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**Malaysia
Airlines
MH370
crash**

**How do
planes
work?**

**Interview with
TATA Steel Employees**

Coke to Coke Project 2014
Henk Gotlieb, Piet Gotlieb,
Robin Wacanno and Wilco Stam
Ir S. Ramgolam

Preface

The magazine you are about to read was written for the Coke to Coke project which is organized by Jet-Net and our school. The purpose of this project is to interest students to pick a scientific study. With school we've visited TATA Steel in IJmuiden where we got a tour around some important parts of the steel production. We also interviewed some TATA Steel employees there.

The main subject of our magazine is aeroplanes. Thus this magazine will give you some essential information about aeroplanes and how they function. Our writers and editors have visited Schiphol Airport on the 29th of April 2014 to get a better look at the aeroplanes and the Airport itself. Sadly The weather was not on our side and we weren't able to take pictures of aeroplanes outside.



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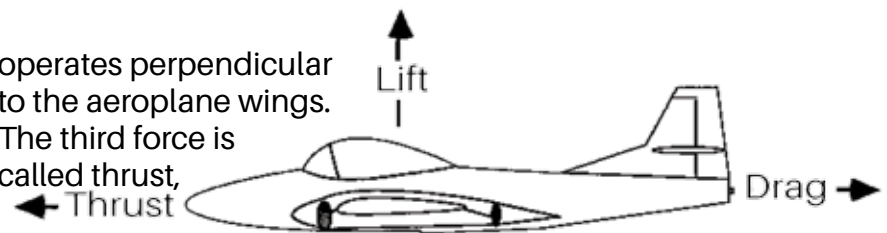
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AEROPLANE PHYSICS

To explain how an aeroplane flies you should start by thinking of the forces. There are 4 forces on an aeroplane. The first one is applied to everything on earth, this one is called the weight force or gravity. This creates a downwards force. We can calculate the downwards force with the formula $m * g$. M being the mass and g being gravity which on earth is about 9.81. But of course an aeroplane moves up. For this we have a force called lift. Lift

operates perpendicular to the aeroplane wings. The third force is called thrust,

this force makes the aeroplane move forwards. Thrust on an aeroplane can be created by a propeller or a jet engine. The principal of such an engine is that it accelerates air out of the back and then follows newton's third law. This can be proven by a balloon filled with air an opening it.

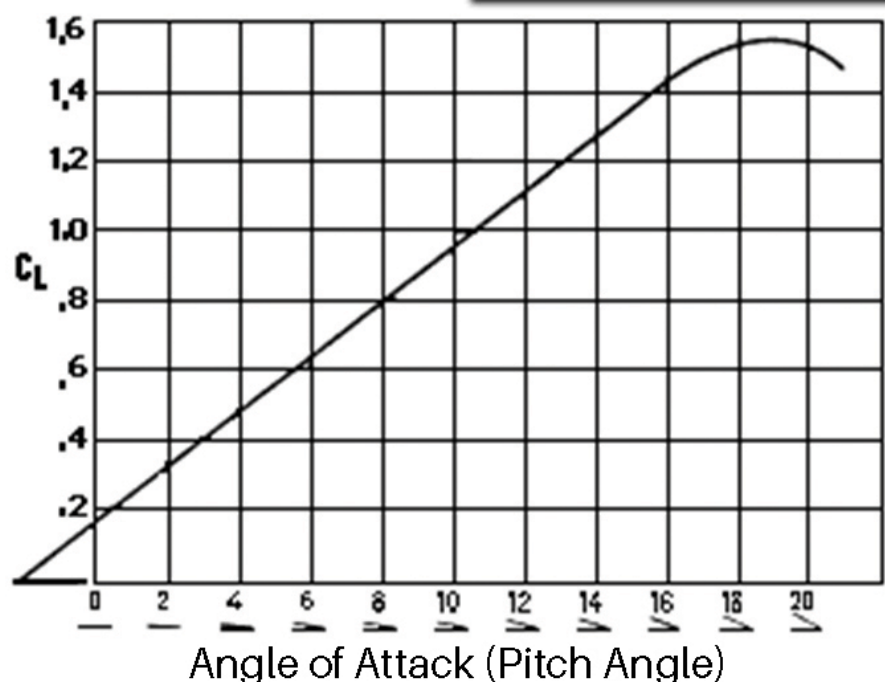


The balloon will shoot forward. The last force on an aeroplane is drag. It moves the aeroplane backwards. Drag is created mostly by air resistance. We can minimize this drag by making the aeroplane aerodynamic. This means that it has smooth lines.

