



Proceedings of
XVI BALKAN MINERAL PROCESSING CONGRESS
Belgrade, Serbia, June 17-19, 2015



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**XVI BALKAN MINERAL
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I

VOLUME I

Edited by

Nadežda Čalić, Ljubiša Andrić,
Igor Miljanović, Ivana Simović



MINING INSTITUTE BELGRADE

ACADEMY OF ENGINEERING SCIENCES OF SERBIA

UNIVERSITY OF BELGRADE

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2015

XVI BALKAN MINERAL PROCESSING CONGRESS
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Foreword

Practically, all human societies depend on the availability and use of mined products. Mining and mineral processing has played a vital part in the history and economy of the Balkans.

In the world, mineral processing was an art till the 1920s, when it started to become a science. The achievements of fundamental science enabled the explanation of phenomena in the processes of mineral processing, or they started from fundamental science to come to an appropriate solution in mineral processing. In many respects mineral processing becomes fundamental science.

Balkan countries have more or less rapidly accepted innovations in the field of mining and mineral processing.

Generations of professionals from Balkan trained on the tradition of mining schools, afterward universities, (Schemnitz established 1702, Jachimov 1716, Banska Štiavnica 1725, Jekatarinburg 1730, L' Ecole Polytechnique 1794 in Paris, Politehnika in Prague, and certainly the most famous Bergakademie Freiberg founded in 1765, and much later, universities in the United States and Soviet Union) contributed to today's level of development of mineral processing, and contributed to the quality of studies of mineral processing, both in the world, and so in the Balkans.

After the Second World War in the Balkans a large number of universities, faculty, institutes and laboratories of mining industry with special departments for mineral processing were opened. In many Balkan countries remarkable impact on development of mineral processing had Russian and American schools.

A great number of researchers and specialists in Balkan area were occupied for more decades by the research in mineral processing. The goal of this research was establishment of concentration process in industry, capacity enlargement, optimization of processes, increase the energy efficiency of processes and devices, introduction or construction of new machines. Based on those activities, Balkan mining has been evolving and continuously operates up to nowadays. As a result, in the Balkan countries appeared a significant number of successful researchers in the field of mineral processing. They founded the first Balkan mineral processing Committee (1973), and then the Balkan Academy of Mineral Technology.

Balkan Congress on Mineral Processing is beening held for 40 years. Participation in the work of the Committee of the Balkan mineral processing is a strong link between the development of the science and profession with global trends, and it provides the possibility of establishing direct contacts between researchers, designers, equipment manufacturers and investors from the region and around the world. It has already become tradition to hold every second year an international event, "Balkan Mineral Processing Congress," in which participate, not only Balkan experts, than experts from the whole world.

Maintenance XVI Balkan Congress on Mineral Processing in Belgrade from 16 to 21 June 2015 is held under the auspices of the Ministry of Mines and Energy of Serbia, with the financial assistance of the Ministry of Republic of Serbia. Incomparably greater financial support Congress had from sponsors who strongly support the mineral processing industry all over the world.



Prof. dr Nadežda Čalić

The XVI BMPC Chair

VOLUME I

PLENARY

Nadežda Čalić, A BRIEF LOOK ON THE LONG HISTORY OF METALIC ORES PROCESSING IN THE BALKANS	21
S. Komar Kawatra, SUSTAINABILITY IN MINERAL PROCESSING PLANTS	29
Valentine A. Chanturiya, Igor Zh. Bunin, Maria Ryazantseva and Irina Khabarova USE OF HIGH – POWER ELECTROMAGNETIC PULSES (HPEMP) FOR THE MODIFICATION OF THE SULPHIDES SURFACE.	37
James L. Hendrix, OVERVIEW OF TREATING GOLD ORES CONTAINING LOW-GRADE COPPER VALUES	45
Miloljub Grbović, Svetislav Radivojević, Ljutica Košutić, Dušan Salatić, COPPER MINE MAJDANPEK 60 YEARS LATER – IS IT HOW WE IMAGINED IT?	53

MATERIAL ANALYSIS AND MINERAL CHARACTERIZATION

Dean David, THE EFFECT OF METALLURGICAL SAMPLE COMPOSITING ON THE MEASUREMENT OF OREBODY VARIABILITY	59
Tomasz Niedoba, Agnieszka Surowiak, Dariusz Jamróz, METHODS OF DETERMINING CRUCIAL PROPERTIES TO IDENTIFY THE TYPE OF COAL.	69
G. Demirci, M. Taksuk, GENERAL CHARACTERIZATION OF TUNÇBILEK COALS, TURKEY	75
Merve Yüksel, H. Semih Demircan, Emre Erkan, Sercan Sevgül, ANALYSING THE REFRACTORINESS OF KAYMAZ GOLD ORE BY DIAGNOSTIC LEACHING	79
Mashukov A. V., Mashukova A. E., Bistryakova S. A., VARIATIONS OF THE COPPER CONTENT IN THE ORES OF NORILSK TYPE.	83
Andreas Iordanidis, Javier Garcia-Guinea, Konstantinos Gudulas, CHARACTERIZATION OF THE LINING MORTAR OF A CISTERN FROM THE ANCIENT MINING AND METALLURGICAL SITE OF LAVRION, GREECE	87
Milorad Grujic, Blagoje Spaskovski, Masan Grujic, Zoran Markovic, CHARACTERIZATION OF PORPHIRY COPPER ORE FROM NORTH REVIR ZONE TS2 MAJDANPEK.	93
Deniz Talan, Ümit Atalay, N. Emre Altun, CHARACTERIZATION OF KAYSERI-DEVELI PB-ZN OXIDE ORE	99
Mira Milić, RESULTS OF RIVER AGGREGATE BANJA LUKA REGION FOR PRODUCTION OF CONCRETE.	103
Özen Kılıç, EFFECTS OF PHYSICAL PROPERTIES TO THERMAL DECOMPOSITION OF DOLOMITES	109
Martin Griesdorn, NEW POSSIBILITIES TO INFLUENCE PELLET PROPERTIES BY PHOTO-OPTICAL PARTICLE ANALYSES	115

COMMUNITION AND CLASSIFICATION

Alex Jankovic, Walter Valery, ADVANCES IN ORE COMMUNITION PRACTICE OVER THE LAST 25 YEARS.	123
Biröl Sönmez, Renato Oliveira, Alex Jankovic, Walter Valery, Murat Us, METSO HRC™-ENERGY-EFFICIENT COMMUNITION TECHNOLOGY.	131
M. Ranchev, V. Kovacheva, I. Grigorova, I. Nishkov, D. Mochev, D. Nikolov, A. Angelov, T. Pukov, TECHNOLOGICAL PARAMETER ANALYSIS IN THE SECONDARY-TERTIARY CRUSHING STAGE IN ASSAREL CONCENTRATOR	139
M. Ranchev, I. Grigorova, V. Kovacheva, D. Mochev, I. Nishkov, D. Nikolov, A. Angelov, T. Pukov, GRINDING IN ASSAREL CONCENTRATOR – IMPROVEMENT WAYS.	147
M. Ranchev, I. Grigorova, V. Kovacheva, D. Mochev, I. Nishkov, D. Nikolov, A. Angelov, T. Pukov IMPROVEMENT POSSIBILITIES OF DISINTEGRATION PROCESS IN ASSAREL CONCENTRATOR.	153
Yakup Umucu, Vedat Deniz, Osman Mart, Abdi Kemal Yüce, COMPARISON OF GRINDING EFFICIENCY BETWEEN BALL MILLS AND VERTICAL ROLLER MILLS AND COARSE GRINDING	161

D.Katircioğlu Bayel, Ö.Y.Toraman, INFLUENCE OF GRINDING AID ON THE BREAKAGE PROCESS OF CALCIUM CARBONATE IN A VERTICAL STIRRED BALL MILL	165
Ahmad Hassanzadeh, INCREASING PRIMARY GRINDING CIRCUIT EFFICIENCY CONSIDERING GRINDING CAPACITY ENHANCEMENT	171
Zhivko Iliev, Ivailo Bogdanov, Nikolay Ivanov, ANALYSIS OF THE VIBRATION STATE OF THE ECCENTRIC SHAFT WITH THE BEARINGS OF A COMPLEX PENDULUM JAW CRUSHER.	179
G.I. Gazaleeva, N.V. Shikhov, A.A. Mushketov, APPLICATION OF SPECIAL METHODS OF DISINTEGRATION FOR DRESSING OF ORES AND NONMETALLIC RAW MATERIALS .	185
Lubomir Kuzev, COMPARATIVE STUDY OF GRINDABILITY IN STANDART BOND BALL MILL WITH TWO GRINDING MEDIA – BALLS AND TETRABALLPEBS.	191
Çetin Hoşten, Hande Mertyürek, A GRAPHICAL ASSESSMENT OF THE EFFECT OF FEED SIZE DISTRIBUTION ON PARTICLE-BED COMMUNUTION IN PISTON-DIE PRESS	197
Malyshev V.P., Zubrina Y.S., Makasheva A.M., Fedorovich J.A., ENTROPY OF MATERIAL GRINDING IN BALL MILLS	203
Nedeljko Magdalinović, Milan Trumić, Srđana Magdalinović, Maja Trumić, THE KINETICS OF GRINDING IN THE INDUSTRIAL ROD MILL	207
Rasskazova A.V., D.E. Alexandrova T.N., INFLUENCE OF MECHANOACTIVATION OF FILLING COMPOUND ON THE STRENGTH OF COAL BRIQUETTE	211

