



Designation: ~~D4292~~ – ~~10~~ D4292 – 17

Standard Test Method for Determination of Vibrated Bulk Density of Calcined Petroleum Coke¹

This standard is issued under the fixed designation D4292; 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 density of a representative ~~2-kg~~ 2 kg sample of calcined petroleum coke, after vibration to increase compaction.

1.2 The procedure is limited to particles passing through a ~~6.68-mm~~ 6.68 mm opening sieve (equivalent to a ~~3-mesh Tyler Standard~~ 0.265 in. USA Series) and retained on a ~~0.21-mm~~ 0.21 mm opening sieve (equivalent to a ~~65-mesh Tyler Standard~~ 70 mesh USA Series). Further, the procedure is limited to a specific test sample having particles retained between screens having openings that differ by a factor of less than $2\sqrt{2}$ and preferably less than 2.

1.3 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

1.4 *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~~ safety, health, and health ~~environmental~~ environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

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](#)

[D5709 Test Method for Sieve Analysis of Petroleum Coke](#)

[D6969 Practice for Preparation of Calcined Petroleum Coke Samples for Analysis](#)

[D6970 Practice for Collection of Calcined Petroleum Coke Samples for Analysis](#)

[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 *as-calcined particles, n—of coke*, those particles that have not been subject to laboratory crushing.

3.1.2 *bulk density, n—of coke*, the ratio of the mass of a collection of particles of a specified particle size range to the volume occupied.

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

3.1.4 *laboratory crushed particles, n—of coke*, those particles of petroleum coke that have been crushed in the laboratory.

¹ This test method is under the jurisdiction of ASTM Committee [D02](#) on Petroleum ~~Products~~ Products, Liquid Fuels, 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.

*A Summary of Changes section appears at the end of this standard

4. Summary of Test Method

4.1 After appropriate crushing of the calcined coke, using both the jaw crusher and roll crusher, the test volume of 100 g is measured after vibration and the bulk density is calculated.

5. Significance and Use

5.1 Vibrated bulk density, VBD, is an indicator of calcined petroleum coke porosity, which affects its suitability for use in pitch-bonded carbon applications. (**Warning**—Vibrated bulk density for a sample of calcined petroleum coke is strongly dependent upon average particle size and particle size range. Bulk density tends to increase with decreasing coke size. A narrow particle size range for this test minimizes the possibility for variation due to skewing of the test sample toward either screen defining the sample. Particle size range tested should be agreed upon by the purchaser and supplier.)

NOTE 1—An example of the use of VBD to characterize coke for prebaked anodes for aluminum smelting is reported by Belitskus³ who found particles passing through a ~~0.59-mm~~ 0.59 mm opening, No. 30, sieve and retained on a ~~0.30-mm~~ 0.30 mm opening, No. 50, sieve to be preferred. Other popular ranges are particles passing through a ~~2.36-mm~~ 2.36 mm opening, No. 8, sieve and retained on a ~~1.17-mm~~ 1.17 mm opening, No. 16, sieve for the continuous Soderberg anode process and particles passing through a ~~6.68-mm~~ 6.68 mm opening sieve (equivalent to a ~~3-mesh Tyler Standard~~ 0.265 in. USA Series) and retained on a ~~3.33-mm~~ 3.33 mm opening, No. 6, sieve for graphite electrode manufacture.

6. Apparatus

6.1 *Jaw Crusher*, laboratory type; jaw opening, approximately ~~5050 mm~~ by ~~200-mm~~ 200 mm; jaws can be set to gaps of approximately ~~3-23.2 mm~~ to ~~12.7-mm~~ 12.7 mm; manganese steel jaw plates.

6.2 *Roll Crusher*, laboratory type; glass hardened rolls; roll diameter, approximately ~~200-mm~~ 200 mm; roll width, approximately ~~150-mm~~ 150 mm; gap range from ~~00 mm~~ to ~~12-712.7~~ mm, both rolls shall rotate to crush the material. Do not use a disc mill, disc type grinder, or disc pulverizer, since these contain one stationary roll. Prior to use, check and adjust the springs on the roll crusher according to the manufacturer's recommendation.