We can calculate the lift with the equation of magnitude of lift per unit wing area. This equation is $L = 0.5 * P * Cl * V$ squared. In this formula L is of course lift. P is the density of the air which creates the resistance. This resistance is normally 1.2754 kg/m cubed. Cl is the coefficient of the lift. This coefficient has to do with the wings and changes with the angle of attack. The angle of attack is the angle between the nose of the aeroplane and the horizontal line formed underneath the wings. This horizontal line is formed because even if an aeroplane is taking off it is still partially moving horizontally. As you increase the angle of attack the lift rises until a certain

point. At this point the wings are almost vertically and create a surface of drag force. This point is called stall.

Graph of the coefficient of lift

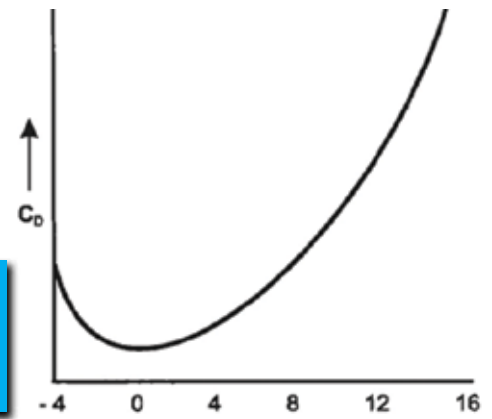


There is a similar equation for the drag on an aeroplane. This equation is

$D = 0.5 \times P \times C_D \times V^2$. This formula works the same except for that C_D is the coefficient of drag. This also has to do with the angle of attack. As the angle of attack increases the coefficient of drag also increases. This is

because as the aeroplane is pitching there is more wing area perpendicular to the flow.

**Angle of Attack
(Degrees)**



Facts about aeroplanes

About 4.5 million people fly every day.

About 16.5 billion people fly on a yearly basis.

Tupolev TU 144 is the fastest passenger aeroplane ever built.

The maximum capacity of an A380 is 853 passengers.

The A380 is also the most fuel efficient aeroplane per capita.

Around 3 billion people boarded some 35 million flights last year.

Only 224 people died in an air crash last year.

In fact, 2013 was the safest year ever for airlines, surpassing 2012 , which surpassed 2011.

Tata Steel

Assignments

Chapter 1

Question 1: What are the main three raw materials used to make iron?

The main three raw materials used to make iron are, Iron ore, coal and limestone.

Question 2: Where do the raw materials come from and how are they transported to the plant?

Limestone comes from all over the world because it's found almost everywhere. It's transported by ship and truck. Coal comes from rests of plants which died during the Carboniferous period. Due to compression it became rock solid and there are coal mines now a days. Coal is transported by truck or mostly by ship. Coal is found mostly in China and the U.S.A. Iron comes from mines mostly from Australia, Asia and South America. It is mined in mines and transported by ship and truck as well.

Question 3: How and why are the raw materials processed before they are used in the blast furnace?

The raw materials are processed to remove most of the impurities. The process is called coking coal, the coking process consists of heating coking coal to around 1000-1100°C in the absence of oxygen to drive off the volatile compounds (pyrolysis). This process results in a hard porous material - coke. Coke is produced in a coke battery which is composed of many coke ovens stacked in rows into which coal is loaded.

Question 4: What role does each of these three raw materials play in the iron-making process?

Coal is used to burn everything. Of course the oxygen is used in this as well because you can't have fire without oxygen and of course iron ore is molten to make iron liquid which can be shaped.

Question 5: What can you say about the ecological effects of using these raw materials?

Transportation = a lot of pollution. Due to mining the amount of iron ore in the country of origin will become less until it will finally run out

Question 6: How can these side effects be reduced?

By following the environmental laws and implementing innovative technics. Also they make use of solar energy and put filters in the exhaustion tube.

Question 7: Why is scrap used?

Scrap is cheaper and by recycling we don't run out of the resources earth gave us. By using this method you also automatically take out the unwanted toxics.

Question 8: what are the advantages and disadvantages of using scrap in the steel making process?

Advantages: by using scrap you can save up to 74 percent of the money and 86 percent of environmental damage. Also, the demand for processed scrap has risen dramatically.

Disadvantages: they need to use more energy and transporting it is more expensive.

