



Designation: D7084 – 04 (Reapproved 2009)

Standard Test Method for Determination of Bulk Crush Strength of Catalysts and Catalyst Carriers¹

This standard is issued under the fixed designation D7084; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This test method covers the determination of bulk crush strength of a bed of formed catalyst particles $\frac{1}{32}$ to $\frac{3}{16}$ in. (0.8 to 4.8 mm) in diameter and is intended to provide information concerning the ability of the catalyst material to maintain physical integrity.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

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

D3766 Terminology Relating to Catalysts and Catalysis

D4180 Test Method for Vibratory Packing Density of Formed Catalyst Particles and Catalyst Carriers

E177 Practice for Use of the Terms Precision and Bias in ASTM Test Methods

E456 Terminology Relating to Quality and Statistics

E691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method

3. Terminology

3.1 *Definitions:*

3.1.1 See also Terminology D3766.

3.1.2 *bulk crush strength*—pressure that generates 1 % fines for a sample contained in a cylindrical sample holder and crushed with a piston.

¹ This test method is under the jurisdiction of ASTM Committee D32 on Catalysts and is the direct responsibility of Subcommittee D32.02 on Physical-Mechanical Properties.

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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.

3.1.3 *generated fines*—particle size after crushing that passes through a sieve one-half of the diameter of the catalyst pellet.

4. Summary of Test Method

4.1 A representative sample is placed in a cylindrical sample holder, which is fitted with a piston. The piston is allowed to compress the catalyst at a known pressure. The percent of generated fines is determined by sieving.

5. Significance and Use

5.1 This test method is a means of determining the crushing strength of a catalyst in a bed. Techniques to measure the crushing strength of formed catalyst particles is limited to crushing of individual particles, which may not be related to how the catalyst will crush in a reactor or bed. For some catalysts, such as granules, this technique may be the only viable method for obtaining crushing strength. The production of fines in a reactor is not desired because of the potential of bed compaction and the pressure buildup in the reactor.

6. Apparatus

6.1 *Hydraulic Press*, capable of 3200 lb (1450 kg) loading, including a force gage. Maximum load capacity of the press should match with the accuracy measuring the applied force.

NOTE 1—Lower maximum load may be acceptable for testing less strong materials.

6.2 *U.S. Standard Sieves*, set (Tyler Equivalent).

6.3 *Test Cell*, (Fig. 1).

NOTE 2—A top loading cell can be used, but reproducibility of this test is a function of the volume being crushed and therefore the constant volume cell, as shown in Fig. 1, is recommended. A smaller l/d ratio for the cell will alter the results, and for certain applications, it may be more desirable.^{3,4}

6.4 *Drying Oven*.

6.5 *Balance*, having a sensitivity of 0.1 g.

³ Bradley, S. A., Pitzer, E., and Koves, W. J., "Bulk Crush Testing of Catalysts," *Characterization and Catalyst Development*, ACS Symposium Series 411, Bradley, S. A., Gattuso, M. J., and Bertolacini, R. J., Eds., 1989, pp. 398–406.

⁴ Adams, A. R., Sartor, A. F., and Welsh, J. G., "Problems in Standardizing Catalyst Tests," *Chemical Engineering Progress*, Vol 71, 1975, pp. 35–37.