



Designation: D 2234 / D 2234 M – 02

Standard Practice for Collection of a Gross Sample of Coal¹

This standard is issued under the fixed designation D 2234 / D 2234 M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

INTRODUCTION

Data obtained from coal samples are used in establishing price, controlling mine and cleaning plant operations, allocating production costs, and determining plant or component efficiency. The task of obtaining a sample of reasonable weight to represent an entire lot presents a number of problems and emphasizes the necessity for using standard sampling procedures.

Coal is one of the most difficult of materials to sample, varying in composition from noncombustible particles to those which can be burned completely, with all gradations in between. The task is further complicated by the use of the analytical results, the sampling equipment available, the quantity to be represented by the sample, and the degree of precision required.

This practice gives the overall requirements for the collection of coal samples. The wide varieties of coal-handling facilities preclude the publication of detailed procedures for every sampling situation. The proper collection of the sample involves an understanding and consideration of the physical character of the coal, the number and weight of increments, and the overall precision required.

1. Scope

1.1 This practice covers procedures for the collection of a sample under various conditions of sampling. The sample is to be crushed and further prepared for analysis in accordance with Method D 2013. However, the procedures for dividing large samples before any crushing are given in this practice.

1.2 This practice describes general and special purpose sampling procedures for coals (1) by size and condition of preparation (for example, mechanically cleaned coal or raw coal) and (2) by sampling characteristics.

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, use each system independently of the other. Combining values from the two systems may result in nonconformance with the standard.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

D 121 Terminology of Coal and Coke

D 2013 Method of Preparing Coal Samples for Analysis²
D 6518 Practice for Bias Testing a Mechanical Coal Sampling System²

E 177 Practice for Use of the Terms Precision and Bias in ASTM Test Methods³

E 456 Terminology Relating to Quality and Statistics²

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 accuracy:

3.1.1.1 *generally*—a term used to indicate the reliability of a sample, a measurement, or an observation.

3.1.1.2 *specifically*—a measure of closeness of agreement between an experimental result and the true value. Example: the observed and true sulfur content of a coal consignment. This measure is affected by chance errors as well as by bias.

3.1.2 *mechanical sampling system*—a single machine or series of interconnected machines whose purpose is to extract mechanically, or process (divide and reduce), or a combination thereof, a sample of coal.

3.1.3 *cross-belt sampler*—a single sampling machine or component of a mechanical sampling system designed to extract an increment directly from a conveyor belt surface by sweeping a sampling device (cutter) through the material on the conveyor.

3.1.4 *falling-stream sampler*—a single sampling machine or component of a mechanical sampling system designed to

¹ These methods are under the jurisdiction of ASTM Committee D05 on Coal and Coke and are the direct responsibility of Subcommittee D05.23 on Sampling.

Current edition approved June 10, 2002. Published September 2002. Originally published as D 2234 – 63 T. Last previous edition D 2234 – 00¹.

² *Annual Book of ASTM Standards*, Vol 05.06.

³ *Annual Book of ASTM Standards*, Vol 14.02.

extract an increment from a falling stream of coal at the discharge end of a conveyor or chute by moving a sampling device (cutter) through the falling stream of material.

3.1.5 *gross sample*—a sample representing one lot of coal and composed of a number of increments on which neither reduction nor division has been performed.

3.1.6 *increment*—a small portion of the lot collected by one operation of a sampling device and normally combined with other increments from the lot to make a gross sample.

3.1.7 *probability sample*—a sample collected using a sampling process such that at each stage of the process, a specified non-zero probability of being selected for the sample can be attached to every sampling unit in the lot to be sampled. Given adequate information about the sample results obtained using probability sampling, the probability distribution of sampling errors can be estimated.

3.1.8 *sample*—a quantity of material taken from a larger quantity for the purpose of estimating properties or composition of the larger quantity.

3.1.9 *size consist*—the particle size distribution of a coal.

4. Summary of Practice

4.1 The general-purpose sampling procedures are intended to provide, in 19 of 20 cases, dry ash results that are within an interval of $\pm 1/10$ of the average dry ash results that would be obtained in hypothetical repeated sampling.

4.2 Special-purpose sampling procedures apply to the sampling of coal when other precision limits are required, or when other constituents are used to specify precision, or for performance tests.

4.3 For coals of known size and condition of preparation, tables are given for the determination of the number and weight of increments required for a gross sample for both general and special-purpose sampling.

