
**Aluminium oxide primarily used for the
production of aluminium — Method for
the determination of flow time**

*Oxyde d'aluminium principalement utilisé pour la production
d'aluminium — Méthode de détermination du temps d'écoulement*

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ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

Contents

	Page
Foreword.....	iv
Introduction.....	v
1 Scope.....	1
2 Normative references.....	1
3 Principle.....	1
4 Apparatus.....	1
5 Sample preparation.....	1
6 Procedure.....	2
6.1 General.....	2
6.2 Number of determinations.....	2
6.3 Determination.....	2
7 Reporting of results.....	2
8 Precision.....	2
9 Test report.....	3
Annex A (informative) Results of planned trial.....	5
Bibliography.....	6

Foreword

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

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

The committee responsible for this document is ISO/TC 226, *Materials for the production of primary aluminium*.

Introduction

This International Standard is based on Australian Standard, AS 2879.9, *Alumina—Determination of flow time*.

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Aluminium oxide primarily used for the production of aluminium — Method for the determination of flow time

1 Scope

This International Standard sets out a method for determining the amount of time taken for a given quantity of smelter-grade alumina to flow by gravity through a precisely constructed standard funnel.

NOTE Variations in the apparatus and other test variables can create significant inter-laboratory differences in results. (See [Table A.1](#).)

2 Normative references

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

AS 4538.2, *Guide to the sampling of alumina — Part 2: Preparation of samples*

3 Principle

The standard funnel is loaded with a specified mass of alumina. The time for the alumina to flow out of the funnel is determined.

4 Apparatus

4.1 General

The test may be carried out using manual or automatic timing. An automatic device is shown in [Figure 1](#).

4.2 Funnel, precisely constructed of a corrosion resistant metal, e.g. brass or aluminium, as shown in [Figure 2](#) with an abrasion resistant material, e.g. hardened stainless steel, insert with an outlet diameter of (3,95 to 4,00) mm; this diameter is critical.

4.3 Stand, a suitable device for supporting the funnel.

4.4 Timing device, either a stop watch or automated device capable of an accuracy of 1 s.

4.5 Top-loading balance, capable of weighing 100 g to the nearest 0,1 g.

4.6 Sieve, with apertures within the range (300 to 400) μm to remove abnormal oversize material.

4.7 Container, suitable for containing the test sample.

4.8 Sealable container, suitable for containing and storing the funnel.

5 Sample preparation

The analytical sample shall be conditioned by exposure to the laboratory atmosphere for a minimum of 2 h in a layer of 5 mm maximum thickness. The sample shall then be split as per AS 4538.2 into three

portions of approximately (105 to 120) g for testing. The sample shall then be screened through a sieve (4.6) and the oversize material discarded.

6 Procedure

6.1 General

This procedure is for manually timed determinations.

6.2 Number of determinations

Three determinations shall be carried out.

6.3 Determination

Each determination shall be carried out as follows.

- a) Ensure the funnel is clean with no surface oxides present and dry prior to use; otherwise flow times will not be reproducible. Frequent use has usually been found to be an adequate cleaning method.
- b) Set up the apparatus by placing the funnel (4.2) on the stand (4.3) in a vibration-free environment.
- c) Ensure that the funnel is secure on the stand and that the upper surface is precisely level.
- d) For apparatus not in frequent use, clean the funnel by passing several portions of alumina through it [see a)]. Discard this material prior to testing.
- e) Take one of the prepared samples (see [Clause 5](#)) and accurately weigh a test portion of $(100 \pm 0,1)$ g and place into the container (4.7). (See [Clause 5](#)).
- f) Pour the test portion uniformly into the funnel while manually obstructing the outlet.
- g) Start the flow by removing the outlet obstruction and immediately commence timing. Stop the timing as soon as all the sample has passed through the funnel. Never tap the funnel.
- h) Repeat the procedure with the other two test portions ([Clause 5](#)).
- i) Remove the funnel from the stand and wipe the funnel clean with a dry cloth. Replace it in the sealable container (4.8) to prevent damage to the outlet orifice and minimize atmospheric oxidation of the inner surface.

7 Reporting of results

Report the average of the three results to the nearest second.

8 Precision

A test programme of the method in this International Standard was carried out in accordance with AS 2850. From the results of this programme, a within-laboratory repeatability (r) and between-laboratory reproducibility (R) at the 95 % confidence level as given in [Table 1](#) should be achieved.

