

# CONTENTS

## GREEN RIVER OIL SHALE

	Page
PREAMBLE . . . . .	3
DEFINITIONS . . . . .	3
<b>CLASSIFICATION OF OIL SHALE</b> . . . . .	3
LOCATION, GEOLOGY, AND RESERVES OF GREEN <b>RIVER</b> FORMATION OIL SHALE . . . . .	5
LOCATION . . . . .	5
GEOLOGY OF THE GREEN RIVER FORMATION . . . . .	5
Recent Publications on the Geology of the Green River Formation . . . . .	7
KNOWN RESERVES OF OIL SHALE IN THE GREEN RIVER FORMATION . . . . .	7
PHYSICAL PROPERTIES OF GREEN RIVER OIL SHALE . . . . .	9
VISUAL FEATURES . . . . .	9
<b>SPECIFIC GRAVITY</b> . . . . .	9
Specific Gravity vs. Oil Yield . . . . .	9
Specific Gravity vs. Unit Weight vs. Unit Volume . . . . .	10
Specific Gravity vs. Tons <b>Shale/Acre-Foot</b> vs. Barrels <b>Oil/Acre-Foot</b> , vs. Gallons <b>Oil/Cubic Foot</b> . . . . .	10
Specific Gravity vs. Weight (In Place) vs. Weight (Broken) . . . . .	10
<b>COMPRESSIVE STRENGTH, HARDNESS, AND ELASTIC CONSTANTS</b> . . . . .	17
<b>Elastic</b> Properties—Young's Modulus and Poisson's Ratio . . . . .	17
Compressive Strength . . . . .	17
<b>ROCK MECHANICS RELATING TO ROOM-AND-PILLAR UNDERGROUND MINING OF OIL SHALE</b> . . . . .	17
<b>CRUSHING CHARACTERISTICS OF OIL SHALE</b> . . . . .	20
Characteristics of Mine-Run Shale . . . . .	20
Characteristics of the Product From a Blake-Type Jaw Crusher . . . . .	20
Characteristics of the Product From a Gyratory Crusher . . . . .	21
Characteristics of the Product From a Hammermill Crusher . . . . .	21
Characteristics of the Product From a Toothed-Roll Crusher . . . . .	21
<b>SHEAR STRENGTH</b> . . . . .	21
<b>POROSITY AND PERMEABILITY OF GREEN RIVER OIL SHALE</b> . . . . .	22
<b>PARTICLE SIZE OF INORGANIC MINERAL CONSTITUENTS</b> . . . . .	23
<b>VOID SPACE OF CRUSHED SHALE</b> . . . . .	23
<b>WEATHERING CHARACTERISTICS OF GREEN <b>RIVER</b> OIL SHALE</b> . . . . .	26
<b>ELECTRICAL RESISTIVITY OF OIL SHALE</b> . . . . .	27
<b>THERMAL PROPERTIES OF GREEN RIVER OIL SHALE</b> . . . . .	29
<b>SPECIFIC HEAT</b> . . . . .	29
<b>HEAT CONTENT</b> . . . . .	29
<b>CALORIFIC VALUE</b> . . . . .	30
Gross Heating Values of Oil Shale of Various Grades . . . . .	30
<b>DISTRIBUTION OF GROSS HEATING VALUES IN FISCHER ASSAY PRODUCTS</b> . . . . .	30
<b>THERMAL CONDUCTIVITY</b> . . . . .	31
<b>HEAT OF RETORTING OF OIL SHALE</b> . . . . .	31
<b>CARBONATE DECOMPOSITION PROBLEMS</b> . . . . .	33
<b>THERMAL REACTIONS DETECTABLE BY DTA AND TGA METHODS</b> . . . . .	34
<b>PERMEABILITY CHANGES OF BROKEN OIL SHALE DURING RETORTING</b> . . . . .	34
<b>CHEMICAL PROPERTIES OF GREEN RIVER OIL SHALE</b> . . . . .	37

CONTENTS (Continued)