PHYSICAL CONCENTRATION METHODS

Vladislav Ivanchenko, Yuri, Chugunov, Alla Ivanchenko, MINERALOGY AND DRY CONCENTRATION OF THE ORES OF HEMATITE AND GOETHITE	219
Ali Güney*, Firat Burat, Murat Olgaç Kangal, IMPROVEMENT OF CHROMITE CONCENTRATE HAVING HIGH OLIVINE CONTENT	223
Sándor Nagy, József Faitli, Imre Gombkötő, Barnabás Csőke, Tamás Magyar, Jakab Csaba MECHANICAL PREPARATION METHODS FOR LCD PANELS ORIGINATED FROM USED TVS AND MONITORS.	229
Feridun Boylu, Ufuk Aykaç , Caner Yiğitoğlu, Firat Karakaş and Mehmet S. Çeli, INVESTIGATION OF D_p CONTROLLED DISCHARGING SYSTEM ON BENEFICIATION OF COALS THROUGH PNEUMATIC JIGS.	237
Yakup Umucu, Vedat Deniz, Ahmet hatipoğlu, Başer Tamgüç, Tarik Tunay AN INVESTIGATION ON THE WASHABILITY TREATMENT FOR THE REMOVAL OF SERPENTINE AND MAGNESITE FROM OLIVINE IN THREE DIFFERENT SIZE FRACTIONS.	245
D. Gucbilmez, S.L. Ergü, L. Weitkämper, A STUDY ON GRAVITY SEPARATION OF COARSE AND FINE SIZES SEPARATELY	249
Mladenko Knežević, Draško Simić, Nenad Marjanović, EXTRACTING RICH ULTRA-FINES FRACTION OF LIMONITE IRON ORE FROM TAILINGS, USING FILTER-PRESS	253
A.V.Kurkov, E.S.Bronitskaya, A.A.Rogozhin, APPLICATION OF HIGH INTENSITY MAGNETIC SEPARATION FOR BENEFICIATION OF RARE METAL ORES BEARING RARE EARTH ELEMENTS	261
Mukhtar A.A., Muhymbekova M.K., Nurumgaliev A.H., Momynbekov A.D., Nuskabekov J.S. INVESTIGATION OF MAGNETIC ROASTING PROCESS OF AYATSK LIMONITE ORE WITH WATER-OLI EMULSION	269
Kremena Mincheva, Tashka Ignatova, Stefan Ignatov, Aylin Dzhelyaydinova, Tsvetelin Petkov, Ali Kyazimov, ALTERNATIVE PROCESSES FOR PRODUCTION OF LOW IRON SILICA SAND FROM KAOLINOVO REGION, BULGARIA	273
H. Knapp, L. Horckmans, F. Bouillot, C. Fricke-Begemann, J. Makowe, A. Ducastel, A. Stark, Hermann Wotruba, SENSOR-BASED IDENTIFICATION OF SPENT REFRACTORY BRICKS	279
Amel Zahirović, THE INFLUENCE OF MODIFICATION LIMONITE ORE BASICITY ON THE QUALITY OF SINTER.	285

Elias Stamboliadis, Fuat Kivrakoglu, Meryem Nur Tumbaz, George Patsalis, NEW DEVELOPMENTS IN MAGNETIC SEPARATION	291
S. Mohammadnejad, M. Noaparast, S. Z. Shafaei Tonkaboni, Y. Olyaei, H. Haghi, S. M. Hosseini, THE APPLICATION OF SHAKING TABLE FOR SCHEELITE ENRICHMENT FROM NEZAM-ABAD MINE USING BOX-BEHNKEN DESIGN	299
Khalil Al Rawashdah, Sudgi Al Hamad, CONCENTRATION OF ZIRCON, MONOZIT FROM JORDANIAN BLACK SAND USING GRAVITY, MAGNATIC PROCESS	305
İbrahim Utku Ermiş, CONCENTRATION OF AYDIN-ÇINE REGION FELDSPAR WITH HIGH GRADE RUTILE VIA MULTI GRAVITY SEPARATOR.	309

FLOTATION AND SURFACE CHEMISTRY PROCESSES

Elena Chanturiya, ABOUT INTERRELATION OF COMPOSITIONAL, TEXTURAL, ELECTRICAL, ELECTROCHEMICAL AND THE FLOTATION PROPERTIES OF NATURAL PYRITE OF COPPER-ZINC SULFIDES ORES	315
V.I.Ryaboy, E. D. Shepeta, V.P. Kretov, S.E. Levkovets, I.V.Ryaboy, INFLUENCE OF THE SURFACE-ACTIVE PROPERTIES OF THE RE-AGENTS CONTAINING SODIUM DIALKYLDITHIOPHOSPHATES ON THE FLOTATION OF SULFIDES	321
P. M. Solozhenkin, Sanda Krausz, MODIFIED FATTY ACIDS AS FLOTATION REAGENTS FOR NON-SULFIDE ORES: MOLECULAR MODELING FOR PROGNOSIS OF COLLECTOR ACTIVITY EVALUATION	327
Vladislava Ignatkina , Vladimir Bocharov, Lily Khachatryan, SELECTIVE REAGENT REGIMES AND FLOWSHEET OF FLOTATION TECNOLOGY OF FINELY DISSEMINATED ORES OF NON-FERROUS METALS	333
Sabri Kouachi, Ahmad Hassanzadeh, Moustapha Bouhenguel, Behzad V. Hassas, Mehmet S. Çelik, CONTRIBUTION OF INTERCEPTIONAL EFFECT TO THE CALCULATION OF COLLISION EFFICIENCY OF PARTICLE BUBBLE ENCOUNTER IN FLOTATION	339
Valentina Ivanova, Galina Mitrofanova, FLOTATION OF EUDIALITE: CORRELATION OF EXPERIMENTAL DATA WITH THE RESULTS OF QUANTUM-CHEMICAL CALCULATIONS	347
Vladislava Ignatkina, Phillip Milovich, Alexander Pankin, USE OF SULFHYDRYL COLLECTORS TO INCREASE THE CONTRAST OF FLOTATION PROPERTIES OF SULFIDE MINERALS	353
Ali Uçar, Osman Ö. Taş, Oktay Şahbaz, Bahri Öteyaka, EFFECTS OF BIAS FACTOR AND GAS VELOCITY ON COLUMN FLOTATION OF COLEMANITE	359
A.E.Yüce, G. Bulut, B.Even, O.Güven, FLOTATION RESULTS ACCURACY: THE RIGHT MINERALOGY, LIBERATION SIZE AND PROCESS PARAMETERS	365
Fırat Burat, Mustafa Özer, Beste Aydın, Güven Önal, BENEFICIATION OF OXIDIZED- SULFIDIZED COMPLEX COPPER ORE BY FLOTATION AND LEACHING	371
Dragan Milanovic, Zoran S Markovic, Daniela Urošević, Srdjana Magdalinovic, Zoran Stirbanovic INFLUENCE OF BASIC AND ACIDIC pH REGULATORS ON THE SHEELITE ZETA POTENTIAL	377
Hidayet Çalışkan, Behzad V. Hassas, Mustafa Çınar, Mehmet S. Çelik, EFFECT OF ROUGHNESS AND SHAPE FACTOR ON FLOTATION RECOVERIES OF GLASS BEADS	385
Daniela Urošević, Zoran S. Marković, Dragan Milanović, Srđana Magdalinović, Mile Dimitrijević, Zoran Štirbanović, Ljubiša Andrić, MEASURING OF ELECTROKINETIC-ZETA POTENTIAL IN THE SUSPENSION FORMED FROM SMELTING SLAG.	391
Blagica Cekova, Viktorija Bezovska, Filip Jovanovski, A STUDY ON THE ADSORPTION PROPERTIES OF THE NATURAL ZEOFIT MATERIAL	399
Medyanik N.L, Girevaya K.Y., Shevelin I.Yu, Girevoi T.A., REFINING OF MINERALIZED PROCESS WATERS BY IONIC FLOTATION METHOD	403
Carlos Castañeda Olivera, Antonio Gutiérrez Merma, Leonardo Maurício Torem, FUNDAMENTAL ASPECTS OF THE BIOFLOTATION OF HEMATITE USING THE <i>RHODOCOCCUS</i> <i>ERYTHROPOLIS</i> BACTERIA	407
Elayne Rohem Peçanha, Marisa Bezerra de Melo Monte, Maurício Leonardo Torem, ON THE FUNDAMENTAL ASPECTS OF HEMATITE BIOFLOTATION USING A GRAM-POSITIVE BACILLUS SUBTILIS STRAIN AS A BIOREAGENT	415

