KINETIC AND CRYSTALLIZATION BEHAVIOR OF PALM OIL, PALM KERNEL OIL AND THEIR LIPASE-CATALYZED INTERESTERIFIED BLENDS USING VISCOMETRY

By

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The oil crystallization induction time is an important kinetic parameter that provides fundamental information in elucidating their physical and chemical properties. The main criterion for the selection of technique in determining oil induction time is sensitivity in order to apply the data into the Fisher-Turnbull model for estimation of nucleation activation free energy. However, most currently available techniques possessed certain limitations and drawbacks. This study investigates viscometry's potential as a new technique for oil induction time determination. Palm oil, palm kernel oil and their mixtures in different proportions were used as model systems. The catalytic nature, the efficacy and differences in chemical composition changes of the different regiospecific lipases used on the various oil substrates were also looked into. The changes in crystallization behavior of these lipase-catalyzed interesterified oils were studied by means of viscometry in complement with other techniques.
In this study, lipase-catalyzed interesterification of palm oil and palm kernel oil using non-specific *Pseudomonas* sp. and 1,3-specific *Rhizomucor miehei* lipases demonstrated distinct chemical composition changes. Interestesterification of palm oil tends to form more medium and long chain triacylglycerols while interestesterification of palm kernel oil synthesized medium and short chain triacylglycerols. The two lipases showed high affinity in hydrolyzing palm oil fatty acids, resulting in high amounts of triacylglycerol losses and formation of partial glycerides. For palm kernel oil, the synthesis is enhanced. The hydrolysis preference of the two lipases toward palm oil acylglycerols were postulated to decrease in the order of triacylglycerol, diacylglycerol and monoacylglycerol while the opposite order is true for palm kernel oil.

For the three palm oil – palm kernel oil binary blends (3:1; 1:1 and 1:3; w/w), interestesterification caused similar chemical composition changes especially on the synthesis of medium chain triacylglycerols. The lipase catalytic process was influenced by the major fraction in the blends. Among these blends, 1:1 ratio exhibited the highest degree of interestesterification in terms of the total triacylglycerols concentration that increased in value while the other two blends indicated similar degrees of increment. The diversity and amount of triacylglycerols available are postulated to be the main reasons for the different catalytic activity in these binary blends. *Pseudomonas* sp. lipase showed higher degree and rate of interestesterification compared to *R. miehei* lipase under all conditions. Also, differences in the regiospecificity of the two lipases did not cause different chemical composition changes to all interesterified products. However, the positional specificity and the fatty acids preference of the two lipases had effects on the lipases’ degree of interestesterification.
Viscometry was an excellent and simple technique in monitoring oil crystallization process where it was able to determine the various stages of crystallization induction time. This unique capability of viscometry has merits in oil crystallization studies: correlating the phenomenon of oil fractionation (various crystallization stages) to polymorphism, polymorphic transformation and metastability of the crystal polymorphs. However, viscometry was relatively insensitive in comparison to laser polarized light anisotropy in detection of the initial nucleation event.

Under isothermal cooling, palm oil and the binary blend at 3:1 ratio exhibited fractionation behavior at lower temperature ranges. A two-stage crystallization process was observed where the initial stearin crystallized in the α form while olein crystallized later in the β’ form. At higher isothermal temperature, no fractionation occurred and the β’ form was the only polymorph observed in a single stage crystallization process. The transition temperature for the two-stage to a single-stage crystallization process varied with different oil compositions, indicating the effect of chemical composition on crystallization behavior. Palm kernel oil, 1:1 and 1:3 blends only crystallized in a single-stage process, in the β’ polymorphic form with different microstructures. The coexistence possibility of α and β’ crystals and the metastability of α crystal in fat crystallization were also discussed.

