL COST OF EQUIPMENT	23,433,315		
C-MECHANICAL EQUIPMENT COST	19,988,023		
D-LAND PURCHASE	2,500,000		
E-STARTUP MODIFICATIONS	1,094,127		
F-PREPRODUCTION COSTS	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
POWER	329,219	329,219	329,219
FLOCCULANTS	25,206	20,089	69,183
FLOTATION REAGENTS	68,714	26,720	47,170
WATER	1,529	916	1,331
GRINDING MEDIA	24,880	23,450	24,631
LUBRICANTS	2,689	1,801	2,235
MAGNETITE	7,963	7,963	6,760
MANPOWER	73,826	73,826	73,826
MAINTENANCE SUPPLIES	195,278	195,278	195,278
DIRECT PROCESSING COSTS (A+D+E+F)	59,029,770	58,979,728	59,050,100
WORKING CAPITAL REQUIREMENT ESTIMATION			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	6,301	5,022	17,296
FLOTATION REAGENTS	17,179	6,680	11,793
GRINDING MEDIA	6,220	5,862	6,158
LUBRICANTS	672	450	559
MAGNETITE	1,991	1,991	1,690
SPARE PARTS= 2 % OF MECH. EQUIP.	399,760	399,760	399,760
TOTAL WORKING CAPITAL REQUIRED	432,123	419,766	437,256

ANNUAL OPERATING AND MAINTENANCE COSTS FOR 200 TPH (PRODUCT) PLANTS OPERATING 3456 HOURS PER YEAR			
YEARLY FIXED OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
PLANT LABOR COSTS	885,910	885,910	885,910
ADMINISTRATIVE LABOR AND COSTS	265,773	265,773	265,773
MAINTENANCE SUPPLIES	2,343,330	2,343,330	2,343,330
INSURANCE AND TAXES	1,641,190	1,641,190	1,641,190
TOTAL YEARLY FIXED O&M COSTS	5,136,203	5,136,203	5,136,203
YEARLY VARIABLE OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	302,469	241,071	830,200
FLOTATION REAGENTS	824,571	320,637	566,043
GRINDING MEDIA	298,562	281,395	295,577
LUBRICANTS	32,266	21,615	26,824
MAGNETITE	95,551	95,551	81,119
POWER	3,950,623	3,950,623	3,950,623
PROCESS WATER	18,351	10,990	15,967
TOTAL YEARLY VARIABLE O&M COSTS	5,522,393	4,921,882	5,766,353

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 59030	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 5136
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 13998
*Working Capital	\$ 432	*Ins.&prop. tax/yr.	0 %
*Coal Input	415 tons/hr	*Heating Value	7329 Btu
*Primary Coal output	200 tons/hr	*Heating Value	13618 Bt
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lk
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/h
*Sulfur-Input	2.9 %	*Sulfur-Primary	2.5 %
*Sulfur-Secondary	0 %		

File Record # 10 File code 200PGH-3456
 PITTSBURGH 200 TPH COMMERCIAL @3456

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 58980	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 5136
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 12476
*Working Capital	\$ 420	*Ins.&prop. tax/yr.	0 %
*Coal Input	278 tons/hr	*Heating Value	11048 Bt
*Primary Coal output	200 tons/hr	*Heating Value	13456 Bt
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/l
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/l
*Sulfur-Input	4.41 %	*Sulfur-Primary	2.3 %
*Sulfur-Secondary	0 %		

File Record # 11 File code 200FRE-3456
 UPPER FREEPORT 200 TPH COMMERCIAL @3456

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 59050	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 5136
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 14616
*Working Capital	\$ 437	*Ins.&prop. tax/yr.	0 %
*Coal Input	345 tons/hr	*Heating Value	9162 Bt
*Primary Coal output	200 tons/hr	*Heating Value	13574 B
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/l
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/
*Sulfur-Input	4.27 %	*Sulfur-Primary	3 %
*Sulfur-Secondary	0 %		

File Record # 12 File code 200ILL-3456
 No description

ADVANCED FROTH FLOTATION ECONOMICS 500 TPH COMMERCIAL PLANT

CASE STUDY

**7560 HOURS PER YEAR OPERATION
AT 10 % RATE OF RETURN**

**ADVANCED FROTH FLOTATION ECONOMICS AT 10 PERCENT RATE OF RETURN
500 TPH COMMERCIAL PLANT OPERATING 7560 HOURS PER YEAR**