6.3 *Sieve Shaker*, electrical drive with an automatic timer; should have a rotating and tapping action.

6.4 *Sieves*—meeting Specification E11.

6.5 *Pan Balance*, accurate to ~~0.1 g~~, capacity ~~2.0 kg~~ 0.1 g, capacity ~~2.0 kg~~.

6.6 *Vibrator*⁴, with approximately ~~175-175 mm~~ by ~~250-mm~~ 250 mm deck, must be capable of vibrating at a frequency of ~~60 Hz~~ 60 Hz and an amplitude of ~~0.200.20 mm~~ to ~~0.22-mm~~ 0.22 mm (peak) when loaded with a ~~50-g~~ 50 g cork ring, ~~215-g~~ 215 g graduated cylinder, and a ~~100-g~~ 100 g coke sample.

6.7 *Ohmmeter*, adequate to test continuity of an electrical circuit.

6.8 *Cork Ring*, approximately ~~100-mm~~ 100 mm inside diameter by ~~25-mm~~ 25 mm high by ~~12-mm~~ 12 mm thick, weight approximately ~~50-g~~ 50 g (round-bottom flask support).

6.9 *Graduated Cylinder*, glass, ~~250-mL~~ 250 mL, inside diameter approximately ~~37-mm~~ 37 mm, base diameter approximately 95 mm.

6.10 *Plastic Funnel*, must have a stem with straight sides and an outside diameter of ~~2525 mm~~ to ~~30-mm~~ 30 mm (powder funnel).

6.11 *Automatic Timer, Clock, or Watch*, with a second indicator.

6.12 *Riffle Sampler*, enclosed drawer, approximately ~~380380 mm~~ by ~~290 by 360 mm~~ 290 mm by 360 mm, ~~24-slot~~ 290 mm by 360 mm, 24 slot.

6.13 *Feeler Gauges*, mm size for checking the gap settings on the roll crusher.

7. Precautions

7.1 Exercise care in the operation of the jaw crusher and roll crusher. Turn power off at the source when setting the gap. Wear safety glasses and keep hands clear when feeding material. Turn power off at the source when equipment is opened for cleaning after the grinding operation.

8. Sample Preparation

8.1 Use the crushing procedure in 8.2 and subsequent paragraphs so that contributions to VBD from both *as-calcined* and *laboratory-crushed* particles (which differ significantly in density) are included. Do not remove dedust oil from the sample prior to sample preparation or testing.

NOTE 2—Because the vibrated bulk density method is based on the packing of sized particles, the method of sample preparation can affect results due

³ Belitskus, D. L., "Evaluating Calcined Coke for Aluminum Smelting by Bulk Density," *Aluminium*, Vol 51, No. 2, 1975.

⁴ The calibration procedure described later is specific to a Syntron Model J-1A or J-1B Jogger (from FMC Corp., Material Handling Equipment Div., Homer City, PA). Statistical data were obtained using Model J-1A Joggers.

to differences in particle shapes affecting packing characteristics.

8.1.1 Air-dry the laboratory sample, if it appears to be wet, prior to crushing to avoid caking.

NOTE 3—On agreement by purchaser and supplier, density of only *as-calcined* particles in the selected size range are determined. If so, proceed to Section ~~H11~~ and report as part of the result that only *as-calcined* particles were used.

NOTE 4—Recommended practice for collecting samples and the equipment and procedures for dividing are described in Test Methods ~~D346, D2013, D2234/D2234M, and D4057~~ and Practices ~~D6969 and D6970~~.

8.2 *Jaw Crusher Operation*—Use the procedure appropriate to the jaw crusher being used, adjust the jaws so that the gap between them (at their closest position to each other in the crushing cycle) is approximately ~~5 mm~~ 5 mm. Turn on the jaw crusher motor, slowly feed the sample through the jaw crusher, and collect the product for further reduction through a roll crusher. In this step, the entire gross sample shall pass through the jaw crusher.