Interesterification using the two lipases displayed opposing effect towards crystallization behavior and nucleation rate of the two native oils. Lipase-catalyzed interesterification promoted fractionation behavior at higher temperatures and rate in palm oil. This was not observed for palm kernel oil. Crystallization behavior changes of the 3:1 and 1:3 blends confirmed our hypothesis that the two lipases showed high affinity toward the major
fraction in the blend. The trend of crystallization behavior changes in the 1:1 blend indicated that palm oil triacylglycerols were synthesized first before palm kernel oil. The occurrence of sequential synthesis process signified that the lipases used had higher affinity towards palm oil than palm kernel oil fatty acids. Differential scanning calorimeter thermal profiles of the various lipase-catalyzed oils were in agreement with their chemical composition and crystallization behavior changes. These thermal profiles also provided detailed information of the minor component changes that was not revealed in their crystallization behavior.

The applicability of the Fisher-Turnbull model in fat and oil crystallization is discussed in the final part of this study. A review of published literatures indicated that numerous modifications and assumptions had been made to justify the application of this model for fats and oils nucleation. In this study, nucleation data obtained from laser polarized light anisotropy for the various fat systems were used to investigate those proposed modifications and assumptions. The study showed that a single slope constant might not fully represent the complex fat crystallization phenomenon as compared to multiple slope constants. The multiple slope constants established in fats nucleation may be correlated to the nucleation of compound nucleus with different triacylglycerol compositions. However, the present study also showed that application of multiple slope constants resulted in inconsistencies during calculation of the nucleation energies when statistically different induction data from viscometry and laser techniques were used. The results of this study thus indicate that the validity of the various modifications and assumptions made to the Fisher-Turnbull equation need further verification while the application of this model in fats and oils crystallization need further refinement.
Abstrak tesis yang dikemukakan kepada Senat Universiti Putra Malaysia sebagai memenuhi keperluan untuk ijazah Doktor Falsafah

KINETIK DAN PELAKUAN PEMBEKUAN MINYAK SAWIT, MINYAK ISIRONG SAWIT DAN CAMPURAN LELEMAKNYA SECARA INTERESTERIFIKASI BERMANGKINKAN LIPASE MENGGUNAKAN VISKOMETRI

Oleh

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Januari 2004

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Masa induksi pembekuan minyak merupakan parameter kinetik penting yang membekalkan maklumat asas dalam penentuan ciri-ciri fizikal dan kimia minyak. Kriteria utama dalam pemilihan teknik untuk penentuan masa induksi minyak adalah ciri kepekaan teknik untuk membolehkan data diaplikasikan pada model Fisher-Turnbull dalam penganggaran tenaga pengaktifan bebas pengnuklearan. Bagaimanapun, kebanyakan teknik yang digunakan kini mempunyai had dan kelemahan tertentu. Kajian ini bertujuan menyelidik potensi penggunaan viskometri sebagai satu teknik baru dalam penentuan masa induksi pembekuan minyak. Minyak sawit, minyak isirong sawit dan campuran kedua minyak tersebut dalam pelbagai nisbah digunakan sebagai model pengajian. Sifat pemangkinan, kecekapan pemangkinan dan perubahan komposisi kimia yang disebabkan oleh sifat kespesifik posisi lipase terhadap pelbagai substrat minyak juga dikaji. Perubahan pelakuan pembekuan untuk minyak yang telah dimangkinkan
secara interesterifikasi berenzim menggunakan viskometri berbanding dengan teknik-teknik lain juga diselidiki.

Dalam pengajian ini, tindakbalas pemangkinan berenzim terhadap minyak sawit dan minyak isirong sawit dengan lipase tidak-spesifik *Pseudomonas* sp. dan 1,3-spesifik *Rhizomucor miehei* menunjukkan perubahan komposisi kimia yang berbeza. Pemangkinan minyak sawit membentuk lebih trilgiserida berantai sederhana dan panjang manakala pemangkinan minyak isirong sawit mensintesis trigliserida berantai sederhana dan pendek. Kedua-dua lipase menunjukkan kecenderungan tinggi menghidrolisis asid lemak minyak sawit, menyebabkan kehilangan kandungan trigliserida yang tinggi dan pembentukan peratusan mono- dan digliserida yang tinggi. Untuk minyak isirong sawit, proses sintesis pula menunjukkan peningkatan. Kecenderungan hidrolisis kedua-dua lipase tersebut terhadap gliserida minyak sawit dipostulasi menurun daripada tri-, di- ke monogliserida manakala keadaan sebaliknya dilihat untuk minyak isirong sawit.