Alexander A. Nikolaev, Professor Boris E. Goryachev, INTRODUCING POWDER COMPRESSION TECHNIQUE AS A SUPPLEMENTARY METHOD OF INVESTIGATION THE SURFACE HETEROGENEITY OF SOLIDS AND PARTICLES FOR FLOTATION . . .	423
Tussupbayev N., Bekturganov N., Semushkina L., Turisbekov D., Mukhanova A., INTENSIFICATION OF FLOTATION OF HEAVY-CONCENTRATING COMPLEX ORE WITH APPLICATION OF PROCESS OF RE-GRINDING AND MODIFIED COLLECTING AGENT	429
Z. Bartulović, D. Todorović, V. Milošević, B. Ivošević, J. Čarapić, V. Jovanović, COPPER MINERALS FLOTATION COLLECTOR SELECTION FOR PROCESSING OF THE ORE FROM PYRITE-RICH PARTS FROM „VELIKI KRIVELJ“ DEPOSIT	437
Dejan Todorović, Vladan Milošević, Bartulović Zoran, Branislav Ivošević, Jelena Čarapić, Vladimir Jovanović, Sonja Milićević, PILOT-PLANT FLOTATION TESTING OF COPPER, LEAD AND ZINC MINERALS FROM RICH POLYMETALLIC ORE	441
Jelena Čarapić, Branislav Ivošević, Vladan Milošević, Zoran Bartulović, Dejan Todorović, Vladimir Jovanović, Sonja Milićević, THE POSSIBILITY OF APPLYING CONTEMPORARY FLOTATION COLLECTORS TO IMPROVE THE TECHNOLOGICAL EFFECTS OF PROCESSING COMPLEX ORE WITH PYRITE HIGH CONTENT FROM THE UPPER LAYERS DEPOSIT “VELIKI KRIVELJ”	449
Sanja Petrović, Vukosava Grujić, Srđana Magdalinović, Ljubiša Andrić, Ivana Jovanović, Daniela Urošević, INFLUENCE OF FLOTATION PULP DENSITY ON COPPER CONCENTRATE GRADE AND RECOVERY FROM ORE DEPOSIT „CEROVO“	455
Ivana Jovanović, Srđana Magdalinović, Vukosava Grujić, Daniela Urošević, Miomir Mikić, Sanja Petrović, DETERMINATION OF OPTIMAL REAGENT REGIME IN FLOTATION PROCESS OF COPPER MINERALS FROM „CEROVO“ DEPOSIT	459
Ivana Jovanović, Ljubiša Andrić, Vladan Milošević, Dejan Todorović, Zoran Bartulović, Miomir Mikić, RECOVERY OF COPPER, GOLD AND SILVER FROM ORE DEPOSIT TENKA-3 IN DEPENDENCE ON GRINDING FINENESS	465
Milorad Grujić, Blagoje Spaskovski, Masan Grujić, Zoran Marković, INVESTIGATION IN FLOTABILITY OF PORPHYRY COPPER ORE FROM NORTH REVER ZONE TS2 MAJDANPEK	469
Gracijan Strainović, Zoran Marković, Ivana Profirović, Sandra Radulović, Ana Stanojević, Slavica Milosavljević, FLOTATION CHARACTERISTIC OF COPPER ORE IN FUNCTION OF PARTICLE SIZE DISTRIBUTION IN PRESENCE OF COLLECTOR TYPE XANTHATE AND THIONOCARBAMATE	473
Juliana S. Siqueira, Antonio E. C. Peres, RECOVERY OF SULFIDES FROM A SILICATE ZINC ORE	477
Can Güngören, Tarık M. Erbek, Orhan Ozdemir, Safak G. Ozkan, EFFECT OF SIMULTANEOUS ULTRASONIC TREATMENT ON QUARTZ-AMINE FLOTATION SYSTEM.	483
Sergey A. Kondratiev, FLOTATION STRENGTH OF DESORBABLE FORMS OF REAGENTS AND ITS ESTIMATION	491
Jacques Bezuidenhout, Nathalie Sterbik, Gunter Lipowsky, A LABORATORY INVESTIGATION INTO THE EFFECT OF GANGUE COMPOSITION ON THE FLOTATION RECOVERY AND GRADE OF TWO CU ORES	497
Oktay Bayat, Mahmut Altiner, Zehra Altincelep, UPGRADING BITLIS (TURKEY) KYANITES WITH FLOTATION AND MULTI GRAVITATIONAL METHODS	503
Milan Petrov, Ljubiša Andrić, Vladimir Jovanović, Mašan Grujić, Meline Vukadinović, FLEET-EXTRACTION OF BLUE WATER.	509
Boris Krstev, Aleksandar Krstev, THE PRINCIPLES AND EXAMPLES OF KINETIC PERFORMANCE FOR DOMESTIC LEAD AND ZINC ORES	517
Victor Samiguin, Chingis Lekhatinov, Moshchanetskiy Pavel, MULTI-ZONE FLOTATION CELL'S AUTOMATED STAND	521
Victor Samiguin, Chingis Lekhatinov, Moshchanetskiy Pavel, THE EFFECTIVE AERATION-HYDRODYNAMIC OPERATING MODE OF MULTIZONE FLOTATION CELL.	527
N. Emre Altun, Chuanfu Xiao, Jiann-Yang Hwang, REMOVAL OF UNBURNED CARBON FROM FLY ASH USING A CONCURRENT FLOTATION COLUMN	533
Firat Karakas, Feridun Boylu, İsmail Bentli, Mehmet S. Çelik, BENEFICIATION OF SAPHANE ALUNITE BY FLOTATION	539
Taki Güler, Selçuk Aktürk, BENEFICIATION OF OLIVINE ORE BY NA-OLEATE FLOTATION	543

Milena R. Kostović, Dragan K. Stanković, SHORT CIRCUIT CURRENT MEASUREMENT TECHNIQUE IN ELECTROCHEMICAL STUDIES OF SULPHIDE MINERAL – GRINDING MEDIA INTERACTION	549
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PROCESSING OF INDUSTRIAL MINERALS

Konstantinos Gudulas, Efthimios Papastergiadis, Andreas Iordanidis, Petros Samaras, STUDY OF THE ADSORPTION CAPACITY OF A NATURAL MINERAL AND A SOLID BIOWASTE	557
Georgios Anastassakis, FELDSPAR-CONTAINING ROCKS OF GREECE: MINERALOGICAL CHARACTERISTICS AND PROCESSING FLOW-SHEETS	565
Stanislav Titkov, Tamara Gurkova, Nina Panteleeva, TECHNOLOGY FOR FLOTATION PROCESSING OF POTASH ORES	573
A. Mitrović, M. Zdujić, EVALUATION OF SELECTED SERBIAN KAOLIN CLAYS AS A RAW MATERIAL FOR THE CEMENT AND CONCRETE INDUSTRY	579
Dragan S. Radulović, Slavica R. Mihajlović, Živko Sekulić, Vladimir D. Jovanović, OBTAINING FILLERS BASED ON LIMESTONE FROM DEPOSIT DARZA – ULCINJ, FOR APPLICATIONS IN VARIOUS INDUSTRIES	585

INDEX OF AUTHORS

VOLUME II

COAL PROCESSING

B. Sarıkaya, M. Taksuk, M. Cokuslu, H. Aykul, A CASE STUDY ABOUT PRIMARY AND SECONDARY CIRCUIT DENSITY VARIATIONS IN OMERLER COAL WASHING PLANT WITH STATISTICAL PROCESS CONTROL(SPC) METHOD	593
Zlatko Ječmenica, SUPPLY OF CARBONATE USED AS AN ABSORBENT FOR FLUE GAS DESULPHURIZATION PROJECT IN UGLJEVIK THERMAL POWER PLANT	601
M. Taksuk, H. Yagar, M. Gulsoy, H. Aykul, STATISTICALLY PROCESS CONTROL ANALYZE OF THERMAL COAL AT TUNÇBILEK POWER PLANT	607
Yildirim Tosun, BLACK CARBON PRODUCTION FROM PYROLYSIS AND COMBUSTION OF PYROLYSIS OIL OF ASPHALTITE, WASTE TIRE AND WOOD	615
Miloljub Grbović, Miroslav Spasojević, NEW COAL CLEANING PROCESS FOR LIGNITES FROM SERBIAN MULTILAYER DEPOSITS	623
Yildirim Tosun, MICROWAVE ACTIVATED CRUSHING AND GRINDING OF TURKISH COALS AND SHALE FOR CLEANING AND DESULFURIZATION	629
Ayşe Erdem, Akan Gülmez, Oğuz Altun, Zeki Olgun, TECHNOLOGICAL EVALUATION OF COAL WASHING PLANT SLIME TAILINGS OF MANISA SOMA DEREKÖY (TURKEY).	637
G.Özbayoğlu Sulfur, SULFUR DISTRIBUTION OF TURKISH LIGNITES AND THEIR AMENABILITY TO DESULFURIZATION BY PHYSICAL METHODS	643
Selçuk Özgen, Zeki Olgun, STUDIES OF A HYDROCYCLONE TO PRODUCE CLEAN COAL FROM TUNÇBILEK/TURKEY FINE LIGNITE TAILINGS	647
Jovica Sokolović, Rodoljub Stanojlović, Zoran Marković, Zoran Stirbanović, Suzana Stanković, Vojka Gardić, VALORIZATION OF COAL FROM THE OLD TAILING PONDS FROM ANTHRACITE MINE “VRSKA CUKA” AVRAMICA, SERBIA	651

