

OCTOBER - NOVEMBER, 2020

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marginCandidate's Name KIBUGO DENNISSignature KibSubject 00 Paper code/.....Random No. 0750-732031Personal Number Whatsapp

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Do not
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margin1st ELEMENT OF CONSTRUCT;THE LEARNER APPRECIATES CONTRIBUTION OF
CHEMISTRY TO OUR ECONOMY.Areas of emphasis;

- ① Manufacture of Oxygen
- ② Manufacture of Chlorine
- ③ Extraction of Metals $\leftarrow \begin{matrix} Fe \\ Cu \\ Al \end{matrix}$
- ④ Manufacture of fertilizers
- ⑤ Manufacture of detergents
- ⑥ Manufacture of sodium hydroxide
- ⑦ Manufacture of sulphuric acid
- ⑧ Manufacture of cement
- ⑨ Manufacture of ethanol
- ⑩ Manufacture of Biogas.

Each Process;

V - vessel

Cp - chemical processes

Cd - Conversion to
desired product

Ch - Coherence

Pr - Purification

Key points in assessment

⇒ Raw materials

⇒ Process of production.

⇒ Side effects of the process of production and mitigation

⇒ Social benefits

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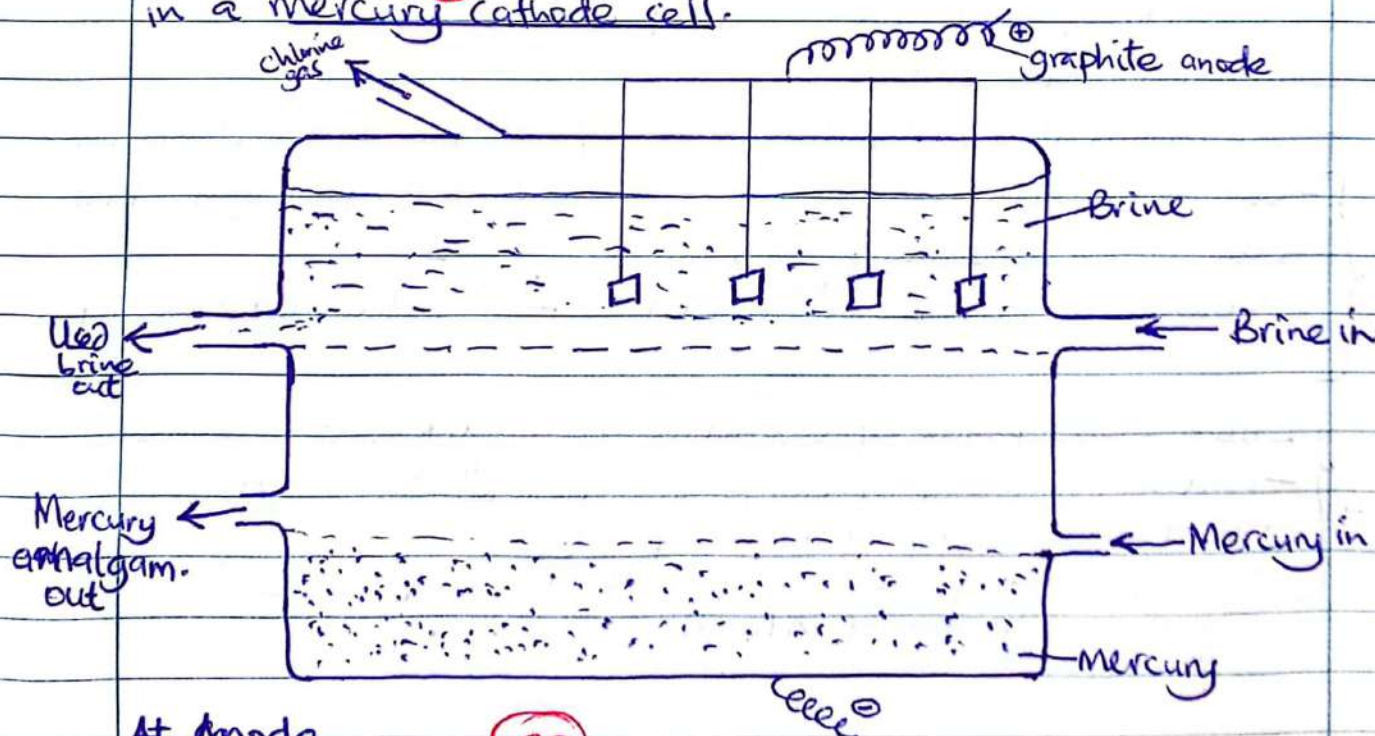
LEARNER APPRECIATES CONTRIBUTION OF CHEMISTRY.
TO OUR ECONOMY.

