

GEORGIA OFFSHORE MINERALS ASSESSMENT

by

ZELLARS-WILLIAMS COMPANY

Division of

**JACOBS ENGINEERING GROUP INC.
LAKELAND, FLORIDA**

Department of Natural Resources
Environmental Protection Division
Georgia Geologic Survey

Project Report No. 14

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*In cooperation with
Minerals Management Service
U.S. Department of the Interior
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Department of Natural Resources
J. Leonard Ledbetter, Commissioner

Environmental Protection Division
Harold F. Reheis, Assistant Director

Georgia Geologic Survey
William H. McLemore, State Geologist

Atlanta

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EXECUTIVE SUMMARY

An assessment of mineral resources in the sea-bed on the continental shelf offshore Georgia was undertaken by Zellars-Williams Company, division of Jacobs Engineering Group Inc., pursuant to a contract dated August 12, 1988. The award was made following a request for proposals by the Georgia Department of Natural Resources and the Minerals Management Service, U.S. Department of the Interior, acting cooperatively with other participants, as the TASK FORCE for Offshore Mineral Resources.

Owing to budgetary constraints, the work assesses the economic viability of commercially exploiting offshore phosphorites and heavy minerals utilizing, to the greatest extent possible, commercially available proven technology.

The premises upon which the occurrences of potentially economic resources are located and their areal extent and volume quantified are based entirely on data made available by others. It is emphasized that this study is based on a minerals occurrence inferred by scattered, widely-spaced data points. The conceptual mining and beneficiation flowsheet designs were formulated based on analysis of these data and assumptions as to ore grade, minerals distribution, and ore continuity.

The phosphate-bearing Middle Miocene area targeted for this study is located within a 3-nautical mile radius of a point which is the intersection of 80°40' latitude, and 32° longitude lines. The ore (matrix) zone identified for mining is 5-7 meters thick, under 8-10 meters of overburden. Water depth, below MSL, is 14-16 meters. The 507 million cubic meters of matrix have the potential of yielding 162 million tonnes of 30% P₂O₅ grade phosphate rock product after mining and beneficiation losses.

For phosphate exploitation, all of the required mining, beneficiation, waste disposal, product storage, ship loading, and supporting infrastructure facilities are entirely offshore. Similarly designed, hybrid cutterhead suction-type hydraulic dredges remove overburden and mine matrix independently. Overburden is pumped through a trailing pipeline about 1.5 nautical miles to a floating, constant level head tank and flexible tremie discharging into previously mined cuts at sea bottom. Matrix is pumped to the beneficiation plant through a pipeline, which lengthens as mining

progresses to a maximum distance of 3 nautical miles. The overburden dredge must excavate about 1.6 cubic meters for each cubic meter of ore mined by the matrix dredge.

A 15-acre man-made island, located in the center of the proposed mining area, houses all the beneficiation processing units required to produce wet phosphate concentrate. The phosphate beneficiation facility consists of washer, feed preparation, flotation and product storage, and loading areas. The beneficiation facility is designed to receive slurried ore from the matrix dredge, disaggregate the ore, wash and grind the oversize rock, remove the clay, and separate the sand from the feed to produce a marketable phosphate concentrate product. Fresh water, produced by a reverse osmosis desalination plant, is used to rinse the concentrate to remove surficial salt residue remaining from the beneficiation process. Concentrate is loaded aboard ocean-going vessels berthed at a wharf from a walled-in type open storage yard. Clay and sand-sized particles, rejected with sea water in the beneficiation process, are thickened with the aid of flocculants, dewatered, mixed, and then discharged through a submerged pipeline into mined cuts. The dredges and island facilities are self-sustaining and are designed to operate 6,000 and 7,000 hours per year, respectively, in all but the most severe weather conditions. The facilities are designed to yield product at the average annual rate of 4.8 million tonnes.

World-wide and domestic phosphate supply-demand projections support the premise that market entry in about the year 2000 is reasonable. The most optimistic estimate of the time required to implement the exploration, development, and preliminary engineering phase of this enterprise could support start-up in the year 1996. Economic sensitivity analyses, based on constant 1988 dollars, for sales prices (FOB vessel off-shore island) of \$36.00 per tonne in 1996, and \$42 per tonne in 1999, demonstrate a promise of economic viability. Construction capital, production cost, and after-tax discounted cash flow return on investment for each of five scenarios, with final production in 1999, and revenue based on a \$42 per tonne sales price, are summarized below.

<u>Case No.</u>	<u>Sales Price \$/tonne</u>	<u>Construction Capital \$ Millions</u>	<u>Production Cost \$/tonne</u>	<u>DCFROI %</u>
II	42	280	16.60	12.2
Ila	42	280	15.15	13.3
Ilb	42	280	18.05	11.1
Ilc	42	252	16.60	14.1
IId	42	308	16.60	10.6

An implied occurrence of surficial sea-bed sands containing heavy minerals and rare earths most amenable to mining by conventional ocean-going dredges targets the area considered in this study. This heavy mineral line, about 30 nautical miles from shore, is about 0.8 nautical miles wide, 8.1 nautical miles long, and 10.4 meters thick. Water depth, below MSL, is 26-30 meters. The 292 million cubic meters of mineral-rich sands have the potential of yielding 15 million tonnes of a suite of heavy minerals and rare earth products, after mining and milling process losses. The dredge is a suction hopper vessel with a leading suction head arm operating from anchored positions to excavate the full depth in panels created in a series of pits.

Dredged sands are processed first in an on-board wet mill and then pumped to a nearby dry mill for final up-grading. The wet mill concentration process rejects oversize and fine sediments, which are collected, thickened, and discharged into the mined cuts. The resulting intermediate product is pumped through a trailing pipeline to a dry mill situated on a semi-submersible platform anchored nearby. The platform is moved, as mining advances, when the distance from mining exceeds about 1.1 nautical miles. This requires the platform to move every five years. The platform is a fully self-contained floating production platform with crew quarters, and product storage and vessel loading equipment.

The heavy mineral facilities are designed to recover rutile, ilmenite, leucoxene, monazite and zircon from heavy mineral sand deposits. Processing facilities include an initial concentration plant (wet mill) located onboard the mining dredge, and a remote-located platform-mounted recovery plant (dry mill). Sea water is used for processing at both the wet and dry mills. The configurations of mine and beneficiation facilities are designed to produce 811,100 tonnes per year of products consisting of a mix of the heavy minerals identified in the study.

Economic analyses are based on capital construction cost of 235 million dollars and a production cost of \$42.53 per average tonne of heavy mineral products. Sales price for the average tonne of heavy mineral product was constructed by applying the current quoted market price for each of the five products to the quantities of each. The resulting artificial average sales price of \$127.00 per tonne is increased by 30% in increments of 10% to test sensitivity. The resulting after-tax discounted cash flow in percent return on investment is given following.

<u>Artificial Average Sales Price \$/tonne</u>	<u>Construction Capital \$ Millions</u>	<u>Production Cost \$/tonne</u>	<u>DCFROI %</u>
127.00	235	42.53	4.2
130.70	235	42.53	6.8
152.40	235	42.53	9.0
165.10	235	42.53	11.7

The results of this study indicate that economics for both phosphate and heavy minerals support further explorative work offshore in the described target and other areas. The technical and economic risk associated with the mining, beneficiation, and infrastructure facilities proposed may be reduced to acceptable levels by more detailed engineering study. This effort is not warranted until further exploratory work is carried on to reduce the uncertainties of the minerals occurrences. This exploration work would focus on developing data upon which to base a scientific determination of level-of-confidence as to the quantity and quality of sea-bottom ore.

Limited areal investigation and complete profile core drilling to recover adequate samples in several locations are required to confirm assumptions made as to grade and quality. Properly located drill holes will aid in reducing uncertainties of continuity and variability. Favorable results of bench scale laboratory analysis and beneficiation process testing would then support more engineering.

Concurrent with the initial phases of the exploration program, limited environmental baseline studies are required to identify, evaluate and quantify biota and marine environments on a site-specific basis. These preliminary studies will provide the data with which potential impacts on marine life may be evaluated. Further, these data will provide the means of analyzing and costing mitigative alternatives to various exploitation plans. The success of, and the cost of, mitigation and environmental monitoring may be a significant additional operating cost in the offshore mining of minerals.

The bibliography, contained as Section 9, is intended to recognize Zellars-Williams Company key professional contributors, in addition to J.M. Williams, P.E., as a principal investigator, and all the sources of reference used in preparing the report.

The Draft Final Report was delivered and reviewed in Atlanta at a Task Force meeting on May 17, 1988. A second Task Force meeting in Atlanta was held on June 14, 1988 to receive input and to consider modifications and amendments to the Draft. The Final Report, reflecting comments of the Task Force, was published on July 20, 1988.

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DEPARTMENT OF THE INTERIOR
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SECTION 2

SCOPE OF STUDY

2.1 OVERVIEW AND OBJECTIVES

In August 1987 Zellars-Williams Company, a member of Jacobs Engineering Group Inc., (ZW), contracted with the Department of Natural Resources, State of Georgia, to provide a resource assessment study for Georgia offshore minerals. The specific study area (Figure 2.1) is defined as the Continental Shelf off of Georgia, lying between Universal Transverse Mercator (UTM) grid lines N 3,362,400 meters and N 3,675,000 meters. The western and eastern study-area boundaries, respectively, are the three geographical-mile line (measured seaward from the coast as depicted on U.S.G.S-U.S.N.O.S. topographic-bathymetric maps) and the shelf break.

Two primary services are defined by the scope of study:

- o preparation of resource assessment studies (for heavy mineral sands and phosphorites), which include quantity, chemical analyses and physical properties, and
- o a general economic feasibility analysis (for both heavy minerals and phosphorites) which consists of a discussion of mining technologies, infrastructure, and other facilities, as well as economic sensitivity analyses of factors relative to exploitation of mineral resources.

Project deliverables are limited to the following items:

- o a computerized geologic database,
- o digitized resource maps, and
- o a final project report describing the physical resource and presenting the economic feasibility analyses.

FIGURE 2.1

Study Area Location Map

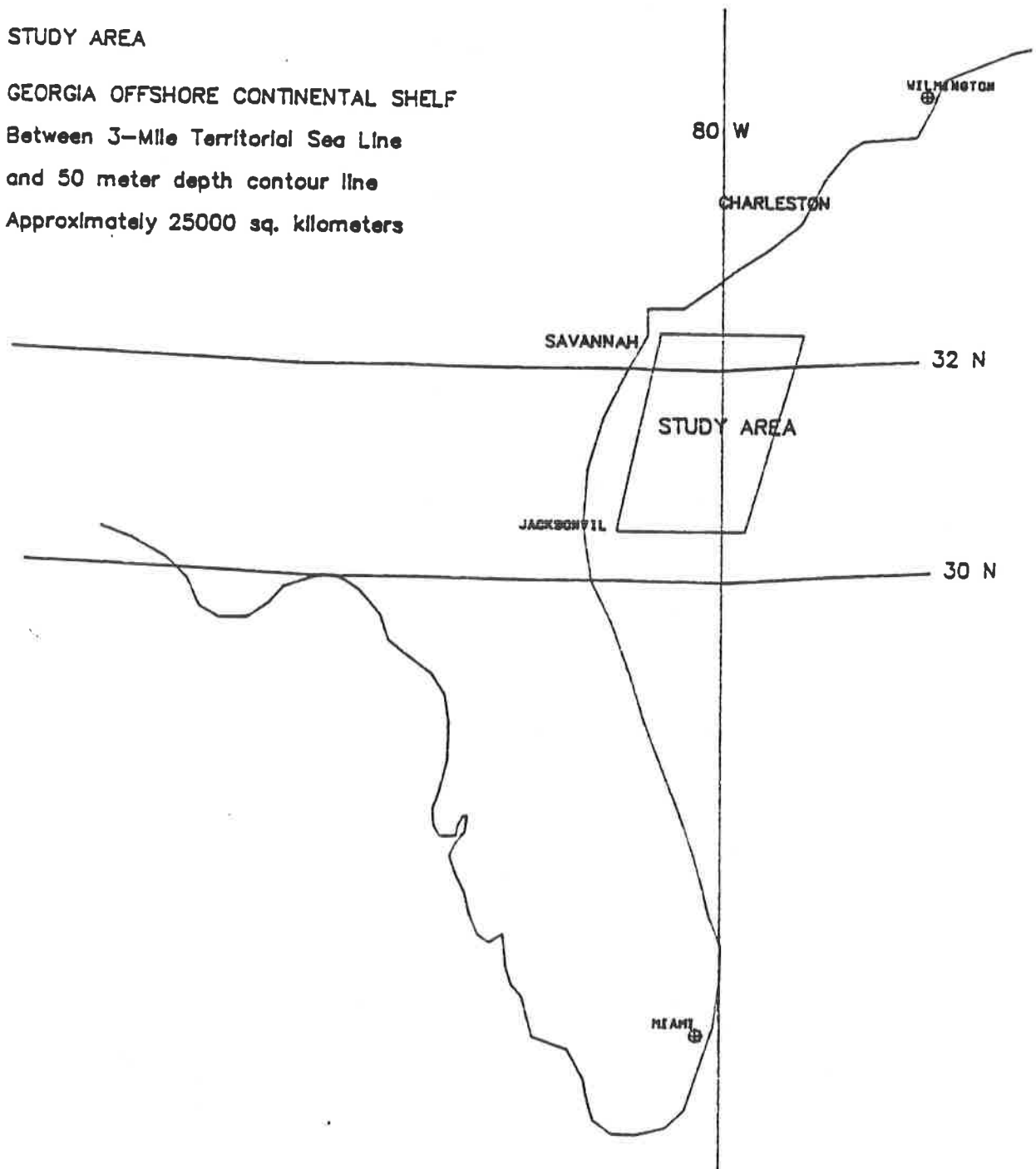
STUDY AREA

GEORGIA OFFSHORE CONTINENTAL SHELF

Between 3-Mile Territorial Sea Line

and 50 meter depth contour line

Approximately 25000 sq. kilometers



2.2 DATA COLLECTION

Resource assessment studies in this report are based on published and unpublished reports and databases. The only two potential mineral resources that have been reported for the Atlantic Continental Shelf (ACS) offshore of Georgia are heavy mineral sands and phosphorites. Deposits of materials such as gravel and shell have been located in other ACS areas, but no descriptive evidence of these materials in exploitable concentrations exists for the study area.

Steps leading to the resource description included identification of available data, collection of them, standardization to provide comparable formats, assessment of data quality and assignment of consequent limitations on its use, integration of data sets of comparable character and quality, and assessment of the natural resource in terms of location and probable quantity and quality.

Available data related to potential mineral resources offshore of Georgia were identified by several means. Bibliography and literature reviews were conducted to assess the availability of published information. Data survey forms were prepared and submitted to certain organizations to determine the availability of unpublished data. Additionally, a number of personal contacts were made in order to obtain specific data or samples, or to follow-up on data survey forms.

The Request for Proposal specified eight potential data sources for evaluation during the course of the first phase of the Resource Assessment Study. Contacted potential sources are listed in Table 2-1, with persons contacted at each, as well as an assessment of the current holdings of each.

- A. Georgia Geological Survey, EPD, DNR, Atlanta, Georgia
Contact: Mr. Jeff Kellam, 404/656-3214

Holdings of the Georgia Geological Survey are generally duplicative of published information that may be as easily acquired elsewhere. However, a careful file review will be conducted with Survey staff to ensure that essential materials do not escape attention.

Table 2-1

Organizations Contacted for Data Relevant to

GEORGIA OFFSHORE MINERAL ASSESSMENT STUDY

Organization	Contacts	Method of Response			Respondent	Type of Data Held	Data Used
		DSF	Letter	Telephone			
A. Georgia Geologic Survey * Atlanta	J. Kellam			X	J. Kellam	Holdings generally available from published sources or available from other sources.	N/A
B. U.S. Bureau of Mines * Washington, D.C.	A. Barsotti L. Lind			X	A. Barsotti	No independent relevant data.	N/A
C. Geology Dept., Univ. of * Georgia, Atlanta	V.J. Henry		X		J. Harding	High resolution seismic (HRS) profiles, side scan records, (CCTV) tapes, bathymetric profiles.	No
D. Marine Extension Service * Univ. of Georgia, Savannah	J. Harding		X		J. Harding	Box cores, vibracores, HRS profiles, side scan records, gamma-sled traverses.	No - data being reduced, not available until Sept. 88
E. Center for Applied Isotope * Studies, Univ. of Georgia Athens	J. Noakes		X		J. Harding	Same investigation and data as Marine Extension Service	N/A
F. Skidaway Institute of * Oceanography, Univ. of Savannah	V.J. Henry		X		J. Harding	Same as Geology Dept. Univ. of Georgia, Atlanta	N/A
G. U.S. Geological Survey-EMR * Reston, Virginia	A. Grosz E. Force J. Wynn	X		X	A. Grosz	Vibracore and grab samples, HRS profiles, side scan sonar	Geologic Model Phosphate mine model Heavy mineral model
H. U.S.G.S., Office of Marine * Geology, Woods Hole, Mass.	P. Popenoe F. Manheim			X	P. Popenoe F. Manheim	Data set of interpreted seismic profiles covering the Georgia shelf and Blake Plateau. Data file of analyzed shelf grab samples	Data set of interpreted sparker and airgun profiles covering the Georgia shelf and Blake Plateau. Heavy mineral information from data file phosphate analyses on shelf drill cores.
I. NOAA, Boulder, Colorado	R. Warnken	X			R. Warnken	Published data announcements	No - not relevant to study.
J. Mississippi Minerals Research Institute	J. Woolsey			X	J. Harding	Proprietary	No - not released.
K. MMS, Vienna, Virginia	R. Amato	X			R. Amato	Cores and geophysical logs, HRS profiles	No - not relevant.

DSF = Data Survey Form

N/A - Not Applicable

* Organizations Listed in Request for Proposal for evaluation of data relevant to study.

B. U.S. Bureau of Mines, Washington, D.C.

Contact: Mr. Aldo Barsotti, Division of Minerals Availability 202/634-1138; Mr. Langtrey Lynd, Titanium Commodities Specialist, 202/634-1055.

Mr. Barsoti and Mr. Lynd have jointly reviewed DMA data holdings, along with Mr. Don Rogich (Chief, DMA). They concluded that they have no independently developed information that is relevant to the requirements of the Georgia Offshore Minerals Assessment Study. They hold no samples.

C. Geology Department of Georgia State University, Atlanta, GA.

Contact: Professor Vernon J. Henry, 404/658-227 2

There are virtually no unpublished data in the files of Georgia State. Rather, all assessment work is accessible through published information on file there, or elsewhere.

The recent work of Georgia State is based on two data gathering campaigns, the first reported upon in June, 1983. This was work performed for the U.S. Geological Survey (USGS), in a cooperative program with the Bureau of Land Management (BLM), which consisted of a survey conducted to determine the occurrence and distribution of biological and geological hazards on the ocean bottom between Cape Hatteras, N.C. and Jacksonville, Florida from the three-mile inner-shelf boundary seaward to the 50 meter isobath. During the course of this work nearly 6,000 kilometers of trackline were covered, providing the following information:

- o 3.5 khz, 5662 kilometers
- o Uniboom - air gun system, 5734 kilometers
- o Sidescan sonar system, 5872 kilometers

In addition, underwater television camera work was performed, as well as data gathering from 22 dives of the research submersible, Diaphus.

In 1986 Georgia State reported the results of a survey along 420 kilometers of trackline proceeding from the vicinity of the Altamaha River northward into Port Royal Sound, S.C. This work was supplemented by data from 1984 borings by the South Carolina Water Resources Commission, performed in cooperation with the U.S. Geological Survey.

Interpretation of the seismic data gathered for the BLM has contributed to numerous important reports since 1981. Most notable among those, the 1986 publication by Kellam and Henry, "The Interpretation of Seismic Stratigraphy of the Phosphatic Middle Miocene on the Georgia Continental Shelf". This document contains stratigraphic sections derived from the seismic profiles, as well as contour maps showing the structure of important sedimentary strata. These contour and isopach maps represent two levels of refinement beyond the basic uninterpreted raw seismic data.

- D. Marine Extension Service, University of Georgia, Savannah, GA
Contact: Professor James Harding, 912/362-2496

Data collected jointly by Dr. Harding and Dr. Noakes are presently being reduced. Data consists of box cores, vibracores, HRS profiles, side-scan sonar records, gamma-sled traverses, all of which were obtained on a grant to investigate the occurrence of heavy mineral placer deposits offshore Georgia. The investigation is 50 percent complete. Data will be available when investigation is complete (end of August, 1988).

- E. Center for Applied Isotope Studies, University of Georgia,
Athens, GA.

Contact: Professor John Noakes, 404/542-1395

Work being done jointly with Dr. Harding. Not available until end of August, 1988.

F. Skidaway Institute of Oceanography, University of Georgia,
Savannah, GA

Contact: Prof. James Harding, 912/362-2496; Prof. Vernon J. Henry,
404/658-2272

All raw data obtained from high resolution seismic surveys conducted by the University of Georgia are on file at Skidaway. Files containing interpreted seismic data are believed to be located there, as well. Virtually all trackline data have been incorporated into publications.

G. U.S.G.S. Eastern Mineral Resources, Reston, VA

Contact: Mr. Andrew Grosz, 703/648-6314; Mr. Eric Force,
703/648-6325; Mr. Jeff Wynn, 703/648-6389

The U.S.G.S. holds a large body of raw data and interpreted information, as well as a limited amount of unpublished information, that is pertinent to the Atlantic Continental Shelf overall. Certain elements of this work are relevant to the area offshore of Georgia. The most recent data pertinent to offshore Georgia are derived from a survey conducted offshore in June, 1985 in which 26 samples were acquired, including 10 vibracore, three of which have been fully processed. In each instance, surface grab samples were obtained at the location of vibracores. Samples were subjected to mechanical classification on shipboard, with a three-turn spiral classifier; the heavy mineral fraction was then subjected to microscopic analysis and heavy media separation, in order to determine total heavy mineral fraction and other characteristics of the sample.

H. U.S.G.S. Office of Marine Geology, Woods Hole, Massachusetts

Contact: Mr. Peter Popenoe, and Dr. Frank Manheim - 617/548-8700

The Woods Hole, MA office of the U.S. Geological Survey has a large data set of both raw and interpreted seismic profiles as well as the database of analyzed shelf grab samples for the continental shelf off Georgia. The raw seismic data has all been released to the public through the National Geophysical Data Center (NGDC) in Boulder, CO, and most of the interpreted data have been published.

Intepreted, but unpublished, seismic data covering the Georgia continental shelf and slope were also located in Woods Hole, held by Peter Popenoe, who was actively working on the analyses of these data. As a large part of these unpublished data were pertinent to the Georgia Shelf investigation, ZW made an appeal for the unpublished data through the joint Department of Interior-State of Georgia Task Force. These data were released in Open-File (Popenoe and Spalding, 1988), and form the basis for compiling the structure contour and isopach maps.

The unpublished data file of analytical data on Georgia shelf grab samples used in this report was also obtained from the USGS Woods Hole office.

ATTACHMENT "A"
GEORGIA OFFSHORE MINERAL ASSESSMENT
DATA SURVEY FORM

ORGANIZATION:

CONTACT:

TEL. NO.:

I Does your organization possess borehole data in the EEZ offshore Georgia? _____
(If answer to above is NO, proceed to Question II.)

- A. Type of boring _____
- B. Number of borings _____
- C. General location of borings _____
- D. Average depth of boring _____
- E. Geophysical log? _____
 - 1. Type _____
- F. Geological log? _____
 - 1. Correlations completed? _____
- G. Geologic Data Format (hard copy, computer, etc.) _____
- H. Sieve analysis _____
- I. Heavy mineral analysis _____
- J. Phosphorite analysis _____
- K. Other mineral analysis (specify mineral) _____

- L. Have these data been reduced? _____
 - 1. Maps:
 - Type _____
 - Scale _____
 - Quantity _____
 - 2. Cross sections:
 - Scale _____
 - Quantity _____

II Does your organization have bottom grab sample data in the EEZ offshore Georgia? _____

(If answer is NO, proceed to Question III)

- A. Approximate number of samples _____
- B. General sampling location _____
- C. Sieve analysis (specify) _____
- D. Heavy mineral analysis _____
- E. Phosphorite analysis _____
- F. Other mineral analysis (specify) _____

G. Data format (Analysis sheets, computer, etc.) _____

H. Have these data been reduced? _____

1. Maps:

Type _____

Scale _____

Quantity _____

2. Cross sections:

Scale _____

Quantity _____

III Does your organization possess samples taken from the EEZ offshore Georgia? _____

(If answer to above is NO, proceed to question IV.)

A. Type _____ Quantity _____

B. Method of preservation and storage _____

C. General sampling location _____

D. Typical length _____

E. Diameter _____

F. Storage location _____

G. Have samples been described geologically? _____

1. Method employed _____

H. Have the samples been correlated to geologic strata? _____

IV Does your organization possess geophysical data in the EEZ offshore Georgia? _____

(If answer to above is NO, proceed to Question V.)

A. Type _____

B. Number of surveys _____

C. Length of each survey _____

D. Have the data been interpreted? _____

E. Data storage format _____

F. Format of presentation of interpreted data _____

G. Maps:

1. Number _____

2. Scale _____

3. Size _____

H. Cross Sections:

1. Number _____

2. Scale _____

3. Size _____

V Has your organization integrated interpreted data of various types for presentation concerning the EEZ offshore Georgia? _____

(If answer to above is NO, proceed to Question VI.)

A. Location _____

B. Maps:

1. Number _____

2. Scale _____

3. Size _____

C. Cross Sections:

1. Number _____

2. Scale _____

3. Size _____

VI Does your organization possess any unpublished papers (i.e., theses or dissertations) pertaining to the EEZ offshore Georgia? _____
(If answer to above is NO, proceed to Question VII.)

- A. Method of access _____
- B. Type(s) _____
- C. Titles & Authors (please list) _____

VII Is your organization, or staff, aware of any other data concerning the EEZ offshore Georgia? _____

- A. Identify _____
 - 1. Type _____
 - 2. Location _____
 - 3. Contact _____
 - 4. Publication _____
- B. Description of data _____

Please submit this completed questionnaire to:

Mr. Thomas P. Oxford
Zellers-Williams Company
P. O. Box 2008
Lakeland, FL

Phone: 813/665-2194

SECTION 3

RESOURCES OF THE GEORGIA CONTINENTAL SHELF

3.1 INTRODUCTION

Georgia's present-day coast is characterized by tidal inlets and sand shoals associated with numerous barrier islands. The barrier islands tend to be broad nonlinear features unlike the long, narrow islands bordering the Florida coast. This development is due to heavy river sediment loads and coastal energy input favoring constructional rather than erosional features (Pirkle, 1970; Swift, et al, 1972). Oertel and Howard (1972) discuss, in detail, shoal development and morphology on the Georgia coast. Shoals extend two to four miles seaward of estuary entrances at major tidal inlets. Formation and maintenance of these shoals is due to generation of sediment circulation cells which result from dynamic dispersion of tidal and transient currents (Oertel, 1972).

Off of Georgia, the continental shelf extends seaward from the barrier islands between 100 and 200 kilometers to the shelf break where the ocean depth is about 60 meters. Near barrier islands top sediments are generally fine-grained Holocene sands that thin seaward (Foley, undated). Beyond these fine-grained deposits, more coarsly-grained sands, believed to be primarily of fluvial origin, become typical. This textural change occurs at water depths of about 14 meters (Kellam, 1981). Today's shelf morphology and topography resulted from modification of coastal features formed at previously lower sea levels (Swift et al, 1972).

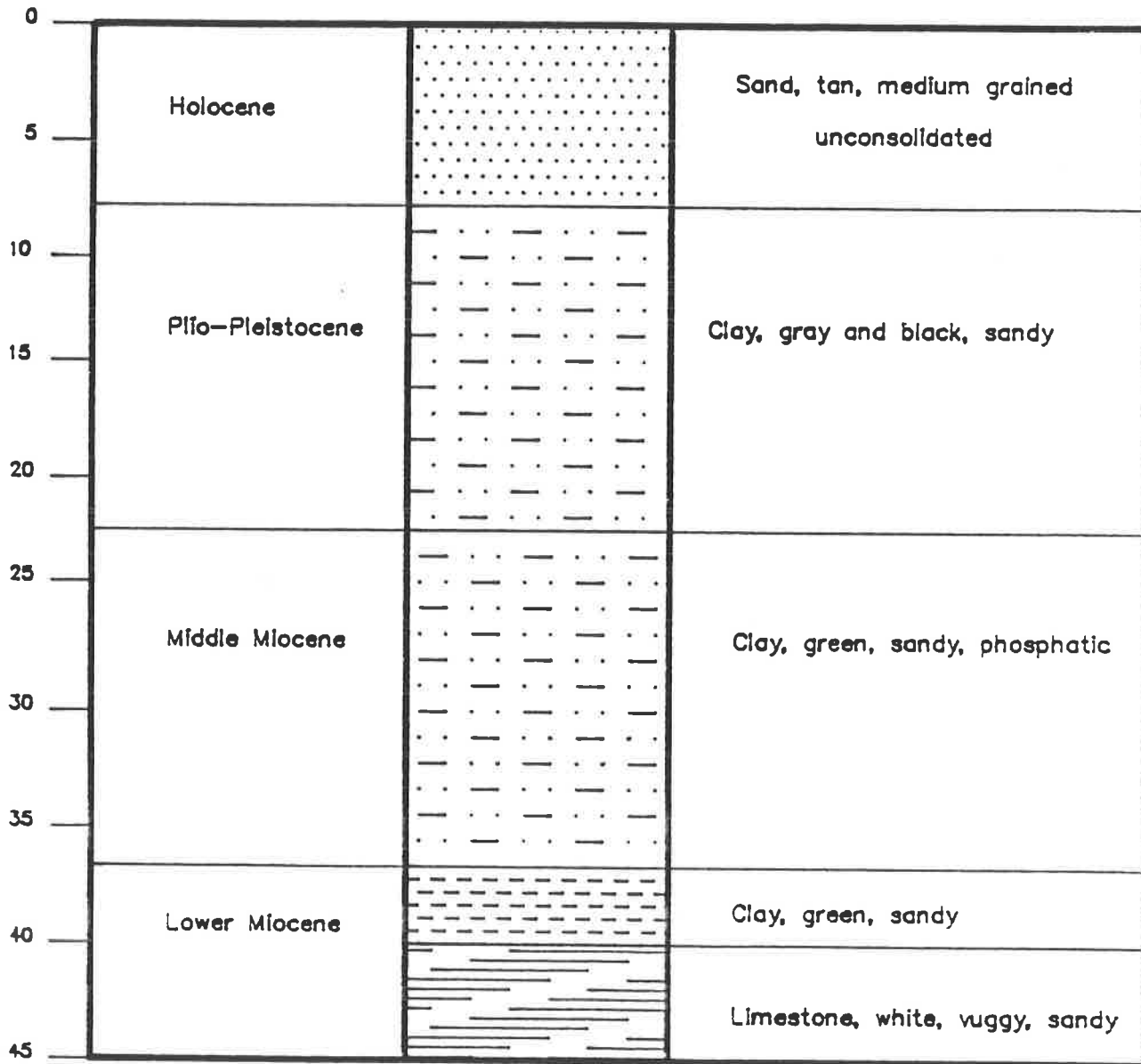
Figure 3.1 shows generalized stratigraphy for the region. For more detailed discussions the reader is referred to Henry and Kellam (1987), Kellam (1981), and Popenoe (1986). Henry and Kellam (1987) provide a good general overview of the geology of the Georgia coastal plain and continental shelf. Discussions include regional structural features, the Floridan Aquifer, and regional stratigraphy. Greater detail related to the Miocene is given by Popenoe (1986).

Figure 3.1

GENERALIZED STRATIGRAPHY

DEPTH (METERS)

Based on Drill Hole at South Tip of Tybee Is.



3.2 DATABASE

3.2.1 Purpose and Scope

The database for the Georgia offshore resource assessment study is to be used for making estimates of quantity and quality of potential resources and to identify targets for further exploration. In order to accomplish this goal, the database must be easy to access and manipulate, and must provide the means for input and integration of new data as they become available.

Potential resources of the Georgia continental shelf are economic heavy minerals and phosphorite. Data relevant to these two types of deposits can be grouped into two general categories: geological and analytical. Geological refers to data that relate to the thickness and structure of stratigraphic units. Examples are seismic records and descriptive logs of cores from drill holes. Analytical data are derived by laboratory procedures that quantify mineral or chemical constituents, determine percentage of grains within specified size ranges, or determine sediment age by paleontological or other methods. Analytical data serve to verify interpretations of geological data, and they facilitate economic evaluations of mineral resources. Analyses are conducted on cores from drill holes and on grab samples of ocean bottom sediments.

Commercially economic concentrations of phosphorite can occur in Middle Miocene strata, and heavy minerals have been observed in grab samples of Quaternary sediments from the ocean floor. Since seismic interpreted data provide thicknesses of and depths to geologic strata of interest, they are useful for preliminary assessment of both phosphorites and heavy minerals. When these interpreted seismic data are digitized into a computerized geologic model they provide a means for estimating phosphorite source bed and overburden thicknesses, and heavy mineral sand deposit thickness. Because of the paucity of available analytical data from core drilling, there are gross limitations to the reliability of such estimates. Vertical and horizontal distributions of phosphorite within Middle Miocene strata cannot be determined without abundant core analysis data. Likewise, although grab

sample analyses are available, there are on four published vibracore analyses within the study area (Ayers, 1977) to make reliable predictions of heavy mineral vertical distributions in Quaternary sediments.

The available data for this assessment study are adequate for making only gross estimations of resource quantities. The great value of existing data is that it provides a sound and essential basis for identifying targets for further exploration.

Zellars-Williams has integrated the unpublished analytical database into a usable database format. These data come from two primary sources, as follow:

- o interpreted and annotated seismic profiles provided by Peter Popenoe of the U.S. Geological Survey (Popenoe and Spalding, 1988), and
- o tabulated grab sample analyses jointly obtained by the U.S. Geological Survey and Woods Hole Oceanographic Institution (Hathaway, 1971).

Targets for further exploration have been identified by the preparation of maps using data from this database and from review of published reports. Once target locations for heavy minerals and phosphorite were established, hypothetical models of economic deposits were placed at the target locations to establish the economic feasibility of mining at these locations if, by intensive core sampling, the deposits are proven to exist.

3.2.2 Database Structure

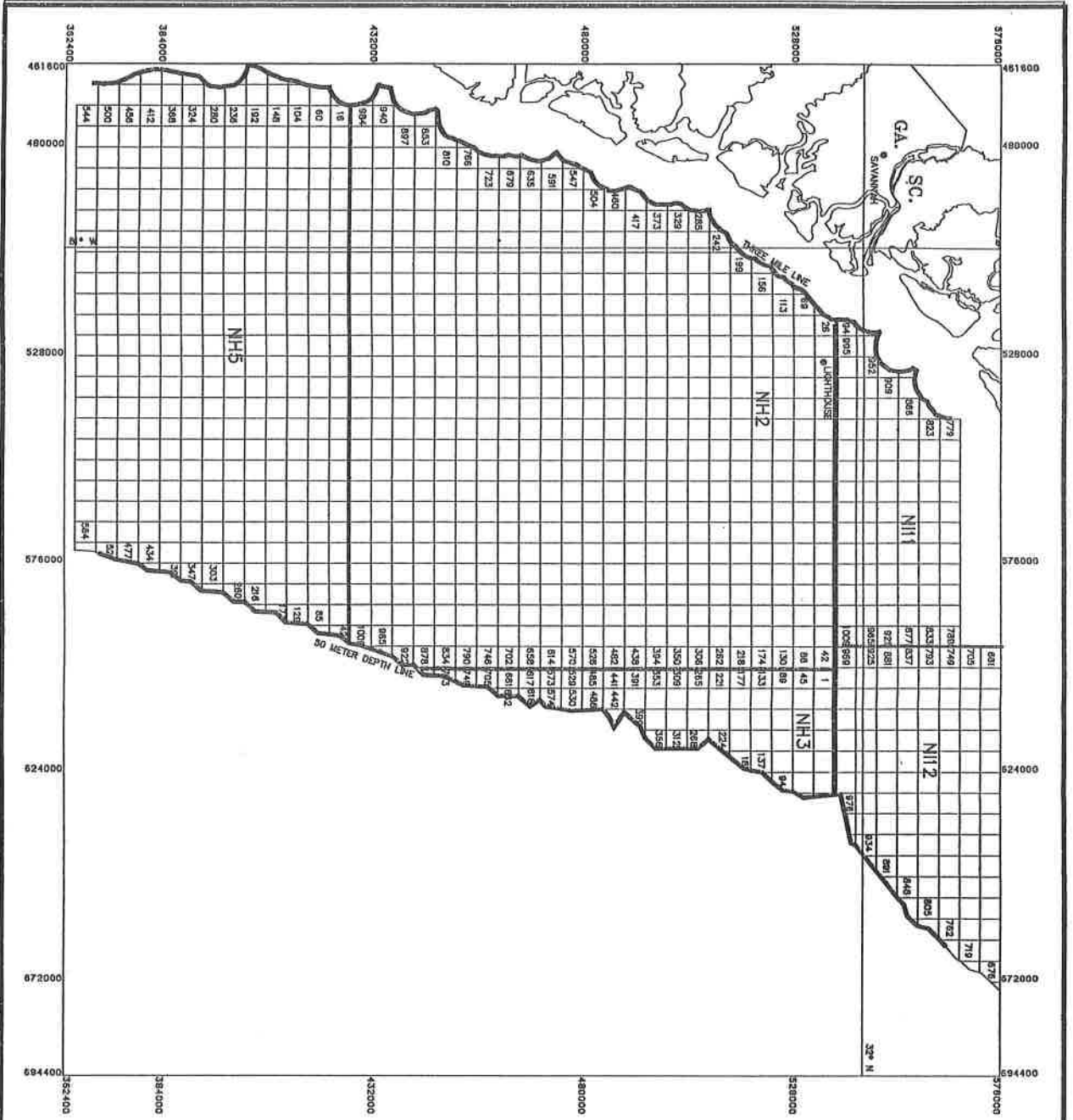
The database prepared by Zellars-Williams contains two separate and distinctly different type of data. The first type is composed of the tabulated analytical data from Hathaway (1971). These quantitative data relate to particle size characterizations, gross mineralogy, heavy mineral concentrations and grab sample locations. For each grab sample location, 45 identified fields of data have been provided for in the database. Fields include those recommended by Grosz and Escowitz (1983), as well as others. The 45 fields are as follow:

- | | | |
|--------------------------|-----------------|------------------|
| 1) Sample I.D. | 16) Magnetite | 31) Glauconite |
| 2) Latitude | 17) Ilmenite | 32) Sphene |
| 3) Longitude | 18) Apatite | 33) Sulfides |
| 4) UTM North | 19) Monazite | 34) Phosphate |
| 5) UTM East | 20) Rutile | 35) Amphibole |
| 6) Depth | 21) Zircon | 36) Limonite |
| 7) Wt. % Gravel | 22) Sillimanite | 37) Zoisite |
| 8) Wt. % Sand | 23) Kyanite | 38) Augite |
| 9) Wt. % Silt | 24) Staurolite | 39) Hypersthene |
| 10) Wt. % Clay | 25) Leucosene | 40) Anadalousite |
| 11) Quartz | 26) Titanite | 41) Spinel |
| 12) Potassium Feldspar | 27) Mica | 42) Dumortierite |
| 13) Plagioclase Feldspar | 28) Garnet | 43) Glaucothane |
| 14) Heavy Minerals | 29) Epidote | 44) Hornblende |
| 15) Phosphorite | 30) Tourmaline | 45) Aegerite |

Data for all of these fields are not presently available for the Georgia continental shelf. Edit, retrieve, input and report writing functions have been developed to key on sample number, location, and location ranges. Data entry windows, menus and retrieval queries facilitate these functions for user friendliness. Standard report formats have been developed and ADVANCED REVELATION permits specialized reports to be easily developed by the user.

The second type of data contained in the database is derived from the three-dimensional computer model (Section 3.3) developed for the Georgia offshore area. From the computer model, data were retrieved and stored for each UTM block within the OCS blocks of the study area, as shown in Figure 3.2. Each block is described by its boundary and geographical center-point, both in latitude and longitude and in the AMS coordinate system. The data for each OCS block consist of 25 fields grouped under major headings, as follows:

- o Location and area
 - oo Area
 - oo UTM East coordinate of block center
 - oo UTM North coordinate of block center
 - oo Latitude of block center
 - oo Longitude of block center



NORTH

GRAPHIC SCALES



GEORGIA OFFSHORE
MINERALS ASSESSMENT

STUDY AREA
SHOWING UTM BLOCKS



FIGURE NO. 3.2

- o Ocean floor character
 - oo Weight percent gravel
 - oo Weight percent sand
 - oo Weight percent silt
 - oo Weight percent clay

- o Stratigraphy and bathymetry
 - oo Water depth
 - oo Quaternary thickness
 - oo Pliocene thickness
 - oo Upper Miocene thickness
 - oo Middle Miocene thickness
 - oo Lower Miocene thickness
 - oo Middle Miocene bottom structure
 - oo Overburden thickness (thickness of stratigraphic units overlying Middle Miocene)

- o Major heavy minerals on ocean floor
 - oo monazite
 - oo rutile
 - oo staurolite
 - oo titanite
 - oo zircon

- o Gross mineralogy
 - oo quartz
 - oo heavy minerals
 - oo potassium feldspar
 - oo plagioclase feldspar
 - oo phosphorite.

There are no provisions for input of new data for the second data type because such provisions would result in inappropriate mixing of raw and modeled data. Menus have been developed to access retrieval utilities and generate reports concerning the modeled database.

Included with this report (Appendix A) are hard copies of both the raw and modeled databases. In addition, these data, on magnetic media, accompany the report to the Georgia Geologic Survey. Raw data have two magnetic media forms: ASCII files for input into the Georgia Geologic Survey's prime computer and REVELATION database files. Modeled data are in ASCII format accessible through REVELATION and specialty access programs developed by Zellars-Williams.

3.3 MODEL CONSTRUCTION

ZW uses the EAGLES-PC software to develop numerical models for natural resource evaluations. The EAGLES-PC program, GRID, provides the capability to produce regular grids from randomly-spaced data points. One grid is produced for each physical and analytical parameter to be evaluated. The grid consists of rows and columns with a calculated numerical value at each intersection. These grids are used to produce maps, cross-sections, volumetric calculations, mine plans, mining sequences, blending and stockpiling alternatives, product quality forecasts, and operating cost evaluations.

There is a virtually unlimited set of equations and parameters to be used to calculate the grid from the data points. For the Offshore Georgia Minerals Assessment project, ZW studied several different sets of equations and parameters prior to selection of the set which provided the best fit with the raw drill-hole data. In general, the selected set is defined as follows:

- o Elliptical linear inverse distance weighting
- o Anisotropic angle of 140 degrees
- o Anisotropic factor of 5
- o Direct assignment distance of 240 meters
- o Maximum search distance of 48,000 meters
- o Extrapolation distance of 22,000 meters
- o Minimum number of points for gridding is 2
- o Fixed sectors used
- o Selection for gridding by number sector
- o Number of points per sector is 2

- o Number of sectors is 8
- o Shadow angle is 10.0 degrees
- o Deterministic weight function applied to power of 0.5.

Grids can also be produced using an EAGLES-PC program called GENGRD. As the name implies, this program generates grids from digitized contour files. Creation of new grids by operations involving original grids is accomplished in GRDMOD (GRID MODification). Grid-to-grid operation capabilities consist of modifications based on:

- | | |
|------------------|-------------------|
| o Intersections | o Division |
| o Unions | o Identity |
| o Targets | o Lower values |
| o Operands | o Upper values |
| o Constants | o Basement limits |
| o Addition | o Ceiling limits |
| o Subtraction | o Data extensions |
| o Multiplication | |

3.3.1 Geological Model

The study area geologic model contains nine grid files, as follows:

- o Thickness of:
 - Quaternary
 - Pliocene
 - Upper Miocene
 - Middle Miocene
 - Lower Miocene
- o Bathymetry
- o Structural contour - elevation of the base of Middle Miocene
- o Overburden thickness
- o Total depth to phosphate matrix.

Thickness grids for individual stratigraphic units were created from discrete point data using the GRID program. Point data were scaled from interpreted, high-resolution, sparker seismic strip charts provided by the U.S. Geological

Survey. Thicknesses were scaled assuming the seismic velocity for sea water (1500 meters per second) for the entire thickness. Some of the data points in the northernmost part of the study area came from Gilliss lines 1-P, 7-P, and 9-P. The majority of data points, however, are from FAY lines 23, 24, 25, 26, 27, and 28. Figure 3.20, at the end of Section 3, shows all of the data points used to create the geological model.

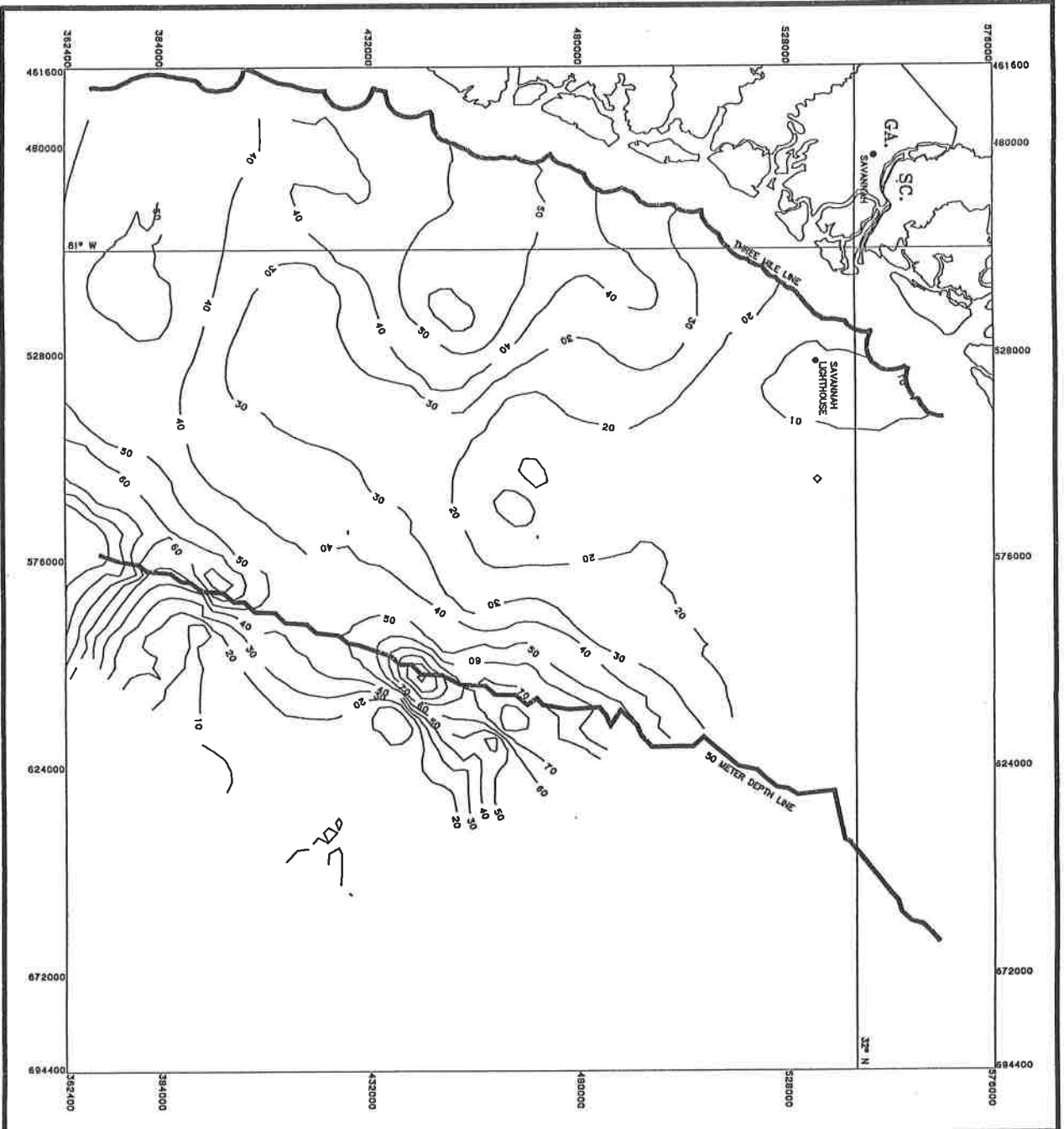
The bathymetry grid was produced using GENGRD. Contours were digitized from several U.S. Geological Survey-National Oceanographic Survey topographic-bathymetric maps that cover the study area.

Grids of overburden thickness, total depth to matrix, and the Middle Miocene base structure were produced in GRDMOD. Overburden thickness (Figure 3.3) is the sum of Quaternary, Pliocene and Upper Miocene thicknesses (Figures 3.4, 3.5, and 3.6, respectively). Total depth to ore (Figure 3.7) is the sum of bathymetry (Figure 3.8) and overburden thickness. The base structure (elevation) contour grid for the Middle Miocene (Figure 3.9) was generated by summing bathymetry, overburden thickness and Middle Miocene (Figure 3.10) thicknesses and multiplying this sum by a negative one.

3.3.2 Analytical Model

The analytical model of the study area was built using sample mineralogical and grain size analyses data files listed in Hathaway 9971). This database is very extensive in terms of both area covered and number of constituents analyzed. However, since the database results from analysis of grab samples of surficial deposits it relates only to the locating of a hypothetical heavy mineral deposit. It is not relevant for development of a phosphorite deposit model in Middle Miocene strata. To remain within the scope of this study, only sample points within the Georgia ACS study area were considered, and only those constituents relevant to evaluation of economic minerals were modeled.

Grids were created from discrete data points for thirteen different constituents. These constituents are summarized below under their respective data file code lines and the approximate number of data points used within the study area. Data file code lines used here are those presented in Hathaway (1971) and are not related to the database prepared in conjunction with this report. They are included here for reference.



GRAPHIC SCALES



NAUTICAL MILES

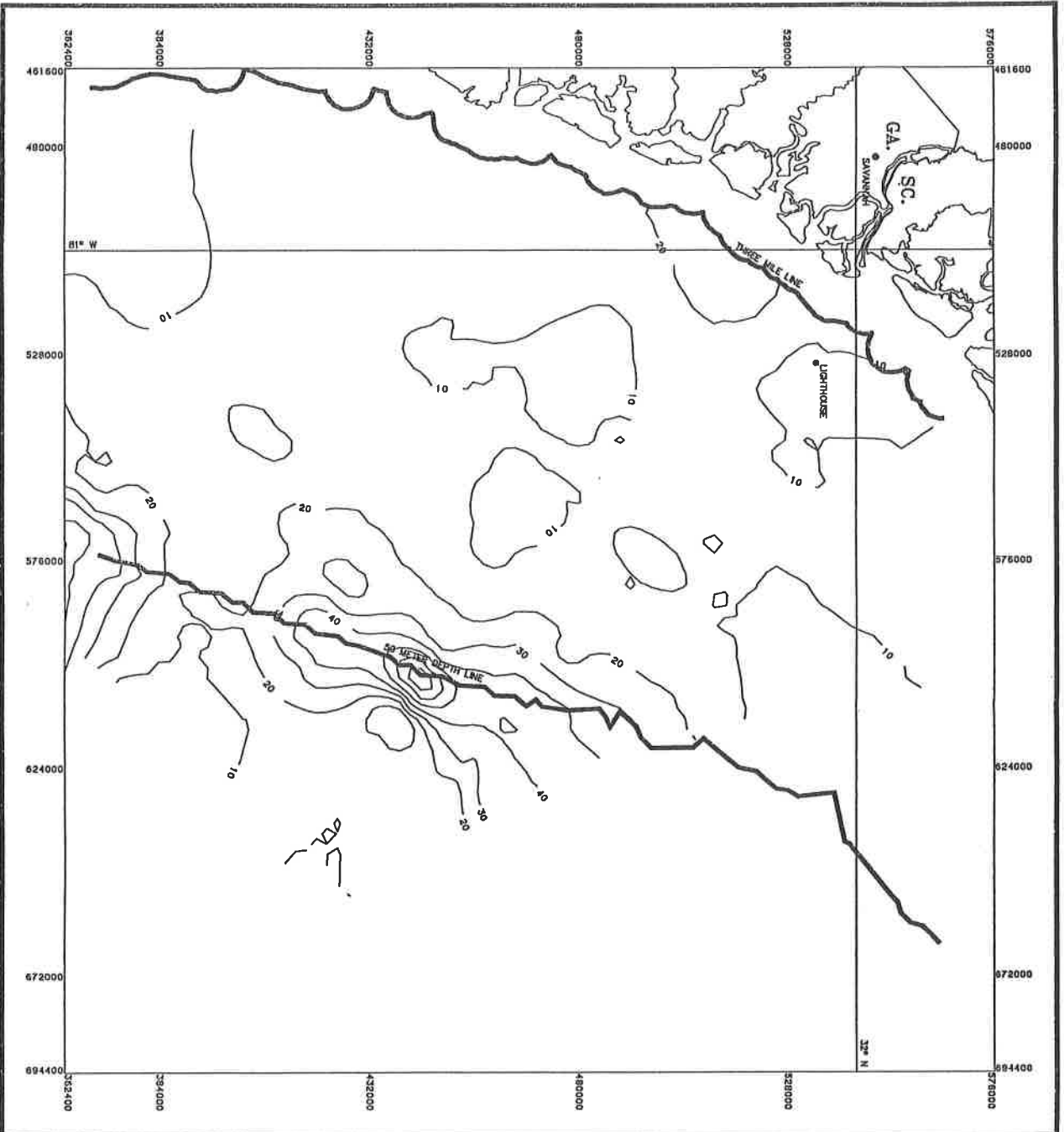


KILOMETERS

GEORGIA OFFSHORE
MINERALS ASSESSMENT
OVERBURDEN ISOPACH
BEDS OVERLYING MIDDLE MIOCENE
THICKNESS IN METERS
CONTOUR INTERVAL = 10 m

ZW

FIGURE NO. 3.3



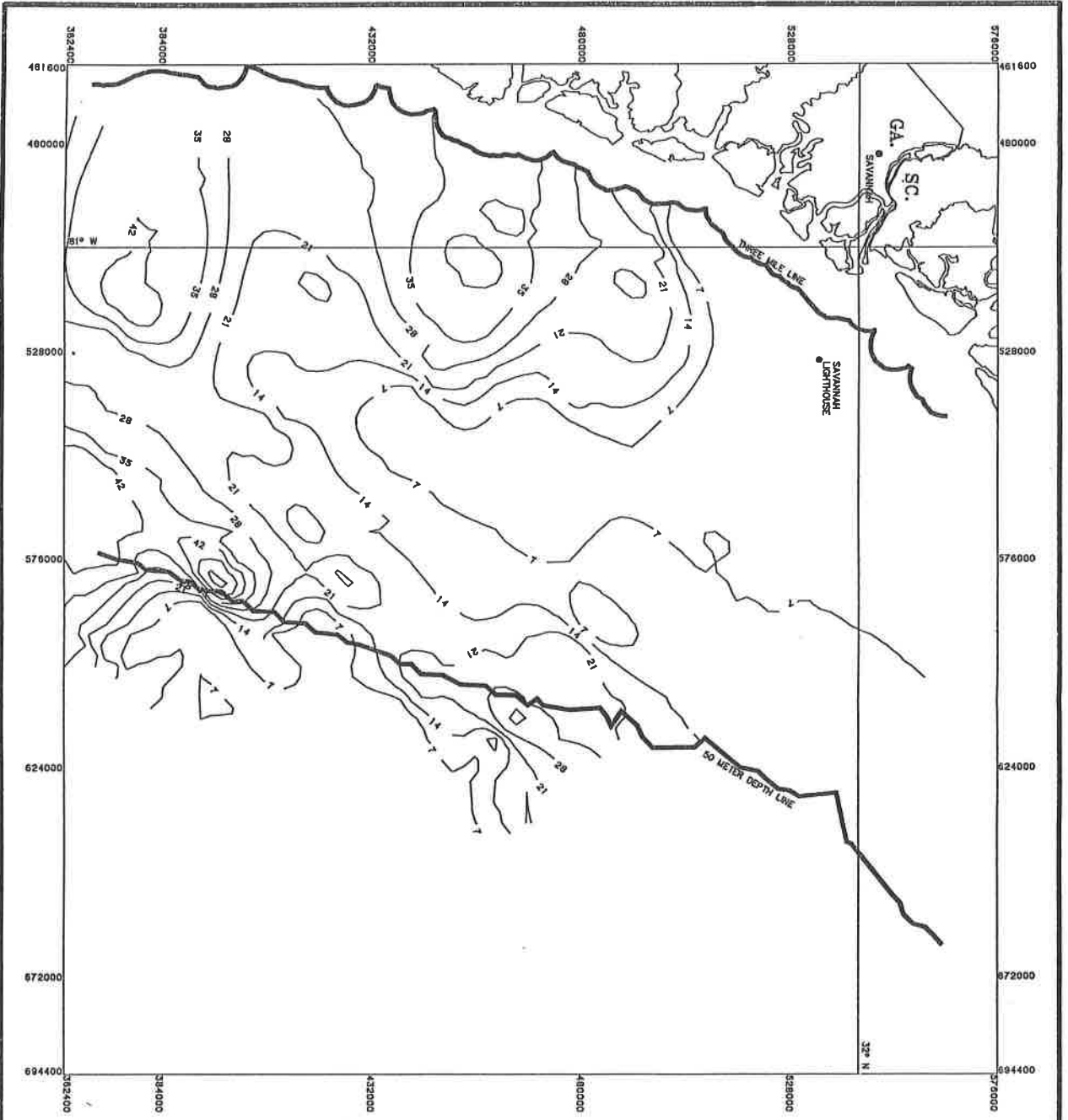
GRAPHIC SCALES



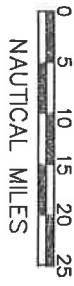
GEORGIA OFFSHORE
MINERALS ASSESSMENT
QUATERNARY ISOPACH
THICKNESS IN METERS
(contour interval 10 m)



FIGURE NO. 3.4



GRAPHIC SCALES



NAUTICAL MILES



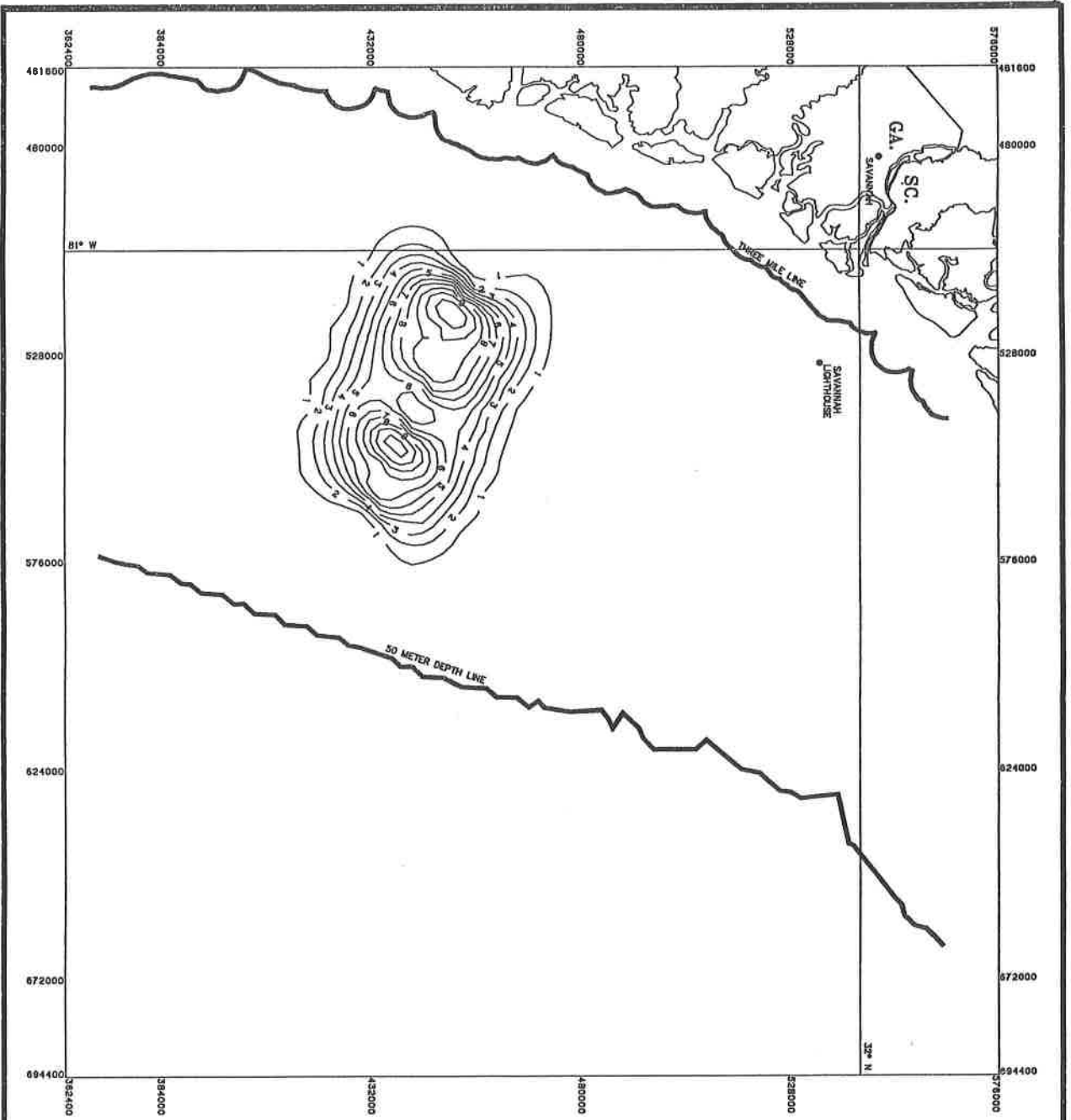
KILOMETERS

GEORGIA OFFSHORE
MINERALS ASSESSMENT

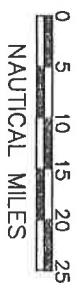
PLIOCENE ISOPACH
THICKNESS IN METERS
CONTOUR INTERVAL = 7 m



FIGURE NO. 3.5



GRAPHIC SCALES

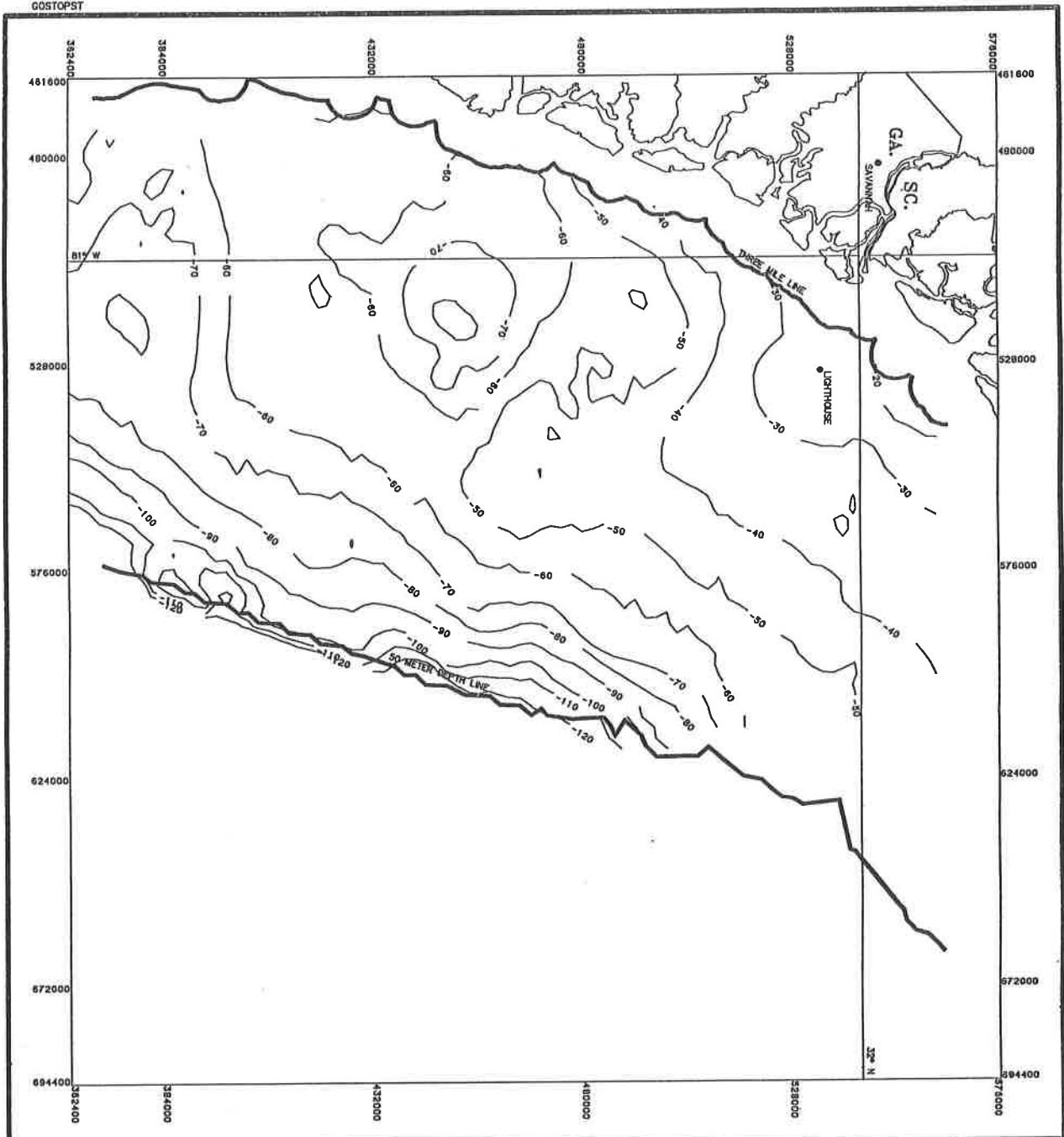


GEORGIA OFFSHORE
MINERALS ASSESSMENT

UPPER MIOCENE ISOPACH
THICKNESS IN METERS
CONTOUR INTERVAL = 1 m

ZW

FIGURE NO. 3.6



GRAPHIC SCALES



NAUTICAL MILES



KILOMETERS

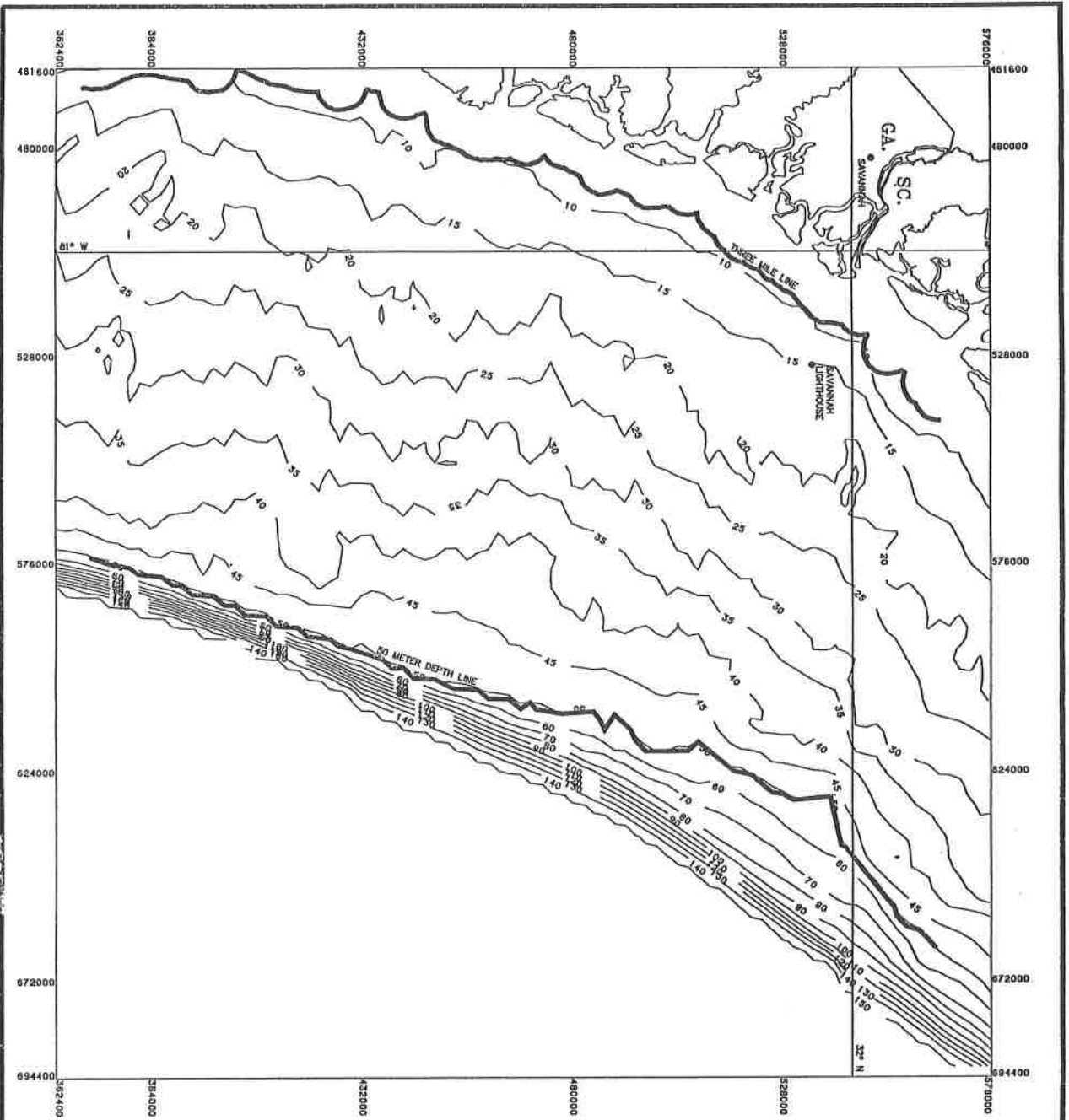
GEORGIA OFFSHORE
MINERALS ASSESSMENT
MIDDLE MIOCENE
TOP STRUCTURE
ELEVATION (MSL)