Cost Item	PITTSBURGH NO. 8 COAL	UPPER FREEPORT COAL	ILLNOIS NO. 6 COAL
Annualized Costs			
Raw Coal \$/MMBtu	0.80	0.80	0.80
Raw Coal \$/Ton	11.73	17.68	14.66
Clean Coal Incremental \$/MMBtu	0.58	0.59	0.64
Clean Coal Total \$/MMBtu	1.38	1.39	1.44
Clean Coal Total \$/Ton	37.68	37.30	38.99
Levelized Costs			
Raw Coal \$/MMBtu	1.06	1.06	1.06
Raw Coal \$/Ton	15.48	23.33	19.35
Clean Coal Incremental \$/MMBtu	0.77	0.77	0.84
Clean Coal Total \$/MMBtu	1.83	1.83	1.90
Clean Coal Total \$/Ton	49.73	49.23	51.47
Other Costs			
Present Value Of Costs	\$380,373,000	\$377,515,000	\$413,473,000
Annualized Desulfurization Cost	\$275.27	\$256.95	\$259.84
Payback Period (years)	7.9	7.9	7.9

CAPITAL REQUIREMENTS FOR 500 TPH (PRODUCT) PLANTS OPERATING 7560 HOURS PER YEAR			
DIRECT PROCESSING COSTS ESTIMATION			
COST ITEM	ALL THREE COALS		
A-CAPITAL COST OF PLANT	103,895,245		
B-CAPITAL COST OF EQUIPMENT	44,503,251		
C-MECHANICAL EQUIPMENT COST	37,960,145		
D-LAND PURCHASE	5,000,000		
E-STARTUP MODIFICATIONS	2,077,905		
F-PREPRODUCTION COSTS	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
POWER	1,630,934	1,630,934	1,630,934
FLOCCULANTS	137,844	191,429	378,347
FLOTATION REAGENTS	375,781	146,124	257,962
WATER	8,363	5,009	7,277
GRINDING MEDIA	136,064	128,240	134,703
LUBRICANTS	14,705	9,850	12,225
MAGNETITE	43,546	43,546	36,968
MANPOWER	122,303	122,303	122,303
MAINTENANCE SUPPLIES	370,860	370,860	370,860
DIRECT PROCESSING COSTS (A+D+E+F)	113,813,550	113,621,445	113,924,729
WORKING CAPITAL REQUIREMENT ESTIMATION			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	33,083	45,943	90,803
FLOTATION REAGENTS	90,187	35,070	61,911
GRINDING MEDIA	32,655	30,778	32,329
LUBRICANTS	3,529	2,364	2,934
MAGNETITE	10,451	10,451	8,872
SPARE PARTS= 2 % OF MECH. EQUIP.	759,203	759,203	759,203
TOTAL WORKING CAPITAL REQUIRED	929,108	883,808	956,052

ANNUAL OPERATING AND MAINTENANCE COSTS FOR 500 TPH (PRODUCT) PLANTS OPERATING 7560 HOURS PER YEAR			
YEARLY FIXED OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
PLANT LABOR COSTS	1,467,639	1,467,639	1,467,639
ADMINISTRATIVE LABOR AND COSTS	440,292	440,292	440,292
MAINTENANCE SUPPLIES	4,450,325	4,450,325	4,450,325
INSURANCE AND TAXES	3,116,857	3,116,857	3,116,857
TOTAL YEARLY FIXED O&M COSTS	9,475,113	9,475,113	9,475,113
YEARLY VARIABLE OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	1,654,128	2,297,151	4,540,158
FLOTATION REAGENTS	4,509,374	1,753,482	3,095,548
GRINDING MEDIA	1,632,763	1,538,879	1,616,438
LUBRICANTS	176,457	118,205	146,694
MAGNETITE	522,547	522,547	443,621
POWER	19,571,207	19,571,207	19,571,207
PROCESS WATER	100,359	60,102	87,318
TOTAL YEARLY VARIABLE O&M COSTS	28,166,835	25,861,573	29,500,981