ASSESSABLE AREAS.

1 and 2. MANUFACTURE OF CHLORINE; - Using Mercury Cathode cell.
OR SODIUM HYDROXIDE SOLUTION.

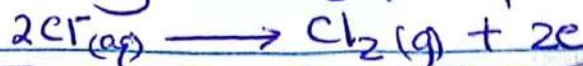
⇒ Raw materials; Concentrated sodium chloride solution, Mercury.
(Brine)

⇒ Process of production;
Chlorine is manufactured by electrolysis of concentrated sodium chloride solution (Brine) using graphite^{as} anode and mercury as cathode in a mercury cathode cell.



At Anode

Chloride and hydroxide ions migrate to the anode and chloride ions are preferentially discharged to form chlorine gas.



For NaOH; At Anode; $\text{Na}^+(\text{aq}) + \text{e}^- \longrightarrow \text{Na}(\text{s})$ The Sodium then mixes with mercury
 $\text{Na}(\text{s}) \longrightarrow \text{Na}(\text{Hg})$

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Sodium amalgam reacts with water forming sodium hydroxide solution

$$\text{Na/Hg (s)} + \text{H}_2\text{O (l)} \rightarrow \text{NaOH (aq)} + \text{H}_2 \text{ (g)} + \text{Hg (l)}$$

⇒ Side effects of the process and mitigation.

- Suffocation due to release of other gases like hydrogen in confined spaces

Proper Use of PPEs

- Exposure to high concentrations of chlorine leading to death or itching of eyes, noses

Proper Use of PPEs

- Exposure to excessive noise from mechanical equipment/cylinders

Proper Use of Personal Protective Equipment

- Exposure to mercury which is highly toxic and may cause damage to nervous system, reproductive system on long time-exposure.

Proper Use of PPEs

⇒ Social benefits

- Manufacturing plants are source of revenue to the Govt hence improved infrastructures.

- Employment opportunities hence improving the standards of living

- Chlorine in water is a disinfectant hence kills pathogens that would cause diseases to man.

- Chlorine is used in manufacture of a weed killers that reduce crop production.

- used in manufacture of soap which is a detergent in homes.

- Used in manufacture of drugs eg pain relievers - eg Aspirin

- Used in manufacture of baking powder

- In paper making industry, it is used to clean the wood paper

- Used in extraction of Aluminium.

- In textile industry to make dyes,

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marginMANUFACTURE OF OXYGEN⇒ Raw materials ; Air ^{or} (Atmospheric air)⇒ Process of production

Atmospheric air is pumped into ^{tanks} ~~plant~~ and the process involves the following stages.

① Filtration

Atmospheric air is filtered using air filters to remove dust particles.

② Drying:

^{ch} Air is cooled until the water vapour condenses. It is passed through a bed of silica gel. This is to remove water vapour.

③ Removal of pollutantsThe remaining air components are passed through beds of charcoal to remove air pollutants (NO_2 , SO_2 , CO , etc)④ Removal of Carbon dioxide

It is then passed through concentrated ^{CP} potassium hydroxide solution to remove Carbon dioxide gas.

⑤Compression

Air is repeatedly compressed at high pressure of 200 atm and ^{allowed to} cooled at -200°C to form liquid air. ^{cd}

⑥Fractional distillation

The liquid air is pumped into fractionating column where nitrogen at with lowest boiling point (-196°C) comes off and later on ^{further} warming Oxygen is collected at -183°C .

⇒ Side effects :- Noise pollution from compressors - ^{proper} Use of appropriate PPE's
- Cold burning of oxygen cylinders

⇒ Social benefits :- ~~for air~~ - For breathing by sea divers, astronauts
→ Employment - salary - ^{improved} ~~improved~~ ^{standards of living} ~~standards of living~~ - Manufacture of steel.
→ Govt revenue - ^{improved} ~~improved~~ ^{infrastructure} ~~infrastructure~~ - Used in ~~acet~~ oxy-acetylene flames for cutting and welding of metals.

