11.19.2 Crushed Stone Processing and Pulverized Mineral Processing

11.19.2.1 Process Description [24, 25]

Crushed Stone Processing

Major rock types processed by the crushed stone industry include limestone, granite, dolomite, traprock, sandstone, quartz, and quartzite. Minor types include calcareous marl, marble, shell, and slate. Major mineral types processed by the pulverized minerals industry, a subset of the crushed stone processing industry, include calcium carbonate, talc, and barite. Industry classifications vary considerably and, in many cases, do not reflect actual geological definitions.

Rock and crushed stone products generally are loosened by drilling and blasting and then are loaded by power shovel or front-end loader into large haul trucks that transport the material to the processing operations. Techniques used for extraction vary with the nature and location of the deposit. Processing operations may include crushing, screening, size classification, material handling and storage operations. All of these processes can be significant sources of PM and PM-10 emissions if uncontrolled.

Quarried stone normally is delivered to the processing plant by truck and is dumped into a bin. A feeder is used as illustrated in Figure 11.19.2-1. The feeder or screens separate large boulders from finer rocks that do not require primary crushing, thus reducing the load to the primary crusher. Jaw, impactor, or gyratory crushers are usually used for initial reduction. The crusher product, normally 7.5 to 30 centimeters (3 to 12 inches) in diameter, and the grizzly throughs (undersize material) are discharged onto a belt conveyor and usually are conveyed to a surge pile for temporary storage or are sold as coarse aggregates.

The stone from the surge pile is conveyed to a vibrating inclined screen called the scalping screen. This unit separates oversized rock from the smaller stone. The undersized material from the scalping screen is considered to be a product stream and is transported to a storage pile and sold as base material. The stone that is too large to pass through the top deck of the scalping screen is processed in the secondary crusher. Cone crushers are commonly used for secondary crushing (although impact crushers are sometimes used), which typically reduces material to about 2.5 to 10 centimeters (1 to 4 inches). The material (throughs) from the second level of the screen bypasses the secondary crusher because it is sufficiently small for the last crushing step. The output from the secondary crusher and the throughs from the secondary screen are transported by conveyor to the tertiary circuit, which includes a sizing screen and a tertiary crusher.

Tertiary crushing is usually performed using cone crushers or other types of impactor crushers. Oversize material from the top deck of the sizing screen is fed to the tertiary crusher. The tertiary crusher output, which is typically about 0.50 to 2.5 centimeters (3/16th to 1 inch), is returned to the sizing screen. Various product streams with different size gradations are separated in the screening operation. The products are conveyed or trucked directly to finished product bins, to open area stock piles, or to other processing systems such as washing, air separators, and screens and classifiers (for the production of manufactured sand).

Some stone crushing plants produce manufactured sand. This is a small-sized rock product with a maximum size of 0.50 centimeters (3/16 th inch). Crushed stone from the tertiary sizing screen is sized in a vibrating inclined screen (fines screen) with relatively small mesh sizes.

Oversized material is processed in a cone crusher or a hammermill (fines crusher) adjusted to produce small diameter material. The output is returned to the fines screen for resizing.

In certain cases, stone washing is required to meet particulate end product specifications or demands.

Pulverized Mineral Processing

Pulverized minerals are produced at specialized processing plants. These plants supply mineral products ranging from sizes of approximately 1 micrometer to more than 75 micrometers aerodynamic diameter. Pharmaceutical, paint, plastics, pigment, rubber, and chemical industries use these products. Due to the specialized characteristics of the mineral products and the markets for these products, pulverized mineral processing plants have production rates that are less than 5% of the production capacities of conventional crushed stone plants. Two alternative processing systems for pulverized minerals are summarized in Figure 11-19.2-2.

In dry processing systems, the mineral aggregate material from conventional crushing and screening operations is subject to coarse and fine grinding primarily in roller mills and/or ball mills to reduce the material to the necessary product size range. A classifier is used to size the ground material and return oversized material that can be pulverized using either wet or dry processes. The classifier can either be associated with the grinding operation, or it can be a stand-alone process unit. Fabric filters control particulate matter emissions from the grinding operation and the classifier. The products are stored in silos and are shipped by truck or in bags.

In wet processing systems, the mineral aggregate material is processed in wet mode coarse and fine grinding operations. Beneficiation processes use flotation to separate mineral impurities. Finely ground material is concentrated and flash dried. Fabric filters are used to control particulate matter emissions from the flash dryer. The product is then stored in silos, bagged, and shipped.