4.4 The procedures appear in the following order:

Test Method	Section
Sampling of Coals Based on Size and Condition of Preparation	8.1
General-Purpose Sampling Procedure	8.1.1
Number and Weight of Increments	8.1.1.2
Number of Gross Samples	8.1.1.4
Special-Purpose Sampling	8.1.2
Number and Weight of Increments	8.1.2.2
Number of Gross Samples	8.1.2.3
Division of the Gross Samples Before Crushing	8.2
Sampling of Coal for Total Moisture Determination	8.3
Types of Moisture Samples	8.3.1
Entire Gross Samples	8.3.1.1
Special Moisture Subsamples	8.3.1.2
Other Subsamples for Moisture Testing	8.3.1.3
Special Precautions	8.3.2
Weight of Increments	8.3.3
Number of Increments	8.3.4
Moisture Sampling Based Only on Size	8.3.4.1

5. Significance and Use

5.1 It is intended that this practice be used to provide a sample representative of the coal from which it is collected. Because of the variability of coal and the wide variety of sampling equipment, caution should be used in all stages of sampling from system specifications and equipment procurement to equipment acceptance testing and actually taking the final sample.

5.2 After further processing (Method D 2013), the sample may be analyzed for a number of different parameters. These parameters may affect the lot's value, its ability to meet specifications, its environmental impact, as well as other properties.

6. Increment Collection Classification

6.1 The type of selection, the conditions under which individual increments are collected, and the method of spacing of increments from the coal consignment or lot are classified according to the following descriptions and Table 1. These designations are to be used for sampling specifications and for descriptions of sampling programs and sampling equipment.

TABLE 1 Increment Types, Conditions, and Spacing

Condition of Increment Collection from the Main Body of Coal	Types of Increment			
	Type I No Human Discretion Is Used		Type II Human Discretion Is Used	
	Spacing of Increments		Spacing of Increments	
	1. Systematic	2. Random	1. Systematic	2. Random
Condition A, stopped belt cut	I-A-1	I-A-2	II-A-1	II-A-2
Condition B, full-stream cut	I-B-1	I-B-2	II-B-1	II-B-2
Condition C, part-stream cut	I-C-1	I-C-2	II-C-1	II-C-2
Condition D, stationary sampling	I-D-1	I-D-2	II-D-1	II-D-2



6.2 *Types of Increments*—The types of selection of increments are based on whether or not there is human discretion in the selection of the pieces of coal or portions of the coal stream.

6.2.1 *Type I*, in which specific pieces or portions are not subject to selection on a discretionary basis. This includes that in which the increment is collected in precise accord with previously assigned rules on timing or location that are free of any bias. Type I selection increments generally yield more accurate results.

6.2.2 *Type II*, in which some measure of human discretion is exercised in the selection of specific pieces of coal or of specific portions of the stream, pile, or shipment.

6.3 *Conditions of Increment Collection*—The conditions under which individual increments are collected are the conditions of the main body of coal relative to the portion withdrawn. Four conditions are recognized:

6.3.1 *Condition A (Stopped-Belt Cut)*, in which a loaded conveyor belt is stopped and a full cross-section cut with parallel sides is removed from the coal stream. The distance between the parallel faces shall not be less than three times the normal top size of the coal.

6.3.2 *Condition B (Full-Stream Cut)*, in which a full cross-section cut is removed from a moving stream of coal.

6.3.3 *Condition C (Part-Stream Cut)*, in which a portion, not a full cross section, is removed from a moving stream of coal.

6.3.4 *Condition D (Stationary Coal Sampling)*, in which a portion of coal is collected from a pile, a rail car, a barge, or a shiphold.

6.4 *Spacing of Increments*—The spacing of increments pertains to the kind of intervals between increments. Two spacing methods are recognized: systematic and random. Systematic spacing is usually preferable.

6.4.1 *Systematic Spacing 1*, in which the movements of individual increment collection are spaced evenly in time or in position over the lot.

6.4.2 *Random Spacing 2*, in which the increments are spaced at random in time or in position over the lot.

7. Organization and Planning of Sampling Operations

7.1 This practice provides definitive procedures for the collection of a gross sample. Parties claiming to use this practice must adhere to the procedures as set out in this standard. If the sampling is not done in accordance with the procedures set out in this practice then that sample may not be suitable for comparison with a sample collected by the procedures described in this practice. Since it may be impracticable or impossible to take another sample of a given lot of coal it is essential that parties agree on sampling procedures prior to undertaking sampling.

7.2 *Selection of Appropriate Sampling Procedure*—Variations in coal-handling facilities make it impossible to publish rigid rules covering every sampling situation in complete and exact details. Proper sampling involves an understanding and proper consideration of the minimum number and weight of increments, the size consist of the coal, the condition of preparation of the coal, the variability of the constituent sought, and the degree of precision required.

7.2.1 *Number and Weight of Increments*—The number and weight of increments required for a given degree of precision depends upon the variability of the coal. This variability increases with an increase in free impurity. A coal high in inherent impurity and with comparatively little free impurity may exhibit much less variability than a coal with a low inherent impurity and a relatively high proportion of free impurity. For most practical purposes, an increase in the ash content of a given coal usually indicates an increase in variability. It is imperative that not less than the minimum specified number of increments of not less than the minimum specified weight be collected from the lot. For Condition D, the increments shall be of equal weight.