	Page
THE MODIFIED FISCHER ASSAY . . . . .	37
Fischer Assay Procedure . . . . .	37
Data Obtainable From the Modified Fischer Assay . . . . .	37
Properties of Fischer Assay Products . . . . .	37
TRACE ELEMENTS IN OIL SHALE . . . . .	37
FIELD MOISTURE CONTENT OF OIL SHALE . . . . .	39
SULFUR AND NITROGEN—DISTRIBUTION IN SHALE AND IN ASSAY PRODUCTS . . . . .	39
MINERALOGICAL COMPOSITION OF OIL SHALE . . . . .	39
SODIUM SALTS IN GREEN RIVER OIL SHALE . . . . .	43
GREEN RIVER SHALE—A MINERAL STOREHOUSE . . . . .	43
DEFINITION OF SALINE MINERALS . . . . .	43
RESERVES OF SALINE MINERALS OF INTEREST . . . . .	43
PROCESSING OF OIL SHALE CONTAINING SALINE MINERALS . . . . .	44
DECOMPOSITION OF SALINE CARBONATES AT RETORTING TEMPERATURES . . . . .	45
Thermal Decomposition of Dawsonite . . . . .	45
Thermal Decomposition of Shortite . . . . .	45
Thermal Decomposition of Nahcolite . . . . .	45
Thermal Decomposition of Trona . . . . .	45
Thermal Decomposition of Gaylussite . . . . .	45
ADDITIONAL REFERENCES ON SALINE MINERALS IN OIL SHALE . . . . .	45
PROPERTIES OF THE ORGANIC MATTER (KEROGEN) IN GREEN RIVER OIL SHALE . . . . .	47
KEROGEN . . . . .	47
VISUAL FEATURES OF KEROGEN . . . . .	47
ULTIMATE COMPOSITION OF KEROGEN . . . . .	47
CHEMICAL FORMULA AND MOLECULAR WEIGHT OF KEROGEN . . . . .	47
GROSS HEATING VALUE OF PURE KEROGEN . . . . .	47
COMPOSITIONAL VARIATIONS IN KEROGEN vs. DEPTH OF BURIAL . . . . .	47
SPECIFIC GRAVITY . . . . .	48
CARBON/HYDROGEN RATIO IN KEROGEN AND IN OTHER FUELS . . . . .	48
ORGANIC-INORGANIC PARTICLE BONDING . . . . .	48
ORGANIC MATTER CONTENT VERSUS SHALE GRADE . . . . .	48
SPECIFIC HEAT . . . . .	49
DECOMPOSITION BY APPLICATION OF HEAT . . . . .	49
Products of Pyrolysis . . . . .	49
SPECIFIC REACTION RATES . . . . .	49
SOLVENT EXTRACTION OF KEROGEN . . . . .	50
WATER-SOLUBLE ORGANIC MATTER IN CERTAIN TRONA BRINES . . . . .	51
RETORTING PROCESSES . . . . .	53
TYPES OF RETORTING PROCESSES: DIRECT-HEATED AND INDIRECT-HEATED . . . . .	53
OBJECTIVES OF AN OIL SHALE RETORTING PROCESS . . . . .	53
EFFECT OF PRESSURE AND ATMOSPHERE ON RETORTING . . . . .	53
EFFECT OF PARTICLE SIZE ON RETORTING . . . . .	54
EFFECT OF TEMPERATURE ON RETORTING . . . . .	54
EFFECT OF SHALE GRADE ON RETORTING . . . . .	54
KINETICS OF OIL SHALE PYROLYSIS . . . . .	56
YIELD OF GAS, OIL, AND BITUMEN vs. TIME, AS KEROGEN IS DECOMPOSED BY HEAT . . . . .	57
THE N-T-U RETORTING PROCESS . . . . .	59
PROCESS FLOWSHEET . . . . .	59

CONTENTS (Continued)