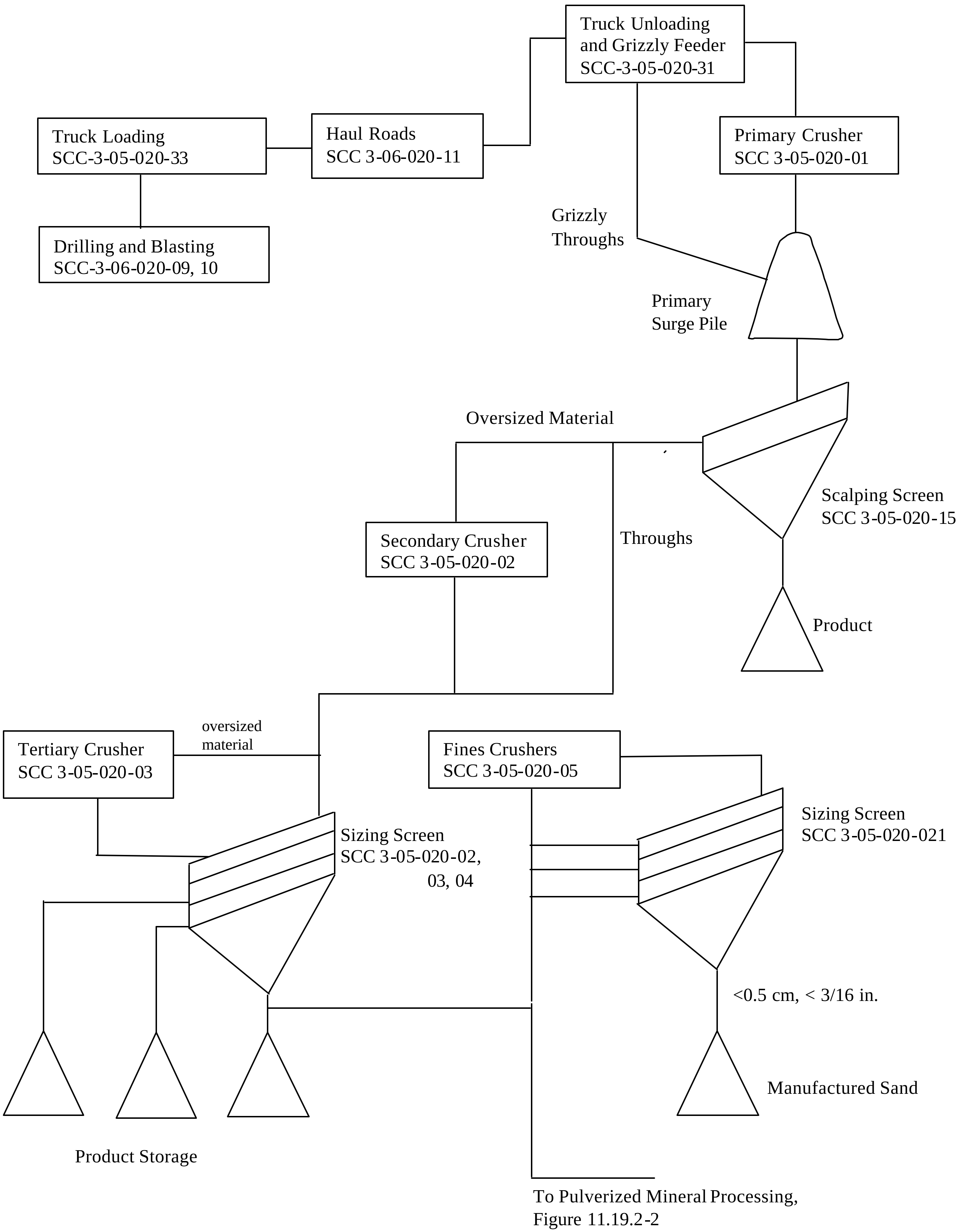

Figure 11.19.2-1. Typical stone processing plant

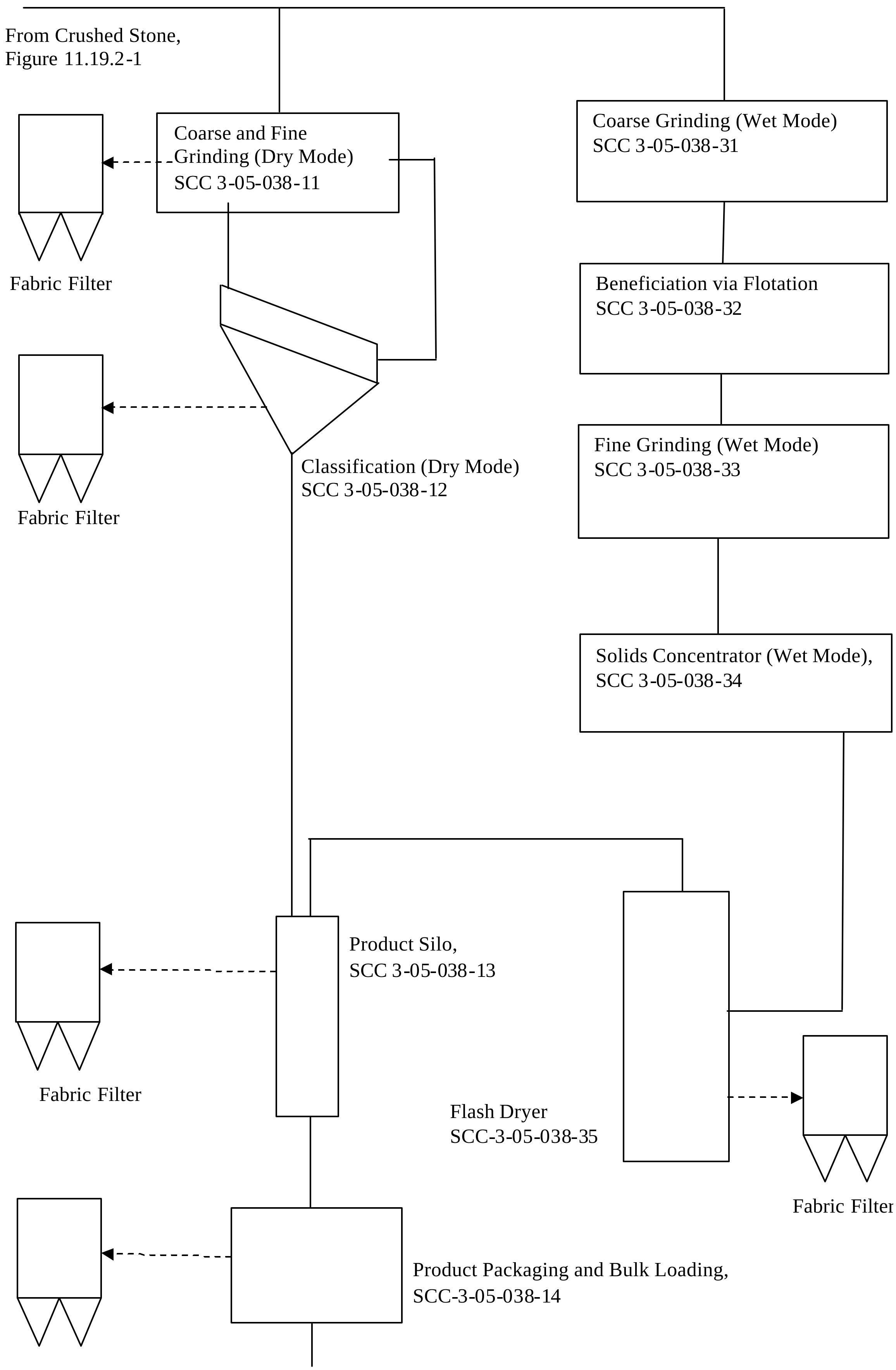

Figure 11.19.2-2 Flowchart for Pulverized Mineral Processing

11.19.2.2 Emissions and Controls [10, 11, 12, 13, 14, and 26]

Crushed Stone Processing

Emissions of PM, PM-10, and PM-2.5 occur from a number of operations in stone quarrying and processing. A substantial portion of these emissions consists of heavy particles that may settle out within the plant. As in other operations, crushed stone emission sources may be categorized as either process sources or fugitive dust sources. Process sources include those for which emissions are amenable to capture and subsequent control. Fugitive dust sources generally involve the reentrainment of settled dust by wind or machine movement. Emissions from process sources should be considered fugitive unless the sources are vented to a baghouse or are contained in an enclosure with a forced-air vent or stack. Factors affecting emissions from either source category include the stone size distribution and the surface moisture content of the stone processed, the process throughput rate, the type of equipment and operating practices used, and topographical and climatic factors.

Of graphical and seasonal factors, the primary variables affecting uncontrolled PM emissions are wind and material moisture content. Wind parameters vary with geographical location, season, and weather. It can be expected that the level of emissions from unenclosed sources (principally fugitive dust sources) will be greater during periods of high winds. The material moisture content also varies with geographical location, season, and weather. Therefore, the levels of uncontrolled emissions from both process emission sources and fugitive dust sources generally will be greater in arid regions of the country than in temperate ones and greater during the summer months because of a higher evaporation rate.

The moisture content of the material processed can have a substantial effect on emissions. This effect is evident throughout the processing operations. Surface wetness causes fine particles to agglomerate on or to adhere to the faces of larger stones, with a resulting dust suppression effect. However, as new fine particles are created by crushing and attrition and as the moisture content is reduced by evaporation, this suppressive effect diminishes and may disappear. Plants that use wet suppression systems (spray nozzles) to maintain relatively high material moisture contents can effectively control PM emissions throughout the process. Depending on the geographical and climatic conditions, the moisture content of mined rock can range from nearly zero to several percent. Because moisture content is usually expressed on a basis of overall weight percent, the actual moisture amount per unit area will vary with the size of the rock being handled. On a constant mass-fraction basis, the per-unit area moisture content varies inversely with the diameter of the rock. The suppressive effect of the moisture depends on both the absolute mass water content and the size of the rock product. Typically, wet material contains >1.5 percent water.

