

UNIVERSITI PUTRA MALAYSIA

KINETIC AND CRYSTALLIZATION BEHAVIOUR OF PALM OIL, PALM KERNEL OIL AND THEIR LIPASE-CATALYZED INTERESTIFIED BLENDS USING VISCOMETRY

CHEN CHIT WAY.

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By

CHEN CHIT WAY

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Chairwoman : Associate Professor Lai Oi Ming, Ph.D.

Faculty : Food Science and Biotechnology

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. Interesterification of palm oil tends to form more medium and long chain triacylglycerols while interesterification 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), interesterification 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 interesterification 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 interesterification 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 interesterification.



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.



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

Oleh

CHEN CHIT WAY

Januari 2004

Pengerusi : Professor Madya Lai Oi Ming, Ph.D.

Fakulti : Sains Makanan dan Bioteknologi

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 kespesifikan posisi lipase terhadap pelbagai substrat minyak juga dikaji. Perubahan pelakuan pembekuan untuk minyak yang telah dimangkinkan



secara interesterifikasi berenzim menggunakan viskometri berbanding dengan teknikteknik 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 trigliserida 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 seakanakan 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



vii

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 fraksinasi (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 fraksinasi 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 fraksinasi 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. Tren 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 permeteran 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 andaian 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 andaian 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



mungkin berkaitan dengan nukleus sebatian yang terdiri daripada komposisi trigliserida yang berlainan. Bagaimanapun, keputusan kajian ini juga menunjukkan bahawa penggunaan pemalar kecerunan gandaan boleh menyebabkan perbezaan dalam pengiraan tenaga pengaktifan nukleasi bebas daripada data induksi yang diperolehi daripada viskometri dan teknik laser. Keputusan penyelidikan ini menunjukkan bahawa penggunaan pelbagai pengubahsuaian dan andaian ke atas model Fisher-Turnbull perlu diimbas kembali dan penggunaan model ini dalam pembekuan minyak memerlukan kajian lanjutan.



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TABLE OF CONTENTS

	Page
ABSTRACT	ii
ABSTRAK	vi
ACKNOWLEDGEMENTS	xi
APPROVAL	xiii
DECLARATION	xv
LIST OF FIGURES	XX
LIST OF TABLES	xxvi
LIST OF ABBREVIATIONS	xxviii

CHAPTER

1	INTRODUCTION	1
2	LITERATURE REVIEW	
	Crystallization of Fats and Oils	
	Introduction	9
	Fat Polymorphism	12
	Thermodynamic Stability and Crystallization of Polymorphs	17
	Crystal Sizes, Habit and Morphology	19
	Polymorphism and Crystallization Behavior of Fats and Oils	
	Palm Oil and Its Derivatives	20
	Palm Kernel Oil and Its Derivatives	26
	Application of Fisher-Turnbull Model for the Estimation of Nucleation Activation Free Energy	28
	Techniques Used in Induction Time Determination	
	Criteria in Techniques Selection	33
	Classification of Techniques	35
	Techniques Based On Optical Principle	
	Polarized Light Microscopy	35
	Laser Polarized Light Anisotropy	38
	Turbidimetry	40
	Light Scattering Spectroscopy	41
	Technique Based On Thermal Principle	
	Differential Scanning Calorimetry	42



Techniques Based On Mass Deposition Principle	
Pulsed-Nuclear Magnetic Resonance	
Spectroscopy	45
X-ray Diffraction	48
Viscometry	51
Lipases	
Introduction	54
Properties of Lipases	56
Lipase Specificity	58
Application of Lipases in the Modification of Fats and Oils	61
LIPASE-CATALYZED INTERESTERIFICATION OF PALM OIL, PALM KERNEL OIL AND THEIR BINARY BLENDS	
Introduction	65
Materials and Methods	
Materials	66
Methods	
Blend Preparation	67
Lipase Immobilization	67
Interesterification Reaction	68
Determination of Hydrolytic Activity	68
TAG Analysis	69
Results and Discussion	
TAG Compositional Analysis	71
Palm Oil Interesterification	76
Palm Kernel Oil Interesterification	81
Catalytic Nature of the Lipases	84
Palm Oil-Palm Kernel Oil Blends Interesterification	88
Conclusion	99
VISCOMETRY AS A NEW TECHNIQUE IN CHARACTERIZATION OF CRYSTALLIZATION PROCESS	
Introduction	101
Materials and Methods	
Materials	102

