



- 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<sup>-1</sup> plant are less than double those of a 100 tonne day<sup>-1</sup> 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%

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**M Lipman**



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