8.3 *Roll Crusher Operation*—(**Warning**—To avoid damage to the rolls, size reduction with the roll crusher must be limited to a maximum ratio of 4 to 1. Depending on the fraction desired, a one-step reduction is often not possible from the maximum particle size in the jaw crusher product and intermediate roll settings are used. The sample is reduced to the desired mesh size using as few intermediate settings as possible (but not exceeding the 4 to 1 reduction ratio).

8.3.1 With the motor deactivated, and using a method appropriate to the roll crusher being used, adjust the roll gap according to the following procedure. If the rolls are readily accessible, adjustment with a leaf-type feeler gage inserted between the rolls with the motor deactivated is useful.

8.3.2 Calculate the ratio of the maximum particle size of the roll crusher feed (expressed as the opening, in millimetres, of the finest screen through which the largest particles will pass) to the maximum particle size of the bulk density fraction required (expressed as the opening, in millimetres, of the coarser of the two screens used to define the bulk density fraction).

8.3.3 Select the number of crushing steps required from the following table:

Ratio	Number of Crushing Steps Required
1.1 to 4.0	1
4.1 to 16.0	2
16.1 to 64.0	3

8.3.4 For each crushing step required, the roll gap is decreased (from a value equivalent to the maximum particle size of the feed) by a factor of:

$$\sqrt[n]{\text{Ratio}} \text{ (as defined in 8.3.2)} \quad (1)$$

where:

n = number of crushing steps required (8.3.3)

8.3.5 For example, it is desired to reduce a coke having a maximum particle size of ~~6.68 mm~~ 6.68 mm to one having a maximum particle size of ~~0.208 mm~~ 0.208 mm. The calculation is as follows:

Ratio = 32.115 (see 8.3.2)

Crushing steps required = 3 (see 8.3.3)

Factor = $\sqrt[3]{32.115} = 3.179$ (see 8.3.4)

1st setting: $6.68 \text{ mm} \div 3.179 = 2.101 \text{ mm}$ ~~6.68 mm~~ $6.68 \text{ mm} \div 3.179 = 2.101 \text{ mm}$

2nd setting: $2.101 \text{ mm} \div 3.179 = 0.661 \text{ mm}$ ~~2.101 mm~~ $2.101 \text{ mm} \div 3.179 = 0.661 \text{ mm}$

3rd setting: $0.661 \text{ mm} \div 3.179 = 0.208 \text{ mm}$ ~~0.661 mm~~ $0.661 \text{ mm} \div 3.179 = 0.208 \text{ mm}$

8.3.6 After the roll gap is adjusted, remove the feeler gage (if used), turn on the roll crusher motor, slowly feed ~~0.3 kg~~ 0.3 kg of the jaw crusher product through the roll crusher, and collect the sample. When more than one roll crushing step is required, regrind through smaller openings the entire ~~0.3 kg~~ 0.3 kg sample, and collect the sample. Do not sieve the sample between crushing steps. Then, using the appropriate screens (those defining the bulk density fraction), sample receiver, and cover, sieve the roll-crushed sample in the sieve shaker for ~~15 min~~ 15 min, as required by Test Method ~~D5709~~, Table 3. With this final roll crusher setting, at least 30 % of the coke generally will be in the desired particle size range. A sieve shaker shall be used for the final sieving step to remove the undersize. Do not use other means of removing the undersize. Do not overload the screen as described in Test Method ~~D5709~~, subsection 9.5. Overloading a screen occurs when too much material is on a screen and prevents a particle from touching the screen and having the opportunity to pass through the screen. For a ~~200 mm~~ 200 mm diameter screen and calcined petroleum coke, the quantity is approximately ~~200 g~~ 200 g.

8.3.7 This setting will produce roughly equal weights of coke coarser and finer than the desired fraction, provided that the starting material is sufficiently coarse. If yield is at least 30 % and the ratio of coarser to finer product is between 0.8 and 2.0, crushing is satisfactory and the remainder of the material is fed through the roll crusher, using as many intermediate settings as required. The entire roll crusher product is consolidated and the desired fraction separated.

8.3.8 At the roll gap setting intended to maximize the final product, proceed as follows if the criteria in 8.3.7 are not met. If after one pass the ratio of coarser to finer-than-desired coke is greater than 2.0, decrease the roll gap to 80 % of its original value