PLANT AND PROCESS DESIGN AND OPERATING PRACTICE

Irina Pestriak, Valery Morozov, Erdenetuya Otchir, MODELING OF PROCESSES AND THE DEVELOPMENT OF CLOSED CYCLE OF CONDITIONING RECYCLED WATER DURING THE PROCESSING COPPER-MOLYBDENUM ORES	659
Zivko Gocev, Aleksandar Krstev, Boris Krstev, Mirjana Golomeova, Afrodita Zendelska, THE MODELS OF OPTIMIZATION FOR INCREASING OF COPPER AND GOLD RECOVERIES IN BUCIM MINE	665

Mariana Gabriela Flucus, Mihai Florian Flucus, Ioan Flucus, CONSIDERATIONS REGARDING THE USE OF MATHEMATICAL MODELING IN INDUSTRIAL IMPACT STUDIES INVOLVING POLLUTANT DISPERSION	671
Todor Angelov, Georgy Savov, Aleksander Tsekov, Dejan Karanfilov, BUCIM COPPER PROJECT NEW DEVELOPMENTS	677
Nihad Omerović, Igor Miljanović, Ruzmir Avdić, RESOLVING OPTIMIZATION PROBLEMS OF PREPARATION ERUPTIVE AGGREGATES USING PROGRAMING DRIVEN BY EVENTS	683
Nihad Omerović, Igor Miljanović, Ruzmir Avdić, OPTIMIZATION OF GRINDING ERUPTIVE AGGREGATES USING METHODS OF MULTI-CRITERIA ANALYSIS	687

PYRO-HYDROMETALLURGY AND BIO-PROCESSING

Branislav Marković, Vladislav Matković, Miroslav Sokić, VANADIUM RECOVERY AS FERROVANADIUM FROM SPENT CATALYSTS	697
Ahmet Göveli, M. Ümit Atalay, NICKEL EXTRACTION FROM TURKISH LATERITIC ORE BY HYDROCHLORIC ACID LEACHING	701
SH.R. Samikhov, Z.A. Zinchenko, N. Shermatov, THE STUDY AND DEVELOPMENT OF THE MATHEMATICAL MODELS OF POOR GOLD-CONTAINING ORES THE PROCESS HEAP (THE DUMP) LEACHING	709
K.K. Mamyrbayeva, V.A. Lukanov, A. Eshmoldayeva, PROCESSING OF AKTOGAI (KAZAKHSTAN) MIXED COPPER ORE	713
Ş. Beste Aydin, Hüseyin Baştürkcü, Alim Gül, EVALUATION OF LEACHING PARAMETERS FOR GOLD ORE CONTAINING ELECTRUM.	719
Milena Danovska, Dejan Karanfilov, Mirjana Golomeova, Boris Krstev, Afrodita Zendelska DESIGN OF A HIGH CURRENT EXTRACTION/STRIPPING SYSTEM USING EXTRACTION AND STRIPPING ISOTHERMS.	723
Tomuş Nicolae, Zlăgnea Marius, Botez Adriana, Dobre Oana, Radu Aura Daniela, RESEARCHES CONCERNING THE POSSIBILITY TO OBTAIN THE URANIUM CONCENTRATES BY ELECTROLYSIS	729
Nikolay V. Vorobiev-Desyatovsky, Sergey A. Kubyshkin, Rimma I. Ibragimova, PROSPECTS OF USING ACTIVATED CARBON FOR DETOXICATION OF CYANIDE SOLUTIONS IN GOLD HYDROMETALLURGY	737
M. Deniz Turan, Z. Abidin Sari, Mehmed Erdem, SELECTIVE LEACHING OF BLENDED COPPER SLAG	745
Galina Sedelnikova, Dmitriy Kim, Natalya Ibragimova, HEAP BIOOXIDATION OF COMPLEX GOLD SULFIDE ORE.	749
Jana Ficeriova, Erika Dutkova, NON-CYANIDE LEACHING AND ELECTROLYSIS OF GOLD	757
Vapur H., Demirci S., Top S., Altiner M, REMOVAL OF IRON CONTENT IN FELDSPAR ORES BY LEACHING WITH ORGANIC ACIDS	761
Emre Erkan, H.Semih Demircan, Merve Cankurtaran, Sercan Sevgul, EFFECTS OF DIFFERENT CRUSH SIZE ON HEAP LEACH RECOVERY OF HIMMETDEDE OXIDE ORE	767
Aleksandar Krstev, Boris Krstev et al., THE PRINCIPLES AND EXAMPLES OF LEACHING AND BIO-LEACHING OF COPPER ORES	773
S. Beikzadeh-Noei, S. Sheibani, F. Rashchi, S. M. J. Mirazimi, BIOLEACHING KINETICS OF COPPER RECOVERY FROM LOW GRADE COPPER ORE	777
Jelena V. Milojković, Marija L. Mihajlović, Zorica R. Lopičić, Marija S. Petrović, Tatjana D. Šoštarić, Jelena T. Petrović, Marija R.. Stanojević, DEVELOPMENT OF HYBRID ORGANIC-INORGANIC (BIO)SORBENTS FOR PB(II) REMOVAL	783
Irena I. Spasova, Marina V. Nicolova, Plamen S. Georgiev and Stoyan N. Groudev, COMPARATIVE VARIANTS OF MICROBIAL PRETREATMENT OF A GOLD-BEARING SULPHIDE CONCENTRATE UNDER DIFFERENT GROWTH AND TECHNOLOGICAL CONDITIONS	787

T.N. Alexandrova, A.V.Alexandrov, N.M. Litvinova, ADVANCED METHODS OF PROCESSING REFRACTORY GOLD BEARING ORES	791
Svetlana Bratkova, Rosen Ivanov, Anatoliy Angelov, Katerina Nikolova, THE INFLUENCE OF HYDRAULIC RETENTION TIME ON THE PERFORMANCE OF MICROBIAL FUEL CELL INTEGRATED IN SUCCESSIVE ALKALINITY-PRODUCING SYSTEM	795
Meryem Göktaş, Murat Erdemoğlu, BENEFICIATION OF LATERITIC NI-CO ORE FROM MANISA – ÇALDAĞ, TURKEY	801
P.V. Aleksandrov, A.S. Medvedev, MECHANISM OF INTERACTION BETWEEN MOLYBDENITE CONCENTRATE AND SODIUM CHLORIDE WHEN HEATED IN THE PRESENCE OF OXYGEN	807
Y. Olyaei, M. Noaparast, S. Z. Shafaei Tonkaboni, A. Amini, H. Haghi, THE EXTRACTION OF GOLD FROM THE HAMZE-QARNEIN ORE BY HEAP LEACHING IN LABORATORY SCALE	813
Birgül Benli, Yücel Özsoy, Fatma Arslan, EFFECTS OF ACID TREATMENTS ON REFRACTORY GOLD ORE PRIOR TO CONVENTIONAL GOLD RECOVERY	817
A. Rezaei, Y. Olyaei, S. Z. Shafaei Tonkaboni, M. Noaparast, H. Haghi, A. Allahverdi, COPPER RECOVERY FROM MESKANI OXIDE ORE USING HEAP LEACHING	823
Vesna Conić, Ljiljana Avramović, Radojka Jonović, Radmila Marković, Mile Bugarin, SX-EW TREATMENT OF THE SOLUTION OBTAINED AFTER ACID LEACHING RTB BOR FLOTATION TAILING	827
S. Abdi Bastami, B. Rezaie, A. Amini, H. Abdollahi and Amir Pazooki, PRELIMINARY CYANIDATION OF ZAVVARIAN GOLD ORE	831
Yücel Özsoy, Birgül Benli, Fatma Arslan, APPLICATION OF BIOOXIDATION PRIOR TO CYANIDATION CASE STUDY: TURKISH SULFIDIC GOLD-BEARING ORES.	835