3

4



Methods

5

Removal of Free Fatty Acid	103
Viscometry for Induction Time Determination and Shear Rate Effect	103
Laser Polarized Light Anisotropy for Induction Time Determination	105
X-ray Diffraction	106
Polarized Light Microscopy	107
Results and Discussion	
Effect of Shear Rate on Viscometry	108
Interpretation of Viscosity Output	111
Induction Time Curves of Viscometry	115
Sensitivity Evaluation of Viscometry in Relative to Laser Polarized Light Anisotropy	137
Conclusion	143
KERNEL OIL AND THEIR BINARY BLENDS Introduction	145
Introduction	145
Materials and Methods	
Materials	147
Methods	
Interesterification Reaction	147
Removal of Free Fatty Acid	148
Characterization of Crystallization Behavior	148
Analysis of DSC Thermal Properties	148
Results and Discussions	
Effect of Interesterification on Palm Oil and Palm Kernel Oil Crystallization	1 49
Effect of Interesterification on the Crystallization of Palm Oil-Palm Kernel Oil Binary Blends	157
Effect of IE on Thermal Properties	10.
	166



6

APPLICABILITY OF FISHER-TURNBULL MODEL IN FATS AND OILS SYSTEM FOR ESTIMATION OF NUCLEATION **ACTIVATION FREE ENERGIES**

Introduction	176
Materials and Methods	
Materials	177
Methods	
Induction Time Determination	178
Calculation of the Nucleation Activation Free Energy	178
Statistical Analysis	179
Results and Discussion	
Interpretation of the Slope Constant from Plot of $\ln(\tau T_c)$ vs. $1/T_c(\Delta T)^2$	179
Effect of Technique Sensitivity on Activation Energies Estimated from the Fisher-Turnbull Model	183
Conclusion	190
7 SUMMARY, CONCLUSION AND RECOMMENDATIONS	
Summary	191
Conclusion and Recommendations	195
BIBLIOGRAPHY	197
APPENDICES PUBLICATIONS	



LIST OF FIGURES

Figure		Page
1	Diversity of fatty acid composition of TAG.	12
2	Double and triple chain length structure configuration.	13
3	Three typical subcell arrangements for the main polymorphic forms of fats.	14
4	A Gibbs energy – temperature relationship of three typical polymorphs in TAG.	18
5	Polymorphic transition of PO and PKO during heating at 0.5°C/min after fast chilling of the melt from 70°C to -25°C.	21
6	PO polymorphism under cooling and heating.	22
7	Laser polarized light anisotropy for induction time determination of an oil system.	39
8	One of the limitations of pNMR spectroscopy in measuring induction time.	47
9	Diffraction of X-rays in a crystal lattice.	48
10	Proposed bilayer lamellar structure of TAG in the liquid state.	52
11	TAG profiles of (a) PO and (b) PKO.	72
12	TAG profiles of PO: PKO blends at: (a) 3:1; (b) 1:1 and (c) 1:3 ratio.	73
13	TAG profiles of PO at (a) 0 hr; (b) 3 hr; (c) 6 hr; (d) 9 hr; (e) 12 hr; (f) 24 hr and (g) 48 hr of IE using immobilized <i>Pseudomonas</i> sp. lipase.	77
14	TAG profiles of PO at (a) 0 hr; (b) 3 hr; (c) 6 hr; (d) 9 hr; (e) 12 hr; (f) 24 hr and (g) 48 hr of IE using immobilized <i>Rhizomucor miehei</i> lipase (Lipozyme IM60).	78



