

## Table of content

I. Introduction .....	1
II. Identification of the problem .....	3
III. Aim of the work .....	4
1- Literature review .....	5
1.1. The hazard potential caused by wasting spent printed circuit boards on the environment and the need to recycle it. ....	6
1.2. The manufacturing technology of PCBs .....	8
1.2.1. The base and reinforcing materials .....	8
1.2.2. The different laminates .....	8
1.2.3. Epoxy laminates .....	9
1.2.4. Polyester laminate .....	9
1.2.5. Silicone laminate .....	9
1.2.6. Melamine laminate .....	9
1.2.7. The copper foil .....	10
1.3 The different methods applied to recover metal values from the useless PCBs .....	11
1.3.1 The pyrometallurgical method .....	11
1.3.1.1 Copper recovery .....	11
1.3.1.2 Lead recovery .....	14
1.3.2 Recovery by hydrometallurgical methods .....	16
1.3.2.1 Metal recovery by leaching with H <sub>2</sub> SO <sub>4</sub> acid .....	16
1.3.2.2 Recovery by leaching with nitric acid .....	19
1.3.2.2.1 Recovery of gold .....	19
1.3.2.2.2 Recovery of copper .....	21
1.3.2.2.3 Recovery of tin .....	22
1.3.2.2.4- Recovery of lead .....	24
1.3.2.3 – Recovery by leaching with HCl acid .....	27
1.3.2.4 – Recovery by leaching with alkali halides .....	28
1.3.2.5 – Recovery by leaching with NH <sub>3</sub> OH solution .....	28
1.3.2.6 – Cementation by iron .....	29
1.3.2.7 – Recovery by electrochemical and electrowinning methods .....	30
1.3.2.7.1 – Recovery by electrowinning method .....	30
1.3.2.7.2–The electrochemical method .....	30
1.3.2.8 – Recovery by electrostatic method .....	32
1.3.2.9 – Recovery by solvent extraction method .....	33

## Table of content

1.3.2.10 – Recovery by liquid membrane method .....	37
1.3.2.11 – Biological and microbial recovery by electrostatic method .....	37
1.3.2.12 – Mechanical recovery method .....	38
1.3.2.13 – Other options for discarding PCBs.....	39
2- Experimental .....	41
2.1 – Materials .....	41
2.1.1 – The printed circuit board scrap.....	41
2.1.2 – The chemicals.....	41
2.1.3 – Water .....	42
2.2 – Measurements of the physico-chemical properties .....	43
2.3 – Description of the suggested method .....	45
2.4 – Hydrometallurgical treatment of the PCB samples .....	47
2.5 – Pyrometallurgical treatment .....	47
2.6 – Preparation of different valuable salts .....	48
2.7 – The experimental conditions .....	49
3 – Results.....	51
3.1 – Extraction of metals from PCBs by pyrometallurgical treatment..	57
3.1.1 – Dissolving the ash of the PCB in sulfuric acid .....	57
3.1.2 – Dissolution the ash of the burnt PCBs in hydrochloric acid.....	61
3.1.3 – Dissolution of the burnt PCB ash in nitric acid .....	61
3.2 – Extraction of metals from the burnt PCBs by hydrometallurgical treatment.....	63
3.2.1 – Leaching in nitric acid .....	63
3.2.2 – Leaching in sulfuric acid .....	72
3.2.3 – Recovery of gold from PCBs samples type C .....	77
3.3 – Thermal reduction of copper, tin, and lead oxides .....	81
4 – Discussion .....	87
5 – Process economics .....	97
6 – Summary .....	99
7 – Conclusions.....	102
8 – References .....	103
9 – Summary in Arabic	

## List of Tables

Table No.	Definition	Page No.
1-	The components of the spent PCBs	1
2-	The experimental conditions applied throughout the experimental work	49
3-	The composition of the spent PCBs	51
4-	Average composition of typical PCBs	51
5-	The cost study of processing 1000 kg spent PCBs	97

## List of Plates

Plate No.	Definition	Page No.
1-	The laboratory distiller	42
2-	Laboratory apparatus for separation of copper as sulfide	44
3-	Three roll crushing machine	46
4-	The magnetic separator machine	46
5-	A tube furnace used for reduction process	48
6-	The mechanical shaker	50
7-	A photograph of spent PCBs cut strips.	52
8-	A photograph of a multilayer base material with copper	52
9-	The removed base material	53
10-	A view of removed parts from the finished PCBs	53
11-	Bed plate made of polymeric material after making the required drawings and perforation	53
12-	PCB samples containing soldering material	54
13-	PCB samples containing soldering material	54
14-	Cut boundary pieces of finished PCB	55
15-	Cut boundary pieces from finished multilayer PCB	55
16-	A scrap of finished PCB after drilling and soldering with Sn/Pb alloy	55
17-	A scrap PCB containing Sn/Pb soldering and gold figures.	56
18-	PCB scrap containing gold layer coated on copper	56