	Page
PROCESS DESCRIPTION . . . . .	59
PROCESS EVALUATION . . . . .	59
RECENT DEVELOPMENTS . . . . .	59
THE GAS COMBUSTION RETORTING PROCESS . . . . .	59
EVOLUTION OF THE GAS COMBUSTION PROCESS . . . . .	61
GENERAL DESCRIPTION OF THE GAS COMBUSTION PROCESS . . . . .	62
PROCESS FLOWSHEET . . . . .	63
PROCESS DETAILS . . . . .	63
OPERATING CONDITIONS AND PERFORMANCE DATA . . . . .	64
INDUSTRY CONSORTIUM EXAMINED GAS COMBUSTION RETORTING DURING 1964-1967 . . . . .	66
STATUS OF GAS COMBUSTION RETORTING TECHNOLOGY . . . . .	66
THE HYDROTORTING PROCESS . . . . .	68
PROCESS DEVELOPMENT HISTORY . . . . .	68
PROCESS FLOWSHEET . . . . .	68
PROCESS DESCRIPTION . . . . .	68
PRODUCT PROPERTIES . . . . .	69
MATERIAL BALANCE . . . . .	69
OPERATING CONDITIONS . . . . .	69
STATUS OF THE TECHNOLOGY OF THE HYDROTORTING PROCESS . . . . .	69
THE UNION OIL RETORTING PROCESS . . . . .	70
PROCESS FLOWSHEET . . . . .	70
PROCESS DESCRIPTION . . . . .	70
OPERATING CONDITIONS AND PRODUCT YIELDS . . . . .	72
Product Properties . . . . .	72
Material and Heat Balances . . . . .	72
THE " S GR VARIATION OF THE UNION OIL PROCESS . . . . .	72
LONG-TIME DISPOSAL OF UNION SPENT SHALE . . . . .	73
THE TOSCO II RETORTING PROCESS . . . . .	75
DEVELOPMENT HISTORY . . . . .	76
PROCESS FLOWSHEET . . . . .	76
PROCESS DESCRIPTION . . . . .	76
Separation of Spent Shale and Ceramic Balls . . . . .	76
HEAT AND MATERIAL BALANCES— OIL PRODUCT CHARACTERISTICS . . . . .	77
SPENT SHALE FROM THE TOSCO II RETORTING PROCESS . . . . .	77
Physical Properties . . . . .	77
Particle Size . . . . .	78
Chemical Analysis . . . . .	78
Soluble Salts in TOSCO II Spent Shale . . . . .	78
Salinity, pH, Conductivity and Plant Nutrients . . . . .	79
Bulk Density of Dry Spent Shale Solids . . . . .	79
Water Wetting and Water Penetration . . . . .	79
STATUS OF TOSCO TECHNOLOGY . . . . .	79
THE LURGI-RUHRGAS PROCESS . . . . .	80
PROCESS FLOWSHEET . . . . .	80
HEAT AND MATERIAL BALANCES . . . . .	80
STATUS OF THE L-R RETORTING PROCESS . . . . .	81
THE ROHRBACH-LURGI PROCESS . . . . .	81
THEPETROSIXRETORTINGPROCESS . . . . .	82

CONTENTS (Continued)

	Page
PROCESS DETAILS . . . . .	82
PROCESS FLOWSHEET . . . . .	83
HEAT <b>BALANCE/MATERIAL BALANCE/PRODUCT INFORMATION</b> . . . . .	83
STATUS OF PETROSIX RETORTING PROCESS TECHNOLOGY . . . . .	84
DEMONSTRATION FACILITY . . . . .	84
THE PARAHO RETORTING PROJECT . . . . .	84
PROPERTIES OF GREEN RIVER SHALE OIL AND SHALE OIL COKE . . . . .	87
DEFINITIONS . . . . .	87
PROPERTIES OF FISCHER ASSAY SHALE OIL . . . . .	87
Physical Properties . . . . .	87
Specific Gravity of Assay <b>Oil</b> . . . . .	88
Chemical Properties . . . . .	88
PROPERTIES OF SHALE OILS FROM VARIOUS PILOT PLANTS . . . . .	88
SHALE OIL COKE . . . . .	90
THE PROPERTIES OF SPENT SHALE . . . . .	91
PROPERTIES OF SPENT SHALE FROM THE FISCHER ASSAY . . . . .	91
Chemical Analyses . . . . .	91
Gross Heating Value . . . . .	92
Specific Heat . . . . .	92
Heat Content . . . . .	93
Thermal Conductivity . . . . .	93
Compressive Strength . . . . .	93
Fusion Point and Chemical Composition of Spent <b>Shale</b> Ash . . . . .	93
PROPERTIES OF SPENT SHALE FROM N-T-U PROCESS RETORTING . . . . .	94
PROPERTIES OF SPENT SHALE FROM GAS COMBUSTION RETORTING . . . . .	95
Fischer Assay, Mineral <b>CO<sub>2</sub></b> , Organic Carbon, and Ignition Loss . . . . .	95
Bulk Density, Specific Gravity, Permeability, and Particle Size . . . . .	96
Salinity and Fertility . . . . .	%
PROPERTIES OF SPENT SHALE FROM TOSCO <b>II</b> PROCESS RETORTING . . . . .	96
<b>Bulk</b> Density, Specific Gravity, Permeability, Particle Size . . . . .	96
<b>Salinity</b> and Fertility . . . . .	96
Water Wetting and Water Penetration . . . . .	96
Compaction . . . . .	97
Soluble Salts in TOSCO <b>II</b> Spent Shale . . . . .	97
Chemical Analysis . . . . .	97
PROPERTIES OF SPENT SHALE FROM UNION OIL RETORTING PROCESS . . . . .	97
Chemical Analyses . . . . .	97
Density, Permeability and Particle Size . . . . .	98
DISPOSAL AND USES OF SPENT SHALE ASH . . . . .	98
Studies by Denver Research Institute . . . . .	98
Studies by Colony <b>Development</b> Operation . . . . .	99
COMBUSTION OF SPENT SHALE . . . . .	99
MISCELLANEOUS INVESTIGATIONS IN SPENT SHALE . . . . .	99
PROPERTIES OF RETORT WATER . . . . .	101
ORIGIN AND AMOUNT OF RETORT WATER . . . . .	<b>101</b>
USBM Study of Retort Water . . . . .	<b>101</b>
Phenols and Organic Acids in Retort Water . . . . .	101
CHEMICAL CHARACTERISTICS . . . . .	I02