SOLID WASTE AND WASTE WATER TREATMENT and SOIL REMEDIATION

Mihai Alexandru, MINERAL WASTE MANAGEMENT IN THE PORT OF CONSTANTA	845
Tussupbayev N., Bekturganov N., Semushkina L., Turisbekov Mukhanova A., Musina M. FLOTATION PROCESSING OF TECHNOGENIC MINERAL RAW MATERIALS BASED ON COMPOSITION AGENT.	853
Yuri Chugunov, Vladislav Ivanchenko ,TECHNOLOGY FOR ENRICHMENT AND REPROCESSING OF SLAG WASTE INCINERATION PLANTS	859
Ilker Acar, M.U. Atalay, VARIATION OF CENOSPHERES IN BITUMINOUS COAL FLY ASHES	861
D.V. Makarov, O.V. Suvorova, V.A. Kumarova, N.K. Manakova, R.G. Melkonyan, BUILDING MATERIALS FROM MINING AND CONCENTRATION WASTES OF THE MURMANSK REGION, RUSSIA.	869
M.V. Belitska, LITHOLOGY AND TECHNOLOGICAL FEATURES OF SEDIMENTS RIVER INHULETS POLLUTED WITH THE WASTES OF INDUSTRI IN KRIVEY RIG BASIN (UKRAINE)	875
S.A. Kvyatkovskiy, G.Zh. Abdykirova, Ye.A. Sitko, M.T. Shazhaliyev, S.B. Dyussenova, INFLUENCE OF TEMPERATURE CONDITIONS OF CONVERTER SLAG PROCESSING ON THE COPPER SULPHIDE AND FERRUM CRYSTALS FORMATION	879
Shavakyleva Olga Petrovna, Sedinkina Nataliya Anatolievna, WAYS TO IMPROVE THE EFFICIENCY OF PROCESSING MAN-MADE RESOURCES	883
G.Zh. Abdykirova, N.S. Bekturganov, M.Sh. Tanekeeva, A.Ye. Sydykov, Sh.A. Telkov, G.A. Toylanbay, RESEARCH ON OBTAINING ELECTROLYTIC MANGANESE DIOXIDE FROM MANGANESE-CONTAINING SLUDGE LEACHING SOLUTIONS	887
Julia Bajurova, Anton Svetlov, Olga Suvorova, Victoria Kumarova, Dmitriy Makarov, Vladimir Masloboev, THE POSSIBILITY OF COMPLEX PROCESSING OF COPPER-NICKEL CONCENTRATION TAILINGS	891
Grozdanka D. Bogdanović, Velizar Stanković, Milan M.Antonijević, Dejan V.Antić, Dragan Milojević, Darko Milicević, ACID LEACHING OF COPPER FROM MINING - WASTE DUMP	895

H. Nourizadeh, F. Rashchi, SYNTHESIS OF VANADIUM PENTOXIDE FROM POWER PLANTS FLY ASH LEACHING SOLUTION	901
Ivana Jovanović, Igor Miljanović, Miomir Mikić, REVIEW OF CONTEMPORARY WORLD STUDIES ON CHARACTERISTICS OF FLY ASH AS A SECONDARY MINERAL RESOURCE; PART 2	905
Pedro P. M. Ribeiro, Iranildes D. Santos, Achilles J. B. Dutra, COPPER CONCENTRATION FROM CRUSHED AND GRINDED PRINTED CIRCUIT BOARDS USING A ZIG-ZAG CLASSIFIER	913
Gulsen Tozsina, Ali Ihsan Arolb, EFFECT OF MARBLE WASTE ON THE ACID GENERATION INHIBITION AND HEAVY METAL MOBILITY IN COPPER SULPHIDE TAILINGS	919
Madali Naimanbayev, Nina Lokhova, Zhazira Baltabekova, Arailym Dukembayeva, Zhantore Dzhurkanov, RECEIVING A CONCENTRATE OF RARE-EARTH ELEMENTS FROM WITHDRAWAL FROM PROCESSING OF PHOSPHORITES	927
Gábor Mucsi, Imre Gombkötő, Zoltán Molnár, Viktor Török, MECHANICAL ACTIVATION AND CLASSIFICATION OF FLY ASH TO ENHANCE ITS REACTIVITY	931
Shyqri Kelmendi, Bajram Mustafa, Faton Kelmendi, USE OF FLY ASH IN UNDERGROUND MINES LIKE HYDRAULIC FILL MATERIAL.	939
Irina V. Shadrinova, Natalia N. Orekhova, EXPERIMENTAL COMPARISON OF PROCESSES FOR RECOVERY OF COPPER AND ZINC FROM MINE WATER	945
Ultrakova A., Naymanbaev M. A., Onayev M., Dzhurkanov J., Alzhanbayeva N., PROCESSING OF TITANIUM PRODUCTION CHLORIDE WASTES OBTAINING NIOBIUM ENRICHED MIDDINGS.	953
Mirjana Golomeova, Afrodita Zendelska, Boris Krstev, Blagoj Golomeov, Aleksandar Krstev, REMOVAL OF HEAVY METAL IONS FROM AQUEOUS SOLUTIONS USING CLINOPTILOLITE	959
Bajram Mustafa, Shyqri Kelmendi, Sali Kurshumliu, TREATMENT OF THE ACIDIC WATERS IN TREPJA JAROSIT TAILINGS	965
Ataç Başçetin, Orhan Özdemir, Deniz Adıgüzel, Yasin Baktarhan, Mink Ter Harmsel, USE OF GEOEXTILE FILTRATION SYSTEM (GEOTUBE® TECHNOLOGY) FOR DEWATERING OF MINERAL PROCESSING PLANT TAILINGS.	969
Viorica Ciocan, Sanda Krauzs, THE DOMESTIC RESIDUAL WATERS ADVANCED CLEANING WITH MAGNESIUM MINERALS	973
Ünzile Yenial, Gülay Bulut, UTILIZATION OF MINING WASTES FOR WASTEWATER TREATMENT	979
Marius Zlagnean, Sorin O. Mihai, Nicolae Tomus, Alexandru Nicolici, Sorin Halga, NEW TRENDS IN TAILINGS DISPOSAL – STUDY CASE: ROVINA MINING PROJECT, ROMANIA	987
Predrag Dimovski, Zdravko Hojka, Branimir Monevski, PROPOSAL OF OPTIMAL SOLUTION FOR DUMPING FLY ASH AND SLAG FROM THERMO POWER PLANTS, HEATING PLANTS AND METALLURGIC FACILITIES.	995
Stoyan N. Groudev, Plamen S. Georgiev, Irena I. Spasova and Marina V. Nicolova, BIOREMEDIATION OF AN ALKALINE SOIL HEAVILY POLLUTED WITH RADIONUCLIDES AND HEAVY METALS.	1003
Jelena D. Nikolić, Vladimir D. Živanović, Srđan D. Matijašević, Snežana N. Zildžović, Snežana R. Grujić, Sonja V. Smiljanić, Ana M. Vujošević, ECO-MATERIALS FOR SOIL REMEDIATION BASED ON POLYPHOSPHATE GLASSES.	1007
Milica M. Vlahović, Sanja P. Martinović, Tatjana D. Volkov Husović, LEACHING BEHAVIOR OF SULFUR CONCRETE WITH FLY ASH USED FOR REMOVAL OF HEAVY METALS FROM WASTEWATER	1013
Tatjana Šoštarić, Marija Petrović, Jelena Milojković, Jelena Petrović, Marija Stanojević, Ljubiša Andrić, Mirjana Stojanović, BIOSORPTION OF Cu(II) IONS FROM AQUEOUS SOLUTION BY WASTE APRICOT STONES PRE-TREATED BY MECHANICAL ACTIVATION	1017
A. Ekrem Yüce; Güven Önal; Gündüz Ateşok, BENEFICIATION AND PRE FEASIBILITY STUDIES FOR IRON STEEL CONVERTER SLAG	1021

Florent Dobroshi, Fatos Rexhepi, Blerim Baruti, Dilaver Salihi, Mensur Kelmendi, Ilirian Malollari HIGH ACIDITY INDICATORS OF THE PHYSICO - CHEMICAL PROPERTIES OF DRINKING WATER IN SOME VILLAGES IN THE DISTRICT OF THE "TREPÇA" MINE.	1025
E. Dutková and J. Ficeriová, LEACHING OF GOLD FROM ACTIVATED GOLDSMITH' S WASTE	1029
Violeta Čolaković, Vladan Čanović, Branka Jovanović, Dragan Milošević, DRAINAGE OF SURFACE AND UNDERGROUND WATERS FROM THE SURFACE OF THE FUTURE FLYING AND BOTTOM ASH DEPOT "CIRIKOVAC"	1035
Pavle Stjepanović, Nenad Milojković, Klara Konc Janković, Dejan Lazić, ANALYSIS OF THE DEPOSITED MATERIALS OF FLYING AND BOTTOM ASH AT THE DEPOT OF TPPT B	1041
Jasmina Nešković, Klara Konc Janković, Dejan Lazić, Pavle Stjepanović, TECHNICAL TESTS OF THE PREPARATION OF MINERAL ORES AT THE CORES OF SURVEY DRILL SITES OF THE KRAKU BUGARESKU BASIN	1049
Nenad Milojković, Grozdana Tomasović, Jasmina Nešković, THE TECHNOLOGY OF TRANSFORMATION OF DANGEROUS WASTE FROM THE LAND POLLUTED BY CRUDE OIL INTO INERT WASTE	1055