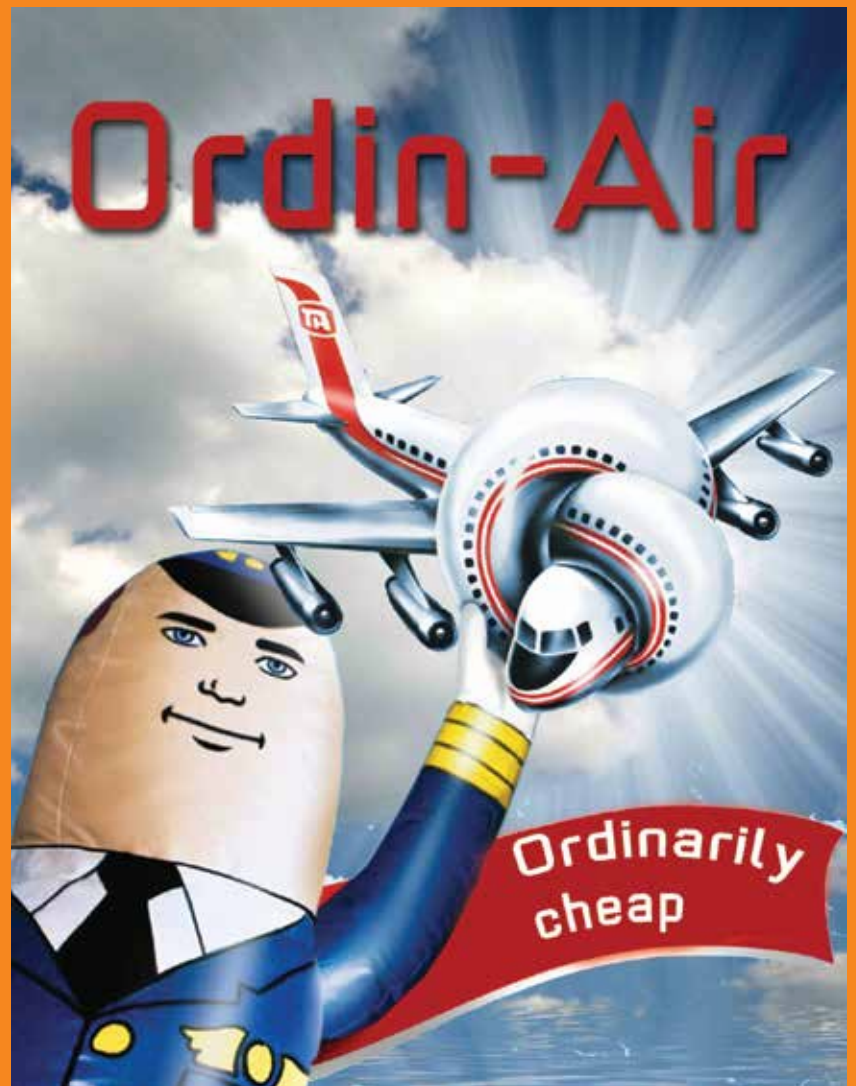
Ads



@

*Actus
Insurance*

"Just in case"



Tata Steel

Assignments

Chapter 2

Question 1: Calculate the mass of each element.

$$\text{Fe} = 94.9\% \text{ of } 100 = 94.9 \text{ kg}$$

$$\text{C} = 4.55\% \text{ of } 100 = 4.55 \text{ kg}$$

$$\text{Si} = 0.25\% \text{ of } 100 = 0.25 \text{ kg}$$

$$\text{Mn} = 0.3\% \text{ of } 100 = 0.3 \text{ kg}$$

Question 2: How many kilograms of each element are oxidised of the 100 kg hot metal?

$$0.02 \times 94.9 = 1.898 \text{ kg Fe}$$

$$4.55 - 0.05 = 4.5 \text{ kg C}$$

$$0.3 - 0.1 = 0.2 \text{ kg Mn}$$

Question 3: How many kilograms of steel are produced?

$$100 - 1.898 - 4.5 - 0.2 = 93.402 \text{ kg}$$

Question 4: Calculate the amount of energy in megajoule that is generated during the process.

$$\text{Fe} = 4.3 \times 1.898 = 8.1614 \text{ MJ}$$

$$\text{C} = 11.7 \times 4.5 = 52.65 \text{ MJ}$$

$$\text{Mn} = 7.4 \times 0.2 = 1.48 \text{ MJ}$$

$$\text{Total is } 62.2914 \text{ MJ}$$

Question 5: How much energy is used in natural gas a year per household?

$$32 \times 2000 = 64000 \text{ MJ}$$

Question 6: The energy produced from how many kg of hot metal is equivalent to the energy used in natural of one household?

$$62.2914 : 100 = 0.622914$$

$$64000 : 0.622914 = 102742.9148 \text{ kg}$$

Question 7: If 45% of the heat generated by

the C combustions will leave the process through the waste gasses what will be the temperature of the liquid steel?

