



# INŻYNIERIA MINERALNA

CZASOPISMO POLSKIEGO TOWARZYSTWA  
PRZERÓBKI KOPALIN



NR 2(52) 2023, LIPIEC – GRUDZIEŃ



JOURNAL OF THE POLISH  
MINERAL ENGINEERING SOCIETY

NO. 2(52) 2023, JULY – DECEMBER



# Dimension-Stone Quarrying Optimization through Integrated Modelling between Joint Sets and Cutting Grid: a Case Study at Tan Long Dimension Stone Quarry in Southcentral Coastal Province of Binh Dinh

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<http://doi.org/10.29227/IJM-2023-02-37>

Submission date: 23-08-2023 | Review date: 29-09-2023

## Abstract

*Dimension-stone quarrying optimization is significantly important to increase the recovery ratio of dimension stone and to reduce the cutting cost. Due to fracture-existed rock mass, in the mining operation block size and mining direction influences to the recovery ratio and the cutting cost. Therefore, the paper suggests the quarrying optimization for dimension stone to obtain the highest recovery ratio and the lowest cutting cost, based on optimizing block size and mining direction to get a cutting grid of dimension stone. Through developing an integrated modelling between joint set modelling and cutting grid modelling, intact blocks and fractured blocks were generated. From this, block statistics were conducted to get the maximum recovery ratio of dimension stone and the minimum cutting rate between the cutting area and the recovered block volume, which helps to choose an optimizing block size and mining direction. The research was carried out at Tan Long dimension stone quarry where a block size (0.9m x 0.6m x 1.35m) and a mining direction paralleling to joint set 1 will ensure the highest recovery ratio of 13.87% and the lowest cutting rate of 25 m<sup>3</sup>/m<sup>3</sup>.*

**Keywords:** dimension stone, modelling, joint sets, block size, recovery ratio, cutting rate

## 1. Introduction

Dimension stone is a natural stone made from intact rock groups of magma, sedimentation, metamorphism without discontinuities and it is quarried and processed to various sizes, shapes, colours and polishes. In stone, there are more joints causing it more difficult to recover more intact blocks [1]. This makes low effectiveness in mining operation due to low recovery ratio and high cutting rate of dimension stone. Collection on joints in stone has been interested in exploration and extraction stages but there are no applications of the collection into optimizing quarrying operation to improve the mining effectiveness [2][3]. Recovering blocks in mining operation is significantly important because it also influences to the following stages as processing activities and quarrying technology and processing technology selections suitable with joint sets to increase the recovery ratio and the low cost. Selecting block size and mining direction are dramatically important because they decide the recovery ratio, the mining cost and mining and processing technologies from joint sets at quarries.

Nowadays, there has been more research on joints in rock mass to calculate recovery ability for dimension stones. Tuan (2019) interested in joint sets to recover valuable blocks of more than 0,4 m<sup>3</sup> based on the modelling of a fracture network in rock mass but block sizes of more than 0,4 m<sup>3</sup> also were not considered their shapes [4]. Mutluturk (2007) showed that beside the quality, dimensional stone also depended on desired

size. This would be done by blocks generated from joints in rock mass. The block was put with market blocks (rectangular blocks inside and their sizes of 3 x 2 x 1m or 1.5 x 1 x 1) to show how many market blocks [5]. However, the author just showed the way to do, but did not give a result of the method because of lacking fracture modelling ability. Mosch (2011) showed the size and shape of blocks governed by dip direction of joints. The paper showed spatial joint distribution in rock mass navigated three coordination points from the data of joints with window sample and scanline. From calculating pixels in the model to show volume of blocks, the author just established a fracture network for the whole quarries in simple way with three face boundaries of the model [6]. Fernandez-de Arriba (2013) contributed an optimization algorithm on recovery ratio of dimensional stone based on blocks formatted by three joint sets with dip direction angle, dip angle and spacing parameters to divide the blocks into smaller size of 1.5 x 2 x 1.5m. Basing on the mining direction defined from minimum dip direction angle to maximum dip direction angle and mining direction increments determined a mining direction with the maximum recovery ratio, but the paper has not yet to show a change in the volume and the shape of stone blocks with spatial relationship of joint sets [7]. Yarahmadi (2017) also approached into various quarrying direction to optimize the recovery ratio, but the paper showed the intersection of three major joint sets to actual cutting pattern to generate stone blocks with their specific shapes. From

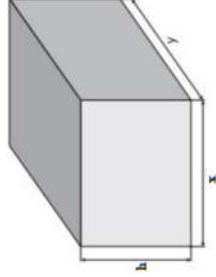


Fig. 1. Dimensions of a minable base block

Tab. 1. Values showing the change in size and area of a minable block

No	Volume, m <sup>3</sup>	Height h, m	Cutting area S <sub>0</sub> , m <sup>2</sup>	x=y, m	k ratio	Length x, m	Width y, m	Area S, m <sup>2</sup>	S/S <sub>0</sub>
1	0.4	0.6	1.96	0.82	0.1	2.58	0.26	3.41	1.74
2	0.4	0.6	1.96	0.82	0.2	1.83	0.37	2.64	1.35
3	0.4	0.6	1.96	0.82	0.3	1.49	0.45	2.33	1.19
4	0.4	0.6	1.96	0.82	0.4	1.29	0.52	2.17	1.11
5	0.4	0.6	1.96	0.82	0.5	1.15	0.58	2.08	1.06
6	0.4	0.6	1.96	0.82	0.6	1.05	0.63	2.02	1.03
7	0.4	0.6	1.96	0.82	0.7	0.98	0.69	2	1.02
8	0.4	0.6	1.96	0.82	0.8	0.91	0.73	1.97	1.01
9	0.4	0.6	1.96	0.82	0.9	0.86	0.77	1.96	1
10	0.4	0.6	1.96	0.82	1	0.82	0.82	1.97	1.01

each of the shapes, the recovery ratio would be solved by comparing to rectangular blocks having the same volume as the ones. The recovery ratio of each stone block was calculated by comparing rectangular areas having the same volume as the stone block with a total of the surrounding area of the block, and the ratio changes from 0 to 1. When the ratio reaches to 1, the shape of block will be the best. However, the paper has not assessed the change in the volume of block due to the intersection of three major joint sets and the recovery ratio has not calculated with the volume and shape the plants need [8].

From the research above, there have not been papers on optimizing dimension stone quarrying through block size and mining direction to increase the recovery ratio and to reduce the cutting rate. Therefore, the study begins with ranging block sizes from joint sets, cutting area, mining equipment and processing machines. After that, the paper establishes an integrated modelling by combining joint set modelling with cutting grid modelling. An optimal block size which has the highest recovery ratio and the lowest cutting rate will be selected. The paper did experiment at Nui Trai dimension stone quarry in Binh Dinh province, contributing to selecting an optimal block size and specific mining direction for the quarry.