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 113814	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 9475
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 32638
*Working Capital	\$ 929	*Ins.&prop. tax/yr.	0 %
*Coal Input	1037.5 tons/hr	*Heating Value	7329 Btu/lb
*Primary Coal output	500 tons/hr	*Heating Value	13618 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	2.9 %	*Sulfur-Primary	2.5 %
*Sulfur-Secondary	0 %		

File Record # 16 File code 500PGH-7560
 PITTSBURGH 500 TPH COMMERCIAL @7560

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 113621	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 9475
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 29967
*Working Capital	\$ 884	*Ins.&prop. tax/yr.	0 %
*Coal Input	695 tons/hr	*Heating Value	11048 Btu/lb
*Primary Coal output	500 tons/hr	*Heating Value	13456 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	4.41 %	*Sulfur-Primary	2.3 %
*Sulfur-Secondary	0 %		

File Record # 17 File code 500FRE-7560
 UPPER FREEPORT 500 TPH COMMERCIAL @7560

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 113925	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 9475
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 34184
*Working Capital	\$ 956	*Ins.&prop. tax/yr.	0 %
*Coal Input	862.5 tons/hr	*Heating Value	9162 Btu/lb
*Primary Coal output	500 tons/hr	*Heating Value	13574 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	4.27 %	*Sulfur-Primary	3 %
*Sulfur-Secondary	0 %		

File Record # 18 File code 500ILL-7560
 ILLINOIS NO. 6 500 TPH COMMERCIAL @7560

ADVANCED FROTH FLOTATION ECONOMICS 20 TPH SEMI-WORKS PLANT

CASE STUDY

**7560 HOURS PER YEAR OPERATION
AT 10 % RATE OF RETURN**

**ADVANCED FROTH FLOTATION ECONOMICS AT 10 PERCENT RATE OF RETURN
20 TPH SEMI WORKS PLANT OPERATING 7560 HOURS PER YEAR**

Cost Item	PITTSBURGH NO. 8 COAL	UPPER FREEPORT COAL	ILLNOIS NO. 6 COAL
Annualized Costs			
Raw Coal \$/MMBtu	0.80	0.80	0.80
Raw Coal \$/Ton	11.73	17.68	14.66
Clean Coal Incremental \$/MMBtu	1.43	1.44	1.49
Clean Coal Total \$/MMBtu	2.23	2.24	2.29
Clean Coal Total \$/Ton	60.76	60.38	62.08
Levelized Costs			
Raw Coal \$/MMBtu	1.06	1.06	1.06
Raw Coal \$/Ton	15.48	23.33	19.35
Clean Coal Incremental \$/MMBtu	1.89	1.91	1.96
Clean Coal Total \$/MMBtu	2.95	2.96	3.02
Clean Coal Total \$/Ton	80.21	79.71	81.94
Other Costs			
Present Value Of Costs	\$37,328,000	\$37,213,000	\$38,653,000
Annualized Desulfurization Cost	\$675.33	\$633.20	\$607.27
Payback Period (years)	7.9	7.9	7.9

CAPITAL REQUIREMENTS FOR 20 TPH (PRODUCT) PLANTS OPERATING 7560 HOURS PER YEAR			
DIRECT PROCESSING COSTS ESTIMATION			
COST ITEM	ALL THREE COALS		
A-CAPITAL COST OF PLANT	10,915,350		
B-CAPITAL COST OF EQUIPMENT	4,675,561		
C-MECHANICAL EQUIPMENT COST	3,988,135		
D-LAND PURCHASE	250,000		
E-STARTUP MODIFICATIONS	218,307		
F-PREPRODUCTION COSTS	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
POWER	95,921	95,921	95,921
FLOCCULANTS	5,514	7,657	15,134
FLOTATION REAGENTS	15,031	5,845	10,319
WATER	335	200	291
GRINDING MEDIA	5,443	5,130	5,388
LUBRICANTS	588	394	489
MAGNETITE	1,742	1,742	1,479
MANPOWER	122,303	122,303	122,303
MAINTENANCE SUPPLIES	38,963	38,963	38,963
DIRECT PROCESSING COSTS (A+D+E+F)	11,669,497	11,661,812	11,673,944
WORKING CAPITAL REQUIREMENT ESTIMATION			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	1,323	1,838	3,632
FLOTATION REAGENTS	3,608	1,403	2,476
GRINDING MEDIA	1,306	1,231	1,293
LUBRICANTS	141	95	117
MAGNETITE	418	418	355
SPARE PARTS= 2 % OF MECH. EQUIP.	79,763	79,763	79,763
TOTAL WORKING CAPITAL REQUIRED	86,559	84,747	87,637