7.2.2 *Increment Collection Method to Be Used*—To obtain complete representation of all sizes, it is most desirable that the sample increments be withdrawn from the full cross section of the stream. The best possible increment is a full cross-section cut removed from a stopped belt, Classification I-A-1 in Table 1. The best possible increment from a flowing stream of coal is one obtained by moving a cutter device entirely across the stream at a uniform speed, the same for each increment, into one side of the stream and out of the other, without allowing the receptacle to overflow (Classification I-B-1 in Table 1). Classification methods given in Table 1 are listed in order of decreasing reliability. The highest possible classification method, wherever feasible, should be used. Details of sampling procedures should be agreed upon in advance by all parties concerned. Whenever circumstances dictate utilization of increment collection classifications “Condition C” or “Condition D” or “Type II,” details of sampling procedure shall be agreed upon in advance by all parties concerned.

7.3 *Distribution of Increments*—It is essential that the increments be distributed throughout the lot to be sampled. This distribution is related to the entire volume of the lot, not merely its surface or any linear direction through it or over it. If circumstances prevent the sampler from applying this principle, the lot is sampled only in part, and the gross sample is representative only of this part. The spacing of the increments shall be varied if the possibility exists that increment collection may get “in phase” with the sequence of coal variability. Example: routine sampling of commercial coal from a continuous stream (conveyor belt) in which increment collection is automatic and its sequence coincides with the “highs” or “lows” in the content of fines.

7.4 *Dimensions of Sampling Device*—The opening of the sampling device shall be no less than 2.5 times the nominal top size of the coal and no less than 30 mm [1.25 in.]. The sampling device shall be of sufficient capacity to completely retain or entirely pass the increment without spillage at the maximum rate of coal flow.

7.5 *Characteristics and Movement of Sampling Device*—In sampling from moving streams of coal, the sampling device shall be designed to collect each increment with no selective rejection of material by size and with no contamination by nonsample material.

7.5.1 *Falling-Stream Sampler*—In collecting an increment, the falling-stream cutter should move at a constant velocity through the entire cross section of the stream of coal. The mass

m , in kg [lbs.], of material collected in one pass through the stream a by falling-stream cutter with cutting edges and cutter velocity perpendicular to the stream flow is calculated from the following equation:

$$m = \frac{Cw}{3.6v_c} \left[m = \frac{Cw}{1.8v_c} \right] \quad (1)$$

where:

C = the stream flow rate in Mg/hr [ton/hr]
 w = the tip-to-tip cutter aperture width in mm [in.] and,
 v_c = the cutter speed in mm/s [in./s]

NOTE 1—Falling stream cutter speeds of 460 mm/s [18in./s] or less have been found to produce acceptable results.

NOTE 2—The constant value 3.6 [1.8] in the denominator of Eq.1 and Eq.2 converts Mg/hr to kg/s [ton/hr to lbs/s].

7.5.2 Cross-Belt Sampler—The cross-belt cutter should be designed and operated at a velocity across the conveyor surface that is high enough to prevent selective rejection of material by size, prevent contamination of the sample with material not collected within the cutter, and avoid mechanical problems due to damming of conveyed material against the outside of the cutter body as the cutter travels through the stream. Furthermore, the design should assure a complete increment extraction, and the arc of travel of the sweep-arm cutter should closely fit the configuration of the conveyor belt. The mass m , in kg [lbs], of material collected in one pass through the moving stream by a cutter with cutting edges and cutter velocity perpendicular to the stream flow is calculated from the following equation:

$$m = \frac{Cw}{3.6v_b} \left[m = \frac{Cw}{1.8v_b} \right] \quad (2)$$

where:

C = the stream flow rate in Mg/hr [tons/hr]
 w = the tip-to-tip cutter aperture width in mm [in.], and
 v_b = the conveyor belt speed in mm/s [ton/s]

NOTE 3—To avoid mechanical problems and spillage and to assure correct sample delimitation the higher ratio of cutter speed to belt speed the better. Ratios of cutter speed to belt speed of 1.5 or greater have been found to produce acceptable results.

7.6 There shall be no structural member or other impediment with a cutter body that impedes either sample collection or sample discharge.

7.7 Preservation of Moisture—The increments obtained during the sampling period shall be protected from changes in composition as a result of exposure to rain, snow, wind, sun, contact with absorbent materials, and extremes of temperature. The circulation of air through equipment must be reduced to a minimum to prevent both loss of fines and moisture. Samples in which moisture content is important shall be protected from excessive air flow and then shall be stored in moisture-tight containers. Metal cans with airtight lids, or heavy vapor-impervious bags, properly sealed, are satisfactory for this purpose.