## 2. Method

In dimension-stone extraction, determining recovered block sizes and mining directions is significantly important to suit to the joint network so that the recovery ratio of intact blocks could get the highest as well as the cutting cost reduces to the lowest level. Therefore, it is necessary to consider block-size optimization so that the lateral cutting area will be the smallest and the size will be suitable for cutting machines, processing machines and market-required products. For this reason, the optimization will need to be implemented with the following requirements.

### 2.1. Block size optimization

The purpose of dimension-stone extractions is to produce high-quality blocks at an optimizing cost with the highest recovery. To get the purpose achievement above, importance is choosing a suitable cutting technology to bring back a desired

result. Cutting direction influences the recovery of market blocks and the direction always parallels to the direction of major joint set.

Thus, the top and bottom planes of blocks do not put into consideration of cutting area, because both planes will not affect to the optimizing production [9]. In this case, the strongest influence is perpendicular to cutting planes. Therefore, an approach is to decrease lateral cutting planes. The desired size of a cutting block should be selected from the base of block modelling. Generally, cube and cuboid cut are the geometric shapes of the minable blocks in quarries. In fact, the height of mining benches is constant in dimensional-stone quarries, and it is determined as the height of minable blocks. On the other hand, the height of minable blocks is prior to determining and during the optimization process of production planning, the other dimensions must be optimized afterwards. The volume of a base block is calculated as Equation (1).

$$V=x \cdot y \cdot h, m^3 \quad (1)$$

In which:

- V – volume of a minable base block, m<sup>3</sup>
- x and y – length and width of a block, m
- h – height of a mining bench and blocks, m

It is assumed that the volume of a block is constant, the most suitable dimensions can be formed by Equation (2) with concentration on minimizing the lateral cutting planes.

$$V=x \cdot y \cdot h \Rightarrow y=V/(x \cdot h) \quad (2)$$

The most important is to decrease production cost to the lowest value by minimizing lateral cutting area of minable block as determined by Equation (3).

$$S=(x+y) \cdot 2h \quad (3)$$

Combining Equation (2) and Equation (3), we have:

$$S=2h \cdot [(h \cdot x^2 + V)/(x \cdot h)] \quad (4)$$

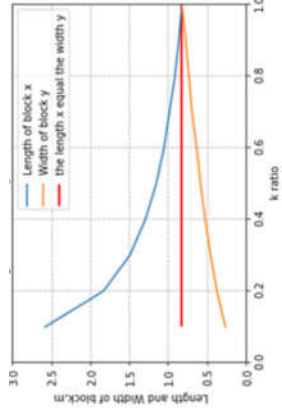


Fig. 2. Change in length and width of a minable block via k ratio.

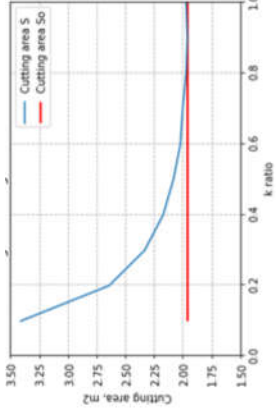


Fig. 3. Change in lateral cutting area via k ratio

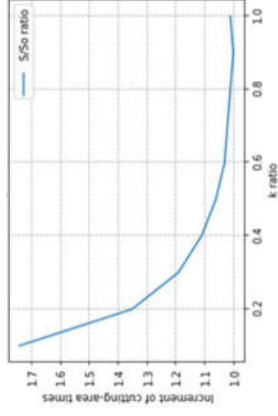


Fig. 4. Increment in cutting area times via k ratio

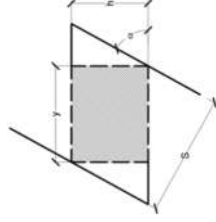


Fig. 5. Calculation on the height of minable block

To minimize lateral cutting area of minable blocks, the derivative of the function  $S=f(x)$  must be equal to zero. Dimensions of minable block is calculated with Equation (5) below:

$$\begin{aligned} \frac{ds}{dx} = 0 \Rightarrow 2h^2 \cdot x^2 - h^2 \cdot x^2 - h \cdot V = 0 \Rightarrow \\ h^2 \cdot x^2 = h \cdot V \Rightarrow x = \pm \sqrt{\frac{V}{h}} \end{aligned} \quad (5)$$

From the value  $x$  in equation (5), replacing  $x=\sqrt{V/h}$  into equation (2), the width  $y$  is defined in equation (6):

$$y=V/(x \cdot h)=V/\sqrt{V/h} \cdot 1/h=\sqrt{V/h} \quad (6)$$

Therefore, to collect the blocks with the minimum cutting cost, cutting area is square, where the width is equal to the length ( $x=y=\sqrt{V/h}$ ,  $m$ ).

To calculate lateral cutting planes, the value  $x=y=\sqrt{V/h}$  is replaced in Equation (3):

$$S_o=4\sqrt{V \cdot h} \quad (7)$$

A relationship between the width and the length of a minable block by k ratio is determined with Equation (8):

$$k=y/x, m \Rightarrow y=k \cdot x, m \quad (8)$$

Replacing the values in Equation (8) into Equation (3), we have an Equation (9) as below:

$$S=4k \cdot x \cdot h, m^2 \quad (9)$$

Increment in area will occur when the two dimensions are not equal, defined by equation (10):

$$S/S_o=(4k \cdot x \cdot h)/(4\sqrt{V \cdot h})=k \cdot x \cdot \sqrt{h}, m \quad (10)$$

In which:

k – ratio between the width and length of minable block, m;



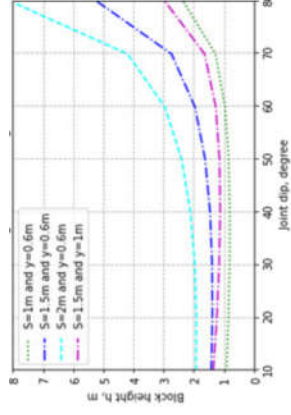


Fig. 6. Change in height of minable block via change in the dip angle in the same joint set

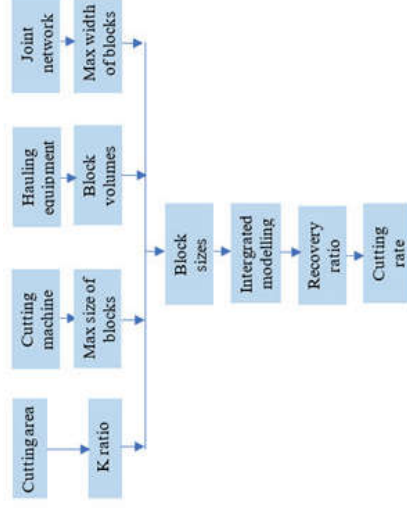


Fig. 7. Flow chart to calculate suitable size for dimension stone

- x – length of minable block, m;
- h – width of minable block, m;

It is assumed that a minable block has a volume of  $0.4 \text{ m}^3$ , its height of  $0.6 \text{ m}$  and  $k$  value changes from  $0.1$  to  $1$ , leading to the outputs represented in Tab.1 and a relationship between the width and the length shown in Fig. 2, Fig. 3 and Fig. 4.

