

---

## THERMALLY PROCESSED FISHERY PRODUCTS

---

Mohan C. O., Remya, S., Sreelakshmi, K. R.

Fish Processing division

Email ID: *comohan@gmail.com*

Thermal processing is an age old well established food preservation technology. The Indian seafood canning industry, once at its boom has collapsed due to non-availability of suitable cheaper containers and competition from other countries. The development of domestic market is very essential to sustain the growth and development of this industry. In recent years there is an increasing demand for convenience products in India due to modernization of the country with supermarkets and hypermarkets across urban places. The demand is also expected to increase due to population growth and increasing disposable income. Market size of canned seafood in India is very small and highly fragmented compared to frozen seafood sector. However, its demand is increasing in most of the countries including in Asia. Europe and North America are the largest market for canned fish products followed by Asia-Pacific and Middle East & African countries. Dongwon, Century Pacific Food INC, Wild Planet, Frinsa, Natural SLA and Bumble Bee are the key players in this sector.

The concept of thermal processing has come a long way since the invention of the process by French confectioner, Nicholas Appert. Later on Bigelow and Ball developed the scientific basis for calculating the sterilization process for producing safe foods. Today, thermal processing forms one of the most widely used method of preserving and extending shelf life of food products including seafood's. Thermal processing involves application of high temperature treatment for sufficient time to destroy all the microorganisms of public health and spoilage concerns. Normally, thermal processing is not designed to destroy all microorganisms in a packaged product, which may result in low quality product which destroys important nutrients. Instead of this, the pathogenic microorganisms in a hermetically sealed container are destroyed by heating and a suitable environment is created inside the container which does not support the growth of spoilage type microorganisms. Several factors must be considered for deciding the extent of heat processing which include,

- a) type and heat resistance of the target microorganism, spore, or enzyme present in the food

- b) pH of the food
- c) heating conditions
- d) thermo-physical properties of the food and the container shape and size
- e) storage conditions

Thermal processing is designed to destroy different microorganisms and enzymes present in the food. Normally in thermal processing, exhausting step is carried out to before sealing the containers. In some cases, food is vacuum packed in hermetically sealed containers. In such cases very low levels of oxygen is intentionally achieved. Hence, the prevailing conditions are not favorable for the growth of microorganisms that require oxygen (obligate aerobes) to create food spoilage or public-health problems. Further, the spores of obligate aerobes are less heat resistant than the microbial spores that grow under anaerobic conditions (facultative or obligate anaerobes). The growth and activity of these anaerobic microorganisms are largely pH dependent. From a thermal-processing standpoint, foods are divided into three distinct pH groups which are given below. Changes in the intrinsic properties of food, mainly salt, water activity and pH are known to affect the ability of microorganisms to survive thermal processes in addition to their genotype. Due to health related concerns on the use of salt, there is increased demand to reduce salt levels in foods. The United States Food and Drug Administration (FDA) have classified foods in the federal register (21 CFR Part 114) as 3 categories:

1. high-acid foods (pH < 3.7; e.g., apple, apple juice, apple cider, apple sauce, berries, cherry (red sour), cranberry juice, cranberry sauce, fruit jellies, grapefruit juice, grapefruit pulp, lemon juice, lime juice, orange juice, pineapple juice, sour pickles, vinegar)
2. acid or medium-acid foods (pH 3.7 - 4.5; e.g., fruit jams, frit cocktail, grapes, tomato, tomato juice, peaches, piento, pineapple slices, potato salad, prune juice, vegetable juice)
3. low-acid foods (pH > 4.5; e.g., all meats, fish and shellfishes, vegetables, mixed entries, and most soups).

The acidity of the substrate or medium in which micro-organisms are present is an important factor in determining the extent of heat treatment required. With reference to thermal processing of food products, special attention should be devoted to *Clostridium botulinum* which is a highly heat resistant mesophilic gram positive, rod shaped spore-forming anaerobic pathogen that produces the toxin *botulin*. It has been generally accepted that *C. botulinum* and other spore forming, human pathogens does not grow and produce toxins below a pH of 4.6. The organisms that can grow in such acid conditions are destroyed by relatively mild heat treatments. For food with pH values greater than 4.5, which are known as low-acid products which includes fishery products, it is necessary to apply a time–temperature regime sufficient

