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BSI Standards Publication

Hard coal and coke — Mechanical sampling

Part 5: Coke — Sampling from moving streams

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National foreword

This British Standard is the UK implementation of ISO 13909-5:2016. It supersedes BS ISO 13909-5:2001 which is withdrawn.

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Hard coal and coke — Mechanical sampling —

Part 5:
Coke — Sampling from moving streams

Houille et coke — Échantillonnage mécanique —

Partie 5: Coke — Échantillonnage en continu

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT), see the following URL: Foreword — Supplementary information.

The committee responsible for this document is ISO/TC 27, *Solid mineral fuels*, Subcommittee SC 4, *Sampling*.

This second edition cancels and replaces the first edition (ISO 13909-5:2001), which has been technically revised.

ISO 13909 consists of the following parts, under the general title *Hard coal and coke — Mechanical sampling*:

— *Part 1: General introduction*

— *Part 2: Coal — Sampling from moving streams*

— *Part 3: Coal — Sampling from stationary lots*

— *Part 4: Coal — Preparation of test samples*

— *Part 5: Coke — Sampling from moving streams*

— *Part 6: Coke — Preparation of test samples*

— *Part 7: Methods for determining the precision of sampling, sample preparation and testing*

— *Part 8: Methods of testing for bias*

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INTERNATIONAL STANDARD ISO 13909-5:2016(E)

Hard coal and coke — Mechanical sampling —

Part 5:
Coke — Sampling from moving streams

1 Scope

This part of ISO 13909 specifies procedures and requirements for the design and establishment of sampling schemes for the mechanical sampling of coke from moving streams and the methods of sampling used.

The diversity of types of equipment for sampling and the conditions under which mechanical sampling is performed make it inappropriate to specify standard designs for samplers which will be applicable to all situations.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 13909-1:2016, *Hard coal and coke — Mechanical sampling — Part 1: General introduction*

ISO 13909-6, *Hard coal and coke — Mechanical sampling — Part 6: Coke — Preparation of test samples*

ISO 13909-7, *Hard coal and coke — Mechanical sampling — Part 7: Methods for determining the precision of sampling, sample preparation and testing*

ISO 13909-8, *Hard coal and coke — Mechanical sampling — Part 8: Methods of testing for bias*

ISO 21398, *Hard coal and coke — Guidance to the inspection of mechanical sampling systems*

3 Terms and definitions

For the purposes of this part of ISO 13909, the terms and definitions given in ISO 13909-1 apply.

4 Establishing a sampling scheme

4.1 General

The general procedure for establishing a sampling scheme is as follows:

a) define the quality parameters to be determined and the types of samples required;

b) define the lot;

c) define the precision required;

d) determine the method of combining the increments into a sample, or number of sub-lot samples, and the method of sample preparation (see ISO 13909-6);

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e) determine or assume the variability of the coke (see 4.3.2) and the variance of preparation and testing (see 4.3.3). Methods for determining variability and the variance of preparation and testing are given in ISO 13909-7;

f) establish the number of sub-lots and the number of increments per sub-lot required to attain the desired precision (see 4.3.4);

g) define the sampling interval (see Clause 5);

h) ascertain the nominal top size of the coke for the purpose of determining the minimum mass of sample (see 4.4 and Table 1);

NOTE The nominal top size may initially be ascertained by consulting the consignment details, or by visual estimation, and may be verified, if necessary, by preliminary test work.

i) determine the minimum average increment mass (see 4.5).

4.2 Design of the sampling scheme

4.2.1 Material to be sampled

The first stage in the design of the scheme is to identify the cokes to be sampled. Samples may be required for technical evaluation, process control, quality control, and for commercial reasons by both the producer and the customer. It is essential to ascertain exactly at what stage in the coke-handling process the sample is required and, as far as practicable, design the scheme accordingly.

4.2.2 Parameters to be determined on samples

The samples for moisture and physical tests may be collected separately or as one sample, which is then divided. In this part of ISO 13909, a sample which is collected for the determination of moisture (and possibly also for general analysis) is referred to as the moisture sample; a sample which is collected for physical tests only is referred to as the physical sample. If a sample is used for the determination of moisture and for physical tests, it is referred to as a common sample.