15	Effect of different lipases on IE of PO: (a) cumulative summation of TAG that increased in concentration, Σ [TAGI _t]; (b) % TAG remaining; and (c) hydrolysis rate (% FFA liberated).	79
16	TAG profiles of PKO at (a) 0 hr; (b) 3 hr; (c) 6 hr; (d) 9 hr; (e) 12 hr; (f) 24 hr and (g) 48 hr of IE using immobilized <i>Pseudomonas</i> sp. lipase.	82
17	TAG profiles of PKO at (a) 0 hr; (b) 3 hr; (c) 6 hr; (d) 9 hr; (e) 12 hr; (f) 24 hr and (g) 48 hr of IE using immobilized <i>Rhizomucor miehei</i> lipase (Lipozyme IM60).	83
18	Effect of IE using different lipases on PKO: (a) cumulative summation of TAG that increased in concentration, $\sum[TAGI_t]$; and (b) % TAG remaining; and (c) hydrolysis rate (% FFA liberated).	85
19	Percentages of IE in term of $\sum[TAGI_t]$ relative to their initial concentration, $\sum[TAGI_0]$ of PO and PKO catalyzed by <i>R. miehei</i> (Lipozyme IM60) (LP) and <i>Pseudomonas</i> sp. (PS) lipases.	86
20	TAG profiles of PO: PKO (3:1) blend at (a) 0 hr; (b) 3 hr; (c) 6 hr; (d) 9 hr; (e) 12 hr; (f) 24 hr and (g) 48 hr of IE using immobilized <i>Pseudomonas</i> sp. lipase.	89
21	TAG profiles of PO: PKO (3:1) blend at (a) 0 hr; (b) 3 hr; (c) 6 hr; (d) 9 hr; (e) 12 hr; (f) 24 hr and (g) 48 hr of IE using immobilized <i>Rhizomucor miehei</i> lipase (Lipozyme IM60).	90
22	TAG profiles of PO: PKO (1:1) blend at (a) 0 hr; (b) 3 hr; (c) 6 hr; (d) 9 hr; (e) 12 hr; (f) 24 hr and (g) 48 hr of IE using immobilized <i>Pseudomonas</i> sp. lipase.	91
23	TAG profiles of PO: PKO (1:1) blend at (a) 0 hr; (b) 3 hr; (c) 6 hr; (d) 9 hr; (e) 12 hr; (f) 24 hr and (g) 48 hr of IE using immobilized <i>Rhizomucor miehei</i> lipase (Lipozyme IM60).	92
24	TAG profiles of PO: PKO (1:3) blend at (a) 0 hr; (b) 3 hr; (c) 6 hr; (d) 9 hr; (e) 12 hr; (f) 24 hr and (g) 48 hr of IE using immobilized <i>Pseudomonas</i> sp. lipase.	93
25	TAG profiles of PO: PKO (1:3) blend at (a) 0 hr; (b) 3 hr; (c) 6 hr; (d) 9 hr; (e) 12 hr; (f) 24 hr and (g) 48 hr of IE using immobilized <i>Rhizomucor miehei</i> lipase (Lipozyme IM60).	94



26	Effect of IE using different lipases on PO: PKO blend mixtures of 3:1, P31; 1:1, P11 and 1:3, P13: (a) hydrolysis rate (% FFA liberated); (b) % TAG remaining; and (c) total concentration increases of $[TAGI_t]$.	97
27	Typical CdS photodiode chart-recorder output of laser polarized light anisotropy corresponding to PO isothermal crystallization.	106
28	Viscosity outputs of PO isothermal crystallization at (a) 295K and (b) 291K. Induction times of the various stages of crystallization are indicated.	112
29	Comparison of viscosity outputs for (a) PO and (b) PKO isothermal crystallization at different T_c .	113
30	Nucleation data determined using viscometry for isothermal crystallization of (a) PO and (b) PKO.	117
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.	118
32	PO isothermal crystallization at 291K at different interval. (a) Initial stage of crystallization; (b) after τ_2 ; (c) and (d) are toward the end of the crystal growth stage.	125 – 126
33	PO isothermal crystallization at 301K at different intervals. Only needle-like shaped crystals were observed.	127
34	PO isothermal crystallization at 291K at the end of the crystallization process. The spherical crystals (α crystals) are still visible although being enclosed.	129
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.	132
36	PKO isothermal crystallization at different T_c . (a) 285K; (b) 289K; (c) 293K and (d) 297K.	133 – 134
37	PKO isothermal crystallization at different T_c . (a) 279K; (b) 281K and (c) 283K.	136