CONTOUR INTERVAL: 10 METERS



FIGURE NO. 3.7

GOSTOPST



GRAPHIC SCALES



GEORGIA OFFSHORE
MINERALS ASSESSMENT

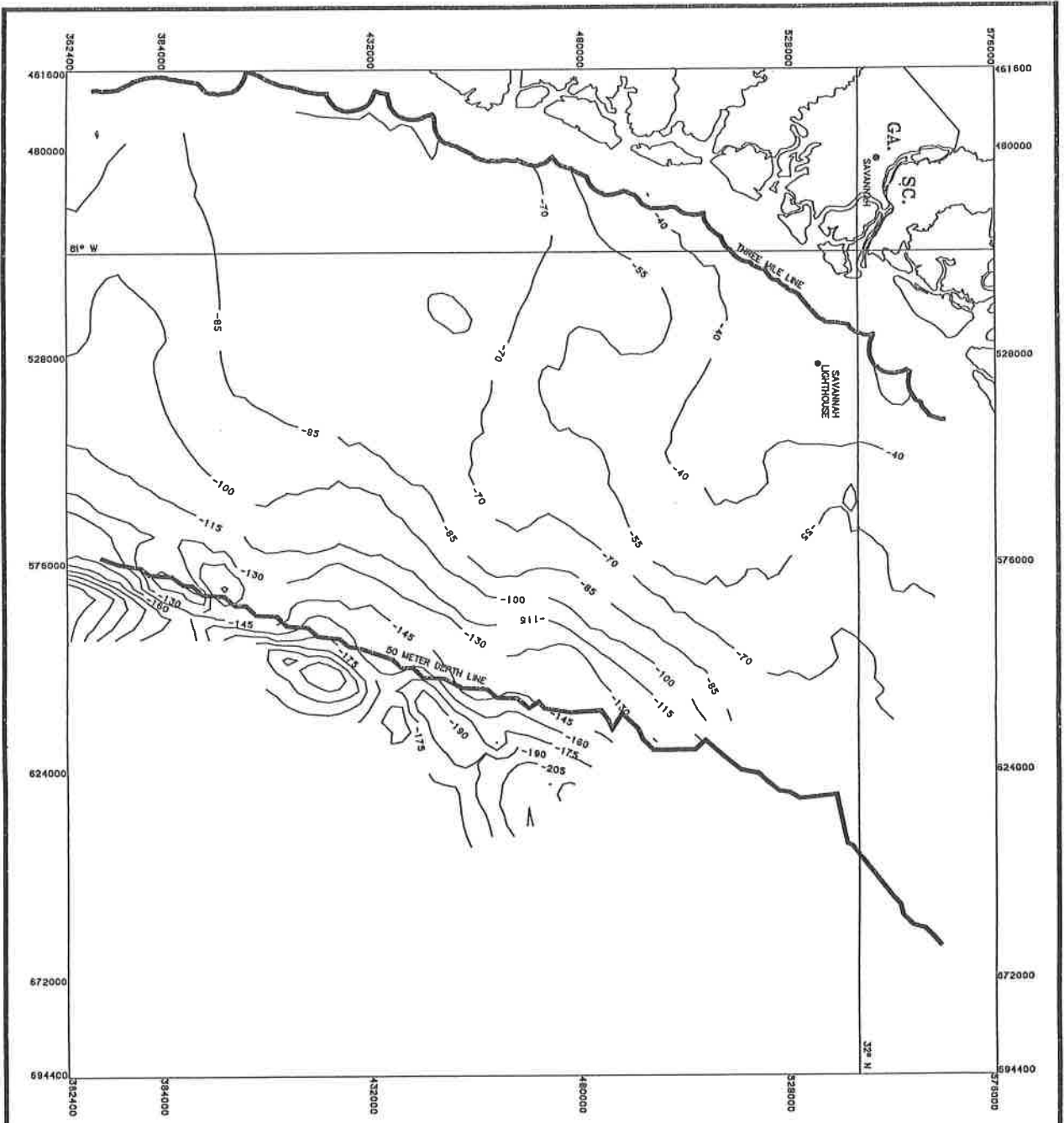
BATHYMETRY

DEPTH BELOW MSL

CONTOUR INTERVAL = 5 & 10 m

ZW

FIGURE NO. 3.8



GRAPHIC SCALES



NAUTICAL MILES



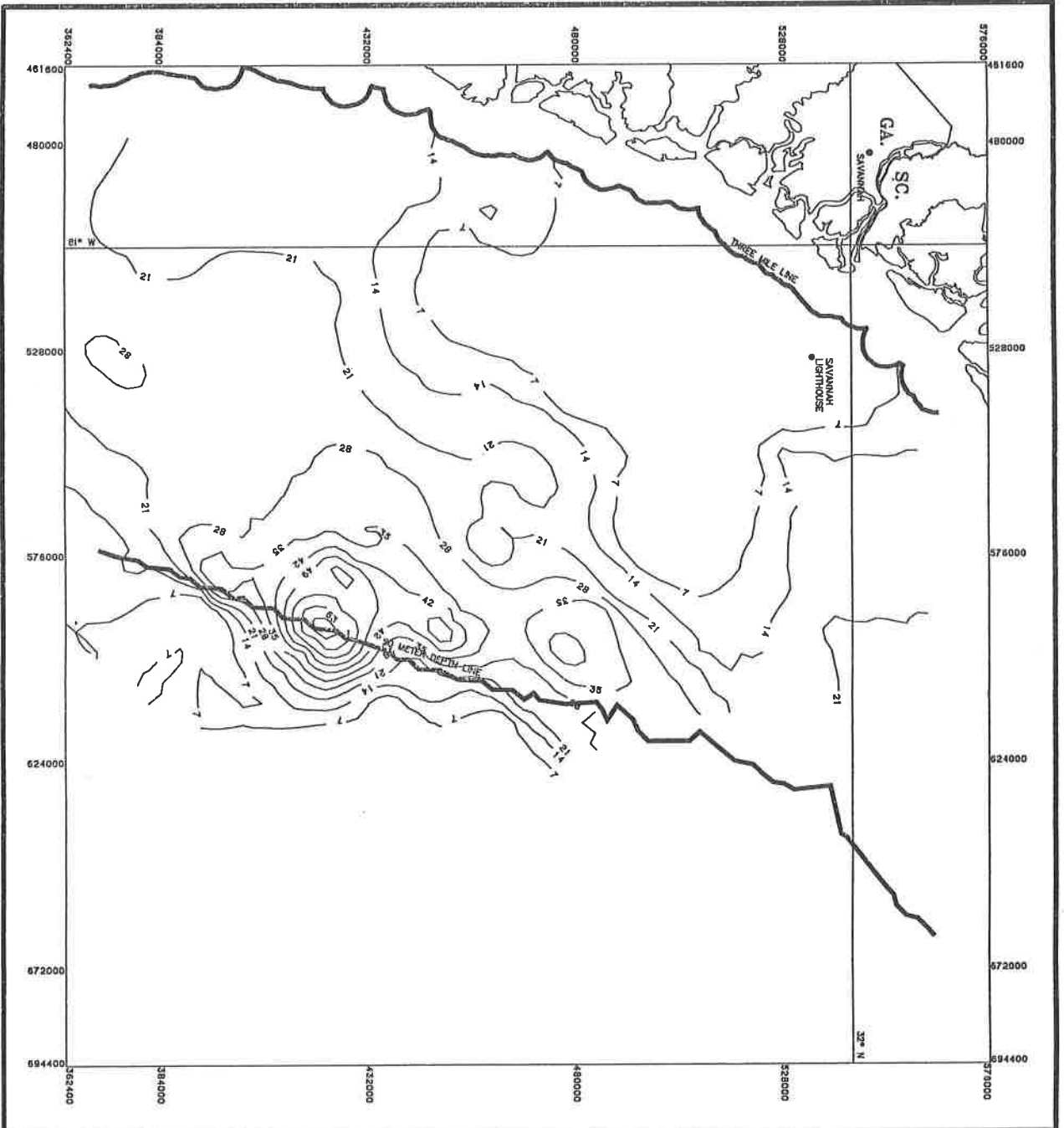
KILOMETERS

GEORGIA OFFSHORE
MINERALS ASSESSMENT

STRUCTURE CONTOUR
BASE OF MIDDLE MIOCENE
ELEVATION IN METERS (MSL)



FIGURE NO. 3.9



GRAPHIC SCALES



NAUTICAL MILES



KILOMETERS

GEORGIA OFFSHORE
MINERALS ASSESSMENT
MIDDLE MIOCENE ISOPACH
THICKNESS IN METERS
CONTOUR INTERVAL = 7 m



FIGURE NO. 3.10

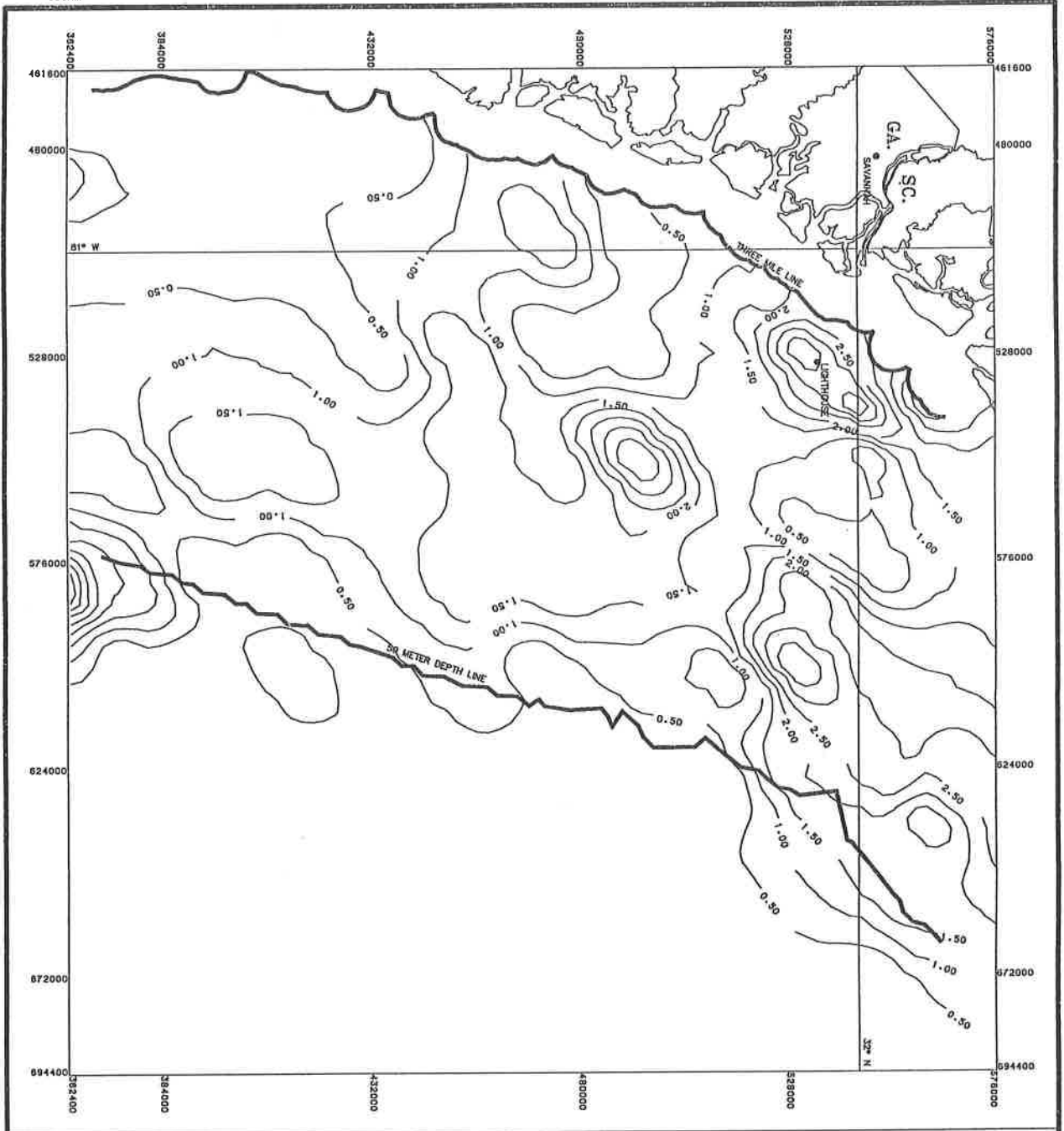
- o Code line 320 - 91 sample points; components given in percent by point count of the fine grain sand fraction (.125-.250 mm)
 - oo Quartz
 - oo Phosphorite
 - oo Potassium feldspar
 - oo Plagioclase
 - oo Heavy minerals

- o Code line 210 - 80 sample points; constituent in percent by weight of total sample
 - oo gravel (greater than 2mm)
 - oo sand (0.062 to 2 mm)
 - oo silt (0.004 to 0.062 mm)
 - oo clay (less than 0.004 mm)

- o Code line 560 - 17 sample points; mineral in percent by weight in the sand fraction (62 um to 2 mm) of the whole sample
 - oo monazite
 - oo rutile
 - oo staurolite
 - oo titanite
 - oo zircon

Figure 3.11 is an isopleth map, built from 91 data points in this database that shows the heavy mineral concentration within the sand fraction. Occurring at water depths between 25 and 40 meters is a linear trend of relatively high heavy mineral concentration (greater than 3%). A detailed bathymetric map (USGS, NOS, 1978) of the study area reveals that within this depth range there are topographic features that could be interpreted as relict sand shoals. Note in Figure 3.12 that between the three-mile line and the 50-meter water-depth contour the sand content is 100%. Development of these features parallels the trend of the higher heavy mineral concentration.

The hypothetical heavy mineral mining location used in this study was selected, in part, because of the distinct heavy-mineral concentration trend seen in Figure 3.11. For this project, this trend has been divided into two parts based on bottom bathymetry and geological interpretations related to



GRAPHIC SCALES



NAUTICAL MILES



KILOMETERS

GEORGIA OFFSHORE
MINERALS ASSESSMENT

HEAVY MINERAL

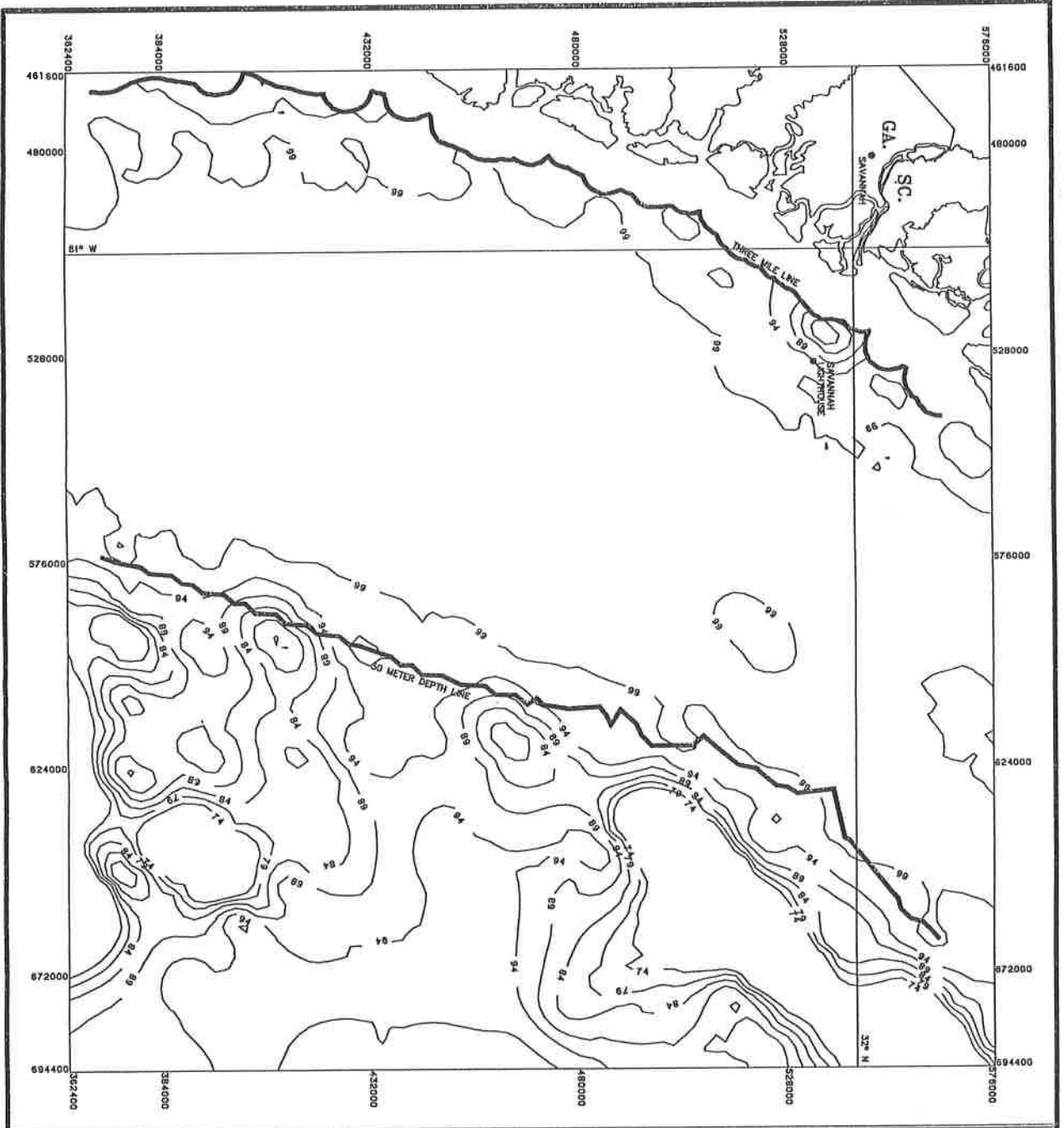
PERCENT BY COUNT

.125 - .250 SAND

CONTOUR INTERVAL 0.5%

FIGURE NO. 3.11





GRAPHIC SCALES



GEORGIA OFFSHORE
MINERALS ASSESSMENT

SAND
PERCENT BY WEIGHT
OF TOTAL GRAB SAMPLE
CONTOUR INTERVAL = 5 m



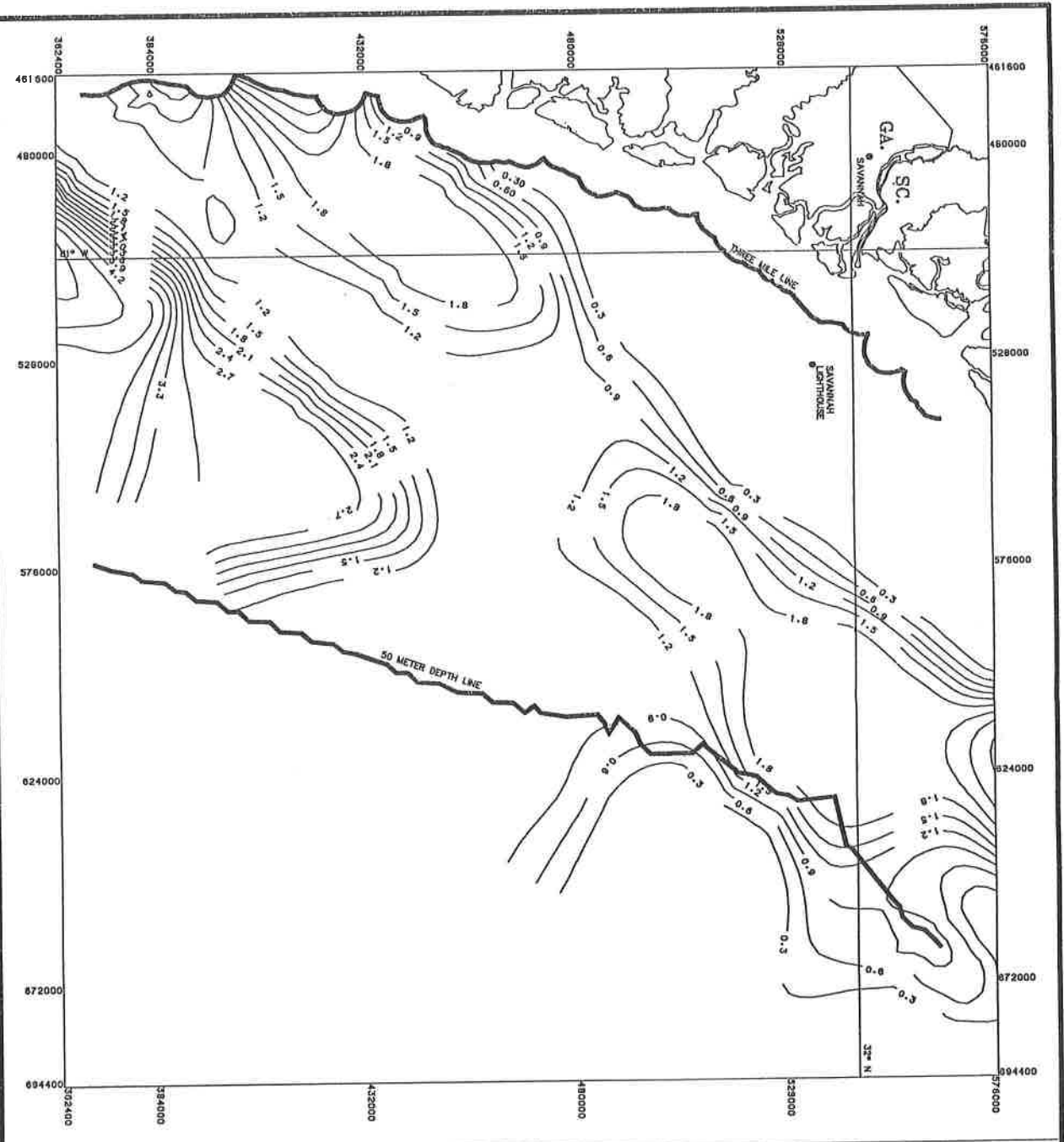
FIGURE NO. 3.12

onshore heavy-mineral deposit trends. However distinct this trend is, it must be noted that it is based on grab samples with an average area of influence of 507 square kilometers.

The aforementioned trend is very pronounced using total heavy mineral content and is supported, in general, by trends in the mineral species rutile, monazite, zircon, and staurolite (Figures 3.13 through 3.16). Unfortunately, the mineral species database does not contain a field for ilmenite, and leucosene is listed under titanite (Figure 3.17). While the trends in the species data approximate the total heavy mineral trend, they do not exactly overlay due to sampling frequency and distribution differences between the data sets. In the area of interest, there are species data at six locations, an average of about 105 kilometers apart. The average area of influence for each site is over 11,000 square kilometers. None of the points lie within the defined heavy mineral trend.

Another notable difference between the two data sets is that the total heavy mineral analyses are percentages of only the fine grained (0.125 to 0.250 mm) sand fraction, while the species analyses are a percent of the total (0.062 to 2.0 mm) sand fraction. Without knowing the heavy-mineral content of sand sizes outside of the 0.125 to 0.250 mm range and the ratio of this size range to total samples, it is not possible to determine in-situ heavy-mineral concentration. If heavy-mineral grains are predominantly in the 0.125 to 0.250 mm size range, then materials outside of this size range decrease the overall in-situ heavy-mineral concentration. Alternatively, in-situ concentration could be the same as, or even higher, than in the 0.125 to 0.250 size range.

In a plan for exploiting East Coast heavy mineral placers, the U.S.B.O.M. (1987) designed a plant to operate aboard a dredge. This plant was designed to recover heavy minerals from sand deposits typical of those found off the coast of Virginia. As designed, material greater than 10 mesh (2 mm) and less than 200 mesh (0.075 mm) would be discarded overboard. It was assumed that only 50 percent of the total material could be eliminated without significantly reducing heavy mineral recovery.



NORTH

GRAPHIC SCALES

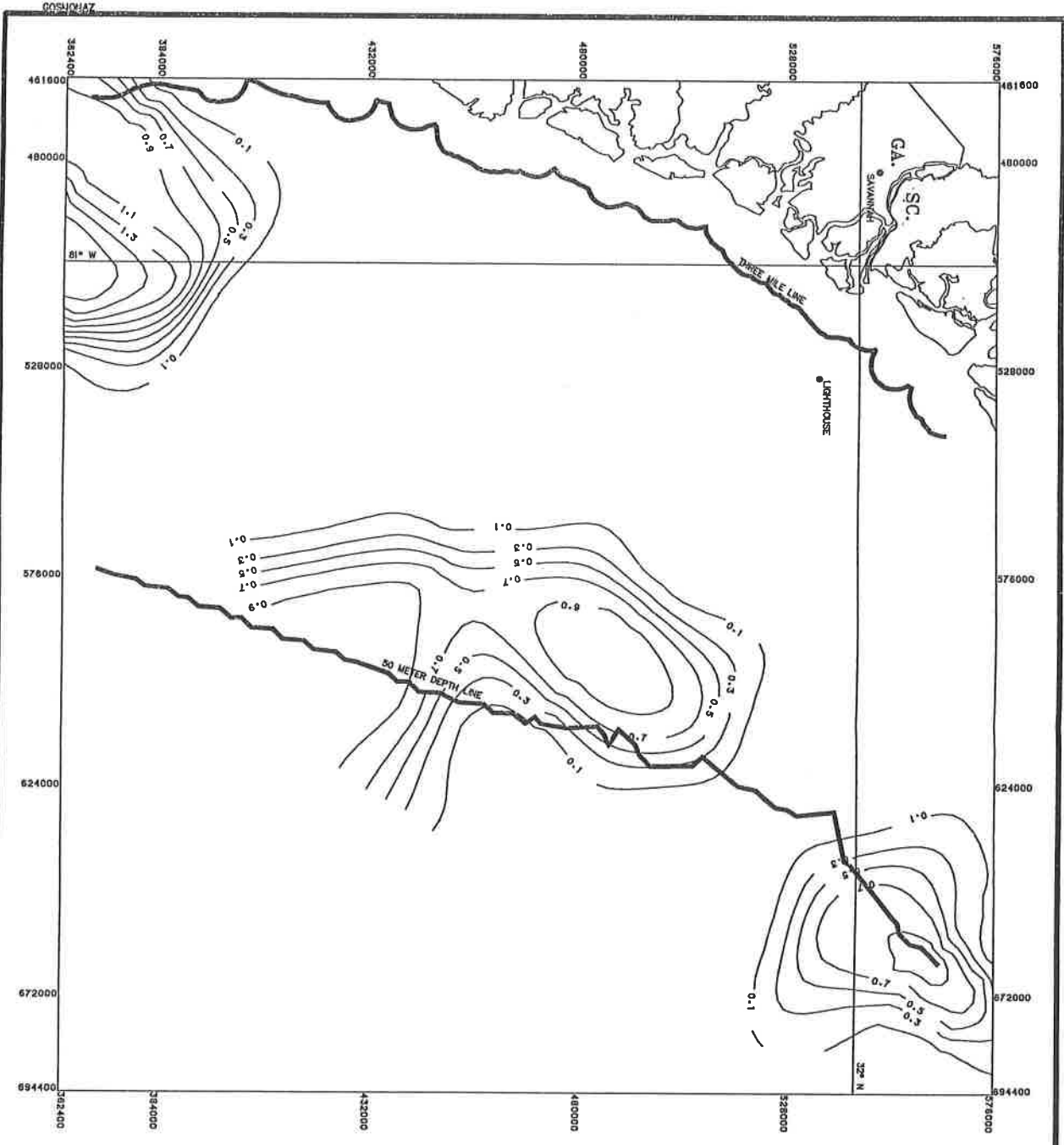


GEORGIA OFFSHORE
MINERALS ASSESSMENT

RUTILE
WEIGHT PERCENT OF HEAVY
MINERALS IN 62µm - 2mm SAND
CONTOUR INTERVAL = 0.3 m



FIGURE NO. 3.13



NORTH

GRAPHIC SCALES

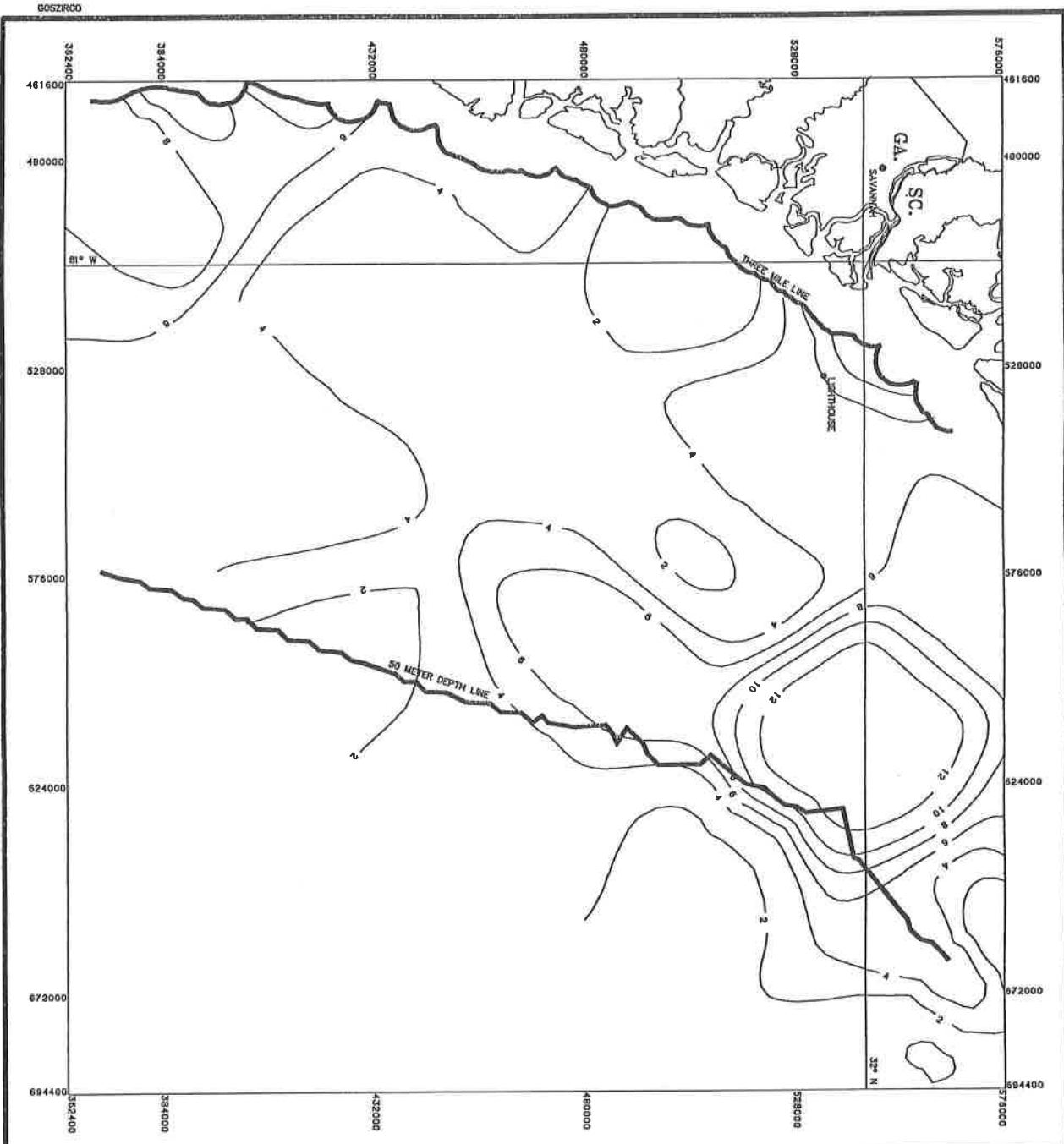


GEORGIA OFFSHORE
MINERALS ASSESSMENT

MONAZITE
WEIGHT PERCENT OF HEAVY
MINERALS IN 62µm - 2mm SAND
CONTOUR INTERVAL : 0.2%



FIGURE NO. 3.14



GRAPHIC SCALES



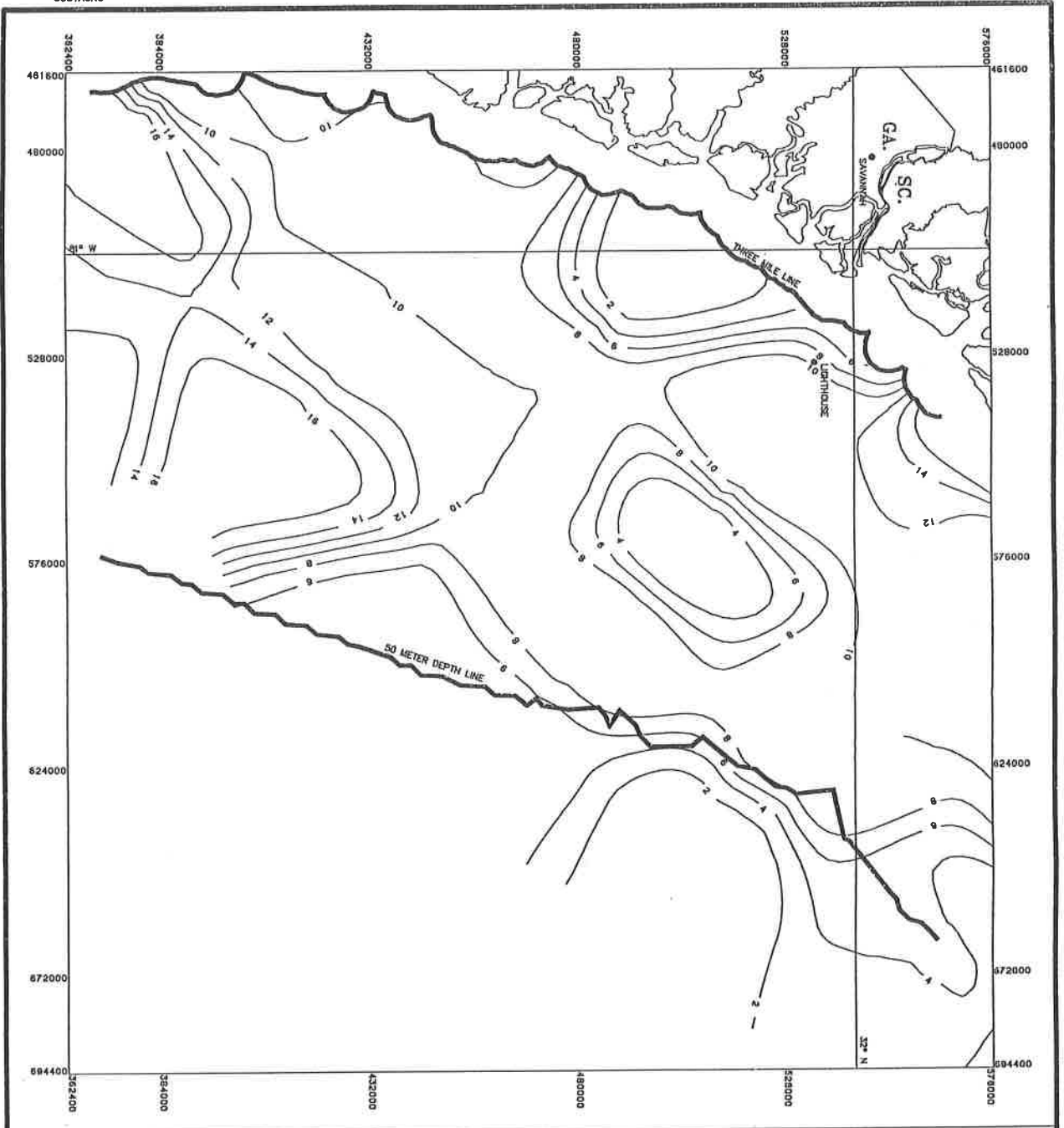
GEORGIA OFFSHORE
MINERALS ASSESSMENT

ZIRCON
WEIGHT PERCENT OF HEAVY
MINERAL IN 62mu - 2mm SAND
CONTOUR INTERVAL : 2%

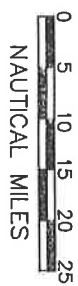


FIGURE NO. 3.15

005ZRC0



GRAPHIC SCALES

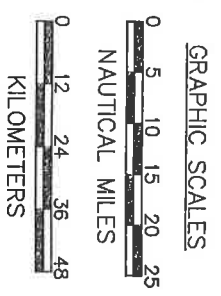
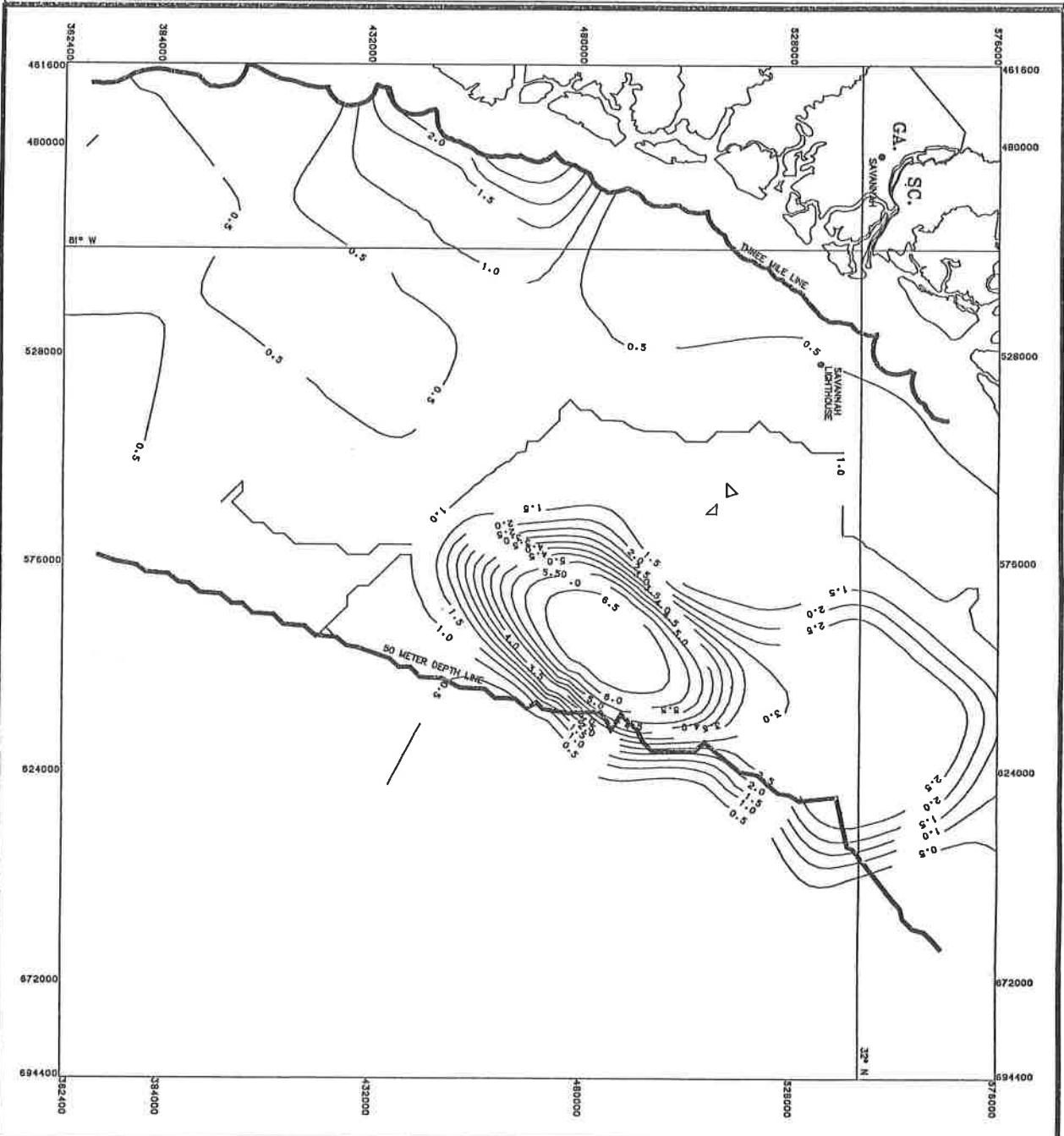


GEORGIA OFFSHORE
MINERALS ASSESSMENT

STAUROLITE
WEIGHT PERCENT OF HEAVY
MINERALS IN 62 μ m - 2mm SAND
CONTOUR INTERVAL : 2%



FIGURE NO. 3.16



GEORGIA OFFSHORE
MINERALS ASSESSMENT

TITANITE

WEIGHT PERCENT OF HEAVY
MINERALS IN 62µm - 2mm SAND
CONTOUR INTERVAL = 0.5 m



FIGURE NO. 3.17

Pirkle and Yoho (1970) present analyses of twenty surface sand samples of the Trail Ridge type which were selected from localities as far north as southern Georgia, and as far south as central peninsular Florida. In these samples, the heavy minerals tend to be concentrated in the plus 230 to minus 120 mesh (0.062 to 0.125 mm) fraction. Percentages of heavy minerals in total samples were significantly less than in the 0.062 to 0.125 mm fraction.

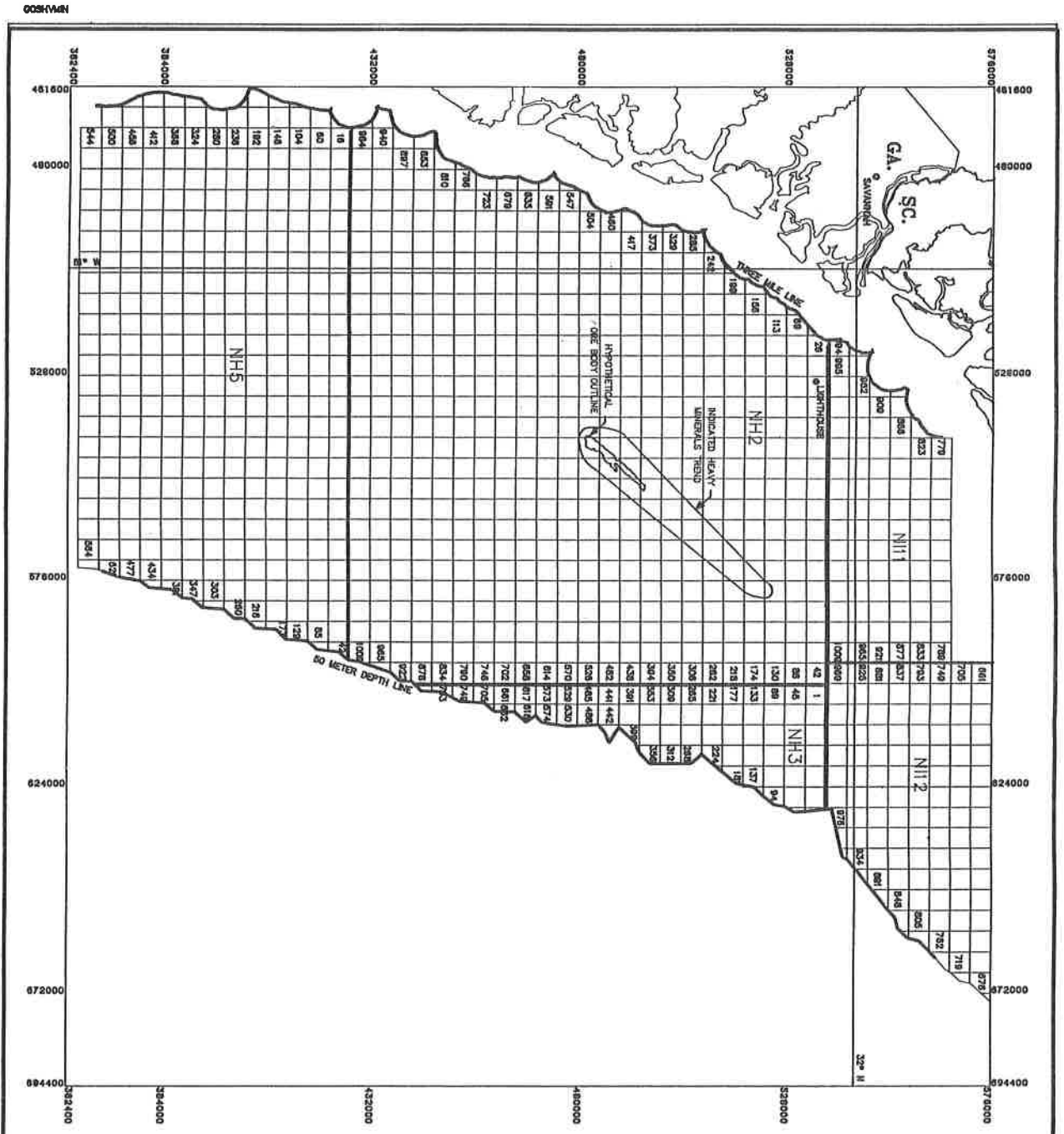
For the purposes of this study, a hypothetical deposit model has been built using the following assumptions:

- o The mining site has been sized to fit the orebody outline of the Green Cove Springs heavy-mineral deposit in northeastern Florida (Figure 3.18).
- o Orebody thickness is considered to be the entire thickness of the Quaternary sands within the orebody outline.
- o Species distribution is calculated from U.S.B.O.M. 1987 using annual production estimates for mean grades of mineral species. For annual mining of 5 million short tons the following species recoveries are realized:

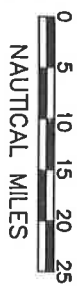
	<u>Tons Recovered</u>	<u>Tons Recovered as Percent of Total Mined</u>	<u>Percent HM Recovery</u>	<u>Tons In-situ</u>	<u>Percent In-situ</u>
Ilmenite	221,862	4.44	83.6	265,400	5.31
Rutile	14,119	0.28	80.8	17,500	.35
Leucoxene	35,398	0.70	80.8	43,800	.87
Zircon	25,994	0.52	83.6	31,000	.62
Monazite	6,772	0.14	83.6	8,100	.17

3.4 PHOSPHORITE POTENTIAL

Zellers-Williams' (1978) report on known occurrences of phosphate deposits in Georgia, North Carolina and South Carolina was prepared for entry into the U.S. Bureau of Mines' Minerals Availability System. Data were collected from known literature, mineral interests previously



GRAPHIC SCALES



GEORGIA OFFSHORE
MINERALS ASSESSMENT
HYPOTHETICAL
HEAVY-MINERAL DEPOSIT
LOCATION



FIGURE NO. 3.18

prospected in the region, and governmental agencies on a regional, deposit summary, or individual prospect hole database. Estimated resources for the "Savannah District" included an offshore portion which had almost no control (two drill cores and seismic profiling).

Subsequently, Zellars-Williams, under the auspices of the U.S. Geological Survey, conducted a technical feasibility and economic potential study (Zellars-Williams, 1979) in the Georgia-South Carolina area near Savannah. This study employed the extrapolation of knowledge of onshore ore characteristics to an inferred offshore deposit because very little data were available offshore.

In general, phosphate minerals occur in marine sedimentary rocks of the Atlantic Coastal Plain from the Florida Keys to North Carolina. The known deposits of marginal or economic grade are confined to sediments of Middle Miocene or, in some cases, younger phosphate containing sediments derived from reworking of middle Miocene beds (Cathcart, 1968). Middle Miocene deposits on the continental shelf of Georgia are represented by The Coosawhatchie Formation (Henry and Kellam, 1987). The Coosawhatchie Formation contains marine sands and clays with variable amounts of phosphate mineral. It has been divided into four members, the most important of which is the Tybee Phosphorite Member. Lithology of the Tybee member is discussed by numerous authors, including Kellam (1981), Henry and Kellam (1987) and Woolsey, (1977).

Savannah is underlain by thousands of feet of sedimentary beds ranging in age from Late Cretaceous to Holocene. Near the center of Chatham County, the top of the phosphate matrix is at Elevation -45 meters. Because the overburden is excessively thick and the matrix thickness is less than 5 meters at this location, the phosphate is not considered mineable under present-day mining criteria. However, to the east and northeast the phosphate matrix thickens and overburden decreases. The higher elevation of the matrix at the coast would appear to contradict the influence of the regional dip to the southeast. The reversal in this case is caused by the north-south trending Beaufort Arch, the axis of which passes beneath the Savannah Light Tower, about 16 kilometers offshore from Savannah Beach on

Tybee Island. Although the limited wide-spaced drilling onshore and the drill data at the Light Tower suggest this structural trend, the seismic profiling work by Woolsey (1976) has provided clear evidence of the structure. It is quite probable that the phosphate matrix in the area north of the Light Tower constitutes the stable sea floor which is being abraded by migrating sand waves.

3.4.1 Techniques for Phosphorite Exploration

Seismic reflection surveys yield worthwhile broad-based information on stratigraphy of offshore areas. Middle Miocene strata, which typically contain the phosphate matrix, have seismic signatures that are recognizable and traceable on a regional basis (Kellam, 1981; Woolsey, 1977). Therefore, interpreted seismic data can be used to approximate depth to, and thickness of, Middle Miocene strata. In this manner, favorable sites for detailed exploration can be established. Seismic data, however, do not provide any information on the actual phosphate content of the Middle Miocene.

In phosphate prospecting there is no substitute for a well-designed program to obtain suitable cores of phosphate matrix. Cores are typically retrieved in four-inch core barrels, and coring is continuous between the top and bottom of the phosphate matrix. A properly executed coring effort will not only provide excellent records of matrix characteristics, but more importantly, it will deliver essential samples for determining the processability of the matrix and contained phosphate rock.

3.4.2 Phosphorite Exploration Targets

Exploration targets indicated by Henry and Kellam (1987) are the eastern flank of the Beaufort Arch, subsurface topographical features (The Tybee Trough, for example), and basal units along the edge and seaward of the Sea Island Scarp. The eastern flank of the Beaufort Arch is considered to be a primary target because phosphorite deposits tend to accumulate on the nose and flanks of structural highs.

Initial exploration for phosphorite should be conducted in locations where, if a deposit is proven, it will have the most economically favorable potential for development. Since analyses of core samples providing data on phosphate ore

grade and quality are very limited, exploration targets must be selected on the basis of relative accessibility. One such site has been selected using unpublished, high-resolution "sparker" seismic-reflection profiles which were collected and interpreted by the U.S. Geological Survey (Popenoe, personal communication).

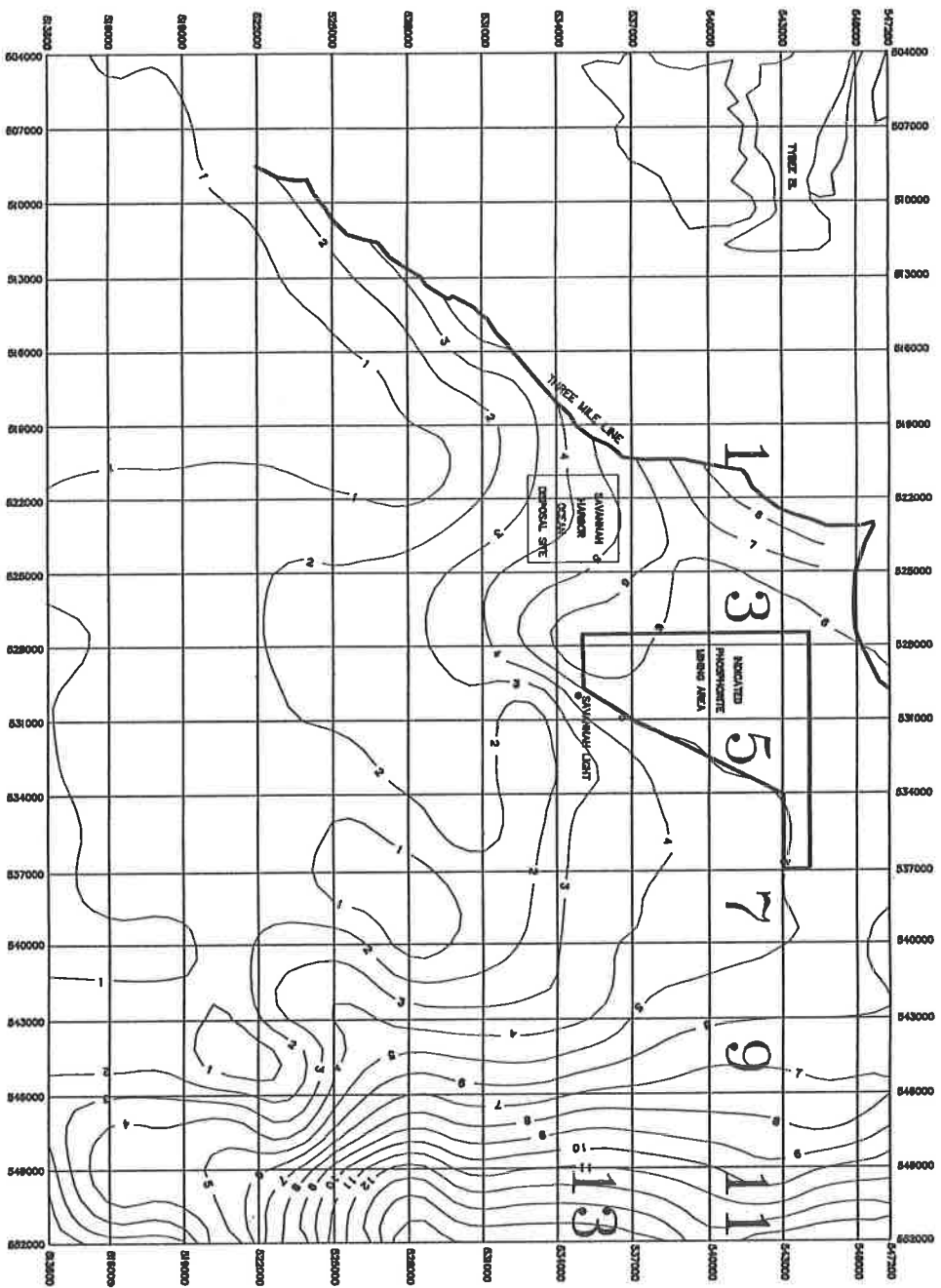
This location, shown in Figure 3.19, has been used in this report for studying the feasibility of phosphate mining on the continental shelf of Georgia. The site selection was confined by an area of zero Middle Miocene thickness immediately to the south, the Corps of Engineers channel widening dump to the southwest, thickening overburden to the east and west, and the South Carolina border immediately to the north. This area contains the shallowest Middle Miocene deposits in the entire study area, as well as the thinnest overburden.

3.5 HEAVY MINERAL POTENTIAL

Three heavy-mineral provinces are generally recognized for the Atlantic Continental Shelf (ACS) of the United States: northern, central and southern. The Georgia coast lies within the southern ACS. Grosz, (1983) cites a number of older studies that refer to economic potential of heavy-mineral accumulations within sediments of the ACS, but do not convey sufficient information for making quantitative resource estimates. Recently published studies of ACS economic heavy-minerals contain very limited information specific to Georgia.

A reconnaissance study conducted by the U.S.G.S. (Grosz, 1983) involved analysis of 71 ACS sediment grab samples from Florida, North Carolina and Virginia. Although none of the samples represent the Georgia ACS, the study is important because results indicate that concentrations of heavy minerals occur in surficial ACS sediments in areas offshore of land areas that contain no economic concentrations.

Over the past few years, U.S.G.S. researchers have made significant progress in defining heavy mineral distributions on the ACS. Two characteristics of the southern ACS reported by Grosz (et al, 1986) are pertinent to this study. These are:



GRAPHIC SCALES



GEORGIA OFFSHORE
MINERALS ASSESSMENT

INDICATED PHOSPHORITE MINING AREA
W/MIDDLE MIOCENE THICKNESS



CONTOUR INTERVAL 1 m

FIGURE NO. 3.19

- o elevated heavy mineral concentrations in the southern ACS appear to be limited to inner-shelf sediments (less than 60 meters water depth), and
- o heavy mineral assemblages of the southern ACS are more economically attractive than those of the northern provinces.

Ongoing studies are being conducted by the U.S.G.S. (Grosz, et al, 1986; Grosz, 1987) to assess the potential for the existence of heavy mineral placer deposits in continental shelf sediments. These studies include analyses and interpretations of grab samples, vibracores and seismic reflection profiles. Vibracore analyses have not been completed for the Georgia ACS. However, preliminary reports, based on grab sample analyses, indicate that elevated values of rutile, zircon, monazite and phosphorite are found offshore of central Georgia.

3.5.1 Techniques for Heavy Mineral Exploration

Sediment sampling on the ACS is done by either grab sampling or vibracoring. Grosz (et al, 1986) have concluded that grab sample analyses are of limited use in ACS placer resource estimation and the technique should be limited to very broad regional studies of qualitative aspects of heavy-mineral assemblages. The same report further concludes that, at the present time, no substitute for vibracoring is presently available for resource estimation and geologic studies in the marine environment. Vibracores are an essential element for evaluation because they provide important information on the vertical extent of heavy-mineral concentration.

Development of geophysical techniques specifically for heavy-mineral exploration on continental shelves is in its infancy. Radiometric data obtained using towed submersible sleds have shown promise as a tool for offshore ilmenite exploration (Tixeront, et al, 1978). Grosz (et al, 1986) documents testing of induced polarization (IP) with a prototype marine IP electrode streamer. Results indicate that the IP method has potential for application as an offshore exploration system and as a shipboard assaying tool.

3.5.2 Heavy Mineral Exploration Targets

In a thorough review of published reports and publically available unpublished documents, no accounts of ACS heavy mineral placer discoveries have been found. The U.S.B.O.M. (1987) reported that two companies explored in 1986 for heavy-mineral placers on the southern ACS. According to Grosz (et al, 1986), the prospect for finding commercially exploitable heavy-mineral deposits in ACS sediments appears favorable.

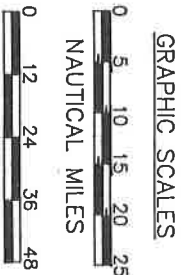
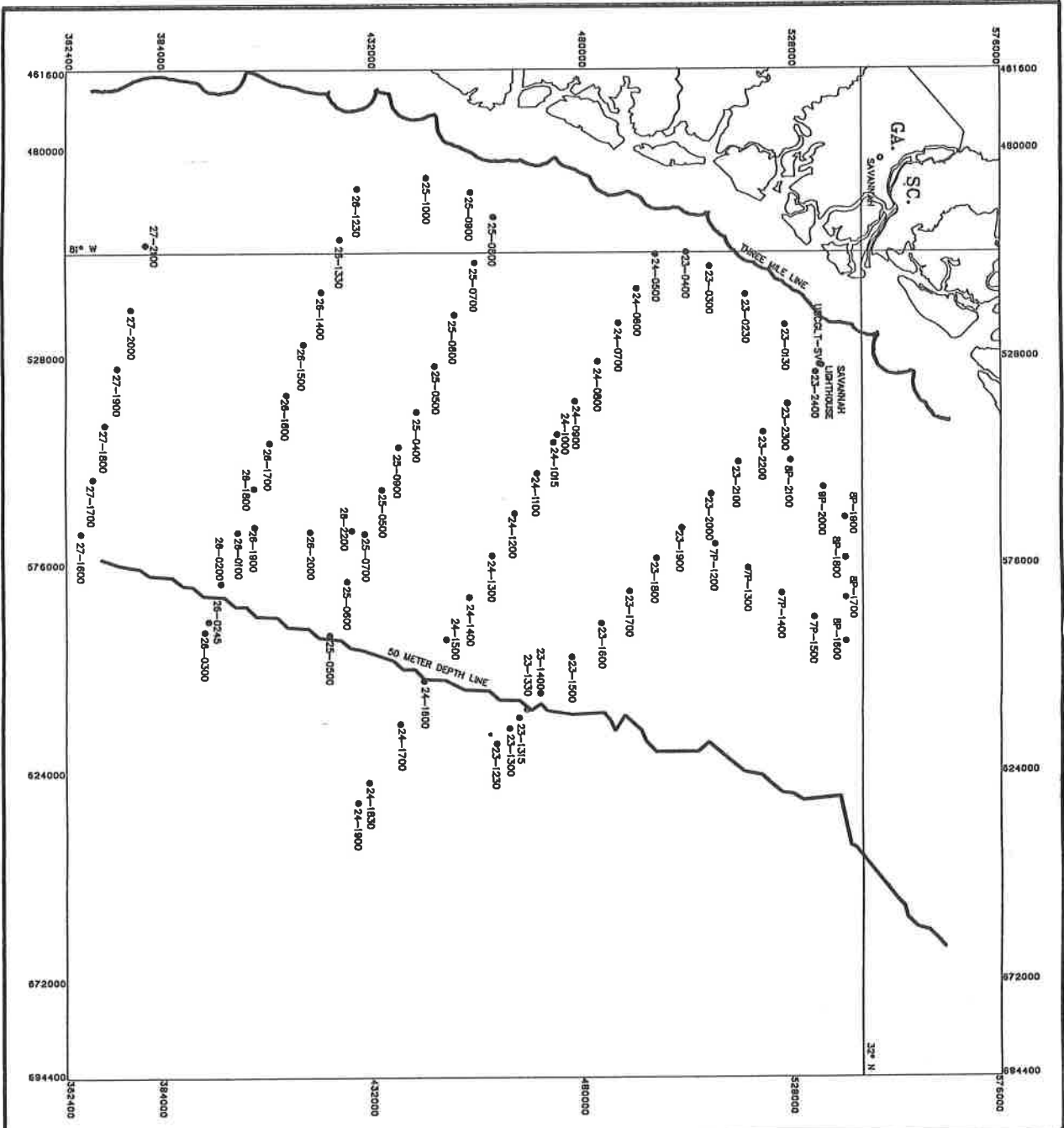
Attanasi (et al, 1987) suggest three types of sediment deposits that are likely to contain offshore titanium mineral placer deposits. These are:

- o beach complex or strand-line deposits formed during a previously lower stand of sea level,
- o linear shore-tied or isolated sand shoals, and
- o older fluvial deposits.

The world's major sources of titanium minerals are onshore beach complex or strand-line deposits (U.S.B.O.M., 1987). In a broad definition presented by Attanasi (et al, 1987) beach complex deposits include beach, aeolean dune, inlet and washover fan deposits. These deposits are generally characterized by fine-grained, well-sorted sands.

Regardless of the exact mechanism, heavy mineral accumulations offshore would have developed during, and as a result of, sea level stands lower than today's. Considering that elevated heavy-mineral concentrations in the southern ACS appear to be limited to inner-shelf sediments, i.e., less than 60 meters water depth (Grosz, 1986), and considering that there is a recognized textural change seaward of 14 meters water depth (Kellam, 1981), primary exploration targets are apparent strand-line deposits lying at water depths between 14 and 60 meters. The location designated as a hypothetical deposit (Figure 3.18) in the Heavy Mineral Analytical Model (Section 3.3.2) is one such exploration target.

An interesting and important feature of the location map for the hypothetical heavy mineral deposit (Figure 3.18) is the relative size of the Green Cove Springs deposit compared to the heavy mineral concentration trend and to the overall study area. Exploration for a heavy-mineral placer deposit having the dimensions of the Green Cove Springs deposit compares to the proverbial needle in the haystack.



ZW

GEORGIA OFFSHORE
MINERALS ASSESSMENT

GEOLOGICAL MODEL

DATA POINTS
From Seismic Profiles

FIGURE NO. 3.20

SECTION 4**OFFSHORE MINING TECHNOLOGY****4.1 INTRODUCTION**

The two types of mineral resources that exist off the coast of Georgia are heavy minerals placer deposits and phosphorite sands deposits. Heavy minerals deposits occur when a heavy mineral source is eroded and the resulting sands are transported to the depositional site by vigorous hydraulic conduits such as waves, tides, or wind. Sediments are generally sorted, weathered, and form concentrations of heavy minerals having economic values. Heavy metals are known to exist off the coast of Georgia, but none have been explored sufficiently to warrant construction of a site-specific geologic model. Consequently, the geological model used in this study is hypothetical and is based on current strandline models from other areas of the world. A strandline deposit is one which was formed during strands at or above sea level. The strandline placers, which form the basis for the geologic model, are the primary sources for the world's supply of titanium, zircon, and other heavy minerals.

A typical heavy mineral strandline deposit contains 140,000,000 tonnes of sands located beneath 80 feet of ocean. The deposit thickness is from 3-12 meters, with no defined overburden. Deposits at much deeper ocean depths, and those with overburden, are considered economically unattractive for the present hypothetical conditions.

More information is known about phosphorite, which also occurs offshore Georgia. Extensive work on phosphorite has been done at Onslow Bay off the Atlantic Coast of North Carolina, a geologically similar area. In addition, drilling at Tybee Island and near Savannah indicates that deposits of potential economic value exist off the coastline.

The deposit parameters for phosphorite deposits offshore Georgia are similar to the characteristics listed above for heavy minerals in regard to ocean depth and deposit thickness, except that some overburden above the phosphorite exists. The type of mining systems and equipment that are applicable to heavy minerals mining may also be suitable for phosphorite mining. However, in phosphorite mining, provisions must be made for overburden disposal.

To a considerable degree, the selection of mining equipment is affected by oceanographic and meteorological conditions. Unfavorable conditions may require shutdown and movement to a safe harbor. At other times conditions may result in a lower production rate. In any case, mining equipment must be designed to meet the oceanographic conditions described in Section 5, and/or be capable of moving to safe harbor in the event of a major storm.

4.2 STATE-OF-THE-ART

Technical advances in offshore oil production have resulted in advanced technology that is currently available for application in the exploitation of offshore marine deposits. Mining must proceed from a central platform, or working area, from which mining and dispatching operations are controlled. These platforms or working stations consist of three general types:

- 1) floating platforms
- 2) fixed platforms
- 3) walking platforms.

Floating platforms generally take the form of especially designed vessels on flotation hulls with dredging equipment mounted or attached. Pontoon or barge-type hulls are used for dredging work in estuaries, harbors, rivers, ship-channels and in-land waters, as these are not suitable for offshore ocean conditions. Dredged material is pumped as a water-solids mixture (slurry) via trailing pipeline to the point of deposition, or is transferred to tugboat-towed scows for transport. Conventional sea-going transport vessel configuration

modified to accommodate dredging equipment is widely used for offshore ocean deep-water dredging. These vessels usually contain compartments to store dredged material and to transport the contents to shore.

In some experimental cases, the actual mining is directed from submersible vessels or bottom-supported vehicles that are attached to the platform by pipelines, power supplies, and mechanical material handling systems such as bucketlines or dippers. While these systems have obtained samples and engaged in exploration activities at depths of over 1000 feet, presently the technology is insufficient to support similar large scale mining operations. Dredges are the only proven mining system that utilize the concept of floating platforms.

Fixed platforms have been used in sulfur mining and oil production for some time. Because they are immobile and above the surface, fixed platforms provide a working area free from movements of the ocean surface and currents. However, this immobility results in a high operating cost when conventional mechanical and hydraulic mining techniques are used. On the other hand, borehole mining can be operated from fixed platforms. In this mining technique, boreholes are drilled through the overburden to the mineral formation (matrix) by mining tools. High pressure water jets, attached to the mining tools, disaggregate the matrix and remove it from the host rock. The slurry is then pumped to the processing plant. Although it has never been successfully applied to commercial phosphate operations, the borehole mining method is being successfully used in commercial mining of sulfur and potash. Borehole mining may be applicable in phosphate deposits with deep overburden. Since it is not necessary to remove overburden, borehole mining techniques result in no overburden removal costs.