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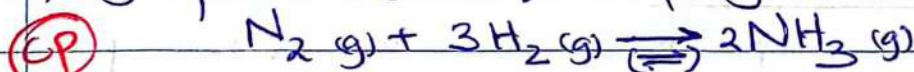
Do not
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marginMANUFACTURE OF FERTILIZERS.

A. AMMONIUM FERTILIZERS

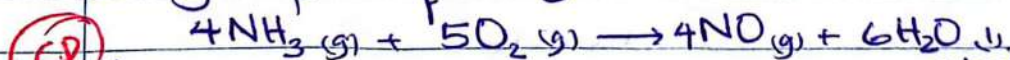
- ← Urea (H_2NCONH_2)
- ← Ammonium nitrate
- ← Ammonium sulphate
- ← Ammonium phosphate
- ← Calcium Ammonium Nitrate (CAN)

⇒ Raw materials; Nitrogen gas, Hydrogen gas.⇒ Process of production:

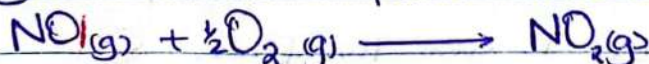
Nitrogen from fractional distillation of liquid air is reacted with hydrogen from natural gas in a ratio of 1:3 respectively to form ammonia by Haber process. The reaction requires low temperature (450-500°C), high pressure (200 atm) and finely divided Iron Catalyst.



Ammonia produced is heated in air (oxygen) in presence of platinum catalyst forming nitrogen monoxide and water. All these in a tank.

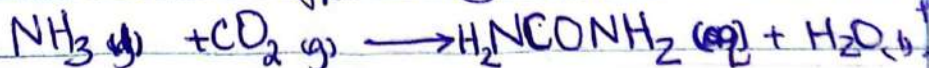


Nitrogen monoxide is further oxidised to nitrogen dioxide

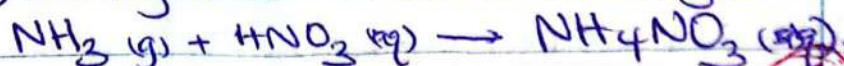


Nitrogen dioxide is dissolved in water in presence of oxygen, in a tank, forming nitric acid.

Urea; Obtained by reacting liquid ammonia gas with carbon dioxide at high pressure.



Ammonium Nitrate; By reacting nitric acid with ammonia gas.



Ammonium Sulphate;
$$\text{NH}_3 (\text{g}) + \text{H}_2\text{SO}_4 (\text{l}) \rightarrow (\text{NH}_4)_2\text{SO}_4 (\text{aq})$$

The fertilizers are further concentrated and converted to solid form.

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⇒ Side effects + Mitigation:

- Runoff into water bodies promoting ^{increased} algae growth thus oxygen supply is cut
- Some when dissolved in water form acidic solution that alter soil pH ^{off leading to suffocation of aquatic animals} hence low crop production.

⇒ Social benefits:

- Source of employment as residents get salaries hence improved standards of living.
- High levels of nutrients supplied ^{leading to} to improved crop production hence better standards of living to farmers
- Some when dissolved in water form acidic solutions that alter soil pH, hence low crop production

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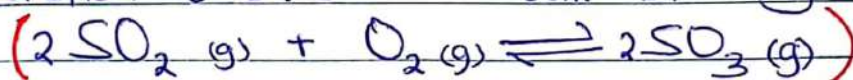
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marginMANUFACTURE OF SULPHURIC ACID

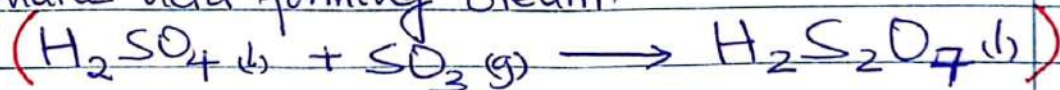
⇒ Raw materials ; - Sulphur dioxide gas.
- Oxygen gas.

⇒ Process of production;

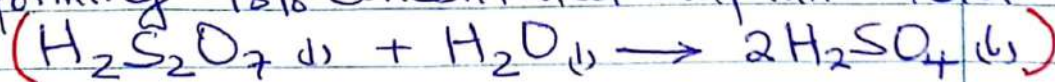
Dry Sulphur dioxide free from impurities is heated with dry pure Oxygen gas at ^{low} temperature (of about 450-500°C), high pressure (of about 1-3 atmospheres) in presence of vanadium(V) oxide catalyst to form sulphur trioxide. The reaction occurs in a combustion cylinder.