A variety of material, equipment, and operating factors can influence emissions from crushing. These factors include (1) stone type, (2) feed size and distribution, (3) moisture content, (4) throughput rate, (5) crusher type, (6) size reduction ratio, and (7) fines content. Insufficient data are available to present a matrix of rock crushing emission factors detailing the above classifications and variables. Available data indicate that PM-10 and PM-2.5 emissions from limestone and granite processing operations are similar. Therefore, the emission factors developed from the emissions data gathered at limestone and granite processing facilities are considered to be representative of typical crushed stone processing operations. Emission factors for filterable PM, PM-10, and PM-2.5 emissions from crushed stone processing operations are presented in Tables 11.19.2-1 (Metric units) and 11.19.2-2 (English units.)

Table 11.19.2-1 (Metric Units). EMISSION FACTORS FOR CRUSHED STONE PROCESSING OPERATIONS (kg/Mg)[a]

Source [b]	Total Particulate Matter [r,s]	EMISSION FACTOR RATING	Total PM-10	EMISSION FACTOR RATING	Total PM-2.5	EMISSION FACTOR RATING
Primary Crushing (SCC 3-05-020-01)	ND		ND[n]		ND[n]	
Primary Crushing (controlled) (SCC 3-05-020-01)	ND		ND[n]		ND[n]	
Secondary Crushing (SCC 3-05-020-02)	ND		ND[n]		ND[n]	
Secondary Crushing (controlled) (SCC 3-05-020-02)	ND		ND[n]		ND[n]	
Tertiary Crushing (SCC 3-050030-03)	0.0027[d]	E	0.0012[o]	C	ND[n]	
Tertiary Crushing (controlled) (SCC 3-05-020-03)	0.0006[d]	E	0.00027[p]	C	0.00005[q]	E
Fines Crushing (SCC 3-05-020-05)	0.0195[e]	E	0.0075[e]	E	ND	
Fines Crushing (controlled) (SCC 3-05-020-05)	0.0015[f]	E	0.0006[f]	E	0.000035[q]	E
Screening (SCC 3-05-020-02, 03)	0.0125[c]	E	0.0043[l]	C	ND	
Screening (controlled) (SCC 3-05-020-02, 03)	0.0011[d]	E	0.00037[m]	C	0.000025[q]	E
Fines Screening (SCC 3-05-020-21	0.15[g]	E	0.036[g]	E	ND	
Fines Screening (controlled) (SCC 3-05-020-21)	0.0018[g]	E	0.0011[g]	E	ND	
Conveyor Transfer Point (SCC 3-05-020-06)	0.0015[h]	E	0.00055[h]	D	ND	
Conveyor Transfer Point (controlled) (SCC 3-05-020-06)	0.00007[i]	E	2.3×10^{-5}[i]	D	6.5×10^{-6}[q]	E
Wet Drilling - Unfragmented Stone (SCC 3-05-020-10)	ND		4.0×10^{-5}[j]	E	ND	
Truck Unloading - Fragmented Stone (SCC 3-05-020-31)	ND		8.0×10^{-6}[j]	E	ND	
Truck Unloading - Conveyor, crushed stone (SCC 3-05-020-32)	ND		5.0×10^{-5}[k]	E	ND	

a. Emission factors represent uncontrolled emissions unless noted. Emission factors in kg/Mg of material throughput. SCC = Source Classification Code. ND = No data.

b. Controlled sources (with wet suppression) are those that are part of the processing plant that employs current wet suppression technology similar to the study group. The moisture content of the study group without wet suppression systems operating (uncontrolled) ranged from 0.21 to 1.3 percent, and the same facilities operating wet suppression systems (controlled) ranged from 0.55 to 2.88 percent. Due to carry over of the small amount of moisture required, it has been shown that each source, with the exception of crushers, does not need to employ direct water sprays. Although the moisture content was the only variable measured, other process features may have as much influence on emissions from a given source. Visual observations from each source under normal operating conditions are probably the best indicator of which emission factor is most appropriate. Plants that employ substandard control measures as indicated by visual observations should use the uncontrolled factor with appropriate control efficiency that best reflects the effectiveness of the controls employed.

c. References 1, 3, 7, and 8

d. References 3, 7, and 8

e. Reference 4

f. References 4 and 15

g. Reference 4

h. References 5 and 6

i. References 5, 6, and 15

j. Reference 11

k. Reference 12

l. References 1, 3, 7, and 8

m. References 1, 3, 7, 8, and 15

n. No data available, but emission factors for PM-10 for tertiary crushers can be used as an upper limit for primary or secondary crushing

o. References 2, 3, 7, 8

p. References 2, 3, 7, 8, and 15

q. Reference 15

r. PM emission factors are presented based on PM-100 data in the Background Support Document for Section 11.19.2

s. Emission factors for PM-30 and PM-50 are available in Figures 11.19.2-3 through 11.19.2-6.