A unique walking platform is being developed by IHC Holland. It can be described as a self-elevating platform on which all motions are eliminated because it uses the sea bottom as a supporting structure. In addition, the platform has the ability to walk without being lowered into floating position, a feature that is required since the digging tool must continuously move over the mining area, similar to a land-based dragline. Power for this platform is provided by a surface vessel, which also will receive the material mined for

further processing. These supply lines are the only connection between the surface vessel and the walking mining platform. Although several variations of this machine have been developed and tested, currently no commercial walking platforms are in use.

Ellicott Machine Corporation of Baltimore, Maryland has proposed conceptual designs of platform dredges incorporating design features of conventional dredges and offshore exploration platforms. The design is suitable for mining in shallow offshore waters. This design shows a great deal of promise, and if supported by the viability of Atlantic coast OCS mining may be commercially developed in the near future.

4.3 DREDGES

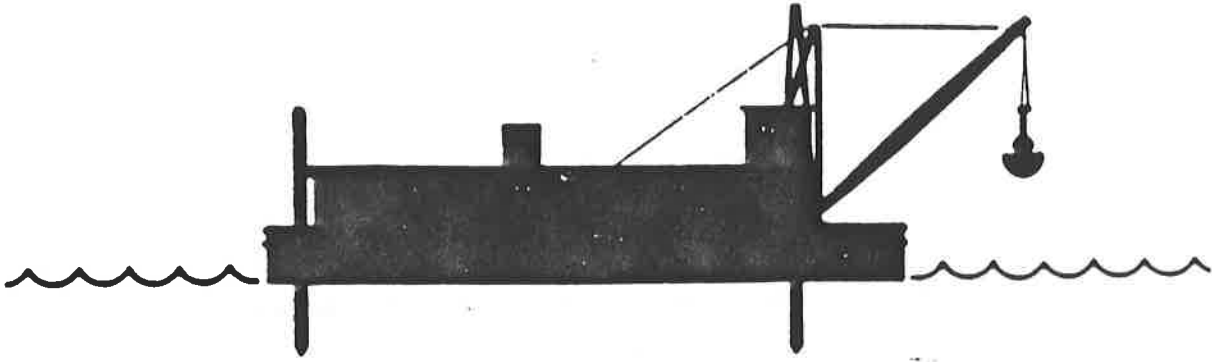
The dredge, of one type or another, is the only system proven to be successful for offshore mining. Several types of dredges have been developed and commonly employed for under-water excavation. Very few of these are suitable for deep water and ocean conditions.

Dredges may be classified as two general types. These are mechanical dredges and hydraulic dredges. The classification is based on the method used to handle excavated material.

4.3.1 Mechanical Dredges

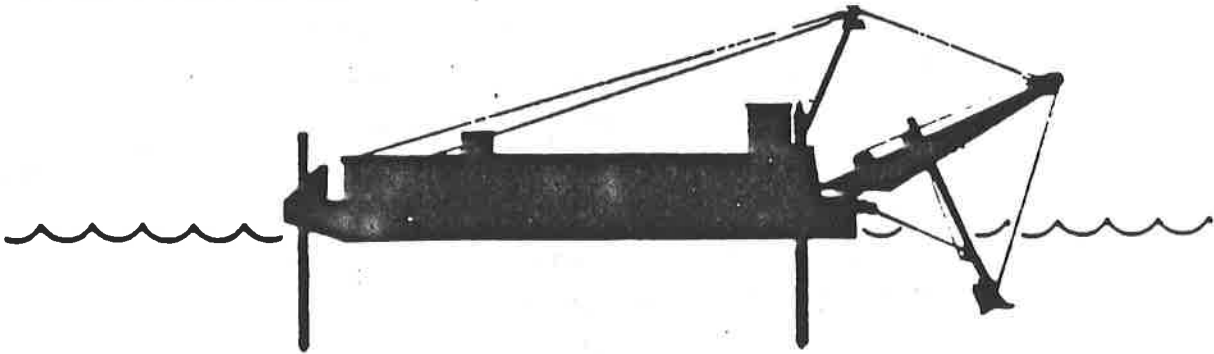
Mechanical dredges consist of three general types, as illustrated on Figure 4.1. These, as a class, are not suitable for production mining of phosphorites or heavy minerals in the offshore ocean environment. They are included here to describe their capabilities, applications, and limitations.

- 1) grapple dredge
- 2) dipper dredge
- 3) bucket dredge.



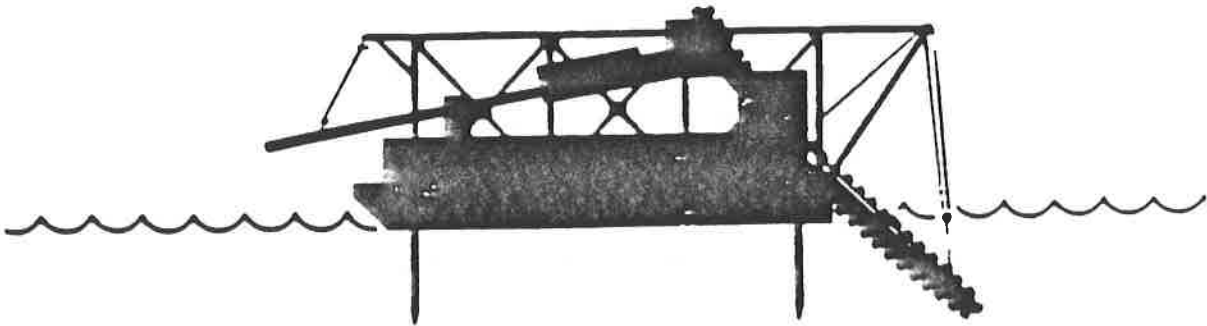
The Grapple Dredge

In this type, the work is done by a clamshell bucket suspended from a derrick mounted on a barge. It is most suitable for excavating medium-soft materials in confined areas near docks and breakwaters.



The Dipper Dredge

A powerful dipper bucket mounted at the forward end gives the dipper dredge its main advantage: strong "crowding action," produced as the bucket is forced into material being moved. This permits efficient removal of rock and other hard materials. For its size, a dipper dredge can handle larger pieces, thus reducing blasting needs.



The Bucket Dredge

Buckets mounted on an endless chain do the work here. Each bucket digs, conveys and dumps its own load. A continuous work cycle makes the bucket dredge an efficient mechanical dredge, when used in operations such as sand and gravel production.

Grapple Dredge

The grapple dredge is a flat-topped barge upon which a derrick is mounted to support the clamshell bucket by means of wire rope lines. The clamshell derrick is attached to a revolving machinery deck similar to a land-based dragline tub. Similarly, the bucket swings around the derrick to load barges anchored nearby, or to spoil material.

Two general types of grab buckets are used -- the clamshell, for mud or stiff mud, and the orange peel, for loose rock or other hard or bulky materials. The grab dredge is used extensively around docks, piers, and particularly in the corners of cuts where it has the ability to get in close without damaging structures. This dredge works well in silts and stiff muds and is particularly effective where there are obstructions and trash. Production is poor, and an irregular bottom is left, making it unsuitable for stiff hard materials.

Since digging action depends upon bucket weight, the grapple dredge does not have sufficient penetration to obtain a "full bite", or full load in hard materials. Dredging depth is restricted only by the length of the hoisting wire. However, deeper dredging will result in lower production due to increased hoisting time. Dredging depths of 100 feet are not uncommon.

Dipper Dredge

Dipper Dredges - The dipper dredge is a power shovel or backhoe operating from the forward end of a barge. Like its land counterpart, the dipper dredge has good crowding action, making it suitable for handling large rocks, and casting them into nearby barges for removal. To obtain stability, spuds anchor the dredge when excavating. It is most effective in hard materials such as till, soft and broken rock, and shales, but also works well in areas where obstructions such as boulders, snags or timbers exist.

Located on the hull are two forward spuds and one stern or kicking spud, similar to those on grab dredges. The two forward spuds are used to lift the barge above its normal flotation and thereby obtain additional weight for

absorbing the reactions of the digging operation. The kicking spud is used to move the dredge forward. Digging depth is limited by the length of the boom, 65 feet being about the maximum.

Both the grapple dredge and the dipper dredge are unsuitable for offshore operations. The grapple dredge is unproductive in large tonnage and deep water deposits, while the dipper dredge has mechanical limitations and limited digging depth.

Bucket Dredge

These dredges excavate with a continuous chain of buckets supported on an inclined ladder that moves up and down around two pivots called tumblers. As the buckets go around the lower tumbler, they scoop up the material, carry it up the ladder, finally dumping it into an ore chute as the buckets pass over the upper tumbler. The continuous action at the bucket chain provides good production and efficient operations. The bucket dredge is extensively used for sand and gravel deposits, and diamond and heavy metal (tin) deposits.

One of the disadvantages of this dredge is that it has to be moored with five or more lines and anchors. These moorings hinder traffic, and moving and resetting the dredge is time-consuming. Not only does this dredge have poor mobility as a result of the moorings, but it is not stable when being towed, principally because of the high center of gravity caused by the ladder, A-frame, and buckets. A second disadvantage is that it is not a rough-weather dredge. In active water the material washes out of the buckets. Waves of three feet or more make it non-productive, although recent design has improved this condition.

4.3.2 Hydraulic Dredges

Hydraulic dredges can be classified into two main types - cutter head and suction head - based on the "head" attachment at the end of the suction pipe. For offshore marine applications, both types of hydraulic dredges consist of ocean-worthy self-propelled vessels on which a large centrifugal pump and suction pipes are mounted. The centrifugal pump draws a mixture of water

and suspended solids from the sea bottom, which is pumped as a slurry to on-board hoppers, nearby barges, or into slurry pipelines. Loose material can be drawn into the suction head with a plain hydraulic suction head. Hard materials require a cutter head to dislodge and direct material into the suction head.

Plain-Suction Dredges

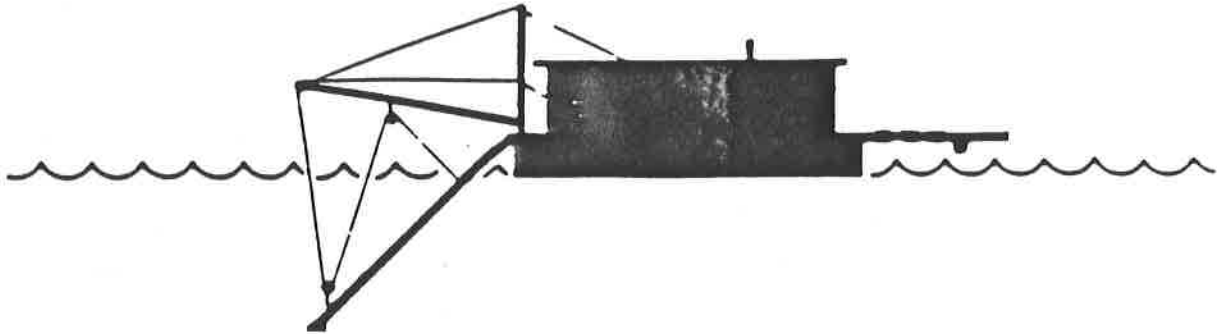
Plain-suction dredges are similar in hull construction to a regular ship, but they often differ from other dredges in the location of the suction pipe. The plain-suction dredge often has its suction pipe in a well at the bow, whereas other types have their suction pipes alongside. The suction pipe, regardless of its location, extends through the hull to the dredge pump.

For compacted material, the plain-suction dredge often has water jets installed at the lower end of the suction. High-pressure water is forced through the jets to break up the material. The suction end is also often flattened in a rectangular shape, similar to the mouthpiece of a vacuum cleaner, with the jets attached around the perimeter.

The dredge pump creates a pressure drop resulting in the movement of water and solids material into the suction pipe head. The dredge pump pushes the slurry along the discharge pipe to on-board hoppers or barges moored alongside the barge. Technology for dredge pumps is advanced, with special alloy castings available for pumping abrasive material. Most dredge pumps cannot lift slurry much more than 7 meters above the ocean level. To increase lift, pumps are mounted on the suction pipe boom below water level; however, motors must also be of the submersible type or extended power transmission shafts constructed. Economics is a prime determinate in design of dredge pumping systems. Dredge technology is well advanced.

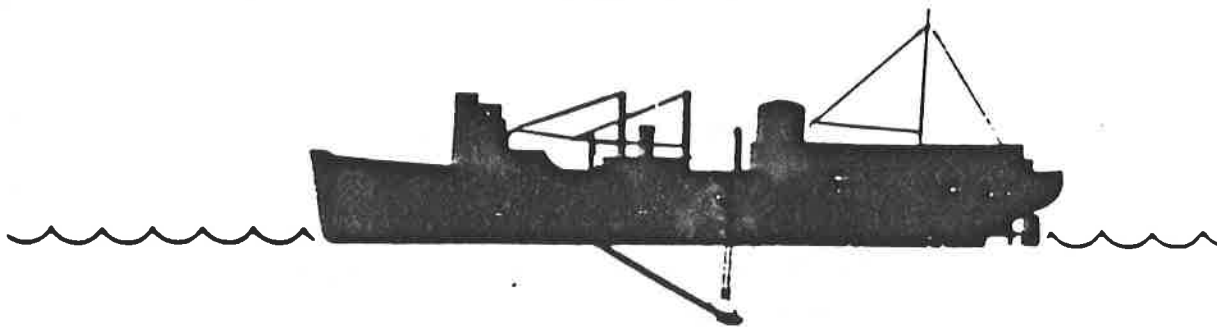
Figure 4.2 illustrates three types of hydraulic dredges.

The plain suction dredge shown is commonly employed for civil works excavation in and around harbors and marine facilities. Owing to the design



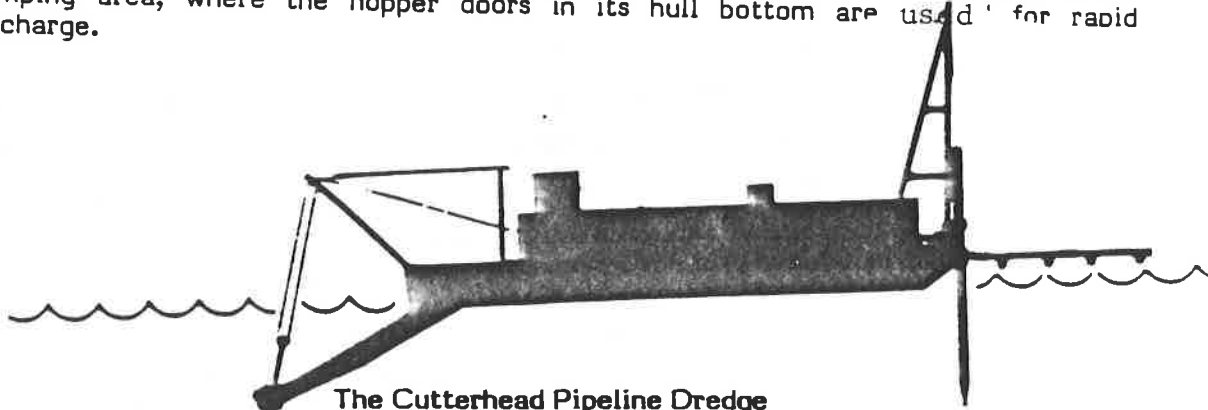
The Plain Suction Dredge

In this type of dredge, a suction pipe is lowered to the surface to be worked. A powerful dredge pump draws up the material, mixed with water, and discharges through a pipeline. Units of this type are used for digging soft, free-flowing materials.



The Self-Propelled Hopper Dredge

Resembling an ocean-going ship, this vessel functions in a way similar to a plain suction dredge. Material is gathered from the bottom by dragged suction heads, then pumped into storage hoppers. When filled, the dredge proceeds to a deep-water dumping area, where the hopper doors in its hull bottom are used for rapid discharge.



The Cutterhead Pipeline Dredge

The most versatile and widely used excavating unit for transporting waterbound solids. A rotating cutter loosens the material, which is then sucked through the dredging pump, discharged via a pipeline at the stern. These dredges can dig and pump all types of alluvial materials, also, clay, hardpan and other compacted deposits.

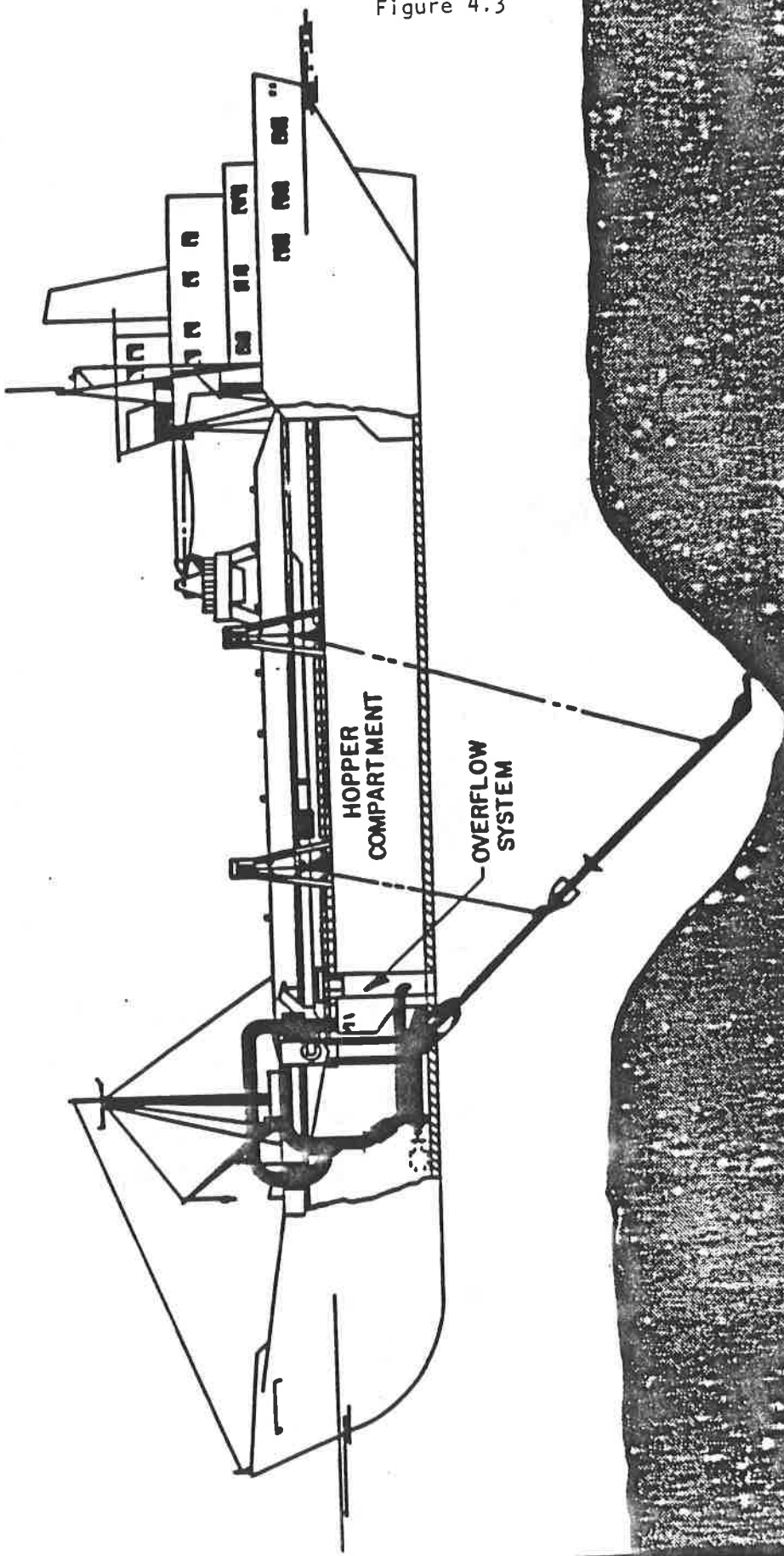
of the hull, which is often a single barge-shaped pontoon, this type suction dredge is not suitable for operating in the offshore ocean environment. The hull is not seaworthy enough to permit safe operation. This dredge may be self-propelled, but is more often towed and positioned by tugboats. The depth capability of this dredge is limited to the net positive suction head available at the dredge pump mounted on the deck, usually 5-8 meters. Depth is theoretically unlimited when the pump is submerged. Submergence is limited by design considerations, such as size of structural components, and the floating platform. Capacity is dictated by pump size, and power available.

The self-propelled hopper dredge is also known as the trailing suction head dredge.

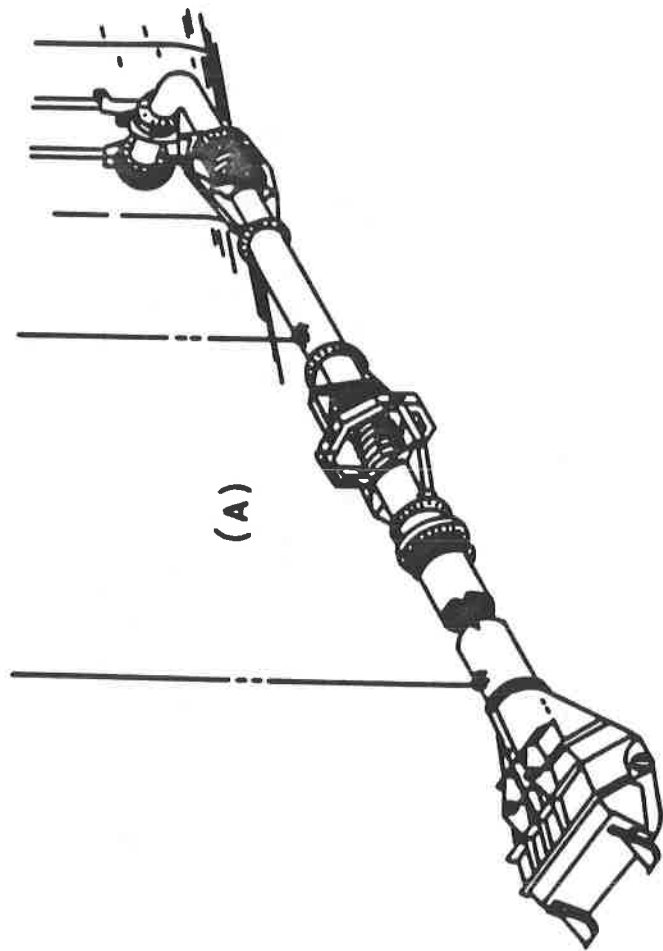
This dredge operates while the vessel is underway, moving forward at about 1-3 knots. As the name indicates, the suction pipe trails behind the vessel dragging along the sea bottom. Figure 4.3 illustrates this type of dredge. Because dredging takes place as the vessel is underway, a deep excavation such as that illustrated is not typical. This shape and depth excavation would result from a fixed position with the vessel anchored.

Specially designed heads, depending upon the material being dredged, are mounted on the pipe and are referred to as dragheads. Figure 4.4 illustrates a typical trailing drag arm and several types of drag heads. For certain applications, a submerged dredge pump is added to the drag arm to increase effective depth and capacity. Dragheads can normally be adjusted and generally cut a path 1 meter wide by 1/3 meter deep. The resulting cuts are numerous shallow trenches in the sea bottom. Mining control is limited with the trailing suction head dredge. The dredged material is pumped into a hopper onboard the vessel, dewatered, washed and screened, then transported to shore when the hopper is full. When material is washed, waste material can be discharged through a pipe/pumping system to the bottom of the ocean, thus avoiding turbulence. The rejected sands partially settle in the mined trenches.

Figure 4.3



Marine Mining on the Outer Continental Shelf
U.S. Department of the Interior, Mineral Management Service
OCS Report 87-0035



(A)

(A) TYPICAL TRAILING DRAG ARM
 (B) DIFFERENT DRAG HEADS

Figure 4.4

(B)

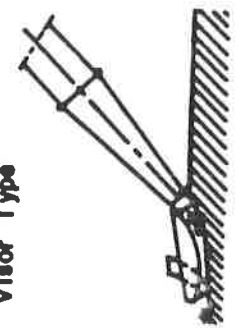
DRAG HEADS FOR SAND AND GRAVEL



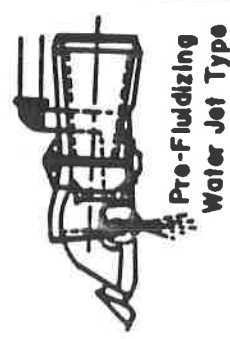
Viscor Type



California Type



Venturi Type



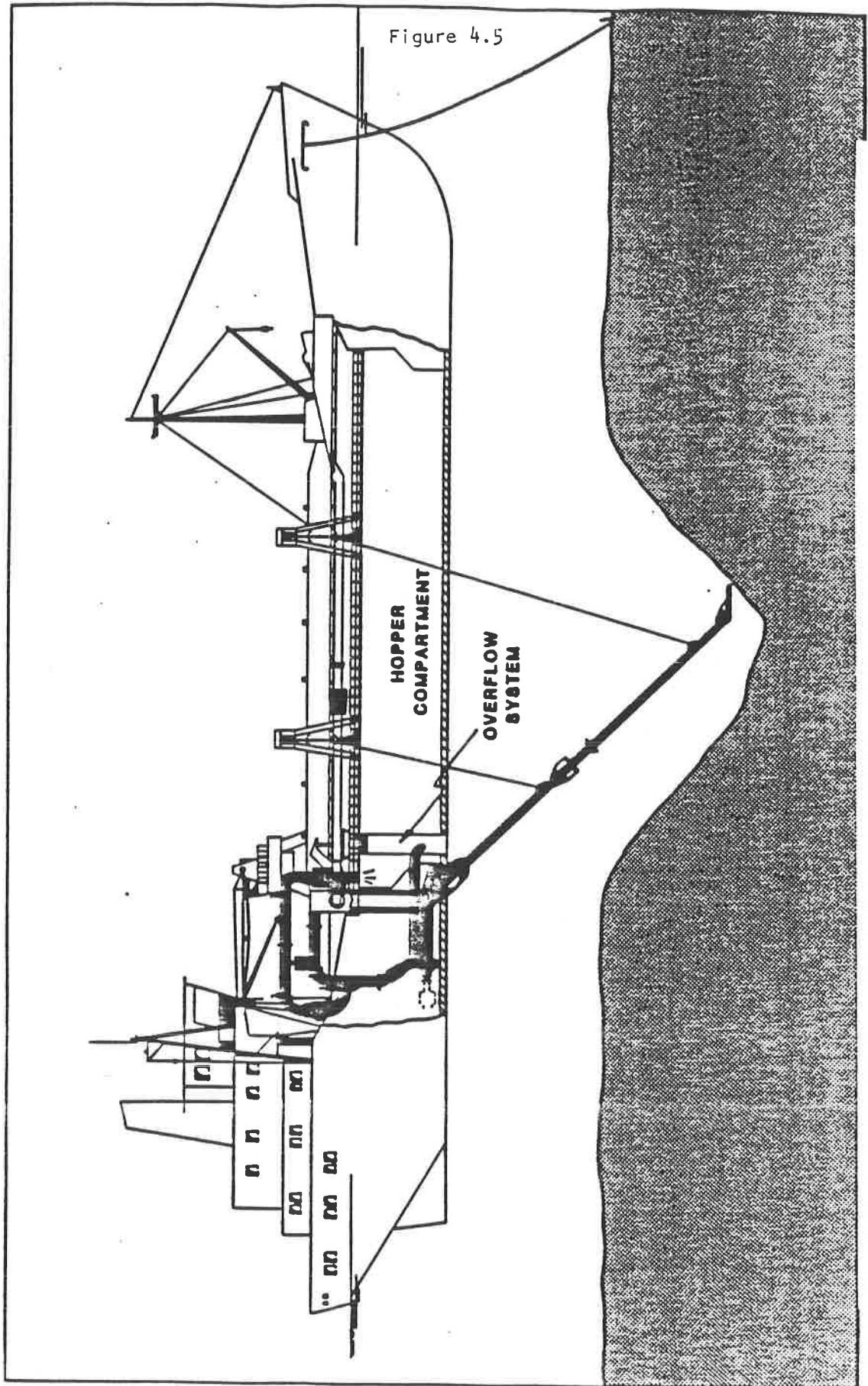
Pre-Fluidizing
Water Jet Type

Trailing suction head dredges are common in channel dredging operations. An example is the DCI Dredge IX built by IHC Holland for the Dredging Corporation of India. This is the fifth trailing suction head dredge bought by this company. The primary function of this dredge is to maintain shipping channels and approaches to several ports. The DCI Dredge IX is a twin-screw trailing suction dredger with a hopper capacity of 4,500 m³. Two 800 mm diameter suction pipes are capable of dredging to a depth of 25 meters. The DCI Dredge IX is equipped with an automatic light mixture installation which ensures that only a mixture with a predetermined solids concentration goes into the hopper. The hopper can be filled in about 40 minutes. Spoil is discharged through 18 conical valves arranged in two rows in the bottom of the hopper. Air conditioned living quarters for the crew of 50 men are built in the rear of the vessel. Complete instrumentation allows the dredge master to optimize the entire hopper charging process. Overall length is 102 meters, with an 18 meter beam. Power is provided by two 1070 kW electric motors operated from the two main 3850 kW propulsion engines.

Another use for trailing suction head dredges is in mining of aggregates off shore in the United Kingdom (U.K.). Twenty million tons of aggregate are mined by trailing suction head dredges in the U.K. The trailing suction dredge is an efficient mining tool and has the ability to operate under almost all conditions in the rough North Sea waters. An example, the Arco Avon has a submersible dredge pump installed in the trailing-suction pipe.

This enables the Arco Avon to dredge approximately 43 meters deep. The 1,000 kW centrifugal pump has a suction mouth diameter of 700 mm and is capable of pumping sand/gravel at a rate of 2,000 tons/hour. An automatic swell compensator raises and lowers the suction pipe so dredging can continue in sea conditions of up to 6 m swells. The vessel is 98 meters with length, with a 17 meter beam.

Anchored suction head dredges operate much the same as trailing suction head dredges except that dredges are anchored to a location and angular movement is restrained by those anchors. Figure 4.5 illustrates the configuration of a sea-going anchor-type suction head hopper dredge operating at anchor. The suction head is held in one location longer so pits



are dug instead of trenches. The dredge can mine panels about 80 meters wide and 1000 meters long in about 60 meter blocks.

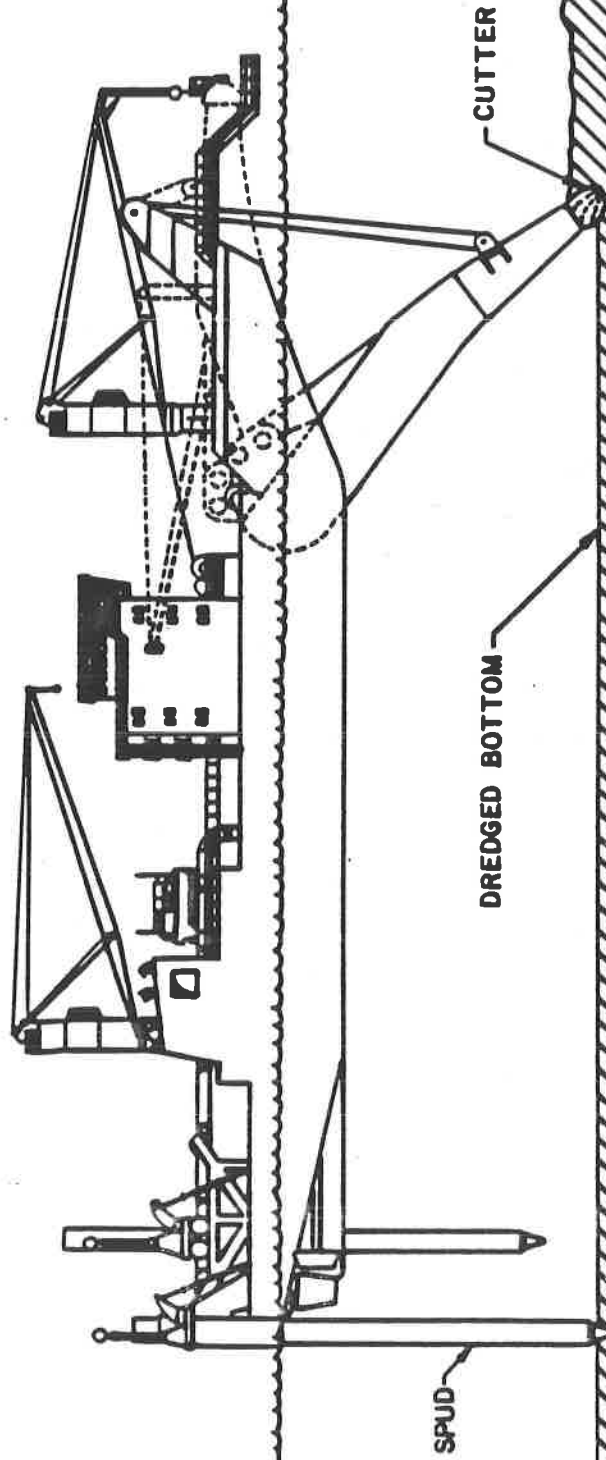
As the desired depth is reached for the panel, the anchor is pulled and the dredge relocated to the next block. The mining process is repeated for each new block. Since the suction head is dragged over the bottom only by the swing motion of the dredge, it has less digging capability than the trailing suction head dredge. Operation of this dredge often requires the use of a separate tug to remove, re-position, and re-set the anchors.

Anchored suction dredges are used in Japan for aggregate mining, usually at depths of around 30 meters. In Europe, these dredges have been used, but in recent years all mining dredges operating offshore the United Kingdom and the European coast have been of the trailing suction head design.

Cutter Head Dredges

The cutter head dredge is essentially a combination of other dredges, adapted so that material is excavated mechanically and transported hydraulically to another location. The cutters are mounted near the suction intake of the dredge pump and attached to the bottom of a ladder which, in turn, is attached at the bow of the vessel. Cutters are connected by a shaft to the cutter motor. Rotation of the cutter agitates loose material and cuts hard material. Cut material is directed to the suction intake through the motion of the cutter and the design of the suction intake pipe. Material is pumped aboard the vessel and handled in the same manner as the plain suction head dredges. A typical cutter head hydraulic dredge is shown on Figure 4.6. This dredge utilizes a basket type radial cutter head. The blades of the cutter may be plain for semi-compacted material, or may be studded with replaceable teeth for harder material. Spuds are used to position the platform and to resist the reactive force of the cutter head.

Figure 4.6



In addition to the cutter head, the ladder carries the suction pipe, lubricating lines, motors and reduction gear. The aft, or upper end of the ladder, is supported by heavy trunions set in a well in the bow of the dredge hull. The dredge is held in position by spuds. Movement of the cutter head is from side to side over an arc angle of 90°-100°, and is controlled by winching anchored swing lines attached to winch drums on board the vessel.

The A-frame is the main support for the block-and-tackle that supports the ladder. It is usually pinned to the forward end of the dredge hull rather than being fixed rigidly. This arrangement allows for movement while the dredge is operating. It is tied back to an H-frame by flexible wires or steel rods. Angular rotation of the vessel about a spud permits the dredge platform and attached ladder to advance, thereby forming a mining pit.

A cutter head dredge which utilizes a bucket wheel to excavate material is shown on Figure 4.7. This dredge is essentially the same as the basket cutter head dredge. The cutting wheel is designed for the material to be excavated, with or without teeth, and directs the excavated material to a suction pipe. The ladder, or boom, supports the bucket wheel, bucket wheel motor, suction pipe and, if required by depth and capacity, a submerged dredge pump and submersible motor. In recent years many of these type dredges have been built for high capacity or difficult digging conditions. This type dredge has also been adopted to sea-going vessels for mining in offshore ocean conditions.

Cutter head dredges of both types have been used extensively for mining onshore, including heavy minerals and phosphorite and are, in recent years, being extensively adopted to offshore ocean dredging applications.

4.4 CURRENTLY AVAILABLE MINERAL DREDGING SYSTEMS

There are many examples of modern dredging applications, many of which are for the purpose of mineral recovery. Table 4-1 lists some of the more important mining dredges world-wide, with statistics of interest. Examples of each type; bucket ladder dredge, cutter suction dredge, bucket wheel dredge.

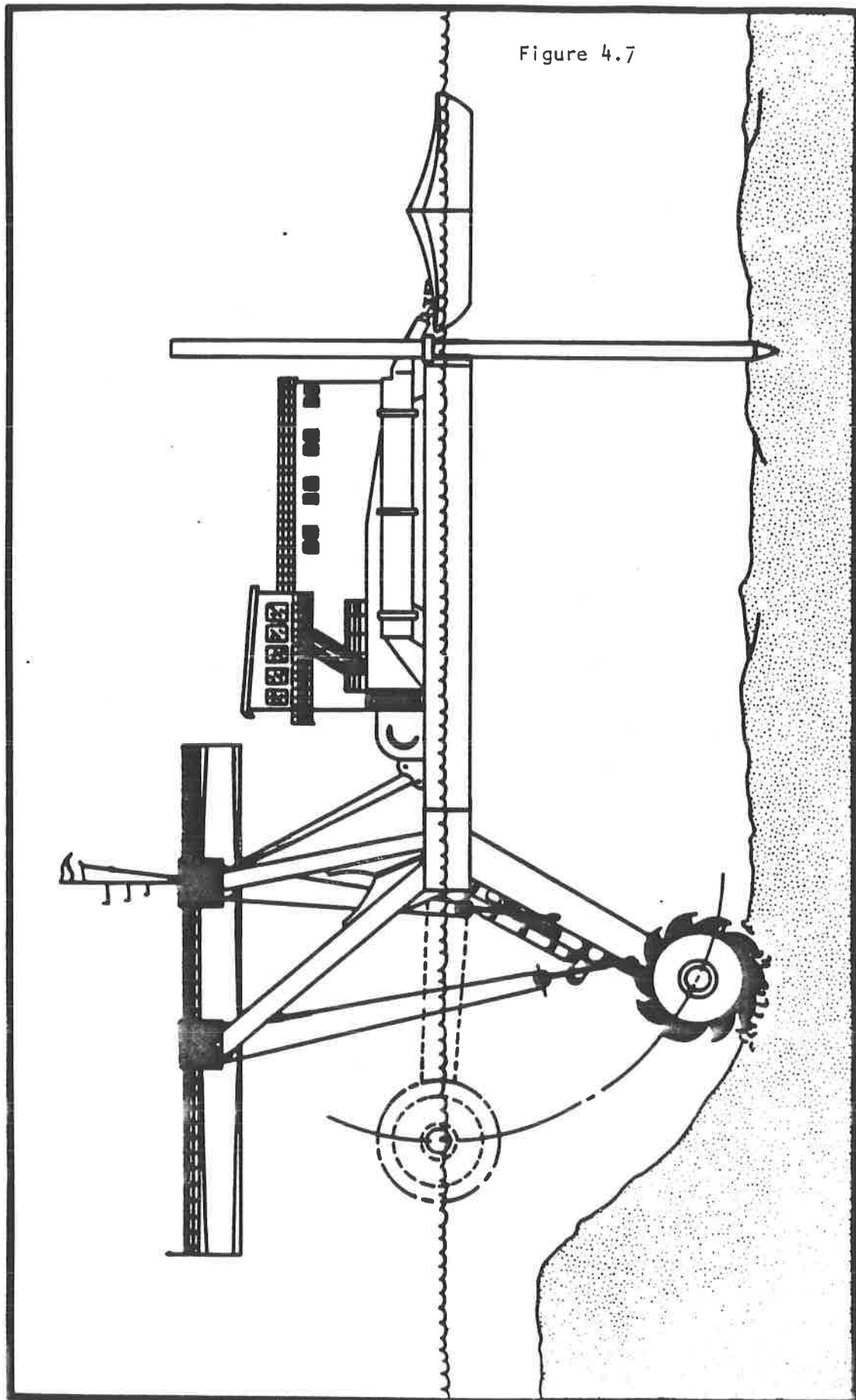


Figure 4.7

Table 4-1
Commercially Available Mineral Dredging Systems

Manufacturer	Description of Dredge	Ore	Depth Meters	Throughput M ³ / Month (600 Hrs)
Bucket Ladder Dredges				
Alluvial Dredges Ltd. Blackhall Lane Paisley, PAI ITA Scotland	100-1,000 liter buckets	NS ¹	6-50	NS
IHC Holland P.O. Box 3, 3360 AA Sleidrecht Holland	300 liter bucket, 30/min, 75% full 453 liter bucket, 75% full, wave compensated	Au Sn	11 30.6	243,000 333,000
OCP Group - FW Payne & Son (UK) Ltd. 34 Southborough Rd., Bickley Bromley Kent BR1 2EB, England	100 liter up for prospecting and mining	Various	12-50	81,000-500,000
Richards Structural Steel Co., Ltd. P.O. Box 78, Phoenix Iron Works Leicester, LE4 GFY, England	Various - mobile plants	NS	NS	400-40,000
Cutter Suction Dredges				
American Marine & Machinery Co., Inc. P.O. Box 100923 Nashville, Tennessee 37210 USA	Submerged pumps (38% solids), hydraulic cutter and spuds, 86-4263 KW	NS	30+	46,800- 1,404,000
Dredge Plant (Mining), Pty. Ltd. P.O. Box 317, Palm Beach Queensland 4221, Australia	High speed cutter wheel (70 rpm) 54-463 KW, 600-1,500 mm wheel at 35% solids	Various	NS	20,700-228,000
Orenstein & Koppell "Bilberg 1"	Self-propelled cutter head 900-950 mm suction dredge pump 2250 KW, 2600 mm cutterhead	NS	25 M	760,000

<u>Manufacturer</u>	<u>Description of Dredge</u>	<u>Ore</u>	<u>Depth Meters</u>	<u>Throughput M³/ Month (600 Hrs)</u>
Cutter Suction Dredges (contd)				
Ellicott Machinery Corp. International Inc. 1600 Bush Street Baltimore, Maryland 21230 USA	Standardized cutter suction (Dragon class) 150-900 mm discharge, to 1,500 HP	Various	6-30	22,800- 1,101,000
IHC Holland P.O. Box 3, 3360 AA Sleidrecht Holland	Standardized cutter suction (Beaver class) 250-10,000 KW, hydraulic spuds	NS	NS	NS
Bucket Wheel Dredges				
Ellicott Machinery Corp. International Inc. 1600 Bush Street Baltimore, Maryland 21230 USA	Wheel Dragon class, 254-900 mm wheel 3:1 improvement over cutter for mining	Various	8-21 plus	45,600- 1,836,000
Humphreys Mineral Industries, Inc. 2219 Market Street Denver, Colorado 80205 USA	Bucket wheel feeding separate process plant 70-90% mineral recovery to 325 mesh	Ba/Sn/Au	30	NS
IHC Holland P.O. Box 3, 3360 AA Sleidrecht Holland	Beaver wheel class. 2,200 mm wheel, 18.6 rpm 400-650 mm suction 750-4,000 KW	NS	10-16	NS
Neumann Equpt (Pty) Ltd. P.O. Box 8, Currumbin Queensland 4223, Australia	Series 200-300 200-450 mm suction. 35% solids	NS	6-15	to 200,000
Orenstein & Koppell AG Karl Funke Strasse 30 D-4600, Dortmund, FRG	UWS 250, 5,000 mm wheel. 10 x 250 liter buckets 380 KW Tin dredge (planned) 8,000 mm wheel, submerged pump, 2,400 KW	NS Sn	NS 100	NS 1,350,000

Manufacturer	Description of Dredge	Ore	Depth Meters	Throughput M ³ / Month (600 Hrs)
Deep Water Dredges				
Alluvial Mining and Shaft Sinking Co.	AMROD 305 mm discharge, submerged centrifugal	Au/diam/Ti	to 300	200,000
High Pavement, Basildon Essex 5514 IEA, England	DOD series, 150 mm suction and jet. Diver operated.	NS	200-300	NS
Fuchs Systems Inc. P.O. Box 379 Salisbury, N.C. 28144, U.S.A.	Air lift	NS	15-120	160,000-180,000
OCP Group - FW Payne (UK) Ltd. 34 Southborough Rd., Bickley Bromley Kent BR1 2EB, England	Remote control underwater suction	Various	50-150	NS
Orenstein & Koppell AG Karl Funke Strasse 30 D-4600, Dortmund, FRG	Multiple head collector 30 m wide Submerged suction with vibrator and jetting	Mn nodules Red Sea muds	6,000 m 3,000 m	NS NS
Orenstein & Koppell "Draga D-9"	Split hopper suction dredger 2-700 mm suction dredge pump 1200 hp each.	NS	28 m	1,480,000

NS = Not specified

4.5 BOREHOLE MINING

During the past several years there has been a considerable amount of interest in the United States and Canada on the extraction of minerals through a borehole from deeper sedimentary deposits. Several private companies evaluated borehole mining methods for mining deep phosphate rock in North Carolina back in the 1960's, as well as other locations. The concept of mining through a borehole is obviously not novel as Frasch sulfur has been mined commercially through a borehole since the 1890's. The extraction of slurried minerals through a borehole, however, has not achieved any significant commercial success.

In 1973, the United States Bureau of Mines (USBM) took an active interest in the development of this technology as part of their program to increase the domestic availability of critical minerals. In 1976, they developed a tool specifically designed to mine coal, that was built by Flow Industries Inc. (Flow). This early work indicated that coal could be slurried in place by high pressure water and transported by use of an eductor pump. Experimental test work was also conducted in the slurry mining of California oil sands by the USBM.

Emphasis at the USBM then shifted to adapt the concept to the mining of uranium ore-bearing sandstone in Wyoming. The initial tests were conducted during 1977 in conjunction with Rocky Mountain Energy Co. (RME). The result of these tests encouraged RME to develop a prototype system with Flow which was operated over a several month period. The test results indicated that uranium bearing sandstone could be eroded with high pressure water at a standoff distance in excess of 70 feet when the nozzle was operated in an air environment. A satisfactory production rate was achieved when the operating conditions were optimized. They were able to elevate the slurried sandstone with the eductor pump from the air-filled cavity at a depth in excess of 200 feet. The energy required to elevate this slurry by this method was high. Unfortunately, at about that time, the price of uranium dropped dramatically, causing RME to discontinue their program prematurely. At about the same time this test work was being conducted, the USBM became interested in re-evaluating the technology as it could be applied to phosphates.

In 1980 a test program was conducted at a northeast Florida site using the USBM equipment developed for coal and uranium sands. The test results indicated that in that particular environment, borehole mining had to be conducted in a flooded cavity to maintain roof support. It was encouraging to determine that even when operated in a flooded condition, a surprisingly good production rate could be achieved, and that a radius approaching 20 feet was obtainable. When the system was operated with the cavity filled with water to the top of the casing, the energy required to lift the slurry created by the cutting jet action by the eductor pump was considerably less than in earlier tests.

Encouraged by these results, a joint venture research program between Agrico and International Minerals and Chemical Company was established to conduct a new test program. The actual borehole test work was conducted in late 1984.

The results of this test program were encouraging. In all cases, a consistent hole radius of approximately 20 feet was obtained. No subsidence occurred as all the cavities were developed in a flooded environment with a positive casing overflow. The production rates were adequate for the cutting jet flow rates available, and it was apparent that with increased cutting jet nozzle flow rates, and with a system specifically designed for that site, production rates could be substantially improved. In early 1985 most of the waste clay (a major environmental and disposal storage problem in the central Florida strip mines) was successfully thickened and re-injected back into the cavities created by extraction. The drilled holes (16 inches in diameter) were plugged after backfilling and the casings removed. By removing the steel casings (PVC also used and pulled) and repeatedly recycling them, the economics of borehole extraction are decidedly more attractive.

Upon the completion of the test program, an overall conceptual analysis was made to determine how the above results could be converted into a practical commercial development. A mining plan was conceived indicating that a multi-unit system with a portable centralized distribution and receiving unit was the most likely approach. Economic projections made, based on this

plan, were encouraging. These projections indicated that land based, large, previously unmineable resources had the potential of being a cost effective, environmentally acceptable, long-term phosphate rock supply.

The basis of the design would be a system having a high operating factor with a minimum mobilization time between pre-drilled boreholes. The mining concept calls for a separation of the four unit functions deemed necessary to mine phosphate rock at that site. The extraction unit's only function is to mine; the other three functions - drilling and casing, backfilling, hole plugging and casing pulling - would be conducted separately.

A land-side borehole slurry mining process would use a 12-inch to 16-inch diameter cased borehole drilled to the matrix and uncased through the ore zone. Figure 4.8 is an illustration of a conceptual arrangement for borehole mining in north Florida. Because of the depth to the base of the orebody (occasionally over 200 feet), a multi-stage turbine pump is required to lift the ore slurry back to the surface. The ore is slurried by a high pressure (275 psi) water jet making an arc of 270° to 360°. This jetting action creates a cavity approximately 50 feet in diameter at a height determined by the matrix thickness in each hole. Due to the limited size of down-hole equipment, some 20 mining units are necessary to produce 2.5 million tons per year of product. This quantity is based on a 60 percent matrix recovery with each slurry unit producing the equivalent of 50 product tons per hour in recovered ore.

Dedicated mining units produce matrix to a centralized delivery system for transport to the plant. A separate drilling and casing unit is advancing in front of each of the three groups. When a unit finishes mining, a four-hour move is required to set up the next hole in the series. Behind each group is a backfilling unit, placing a mixture of tailings and consolidated clays into the finished boreholes. The 18 to 20 percent solids clay material is dredged from a single 500-acre settling pond that could possibly be used throughout the life of the project. This type of waste disposal may create permitting problems because of the material being placed into an aquifer. But, this type of procedure using sand tailings from the mill, is presently being evaluated as an alternative means of preventing subsidence problems at the surface.

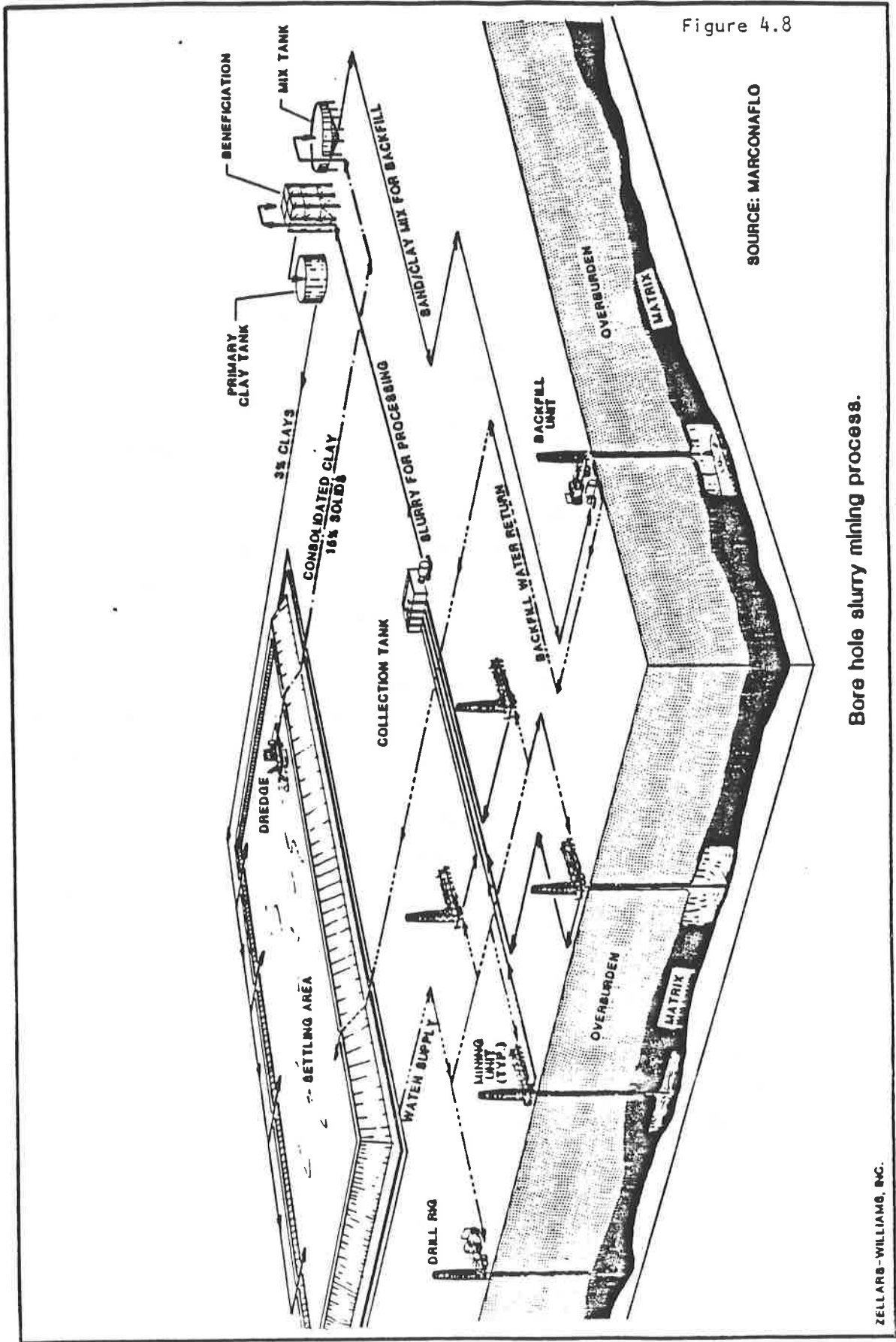


Figure 4.8

SOURCE: MARCONAFLO

Bore hole slurry mining process.

ZELLARS-WILLIAMS, INC.

A typical mining equipment scheme provides 932 tonnes per hour of matrix in a 20% solids slurry to the beneficiation plant.

Some of the positive features that a land-based borehole extraction system would offer industry are partially listed as follows:

- o Low capital cost per unit of material moved.
- o No surface disturbance. Surface can be utilized for practically any use immediately after mining.
- o Waste material resulting from mining and mineral processing can be disposed of back into the mined-out cavity.
- o Small, erratic, or highly faulted deposits can be selectively mined with a minimum of surface infrastructure required.
- o Development drilling necessary to delineate an orebody to justify open pit mining could be reduced when borehole mining is considered. The definition of "proven ore" would take on a different meaning.
- o Only the material that needs to be moved for subsequent processing has to be handled.
- o The system would be very adaptable for automated operation.
- o The concept appears to be environmentally acceptable. It allows potential development of valuable commodities that could not be mined by conventional methods.
- o Borehole extraction could have many other uses besides mining. Any time it would be desirable to create an artificial cavity within a favorable horizon for waste disposal, storage of recoverable material, well field regeneration, etc., through a restricted orifice, this concept should be considered.

The Georgia offshore area of interest between the 3-mile territorial sea line, and the 50-meter contour, indicates some phosphorite occurrence at depths which might fit the borehole mining concept. These areas appear to occur as pockets of what might be phosphate-rich, deep Middle Miocene. Little or nothing is known or available at this time to warrant consideration of borehole mining to Georgia offshore phosphates. The discussion above is given only to acquaint the reader with the general state-of-the-art as it may

apply to phosphate mining. Development Planning and Research Associates, Inc., (DPRA) 1987, in their offshore North Carolina phosphate feasibility report, describe a conceptual system for borehole mining a phosphate resource. The 20-meter thick phosphate zone proposed for borehole mining is in 30 meters of water, under 50 meters of overburden, and is centered on an exploratory borehole about 60 kilometers east of Cape Fear. This kind of investigation and work is beyond the scope of this study.

4.6 APPLICABILITY OF EXISTING TECHNOLOGY

For a continuous mining operation offshore Georgia, only two types of dredges are feasible - the trailing or anchored suction head dredge, and the cutter head dredge. These dredges can be built on ocean-going vessels with large receiving hoppers and washing plants to reduce the volume of material transported. These dredges can also be integrated into transportation systems utilizing slurry pipelines, barges, or a self-contained load/unload hopper-dredge.

The principal problem with the cutter wheel and bucket line dredges is that being digging dredges they require heavy mechanical equipment and supporting steel structures, resulting in a high bottom contact pressure by design. However, being digging dredges by design, they will dig in response to hull movements making it difficult to maintain permanent contact with the dredging face. Oceanic conditions such as waves, swell currents, and wind causes the dredge hull to surge, heave, pitch, roll, sway and yaw in relation to the ocean bottom. This movement prevents contact with ocean bottom and stresses mechanical and structural components.

Solutions to this problem have been advanced, one of which is to build a semi-submersible hull configuration instead of a surface pontoon. Analysis of response curves for waves striking the hull at 135° (considered the most severe angle) indicates a vast improvement in pitch and heave with the semi-submersible hull design. Solutions to this problem appear to be within the state-of-the-art technology and one dredge operating in moderate oceanic conditions has been built to mine tin in Thailand using a large cutter head dredge. A spud is used to keep the dredge on station balance by shock

absorbers which were built into the ladder suspension and swing wires. While not really flexible, this mechanical innovation prevents undue shock loading of critical mechanical components. Further testing and investigation would be necessary to apply this technology to offshore Georgia coastal conditions. Currently, work is being done to create a truly flexible dredge by using a rigid bucket ladder with the supporting pivot shaft connected to the pontoon by link bars and hydro-pneumatic cylinders. Movement in relation to the pontoons is permitted by the pivot shift. In addition, the support bracket is supported by a buffer cylinder which permits the bow to move vertically and keeps the digging force on the bottom by adjusting the pressure on the cylinders.

The trailing suction head dredge, equipped with a draghead, has a low bottom contact pressure and does not sink into the bottom, but maintains contact with the bottom despite dredge hull movements. Because of low weight, the trailing suction head dredge can be equipped with a universal hinge, a horizontal hinge, sliding and turning glands and swell compensation buffer gear. This keeps the draghead on the bottom at constant pressure while the bow moves up and down.

The principal disadvantage of the seagoing trailing suction head dredge is that excavation of material at sea bottom generally occurs while the host vessel is travelling at 1-3 knots. The suction head is dragged along the bottom and the depth of cut depends on the effective contact weight and the consolidation of the material. The suction drag head can not remove (cut) more than a few feet with each pass. The width of the cut is limited by the size of the drag head and the angle of repose of the material being excavated. A single pass may make a cut 1 to 2 meters deep and 5 to 8 meters wide in free-flowing sands and gravels. Many passes are required to mine any significant depth.

The seagoing trailing suction drag head dredge is most effective when operated from a vessel which contains compartments for storing dredged material. Dredged material is deposited directly in the on-board integral hopper either directly or after mechanical sizing to reject oversize material. The dredge hopper vessel, with or without on-board processing, is designed to

remain at sea long enough to fill its hoppers. The vessel, when loaded to capacity, returns from the mine site to a designated land-side dump where the hopper is unloaded. Some vessels are designed to bottom dump hopper contents, while others transfer material from the hopper by self-contained slurry pumps, Marcona-flow, or by other conventional methods.

One version of the seagoing suction drag head dredge is the anchor dredger. The seagoing vessel is similarly equipped with a suction head and hopper. This dredge works at anchor and does not move while dredging, other than periodically to winch itself forward as required to keep the flow of material feeding into the suction pipe head. This type of dredge has the advantage that it can work in a deep deposit and covers very little area of the sea bed. The disadvantage is that the sea bottom is left with a series of holes.

The seagoing suction dredge, whether of the anchor type or trailing suction type, is suitable for mining loosely compacted surficial sands containing heavy minerals which do not require removal of overburden.

A system which can operate safely in the offshore Atlantic Ocean coastal water environment is the first requirement which must be met by any equipment assemblage. For the mining of phosphorite, an equally important requirement is that the system be capable of engaging the total horizon of material to be excavated and to do so with an acceptable level of recovery. In other words, overburden and matrix each should be excavated in a single pass, while leaving a minimum of ore having value behind and/or diluting at a minimum the desired ore with barren material. Additional characteristics of the system must be: high level of reliability, and ease of maintenance and component replacement; ability to partially upgrade ore onboard; ability to efficiently transfer or transport upgraded ore to a nearby moored vessel or barge, or to a centrally located offshore beneficiation plant; capable of quickly suspending operation, riding out sudden storms, and quickly resuming work.

The selected systems for mining offshore Georgia phosphorites and heavy minerals are described in Sections 5 and 6, respectively, of this report.

SECTION 5

PHOSPHATE DEVELOPMENT FEASIBILITY

5.1 INTRODUCTION

This section deals with the work leading to the selection of a preferred configuration for mine, beneficiation, and related infrastructure components required for the commercial exploitation of Middle Miocene phosphorite occurrences offshore the coast of Georgia in the Atlantic Ocean. The reader is taken through a description of the proposed mining area and a comparison of production-configuration schemes. This comparison is based on information and data developed and published in previous studies. Much of this comparative work relies on reports of the Bureau of Mines and Minerals Management Service of the U.S. Department of Interior, Zellars-Williams Company, and Development Planning and Research Associates, Inc.

The configuration selected as a result of the comparative study is that of hybrid dredges mining to an offshore beneficiation facility from which finished product is shipped.

Each component is fully described and capital and operating costs estimated. Economics and viability are based on current phosphate rock sales prices and on supply-demand projections, which indicate the year 2000 as the time-frame in which realization of this enterprise may become viable.

Dredge design and excavating-pumping rate expectations, which underly the premises of the proposed annual production of 4.8 million tonnes of phosphate rock, assume that coquina or similar cemented conglomerates do not occur in the overburden or ore zone horizons scheduled for mining. A phosphate mining enterprise at Santo Domingo on the west coast of Baja Sur California, Mexico, failed to enter production after expenditures of about 60 million dollars because the overburden and ore zones were improperly characterized as uniform beach sands. This soils classification came about as a result of drilling and sampling techniques which failed to characterize in-situ coquina.

The coquina turned out to be impenetrable by the dredges designed and built for this project. Coquina lenses reportedly occur frequently enough to create problems for Texasgulf in mining the marine deposits at their Lee Creek, N.C. mine.

This experience adds emphasis to the importance of a properly designed and executed exploration program for offshore minerals.

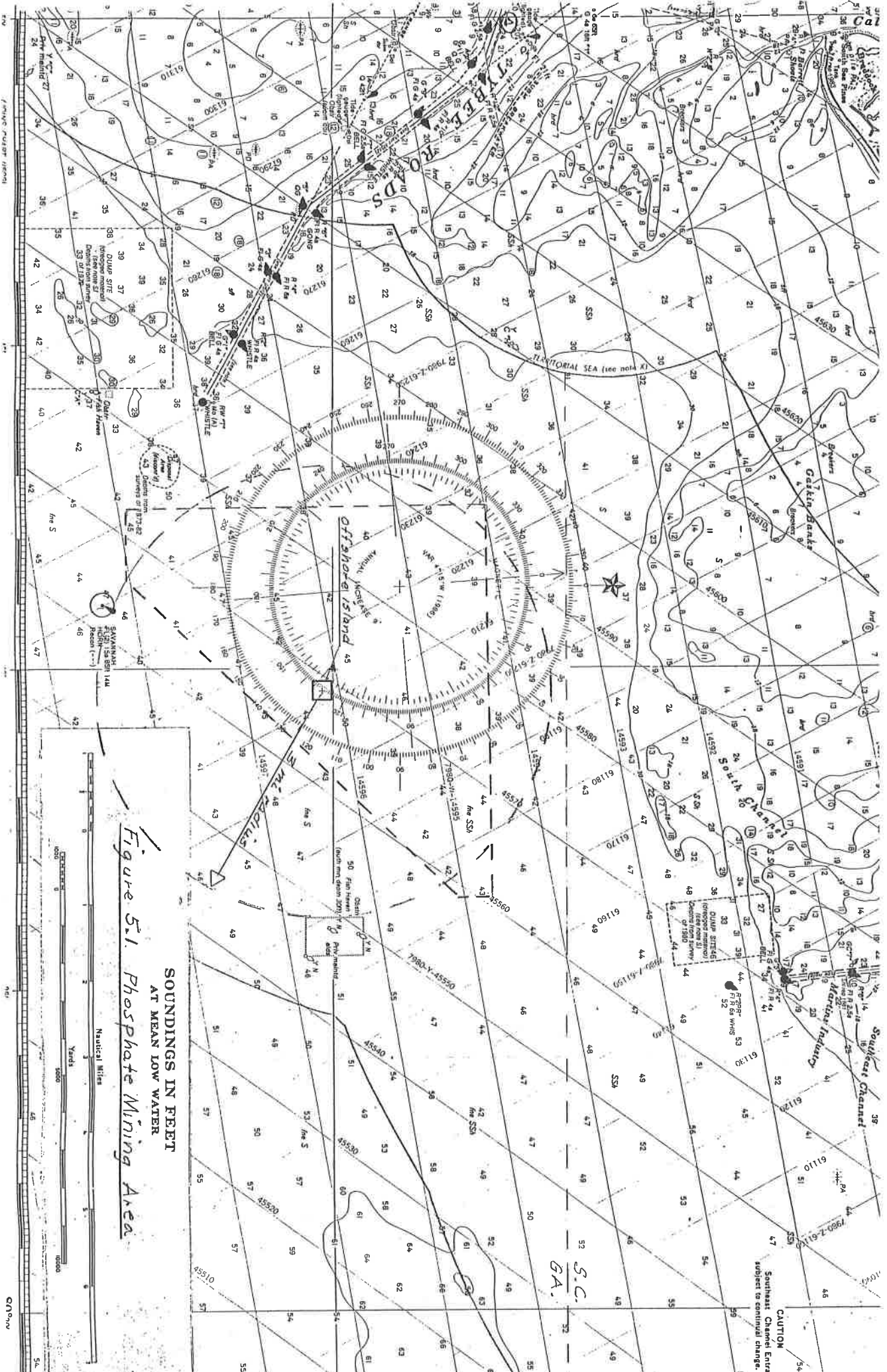
5.2 MINING

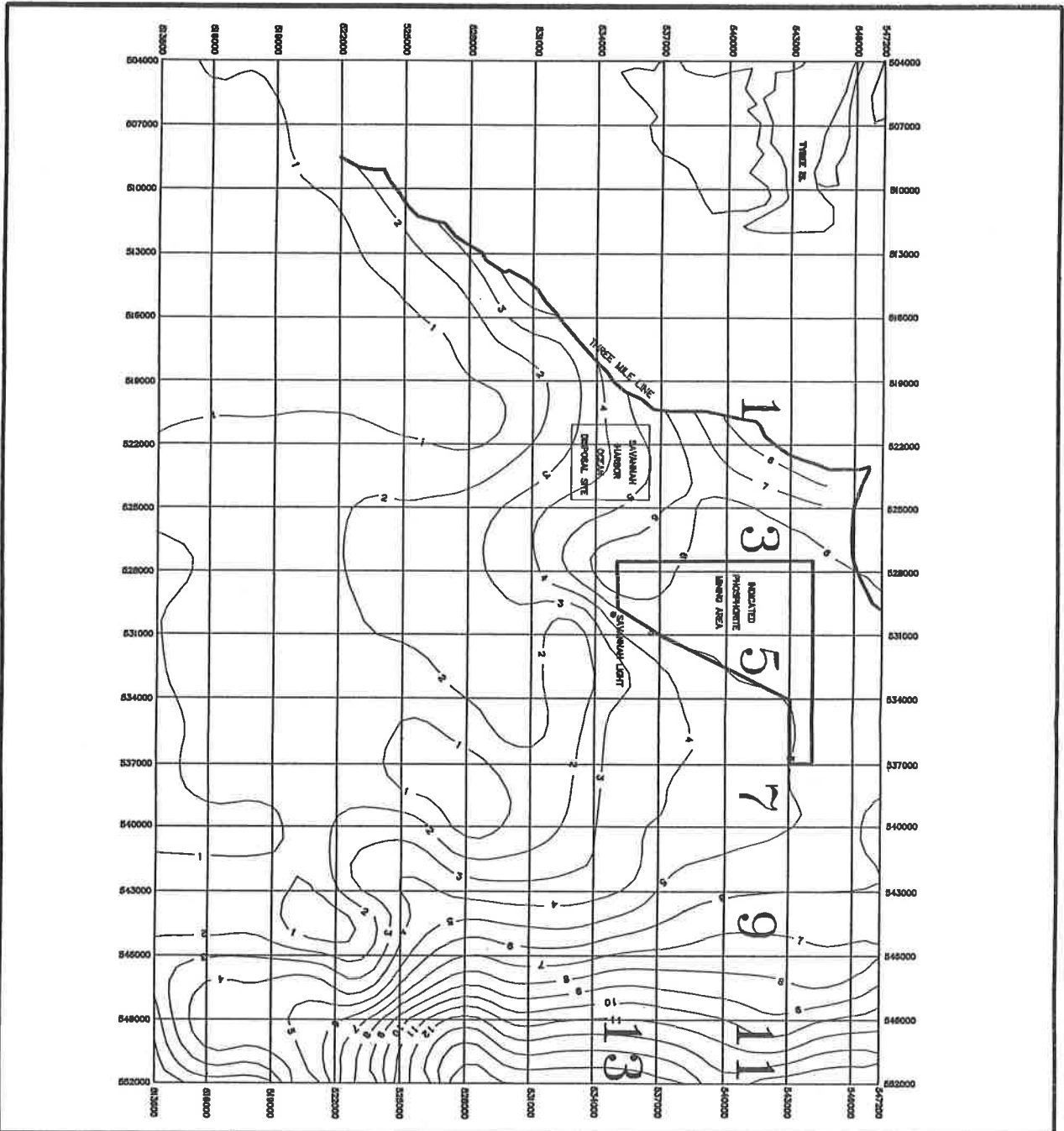
5.2.1 Selection of Mining Area

Figure 5.1 shows the area under consideration for phosphate mining. This location contains the thinnest overburden and shallowest phosphate in the study area. Due to the seaward slope of the Miocene sediments, as well as increasing water depths, areas seaward of the model area are increasingly difficult to mine by surface techniques. A more complete review of the model area and geology is given in Section 3.