In addition, if cutting area of minable blocks gets the lowest value, the optimization shape of the blocks will be a cuboid with square planes and the height  $h$ . It is proven that when  $h$  has a trend in reaching each dimension of minable block, the whole cutting area will reduce. Therefore, a cube with its edges of  $h$  and a cuboid with its cutting area of  $b^2$ , its height of  $d$  has the same volume. This could be proven under a condition  $h^3 = b^2 \cdot d$  và  $d < h < b$ , as in Equation (11).

$$h^2 < b^2 \Rightarrow 2h^2 < 2b^2 \Rightarrow 6h^2 < 2h^2 + 4b \cdot d \quad (11)$$

From the interpolation in Equation (11), the whole areas of a cube are smaller than that of a cuboid with square sections in the same volume. Moreover, Equation (7) is also demonstrated with the acceptance  $b < h < d$ . As a result, a cube and a cuboid having square planes is the most suitable for the shape of minable blocks.

Optimal shape of minable blocks is assessed through an index called cutting rate. The rate is defined as a cutting area per an unit volume of recovered blocks. The rate is shown as in Equation (12).

$$t = (\sum S_i) / V \quad (12)$$

In which:

- t – cutting rate;
- $S_i$  –  $i^{\text{th}}$  cutting area in minable block,  $\text{m}^2$ ;
- V – minable-block volume,  $\text{m}^3$ ;

Consideration about a minable block with squared area and height  $h$  could be written in Equation (13).

$$t = (2h \cdot (x+y)) / V = 4 \sqrt{(h/V)} \quad (13)$$

As mentioned above, a minable block will reach the most suitable volume when the cutting rate is the smallest. As Equation (14), the volume of a minable block has a trend in reaching infinite when the rate reaches to zero.

$$\lim_{V \rightarrow \infty} t = \lim_{V \rightarrow \infty} 4 \sqrt{\frac{h}{V}} = 0 \quad (14)$$

From Equation (14), if block volume increases, the cutting rate will reach zero. This could be explained that when the volume increases, mining effectiveness will increase. In the fact of dimension-stone quarrying, the volume of block only reaches a specific limit because of depending on hauling and processing equipment.

## 2.2. Height of minable block

According to section 2.1, when height of minable blocks reaches the other dimensions, the cutting area will decrease. In addition, cutting blocks needs to be interested in major joint set to decrease the influence of joints on block fragmentation. This could be done by cutting blocks along to the strike of the major joint set. In the other hand, the length of minable blocks parallels to the strike of the major joint set, the width is perpendicular to the major joint set. Therefore, to ensure the width of minable block, the height of minable block needs to be calculated following spacing of joint set and joint set dip angle. This calculation is represented in Fig. 5 and Equation (15).

$$h = ((S - y \cdot \sin \alpha) \cdot t g \alpha) / \sin \alpha \quad (15)$$



Fig. 8. Location of Nui Trai quarry in Binh Dinh Province (Mapped by UAV)

Tab. 2. Parameters of joint sets at Nui Trai quarry, Binh Dinh Province

No	Joint set 1			Joint set 2			Joint set 3		
	Dip, degree	Dip direction, degree	Spacing, m	Dip, degree	Dip direction, degree	Spacing, m	Dip, degree	Dip direction, degree	Spacing, m
1	80	70	3.5	80	190	2	80	35	5
2	80	70	2	80	190	3	80	35	2
3	80	70	3.5	80	190	2	80	35	2
4	80	70	2.5	80	190	2	80	35	2
5	80	70	4	80	190	1	80	35	2
6	80	70	2.5	80	190	2	80	35	5
7	80	70	2	80	190	3	80	35	4
8	80	70	1.5	80	190	2	80	35	2
9	80	70	3	80	190	1	80	35	2
10	80	70	2	80	190	4	80	35	5
11	80	70	5	80	190	1	80	35	2
12	80	70	3	80	190	4	80	35	5
13	80	70	3	80	190	3	80	35	1
14	80	70	2	80	190	1	80	35	1.5
15	80	70	3	80	190	2	80	35	5
16	80	70	2	80	190	1	80	35	5
17	80	70	2	80	190	1	80	35	2
18	80	70	2	80	190	2	80	35	2
19	80	70	4	80	190	2	80	35	5
20	80	70	4	80	190	1	80	35	2
21	80	70	2	80	190	2	80	35	6
22	80	70	3	80	190	1	80	35	3
23	80	70	5	80	190	5	80	35	2
24	80	70	3	80	190	2	80	35	2
25	80	70	3	80	190	4	80	35	3
26	80	70	3	80	190	5	80	35	3
27	80	70	1	80	190	2	80	35	2
28	80	70	3	80	190	2	80	35	4
29	80	70	2	80	190	2	80	35	3
30	80	70	3	80	190	1	80	35	3
31	80	70	2	80	190	2	80	35	1
32	80	70	2.5	80	190	4	80	35	6.5
33	80	70	3	80	190	2	80	35	3
34	80	70	5	80	190	1	80	35	6
35	80	70	4	80	190	3	80	35	6
36	80	70	1	80	190	2	80	35	2
37	80	70	3	80	190	3	80	35	5
38	80	70	2	80	190	1	80	35	2
39	80	70	2	80	190	5	80	35	2
40	80	70	1	80	190	1	80	35	5
41	Average Spacing		2.75	Average Spacing		2.25	Average Spacing		3.3

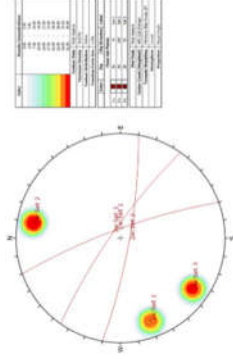


Fig. 9. Analyzing and representing joint sets for Nui Trai dimension stone quarry in Binh Dinh Province

Tab. 3. Working parameters of selected disc sawing, CXVQ-3300-2

No	Parameters	Unit	Value
1	Machine size	m	3.45*1.35*2.6
2	Number of discs	disc	2
3	Disc diameters	m	2.2; 3.5
4	Cutting depth	m	0.85-1.5
5	Cutting width	m	1.3-1.35
6	Machine weight	ton	9.5
7	Power capacity	kW	2*45kW

Fig. 10. Disc sawing machine at the quarry.