Table 11.19.2-2 (English Units). EMISSION FACTORS FOR CRUSHED STONE PROCESSING OPERATIONS (lb/Ton)[a]

Source [b]	Total Particulate Matter [r,s]	EMISSION FACTOR RATING	Total PM-10	EMISSION FACTOR RATING	Total PM-2.5	EMISSION FACTOR RATING
Primary Crushing (SCC 3-05-020-01)	ND		ND[n]		ND[n]	
Primary Crushing (controlled) (SCC 3-05-020-01)	ND		ND[n]		ND[n]	
Secondary Crushing (SCC 3-05-020-02)	ND		ND[n]		ND[n]	
Secondary Crushing (controlled) (SCC 3-05-020-02)	ND		ND[n]		ND[n]	
Tertiary Crushing (SCC 3-050030-03)	0.0054[d]	E	0.0024[o]	C	ND[n]	
Tertiary Crushing (controlled) (SCC 3-05-020-03)	0.0012[d]	E	0.00054[p]	C	0.00010[q]	E
Fines Crushing (SCC 3-05-020-05)	0.0390[e]	E	0.0150[e]	E	ND	
Fines Crushing (controlled) (SCC 3-05-020-05)	0.0030[f]	E	0.0012[f]	E	0.000070[q]	E
Screening (SCC 3-05-020-02, 03)	0.025[c]	E	0.0087[l]	C	ND	
Screening (controlled) (SCC 3-05-020-02, 03)	0.0022[d]	E	0.00074[m]	C	0.000050[q]	E
Fines Screening (SCC 3-05-020-21)	0.30[g]	E	0.072[g]	E	ND	
Fines Screening (controlled) (SCC 3-05-020-21)	0.0036[g]	E	0.0022[g]	E	ND	
Conveyor Transfer Point (SCC 3-05-020-06)	0.0030[h]	E	0.00110[h]	D	ND	
Conveyor Transfer Point (controlled) (SCC 3-05-020-06)	0.00014[i]	E	4.6×10^{-5}[i]	D	1.3×10^{-5}[q]	E
Wet Drilling - Unfragmented Stone (SCC 3-05-020-10)	ND		8.0×10^{-5}[j]	E	ND	
Truck Unloading -Fragmented Stone (SCC 3-05-020-31)	ND		1.6×10^{-5}[j]	E	ND	
Truck Unloading - Conveyor, crushed stone (SCC 3-05-020-32)	ND		0.00010[k]	E	ND	

a. Emission factors represent uncontrolled emissions unless noted. Emission factors in lb/Ton of material of throughput. SCC = Source Classification Code. ND = No data.

b. Controlled sources (with wet suppression) are those that are part of the processing plant that employs current wet suppression technology similar to the study group. The moisture content of the study group without wet suppression systems operating (uncontrolled) ranged from 0.21 to 1.3 percent, and the same facilities operating wet suppression systems (controlled) ranged from 0.55 to 2.88 percent. Due to carry over of the small amount of moisture required, it has been shown that each source, with the exception of crushers, does not need to employ direct water sprays. Although the moisture content was the only variable measured, other process features may have as much influence on emissions from a given source. Visual observations from each source under normal operating conditions are probably the best indicator of which emission factor is most appropriate. Plants that employ substandard control measures as indicated by visual observations should use the uncontrolled factor with an appropriate control efficiency that best reflects the effectiveness of the controls employed.

c. References 1, 3, 7, and 8

d. References 3, 7, and 8

e. Reference 4

f. References 4 and 15

g. Reference 4

h. References 5 and 6

i. References 5, 6, and 15

j. Reference 11

k. Reference 12

l. References 1, 3, 7, and 8

m. References 1, 3, 7, 8, and 15

n. No data available, but emission factors for PM-10 for tertiary crushers can be used as an upper limit for primary or secondary crushing

o. References 2, 3, 7, 8

p. References 2, 3, 7, 8, and 15

q. Reference 15

r. PM emission factors are presented based on PM-100 data in the Background Support Document for Section 11.19.2

s. Emission factors for PM-30 and PM-50 are available in Figures 11.19.2-3 through 11.19.2-6.

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Emission factor estimates for stone quarry blasting operations are not presented because of the sparsity and unreliability of available tests. While a procedure for estimating blasting emissions is presented in Section 11.9, Western Surface Coal Mining, that procedure should not be applied to stone quarries because of dissimilarities in blasting techniques, material blasted, and size of blast areas. Emission factors for fugitive dust sources, including paved and unpaved roads, materials handling and transfer, and wind erosion of storage piles, can be determined using the predictive emission factor equations presented in AP-42 Section 13.2.

The data used in the preparation of the controlled PM calculations was derived from the individual A-rated tests for PM-2.5 and PM-10 summarized in the Background Support Document. For conveyor transfer points, the controlled PM value was derived from A-rated PM-2.5, PM-10, and PM data summarized in the Background Support Document.