ANNUAL OPERATING AND MAINTENANCE COSTS FOR 20 TPH (PRODUCT) PLANTS OPERATING 7560 HOURS PER YEAR			
YEARLY FIXED OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
PLANT LABOR COSTS	1,467,639	1,467,639	1,467,639
ADMINISTRATIVE LABOR AND COSTS	440,292	440,292	440,292
MAINTENANCE SUPPLIES	467,556	467,556	467,556
INSURANCE AND TAXES	327,461	327,461	327,461
TOTAL YEARLY FIXED O&M COSTS	2,702,947	2,702,947	2,702,947
YEARLY VARIABLE OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	66,165	91,886	181,601
FLOTATION REAGENTS	180,375	70,139	123,821
GRINDING MEDIA	65,311	61,555	64,651
LUBRICANTS	7,058	4,728	5,861
MAGNETITE	20,902	20,902	17,741
POWER	1,151,055	1,151,055	1,151,055
PROCESS WATER	4,014	2,404	3,491
TOTAL YEARLY VARIABLE O&M COSTS	1,494,880	1,402,669	1,548,241

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 11669	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 2703
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 1732
*Working Capital	\$ 87	*Ins.&prop. tax/yr.	0 %
*Coal Input	41.5 tons/hr	*Heating Value	7329 Btu/lb
*Primary Coal output	20 tons/hr	*Heating Value	13618 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	2.9 %	*Sulfur-Primary	2.5 %
*Sulfur-Secondary	0 %		

File Record # 4 File code 20PGH-7560
PITTBURGH 20 TPH SEMI WORKS

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 11662	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 2703
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 1625
*Working Capital	\$ 85	*Ins.&prop. tax/yr.	0 %
*Coal Input	27.8 tons/hr	*Heating Value	11048 Btu/lb
*Primary Coal output	20 tons/hr	*Heating Value	13456 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	4.41 %	*Sulfur-Primary	2.3 %
*Sulfur-Secondary	0 %		

File Record # 5 File code 20FRE-7560
UPPER FREEPORT 20 TPH SEMI WORKS

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 11674	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 2703
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 1794
*Working Capital	\$ 88	*Ins.&prop. tax/yr.	0 %
*Coal Input	34.5 tons/hr	*Heating Value	9162 Btu/lb
*Primary Coal output	20 tons/hr	*Heating Value	13574 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	4.27 %	*Sulfur-Primary	3 %
*Sulfur-Secondary	0 %		