Tab. 4. Parameters of disc sawing machine, QSQ2200B, at processing plant

No	Parameters	Unit	Value
1	Maximum cutting depth	m	0.95
2	Cutting length (axis X)	m	3.8
3	Cutting length (axis Y)	m	2
4	Power motors	Kw	45/55
5	Disc diameters	m	2.2;2;1.8;1.6 1.2;1;0.8;0.6
6	Block width	m	2.1
7	Block height	m	1.35
8	Block length	m	3.6
9	Cutting velocity (axis X)	m/s	Modify
10	Beam velocity	m/mi	Modify
11	Vertical displacement velocity	m/s	Modify
12	Beam-moving power	Kw	3
13	Vertical displacement motor	Kw	1.5
14	Installed power	Kw	45
15	Cooling water (1.5 bar)	l/m	30
16	Machine length	m	7.5
17	Machine width	m	4.35
18	Machine height	m	6
19	Machine weight	tone	12

Tab. 5. Summary of necessary parameters for limiting sizes of minable blocks

No	Parameters	Block length, m	Block width, m	Block height, m	Block volume, m <sup>3</sup>
1	Disc sawing machine for blocks	-	1.4	1.35	-
2	Disc sawing machine for slabs	3.6	2.1	1.35	-
3	Cutting paralleling to joint set 1	-	2.94	-	-
4	Cutting paralleling to joint set 2	-	2.94	-	-
5	Cutting paralleling to joint set 3	-	2.94	-	-
6	Hauling and transporting machines	-	-	-	7

Tab. 6. Minable-block sizes

No	Block name	Block length, m	Block width, m	Block height, m	Block volume, m <sup>3</sup>
<b>I</b>					
1	Size 1.1	1.9	1.3	0.6	1.5
2	Size 1.2	1.6	1.1	0.6	1.1
3	Size 1.3	1.3	0.9	0.6	0.7
4	Size 1.4	2	1.4	1.35	3.8
5	Size 1.5	1.7	1.2	1.35	2.8
6	Size 1.6	1.4	1	1.35	1.9
7	Size 1.7	1.1	0.8	1.35	1.2
8	Size 1.8	0.9	0.6	1.35	0.7
<b>II</b>					
1	Size 2.1	1.9	1.3	0.6	1.5
2	Size 2.2	1.6	1.1	0.6	1.1
3	Size 2.3	1.3	0.9	0.6	0.7
4	Size 2.4	1.7	1.2	1.35	2.8
5	Size 2.5	1.4	1	1.35	1.9
6	Size 2.6	1.1	0.8	1.35	1.2
7	Size 2.7	0.9	0.6	1.35	0.7
<b>III</b>					
1	Size 3.1	1.9	1.3	0.6	1.5
2	Size 3.2	1.6	1.1	0.6	1.1
3	Size 3.3	1.3	0.9	0.6	0.7
4	Size 3.4	1.7	1.2	1.35	2.8
5	Size 3.5	1.4	1	1.35	1.9
6	Size 3.6	1.1	0.8	1.35	1.2
7	Size 3.7	0.9	0.6	1.35	0.7

Tab. 7. Summary of recovery ratio and cutting rate for different block sizes in three cutting directions

No	Block name	Total number of blocks	Total number of intact blocks	Recovery ratio, %	Cutting rate, m <sup>3</sup> /m <sup>3</sup>
1	Size 1.1	12480	451	3.61	81.97
2	Size 1.2	17856	932	5.22	61.32
3	Size 1.3	27360	2375	8.68	40.86
4	Size 1.4	4032	86	2.13	91.66
5	Size 1.5	5742	191	3.33	65.01
6	Size 1.6	8307	490	5.90	41.62
7	Size 1.7	12960	1220	9.41	30.80
8	Size 1.8	21780	3021	13.87	25.37
9	Size 2.1	12480	276	2.21	133.94
10	Size 2.2	17856	739	4.14	77.34
11	Size 2.3	26752	2049	7.66	46.31
12	Size 2.4	5742	149	2.59	83.33
13	Size 2.5	8520	397	4.66	52.69
14	Size 2.6	13500	1140	8.44	34.34
15	Size 2.7	21978	2691	12.24	28.74
16	Size 3.1	12480	263	2.11	140.56
17	Size 3.2	17856	681	3.81	83.92
18	Size 3.3	26752	1862	6.96	50.96
19	Size 3.4	5742	139	2.42	89.32
20	Size 3.5	8520	344	4.05	60.80
21	Size 3.6	13500	1033	7.65	37.90
22	Size 3.7	21978	2592	11.79	29.83

In which:

h – height of minable block, m;

α – dip angle of joint in a joint set, degree;

y – width of minable block, m;

S – Spacing of joint in the same joint set, m.

Through analysis on heights of block with dip angle of joint in a joint set changing from 0° to 80° and spacing S changing from 1m to 2m, the width of minable block changing from 0.6m to 1m, the heights were changed and shown in Fig. 6.

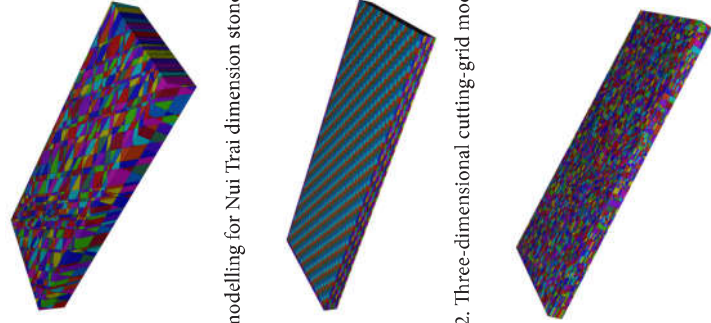


Fig. 11. Three-dimensional modelling for Nui Trai dimension stone quarry, Binh Dinh Province

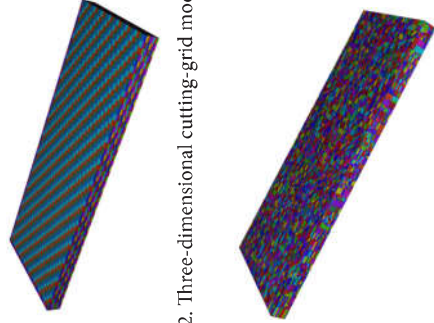


Fig. 12. Three-dimensional cutting-grid modelling

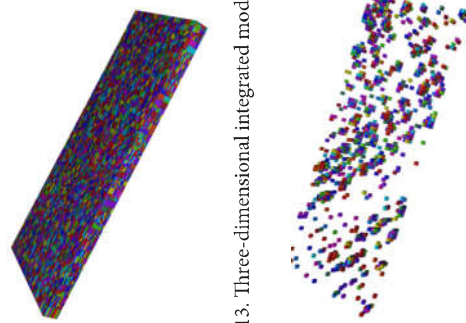


Fig. 13. Three-dimensional integrated modelling

Fig. 14. Three-dimensional modelling after applying filter algorithm for intact blocks

Through Fig. 6, it is claimed that when dip angle of joint in the same joint set becomes steeper, the height will be raised and inversely.