(CP) Sulphur trioxide is dissolved in with little concentrated Sulphuric acid forming oleum.



(CD) Oleum is added to moderated ^{volumes} ~~amounts~~ of distilled water forming 98% concentrated Sulphuric acid.



⇒ Side effects and mitigation

- Toxic misty fumes from oleum ^{which} ~~are~~ when inhaled may cause breathing problems and many side effects.
- Acid spills on the floor/surfaces leading to accidents

⇒ Social benefits

- Employment $\equiv$ salaries $\equiv$ improved standards of living
- ^{the} Manufacture of fertilizer $\equiv$ increased farm yields $\equiv$ improved standards
- used in car batteries as electrolyte - - -

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MANUFACTURE OF CEMENT.

⇒ Raw materials: Limestone, clay, gypsum.

⇒ Process of production:

A mixture of Limestone and clay is crushed and milled into a fine powder.

The fine powder is then mixed with water and allowed to flow down a rotating drum (cylinder) in which it is strongly heated to about 1500°C.

Limestone decomposes to calcium oxide and carbon dioxide

$$(\text{CaCO}_3(s) \longrightarrow \text{CaO}(s) + \text{CO}_2(g))$$

(CP) Calcium oxide reacts with aluminium oxide and silicon dioxide in clay form lumps of calcium aluminate and calcium silicate

(PF) The lumps are crushed to form cement as a fine powder
 Gypsum is added during the grinding process to moderate the reaction between cement and water (setting of cement)
 Cement is packed in bags ready for use.

⇒ Side effects and mitigation

- Dust, noise during crushing
- Poisonous fumes during crushing
- Falling objects
- Hot surface burns
- Slips and falls during lifting, overloading

} use of
Appropriate PPE's

⇒ Social benefits.

- Employment opportunity to residents to improve their standard of living.
- Revenue to government of Uganda to increase improve on infrastructure

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MANUFACTURE OF ETHANOL

⇒ Raw materials ; - Starch containing material eg Maize, Cassava, sweet
or glucose
millet, Sorghum, Potato
- Malt, Yeast.

⇒ Process of production.

The starch containing material is crushed and roasted (heated) to extract starch. Malt is then added to starch in a container and it is then covered. Malt contains an enzyme, diastase that catalyses hydrolysis of starch to maltose.

(CP) Yeast is then added to maltose after about 3 days at room temperature. Maltase in yeast catalyses the hydrolysis of maltose to glucose.

(Cd) Zymase enzyme in yeast catalyses the decomposition of glucose to ^{Crude} ethanol and carbon dioxide.

Crude ethanol is converted to pure ethanol by fractional distillation. (Pr)

⇒ Side effects and mitigation

- Ethanol spills on surface leading to falls and accidents.
 - Hot surface burns during distillation. — Appropriate PPEs
- (Add more points)

⇒ Social benefits.

- Employment opportunity, salary hence improved standards of living.
 - Ethanol is used as a fuel in motor engines.
 - As a solvent for some paints.
 - Manufacture of drugs.
 - Manufacture of perfumes.
- build the point from there.

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MANUFACTURE OF DETERGENTS

(A) NON-SOAPY / SOAPLESS DETERGENTS.

From an alcohol;

→ Raw materials; Duodecan-1-ol, Concentrated sulphuric acid, Sodium hydroxide solution.

Process of production;

Duodecan-1-ol is reacted with cold concentrated sulphuric acid in a plastic ^(v) container forming duodecyl hydrogen sulphate which is reacted with sodium hydroxide solution to form a detergent. This mixture can be added to minimum volumes of water to form liquid detergent.

Some additives such as whitening agents, biological enzymes, fragrance, fillers, stabilizers may be added during the process.

Side effects and mitigation.

- Acid spills on surfaces
- Burns from acids when in contact with skin.
-

Social benefits.

- Production of cleansing agents that one can use to clean surfaces to improve on hygiene hence improved health living.
- Employment ⇒ Salaries ⇒ improved standards of living.

(B) SOAPY DETERGENTS

→ Take them through Saponification.