The energy produced per 100kg hot metal for heating steel is 47.0739MJ. temperature increase is 732.3841degrees Celsius. So the steel temperature is 2082.4 degrees Celsius.

Question 8: If we want to melt 1 kg of scrap and heat it to 1650 degrees how much energy is required?

$$27100 + 1630 \times 690 = 1.3957 \text{ MJ.}$$

Question 9: How many kg of scrap can be melted with the 100 kg of hot metal making steel of 1650 degrees?

$$27.791436 : 1.3957 = 19.91218457 \text{ kg of scrap.}$$

Question 10: How many kg of steel are produced?

$$113.0642 \text{ kg of steel.}$$

Question 11: If we want to make 320 tons of this steel how many tons of hot metal scrap are required?

$$320 : 113.0642 \times 93.251 = 263.64 \text{ tons of hot metal.}$$

$$320 : 113.0642 \times 19.91218457 = 56.36 \text{ tons of scrap.}$$

Question 12: How many cubic meters of steel is that?

$$320 : 7 = 45.71 \text{ m}^3$$

Question 13: Suppose a steel ladle has an internal diameter of 4 meters. What is the required height of the ladle if the steel surface must be 50 cm below the top of the ladle?

$$\text{ladle surface is } 12.57 \text{ m}^2.$$

$$\text{ladle height is } 4.14 \text{ metres.}$$

Chapter 3

Question 1: How long does it take for the steel to pass the section?

$6/0.1 = 60$ seconds

Question 2: What is the minimum rising velocity for an inclusion entering at the bottom required to reach the surface within the section?

Minimum rising velocity is 1.3 cm/s

Question 3: For which particle sizes given in the table, all particles will reach the surface within the sector?

All the particles with a size bigger than 0.2 mm will reach the surface within this section.

Question 4: After how many meters is the strand completely solidified when casting a slab with a thickness of 225 mm at 1.5 m/min?

It takes 30.375 meter to solidify completely.

Question 5: How many tons of slabs are produced per minute (density of liquid steel is 7000 kg/m³).

6.1425 ton/min produced

Question 6: How many tons a year can be produced when operating 90% of the year?

$6.1425 \times 60 \times 24 \times 365 \times 0.9 = 2.9$

2.9 megaton of slabs produced per year.

Question 7: Why is casting so critical for the cleanliness of the steel?

The steel wouldn't be usable otherwise.

Question 8: Which inclusion is worse: an inclusion that keeps his form during rolling or a participle that is rolled out like steel?

A particle that keeps his form because it's more difficult to make a shape from it than a part that can be rolled.

Question 9: Describe the process steps from steel slab to tinned coil

First the steel slab is rolled out to a coil, this is then taken through a bath of tin and the excess of tin is blown off with air.

Question 10: What is the length of the hot rolled coil?

The slab is 10.8m long and 225mm thick and the final thickness is 2.5mm. The begin and end are cut off.

$10.8 \times 225 : 2.5 \times 0.98 = 952.56$ The hot rolled coil is 952.56m long.

Question 11: How long is the cold rolled coil?

The cold rolled coil is 0.22mm thick

$952.56 \times 2.5 : 0.22 = 10824.5$ m long.

Question 12: What is the maximum inclusion size that is allowed in the material?

Wall thickness is $0.22 : 3 = 0.07333$ mm

Maximum inclusion size allowed is $0.07333 : 3 = 0.02444$ mm.

Important events in aviation history



One of the first jet planes.



The Fokker Dr.1. This plane was used during WW I

In 1910 the concept of a plane propelled by jet engines was patented by Henri Coandă.

The 1st World War was the first war during which aeroplanes were used to fight the enemy. This also meant that the current design of the time was improved to be suitable for warfare.

1900 1910 1918
|-----|-----|-----|
1903 1914

1903 was a very important year in aviation history. For on the 17th of December of that year the Wright brothers had succeeded in creating and flying an engine powered aeroplane. Many inventors had attempted to fly a plane before them, they used: gliders, balloons and airships.



A picture of the Wright Flyer

1945

After the 2nd World War commercial aviation became more popular. This meant that the transportation of both passengers and cargo would happen much faster compared to the conventional methods of transport at the time.