38	Comparison of nucleation data determined from laser polarized light anisotropy and viscometry techniques for isothermal crystallization of (a) PO, and (b) PKO.	138
39	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.	139
40	Light scattering turbidimetry output of cocoa butter crystallization, illustrating induction periods for the two crystallization stages.	143
41	Induction time curves established from (a) viscometry and (b) laser polarized light anisotropy for isothermal crystallization of PO catalyzed using <i>Pseudomonas</i> sp. (PS) and <i>R. miehei</i> (LP) lipases.	150
42	Induction time curves established from (a) viscometry and (b) laser polarized light anisotropy for isothermal crystallization of PKO catalyzed using <i>Pseudomonas</i> sp. (PS) and <i>R. miehei</i> (LP) lipases.	155
43	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 <i>Pseudomonas</i> sp. (PS) and <i>R. miehei</i> (LP) lipases.	158
44	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 <i>Pseudomonas</i> sp. (PS) and <i>R. miehei</i> (LP) lipases.	161
45	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 <i>Pseudomonas</i> sp. (PS) and <i>R. miehei</i> (LP) lipases.	164
46	DSC thermal profiles of PO before (control) and after IE using <i>Pseudomonas</i> sp. (PS) and <i>R. miehei</i> (LP) lipases: (a) heating and (b) cooling curves	167
47	DSC thermal profiles of PKO before (control) and after IE using <i>Pseudomonas</i> sp. (PS) and <i>R. miehei</i> (LP) lipases: (a) heating and (b) cooling curves.	168
48	DSC thermal profiles of PO: PKO in 3:1 blend (P31) before (control) and after IE using <i>Pseudomonas</i> sp. (PS) and <i>R. miehei</i> (LP) lipases: (a) heating and (b) cooling curves.	169



49	DSC thermal profiles of PO: PKO in 1:1 blend (P11) before (control) and after IE using <i>Pseudomonas</i> sp. (PS) and <i>R. miehei</i> (LP) lipases: (a) heating and (b) cooling curves.	170
50	DSC thermal profiles of PO: PKO in 1:3 blend (P13) before (control) and after IE using <i>Pseudomonas</i> sp. (PS) and <i>R. miehei</i> (LP) lipases: (a) heating and (b) cooling curves.	171
51	Plots of $ln(\tau T_c)$ vs. $1/T(\Delta T)^2$ of: (a) PO and (b) PKO with nucleation data determined using laser polarized light anisotropy.	180
52	Plots of $\ln(\tau T_c)$ vs. $1/T(\Delta T)^2$ 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.	181
53	Plots of $ln(\tau T_c)$ vs. $1/T(\Delta T)^2$ of: (a) PO and (b) PKO with crystallization induction time determined using viscometry.	184
54	Plots of $\ln(\tau T_c)$ vs. $1/T(\Delta T)^2$ of PO – PKO binary blends at (a) 3:1, (b) 1:1 and 1:3 ratios with crystallization induction time determined using viscometry.	185
55	Comparison of ΔG_n estimated from the multiple slope constant of (a) PO and (b) PKO using viscometry and laser polarized light anisotropy.	187
56	Comparison of ΔG_n 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.	188
57	Comparison of ΔG_n estimated from the multiple slopes constant of PO catalyzed by (a) <i>Pseudomonas</i> sp. and (b) <i>R. miehei</i> lipases using viscometry and laser polarized light anisotropy.	215
58	Comparison of ΔG_n estimated from the multiple slopes constant of PKO catalyzed by (a) <i>Pseudomonas</i> sp. and (b) <i>R. miehei</i> lipases using viscometry and laser polarized light anisotropy.	216
59	Comparison of ΔG_n estimated from the multiple slopes constant of PO – PKO binary blend at 3:1 ratio catalyzed by (a) <i>Pseudomonas</i> sp. and (b) <i>R. miehei</i> lipases using viscometry and laser polarized light anisotropy.	217