The area modeled ranges from 6 to 25 nautical miles from shore. Figure 5.2 is a geologic map of this area containing about 180 3-kilometer square blocks. Twenty years of mining to yield 3-5 million tonnes of product per year covers a small fraction of the total blocks identifying Middle Miocene phosphorites. The number of blocks required depends upon the matrix thickness, which is taken as the Middle Miocene thickness. Since matrix thickness, overburden thickness, and depth of water are not constant in the model area, a methodology was developed to select the most favorable economic mining site.

Each block has an overburden thickness, a matrix thickness, and a water depth. The relative proportion of these determines dredge operating and capital costs. By examination of these data, 13 blocks were selected for economic evaluation. Table 5-1 lists the boundary limits of each selected block. These blocks were analyzed for dredge capital costs, and dredge operating costs. Zellars-Williams computerized dredge model was used to calculate production rates and costs. All plant costs are assumed to be location independent. An incremental waste disposal charge was added to the





GRAPHIC SCALES



GEORGIA OFFSHORE
MINERALS ASSESSMENT

INDICATED PHOSPHORITE MINING AREA
W/MIDDLE MIOCENE THICKNESS

CONTOUR INTERVAL 1 m

ZW

FIGURE NO. 5.2

capital and operating costs, when the mining depth exceeded 27 meters. The sum of dredge operating cost, dredge capital cost, and incremental waste disposal cost, expressed in dollars per tonne of product, was added to give the total cost. Results are summarized in Table 5-2 for each block.

Table 5-1

Block Coordinates

<u>Blocks</u>	<u>Northing</u>	<u>Southing</u>	<u>Easting</u>	<u>Westing</u>
1	543,000	540,000	522,000	519,000
2	543,000	540,000	525,000	522,000
3	543,000	540,000	528,000	525,000
4	543,000	540,000	531,000	528,000
5	543,000	540,000	534,000	531,000
6	543,000	540,000	537,000	534,000
7	543,000	540,000	540,000	537,000
8	543,000	540,000	543,000	540,000
9	543,000	540,000	546,000	543,000
10	543,000	540,000	549,000	546,000
11	543,000	540,000	552,000	549,000
12	540,000	537,000	552,000	549,000
13	537,000	534,000	552,000	549,000

Table 5-2

Mining Area Dredge Operating Costs

Block #	Depth		Strip Ratio	Total Mine Depth m	Dredge Cost \$/t Matrix	Increm. Waste Cost \$/t Matrix	Total Cost \$/t Matrix
	Ore m	Ovbd. m					
1	9.0	15.5	1.72	32.2	\$2.06	\$.06	\$2.12
2	7.2	12.0	1.67	30.0	1.88	.04	1.92
3	5.9	11.3	1.92	27.3	1.88	.04	1.92
4	5.6	8.5	1.52	26.3	1.66	.00	1.66
5	5.2	8.0	1.54	27.7	1.68	.01	1.69
6	4.6	7.5	1.63	28.3	1.93	.02	1.95
7	4.7	8.2	1.74	29.6	2.01	.03	2.04
8	5.3	8.7	1.64	32.0	2.18	.06	2.24
9	6.3	9.7	1.54	35.0	2.10	.09	2.19
10	8.1	11.3	1.40	39.0	2.14	.13	2.27
11	11.0	12.2	1.11	43.0	1.94	.17	2.11
12	12.0	12.0	1.00	43.5	1.84	.17	2.01
13	12.2	12.0	.98	44.2	1.83	.18	2.01

Note: Total mine depth includes water depth from MSL to sea floor (top of overburden) at each location.

Using the lowest total cost/tonne of matrix (ore) as the selection criteria, Blocks 4 and 5 were chosen as the core of the initial mining site. The size of the site was matched to an area required to support a 3.5 million tonne (product, dry) per year operation for twenty years. This area contains the shallowest Middle Miocene location, as well as the thinnest overburden in the entire model area.

The initial area is approximately triangular in shape, with the hypotenuse being the 5 meter Middle Miocene thickness contour on the southeastern side. The southwestern and northeastern corners are described as:

	<u>AMS Coordinates</u>		<u>Lat. and Long.</u>
	<u>East</u>	<u>North</u>	
SW	527500	535000	80°42'32.45", 31°57'8.34"
NE	537000	544000	80°36'29.34", 32°01'59.68"

The site contains parts of the following OCS blocks:

NI 17-11 - 951, 952, 953, 995, 996, and 997

NH 17-2 - 27 and 28

The site is characterized by the following in-situ parameters:

<u>Item</u>	<u>Meters</u>			<u>Meters³</u>
	<u>Average</u>	<u>Min.</u>	<u>Max.</u>	<u>Volume</u>
Water Depth	13.97	11.4	16.4	--
Overburden	8.02	7.1	9.9	366,746,720
Matrix	5.44	5.0	7.0	249,040,020
Stripping Ratio (m:m)	1.47	1.42	1.41	
Total Mining Depth	27.43	26.4	28.8	

All overburden material is sand material with no cementing. There is no Pliocene or Upper Miocene material present within the confines of the site.

Using the "Design Basis Data" from Table 10, page 54, of the 1979 ZW report, a target production rate of 3.5 million tonnes for 20 years, and the summarized site data listed below, an annualized production summary was prepared.

Summarized Site Data

Total Matrix Volume (meters ³)	249,040,020
Matrix "X" m ³ ore to produce 1 ton product	3.37
Percent Clay Waste	21.29
Total Product Tonnes (dry)	73,899,000
Total Area (meters ²)	45,741,096
(acres)	11,303

The initial mining area described above includes parts of eight blocks having the most favorable mining characteristics and is the area targeted for earliest exploitation. The total mineable area, however includes at least eight additional blocks to permit increasing mine life and/or annual yield. Experience in early years will result in improved technology, increase the mineable area, and permit exploitation of as much as 500,000,000 m³ of phosphorite matrix in the Middle Miocene. The product yield over the life of a single enterprise would be as much as 150,000,000 tonnes.

5.2.2 Configuration and Production Rate Comparison

The annual production of any mineral beneficiation facility is dependent upon the ability of the mine to supply ore. Normally, plant production is based on operational efficiency which is largely independent of mining because of the ease of providing large stockpiles of plant feed. Most phosphate rock production is based on a link between the mining dragline - ore transportation system and the plant washer. High operating factors are typical and ore storage is not a requirement. Operating factors for most ocean mining equipment, however, are low by comparison. Climatic and other conditions beyond the control of the operator are the major contributors to the reduced operating factor.

Production based on mining of ore at sea for beneficiation at a remotely located land-based facility is greatly dependent on the effective operating factors of the excavating and transporting equipment and systems employed.

As a basis for uniform comparison of alternative configuration schemes certain criteria were established. The criteria adopted for comparative evaluation given in Table 5-3 are based on previous work and on reported experience with ocean-going dredges and transportation systems. These criteria were later modified to better fit the preferred mining equipment and systems configuration.

Table 5-3
Criteria Basis for Configuration Comparison

Annual Mining Equipment Availability

Days lost:	
annual dry dock/repairs	30
adverse weather/sea conditions	36
	66
Days operational	299
Hours/day operational	21
Mechanical availability	90%
Effective operating hours (299 x 21 x .90)	5,651

<u>Item Description</u>	<u>Unit</u>	<u>Value</u>
Average overburden thickness	meters	8.02
Average matrix (ore) thick.	meters	5.44
Matrix "X"	m ³ ore/1 tonne product	3.37
Matrix & overburden density	tonnes/m ³	1.36
	lb/ft ³	85
Mining recovery	percent	85
Stripping ratio	m ³ ; overburden/m ³ matrix	1.73
Suction head pipe or dredge pump discharge diameter	mm	900
inches	36	
Pipeline velocity	m/sec	4.92
	ft/sec	15.0
Dredge production dry solids	m ³ /yr	12,118,000
	tonnes/hr	2,196
Average slurry solids	percent	26
Washer rejects	percent	20
Distance to land-based beneficiation plant	nautical miles	27
Average vessel speed	knots	12

Typically, offshore dredges are ocean-going vessels equipped for mining and contain hoppers for collecting dredged material. Since these vessels also serve as transports, their availability for mining is limited. Investment is high and utilization for mining is low. This appears to be the norm as is experienced by operators who use these types of foreign-built dredges in the North Atlantic, Pacific Ocean and Sea of Japan. These systems are most effective where: there is little or no overburden; where the ratio of ore to product is low; and where concentration takes place on board. This is not the case for phosphate.

However, because sea-going suction head hopper type dredges have a long and successful history of operating under ocean conditions, they are considered here in evaluating alternative configuration schemes.

The four major project configuration schemes considered for offshore phosphorite production are:

1. Sea-going hopper dredge for mining and transportation to an onshore plant.
2. Sea-going hopper dredge mining and barge transportation of ore to an onshore plant.
3. Dredge mining and pipeline transportation of ore to onshore plant.
4. Dredge mining and pipeline transportation of ore to nearby offshore island plant.

The mining dredge vessel or platform in each of the four major configurations is equipped with an onboard processing (washing) plant. Flowsheet data indicate that about 20% of the dredged material can be eliminated by washing. This reject material, a mixture of oversize and slimes, would be disposed of in nearby mined-out areas. In Configurations 1, 2, and 3, matrix is transported, after washing, to a land-based plant for further processing. The dredge vessel size is determined by the necessity of making the vessel seaworthy, not by the dredging equipment. In Configuration 1, a large hopper is required for storage as the dredge is also the vessel used to transport ore, after washing, to shore.

Since dredge vessel size is larger than required for the dredging equipment alone, the addition of a washing plant costs only slightly more than if located onshore. Plant operating costs are identical. However, with onboard processing, material transported to shore decreases by 20%, resulting in a corresponding reduction in transportation costs of 20%. In addition, waste disposal of the 20% fraction rejected by washing at an onshore plant must be either re-transported from the plant and disposed of in the mined-out areas, or disposed of in tailing impoundments onshore. Either way, the offshore washing plant reduces costs considerably by wasting the 20% fraction rejected in nearby mine areas.

For Configuration 4, costs are expected to be about equal, with or without onboard processing. This is because the processing plant is located near the mine area. Therefore, for Case 4, either onboard or offboard washing can apply.

1. Sea-going hopper dredge for mining and transportation to an onshore plant.

Figure 5.3 shows this configuration. An anchor suction dredge removes overburden, pumping it to mined-out areas. One anchor suction dredge is dedicated to overburden removal. A second matrix dredge follows at least 2,000 feet behind the overburden dredge. The anchored suction head dredge slurries and pumps the ore to a distribution box, and then the ore is screened, washed and deslimed. About 80 percent of the material is loaded into a hopper on board the vessel. Here, through a series of weirs, the washed matrix is dewatered to 75% solids. When the hopper is full, the suction head and pipes are raised from the bottom to the deck. The dredge now functions as a normal merchant ship and carries the material 27 nautical miles to the plant site. The plant site was selected in an industrial area where permitting problems and land acquisition problems are minimized. It was felt that an onshore plant located closer to the mining operation on the barrier islands would be environmentally unacceptable.

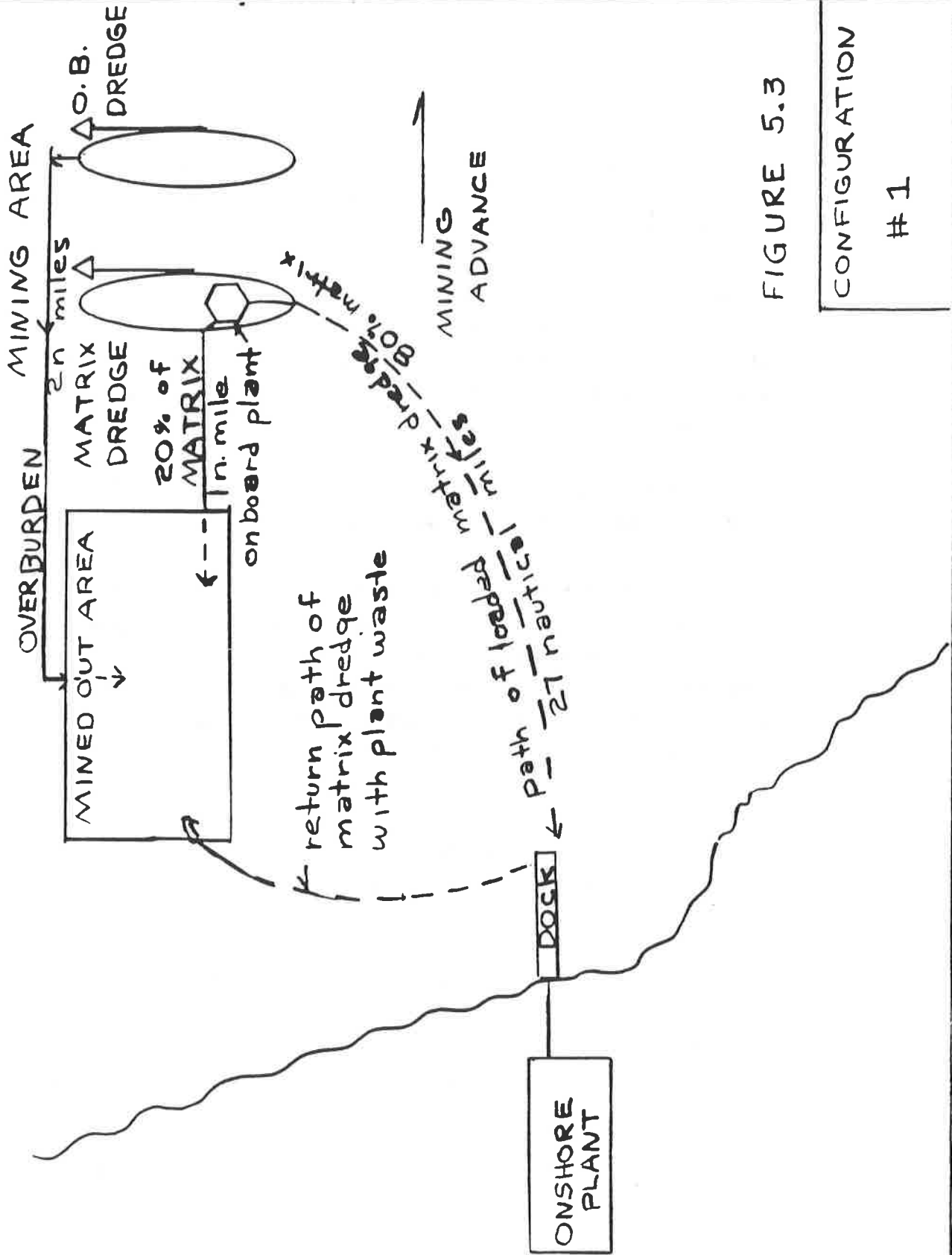


FIGURE 5.3

CONFIGURATION

1

Costs for hopper dredges were taken from the open file report "An Economic Reconnaissance of Selected Heavy Mineral Placer Deposits in the U.S. Exclusive Economic Zone" by the Bureau of Mines Washington Staff, released 4-87.

For a hopper dredge, cycle times consist of loading, travel, unloading and return travel. The hopper size increases capacity, but also increases capital. In an attempt to optimize hopper size, four loading capacities were analyzed. Table 5-3 shows the design criteria used to determine productivity and costs.

Loading and unloading is done by a 900 mm pump using the criteria in Table 5-3 at the rate of 2,916 tonnes per hour.

Table 5-4 shows the time required for each element in the cycle. The cycles per year are based upon 5,651 hours. The tonnes per cycle are based upon the loading time, which is different for each case. Table 5-4 also lists the tonnes per year of product produced for each capacity. As Table 5-4 shows, increases in loading times (hopper capacity) result in only a slight increase in tonnes per year of product.

Table 5-4
Cycle Time Configuration 1

<u>Item</u>	<u>Hours</u>	<u>Hours</u>	<u>Hours</u>	<u>Hours</u>
Load Ore	5.00	10.00	15.00	20.00
Travel to Plant	2.25	2.25	2.25	2.25
Unload Ore	5.00	10.00	15.00	20.00
Load Tails	5.00	10.00	15.00	20.00
Travel to Mine	2.25	2.25	2.25	2.25
Dump Tails	<u>5.00</u>	<u>10.00</u>	<u>15.00</u>	<u>20.00</u>
Total Cycle Time	<u><u>24.50</u></u>	<u><u>44.50</u></u>	<u><u>64.50</u></u>	<u><u>84.50</u></u>

Table 5-4 (continued)

Cycles per year	230.65	127	87.6	66.88
Tonnes per cycle	11,666	23,300	35,000	46,600
Tonnes hauled	2,690,691	2,962,400	3,066,000	3,120,000
Tonnes prod. produced	734,000	808,000	836,000	851,000

The following USBM equations from Open File Report 4-87 were used:

$$(P) \text{ Hopper Capacity} = \frac{\text{Daily Haul Capacity (DHC)}}{2.9607(L)^{.2923}}$$

Where

DHC = short tonnes hauled divided by operating days

L = one way haul distance in nautical miles

Operating Days = 299

Short tonnes hauled will be determined

$$\text{Dredge capital cost} = 7,052 (P)^{.9421}$$

Plant capital costs are based upon \$20,000,000 for an onshore plant, \$4,000,000 for an onboard plant and \$15,000,000 for dock construction. Infrastructure is estimated at 30% of the total of these costs. These costs are based on a phosphate plant yielding 4,000,000 tonnes of product per year. To allow for other product rates, an exponent of .7 was used. The general formula is:

$$\text{Capital Cost A} = (\text{Production/yr A} + 4,000,000)^{.7} * B$$

where A = production/year from Table 5-6

B = base cost (\$20,000,000, \$4,000,000, \$28,000,000) for the 4,000,000 tpy case

Table 5-5 is a summary of calculated hopper sizes and the resulting capital required for each production rate from Table 5-4. The overburden dredge does not require a large hopper and its cost is estimated from other sources. Dollars per ton capital is based on 20 years of mine production for each production scenario.

Table 5-5
Capital Costs Configuration 1

Product X 1,000 Tonnes	Annual 20 Yrs.	Hopper ST	Millions of Dollars							\$/M Ton
			Mat. Dredge	Ob. Dredge	Ob. Plant	Dock	OS Plant	Misc	Tot	
734	14,680	8,780	36.60	40.00	1.22	4.58	6.10	26.55	115.05	7.84
808	16,160	9,668	40.08	40.00	1.31	4.90	6.53	27.84	120.65	7.47
836	16,720	10,005	41.39	40.00	1.34	5.02	6.69	28.33	122.77	7.34
851	17,020	10,183	42.08	40.00	1.35	5.08	6.77	28.59	123.87	7.28

Table 5-7 combines the capital cost per tonne with the operating cost per tonne, to provide a basis for cost comparison.

Operating costs for the suction head hopper type matrix mining dredge are based on the following U.S.B.O.M. formula (from Open File Report 4-87).

$$\text{Dredge operating cost (\$/s.t.)} = \frac{2.7534 (P) + 5,453}{\text{Daily Dredge Capacity}}$$

where P = payload or hopper capacity in short tons

daily dredge capacity = annual capacity in short tons ÷ days.

Operating costs for the overburden dredge and for processing are based on Zellars-Williams operating cost model. Table 5-6 lists a summary of operating costs for the different production rates.

Table 5-6
Operating Cost - Configuration 1
Operating Cost \$/Metric Ton Product

Tonnes Matrix*	Mat. Dred.	O.B. Dred.	Plant	Waste Disp.	Prod. Hand.	Admin.	Total
3,363,000	10.65	3.91	5.71	0.40	.45	1.30	22.42
3,703,000	10.45	3.91	5.71	0.40	.45	1.30	22.22
3,832,000	10.38	3.91	5.71	0.40	.45	1.30	22.15
3,900,000	10.35	3.91	5.71	0.40	.45	1.30	22.12

* 4.6 tonnes matrix mined results in one tonne of product.

Table 5-7
Total Comparative Cost per Tonne, Configuration 1

<u>Tonnes Matrix</u>	<u>Capital</u>	<u>Operation</u>	<u>Total</u>
3,363,000	\$ 7.84	\$22.42	\$30.26
3,703,000	7.47	22.22	29.69
3,832,000	7.34	22.15	29.49
3,900,000	7.28	22.12	29.40

2. Sea-going Hopper Dredge Mining, Barge Transportation of Ore to an Onshore Plant

Figure 5.4 shows this configuration. An anchor suction dredge removes overburden, pumping it to mined-out areas. One anchor suction dredge is dedicated to waste and the other is used mostly for matrix. Since no large hoppers are required, as in Configuration 1, both dredges can be identical in design. To maximize production, the matrix dredge is required to operate in overburden some of the time. Table 5-3, shows the design criteria used for production and operating cost calculations.

The stripping ratio expressed in terms of cubic meters waste to cubic meters matrix is defined by the following equation:

$$\begin{aligned} \text{Stripping Ratio} &= \frac{\text{Overburden Thickness}}{\text{matrix thickness} \times \% \text{ recovery}} \\ &= \frac{8.02}{5.44 \times .85} = 1.73 \end{aligned}$$

For each cubic meter of matrix mined, 1.73 cubic meters of waste needs to be removed. The total production from the overburden and matrix dredge is:

$$2 \times 12,118,000 \text{ m}^3/\text{yr} = 24,236,000 \text{ m}^3$$

This approach assumes that 15% of the ore zone is not recovered, as compared to the alternative approach of adding this volume to the overburden.

This is the total annual production from both dredges. Taking in account the required stripping ratio, the annual ore production is:

$$24,236,000 \div (1+1.73) = 8,877,000 \text{ m}^3/\text{yr}$$

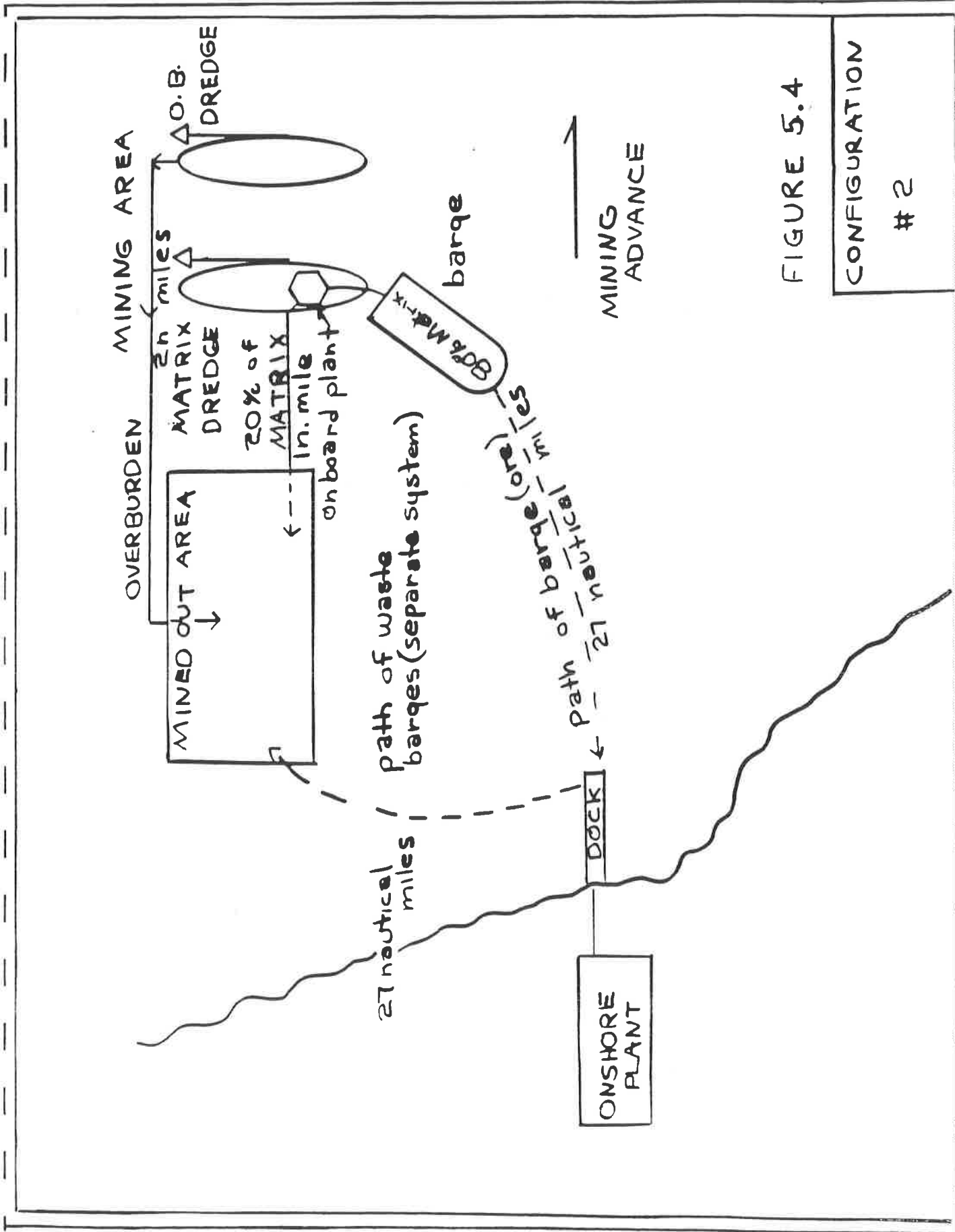


FIGURE 5.4

CONFIGURATION

2

Annual matrix tonnage is:

$$8,877,000\text{m}^3 (1.36 \text{ t/m}^3) = 12,074,000 \text{ tonnes}$$

Annual product tonnage is:

$$8,877,000\text{m}^3 + (3.37 \text{ t/m}^3) = 2,634,000 \text{ tonnes}$$

From these calculations, it is apparent that the matrix dredge must operate in overburden part of the time in order to maximize production.

The matrix dredge pumps matrix into a distribution box from which it is screened, washed, and deslimed. About 20% of the matrix is removed by onboard washing and disposed of in mined-out areas. The remaining 80% of the matrix is dewatered to 75% solids aboard 26,000 tonne barges. These barges are towed to the on shore beneficiation plant by tug boats. After matrix is unloaded by pumping it from the barge into live storage containment, the barge is towed back to the overburden dredge and another cycle begins. In order to avoid a large tailings area, an independent fleet of barges and tugs load, transport, and dump the plant tailings in the mined-out areas. By providing storage at the plant and a separate waste disposal system, the plant operation is not directly tied to the mine.

Table 5-8 shows the time required for each element in the cycle. The cycles per year are based upon 4,140 hours (the hours dredging in matrix). The tonnes per cycle are based upon the cycle time. Criteria from Configuration 1 apply here with the exception that barges move at 8 knots.

Table 5-8
Cycle Time Configuration 2

<u>Item</u>	<u>Hours</u>
Load barge	8.36
Barge to plant	3.38
Unload barge	8.36
Barge return	3.38
Total cycle time	<u>23.48</u>
Cycles per year	176.3
Tonnes per cycle	19,500
Tonnes hauled per year	3,439,000

Since the dredge mines 12,074,000 tonnes of matrix annually, the number of dredges required is:

$$12,074,000 (.8) \div 3,439,000 = 2.81 \text{ or } 3$$

The waste cycle is assumed to be similar to the matrix cycle. Although the waste from the onshore plant is only 7,029,000 tonnes (as shown below), the loading-dumping times and percent solids are expected to compensate for these differences.

$$\text{washed matrix} - \text{product} = \text{waste}$$

$$12,074,000 (.8) - 2,630,000 = 7,029,000$$

In all, a total of seven barges and tugs are required, three for matrix handling, three for waste disposal, and one for a spare. Dredge, barge, and tug capital costs are estimated from updating previous studies. Plant capital costs are based on \$20,000,000 for an on-shore plant, \$4,000,000 for an onboard plant, and \$28,000,000 for infrastructure and \$15,000,000 for dock. These costs are based on a phosphate plant yielding 4,000,000 tonnes of product per year. To adjust cost for other production rates, an exponent of .7 was used. The general formula to estimate capital cost for 2,634,000 tonnes per year production is:

$$\text{Capital Cost} = (2,634,000 \div 4,000,000)^{.7} * B$$

where B = the base cost of capital items.

Table 5-9 itemizes the capital required for comparison of Configuration 2.

Table 5-9
Capital Cost Configuration 2

<u>Item</u>	<u>mm \$ Unit Cost</u>	<u>No.</u>	<u>Total Cost</u>
Barges	16.2	7	\$113,400,000
Tugs	5.5	7	38,500,000
Matrix dredge	40.00	1	40,000,000
Overburden Dredge	40.00	1	40,000,000
Beneficiation Plant	14.93	1	14,930,000
Onboard Plant	2.99	1	2,990,000
Infrastructure & Misc.	20.90		20,900,000
Vessel Berths, loading dock	11.20		11,200,000
Total			\$281,900,000
\$ per tonne annual production			107.03
\$ per tonne mine life (20 years)			5.35

Operating costs are computed using Zellars-Williams operating cost model. Table 5-10 summarizes the operating costs.

Table 5-10
Operating Costs Configuration 2

	<u>Cost per tonne product</u>
Mining	6.64
Plant	4.94
Waste/Water	.25
Product Handling	.45
Administration	<u>1.30</u>
Total	\$13.58

The total comparative cost for Configuration 2 is \$18.93 per tonne product.

3. Dredge mining, pipeline transportation of ore to onshore plant

Because the location of the plant is upstream of the river, a pipeline system is not feasible. A substantial part of the pipeline would lie across shipping channels and industrial installations. For this reason, as well as environmental considerations, the pipeline system was not considered in further detail for this report. This is the same conclusion reached by other investigators, i.e., Zellars-Williams 1979, and Development Planning and Research Associates, Inc., 1987 North Carolina Offshore. Figure 5.5 illustrates the configuration.

4. Dredge mining, pipeline transportation to offshore plant

Figure 5.6 shows this configuration. An overburden dredge mines overburden sands ahead of the matrix dredge. Overburden is pumped back to the nearby mined-out areas. Trailing about 2,000 feet behind, in the same cut, the matrix dredge mines and pumps directly to a nearby offshore plant. This plant is built on an island formed by dredged material, located equi-distant an average of two nautical miles from the mining areas. The pipeline is flexible and most of it is submerged. Only the flexible portion near the dredge is floating. At the beneficiation plant, matrix is processed, and a saleable product produced. Waste is pumped through a separate pipeline to mined-out areas and released. All processing is done at the island-based processing plant. Product from the beneficiation plant is barged to shore for sale. The dredge production is identical to Configuration 2.

Barges are only needed to transport the product to Savannah Harbor. The cycle time is based on the same criteria as for Configuration 1.

Loading time is:

barge capacity ÷ loading rate = hours

Tonnes (26,000 × .75) ÷ (2916) t/hr = 6.69 hours

Travel time is:

distance ÷ speed = hours

27 (nautical miles) ÷ 12 knots = 2.25

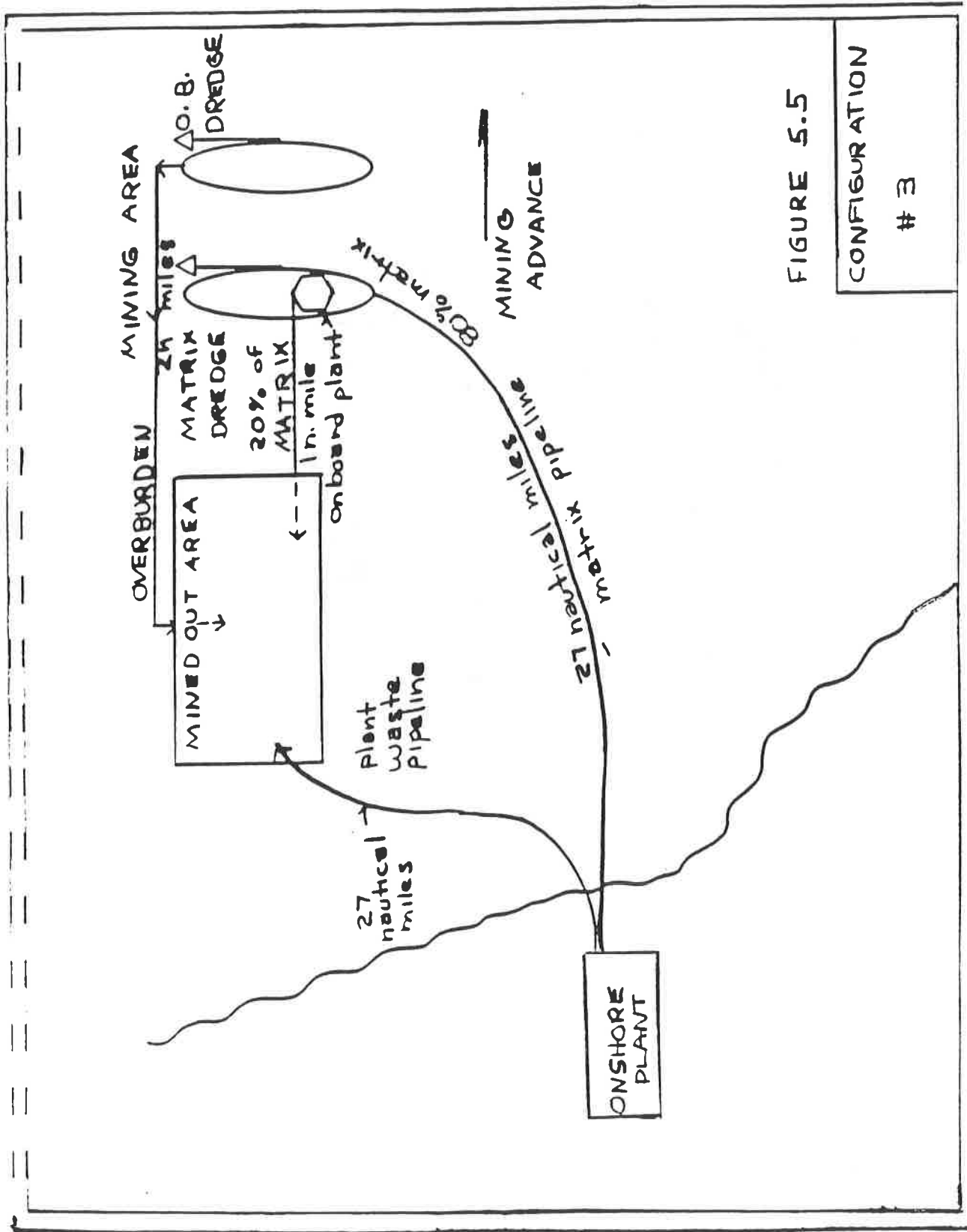


FIGURE 5.5

CONFIGURATION

3

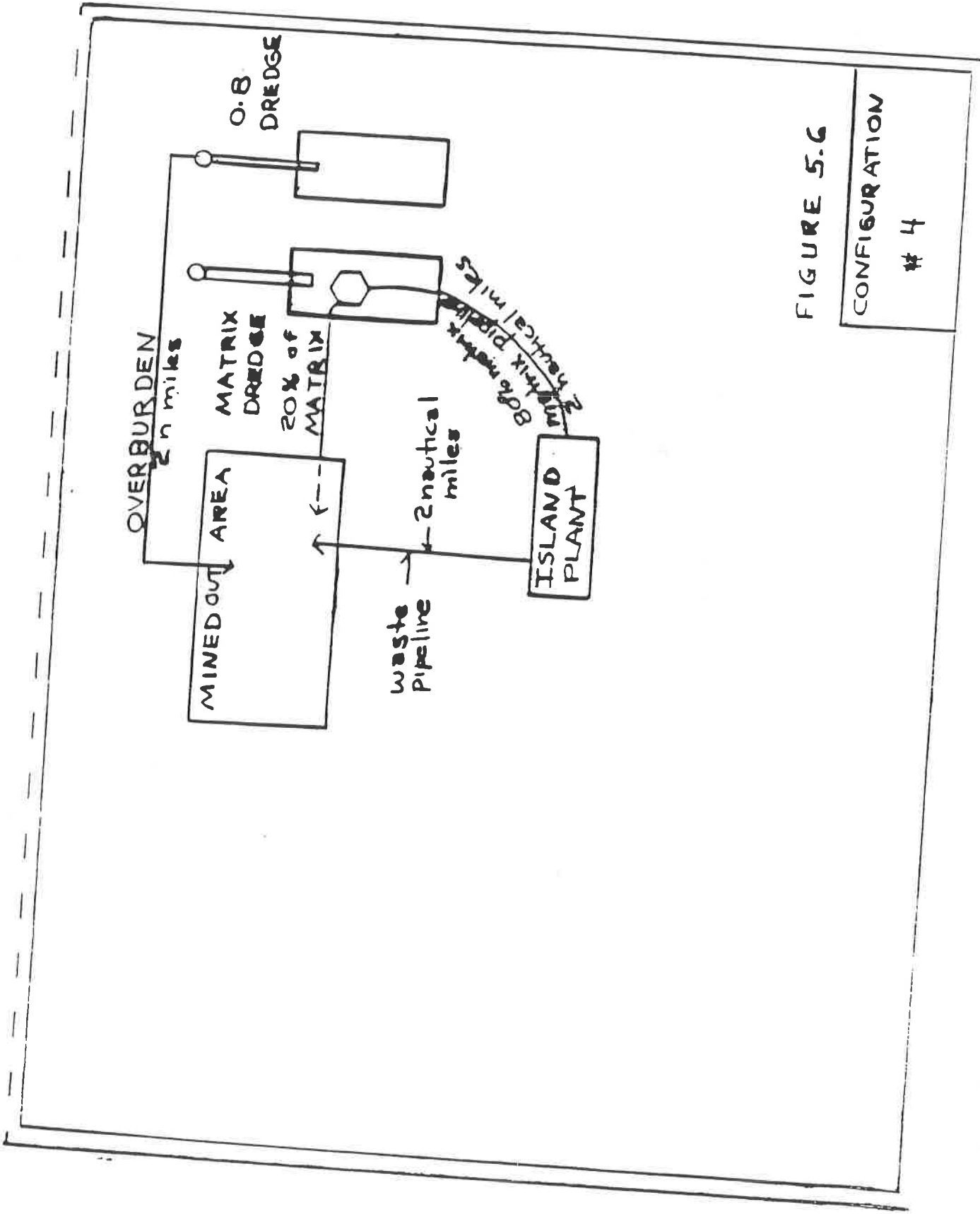


FIGURE 5.6

CONFIGURATION

4

Assuming that unloading and loading are equivalent, cycle time is:

	<u>Hours</u>
Loading	2.25
Plant to harbor	6.69
Unloading	6.69
Harbor to plant	<u>2.25</u>
Total Cycle Time	<u>17.88</u>
Cycle per year	316
Tonnes per cycle	19,500
Tonnes hauled per year	6,162,000

Since only 2,634,000 tonnes of product require transport, one tug and one barge is adequate. Employment of contract transport carrier systems for product may be indicated.

Capital costs are summarized in Table 5-11. The only difference from Configuration 2 is the number of barges, tugs, island cost, and pipeline cost.

Table 5-11
Capital Cost Configuration 4

<u>Item</u>	<u>mm \$ Unit Cost</u>	<u>No.</u>	<u>Total Cost</u>
Barges	16,200,000	1	\$ 16,200,000
Tugs	5,500,000	1	5,500,000
Matrix dredge	40,000,000	1	40,000,000
Overburden dredge	40,000,000	1	40,000,000
Beneficiation plant	14,930,000	1	14,930,000
Onboard plant	2,990,000	1	2,990,000
Infrastructure & Misc.	20,900,000	1	20,900,000
Island	30,000,000	1	30,000,000
Pipelines	2,500,000	2	5,000,000
Vessel berth & loading dock	11,200,000	1	<u>11,200,000</u>
Total Capital			<u>\$186,720,000</u>
\$ per tonne annual production			70.89
\$ per tonne mine life (20 years)			3.54

Operating costs were computed using Zellars-Williams operating cost model. Table 5-12 summarizes the operating costs.

Table 5-12
Operating Cost Configuration 4

<u>Item</u>	<u>\$ Cost per tonne</u>
Mining	5.76
Plant	4.94
Waste/water	.25
Product handling	.46
Administration	<u>1.30</u>
Total	<u><u>12.71</u></u>

The total cost for comparison of Configuration 4 is \$16.25 per tonne of product.

5.2.3 Selection of Configuration

It is evident that, from a material handling standpoint, the offshore plant should be more efficient. Material is processed near the plant and wasted near the plant in mined-out areas. With onshore plants, washed matrix is hauled 27 nautical miles by barge and tug, processed, and the waste hauled 27 miles back to the mined-out pits for disposal. Table 5-13 outlines comparative capital and operating costs for each configuration. Based upon this trade-off study, Configuration 4, utilizing an offshore plant, was selected as the basis for examining the economic feasibility of exploiting off-shore phosphorites. This configuration is developed in further detail in the following parts of this section.

Table 5-13
Configuration Selection

<u>Configuration</u>	<u>Annual Production Tonnes</u>	<u>Cost \$/Tonne Concentrate</u>		
		<u>Capital</u>	<u>Operating</u>	<u>Total</u>
1	851,000	7.28	22.42	29.70
2	2,634,000	5.35	13.58	18.93
3	Not feasible (no economics done)			
4	2,634,000	3.54	12.71	16.25

- Configuration 1) Sea-going hopper dredge for mining and transportation to an onshore plant.
- Configuration 2) Seagoing hopper dredge mining and barge transportation of ore to an onshore plant.
- Configuration 3) Dredge mining, pipeline transportation of ore to onshore plant.
- Configuration 4) Dredge mining, pipeline transportation of ore to nearby offshore island plant.

Zellers-Williams, 1979, treated Configuration 2 in considerable detail and concluded that favorable economics could result if all the assumptions made proved to be valid. The beneficiation process flowsheet suggested by Zellers-Williams, 1979, is adopted for this study, with minor modification in the degree of final processing. Most modern chemical fertilizer production plants use wet phosphate rock as feed stock. Calcination to improve grade of phosphate rock after wet processing is a matter of economics not considered essential to evaluating feasibility.

Capital and operating costs of beneficiation plants of various production rates, together with ancillary facilities and supporting infrastructure, are well known, and no attempt is made in this report to construct new estimates. Capital and operating costs are developed from current in-house data, factored for the production rates and unit costs applicable to the selected configuration and local conditions.

5.2.4 Design Criteria

Table 5-14 lists the design criteria used for determining production limits, operating costs, equipment needs, and capital requirements of the selected configuration. As with any mining project, the physical and chemical geologic parameters are site-specific, having been determined by nature. These characteristics were based upon the initial mine site selected in Section 5.1.1.

Operating factors were determined by past experience, as well as consideration of the unique mining environment. In the case of offshore dredging, it is necessary to consider the size and design of the dredge from a seaworthy standpoint. A large vessel is necessary to accommodate the mining depths; therefore, required size is somewhat independent of production. The largest dredge pumps operating in ocean mining today have a suction head pipe diameter of 1200 mm (48"). For the conditions of offshore Georgia, a 900 mm diameter (36") suction head pipe was used to determine productivity. The design philosophy is to use the largest practical dredge pump, mounted on a seaworthy vessel. For example, a dredge pump producing half the capacity of a 900 mm dredge pump gives only a small reduction in capital and operating costs. Therefore, the design philosophy maximizes production while minimizing the costs.

Table 5-15, Climatic and Physical Oceanographic Data, for the southeastern United States continental shelf, indicates conditions which may cause dredge mining operations to shut down which depends upon the specific equipment and configuration utilized.

The production rates are determined from the design criteria. In most land-based phosphate operations, the beneficiation plant is optimized and, because its maintenance and operations are easier, operating hours exceed the dragline (mining) operating hours. Often, several draglines feed the same plant. Stockpiles and surge bins cushion the difference between operating hours and production hours.

Table 5-14
Design Criteria

o Ore (matrix) assumed distribution

<u>Size Fraction</u>	<u>Percent</u>	<u>BPL</u>	<u>Disposition</u>
+4 Mesh	2.74	17.03	Grind to feed
4x8 Mesh	0.64	33.38	Grind to feed
8x16 Mesh	2.05	30.18	Grind to feed
16x150 Mesh	68.52	25.53	Flotation Feed
16x150 Mesh	4.76	6.00	Feed dilution
-150 Mesh	21.29	15.07	Clay Waste

o Grade Criteria (Estimated)

Feed Head 16x150 - 24.20 BPL
 Rougher Concentrate - 55.00 BPL
 Final Concentrate (Float) - 66.0 BPL
 Final Concentrate (if Calcined) - 68.00 BPL

o Recoveries

Mining Recovery - 90%
 Primary Cyclone Recovery of Feed - 98%
 Secondary Cyclone Recovery - 99%
 Rod Mill Weight Recovery - 85%
 Flotation Recovery (Overall) - 80% of BPL values in the total feed

o Annual Operating Hours

Days lost:	
annual dry dock/repairs	30
hurricane	1
gale force winds	5
fog	1
other	<u>1</u>
	38
Days operational	327
Hours operational/year (327 x 24)	7,848
Mechanical availability	90
Overburden dredge	
Operating factor *	83
Matrix Dredge	
Operating factor *	87
Dredge operating factor - average, use	85%
Overall operating factor - .90 x .85 =	76.5%
Effective production hours/year	6,000
(7,848 x .715)	

* Note: operating factor for dredges is based on allowing time for resetting spuds at end of each mining cycle.

Table 5-14 (continued)
Design Criteria

o Beneficiation Plant	
Washer production hours	6,000
Production hours feed prep. flotation and product to storage	7,000
o Mining Data	
Average Water Depth	13.97 m
Average Overburden Depth	8.02 m
Average Matrix (ore) Depth	5.44 m
Average Mining Depth (below MSL)	27.43 m
Matrix "X" (m^3/t prod.)	3.13
Matrix Density - 1.44 tonnes/ m^3 (90 lbs/ ft^3)	1.44
Stripping Ratio - 1.64 m^3 overburden/ m^3 matrix	1.64
Overburden Density - 1.6 tonnes/ m^3 (100 lbs/ ft^3)	1.60

Note: Oceanographic information is contained in Table 5-15.

Table 5-15

Climatic and Physical Oceanographic Data *

Much of the following information applies generally to the Savannah, Georgia region rather than specifically to the proposed offshore mining site. Local measurements within the area of interest have not been made.

- Precipitation:** Average annual rainfall is 51 inches, half of which falls during the June 15 through September 15 thunderstorm season. Snowfall is rare and occurs, on an average, less than once a year.
- Wind:** Winter surface winds are chiefly out of the west while the summer months experience north and east winds alternating with those from the west. Average wind speed during the year is about 7 miles per hour with peaks each month ranging up to 30 to 38 miles per hour.
- Storms:** During an 84-year period to 1970, all tropical cyclones occurred between May 28 and October 19. Severe tropical storms affect the area about once in 10 years. In the period 1954-1975, seven cyclones passed through the Savannah area.
- Fog:** Heavy fog is common along the coast and Savannah experiences 44 foggy days a year. The distribution of foggy periods is fairly even through the year, although July and August have less.
- Temperature:** The climate is temperate with a seasonal mean of 51°F in the winter and 80°F in the summer. The record minimum and maximum are 8°F and 105°F.
- Tides:** The maximum spring tidal range along the southeastern coast is 8 feet and occurs in the Savannah area. Strong onshore winds can raise the water level a significant amount above the maximum normal tide level.
- Waves:** Spring and summer waves from the southeast are generally small. Although more severe wave conditions result from the strong fall and winter winds from the north and west, the proposed mining site is relatively well sheltered by land from this direction. Offshore from Savannah the recorded percent frequency of two levels of wave height is:

<u>Wave Height</u>	<u>Feb.</u>	<u>May</u>	<u>Aug.</u>	<u>Nov.</u>	<u>Annual</u>
4 foot	40%	66%	74%	48%	57%
12 foot	5%	2%	1%	1.5%	2.4%

* From Zellars-Williams (May 1979)

For ocean mining, the plant is dependent on feed from a single dredge, so stockpiling is impractical. Therefore, the washer or front end of the plant must reduce operating hours from the normal of about 7,000 hours per year to match the dredge, which is limited to 6,000 hours per year. A quick look at capital costs from previous studies shows that dredging and transportation comprise a much larger percent of total project capital than does the beneficiation plant. Therefore, the dredging/transportation systems are optimized at a slight reduction in plant capital cost efficiency.

Section 4 lists the available state-of-the-art technologies. The only currently utilized system capable of mining phosphate in offshore Georgia is a plain suction head dredge. There is considerable doubt that this dredge is capable of mining the phosphorite which is consolidated. If this is true, then no currently utilized systems exist for mining offshore Georgia phosphorite.

5.2.5 Mining Systems

The system proposed for offshore phosphate mining in the areas identified is an advanced version of a hydraulic dredge of the cutter head suction type.

The platform would be constructed of steel, taking the shape of a large hull comprising a series of watertight compartmentalized buoyant sections fastened together to make a semi-rigid structure. The buoyancy and structural integrity of the platform must be capable of supporting the spuds, pumps, prime movers, deck machinery, operator's house, ladder and superstructure, and as required, certain ore washing and screening equipment. This structure must be capable of floating, with safe freeboard, in moderate seas while being towed or otherwise moved by tug. During operation, the platform will be supported on legs extending to the bottom of the cut and must be structurally capable of carrying the dead load, wind and wave loads, and the dynamic loads imposed by the excavating machinery. The design and construction of this kind of platform is entirely within the technological expertise and experience of U.S. contractors and manufacturers.

The platform-hull will be equipped with a ladder supported by cantilevered overhead structural members. The ladder will pivot on a swivel located on or near deck level at the front end of the platform-hull to permit the ladder to

articulate. The ladder, about 250 feet in length, when lowered to 45° below horizontal, will swing port to starboard over an arc angle of 80°-90°. At digging depth of about 130 feet (below water surface), the chord distance of the arc swing will permit a cut width of about 360 feet. With the ladder lowered to 60°, digging depth of 165 feet and cut width of about 360 feet can be realized.

An hydraulic or electric motor driven cutter head mounted at the end of the ladder engages and excavates the material to be extracted. The cutter head directs excavated material to the flared open end of a pipe which leads to the suction side of a centrifugal pump. The pump is also submerged and is located about one-third the distance up the ladder. The pump is a high capacity, low head end suction centrifugal pump capable of passing large solids. This pump is direct driven through an extended mechanics shaft arrangement or directly by a variable speed submerged electric motor and gear box mounted on the ladder.

The platform-hull is designed to accommodate eight spuds. The entire platform is supported by four spuds extending to the ocean bottom. The lower end of each spud has an enlarged pad providing the area required for bearing to support the platform-hull. The spuds are of a length, when retracted, to permit floating with minimum draft, and when extended, to provide clearance above high tide and severe weather seas. Four of the spuds (working spuds) are mounted in carriage systems which will facilitate controlled horizontal movement of the platform. This movement, with working spuds extended, will permit advancing the mining face of the cut about 50 feet without resetting spuds.

When the full limit of horizontal travel is completed, the other four spuds (fixed or positioning spuds) are extended, the working spuds retracted, and the platform repositioned.

The working spuds are extended, the positioning spuds are retracted and the advance cycle by manipulation of the carriage system is repeated.

This platform-hull cutter head suction dredge will operate in all but the most severe weather conditions. When gale or hurricane force wind and wave

action occurs, the platform will ride out these conditions above the sea, supported on eight legs.

The cutter head may be an open radial multi-blade basket-type with cutter teeth designed for loose sand, sandy-clay and moderately cemented sands and gravels. Since the cutter head is axially mounted and rotates in one direction, excavation occurs when the ladder sweeps in the same direction. During the return sweep, no engagement of the cutter head occurs and the pump will collect material previously loosened. The matrix dredge will be equipped with a radial basket-type cutter head.

The cutter head may be of a bucket wheel design. The rotating axis of the wheel is perpendicular to the ladder and the buckets engage the excavating face in both sweeping directions. Bucket configuration and spacing is arranged for the type of material to be excavated and buckets spaced on the wheel to reject oversize particles. Production from this type of cutter is expected to be better than from a basket-type. The overburden dredge will be equipped with a bucket-wheel type cutter head.

The proper cutter type is a matter of design based upon accurate knowledge of soil conditions. For the purpose of this study, dredge production is based on experience with these two cutter heads in unconsolidated sandy material and on practical limits of centrifugal pump capacity, average solids content of 30-40% by weight in the slurry.

The mining system described above is based on a design proposed by Ellicott Machinery Corporation of Baltimore, MD, for mining sands offshore U.S. Atlantic coastal waters for beach nourishment. The design and construction of the dredge platform described is well within the capability of this manufacturer, who will combine its own dredge construction experience with the experience of offshore gas and oil exploration and production platform contractors.

Production is limited by the capacity of the ladder-mounted dredge pump. The capacity of the dredge pump is restricted by its size (weight) and the power output of the prime mover (motor, speed reducer and power transmission system). GIW Industries, Inc., of Grovetown, Georgia has

recently supplied deck and ladder pumps (30 x 34 TBC 84, and 34 x 34 LHD-60) to Shipyard Stapel B.V., The Netherlands, for the dredge "Amazone" built for Dredging International, N.V., Belgium. These pumps have slurry pumping capacity in the range of 50,000-70,000 gpm at discharge heads up to 500 feet.

The practical upper limit of currently manufactured submersible electric motors is about 3000 kW.

The combination of these state-of-the-art currently manufactured components indicates that dredge slurry pump capacities of 70,000 gpm at 40% solids, and 7,200 tonnes (dry solids) per hour are realistic. Total head, and therefore discharge head, is limited for practical purposes only by the amount of energy available at the pump shaft, i.e., by the horsepower (kW) of the prime mover.

The mining and ore transport system described above envisages an arrangement which is an assembly of cutter head, ladder pump and deck pump sized for maximum performance consistent with available power and the practical limitations of the platform and its structural components working in an ocean environment. This is the premise for mining which is the basis for determining the annual production capacity of the selected configuration used in evaluating feasibility of the enterprise.

5.2.6 Mining Dredges

Two dredges will be required for the mining of phosphorites from the offshore areas described in Section 5.2.1. One dredge will excavate and remove overburden, the other will mine matrix and remove it to the beneficiation plant.

Overburden from the initial mining area will be used as hydraulic fill in the construction of the off-shore island.

The overburden dredge will excavate overburden and discharge through a trailing pipeline for deposition in mined-out cuts. The pipeline would be supported at a semi-submerged level by floats to minimize wave action effects. The pipeline would discharge to a barge-mounted hopper and tremie.

The tremie would direct discharge of the slurry below water near the bottom of the cut being backfilled. The discharge pipeline and tremie hopper barge would be tended by a tugboat which "shepherds" the pipeline and moves the tremie hopper barge.

The overburden dredge must remove about 7 cubic yards (5.1 cubic meters) for each tonne of final product produced. Average water depth is 45.8 feet, and the average depth of overburden is 26.3 feet (23.3 feet minimum to 32.5 feet maximum) in the area designated for mining. The platform must be capable of operating safely above the water surface with a clear distance of about 6-10 feet. Tide variance of +7.4 feet and wave height of 15 feet should be allowed. This will put the bottom of the platform at Elevation +30.4 (8 + 7.4 + 15). Assuming a depth of the platform-hull of 24 feet, the top of the platform would be at Elevation +54.4. Average overburden digging depth from top of platform to Elevation -72.1 is 126.5 ft. (54.4 + 45.8 + 26.3). Maximum digging depth to Elevation -86.3 is 140.7 feet (54.4 + 53.8 + 32.5).

The overburden dredge will excavate about 11,200 cubic yards (8,564 m³) from one position; the spud carriage system will advance the platform approximately 50 feet, before repositioning. This cycle will take 30-60 minutes.

This dredge is equipped with a GIW 34 x 34 LHD-60 ladder pump and 2500 kW variable speed submersible motor. The pump capacity is 65,000 gpm at about 85 feet head (26 meters). A bucket wheel cutter head, at the end of the ladder, powered by a 1500 kW motor excavates and directs overburden to the ladder pump suction.

The ladder pump discharges directly into the suction of a GIW 30 x 33 MDH 72 slurry pump mounted on the deck. This pump is fitted with an impeller capable of 65,000 gpm at 200 feet head (61 meters) at 350 rpm. The prime mover for this pump is a 4500 kW variable speed electric motor and speed reducer.

The overburden dredge is capable of mining at the average rate of 6,560 tonnes per hour at 35% solids, and transporting this slurry through a trailing pipeline about 1.5 nautical miles (9,120 feet) to waste in nearby mine cuts.

The matrix excavating dredge will excavate matrix and discharge through a trailing pipeline to a central processing plant. The area to be mined over a 20-30 year period will be within a radius of about 3 nautical miles (18,240 feet) from an artificial island on which the plant is built. The maximum pipeline length will be about 25,000 feet. The matrix mining dredge will operate from a stationary position above the water surface as described for the overburden dredge. The matrix dredge must remove about 4 cubic yards (3.1 cubic meters) for each tonne of final product produced. Average depth of matrix is 17.8 feet (16.4 ft. min. to 23 ft. max.). The average bottom of the matrix is at Elevation -90.1. From the top of the platform at Elevation +54.4, the average matrix digging depth is 144.1 ft. Maximum digging depth to Elevation -109.3 is 163.7 feet (54.4 + 53.8 + 32.5 + 23).

For each move, the matrix dredge will excavate about 7,500 cubic yards (5735 m³). The repositioning cycle, which occurs at the end of the spud carriage system travel (about 50 ft.), will take about 30-60 minutes.

This dredge is equipped with a GIW 30 x 33 MDH 72 ladder pump and 1500 kW variable speed submersible motor. The pump capacity is 45,000 gpm at about 90 feet head (27 meters). A radial basket-type cutter head, at the end of the ladder, powered by a 1500 kW motor excavates and directs matrix to the ladder pump suction. The ladder pump discharges directly into the suction of a GIW 30 x 34 T8C 84 slurry pump mounted on the deck. This pump has a capacity of 45,000 gpm at 450 feet head (137 meters), and is driven by a 6,500 kW variable speed motor and speed reducer at 425 rpm. The matrix dredge is capable of mining at the average rate of 3,600 tonnes per hour at 30% solids, and transporting this slurry three nautical miles (18,240 feet) to the island-based beneficiation plant.

The two dredges are to be similar in design and construction. Average digging depth for the overburden dredge from top of deck is about 127 ft. (39 m) and for the matrix dredge about 144 ft. (44 m). Ladder length would be matched to the cut depth. Cutter head power would be the same. Ladder pumps would be similar, the overburden dredge having more capacity. Deck pumps would be sized to accommodate the slurry and pipeline distance.

The overburden dredge requires about 9500 kW diesel engine powered electric energy generating capability to provide power to all equipment. Maximum

power demand, which occurs when dredge pumps are being started while the other machine is operating, is about 9400 kW. During normal operation over mine life the power demand is about 7500 kW. Fuel consumption is about 1.4 tonnes per hour.

The matrix dredge requires installed diesel engine electric generating capability of about 10,500 kW. Mine life average power demand is about 8400 kW. Maximum power demand occurs when mining at the extremities of the orebody, about 3 nautical miles, is estimated to be about 10,500 kW. Fuel consumption for mine life average is about 1.8 tonnes per hour.

The two dredges will be similarly equipped with diesel fuel powered electric generators having a nominal continuous rating of 10,000 kW and standby rating of 12,000 kW. Fuel storage capacity of about 1360 tonnes (10,000 bbls) to permit one month of operation without re-supply is provided.

Fuel is to be supplied by a commercial operator such as Belcher Company of Georgia, Inc., who will contract for delivery to the offshore dredges by fuel barge (10,000-17,000 bbl capacity). This fuel barge would normally deliver and transfer diesel to each dredge on a 10-15 day cycle.

Crew accommodations for three shifts are provided in 2-bed cabins. Crews work two weeks offshore, 14 days @ 12 hours/day, and go ashore for seven days. Shifts are staggered so that while two shifts are on duty offshore, one shift is at rest on shore. Cooking and mess facilities are provided to serve about 40 persons, three meals each day. Provisioning and re-supply occurs on a two-week cycle when crew shifts change. Crews and provisions are transported from Port Savannah by motor launch.

Each dredge has a helicopter landing deck platform positioned in cantiliver-fashion off the stern.

For purposes of estimating capital cost, it is assumed the two dredges are identical; sized for the maximum conditions. Operating cost will be estimated separately for the two machines based on materials handled and distances transported.

5.3 BENEFICIATION

The beneficiation facilities have been grouped into the following areas: washer, feed preparation, flotation, reagent, waste disposal, water recirculation, and product storage and loading.

These areas are designed to receive slurried ore from the dredge, disaggregate the ore, wash and grind the oversize rock, remove clay from the feed, and separate the sand from the feed to produce a marketable phosphate concentrate product.

Sea water will be used in the beneficiation process, which will result in a higher level of chlorides in the concentrate. Chlorides will be removed from the concentrate by filtering and rinsing with fresh water supplied by desalination units.

Waste products (clay and sand tailings) will be returned to the mine cuts.

5.3.1 Washer

The phosphate rock ore (matrix) is dug and slurried by the dredge and then pumped to the washer for initial processing. The purpose of the washer is to separate the +20 mesh rock from the -20 mesh fines and to grind the +20 mesh rock to pass 20 mesh.

Large clay balls and other deleterious material are discarded at the washer. This material is recovered from the discard pile and used as fill to repair erosion, and/or is placed as fill along the toe of the outer slopes of the island.

The slurried matrix is received from the dredge at the matrix distributor where it is diverted to the trommel screens. The trommel screens separate the material at 2 inch. The +2 inch oversize is conveyed to a reject pile, while the -2 inch undersize from the trommels gravity flows to the flume screens. The flume screens separate the material at about 20 mesh. The flume screens facilitate a quick reduction in flow and removal of a large percentage of the solids. The +20 mesh material from the flume screen

oversize is re-screened at the primary vibrating screens. Plus 20 mesh oversize from the primary vibrating screens is then pumped to the milling section which consists of a rod mill in closed circuit with vibrating screens (secondary screens).

The secondary vibrating screens feed a surge bin. Feed retrieval from the bin is achieved by a weigh-belt feeder which is designed to deliver a controlled rate of feed to the rod mill. The rod mill discharge reports to a pump box which recycles the ground pulp to the secondary vibrating screens. The ground -20 mesh material passing the secondary vibrating screens is combined with the -20 mesh undersize from the flume screens and primary vibrating screens and is pumped to feed preparation. The +20 mesh material from the secondary vibrating screens reports to the mill feed surge bin.

The flowsheet for the washer is shown in Figure 5.7.

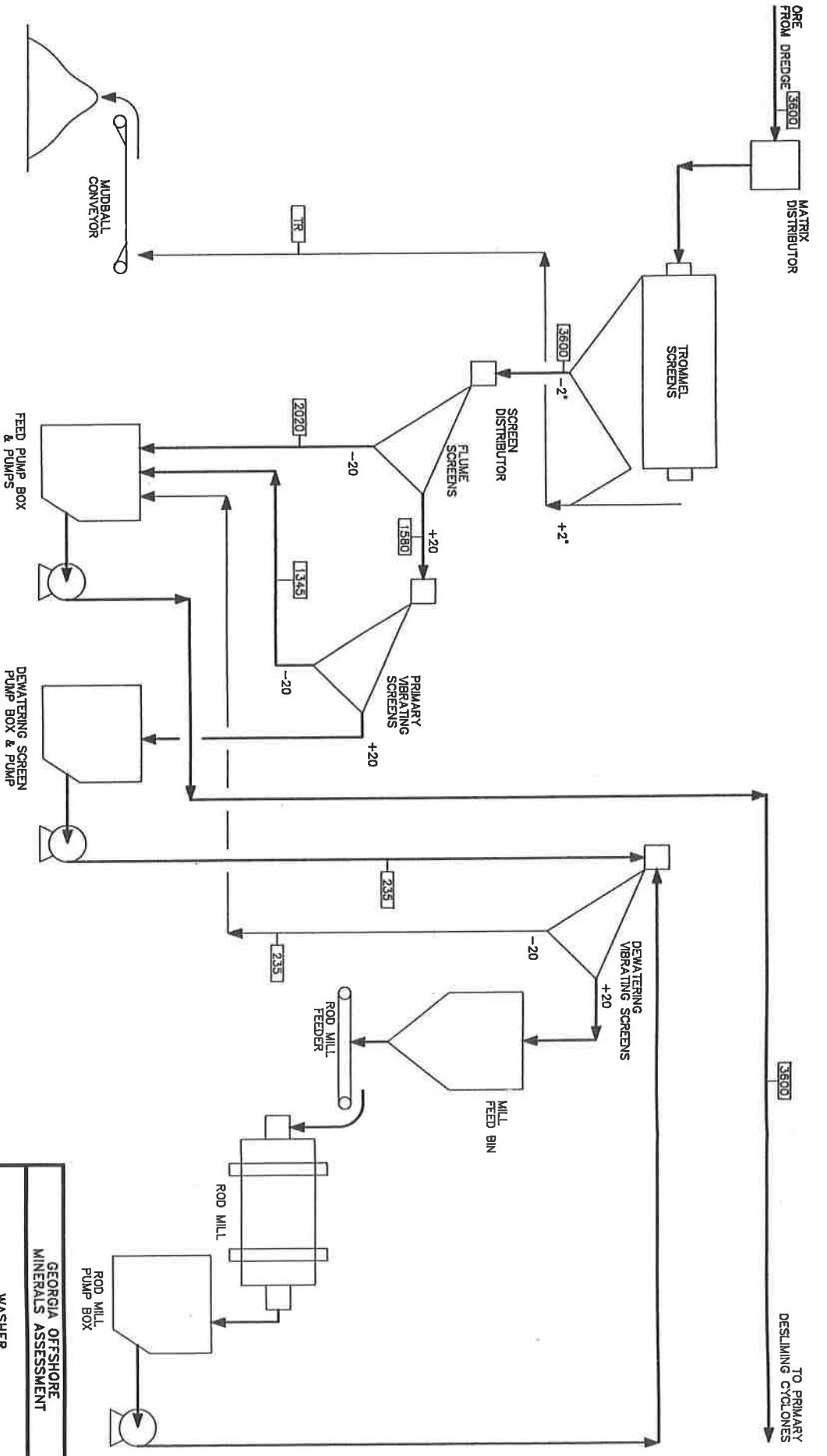
5.3.2 Feed Preparation

The -20 mesh feed from the washer is pumped to the feed preparation area. Primary activities conducted in the feed preparation area are:

- o Removal of the -150 mesh particles (slimes) from the flotation feed. The -150 mesh slimes are removed in order to improve flotation efficiency and to reduce reagent consumption.
- o Perform attrition scrubbing of the flotation plant feed.
- o Provide feed to the flotation plant at a uniform rate by feed surge storage and control of feed tonnage rate.

This discussion describes one train. More than one train is required.

Feed from the washer is pumped to the primary desliming cyclones. The cyclones are used to remove -150 mesh slimes (clays) from the feed. The primary desliming cyclone underflow, at about 65% solids, gravity flows to the feed surge bin. The feed surge bin is designed to provide about 24 hours of live feed storage, smooths out upstream process surges, and helps to maintain a constant rate of feed to the feed preparation circuit. When the bin overflows, it also functions as a desliming operation.



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WASHER FLWSHEET	
DATE: 5-9-88	BY: MEK
FIGURE 5.7	

Feed is reclaimed from the storage bin as a slurry and is pumped to the secondary desliming cyclones. The cyclones remove additional -150 mesh slimes and dewater the feed prior to attrition scrubbing. The secondary desliming cyclone underflow, at about 65% solids, gravity flows to the attrition scrubbers. Scrubbing of the feed removes any tramp clay particles, removes some of the friable carbonates by reducing it to slime particle size, and effectively scours the particle surfaces to enhance flotation performance.

Scrubbed feed is then repulped with recycle water and pumped through the tertiary desliming cyclones to remove the slimes produced during the scrubbing step.