## CONTENTS (Continued)

	Page
PROPERTIES OF RETORT GASES . . . . .	103
CHARACTERISTICS AND YIELDS . . . . .	103
IN SITU RETORTING OF OIL SHALE . . . . .	105
GENERAL CONSIDERATIONS . . . . .	105
SHALE PROPERTIES IMPORTANT TO IN SITU RETORTING . . . . .	105
CHANGES IN ROCK CHARACTERISTICS DUE TO RETORTING . . . . .	105
FIELD EXPERIMENTS <b>WITH</b> IN SITU RETORTING OF OIL SHALE . . . . .	<b>106</b>
USBM Work . . . . .	<b>106</b>
<b>Sinclair</b> Oil & Gas Company Experiments . . . . .	106
Equity Oil Company Experiments . . . . .	107
PROPOSED NUCLEAR IN SITU OIL SHALE PROJECTS . . . . .	108
Project Bronco . . . . .	108
Operation Utah . . . . .	<b>110</b>
STATUS OF IN SITU RETORTING TECHNOLOGY . . . . .	110
GASIFICATION OF OIL SHALE . . . . .	111
THE IGT OIL SHALE HYDROGASIFICATION PROCESS . . . . .	111
STATUS OF THE IGT SHALE GASIFICATION PROCESS . . . . .	111

## **U.S. COAL**

PREAMBLE . . . . .	115
THE ORIGIN OF COAL . . . . .	117
THE ACCUMULATION OF COAL SOURCE MATERIALS . . . . .	117
THE COALIFICATION PROCESS . . . . .	117
THE CLASSIFICATION OF COAL . . . . .	119
THE ASTM CLASSIFICATION OF COAL BY RANK . . . . .	119
Symbols for Expressing Classification . . . . .	119
Calculations Necessary for Coal Classification . . . . .	119
CLASSIFICATION OF COALS BY PETROGRAPHIC PARAMETERS . . . . .	121
COAL PETROGRAPHY . . . . .	123
LITHOLOGIC CLASSES OF COAL . . . . .	123
COMPONENTS OF COAL CLASSES . . . . .	123
MACERALS. THE "ORGANIC MINERALS" OF COAL . . . . .	123
THE <b>USBM/THIESSEN</b> METHOD OF EXPRESSING COAL COMPOSITION . . . . .	124
SPACKMAN'S CLASSIFICATION RELATES MACERALS TO REFLECTANCE . . . . .	125
APPLICATION OF COAL PETROGRAPHY TO COAL CONVERSION . . . . .	125
THE PHYSICAL PROPERTIES OF COAL . . . . .	127
SPECIFIC GRAVITY . . . . .	127
WEIGHT. IN PLACE . . . . .	127
WEIGHT. BROKEN . . . . .	<b>127</b>
Typical Values . . . . .	128
GRINDABILITY . . . . .	128
ASTM Hardgrove Machine Method . . . . .	128
Typical Grindability Indexes of American <b>Coals</b> . . . . .	128
FRIABILITY . . . . .	128
Drop Shatter Test for Impact Toughness . . . . .	128
Tumbler Test . . . . .	128
COMPRESSIVE STRENGTH . . . . .	129

CONTENTS (Continued)