### 2.3. Flow chart to determine the most suitable block size

1. Cutting area: Based on optimal block size, the length and width of minable block are equal, bringing back the highest effectiveness, but consideration on ratio relationship, the width being 80 percent as much as the length still ensures cutting area which is little larger than the optimal cutting area.
2. Mining and processing equipment: When implementing mining and process operation for dimension stone, working parameters of the equipment are interested in the dimensions of block, including length, width, and height the equipment could operate properly. This is a foundation to select block size, which is not larger than the chosen equipment.
3. Hauling equipment: Hauling equipment is interested in the volume of minable block. Therefore, the volume could not exceed the one the equipment delivers.
4. Joint Network: Joint network mentions to the maximum width of a block, which is calculated via average spacing of joints in the same set. The maximum width satisfies conditions in equation (16).

$$y_{max} = (S_{jp} \cdot tg\alpha \cdot h \cdot sin\alpha) / \cos\alpha \quad (16)$$

in which:

- $y_{max}$  – maximum width of minable block, m
- $S_{jp}$  – average spacing of joints in the same set, m
- $\alpha$  – dip angle of joints in the same set, degree

5. The length of minable block is firstly selected from the dimensions satisfying the width of slabs cut following the standard of dimension stone and the height of cutting blocks being smaller than the maximum height mining and processing equipment could operate. The maximum width,  $y_{max}$ , is defined in step 4, checking the width according to the equipment from mining and processing operation and giving a range of wide value decreased gradually to zero. After that the length of a cutting block is defined following the ratio have been defined in step 1. Checking dimensions of cutting blocks is according to the width and length of working operation from the equipment and the working volume of hauling equipment; more than  $0.4 \text{ m}^3$ . As a result, lists of the satisfied sizes are given with the strike of joint sets.

6. Integrated Modelling: Modelling is formed with a base on joint sets, mining direction, block sizes of minable block, leading to forming an integrated modelling being a result of intersection between joint sets and cutting grid.

7. Recovery ratio is a result after modelling, where the ratio is calculated by the number of intact minable blocks divided by the total blocks in the modelling.

8. Cutting rate,  $t$ , is defined a ratio between total cutting area and recovered block volume, shown in equation (17).

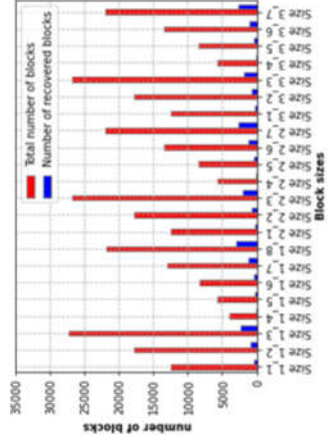


Fig. 15. Total number of blocks and recovered blocks for each block size

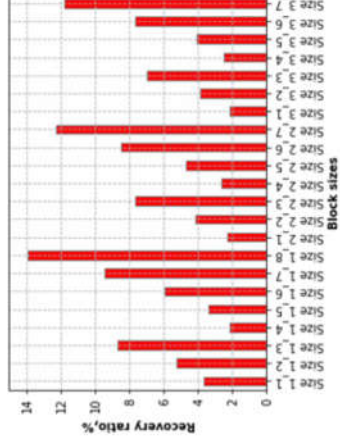


Fig. 16. Recovery ratio for each block size

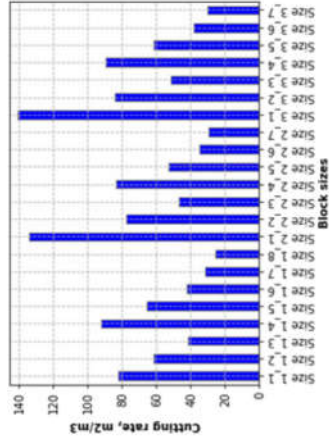


Fig. 17. Cutting rate for each block size

$$t = (\sum S_{ij}) / (\sum V_j)$$

In which:

t – cutting rate.

$S_{ij}$  –  $j^{\text{th}}$  cutting area in  $i^{\text{th}}$  minable block,  $m^2$ .

$V_j$  –  $j^{\text{th}}$  recovered block volume,  $m^3$ .

$i, j$  – index for the number of cutting areas in a specified block.

In cutting operation in dimension stone quarry, due to adjacent blocks, the number of cutting planes is three, including bottom, side, and back planes. The flow chart to determine the most suitable block size is represented in Fig. 7.

### 3. Case study at Tan Long dimension stone quarry in Southern coastal province of Binh Dinh

#### 3.1. Joint data collection

Nui Trai dimension stone quarry extracts granite to produce dimension stone in Phu Cat district, far from 35km Northern Quy Nhon city. The quarry spreads about 4.9 ha at side hill with an elevation from +30m to 70m (Fig.8). Joints selected in Tab. 2 was carried out with scan line on the surface. After that these joints was classified into joint sets with

classified algorithms via software Dips [10],[11] (Fig.9). The group include three major joint sets with the dip direction and the dip of  $70^\circ < 80^\circ$ ,  $190^\circ < 80^\circ$  và  $35^\circ < 80^\circ$ , respectively.

#### 3.2. Mining fleet information

Dimension stone quarries in Binh Dinh Province mostly used modern sawing methods, such as disc sawing, diamond wire sawing. In which, quarries popularly applied main sawing method of being disc sawing at large-output quarries because smooth planes were created to form block sizes satisfying size standard for the processing plant.

In dimension stone quarries estimated to use disc sawing machines but this research only carried out with the same disc sawing machine on supplying firms. For example, disc diameters and working parameters were shown in Table 3 (Fig. 10).

The quarry estimated to use disc sawing machine to slice blocks into slabs with blaze diameters from 0.6 to 3m on the same rotary axis, unchanged spacing of the blazes installed equal to slab thickness. In processing operation, blaze system was moved in three-dimension cutting. Basic parameters of disc cutting at processing plant were shown in Table 4. The quarry used front-wheel excavators to transport blocks from the quarry to stockpiles, the excavators could evaluate up to 7  $m^3$  (about 20 tonnes).



Through joint-set analysis, mining fleet and necessary sizes to determine the sizes and volume of minable blocks were shown in Tab. 5.

The information summarized in Table 5 combined with the flow chart in Fig. 7 to design the sizes of minable blocks given Tab. 6.

### **3.4. Establishment of an integrated modelling between joint sets and cutting grid**

From the joint data measured in Tab. 2, a three-dimensional modelling was built with joint sets. The size of the modelling of being 100 m x 40m 5m was generated through software 3DEC of atasca brand [12], given in Fig. 11.

Cutting grid modelling formed by the sizes of minable blocks with cutting operation paralleling to each joint set in Table 6 was represented in Fig. 12.

### **4. Results and discussions**

By intersection between joint set modelling in Fig. 11 and cutting-grid modelling in Fig. 12, an integrated modelling was generated and shown in Fig. 13.

By a filter algorithm in 3DEC software for filtering intact blocks in the modelling, the number of intact blocks were derived from the integrated modelling and shown in Fig. 14.

Particularly, establishing three-dimensional integrated modelling between joint sets and cutting grid generated with one of the three cutting directions (paralleling to joint set 1, joint set 2 and joint set 3) and block sizes in Tab. 6. The total number of blocks and intact blocks, recovery ratio and cutting rate were obtained in Tab. 7. The result showing the total number of blocks and intact blocks was represented in Fig. 15. Similarly, the figures for the recovery ratio and the cutting rate were represented in Fig. 16 and Fig. 17, respectively.