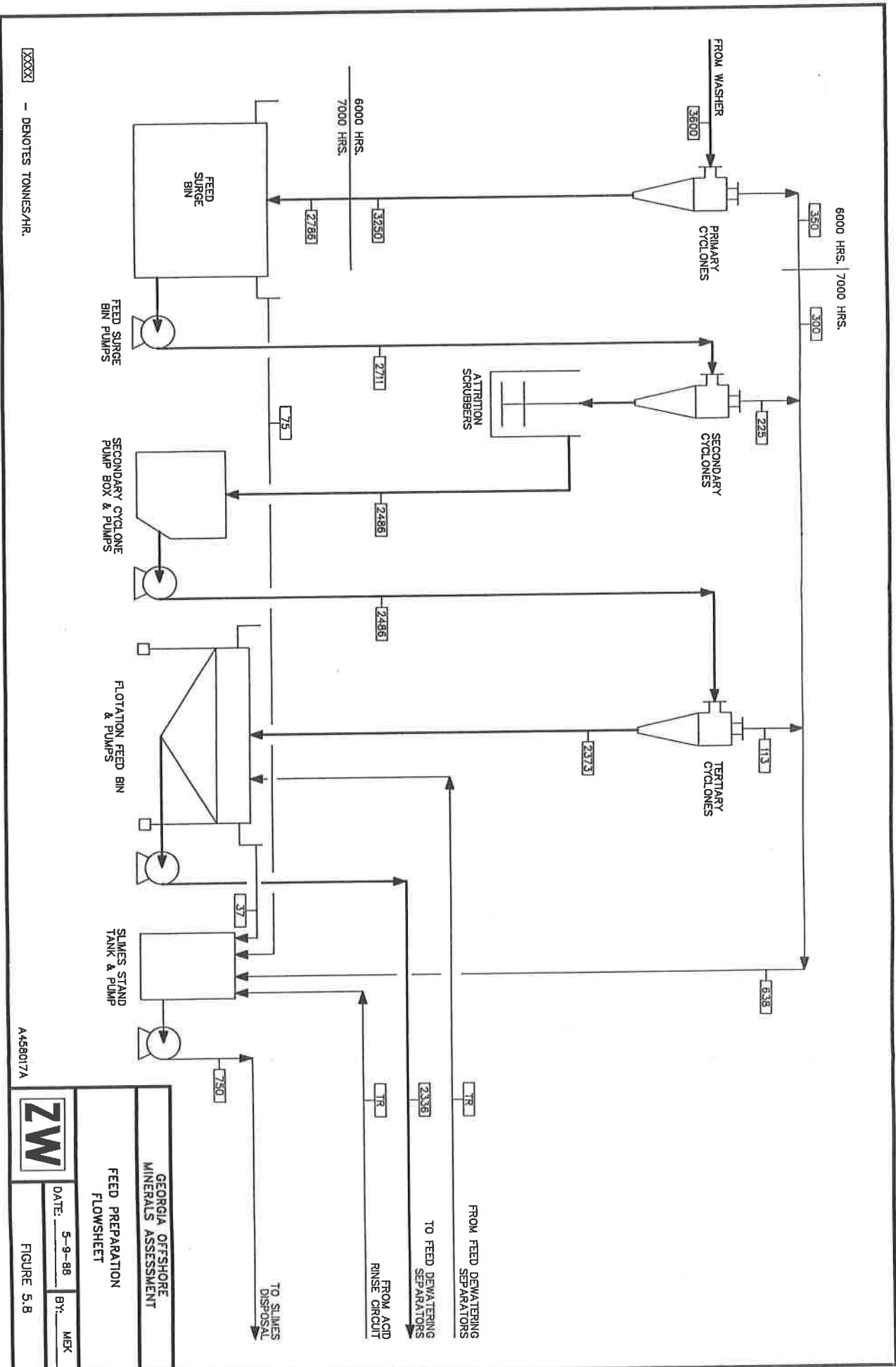
The primary, secondary and tertiary desliming cyclone overflows and bin overflows contain slimes and fine solids entrained in dewatering. The combined slimes collect at the slimes stand tank and then gravity flow to the waste disposal station. Clarified water from the waste disposal station is returned to the plant for re-use in the process. Waste disposal and water distribution are reviewed in Section 5.3.5 and 5.3.6, respectively.

The tertiary desliming cyclone underflow reports to the flotation feed bins. The bins provide about 4 hours of live storage and are used to maintain a constant feed rate to flotation. The bins are designed to overflow, thereby functioning as a desliming operation as well. Feed from the bins is pumped to the feed dewatering separators in the flotation area.

The flowsheet for the washer is shown in Figure 5.8.

5.3.3 Flotation

The flotation section is designed to recover the phosphate from the sized, deslimed feed delivered from the feed preparation area and produce a high grade saleable product. The conventional two-stage Crago process is employed for this purpose and consists of anionic rougher flotation of the phosphate particles followed by deoiling and cationic cleaner flotation of the silica particles.



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FEED PREPARATION FLWSHEET	
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FIGURE 5.8	

The objective of rougher flotation is to obtain a bulk separation of the phosphate from the silica, achieving a reasonable recovery of phosphate without an attempt to produce a saleable concentrate. Significant rejection of silica is accomplished in this rougher step, but the concentrate is still high in silica. The rougher flotation reagents are removed by acid scrubbing and then the feed is subjected to cationic cleaner flotation where most of the remaining silica is floated and removed from the phosphate sink particles. The final concentrate product is relatively free of silica.

Reagents used in the rougher flotation circuit are:

- o Fatty Acid (or Fatty Acid Soap). An organic fatty acid (oleic acid, etc.) derived from wood pulp processing.
- o Fuel Oil. An extender used to aid in flotation and froth control.
- o Sodium Hydroxide or Ammonium Hydroxide. Used for pH adjustment.

Sulfuric acid is the deoiling reagent. The acid attacks the reagents, solubilizing them, making it possible to wash the particle surfaces clean.

The reagents used in cationic cleaner flotation are:

- o Organic Amine Reagents. The primary silica flotation chemical.
- o Kerosense. An extender.
- o Sodium hydroxide for pH control, as necessary.

The deslimed feed from storage is pumped to the dewatering separators which dewater the feed to 68-72 percent solids prior to entering the reagent conditioners. Fatty acid, fuel oil and caustic are added at the conditioners and allowed to mix (condition) with the pulp for 3 to 4 minutes. The conditioned feed is then discharged into the rougher flotation machines. Flotation is conducted carrying the rougher concentrate to the overflow.

Rougher concentrate is then pumped through cyclones that dewater the solids to facilitate acid scrubbing. Reagentized water recovered from the cyclone overflow is returned to the flotation feed bin in the feed preparation area.

After scrubbing with sulfuric acid, the feed is washed free of spent rougher reagents by countercurrent flushing with water in primary and secondary wash boxes.

The de-oiled rougher concentrate is then fed to the cationic cleaner flotation cells where amine and kerosene are added to float the silica from the phosphate. Final concentrate reports to a pump box where it is pumped to the filtration section. The rougher tailings and cleaner tailings gravity flow to the general mill tailings pump box, and are combined and pumped to the GMT dewatering cyclones at the waste disposal station.

At the filtration area, the flotation concentrate is dewatered by cyclones followed by filtering and a two-stage countercurrent wash with fresh water to remove chlorides (sea salt). Horizontal table filters with sprays are used to filter and wash the concentrate. The washed and dewatered product is then conveyed to product storage. Wash filtrate from the filters is collected and returned to the plant hydraulic station.

The flowsheet for flotation is shown in Figure 5.9.

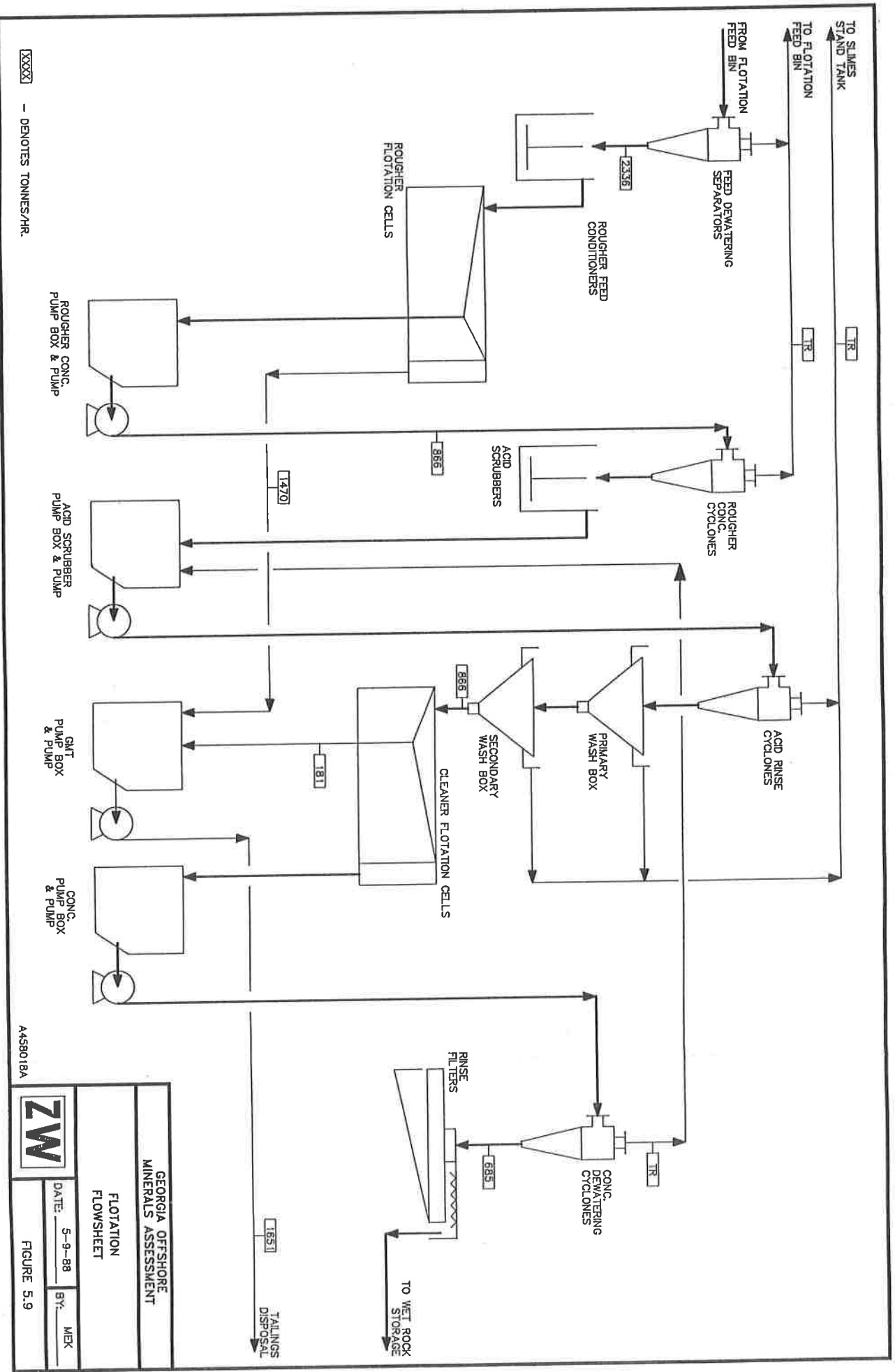
5.3.4 Reagent Storage

General

This area contains facilities to receive, unload, store, mix, and distribute reagents to the flotation plant and flocculants to the thickeners.

The system is designed to provide storage of reagents with capacity to receive shipments based on normal turnarounds. The mixed reagents storage capacity is based on the concept of one reagent operator five days per week preparing the reagent requirements for three shifts, seven days per week.

Stations for unloading are located to allow the receipt of reagents by ship/barge.



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FLotation FLowsheet	
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FIGURE 5.9	

Electric heat is provided for No. 5 fuel oil, fatty acid, 50% caustic, and amine as required to pump and dilute these reagents for use in the flotation plant.

The tank farm will be enclosed by a wall for spillage containment and to aid in housekeeping.

Fatty Acid

This reagent is delivered in 20,000 gallon lots. The fatty acid can be unloaded and stored in two 50,000-gallon storage tanks. Electric heat is provided to heat the fatty acid to about 120°F as necessary to unload, transfer, and store the chemical in a fluid state.

Fuel Oil

Number 5 fuel oil will be delivered in 20,000 gallon lots and unloaded using the fatty acid unloading pump. No. 5 fuel oil is viscous and must be heated to approximately 120°F for reasonable handling.

Fuel oil is stored in a 46,000 gallon insulated heated storage tank and is circulated to ensure consistency and to maintain fluidity. The fuel oil is furnished to the fatty acid-fuel oil mix tank as required. The resulting fatty acid/fuel oil mix is metered to the rougher flotation conditioners.

Sulfuric Acid

Sulfuric acid (minimum of 93% H_2SO_4) will be unloaded into a 24,000 gallon storage tank. It is fed to the acid scrubber circuit at the received concentration and the rate is controlled by a pH indicating/controller located at the acid scrubbers.

Amine

Amine will be unloaded into a 24,000 gallon storage tank. The 100% amine will be maintained at approximately 100°F to maintain fluidity.

Temperature control and mixing by an agitator are provided in order to prevent overheating and degradation of the amine.

The 100% amine is pumped to the dilution/ mix tanks (10,000 gallons) where water is added to obtain a 5% solution of amine. The mixture is then transferred to a 14,000 gallon use tank for metering into the process.

Kerosene

Kerosene will be stored in a 12,000-gallon storage tank. From storage it will be metered to the flotation area for use as an extender in cleaner flotation.

Sodium Hydroxide

Sodium hydroxide will be received as a 50% NaOH solution and stored in a 45,000 gallon storage tank. The 50% caustic must be heated in cool weather to prevent solidification; therefore, the system is provided with heated lines and the storage and mix tanks are heated.

The 50% caustic is diluted to 10% with water for plant use. After mixing, the 10% solution is transferred to a storage tank where it is metered to the rougher flotation section for pH control.

Flocculant

Flocculant is diluted directly with water to a low concentration suitable for metering into the thickener. The flocculant tank is provided with an agitator and recirculation capability.

5.3.5 Waste Disposal

The combined slimes from the feed preparation area gravity flow to the waste clay thickeners. The type of thickeners required are the high rate compact type that require less land area than conventional earth-bottom thickeners. The typical compact thickener consists of: a shallow,

cylindrical, cone-bottom tank; dewatering rakes and rake-drive; and an elaborate feed and discharge system for controlling slurry input, rate of addition of a flocculating agent, and the level and composition of the thickened slurry bed within the machine. Feed is typically injected into the center of the bed and clarified water is usually removed by way of a perimeter launder at the top of the tank. Clarified water from the thickener overflow water is returned to the plant hydraulic station.

The mill tailings (GMT) from the flotation area are pumped to dewatering cyclones. The cyclone overflow is returned to the hydraulic station while the cyclone underflow is fed into the waste clay thickeners. The thickener, therefore, acts as a mixing device, as well as facilitating a high-solids content sand-clay waste stream. It is believed that a high-solids content sand-clay waste stream, carefully deposited at or near ocean bottom, will undergo relatively little dispersion if water depth were sufficient and subsurface currents were not extraordinary.

An array of compact thickeners of adequate capacity could be constructed in various configurations. It is estimated (without specific knowledge of the character of the waste clays to be encountered offshore) that six units of 85-foot diameter, or three units of 140-foot diameter, would be sufficient for the proposed operation. The latter, disposed in a triangular array, would be less space-consuming than six units in a hexagonal configuration.

Whether waste clays are prethickened or not, and whether or not sand tailings addition were practiced, disposal of the waste streams would be within the mined-out areas. Typically, the discharge point would be well below sea level in order to minimize dispersion. The discharge line would require periodic tending to move the effluent point for even distribution of the mined-area backfill.

5.3.6 Water Requirements

Water is used extensively in mining and beneficiation as a processing medium and as a means of transporting solids in the form of aqueous slurries. The three main sources of water are: (a) sea water; (b) recirculated process water; and (c) fresh water.

Recirculated process water is collected at the plant hydraulic station where pumps lift the water, via independent distribution systems, to various areas of the beneficiation plant. Sea water is also pumped to the hydraulic station to replace system losses. Fresh water is used to wash the flotation concentrate and is required for reagent dilution, and for laboratory and potable water needs.

Fresh Water

Fresh water is required for the following plant uses:

- o concentrate product wash
- o reagent dilution
- o metallurgical laboratory use
- o potable water.

Systems that in normal circumstances would be supplied with fresh water, such as pump seal water, are not included in the total demand. It is also assumed that a source other than fresh water is used for sanitary fixtures.

A HydroFuge reverse osmosis (R/O) modular system is recommended to fill the planned fresh water needs. Water requirements, based on 150 ppm Cl⁻ content in the treated (fresh) water are presented below.

Fresh (R/O Desalinated) Water Requirements

<u>Description of Water Use</u>	<u>Rate (gpm)</u>
Concentrate product washing	1,315
Reagent dilution	25
Met. lab	5
Potable water	5
Misc. (10% add. capacity)	<u>135</u>
Total	1,485
or	2,138,400 gpd

On a washed concentrate product tonnage basis, approximately 115 gallons of fresh water are used by the horizontal table filters for each tonne of product.

A 10 percent safety factor has been allowed in computing total fresh water requirements.

Each HydroFuge R/O module proposed will produce approximately 300,000 gallons per day (1,136 m³) of fresh water (Cl⁻ content approximately 150 ppm) from average sea water feed of 1,000,000 (3,785 m³) gallons per day, at 19,000 to 21,000 ppm Cl⁻. The units operate at 30 percent recovery. Thirty percent recovery requires a 3-1/3:1 ratio of sea water delivered to the pump per unit of fresh water produced. This assumes a delivery pressure 75 psi (52 m).

In fact, actual operating recovery can be varied from 20 to 70 percent depending on output of water required and its contained chloride (or TDS) content.

The fresh water system installation required for concentrate product rinsing and other uses will require eight reverse osmosis modules.

The high Cl⁻ filtrate from the R/O units will be discharged as waste. The wash filtrate from the two-stage countercurrent wash on the table filters is collected and returned to the plant hydraulic station.

Process Water

The main sources of process water are: recirculated water from the GMT cyclones overflow, recirculated water from the slimes thickeners overflow, and table filter wash filtrate. Process water make-up requirements are provided by the sea water pump station which supplies water to the hydraulic station.

The beneficiation plant hydraulic station consists of two tanks. Fresh water flows into the first tank which supplies water to a reagent water pump and to the laboratory. Excess water overflows the first tank into the second tank,

which satisfies the beneficiation process water supply pumps (high and low pressure) demand for water. The second tank also receives recycled water from the GMT cyclones overflow, the slimes thickeners overflow, table filter wash filtrate, as well as sea water from the sea water pump station.

5.3.7 Product Storage and Loading

Washed concentrate is conveyed from the filtration section to the wet rock product storage pile.

The storage pile will be contained in an open-top structure about 200 feet wide by 700 feet long, with concrete walls about 30 feet high. In normal operation, concentrate will be piled as much as 15 feet above the walls, resulting in a storage capacity of approximately 340,000 tonnes.

The storage system consists of a bridge-type dual bucket wheel stacker/reclaimer that spans the total width of the storage area and travels the length of the stockpile. Washed concentrate is stored via the bridge supported stacker conveyer, tripper car, and discharge chute. Concentrate is reclaimed via the bridge supported dual bucket wheels. The independent digging wheels feed a conveyor system which, in turn, feeds a shiploader with the capability of loading vessels at the rate of 3,000-3,500 tonnes/hour. The shiploader is equipped with a cantilevered section that extends out over the mooring berth to distribute the concentrate during loading of the vessel.

The mooring berth will be located along the full length of one side of the island, and adjacent to the wet rock product storage pile. The berth will also permit off-loading of fuel, reagents, and other supplies required to sustain the island operation.

5.4 CONFIGURATION AND INFRASTRUCTURE

The preferred configuration of mine, beneficiation and support facilities is that which results in the least investment and the lowest cost of production. Accuracy in assessing and evaluating risks is a necessary and vital element of engineering the design and construction of the preferred configuration.

Depending on the specifics of location conditions, offshore dredging activities may be detrimental, beneficial, or have no determinable effect on fauna, the coastal environment, or the sea floor.

The offshore area targeted for initial exploitation of the phosphorite resource is located in 46 feet of water (average depth) just north of the Savannah Harbor navigation light tower, which marks the entrance to the Tybee Road ship channel. The northern extremity of the proposed mining area is about 2 nautical miles north of the 32° latitude line, and 4-7 nautical miles south and west of the Port Royal Sound navigation channel entrance.

The preferred configuration concept envisages the offshore location of all mining, beneficiation and support facilities. No production activity takes place on shore. Finished product is loaded on vessel for transport to the customer from the offshore location.

Zellars-Williams, 1979, under a contract to the U.S.G.S, based their work on mining a hypothetical orebody located in the same area identified and targeted for this study. Matrix, after washing aboard the dredge to reject oversize (+3/4") and fine colloidal material (-200 mesh), was transported by barge for final processing at a beneficiation plant located 27-30 nautical miles up the Savannah River on Hutchinson Island.

Comparative economics based on state-of-the-art technology and current conditions favor locating all of the processing and supporting infrastructure in a single facility on an offshore man-made artificial island. Construction of an island, in the center of the mining area, having a surface area of about 15 acres at Elevation +35.0 is proposed.

The same considerations apply to construction of the beneficiation plant, ancillaries, storage and load-out facilities on the island plant site as for a land side location. In addition to accounting for some increase in the cost of construction owing to the requirement for water-borne transportation of labor, equipment and materials, several specific additional requirements must be considered. These are; 1) getting electric power to the island, 2) providing potable water, and fresh water for de-salting concentrates, 3) standby power generation for minimum maintenance and safety during power outages, 4) worker accommodations, commissary, kitchen and dining facilities, and 5) transportation of workers and supplies. These extra facilities are no more than are ordinarily required of any remote plant site location.

Permitting requirements, once the concept is fully explained and understood, are likely to be less tedious and restrictive, and therefore less time-consuming and less costly. The post-mining use (after 25-30 years) of the island may prove to be an attractive and valuable asset to the environment, and local community.

Any one of several techniques may be employed for the design and construction of the island. One method is to simply dredge overburden material and place it hydraulically in the designated area. Overburden sands may be excavated by mining dredges and pumped to a single general location. The sands would pile up, assuming a natural angle of repose for fully saturated material until they were high enough above sea level to consolidate and permit spreading and leveling. The perimeter would be protected by continuous steel sheet piling, or by the construction of granite rip-rap, granite cobble and reinforced concrete armour.

Another technique would be to construct, on the perimeter, a rubble-mound breakwater using large granite rock and cobble. The inside of the breakwater cofferdam would be filled with dredged sand overburden material. Geotextile fabric placed on the inside slopes of the breakwater would contain the sand, and permit consolidation.

The estimate included in this report is based on island construction, using the average of the costs of the two techniques described above.

A technique which may offer the most potential for savings and economy of time is that of building all of the plant and support facilities, factory style, at land-side, and "sea-lifting" complete assemblies to the site. This concept has been around since the 1950's when refinery units were built in yards at Houston and shipped to Guatemala on commercial freighters. More recently, this concept, using barges on which oil refinery modules were assembled, was employed in the oil fields of Alaska's North Slope. This project could utilize this technology to advantage. All of the beneficiation plant process modules, support facility structures and wharfs would be constructed on the pre-stressed concrete "honeycomb" sandwich cell-type floating platforms. The platforms would be towed offshore to the plant site and grounded on the prepared sea floor. The advantage of precasting and segmental construction on-shore offers the opportunity for achieving high quality, economy, and speed. An additional feature of this construction is that it is likely to result in the least disruption of the marine environment. The honeycomb pattern lends itself to compartmentalization and can provide separate compartments for storage of different liquids.

Ocean-going vessel berthing will be accommodated by facilities located along the full length of one side of the island. Alongside and adjacent to the berths, a walled-in wet rock concentrate storage pile will be located. The wet rock storage capacity is based on the assumption that weather conditions occur to prevent vessels from arriving and berthing for loading a maximum period of 10 consecutive days. It is also assumed that an additional period of up to 5 consecutive days caused by mechanical breakdown, or other cause, would prevent ship loading. Ship loading would be conducted 320 days per year. Storage is provided based on production at 100% of design capacity (16,440 tonnes per day) for 15 days, or a total of 250,000 tonnes (1.9 tonnes/m³). The storage pile is contained in a concrete walled open-top structure, with a pitched floor to facilitate drainage and to collect water.

In plan, the storage structure will be 200 feet wide and about 700 feet long, with concrete walls about 30 feet high. Filled to wall height, about 250,000 tonnes of wet phosphate rock can be contained. In operation under normal conditions, concentrate would be piled an additional 15 feet to result in a trapezoidal cross-section. With this additional storage above the top of the wall, as much as 340,000 tonnes can be contained.

This storage pile will be served by combination stacker-reclaimer equipment, with a bridge spanning the total width which travels longitudinally the length of the pile. The bridge is supported by a hinged leg outside the storage wall, and a fixed leg on the wall. The bridge supports dual bucket wheel booms for reclaiming from the storage pile. The bridge also supports a tripper car, stacker belt, and chute. A belt conveyor from the beneficiation plant feeds the inflow cross belt via a tripper car. The cross belt at the back of the bridge's main girder loads the stack via a chute. The reclaiming bucket wheels feed a conveyor system which, in turn, feeds a ship loader with the capability of loading vessels at the rate of 3000-3500 tph. The linear movements of the bridge type stacker/reclaimer, and its operating conditions, make automatic operation possible. The dual function of stacking and reclaiming are accomplished with the same traveling bridge mounted equipment. A trough, into which reclaimed material is collected for feeding the ship loader, permits reclaiming and ship loading. The bridge is about 260 feet long, spanning the storage pile and feeder trough (about 200 feet). The ship loader, with a cantilevered section extending out over the mooring berth, moves along the length of the dock to transfer and distribute concentrate for uniform loading of a vessel.

The berth, with mooring dolphins, will also permit off-loading of fuel, reagents, spare parts and other supplies required to sustain the island operation. Vessel loading and unloading can be accommodated in all but severe weather conditions, when vessels will be required to stand-off, under power, and/or at anchor until conditions permit returning to the berth.

- 1) Primary electric service will be supplied by a 750 MCM submarine cable at 115 kv, from Tybee Island by Savannah Electric and Power Co. The jacketed 750 MCM aluminum conductor will be encased in a 6" diameter conduit and cooled by a circulating oil bath. The conduit will be laid about five feet below the sea floor. A substation on the island will reduce voltage to 2.4, 4.16, and 6.9 kv, for distribution to load centers, as required.
- 2) Desalination of sea water will produce a high quality water suitable for human consumption, and for special uses such as boiler feed make-up, and

reagent solutions. Since the beneficiation process will use sea water for disaggregation, washing and flotation, the concentrate rock will contain a higher level of chlorides. The chlorides which are external to the phosphate particles may be removed by filtering and two-stage counter-current washing with fresh water. Concentrate product washing by this process will require about 115 gallons of fresh water (desalinated to 150 ppm Cl⁻) per tonne of concentrate. Total fresh water required is estimated to be about 2,000,000 gpd. Desalination by state-of-the-art reverse osmosis HydroFuge units designed by World Water Treatment, Inc. of Concord, CA, is proposed. Each HydroFuge unit will produce approximately 300,000 gpd of fresh water (Cl⁻ content less than 150 ppm) from 1,000,000 gpd of sea water containing about 35,000 ppm TDS, and 20,000 ppm Cl⁻. Six units are required to produce 2,140,000 gpd (1440 gpm). Eight units are provided; one for service during maintenance shutdown cycles and one as a standby to augment supply, if necessary. The HydroFuge R/O system and appurtenances is housed in a 10,000 ft² building. Raw water pumps capable of 6,000,000 gpd (4,200 gpm) are required to feed the R/O modules. Brackish water recovered after countercurrent filter-washing to de-salt concentrate is retained to supplement sea water make-up required for the beneficiation process. The enriched brine from the R/O system is returned to the sea. In addition, a fresh water ground storage tank of about 1,000,000 gallons capacity will be provided, (75' dia. x 30' side water depth.) The balance of the water supply system is the same as for any land side plant location.

- 3) Power outages are suffered by every user of commercially supplied power. The island location requires that minimum standby power be provided by an automatic starting diesel engine powered 60 Hz generator. Minimum power is required for lighting, heating, air-conditioning, potable and fire-fighting water systems, navigation lighting and personnel accommodations. This requirement will be met by a Caterpillar Model 3616 generator set, with automatic transfer switch, rated at 4000 kW. Fuel oil storage of 5,000 bbls in a 35' dia. x 30' high tank will be provided.
- 4) Personnel accommodations consisting of temporary housing, commissary, kitchen and dining facilities are required. Housing in dormitory type facilities will be provided for use by personnel during their two-week

tour (two 12-hour shifts, 14 days, 168 hours on three-week cycles). Housing will be sized to accommodate about 150 people. Cooking and dining facilities, including commissary with cold storage will also be designed to feed 150-160 people, 3 meals per day.

- 5) A motor launch will be provided to transport personnel and supplies from the island to the location of the turning basin in Port of Savannah. The launch will be seaworthy in all but severe weather conditions and capable of making ± 30 knots so that a one-way trip takes no longer than one hour.

Matrix is pumped through a trailing pipeline terminating at the distribution head of the washer on the island. The matrix/slurry transportation pipeline is lengthened as mining progresses.

The two dredges are self-contained and, to a great extent, are self-sustaining. They require no direct service link to the island, or to land-side facilities, other than for re-supply and to transport workers. One ocean-going tugboat is assigned to service the mining operation. This tug is equipped with a rotating lift crane suited to at-sea maintenance and repair work. The tug moves and positions pipelines and the overburden waste discharge barge as mining progresses. This tugboat is also used to move the dredges to port for annual drydock maintenance and repairs.

All offshore operations will be based on work crew cycles of two weeks duty and one week off. This requires three completely staffed crews of operating, maintenance and supervisory personnel. While on duty, offshore personnel work 14 twelve-hour shifts, for a total of 168 hours each three week cycle. The wages for this work schedule is based on 40 hours per week, three weeks, 120 hours at regular time, and 48 hours at premium time. All meals and sleeping accommodations are provided by the enterprise at no cost to employees.

Accommodations, consisting of two-bed cabins, each complete with lavatory and shower, clothes lockers and desks are provided. Each offshore operating location contains its own accommodations. A fully-equipped kitchen,

provisioned commissary and staff will prepare and serve three meals each day in a dining room. Library, television, and indoor activity rooms will be provided. Physical exercise and conditioning facilities, both indoor and outdoor, will also be provided.

The island facilities will include a first-aid station, with a nurse, to attend to minor maladies and injuries. A heliport will enable the rapid evacuation of seriously sick, or injured, persons to mainland hospitals.

The configuration described above offers the opportunity to realize the commercialization of offshore mining. Mined matrix is delivered to a nearby beneficiation plant where it is upgraded to produce a commercial grade phosphate rock concentrate product. The wet beneficiation process uses sea water, except for final filter-rinsing with desalinated sea water to remove encrusted salt. The final product is loaded on commercial ocean-going transport vessels from an outdoor storage yard, by high capacity reclaimer and ship loader. The dock permits vessel loading of concentrate and vessel unloading of fuels, reagents, supplies, and other dry good commodities required to sustain operations. Utilization of the invested capital is maximized as the mining and beneficiation processes will continue to operate in all but hurricane weather conditions.

The final product is not calcined. Previous work by others, Zellars-Williams 1979, and DPRA 1987, considered calcination as a part of the beneficiation process. These reports indicate that grade is improved by about two BPL percentage points by calcination. No test work has been conducted to support this grade improvement. This report concludes that the benefit gained, solely that of improving P_2O_5 grade, does not justify the expense incurred. Cash operating costs of calcination, as reported by Zellars-Williams 1979, adjusted to 1987, and DPRA 1987, vary from \$2.78 to \$3.22 per tonne. Return on the invested capital required for calcination adds \$2.50 to \$3.00 per tonne. The premium on penalty for each BPL grade percentage point is on the order of \$0.70-\$0.90.

The viability of this enterprise does not depend on producing 68 BPL phosphate rock concentrate. Many commercial chemical fertilizer plants use 66 BPL and lower grades for feed to manufacture phosphoric acid and diammonium phosphate (DAP). The supply demand forces of the world market, and particularly the requirements of chemical fertilizer producers within freight cost-effective shipping distances, will dictate viability.

The objective of the configuration selected for this economic feasibility evaluation is to produce a commercially marketable product at the least cost. Implementation economics will be satisfied when the demand for 4.8 million tonnes of 66 BPL phosphate concentrate becomes a reality.

5.5 ESTIMATED CAPITAL COST

This section deals with the expenditures required to implement a phosphate mining-beneficiation operation having the configuration and features previously described. Estimated cost is based on conceptual and schematic designs, and is order-of-magnitude having an accuracy of plus or minus 25%.

5.5.1 Capital Cost

Estimated capital cost has been prepared by a combination of generally accepted methodology. Island construction cost for building a 15-acre island by conventional civil-marine construction techniques has been prepared by preparing a survey of the quantities of the various work items and estimating the cost of each on an individual basis. Island construction cost includes all of the features required of an isolated offshore facility which would not be required of a conventional mainland site. The cost of island construction includes a ship loading dock as an integral part since no channel dredging is required. Table 5-16, Island Construction Cost Estimate, is a summary of cost by item for all the features included.

Beneficiation plant cost has been estimated for each production section; i.e., washer, feed preparation, flotation, reagents, water recirculation and waste disposal, product rinsing, wet rock storage, and support facilities, by

Table 5-16
Phosphate Mining Enterprise
Cost Estimate - Island Construction

<u>Item</u>	<u>\$X1,000</u>
Mobilization	\$ 350
Surveying	75
Navigation markers	30
Perimeter armor wall	7,500
Dredged fill	11,100
Vessel berth and dock	3,000
Mooring dolphins	250
Navigation aids	150
Submarine electric power service	12,500
Potable water plant and storage	150
Communications systems	100
Motor launch	500
Living accommodations	1,080
Kitchen, dining and recreation facilities	625
Standby generator 5000 kW	1,000
Fuel storage, 5000 bbl	<u>125</u>
 Total	 <u><u>\$ 38,535</u></u>

factoring techniques. Recorded costs of similar plants were compared by production process section for flowsheet applicability, adjusted for throughput or product capacity, and modified for specific dissimilarities. The resulting cost, reflecting the proposed capacity, was adjusted by applying the Engineering News Record (ENR) Construction Cost Index and the Chemical Engineering (CE) Plant Cost Index to determine current (May 1988) cost.

The procedure is to compare the process flowsheets and/or equipment requirements of the proposed plant section with that of a comparable plant section for which cost is known. The known cost estimate is modified to omit items not required of the proposed plant. Cost is adjusted for throughput (annual tonnes of matrix), or for product (annual tonnes of wet rock concentrate) by the ratio of these raised to the 0.7 power. This cost is modified for additions to the plant section, if required, of the proposed plant section. Current cost is determined by applying a multiplier. The multiplier reflects the difference in cost between the date of the known cost and May 1988 by a ratio of the average of ENR and CE indices. No attempt has been made to prepare an itemized equipment list for the beneficiation plant.

Dredge costs have been estimated by preparing a conceptual design with a general description of the principal components. Each dredge is a complete self-sustaining unit designed to remain at sea in all weather conditions. The principal machinery, equipment and structural components are identified, sized, and the weight of each estimated. Cost is the summation of the individual cost of the components. Table 5-17, Dredge Cost Estimate, is a summary of cost by item for each component. The design and construction of the dredges would be undertaken by one of several U.S. manufacturers as a result of a controlled procedure of design/construct competitive bidding. For purposes of this study, the cost of the two dredges is identical, whereas in the case of actual implementation, this may not be true. Dredge cost includes startup, acceptance testing, and commissioning.

The cost of special features and other items is estimated as the result of research of in-house data and telephone conversations with manufacturers, vendors, suppliers and other various experts.

Table 5-17

Dredge Cost Estimate

	<u>Weight Short Tons</u>	<u>Cost \$X1000</u>
<u>Hull-platform</u> (90' x 400' or 100' x 360')	3,000	\$ 9,000
<u>Upper Deck House</u> 9,200 ft ² houses bridge, operations, personnel accommodations, kitchen, dining, etc., including furnishings	235	920
<u>Lower Deck House</u> 8,000 ft ² house switchgear, generators, deck pump, other machinery	200	480
<u>Heliport</u> 40' x 40', aft overhung	200	700
<u>Fabricated Steel Components</u> Ladder, ladder superstructure, 8 spuds, spud carriages, etc.	2,450	12,240
<u>Machinery</u> Dredge pumps, cutterhead, motors, speed transmission, generators, hydraulic systems, winches, hoists, etc.	610	7,240
<u>Switchgear</u> Electric controls and wiring	10	850
<u>Navigation and Weather Equipment</u> Radar positioning gear and weather station	3	150
<u>Mass Flow Meter</u> (Production meter) meters, recorders, instrumentation	5	200
<u>Communications</u> VHF, AM-FM, TV, radio telephone	2	150
<u>Heating, Ventilating and Air-conditioning</u> Upper and lower deck houses	10	200
<u>Spud Hoist and Carriage System</u> Instrumentation and controls	1	150
<u>Tools, Specialty Maintenance</u> Equipment and Supplies	15	250

Table 5-17 (continued)

	<u>Weight Short Tons</u>	<u>Cost \$X1000</u>
<u>Protective Coatings and Cathodic Protection</u>	1	750
<u>Engineering</u> Preliminary engineering, modeling, design engineering and detailed engineering fabrication		1,500
<u>Other</u>		
Undefined development expense		500
<u>Transportation</u> Shipyard to site by sea		180
<u>Commissioning</u> Startup, operating training and performance testing		<u>2,000</u>
Total Estimated Cost		<u>\$ 37,460</u>
Fuel, supplies, and personnel	<u>1,808</u>	
Total Estimated Weight	<u>8,550</u>	

Table 5-18, Phosphate Mining Enterprise Total Facility Capital Cost Estimate, is a summary of the total capital cost required to construct the offshore phosphate mining facilities described in this section. Fifteen percent is included as an allowance for costs which will be incurred for items not now predicted. Total capital costs include design, engineering, procurement, and construction management services as are applicable to each item.

5.5.2 Pre-production Cost

Pre-production cost in the amount of 10 million dollars is included as a part of the total investment required to implement the proposed enterprise mining scheme. This cost is intended to include the extensive drilling, sampling, and testing programs required to accurately identify the areal extent and grade-quality characteristics of the Middle Miocene targeted for exploitation. This cost is also intended to include the cost of limited studies required to obtain permits. This program would include exploratory drilling to the extent required to describe and define economically mineable reserves, based on the most effective beneficiation process flowsheet developed by the test work. This program includes the cost of bulk sample collection and a pilot plant test program to verify and refine the process flowsheet, material balances, reagent and water consumption, and recovery efficiencies such as are required to provide criteria and parameters for design and detail engineering. No interest is charged for the use of this money because it is assumed that these expenditures are in the nature of the regular research and development costs incurred by enterprises engaged in commercial minerals exploitation. Payback of pre-production/development cost is, however, included as a part of the total investment required by the enterprise.

The importance of environmental considerations and the related concerns of marine fisheries and others are not to be underestimated. The pre-production cost described herein does not include the cost of comprehensive environmental studies, or the preparation of an EA or EIS. It is unlikely that the private sector alone would undertake these kinds of studies without substantial incentive. Estimating the cost of such studies is beyond the scope of this report.

Table 5-18
Phosphate Mining Enterprise - Total Facility

Capital Cost Estimate
 (4.8 x 10⁶ tonnes/year product)

<u>Item</u>	<u>Cost</u> <u>\$X1000</u>
Island Construction	\$ 42,400
Overburden and Matrix Dredges	74,920
Trailing Pipelines	4,405
Overburden Water Barge and Tremie	1,210
Tugboats (2)	5,000
Washer Section	3,289
Feed Preparation Section	19,389
Flotation Section	26,565
Reagents Storage and Supply Section	2,240
Water Recirculation and Waste	18,471
Desalination and Water Storage	7,073
Desalt Rinsing Section	1,500
Wet Rock Storage	10,909
Stacker Reclaimer Shiploader	15,000
Buildings, Warehouse and Support Facilities	<u>11,098</u>
 Totals	 \$ 243,469
 Contingency - 15%	 <u>36,521</u>
 TOTAL	 <u><u>\$ 279,990</u></u>

This program will be conducted over a period of 24-30 months and will be followed by a comprehensive economic analysis based on the latest market supply-demand price scenarios. A list of the tasks/objectives to be accomplished during this pre-production period before design and detailed engineering is undertaken is listed below.

- o drilling
- o sampling
- o geologic database update
- o bench scale test work
- o economic cutoffs applied
- o reserves estimates
- o bulk sampling
- o pilot scale test program
- o fresh water rinse tests
- o acidulation test work to determine amenability of concentrate to acidulation of fertilizer manufacture
- o preliminary mine plan
- o preliminary design of dredges and ancillaries
- o island construction engineering alternatives evaluated
- o environmental issues identified
- o cost and likelihood of permitting estimated
- o lease and royalty fees/costs established
- o capital cost estimates
- o implementation plan and schedule
- o supply-demand and market scenarios
- o identify potential market
- o current product selling price
- o bankable document report.

The decision to move forward to implementation by contracting for detailed engineering, procurement, and construction can be taken with a high degree of confidence in the reliability of the economic analysis. Technological and economic risks will have been reduced to an acceptable level. If the economics are favorable and the market supports sales price and demand premises, the final phase of implementation can be initiated.

5.5.3 Replacement Capital

The employment of capital to replace equipment when its useful life has expired is replacement capital. Useful life is based on the concept that the level of maintenance is as required to keep the equipment (facilities) operational at an acceptable level of production. Useful or economic life is the period (time in years) until the failure rate increases to such an extent that it is no longer economical to operate.

The proposed mine-beneficiation complex operation and production is based on certain mechanical availability. This level of mechanical availability is the result of regular and scheduled shut-down maintenance. This maintenance for parts, supplies, and labor, in the amount of \$12,000,000 per year, is included in operating cost.

The severe service and adverse climatic environment requires a high level of regular and preventive maintenance. During one month of the year when all facilities are shut down while the dredges are in dry-dock, certain capital will be employed to sustain the equipment and facilities at design production capability. The additional sum of one million dollars per year is allowed as replacement capital. It is anticipated that this will maintain facilities at design level for a period of 30 years, without requiring the employment of additional replacement capital. The only exception is in the event technologically superior replacement equipment is warranted as justified by the economics of increased production.

5.5.4 Working Capital

- o Ordinary operation of a business involves a circulation of capital within the current asset (capital cost) group. Cash is expended for materials (parts, supplies, expendibles), labor and services (electric energy, rental, fees, royalty, ...) and these expenditures are accumulated as costs. These costs are converted (wet rock inventory stock pile) into receivables and ultimately (back out by shipment) into cash again.

- o The average time intervening between the acquisition of materials or services and expenditure for labor entering this process and final cash realization constitutes an operating cycle.
- o The amount of capital committed (taken out of current funds or borrowed) to this cycle is working capital.
- o Cost of working capital (interest) is added.

To simplify economic analysis, the working capital requirement for this enterprise is estimated to be \$3.6 million, which is equal to the total production cost of 250,000 tonnes of phosphate rock concentrate for a period of 75 days (15 days supply in storage, plus 60 days for collecting receivables). To simplify economic analysis, working capital of \$3,600,000 is used throughout and recovered in the last year.

5.5.5 Comparable Capital Cost Estimates

Previous studies of the potential feasibility for commercial exploitation of offshore U.S. Atlantic coast phosphorites have produced capital cost estimates of the investment required.

ZW (1979) and DPRA (1987), each reported capital costs for development of phosphate mining and beneficiation facilities. The cost estimated for each of those studies envisaged offshore mining, on-board scalping/washing and partial desliming, transport of this intermediate product to land, beneficiation and product load-out from a central land-based complex.

The two estimates cover very similar methods of handling and processing matrix and the treatment of beneficiated concentrate. Each estimate has been adjusted for annual volume throughput, product output, and indexed to a comparable economic cost basis. Table 5-19 is a display of costs for annual finished product capacity of 4.8 million tonnes, comparable to the cost estimated for this study.

The table shows reasonable agreement, except for sea transportation cost. If this cost is equalized for the two estimates at the higher cost, the variance between the two estimates is within 5% for wet rock facility cost, and 14% for total facility cost.

Table 5-19

**Comparable Capital Cost Estimates from Previous Studies
Adjusted for Capacity and Cost Index**
(approximately 4.8 million tonnes product)

<u>Item</u>	<u>\$ X 1,000</u>		<u>Equalize to DPRA</u>
	<u>DPRA</u>	<u>Z-W</u>	
Dredge	\$ 36,660	\$ 31,340	--
Scalping/Washer (on-board)	6,240	3,290	--
Feed Preparation (land-based)	15,080	19,390	--
Flotation Plant	13,280	26,570	--
Reagents Section	--	2,240	--
Water Supply, Recirculation and Waste	22,770	18,470	--
Infrastructure	26,220	--	--
Off-sites	--	14,040	--
Sea Transportation	232,950	51,460	181,490
Unloading Rock	25,750	--	--
Wet Rock Storage	--	14,230	--
	<u>\$378,950</u>	<u>\$181,030</u>	<u>\$362,520</u>
Contingency	<u>37,900</u>	<u>18,100</u>	<u>36,250</u>
Total Wet Rock Facility	\$416,850	\$199,130	\$398,770
Calcination*	\$110,890*	\$ 68,620	--
Contingency	<u>11,090</u>	<u>6,860</u>	--
Total Calcination*	<u>\$121,980*</u>	<u>\$ 75,480</u>	--
Total Facility	<u><u>\$538,830</u></u>	<u><u>\$274,610</u></u>	<u><u>\$474,252</u></u>

* includes product storage/handling

NOTE: DPRA (1987) and ZW (1979) costs adjusted by ENR Construction Cost Index to 1988, and factored for through-put and production output to ZW (1988) study basis.

This discussion is not intended to be a critique of previous estimates, but is included here as a basis for comparison. Such variance is to be expected from estimates based on conceptual designs and preliminary definition of conditions.

The total costs estimated, at different times, by each of two investigators, are for comparable configurations providing conventional facilities at landside locations. The total wet rock facility cost of about \$400 million is comparable to the proposed totally offshore facilities' configurations estimated cost of \$280 million.

5.6 ESTIMATED OPERATING COST

In view of the uncertainties in geology and production configuration, a detailed operating cost breakdown is not indicated. Zellars-Williams has compiled cost information on phosphate plants for many years and developed a relationship of costs to production for different geological and operating conditions. These relationships are broken down into operating modules and compiled in a computer model. This computer model has been used extensively in projects such as the World Phosphate Study 85, and the Assessment of Alternative Technology Study, for the Florida Institute of Phosphate Research (FIPR), as well as for evaluating performance of numerous operating mines.

Three cost modules specific to the offshore mining configuration were developed to make the cost model applicable to most of the operations. Cost of transportation and accommodations for personnel, and for product rinsing were estimated separately. All ZW operating cost models are based on short tons. Conversion to metric tons is performed for economic analysis. The expression **ton** in this report is for 2000 lbs. The expression **tonne** is for 2205 lbs. A copy of the cost model computer printout (pages 1 through 9 of 9) is included at the end of this section. The modules applicable to offshore Georgia are described in the following text.

Labor Costs

Labor costs are based on hours consumed for actual production functions. To this, a factor of 26% is added to allow for extra men, foremen, supervisors, and managers. The factors for each division follow:

Additional men	5%
Foremen	16%
Supervisors	3%
Managers	2%
Total	<u>26%</u>

The average rate used for labor is \$17.14 per hour, and includes overtime and fringe benefits.

The basis of this average rate is as follows:

Average hourly wage	\$ 12.00
Burden, including fringes	<u>3.00</u>
Total Average Hourly Rate	\$ 15.00
Premium Average Hourly Rate	\$ 22.50
Work Cycle each 3 week period:	
120 hours @ \$15.00 =	\$1,800.00
<u>48 hours @ \$22.50 =</u>	<u>1,080.00</u>
168 hours =	\$2,880.00

Average hourly wage: $\frac{\$2,880}{168 \text{ hr.}} = \$17.14/\text{hour}$

Administrative Costs

A figure of \$1.30 was used. This includes clerical, engineering support, planning, accounting, personnel, payroll, safety, legal, and all other local administrative, technical, and laboratory services. This does not include sales expense, taxes, insurance, exploration drilling, depletion, depreciation, or amortization.

Unit Costs

Unit cost for utilities, reagents, and other items are given on page 1 of the computer printout.

Estimated operating costs taken from the cost model, rounded and converted to metric units are given in Table 5-20. Indirect and offshore costs are individually estimated by other techniques. This is the basis of economic analysis.

The control units are the factors upon which the consumption factors are based. The consumption factors for each module are listed below.

Slurry Pumping of Matrix

This module covers the cost of pumping matrix slurry from the slurry well (pit) at the mine cut near the dragline to the washer, the first production unit in the beneficiation plant. Cost includes all the slurry pumps, pipeline, electric power supply, switchgear, control systems, and all appurtenances required for the matrix pumping system. All components are skid mounted. Cost includes seal water supply systems. Pit pump operation is included except for moving cost, which is a part of hydraulic monitor cost. Cost developed by this module is a function of distance based on transporting 1,000 tph of matrix (dry basis) at 30% solids average (by weight) and a pipeline velocity of 15 fps.

The model for this study is modified to cover the slurry density, pipeline size and lengths, and total system head conditions applicable to the offshore mining configuration described.

COST UNIT: Dry ton-miles matrix

UNIT CONSUMPTION:

Fuel	0.0866 gal.
Operating labor	.00046 manhours
Operating supplies	\$.00197
Maintenance labor	.00046 manhours
Maintenance supplies	\$.01194

Table 5-20
Operating Cost
4.8 million tonnes/year

Direct Cost

<u>Unit Operation/Item</u>	<u>\$/tonne product</u> (wet rock, dry basis)	
<u>Mining</u>		
Overburden dredge and disposal	1.60	
Matrix dredge	1.50	
Matrix pumping	<u>1.30</u>	4.40
<u>Beneficiation</u>		
Washer	1.10	
Feed preparation	0.85	
Flotation	3.03	
In-process storage	0.20	
Hydraulic station	<u>0.22</u>	5.40
<u>Waste Disposal/Water Reclamation</u>		
Tailing waste	0.60	
Slimes waste	0.51	
Make-up water	<u>0.04</u>	1.15
<u>Product Management</u>		
Rinsing and conveying	0.30	
Handling and storage	0.25	
Load-out	<u>0.25</u>	0.80
Supervisor, clerical and technical support		1.40
Offshore accommodations (personnel live and travel)		<u>0.45</u>
Direct Cost		\$13.60
<u>Indirect Cost</u>		
Administration	0.20	0.20
Sales expense	0.25	0.25
Royalty @ 5% of sales price (\$35 & \$42)	1.75	to 2.10
Taxes (ad valorem, etc.)	0.20	0.20
Other (not specifically identified)	<u>0.25</u>	<u>0.25</u>
Indirect Cost	\$ 2.65	\$ 3.00
Total Operating Cost:		
(@ \$35 sales price)	\$16.25	
(@ \$42 sales price)		\$16.60

Washer

This module consists of ore disaggregation, and separation and washing of pebble. A common washer includes a trommel, static screens, vibrating screens, and log washers. Battery limits are from the matrix pumping system discharge to the feed distributor for the primary cyclones and the pebble transfer conveyor.

COST UNIT: Tons matrix

UNIT CONSUMPTION:

Electricity	2.25 KWH
Operating labor	.00195 manhours
Operating supplies	\$.001
Maintenance labor	.00199 manhours
Maintenance supplies	\$0.05114

Feed Preparation

This module represents two stages of desliming and includes feed sizing and in-process storage of feed. Battery limits are from primary desliming cyclone feed distributor to the flotation feed dewatering or conditioning.

COST UNIT: Tons Flotation Feed

UNIT CONSUMPTION:

Electricity	3.00 KWH
Operating Labor	.00148 manhours
Operating Supplies	\$.00076
Maintenance labor	.00151 manhours
Maintenance supplies	\$0.03881

Flotation

This module includes anionic rougher flotation for two size fractions, deoiling, and cationic cleaner flotation. Battery limits are from discharge of flotation feed prep to the tails discharge point and the flotation concentrate discharge point.

COST UNIT: Ton Flotation Feed**UNIT CONSUMPTION:**

Electricity	3.50 KWH
Operating labor	.00594 manhours
Operating supplies	\$.00305
Maintenance labor	.00606 manhours
Maintenance supplies	\$0.15577

Reagents:

Fatty Acid	1.0 lb
Fuel Oil	1.25 lb
NaOH/NH ₃	.4 lb
H ₂ SO ₄	1.3 lb
Amines	.17 lb
Kerosene	.1 lb

In-Process Storage (Product Bins)

This module is for wet bin storage and retrieval of product. Battery limits are between product discharge from the washer and flotation plant to the product conveyor.

COST UNIT: Tons Product (as derived from flotation feed tons)**UNIT CONSUMPTION:**

Electricity	.18 KWH
Operating labor	.00074 manhours
Operating supplies	\$.00030
Maintenance labor	.00075 manhours
Maintenance supplies	\$0.1941

Hydraulic Station

This module is for operation of a plant hydraulic station. Battery limits are from the water collection points of recycled water from other modules, to the make-up water supply points in other modules.

COST UNIT: 1,000,000 gallons**UNIT CONSUMPTION;**

Electricity	700 KWH
Operating labor	.30140 manhours

Operating supplies	\$.15498
Maintenance labor	.30743 manhours
Maintenance supplies	\$7.90

Slurry Pumping of Tailings

This module is for hydraulic transport of tailings as a function of pumping distance to the disposal site. Tails are fed directly from the flotation plant. Battery limits are from the tails slurry pump to discharge from the tails pipeline at the sand-clay mix tank thickener.

COST UNIT: Ton-Miles Tailings

UNIT CONSUMPTION:

Electricity	.76 KWH
Operating labor	.00046 manhours
Operating supplies	\$.00197
Maintenance labor	.00046 manhours
Maintenance supplies	\$.01194
Replacement pipe	\$.0015/ft.

Slurry Pumping of Slimes

This module accounts for hydraulic transport of slimes as a function of distance to the disposal site. No credit is implicit in this module for gravity flow. Therefore, unit consumptions should be estimated on the basis of actual pumping distance. Battery limits are from the high grade sand-clay mix thickener to the end of the waste pipe discharge in mined-out cuts.

COST UNIT: Ton-Miles Slimes

UNIT CONSUMPTION:

Electricity	1.15 KWH
Operating labor	.00141 manhours
Operating supplies	\$.00604
Maintenance Labor	.00142 manhours
Maintenance supplies	\$.03661
Pipe replacement	\$.00016/ft.

Make-up Water

This module accounts for fresh water pumped from deep wells as the source supply to make up for system losses. The basis is 7,500 gpm pumped a distance of one mile from a water level of 150 feet below the center line of discharge. The battery limits are from the deep aquifer water level surface to the hydraulic station. For the offshore situation this module is used for the cost of pumping sea water.

COST UNIT: 1,000,000 gallons

UNIT CONSUMPTION:

Electricity	850 KWH
Operating labor	.301 manhours
Operating supplies	\$.51591
Maintenance labor	.30501 manhours
Maintenance supplies	\$7.82

Conveyor

This module accounts for transportation by conveyor belt a distance of 600 feet with a 50-foot rise in elevation. The battery limits are from the product bin discharges to the conveyor belt discharge above the stockpiles.

COST UNITS: Tons of Product

UNIT CONSUMPTION:

Electricity	.05 KWH
Operating labor	.00011 manhours
Operating supplies	\$.0023
Maintenance labor	.00011 manhours
Maintenance supplies	\$.00286

Storage

This module accounts for open pile storage of phosphate pebble and concentrate. Stacker and reclaimer factors are included. Battery limits are from the end of the transportation conveyor to the storage pile by stacker or tripper.

COST UNIT: Ton Product

UNIT CONSUMPTION:

Electricity	.22 KWH
Operating labor	.00351 manhours
Operating supplies	\$.02166
Maintenance labor	.00355 manhours
Maintenance supplies	\$.09114

Loadout

This module covers getting product from storage to the rail car. Battery limits are from the reclaimer which retrieves material from the wet rock pile to placement into the rail car. In this case, cost is for loading ocean-going vessels.

COST UNIT: Ton Product

UNIT CONSUMPTION:

Electricity	.20 KWH
Operating labor	.00351 manhours
Operating supplies	\$.01203
Maintenance labor	.00355 manhours
Maintenance supplies	\$.09114

Offshore Dredge Mining Cost Modules

Three unique models were added for offshore Georgia. These are: dredge mining overburden, dredge mining matrix, and barge transportation. These modules are described below:

Dredge Mining Overburden

This module covers the cost of mining overburden and pumping it to nearby mine cuts. It is keyed-off of a dredge program for cost inputs. For the selected system, the unit consumptions follow.

COST UNIT: Cubic yards overburden

UNIT CONSUMPTION:

Fuel	.09798 gallons
Operating labor	.00489 manhours
Operating supplies	\$.01245
Maintenance labor	.00153 manhours
Maintenance supplies	\$.061

Dredge Mining Matrix

This module covers the cost of mining matrix and pumping it to the surface. From here the matrix pumping module takes over. This module is keyed off the dredge program for cost inputs. For the selected system, the unit consumptions follow.

COST UNIT: Cubic yards matrix

UNIT CONSUMPTION:

Fuel	.11286 gallons
Operating labor	.00796 manhours
Operating supplies	\$.02028
Maintenance labor	.00248 manhours
Maintenance supplies	\$.09936

Barge Transportation System

For configuration 2, barges were used to transport matrix from the dredge to the onshore plant, and transport waste back to the ocean disposal site. Loading and unloading costs are included in this module.

COST UNIT: Cubic yards matrix

UNIT CONSUMPTION:

Fuel	.2568 gallons
Operating labor	.0103 manhours
Operating supplies	\$.00722
Maintenance labor	.0088 manhours
Maintenance supplies	\$.05169

5.7 ECONOMICS AND VIABILITY

5.7.1 Phosphate Market Evaluation

The United States, the leading world producer of phosphate fertilizers, supplies about 30% of world consumption. The long-established dominance of U.S. phosphate fertilizer producers in export markets, mainly from Florida and North Carolina, has been successfully challenged by the state-controlled phosphate producers of North Africa and the Middle East. The erosion of U.S. producers' share of total world markets by these state-controlled producers became evident as domestic consumption peaked in 1980-81, and since contracted. Global P_2O_5 fertilizer consumption appears to have levelled off and most forecasters suggest future growth at no more than 2-3% per year.

The U.S. phosphate rock industry capacity has grown from about 12 million tonnes per year in the 1950's to nearly 63 million tonnes per year in the 1980's. In the 1950's, U.S. production represented 50% of world-wide production. Today, U.S. production is only about 30% of world production.

The mature market demands of the U.S. agricultural sector for phosphate fertilizers are being met by domestic mines and rock producers, with minor exceptions. This demand accounts for about 19 million tonnes of phosphate rock (6 million P_2O_5 tonnes). Morocco's OCP, from its Bou-Craa mine, is supplying a Gulf Coast U.S. fertilizer manufacturer with about 1 million tonnes of phosphate rock (370,000 P_2O_5 tonnes). This rock is shipped after drying by OCP, but before washing to remove the salt water residue which results from beneficiation in sea water. Fresh water rinsing is accomplished at the site before the rock is fed to the chemical plant.

Current U.S. phosphate rock production is about 40 million tonnes per year (12.5 million P_2O_5 tonnes), or 64% of capacity. Future demand and market scenarios which drive the industry are unlikely to require or justify any significant increase in this production. Meanwhile, however, exhaustion of economic reserves in areas being mined by present facilities will require that U.S. industry, mainly in Florida and North Carolina, invest in new

replacement mines and beneficiation plants. Some estimates indicate that as much as 30 million tonnes of new (replacement) capacity will be required between the years 1990 and 2005.

Total phosphate trade in P₂O₅ tonnes (including rock, acids and fertilizer products) is projected in the following table.

Total Phosphate Trade

	<u>1975</u>	<u>1980</u>	<u>1985</u>	<u>1990</u>	<u>1995</u>	<u>2000</u>
World (million tonnes P ₂ O ₅)	20.1	27.8	26.5	26.3	30.3	31.1
U.S. (million tonnes P ₂ O ₅)	5.6	8.7	8.1	7.7	8.1	7.5
U.S. world share	28%	31%	30%	29%	27%	24%

The U.S. has adequate capacity in-place to supply this projected trade through 1996. A short-fall will be created if replacement costs (new mines and expansion of existing) cannot result in operations which yield favorable economic return.

Assuming stable markets and no significant new investment in new or replacement capacity, a short-fall in U.S. production of acid-grade phosphate rock as indicated in the following table is predicted.

Million Tonnes of Rock

1997 - 1.8	2002 - 12.2	2007 - 21.8
1998 - 1.5	2003 - 13.2	2008 - 29.0
1999 - 2.4	2004 - 15.0	2009 - 30.3
2000 - 8.3	2005 - 15.0	2010 - 30.3
2001 - 12.2	2006 - 15.0	

This scenario would indicate, if present capacity is not replaced, that a market would be created in the year 2000 to support an alternative rock production scenario such as from offshore Georgia.

Acid-grade rock is that which is amenable to downstream chemical conversion, first to phosphoric acid and later to fertilizer products. Phosphate rock concentrates of grades 64-66 BPL (29-30% P₂O₅) are routinely used by captive producers as feed stock for chemical conversion. This trend will increase as supplies of high grade rock world-wide are depleted.

Whether or not replacement capacity is realized will depend on economics. Replacement capacity will require new investment at the cost, in current dollars, of \$65 to \$90 per annual tonne of capacity, or a total of \$1.95-\$2.7 billion.

The lower required investment cost range applies where existing infrastructure can be utilized. The higher cost range includes some additional or new infrastructure. Higher costs will be incurred if totally new infrastructure is required.

Current and near-term future production costs of Florida producers operating existing mines and beneficiation plants provide one rational basis of comparison for any alternative domestic-sourced production. (See Table 5-21). This table shows direct cash cost of production and indirect costs for taxes, sales expense (Phosphate Rock Export Association) and insurance, plus items which account for the cost of money (interest), a minimum return on capital invested for physical improvements (amortization), and reserves (depletion).

To complete the comparison, the cost of handling, drying, transporting, and ship loading must be added to the FOB mine cost. These costs, common to both present and near-term future mines, consist of the following items.

Dollars Per Short Ton (Dry Basis)

Freight to Port	\$3.40
Unload to Storage	.20
Drying (at port)	1.75
Port Storage	.65
(port charge)	
Vessel Loading	<u>2.20</u>
Total	\$8.20

Table 5-21

Cost of Production

Dollars Per Short Ton (dry basis)

	<u>Current Mines</u>		<u>Near-Term Future Mines</u>	
1. Mining	\$2.45		\$ 4.24	
2. Beneficiation	3.30		5.27	
3. Waste Disposal, Land Reclamation and Water Re-use	2.44		4.53	
4. Product Management	0.46		0.46	
5. Admin., Clerical, Technical	1.30		1.30	
Cash Cost (Wet)		\$ 9.95		\$15.80
Severance	1.35		1.35	
Other taxes	0.50		0.50	
Sales exp. (Phosrock)	0.50		0.50	
Insurance	<u>0.10</u>		<u>0.10</u>	
Sub-total		2.45		2.45
* Interest on Working Capital	0.40		0.60	
** Amortization of Investment (\$65/t)	9.75	(\$90/t)	13.50	
Depletion	<u>1.00</u>		<u>1.00</u>	
Sub-total		<u>11.15</u>		<u>15.10</u>
Total Cost, Wet FOB Mine		<u>\$23.55</u>		<u>\$33.35</u>

* Cash cost of 3 months production, 20 years @ 10%

** 20 years @ 15%

If all costs and expenses are allocated and a reasonable return on investment accounted for, as indicated in Table 5-21, Florida rock producers can put phosphate rock aboard vessels at Port Tampa for between \$31.75 and \$41.55 per ton (\$35.00 and \$45.81 per tonne), over the period 1988 through about 1992.

Current selling price of 68 BPL (31% P_2O_5) phosphate rock loaded on vessels at Port Tampa is \$29.00 to \$30.00 per tonne. This pricing is in response to competitive pressure and is possible because most Florida producers have fully amortized the investments made when costs were lower, and/or are willing to sacrifice normally acceptable returns for sustained production and utilization of installed capacity.

Phosphate fertilizer producers will purchase and use 66 BPL (30.2% P_2O_5) grade rock, if the quality makes it suitable for acidulation, etc., and if the selling price is attractive. Under certain market conditions a price penalty or premium is recognized when grade is much below or above about 68 BPL. The BPL grade point penalty, when market conditions warrant it, is generally on the order of \$0.70 to \$0.90, or \$1.40 to \$1.80 per tonne for 66 BPL rock.

Table 5-22 is constructed from these projections by adding current and estimated future freight, and port handling and ship loading costs. Return on invested capital at the rate of 15% is separately added to amortize the use of money. A 20% pre-tax profit based on cost is added for a total selling price which is the minimum considered necessary to attract investment in new or replacement facilities. Based on this analysis, a case can be made for predicting the selling price of 66 BPL wet rock in the year 1996 of \$34.00 to \$36.00 per tonne, and \$42.00-\$44.00 per tonne in the year 2000.

Economic analysis, therefore, is conducted on sales price of 66 BPL wet rock at \$35.00 per tonne, based on immediate implementation to achieve the first production in the year 1996. The most favorable scenario is to start production in 1999-2000 when it is more likely that a market will exist. Economic analysis is also conducted on a sales price of \$42.00 per tonne.

A charge for royalty or minerals severance tax estimated to be computed as 5% of the sales price is included, as indicated in operating cost Table 5-20, in the economic analysis.

An underlying premise of the economics and viability of the offshore configuration proposed is that implementation and subsequent production is based on having a market. The production from this enterprise needs to be committed on a long-term basis to chemical fertilizer producer customers. Limited storage of finished product is provided on the offshore island. The customer's production of phosphatic fertilizers must be linked to a continuous supply of phosphate rock feed stock from the offshore facilities. Storage of wet rock must be provided by the customer at his plant.

Table 5-22

Cash Cost per Annual Tonne Phosphate Wet Rock

Constant 1988 Dollars

	<u>1988 - 1995</u>	<u>1996 - 2000</u>
Average Wet Rock FOB Mine	\$13.25 - 14.35	\$14.77 - 15.10
Freight, Port Storage and Ship Loading	5.35 - 6.58	6.57 - 7.90
Total Cost Aboard Vessel	18.60 - 20.93	21.34 - 23.00
15% Charge on Invested Capital	9.75	13.50
20% Pre-tax Profit	<u>6.00</u>	<u>7.00</u>
Total Selling Price	<u>\$34.35 - 36.68</u>	<u>\$41.84 - 43.50</u>

5.7.2. Economic Analysis

The discounted cash flow rate of return on investment (DCFROR) method of economic analysis is used to evaluate the viability potential of exploiting offshore Georgia phosphate as proposed in this study. DCFROR is computed using computer-driven software programs adapted to this type enterprise. The computer software calculates to determine the rate of return at which the positive and negative cash flows, when discounted to the present, equal zero. The present value of cash outflow and inflow is computed to result in the lowest possible positive and negative net present values (NPV). This procedure is repeated for differing scenarios of investment, income (sales price) and operating cost to gain an understanding of sensitivity. All economic values are based on constant 1988 dollars.

Each scenario is represented by a separate computer run computation of DCFROR and net present value (NPV). A copy of each of the computer printouts for Case I and Case II is included at the end of this section.

Extraordinary costs associated with start-up are accounted for by taking into income 2.4 million tonnes of product sales, and taking as cost the production of 4.8 million tonnes. This procedure is used in each case.

Table 5-23 is a summary of DCFROR results for base case investment and operating costs, and for two sales price and revenue scenarios. The lower sales price is based on market penetration in the year 1996. The higher price is based on making market in 1999.

Table 5-23

Case No.	Sales Price \$/tonne	Construction Capital Millions Dollars	Production Cost \$/tonne	DCFROR %
I	35	280	16.25	6.6%
II	42	280	16.60	12.2%

Table 5-24 is a summary of DCFROR results for two constant sales prices and revenue, constant production cost, and about 10% increments of change in investment.

Table 5-24

<u>Case No.</u>	<u>Sales Price</u> <u>\$/tonne</u>	<u>Construction Capital</u>		<u>Production</u> <u>Cost</u> <u>\$/tonne</u>	<u>DCFROR</u> <u>%</u>
		<u>Millions</u> <u>Dollars</u>	<u>Variance</u> <u>% +/-</u>		
I(a)	35	252	-10	16.25	8.4
I(b)	35	308	+10	16.25	5.0
II(a)	42	252	-10	16.60	14.1
II(b)	42	308	+10	16.60	10.6

Table 5-25 is a summary of DCFROR results for constant investment, two sales prices, and about 10% increments of change in production cost.

