

TABLE OF CONTENTS

	<u>Page</u>
FOREWORD	vii
TABLE OF CONTENTS	ix
ABBREVIATIONS	xi
SYMBOLS	xiii
LIST OF TABLES	xv
LIST OF FIGURES	xvii
SUMMARY	xxi
1. INTRODUCTION	1
2. LITERATURE	9
2.1 Rare Earth Elements, Discovery and Properties	9
2.2 Production of REEs from Primary Resources	11
2.2.1 Monazite ore	16
2.2.2 Bastnaesite ore	17
2.2.3 Xenotime ore	17
2.3 Importance of REEs and Their Supply Risk	18
2.4 The Usage Area of REEs	20
2.5 Rare Earth Elements Magnets	23
2.5.1 Usage area of NdFeB magnets	26
2.5.2 The production methods of NdFeB magnets	27
2.5.2.1 Sintered type NdFeB magnets	27
2.5.2.2 Polymer - bonded NdFeB magnets	28
2.6 Recycling of REEs from NdFeB Magnets.	28
2.6.1 Direct re-use and direct re-processing methods	30
2.6.2 Recovery of REEs from NdFeB magnet by pyrometallurgical methods ..	30
2.6.3 Recovery of REEs from NdFeB by hydrometallurgical methods.....	33
2.6.3.1 Direct leaching process and selective iron precipitation.....	33
2.6.3.2 Selective leaching process.....	36
2.6.3.3 Production of RE oxides	38
2.7 Literature Review and the Research Strategy	39
3. EXPERIMENTAL PROCEDURE	43
3.1 Characterization of NdFeB Magnets Powders	43
3.2 Experimental Procedure for Recycling of NdFeB Magnets Employing Acid Baking and Ultrasonic-Assisted Leaching followed by Production of RE oxides.	46
3.2.1 Methodology for acid-baking.....	46
3.2.2 Taguchi experimental design for ultrasonic-assisted selective leaching ..	46
3.2.3 Production of RE oxides by solution combustion.....	47
3.2.4 Production of RE oxides by ultrasonic spray pyrolysis	48
3.3 Experimental Procedure for Recycling of NdFeB Magnets Employing Oxidative Direct Leaching and Iron Precipitation in an Autoclave	50

3.3.1 Taguchi experimental design for direct leaching	50
3.3.2 Leaching experiments and characterization of the leach residue	50
3.3.3 Box-Behnken design for iron precipitation process in an autoclave.....	52
3.3.4 Iron precipitation process in an autoclave	52
3.4 Experimental Procedure for Recycling of NdFeB Magnets Employing Oxidation, Selective Leaching and Iron Precipitation in an Autoclave	53
3.4.1 Oxidation of NdFeB magnet powders.....	53
3.4.2 Taguchi experimental design for selective leaching.....	54
3.4.3 Box-Behnken design for iron precipitation in the autoclave.....	54
4. RESULT AND DISCUSSION.....	43
4.1 Recycling of NdFeB Magnets Employing Acid Baking and Ultrasonic- Assisted Leaching followed by Production of RE oxides	57
4.1.1 Characterization of the pre-treated NdFeB powder	57
4.1.2 Taguchi analysis of ultrasound-assisted water leaching process and statistical analysis	60
4.1.3 Characterization of RE oxides produced by solution combustion	63
4.1.4 Characterization of RE oxides produced by USP method	70
4.1.5 Conclusion.....	76
4.2 Recycling of NdFeB Magnets Employing Oxidative Direct Leaching and Iron Precipitation in an Autoclave	77
4.2.1 Characterization of leach residue occurred through in-situ iron hydrolysis during leaching	77
4.2.2 Taguchi analysis of leaching process and statistical analysis	82
4.2.3 Regression analysis of REEs and iron	84
4.2.4 Optimization of leaching process	85
4.2.5 Iron precipitation under pressure and high temperature.....	87
4.2.6 Model fitting, statistical analysis and response surface analysis	87
4.2.7 Optimization of the iron precipitation process in the autoclave.....	91
4.2.8 Characterization of the precipitate formed in the autoclave	92
4.2.9 Conclusion.....	94
4.3 Recycling of NdFeB Magnets Employing Oxidation, Selective Leaching and Iron Precipitation in an Autoclave.....	95
4.3.1 Oxidation of NdFeB magnet powders.....	95
4.3.2 Taguchi analysis of selective leaching process and statistical analysis	99
4.3.3 Characterization of the leach residue	104
4.3.4 Iron precipitation in the autoclave.....	104
4.3.5 Model fitting, statistical analysis and response surface analysis	105
4.3.6 Optimization of the iron precipitation process in the autoclave.....	108
4.3.7 Conclusion.....	110
5. CONCLUSION	112
REFERENCES.....	119