In Tab. 7, Fig. 15, Fig. 16 and Fig. 17, block sizes of size 1\_8, size 2\_7 and size 3\_7 have the same size of 0.9m x 0.6m x 1.35m. Recovery ratios relating to these sizes are 13.87 %, 12,24% and 11,79%, respectively. Meanwhile, respective cutting rates for these sizes are 25.37%, 28.74%, 29.83%. As a re-

sult, the size of size 1\_8 with its value of 0.9 x 0.6 x 1.35m cut in the direction paralleling to joint set 1 has the highest recovery ratio of 13.87% and the lowest cutting rate of 25.37%.

### **4. Conclusions**

Dimension stone has been more and more popular extraction to bring back higher effective economic compared with the extraction for common construction materials. Effectiveness of quarrying dimension stone depends on less joint sets existed in quarries and selecting suitable cutting and processing methods. This is shown via improving the recovery ratio and the low cost of dimension stone. The paper showed clearly that mining direction and block size play an important role in selecting cutting machine from joint network at quarries. There are some conclusions below:

- Integrated modellings selected play an important role in calculating the volume and the size of minable blocks because the modelling is interested in dips, dip directions, spacings of joints and cutting grids.
- Optimizing block size plays an important role in decreasing block-cutting area. Optimization size is square, but short edge being more than 80 percent of long edge still ensures and suits with cutting machines. Minable-block size has a significant meaning in calculating recovery ratio, depending on joint-set parameters. The optimizing size in cutting grid must ensure the highest recovery ratio and the lowest cutting rate. For Nui Trai dimension stone quarry, the size of size 1\_8 (0.9x0.6x1.35m) is sure that the recovery ratio is the highest while the cutting rate is the smallest from the sizes selected.
- Mining direction for dimension stone is horizontal length of block size chosen to parallel to one of the strikes of joint sets. The selected direction ensures the recovery ratio is the highest while the cutting rate is the smallest. For Nui Trai dimension stone quarry, mining direction is parallel to joint set 1.

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# Fuzzy Multi-Attribute Decision Model for the Optimal Mine Closure Option to Contribute to Sustainable Development in Binh Duong Province, Vietnam

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<http://doi.org/10.29227/IIM-2023-02-38>

Submission date: 20-08-2023 | Review date: 21-09-2023

## Abstract

*Binh Duong is the leading industry development province of Vietnam. In particular, quarries in Di An, Phu Giao and Tan Dong Hiep districts have contributed significantly to the demand for construction and transportation in the locality and vicinity. The quarries in Binh Duong province are exploited by the open-pit mining method. The mining depth is from 100m to 150 m. The mine surface area is hundreds of hectares. At the end of the quarries will leave huge pits. The current regulations of Vietnam on mine closure are mainly aimed at ensuring the stability of the physical and chemical factors of the mine, while the land use after the mine closure is permanent. Binh Duong province has a rapid urbanization rate, the use of land after mining here is very important and has a significant influence on the sustainable development of the region. Depending on the occupied area of the mine or mine cluster, there are many options to close the mine after mining based on the required technical, economic, social and environmental criteria. The paper uses fuzzy multi-attribute decision model to calculate the optimal solution selection. The selected option is to use the mine lake for tourism, entertainment and water storage at Nui Nho mine, Di An city, Binh Duong province with the highest total score of economic, social and environmental criteria.*

**Keywords:** mine closure, fuzzy multi-attribute decision, sustainable development

## 1. Introduction

Mining closure is rated as one of the top risk activities of mining, its importance is increasingly recognized, more stringently required mine closure regulations have been introduced since 1990s [19, 23]. Mining closures can cause negative impacts such as job loss, tax revenue deficit, impact on infrastructure development, reduced demand for local goods and services, and especially environmental landscape [1, 6]. The development opportunities that mines can offer to local communities after mine closure should be carefully studied. If managed properly, the mine closure transition can provide significant opportunities in line with the Sustainable Development Goals (SDGs), such as resettlement, infrastructure development for other purposes creating new economic resources [3, 18].

Around the world, organizations such as the International Council on Mining and Metals (ICMM), the World Bank have reported on the sustainable mine closure framework [13, 15]; Countries with developed mining industries such as the US, Australia, Canada, and South Africa have legalized mine closures and issued detailed manuals. Some of the key themes in these guidelines and standards include integrated closure planning that considers the environmental, financial, physical, and socioeconomic context of a particular site, incorporating the stakeholders including community goals and aspects of social welfare, environmental management based on optimization of protection, land use and infrastructure

[14]. Some of the proposed legislation includes the following sustainable land use practices under the statutory framework: i) Closures must begin at the start of the operational phase and continue until the start of the closure phase; ii) The quantification and management of environmental risks must be achieved; iii) Mine Health and Safety regulations must be observed; iv) The identification and quantification of residual environmental impacts must be achieved; v) The land must be restored to its natural state or to a predetermined state as agreed by the government to include the concept of sustainable development; vi) Mining operations must be effectively and cost-effectively closed.

Binh Duong is a leading industrial province in the country. Along with the economic development and infrastructure construction, the demand for stone construction materials is increasing. Currently, the province has 22 mines, of which 16 are being exploited and 5 are under construction. The total licensed mining area is 778.11 hectares with a total licensed mining capacity of 14,112 million m<sup>3</sup>/year. Construction material mines in Binh Duong province are mainly concentrated in the districts: Phu Giao (3 mines) and Bac Tan Uyen (19 mines).

The quarries in Binh Duong have a close relationship: they work together on the same shore, exploit together deep below the self-flowing drainage level, and are connected to regional roads. Around the mine, it is arable land of local people. Open pit mining inevitably causes changes in the surrounding envi-



Fig. 1. Location of mine closure area (Google Map)

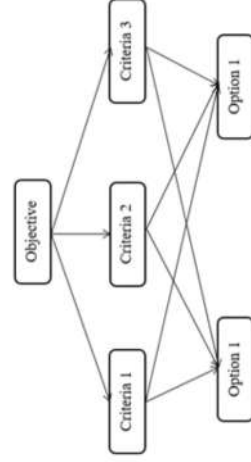


Fig. 2. AHP hierarchical structure diagram

ronment, the extent of which depends on the depth of finish, mining capacity, technology, equipment as well as size, shape and location of the mine [7].