7.8 Contamination—The sampling arrangement shall be

planned so that contamination of the increments with foreign material or unrelated coal does not create bias of practical consequence.

7.9 Mechanical System Features—It is essential that mechanized systems as a whole, including sampling machines, chutes, feed conveyors, crushers and other devices, be self-cleaning and non-clogging and be designed and operated in a manner that will facilitate routine inspection and maintenance.

7.10 Personnel—Because of the many variations in the conditions under which coal must be sampled, and in the nature of the material being sampled, it is essential that the samples be collected under the direct supervision of a person qualified by training and experience for this responsibility. Where human labor is employed to collect the increments, it is essential that samples be collected by a trained and experienced sampler or under the direct personal observation of such a person. This includes sampling for the purpose of determining sampling characteristics of a coal or characteristics of a particular sampling apparatus.

7.11 Criteria of Satisfactory Performance—A satisfactory sampling arrangement is one that takes an unbiased sample at the desired degree of precision of the constituent for which the sample is to be analyzed. One fundamental characteristic of such an arrangement is that the size consist of the sample will adequately represent the true size consist of the coal. Sampling systems shall be tested initially and at regular intervals to determine whether the sample adequately represents the coal. In addition, sampling systems should be given a rough performance check as a matter of routine. This is done by comparing the weight or volume of collected sample with that of the total flow of coal to ensure a constant sampling ratio.

7.12 Relative Location of Sampling and Weighing—It is preferable that coal be weighed and sampled at the same time. If there is a lapse in time between these two events, consideration should be given by both the purchaser and the seller to changes in moisture during this interval and the consequent shift in relationship of moisture to the true quality of the coal at the instant when ownership of the coal transfers from one to the other.

8. Procedures

8.1 Sampling of Coals Based on Size and Condition of Preparation:

8.1.1 General-Purpose Sampling:

8.1.1.1 Where probability sampling is employed, the general-purpose sampling procedures are intended to provide, in 19 of 20 cases, dry ash results that are within the interval of $\pm 1/10$ of the average dry ash results that would be obtained in hypothetical repeated sampling.

NOTE 4—Neither samples collected using part-stream increment collection nor samples collected from stationary coal are probability samples because in each case there are portions of the lot that have no chance of being selected for the sample.

8.1.1.2 **Number and Weight of Increments**—Obtain the number and weight of increments as specified in Table 2 except as provided in 8.1.1.5(b). Determine the minimum number of increments from the condition of preparation, and determine the minimum weight of each increment from the top size of the coal. Classify the coals to be sampled according to the general

TABLE 2 Number and Weight of Increments for General Purpose Sampling Procedure^A

Top Size	¾ 16 mm]	2 in. [50 mm]	6 in. [150 mm] ^B
Mechanically Cleaned Coal ^C			
Minimum number of increments	15	15	15
Minimum weight of increments, lbs	2	6	15
Minimum weight of increments, kg	1	3	7
Raw (Uncleaned Coal) ^C			
Minimum number of increments	35	35	35
Minimum weight of increments, lbs	2	6	15
Minimum weight of increments, kg	1	3	7

^AUnder Conditions C and D, see 7.2.1 and 7.2.2.

^BFor coals above 6-in. [150-mm] top size, the sampling procedure should be mutually agreed upon in advance by all parties concerned.

^CIf there is any doubt as to the condition of preparation of the coal (for example, mechanically cleaned coal or raw coal), the number of increments for raw coal shall apply. Similarly, although a coal has been mechanically cleaned, it may still show great variation because of being a blend of two different portions of one seam or a blend of two different seams. In such cases, the number of increments should be as specified for raw (uncleaned) coal.

purpose procedure into three groups by top size. Further classify each of these groups into two subgroups in accordance with the condition of preparation. These classifications are shown in Table 2.

8.1.1.3 Variations in construction of the sampling device and flow, structure, or size consist of the coal may make it impracticable to collect increments as small as the minimum weight specified in Table 2. In such cases, collect an increment of greater weight. However, do not reduce the minimum number of increments, regardless of large excesses of individual increment weights. Table 2 lists the absolute minimum number of increments for general-purpose sampling which may not be reduced except as specified in 8.1.1.5(b). Other considerations may make it advisable or necessary to increase this number of increments.

8.1.1.4 *Number of Gross Samples*—Under the general-purpose sampling procedure, for quantities up to approximately 1000 Mg [1000 tons] it is recommended that one gross sample represent the lot. Take this gross sample in accordance with the requirements prescribed in Table 2.