SUSTAINABILITY IN MINERAL PROCESSING

Lyubomir Ilchev, Nadezhda Davcheva-Ilcheva, INDICATORS DESCRIBING PRESSURES ON ENVIRONMENT FROM MINING, CONCENTRATION AND METALLURGY	1061
Desislava Kostova, Valentin Velev, REINDUSTRIALIZATION AND BULGARIAN MINING INDUSTRY	1065
Teodora Tinkova, Irena Grigorova, Ivan Nishkov, NEW APPROACHES ON GYPSUM BODY COMPOSITE MATERIALS ADDITION	1069
Irena Grigorova, INDUSTRIAL MINERALS PROCESSING WASTE – NEW SECONDARY PRODUCTS.	1077
Vladimir Jovanović, Živko Sekulić, Branislav Ivošević, Slavica Mihajlović, Milan Petrov, Dragan Radulović, MECHANICAL PROPERTIES OF LIMESTONE BRIQUETTES AND PELLETS WITH BENTONITE FOR CALCIFICATION OF ACID SOIL	1083

APPLICATIONS OF MINERAL PROCESSING IN RELATED INDUSTRIES

Murat Erdemoğlu, MECHANOSYNTHESIS OF SRTIO ₃ AND BATIO ₃ THROUGH INTENSIVE BALL MILLING	1087
H. Serdar Mutlu, Turan Uysal Muhammed Şener, Murat Erdemoğlu, INVESTIGATIONS FOR INNOVATIVE CERAMIC WALL TILES: SYNERGISTIC EFFECTS OF PYROPHYLLITE AND COLEMANITE.	1095
Eugenia Panturu, Razvan – Ioan Panturu, Antoneta Filcenco – Olteanu, Aura Daniela Radu KINETICS OF URANIUM ADSORPTION ON CARBON IMPREGNATED WITH ZERO- VALENT IRON NANOPARTICLES	1103
Ljiljana Tankosić, Nadežda Čalić, Milena Kostović, SELECTIVE FLOCCULATION OF LIMONITE AND CLAY BY POLYACRYLAMIDES	1109
Bulent Toka, A. İ. Arol, THE RHEOLOGICAL AND FILTRATE PROPERTIES OF BENTONITES ACTIVATED WITH BORATE AND TREATED WITH POLYMERS	1115
Yury V. Semenov, OPTIMIZATION OF ORGANO-MINERAL SORBENTS AND DEVICES FOR REMOVAL OF OIL POLLUTION FROM WATER SURFACE	1125
Anja Terzić, Lato Pezo, Ljubiša Andrić, Milan Trumić, Grozdanka Bogadanović, EFFECTS OF MECHANICAL ACTIVATION ON THE PARAMETERS OF MICA QUALITY FOR APPLICATION IN INSULATION MATERIALS - CHEMOMETRIC APPROACH.	1131
Marko Pavlović, Tatjana Volkov-Husović, Ljubiša Andrić, FILLERS FOR FOUNDRY COATING	1139
Sanja P. Martinović, Milica M. Vlahović, Tatjana D. Volkov Husović, POSSIBILITY OF USING DIATOMACEOUS EARTH FROM KOLUBARA AND VESJE DEPOSITS FOR PRODUCTION OF BEER FILTER AIDS.	1143

INDEX OF AUTHORS

PILOT-PLANT FLOTATION TESTING OF COPPER, LEAD AND ZINC MINERALS FROM RICH POLYMETALLIC ORE

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Abstract: The investigation results presented in this paper were performed in order to examine the possibility of efficient processing of valuable minerals from the rich complex polymetallic ore with extremely high content of copper, lead and zinc (0.86% Cu, 4.46% Pb and 2.51% Zn). These tests were carried out in pilot-plant facility of the Laboratory for mineral processing in Institute for Technology of Nuclear and Other Mineral Raw Materials (ITNMS). The role of scientific research is to thoroughly investigate the flotation concentration of valuable components and to confirm the laboratory tests on which the technological scheme to produce a separate concentrates of copper, lead and zinc is defined, on pilot-plant scale. While performing those pilot-plant tests, it was found that it is possible to produce three commercial products from this ore, following a copper, lead and zinc rough concentrates single-stage cleaning.

Keywords: polymetallic ore, flotation, pilot-plant, copper, lead, zinc.

INTRODUCTION

In order to investigate the possibilities for effective preparation and concentration of copper, lead and zinc minerals from the rich polymetallic ore in the Laboratory for mineral processing of ITNMS Institute, technological experiments were conducted in pilot plant facility using ore representative sample.

As a basis for defining the technical and technological flotation conditions on pilot-plant level, Institute researchers used the Report of technological results defined from laboratory tests carried out during the last few years.

This paper provides an overview of the activities conducted during the pilot-plant test and are presented with the achieved results. In addition, paper contains expert commentary ITNMS associates who are engaged in this problem, as well as conclusions with a proposal on further activities.

The ultimate goal of these tests is to obtain a copper, lead and zinc concentrates according to commercial conditions and requirements for further pyrometallurgical processing.

EXPERIMENTAL PROCEDURE

Testing samples

Sample preparation

Ore sample for technological tests was prepared as follows:

- The ore sample was first crushed in the jaw crusher in open circuit to - 12 mm particle size.
- Primary crushed sample was further delivered on open circuit grain size reduction in the roll crusher with 4 mm gap between the rollers.
- The third level of the sample grain size reduction was carried out also in the roll crusher with 2 mm gap between the rollers, in a closed circuit. As a crushed product classification device was used continuous feeding vibration sieve with screen opening $d = 2$ mm.
- In this way, the sample coarseness was reduced to - 2 mm size.
- In this way comminuted sample after homogenization, represented the feed to milling process.

Physical and chemical characterization of samples

Sample specific gravity was determined by the pycnometer, and amounts:

$$\gamma = 2.87 \text{ g/cm}^3$$

The ore natural pH value before milling and flotation process, measured in pulp with 68% of solids, amounts:

$$\text{pH} = 8.6$$

The sample moisture content amounts:

$$W_o = 3.38 \%$$

Table 1, Ore sample chemical composition.

Element	Ag, ppm	As, ppm	Bi, ppm	Ca, %	Cd, ppm	Cu, ppm	Fe, %	Hg, ppm	Pb, ppm	S, %	Sb, ppm
Content	>10	3382	0.51	1.10	185.90	8616	3.99	0.21	>10000	>5	497

Element	Se, ppm	Sn, ppm	Zn, ppm	Au, ppm	Au(R), ppm	Au(S), ppm	Ag, ppm	Pb, ppm	Zn, ppm	SiO ₂ , %	Al, %
Content	3.1	0.5	>10000	0.07	0.07	N.A.	33.2	48500	28800	51.5	4.84

Mineralogical and geological composition

Rich polymetallic ore microscopic examinations are defined following ore minerals: galena, chalcopyrite and sphalerite, and subordinated marcasite, pyrite, tetrahedrite and bournonite. Gangue minerals are represented by quartz, diopside, chlorite, calcite, etc. (Figure 1, 2, 3, 4, 5, 6)

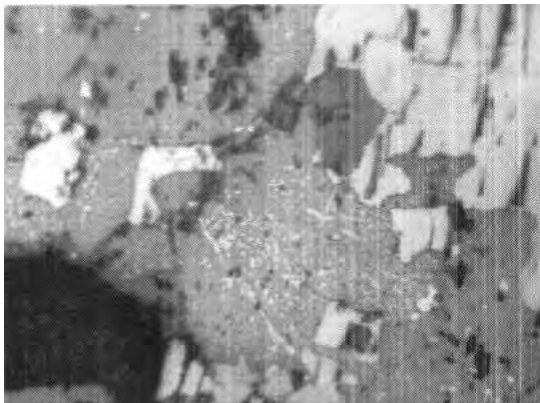


Figure 1, Marmatite with chalcopyrite inclusions and suppressed galena remains.

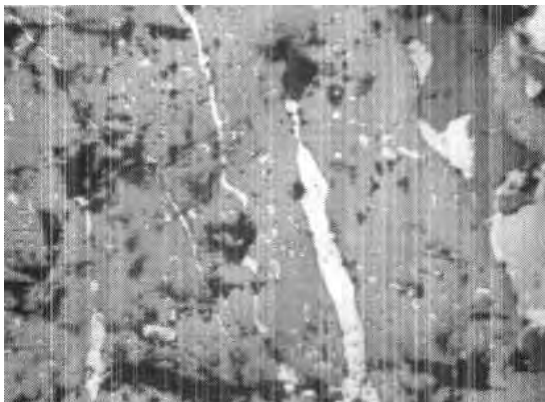


Figure 2, Marmatite with chalcopyrite inclusions and veins.