Untuk ketiga-tiga campuran lelemak minyak sawit dan isirong sawit (3:1; 1:1 dan 1:3; b/b), pemangkinan berenzim menyebabkan perubahan komposisi kimia yang seakan-akan sama terutamanya pada sintesis trigliserida berantai sederhana. Tindakbalas pemangkinan dipengaruhi oleh fraksi utama campuran lelemak. Di antara campuran lelemak, nisbah 1:1 menunjukkan darjah interesterifikasi yang paling tinggi dari segi jumlah peningkatan kepekatan trigliserida manakala kedua-dua campuran lain menunjukkan darjah peningkatan yang sama. Kepelbagaian dan kandungan trigliserida dipostulasi sebagai faktor utama yang menyebabkan perbezaan kadar pemangkinan di antara campuran lelemak tersebut. Lipase *Pseudomonas* sp. menunjukkan kadar dan darjah interesterifikasi yang lebih tinggi berbanding dengan lipase *R. miehei* dalam
semua keadaan. Ciri kespesifikan lipase terhadap perubahan komposisi kimia tidak ketara. Sebaliknya, sifat kespesifikan posisi dan juga kecenderungan lipase terhadap asid lemak merupakan faktor penentuan kadar pemangkinan.

Penyelidikan ini telah membuktikan bahawa viskometri sesuai dan mudah digunakan dalam pemantauan proses pembekuan minyak di mana ia berupaya menentukan masa induksi pada pelbagai tahap pembekuan. Keupayaan ini boleh menambahkan pemahaman terhadap pelakuan pembekuan minyak: mengkaitkan hubungan fenomena fraksiisasi (pelbagai tahap pembekuan) dengan bentuk polimorfik, transformasi polimorfik dan kestabilan kristal dalam pelbagai bentuk polimorfik. Walau bagaimanapun, viskometri didapati kurang peka berbanding dengan teknik anisotropi bercahaya laser terkutub dalam pengesanan pelakuan awal proses pembekuan.

Di bawah penyejukan isoterma, minyak sawit dan lelemak campuran pada nisbah 3:1 menunjukkan pelakuan fraksinisasi pada julat suhu yang rendah. Proses pembekuan dua tahap diperhatikan di mana fraksi stearin membeku terlebih dahulu dalam bentuk α manakala olein membeku kemudian sebagai hablur β'. Pada suhu isoterma yang lebih tinggi, pelakuan fraksinisasi tidak berlaku dan hablur β' merupakan satu-satunya bentuk hablur yang hadir dalam proses pembekuan satu tahap tersebut. Suhu peralihan daripada proses pembekuan dua tahap ke satu tahap berbeza bergantung pada komposisi minyak dalam campuran dan ini menunjukkan kesan perubahan komposisi kimia terhadap pelakuan pembekuan. Minyak isirong, lelemak campuran pada nisbah 1:1 dan 1:3 pula hanya membeku dalam satu tahap, dalam bentuk β' tetapi dalam pelbagai mikrostruktur. Kemungkinan kewujudan hablur α dan β' serta ciri ketidakstabilan hablur α dalam pembekuan minyak juga dibincangkan.
Pemangkinan dengan kedua-dua lipase menunjukkan kesan berlawanan terhadap pelakuan dan kadar pembekuan kedua-dua minyak asli. Pemangkinan berenzim menggalakkan pelakuan fraksinasi pada minyak sawit pada suhu yang lebih tinggi dan kadar yang lebih cepat tetapi kesannya tidak ketara terhadap minyak isirong. Perubahan pelakuan pembekuan pada lelemak campuran 3:1 dan 1:3 membuktikan hipotesis bahawa lipase menunjukkan affiniti yang tinggi terhadap fraksi utama dalam compuran lelemak. Perubahan pelakuan pembekuan pada lelemak campuran nisbah 1:1 menunjukkan bahawa trigliserida minyak sawit disintesis terlebih dahulu sebelum tindakbalas beralih kepada minyak isirong sawit. Proses sintesis berturutan ini juga menunjukkan bahawa lipase mempunyai affiniti yang lebih tinggi terhadap asid lemak minyak sawit berbanding dengan asid lemak minyak isirong. Terma profil perubahan kalori pengimbasan untuk pelbagai minyak pemangkinan berenzim adalah sejajar dengan perubahan komposisi kimia dan pelakuan pembekuan. Terma profil tersebut juga membekalkan maklumat terperinci yang penting dalam pengajian perubahan komponen surih yang tidak dapat dikesan dalam perubahan pelakuan pembekuan.