The mining process has changed the landscape, affecting the environment, ecology, and traffic in the area. Currently and a few years from now, the quarries in Binh Duong province will end their exploitation and have to close according to regulations. Vietnam has clear regulations on the contents of mine closures, which are shown in the following documents:

- Law on Minerals No. 60/2010/QH12 approved by the National Assembly of the Socialist Republic of Vietnam, term XII, 8th session, on November 17, 2010;
- Law on Environmental Protection No. 55/2014/QH13 passed by the National Assembly on June 23, 2014;
- Circular No. 45/2016/TT-BTNMT dated December 26, 2016 of the Ministry of Natural Resources and Environment "Regulating on mineral exploration project, mineral mine closure and form of report on mineral activities and samples of documents in the application for a license for mineral activities, the application for approval of mineral reserves, and the application for closure of a mineral mine; order and procedures for mineral mine closure";
- Circular No. 38/2015/TT-BTNMT dated June 30, 2015 of the Ministry of Natural Resources and Environment on environmental renovation and restoration in mineral mining activities;

The regulations on mine closure in Vietnam are determined that after the end of mining, bring the mine to a stable state: leveling, renovating floors, dismantling works, etc., make a plan to close the mine and submit it to the authorities when preparing to end mining. The new mine closure is mainly concerned with the physical stability of the work, not integrating economic and social factors into the mine closure. The site of land use after the mine closure is directly related to

society, but it is only oriented to be used as a water reservoir, planting trees without specific instructions on physical and chemical stability, etc. Closing costs have to be taken from the project's funds, but with each different model of land use after mining, the cost of closing the mine will be different, affecting the efficiency of the investor. At that time, it is necessary to consider the lifespan, the end boundary, the different stability assurance solutions to ensure the effective project after the closure. Land use after the closure of mines has not been effective, the orientation to use the premises stated in the environmental impact assessment (EIA) report is often counter-productive, simple, with as little improvement costs as possible, not really suitable with the natural and socio-economic characteristics of the area.

Mines in the same area do not have a link in a common whole, there is no integrated closure model for the most optimal use of the site after closing. Existing studies have only focused on the use of post-closure premises on the basis of the criteria to ensure the set goals, but there are no studies on stability for each model.

That's why choosing an appropriate mine closure model that contributes to the sustainable development of the region is essential and has practical significance, especially with Binh Duong province with rapid urbanization and rapid development of industries.

## 2. Research methodology

### 2.1. Research subjects

- Research object: Mine closure and land use after mining.
- Scope of research: Nui Nho mine with an area of 33.9 hectares. This is the place that takes away the most soil and rock in the area, causing a lot of environmental impact
- Location is in Binh Thung quarter, Binh An ward, Di An town, Binh Duong province. The location of mineral mine closure is about 20 km southwest of Ho