Table 5-25

<u>Case No.</u>	<u>Sales Price</u> <u>\$/tonne</u>	<u>Construction</u> <u>Capital</u> <u>Millions</u> <u>Dollars</u>	<u>Production Cost</u>		<u>DCFROR</u> <u>%</u>
			<u>Cost</u> <u>\$/tonne</u>	<u>Variance</u> <u>% +/-</u>	
I(c)	35	280	14.80	-10%	8.0
I(d)	35	280	17.70	+10%	5.1
II(c)	42	280	15.15	-10%	13.3
II(d)	42	280	18.05	+10%	11.1

PHOSPHORITE SELECTED CASE

OPERATING COSTS

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INPUT FACTORS:	ITEM	UNIT COST \$
MATRIX I	KWH	.043
TOTAL I	OPERATING LABOR MM	17.14
TONS OF PRODUCT/YEAR	DIESEL FUEL GAL.	.60
% OF SLIMES IN MATRIX I	A-FATTY ACID 0	.08
% OF PEBBLE IN MATRIX I	B-FUEL OIL 0	.071
% OF SAND TAILS IN MATRIX I	C-HADH/AMHS 0	-.075
% OF FLOT. CON. IN MATRIX I	D-H2SO4 0	-.025
MATRIX DRY DENSITY	E-AMINES 0	.24
MATRIX PUMPING DISTANCE	F-KEROSENE 0	.091
SLIMES PUMPING DISTANCE	36" PIPE MATRIX	100
TAILS PUMPING DISTANCE	42" PIPE O. B.	100
THICKNESS OF MATRIX	30" PIPE WASTE	100
MM GALLONS/YR HYDR. STA.		
MM GALLONS/YR MAKE UP		
MM CYD OVERBURDEN		
MM CYD MATRIX		
MM TONS MATRIX		
MM TONS SLIMES		
MM TONS SANDS		
MM TONS PEBBLE		
MM TONS FLOT CON		
ORE DENSITY NET		
RATIO OF CONCENTRATION		
FEET OVERBURDEN		
ACRES/YEAR		
TONS/ACRE		
ACRE FT SLIMES/YEAR		
FLOTATION RECOVERY %		
WINE RECOVERY %		
PROD. PEBBLE GRADE IBPL		
PROD. CON. GRADE IBPL		
COMP. PROD. GRADE IBPL		
FLOT FEED % BPL		

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UNIT CONSUMPTION

MILKING (WORK AREA)

MODULE	UNITS	CONSUMABLES	ELECTRICITY KWH/UNIT	OPERATING LABOR RH/UNIT	OPERATING SUPPLY \$/UNIT	MAINTENANCE LABOR RH/UNIT	MAINTENANCE SUPPLY \$/UNIT	FUEL GALLONS/UNIT	REAGENTS \$/UNIT	CONTRACT REPLACEMENT PIPE FT/UNIT
(a) OVERBURDEN DREGS	CY OVERBURDEN			.00489	.02145	.00153	.06100	.09798		
(b) MATRIX DREGS	CY MATRIX			.00796	.02028	.00248	.09936	.11786		
(c) SLURRY PUMPING MATRIX	MATRIX TONS-MILE			.00046	.00197	.00046	.01194	.0866		.00030

BENEFICIATION (WORK AREA)

MODULE	UNITS	CONSUMABLES	ELECTRICITY KWH/UNIT	OPERATING LABOR RH/UNIT	OPERATING SUPPLY \$/UNIT	MAINTENANCE LABOR RH/UNIT	MAINTENANCE SUPPLY \$/UNIT	FUEL GALLONS/UNIT	REAGENTS \$/UNIT (TON FLT FD)	CONTRACT REPLACEMENT PIPE FT/UNIT
(a) WASHER	TONS MATRIX		2.25	.00195	.00100	.00199	.05114	A-	I	
(f) FLOTATION PREP	TONS FLOT FEED		3.00	.00148	.00076	.00151	.03881	B-	1.25	
(g) FLOTATION	TONS FLOT FEED		3.50	.00594	.00305	.00606	.15377	C-	.4	
(h) IN PROCESS STORAGE	TONS FLOT FEED		.18	.00074	.00038	.00075	.01941	D-	1.3	
(i) HYDRAULIC STATION	1,000,000 GALLONS		700	.30140	.15498	.30743	7.40	E-	.17	
								F-	.1	

WASTE DISPOSAL, LAND RECLAMATION AND WATER RE-USE (WORK AREA)

MODULE	UNITS	CONSUMABLES	ELECTRICITY KWH/UNIT	OPERATING LABOR RH/UNIT	OPERATING SUPPLY \$/UNIT	MAINTENANCE LABOR RH/UNIT	MAINTENANCE SUPPLY \$/UNIT	FUEL GALLONS/UNIT	REAGENTS \$/UNIT	CONTRACT REPLACEMENT PIPE FT/UNIT
(j) SLURRY PUMPING TAILS	TAILS TON MILE		.76	.00046	.00197	.00046	.01194			.00015
(k) SLURRY PUMPING SLIMES	SLIMES TON MILE		1.15	.00141	.00604185	.00142	.03661			.00016
(l) MAKE UP WATER	1,000,000 GALLONS		850	.30100	.51591	.30401	7.82			

PRODUCT MANAGEMENT (WORK AREA)

MODULE	UNITS	CONSUMABLES	ELECTRICITY KWH/UNIT	OPERATING LABOR RH/UNIT	OPERATING SUPPLY \$/UNIT	MAINTENANCE LABOR RH/UNIT	MAINTENANCE SUPPLY \$/UNIT	FUEL GALLONS/UNIT	REAGENTS \$/UNIT	CONTRACT REPLACEMENT PIPE FT/UNIT
(m) CONVEYOR	TONS PRODUCT NET		.05	.00011	.00023	.00011	.00286			
(n) STORAGE	TONS PRODUCT		.22	.00351	.02166	.00355	.09114			
(o) LOADOUT	TONS PRODUCT		.20	.00351	.01203	.00355	.09114			

UNIT COST

MIXING (WORK AREA) COST

MODULE	UNITS	CONSUMABLES				REAGENTS				CONTRACT REPLACEMENT PIPE TOTAL			
		ELECTRICITY \$ PER UNIT	OPERATING LABOR \$ PER UNIT	OPERATING SUPPLY \$ PER UNIT	MAIN. LABOR \$ PER UNIT	FUEL \$ PER UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT	FUEL \$ PER UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT
(a) OVERBURDEN DREDGE	CY OVERBURDEN	\$.000	\$.084	\$.012	\$.026	\$.059	\$.000	\$.242	\$.000	\$.059	\$.000	\$.242	
(b) MTRIT DREDGE	CY MTRIT	\$.000	\$.136	\$.043	\$.043	\$.088	\$.000	\$.366	\$.000	\$.088	\$.000	\$.366	
(d) SLURRY PUMPING MTRIT TONS-MILE	TONS-MILE	\$.000	\$.008	\$.002	\$.008	\$.052	\$.030	\$.112	\$.012	\$.052	\$.030	\$.112	

BENEFICIATION (WORK AREA) COST

MODULE	UNITS	CONSUMABLES				REAGENTS				CONTRACT REPLACEMENT PIPE TOTAL			
		ELECTRICITY \$ PER UNIT	OPERATING LABOR \$ PER UNIT	OPERATING SUPPLY \$ PER UNIT	MAIN. LABOR \$ PER UNIT	FUEL \$ PER UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT	FUEL \$ PER UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT
(a) WASHER	TONS MTRIT	\$.101	\$.033	\$.001	\$.034	\$.051	\$.271	\$.000	\$.051	\$.000	\$.051	\$.271	
(f) FLOTATION PREP	TONS FLOAT FEED	\$.135	\$.025	\$.001	\$.026	\$.039	\$.226	\$.000	\$.039	\$.000	\$.039	\$.226	
(g) FLOTATION	TONS FLOAT FEED	\$.158	\$.102	\$.003	\$.104	\$.156	\$.803	\$.000	\$.156	\$.000	\$.156	\$.803	
(h) TH PROCESS STORAGE	TONS FLOAT FEED	\$.008	\$.013	\$.000	\$.013	\$.019	\$.054	\$.000	\$.019	\$.000	\$.019	\$.054	
(i) HYDRAULIC STATION	1,000,000 GALLONS	\$ 31.50	\$ 5.17	\$.15	\$ 5.27	\$ 7.90	\$ 49.99	\$.000	\$ 7.90	\$.000	\$ 7.90	\$ 49.99	

WASTE DISPOSAL, LAND RECLAMATION AND WATER RE-USE (WORK AREA)

MODULE	UNITS	CONSUMABLES				REAGENTS				CONTRACT REPLACEMENT PIPE TOTAL			
		ELECTRICITY \$ PER UNIT	OPERATING LABOR \$ PER UNIT	OPERATING SUPPLY \$ PER UNIT	MAIN. LABOR \$ PER UNIT	FUEL \$ PER UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT	FUEL \$ PER UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT
(j) SLURRY PUMPING TAILS	TAILS TON MILE	\$.034	\$.008	\$.002	\$.009	\$.012	\$.015	\$.079	\$.012	\$.012	\$.015	\$.079	
(k) SLURRY PUMPING SLIMES	SLIMES TON MILE	\$.052	\$.024	\$.006	\$.024	\$.037	\$.016	\$.159	\$.037	\$.016	\$.037	\$.159	
(l) MAKE UP WATER	1,000,000 GALLONS	\$ 38.250	\$ 5.159	\$.516	\$ 5.211	\$ 7.816	\$ 56.452	\$.000	\$ 7.816	\$.000	\$ 7.816	\$ 56.452	

PRODUCT MANAGEMENT (WORK AREA) COST

MODULE	UNITS	CONSUMABLES				REAGENTS				CONTRACT REPLACEMENT PIPE TOTAL			
		ELECTRICITY \$ PER UNIT	OPERATING LABOR \$ PER UNIT	OPERATING SUPPLY \$ PER UNIT	MAIN. LABOR \$ PER UNIT	FUEL \$ PER UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT	FUEL \$ PER UNIT	REAGENTS \$ PER UNIT	CONTRACT REPLACEMENT PIPE \$/UNIT
(a) CONVEYOR	TONS PRODUCT MET	\$.002	\$.002	\$.000	\$.000	\$.003	\$.009	\$.244	\$.003	\$.003	\$.000	\$.009	
(p) STORAGE	TONS PRODUCT	\$.010	\$.040	\$.022	\$.061	\$.091	\$.244	\$.000	\$.091	\$.000	\$.091	\$.244	
(q) LOADOUT	TONS PRODUCT	\$.009	\$.040	\$.012	\$.061	\$.091	\$.233	\$.000	\$.091	\$.000	\$.091	\$.233	

COSTS PER TON

MINING COST

MODULE NAME	VARIABLE	TONS OF PRODUCT PER VARIABLE	ELECTRICITY \$ PER TON PRODUCT	OPERATING LABOR \$ PER TON PRODUCT	OPERATING SUPPLY \$ PER TON PRODUCT	MAIN. LABOR \$ PER TON PRODUCT	MAIN. SUPPLIES \$ PER TON PRODUCT	FUEL \$ PER TON PRODUCT	REAGENTS \$ PER TON PRODUCT	CONTRACT \$ PER TON PRODUCT	REPL. PIPE \$ PER TON PRODUCT	TOTAL \$ PER TON PRODUCT
(a) OVERBURDEN DREDGE	CY OVERBURDEN	4.07304	\$ 8.000	\$ 6.308	\$ 6.076	\$ 6.159	\$ 6.370	\$ 6.357	\$ 6.000	\$ 6.000	\$ 6.000	\$ 1.470
(b) MATRIX DREDGE	CY MATRIX	3.70741	\$ 8.000	\$ 6.506	\$ 6.075	\$ 6.150	\$ 6.368	\$ 6.251	\$ 6.000	\$ 6.000	\$ 6.000	\$ 1.358
(c) SLURRY PUMPING MATRIX TONS-MILE		10.52905	\$ 8.000	\$ 6.083	\$ 6.021	\$ 6.084	\$ 6.176	\$ 6.547	\$ 6.000	\$ 6.000	\$ 6.318	\$ 1.178
TOTAL			\$ 8.000	\$ 6.097	\$ 6.172	\$ 6.400	\$ 6.865	\$ 6.155	\$ 6.000	\$ 6.000	\$ 6.318	\$ 4.007

BENEFICIATION COST

MODULE NAME	VARIABLE	TONS OF PRODUCT PER VARIABLE	ELECTRICITY \$ PER TON PRODUCT	OPERATING LABOR \$ PER TON PRODUCT	OPERATING SUPPLY \$ PER TON PRODUCT	MAIN. LABOR \$ PER TON PRODUCT	MAIN. SUPPLIES \$ PER TON PRODUCT	FUEL \$ PER TON PRODUCT	REAGENTS \$ PER TON PRODUCT	CONTRACT \$ PER TON PRODUCT	REPL. PIPE \$ PER TON PRODUCT	TOTAL \$ PER TON PRODUCT
WASHING	TONS MATRIX	4.50150	\$ 6.456	\$ 6.151	\$ 6.005	\$ 6.154	\$ 6.230					\$ 6.995
FLOTATION PREP	TONS FLOAT FEED	3.40991	\$ 6.460	\$ 6.086	\$ 6.003	\$ 6.088	\$ 6.132					\$ 6.770
FLOTATION	TONS FLOAT FEED	3.40991	\$ 6.537	\$ 6.347	\$ 6.010	\$ 6.354	\$ 6.531		\$ 6.959			\$ 2.739
IM PROCESS STORAGE	TONS FLOAT FEED	3.40991	\$ 6.028	\$ 6.043	\$ 6.001	\$ 6.044	\$ 6.044					\$ 6.182
HYDRAULIC STATION	1,000,000 GALLONS	.00397	\$ 6.125	\$ 6.021	\$ 6.001	\$ 6.021	\$ 6.031					\$ 6.199
TOTAL			\$ 61.606	\$ 6.610	\$ 6.019	\$ 6.661	\$ 6.991	\$ 6.000	\$ 6.959			\$ 11.985

WASTE DISPOSAL AND WATER RECLAMATION COST

MODULE NAME	VARIABLE	TONS OF PRODUCT PER VARIABLE	ELECTRICITY \$ PER TON PRODUCT	OPERATING LABOR \$ PER TON PRODUCT	OPERATING SUPPLY \$ PER TON PRODUCT	MAIN. LABOR \$ PER TON PRODUCT	MAIN. SUPPLIES \$ PER TON PRODUCT	FUEL \$ PER TON PRODUCT	REAGENTS \$ PER TON PRODUCT	CONTRACT \$ PER TON PRODUCT	REPL. PIPE \$ PER TON PRODUCT	TOTAL \$ PER TON PRODUCT
SLURRY PUMPING TAILS	TAILS TON MILE	6.84114	\$ 6.235	\$ 6.054	\$ 6.013	\$ 6.055	\$ 6.082					\$ 6.542
SLURRY PUMPING SLIMES	SLIMES TON MILE	3.10845	\$ 6.161	\$ 6.075	\$ 6.019	\$ 6.076	\$ 6.114					\$ 6.493
MAKE UP WATER	1,000,000 GALLONS	.00668	\$ 6.026	\$ 6.003	\$ 6.004	\$ 6.000	\$ 6.005					\$ 6.038
TOTAL			\$ 6.422	\$ 6.133	\$ 6.033	\$ 6.134	\$ 6.201	\$ 6.000	\$ 6.000	\$ 6.000	\$ 6.152	\$ 11.074

PRODUCT MANAGEMENT COST

MODULE NAME	VARIABLE	TONS OF PRODUCT PER VARIABLE	ELECTRICITY \$ PER TON PRODUCT	OPERATING LABOR \$ PER TON PRODUCT	OPERATING SUPPLY \$ PER TON PRODUCT	MAIN. LABOR \$ PER TON PRODUCT	MAIN. SUPPLIES \$ PER TON PRODUCT	FUEL \$ PER TON PRODUCT	REAGENTS \$ PER TON PRODUCT	CONTRACT \$ PER TON PRODUCT	REPL. PIPE \$ PER TON PRODUCT	TOTAL \$ PER TON PRODUCT
CONVEYOR STORAGE	TONS PRODUCT MET	1.1764705824	\$ 6.003	\$ 6.002	\$ 6.000	\$ 6.002	\$ 6.003					\$ 6.011
LOADOUT	TONS PRODUCT	1	\$ 6.010	\$ 6.060	\$ 6.022	\$ 6.061	\$ 6.091					\$ 6.244
TOTAL			\$ 6.009	\$ 6.060	\$ 6.012	\$ 6.061	\$ 6.091		\$ 6.000			\$ 6.233

TOTAL

TOTAL OPERATING COST

6 PER SHORT TONS

6 PER SHORT TON OF PRODUCT

(WORK AREA)	ELECTRICITY	OPERATING LABOR	OPERATING SUPPLY	MAIN LABOR	MAIN SUPPLY	FUEL	REAGENT	REPL. PIPE	CONTRACT	ADMIN, CLER, TECH	CAP-ABORT	TOTAL
MINING	\$0.000	\$1.097	\$0.172	\$0.400	\$0.865	\$1.155	\$0.000	\$0.319				\$4.007
BENEFICIATION	\$1.606	\$0.618	\$0.019	\$0.661	\$0.991	\$0.900	\$0.959	\$0.000			\$0.000	\$4.885
WASTE, RECLAIM AND WATER	\$0.422	\$0.133	\$0.033	\$0.134	\$0.201	\$0.000	\$0.000	\$0.152	\$0.000			\$1.074
PROD. MANAGEMENT	\$0.022	\$0.123	\$0.034	\$0.124	\$0.186	\$0.000	\$0.000	\$0.000				\$0.488
ADMIN, CLER, TECH										\$1.300		\$1.300
TOTAL	\$2.050	\$2.000	\$0.250	\$1.319	\$2.243	\$1.155	\$0.959	\$0.470	\$0.000	\$1.300	\$0.000	\$11.753

3 OF (WORK AREA) COST BY MODULE

MINING (WORK AREA) % OF TOTAL

MODULE	ELECTRICITY	OPERATING LABOR		OPERATING SUPPLY		MAINTENANCE LABOR		MAINTENANCE SUPPLY		FUEL	REAGENTS		REPLACEMENT PIPE		TOTAL
		%	W.D., W.R. COST	%	W.D., W.R. COST	%	W.D., W.R. COST	%	W.D., W.R. COST		%	W.D., W.R. COST	%	W.D., W.R. COST	
(a) OVERBURDEN DREDGE	.00	12.69	1.09	3.96	9.25	0.91	.00	.00	36.70						
(b) MATRIX DREDGE	.00	12.62	1.00	3.94	9.19	6.27	.00	.00	33.89						
(c) SLURRY PUMPING MATRIX	.00	2.07	.52	2.09	3.14	13.65	.00	.00	29.41						
TOTAL	.00	27.38	4.28	9.99	21.58	20.83	.00	7.94	100.00						

BENEFICIATION (WORK AREA) % OF TOTAL

MODULE	ELECTRICITY	OPERATING LABOR		OPERATING SUPPLY		MAINTENANCE LABOR		MAINTENANCE SUPPLY		FUEL	REAGENTS		REPLACEMENT PIPE		TOTAL
		%	W.D., W.R. COST	%	W.D., W.R. COST	%	W.D., W.R. COST	%	W.D., W.R. COST		%	W.D., W.R. COST	%	W.D., W.R. COST	
(e) WASHER	9.34	3.08	.09	3.14	4.72	.00	.00	.00	20.37						
(f) FLOTATION PREP	9.42	1.77	.05	1.81	2.71	.00	.00	.00	15.76						
(g) FLOTATION	10.99	7.11	.21	7.25	10.87	.00	.00	19.63	56.06						
(h) IN PROCESS STORAGE	.57	.09	.03	.90	1.35	.00	.00	.00	3.74						
(i) HYDRAULIC STATION	2.56	.42	.01	.43	.64	.00	.00	.00	4.07						
TOTAL	32.88	13.27	.40	13.53	20.30	.00	19.63	.00	100.00						

WASTE DISPOSAL, LAND RECLAMATION AND WATER RE-USE (WORK AREA)

MODULE	ELECTRICITY	OPERATING LABOR		OPERATING SUPPLY		MAINTENANCE LABOR		MAINTENANCE SUPPLY		FUEL	REAGENTS		REPLACEMENT PIPE		CONTRACT TOTAL
		%	W.D., W.R. COST	%	W.D., W.R. COST	%	W.D., W.R. COST	%	W.D., W.R. COST		%	W.D., W.R. COST	%	W.D., W.R. COST	
(j) SLURRY PUMPING TAILS	21.91	5.02	1.26	5.07	7.61	.00	.00	.00	50.49						
(k) SLURRY PUMPING SLIMES	14.98	6.99	1.75	7.06	10.60	.00	.00	4.54	45.92						
(l) MAKE UP WATER	2.41	.32	.03	.33	.49	.00	.00	.00	3.58						
TOTAL	39.29	12.34	3.04	12.47	18.70	.00	14.17	.00	100.00						

PRODUCT MANAGEMENT (WORK AREA) % OF TOTAL COST

MODULE	ELECTRICITY	OPERATING LABOR		OPERATING SUPPLY		MAINTENANCE LABOR		MAINTENANCE SUPPLY		FUEL	REAGENTS		REPLACEMENT PIPE		TOTAL
		%	W.D., W.R. COST	%	W.D., W.R. COST	%	W.D., W.R. COST	%	W.D., W.R. COST		%	W.D., W.R. COST	%	W.D., W.R. COST	
(m) CONVEYOR	.58	.45	.06	.46	.69	.00	.00	.00	2.74						
(n) STORAGE	2.03	12.34	4.44	12.46	18.69	.00	.00	.00	49.96						
(o) LOADOUT	1.85	12.34	2.47	12.46	18.69	.00	.00	.00	47.80						
TOTAL	4.46	25.13	6.96	25.38	38.07	.00	.00	.00	100.00						

1 OF TOTAL COST BY (WORK AREA)

	ELECTRICITY	OPERATING LABOR	OPERATING SUPPLY	MAINTENANCE LABOR	MAINTENANCE SUPPLY	FUEL	REAGENTS	REPLACEMENT PIPE	CONTRACT	ADMIN, CLER, TECH	EMP-AMORT	TOTAL
(a) OVERBURDEN DREDGE	.00	4.33	.64	1.35	3.15	3.04	.00	.00				11.55
(b) MATRIX DREDGE	.00	4.50	.64	1.34	3.13	2.14	.00	.00				10.03
(c) SLURRY PUMPING MATRIX	.00	.71	.10	.71	1.07	4.65	.00	2.71				34.09
SUBTOTAL MIXING	.00	9.33	1.46	3.41	7.34	9.83	.00	2.71			.00	8.47
(e) WASHER	3.80	1.78	.04	1.31	1.96	.00	.00	.00				6.55
(f) FLOTATION PREP	3.92	.74	.02	.75	1.13	.00	.00	.00				23.30
(g) FLOTATION	4.57	2.95	.09	3.01	4.52	.00	0.16	.00				1.55
(h) IN PROCESS STORAGE	.23	.37	.01	.38	.56	.00	.00	.00				1.69
(i) HYDRAULIC STATION	1.07	.17	.01	.18	.27	.00	.00	.00			.00	41.56
SUBTOTAL BENEFICIATION	13.67	5.51	.17	5.62	8.44	.00	0.16	.00			.00	4.61
(j) SLURRY PUMPING TAILS	2.00	.46	.11	.46	.70	.00	.00	.88				4.70
(k) SLURRY PUMPING SLIMES	1.37	.44	.16	.65	.97	.00	.00	.42				.33
(l) MAKE UP WATER	.22	.03	.00	.03	.04	.00	.00	.00				9.14
SUBTOTAL M.O., L.R. & M.R. 3.59		1.13	.20	1.14	1.71	.00	.00	1.29	.00			.09
(m) CONVEYOR	.02	.02	.00	.02	.03	.00	.00	.00				2.07
(n) STORAGE	.08	.51	.10	.52	.70	.00	.00	.00				1.98
(o) LOADOUT	.00	.51	.10	.52	.70	.00	.00	.00				4.15
SUBTOTAL PRODUCT HAND.	.10	1.04	.29	1.05	1.50	.00	.00	.00				11.06054
ADMIN, CLER, TECH										11.06		
TOTAL	17.44	17.02	2.19	11.22	19.08	9.83	0.16	4.00	.00	11.06	.00	100.00

INPUTS:

MATERIAL CHARACTERISTICS:

SEDIMENT VOLUME	39427000	CY
TONS SEDIMENTS	675281050	TONS
DENSITY SEDIMENTS	90.00	TONS/CY
% MOISTURE (BY WEIGHT) SEDIMENTS	0	
% SOLIDS (BY WEIGHT) SEDIMENTS	100	
S. 5. SEDIMENTS	1.44	
S. 6. SOLIDS IN SEDIMENTS	1.44	

UNITS:

PRODUCTION AND HORSEPOWER	UNIT:	PER DREDGE QUANTITY:	ALL DREDGES QUANTITY:
FLOW IN DREDGE OUTPUT	GAL/MIN	45010	45010
PRODUCTION THROUGH PIPE	CY/HOUR	13372	13372
PRODUCTION OF SOLIDS	TONS/HOUR	3992	3992
ANNUAL PRODUCTION	CY/YEAR	19726506	19726506
PER DREDGE	YEARS	20.00	20

DREDGING PARAMETERS:

SIZE OF DISCHARGE PIPE	35.4	INCHES
LENGTH OF PIPE AVERAGE	200	FEET
LENGTH OF PIPE MAXIMUM	200	FEET
DESIGN VELOCITY	14.66	FT/SEC
% OF SOLIDS (BY WEIGHT) PUMPED	24	
WATER MILLINGS NUMBER (70-150) SEE U10	140	
FRICTION FACTOR MULTIPLIER	1	(WATER=1)
ELEVATION OF SEDIMENTS	0	FEET
WATER ELEVATION PIPE LINE	125	FEET
VELOCITY HEAD	3	FEET
POWER PUMP EFFICIENCY	.8	
POWER TRANSMISSION EFFICIENCY	7042	
HORSEPOWER AUXILIARY MOTORS		

COSTS:

LABOR	17.14	\$/HOUR
NEW REQUIRED	20	NEW/SH
DIESEL FUEL	.6	\$/GAL
NUMBER OF DREDGES	1	
DREDGE/PIPE/MISC. COST	40000000	

VALUE AFTER JOB	0	
% INTEREST ON CAPITAL	15	
% INTEREST ON INSURANCE	1	
% INTEREST ON TAXES	1	

DREDGE PRODUCTION FACTORS:

SCHEDULED DAYS/YEAR	327	DAYS
SCHEDULED SHIFTS/DAY	3	SHIFTS
SCHEDULED HR/SHIFT	8	HOURS
TOTAL HOURS/YEAR SCHEDULED	7848	HOURS
HOURS/SHIFT OPERATING	6.8	HOURS
% MECHANICAL AVAILABILITY	90	%
TOTAL HOUR/YEAR PRODUCING	6003.72	HOURS

CONVERSION FACTORS:

PIE	3.14
GALLONS/CUBIC FEET	7.48
CUBIC FEET/ CUBIC YARD	27
WEIGHT CUBIC FOOT WAT	62.4
MINUTES/HR	60
GAL/HP	.06

CALCULATIONS:

VELOCITY HEAD	3	FEET	3		
FRICTION HEAD	3	FEET	3		
STATIC HEAD	125	FEET	125		
TOTAL DYNAMIC HEAD AVE	131	FEET	131		
TOTAL DYNAMIC HEAD MAX.	131	FEET	131		
PUMP HORSEPOWER AVERAGE	2259	HP	2259		
PUMP HORSEPOWER MAXIMUM	2259	HP	2259		
ANNUAL OPERATING COSTS	UNIT	\$/UNIT	QUANTITY	\$/YEAR	\$/CY SEDIMENT
PER DREDGE:					
DIESEL FUEL	GAL	.6	2274274	1335164	6.048
LABOR	HR	17.14	156960	2690294	6.136
MAINTENANCE	% CAPITAL COST		.07	2800000	6.142
MISCELLANEOUS SUPPLIES	% CAPITAL COST		.01	400000	6.070
CAPITAL COST ALLOWANCE	% YEAR CAPITAL		2000305	2000305	6.101
INTEREST	% CAPITAL COST		FORMULA	3150023	6.160
INSURANCE	% CAPITAL COST		FORMULA	210002	6.011
TAXES	% CAPITAL COST		FORMULA	210002	6.011
TOTAL COST				12796389	6.649
ANNUAL OPERATING COSTS	UNIT	\$/UNIT	QUANTITY	\$/YEAR	\$/CY SEDIMENT
PER DREDGE:					
DIESEL FUEL	GAL	.6	2274274	1335164	6.048
LABOR	HR	17.14	156960	2690294	6.136
MAINTENANCE	% CAPITAL COST		.07	2800000	6.142
MISCELLANEOUS SUPPLIES	% CAPITAL COST		.01	400000	6.070
CAPITAL COST ALLOWANCE	% YEAR CAPITAL		2000305	2000305	6.101
INTEREST	% CAPITAL COST		FORMULA	3150023	6.160
INSURANCE	% CAPITAL COST		FORMULA	210002	6.011
TAXES	% CAPITAL COST		FORMULA	210002	6.011
TOTAL COST				12796389	6.649

Project Year	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015
Sales Revenue																									
Production, Million IPY	2.4	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Sales Price, \$/Tonne	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00
Total Revenue	84000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000	140000
Production Costs																									
Direct Production Costs \$/Tonne	4.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40
Mining	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40	3.40
Beneficiation	1.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00
Rising	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Handling and Storage	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Vessel Loading	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Waste Disposal	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Suvey, Chemical, Tech	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Offshore Accommodations	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Total Cash Cost	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60
Indirect Production Cost, \$/Tonne	0.20	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Administration	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Sales	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Royalty @ 5% of sales price	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Taxes (misc)	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Other	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Total Indirect Cost	0.20	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Total Production Cost	13.80	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85	13.85
Total Cash Cost, \$/yr	65280	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200	127200
Total Indirect Cost, \$/yr	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000	78000
Total Production Cost, \$/yr	143280	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200	205200
Cash Flow (Revenue-Prod Cost)	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Investment	10000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Pre-construction	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Construction Capital	0	35000	85000	120000	40000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Interest During Construction	0	1750	7150	18000	26000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Total Investment	10000	36750	92750	138000	66000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Principal	0	0	0	0	0	343260	373650	389150	291975	274000	257625	240450	223275	206100	189225	171750	154575	137400	120225	103050	85875	68700	51525	34350	17175
Principal Payment	0	0	0	0	0	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175	17175
Interest @ 10%	0	0	0	0	0	28350	37365	46380	55395	64410	73425	82440	91455	100470	109485	118500	127515	136530	145545	154560	163575	172590	181605	190620	199635
Replacement Capital	0	0	0	0	0	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000
Working Capital	0	0	0	0	0	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800
Cash Flow (After Investment)	-10000	-36750	-92750	-138000	-66000	-30150	49835	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855
Depreciation (7 yr ACES)	0	0	0	0	0	49005	84123	60078	42983	30675	21645	15120	10695	7560	5400	3900	2790	1980	1410	1000	720	510	360	250	180
Depletion	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
taxable Income	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Tax Rate, %	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Income Tax	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Ret. Income After Tax	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Cash Flow	-10000	-36750	-92750	-138000	-66000	-30150	49835	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855	59855
Level Cash Flow	-10000	-46750	-139500	-277500	-343500	-373650	-340970	-300000	-268410	-221463	-181105	-139224	-95568	-64050	-40500	-27431	18132	69171	138233	172448	215773	268214	330772	405446	497521

INPUTS:

MATERIAL CHARACTERISTICS:

SECTORET VOLUME	UNITS:	QUANTITY:	PER DREDGE QUANTITY:	ALL DREDGES QUANTITY:
TONS SEDIMENTS	CY	641800000		
DENSITY SEDIMENTS	0/CF	866430000		
% MOISTURE(BY WEIGHT) SEDIMENTS	-	100.00		
% SOLIDS(BY WEIGHT) SEDIMENTS	-	0		
S. G. SEDIMENTS	-	1.00		
S. G. SOLIDS IN SEDIMENTS	-	1.60		

DREDGING PARAMETERS:

SIZE OF DISCHARGE PIPE	INCHES	41.4
LENGTH OF PIPE AVERAGE <td>FEET</td> <td>12000</td>	FEET	12000
LENGTH OF PIPE MAXIMUM <td>FEET</td> <td>12000</td>	FEET	12000
DESIGN VELOCITY <td>FT/SEC</td> <td>15.5</td>	FT/SEC	15.5
% OF SOLIDS(BY WEIGHT) PUMPED <td>-</td> <td>34.7</td>	-	34.7
WATER WILLIAMS NUMBER (70-150) SEE D10 <td>-</td> <td>140</td>	-	140
FRICTION FACTOR MULTIPLIER <td>(WATER-1)</td> <td>1</td>	(WATER-1)	1
ELEVATION OF SEDIMENTS <td>FEET</td> <td>0</td>	FEET	0
MAXIMUM ELEVATION PIPE LINE <td>FEET</td> <td>35</td>	FEET	35
VELOCITY HEAD <td>FEET</td> <td>3</td>	FEET	3
DREDGE PUMP EFFICIENCY <td>-</td> <td>.8</td>	-	.8
POWER TRANSMISSION EFFICIENCY <td>-</td> <td>1</td>	-	1
HORSEPOWER AUXILIARY MOTORS <td>-</td> <td>7842</td>	-	7842

COSTS:

LABOR	\$/HOUR	17.14	\$/UNIT	4819	\$/YEAR	1888927	\$/CY SEDIMENT	6.416
MEN REQUIRED PER DREDGE	MAN/SH	20				2690294		6.084
DIESEL FUEL	\$/GAL	.6				2800000		6.087
NUMBER OF DREDGES	0	1				400000		6.012
DREDGE/PIPE/IN/SEC. COST PER DREDGE	\$/	40000000				2002514		6.062
VALUE AFTER JOB	\$/	0				3150189		6.098
% INTEREST ON CAPITAL	%	15				210013		6.007
% INTEREST ON INSURANCE	%	1				210013		6.007
% INTEREST ON TAXES	%	1				210013		6.007

DREDGE PRODUCTION FACTORS:

SCHEDULED DAYS/YEAR	DAYS	327	\$/UNIT	17.14	\$/YEAR	1888927	\$/CY SEDIMENT	6.416
SCHEDULED SHIFTS/DAY <td>SHIFTS</td> <td>3</td> <td></td> <td></td> <td></td> <td>2690294</td> <td></td> <td>6.084</td>	SHIFTS	3				2690294		6.084
SCHEDULED HR/SHIFT <td>HOURS</td> <td>8</td> <td></td> <td></td> <td></td> <td>2800000</td> <td></td> <td>6.087</td>	HOURS	8				2800000		6.087
TOTAL HOURS/YEAR SCHEDULED <td>HOURS</td> <td>7848</td> <td></td> <td></td> <td></td> <td>400000</td> <td></td> <td>6.012</td>	HOURS	7848				400000		6.012
HOURS/SHIFT OPERATING <td>HOURS</td> <td>6.8</td> <td></td> <td></td> <td></td> <td>2002514</td> <td></td> <td>6.062</td>	HOURS	6.8				2002514		6.062
% MECHANICAL AVAILABILITY <td>%</td> <td>90</td> <td></td> <td></td> <td></td> <td>3150189</td> <td></td> <td>6.098</td>	%	90				3150189		6.098
TOTAL HOUR/YEAR PRODUCING <td>HOURS</td> <td>6003.72</td> <td></td> <td></td> <td></td> <td>210013</td> <td></td> <td>6.007</td>	HOURS	6003.72				210013		6.007

CONVERSION FACTORS:

PIE	3.14
GALLONS/CUBIC FEET	7.48
CUBIC FEET/ CUBIC YARD	27
WEIGHT CUBIC FOOT WATER	62.4
MINUTES/HR	60

CALCULATIONS:

PRODUCTION AND HORSEPOWER	UNIT:	QUANTITY:	PER DREDGE QUANTITY:	ALL DREDGES QUANTITY:
FLOW IN DREDGE OUTPUT	GAL/MIN	65088		
PRODUCTION THROUGH PIPE	CY/HOUR	19337		
PRODUCTION OF SOLIDS	TONS/HOUR	7225		
ANNUAL PRODUCTION	TONS/YEAR	32130341		
PER DREDGE	TONS/YEAR	19.97		

VELOCITY HEAD	FEET	3	\$/UNIT	4819	\$/YEAR	1888927	\$/CY SEDIMENT	6.416
FRICTION HEAD	FEET	146				2690294		6.084
STATIC HEAD	FEET	35				2800000		6.087
TOTAL DYNAMIC HEAD AVE.	FEET	184				400000		6.012
TOTAL DYNAMIC HEAD MAX.	FEET	184				2002514		6.062
PUMP HORSEPOWER AVERAGE	HP	4819				3150189		6.098
PUMP HORSEPOWER MAXIMUM	HP	4819				210013		6.007

ANNUAL OPERATING COSTS	UNIT	QUANTITY	\$/UNIT	\$/YEAR	\$/CY SEDIMENT
PER DREDGE					
DEISEL FUEL	GAL	3148211	.6	1888927	6.059
LABOR	MAN	156960	17.14	2690294	6.084
MAINTENANCE	% CAPITAL COST	.07		2800000	6.087
MISCELLANEOUS SUPPLIES	% CAPITAL COST	.01		400000	6.012
CAPITAL COST ALLOWANCE	\$/ YEAR CAPITAL	2002514		2002514	6.062
INTEREST	% CAPITAL COST	FORMULA		3150189	6.098
INSURANCE	% CAPITAL COST	FORMULA		210013	6.007
TAXES	% CAPITAL COST	FORMULA		210013	6.007
TOTAL COST				13351949	6.416

ANNUAL OPERATING COSTS	UNIT	QUANTITY	\$/UNIT	\$/YEAR	\$/CY SEDIMENT
ALL DREDGES:					
DEISEL FUEL	GAL	3148211	.6	1888927	6.059
LABOR	MAN	156960	17.14	2690294	6.084
MAINTENANCE	% CAPITAL COST	.07		2800000	6.087
MISCELLANEOUS SUPPLIES	% CAPITAL COST	.01		400000	6.012
CAPITAL COST ALLOWANCE	\$/ YEAR CAPITAL	2002514		2002514	6.062
INTEREST	% CAPITAL COST	FORMULA		3150189	6.098
INSURANCE	% CAPITAL COST	FORMULA		210013	6.007
TAXES	% CAPITAL COST	FORMULA		210013	6.007
TOTAL COST				13351949	6.416

Project Year	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015
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Sales Revenue	2.4	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
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Production, Million TPY	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00
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Sales Price, \$/Tonne	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000
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Total Revenue	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40
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Production Costs	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40
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Direct Production Costs \$/Tonne	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40
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Indirect Production Cost, \$/Tonne	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
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Total Production Cost	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40
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Total Cash Cost	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40
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Total Cash Cost, \$/yr	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000
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Total Indirect Cost, \$/yr	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
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Total Production Cost, \$/yr	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000	160000
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Cash Flow (Revenue-Prod Cost)	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
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Investment	10000	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
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Pre-construction	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
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Construction Capital	31500	76500	100000	30000	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
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Interest During Construction	1575	6975	16300	23000	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
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Total Investment	10000	33075	83475	124200	59000	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
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Principal	0.00	0.00	0.00	0.00	0.00	310150	336265	279135	263620	240120	235613	217105	201530	186370	170563	155075	139568	124000	108553	93000	77500	63000	48500	34000	19500
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Interest @ 10%	0.00	0.00	0.00	0.00	0.00	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500	15500
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Replacement Capital	0.00	0.00	0.00	0.00	0.00	25015	33977	27914	26363	24012	23611	21711	20153	18637	17056	15507	13957	12400	10855	9300	7750	6300	4850	3400	1950
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Working Capital	0.00	0.00	0.00	0.00	0.00	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000
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Cash Flow (After Investment)	-10000	-33075	-83475	-124200	-59000	-26815	53583	61066	62637	64188	65739	67289	68840	70391	71942	73492	75043	76594	78145	79695	81246	82797	84348	85899	87450
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Depreciation (7 yr ACSI)	0.00	0.00	0.00	0.00	0.00	44320	75556	54245	38738	27656	21656	13833	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
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Taxable Income	0.00	0.00	0.00	0.00	0.00	3421	11950	10246	15937	19797	23520	23520	23520	23520	23520	23520	23520	23520	23520	23520	23520	23520	23520	23520	23520
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Tax Rate, %	0.00	0.00	0.00	0.00	0.00	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35
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Income Tax	0.00	0.00	0.00	0.00	0.00	1197	4182	3586	5583	6863	8259	8259	8259	8259	8259	8259	8259	8259	8259	8259	8259	8259	8259	8259	8259
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Net Income (After Tax)	0.00	0.00	0.00	0.00	0.00	22838	71717	66609	63807	61921	60261	59011	57761	56511	55261	54011	52761	51511	50261	49011	47761	46511	45261	44011	42761
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Cash Flow	-10000	-33075	-83475	-124200	-59000	-26815	49168	62947	62947	62947	62947	62947	62947	62947	62947	62947	62947	62947	62947	62947	62947	62947	62947	62947	62947
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Cash Flow	-10000	-43075	-126550	-250750	-310150	-335565	-298970	-256509	-211642	-165310	-115100	-60368	-30616	-110	33400	78642	121304	162604	201972	239108	274132	307974	341554	374922	408132
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PHOSPHATE MINING
 (Thousand \$ per Year)
 CASE 1(b)

5/13/88

Project Year	-5	-4	-3	-2	-1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Year	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015
Sales Revenue						4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Production, Million TPy						2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4
Sales Price, \$/Tonne						35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00	35.00
Total Revenue						84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00	84.00
Production Costs						4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00
Direct Production Costs \$/Tonne						1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67	1.67
Beneficiation						5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40
Rinsing						-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30	-.30
Handling and Storage						-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25
Vessel Loading						-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25
Waste Disposal						1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	
Sugar, Chemical, Tech						1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	
Offshore Recommendations						-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45	-.45
Total Cash Cost						13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60
Indirect Production Cost, \$/Tonne						2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33
Administration						-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20
Sales						-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25
Royalty @ 5% of sales price						1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75
Taxes (misc)						-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20	-.20
Other						-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25	-.25
Total Indirect Cost						2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65	2.65
Total Production Cost						16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25	16.25
Total Cash Cost, \$/Yr						65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00	65.00
Total Indirect Cost, \$/Yr						127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20	127.20
Total Production Cost, \$/Yr						78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20	78.20
Cash Flow (Revenue-Prod Cost)						6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00
Investment						10000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Pre-construction						0	38500	93500	13000	44000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Construction Capital						0	1825	8525	19800	26600	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Interest During Construction						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Total Investment						10000	48125	103325	151000	72600	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Principal						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Principal Payment						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Interest @ 18%						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Replacement Capital						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Working Capital						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Cash Flow (After Investment)						-12000	-40425	-102025	-151000	-72600	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00
Depreciation (7 yr RCST)						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Leptation						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Taxable Income						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Tax Rate, %						0	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35
Income Tax						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Net Income (After Tax)						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Cash Flow						-10000	-40425	-102025	-151000	-72600	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00
Total Cash Flow						-10000	-50425	-122025	-166000	-78860	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00

Project Year	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020				
Sales Revenue																															
Production, Million TPY	2.4	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0			
Sales Price, \$/Tonne	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00		
Total Revenue	100800	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600		
Production Costs																															
Direct Production Costs \$/Tonne																															
Mining	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40		
Beneficiation	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40		
Rinsing	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30		
Handling and Storage	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25		
Vessel Loading	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25		
Waste Disposal	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15			
Super, Clerical, Tech	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40		
Offshore Accommodations	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45		
Total Cash Cost	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60		
Indirect Production Cost, \$/Tonne																															
Administration	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20		
Sales	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	
Royalty @ 5% of sales price	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10		
Taxes (misc)	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	
Other	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	
Total Indirect Cost	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00		
Total Production Cost	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60		
Total Cash Cost, \$/yr	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	
Total Indirect Cost, \$/yr	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	
Total Production Cost, \$/yr	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	
Cash Flow (Revenue-Prod Cost)	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Investment																															
Pre construction	10000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Construction Capital	0	35000	120000	40000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Interest During Construction	0	1750	7750	18250	26000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Total Investment	10000	36750	92750	138000	66000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Principal	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Principal Payment	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Interest @ 10%	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Replacement Capital	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Working Capital	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Cash Flow (After Investment)	-10000	-36750	-92750	-138000	-66000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Depreciation (7 Yr 90%)	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Depletion	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Taxable Income	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Tax Rate, %	0	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35
Income Tax	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Net Income After Tax	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Cash Flow	-10000	-36750	-92750	-138000	-66000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Cumulative Cash Flow	-10000	-46750	-139500	-277500	-343500	-389500	-422000	-440000	-445000	-438000	-420000	-392000	-355000	-310000	-258000	-202000	-143000	-8200													

MESQUITE MINING
 (Thousands \$ per Year)
 CRSE 11(b)

Project Year	-5	-4	-3	-2	-1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Year	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018

Production, Million Tpy	2.4	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	
Sales Price, \$/Tonne	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00
Total Revenue	100800	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600

Production Costs

Direct Production Costs \$/Tonne

Mining	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	4.40	
Beneficiation	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	5.40	
Flotation	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30	.30
Handling and Storage	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25
Vessel Loading	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	
Waste Disposal	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	
Superv, Clerical, Tech	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45	.45
Offshore Reconnosations	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	13.60	
Total Cash Cost																										

Indirect Production Cost, \$/Tonne

Administration	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20
Sales	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25
Royalty @ 5% of sales price	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10
Taxes (local)	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20
Other	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25
Total Indirect Cost	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00
Total Production Cost	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60	16.60
Total Cash Cost, \$/yr	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280	65280
Total Indirect Cost, \$/yr	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400	14400
Total Production Cost, \$/yr	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680	79680

Cash Flow (Revenue-Prod Cost)

Investment	0	0	0	0	0	21120	121920	121920	121920	121920	121920	121920	121920	121920	121920	121920	121920	121920	121920	121920	121920	121920	121920	121920	121920
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Investment

Pre-construction	10000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Construction Capital	0	38500	93500	132000	44000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Interest During Construction	0	1925	8525	19800	28600	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Total Investment	10000	40425	102025	151800	72600	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Principal	0	0	0	0	0	376800	395215	339165	320123	301160	282638	263795	244953	226110	207268	188525	169583	150740	131838	113005	94213	75370	56528	37685	18843
Principal Payment	0	0	0	0	0	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843	18843
Interest @ 10%	0	0	0	0	0	16265	35522	33917	32032	30116	28264	26380	24435	22511	20727	18843	16953	15074	13198	11306	9421	7537	5653	3769	1884
Replacement Capital	0	0	0	0	0	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000
Working Capital	0	0	0	0	0	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800	1800

Cash Flow (After Investment)

Depreciation (7 yr A005)	0	0	0	0	0	53852	92291	65911	47869	33653	23615	16800	11800	8200	5700	4000	2800	2000	1400	1000	700	500	350	250	180
Depletion	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Taxable Income	0	0	0	0	0	18546	20910	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224
Tax Rate, %	0	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35
Income Tax	0	0	0	0	0	6491	7318	9818	9818	9818	9818	9818	9818	9818	9818	9818	9818	9818	9818	9818	9818	9818	9818	9818	9818
Net Income After Tax	0	0	0	0	0	6855	13591	10782	20031	21231	33405	45555	46700	48000	49300	50600	51900	53200	54500	55800	57100	58400	59700	61000	62300
Cash Flow	-10000	-40425	-102025	-151800	-72600	-18865	64463	60755	61816	63027	64238	65449	66660	67871	69082	70293	71504	72715	73926	75137	76348	77559	78770	79981	81192
Cumul Cash Flow	-10000	-50425	-152425	-304225	-376825	-339165	-282638	-226110	-169583	-113005	-56528	0	37685	75370	113005	150740	188430	226110	263795	301160	339165	376850	414545	452240	489935

10.6 x
 14227

PHOSPHATE MINING
 (Thousands \$ per Year)
 (USE 111c)

5/13/88

Project Year	-5	-4	-3	-2	-1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Production, Million Dpr	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00
Sales Price, \$/tonne	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24
Total Revenue	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08	514.08
Indirect Production Cost, \$/tonne	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06
Administration	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27	0.27
Sales	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23
Royalty @ 5% of sales price	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56	0.56
Taxes (misc)	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Other	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
Total Indirect Cost	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06
Total Production Cost	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24	12.24

Year	-5	-4	-3	-2	-1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Construction Capital	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Interest During Construction	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Total Investment	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Principal	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Interest @ 10%	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Replacement Capital	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Working Capital	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Cash Flow (After Investment)	-10000	-36750	-92750	-138000	-66000	98923	96263	100400	102117	103835	105552	107270	108987	110705	112422	114140	115857	117575	119292	121010	122727	124445	126162	127879	129596
Depreciation (7 yr ACRS)	0	0	0	0	0	49066	84123	60078	42903	30675	22320	15320	0	0	0	0	0	0	0	0	0	0	0	0	0
Depletion	0	0	0	0	0	3400	18441	27859	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224	28224
Taxable Income	0	0	0	0	0	3400	18441	27859	41581	43253	44936	46608	48280	49952	51624	53296	54968	56640	58312	59984	61656	63328	65000	66672	68344
Tax Rate, %	0	0	0	0	0	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35
Income Tax	0	0	0	0	0	1190	6455	9761	14535	15139	15768	16400	17032	17664	18296	18928	19560	20192	20824	21456	22088	22720	23352	23984	24616
Net Income After Tax	0	0	0	0	0	2210	11988	18089	27046	28714	29840	30966	32092	33218	34344	35470	36596	37722	38848	39974	41100	42226	43352	44478	45604
Cash Flow	-10000	-36750	-92750	-138000	-66000	98923	96263	100400	102117	103835	105552	107270	108987	110705	112422	114140	115857	117575	119292	121010	122727	124445	126162	127879	129596
Equal Cash Flow	-10000	-40750	-135250	-275300	-343500	-351510	-279012	-205277	-139331	4572	7504	14218	40687	26052	33204	39652	45506	51359	57213	63066	68919	74772	80625	86478	92331

13.3 %
 80045

Project Year	-5	-4	-3	-2	-1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Year	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018

Sales Revenue	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8
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Production, Million Tpy	2.4	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8
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Sales Price, \$/Tonne	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00	42.00
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Total Revenue	108000	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600	201600
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Direct Production Costs \$/Tonne	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8	4.8
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Mining	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94	5.94
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Beneficiation	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33	3.33
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Grinding	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8
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Handling and Storage	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27	1.27
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Vessel Lossing	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54	1.54
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Waste Disposal	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0
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Super, Chemical, Tech	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96	14.96
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Offshore Recommendations	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2
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Offshore Recommendations	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2
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Total Cash Cost	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22	28.22
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Indirect Production Cost, \$/Tonne	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.8
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Administration	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10	2.10
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Sales	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2
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Royalty @ 5% of sales price	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2
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Taxes (misc)	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09	3.09
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Other	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05	18.05
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Total Indirect Cost	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808	71808
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Total Production Cost	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832	14832
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Total Cash Cost, \$/yr	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640
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Total Indirect Cost, \$/yr	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640	86640
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Total Production Cost, \$/yr	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000	18000
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Principal	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
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Interest @ 10%	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
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Replacement Capital	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
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Working Capital	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
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Cash Flow (After Investment)	-18000	-36750	-92750	-138000	-63000	-21950	75611	83045	84762	86460	80197	89915	91632	93350	95067	96785	98502	100220	101937	103655	105372	107090	108807	110525	112242
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Depreciation (7 yr MERS)	0	0	0	0	0	49006	84123	68078	42983	34675	30640	30675	15350	0	0	0	0	0	0	0	0	0	0	0	0
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Depletion	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
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Taxable Income	0	0	0	0	0	11484	28930	27903	27903	27903	27903	27903	27903	27903	27903	27903	27903	27903	27903	27903	27903	27903	27903	27903	27903
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Tax Rate, %	0	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35
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Income Tax	0	0	0	0	0	4019	7125	9766	10052	10681	10681	10681	10681	10681	10681	10681	10681	10681	10681	10681	10681	10681	10681	10681	10681
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Net Income After Tax	0	0	0	0	0	7464	13004	18136	15066	20160	31637	42332	43940	45548	47157	48765	50373	51981	53589	55197	56805	58413	60021	61629	63237
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Cash Flow	-18000	-36750	-92750	-138000	-63000	-21950	58616	61651	64686	59559	64755	61884	57636	53381	54974	56567	58160	59753	61346	62939	64532	66125	67718	69311	70904
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Capital Cash Flow	-18
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SECTION 6

HEAVY MINERAL DEVELOPMENT FEASIBILITY

6.1 INTRODUCTION

Exploitation of heavy minerals occurring offshore the Atlantic coast of Georgia in OCS waters relies on data and information produced in previous reports. Publications of the Bureau of Mines and Minerals Management Service of the U.S. Department of Interior and of the Marine Mining Journal are the sources of most costs.

This section deals with the possible potential for commercial exploitation of these minerals by employing technology which has been tested in other offshore mineral mining ventures, and/or in offshore oil and gas exploration and production operations. The applicability of the technology to heavy minerals is reviewed in a comparison of alternative configuration schemes. The preferred scenario, which is the result of this comparison, is based on mining and partial on-board beneficiation by an ocean-going vessel. The suction-type hopper dredge commonly employed by United Kingdom and European operators is the obvious choice. These mining-processing platforms are not currently manufactured in the U.S. Final processing of the intermediate product is conducted offshore in a platform-mounted plant. Finished product is transported to port for sales and distribution. Capital and operating cost estimates are based on data gathered from researching previous publications, and from in-house experience with land-based heavy minerals operations. Economic viability is evaluated by discounted cash flow techniques based on the application of several variable cost scenarios.

6.2 MINING

6.2.1 Area Selection

Section 3 describes the processes that form heavy mineral deposits and how the mineral database was formed. The selected mining area is based on computer modeling techniques using the following sources:

- o discrete points from unpublished "sparker" seismic profiles received from Peter Popenoe, U.S.G.S.,
- o data file of sampling point on the continental margin off the Georgia Coast received from the USGS - Woods Hole
 - percent sand fraction - code line 210
 - percent of sand fraction consisting of heavy minerals, quartz, and feldspar - code line - 320
 - species of heavy minerals - code line 560.

A distinct trend of heavy mineral concentration in ocean bottom grab samples is evident. This trend is supported by total percent mineral species as well as individual species information for rutile, monazite, zircon and staurolite. It should be emphasized that sampling points are widely spaced and have an average area of influence over 11,000 square kilometers. None of the actual sampling points were within the selected mining area. Figure 6.1 shows the selected mining area and geological trends. The selected area has a greater heavy mineral thickness and better data reliability than the trend located closer to shore.

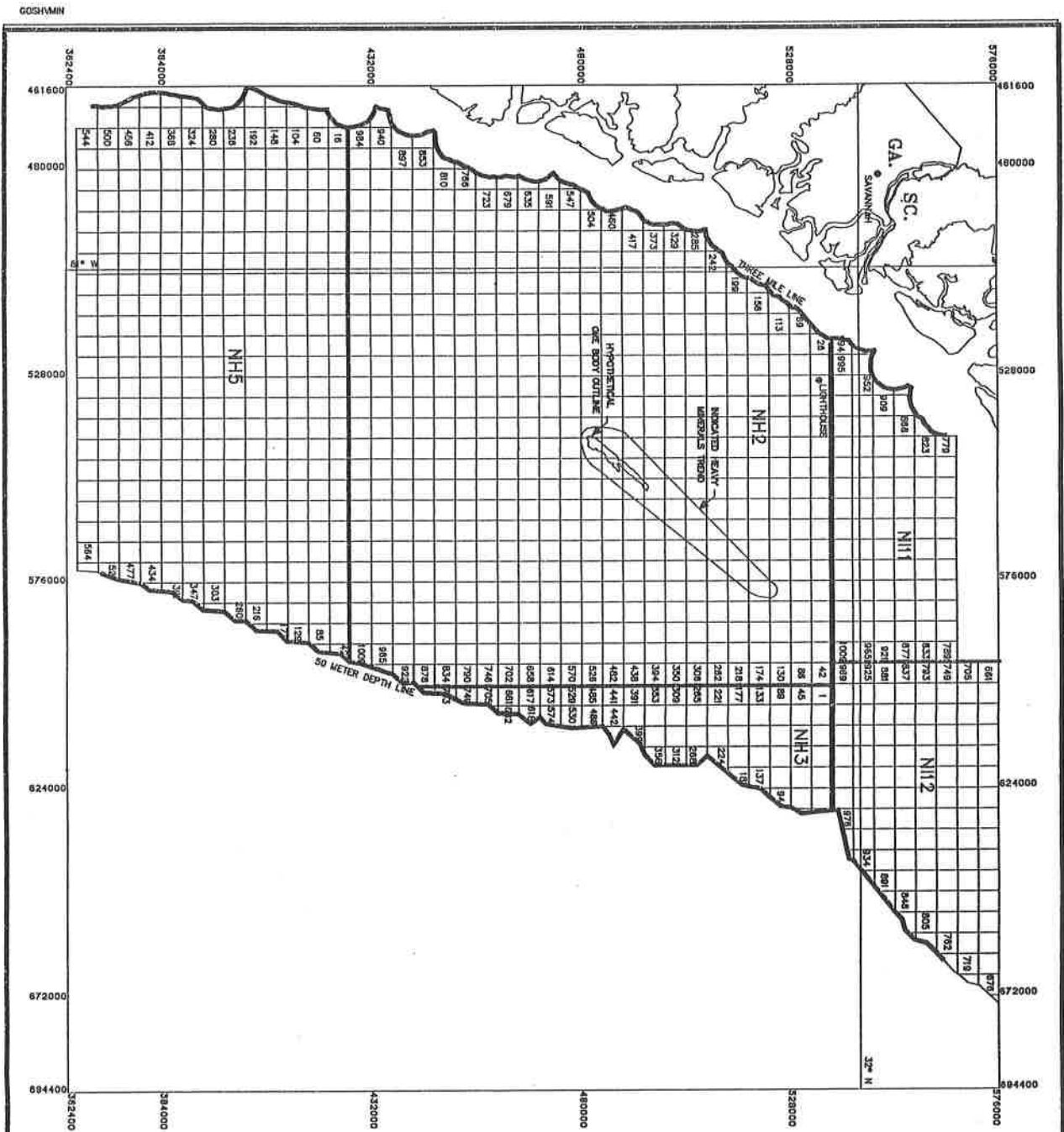
The location and site characteristics are described in Tables 6-1 and 6-2.


Table 6-1

	<u>AMS Coordinates</u>		<u>Lat. and Long.</u>
	<u>East</u>	<u>North</u>	
SW	543000	481400	80°32'39.14", 31°28'05.64"
NE	557600	495400	80°23'34.32", 31°35'38.11"

(Approximately 18.0 km by 1.5 km)

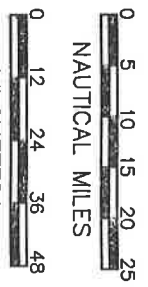
(Area = 28,134,100m² or 6,952 acres)





NORTH

GRAPHIC SCALES



0 5 10 15 20 25
NAUTICAL MILES

0 12 24 36 48
KILOMETERS

GEORGIA OFFSHORE
MINERALS ASSESSMENT

HYPOTHETICAL
HEAVY-MINERAL DEPOSIT
LOCATION




FIGURE NO. 6.1

Table 6-2
Site Characteristics of Mining Area

<u>Item</u>	<u>Meters</u>			<u>Meters³</u>
	<u>Average</u>	<u>Min.</u>	<u>Max.</u>	<u>Volume</u>
Water Depth	27.2	26.4	29.7	--
Ore Thickness	10.4	9.8	11.8	292,200,000
Total Mining Depth	37.6	36.4	41.4	
Heavy Mineral Percent	3.6	2.6	4.0	

Since no adequate heavy mineral species data have been made available, for the purpose of this study only, it has been assumed that the contained heavy mineral content expressed in the model represents the total percent oxides of heavy minerals.

Site characteristics show that the total available tonnes of mineral-bearing sands within the study's orebody outline (520,100,000 tonnes) are more than sufficient to support a 15,300,000 tonne per year mining operation for a period of 20 years at minimum (306,000,000 tonnes).

6.2.2 Configuration and Production Rate Comparison

Although, at first, the topics of project configuration and production rate appear unrelated for Georgia offshore mining, the production rate depends upon project configuration. As such, they are included in the same discussion.

The annual production of any mineral beneficiation facility is dependent on the ability of the mine to supply ore. Normally, plant production is based on operational efficiency, largely independent of mining because of the ease in providing large stockpiles of plant feed. Most heavy mineral production is based on a linkage between mining, ore transportation, and the plant washer. High operating factors are realized and ore storage is not a requirement. Operating factors for most ocean mining equipment are low compared to onshore mining. This is due to climatic and other conditions beyond the control of the operator.

Production based on mining of ore at sea for beneficiation at a remotely located land-based facility is greatly dependent on the effective operating factors of the excavating and transporting equipment and systems.

As a basis for uniform comparison of alternative configuration schemes certain criteria were established. The criteria adopted for comparative evaluation given below in Table 6-3 are based on previous work and on reported experience with ocean-going dredges and transportation systems. These criteria were later modified to better fit the preferred mining equipment and systems configuration.

Ocean-going vessels equipped for mining are large, containing hoppers for collecting dredged material. These vessels also serve as transports and, therefore, their availability for mining is very limited. Investment is high and utilization for mining is low. This appears to be the norm as is experienced by operators who use these types of foreign-built dredges in the North Atlantic, Pacific Ocean and Sea of Japan. These systems are most effective where there is little or no overburden, where the ratio of ore to product is low, and where concentration takes place on board.

Table 6-3
Criteria Basis for Configuration Comparison

Annual Mining Equipment Availability

Days lost:	
annual dry dock/repairs	30
adverse weather/sea conditions	<u>36</u>
	66
Days operational (1)	299
Hours/day operational	21
Mechanical availability	90%
Effective operating hours	5,651
(299 x 21 x .90)	

(1) See Table 5-15, Climatic and Physical Oceanographic Data for basis used to determine days operational.

Table 6-3 (continued)

<u>Item Description</u>	<u>Unit</u>	<u>Value</u>
Average overburden thickness	meters	None
Average ore thickness	meters	9.80
Ore density	tonnes/m ³	1.78
	lb/ft ³	111
Mining recovery	percent	65
Suction head pipe or dredge pump discharge diameter	mm	900
	inches	36
Pipeline velocity	m/sec	4.92
	ft/sec	16.1
Dredge production dry solids	m ³ /yr	10,300,000
	tonnes/hr	3,240
Average slurry solids	percent	26
Washer rejects	percent	50
Distance to land-based beneficiation plant	nautical miles	50
Average vessel speed	knots	12

Because sea-going suction head hopper type dredges have a long and successful history of operating under ocean conditions they are considered here in evaluating alternative configuration schemes.

The four major project configuration schemes considered for offshore heavy mineral production are:

1. Sea-going hopper dredge for mining and transportation to an onshore plant.
2. Sea-going hopper dredge mining and barge transportation of ore to an onshore plant.
3. Dredge mining, pipeline transportation of ore to onshore plant.
4. Dredge mining, pipeline transportation of ore to a nearby offshore island plant.

The mining dredge vessel or platform in each of the four major configurations is equipped with an onboard processing (washing) plant. Flowsheet data indicate that about 50% of the dredged material can be eliminated by washing. This reject material, a mixture of gravel oversize and sediments, would be disposed of in nearby mined-out areas. In Configurations 1, 2, and 3, matrix is transported, after washing, to a land-based plant for further processing. In configuration 4, matrix is transported by slurry pipeline from the dredge vessel to a nearby offshore plant for further processing. The physical dredge vessel size is determined by the necessity of making the vessel seaworthy, not by the dredging equipment. In Configuration 1 a large hopper is required for storage as the dredge is also the vessel used to transport ore, after washing, to shore.

Since dredge vessel size is larger than required for the dredging equipment alone, the addition of a washing plant costs only slightly more than if located onshore. Plant operating costs are identical. However, with onboard processing, material transported to shore decreases by 50%, resulting in a corresponding reduction in transportation costs of 50%. In addition, waste disposal of the 50% fraction rejected by washing at an onshore plant must be either re-transported from the plant and disposed of in the mined-out areas, or disposed of in tailing impoundments onshore. Either way, the on-vessel washing plant reduces costs considerably by wasting the 50% fraction rejected in nearby mine areas.

The cost comparisons indicate that an on-board washing plant is also favored for configuration 4, even though the cost savings are not as pronounced as for the other configurations.

1. Sea-going hopper dredge for mining and transportation to an onshore plant.

Figure 6.2 shows this configuration. Since the mineral sands are on top of the ocean bottom, no overburden dredge is required. An anchored suction head dredge mines ore by removing the total ore horizon, then moves forward by mining the resulting bank. Mining recovery is limited to about 65% with this system. The anchored suction head dredge deposits the ore into a distribution box, from which it is screened, washed and desilted.

MINING AREA

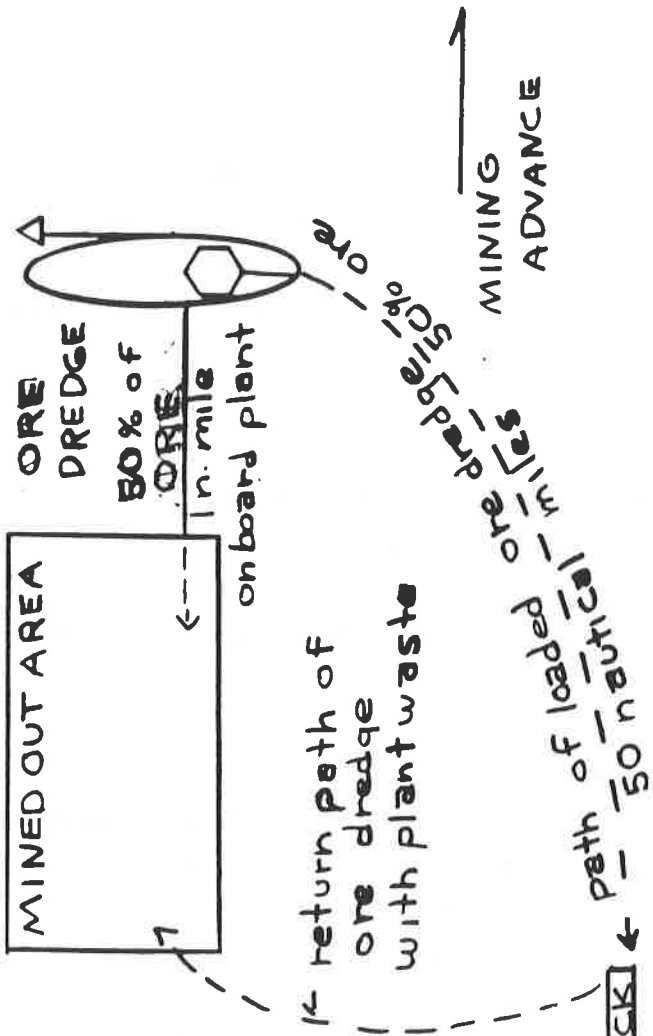


FIGURE 6.2

CONFIGURATION
1

About 50 percent of the material is loaded into a hopper on board the vessel. Here, through a series of weirs, the washed matrix is dewatered to 75% solids. When the hopper is full, the suction head and pipes are raised from the bottom to the deck. The dredge now functions as a normal merchant ship and carries the material 50 nautical miles to the plant site. The plant site is located in an industrial area on or near Hutchinson Island, where permitting problems and land acquisition problems are minimized. It is felt that an onshore plant located closer on the barrier islands to the mining operation would be environmentally unacceptable.

Cost for hopper dredges were taken from the open file report "An Economic Reconnaissance of Selected Heavy Mineral Placer Deposits in the U.S. Exclusive Economic Zone" by the Bureau of Mines Washington Staff, released 4-87. Capital costs are based on U.S.-built hopper dredges constructed between 1977 and 1985. Operating costs are from actual operating conditions.

For a hopper dredge, cycle times consist of loading, travel, unloading and return travel. The hopper size increases capacity, but also increases capital. In an attempt to optimize hopper size, four loading capacities were analyzed. Table 6-3 shows the design criteria used to determine productivity and costs.

Loading and unloading is done by a 900 mm pump using the criteria in Table 6-3 at the hourly rate of 3,240 tonnes per hour

Table 6-4 shows the time required for each element in the cycle. The cycles per year are based upon 5,651 hours. The tonnes per cycle are based upon the loading time, which is different for each case. Table 6-4 also lists the tonnes per year of product produced for each capacity. As Table 6-4 shows, increases in loading times (hopper capacity) result in only a slight increase in tonnes per year of product.