Penggunaan model Fisher-Turnbull terhadap pembekuan minyak dibincangkan di bahagian terakhir projek ini. Sorotan literatur menunjukkan bahawa pelbagai pengubahsuaian dan andaiian perlu dibuat sebelum model ini boleh diaplikasikan dalam sistem nukleasi minyak. Dalam kajian ini, data nukleasi yang diperolehi daripada anisotropi bercahaya laser terkutub untuk pelbagai sistem minyak telah digunakan untuk mengkaji kesesuaian pengubahsuaian dan andaiian tersebut. Ia menunjukkan bahawa pemalar kecerunan tunggal mungkin tidak dapat memaparkan keadaan sebenar sifat pembekuan minyak yang kompleks jika dibandingkan dengan pemalar kecerunan gandaan. Pemalar kecerunan gandaan yang diterbitkan daripada nukleasi minyak
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I certify that an Examination Committee met on 6th January 2004 to conduct the final examination of Chen Chit Way on his Doctor of Philosophy thesis entitled “Kinetics and Crystallization Behavior of Palm Oil, Palm Kernel Oil and their Lipase-Catalyzed Interesterified Blends using Viscometry” in accordance with Universiti Pertanian Malaysia (Higher Degree) Act 1980 and Universiti Pertanian Malaysia (Higher Degree) Regulations 1981. The Committee recommends that the candidate be awarded the relevant degree. Members of the Examination Committee are as follows:

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DECLARATION

I hereby declare that the thesis is based on my original work except for quotations and citations which have been duly acknowledged. I also declare that it has not been previously or concurrently submitted for any other degree at UPM or other institutions.

CHEN CHIT WAY

Date: 20 Feb 2004
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29 Comparison of viscosity outputs for (a) PO and (b) PKO isothermal crystallization at different Tc.

30 Nucleation data determined using viscometry for isothermal crystallization of (a) PO and (b) PKO.

31 Nucleation data determined using viscometry for isothermal crystallization of PO – PKO at the ratios of (a) 3:1; (b) 1:1 and (c) 1:3.

32 PO isothermal crystallization at 291K at different interval. (a) Initial stage of crystallization; (b) after τ2; (c) and (d) are toward the end of the crystal growth stage.

33 PO isothermal crystallization at 301K at different intervals. Only needle-like shaped crystals were observed.

34 PO isothermal crystallization at 291K at the end of the crystallization process. The spherical crystals (α crystals) are still visible although being enclosed.

35 Illustration of how XRD results could be misleading. At the last stage, when α crystal is fully enclosed by β' crystals, the XRD was unable to detect the α crystal enclosed by the thick layer of β' crystals.

36 PKO isothermal crystallization at different Tc. (a) 285K; (b) 289K; (c) 293K and (d) 297K.

37 PKO isothermal crystallization at different Tc. (a) 279K; (b) 281K and (c) 283K.
Comparison of nucleation data determined from laser polarized light anisotropy and viscometry techniques for isothermal crystallization of (a) PO, and (b) PKO.

Comparison of nucleation data determined from laser polarized light anisotropy and viscometry techniques for isothermal crystallization of PO – PKO binary blends at (a) 3:1, (b) 1:1 and (c) 1:3 ratio.