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The container is covered to prevent aerial oxidation.

(CP) The container and contents are maintained at a temperature between 25-30°C.

(Cd) Anaerobic bacteria breakdown the organic matter to finally methane, ammonia, hydrogen sulphide, Carbon dioxide and nitrogen gases.

⇒ Side effects and mitigation

- Fire outbreaks during leakages on pipes

- Poisonous fumes in case of any leakages on pipes

By sealing off all pipes.

Maintain taps closed.

Proper use of PPE's

⇒ Social benefits

- Biogas is used for cooking and lighting since it is a renewable gas.

- Bio-slurry is used as an organic fertilizer and animal feeds to increase farmer's farm production hence better standards of living.

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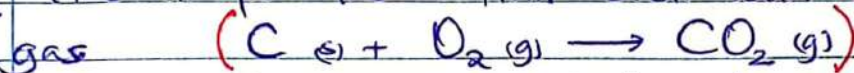
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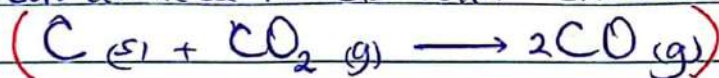
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marginEXTRACTION OF IRON⇒ Raw materials: Ore (Haematite), Limestone, Coke.⇒ Process of production:The raw materials, i.e. haematite, limestone and coke are fed into a blast furnace.Bottom
part
of furnaceStage 1: Oxidation of Coke.Hot air from the bottom ^(oxidises) reacts with coke forming carbon dioxide gasMiddle
part
of furnaceStage 2: Reduction of Carbon dioxide

Carbon dioxide reacts with excess coke forming carbon monoxide

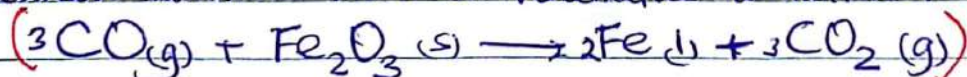


(cp)

Stage 3: Reduction of Iron(III) oxide (haematite)

(cd)

Carbon monoxide reduces haematite to molten iron and carbon dioxide

Role of Limestone

Calcium carbonate decomposes to calcium oxide and carbon dioxide. The calcium oxide reacts with silicon dioxide and aluminium oxide impurities forming calcium silicate and calcium aluminate that are tapped off.

(Pr)

Purification: Pure iron (wrought iron) is obtained by passing air through molten iron to remove non-metal impurities.⇒ Side effects + Mitigation

- Poisonous fumes

- Proper use of PPE

- Excessive noise from the plant

- PPE

- Too much heat from furnace to workers

- Chemical spills on molten iron

⇒ Social benefits

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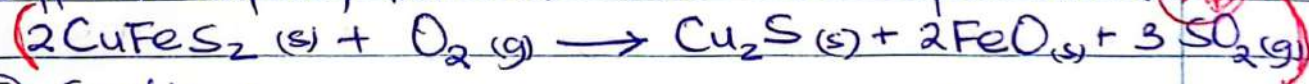
Do not
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marginEXTRACTION OF COPPER.⇒ Raw materials; Ore (Copper pyrites)
Silicon dioxide⇒ Production process;

① Concentrating the ore by froth flotation.

The ore is crushed and ^{mixed} ~~mixture~~ with water containing a frothing agent such as palm oil in a container. Air is blown in the mixture to agitate as ore particles go to the surface ^{with oil} while impurities sink down with water. The froth is skimmed off and dilute sulphuric acid is added to break the froth. The froth is filtered off and dried.

② Roasting.

The dried ore is roasted in air in a ^{blast} ~~furnace~~ [✓] to form Copper(I) sulphide, Iron(II) oxide and Sulphur dioxide ^{cd}.



③ Smelting

^{cd} Silicon dioxide is added to the above resultant mixture ^{in absence} ~~in~~ of ^{air} ~~extra~~ all in a furnace to remove Iron(II) oxide.

④ Reduction;

The copper(I) sulphide is heated in controlled amount of air to form Impure copper. ^{cd}

Purification; Impure copper is purified by electrolysis using Impure copper as anode and pure copper as cathode using acidified Copper(II) sulphate solution electrolyte. ^{Pr}

⇒ Side effects and Mitigation

- Toxic fumes from production process can lead to suffocation and death.
- Sulphur dioxide produced as a by-product reacts with water forming acidic rains that affect walls of houses.