Table 6-4
Cycle Time Configuration 1

<u>Item</u>	<u>Hours</u>	<u>Hours</u>	<u>Hours</u>	<u>Hours</u>
Load Ore	5.00	10.00	15.00	20.00
Travel to Plant	4.17	4.17	4.17	4.17
Unload Ore	5.00	10.00	15.00	20.00
Load Tails	5.00	10.00	15.00	20.00
Travel to Mine	4.17	4.17	4.17	4.17
Dump Tails	5.00	10.00	15.00	20.00
Total Cycle Time	28.34	48.34	68.34	88.34
Cycles per year	199.40	116.90	82.70	63.97
Tonnes per cycle	8,100	16,200	24,300	32,400
Tonnes hauled	1,615,000	1,893,000	2,009,000	2,072,000
Tonnes mined	3,230,000	3,786,000	4,018,000	4,144,000

The following USBM equations from Open File Report 4-87 were used:

$$(P) \text{ Hopper Capacity} = \frac{\text{Daily Haul Capacity (DHC)}}{2.9607(L)^{-.2923}}$$

Where

DHC = short tons hauled divided by operating days

L = one way haul distance in nautical miles

Operating Days = 299

Short tons hauled will be determined

$$\text{Dredge capital cost} = \$7,052 (P)^{.9421}$$

Plant capital cost =

Onboard processing facilities = $319.12(X)^{0.960}$

Onshore processing facilities = $22,500(X)^{0.68}$

where X is plant feed in short tons per day.

Table 6-5 is a summary of calculated hopper sizes and the resulting capital required for each production rate from Table 6-4. The overburden dredge does not require a large hopper and its cost is estimated from other sources. Dollars per ton capital is based on 20 years of mine production for each production scenario.

Table 6-5
Capital Costs Configuration 1

Million <u>Annual</u>	Prod.Tonnes <u>20 Years</u>	Hopper <u>Tons</u>	Millions of Dollars					<u>\$*M</u> <u>Ton</u>
			<u>Mt.</u> <u>Dredge</u>	<u>Ob.</u> <u>Plant</u>	<u>OS</u> <u>Plant</u>	<u>Misc.</u>	<u>Total</u>	
3.230	64.6	6,308	26	3	8	11	48	.75
3.786	75.7	7,394	31	3	9	13	56	.74
4.018	80.4	7,847	33	3	10	14	60	.75
4.144	82.9	8,093	34	3	10	14	61	.74

Operating costs for the suction head hopper type ore mining dredge are based on the following U.S.B.O.M. formula (from Open File Report 4-87).

$$\text{Dredge operating cost (\$/s.t.)} = \frac{2.7534 (P) + 5,453}{\text{Daily Dredge Capacity}}$$

where P = payload or hopper capacity in short tons

daily dredge capacity = annual capacity in short tons ÷ days.

$$\text{Onboard processing facilities} = 25.5(X)^{-0.520}$$

$$\text{Onshore processing facilities} = 59.4(X)^{-0.345}$$

where X is the plant feed throughput in short tons per day.

Table 6-6
Operating Cost - Configuration 1
Operating Cost \$/Metric Ton Product

<u>Tonnes Mined</u>	<u>Dredge</u>	<u>O.B. Plant</u>	<u>O.S. Plant</u>	<u>Total</u>
3,230,000	\$2.11	\$.21	\$1.63	\$3.95
3,790,000	2.04	.20	1.54	3.78
4,020,000	2.01	.19	1.51	3.71
4,140,000	2.00	.19	1.50	3.69

Table 6-7
Total Comparative Cost per Tonne, Configuration 1

<u>Tonnes Mined</u>	<u>Capital</u>	<u>Operation</u>	<u>Total</u>
3,230,000	\$.75	\$ 3.95	\$ 4.70
3,786,000	.74	3.78	4.52
4,018,000	.75	3.71	4.46
4,144,000	.74	3.69	4.43

2. Sea-going Hopper Dredge Mining, Barge Transportation of Ore to an Onshore Plant

Figure 6.3 shows this configuration. The dredge pumps mined ore into a distribution box from which it is screened, washed, and desilted. About 50% of the ore is removed by onboard washing and disposed of in mined-out areas. The remaining 50% of the ore is dewatered to 75% solids aboard 26,000 tonne barges. These barges are towed to the onshore beneficiation plant by tug boats. After ore is unloaded by pumping it from the barge into live storage containment, the barge is towed back to the overburden dredge and another cycle begins. In order to avoid a large tailings area, an independent fleet of barges and tugs load, transport, and dump the plant tailings in the mined-out areas. By providing storage at the plant and a separate waste disposal system, the plant operation is not directly tied to the mine.

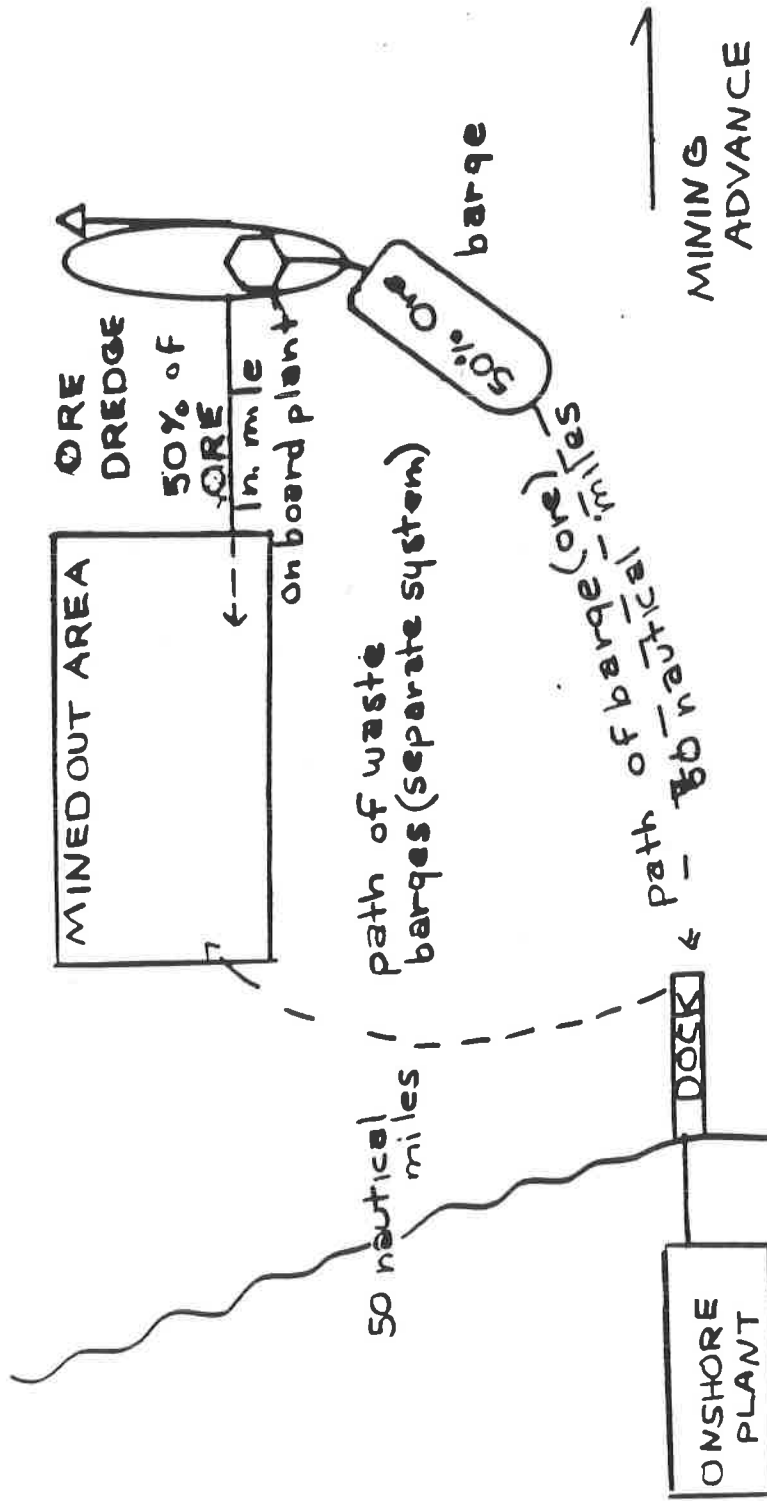


FIGURE 6.3

CONFIGURATION

2

Table 6-8 shows the time required for each element in the cycle. Criteria from Configuration 1 apply here with the exception that barges move at 8 knots.

Table 6-8
Cycle Time Configuration 2

<u>Item</u>	<u>Hours</u>
Load barge	12.03
Barge to plant	6.25
Unload barge	12.03
Barge return	<u>6.25</u>
Total cycle time	<u><u>36.56</u></u>
Cycles per year	154.8
Tonnes per cycle	19,500
Tonnes hauled per year	3,019,000

Since the dredge mines 18,310,000 tonnes of ore annually, the number of dredges required is:

$$18,310,000 (.5) \div 3,019,000 = 3.03 \text{ or } 3$$

The waste cycle is assumed to be similar to the ore handling cycle. Since the mineral concentration is only 6%, most of the waste from the onshore plant is barged back to the mined-out areas. In all, a total of seven barges and tugs are required, three for ore handling, three for waste disposal, and one for a spare.

Capital costs are calculated using the same methodology as Configuration 1.

Table 6-9 itemizes the capital required for comparison of Configuration 2.

Table 6-9
Capital Cost Configuration 2

<u>Item</u>	<u>mm \$ Unit Cost</u>	<u>No.</u>	<u>Total Cost</u>
Barges	16.2	7	\$113,400,000
Tugs	5.5	7	38,500,000
Ore dredge	40.00	1	40,000,000
Beneficiation Plant	27.00	1	27,000,000
Onboard Plant	13.80	1	13,800,000
Infrastructure & Misc.	30% of above		69,800,000
Total			302,500,000
\$ per tonne annual mined			16.52
\$ per tonne mined mine life (20 years)			.83

Operating costs for the plant are computed using the same methodology as for Configuration 2. Dredge costs are from ZW model explained in Section 5.7 (Operating Costs).

Table 6-10
Operating Costs Configuration 2

	<u>Cost per tonne product</u>
Mining Dredge	.42
Plant onshore	.90
Plant onboard	.09
Barge transportation	.39
Waste disposal	<u>.39</u>
Total	<u><u>\$2.19</u></u>

The total comparative cost for Configuration 2 is \$3.02 per tonne product.

3. Dredge mining, pipeline transportation of ore to onshore plant

Because the location of the plant is upstream on the river, a pipeline system is not feasible. A substantial part of the pipeline would lie across shipping channels and industrial installations. For this reason, as well as environmental considerations, the pipeline system was not considered in further detail for this report. This is the same conclusion reached by other investigators, i.e., Zellars-Williams, 1979, and Development Planning and Research Associates, Inc., 1987 North Carolina Offshore. Figure 6.4 illustrates the configuration.

4. Dredge mining, pipeline transportation to offshore plant

A sea-going dredge mines ore and pumps it to the on-board washer. The partially beneficiated ore is then pumped directly to a nearby offshore plant. This plant is built on an island formed by dredged material, located equi-distant an average of two nautical miles from the mining areas. The pipeline is flexible and most of it is submerged. Only the flexible portion near the dredge is floating. At the beneficiation plant, partly beneficiated ore is processed, and a saleable product produced. Waste is pumped through a separate pipeline to mined-out areas and released. All processing is done at the island-based processing plant. Product from the beneficiation plant is barged to shore for sale. The dredge production is identical to Configuration 2. Figure 6.5 illustrates this configuration.

Barges or vessels are only needed to transport the product to the final destination. No extra cost was added since the final destination is not known.

Capital costs are summarized in Table 6-11. The only difference from Configuration 2 is the the island cost, and pipeline cost.

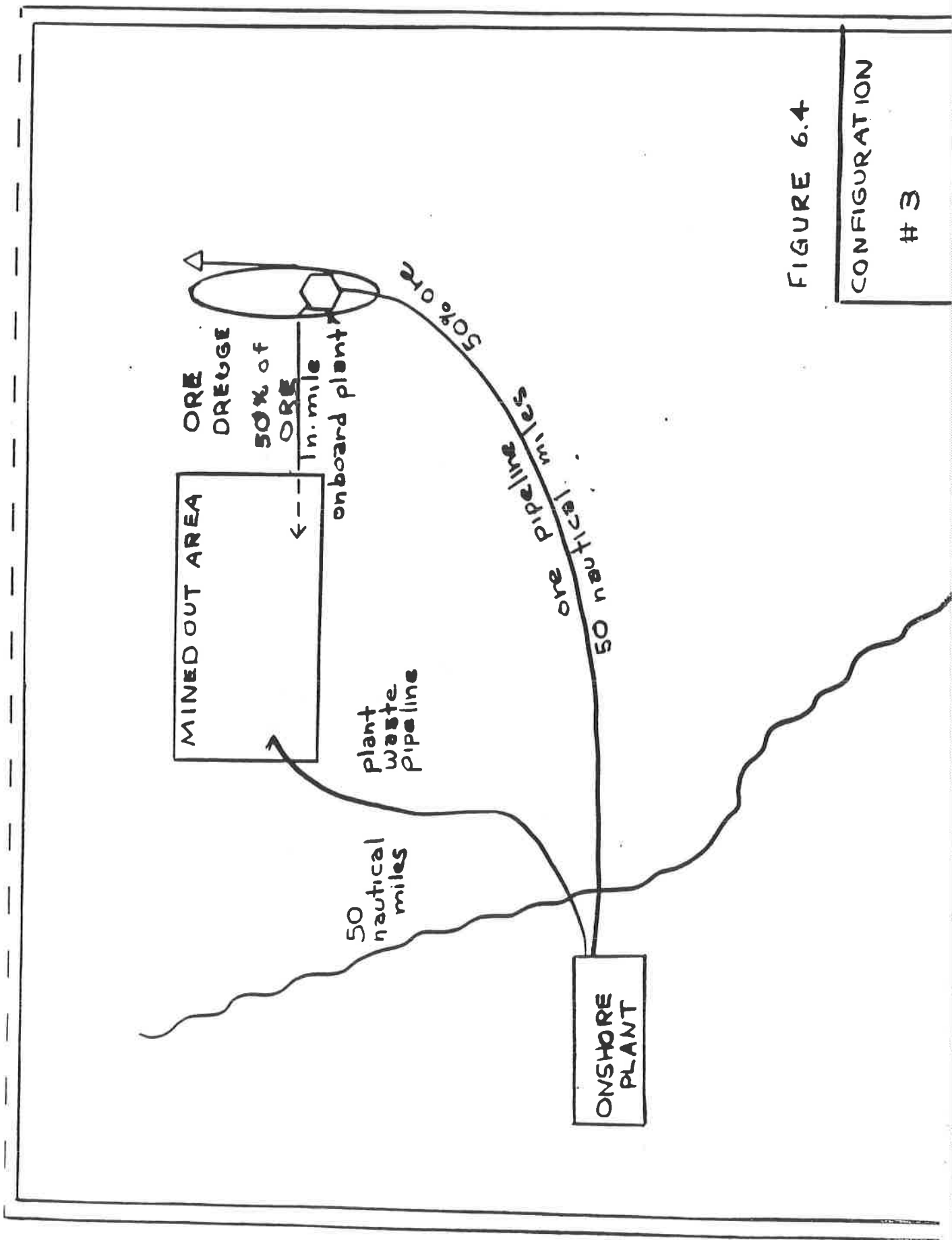


FIGURE 6.4

CONFIGURATION

3

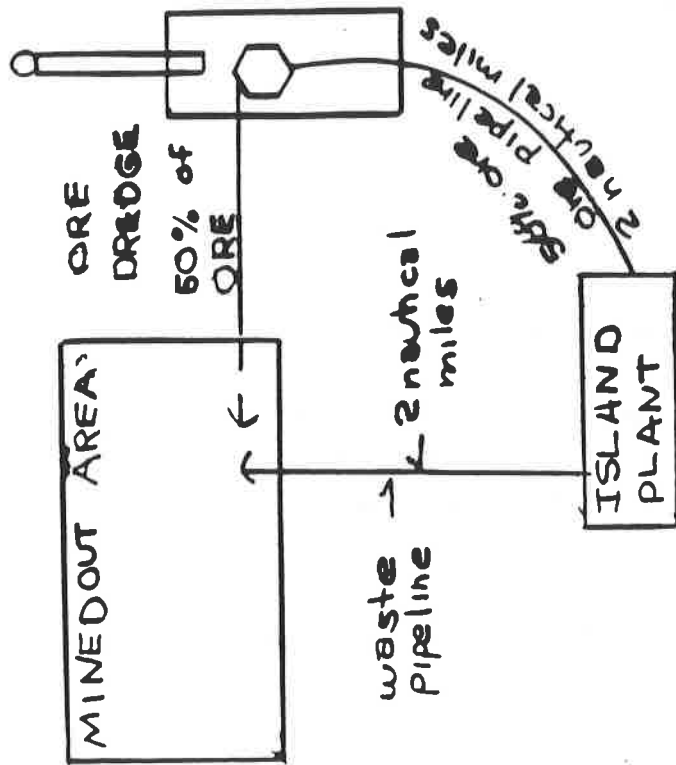


FIGURE 6.5

CONFIGURATION

4

Table 6-11
Capital Cost Configuration 4

<u>Item</u>	<u>mm \$ Unit Cost</u>	<u>No.</u>	<u>Total Cost</u>
Ore dredge	40,000,000	1	40,000,000
Beneficiation plant	27,000,000	1	27,000,000
Onboard plant	13,800,000	1	13,800,000
Island	60,000,000	1	60,000,000
Pipelines	2,500,000	2	5,000,000
Infrastructure & Misc.	30% of above		43,700,000
Total Capital			<u>189,500,000</u>
Tonnes mined			18,300,000
\$ per tonne annual production (mined)			10.36
\$ per tonne (mined) mine life (20 years)			.52

Operating costs for dredge costs and waste disposal were computed using Zellars-Williams operating cost model. Plant costs are from the U.S.B.M. model. Table 6-12 summarizes the operating costs.

Table 6-12
Operating Cost Configuration 4

<u>Item</u>	<u>\$ Cost per tonne</u>
Mining	.42
Plant (onshore)	.90
Plant (offshore)	.09
Waste/water	<u>.51</u>
Total	<u>1.92</u>

The total cost for comparison of Configuration 4 is \$2.44 per tonne of product.

6.2.3 Selection of Configuration

It is evident that from a material handling standpoint, the offshore plant should be more efficient. Material is processed near the plant and wasted near the plant in mined-out areas. With onshore plants, washed matrix is hauled 50 nautical miles by barge and tug, processed, and the waste hauled 50 nautical miles back to the mined-out pits for disposal. Table 6-13 outlines comparative capital and operating costs for each configuration. Based upon this trade-off study, Configuration 4, utilizing an offshore plant, was selected as the basis for examining the economic feasibility of exploiting offshore heavy minerals. This configuration is developed in further detail in the following parts of this section.

Table 6-13
Configuration Selection
\$ per tonne concentrate

<u>Configuration</u>	Annual Production		<u>Capital</u>	<u>Operating</u>	<u>Total</u>
	<u>Tonnes</u>				
1	851,000	\$.74	\$3.69	\$ 4.43	
2	18,300,000	.83	2.19	3.02	
3	Not feasible (no economics done)				
4	18,300,000	.52	1.92	2.44	

- Configuration 1) Sea-going hopper dredge for mining and transportation to an onshore plant.
- Configuration 2) Seagoing hopper dredge mining and barge transportation of ore to an onshore plant.
- Configuration 3) Dredge mining, pipeline transportation of ore to onshore plant.
- Configuration 4) Dredge mining, pipeline transportation of ore to nearby offshore island plant.

6.2.4 Design Criteria

Table 6-14 lists the design criteria used for determining production limits, operating costs, equipment needs, and capital requirements of the selected configuration. As with any mining project, the physical and chemical geologic parameters are site-specific, having been determined by nature. These characteristics were based upon the initial mine site selected in Section 5.1.1.

Operating factors were determined by past experience, as well as consideration of the unique mining environment. In the case of offshore dredging, it is necessary to consider the size and design of the dredge from a seaworthy standpoint. A large vessel is necessary to accommodate the mining depths; therefore, required size is somewhat independent of production. The largest dredge pumps operating in ocean mining today have a suction head pipe diameter of 1200 mm (48"). For the conditions of offshore Georgia, a 900 mm diameter (36") suction head pipe was used to determine productivity. The design philosophy is to use the largest practical dredge pump, mounted on a seaworthy vessel. For example, a dredge pump producing half the capacity of a 900 mm dredge pump gives only a small reduction in capital and operating costs. Therefore, the design philosophy maximizes production while minimizing the costs.

Table 6-14
Design Criteria

o Grade Criteria:

Feed Grade:

Ilmenite	5.31%
Rutile	.35%
Leucoxene	.87%
Zircon	.62%
Monazite	.17%

o Recoveries:

	<u>Mine</u>	<u>Wet</u> <u>Mill</u>	<u>Dry</u> <u>Mill</u>
Ilmenite	92%	83%	97%
Rutile	92%	85%	97%
Leucoxene	92%	70%	95%
Zircon	92%	92%	90%
Monazite	92%	70%	90%

Table 6-14 (continued)

o Operating Factors	
Dredge and Washer	4,700
Beneficiation Plant	4,700
o Mining Data	
Average Water Depth	27.2
Maximum Mining Depth (below MSL)	41.4
Average Mining Depth	37.6
Maximum Ore Thickness	11.8
Average Ore Thickness	10.4
Ore Density, tonnes/cm	1.78

Note: Oceanographic information is contained in Table 5-15.

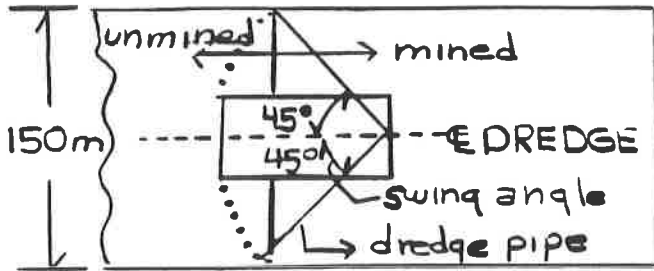
Section 4 lists the available state-of-the-art technologies. Anchored hopper dredges have been used successfully in the Pacific Ocean for commercial sand and gravel mining. The heavy mineral sands are not consolidated, so a system utilizing this dredge is reasonable.

6.2.5 Mining System

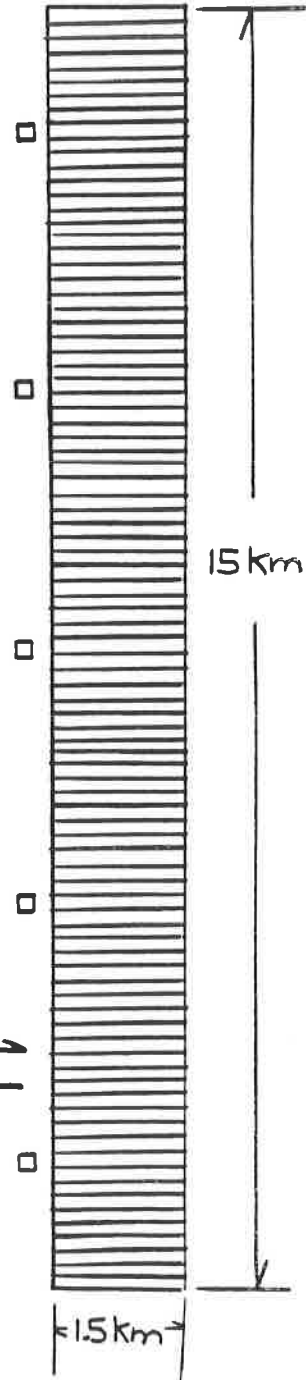
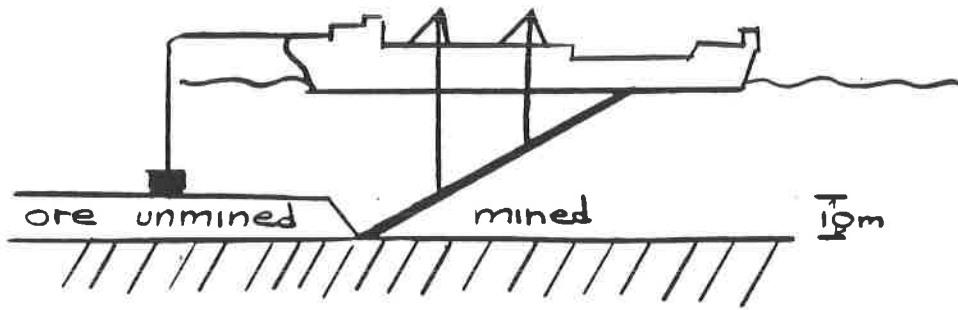
The heavy mineral mining area shown in Figure 6.6 is 15 km long and 1.5 km wide. This is a simplified depiction of the strand identified and selected for mining. The anchor suction dredge will start mining at the south end of the mining area. By moving forward slowly through winches operating against anchors, the dredge is able to mine the full 10 meter face. Movement side-to-side is controlled by winches which swing the dredge about 45° each side of the center line. With the anchor pivot point 100 meters from the dredge intake, the dredge can mine about 150 meters wide. This "150-meter width" is called a panel.

The anchor dredge starts mining at the south end of the mining area. Movement across the narrow orebody is accomplished by mining panels 150 meters wide. Within these panels a cut face, about 10 meters deep by 150 meters wide, is developed. After the dredge finishes mining the first panel, it reverses direction and mines the adjacent northern panel. Dredge movement is alternately east to west, then west to east, in panel increments. Mine advance is south to north.

PLAN VIEW
MINING PANEL



ELEVATION VIEW DREDGE



MINING ADVANCE ↑

DREDGING DIRECTION ⇄

- Plant locations
- ▬ mining panels

FIGURE 6.6

On-board the dredge is a wet mill designed to eliminate 50% of the ore which is without heavy minerals. This wet mill is fed directly from the dredge. Waste material from the washer plant is placed in a collection hopper, dewatered to 40% solids, and pumped to mined-out panels. For the first 1000 meters of mining, waste must be disposed of outside the mining area. From this point, a steady-state operation is reached, with disposal 1000 meters from mining. Any closer than 1000 meters could result in some waste being carried into the present mining operations. If necessary, preventive measures, such as turbidity curtains could be maintained between the mining area and the disposal site. However, with 1000 meters between the disposal areas and current mining, it is not anticipated that disposal in mined-out areas will drift into and dilute currently mined ore.

The waste disposal pipe is 24"-30" in diameter and is attached to the dredge with flexible pipe. The pipeline is attached to flotation devices every 50 meters. A small tug will be required to move the pipe into position for waste disposal.

Concentrate from the wet mill is placed in a distribution hopper, dewatered to 40% solids and pumped to the floating dry mill. A 20" pipeline is required to pump 1600 tonnes per hour. When distance exceeds 2.1 km, the dry mill is moved 3 km north and continues to operate at that location until pumping distance again exceeds 2.1 km. Again, the dry mill moves 3 km north. Over 20 years of mine life, the dry mill is moved four times. More mill detail is given in Section 6.3

6.3 PROCESSING

6.3.1 Design Basis

The processing facilities are designed to recover rutile, ilmenite, leucosene, monazite, and zircon from heavy mineral sand deposits typical of those found off the coast of Georgia. Processing facilities include an initial concentration plant (wet mill) located onboard the dredge, and a platform-mounted recovery plant (dry mill) located 1 to 3 miles from the wet mill. Sea water will be used for processing at both the wet and dry mills.

Because of probable periods of unscheduled maintenance and unfavorable sea conditions, the dredge wet mill and dry mill are scheduled to operate 250 days per year, 21 hours per day with a 90% availability. This results in 4,725 operating hours per year.

The mineral distribution in the mineral sand deposit is calculated from Open File Report, USBOM 87-04, using annual production estimates for mean grades of the minerals. The in-situ mineral distribution is summarized in Table 6-15.

Table 6-15
Percent Distribution of Individual Minerals
(in-situ)

<u>Mineral</u>	<u>Mineral Classification</u>	<u>Percent of</u>	
		<u>Ore</u>	<u>Mineral</u>
Ilmenite	Heavy	5.31	72.54
Rutile	Heavy	0.35	4.78
Leucoxene	Heavy	0.87	11.89
Zircon	Heavy	0.62	8.47
Monazite	Rare Earth	0.17	2.32
Totals		<u>7.37</u>	<u>100.00</u>

Overall recovery for the orebody for the individual minerals is presented in Table 6-16. The overall recovery of 72.42% was based on a mining recovery of 92%, an average wet mill recovery of 82%⁽¹⁾, and an average dry mill recovery of 96%⁽¹⁾. Product tonnages are based on 15,300,000 tonnes/year of ore to the dredge.

6.3.2 Initial Concentration Plant (Wet Mill)

The initial concentration plant or wet mill is located onboard the dredge. The onboard processing facilities include trommel screens to eliminate

(1) Based on "in-house" information of recoveries at heavy mineral operations and are considered a realistic representation of the products which could be recovered.

Table 6-16

Percent Distribution of Heavy Minerals to Final Product

Mineral	Distribution		Weighted % Distribution of Minerals						Overall		Product	
	Ore % in-situ	Mineral % in-situ	Tonnes in-situ	Mining Rec.	Mining %	Wet Mill Rec.	Wet Mill %	Dry Mill Rec.	Dry Mill %	Overall Rec.	Overall Wt %	Product Tonnes
Ilmenite	5.31	72.54	812,419	92	66.74	83	55.39	97	53.73	74.07	53.73	601,750
Rutile	0.35	4.78	53,534	92	4.40	85	3.74	97	3.63	75.85	3.63	40,600
Leucoxene	0.87	11.89	133,163	92	10.94	70	7.66	95	7.27	61.18	7.27	81,460
Zircon	0.62	8.47	94,861	92	7.79	92	7.17	90	6.45	76.18	6.45	72,250
Monazite	0.17	2.32	25,983	92	2.13	70	1.49	90	1.34	57.96	1.34	15,040
	7.32	100.00	1,119,960	92	92.00	82	75.45	96	72.42	72.42	72.42	811,100
			(1)									(2)

Notes:

- (1) $(15,300,000 \text{ tonne/year ore}) \times (.0732) = 1,119,960 \text{ tonne/year in-situ minerals in ore.}$
- (2) $(1,119,960 \text{ tonne/year minerals}) \times (.7242) = 811,100 \text{ tonne/year recoverable minerals.}$

oversize material (+10 mesh), cyclones to reduce fines (-200 mesh), and spirals to concentrate the heavy minerals and reject the lighter fractions. Spirals were chosen because they are least affected by ship motion production by wave action.

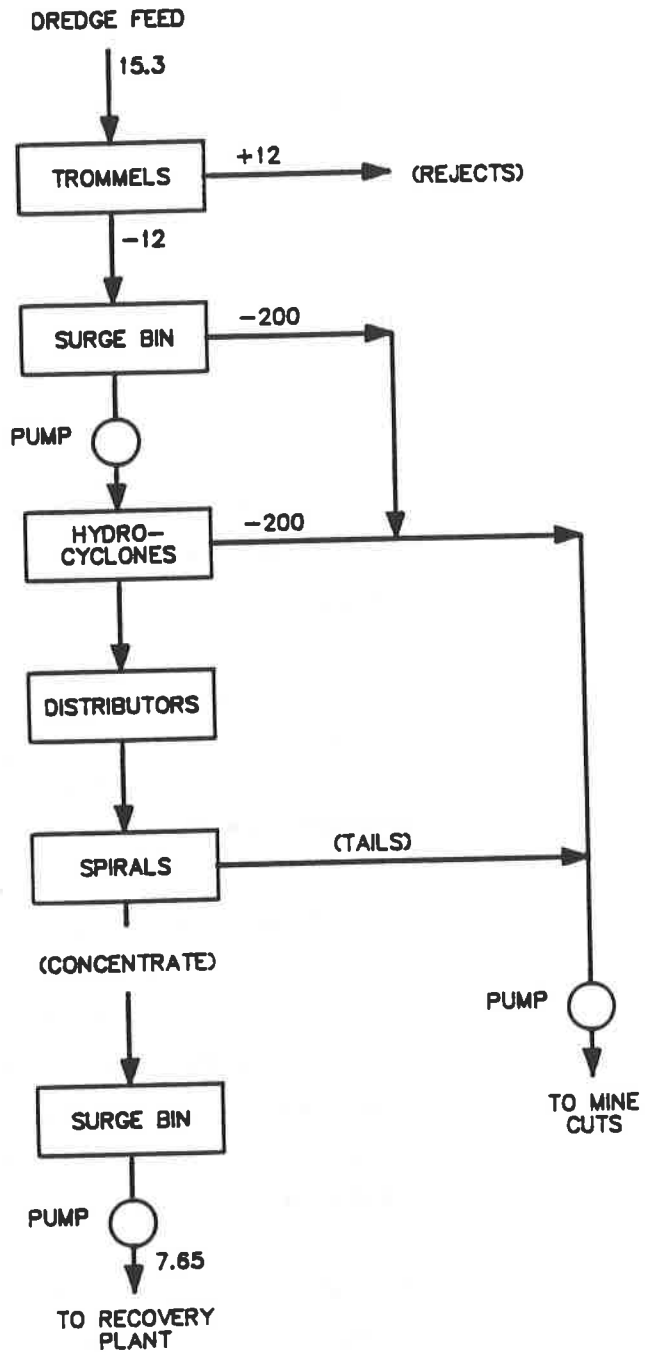
Approximately 50% of the ore consisting of +10 mesh rejects, -200 mesh fines (sediments) and spiral tails is eliminated at the wet mill. This reject material is combined and pumped to the mined-out areas for disposal. Typically, the discharge point would be well below sea level in order to minimize dispersion.

Spiral (rough) concentrate is collected in a surge bin (4 hour capacity) and is then pumped to the platform-mounted recovery plant or dry mill. A flowsheet/material balance for the initial concentration plant is given in Figure 6.7

6.3.3 Recovery Plant (Dry Mill)

Rough concentrate from the wet mill reports to a feed surge bin. The bin is designed to provide about 8 hours of live feed storage, smooths out upstream process surges, and helps to maintain a constant rate of feed to the recovery plant. When the bin overflows, it also removes fines. Feed is reclaimed from the storage bin as a slurry and is pumped to the primary vibrating screens where +48 mesh material is removed and sent to the rod milling circuit. The rod mill discharge is treated by hydrocyclones to remove -200 mesh fines and then returned to the primary vibrating screens.

Minus 48-mesh sand from the primary vibrating screens is passed through rougher cone concentrators (Reichert cones), and then concentrating tables, to produce a material containing 70 to 80 percent heavy minerals. Tailings from the cones and tables are sent to scavenger cones to recover additional heavy minerals. The scavenger concentrate is recycled to the rougher cones, while the scavenger tails are discarded.



XXX - DENOTES RATE IN MILLION DRY TONNE/YR.

GEORGIA OFFSHORE
MINERALS ASSESSMENT
DATE: 5-17-88 BY: MEK

ZW INITIAL CONCENTRATION PLANT
FIGURE 6.7

A458019A

Most of the ilmenite contained in the heavy mineral concentrate is removed using high-intensity wet magnetic separators. The remaining material is dewatered using classifiers, then dried and heated prior to electrostatic separation. A high tension electrostatic separator is used to separate the conductors (ilmenite, rutile and leucoxene) from the non-conductors (monazite and zircon). A middling fraction is returned to the high tension electrostatic separator feed.

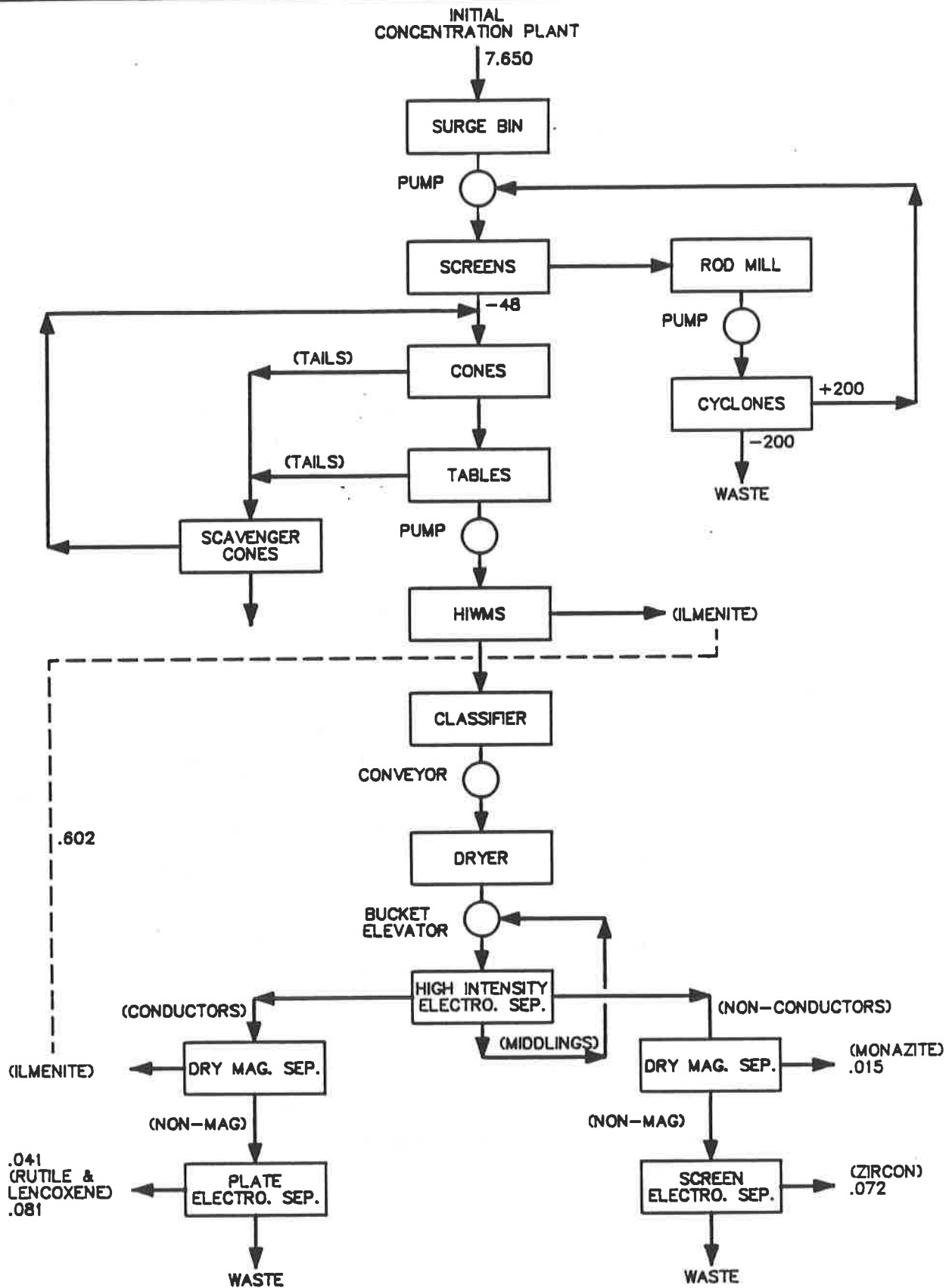
Conductors first report to a dry magnetic separator to recover ilmenite not removed by the high-intensity wet magnetic separators. The non-magnetic conductors are then concentrated into a rutile-leucoxene fraction using plate electrostatic separators. A middling fraction is returned to the plate electrostatic separator feed.

Non-conductors from the high tension electrostatic separators are fed to dry magnetic separators where the monazite fraction is recovered. The non-magnetic non-conducting material then flows to screen electrostatic separators which recover the zircon fraction.

A flowsheet/material balance for the recovery plant is given in Figure 6.8.

In practice, the waste streams from the plate and screen electrostatic separators usually contain other minerals such as sillimanite, kyanite and staurolite, which can be recovered as byproducts. "Zircor" is a product made by heating sillimanite, kyanite and zircon, and marketed as a foundry sand substitute for zircon.

The -200 mesh fines (sediment) and most of the tailings from the dry mill will be combined and pumped to the mined-out areas. Typically, the discharge point would be well below sea level in order to minimize dispersion. The discharge line would require periodic tending to move the effluent point for even distribution of the mined area backfill.



XXX - DENOTES RATE IN MILLION DRY TONNE/YR.

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RECOVERY PLANT
FIGURE 6.8

A458020A

6.3.4 Water Requirements

Water is used extensively in mining and beneficiation as a processing medium and as a means of transporting solids in the form of aqueous slurries. The source of water for the initial concentration plant (wet mill) and the recovery plant (dry mill) is sea water.

It is assumed that the recovery plant efficiency and/or product quality is not affected by the presence of chlorides (sea salt) and that a fresh water wash is not required.

6.3.5 Product Storage and Loading

Products from the recovery plant will be stored in bins and transferred to vessels/barges alongside the platform, via a shiploader.

6.4 CONFIGURATION AND INFRASTRUCTURE

The most favorable configuration for the exploitation of heavy minerals offshore Georgia requires the use of state-of-the-art ocean mining equipment. Seabed mining world-wide is dominated by pump-type ocean-going vessels having hoppers to contain and transport dredged materials. These dredges are known as suction hopper dredges. They may be of the trailing suction head type, or they may be of the leading suction head type. The latter type, which operates at anchor, is preferred for heavy minerals because it permits excavation of the entire mineral-bearing sand horizon. Since no overburden sediments occur in the area targeted for mining, this type dredger will remove all of the mineral-bearing sand within the scope of its anchor chain and suction pipe arm before moving forward. These dredges are essentially ocean-going seaworthy vessels equipped with the specialized apparatus required, and are built in European, Taiwanese, Korean and Japanese shipyards. United States shipyards are not able to compete in this market.

The preferred dredge is a vessel with a hopper capacity of about 5000 m³. The hydraulic mining system consists of a suction head, suction pipe arm, a submerged slurry pump, and on-board booster pumps.

This dredge must be capable of mining to about Elevation -140, or 160 to 170 feet below sea level. Depending on specific design, the suction arm will be as much as 300 feet long. The lower end of the arm is hinged to permit raising and stowing within the length of the vessel.

Mineral sands mined from sea bottom are pumped as a solids-water mixture by the submerged pump to an on-board wet processing mill. The wet mill rejects oversize, barren light weight particles and tailings which are wasted overboard. About 50% of the mined materials are rejected from the shipboard plant, and directed to previously mined cuts at sea bottom. The concentrated mineral-laden sands are collected in the hopper. This hopper acts as a live storage sump feeding the suction side of the booster pump(s) which transfer the concentrate slurry to a nearby dry mill via semi-submerged surface buoyed pipeline.

The dry mill completes beneficiation of the mineral sands through a series of unit process steps, each of which produce five or more minerals having value. The complete dry mill is located on a square-hull type semi-submersible platform anchored nearby. Rejects from the dry mill, consisting of sand tailings and sediments, are combined and discharged by pipeline to the mined-out cuts. Products comprising the four heavy minerals and rare earths are separately stored in bins to provide several day's storage. Bins are unloaded by conveyors which transfer material to a ship loader.

The platform envisaged is similar to one designed by Marcon Engineering of the Netherlands (Norrning 4). This is a four-column, square-hull, semi-submersible production platform having two 246-foot square main decks. The upper deck is the platform on which the dry mill and ancillary facilities are located. The lower deck contains crew quarters, and all the facilities required to sustain life in a comfortable fashion. The lower deck also contains storage and maintenance facilities. Cantilevered sections extend the effective area of each deck to accommodate shiploading and unloading, heliport, and other features required.

The dredger and floating production platform (FPS) are self-contained and, to a great extent, are self-sustaining. They require no direct service link to the mainland, or to land-side facilities, other than for re-supply and to transport workers. One ocean-going tugboat is assigned to service the mining operation. This tug is equipped with a rotating lift crane suited to at-sea maintenance and repair work. The tug moves and positions pipelines as mining progresses.

All offshore operations will be based on work crew cycles of two weeks duty and one week off. This requires three completely staffed crews of operating, maintenance and supervisory personnel. While on duty, offshore personnel work 14 twelve-hour shifts, for a total of 168 hours each three week cycle. The wages for this work schedule is based on 40 hours per week, three weeks, 120 hours at regular time, and 48 hours at premium time. All meals and sleeping accommodations are provided by the enterprise at no cost to employees.

A motor launch will be provided to transport personnel and supplies from the island to the location of the turning basin in Port of Savannah. The launch will be seaworthy in all but severe weather conditions and capable of making ± 30 knots so that a one-way trip takes no longer than one hour.

Accommodations, consisting of two-bed cabins, each complete with lavatory and shower, clothes lockers and desks are provided. Each offshore operating location contains its own accommodations. A fully-equipped kitchen, provisioned commissary and staff will prepare and serve three meals each day in a dining room. Library, television, and indoor activity rooms will be provided. Physical exercise and conditioning facilities, both indoor and outdoor, will also be provided.

The FPS facilities will include a first-aid station, with a nurse, to attend to minor maladies and injuries. A heliport will enable the rapid evacuation of seriously sick, or injured, persons to mainland hospitals.

Diesel engine electric generators supply power for the marine/vessel systems, the beneficiation plant, living quarters, and to meet other demands as required to make the semi-submersible floating production system totally self-sustaining.

Finished heavy mineral and rare earth products of about 810,000 tonnes per year are loaded aboard bulk cargo vessels on barges for transport to destination. This configuration proposes shipping to Port Savannah by enterprise operated barges, and offloading, warehousing, and distribution by other commercial operators. The point of sale is FOB, Port Savannah.

The configuration selected, using currently available technology and equipment, makes possible the early implementation of the programs required to exploit heavy minerals offshore Georgia. The dredger and FPS have the flexibility to recover mineral-bearing sands at whatever location on the OCS their occurrence warrants it, at the least economic and technical risk.

6.5 ESTIMATED CAPITAL COST

This section deals with the expenditures required to implement a heavy minerals mining-beneficiation operation having the configuration and features previously described. Estimated cost is based on conceptual and schematic designs, and is order-of-magnitude having an accuracy of plus or minus 30%.

6.5.1 Capital Cost

Estimated capital cost has been prepared by combining techniques developed by the U.S. Bureau of Mines, together with generally accepted methods by factoring in-house or researched information. Dredges, wet mill, and dry mill cost estimates are based on formulas contained in Bureau of Mines Open File Report 4-87. Cost of the semi-submersible production platform is based on data published in Ocean Industry, April 1988.

Table 6-17, Heavy Minerals Mining Enterprise Total Facility Capital Cost Estimate, is a summary of the total capital cost required to construct the offshore phosphate mining facilities described in this section. Twenty percent is included as an allowance for costs which will be incurred for items not now predicted. Total capital costs include design, engineering, procurement, and construction management services as are applicable to each item.

6.5.2 Pre-production Cost

Pre-production cost in the amount of 10 million dollars is included as a part of the total investment required to implement the proposed enterprise mining scheme. This cost is intended to include the extensive drilling, sampling, and testing programs required to accurately identify the areal extent and grade-quality characteristics of the Middle Miocene targeted for exploitation. This cost is also intended to include the cost of limited studies required to obtain permits. This program would include exploratory drilling to the extent required to describe and define economically mineable reserves, based on the most effective beneficiation process flowsheet developed by the test work. This program includes the cost of bulk sample collection and a pilot plant test program to verify and refine the process flowsheet, material balances, reagent and water consumption, and recovery efficiencies such as are required to provide criteria and parameters for design and detail engineering. No interest is charged for the use of this money because it is assumed that these expenditures are in the nature of the regular research and development costs incurred by enterprises engaged in commercial minerals exploitation. Payback of pre-production/development cost is, however, included as a part of the total investment required by the enterprise.

This program will be conducted over a period of 24-30 months and will be followed by a comprehensive economic analysis based on the latest market supply-demand price scenarios. A list of the tasks/objectives to be accomplished during this pre-production period before design and detailed engineering is undertaken is listed below.

Table 6-17
Heavy Minerals Mining Enterprise - Total Facility
Capital Cost Estimate

	<u>Cost</u> <u>\$X1000</u>
Floating Production Platform	\$ 66,100
Suction Hopper Dredge	45,800
Trailing Pipelines	3,800
Waste Disposal at Sea System	1,100
Tugboat	2,500
Wet Mill (aboard dredge)	12,800
Dry Mill (aboard platform)	26,300
Product Storage	4,400
Shiploader	9,200
Product Transport (tug-barge)	<u>22,800</u>
Sub-total	\$194,800
Contingency, 20%	<u>39,000</u>
TOTAL	<u><u>\$233,800</u></u>
 Round-out and use	 \$235,000

Capacity Basis

Mineral sands mined	15,300,000 tonnes/year
Intermediate product	7,650,000 tonnes/year
Final heavy mineral product	811,000 tonnes/year

- o drilling
- o sampling
- o geologic database update
- o bench scale test work
- o economic cutoffs applied
- o reserves estimates
- o bulk sampling
- o pilot scale test program
- o fresh water rinse tests
- o acidulation test work to determine amenability of concentrate to acidulation of fertilizer manufacture
- o preliminary mine plan
- o preliminary design of dredges and ancillaries
- o island construction engineering alternatives evaluated
- o environmental issues identified
- o cost and likelihood of permitting estimated
- o lease and royalty fees/costs established
- o capital cost estimates
- o implementation plan and schedule
- o supply-demand and market scenarios
- o identify potential market
- o current product selling price
- o bankable document report.

The decision to move forward to implementation by contracting for detailed engineering, procurement, and construction can be taken with a high degree of confidence in the reliability of the economic analysis. Technological and economic risks will have been reduced to an acceptable level. If the economics are favorable and the market supports sales price and demand premises, the final phase of implementation can be initiated.

6.5.3 Replacement Capital

The employment of capital to replace equipment when its useful life has expired is replacement capital. Useful life is based on the concept that the level of maintenance is as required to keep the equipment (facilities)

operational at an acceptable level of production. Useful or economic life is the period (time in years) until the failure rate increases to such an extent that it is no longer economical to operate.

The proposed mine-mill complex operation and production is based on certain mechanical availability. This level of mechanical availability is the result of regular and scheduled shut-down maintenance. Maintenance expense for parts, supplies, and labor is included in operating cost.

The severe service and adverse climatic environment requires a high level of regular and preventive maintenance. During scheduled periods when all facilities are shut down while the dredger and floating production system are in dry-dock, certain capital will be employed to sustain the equipment and facilities at design production capability. The additional sum of 3 million dollars per year is allowed as replacement capital. It is anticipated that this will maintain facilities at design level for a period of 30 years, without requiring the employment of additional replacement capital. The only exception is in the event technologically superior replacement equipment is warranted as justified by the economics of increased production.

6.5.4 Working Capital

- o Ordinary operation of a business involves a circulation of capital within the current asset (capital cost) group. Cash is expended for materials (parts, supplies, expendibles), labor and services (electric energy, rental, fees, royalty, ...) and these expenditures are accumulated as costs. These costs are converted (concentrate inventories) into receivables and ultimately (back out by shipment) into cash again.
- o The average time intervening between the acquisition of materials or services and expenditure for labor, entering this process and final cash realization constitutes an operating cycle.
- o The amount of capital committed (taken out of current funds or borrowed) to this cycle is working capital.
- o Cost of working capital (interest) is added.

The working capital requirement for this enterprise is estimated to be equal to about 20 days total cash production cost. To simplify economic analysis, working capital of \$3,300,000 is used throughout and recovered in the last year.

6.6 ESTIMATED OPERATING COST

Operating costs for dredging were taken from the ZW dredge module. Operating costs for transportation, ore pumping, and waste disposal were also taken from ZW cost modules.

All plant operating costs were taken from formulas in the U.S.B.M. report for heavy minerals. A description of these formulas is given in Section 5.2.2. A complete discussion of ZW modules is given in Section 5.7

Operating costs are listed in Table 6-18.

Table 6-18
Operating Costs

	<u>\$ per tonne mined</u>	<u>\$ per tonne product</u>
Dredge	.41	7.73
Onboard plant (washing)	.09	1.70
Offboard plant (concentration)	.90	16.98
Ore pumping	.16	3.02
Waste disposal	.08	1.51
Barge transportation	.02	.38
Administration, clerical	.16	3.02
Island Accommodations	<u>.05</u>	<u>.94</u>
TOTAL COST	<u><u>\$1.87</u></u>	<u><u>\$35.28</u></u>

6.7 ECONOMICS AND VIABILITY

6.7.1 Market Potential

The United States relies, to a large extent, on the import of certain heavy minerals and rare earths to supply domestic needs. Production and supply is for the most part dominated by Australia, which establishes quality standards and sets market price.

The heavy mineral-bearing sands also contain a host of other not readily identified rare earths for which the U.S. depends totally upon imports for supply. Many of these relate to strategic minerals required to sustain production of vital manufactured goods needed by the U.S. in the event of emergency. There is good reason to believe that the selling price of these minerals will continue to increase as demand grows. Recovery of the minor quantities of high-value rare earth minerals will add significantly to the revenue. These two factors will serve to improve viability and hasten the time when offshore recovery of these minerals is realized. The commitment, if made, by the private sector with the support of responsible agencies of the U.S. Government to pursue the programs necessary can achieve this objective. Some of what is required is described in Section 5.5.2 of this report, and is included as part of enterprise investment in the economic analysis which follows herein for heavy minerals.

6.7.2. Sales Price

Total annual revenue from sales is based on an average price for the suite of heavy minerals produced. The price is in dollars per tonne for bulk concentrates, FOB Port Savannah. The average selling price is obtained by computing the total annual sales revenue by summing the annual revenue generated by each of the five minerals. The sales price of each mineral was obtained by converting or otherwise adjusting current bulk quantity market prices quoted by Metal Bulletin and published in Industrial Minerals, April 1988.

It is important to recognize that the average sales price resulting from this computation is a totally hypothetical value based on a theoretical product mix and on recent quoted market prices for each product. No recognition can be made for grade or quality as these are unknown. The average sales price, computed as per the following table, is simply a convenient way to estimate annual sales revenue.

<u>Mineral</u>	<u>Annual Tonnes</u>	<u>Sale Price \$/tonne</u>	<u>Annual Sales Revenue</u>
Ilmenite	601,750	46.00	\$ 27,680,500
Rutile	40,600	430.00	17,458,000
Leucoxene	81,460	385.00	31,362,100
Zircon	72,250	248.00	17,918,000
Monazite	<u>15,040</u>	570.00	<u>8,572,800</u>
TOTAL	<u>811,100</u>		<u>\$ 102,991,400</u>
Average Selling Price, FOB Savannah			\$ 126.98

6.7.3 Economic Analysis

The discounted cash flow rate of return on investment (DCFROR) method of economic analysis is used to evaluate the viability potential of exploiting offshore Georgia heavy minerals as proposed in this study. DCFROR is computed in the same manner described for phosphates in Section 5.7.2. This procedure is repeated for scenarios of investment, income (sales price) and operating cost to gain an understanding of sensitivity. All economic values are based on constant 1988 dollars. A charge computed at 5% of the average product-tonne sales price is included to cover the estimated cost of royalty or severance tax.

Each scenario is represented by a separate computer run computation of DCFROI and net present value (NPV). A copy of the computer printouts is included at the end of this section.

Extraordinary costs associated with start-up are accounted for by taking into income 410,000 tonnes of product sales, and taking as cost the production of 811,100 tonnes. This procedure is used in each case.

Table 6-19 is a summary of DCFROR results for base case investment and operating costs, and for one sales price and revenue scenario.

Table 6-19**Base Case**

<u>Average Sales Price \$/tonne</u>	<u>Construction Capital Millions Dollars</u>	<u>Product Cost \$/tonne</u>	<u>DCFROR %</u>
\$127.00	235	42.53	4.2

6.7.4 Sales Price Sensitivity

Sensitivity to sales price is indicated by the results of economic analyses at increased sales price, in increments of 10%, with all other costs remaining constant. Table 6-20 illustrates sensitivity to sales price.

Table 6-20
Sales Price Sensitivity

<u>Avg. Sales Price \$/tonne</u>	<u>Increase %</u>	<u>DCFROR %</u>
130.70	+10%	6.8%
152.40	+20%	9.0%
165.10	+30%	11.7%

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 Title: HERMINI

5/13/88

HEAVY MINERALS
 (Thousand \$ per Year)
 BASE CASE

Project Year	-5	-4	-3	-2	-1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Sales Revenue						.41	.81	.81	.81	.81	.81	.81	.81	.81	.81	.81	.81	.81	.81	.81	.81	.81	.81	.81	.81
Production, Million TPy						127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00	127.00
Sales Price, \$/Tonne						52070	182870	182870	182870	182870	182870	182870	182870	182870	182870	182870	182870	182870	182870	182870	182870	182870	182870	182870	182870
Total Revenue						7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73	7.73
Production Costs						1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70
Direct Production Costs \$/Tonne						16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98	16.98
Mining						.38	.38	.38	.38	.38	.38	.38	.38	.38	.38	.38	.38	.38	.38	.38	.38	.38	.38	.38	.38
On Board Processing (Wet Mill)						1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	1.51	
Slurry Transport (Dry)						3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	
Platform Processing (Dry Mill)						.94	.94	.94	.94	.94	.94	.94	.94	.94	.94	.94	.94	.94	.94	.94	.94	.94	.94	.94	
Vessel Transport						3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	3.02	
Waste Disposal						35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	
Sugar, Clerical, Tech						.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20
Offshore Accommodations						.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25
Total Cash Cost						6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	
Indirect Production Cost, \$/Tonne						.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20
Administration						.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25
Sales						6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	
Royalty @ 5% of sales price						.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20	.20
Taxes (misc)						.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25	.25
Other						7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	
Total Indirect Cost						42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	42.53	
Total Production Cost						28910	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	
Total Cash Cost, \$/yr						5946	5073	5073	5073	5073	5073	5073	5073	5073	5073	5073	5073	5073	5073	5073	5073	5073	5073	5073	
Total Indirect Cost, \$/yr						34876	34450	34450	34450	34450	34450	34450	34450	34450	34450	34450	34450	34450	34450	34450	34450	34450	34450	34450	
Total Production Cost, \$/yr						17194	68420	68420	68420	68420	68420	68420	68420	68420	68420	68420	68420	68420	68420	68420	68420	68420	68420	68420	
Cash Flow (Revenue-Prod Cost)						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Investment						10000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Pre-construction						0	38000	60000	35000	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Construction Capital						0	1500	7000	15500	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Interest During Construction						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Total Investment						10000	31500	87000	105500	56750	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Principal						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Principal Payment						0	290750	304281	261675	247138	232000	218003	203255	189588	174450	159913	145375	130838	116300	101763	87265	72668	58150	43613	
Interest @ 10%						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Replacement Capital						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Working Capital						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Cash Flow (After Investment)						-10000	-31500	-87000	-105500	-56750	40706	42168	43614	45067	46521	47975	49429	50882	52336	53790	55244	56697	58151	59605	
Depreciation (7 yr AOCES)						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Depletion						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Taxable Income						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Tax Rate, %						0	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	
Income Tax						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Net Income After Tax						0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Cash Flow						-10000	-31500	-87000	-105500	-56750	40706	42168	43614	45067	46521	47975	49429	50882	52336	53790	55244	56697	58151	59605	
Annual Cash Flow						-10000	-41500	-126000	-234000	-290750	-255303	-210575	-165593	-121417	-76803	-32165	12165	39521	67622	91068	127359	158354	187300	213000	

HEAVY MINERALS
 (Thousand \$ per Year)
 BASE CASE
 (1.30X SALES PRICE)

Project Year	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013
Sales Revenue																									
Production, Million TPY																									
Sales Price, \$/Tonne																									
Total Revenue	67691	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731	133731
Production Costs																									
Direct Production Costs \$/Tonne																									
Mining																									
On board Processing (Net Mill)																									
Slurry Transport (One)																									
Platform Processing (Dry Mill)																									
Vessel Transport																									
Waste Disposal																									
Super, Clerical, Tech																									
Offshore Accommodations																									
Total Cash Cost	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28	35.28
Indirect Production Cost, \$/Tonne																									
Administration																									
Sales																									
Royalty @ 5% of sales price																									
Taxes (misc)																									
Other																									
Total Indirect Cost	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16	9.16
Total Production Cost	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44	44.44
Total Cash Cost, \$/yr	28930	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577	28577
Total Indirect Cost, \$/yr	7508	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416	7416
Total Production Cost, \$/yr	36438	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993	35993
Cash Flow (Revenue-Prod Cost)	0	0	0	0	0	31253	97738	97738	97738	97738	97738	97738	97738	97738	97738	97738	97738	97738	97738	97738	97738	97738	97738	97738	97738
Investment																									
Pre-construction	10000																								
Construction Capital	0	30000	80000	92000	35000																				
Interest during Construction	0	1500	7000	15500	21750																				
Total Investment	10000	31500	87000	105500	56750																				
Principal	0	0	0	0	0	290750	528	261675	247130	232600	210863	203525	189988	174450	159913	145375	130838	116300	101763	87225	72688	58150	43613	29075	14538
Principal Payment	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Interest @ 10%	0	0	0	0	0	29075	53	26160	24714	21260	21086	20353	18999	17445	15991	14538	13084	11630	10176	8723	72689	5815	4361	2908	1454
Replacement Capital	0	0	0	0	0	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000
Working Capital	0	0	0	0	0	16500	16500	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Cash Flow (After Investment)	-10000	-31500	-87000	-105500	-56750	528	93835	68570	70624	71478	72932	74305	75839	77293	78747	80200	81654	83108	84562	86015	87469	88923	90377	91830	89984
Depreciation (7 yr RCRS)	0	0	0	0	0	41548	71285	50652	36315	25964	25935	25964	12967	0	0	0	0	0	0	0	0	0	0	0	0
Depletion	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Taxable Income	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Tax Rate, %	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Income Tax	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Net Income After Tax	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Cash Flow	-10000	-31500	-87000	-105500	-56750	528	74677	50931	49587	47553	46498	45842	45848	45848	45848	45848	45848	45848	45848	45848	45848	45848	45848	45848	45848
Cumul Cash Flow	-10000	-41500	-128500	-234000	-290750	-290222	-215545	-161614	-115067	-67464	-18946	30486	76334	118589	161789	205934	251024	297059	344039	391963	440833	490648	541488	593112	658154
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SECTION 7

ENVIRONMENTAL

7.1 ENVIRONMENTAL SETTING

In the present study, two areas are under consideration for potential exploitation of mineral occurrences. The phosphorite occurrence is located 5 nautical miles offshore Savannah, and the heavy minerals location under consideration is 35 nautical miles offshore Savannah. Both of these suspected occurrences lie within that broad portion of the southwestern Atlantic Ocean known as the Georgia Bight. This region is bound by Cape Fear, North Carolina to the north, and by Cape Canaveral, Florida to the south. The Georgia Bight extends seaward from the coast to the Florida-Hatteras Slope which represents the edge of the Continental Shelf. The coastal margin of the Bight in the vicinity of the mineral resources is characterized mostly by undeveloped sea islands and extensive coastal marshes and tributaries.

The scope of work and assignment described for this resource assessment study includes economic feasibility without the requirement to evaluate environmental considerations. This section presents a very brief overview and describes the kinds of things which would require comprehensive study in an EA or EIS. No attempt is made to describe the scope or content, nor to definitively estimate the cost of such studies.

Coastal/Estuarine Environment

Coastal Georgia is typified by a barrier island salt marsh regime. Sand beaches of mild relief face the open waters of the southeast Atlantic. Beaches give way to parallel dune lines placed by deposition of sediments transported through wave action. The dune areas generally protect a stand of coastal vegetation that grades from sea oats to salt-tolerant grasses, into oak and pine forests. Behind the islands lie protected salt marshes replete with tidal creeks, streams, and bays.

Salt marshes serve as a mixing zone for fresh water from coastal rivers with saltwater pushed into the marsh during tidal maximums. The dynamics of

tidal bore and streamflow drive an ecological mechanism fueled on nutrients and sunlight. Productivity in the salt marsh and estuaries forms the foundation of the marine food chain.

Resort and recreational developments are numerous and notable on the barrier islands. Jekyll, St. Simons, Sea Islands, and Tybee Islands, have commercially important resort areas, along with public access recreational areas. The status of these highly acclaimed vacation destinations gives credence to the value of Georgia's coastal natural resources. Interspersed with commercial developments are large areas of undeveloped lands in the form of parks, reserves, and wildlife management areas.

Jekyll Island State Park, the islands within the Savannah Wildlife Refuge, and Wolf Island National Wildlife Refuge and Wilderness Area are representative of areas that remain as undeveloped, or natural coastline. These sanctuaries of preserved natural ecosystems and geographic microcosms currently protect many coastal resources. Strict coastal zone management practices are now controlling further degradation of barrier islands, while allowing compatible development to continue.

Impacts to the beaches on the barrier islands, or to salt marshes and wetlands in the coastal zone, are a concern for the feasibility of any onshore or offshore activity. Review of the impacts should consider methods to improve the existing natural resource when possible, without defeating the mission of utilization of the discovered mineral.

Savannah River

The Savannah River has its headwaters in the Blue Ridge Province in northern Georgia. A significant freshwater river, it transverses a hundred or more kilometers and has a 27,392 km² drainage basin. Discharge of the lower river has been estimated at over 300 m³/s. Control structures, dams, and maintenance dredging have altered the natural hydraulics of the system and impacted the associated ecosystems.

Deepwater port facilities located on the Savannah River handle a variety of cargoes. Bulk shipments of dry and liquid products, along with increasing

numbers of container vessels from other U.S. and foreign locations, now utilize the historic port of Savannah. Continued use of the maintained channel by the river's many industrial facilities further emphasizes the nature of this busy port area. Forest products, petroleum, and basic chemicals are produced and shipped from the Savannah area. Georgia Port Authority reports cargo levels near seven million tons for the 1987 year at the deepwater facilities.

Development of the river frontage began in 1733 with the founding of the city by General James Edward Oglethorpe. General Oglethorpe's planned development of the city has matured into a major east coast port. Commercial and industrial developments along the river and on islands in the river are extensive, above and below the originally planned community.

At present, concern over the impact of developments on the river and in adjacent coastal marshlands has led to the promulgation of regulations governing future impacts. Due to the importance of the coastal marshlands and riverine wetlands on the river's ecological status, future developments are likely to occur only at suitable non-marsh or non-wetland locations.

Offshore

The width of the Continental Shelf in the Georgia offshore area is approximately 130 km. The depth of the shelf break off Georgia averages 56 m. The average depth of water at the location of the occurrences (heavy minerals) is 27.2 m, and at the location of the phosphorite occurrences in the Middle Miocene is 15 m.

The shelf is a marine extension of the Atlantic Coastal Plain which is relatively flat and slopes seaward an average of 36 cm/km.

The south Atlantic seafloor is over 80% sand bottom (Hollister, 1973; George & Staiger, 1979). Two major sedimentary regimes occur: an inshore area approximately 10 to 30 km wide characterized by fine to very fine-grained sand, and an offshore expanse stretching to the shelf-slope break covered by coarse-grained sediments (Gorsline, 1963; Henry & Hoyt, 1968). Off the

coast of Georgia this boundary is distinct and occurs quite consistently at a depth of 11 meters (Pilkey & Frankenberg, 1964). The near-shore shelf zone acts as an effective sediment trap, beyond which little sediment deposition occurs (Neiheisel & Weaver, 1967; Pilkey, 1963; Bigham, 1973). Distribution of minerals in Continental Shelf waters and sediments off Georgia indicates a long-shore transport from north to south within the near-shore zone. Lateral transport of sediments across the shelf is not extensive.

The shelf surface is generally smooth with rare and intermittent outcrops of hardground; hardgrounds in the South Atlantic are "reefs" and express relief above the surrounding sedimentary regime or are buried under superficial sediments of varying thicknesses. One such "reef" is within the Gray's Reef National Marine Sanctuary. The location of Gray's Reef is 17.5 nautical miles off the coast of Sapelo Island, Georgia, with corner coordinates of: 31°21.45'N, 80°55.17'W; 31°25.25'N, 80°55.17'W; 31°25.15'N, 80°49.42'W; and 31°21.45'N, 80°49.42'W.

Natural hardground and artificial reefs support a wide variety of marine life. Such hardground is known as a live bottom reef and is defined as: those areas which contain biological assemblages consisting of such sessile invertebrates as sea fans, sea whips, hydroids, anemones, ascidians, sponges, bryozoans, or corals living upon and attached to naturally occurring hard or rocky formations with rough, broken, or smooth topography, or whose lithotope favors the accumulation of turtles, fish, and other fauna.