The DC-10 used to be a very popular aeroplane.



A Space Shuttle without the extra fuel tanks

In 1982 the U.S. began to use Space Shuttles to re-enter the atmosphere from space. This plane-like spaceship went up into space with three enormous fuel tanks/engines. These are detached when they run out of fuel.

1982

2014

1969

2001

In 1969 the first test flight with the Concorde aircraft was performed. The Concorde was one of the two supersonic planes to have ever been used as a commercial passenger aircraft. The Concorde has only crashed once this was on the 25th of July 2000. On April the 10th 2003 the retirement of the Concorde was announced.



The Concorde Aeroplane with the iconic drooping nose.

The security on planes and in airports would change dramatically after the 11th of September 2001. On this day a group of terrorists hijacked two planes and flew them into the Twin Towers. Due to this event governments realized that the security on airports and aeroplanes was not strict enough.



The Twin Towers during the attack

Tata Steel

Assignments

Chapter 4

Question 1: Describe the process steps in the making of a beverage can.

The modern method for making aluminium beverage cans is called two-piece drawing and wall ironing. First aluminium is rolled into a thin sheet. This sheet is cut into a circle which will form the bottom and the side of the can. The small ripples at the top of the metal are called "ears". These ears are ironed and shaped and then fit onto the can. The lid is made of a different kind of alloy than the base of the can. The centre of the lid is stretched upward slightly and drawn by a machine to form a rivet. The pull tab, a separate piece of metal, is inserted under the rivet and secured by it. A rivet is the shape of the opening of the can.

Question 2: How many coils of 10 tons can the plant process per year?

Per year it can process $100000 : 4 = 25000$.

$25000 \times 24 \times 365 = 219000000$.

$21900000 \times 0.9 = 197100000$.

$197100000 : 10000 = 19710$ coils of 10 tons.

Question 3: How many cans are produced per year?

Number of cans per hour times hours in a year and then times 90%

$100000 \times 24 \times 365 \times 0.9 = 788400000$

Question 4: How many rejected cans per slab and per year are allowed?

$788.4 \times 2 = 1576.8$

Question 5: How many square meters of storage is required to store a week's production?

A week's production is $100000 \times 24 \times 7 \times 0.9 = 15120000$

$4000 : 12.5 = 320$ cans per stack

$15120000 : 320 = 47250$ stacks

$7.5 \times 7.5 = 56.25 \text{ cm}^2$ per stack

$47250 \times 56.25 = 2657812.5 \text{ cm}^2 = 26578.125$ square meters of storage is needed for a week's production.

Question 6: How and where are cans recycled?

Cans are recycled by melting down the cans, aluminium slabs are made out of the molten aluminium and new cans are made from the aluminium slabs.

Question 7: What are the main differences between steel and aluminium cans from a recycling point of view?

Aluminium is lighter than steel, this means there are less transport costs.

Question 8: What happens after the separation process with the aluminium and the steel?

The whole cycle will start again for both. They will be processed into slabs again and made into can or other products.



There is a lot to tell about schiphol: shopping, air traffic, security, gates, check-in, arrivals etc. That is why it is quite the task to actually write about it. I decided to divide this article into different headings, so you could get to know the ins and outs of Schiphol as structured as possible.

Shopping - Schiphol is not just a place to take off and land just to get from one place to another. It can be for fun and exploring, having a good time with your family and friends and to be amazed by the overprized articles they sell because of the monopoly they have on it. Schiphol, with it's over 100 shops is like shopping mall. Also, they handle a unique system for you as a passenger to be able to bring things on your flight. The see, buy, fly system is something mainly known in Schiphol.



Departure - Schiphol has 3 terminals where you can check-in and go through passport control so you can fly off to your holiday destination. But behind

that passport control it gets way more complicated. Which way do you go? Luckily there are signs everywhere telling you what is where, but it still

can be pretty confusing with its total of 165 gates, and they are expanding all the time.

Arrivals - Arrival at Schiphol is pretty simple. You get of the aeroplane and you basically just follow the crowd. There are 14 luggage claim stations to choose from. After you got your bag, you go through security again and you are free to go and enjoy being home at last.

Charity - Schiphol, besides making money, has many different good goals. They are cooperating with Unicef and recently made an environmental friendly area in the European departure hall.