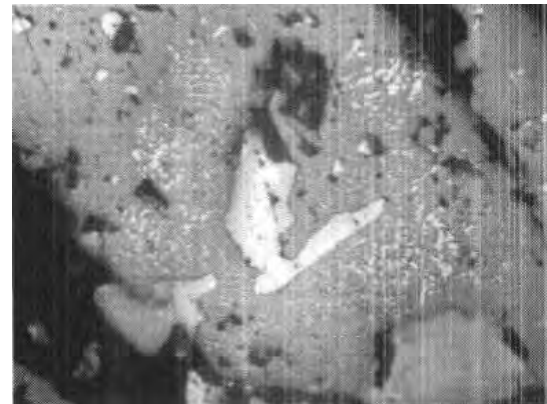


Figure 3, Marmatite with the galena affected chalcopyrite high density inclusions.

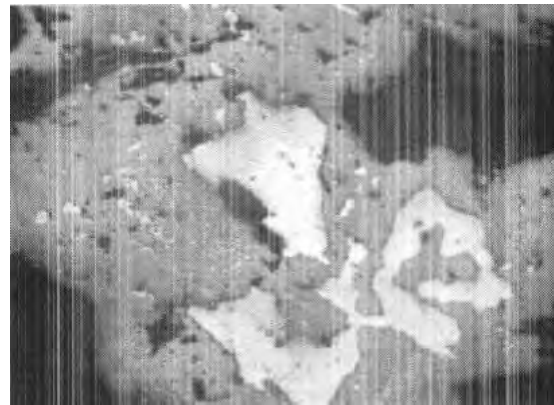


Figure 4, Marmatite with the galena affected chalcopyrite high density inclusions.



Figure 5, Marmatite with the chalcopyrite inclusions, suppressed galena remains, chalcopyrite, tetrahedrite and pyrite.

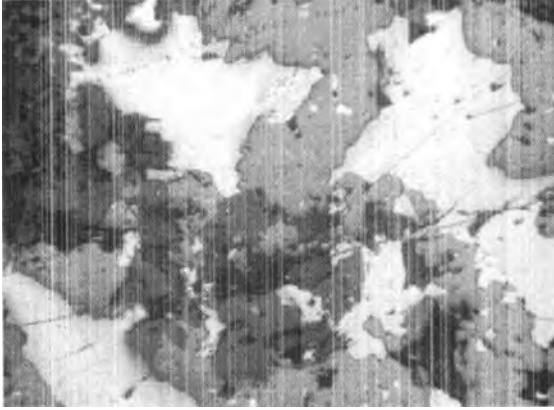


Figure 6, Marmatite affected galena, galena "Rags" in younger sulphides.

Galena forms a larger surfaces with fragments of sulfides and gangue minerals. Coarseness of these fragments in galena is from 0.02 to 0.1 mm. Galena is also located in chalcopyrite in the form of inclusions grain size from 0.015 to 0.05 mm, and as well forms the surfaces to 0.15mm.

Sphalerite builds larger surfaces cracked and pushed with galena, tetrahedrite and chalcopyrite, wherein these minerals reach the coarseness of 0.025 mm to 0.1 mm. Sphalerite also occurs in the form of fragments in chalcopyrite and galena, and reaches the coarseness of 0.025 mm to 0.1 mm. Cracks in sphalerite are filled with a gangue minerals.

Likewise, chalcopyrite allocations in sphalerite are characteristic. Chalcopyrite grains, which occur in the form of intergranular film around the sphalerite grains perimeter reach coarseness of 0.010 mm to 0.025 mm, while inside sphalerite grains chalcopyrite allocations can be very small, to under 0.005 mm.

Fine chalcopyrite allocations in galena and sphalerite can cause increased losses of chalcopyrite in lead concentrate and sphalerite in copper concentrate.

Technical and technological description of the flotation concentration pilot-plant process

Based on the laboratory tests results and technical and technological ITNMS equipment capabilities, equipment connection and parameters synchronization is carried out for efficient probe implementation. Technical - technological processing and sampling parameters in the pilot-plant facility were established as follows:

- Flow capacity: $Q=42\text{kg/h}$,
- Grinding coarseness in classifier overflow: 69% -0.074mm,
- Pilot plant probe duration: ~10h/working day
- Sampling interval: $t=15\text{min}$,
- Concentration products were sampled after probe.

According to previously established scheme made on laboratory scale, maintaining all relevant parameters at a constant value, pilot-plant test was carried out.

Continuous monitoring and sampling, to a greater extent, laboratory tests process simulation on the pilot-plant level was carried out, for verification and confirmation of laboratory tests.

Material balance and pilot-plant probe technological indicators

The pilot-plant process products, copper, lead and zinc concentrates were, after 6 days period (10-12 hours per day) of probe, dried and weighed in order to calculate mass balances and to obtain the technological effects data. After completion the entire pilot-plant test on the sample mass $m = 2650.00\text{ kg}$ of dry ore, concentration products representative samples, copper, lead and zinc minerals concentrates and tailings, were sent to chemical characterisation. Material balance and pilot-plant probe technological indicators are shown in Table 1.

Table 1, Material balance and pilot-plant probe technological indicators.

Product	M, %	Cu, %	Pb, %	Zn, %	Ag, g/t	I Cu, %	I Pb, %	I Zn, %	I Ag, %
Feed	100.00	0.86	4.46	2.51	33.71	100.00	100.00	100.00	100.00
C/Cu	3.02	20.88	6.53	4.30	580.00	73.25	4.43	5.17	51.96
C/Pb	5.23	1.30	71.26	4.10	260.00	7.90	83.64	8.53	40.34
C/Zn	3.86	1.20	1.80	52.20	17.10	5.38	1.56	80.15	1.96
Tailings	87.89	0.13	0.53	0.18	2.20	13.47	10.37	6.15	5.74

Technological scheme of copper, lead and zinc minerals flotation concentration in the pilot-plant facility

Figure 7 shows the production copper, lead and zinc minerals flotation concentration technological scheme, with intermediate products and concentrates technological positions.

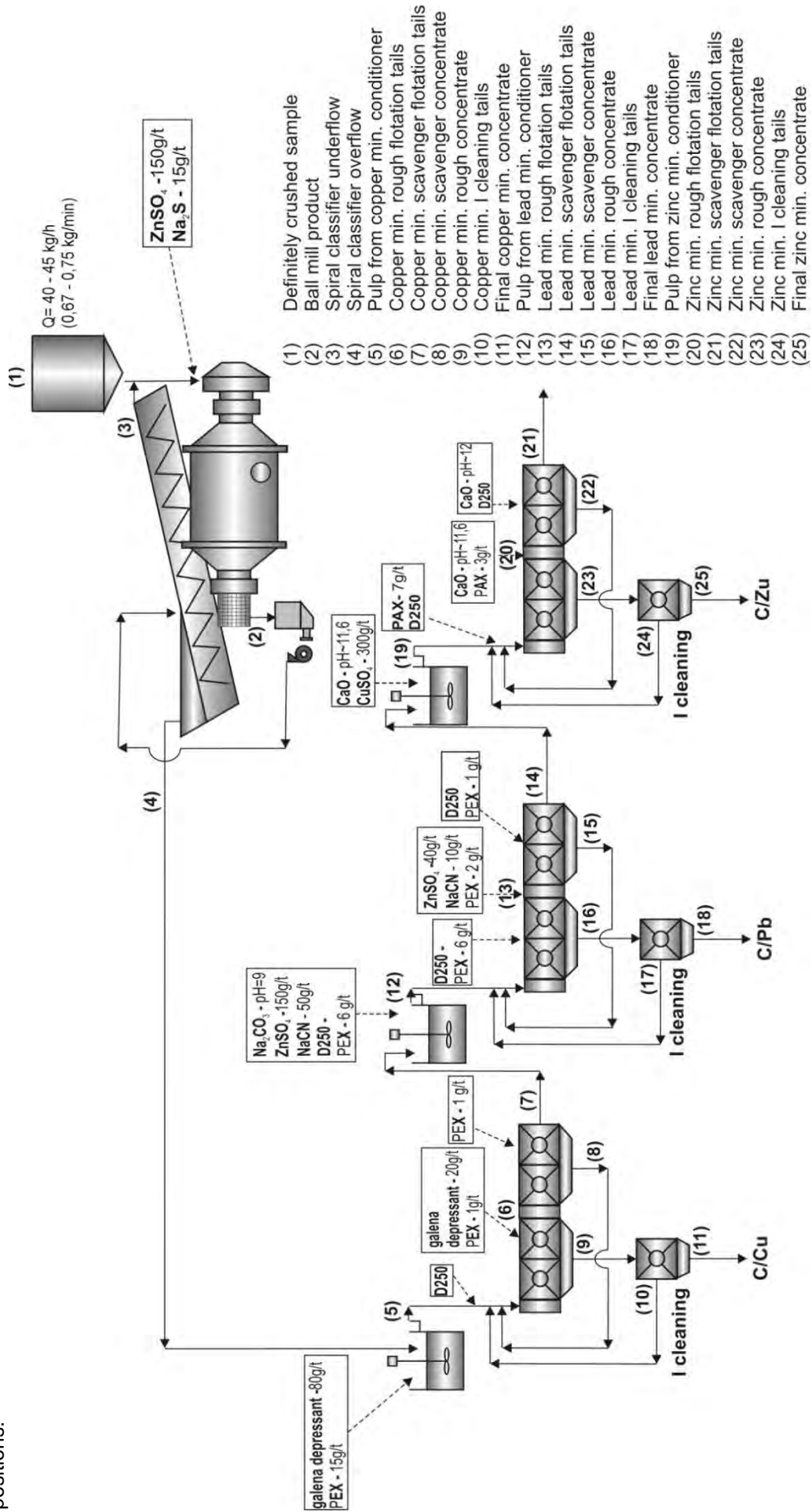


Figure 7. The technological scheme of production copper, lead and zinc mineral concentrates