The extrapolation line was drawn through the PM-2.5 value and the mean of the PM-10 values. PM emission factors were calculated for PM-30, PM-50, and PM-100. Each of these particle size limits is used by one or more regulatory agencies as the definition of total particulate matter. The graphical extrapolations used in calculating the emission factors are presented in Figures 11.19.2-3, -4, -5, and -6.

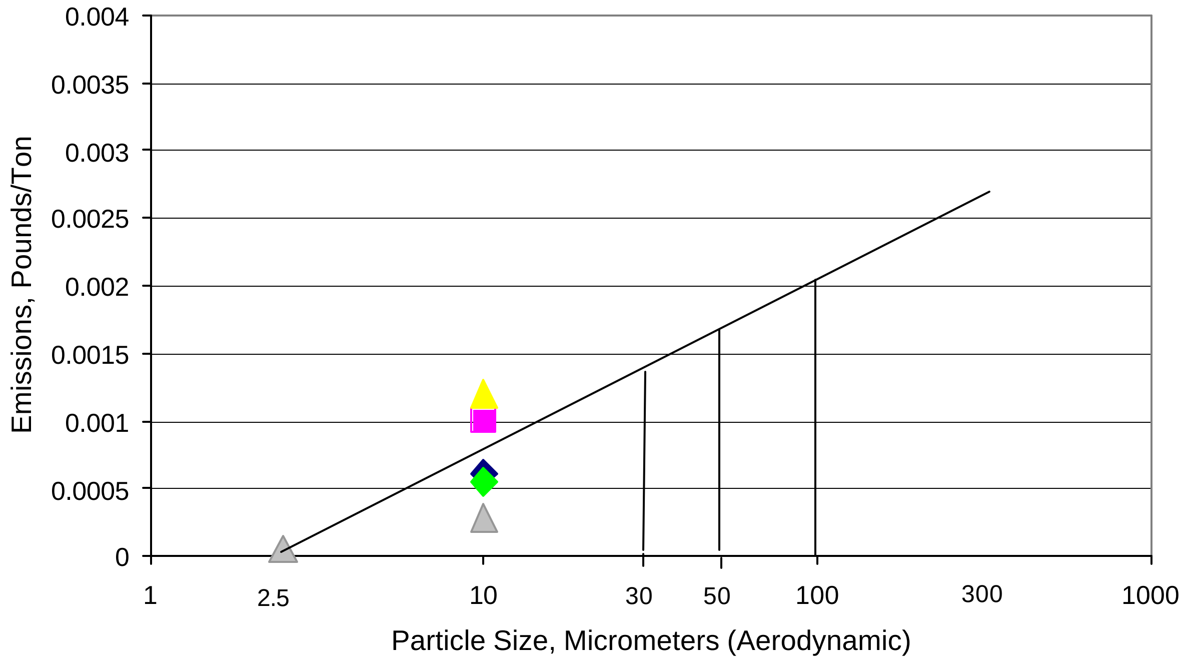

Figure 11-19-3. PM Emission Factor Calculation, Screening (Controlled)

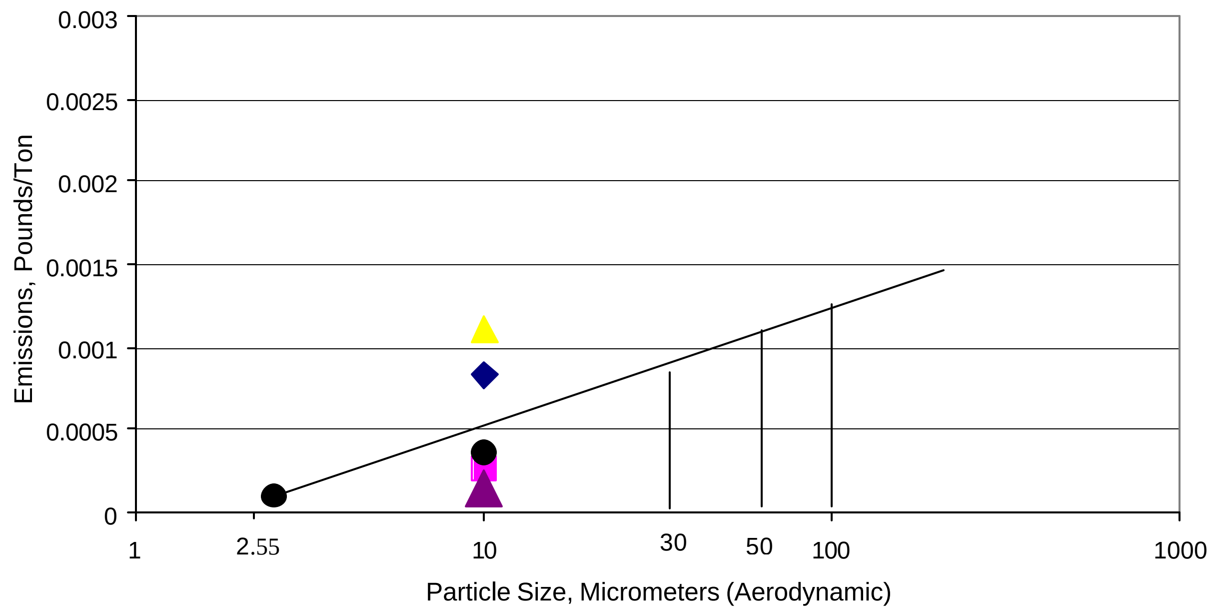

Figure 11.19-4. PM Emission Factor Calculation, Tertiary Crushing (Controlled)