Aircrash Speculation: Malaysia Airlines

How did Malaysia Airlines crash? What went wrong? No one knows the answer to these questions yet. What we do know is that this search will take a very long time and a lot of people are involved in the process. President Obama from the US visited Kuala Lumpur, the capital of Malaysia, at the time of writing (28th of April 2014). The search for the missing aeroplane started exactly 51 days ago and is already the most expensive search in its kind in aviation history.

Global worries - It seems as if everyone feels bad for the 239 people that probably died and their relatives. No wonder of course. Imagine, many innocent people died in the crash. In the past 51 days, over a dozen countries have been involved in the search for flight MH370. Researchers announced that the search might take years and millions or even billions of dollars.



Malaysian minister of transport

Presidents - Both the president of the US and Australia are involved in the process. For Australia it's logical because the aeroplane has supposedly crashed in the Indian Ocean near Australia. For the US on the other hand there is no obvious reason but they are very concerned because Obama is visiting today. The tone of the presidents across the globe is changing. The Australian president said that

the aeroplane "may never be found again."

Search methods - For the search a lot of modern technologies are used. The black boxes, which hold the information about the flight and all communication within the aeroplane and are the main



Bluefin 21



The Black box flight recorder

objective of the search, the back box has an underwater locator beacon which sends out pings for approximately 30 days before the battery dies. To detect these ultrasonic pings, they use Australian naval ships, the ocean shield to drag a towed pinger locator underwater. This can detect the pings to up to 6000 metres in depth. They also sent an underwater drone, equipped with sonar and cameras, called the Bluefin 21 which can detect to 4500 metres away.



Flight details - After flight MH370's take off, there was barely no communication with air traffic control. Kuala Lumpur ATC (Air Traffic Control) told MH370 to contact Vietnamese ATC but they never did. MH370 was spotted on a Malaysian army radar, but not on their planned flight path. After losing contact with the radar, the aeroplane, besides the failure of all other communication equipment, continued to send out signals to a satellite which flew at 35800 km above sea level near the Indian coast. It continued to do this every hour for the next seven hours before all contact was lost. The range in which this aeroplane can be is huge. In seven hours the range goes from Russia, to Japan, to Australia, to the south of the Indian Ocean, to Africa, and to Kazakhstan and Iran. This means that the search can go on for an extremely long period of time.



A	A	V	E	A	A	F	C	A	A
E	I	S	R	T	T	F	I	D	O
R	R	L	U	C	T	O	L	I	P
O	B	A	T	N	E	E	I	Z	D
P	U	V	R	K	T	K	F	A	N
L	S	I	A	R	H	A	T	L	E
A	I	R	P	O	R	T	C	C	C
N	B	R	E	U	U	A	A	L	S
E	S	A	D	T	S	X	V	A	E
T	R	I	P	E	T	I	U	D	D

Aeroplane
Airport
Brake
Thrust
Departure
Takeoff
Arrivals
ATC
Trip
Airbus
Pilot
Route
ADIZ
Lift
Descend
ALCLAD

Where To Go?

Top 10 Travel Destinations

1

Cape Town - South Africa

Cape Town attracts a lot of visitors with its story of Nelson Mandela. Cape Town was a big inspiration for Nelson and he left his traces there. Visitors can visit museums and the Robben Island prison to see the history of this inspiring man. Also In 2014 Cape Town is the World Design Capital. Visitors can enjoy architecture fairs and fashion shows hosted by students.



2

Christchurch - New Zealand

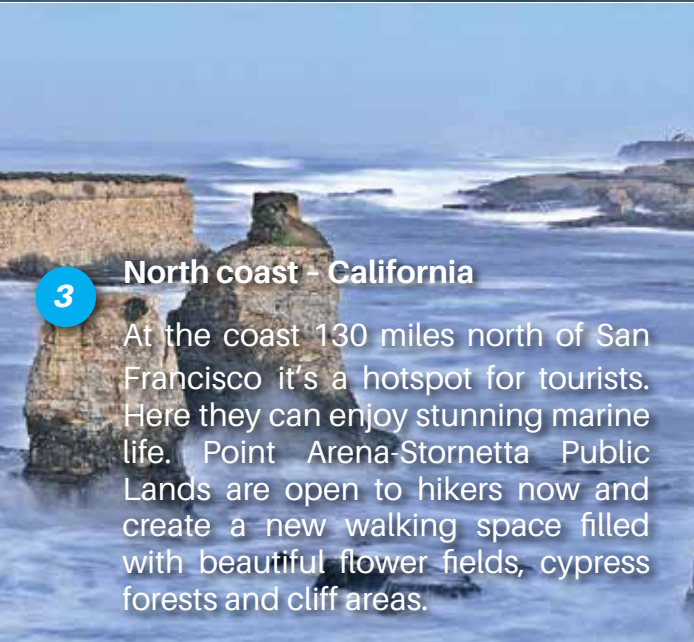
Three years after the two devastating earthquakes the city of Christchurch is experiencing a creative rebuild. Modern buildings are rising up out of the ground like there is no tomorrow.