Technical description of the Cu, Pb and Zn minerals pilot-plant flotation process

Figure 8 shows the technical scheme of copper, lead and zinc minerals pilot-plant flotation process with the installed equipment positional arrangement.

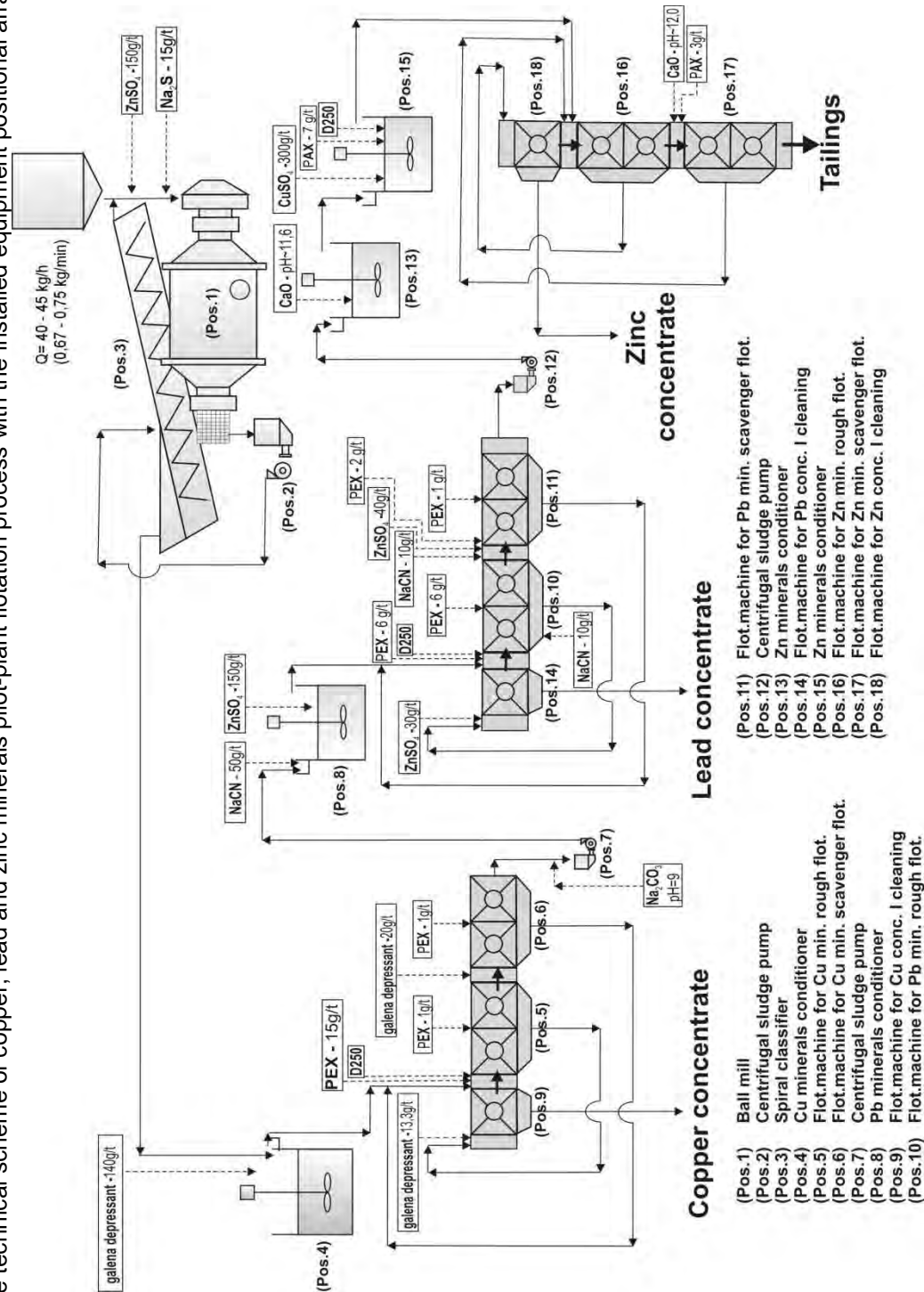


Figure 8, Technical scheme of obtaining copper, lead and zinc mineral concentrates with the equipment positions

Discussion

The main task of useful components flotation concentration pilot-plant process from the tested ore sample was to confirm the laboratory tests results under which technological scheme was defined. It should be noted that the pilot-plant test was performed without greater delays, problems and concentration parameters oscillations, that were monitored. High degree of selectivity was achieved by applying used flotation reagents in the pilot-plant process, which allows obtaining separate copper, lead and zinc concentrates.

Regarding obtained concentrates quality, it can be stated:

Copper concentrate – Considering previous investigations, it was decided in advance to perform only one rough concentrate cleaning stage. Satisfying copper content in copper minerals concentrate was obtained after one rough concentrate cleaning stage. Namely, 20.88% of copper in this product allows its further application in the pyrometallurgical processes.

Also preferred fact is that this copper concentrate contains 6.53% of lead and 4.30% of zinc and which are in the acceptable range for pyrometallurgical standard. Eventual additional cleaning of this concentrate, could decrease lead and zinc content in this concentrate and improve its quality regarding the related components content.

Lead concentrate – As the lead content in this ore is very high, it was decided to perform only one cleaning treatment of lead rough concentrate according to the laboratory tests conditions. In this way, 71.26% of lead content was obtained in the lead final concentrate. Extremely high quality of this product was achieved after a single cleaning treatment. In this way lead minerals flotation is simplified, and also reinforces the given raw material processing techno-economic effects. The 1.30% of copper content is below the upper limit of tolerance and does not present any problem regarding price on market, especially if we take into account that this is a concentrate that can be further enriched.

Zinc concentrate - Content of zinc in this ore is quite high and very challenging in terms of processing and concentration. During the concentration of zinc minerals in pilot-plant process, it was also decided to run just one rough zinc concentrate cleaning treatment. Significantly higher content (52.20% of zinc) was obtained than minimum requirement for the pyrometallurgical processing. From this

point of view it can be concluded that the zinc minerals concentration during the pilot-plant probe completely succeeded.

Regarding the accompanying elements content, points out that 1.20% of copper content is entirely in the range of tolerance for the market and 1.80% of lead content is below the upper limit prescribed value for the further zinc concentrate pyrometallurgical processing.

As already mentioned in comments on copper and lead concentrates, zinc concentrate may be also subjected to additional cleaning flotation process in order to increase the zinc content and a decrease accompanying components content, if necessary.

Based on these facts, it can be concluded that the pilot plant test fully succeeded from the point of confirming the laboratory tests results and conducting a continuous process during the ore sample processing. All mentioned suggests that it is possible to apply the given technological process on an industrial scale, relatively easy way of running processes and control of relevant flotation parameters.

CONCLUSION

After performed pilot-plant test on a rich polymetallic ore sample and the obtained results analysis, it can be concluded as follows:

- The tested ore sample physico-chemical characteristics represents a typical example of a very rich polymetallic ore with high potential and possibility for simple flotation valorization of copper, lead and zinc metals.
- Technical-technological scheme, defined by laboratory tests, is quite simple and applicable in terms of reagent regime, running process possibility and controlling relevant parameters, especially taking into consideration that it is a very rich polymetallic ore.
- Pilot plant flotation test results clearly indicates the possibility of obtaining three high quality separate product copper, lead and zinc concentrates, already after rough concentrates first stage cleaning.
- The impurities contents in the copper, lead and zinc concentrates is within the tolerance limits and therefore does not reduce the economic value of the concentrates.
- Copper, lead and zinc minerals flotation technical and technological parameters enable further purification process of

once cleaned copper, lead and zinc concentrates in order to obtain higher quality and commercially interesting products.

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