⇒ Social benefit

- Employment opportunity - salary - Improved standards of living.

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marginEXTRACTION OF ALUMINIUM.

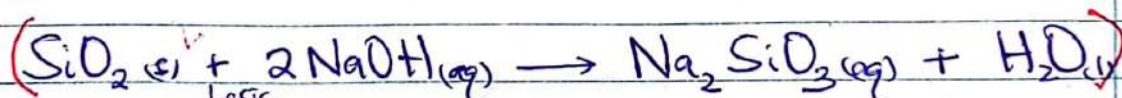
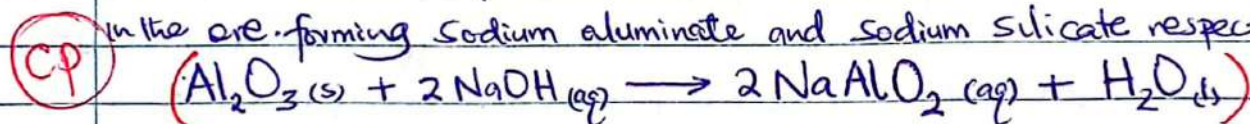
⇒ Raw materials; Ore (Bauxite), sodium hydroxide

⇒ Process of production;
Concentrating the Ore

Bauxite is ground to powder and heated to convert any Iron(II) oxide impurity present to Iron(III) oxide and also to remove water of crystallisation.

The powder is then boiled with hot concentrated sodium hydroxide solution that dissolves the amphoteric aluminium oxide and acidic silicon dioxide (✓)

in the ore forming sodium aluminate and sodium silicate respectively (✓) (control)

- The undissolved ^{basic} Iron(III) oxide and titanium(IV) oxide are filtered off

- Carbon dioxide is bubbled through the filtrate to precipitate aluminium hydroxide leaving silicate ions in the solution.

(Cd) - Aluminium hydroxide is washed, dried and heated strongly to produce aluminium oxide.

Electrolysis of aluminium oxide

Aluminium oxide is dissolved in molten cryolite to lower its melting point to 800°C. Electrolysis of molten aluminium oxide occurs using graphite electrodes in an Iron bath lined with graphite.

At Cathode; $\text{Al}^{3+}(\text{l}) + 3\text{e}^- \rightarrow \text{Al}(\text{l})$ (At Anode $2\text{O}^{2-}(\text{l}) \rightarrow \text{O}_2(\text{g}) + 4\text{e}^-$)⇒ Side effects and mitigation

- Pollution from poisonous fumes

- Burns caused by contact with hot surfaces of

- chemical spills

⇒ Social benefits.

- Employment opportunities to residents hence improved standards of living

- Source of revenue to government hence improved infrastructures

EXTRACTION OF IRON

⇒ Raw materials: Ore (Haematite), Limestone, Coke.

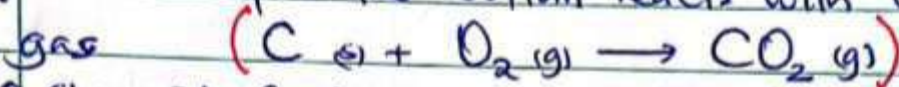
⇒ Process of production:

The raw materials, i.e. haematite, limestone and coke are fed into a blast furnace.

Bottom part of furnace

Stage 1: Oxidation of Coke.

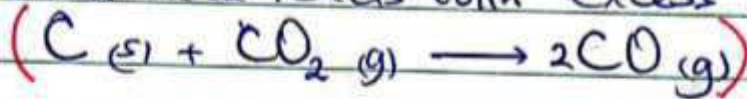
Hot air from the bottom reacts with coke forming carbon dioxide gas (oxidises)



Middle part of furnace

Stage 2: Reduction of Carbon dioxide

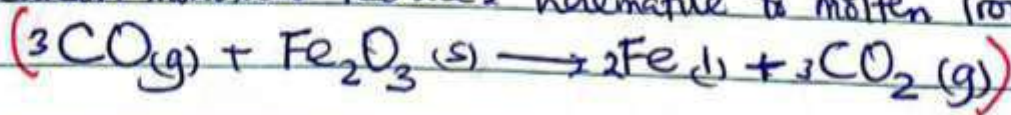
Carbon dioxide reacts with excess coke forming carbon monoxide



cp

Stage 3: Reduction of Iron(III) oxide (haematite)

Carbon monoxide reduces haematite to molten iron and carbon dioxide



Role of Limestone

Calcium carbonate decomposes to calcium oxide and carbon dioxide. The calcium oxide reacts with carbon dioxide and aluminium oxide impurities forming calcium silicate and calcium aluminate that are tapped off.