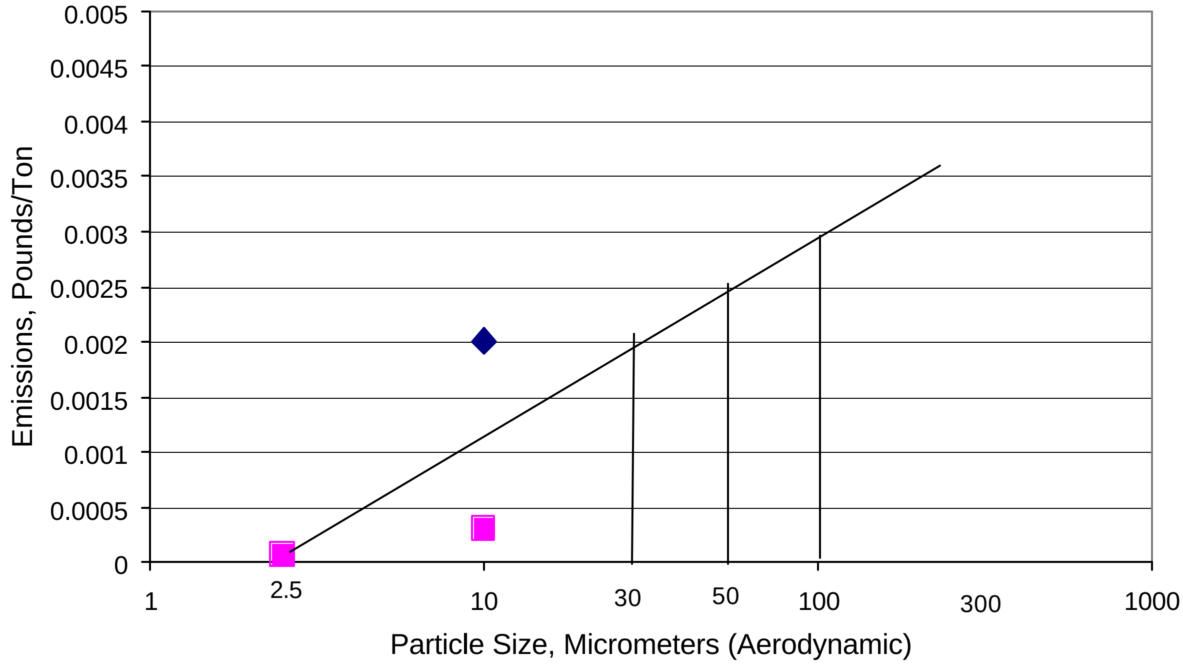

Figure 11-19.5. PM Emission Factor Calculation, Fines Crushing (Controlled)