Light scattering turbidimetry output of cocoa butter crystallization, illustrating induction periods for the two crystallization stages.

Induction time curves established from (a) viscometry and (b) laser polarized light anisotropy for isothermal crystallization of PO catalyzed using *Pseudomonas* sp. (PS) and *R. miehei* (LP) lipases.

Induction time curves established from (a) viscometry and (b) laser polarized light anisotropy for isothermal crystallization of PKO catalyzed using *Pseudomonas* sp. (PS) and *R. miehei* (LP) lipases.

Induction time curves established from (a) viscometry and (b) laser polarized light anisotropy for isothermal crystallization of PO – PKO binary blend at 3:1 ratio, catalyzed using *Pseudomonas* sp. (PS) and *R. miehei* (LP) lipases.

Induction time curves established from (a) viscometry and (b) laser polarized light anisotropy for isothermal crystallization of PO – PKO binary blend at 1:3 ratio, catalyzed using *Pseudomonas* sp. (PS) and *R. miehei* (LP) lipases.

Induction time curves established from (a) viscometry and (b) laser polarized light anisotropy for isothermal crystallization of PO – PKO binary blend at 1:1 ratio, catalyzed using *Pseudomonas* sp. (PS) and *R. miehei* (LP) lipases.

DSC thermal profiles of PO before (control) and after IE using *Pseudomonas* sp. (PS) and *R. miehei* (LP) lipases: (a) heating and (b) cooling curves.

DSC thermal profiles of PKO before (control) and after IE using *Pseudomonas* sp. (PS) and *R. miehei* (LP) lipases: (a) heating and (b) cooling curves.

DSC thermal profiles of PO: PKO in 3:1 blend (P31) before (control) and after IE using *Pseudomonas* sp. (PS) and *R. miehei* (LP) lipases: (a) heating and (b) cooling curves.
49 DSC thermal profiles of PO: PKO in 1:1 blend (P11) before (control) and after IE using *Pseudomonas* sp. (PS) and *R. miehei* (LP) lipases: (a) heating and (b) cooling curves.

50 DSC thermal profiles of PO: PKO in 1:3 blend (P13) before (control) and after IE using *Pseudomonas* sp. (PS) and *R. miehei* (LP) lipases: (a) heating and (b) cooling curves.

51 Plots of ln(τTc) vs. 1/T(ΔT)² of: (a) PO and (b) PKO with nucleation data determined using laser polarized light anisotropy.

52 Plots of ln(τTc) vs. 1/T(ΔT)² of PO – PKO binary blends at (a) 3:1, (b) 1:1 and 1:3 ratios with nucleation data determined using laser polarized light anisotropy.

53 Plots of ln(τTc) vs. 1/T(ΔT)² of: (a) PO and (b) PKO with crystallization induction time determined using viscometry.

54 Plots of ln(τTc) vs. 1/T(ΔT)² of PO – PKO binary blends at (a) 3:1, (b) 1:1 and 1:3 ratios with crystallization induction time determined using viscometry.

55 Comparison of ΔGₙ estimated from the multiple slope constant of (a) PO and (b) PKO using viscometry and laser polarized light anisotropy.

56 Comparison of ΔGₙ estimated from the multiple slope constant of PO – PKO binary blends at (a) 3:1 (b) 1:1 and (c) 1:3 ratios using viscometry and laser polarized light anisotropy.

57 Comparison of ΔGₙ estimated from the multiple slopes constant of PO catalyzed by (a) *Pseudomonas* sp. and (b) *R. miehei* lipases using viscometry and laser polarized light anisotropy.

58 Comparison of ΔGₙ estimated from the multiple slopes constant of PKO catalyzed by (a) *Pseudomonas* sp. and (b) *R. miehei* lipases using viscometry and laser polarized light anisotropy.

59 Comparison of ΔGₙ estimated from the multiple slopes constant of PO – PKO binary blend at 3:1 ratio catalyzed by (a) *Pseudomonas* sp. and (b) *R. miehei* lipases using viscometry and laser polarized light anisotropy.