Pr

Purification: Pure iron (wrought iron) is obtained by passing air through molten iron to remove non-metal impurities.

⇒ Side effects + Mitigation

- Poisonous fumes

Proper use of PPE

- Excessive noise from the plant

PPE

- Too much heat from furnace to workers

- Chemical spills of molten slag

⇒ Social benefits

EXTRACTION OF ZINC

⇒ Raw materials; Ore (Zinc blende), Coke

⇒ Process of production;

Concentration of the ore by froth flotation.

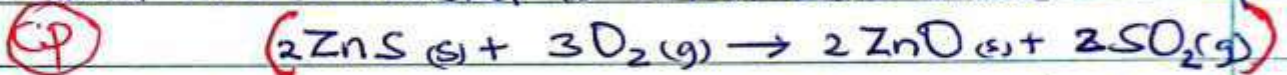
The ore is crushed into powder and mixed with water containing a frothing agent such as palm oil in a tank. Containers.

Compressed air is blown through the mixture to agitate it, making air bubbles rise to the surface with froth. The impurities sink at the bottom since they are wetted by water and ore float on surface since they are wetted by oil.

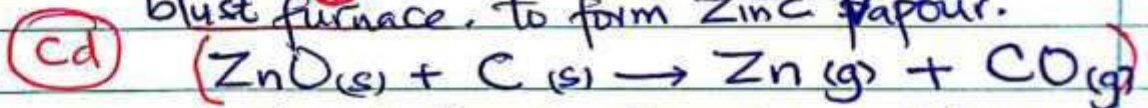
The froth is skimmed off, and dilute sulphuric acid is added to it to break the froth. It is filtered off and dried.

Roasting

The dried ore is roasted to obtain zinc oxide and sulphur dioxide.



Reduction; Zinc oxide is reduced by heating with coke in a blast furnace. to form zinc vapour.



The zinc vapour distils off from the furnace, cooled by a spray of molten lead.

(Pr) Purification; This is by Redistillation.

⇒ Side effects and Mitigation — Proper use of PPE

- Poisonous fumes that are toxic to man leading to deaths.
- Excessive heat and noise from rotating cylinders — Proper use of PPE

⇒ Social benefits

- Employment opportunity to the residents hence improving their standard of living.
- Source of government revenue to improve infrastructure in the region.

that are ornaments Product formed is used in manufacture of alloys such as Brass.

EXTRACTION OF COPPER.

⇒ Raw materials; Ore (Copper pyrites)
Silicon dioxide

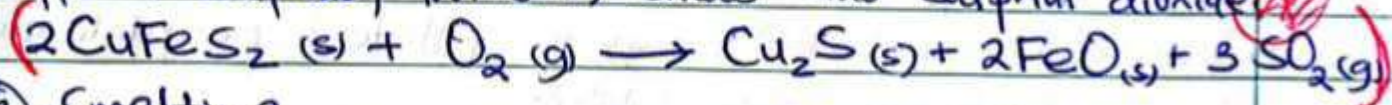
⇒ Production process;

① Concentrating the ore by froth flotation.

The ore is crushed and ^{mixed} ~~mixture~~ with water containing a frothing agent such as palm oil in a container. Air is blown in the mixture to agitate as ore particles go to the surface ^{with oil} while impurities sink down with water. The froth is skimmed off and dilute sulphuric acid is added to break the froth. The froth is filtered off and dried.

② Roasting.

The dried ore is roasted in air in a ^{blast} furnace to form Copper(I) sulphide, Iron(II) oxide and Sulphur dioxide.



③ Smelting

^{done in a container} The above resultant mixture ^{in absence} ~~is~~ of ~~air~~ ^{air} all in a furnace to remove Iron(II) oxide.

④ Reduction;

The copper(I) sulphide is heated in controlled amount of air to form Impure copper.