Geological Controls on Evolution of Submarine Channels in Song Hong Basin, Offshore Vietnam,.....	7
Anh Ngoc LE, Hoa Minh NGUYEN, Muoi Duy NGUYEN, Ngan Bui THI	
Simulation on Flyrock due to Blasting Using Smoothed Particle Hydrodynamics (SPH) with LS-Dyna software,.....	13
Bao Tran DINH, Trieu Do VAN, Viet Pham VAN, Nguyen Dinh ANH	
Current Situation of State Management on Mineral Mining in The North Eastern Vietnam and Tasks Proposal for Audit Activities,.....	23
Bui Thi Thu Huong, DUONG Quang Chinh, DUONG Duc Trong	
A New Approach on Improving The Operation of Over-Current Relays in 6kV Mining Grids of QuangNinh, VietNam,.....	29
BUN Ho Viet, THANH Le Xuan	
Prediction of Tunnel Cross-Sectional Area After Blasting,.....	39
Chi Thanh NGUYEN, Nghia Viet NGUYEN	
Research on the Effect of the Mine Waste Dump on the Stability of Tunnels Below in the Quangninh Coal Area by Numerical Method,.....	49
Dang VAN KIEN, Vo TRONG HUNG, Bui XUAN NAM, Nguyen HUU SA	
Industrial Symbiosis Applied to Vietnam Coal Mining Industry to Promote the Circular Economic Model towards Sustainable Development Goals,.....	57
DINH CHIEU LE, NGA Nguyen, THI BICH Dong, MINH THONG Le	
Effect of Power Quality on the Performance of Explosion-Proof Transformers in Mining in Vietnam,.....	65
DO Nhu Y, NGO Xuan Cuong, NGUYEN Thi Hong	
Determining the Correction Factors of Overhead-Conductors in 6kV Mining System of QuangNinh, VietNam with the Consideration of Power Harmonic Impact,.....	71
GIANG Vu Hoang, THANH Le Xuan	
Machine Learning Algorithms for Data Enrichment: A Promising Solution for Enhancing Accuracy in Predicting Blast-Induced Ground Vibration in Open-Pit Mines,.....	79
Hoang NGUYEN, Xuan-Nam BUI, Carsten DREBENSTEDT	
Numerical Study on Effects of Airflow Parameters on the Air Temperature the at Mechanized Longwall of Mongduong Coal Mine,.....	89
Hong NGUYEN THI, Quang NGUYEN VAN	
Segmentation of Homogeneous Regions of Gravity Field Properties by Machine Learning Method in Central Area of Vietnam,.....	97
Hong Phan THI, Phuong DO MINH, Huu Tran VAN	
The Collision Between Indochina and South China Blocks in Northwestern Vietnam and its Controversy,.....	103
Khuong The HUNG, Jan GOLONKA, Nguyen Khac DU	
Challenges to the Development of Unconventional Natural Gas – The Case of Shale Gas,.....	113
LE Minh Thong, TRAN Van Hiep, DO Huu Tung	
The Impact of Digital Leadership on Organizational Performance: A Study in Vietnam's coal Mining Companies,.....	121
Le VAN CHIEN, Nguyen DUC THANG, Pham KIEN TRUNG, Nguyen THI HOAI NGA	
Developing Electronic Government Towards Digital Government to Enhance the Efficiency of State Governance in Vietnam,.....	131
Chu Thi Khanh LY, Nguyen Quynh NGA, Nguyen Van HAU, Tran Thi Huong HUE	
Gas Hydrate Detection Based on High Resolution Seismic Data in the Southeastern Offshore of Vietnam,.....	137
Mai Thanh TAN, Mai Thinh HA, Nguyen Quoc HUY, Nguyen Nhu TRUNG	
Optimizing the Width and Compressive Strength of Artificial Protective Pillar in the Mining of Medium-Thick Coal Seams in Quang Ninh Using the Numerical Model,.....	143
BUI Manh Tung, DINH Van Cuong	
Facies Analysis and Depositional Environmental Interpretation of The Upper Oligocene, Block 09-2/10, Cuu Long Basin,.....	155
Muoi Duy NGUYEN, Anh Ngoc LE, Hoa Minh NGUYEN, Ngan THI BUI	
Identifying the Potential Application of Unmanned Aerial Vehicle Technology in Mine Waste Dumps,.....	163
Ba Dung NGUYEN	
Establishing the Vertical Movement Map of Cuu Long Delta River by GNSS Data,.....	173
NGUYEN Gia Trung, NGUYEN Viet Nghia, LY Lam Ha, YU Trung Dung, NGUYEN Quoc Long, KIM THI Thu Huong, PHAM Ngoc Quang, NGUYEN Viet Qian	
Developing Criteria for Assessing The Stability of Water Supply Models in High Mountains and Water-Scare Areas,.....	179
NGUYEN Manh Truong, DINH Anh Tuan, NGUYEN Tiep Tan, U Thi Hong Nghia, DO Van Binh	
Sustainable Industrial Development in Vietnam,.....	187
NGUYEN Ngoc Son	
Building a Digital Society to Enhance the Efficiency of National Governance in Vietnam,.....	195
NGUYEN Quynh Nga, CHU Thi Khanh Ly, NGUYEN Van HAU	
Theory Y in Modern Management: Advantages, Disadvantages, and the Relationship with Theory X,.....	203
NGUYEN Thanh Ha, NGUYEN THI Thanh Huyen, NGUYEN Thi Lan Huong	
Enhancing Workplace Safety: A Comprehensive Action Plan for Duong Huy Coal Company (2021–2023),.....	205
Nguyen THI HOAI NGA, Nguyen DUC THANG, Le DINH CHIEU, Le VAN CHIEN, Pham KIEN TRUNG	
Research on Electric Leakage Protection to Improve Electrical Safety in Underground Mining in Vietnam,.....	209
NGUYEN Trung Giang, NGUYEN Thac Khanh, NGO Xuan Cuong, DO Nhu Y	
Investigation of Marine Sediments with a Sub-bottom Profilers System in West Coast of Camau, Vietnam,.....	215
DUNG NGUYEN Quang, GIANG NGUYEN Van, THANH LE Ngoc	
Integration of Mobile and Web GIS Technologies to Promote Smart and Sustainable Tourism in Vietnam,.....	225
Mai Dung NGUYEN, Xuan Ban TO, Hong Anh LE	
Study on Technological Solutions to Increase the Recovery and Quality of the Copper Concentrate at Ta Phoi Beneficiation Plant in Vietnam,.....	231
NHU Thi Kim Dung, PHAM Thi Nhung, YU Thi Chinh, LE Viet Ha	
Promoting Gender Equality and Awareness in the Vietnamese Mining Sector: Perceptions, Challenges, and Policy Recommendations,.....	235
Pham MINH HANG, Pham THI LUONG, Nguyen THI HOAI NGA, Pham KIEN TRUNG	
Dimension-Stone Quarrying Optimization through Integrated Modelling between Joint Sets and Cutting Grids: A Case Study at Tan Long Dimension Stone Quarry in Southeastern Coastal Province of Binh.....	239
PHAM Van Viet, NGUYEN Anh Tuan, PHAM Van Hoa, TRAN Dinh Bao	
Fuzzy Multi-Attribute Decision Model for the Optimal Mine Closure Option to Contribute to Sustainable Development in Binh Duong Province, Vietnam,.....	249
PHAM Hong Viet, DO Ngoc Tuoc, BUI Xuan Nam	
Research of Building the Reasonable Mixing Ratio between Waste Rock and Fly Ash as Backfill Material in Mongduong-Cocau Area, Quang Ninh, Vietnam,.....	257
PH Hung NGUYEN, CaoKhai NGUYEN, Thi Kim Thanh NGUYEN	
Selecting Parameters to Design Auxiliary Ventilation in Underground Mine,.....	267
Phuong Thao DANG	
Fracture Mechanism of Hard Main Roof and Determining the Width of Coal Pillars when Extracting Flat-lying Coal Seams,.....	271
Quang Phuc LE, Van Chi DAO, Phi Hung NGUYEN, Thai-Tien Dung VU	
Understanding Saltwater Origins and Mechanisms in the Coastal Aquifers of Da Nang Area (Central Vietnam),.....	281
Thao Bach NGUYEN, Nhan Dang DUC, Bang Duc DAO	
Emission Reduction in Oil & Gas Subsurface Characterization Workflow with AI/ML Enabler,.....	289
Thuy Nguyen Thi THANH, Samie LEE, The NGUYEN, Le Quang DUyen	
Effectiveness of a Mobile Application-Based Intervention to Improve Knowledge and Practice Regarding Silicosis Among High-Risk Workers of Dust Exposure in a Northern Province of Vietnam,.....	295
Nguyen Thi THU HUYEN, Ta Thi KIM NHUNG, Pham Thi QUAN, Nguyen THANH THAO, Nguyen NGOC ANH, Nguyen Thi LIEN HUONG, Le Thi HUONG, Luong MAI ANH, Le Thi THANH XUAN	
3D LOD3 Modelling of High Building Using Terrestrial Laser Scanning and Unmanned Aerial Vehicle: A Case Study in Halong City, Vietnam,.....	303
Le THI THU HA, Nguyen QUOC LONG	
Geological and Geochemical Characteristics of the Pac Lang Gold Deposits, Northeastern Vietnam and Their Potential Prospects,.....	311
KHUONG The Hung, NGUYEN Van Dat, NGUYEN Thi Cuc, PHAM Nhu Sang	
Geological Hazard Investigation Combined with Mathematical Modelling in Flood Risk Assessment: A Case Study of Hoang Long River, Ninh Binh Province, Vietnam,.....	319
Nhu Y NGUYEN, Vo Xuan BAN, Dang Dinh KHA	
Radon-Radium Thermal Mineral Water in Vo Am Ecotourism Project Area, Ngoc Luong Commune, Yen Thuy District, Hoa Binh Province, Vietnam,.....	327
BAN TO Xuan, DUC Tran Van, TRONG Nguyen Huu, TUAN Truong Duc	
Prediction of Road Subsidence Caused by Underground Mining Activities by Artificial Neural Networks,.....	335
Hung Viet NGUYEN, Duyen Quang LE, Long Quoc NGUYEN, Tomasz LIPECKI	
Assessment of Air Quality Index in Annaba,.....	341
Salem BADIOULI, Aissa BENSELHOUB, Souad NARIS, Nadia DOVBASH, Abdelaziz DRES, Khadija Marame BENGHADAB, Fares BOUTARFA, Mohamed BOUNOUALA, Stefano BELLUCCI	
Mineralogical and Chemical Characteristics of Phosphates from the Djebel Onk Deposits (Tebessa, Algeria),.....	351
Toukila TAHRI, Souad NARIS, Nacer BEZZI, Abdelali BOUZENZANA, Omar SEKOU, Rabet TRIRAT, Theziri AMRANE, Aissa BENSELHOUB	
Optimizing Dry Ultrafine Grinding of Taic in Attritor Mill,.....	361
S.E. EL-MOFTY, A.M. ELBENDARI, A.A. EL-MIDANY, M.K. ABDELRAHMAN	
Embankments Stability of an Opencast Mine with the Proposal of a New Mining Method for Its Reopening (Kef Essenoun, Algeria),.....	367
M.C. MEZAWI, M.A. BACHAR ASSEF, JM. OUID HAMOU, S. NARIS, A. BENSELHOUB	
Statistical Analysis of Selected Coal Characteristics and Toxic Compounds for FGX Air-Vibrating Separation,.....	377
Waldemar MIJAK, Tomasz NIEDOBA, Daria POLEK, reneusz BAIC, Wieslaw BLASCHKE	