8.1.1.5 For quantities over 1000 Mg [1000 tons], use any of the following alternatives:

(a) Take separate gross samples for each 1000 Mg [1000 tons] of coal or fraction thereof.

$$N = K \sqrt{\frac{L}{1000}} \quad (3)$$

where:

L = the number of Mg [tons]

K = 15 for mechanically cleaned coal or 35 for raw coal (see Table 2)

(b) Take separate gross samples for each 1000 Mg [1000 tons] lot of coal or fraction thereof, and thoroughly mix their No. 60 sieve size analysis samples together in proportion to the tonnage represented by each sample. Make one analysis of the composite sample.

NOTE 5—Practical experience indicates that the maximum size of a lot of coal to be represented by one gross sample should not exceed 10 000 Mg [10 000 tons].

8.1.2 *Special-Purpose Sampling:*

8.1.2.1 This special-purpose sampling procedure shall apply to the sampling of coal when increased precision is required,

and the only knowledge of the coal is its top size and conditions of preparation.

8.1.2.2 *Number and Weight of Increments*—Take the same number and weight of increments per gross sample as specified in Table 2, or as specified in 8.1.1.5(b).

8.1.2.3 *Number of Gross Samples*—To obtain increased precision for the final result for a given consignment, increase the number of gross samples collected from that consignment and analyze each gross sample separately, reporting the average of results. To reduce errors to one half, that is, to “double” the precision, take four times as many gross samples. Similarly, to reduce errors to one third, to “triple” the precision, take nine times as many gross samples.

8.2 *Division of the Gross Sample Before Crushing:*

8.2.1 In the case of very large and unwieldy gross samples, it is permissible to divide the gross sample to reduce its weight, provided the following conditions are fulfilled:

8.2.1.1 If the entire gross sample is mixed in a suitable blender (double-cone or twin-shell tumbler) it is permissible to divide the sample using the schedule of Table 2. Test the divided sample for bias.

8.2.1.2 If each very large increment is reduced in quantity by secondary sampling, take at least six secondary increments from each primary increment. The method of collection of secondary increments must be proved to be free from bias. In no case shall the weight of a secondary increment be less than shown in the schedule of Table 2.

8.3 *Sampling of Coal for Total Moisture Determinations:*

8.3.1 *Types of Moisture Samples*—Moisture determinations as specified in the method to be used are to be made on the following kinds of samples.

8.3.1.1 *Entire Gross Sample*—For referee tests, air dry the entire gross sample and measure the weight loss from the entire gross sample during this drying. This procedure can be carried out on the entire gross sample as a single batch or on groups of primary increments or as separate operations on the individual primary increments; obtain, by one of these means, the total weight loss from the entire gross sample. After this air drying, the sample can be crushed or divided, or both, as required by the referee test for moisture.

8.3.1.2 *Special Moisture Subsample*—For moisture testing, a special subsample can be taken from a gross sample before any operations of air drying or crushing. Take this subsample

from the gross sample in accordance with the requirements of 8.3.

8.3.1.3 *Other Subsamples for Moisture Testing*—For moisture testing, a subsample can be used that is collected after the initial crushing and dividing of a gross sample. The procedures for the crushing and dividing, and for this subsequent subsampling for moisture, are given in Method D 2013.

8.3.2 *Special Precautions*—Collect samples and subsamples for moisture in such a manner that there is no unmeasured loss of moisture of significant amount. Make adequate weighings before and after drying or other operations to measure all significant weight losses.

8.3.3 *Weight of Increments*—The minimum weight of each increment must be that which is sufficient as to be free of bias. This depends on the top size of the coal in the stream being sampled, the dimensions of the collection device, and other factors of the withdrawal of the increment. Since much of the moisture tends to be distributed uniformly across the surface, moisture bias is present when the size consist of the sample is not the same as the size consist of the lot sampled. In addition, when there is no knowledge of the sampling characteristics for moisture, each increment shall not weigh less than the values in Table 2.

8.3.4 *Number of Increments*—The number of increments required for a given degree of precision depends on the weight of the increments, the distribution of the moisture, and the total amount of moisture. The distribution of moisture, however, is

not easily evaluated independent of total moisture; consequently, the combined effects can be measured by determining the sampling characteristics for moisture.

8.3.4.1 *Moisture Sampling Based Only on Size*—When there is no knowledge of the sampling characteristics for moisture, collect at least the number of increments from the lot of coal as those given in Table 2. When a special moisture subsample is taken from the gross sample before any drying or crushing operations, collect the number of increments for the subsample as specified in 8.2.

8.4 *Maintenance of Mechanical Sampling Equipment*

8.4.1 Assure that mechanical sampling equipment is easily and safely accessible throughout to facilitate inspection, cleaning, or repairs.

