

Contents

Figures.....	iii
Tables.....	vi
Abbreviations.....	viii
1 Introduction.....	1
1.1 Subject and objectives.....	2
1.2 Structure.....	3
2 Genesis of NF metal scraps from MMSW	5
2.1 Properties and usage of NF metals	5
2.2 Collection of post-consumer waste on household level	7
2.3 Management and NF metal potential of MMSW in Germany	8
2.4 Production of NF metal scraps from MMSW	11
2.4.1 Technical extraction of NF metals with eddy-current separation.....	11
2.4.2 NF metal scraps from MBT plants (MBT scraps)	12
2.4.3 NF metal scraps from MSWI (MSWI scraps)	15
2.5 State of the art processing of NF metal scraps.....	20
3 NF metal recycling.....	24
3.1 Refining and remelting.....	25
3.2 Quality requirements and applicable recycling processes	26
3.2.1 Recycling processes for aluminium.....	26
3.2.2 Recycling processes for copper	29
3.2.3 Recycling processes for zinc.....	33
3.2.4 Zinc in copper refining.....	35
3.3 Synopsis.....	36
4 Market for NF metal scraps	38
4.1 Leading function of refined metals.....	38
4.2 Pricing of NF metal scraps	39
4.3 International trade with NF metal scraps	43
5 Advanced processing of the heavy metal fraction from MSWI scraps	46
5.1 Principles of sensor-based sorting.....	46
5.2 Identification of applicable sensor technologies	47
5.3 Colour sorting as concept for a model process	48
5.3.1 Comminution trials	49

5.3.2	Analysis of bright heavy metals.....	56
5.3.3	Colour sorting trials.....	57
6	Technical-economic assessment.....	60
6.1	Evaluation of key figures.....	61
6.1.1	Definition of the problem.....	61
6.1.2	Estimation of sales revenues.....	65
6.1.3	Estimation of disposal cost.....	68
6.2	Example heavy metal fraction.....	68
6.3	Evaluation of processing targets.....	70
6.3.1	Classification of the yellow fraction.....	70
6.3.2	Evaluation of the most promising sorting products.....	71
6.4	Process simulation.....	74
6.4.1	Simulation of the pre-treatment.....	75
6.4.2	Simulation of colour sorting.....	77
6.4.3	Summary of the results from the simulation.....	82
6.5	Estimation of processing costs.....	85
6.5.1	Flow sheet of example plant.....	85
6.5.2	Annual throughput.....	87
6.5.3	Investment.....	88
6.5.4	Processing costs.....	90
6.6	Economic assessment based on the NPV.....	92
6.6.1	Sensitivities.....	94
7	Conclusion and Outlook.....	99
	Annex I: Properties of MBT scraps (informative).....	103
	Annex II: Pictures.....	104
	Annex III: Simulation of colour sorting - diagrams.....	106
	Annex IV: Sales revenues at different transfers into the fine fraction.....	111
	References.....	113
	Summary.....	121
	Kurzfassung.....	123
	Lebenslauf.....	125