File Record # 6 File code 20ILL-7560
ILLINOIS NO. 6 20 TPH SEMI WORKS

ADVANCED FROTH FLOTATION ECONOMICS 200 TPH PLANT ADDITION

2 CASE STUDIES

- 1) 7560 HOURS PER YEAR OPERATION AT 10 % RATE OF RETURN**
- 2) 3456 HOURS PER YEAR OPERATION AT 10 % RATE OF RETURN**

PROCESS EQUIPMENT FOR PLANT ADDITION

20 TPH CLEAN COAL SEMI-WORKS CONCEPTUAL DESIGN
ICF KAISER ENGINEERS PROJECT NUMBER 88107-250-00

ADVEQUIP.wk3

TASK 15 EQUIPMENT LIST FOR 20 TONS PER HOUR, SEMI-WORKS FLOWSHEET

EQUIP. NO.	DESCRIPTION	# OF UNITS	WEIGHT	PRICE	UNIT HP	TOTAL HP	ENCL	VOLTS	RPM	MOTOR SUPPLIED	COMMENTS
111	RAW COAL CRUSHER	1	12,000	79,500	50.00	50.00	TEFC	480	1800	YES	GUNDLACH 45 DA
150	MIDDINGS CRUSHER DRIVE 1	1	12,000	125,811	100.00	100.00	TEFC	480	1800	YES	GUNDLACH CAGEPACTOR
150.1	MIDDINGS CRUSHER DRIVE 2	1	-	INCLUDED	75.00	75.00	TEFC	480	1800	YES	SAME
152	OVERSIZE PROTECTION PUMP	1	5,000	12,912	40.00	40.00	TEFC	480	1800	YES	GOYNE PUMP
153	OVERSIZE PROTECTION SIEVE BEND	2	5,600	10,600	-	-	-	-	-	-	5'W,40'R,60,.35 MM,3/32 ISO
208	VARI-SIEVE	2	7500	103414	-	-	-	-	-	-	KREBS 5'W VARI-SIEVE
210	BALL MILL	1	186,000	606,320	750.00	750.00	TEFC	4160	900	YES	10' DIA. X 6' CONICAL BALL MILL
220	ADVANCED FLOTATION FEED PUMP	1	5,000	25,803	100.00	100.00	TEFC	480	1800	YES	GOYNE PUMP
230	ADVANCED FLOTATION CELL	4	46,000	466,400	-	-	-	-	-	-	ICF KE MICROCEL™ MODEL 12025
230.1	ADVANCED FLOTATION PUMP	4	5,000	INCLUDED	75.00	300.00	TEFC	480	1800	YES	GOYNE PUMP
240	COAL STATIC THICKENER DRIVE	1	17,000	68,900	3.00	3.00	TEFC	480	1800	YES	EIMCO 50' DIAMETER HIRATE
240.1	COAL STATIC THICKENER LIFTING DEVICE	1	-	INCLUDED	1.00	1.00	TEFC	480	900	YES	SAME
247	COAL THICK. CLARIFIED WATER PUMP	1	5,000	30,152	200.00	200.00	TEFC	480	1800	YES	GOYNE PUMP
249	COAL STATIC THICKENER U'FLOW PUMP	1	5,000	12,207	25.00	25.00	TEFC	480	1800	YES	GOYNE PUMP
260	CLEAN COAL FILTER DRIVE	1	122,000	1,228,710	10.00	10.00	TEFC	480	1800	YES	ANDRITZ RUTHNER, INC.
260.1	AGITATOR	3	-	INCLUDED	1.50	4.50	TEFC	480	1800	YES	SAME
260.2	DISCHARGE GATES	1	-	INCLUDED	30.00	30.00	TEFC	480	1800	YES	SAME
260.3	AIR COMPRESSOR	1	8,000	52,391	200.00	200.00	TEFC	480	1800	YES	AIRTEC
260.4	FILTRATE PUMP	1	5,000	8,509	5.00	5.00	TEFC	480	1800	YES	GOYNE PUMP
260.5	LUBRICATOR	1	-	INCLUDED	1.00	1.00	TEFC	480	1800	YES	ANDRITZ RUTHNER, INC.
260.6	AUXILLARY AIR COMPRESSOR	1	5,000	INCLUDED	7.50	7.50	TEFC	480	1800	YES	SAME
260.7	INTERNAL CONVEYOR	1	-	INCLUDED	10.00	10.00	TEFC	480	1800	YES	SAME
335	MIDS SIEVE BEND	1	2,200	4,876	-	-	-	-	-	-	3'W,80'R,60,.5 MM,3/32 ISO
340	MIDS DRAIN & RINSE SCREEN	1	18,000	23,320	20.00	20.00	TEFC	480	1800	YES	TABOR 4X16 SD VIB. HORIZONTAL
398	1/2 OF PLANT & COLUMN AIR COMPRESS.	1	8000	26,200	200.00	100.00	TEFC	480	1800	YES	AIRTEC
398.1	PREFILTERS	1	500	INCLUDED	-	-	-	-	-	-	SAME
398.2	AFTER FILTERS	2	750	INCLUDED	-	-	-	-	-	-	SAME
400	PROPORTION OF FLOCCULANT SYSTEM	1	-	37,893	-	2.00	-	-	-	-	MINETEC
405	REAGENT SYSTEM	1	-	33,454	-	-	-	-	-	-	SAME
430	BALL MILL OVERHEAD CRANE HOIST	1	5,000	44,520	25.00	25.00	TEFC	480	1800	YES	THERN
430.1	BALL MILL OVERHEAD CRANE TRAM	1	-	8,480	10.00	10.00	TEFC	480	1800	YES	THERN
TOTAL VALUES			485,550	3,010,372		2,069					HEATING LOAD 715 KW