8.4.2 Wear of mechanical components may eventually cause a system, which had originally been checked satisfactorily for bias, to produce biased samples. Inspect mechanical systems frequently and in accordance with a planned maintenance scheme in order to ensure continuous reliable operation by detecting and repairing system components that have undergone wear beyond a critical level or are broken.

9. Precision and Bias

9.1 The precision of the general-purpose sampling procedure, based on size and condition of preparation, is stated in 8.1.1.1. If a different precision is required, reference 8.1.2.

9.2 Mechanical sampling systems are tested for bias using the procedures of Practice D 6518.

ANNEX

(Mandatory Information)

A1. TEST METHOD FOR ESTIMATING THE OVERALL VARIANCE FOR INCREMENTS

A1.1 Scope

A1.1.1 This test method describes the procedure for estimating the overall variance for increments of one fixed weight of a given coal. It is applicable to mechanical sampling when there is no need to explore system and random variance components, but there is a need for obtaining the overall variance for increments (the size of increments is dictated by the sampling equipment).

A1.2 Procedure

A1.2.1 The following procedure should be used to determine the overall variance of increments:

A1.2.2 Collect two series of individual increments at widely spaced intervals, for example, a series of ten increments, two each day for five days, followed by a second series of ten collected in similar fashion. Both series must be from the same coal.

A1.2.3 Collect each increment by using as much of the equipment and procedure used in routine sampling operations as possible. Remove the individual increment from the sampling system without mixing with or contaminating by any other increment. Where possible, allow it to pass through any

mechanical crusher or subsampler, or both, which is located in the system before the point of blending with other increments.

A1.2.4 Then weigh the individual increment (if desired for record purposes) and reduce to a laboratory sample by procedures identical as possible to those used in the routine preparation and reduction of gross samples.

A1.2.5 Analyze the sample for the constituents for which the variance calculations are to be made. Usually sampling specifications are based on dry ash, but where total moisture or as-received Btu is of particular concern, the analyses should be made for these.

TABLE A1.1 Variance Ratio Limit Values

1	2	3
Increment per Set	Variance Ratio Limit	"C" Factor
10	3.18	1.92
20	2.17	1.53
30	1.86	1.40
40	1.70	1.33
50	1.61	1.29

A1.3 Calculation

A1.3.1 For each series, compute a variance value from the analyses of the ten increments as follows:

$$s^2 = (\Sigma x^2 - (\Sigma x)^2/n)/(n - 1) \quad (\text{A1.1})$$

where:

- s^2 = variance value for series,
- Σx^2 = sum of squares of ash results,
- $(\Sigma x)^2$ = square of the sum of ash results, and
- n = number of individual ash results in the series.

A1.3.2 For the two series, the ratio of the larger variance to the smaller should not exceed the value given in Table A1.1, Column 2. If they differ by less than this amount, the variances are combined to give the estimated overall increment variance for the coal as follows:

$$s_o^2 = C[(s_1^2 + s_2^2)/2] \quad (\text{A1.2})$$

where:

- s_o^2 = probable maximum value of the overall variance for increments;

- C = factor from Table A1.1, Column 3, corresponding to the number of increments per set;
- s_1^2 = s^2 from first series; and
- s_2^2 = s^2 from second series.

A1.3.3 If the ratio of the larger variance to the smaller does give a greater value than the Table A1.1, Column 2 value, the two series are to be considered in a single set of increments, and another set equal to this enlarged set is to be taken. For example, if originally 2 sets of 10 increments were taken, these would be combined to give a set of 20. Then an additional set of 20 increments would be collected, giving 2 sets of 20 increments each. Variance values are computed for the two new series and the test is repeated using the appropriate factors given in Table A1.2. If these results have a ratio which is less than the appropriate value in Column 2 of Table A1.2, they are combined by using Eq A1.2 and used as the new variance for increments.

A1.3.4 *Example*—The example given in Table A1.2 illustrates the computation of the overall variance for increments, s_o^2 . Two series of ten increments each are used.

TABLE A1.2 Determination of the Overall Variance for Increments^A

Series 1			Series 2		
Increment Number, <i>n</i>	Dry Ash ^B (<i>x</i>)	(Dry Ash) ^{2B} (<i>x</i>) ²	Increment Number, <i>n</i>	Dry Ash ^B (<i>x</i>)	(Dry Ash) ^{2B} (<i>x</i>) ²
1	4.17	17.3889	11	3.07	9.4249
2	3.62	13.1044	12	4.88	23.8144
3	1.79	3.2041	13	5.14	26.4196
4	4.37	19.0969	14	3.63	13.1769
5	4.64	21.5296	15	3.17	10.0489
6	7.03	49.4209	16	7.20	51.8400
7	6.27	39.3129	17	3.52	12.3904
8	3.91	15.2881	18	0.87	0.7569
9	6.04	36.4816	19	0.72	0.5184
10	<u>4.18</u>	<u>17.4724</u>	20	<u>4.78</u>	<u>22.8484</u>
Sum	46.02	232.2998	Sum	36.98	171.2388

^AThis example involves increment weights in the approximate range from 45 to 90 kg (100 to 200 lbs).