Purification; Impure copper is purified by electrolysis using
 (P) Impure copper as anode and pure copper as cathode
 using acidified Copper(II) sulphate solution electrolyte

⇒ Side effects and Mitigation

- Toxic fumes from production process can lead to suffocation and death
- Sulphur dioxide produced as a by-product reacts with water forming acidic rains that affect walls of houses

→ Proper control of waste
Use of PPE

⇒ Social benefit

- Employment opportunity - salary - Improved standards of living

EXTRACTION OF SODIUM

⇒ Raw materials ; - Sodium chloride (Rock salt)
- Calcium chloride.

⇒ Production process.

Sodium is extracted by electrolysis of molten sodium chloride using Iron as Cathode and graphite as anode in a DOWN'S CELL ✓

(CP) During the process, Calcium chloride is added to Sodium chloride to lower its melting point from 800°C to 600°C

At the Cathode: $\text{Na}^+ + e \longrightarrow \text{Na} \downarrow$ (cd)

(Pr) The sodium ^{discharge} is tapped off and collected into Iron storage tanks containing dry nitrogen.

⇒ Side effects and mitigation

- Poisonous fumes that if inhaled may cause death (Chlorine by-products) - Proper use of PPE
- Burns caused ~~with~~ ^{by} contact with hot surfaces on ^{Down cell.} furnace. - Proper use of PPE

⇒ Social benefits

- Employment opportunities to residents hence improving their standards of living.
- Source of revenue to government hence improving infrastructure.
- Sodium produced is a coolant in nuclear weapons.

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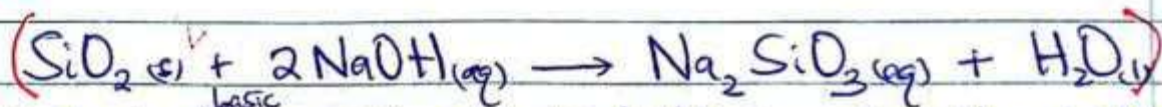
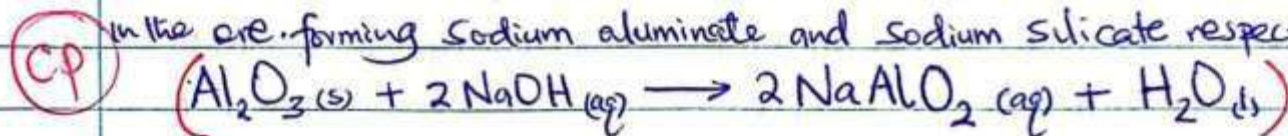
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marginEXTRACTION OF ALUMINIUM.

⇒ Raw materials; Ore (Bauxite), Sodium hydroxide

⇒ Process of production;
Concentrating the Ore

Bauxite is ground to powder and heated to convert any Iron(II) oxide impurity present to Iron(III) oxide and also to remove water of crystallisation.

The powder is then boiled with hot concentrated sodium hydroxide solution that dissolves the amphoteric aluminium oxide and acidic silicon dioxide (✓) in the ore forming sodium aluminate and sodium silicate respectively (✓) in a container.

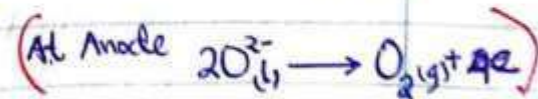
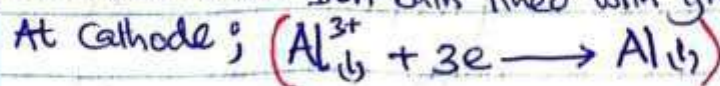


- The Undissolved ^{basic} Iron(III) oxide and titanium(IV) oxide are filtered off
- Carbon dioxide is bubbled through the filtrate to precipitate aluminium hydroxide leaving silicate ions in the solution.

(Cd) - Aluminium hydroxide is washed, dried and heated strongly to produce aluminium oxide.

Electrolysis of aluminium oxide

Aluminium oxide is dissolved in molten cryolite to lower its melting point to 800°C. Electrolysis of molten aluminium oxide occurs using graphite electrodes in an Iron bath lined with graphite.

⇒ Side effects and mitigation

- Pollution from poisonous fumes
- Burns caused by contact with hot surfaces of
- chemical spills

Proper use of PPEs

Proper use of PPE

⇒ Social benefits.

- Employment opportunities to residents hence improved standards of living
- Source of revenue to government hence improved infrastructure