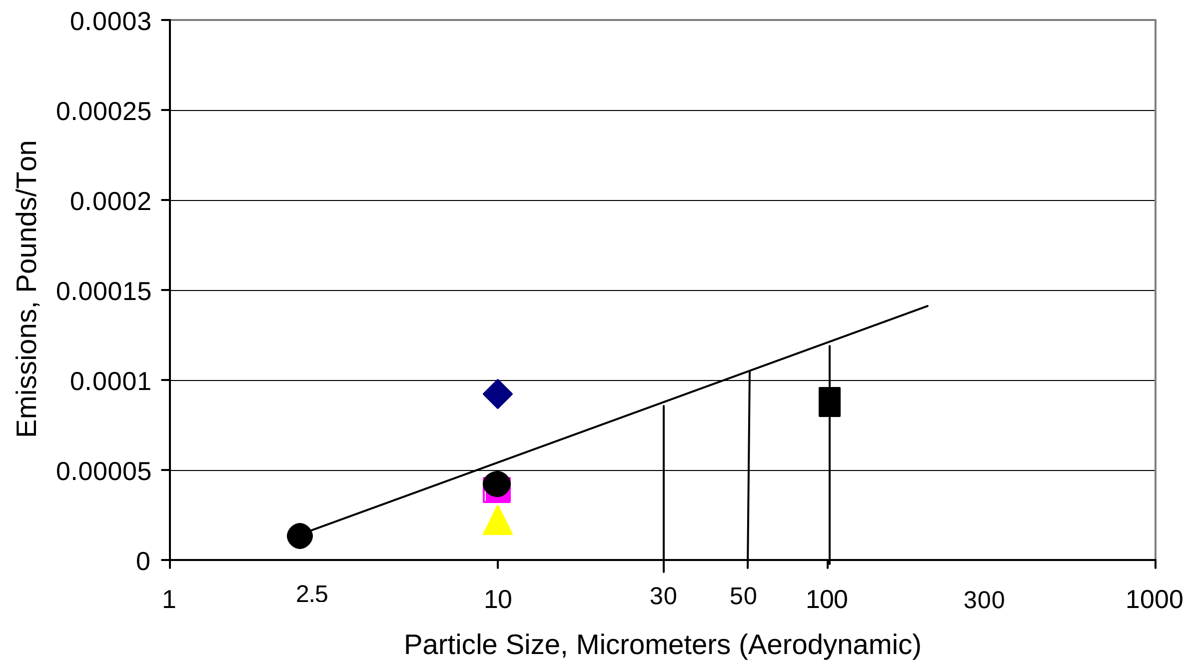

Figure 11.19-6. PM Emission Factor Calculation, Conveyor Transfer Points (Controlled)

The uncontrolled PM emission factors have been calculated from the controlled PM emission factors calculated in accordance with Figures 11.19.2-3 through 11.19.2-6. The PM-10 control efficiencies have been applied to the PM controlled emission factor data to calculate the uncontrolled PM emission rates.

Screening PM-10

Controlled = 0.00073 Lbs./Ton.

Uncontrolled = 0.00865 Lbs./Ton.

Efficiency = 91.6%

Tertiary Crushing PM-10

Controlled = 0.00054

Uncontrolled = 0.00243

Efficiency = 77.7%

Fines Crushing PM-10:

Controlled = 0.0012

Uncontrolled = 0.015

Efficiency = 92.0%

Conveyor Transfer Points PM-10

Controlled = 0.000045

Uncontrolled = 0.0011

Efficiency = 95.9%

The uncontrolled total particulate matter emission factor was calculated from the controlled total particulate matter using Equation 1:

$$\text{Uncontrolled emission factor} = \frac{\text{Controlled total particulate emission factor}}{(100\% - \text{PM-10 Efficiency }\%)/100\%} \qquad \text{Equation 1}$$

The Total PM emission factors calculated using Figures 11.19.2-3 through 11.19.2-6 were developed because (1) there are more A-rated test data supporting the calculated values and (2) the extrapolated values provide the flexibility for agencies and source operators to select the most appropriate definition for Total PM. All of the Total PM emission factors have been rated as E due to the limited test data and the need to estimate emission factors using extrapolations of the PM-2.5 and PM-10 data.

Pulverized Mineral Processing

Emissions of particulate matter from dry mode pulverized mineral processing operations are controlled by pulse jet and envelope type fabric filter systems. Due to the low-to-moderate gas temperatures generated by the processing equipment, conventional felted filter media are used. Collection efficiencies for fabric filter-controlled dry process equipment exceed 99.5%. Emission factors for pulverized mineral processing operations are presented in Tables 11.19.2-3 and 11.19.2-4.

Table 11.19.2-3 (Metric Units). EMISSION FACTORS FOR PULVERIZED MINERAL PROCESSING OPERATIONS [a]

Source [b]	Total Particulate Matter	EMISSION FACTOR RATING	Total PM-10	EMISSION FACTOR RATING	Total PM-2.5	EMISSION FACTOR RATING
Grinding (Dry) with Fabric Filter Control (SCC 3-05-038-11)	0.0202	D	0.0169	B	0.0060	B
Classifiers (Dry) with Fabric Filter Control (SCC 3-05-038-12)	0.0112	E	0.0052	E	0.0020	E
Flash Drying with Fabric Filter Control (SCC 3-05-038-35)	0.0134	C	0.0073	C	0.0042	C
Product Storage with Fabric Filter Control (SCC 3-05-38-13)	0.0055	E	0.0008	E	0.0003	E

a. Emission factors represent controlled emissions unless noted. Emission factors are in kg/Mg of material throughput.

b. Date from references 16 through 23

Table 11.19.2-4 (English Units). EMISSION FACTORS FOR PULVERIZED MINERAL PROCESSING OPERATIONS [a]

Source [b]	Total Particulate Matter	EMISSION FACTOR RATING	Total PM-10	EMISSION FACTOR RATING	Total PM-2.5	EMISSION FACTOR RATING
Grinding (Dry) with Fabric Filter Control (SCC 3-05-038-11)	0.0404	D	0.0339	B	0.0121	B
Classifiers (Dry) with Fabric Filter Control (SCC 3-05-038-12)	0.0225	E	0.0104	E	0.0041	E
Flash Drying with Fabric Filter Control (SCC 3-05-038-35)	0.0268	C	0.0146	C	0.0083	C
Product Storage with Fabric Filter Control (SCC 3-05-038-13)	0.0099	E	0.0016	E	0.0006	E

a. Emission factors represent controlled emissions unless noted. Emission factors are in lb/Ton of material throughput.

b. Data from references 16 through 23

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