



- 9 a A and F
b C
c D and E
d B, D and E
e A

Section 15.1

1 Students should find that they do not possess many items that have not been dependent on a contribution from the chemical industry.

- 2 a Continuous c Continuous
b Batch d Continuous

Section 15.2

a Conditions: lower pressure, or less separation required. Feedstock: methanol can be obtained from a variety of feedstocks. Product: higher yield. Co-products: far fewer.

b Disadvantages: very expensive catalyst, and more than one stage to process.

Section 15.3

- 1 a Many of the fixed costs for a 200 tonne day⁻¹ plant are less than double those of a 100 tonne day⁻¹ plant: for example, the larger plant will require less than twice the area of land for building, and the cost of building access roads will be less than twice as great.
b You have to pay the same fixed costs such as wages and land rental regardless of how much you are producing. But variable costs such as costs of raw materials and energy will double if you double output.

- 2 a Thermal energy released from the reaction can be used to pre-heat, via a heat exchanger, the water which will be made into steam as one of the reactants.
b The unreacted feedstock can be recycled again over the catalyst, saving costs of energy needed in the high temperature and pressure conditions.

Section 15.4

- a The oil comes in by tanker from the oil fields so the refinery on the coast means that the oil does not have to be transported further when it comes off the tanker.
b Sulfur is present as an impurity in oil, and so if the sulfuric acid manufacturing plant is next door, no further transportation is required.

- c The canal system was used to transport limestone from Derbyshire to Birmingham.
d Cheshire is an area of the country which is rich in salt deposits.

Section 15.6

- a $\text{N}_2(\text{g}) + \text{O}_2(\text{g}) \rightarrow 2\text{NO}(\text{g})$
b $2\text{NO}(\text{g}) + \text{O}_2(\text{g}) \rightarrow 2\text{NO}_2(\text{g})$

- c $\text{CH}_4(\text{g}) + 4\text{NO}(\text{g}) \rightarrow 2\text{N}_2(\text{g}) + \text{CO}_2(\text{g}) + 2\text{H}_2\text{O}$
d Excess natural gas is burnt off to produce more heat.

Section 15.7

- 1 a ethanol 46.0
ethanoic acid 60.0
ethyl ethanoate 88.0
b 44 g
c $\frac{36}{44} \times 100 = 81.8\%$
2 66.6%
3 Calculated yield = 0.7 tonnes
% yield = $\frac{0.67}{0.7} \times 100 = 95.7\%$
4 a propanol 60.0
b propene 42.0
c 70%

- 5 a 100%
b No leaving group.
6 a Relative mass of reactants = 154.9
Relative mass of useful product = 74
Atom economy = 47.8%
b $\text{CH}_3\text{CH}_2\text{CH}_2\text{CH}_2\text{Br} + \text{NaOH} \rightarrow \text{CH}_3\text{CH}_2\text{CH}_2\text{CH}_2\text{OH} + \text{NaBr}$
c The mass of the reactants increases but the mass of the useful product stays the same. The atom economy decreases.
7 a 83.7%
b 43.7%
c 36.6%

Section 15 Answers Science D

M Carnoy



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Table of Contents Section 15 Answers Science D

1. Understanding the eBook Section 15 Answers Science D
 - The Rise of Digital Reading Section 15 Answers Science D
 - Advantages of eBooks Over Traditional Books
2. Identifying Section 15 Answers Science D
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Section 15 Answers Science D
 - User-Friendly Interface
4. Exploring eBook Recommendations from Section 15 Answers Science D
 - Personalized Recommendations
 - Section 15 Answers Science D User Reviews and Ratings
 - Section 15 Answers Science D and Bestseller Lists
5. Accessing Section 15 Answers Science D Free and Paid eBooks
 - Section 15 Answers Science D Public Domain eBooks
 - Section 15 Answers Science D eBook Subscription Services
 - Section 15 Answers Science D Budget-Friendly Options
6. Navigating Section 15 Answers Science D eBook Formats

- ePub, PDF, MOBI, and More
 - Section 15 Answers Science D Compatibility with Devices
 - Section 15 Answers Science D Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Section 15 Answers Science D
 - Highlighting and Note-Taking Section 15 Answers Science D
 - Interactive Elements Section 15 Answers Science D
 8. Staying Engaged with Section 15 Answers Science D
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Section 15 Answers Science D
 9. Balancing eBooks and Physical Books Section 15 Answers Science D
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Section 15 Answers Science D
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Section 15 Answers Science D
 - Setting Reading Goals Section 15 Answers Science D
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Section 15 Answers Science D
 - Fact-Checking eBook Content of Section 15 Answers Science D
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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