to inactivate spores of *C. botulinum* which is commonly referred to as a *botulinum cook* in the industry. Thermal processes are calibrated in terms of the equivalent time the thermal centre of the product, i.e. the point of the product in the container most distant from the heat source or cold spot, spends at 121.1°C, and this thermal process lethality time is termed the  $F_0$  value. Although there are other microorganisms, for example *Bacillus stearothermophilus*, *B. thermoacidurans*, and *C. thermosaccolyticum*, which are *thermophilic* in nature (optimal growth temperature  $\sim 50\text{--}55^\circ\text{C}$ ) and are more heat resistant than *C. botulinum* a compromise on the practical impossibility of achieving full sterility in the contents of a hermetically sealed container during commercial heat processing, whereby the initial bacterial load is destroyed through sufficient decimal reductions to reduce the possibility of a single organism surviving to an acceptably low level. This level depends on the organism, usually *Clostridium botulinum*, which the process is designed to destroy. The time required to reduce the number of spores of this organism (or any other micro-organism) by a factor of 10 at a specific reference temperature (121.1°C) is the decimal reduction time, or  $D$  value, denoted  $D_0$ . The  $D_0$  value for *Clostridium botulinum* spores can be taken as 0.25 minutes. To achieve a reduction by a factor of  $10^{12}$ , regarded as an acceptably low level, requires 3 minutes at 121.1°C, and is known as the process value, or  $F$  value, designated  $F_0$  so, in this case,  $F_0 = 3$ , which is known as a botulinum cook which is the basis of commercial sterility.

### **Commercial sterility**

If the thermal process is sufficient to fulfill the criteria of safety and prevention of non-pathogenic spoilage under normal conditions of transport and storage, the product is said to be 'commercially sterile'. In relation to canned foods, the FAO/WHO Codex Alimentarius Commission (1983) defines, commercial sterility as the condition achieved by the application of heat, sufficient alone or in combination with other appropriate treatments, to render the food free from microorganisms capable of growing in the food at normal non-refrigerated conditions at which the food is likely to be held during distribution and storage. Apart from this concept there are circumstances where a canner will select a process which is more severe than that required for commercial sterility as in the case of mackerel and sardine where bone softening is considered desirable.

### **Mechanism of heat transfer**

Understanding the mechanism of heat transfer is very important for thermal processing. Normally, there are three different modes of heat transfer: conduction, convection and radiation. Conduction is the transfer of heat by molecular motion in solid bodies. Convection is the transfer of heat by fluid flow, created by density differences and buoyancy effects, in fluid products. Radiation is the transfer of electromagnetic energy between two bodies at different temperatures. In thermal processed foods, the mechanism of heat transfer is either by conduction, convection or by broken heating (combination of conduction and convection). The

factors which determine the mode of heat transfer are nature or consistency of a food product, the presence of particles, and the use of thickening agents and sugars. The heating modes in the thermal processing are first by heat transfer to the container or packaging material from heating and cooling media, second through the container wall and third is into the product from container wall. Convective-heat transfer rates depend largely on the velocity of flow of the media over the container, and this is an important factor to be controlled in all processing operations. In conduction heating method, energy transfer takes place when different parts of a solid body are at different temperatures. The slowest heating point or cold point in cylindrical metal containers is at its geometric centre for food products heated by conduction method. Convection heat transfer involves the transfer of heat from one location to the other through the actual movement or flow of a fluid. The slowest heating point for convection heated products in cylindrical metal container is approximately 1/10<sup>th</sup> up from the base of the container. Packaging material forms the most important component of thermal processed foods. It should be able to withstand the severe process conditions and should prevent recontamination of the product.

### **Containers for thermal processing**

Containers used for thermal processing should have special properties like it should withstand high temperature and pressure. Tin cans are commonly used in the canning industry and cans are denoted by trade name. First digit represents diameter of can (in inches) and next two digits represent measurement in sixteenth of inches. Apart from OTS cans, other container used in canning are: aluminium cans, tin free steel (TFS) cans, glass containers, retort pouches and semi-rigid containers. Nowadays, retort pouch processing is very popular. The retort pouches are flexible in nature and they easily withstand high temperatures used during thermal processing. They also provide good barrier against moisture and gases. The most common retort pouch is 3 layered laminate. The 3 layers are joined with adhesive lamination. These three layers are:

- a) Polyester layer which helps in providing strength and abrasion resistance
- b) Aluminium foil for providing barrier against moisture, gases and light
- c) Polypropylene/ polyethylene for heat sealing properties.