3

North coast - California

At the coast 130 miles north of San Francisco it's a hotspot for tourists. Here they can enjoy stunning marine life. Point Arena-Stornetta Public Lands are open to hikers now and create a new walking space filled with beautiful flower fields, cypress forests and cliff areas.



4

Albanian coast - Albania

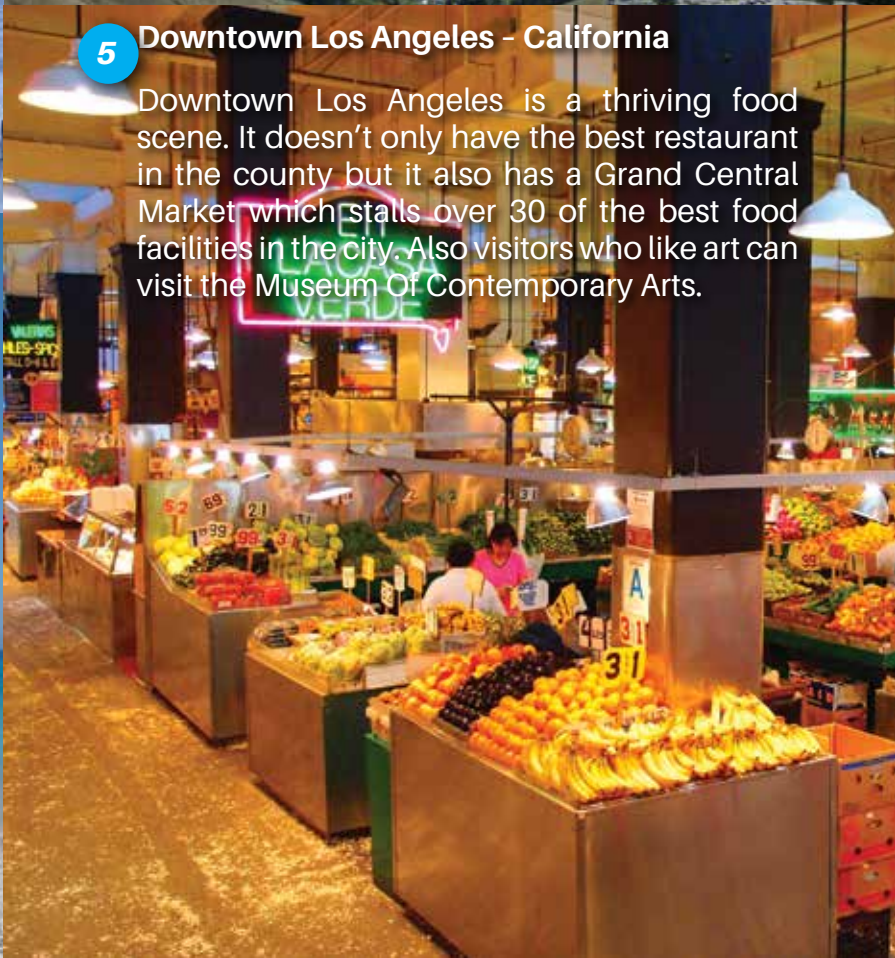
Albania has the ruins of the old Greek and Turkish people, the rugged beautiful coastline and the humble nature of Italy. And if that wasn't enough to convince you of going there, it's also extremely cheap. You can stay there for about 50\$ a night in a five star hotel.



5

Downtown Los Angeles - California

Downtown Los Angeles is a thriving food scene. It doesn't only have the best restaurant in the county but it also has a Grand Central Market which stalls over 30 of the best food facilities in the city. Also visitors who like art can visit the Museum Of Contemporary Arts.



6 Namibia

Namibia combines sustainable tourism with a rural community. In 2013 the country's 79 natural reserves received Gift to the Earth Award from the World Wildlife Fund.



7 Ecuador

Ecuador is home to the beloved Galapagos Islands. It has over 1,600 species of birds, 4,000 kinds of orchids, one of the largest condor shelters on the planet — and one-fifth of the country (including the Galápagos) is protected.