## List of Figures

Plate No.	Definition	Page No.
1-	The process flow sheet .....	45
2-	The effect of heating temperature in air on the extent of weight loss% of printed circuit boards scrap samples .....	58
3-	Effect of time of dissolution extent of ash in sulfuric acid and HCl. at room temperature.....	58
4-	The extent of acid leaching of the ash using hot sulfuric acid and HCl. as affected by the dissolution period up to 60 minutes.....	59
5-	Effect of dissolution temperature on the dissolution extent of copper in ash using 2 and 4 M sulfuric acid and HCl.....	59
6-	Effect of stirring on the dissolution extent of copper in ash (2,4 M sulfuric acid and HCl , 100°C and 60 minutes).....	60
7-	Effect of time on the extent of dissolution of PCB ash in 4 M nitric acid at 100°C.....	62
8-	Effect of nitric acid concentration on the extent of dissolution of PCB ash at 100°C for 60 minutes.....	62
9-	Effect of nitric acid concentration on the extent of copper dissolution in the PCB ash at room temperature.....	63
10-	Effect of leaching time on the extent of copper dissolution in 1 M nitric acid at room temperature (no stirring).....	64
11-	Effect of leaching time on the extent of copper dissolution in 2 M nitric acid at room temperature (no stirring).....	64
12-	Effect of leaching time on the extent of copper dissolution in 3 M nitric acid at room temperature (no stirring) .....	65
13-	The effect of nitric acid molarity on the extent of the dissolved copper at room temperature.....	65
14-	Effect of time on the extent of copper dissolution in 2 M nitric acid at temperatures up to 75°C.....	66
15-	The effect of leaching time on the extent of copper dissolution in 4 M nitric acid at different temperatures up to 75°C.....	67
16-	The effect of time and temperature on the dissolution extent of lead in 2 M nitric acid.....	68
17-	Effect of temperature on the extent of dissolution of lead in 2M nitric acid for periods up to 60 minutes.....	68
18-	The effect of nitric acid morality on extent of tin dissolution at room temperature and after 100 minutes.....	69
19-	Effect of temperature on the extent of tin recovery in nitric acid..	70
20-	Effect of nitric acid molarity on the extent of tin dissolution at temperatures up to 100°C.....	71

## List of Figures

Plate No.	Definition	Page No.
21-	Effect of temperature on the extent of deposition of tin oxide....	71
22-	Extent of dissolution of Cu, Pb and Sn as affected by time in 4M nitric acid at 20°C. (higher stoichiometric ratio.....	72
23-	Effect of sulfuric acid concentration on the extent of dissolution of copper at temperatures up to 100°C.....	73
24-	Effect of stoichiometric ratio of 2M-10M sulfuric acid on the extent of dissolution of copper at 100°C.....	73
25-	Effect of stoichiometric ratio of 4 M sulfuric acid on the extent of copper recovery from spent PCBs.....	74
26-	The effect of sulfuric acid concentration on the extent of polymer deformation at different temperatures.....	75
27-	Effect of nitric acid concentration on the extent of deformation of the polymer base-material of PCBs .....	76
28-	The effect of HCl acid concentration on the extent of deformation of the polymeric base-material of PCBs .....	76
29-	Effect of time of leaching using nitric acid (0.5 – 2 M) on the weight of gold separated from the PCB sample.....	78
30-	Effect of nitric acid (0.5 – 2 M) on the weight of gold recovered from the PCB sample at 100°C for 30 minutes.....	78
31-	Effect of leaching time on the extent of recovery of gold using 2M acids at 100°C.....	79
32-	Effect of leaching time on the extent of recovery of gold using 2-6 M acids at room temperature.....	79
33-	Effect of leaching time on the extent of recovery of gold using 2-6 M acids at 100°C.....	80
34-	Effect of temperature on the purity extent of the deposited tin oxide.....	82
35-	Effect of reduction temperature on the extent of reducing copper sulfide using hydrogen gas.....	82
36-	Effect of reduction temperature on the extent of reducing lead oxide using hydrogen gas.....	84
37-	The Arrhenius plot for the thermal reduction process of lead oxide.....	84
38-	Effect of temperature on the extent of reduction of copper, lead and tin using carbon as a reducing agent.....	85
39-	The Arrhenius plot for the thermal reduction process of copper, lead and tin oxides.....	85
40-	The purity extent of the separated gold strips as a function of potassium per-sulfate: sulfuric acid mol ratio.....	86
41-	Hypothetical simulation of the double layer .....	95