Containers used for thermal processing

Ideally, the container used for thermal processing should fulfill following characteristics:

- Should withstand the sterilisation pressure and temperature

- Should be impervious to air, moisture, dust and disease germs once the can is sealed air tight
- Internal lacquer should not impart toxicity to the contents
- Strong enough to protect the contents during transportation and handling
- Inexpensive, preferably cheap enough to discard after use
- Capable of sealing at high speed
- Pleasing and sanitary appearance

### **Thermal Processing of Fishery Products**

Fishery products, being categorized as low acid foods require heat processing severity with respect to *C botulinum* and  $F_0$  value recommended is 5-20 min. Thermal processing of fishery products include various steps. These steps include, preparations like washing, beheading, gutting, removing scales / fins, cutting into required size, blanching (hot / cold), pre-cooking, filling fish pieces into containers, filling content or medium, exhausting to remove air, sealing, loading into the retort or autoclave, sterilization, washing and storing. Various packaging materials have been used from historically starting from glass container to metal container, flexible retortable pouches and rigid plastic containers. The sterilization process in the canned product can be subdivided into three phases. First one is heating phase, in which the product temperature is increased from ambient to the required sterilization temperature by means of a heating medium (water or steam). This temperature is maintained for a defined time (phase 2 = holding phasing). In (phase 3 = cooling phase) the temperature in the container is decreased by introduction of cold water into the autoclave. In order to reach temperatures above 100°C (sterilization), the thermal treatment has to be performed under pressure in pressure cookers, also called autoclaves or retorts. Simple autoclaves are generally vertical ones with the lid on top. Through the opened lid, the goods to be sterilized are loaded into the autoclave. The cans are normally placed in metal baskets. The autoclave and lid are designed to withstand higher pressures up to 5.0 bar. These types of autoclaves are best suited for smaller operations as they do not require complicated supply lines and should be available at affordable prices. Larger autoclaves are usually horizontal and loaded through a front lid. Horizontal autoclaves can be built as single or double vessel system. The double vessel systems have the advantage that the water is heated up in the upper vessel to the sterilization temperature and released into the lower (processing) vessel, when it is loaded and hermetically closed. Using the two-vessel system, the heat treatment can begin immediately without lengthy heating up of the processing vessel and the hot water can be recycled afterwards for immediate use in the following sterilization cycle. In rotary autoclaves, the basket containing the cans rotates during sterilization which enhances the heat penetration resulting in reduced process time. This technique is useful for cans with liquid or semi-liquid content as it achieves a mixing effect of the liquid/semi-liquid goods. Water immersion retorts are also used in the industry for thermal

processing which is advantageous over steam retorts due to its uniform temperature distribution as there is no possibility of forming air pockets in the retort which limits the heat transfer in steam retorts. At the final stage of the sterilization process the products must be cooled as quickly as possible by introducing cold water. The contact of cold water with steam causes the latter to condense with a rapid pressure drop in the retort. However, the overpressure built up during thermal treatment within the cans, jars or pouches remain for a certain period. During this phase, when the outside pressure is low but the pressure inside the containers is still high due to high temperatures there, the pressure difference may induce permanent deformation of the containers. Therefore, high pressure difference between the autoclave and the thermal pressure in the containers must be avoided. This is generally achieved by a blast of compressed air into the autoclave at the initial phase of the cooling. Sufficient hydrostatic pressure of the introduced cooling water can also build up counter pressure so that in specific cases, in particular where strong resistant metallic cans are used, the water pressure can be sufficient and compressed air may not be needed unlike in flexible retortable pouches. After thermal processing, the containers are washed with chlorinated potable water and stored for conditioning for 2 – 4 weeks. Conditioning helps in proper mixing of the ingredients with the fish products and helps in assessing the extent of thermal process severity. If the containers do not show any deformation, it indicates the effectiveness of the thermal processing.

The important steps in canning process are:

- 1) Raw material preparation
- 2) Blanching/ Precooking
- 3) Filling into containers
- 4) Addition of fill (brine/ oil/ gravy)
- 5) Exhausting
- 6) Seaming/ sealing
- 7) Retorting (heat processing)
- 8) Cooling
- 9) Drying
- 10) Labelling and storage

**Spoilage of canned fishery products:**

Major spoilage encountered in the canned fish products are listed below.

**Identifiable evidences of spoilage:**

1. Flipper
2. Springer
3. Swell
4. Flat sour

5. Hydrogen swell
6. Buckles
7. Leakers
8. Panelled cans

**Spoilage due to physical or chemical reasons:**

1. Black discolouration
2. Blue discolouration
3. Mush
4. Honey combing
5. Stack burning

**Spoilage due to microbial growth:**

1. Gaseous spoilage
2. Non-gaseous spoilage

\*\*\*\*\*