^B10 % ash was subtracted from each of the ash results to simplify the calculations.

$$s^2 = (\Sigma(x)^2 - (\Sigma x)^2/n)/(n - 1)$$

Series 1:

$$s_1^2 = (232.2998 - (46.02)^2/10)/9 = 2.2795$$

Series 2:

$$s_2^2 = (171.2388 - (36.98)^2/10)/9 = 3.8319$$

Variance ratio limit from Table A1.1 = 3.18.

Variance ratio for two test series:

$$s_2^2/s_1^2 = 3.8319/2.2795 = 1.68 < 3.18$$

Since the computed value for the ratio is less than 3.18, variances are combined to give an estimate of the overall variance for increments, s_o^2 :

$$s_o^2 = [1.92(2.2795 + 3.8319)]/2 = 5.867$$

APPENDIX

(Nonmandatory Information)

X1. MONITORING COAL SAMPLING RATIOS USING CONTROL CHARTS

X1.1 Scope

X1.1.1 This procedure may be used to monitor the consistency of coal sampling ratios obtained with common mechanical sampling system control settings of cutter operating intervals, cutter openings, cutter speeds (for falling-stream samplers), and belt speeds (for cross-belt samplers). Out-of-control conditions (see Section X1.4) or excessive variation (see Section X1.5) will serve to alert the operator to potential problems that need to be investigated.

X1.2 Rationale (Commentary)

X1.2.1 The standard suggests that sampling systems should be given a rough performance check as a matter of routine by comparing the weight or volume of the collected sample with that of the total flow of coal to ensure a constant sampling ratio (see 7.11). The procedure offered in this Appendix is one means of continual monitoring of the consistency of the sampling ratio using methodology following the general principles of the *ASTM Manual on Presentation of Data and Control Chart Analysis*. An explanation of the value and use of control charts is given in *Out of the Crisis*.⁴

X1.3 Data Collection and Charting Procedure

X1.3.1 For each lot sampled using a common sampling scheme, obtain and record the net weight of the sample collected at the final stage of mechanical sampling before any off-line sample preparation. Weights should be accurate to within 0.5 % of the weight recorded.

X1.3.2 Obtain and record the lot size (in Mg or tons) using belt scales or other similarly accurate device normally used for determining the lot size.

X1.3.3 Divide the sample weight by the lot size and express the result in pounds per 1000 kilograms or tons per 1000 metric tons.

X1.3.4 Calculate the average sampling ratio \bar{r} using Eq X1.1, where n is the number of sampling ratios in the chart and r_j is the i th sampling ratio in the series of ratios numbered 1 to n . The central line on the chart (CL) is equal to the average, \bar{r} .

$$\bar{r} = \frac{1}{n} \sum_{i=1}^n r_i \quad (X1.1)$$

X1.3.5 Calculate the average moving range \bar{R} using Eq X1.2, where Abs denotes the absolute value.

$$\bar{R} = \frac{1}{n-1} \sum_{i=2}^n \text{Abs}(r_i - r_{i-1}) \quad (X1.2)$$

X1.3.6 Calculate the lower control limit line (LCL) and

⁴ Deming, W.E., *Out of the Crisis*, MIT Center for Advanced Engineering Studies, 1986, pp. 309–370.

upper control limit line (UCL) as,

$$LCL = \bar{r} - 2.66\bar{R} \quad (X1.3)$$

$$UCL = \bar{r} + 2.66\bar{R}$$

NOTE X1.1—The values of these limits are such that if there is a common system of chance causes of variation (no special cause is present) there is only about 1 chance in 100 that a sampling ratio value will be either below the value LCL or above the value UCL.

NOTE X1.2—The constant 2.66 is not a function of the number of n of sampling ratios being charted.

X1.3.7 Plot the sampling ratios on a line chart, with the vertical axis denoting sampling ratio values the horizontal axis denoting dates (and times, if appropriate). Sampling ratios values should always be plotted in chronological order. Add the central line (CL), the lower control limit line (LCL), and the upper control limit line (UCL) to the chart. See Fig. X1.1.

X1.4 Detection of Special Causes (Out-of-Control Conditions)

X1.4.1 A special cause of variation is indicated if one or more values are either above the upper control line or below the lower control line.

X1.4.2 A special cause of variation is indicated when there is a run defined by one of the following:

(a) At least seven consecutive values are on one side of the central line.

(b) At least ten out of eleven consecutive values are on one side of the central line.

(c) At least twelve out of fourteen consecutive points on one side of the central line.