	Page
INDEX OF DUSTINESS . . . . .	130
ELECTRICAL RESISTIVITY . . . . .	130
CLEATS (OR JOINTS) IN COAL . . . . .	131
ADSORPTION CHARACTERISTICS OF COALS . . . . .	132
THE THERMAL PROPERTIES OF COAL . . . . .	133
SPECIFIC HEAT . . . . .	133
HEAT CONTENT . . . . .	133
FREE-SWELLING INDEX . . . . .	133
ASTM Test for Free-Swelling Index . . . . .	133
USBM Small-Scale Test for Free-Swelling Index . . . . .	134
Typical Values . . . . .	134
PLASTIC AND AGGLUTINATING PROPERTIES . . . . .	134
CALOFUFIC VALUE . . . . .	134
Gross Calorific Value (Gross Heat of Combustion) . . . . .	134
Net Calorific Value (Net Heat of Combustion) . . . . .	135
Standard Test for Gross Calorific Value . . . . .	135
Typical Values . . . . .	135
THERMAL CONDUCTIVITY . . . . .	137
INFLUENCE OF MINERALS ON THE HEAT OF COMBUSTION OF COAL . . . . .	138
DIFFERENTIAL THERMAL ANALYSIS OF COAL . . . . .	138
THE CHEMICAL PROPERTIES OF COAL . . . . .	139
COAL SAMPLING FOR CHEMICAL ANALYSIS . . . . .	139
Collection of a Gross Sample (ASTM Designation D-2234-72) . . . . .	139
Preparing Coal Samples for Analysis (ASTM D-2013-72) . . . . .	139
Laboratory Sampling (ASTM D-271-70) . . . . .	140
THE PROXIMATE ANALYSIS OF COAL . . . . .	140
THE ULTIMATE ANALYSIS OF COAL . . . . .	140
MOISTURE IN COAL . . . . .	140
Inherent Moisture . . . . .	140
Surface Moisture . . . . .	140
Hydration Water (Water of Mineral Matter) . . . . .	140
Decomposition Moisture . . . . .	140
Other Terms Relating to Moisture . . . . .	140
MOISTURE DETERMINATION FOR THE PROXIMATE ANALYSIS . . . . .	141
MOISTURE DETERMINATION FOR CLASSIFICATION OF COAL BY RANK . . . . .	141
VOLATILE MATTER IN COAL . . . . .	141
Test Method for Volatile Matter . . . . .	141
Typical Values for Volatile Matter Content . . . . .	141
FIXED CARBON . . . . .	141
Test Method for Fixed Carbon . . . . .	141
Typical Values for Fixed Carbon . . . . .	141
MINERAL MATTER IN U.S. COALS . . . . .	142
Typical Values for Mineral Matter Content . . . . .	142
SULFUR IN COAL . . . . .	142
Typical Values for Sulfur in Coal . . . . .	143
PHOSPHORUS, CHLORINE, SODIUM, AND POTASSIUM IN U.S. COALS . . . . .	143
TRACE ELEMENTS IN U.S. COALS . . . . .	144
Volatile Trace Elements in Coal . . . . .	144

CONTENTS (Continued)