NOTE Results of the test programme are given in [Annex A](#).

Table 1 — Precision data for flow time

Repeatability (r)	Reproducibility (R)
2,7	9,7

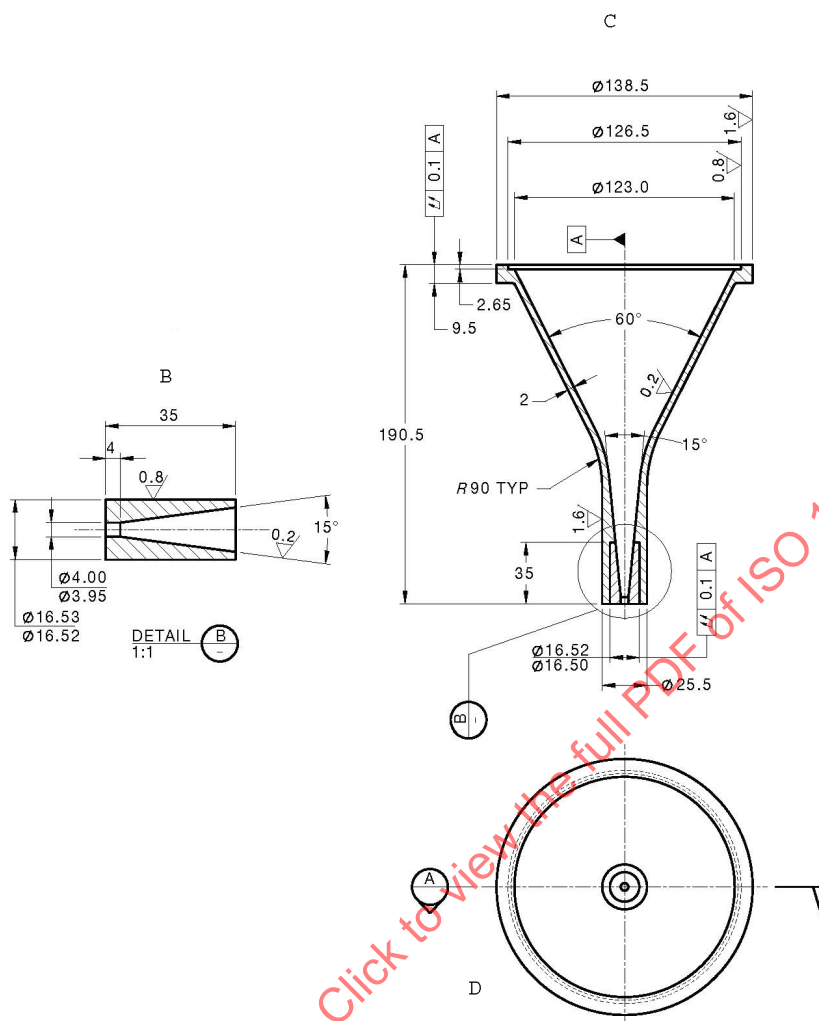
9 Test report

The test report shall include the following information:

- a) identification of the sample;
- b) a reference to this International Standard, i.e. ISO 18843;
- c) average flow time for the sample;
- d) the date on which the test was carried out;
- e) any factors during the course of the test which may have had an effect on the results.



Figure 1 — Automatic flow funnel time apparatus



Key

- A datum line through the funnel
- B hardened insert with orifice shown *in situ* and as detail
- C vertical cross section
- D top view

R90 TYP = Radius 90 typical

= Datum line

= Total run out (i.e. radius tolerance is 0,1 mm)

$\varnothing$ = Diameter

= Finish (0,2 Fine, 1,6 Standard)

$\frac{\varnothing 4.00}{\varnothing 3.95}$ = Tolerance Max./Min.

FINISH 3,2 UND

TOLERANCE $\pm 0,3$ UND

Figure 2 — Flow funnel

Annex A (informative)

Results of planned trial

A planned trial of the method in this International Standard was carried out in accordance with AS 2850. Samples of three smelter grade aluminas were analysed. Results were provided in quadruplicate by six laboratories. The within-laboratory (r) and between-laboratory (R) precision data (at 95 % confidence limits) and mean flow time values calculated from the results are given in [Table A.1](#).

Table A.1 — Precision data obtained using test samples

Sample	Mean flow time s	Repeatability (r)	Reproducibility (R)
S-109	47	1,5	7,3
S-110	68	3,3	10,7
S-111	82	2,9	10,8