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Standard Test Method for Sieve Analysis of Petroleum Coke¹

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1. Scope

1.1 This test method details a procedure for performing particle size distribution analysis by dry sieve testing on green petroleum coke with a topsize of no more than 75 mm and calcined petroleum coke with a topsize of no more than 25 mm. Size fractions go down to and include 4.75 mm for green petroleum coke and 75 μm for calcined petroleum coke.

NOTE 1—To convert units, see Table 1 on nominal dimensions in Specification E11. For example, 75 mm is approximately equivalent to a nominal sieve opening of 3 in. and 25 mm to a nominal sieve opening of 1 in. Likewise, 4.75 mm can be converted to approximately 0.187 in. and 75 microns to 0.0029 in.

1.2 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard. The sieve size is reported as U.S.A. standard test series in any units listed in Table 1 on nominal dimensions of Specification E11, or their commercial size equivalents.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

D346 Practice for Collection and Preparation of Coke Samples for Laboratory Analysis

D2013 Practice for Preparing Coal Samples for Analysis

D2234/D2234M Practice for Collection of a Gross Sample of Coal

D4057 Practice for Manual Sampling of Petroleum and Petroleum Products

¹ This test method is under the jurisdiction of ASTM Committee D02 on Petroleum Products and Lubricants and is the direct responsibility of Subcommittee D02.05 on Properties of Fuels, Petroleum Coke and Carbon Material.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

D4749 Test Method for Performing the Sieve Analysis of Coal and Designating Coal Size

E11 Specification for Woven Wire Test Sieve Cloth and Test Sieves

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *bulk sample*—the reduced and divided representative portion of the gross sample as prepared for shipment to and received by a laboratory, to be prepared for analysis.

3.1.2 *gross sample*—the original, uncrushed, representative portion taken from a shipment or lot of coke.

3.1.3 *lot*—a quantity of coke to be represented by a gross sample.

3.1.4 *representative sample*—a sample collected in such a manner that every particle in the lot to be sampled is equally represented in the gross sample.

3.1.5 *topsize*—the size of the opening of that sieve of a series with the smallest opening upon which is cumulatively retained a total of less than 5 % of the sample. This defined topsize is not to be confused with the size of the largest particle in a lot.

4. Summary of Test Method

4.1 A representative coke sample is divided into ranges of particle size by the use of a series of square-holed sieves.

5. Significance and Use

5.1 The test method concerns the sieving of coke into designated size fractions for the purpose of characterizing the material as to its particle size distribution. It requires the use of standard sieves, standard sampling methods, standard sample preparation methods, and a minimum initial sample mass based on lot topsize. Suggestions are given for industry typical sieve stacks for both green and calcined petroleum coke.

5.2 Particle size distribution is significant in that many physical characteristics of a coke are related to such a distribution including bulk density and surface area. Nuisance characteristics, such as excessive fines in a lot, can also be controlled.

5.3 Results from this test method are useful in determining whether a coke lot meets purchase specifications, for classification purposes, and for quality control. The results of this test

TABLE 1 Industry Typical Sieves

Calcined Petroleum Coke	Green Petroleum Coke
25.0 mm	25.0 mm
19.0 mm	12.5 mm
12.5 mm	4.75 mm
4.75 mm	-4.75 mm
3.35 mm	
2.36 mm	
1.18 mm	
600 µm	
300 µm	
212 µm	
150 µm	
75 µm	
-75 µm	

TABLE 2 Initial Minimum Test Sample Mass Requirements for Sieve Analysis

Topsize	Type of Coke	Initial Sample Mass Requirement, g	Expected Relative Error, %
75 mm	Green	50,000	6
50 mm	Green	30,000	6
25 mm	Green/Calcined	1,500	3
19 mm	Green/Calcined	1,300	1
12.5 mm	Green/Calcined	1,000	1
4.75 mm	Green/Calcined	800	1
2.36 mm	Green/Calcined	700	1
1.18 mm	Green/Calcined	500	1
600 µm	Green/Calcined	300	1
300 µm	Green/Calcined	100	1
150 µm ^A	Green/Calcined	50	1

^A For topsize less than 150 µm, use an initial sample mass requirement of 50 g.

method can also be used to predict the performance of a particular lot of coke in a process.

6. Interferences

6.1 A sieve analysis is very sensitive to the sieve cloth and sieve cloth-frame integrity. Minor separations of the sieve cloth from the frame such as one broken sieve wire, and slight distortions of sieve wires, can cause serious inaccuracies in the final results of a sieve analysis.

6.2 Blinding of or a reduction in the number of openings in a sieve due to a collection of particles caught in the mesh can introduce errors.

6.3 Flooding or overloading of any sieve with particles reduces the probability of any given particle encountering an opening in the sieve.

7. Apparatus

7.1 Sieves:

7.1.1 Sieves will be used in a descending size opening sequence, larger mesh openings above smaller.

7.1.1.1 Typical sets of sieves to be used are listed in [Table 1](#).

NOTE 2—Sets of sieves are often modified. Typically, specifications on sets of sieves are negotiated between the buyer and the seller. The actual sequence used by the operator performing the analysis can vary. For example, intermediate sieves can be chosen to avoid sieve flooding and to make the sieving operation more efficient. [Table 1](#) on nominal dimensions in [Specification E11](#) is to be used as a guide.

7.1.2 A topsize sieve shall be used.

7.1.3 Wire sieve cloth and frames used will conform to [Specification E11](#).

7.1.4 Wire composition and types of frames must be sized properly for potential sieving operations. Stainless steel sieve cloth is very resistant to distortion and preferred over softer metals.

7.1.5 Collecting pans and sieve covers designed to fit the sieves are required.

7.1.6 Check [Specification E11](#) for more details on standard sieves, service checks, and calibration.

7.2 Sieve Shaker:

7.2.1 Use a batch type sieve shaker.³

7.2.2 For sieving small quantities of coke or very fine coke (below 70 mesh), use a laboratory type sieving machine.⁴

8. Sample Preparation

8.1 A representative gross sample of the coke lot must be collected using appropriate procedures from [Practice D346](#), [Test Methods D2234/D2234M](#), or [Practice D4057](#). (**Warning**—The gross sample must not be crushed or reduced in topsize during the gross sample collection process or during subsequent divisions of the sample.)

8.2 The gross sample is divided into a smaller bulk sample following guidelines in [Test Methods D2234/D2234M](#). The bulk sample must remain representative including no loss in topsize. Keeping in mind the initial sample mass requirements (see [Table 2](#)), the bulk sample must be at least twice the largest minimum mass that you estimate will be required for the analysis.

8.3 Upon delivery of the bulk sample to the laboratory, the sample shall be stored in a safe, dry location. Prevent any size degradation, loss of mass, or contamination of the sample until needed for the sieve analysis.

8.4 Immediately prior to the sieve analysis, examine the bulk sample determining whether it is dry and free flowing. If not, use the air drying apparatus and drying procedure of [Practice D2013](#).

8.5 Determine the initial minimum test sample mass required for the analysis from [Table 2](#).

³ The sole source of supply of the model number TS-1 Gilson Testing Screen machine known to the committee at this time is Gilson Company, Inc., P. O. Box 677, Worthington, OH 43085-0677. If you are aware of alternative suppliers, please provide this information to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee,¹ which you may attend.

⁴ The sole source of supply of the Ro-Tap Testing Sieve Shaker known to the committee at this time is W. S. Tyler, Inc., 3200 Bessemer City Rd., P. O. Box 8900, Gastonia, NC 28053-9065. If you are aware of alternative suppliers, please provide this information to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee¹, which you may attend.