	Page
Mercury in U.S. Coals . . . . .	145
ASH IN COAL . . . . .	147
ASH DETERMINATION FOR THE PROXIMATE ANALYSIS . . . . .	147
MAJOR ASH CONSTITUENTS IN U.S. COALS . . . . .	147
TYPICAL CHEMICAL ANALYSIS OF ASH FROM U.S. COALS . . . . .	147
Trace Elements in Coal Ash . . . . .	147
VARIATIONS IN ASH COMPOSITIONS WITH RANK . . . . .	148
TEST FOR SULFUR IN ASH . . . . .	148
FUSIBILITY OF COAL ASH . . . . .	148
ELECTRICAL RESISTIVITY OF FLY ASH . . . . .	149
COAL PYROLYSIS . . . . .	151
DEFINITIONS/GENERAL DISCUSSION . . . . .	151
PRODUCTS OF THE FISCHER ASSAY OF VARIOUS COALS . . . . .	151
LABORATORY CARBONIZATION OF COALS . . . . .	152
The Carbonization Assay (USBM Method) . . . . .	152
CORRELATION OF COAL ANALYSIS WITH CARBONIZATION YIELD . . . . .	154
RELATION BETWEEN REFLECTANCE AND VOLATILE MATTER, CALORIFIC VALUE, OIL YIELD, AND GAS YIELD . . . . .	155
COAL PARTICLE SIZE . . . . .	155
REACTIVITY . . . . .	155
FREE SWELLING INDEX . . . . .	155
COAL GASIFICATION . . . . .	161
GENERAL FLOWSHEET FOR ALL COAL GASIFICATION PROCESSES . . . . .	161
CHARACTERISTIC STEPS IN COAL GASIFICATION PROCESSES . . . . .	161
PRETREATMENT OF COAL . . . . .	162
PRIMARY GASIFICATION . . . . .	162
SECONDARY GASIFICATION . . . . .	162
SHIFT REACTION (SHIFT CONVERSION) . . . . .	162
METHANATION . . . . .	162
The Heat-Removal Problem . . . . .	162
Tube Wall Reactor Catalyst System . . . . .	163
Hot Gas Recycle Catalyst System . . . . .	163
Fluidized Bed Catalyst System . . . . .	163
Catalyst Poisoning Problems . . . . .	163
Methanation Catalyst Materials . . . . .	163
Liquid Phase Methanation . . . . .	163
The Conoco Methanation Company Project . . . . .	163
THE CHEMISTRY OF COAL GASIFICATION . . . . .	163
Basic Chemical Formulas . . . . .	163
Heat of Reaction of Gasification Reactions . . . . .	164
Critical Constants and Heating Values of Common Compounds . . . . .	165
CHEMICAL EQUILIBRIUM IN GASIFICATION REACTIONS . . . . .	165
Typical Equilibrium Constants for Gasification Reactions . . . . .	166
THE EFFECT OF PRESSURE ON GAS COMPOSITION . . . . .	166
OPTIMIZATION OF COAL GASIFICATION PROCESSES . . . . .	167
GASIFICATION PROCESSES INVESTIGATED PRIOR TO 1965 . . . . .	175
GASIFICATION PROCESSES CURRENTLY UNDER INVESTIGATION FOR POSSIBLE APPLICATION IN THE U.S.A. . . . .	177

## CONTENTS (Continued)

	Page
THE ATGAS PROCESS . . . . .	177
ATGAS PROCESS FLOWSHEET . . . . .	177
PROCESS DETAILS . . . . .	177
STATUS OF ATGAS PROCESS DEVELOPMENT . . . . .	179
THE BI-GAS PROCESS . . . . .	179
GENERAL DESCRIPTION OF THE BI-GAS PROCESS . . . . .	179
DESCRIPTION OF THE 5-TON/HOUR PLANT AT HOMER CITY . . . . .	179
MATERIAL BALANCE . . . . .	183
METHANATION OF BI-GAS SYNTHESIS GAS . . . . .	183
THE COED PROCESS . . . . .	183
PROCESS DEVELOPMENT HISTORY . . . . .	184
RESULTS OF BENCH-SCALE TESTING EXAMINED . . . . .	184
PROCESS DEVELOPMENT UNIT TEST RESULTS EXAMINED . . . . .	184
Quality of Products From the Process Development Unit . . . . .	187
PILOT PLANT OF 36 TPD CAPACITY COMPLETED IN 1970 . . . . .	187
COED Pilot Plant Flowsheets . . . . .	188
Typical Pilot Plant Results—Colorado High Volatile B Bituminous Coal . . . . .	188
FILTRATION OF COED OIL DEMONSTRATED AT PILOT PLANT SCALE . . . . .	189
Hydrotreating of COED Pilot Plant Oil . . . . .	189
STATUS OF PROJECT COED . . . . .	189
THE COGAS PROJECT . . . . .	190
COGAS Process Flowsheet . . . . .	190
STATUS OF THE COGAS PROCESS . . . . .	190
THE CO <sub>2</sub> ACCEPTOR PROCESS . . . . .	190
PROCESS DEVELOPMENT HISTORY . . . . .	193
PROCESS FLOWSHEET . . . . .	193
HEAT AND MATERIAL BALANCES . . . . .	193
PROCESS DETAILS . . . . .	193
STATUS OF THE CO <sub>2</sub> , ACCEPTOR PROCESS . . . . .	196
THE HYDRANE PROCESS . . . . .	196
HYDRANE PROCESS FLOWSHEET . . . . .	196
HYDRANE PROCESS DESCRIPTION . . . . .	197
MATERIALS AND HEAT BALANCES . . . . .	197
STATUS OF DEVELOPMENT . . . . .	197
THE HYGAS PROCESS . . . . .	197
HYGAS PROCESS FLOWSHEET . . . . .	198
PROCESS DESCRIPTION . . . . .	198
Coal Pretreatment . . . . .	198
Hydrogasification . . . . .	198
UTILIZATION OF THE CHAR PRODUCT . . . . .	199
Electrothermal Process for Char Gasification . . . . .	199
Steam-Oxygen Process for Char Gasification . . . . .	200
Steam-Iron Process for Char Gasification . . . . .	200
STATUS OF THE HYGAS PROCESS . . . . .	201
THE KELLOGG MOLTEN SALT PROCESS . . . . .	201
PROCESS FLOWSHEETS . . . . .	201
STATUS OF THE MOLTEN SALT PROCESS . . . . .	202
THE KOPPERS-TOTSEK PROCESS . . . . .	202