In mechanical sampling of coke, the only sample which can, in certain circumstances (see 4.2.6), be processed automatically beyond the divided-increment stage is the moisture sample.

In order to achieve the desired precision, it may be necessary to take different numbers of increments for the moisture and physical samples. Where a common sample is taken, the greater number of increments shall be used.

4.2.3 Division of lots

A lot may be sampled as a whole or as a series of sub-lots, e.g. coke despatched or delivered over a period of time, a ship load, a train load, a wagon load, or coke produced in a certain period, e.g. a shift.

It may be necessary to divide a lot into a number of sub-lots in order to improve the precision of the results.

For lots sampled over long periods, it may be expedient to divide the lot into a series of sub-lots, obtaining a sample for each.

4.2.4 Basis of sampling

Sampling may be carried out on either a time-basis or a mass-basis.

In time-basis sampling, increments are taken at fixed time intervals with an increment mass, collected with a fixed speed cutter, which is proportional to the flow rate at the time of extraction.

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In mass-basis sampling, increments are taken at fixed mass intervals, using a belt weigher/mass integrator, and fixed mass increments are extracted using a variable speed cutter or sample preparation system which produces a fixed mass divided increment.

The conditions under which mass-basis sampling may seem to offer the advantage of consistent increment mass, for example highly variable flow rates, are those in which it is most difficult to implement in practice.

Time-basis sampling is by far the simplest to implement and is the basis of this part of ISO 13909.

4.2.5 Precision of sampling

The required precision for a lot for each parameter to be measured shall be decided. The number of sub-lots and minimum number of increments per sub-lot collected shall then be determined as described in 4.3.4, and the average mass of primary increments shall be determined as described in 4.5.

For single lots, the quality variation shall be assumed as the worst case (see 4.3.2). The precision of sampling achieved may be measured using the procedure of replicate sampling (see ISO 13909-7).

At the start of regular sampling of unknown cokes, the worst-case quality variation shall be assumed. When sampling is in operation, a check shall be carried out to confirm that the desired precision has been achieved using the procedure of duplicate sampling as described in ISO 13909-7.

If any subsequent change in precision is required, the number of sub-lots and increments shall be changed as determined in 4.3.4 and the precision attained shall be rechecked. The precision shall also be checked if there is any reason to suppose that the variability of the coke being sampled has increased. The number of increments determined in 4.3.4 applies to the precision of the result when the sampling errors are large relative to the testing errors, e.g. moisture content. However, in some tests, e.g. Micum Index, the testing errors are themselves large. In this case, it may be necessary to prepare two or more test portions from the same sample (see 4.3.4.3) and use the mean of the determinations to give a better precision.

4.2.6 Bias of sampling

It is of particular importance in sampling to ensure, as far as possible, that the parameter to be measured is not altered by the sampling and sample preparation process or by subsequent storage prior to testing. For example, care shall be taken to avoid breakage of coke intended for physical testing and loss of moisture from the moisture sample during storage. This may require, in some circumstances, a limit on the minimum mass of primary increment (see 4.5 and Clause 8).

When collecting samples for moisture determination from lots over an extended period, it may be necessary to limit the standing time of samples by dividing the lot into a number of sub-lots (see 4.3.4).

The use of on-line crushing and division of the moisture sample for moisture determination should be treated with caution because of the risk of bias caused by loss of moisture in the processing (see 6.2.2). In particular, the crushing of hot coke is not recommended. If the bias is unacceptable, the sample shall be left in the uncrushed state and the sample preparation carried out by manual methods. It should be accepted, however, that some bias is inevitable, whether due to breakage or loss of moisture from hot coke. The object, therefore, shall be to restrict such degradation or moisture loss to a minimum.

When a coke-sampling scheme is implemented, it shall be checked for bias in accordance with the methods given in ISO 13909-8.

4.3 Precision of results

4.3.1 Precision and total variance

In all methods of sampling, sample preparation and analysis, errors are incurred and the experimental results obtained from such methods for any given parameter will deviate from the true value of that

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