ADVANCED FROTH FLOTATION ECONOMICS AT 10 PERCENT RATE OF RETURN 200 TPH COMMERCIAL PLANT ADDITION OPERATING 7560 HOURS PER YEAR			
Cost Item	PITTSBURGH NO. 8 COAL	UPPER FREEPORT COAL	ILLNOIS NO. 6 COAL
Annualized Costs			
Raw Coal \$/MMBtu	0.80	0.80	(
Raw Coal \$/Ton	16.80	19.07	17
Clean Coal Incremental \$/MMBtu	0.45	0.49	(
Clean Coal Total \$/MMBtu	1.25	1.29	.
Clean Coal Total \$/Ton	34.07	34.69	34
Levelized Costs			
Raw Coal \$/MMBtu	1.06	1.06	.
Raw Coal \$/Ton	22.17	25.18	22
Clean Coal Incremental \$/MMBtu	0.60	0.65	(
Clean Coal Total \$/MMBtu	1.65	1.70	
Clean Coal Total \$/Ton	44.97	45.80	44
Other Costs			
Present Value Of Costs	\$117,603,000	\$126,080,000	\$130,996
Annualized Desulfurization Cost	\$1,148.40	\$969.02	\$1,45
Payback Period (years)	7.9	7.9	

CAPITAL REQUIREMENTS FOR 200 TPH (PRODUCT) PLANT ADDITION OPERATING 7560 HOURS PER YEAR			
DIRECT PROCESSING COSTS ESTIMATION			
COST ITEM	ALL THREE COALS		
A-CAPITAL COST OF PLANT	42,030,183		
B-CAPITAL COST OF EQUIPMENT	18,003,516		
C-MECHANICAL EQUIPMENT COST	14,558,225		
D-LAND PURCHASE	1,920,718		
E-STARTUP MODIFICATIONS	840,604		
F-PREPRODUCTION COSTS	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
POWER	537,062	537,062	537,062
FLOCCULANTS	36,187	58,446	97,776
FLOTATION REAGENTS	150,312	58,449	103,185
WATER	1,673	1,002	1,455
GRINDING MEDIA	54,425	51,296	53,881
LUBRICANTS	3,787	2,537	4,890
MAGNETITE	0	0	0
MANPOWER	18,948	18,948	18,948
MAINTENANCE SUPPLIES	125,726	125,726	125,726
DIRECT PROCESSING COSTS (A+D+E+F)	45,719,626	45,644,971	45,734,428
WORKING CAPITAL REQUIREMENT ESTIMATION			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	8,685	14,027	23,466
FLOTATION REAGENTS	36,075	14,028	24,764
GRINDING MEDIA	13,062	12,311	12,931
LUBRICANTS	909	609	1,174
MAGNETITE	0	0	0
SPARE PARTS= 2 % OF MECH. EQUIP.	291,165	291,165	291,165
TOTAL WORKING CAPITAL REQUIRED	349,895	332,139	353,500

ANNUAL OPERATING AND MAINTENANCE COSTS FOR 200 TPH (PRODUCT) PLANT ADDITION OPERATING 7560 HOURS PER YEAR			
YEARLY FIXED OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
PLANT LABOR COSTS	227,381	227,381	227,381
ADMINISTRATIVE LABOR AND COSTS	68,214	68,214	68,214
MAINTENANCE SUPPLIES	1,508,710	1,508,710	1,508,710
INSURANCE AND TAXES	1,260,905	1,260,905	1,260,905
TOTAL YEARLY FIXED O&M COSTS	3,065,211	3,065,211	3,065,211
YEARLY VARIABLE OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	434,246	701,350	1,173,312
FLOTATION REAGENTS	1,803,749	701,393	1,238,219
GRINDING MEDIA	653,105	615,551	646,574
LUBRICANTS	45,443	30,442	58,677
MAGNETITE	0	0	0
POWER	6,444,749	6,444,749	6,444,749
PROCESS WATER	20,072	12,020	17,464
TOTAL YEARLY VARIABLE O&M COSTS	9,401,364	8,505,505	9,578,995