CONTENTS (Continued)

	Page
PROCESS FLOWSHEET . . . . .	205
PROCESS CONDITIONS . . . . .	205
K-T GASIFIER DATA FOR U.S. COALS . . . . .	206
THE LURGI PROCESS . . . . .	206
PROCESS FLOWSHEET: PROPOSED <b>BURNHAM</b> PLANT AS EXAMPLE . . . . .	207
PROCESS DETAILS: <b>BURNHAM</b> PLANT AS EXAMPLE . . . . .	207
OXYGEN SUPPLY . . . . .	209
BY-PRODUCTS . . . . .	209
MATERIAL BALANCE . . . . .	209
COAL GASIFICATION . . . . .	209
PROCESS EFFICIENCY . . . . .	209
WATER REQUIREMENTS . . . . .	209
STATUS OF LURGI DRY ASH COAL GASIFICATION PROCESS . . . . .	209
THE SYNTHANE PROCESS . . . . .	209
PROCESS FLOWSHEET . . . . .	210
PROCESS DETAILS . . . . .	210
STATUS OF SYNTHANE PROCESS DEVELOPMENT . . . . .	212
THE UNION CARBIDE PROCESS (Also known as the Union Carbide/Battelle or the Union Carbide/Chemico Process) . . . . .	213
PROCESS FLOWSHEET . . . . .	213
STATUS OF THE UNION CARBIDE PROCESS . . . . .	213
THE WINKLER PROCESS . . . . .	214
COAL LIQUEFACTION . . . . .	215
THE COED PROCESS . . . . .	215
THE H-COAL PROCESS . . . . .	215
PROCESS FLOWSHEET AND MATERIAL BALANCE . . . . .	215
PROCESS DESCRIPTION . . . . .	221
Coal Feed Preparation . . . . .	221
Coal Hydrogenation . . . . .	221
PROCESS VARIABLES TESTED . . . . .	221
SOLIDS REMOVED FROM HYDROGENATED COAL LIQUIDS BY MAGNETIC SEPARATION . . . . .	221
STATUS OF THE H-COAL PROCESS . . . . .	222
Recent References to the H-Coal Process . . . . .	222
PROJECT GASOLINE . . . . .	222
PROCESS FLOWSHEET . . . . .	222
PROCESS DESCRIPTION. 20 TPD PILOT PLANT . . . . .	222
STATUS OF PROJECT GASOLINE . . . . .	223
THE SOLVENT REFINED COAL PROCESS . . . . .	223
DETAILED DESCRIPTION OF THE SRC PROCESS . . . . .	224
STATUS OF DEVELOPMENT OF THE SRC PROCESS . . . . .	226
ADDITIONAL REFERENCES TO SRC PROCESSING . . . . .	226
THE SYNTHOIL PROCESS . . . . .	228
PYROLYSIS PROCESSES . . . . .	228
THE TOSCOAL PROCESS . . . . .	228
THE GARRETT PROCESS . . . . .	228
LIQUID HYDROCARBON SYNTHESIS . . . . .	229
FISCHER-TROPSCH REDUCTION OF CARBON MONOXIDE . . . . .	229
METHANOL SYNTHESIS FROM COAL . . . . .	229

CONTENTS (Continued)

	Page
COAL CHAR . . . . .	231
COMBUSTION OF PULVERIZED CHAR . . . . .	231
FLUIDIZATION PROPERTIES OF COAL CHAR . . . . .	231