Reef areas support invertebrates, recreational target fish, migratory pelagic fish, small seasonal tropic reef fish, common indigenous fish, small schooling bait fish, mid-water fish, and marine turtles. Pelagic birds are seen in the vicinity of these reef areas. Sport fish such as snapper or grouper tend to be long-lived and do not stray far from the reef areas. Long-lived fish are usually secondary or tertiary consumers, at the top of a reasonably large and diverse food web.

Twenty-five species of cetaceans (whales, dolphins, and porpoises) have been reported in offshore waters within the Georgia Bight. Twelve of these species have been found stranded along the Georgia coastline, and one, the spotted dolphin, has been identified by numerous offshore sightings.

Surface water temperatures follow seasonal air temperatures, with a slight lag. Near-shore in the south Atlantic, surface temperatures often show wide seasonal variation in response to varying climatic and run-off patterns and commonly range from 10 to 25°C. In the offshore zone, surface temperatures also respond to climatic changes, but are moderated by the consistently warm (25°C) Gulf Stream and thereby show only minor seasonal variations. In mid-shelf areas, surface water temperatures are relatively constant (19-27°C) year-round. Offshore at deeper depths, bottom temperatures are not readily influenced by weather or wind and are more stable.

Circulation in the Georgia Bight is affected primarily by freshwater runoff, wind, or the northerly flowing Gulf Stream, and to a minor extent by tidal currents, which proceed in a clockwise fashion, and the Coriolis effect. Surface circulation is northeasterly off the Carolinas and intermittent off Georgia and Florida, with a northerly drift in the autumn and winter. A southerly flowing coastal current prevails nearly year-round, inshore of a predominant northeasterly drift offshore, except during winter when runoff is low and when northeasterlies blow for several days at a time. Circulation off Georgia is strongly influenced by the prevailing winds which are most often northeasterly or southwesterly.

Bottom currents off Georgia show no consistent pattern and it is speculated that these currents are influenced by in-drafts from the northerly flowing Gulf Stream. Reefs often provide areas of calm bottom water or favorable bottom currents by damping or deflecting currents, and it has been noted that vertical relief of natural patch reefs or live-bottoms causes an upwelling effect.

In the offshore area of interest, waves come, on an annual basis, from all directions about the same percentage of the time. Seas of less than 4 feet occur most of the time, while wave heights greater than 12 feet are rare. Wave conditions are more severe during fall and winter in response to weather conditions. During the winter months, the area is subjected to extra-tropical storms, locally known as Hatteras lows, and during the summer and fall, to tropical storms and hurricanes originating in the Caribbean and the Gulf of Mexico.

The primary commercial interest in the Georgia offshore area is shrimping (GMFMC & SAFMC, 1980). Shrimp are harvested offshore of Georgia in amounts of 3,000 to 4,000 tpy, compared to 50 tpy of harvested fin fish. Historically, Georgia's commercial fishery has been based upon a six-month coastal shrimping cycle, commencing in the spring, usually late May or early June, when over-wintering and migratory white shrimp move toward offshore waters. During late August a new crop of white shrimp enters the fishery and provides a major portion of Georgia's catch. Georgia's sounds have not been opened since 1977, but prior to that year they were opened during the fall white shrimp period.

Shrimp are most abundant within 4-5 nautical miles of the Georgia shoreline. This location seems to be associated with depth. White shrimp are concentrated in waters of 27 m or less. The commercially less important brown shrimp and pink shrimp can be found in water depths of 55 m and 11-37 m, respectively.

In Georgia, most spawning of shrimp occurs more than 1.2 nautical miles from the shore; some spawning may occur inshore. Spawning seems to correlate with bottom water temperatures of 17-29°C. The spring spawn occurs with the rapid rise in water temperatures and the fall spawn ends with temperature decline. Shrimp may spawn up to four times within the spawning season. Spawning season ranges April - September.

After emerging from their demersal eggs, shrimp go through eleven stages of larval development. The larval stage of shrimp lasts approximately 12 days. Near shore tidal currents transport the post-larvae from the spawning areas into the estuarine shrimp nurseries. While in the nurseries, the shrimp grow quickly and, as juveniles, migrate toward the commercial fishing areas offshore, in late spring and summer. The adult shrimp move from near-shore spawning areas to commercial fishing areas from August through December. Starting in fall to early winter, the adult shrimp migrate south to Florida offshore waters and return to Georgia waters during late winter and early spring. Some portion of the shrimp will over-winter in Georgia waters. The shrimp spawning area and estuarine nurseries are the most important and sensitive habitats of shrimp, with regard to shrimp development.

7.2 PHOSPHATE MINING

The proposed methodology to mine and process the offshore phosphorite occurrence will utilize dredge-type mining equipment, followed by offshore processing. This proposed method will reduce possible onshore impacts associated with site development and plant operations in coastal areas. Infrastructure needs such as power supply, transportation, and operating supplies, would be available from existing on-shore facilities.

Long-term impacts from the mining operations are associated with the condition and characteristics of the mined bottom. Large-scale changes in bottom topography could seriously affect species composition in the mined area waters. If mining operations drastically change the characteristics of the bottom sediments, future biologic development of the bottom and surrounding waters may be severely altered, though it should not be inferred that this represents an adverse impact. The proposed operation would create deep, wide, and long excavations which may cause wave pattern modification. These excavations may never naturally fill due to wave action, since sediment transport is unlikely at water depths greater than 45 feet (Drinnan & Bliss, 1986).

Another area of the proposed mining operation with potential for negative impact on the marine environment concerns the various process effluent streams. The different effluent streams are generated at sea on the mining dredge and artificial island that supports the product beneficiation operations. The effluents can be placed in three categories: sized/inert rejects, process waste clays, and sand tailings.

The mining/beneficiation operations will have a potential impact in three domains within the marine environment. The first region is the upper portion of the euphotic zone. One short-term impact is an influence on phytoplankton. Surface plumes created by effluents from mining or processing can reduce the available sunlight in and beneath the plume. This reduction in sunlight can adversely affect development of phytoplankton by limiting photosynthesis. On the other hand, effluent plumes may concentrate dissolved or suspended nutrients within the euphotic zone, and the presence of these substances may stimulate phytoplankton productivity.

The second area of potential environmental impact due to effluent streams is the water column. Effluent plume turbidity can create a stressful environment for marine organisms. Fin fish and other highly mobile animals can, and usually do, avoid a high particulate area, but eggs and larvae cannot escape. Thus, high concentrations of particulate may create changes in seasonal and spatial patterns of organisms. In addition to particulates, effluent streams may also add dissolved substances to the water column. At significant concentrations these may be toxic to certain organisms, leading to biomass reduction, or they may represent nutrients and lead to inordinate localized rise in biomass.

Shrimp populations are sensitive to conditions that can develop from open-ocean dredging and dumping of dredge spoil. The resulting silt and turbidity from operations could result in shrimp gill erosion. To avoid adverse impacts it is ordinarily necessary to curtail such operations in shrimp trawling grounds when shrimp are abundant. Another adverse effect of dredging on the shrimp fishery is the smothering and destruction of the demersal eggs by the dredge spoil. In addition, severe alteration of bottom contours and substrata composition by dredge spoil can make trawling hazardous, if not impossible, in spoil areas.

Finally, benthic impacts may represent another important receptor of effluent streams. Impacts of effluent streams on the bottom are similar to, but not as severe as, the mining operation itself. If sedimentation is heavy, then benthic communities will be smothered. The characteristics of the sedimentation and type of benthic community will determine whether benthic impacts are severe.

Potential environmental impacts of airborne emissions from the dredging and beneficiation operations are expected to be very light. The only emission from the mining and processing operations will be exhaust from diesel power generation equipment or vessel operation.

Floridan Aquifer

In the vicinity of the hypothetical mine, the Middle Miocene phosphorite source bed overlies the principal artesian aquifer of the region. Because of the importance of the Floridan Aquifer as a water supply, particularly to Savannah, there are concerns about the potential for aquifer contamination from mining activities.

Research will be necessary to define aquifer and aquiclude characteristics in the vicinity of the mine. Items that need to be addressed include the following:

- o thickness and effectiveness of the aquiclude after mining,
- o potential for breaching the aquifer during mining,
- o aquifer water quality and the position of the salt-water/fresh-water interface; if the water quality is poor and the interface is landward of the mining area, then contamination by mining is not an issue.

7.3 HEAVY MINERALS MINING

Potential commercial development of the offshore heavy mineral occurrences has been based on the use of a suction-type hopper dredge with support facilities at an offshore platform-mounted processing plant. As in the case of the proposed phosphorite occurrence, all processing will occur offshore, thereby eliminating onshore impacts that would be associated with onshore processing of the heavy minerals.

Because of the nature of heavy mineral occurrences, mining of heavy minerals will differ from the mining of the phosphorite. Where phosphorite mining will require two dredges, one dredge to remove overburden and one dredge to mine phosphorite matrix, heavy mineral mining will require only one dredge since there is not expected to be any overburden needing removal.

Impacts of heavy mineral mining will be similar to those of phosphorite mining, but substantially reduced. The proposed mining of heavy minerals will excavate to a depth of 7 meters into the ocean bottom. Beneficiation,

both onboard the dredge and the offshore plant, will generate sand tailings which will be placed into the 7 meter deep mine cuts. There will not be any waste-clay effluents to be dealt with as in the phosphorite mining; therefore, increased turbidity due to very small particle waste-clays will not be an expected problem.

Coastal/Estuarine Impacts

Coastal or estuarine ecosystems should not receive direct impacts from offshore mining operations. Current movements of turbidity plumes are generally north or south in the offshore mine locations. Should mine operations occur in waters less than 20 meters in depth, a potential for affecting the sediment budgets of coastal shoreline is possible.

Identification of the mining locations and rate of bottom deepening will play an important role in assessing effects to coastal shorelines. Processes of deposition and removal on coastal shorelines have been shown to result from modification of natural bottom conditions at depths less than 20 meters. The dynamics of current movements, wave action, will need identification, along with bottom and shoreline characterization, prior to confirming specific impacts.

The generation of clean well-sorted sands in the mining and processing operations does present an opportunity to mitigate impacts from mining. Production of beach quality sands from mining beyond the 20 meter depth could provide valuable reconstruction materials for shorelines undergoing erosion caused by other forces. As with all activities in natural environments, investigations into habitat biota relationships prior to the actions would be required, but mitigative and restorative practices are possible.

Impacts on estuarine systems should be minimal as no disturbance of natural conditions are projected. Siting of onshore plant facilities in an area of existing suitable locations is likely. Construction of infrastructure such as docks or canals may be needed, but do not represent perturbances to the natural setting that are unacceptable.

Potential Benefits of Mining

Mining of minerals in the Exclusive Economic Zone (EEZ) is anticipated to generate much interest and debate on the environmental effects associated with resource utilization. While detrimental consequences are discussed at length in many of the available references on the subject, little information has been located that documents positive effects from resource utilization. Lack of information on the environmental benefits may be due to the lack of citable evidence, or lack of directed research on post-utilization conditions. Studies are needed to define methods of reaping potential benefits from mining activities, and to formulate guidelines for making evaluations of what constitutes acceptable impacts versus benefits.

In coastal or deepwater zones of low biologic diversity, mineral resource utilization offers the opportunity to use mining technology to increase habitat diversity and thereby induce biologic diversity with associated benefits. Areas of monotonous bottom conditions, when modified and reclaimed to increase habitat via niche development, offer the potential for increased diversity of species and associated recreational or economic benefits. To effect such measures, actions designed to save potential construction materials are needed. Construction of rock piles, or reef-like areas, when suitable reject materials are encountered, is one technique. Areas excavated to leave behind overhanging ledges or bluffs may be feasible as well, and should be considered.

Similarly, the construction of islands, or the installation of permanent work platforms, offer the potential to incorporate habitat for a variety of species. Artificial habitat in otherwise barren areas will quickly attract a full range of sessile and motile forms of both vertebrates and invertebrates. Clear evidence of this form of pioneer colonization is found at oil platforms and artificial reefs throughout the oceans of the world.

Another potential benefit from mining of offshore bottoms is the generation of materials suitable for beach renourishment. Overburden sands of suitable quality for beach renourishment are expected to occur in mining zones within practical pumping, or barge transportation distances. Use of these materials from deeper waters has the potential to minimize impacts from dredging

operations in the near-shore zones. This trade-off of impacts should be considered as a form of mitigation of environmental consequences due to mining.

Emphasis on habitat enhancement or restoration techniques needs to be considered in the planning stages of all projects. Hence, as mining or exploitation technology evolves with the mining experience, so should mitigation technology evolve. Methods to mitigate impacts, restore bottoms, or create new habitats, will improve the overall acceptability of mineral resource utilization in the public's perception of offshore projects.

Mitigation of Potential Adverse Impacts

Mitigation of potential environmental impacts depends on detailed analysis of mining procedures and plans. While the initial damage to benthic communities may be unavoidable in the short term, measures to re-establish communities may be possible. Careful consideration of waste materials placement may provide an avenue to enhance or reclaim mined-over areas. Methods to re-introduce native flora and faunal components have evolved for land-based mining and need consideration for ocean applications. Similarly, careful consideration of non-benthic components and mining plans may identify measures to alleviate any adverse impacts to those components.

Damage to benthic communities can occur in a variety of forms, including: total removal, substrate removal, smothering of resident sessile forms, reduction of oxygen levels, decreased photoperiod, and loss of food source. These impacts are due to direct and indirect perturbation of the benthic environment. Impacts due to smothering, decreased photoperiod, and decreased oxygen levels from particulates or plume migration may be reduced by careful placement of these materials back into open waters.

Removal of the substrate during mining and elimination of food sources represent more difficult challenges in the reclamation of the seafloor. However, with careful identification of materials handling techniques, and mine planning, the movement of unusable substrate, i.e. overburden, to suitable new locations may be possible. With saved or reclaimed substrate in place, the re-introduction of species appears feasible if similar pre-mine

conditions such as depth, lighting, and food source, prevail. Recolonization by pioneer species brought to barren sites by drift in currents may supply adequate inoculation of sites, when nearby undisturbed areas are upgradient.

Avoidance of areas during periods of sensitive activities may be possible as well and should be considered during mine planning. Seasonally utilized areas for spawning, migration, and breeding, can be identified in advance and operations altered to minimize intrusion. Monitoring of currents and prevailing weather patterns also would allow for the shifting of mining or disposal activities away from sensitive areas downgradient to prevailing conditions.

Another valuable technique applicable to highly motile or pelagic species is hazing. By creating annoying or nuisance conditions in areas to be impacted, it may be possible to cause voluntary abandonment by certain sensitive species. This form of activity, along with removal techniques, while not completely effective, does have merit when less favorable circumstances may prevail.

In summary, further development of mitigation procedures need to be explored. Restoration, reclamation, or enhancement of conditions should receive attention at an early stage of planning to allow for consideration of alternatives prior to initiation of operations. Attempts to mitigate impacts from active operations also need to be considered when sensitive or economically important resources are at risk.

7.4 PERMITTING

7.4.1 Permit Acquisition Procedures

Federal environmental regulations affecting the operation of offshore mining/processing activities are based on two major legislative provisions at the federal level. The Marine Protection Research and Sanctuaries Act (MPRSA), along with the Clean Water Act (CWA), have sections governing the disposal of dredged materials and non-dredged materials in estuarine,

coastal, and open ocean waters. Various other secondary acts also have the potential to be cited as being relevant, as well. These secondary acts which may affect both the heavy minerals site and phosphorite sites include:

- o Endangered Species Act (ESA)
- o National Environmental Policy Act (NEPA)
- o Port and Tanker Safety Act (PTSA).

MPRSA - Provisions of MPRSA require permits issued from EPA for the transportation and dumping of waste materials into the contiguous zone and beyond with restrictions as specified by EPA for non-dredged materials. MPRSA tasks Corps of Engineers with issuing permits for dumping dredged materials while applying EPA criteria for evaluating the impact on the marine environment. MPRSA further delegates Coast Guard with conducting appropriate enforcement activities for unlawful dumping or transportation for dumping of materials.

Basic to the tasks of EPA and Corps of Engineers under MPRSA, is the determination of whether permitted activities will "unreasonably degrade" public health or the marine environment. In making this determination, EPA and Corps of Engineers use criteria specified by statute or established by the EPA Administrator. MPRSA is generally not applicable in estuarine waters.

CWA - The Clean Water Act contains provisions for the establishment of water quality criteria, treatment standards, issuance of discharge permits, and issuance of permits for land-based pollution sources, or stationary pollution sources discharging into territorial waters. Further, the discharge of dredged materials into navigable waters is regulated under the CWA; however, MPRSA usually preempts this provision in coastal or the open ocean.

The CWA will affect any discharges from processing operations associated with the beneficiation of ores. The National Pollutant Discharge Elimination System (NPDES) is the operative format for the execution of CWA provisions as administered by EPA at facilities with pollutant discharges. CWA Section 404 directs Corps of Engineers to issue permits for dredge and fill activities in navigable waters, using criteria promulgated by EPA for disposal sites.

Permitting requirements for the emission of non-dredged material effluents from the offshore processing facilities will be according to NPDES criteria. Application of regulations formulated for the NPDES program have particular relevance to the phosphorite operations. Disposal of spent reagents with tailings or waste clays are anticipated to represent a minor impact due to the bio-degradable nature of the materials utilized. The absorptive capacity of phosphorite matrix clays should immobilize reagents allowing degradation to occur. This form of treatment is common to on-shore operations of a similar nature.

Air - Provisions of the Clean Air Act (CAA) will govern air emissions associated with any of the mining/processing facilities. Should heating systems for reagents or drying facilities for product become necessary, applicable CAA emission restrictions would be applicable, particularly for the stationary facilities. Industry standards for mineral processing operations are routinely met by operations at on-shore facilities of a similar nature should air emission sources be defined.

Georgia environmental regulations will affect only the onshore activities associated with ore shipment. The Environmental Protection Division (EPD) of the Georgia Department of Natural Resources administers programs governing:

- o Water quality control discharge (NPDES),
- o Air quality,
- o Groundwater withdrawal,
- o Surface water withdrawal,
- o Solid waste management,

Georgia has a consolidated environmental program with authority delegated from the U.S. Environmental Protection Agency for issuance and enforcement of federal permits.

Coastal Marshlands

Issues concerning the construction of a storage facility or appurtenant devices in coastal marshlands, are regulated under the Coastal Marshlands Protection Act. Provisions of the Coastal Marshlands Protection Act are administered by a three-member committee, consisting of the EPD Director, Coastal Resources Division Director, and a Natural Resources Commissioner.

Construction and operation of storage or shipping facilities at hypothetical locations on-shore will likely require review and permitting under the Coastal Marshlands Protection Act. Review of dock construction, discharge/intake structures, and other infrastructure, are likely to have temporary impacts on estuarine wetlands. Mitigative measures and procedures would be employed to lessen or alleviate impacts.

SECTION 8

BIBLIOGRAPHY

Zellars-Williams Company key professional contributors, in addition to J. M. Williams, P.E., as a principal investigator, are recognized as follows.

<u>SECTION</u>	<u>TITLE</u>	<u>AUTHOR</u>
1	Executive Summary	J.G. Tavrdes
2	Scope of Study	T.D. Abel
3	Resources	J.S. Spalding T.D. Abel
4	Offshore Mining Technology	J.W. Hughes J.G. Tavrdes
5/6	Phosphate and Heavy Minerals Feasibility Mining Area and Alternative Configuration	J.W. Hughes
	Configuration and Infrastructure	J.G. Tavrdes
	Estimated Capital and Operating Cost	J.W. Hughes J.G. Tavrdes
	Economics and Viability	J.G. Tavrdes
7	Environmental Impacts	T.P. Oxford F.I. Nance J.W. Whittington

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SECTION 9

APPENDIX

9.1 MODELLED DATA

Averaged and listed by OCS Block Number (NH21000).

9.2 RAW DATA

Sea floor Characterization, listed by U.S.G.S. sample point number.

9.3 RAW DATA

Grab sample mineralogy, listed by U.S.G.S. sample point number.

SECTION 9.1

BLOCKID	AREA	LATITUDE (eq. lat)	LONGITUDE (deg)	DEPTH (m)	EAST (m)	NORTH (m)	SILT wt %	SAND wt %	CLAY wt %	DUMPER thk (m)	RIGIDEN thk (m)	UP.WTDC thk (m)	MD.WTDC thk (m)	LIA.WTDC thk (m)	MIL.WTDC thk (m)	OYERBORN thk (m)	QUARTZ thk (m)	K.FLUSP thk (m)	P.FLUSP thk (m)	HYMINS thk (m)	RESPIRT thk (m)	MONGZ thk (m)	RUTILE thk (m)	STAURO thk (m)	TITAN thk (m)	ZIRCON thk (m)	
																											wt %
H2286	23.040	31.655	08.073	586400.0	512000.0	16.5	0.00	99.20	0.70	0.00	16.50	19.50	0.00	1.00	7.30	-53.50	35.40	88.30	1.00	5.50	4.20	0.00	0.00	0.00	0.00	1.50	0.00
H2289	23.040	31.694	08.823	586400.0	516000.0	18.0	0.00	99.00	0.20	0.00	15.10	19.50	0.00	1.00	9.20	-53.00	34.70	88.10	1.00	5.00	4.10	0.00	0.00	0.00	0.00	1.50	0.20
H2291	23.040	31.954	08.619	535200.0	535000.0	18.0	0.00	99.00	0.50	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H2290	23.040	31.694	08.772	586400.0	521600.0	19.2	0.00	99.00	0.20	0.00	13.50	18.30	0.00	1.00	11.10	-52.10	31.00	88.20	1.00	5.50	5.30	0.00	0.00	0.00	0.00	1.50	0.00
H2291	23.040	31.694	08.721	586400.0	525400.0	28.1	0.00	99.00	0.20	0.00	12.10	15.70	0.00	1.20	12.50	-49.10	27.00	88.50	1.10	4.90	4.20	0.00	0.00	0.00	0.00	1.50	0.50
H2292	23.040	31.694	08.671	586400.0	531200.0	28.7	0.00	99.90	0.10	0.00	11.60	11.60	0.00	1.30	12.00	-45.20	23.20	88.60	1.20	4.50	4.50	0.00	0.00	0.00	0.00	1.50	0.00
H2293	23.040	31.694	08.628	586400.0	535000.0	21.3	0.00	100.00	0.00	0.00	11.70	7.70	0.00	1.30	11.00	-42.00	19.40	88.60	1.20	4.10	4.90	0.00	0.00	0.00	0.00	1.50	0.50
H2294	23.040	31.694	08.569	586400.0	540000.0	21.9	0.00	100.00	0.00	0.00	12.00	4.60	0.00	1.40	10.20	-39.50	16.60	88.80	1.20	4.00	4.90	0.00	0.00	0.00	0.00	1.50	1.00
H2295	23.040	31.694	08.519	586400.0	545000.0	22.7	0.00	100.00	0.00	0.00	12.30	2.90	0.00	1.30	9.00	-39.20	15.20	88.70	1.50	3.90	4.80	0.00	0.00	0.00	0.00	1.50	1.00
H2296	23.040	31.694	08.468	586400.0	550400.0	25.5	0.00	100.00	0.00	0.00	12.50	2.30	0.00	0.90	8.60	-41.20	14.00	88.70	1.70	3.80	4.70	0.00	0.00	0.00	0.00	1.50	1.00
H2297	23.040	31.693	08.418	586400.0	555200.0	28.3	0.00	100.00	0.00	0.00	12.40	2.40	0.00	0.70	8.20	-43.70	14.00	89.00	1.60	3.90	4.50	0.00	0.00	0.00	0.00	1.50	1.00
H2298	23.040	31.693	08.367	586400.0	559000.0	29.4	0.00	100.00	0.00	0.00	12.30	2.00	0.00	0.40	5.50	-44.10	14.30	89.10	1.30	3.90	4.60	0.00	0.00	0.00	0.00	1.50	1.00
H2299	23.040	31.954	08.568	535200.0	540000.0	18.8	0.30	99.10	0.60	0.00	11.70	3.50	0.00	0.60	6.30	-46.00	15.10	89.10	1.10	4.00	4.80	0.00	0.00	0.00	0.00	1.50	1.00
H2300	23.040	31.692	08.266	586400.0	559000.0	31.3	0.00	99.90	0.00	0.00	9.60	1.20	0.00	3.40	10.00	-35.10	10.00	86.30	0.80	5.70	6.20	0.00	0.00	0.00	0.00	1.50	1.00
H2301	23.040	31.692	08.215	586400.0	574400.0	33.5	0.10	99.00	0.00	0.00	9.40	18.10	0.00	3.40	5.30	-56.40	19.50	89.60	1.30	4.00	4.40	0.00	0.00	0.00	0.00	1.50	2.20
H2302	23.040	31.692	08.164	586400.0	579200.0	36.7	0.10	99.00	0.00	0.00	10.20	9.70	0.00	0.50	5.00	-63.20	19.90	98.10	1.10	4.10	3.70	0.00	0.00	0.00	0.00	1.50	2.80
H2303	23.040	31.692	08.114	586400.0	584000.0	39.0	0.10	99.00	0.00	0.00	11.30	9.30	0.00	13.60	5.40	-73.20	28.60	98.00	0.60	4.10	3.10	0.00	0.00	0.00	0.00	1.50	4.40
H2304	23.040	31.691	08.063	586400.0	589000.0	46.3	0.00	99.90	0.00	0.00	12.00	9.10	0.00	16.50	5.10	-80.00	22.00	98.00	0.20	4.00	2.60	0.00	0.00	0.00	0.00	1.50	6.60
H2305	23.040	31.691	08.012	586400.0	593000.0	42.0	0.00	99.90	0.00	0.00	14.00	9.70	0.00	23.50	5.70	-98.00	24.50	98.50	0.40	4.10	2.80	0.00	0.00	0.00	0.00	1.50	8.30
H2306	23.040	31.690	07.962	586400.0	598400.0	43.8	0.00	99.70	0.10	0.00	17.20	10.90	0.00	27.60	6.60	-99.40	28.10	89.40	0.60	4.30	3.50	0.00	0.00	0.00	0.00	1.50	6.30
H231	23.040	31.954	08.517	535200.0	545000.0	19.6	0.00	99.60	0.30	0.00	9.30	3.20	0.00	11.00	16.30	-43.90	12.50	87.50	0.90	5.30	5.40	0.00	0.00	0.00	0.00	1.50	1.00
H232	23.040	31.953	08.467	535200.0	550400.0	28.1	0.00	99.90	0.10	0.00	16.10	22.00	0.00	15.50	18.30	-48.20	12.90	88.70	0.90	4.80	4.70	0.00	0.00	0.00	0.00	1.50	1.00
H232B	6.383	31.651	08.076	591600.0	492000.0	13.8	0.00	98.90	0.10	0.00	11.40	1.70	0.00	14.00	18.00	-48.00	13.00	98.10	0.60	4.40	3.00	0.00	0.00	0.00	0.00	1.50	1.00
H233	23.040	31.953	08.416	535200.0	555200.0	21.0	0.00	99.90	0.10	0.00	11.40	1.70	0.00	14.00	18.00	-48.00	13.00	98.10	0.60	4.40	3.00	0.00	0.00	0.00	0.00	1.50	1.00
H2331	23.040	31.651	08.924	591600.0	507200.0	15.7	0.00	99.50	0.50	0.00	16.00	25.70	0.00	1.30	4.70	-57.70	40.80	89.30	0.70	4.00	4.10	0.00	0.00	0.00	0.00	1.50	1.00
H2332	23.040	31.651	08.873	591600.0	512000.0	17.6	0.00	99.20	0.80	0.00	14.70	23.50	0.00	1.40	6.00	-59.30	48.20	88.50	0.80	5.20	4.10	0.00	0.00	0.00	0.00	1.50	1.00
H2333	23.040	31.651	08.823	591600.0	516000.0	19.2	0.00	99.70	0.30	0.00	12.60	24.30	0.00	1.30	10.60	-57.30	36.90	88.50	0.80	5.40	4.30	0.00	0.00	0.00	0.00	1.50	1.00
H2334	23.040	31.651	08.772	591600.0	521000.0	19.8	0.00	99.90	0.10	0.00	11.40	22.60	0.00	1.30	13.00	-55.10	33.90	88.60	0.80	5.20	4.40	0.00	0.00	0.00	0.00	1.50	1.00
H2335	23.040	31.651	08.722	591600.0	526400.0	20.5	0.00	99.80	0.10	0.00	10.90	19.30	0.00	1.70	14.60	-52.30	38.20	88.60	0.90	4.70	4.60	0.00	0.00	0.00	0.00	1.50	1.00
H2336	23.040	31.651	08.671	591600.0	531000.0	21.5	0.00	99.90	0.00	0.00	10.60	15.60	0.00	1.90	15.30	-49.70	26.30	88.60	1.10	4.30	4.70	0.00	0.00	0.00	0.00	1.50	1.00
H2337	23.040	31.651	08.620	591600.0	536000.0	22.6	0.00	100.00	0.00	0.00	10.00	11.20	0.00	2.20	14.30	-46.00	22.00	88.70	1.40	4.00	4.80	0.00	0.00	0.00	0.00	1.50	1.00
H2338	23.040	31.651	08.570	591600.0	540000.0	23.8	0.00	100.00	0.00	0.00	11.10	7.20	0.00	2.60	12.00	-44.00	18.40	88.40	1.90	3.80	4.90	0.00	0.00	0.00	0.00	1.50	1.00
H2339	23.040	31.651	08.519	591600.0	545000.0	25.6	0.00	100.00	0.00	0.00	11.60	4.50	0.00	2.90	9.60	-44.60	16.10	88.10	2.40	3.60	4.90	0.00	0.00	0.00	0.00	1.50	1.00
H234	23.040	31.953	08.365	535200.0	560000.0	22.5	0.00	100.00	0.00	0.00	12.90	1.60	0.00	13.00	19.60	-59.00	14.50	91.40	0.30	4.10	3.50	0.00	0.00	0.00	0.00	1.50	1.00
H2340	23.040	31.650	08.468	591600.0	530400.0	20.0	0.00	100.00	0.00	0.00	11.90	3.20	0.00	2.90	7.50	-46.00	15.10	88.20	2.40	3.60	4.70	0.00	0.00	0.00	0.00	1.50	1.10
H2341	23.040	31.650	08.418	591600.0	535200.0	29.8	0.00	100.00	0.00	0.00	11.70	3.70	0.00	2.10	6.10	-47.10	15.10	88.60	2.00	3.60	4.50	0.00	0.00	0.00	0.00	1.50	1.10
H2342	23.040	31.649	08.317	591600.0	564000.0	31.8	0.00	100.00	0.00	0.00	11.90	3.20	0.00	1.60	3.00	-47.90	15.40	88.90	1.50	4.10	4.40	0.00	0.00	0.00	0.00	1.50	1.10
H2343	23.040	31.649	08.266	591600.0	569000.0	33.1	0.00	99.90	0.00	0.00	10.20	7.50	0.00	1.40	4.50	-58.90	17.70	89.00	1.40	4.20	4.30	0.00	0.00	0.00	0.00	1.50	1.10
H2344	23.040	31.649	08.215	591600.0	574000.0	35.3	0.00	99.90	0.00	0.00	11.70	9.40	0.00	1.20	2.30	-54.50	20.20	89.20	1.50	4.30	3.90	0.00	0.00	0.00	0.00	1.50	1.20
H2345	23.040	31.649	08.164	591600.0	580000.0	48.6	0.00	99.90	0.00	0.00	9.10	11.20	0.00	5.50	2.70	-61.20	20.30	89.50	1.40	4.30	3.40	0.00	0.00	0.00	0.00	1.50	2.50
H2346	23.040	31.649	08.114	591600.0	585000.0	37.7	0.10	99.90	0.00	0.00	10.40	10.20	0.00	12.00	2.10	-71.20	20.60	89.50	1.10	4.20	3.10	0.00	0.00	0.00	0.00	1.50	4.20
H2347	23.040	31.648	08.063	591600.0	590000.0	42.5	0.00	99.90	0.00	0.00	12.00	9.30	0.00	18.10	1.90	-78.90	21.30	89.90	0.70	4.10	3.10	0.00	0.00	0.00	0.00		

BLOCKID	AREA	LATITUDE	LONGITUDE	NORTH	EAST	DEPTH	BARREL	SPND	SILT	CLAY	DAKEM	PIEDM	UP.	NIDC	NO.	NIDC	LA.	NIDC	ML.	NIDC	ML.	NOTS	DAKEM	QUARTZ	K.FLUSP	P.FLUSP	WYMINES	RESPART	ADAMZ	MUTILE	STALUD	TITAN	ZINC
	(sq.mi)	(deg)	(deg)	(m)	(m)	(m)	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	wt %	
H3292	23.040	30.638	00.674	335400.0	531200.0	31.2	0.00	100.00	0.00	0.00	13.60	24.40	0.00	23.20	11.30	-94.40	33.00	91.00	1.70	3.00	2.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3293	23.040	30.638	00.624	335400.0	535400.0	32.7	0.00	100.00	0.00	0.00	13.60	24.20	0.00	23.00	12.10	-93.30	37.00	89.90	1.90	3.00	3.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3294	23.040	30.638	00.574	335400.0	540000.0	34.1	0.00	100.00	0.00	0.00	13.90	24.60	0.00	24.60	13.70	-97.20	38.50	89.30	1.90	3.00	3.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3295	23.040	30.638	00.524	335400.0	545600.0	35.6	0.00	100.00	0.00	0.00	14.60	25.20	0.00	24.30	16.00	-99.90	39.00	89.40	1.30	4.00	3.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3296	23.040	30.637	00.474	335400.0	550400.0	37.1	0.00	99.90	0.00	0.00	15.10	27.40	0.00	23.70	18.00	-104.70	42.50	90.20	0.90	3.00	3.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3297	23.040	30.637	00.424	335400.0	555200.0	38.6	0.00	99.90	0.00	0.00	15.90	31.90	0.00	25.70	19.90	-110.20	46.00	90.90	0.90	3.00	2.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3298	23.040	30.637	00.373	335400.0	560000.0	40.3	0.00	99.50	0.00	0.00	16.70	33.40	0.00	26.40	21.20	-115.10	49.40	91.00	0.20	2.00	2.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3299	23.040	30.637	00.323	335400.0	564800.0	42.9	0.00	99.50	0.00	0.00	17.00	33.20	0.00	27.20	22.60	-120.00	52.20	91.00	0.20	2.00	2.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3300	23.040	30.636	00.273	335400.0	569600.0	45.6	0.00	99.00	0.00	0.00	17.60	33.30	0.00	29.70	21.40	-126.10	58.90	91.90	0.10	2.00	2.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3301	23.040	30.636	00.223	335400.0	574400.0	48.9	0.00	96.90	0.00	0.00	17.00	33.40	0.00	26.10	25.40	-131.30	56.30	81.00	0.40	2.00	1.90	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3302	23.040	30.636	00.173	335400.0	579200.0	51.8	0.00	94.10	0.00	0.00	18.40	16.60	0.00	11.50	48.00	-128.30	37.00	64.70	0.40	2.00	1.90	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3303	23.040	30.635	00.123	335400.0	584000.0	55.0	0.00	93.60	0.00	0.00	17.30	2.60	0.00	1.90	51.30	-151.50	19.90	33.00	0.20	1.70	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3304	0.640	30.635	00.073	335400.0	588800.0	63.7	0.00	95.20	0.00	0.00	17.20	48.10	0.00	32.00	28.40	-147.00	65.30	90.00	0.30	2.20	1.70	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H331	23.040	30.597	00.472	424000.0	539400.0	34.7	0.00	100.00	0.00	0.00	14.00	16.20	0.00	1.90	26.60	14.30	-96.20	32.90	90.60	1.30	3.20	3.20	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H332	9.700	30.635	01.376	391200.0	464000.0	11.4	0.00	98.40	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	
H3322	9.700	30.635	01.376	391200.0	464000.0	11.4	0.00	98.40	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3323	23.040	30.635	01.295	391200.0	464000.0	16.2	0.00	97.00	0.00	0.00	0.00	40.30	0.00	0.00	28.10	18.90	-85.20	49.50	0.00	0.00	5.70	3.40	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3324	23.040	30.635	01.275	391200.0	473600.0	18.7	0.00	98.00	0.00	0.00	0.00	41.00	0.00	0.00	19.90	18.70	-89.40	49.40	0.00	0.00	4.00	3.30	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3325	23.040	30.635	01.225	391200.0	478400.0	20.1	0.00	98.90	0.00	0.00	0.00	41.00	0.00	0.00	28.20	18.40	-89.70	49.40	0.00	0.00	3.90	3.20	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3326	23.040	30.635	01.175	391200.0	483200.0	19.9	0.00	99.30	0.00	0.00	0.00	41.50	0.00	0.00	28.20	18.40	-89.70	49.40	0.00	0.00	3.30	3.10	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3327	23.040	30.635	01.125	391200.0	488000.0	20.1	0.00	99.60	0.00	0.00	0.00	41.40	0.00	0.00	28.20	18.60	-90.10	49.30	0.00	0.00	3.00	2.80	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3328	23.040	30.635	01.075	391200.0	492800.0	21.3	0.00	99.60	0.00	0.00	0.00	41.50	0.00	0.00	28.20	18.00	-91.20	49.70	0.00	0.00	2.80	2.60	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3329	23.040	30.635	01.025	391200.0	497600.0	21.3	0.00	99.60	0.00	0.00	0.00	41.00	0.00	0.00	1.10	38.70	-101.00	33.40	0.00	0.00	3.40	2.60	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H333	23.040	30.597	00.422	424000.0	535200.0	35.7	0.00	99.60	0.00	0.00	0.00	41.00	0.00	0.00	28.40	18.70	-92.70	49.50	0.00	0.00	4.40	2.60	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3330	23.040	30.635	00.975	391200.0	502400.0	22.1	0.00	99.70	0.00	0.00	0.00	40.00	0.00	0.00	0.00	21.20	-93.10	49.50	0.00	0.00	4.00	3.40	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3331	23.040	30.635	00.925	391200.0	507200.0	22.1	0.00	99.70	0.00	0.00	0.00	40.00	0.00	0.00	0.00	21.20	-93.10	49.50	0.00	0.00	4.00	3.40	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3332	23.040	30.635	00.875	391200.0	512000.0	23.4	0.00	99.90	0.00	0.00	0.00	40.60	0.00	0.00	0.00	22.10	-93.10	49.50	0.00	0.00	2.90	2.30	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3333	23.040	30.635	00.825	391200.0	516800.0	25.0	0.00	100.00	0.00	0.00	0.00	38.70	0.00	0.00	0.00	22.90	-93.00	49.30	0.00	0.00	2.50	2.10	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3334	23.040	30.635	00.775	391200.0	521600.0	29.5	0.00	100.00	0.00	0.00	0.00	33.00	0.00	0.00	0.00	24.30	-94.00	46.30	0.00	0.00	3.10	2.10	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3335	23.040	30.635	00.724	391200.0	526400.0	30.7	0.00	100.00	0.00	0.00	0.00	28.20	0.00	0.00	0.00	25.00	-94.00	43.00	0.00	0.00	3.50	2.60	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3336	23.040	30.635	00.674	391200.0	531200.0	30.7	0.00	100.00	0.00	0.00	0.00	28.20	0.00	0.00	0.00	25.00	-94.00	43.00	0.00	0.00	3.50	2.60	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3337	23.040	30.635	00.624	391200.0	536000.0	32.1	0.00	100.00	0.00	0.00	0.00	25.40	0.00	0.00	0.00	26.20	-94.00	41.60	0.00	0.00	3.70	3.20	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3338	23.040	30.635	00.574	391200.0	540800.0	33.6	0.00	100.00	0.00	0.00	0.00	25.40	0.00	0.00	0.00	26.20	-94.00	41.60	0.00	0.00	3.90	3.60	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3339	23.040	30.634	00.524	391200.0	545600.0	35.1	0.00	100.00	0.00	0.00	0.00	20.50	0.00	0.00	0.00	24.60	-104.00	44.90	0.00	0.00	4.00	3.70	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H334	23.040	30.597	00.372	424000.0	536000.0	35.8	0.00	99.70	0.00	0.00	21.10	13.20	0.00	0.00	32.20	17.10	-103.70	36.70	0.00	0.00	4.10	3.50	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
H3340	23.040	30.634	00.474	391200.0	539400.0	35.6	0.00	99.90	0.00	0.00	16.60	31.90	0.																				

SECTION 9.2

Key.....	SAMPLEID..	LAT....	Lon....	NORTH..	EAST...	DEPTH	WTGRAV	WTSAND	WTSILT	WTCLAY
1649	1649	30.017	79.717	321146	623761	871.0	0	40	37	22
1650	1650	30.017	79.500	321389	643055	779.0	0	96	4	0
1733	1733	30.238	79.650	345785	629901	861	0	64	21	14
2279	2279	31.132	81.414	444139	460547	8	9	91	0	0
2280	2280	31.097	81.282	440165	473137	6	0	95	5	0
2284	2284	30.478	81.385	371671	463046	8	3	95	2	0
2419	2419	30.333	80.795	355558	519706	33.0	0	100	0	0
2420	2420	30.353	80.892	357762	510411	28.0	0	100	0	0
1498	1498	30.670	81.003	392048	499681	20.0	0	100	0	0
1663	1663	31.678	79.995	505034	595262	36.0	0	100	0	0
1681	1681	30.830	80.750	410605	523909	24.0	0	100	0	0
1696	1696	30.155	80.488	335891	549274	36.0	1	99	0	0
1706	1706	31.333	80.232	466614	573096	36.0	0	100	0	0
1743	1743	30.850	79.400	413891	652997	802	0	92	8	0
1752	1752	31.478	79.483	483425	644073	449	0	97	2	0
2373	2373	30.263	78.750	349927	716464	804.0	0	94	6	0
2472	2472	30.142	79.545	335197	640142	776.0	31	61	7	0
2702	2702	31.800	79.200	519491	670404	556.0	0	0	0	0
1668	1668	31.823	80.018	521006	592905	30.0	1	98	0	0
2277A	2277A	32.320	81.304	464922	471059	6	0	100	0	0
1653	1653	30.375	79.442	361188	649741	835.0	0	34	30	35
1742	1742	30.745	79.317	402369	661141	752	0	100	0	0
2374	2374	30.517	79.022	377521	689032	876.0	4	90	6	0
2405	2405	32.453	79.847	591002	600404	29.0	0	100	0	0
2411	2411	32.297	79.717	573855	620032	40.0	1	99	0	0
2421	2421	30.350	80.933	357390	506400	26.0	2	98	0	0
2476	2476	30.863	79.168	415709	675129	743.0	15	82	3	0
2706B	2706B	31.800	79.200	519491	670404	556.0	0	0	0	0
1488A	1488A	31.842	80.750	522726	523655	17.0	0	98	2	0
1658	1658	30.830	80.007	411001	595001	146.0	0	73	18	8
1695	1695	30.000	80.493	318714	548900	38.0	0	100	0	0
1705	1705	31.502	80.275	485244	568850	32.0	0	100	0	0
1711	1711	30.497	80.228	373894	574055	43.0	0	100	0	0
1747	1747	31.147	79.775	446318	616773	254	0	95	5	0
1757	1757	32.013	79.507	542700	641043	54	0	100	0	0
2269	2269	32.145	80.827	556333	516346	9	0	100	0	0
2275	2275	31.517	81.199	486717	471594	3	0	89	3	7
1664	1664	31.673	80.243	504290	571726	28.0	0	100	0	0
2270	2270	32.073	80.968	548376	502909	8	0	100	0	0
1654	1654	30.490	79.453	374041	640434	752.0	0	99	1	0
2278	2278	31.333	81.384	466386	463500	4	0	100	0	0
2377	2377	30.358	78.003	361919	700355	813.0	0	96	4	0
2383	2383	30.940	78.572	425297	732006	845.0	0	100	0	0
2424	2424	30.367	81.050	359236	494395	21.0	0	100	0	0
2474A	2474A	30.572	79.525	382070	641448	820.0	39	11	23	25
2402	2402	31.922	78.578	534126	728969	444.0	0	0	0	0
1497	1497	30.833	81.000	410940	500000	10.0	0	100	0	0
1685	1685	30.167	80.750	337100	524072	32.0	0	100	0	0
1701	1701	31.003	80.492	429090	548528	31.0	0	100	0	0
1737	1737	30.507	80.040	375140	592120	204	34	57	8	0
2429	2429	30.385	81.250	361293	475901	23.0	0	100	0	0
2265	2265	32.435	80.380	588634	559286	9	0	100	0	0
1753	1753	31.653	79.497	502006	642540	166	0	30	56	13
1731	1731	30.183	79.887	339443	607186	534.0	0	64	19	16
2379	2379	30.475	78.067	374097	701622	825.0	0	100	0	0
2300	2300	30.830	78.075	414241	779796	949.0	0	100	0	0
2426	2426	30.375	81.142	360167	486388	19.0	5	95	0	0
2473	2473	30.252	79.243	347790	669014	830.0	10	89	0	0
2477	2477	31.000	79.323	431540	660065	604.0	0	0	0	0

Key.....	SAMPLEID..	LAT....	LOX....	NORTH..	EAST...	DEPTH	WTERAV	WTSAND	WTSILT	WTCLAY
2478	2478	31.133	79.125	445787	678768	649.0	16	81	2	0
1665	1665	31.685	80.518	585439	546442	28.0	0	100	0	0
1674	1674	32.468	79.980	591694	595865	16.0	0	100	0	0
1763	1763	31.830	79.242	522753	666485	259	0	20	56	23
2295	2295	32.085	80.625	549731	535389	8.0	0	100	0	0
1773	1773	32.347	78.740	580919	712690	347	0	53	29	18
1767	1767	31.827	78.492	523216	711690	455				
2281	2281	30.930	81.315	421703	469906	7	0	93	7	0
2285	2285	30.362	81.380	358742	463483	8	0	100	0	0
2289	2289	31.325	81.197	465453	481288	7.0	0	97	3	0
2290	2290	31.520	81.065	487049	493828	9.0	0	100	0	0
2384	2384	30.988	78.717	421493	718221	843.0	0	100	0	0
2388	2388	31.533	78.967	490317	693848	494.0	0	0	0	0
2398	2398	32.083	78.458	552330	740683	489.0	0	0	0	0
2408	2408	32.380	79.788	583814	613980	36.0	1	99	0	0
2474B	2474B	30.572	79.525	382878	641448	828.0	0	0	0	0
2483	2483	32.147	78.593	559843	726994	449.0	0	0	0	0
1482	1482	32.327	80.838	576863	590515	16	0	100	0	0
1660	1660	31.168	79.967	448532	598479	46.0	1	99	0	0
1669	1669	32.008	79.980	541626	596340	27.0	0	100	0	0
1670	1670	32.180	80.000	560638	594274	19.0	0	100	0	0
1712	1712	30.337	80.250	356149	572093	49.0	0	100	0	0
1659	1659	31.002	79.983	430847	597060	48.0	0	100	0	0
1758	1758	31.995	79.753	540373	617768	32	0	100	0	0
1746	1746	31.000	79.742	430898	620135	347	0	96	4	0
1764	1764	31.675	79.243	585567	666525	584	0	68	18	13
2268	2268	32.273	80.695	578585	528724	11	3	97	0	0
2389	2389	31.383	78.667	474254	721891	512.0	0	100	0	0
2390	2390	31.213	78.483	455790	739761	648.0	0	0	0	0
2484	2484	32.467	79.875	592532	685726	27.0	1	99	0	0
2785	2785	31.800	79.200	519491	678484	556.0	0	0	0	0
2786A	2786A	31.800	79.200	519491	678484	556.0	0	0	0	0
1492	1492	31.340	81.017	467898	498414	15.0	0	100	0	0
1679	1679	31.160	80.760	447174	522874	19.0	0	100	0	0
2296	2296	32.262	80.450	569385	551884	11.0	5	98	5	0
1680	1680	31.000	80.747	429446	524185	24.0	0	100	0	0
2291	2291	31.678	81.022	584596	497946	8.0	0	92	8	0
1700	1700	30.833	80.497	411856	548136	33.0	0	100	0	0
1582	1582	30.312	80.977	353141	582243	21.0	0	100	0	0
1483	1483	32.333	80.225	577459	572939	13.0	0	100	0	0
1736	1736	30.390	80.890	362171	587436	319	0	76	9	14
1732	1732	30.147	79.725	335543	622797	882	0	19	40	40
1768	1768	31.897	78.492	531540	737229	534	0	99	1	0
2399	2399	32.177	78.767	562016	718572	423.0	0	0	0	0
2410	2410	32.323	79.740	576784	618681	48.0	10	90	0	0
2414	2414	30.267	79.918	348649	684850	510.0	25	66	9	0
2701	2701	31.800	79.200	519491	678484	542.0	0	0	0	0
1583A	1583A	30.330	81.250	353198	475968	12.0	0	94	1	3
1675	1675	32.225	80.325	565387	563683	14.0	0	100	0	0
1684	1684	30.338	80.737	355201	525314	35.0	0	100	0	0
1774	1774	32.333	79.000	578953	688245	85	2	96	2	0
2409	2409	32.350	79.760	579718	616684	38.0	11	89	0	0
1487	1487	31.850	80.460	523749	551890	18.0	0	100	0	0
2293	2293	31.868	80.873	525661	511982	9.0	0	94	6	0
2417	2417	30.313	80.537	353415	544547	41.0	2	98	0	0
2475	2475	30.683	79.523	395255	641446	900.0	78	21	0	0
1485	1485	31.980	80.247	538279	571174	21	0	99	1	0
1667	1667	31.840	80.192	522799	576486	22.0	0	100	0	0
1678	1678	31.340	80.772	467121	521721	22.0	0	100	0	0

Key.....	SAMPLEID..	LAT....	LN....	NORTH..	EAST...	DEPTH	WTGRAV	WTSAND	WTSILT	WTCLAY
1657B	1657B	30.667	80.000	392905	595801	244.0	0	0	0	0
1505	1505	30.165	81.213	336907	479458	15.0	0	100	0	0
1739	1739	30.518	79.693	376767	625373	639	0	100	0	0
1740	1740	30.597	79.332	385907	659950	802				
2397	2397	31.995	78.257	542983	759186	651.0	0	100	0	0
2407	2407	32.403	79.810	585577	611913	32.0	0	100	0	0
2704	2704	31.800	79.200	519491	670404	553.0	0	0	0	0
1495	1495	30.992	81.225	428517	478518	16.0	0	100	0	0
1683	1683	30.497	80.733	373671	525591	32.0	0	100	0	0
1714	1714	30.010	80.257	319946	571688	86.0	0	100	0	0
1756	1756	31.830	79.510	522373	641000	69	0	97	3	0
1772	1772	32.175	78.750	561864	722148	406	0	70	16	13
1703	1703	31.350	80.492	468318	548351	28.0	0	100	0	0
2273U	2273U	31.703	81.173	507379	483575	11				
2208	2208	31.242	81.187	456216	482224	10.0	0	100	0	0
2372	2372	30.017	79.000	322137	692887	798.0	0	98	2	0
1652	1652	30.152	79.447	336430	649599	769.0	0	0	0	0
1488C	1488C	31.842	80.750	522726	523633	17.0	0	0	0	0
2376	2376	30.513	78.500	378145	739911	806.0	0	100	0	0
2382	2382	31.027	78.313	435474	756464	851.0	0	100	0	0
2387	2387	31.253	78.983	459247	692035	546.0	0	0	0	0
1486B	1486B	31.970	80.500	537032	547244	18.0	0	0	0	0
1508B	1508B	30.000	81.250	318632	475888	19.0	0	0	0	0
1496	1496	30.835	81.223	411154	478642	15.0	0	100	0	0
1506	1506	30.167	81.020	337073	498074	21.0	0	99	1	0
1704	1704	31.513	80.500	486416	547477	24.0	0	100	0	0
1776	1776	32.362	79.447	581397	646152	36	0	100	0	0
2420	2420	30.367	81.213	359254	479500	22.0	0	100	0	0
2471	2471	30.067	79.678	326729	627395	894.0	0	11	37	42
2418	2418	30.330	80.703	353209	528519	33.0	0	100	0	0
2283	2283	30.643	81.405	389962	461192	8	0	90	2	0
1730B	1730B	30.000	80.070	328757	589621	374.0	0	0	0	0
1766	1766	31.017	79.003	521665	688992	450	0	99	1	0
1741	1741	30.655	79.175	392606	674868	792	0	97	3	0
1797	1797	32.475	78.000	596864	781956	324				
2423	2423	30.363	81.025	358865	497998	24.0	0	100	0	0
2700	2700	31.300	78.883	464599	701460	542.0	0	0	0	0
1677	1677	31.940	80.620	534584	535914	17.0	0	100	0	0
1690	1690	30.492	80.478	373202	550065	35.0	0	100	0	0
1708	1708	31.000	80.250	429659	571602	36.0	0	100	0	0
1751	1751	31.490	79.770	485301	616815	64	0	99	1	0
2273	2273	31.709	81.129	508021	487793	13	0	100	0	0
2294	2294	31.972	80.752	537135	523464	10.0	25	74	0	0
1662	1662	31.513	80.020	486724	593056	41.0	0	100	0	0
1761	1761	32.177	79.250	561160	664200	54	0	100	0	0
2406	2406	32.430	79.847	588496	608432	27.0	0	100	0	0
1651	1651	30.043	79.333	324577	660691	792.0	0	0	0	0
1744	1744	30.043	79.575	412925	636271	707	0	81	10	0
1749	1749	31.342	79.475	468288	645075	484				
1499	1499	30.660	81.228	391762	478125	19.0	0	100	0	0
1676	1676	32.127	80.473	554410	549680	14.0	0	100	0	0
1702	1702	31.187	80.533	450199	544465	31.0	0	100	0	0
2266	2266	32.495	80.495	595228	547443	12	1	99	0	0
2297	2297	32.467	80.222	592242	573145	11.0	0	100	0	0
1750	1750	31.303	79.763	463694	617691	144	0	76	16	7
1775	1775	32.330	79.275	578133	662363	44	0	99	1	0
1738	1738	30.520	79.867	376772	608738	480	0	96	4	0
1765	1765	31.762	79.100	515389	679157	550	0	95	5	0
2386	2386	31.003	79.000	431504	690948	782.0	0	99	1	0

Key.....	SAMPLEID..	LAT....	LOX....	NORTH..	EAST...	DEPTH	WTGRAV	WTSAND	WTSILT	WTCLAY
2412	2412	30.517	80.117	376189	584754	43.0	5	95	0	0
1655	1655	30.668	79.483	393644	645300	797.0	0	22	38	39
2277B	2277B	32.320	81.304	464922	471059	6	0	100	0	0
2277C	2277C	32.320	81.304	464922	471059	6	0	100	0	0
2422	2422	30.357	80.978	358127	502083	24.0	0	100	0	0
2287	2287	31.003	81.438	429869	450155	6	0	73	10	16
2375	2375	30.805	78.750	409973	715265	949.0	0	0	0	0
2708	2708	31.800	79.250	519414	665670	546.0	0	0	0	0
1488B	1488B	31.842	80.750	522726	523655	17.0	0	0	0	0
1508A	1508A	30.000	81.250	318632	475888	19.0	0	98	2	0
1697	1697	30.340	80.500	356386	548060	36.0	0	100	0	0
1707	1707	31.157	80.210	447049	575297	36.0	0	100	0	0
1754	1754	31.657	79.753	502870	618198	46	0	100	0	0
2272	2272	31.903	81.175	529547	483453	7	1	98	1	0
2276	2276	31.404	81.304	474195	471132	8	0	71	10	18
1730A	1730A	30.008	80.070	328757	589621	374.0	0	66	18	15
2282	2282	30.812	81.368	408605	464767	8	0	958	5	0
2381	2381	31.070	78.142	440608	772733	849.0	0	100	0	0
1734	1734	30.340	79.733	356960	621756	664	0	34	36	29
2703	2703	31.800	79.200	519491	670404	556.0	0	0	0	0
1484	1484	32.160	80.268	558217	568992	15	0	100	0	0
1486A	1486A	31.970	80.500	537032	547244	18.0	0	99	1	0
1494	1494	30.992	80.997	428495	500318	19.0	0	100	0	0
1504	1504	30.255	81.327	346906	468574	15.0	0	100	0	0
1661	1661	31.327	80.007	466047	594509	41.0	0	100	0	0
1666	1666	31.850	80.342	523811	562286	20.0	0	100	0	0
1672	1672	32.298	79.583	574197	633386	25.0	0	100	0	0
1682	1682	30.667	80.787	392498	520437	26.0	0	100	0	0
1713	1713	30.177	80.245	338422	572691	77.0	0	99	1	0
1755	1755	31.832	79.757	522264	617660	40	0	100	0	0
1759	1759	32.002	79.638	550111	628511	35	0	100	0	0
1760	1760	32.167	79.500	559697	640651	36	0	100	0	0
1771	1771	32.162	79.012	559900	687499	181	0	42	42	15
2271	2271	31.842	81.065	522701	493850	9	2	94	4	0
1769	1769	31.985	78.750	540797	712588	386	0	0	0	0
1770	1770	32.003	79.000	542351	688138	406	0	70	16	13
2385	2385	30.953	78.910	426119	699646	802.0	0	100	0	0
2479	2479	31.383	79.150	473380	675920	491.0	26	73	0	0
2480	2480	31.598	79.070	497345	683109	501.0	0	0	0	0
2391	2391	31.403	78.303	477262	756400	621.0	0	0	0	0
1489	1489	31.683	80.750	505177	523695	17.0	0	100	0	0
1490	1490	31.490	80.767	483746	522161	20.0	0	100	0	0
1656	1656	30.672	79.737	393714	621024	579.0	0	97	3	0
1657A	1657A	30.667	80.000	392905	595001	244.0	0	99	1	0
1671	1671	32.167	79.760	559395	616919	27.0	0	100	0	0
2292	2292	31.765	80.890	514207	510417	13.0	0	100	0	0
2416	2416	30.275	80.312	349278	566206	55.0	3	97	0	0
2427	2427	30.367	81.173	359248	483344	22.0	11	89	0	0
2286	2286	30.722	81.487	398675	453404	7	0	38	21	40
1500	1500	30.493	81.255	373298	475528	17.0	0	100	0	0
1748	1748	31.190	79.475	451476	645307	524	0	95	5	0
2378	2378	30.442	78.100	371119	778515	829.0	0	78	15	6
2415	2415	30.300	80.128	352169	583820	217.0	0	88	0	3
2707	2707	31.800	79.250	519414	665670	505.0	0	0	0	0
1481	1481	32.333	79.768	577861	615921	25	0	100	0	0
2392	2392	31.483	78.000	486882	785009	649.0	1	99	0	0
2413	2413	30.247	79.740	346609	621230	640.0	33	61	5	0
1735	1735	30.355	79.887	358467	606999	534	12	55	19	13
1762	1762	31.987	79.252	540106	665178	105	0	89	6	4

Key.....	SAMPLEID..	LAT....	Lon....	NORTH..	EAST...	DEPTH	WTGRAV	WTSAND	WTSILT	WTCLAY
15038	15038	30.330	81.250	355198	475968	12.0	0	0	0	0
2425	2425	30.373	81.102	359977	490231	22.0	0	100	0	0
1686	1686	30.000	80.758	318630	523341	36.0	0	100	0	0
1699	1699	30.667	80.497	392587	548219	38.0	0	100	0	0
1709	1709	30.833	80.255	411185	571248	37.0	0	100	0	0
1710	1710	30.675	80.225	393658	574239	42.0	0	100	0	0
2274	2274	31.543	81.193	489649	481696	12	1	95	4	0
2481	2481	31.680	78.800	506884	708548	543.0	0	0	0	0
1480	1480	32.493	79.763	595604	616187	20.0	0	100	0	0
1491	1491	31.512	80.988	486124	501108	13.0	0	100	0	0
1501	1501	30.483	81.000	372162	500000	26.0	0	99	1	0
1745	1745	30.863	79.728	414964	621581	461	21	78	0	0
1493	1493	31.155	81.012	446596	498888	14.0	0	100	0	0
1479	1479	32.493	79.582	595919	640772	20.0	0	100	0	0

250 Records Processed

Key..... SAMPLEID.. QUARTZ KFELDSPAR PFELDSPAR HEAVYS PHOSPHORITE

1649	1649					
1650	1650					
1733	1733					
2279	2279					
2280	2280					
2284	2284					
2419	2419					
2420	2420					
1498	1498	92	3	3	0	0
1663	1663	92	4	2	0	0
1681	1681	95	3	0	1	0
1696	1696	86	5	2	2	3
1706	1706	80	3	4	2	0
1743	1743					
1752	1752					
2373	2373					
2472	2472					
2702	2702					
1668	1668	89	5	2	4	0
2277A	2277A	87	4	2	0	0
1653	1653					
1742	1742					
2374	2374					
2405	2405					
2411	2411					
2421	2421					
2476	2476					
2706B	2706B					
1488A	1488A	87	2	6	4	0
1658	1658	93	3	1	1	0
1695	1695	86	5	3	2	0
1705	1705	89	5	3	2	0
1711	1711	89	4	4	2	0
1747	1747	19	3	2	0	0
1757	1757	84	7	5	2	0
2269	2269	87	6	3	3	0
2275	2275	88	7	3	0	0
1664	1664	89	4	5	1	0
2270	2270	67	9	2	5	6
1654	1654					
2278	2278					
2377	2377					
2383	2383					
2424	2424					
2474A	2474A					
2482	2482					
1497	1497	92	3	5	0	0
1685	1685	92	1	3	3	0
1701	1701	90	3	5	1	0
1737	1737	28	3	2	0	0
2429	2429	89	6	3	0	0
2265	2265	94	4	2	0	0
1753	1753	72	5	8	0	0
1731	1731					
2379	2379					
2380	2380					
2426	2426					
2473	2473					
2477	2477					

Key..... SAMPLEID.. QUARTZ KFELDSPAR PFELDSPAR HEAVYS PHOSPHORITE

2478	2478					
1665	1665	89	4	5	1	0
1674	1674	87	8	4	4	0
1763	1763	74	5	13	0	0
2295	2295	88	6	5	0	0
1773	1773	45	3	1	0	0
1767	1767					
2281	2281					
2285	2285					
2289	2289					
2290	2290					
2384	2384					
2388	2388					
2398	2398					
2408	2408					
2474B	2474B					
2483	2483					
1482	1482	91	2	5	1	0
1660	1660	88	5	5	1	0
1669	1669	90	4	3	2	0
1670	1670	92	3	2	2	0
1712	1712	85	5	3	6	0
1659	1659	90	5	3	0	0
1758	1758	84	6	5	3	0
1746	1746					
1764	1764					
2268	2268					
2389	2389					
2390	2390					
2404	2404					
2705	2705					
2706A	2706A					
1492	1492	91	3	3	2	0
1679	1679	92	3	2	2	0
2296	2296	82	10	5	2	0
1680	1680	92	5	2	0	0
2291	2291					
1700	1700	90	3	3	2	0
1502	1502	91	5	4	0	0
1483	1483	86	5	8	0	0
1736	1736					
1732	1732					
1768	1768					
2399	2399					
2410	2410					
2414	2414					
2701	2701					
1503A	1503A	92	5	2	0	0
1675	1675	91	2	4	2	0
1684	1684	94	3	2	1	0
1774	1774	78	5	3	0	0
2409	2409	87	8	4	0	0
1487	1487	88	5	5	1	0
2293	2293					
2417	2417					
2475	2475					
1485	1485	94	4	2	0	0
1667	1667	92	2	2	3	0
1678	1678	95	3	1	0	0

Key..... SAMPLEID.. QUARTZ KFELDSPAR PFELDSPAR HEAVYS PHOSPHORITE

1657B	1657B					
1585	1585					
1739	1739					
1740	1740					
2397	2397					
2407	2407					
2704	2704					
1495	1495	89	6	4	0	0
1683	1683	89	4	4	1	0
1714	1714	95	2	2	0	0
1756	1756	82	8	6	1	0
1772	1772	43	6	4	0	0
1783	1783	90	5	3	1	0
2273U	2273U					
2288	2288					
2372	2372					
1652	1652					
1488C	1488C					
2376	2376					
2382	2382					
2387	2387					
1486B	1486B	85	8	5	1	0
1508B	1508B	88	6	4	0	0
1496	1496	89	8	2	0	0
1586	1586	91	4	4	0	0
1784	1784	87	3	5	4	0
1776	1776	85	6	1	7	0
2428	2428	92	3	2	2	0
2471	2471	69	23	4	0	0
2418	2418					
2283	2283					
1730B	1730B					
1766	1766					
1741	1741					
1797	1797					
2423	2423					
2700	2700					
1677	1677	90	3	2	4	0
1698	1698	91	5	3	0	0
1708	1708	91	4	3	1	0
1751	1751	91	4	4	0	0
2273	2273	88	6	5	0	0
2294	2294	88	4	5	2	0
1662	1662	86	4	5	1	0
1761	1761	85	6	6	1	0
2406	2406					
1651	1651					
1744	1744					
1749	1749					
1499	1499	88	7	4	0	0
1676	1676	91	4	2	2	0
1702	1702	93	3	1	2	0
2266	2266	93	2	1	3	0
2297	2297	84	8	5	1	0
1750	1750	83	6	7	0	0
1775	1775	84	8	6	0	0
1738	1738					
1765	1765					
2386	2386					

Key..... SAMPLEID.. QUARTZ KFELDSPAR PFELDSPAR HEAVYS PHOSPHORITE

2412	2412					
1655	1655					
2277B	2277B					
2277C	2277C					
2422	2422					
2287	2287					
2375	2375					
2708	2708					
1488B	1488B	84	7	6	1	0
1508A	1508A	91	3	4	2	0
1697	1697	91	4	2	0	0
1707	1707	93	3	1	2	0
1754	1754	88	5	5	0	0
2272	2272	90	5	4	0	0
2276	2276	80	9	8	1	0
1730A	1730A					
2282	2282					
2381	2381					
1734	1734					
2703	2703					
1484	1484	90	4	4	1	0
1486A	1486A	84	7	8	0	0
1494	1494	89	6	2	1	0
1504	1504	89	7	3	1	0
1661	1661	90	4	4	0	0
1666	1666	91	4	4	0	0
1672	1672	87	6	3	3	0
1682	1682	96	2	0	1	0
1713	1713	93	3	2	1	0
1755	1755	90	4	3	2	0
1759	1759	90	6	2	1	0
1760	1760	82	6	5	2	0
1771	1771	67	14	7	0	0
2271	2271					
1769	1769					
1770	1770					
2385	2385					
2479	2479					
2480	2480					
2391	2391					
1489	1489	86	6	4	1	0
1490	1490	89	5	5	0	0
1656	1656	34	5	2	0	0
1657A	1657A	12	1	0	0	0
1671	1671	87	5	4	3	0
2292	2292	87	7	5	1	0
2416	2416	80	5	3	1	0
2427	2427	93	2	3	1	0
2286	2286					
1500	1500	94	3	3	0	0
1748	1748					
2378	2378					
2415	2415					
2707	2707					
1481	1481	83	6	7	2	0
2392	2392					
2413	2413					
1735	1735	63	6	7	0	0
1762	1762	77	7	6	0	0

Key..... SAMPLEID.. QUARTZ KFELDSPAR PFELDSPAR HEAVYS PHOSPHORITE

15038	15038					
2425	2425					
1686	1686	94	1	0	3	0
1699	1699	89	4	4	2	0
1709	1709	95	3	1	0	0
1710	1710	95	2	2	0	0
2274	2274	88	6	4	1	0
2481	2481					
1480	1480	85	6	5	1	0
1491	1491	92	3	3	0	0
1501	1501	94	2	3	0	0
1745	1745	11	1	1	0	0
1493	1493	93	3	1	1	0
1479	1479	8888	6	5	0	0

250 Records Processed

Key..... SAMPLEID.. MAGNETITE APATITE MONAZITE RUTILE ZIRCON SILLIMANITE KYANITE STAUROLITE LEUCOXENE TITANITE

15038	15038									
2425	2425									
1686	1686									
1699	1699									
1709	1709									
1710	1710									
2274	2274									
2481	2481									
1480	1480									
1491	1491									
1501	1501									
1745	1745									
1493	1493	0	2	5	4		1	0		1
1479	1479	0	3	5	7		0	0		1

250 Records Processed

SECTION 9.3

For convenience in selecting our reports from your bookshelves, they are color-keyed across the spine by subject as follows:

Red	Valley and Ridge mapping and structural geology
Dk. Purple	Piedmont and Blue Ridge mapping and structural geology
Maroon	Coastal Plain mapping and stratigraphy
Lt. Green	Paleontology
Lt. Blue	Coastal Zone studies
Dk. Green	Geochemical and geophysical studies
Dk. Blue	Hydrology
Olive	Economic geology
	Mining directory
Yellow	Environmental studies
	Engineering studies
Dk. Orange	Bibliographies and lists of publications
Brown	Petroleum and natural gas
Black	Field trip guidebooks
Dk. Brown	Collections of papers

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Publications Editor: Patricia Allgood

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