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 45720	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 3065
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 10894
*Working Capital	\$ 350	*Ins.&prop. tax/yr.	0 %
*Coal Input	267 tons/hr	*Heating Value	10499 Bt
*Primary Coal output	200 tons/hr	*Heating Value	13618 Bt
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/h
*Sulfur-Input	2.34 %	*Sulfur-Primary	2.5 %
*Sulfur-Secondary	0 %		

File Record # 19 File code ADV-PGH7560
PITTSBURGH 200TPH PLANT ADDITION @7560

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 45645	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 3065
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 9856
*Working Capital	\$ 332	*Ins.&prop. tax/yr.	0 %
*Coal Input	248 tons/hr	*Heating Value	11921 Bt
*Primary Coal output	200 tons/hr	*Heating Value	13456 Bt
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/l
*Sulfur-Input	2.64 %	*Sulfur-Primary	2.3 %
*Sulfur-Secondary	0 %		

File Record # 20 File code ADV-FRE7560
UPPER FREEPORT 200TPH PLANT ADDITION @7560

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 45734	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 3065
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 11099
*Working Capital	\$ 354	*Ins.&prop. tax/yr.	0 %
*Coal Input	264 tons/hr	*Heating Value	11191 B
*Primary Coal output	200 tons/hr	*Heating Value	13574 B
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/l
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/
*Sulfur-Input	2.86 %	*Sulfur-Primary	3 %
*Sulfur-Secondary	0 %		

File Record # 21 File code ADV-ILL7560
ILLINOIS NO.6 200TPH PLANT ADDITION @7560

**ADVANCED FROTH FLOTATION ECONOMICS AT 10 PERCENT RATE OF RETURN
200 TPH COMMERCIAL PLANT ADDITION OPERATING 3456 HOURS PER YEAR**

Cost Item	PITTSBURGH NO. 8 COAL	UPPER FREEPORT COAL	ILLNOIS NO. 6 COAL
Annualized Costs			
Raw Coal \$/MMBtu	0.80	0.80	0.80
Raw Coal \$/Ton	16.80	19.07	17.91
Clean Coal Incremental \$/MMBtu	0.68	0.72	0.73
Clean Coal Total \$/MMBtu	1.48	1.52	1.53
Clean Coal Total \$/Ton	40.19	40.81	41.50
Levelized Costs			
Raw Coal \$/MMBtu	1.06	1.06	1.06
Raw Coal \$/Ton	22.17	25.18	23.64
Clean Coal Incremental \$/MMBtu	0.89	0.95	0.96
Clean Coal Total \$/MMBtu	1.95	2.00	2.02
Clean Coal Total \$/Ton	53.05	53.88	54.78
Other Costs			
Present Value Of Costs	\$80,653,000	\$84,533,000	\$86,723,000
Annualized Desulfurization Cost	\$1,720.72	\$1,419.48	\$2,111.18
Payback Period (years)	7.9	7.9	7.9

CAPITAL REQUIREMENTS FOR 200 TPH (PRODUCT) PLANT ADDITION OPERATING 3456 HOURS PER YEAR			
DIRECT PROCESSING COSTS ESTIMATION			
COST ITEM	ALL THREE COALS		
A-CAPITAL COST OF PLANT	42,030,183		
B-CAPITAL COST OF EQUIPMENT	18,003,516		
C-MECHANICAL EQUIPMENT COST	14,558,225		
D-LAND PURCHASE	1,920,718		
E-STARTUP MODIFICATIONS	840,604		
F-PREPRODUCTION COSTS	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
POWER	245,514	245,514	245,514
FLOCCULANTS	16,543	26,718	44,698
FLOTATION REAGENTS	68,714	26,720	47,170
WATER	765	458	665
GRINDING MEDIA	24,880	23,450	24,631
LUBRICANTS	1,731	1,160	1,439
MAGNETITE	0	0	0
MANPOWER	8,662	8,662	8,662
MAINTENANCE SUPPLIES	125,726	125,726	125,726
DIRECT PROCESSING COSTS (A+D+E+F)	45,284,040	45,249,912	45,290,010
WORKING CAPITAL REQUIREMENT ESTIMATION			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	4,136	6,680	11,174
FLOTATION REAGENTS	17,179	6,680	11,793
GRINDING MEDIA	6,220	5,862	6,158
LUBRICANTS	433	290	360
MAGNETITE	0	0	0
SPARE PARTS= 2 % OF MECH. EQUIP.	291,165	291,165	291,165
TOTAL WORKING CAPITAL REQUIRED	319,132	310,676	320,649