8

Quang Binh - Vietnam

This destination has opened one of the world's largest caves called Son Doong Cave for visitors. These caves house forests of 100-foot-tall trees. These forests are in return home to monkeys, hornbills and flying foxes.



9

Perth - Australia

This destination has been in the top 10 for ever already. It is famous for its beaches, laid-back vibe and Aboriginal heritage. But lately it has been attracting more visitors with its regional wine list and modish new restaurants.



10

Rotterdam - the Netherlands

After the bombing in World War 2 reconstruction has changed the face of one of Europe's largest ports, modern architecture has given shape to the skyline



Interviews with Tata Steel employees

During the interviews we talked with employees of Tata Steel. Information in these interviews was highly repetitive because we asked the same things to different people.

First we spoke to Hans nooij

Q: How did you get to where you are now?

"I started at the blast furnaces and after that I went to work at the tinning plant. Then I went to the HR department. I had to make a recruitment department and I'm currently the leader of a project called Jet-net"

Q: What do you like most about your job?

"The thing I like the most about my job are the people."

Q: How is Tata Steel doing economically? Especially after the economic crisis.

"Tata steel is facing a lot of difficulties because India and China are producing low cost steel so we aren't able to sell as much. Tata steel in Europe has to specialize to be able to be competitive."

Q: How many people work at Tata Steel?

"Tata Steel in Europe has 36000 employees and Tata Steel IJmuiden has 9000 employees."

Q: What does a normal day look like for you?

"I get up at 7 am, I am a teacher at the training centre. The lessons start at 8:30 am and then from 12 to 13 we have lunch. After that lessons continue until 16:30."

We also spoke to a women from the research department.

Q: What do you like most about your job?

"I like everything about my job the people, the content and welding because that is my area of expertise."

Q: what is your job?

"I do research in new welding techniques."

Q: What does your day look like?

"There is never really a typical day because, although there are some things you always need to do there is always something different to do."

Last but not least we spoke to a man who coordinates projects.

Q: What do you like the most about your job?

"I like the variety in my job, because all projects are different. The projects can be about robotics or other complicated things like certain measurements."

Q: To what industries does Tata Steel mainly sell steel to?

"We mostly sell to the automotive industry and construction."

Free Floppy Disk

Included on the disk:

- * The movie "Airplane".
- * A full copy of Microsoft Flight Simulator.
- * A digital aeroplane encyclopedia.
- * A digital guide on "How to spot a potential terrorist".



Time Distribution

Henk Gotlieb

First of all I would like to say that I had real fun making everything and actually discovering the physics behind airplanes. Also I did enjoy the trip to Tata steel. For the glossy magazine we picked airplanes as subject and for this we went on a trip to Schiphol during the holiday which was a whole lot of fun as well.

Of course all the Tata steel exercises were made together with the whole group. The cooperation within the group was fine. At some point there was a struggle but we got passed that.

Piet Gotlieb

I thought this was a very interesting project but because it's vacation right now, communicating was a bit difficult because I was outside together with Henk while the others thought they had the right to be angry at me because I wasn't reachable at some points. But you know it's vacation, it's already a miracle that I'm actually doing something for school. I obviously also made a part of the exercises. In total I think I spent about 11 hours in total, partially because of a hustle with making a word puzzle because there is no proper program to do that. I had a lot of fun visiting Schiphol and Amsterdam. In total I think this was a pretty good project to do.

Robin Wacanno

Working on the TATA Steel exercises and the magazine was an interesting challenge. Making the cover for the magazine wasn't too difficult and took around 2 hours. The timeline was a bigger project, partially because it had to be changed multiple times. The preface was written in conjunction with the other group members. To make the magazine look more like a real magazine, I've added some fictional advertisements. This didn't take much time. Tasks were evenly divided between the group members but the communication between the group members went sometimes with some difficulty. But as a final conclusion I think I've enjoyed the project.

Wilco Stam

I made the magazine in Adobe InDesign, this was my first time using the software so there was quite a lot of learning needed to do but halfway I got the hang of it. I also realized that putting everything together, checking, adjusting

Tasks

Text on Page 4/5, 8/9 and 18/19

Trip to schiphol

Total Time 16 hours

Text on page 15, 16/17

Trip to schiphol

Total Time 11 hours

Front- and Backcover

Timeline on page 12/13

Text on page 2

Fictional Advertisements

Spelling and Grammar checking

Total Time 14 hours

Layout and pictures on page 2-10, 14-21 and 23

Spelling and grammar checking

Final Editing

Total Time until now 43 hours



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Nieman Publishing