**ALBERTA OIL SANDS**

PREAMBLE . . . . .	235
LOCATION AND OWNERSHIP OF ALBERTA OIL SANDS . . . . .	237
LOCATION OF ALBERTA OIL SANDS . . . . .	237
OWNERSHIP OF OIL SANDS MINERAL RIGHTS . . . . .	237
Policies of the Provincial and Federal Governments . . . . .	237
GEOLOGY AND RESERVES . . . . .	253
GEOLOGY . . . . .	253
RESERVES . . . . .	254
RESERVE ESTIMATES . . . . .	256
THE PHYSICAL PROPERTIES OF ALBERTA OIL SANDS . . . . .	257
VISUAL FEATURES . . . . .	257
VOID VOLUME . . . . .	257
DENSITY, POROSITY, PERMEABILITY, SPECIFIC HEAT, AND THERMAL CONDUCTIVITY . . . . .	257
BITUMEN SATURATION . . . . .	257
BITUMEN-WATER-FINES RELATIONSHIP . . . . .	257
DENSITIES OF WATER-SAND-BITUMEN MIXTURES . . . . .	257
HEAT CAPACITIES OF WATER-SAND-BITUMEN MIXTURES . . . . .	258
PROPERTIES OF INORGANIC MINERALS IN OIL SANDS . . . . .	258
THE PROPERTIES OF BITUMEN IN ALBERTA OIL SANDS . . . . .	265
INSPECTION DATA . . . . .	265
VISCOSITY OF BITUMEN . . . . .	265
DENSITY OF BITUMEN . . . . .	266
PROPERTIES OF SYNTHETIC CRUDE OIL FROM ALBERTA OIL SANDS . . . . .	267
THE PROPERTIES OF COKE MADE FROM ALBERTA OIL SANDS . . . . .	269
IN SITU PROCESSES FOR THE RECOVERY OF VALUES FROM ALBERTA OIL SANDS . . . . .	271
FORWARD COMBUSTION AND REVERSE COMBUSTION . . . . .	271
COMBINATION OF FORWARD COMBUSTION AND WATER FLOOD PROCESSES . . . . .	271
SHELL CANADA'S EMULSION-STEAM DRIVE PROCESS . . . . .	274
NUCLEAR IN SITU PROPOSAL . . . . .	275
CONVENTIONAL ABOVE-GROUND MINING AND PROCESSING SCHEMES FOR ALBERTA OIL SANDS . . . . .	277
EXISTING AND PROPOSED COMMERCIAL VENTURES . . . . .	277
DEVELOPMENT SCHEDULE FOR PROPOSED OIL SANDS PLANTS . . . . .	277
GREAT CANADIAN OIL SANDS, LIMITED . . . . .	277
Plant Flowsheet . . . . .	277
Overburden Removal and Oil Sands Mining . . . . .	277
Bitumen Separation . . . . .	279
Bitumen Froth Cleanup . . . . .	283
Bitumen Coking . . . . .	283
Syncrude Manufacture . . . . .	283
SYNCRUDE CANADA, LIMITED . . . . .	283
Mining System . . . . .	283

CONTENTS (Continued)

	Page
Bitumen Separation and Recovery . . . . .	284
Bitumen Upgrading—Fluid Coking . . . . .	284
Secondary Upgrading . . . . .	284
Synthetic Crude Oil Properties . . . . .	284
Flowsheet and Material and Energy Balance . . . . .	284
<b>THE SHELL CANADA PROJECT . . . . .</b>	<b>286</b>
Mining System . . . . .	286
Hot Water Extraction . . . . .	287
Bitumen Upgrading . . . . .	287
Properties of the Synthetic Crude . . . . .	288
Tankage and Pipeline Transport . . . . .	289
Process Energy, Sulphur, and Material Balances . . . . .	289
<b>THE ATHABASCA OIL SANDS PROJECT (AOP) . . . . .</b>	<b>290</b>
Oil Sands Mining . . . . .	291
Bitumen Separation . . . . .	291
Bitumen Upgrading . . . . .	291
Project Status . . . . .	291
<b>THE HOME OIL/ALMINEX PROJECT . . . . .</b>	<b>291</b>
Oil Sands Mining . . . . .	293
Bitumen Extraction . . . . .	295
Bitumen Upgrading . . . . .	295
Properties of the Synthetic Crude . . . . .	296
Material Balances . . . . .	296
<b>REFERENCES AND BIBLIOGRAPHY . . . . .</b>	<b>301</b>
<b>APPENDIX . . . . .</b>	<b>309</b>
Part I. Coal Conversion Processes Investigated Prior to <b>1965</b>	
Part II, Method of Assaying Oil Shale by a Modified Fischer Retort (Revision of Report of Investigations Number <b>3977</b> )	