ANNUAL OPERATING AND MAINTENANCE COSTS FOR 200 TPH (PRODUCT) PLANT ADDITION OPERATING 3456 HOURS PER YEAR			
YEARLY FIXED OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
PLANT LABOR COSTS	103,946	103,946	103,946
ADMINISTRATIVE LABOR AND COSTS	31,184	31,184	31,184
MAINTENANCE SUPPLIES	1,508,710	1,508,710	1,508,710
INSURANCE AND TAXES	1,260,905	1,260,905	1,260,905
TOTAL YEARLY FIXED O&M COSTS	2,904,745	2,904,745	2,904,745
YEARLY VARIABLE OPERATING AND MAINTENANCE COSTS			
COST ITEM	PITTSBURGH NO. 8	UPPER FREEPORT	ILLINOIS NO. 6
FLOCCULANTS	198,513	320,617	536,371
FLOTATION REAGENTS	824,571	320,637	566,043
GRINDING MEDIA	298,562	281,395	295,577
LUBRICANTS	20,774	13,916	17,270
MAGNETITE	0	0	0
POWER	2,946,171	2,946,171	2,946,171
PROCESS WATER	9,176	5,495	7,983
TOTAL YEARLY VARIABLE O&M COSTS	4,297,767	3,888,231	4,369,415

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 45284	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 2905
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 10894
*Working Capital	\$ 319	*Ins.&prop. tax/yr.	0 %
*Coal Input	267 tons/hr	*Heating Value	10499 Btu/lb
*Primary Coal output	200 tons/hr	*Heating Value	13618 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	2.34 %	*Sulfur-Primary	2.5 %
*Sulfur-Secondary	0 %		

File Record # 22 File code ADV-PGH3456
 PITTSBURGH 200TPH PLANT ADDITION @3456

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 45250	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 2905
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 9856
*Working Capital	\$ 311	*Ins.&prop. tax/yr.	0 %
*Coal Input	248 tons/hr	*Heating Value	11921 Btu/lb
*Primary Coal output	200 tons/hr	*Heating Value	13456 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	2.64 %	*Sulfur-Primary	2.3 %
*Sulfur-Secondary	0 %		

File Record # 23 File code ADV-FRE3456
 UPPER FREEPORT 200TPH PLANT ADDITION @3456

COAL PREPARATION PLANT DATA

Costs in \$1000

*Direct Processing	\$ 45290	*Fuel stockpile	0 days
*Emission/Waste Equip	\$ 0	*Expensible Cap.	0 %
*Off-Site Utilities	\$ 0	*Year 1 outlay	50 %
*On-Site Assembly	\$ 0	*Year 2 outlay	50 %
*Site Modifications	\$ 0	*Year 3 outlay	0 %
*Engineering	\$ 0	*Fixed O&M, Per Year	\$ 2905
*Contingency	\$ 0	*Var O&M/yr @100% Ld	\$ 11075
*Working Capital	\$ 321	*Ins.&prop. tax/yr.	0 %
*Coal Input	264 tons/hr	*Heating Value	11191 Btu/lb
*Primary Coal output	200 tons/hr	*Heating Value	13574 Btu/lb
*Second Coal output	0 tons/hr	*Heating Value	0 Btu/lb
*Fuel Consumption	0 MMBtu/hr	*Reagent Consumption	0 tons/hr
*Sulfur-Input	2.86 %	*Sulfur-Primary	3 %
*Sulfur-Secondary	0 %		

File Record # 24 File code ADV-ILL3456
 ILLINOIS NO.6 200TPH PLANT ADDITION @3456