X1.4.3 A special cause of variation is indicated if there is a trend indicated by at least seven consecutive points increasing continually or at least seven consecutive points decreasing continually.

X1.4.4 If no out-of-control conditions are indicated, the sampling system is considered to be stable and in-control.

X1.5 Monitoring the Coefficient of Variation

X1.5.1 When there are 20 or more sampling ratios charted ($n \geq 20$) and the system is stable, calculate the percent coefficient of variation (%cv) using,

$$\%cv = \frac{s_r(100)}{\bar{r}} \quad (X1.4)$$

where s_r is the sample standard deviation of the sampling ratios obtained from

$$s_r = \left[\frac{1}{n-1} \sum_{i=1}^n (r_i - \bar{r})^2 \right]^{1/2} \quad (X1.5)$$

X1.5.2 A value for the %cv greater than 15 may indicate a need for system improvement. Among the items to be checked include the consistency of velocity of sampling system cutters; the cleanliness of oil and filters; hydraulic oil temperature variations; proper operation of all valves, cylinders, and pumps; the consistency of operation of timers; and the accuracy of the sample weights and lot sizes used in the calculations.

X1.6 Monitoring the Average Observed Sampling Ratio

X1.6.1 The division ratio d of either a falling stream or a cross-belt sampler is calculated from the following equation:

$$d = \frac{w}{tv} \quad (X1.6)$$

where:

- w = the tip-to-tip cutter aperture width, in mm [in.],
- t = the operating interval, in seconds, and
- v = the velocity of the cutter (for falling stream samplers) or velocity of the conveyor belt (for cross-belt samplers) in mm/s [in./s].

X1.6.2 The division ratio d_{sys} for a sampling system consisting of N sampling stages is calculated from the following equation:

$$d_{sys} = d_1 d_2 \dots d_N \quad (X1.7)$$

where:

- d_1 = the division ratio for the primary stage
- d_2 = the division ratio for the secondary stage, and
- d_N = the division ratio for the Nth stage

X1.6.3 The expected value of the observed sampling ratio is the design sampling ratio (alternatively known as the theoretical sampling ratio). The value r_D , in kg per thousand Mg [pounds per thousand tons] is calculated from the following equation:

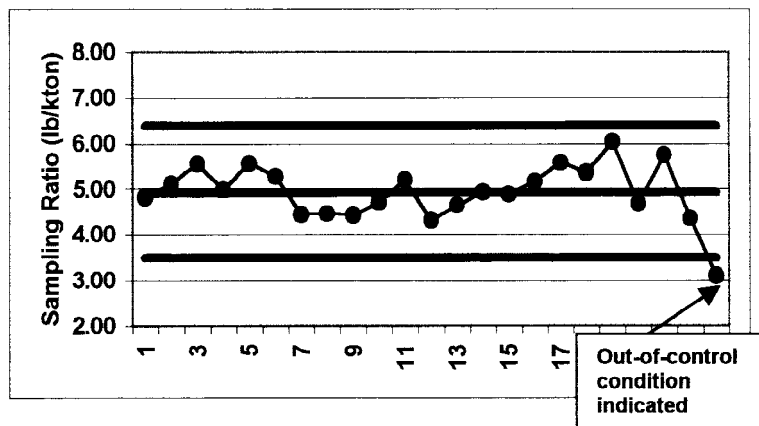


FIG. X1.1 Sampling Ratio Values

 **D 2234 / D 2234 M – 02**

$$r_D = d_{sys} K \quad (X1.8)$$

where:

$$K = 1,000,000 [2,000,000]$$

NOTE X1.3—The term design sampling ratio means the sampling ratio expected (by design), given the specific set of operating parameters (w, t, v) for each sampling stage. If one or more of these operating parameters is changed at any stage of sampling, the design sampling ratio changes.

NOTE X1.4—The constant value K in Equation X1.8 converts the division ratio from a fraction to units of kg/1000 Mg [lb/1000 ton].

Table X1.1 illustrates an example of such calculations.

X1.6.4 When there are twenty or more observed sampling ratios charted with no out-of-control condition indicated and

TABLE X1.1 Calculations of Systems Design Sampling Ratio

	w	t	v	d	r _D
Primary stage	6 in.	190 s	100 in./s	0.0003158	
Secondary stage	2 in.	21 s	14 in./s	0.0068027	
System				2.148E-06	4.30 kton/lb.

the %cv calculated using Eq. X1.4 is less than fifteen percent, compare the average observed ratio to the calculated design ratio. If the difference between the design ratio and the average observed ratio is greater than ten percent of the design ratio, an investigation of the cause is needed. One of the following may have occurred: (1) There is a significant error in one of the measured parameters w, t, or v for one or more stages of sampling. (2) There is a mechanical problem with the sampling system.

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