## CONTENTS

Preface vii
Acknowledgements ix

**BAFE SESSION I: K-ENGINEERING**

Knowledge Engineering: The Way Forward in Propelling the Agricultural Sector into the K-Economy
Dato' Muhamad Zohadie Bardaie 1

Development of Computer-Assisted Exercises to Enhance the Conceptual Thinking Abilities for Technical/Physical Problem Solving in Agriculture and Applied Biology.
Guido Wyseure, Josse De Baerdemaeker and Vic Goedseels 7

Decision Support Tools to Manage Farm Mechanization Cost Effectively
Ooi Ho Seng 13

Expert Rating System: A Sustainable Management Solution for Ecotourism Sites in Peninsular Malaysia
Vikneswaran Nair, Mohd. Daud, Mohd. Zohadie Bardaie and Abdullah Mohd 19

Design, Development and Validation of Expert System for Community Noise Pollution
Ahmed Eifaig, Mohamed Daud, Mohd. Zohadie Bardaie, and Ramdzani Abdullah 25

Using GIS in Ecotourism Development in State of Selangor, Malaysia
A. M. Fatima, Mohamed Daud, Mohd.Zohadie Bardaie and Abdul Rashid Mohd.Shariff 31

Ranking System Based on Internet for Eco-Tourism Site in Malaysia
Mohammad Shokouhi and Mohamed Daud 37

**BAFE SESSION II: RESOURCE CONSERVATION ENGINEERING**

A Computer Package for Simulation of Surface Irrigation Improvements for Water Savings at Farm and Distribution Systems.

Rice Irrigation Water Management Using GIS
M.S.M. Amin, M.K. Rowshon, and T.J. Deepak 45

Application of SWAT Hydrological Model to Upper Bernam Basin
M.S.M. Amin, and S.H. Lai 51

Using Visual Basic for Water Management of Tanjung Karang Rice Irrigation Scheme
T.J. Deepak and M.S.M. Amin 57

A. Fouial and M.S.M. Amin 63

Water Distribution from Porous Pipe Micro Irrigation Lateral
M.S.M. Amin and Fakrul Islam 67

**BAFE SESSION III: CONTROLLED ENVIRONMENT**

Integrated Renewable Energy Farms – FAO/UN Strategy Towards Sustainable Production of Energy and Food
N. El Bassam 73

Biological Life Support Systems under Controlled Environments
N. El Bassam 78-a

Design and Development of Tropical Greenhouse Structures
Rezuwan Kamaruddin 79

Quantification of Natural Ventilation in a Porous Greenhouse Structure
Rezuwan Kamaruddin 87
BAFE SESSION IV: BIOLOGICAL ENGINEERING

Engineering Artificial Cells for Cell Therapy
S. Prakash and M.L. Jones

Acute Dengue Fever Analysis Using Pattern Classifier Model
Fatimah Ibrahim, Saadiah Sulaiman, Mohd Nasir Taib and Wan Abu Bakar Wan Abas

Evaluating Detection Methods for SRB in Industrial Systems
Mohammad Setareh and Reza Javaherdashti

Multiple Offset Transmission-Mode Radar Tomography Applied to Food Imaging
K.C. Lim, M.C. Lim, M.A.M. Hanifa, A. Abd. Karim and M.Z. Abdullah

Nature versus Machine in the Challenges of Knowledge-Industry
Abdul Manan Mat Jais

BAFE SESSION V: FOOD ENGINEERING

Regulations for Genetically Modified (GM) Foods: Ethical and Safety Issues
Artemis Karaali

The Strategies for Fat Reduction in Meat Products
Ozlem Tokusoglu and M. Kemal Unal

Separation of Ternary Mixtures with Electronic Nose: Discriminant Function and Neural Network Analysis
Ozlem Tokusoglu and Murat O. Balaban

Human Milk Fat Substitutes from Palm Oil
Nese Sahin and Artemis Karaali

Dynamic Rheological Characteristics of Tomato Puree
Manoj Kulshreshtha, Ang Ai Huey and Wan Mohamad Wan Abdullah

Production of Xanthan Gum from Beet Sugar Molasses
Meral Yilmaz and Kiymet Guven

Freezing Time Prediction for Partially Dried Fruits
C. Ilcici and F. Icier

Development of Rheological Models for Tomato Juice and Puree
Manoj Kulshreshtha, Goh Sok Leng and Wan Mohamad Wan Abdullah

BAFE SESSION VI: BIO-SCIENCE

Production of Lopopeptide Biosurfactant by Indigenous Isolate of Bacillus sp. BMN 14 in a Batch Bioreactor
Liesbetini Hartoto and Djumali Mangunwidjaja

Antimicrobial Activities of Lactic Acid Bacteria Isolated from Turkish Yoghurt
Merih Kivanc, Erdogam Cakir and Meral Yilmaz

Comparison of Different Antisera for Detection of Pseudomonas syringae pv. Phaseolicola
M.Burcin Mutlu and Kiymet Guven

Production of Gallic Acid by Various Molds from Rhus coriaria
Nalan Yilmaz and Merih Kivanc

Occurrence of Bacillus cereus in Milk and Dairy Products Consumed in Eskishir-Turkey
Kiymet Guven and Yasemin Cekic

Microbiological Analysis of Wafers and Biscuits Obtained from Two Different Factories in Eskishir.
Seda Ercan Akkaya and Merih Kivanc

Isolation of Listeria monocytogenes from Vegetable in Eskisehir (Turkey)
Merih Kivanc and Nermin Ozbasaran
BAFE SESSION VII: MODELING IN FOOD ENGINEERING

Modeling and Experimental Study of Keropok Lekor Freezing Process
Sergei Y. Spotar, Mohd. Nordin Ibrahim and Nor Amaiza Mohd. Amin

Modeling of Bread Dough Aeration during Mixing
N.L. Chin and G.M. Campbell

Drying Characteristic of Glutinous Rice in Rapid Bin Dryer.
Law Chung Lim, Siti Masrinda Tasirin, Wan Ramli Wan Daud and Cheah Hui Ming

Correlations between Thermal Properties and Sensory Analysis Scores of Commercial Turkish Hazelnut Spreads
Aysë Erkahveci, Beraat Özçelik and Artemis Karzali

Development of a Computer Program for Simultaneous Estimation of Thermal Conductivity and Volumetric Heat Capacity for Solid Foods from Transient Temperature Measurements
Ibrahim O. Mohamed

Model Development: Size Reduction Processes of Malaysian Activated Carbon
Yus Aniza Yusof and Siti Masrinda Tasirin

BAFE SESSION VIII: PROCESS ENGINEERING

Removal of Trash in Sterilized Fruitlets in Palm Oil Mill
Ropandi Mamat and Zulkifli Abd. Rahman

Design of Recycled Packed Bed Bioreactor and Its Application on an Enzymatic Inter-Esterification Process
Budiatman Satiaiwihardja, Purwiyatno Hariyadi and Slamet Budijanto

Fructose Production from Dahlia Tuber Inulin by Immobilized Whole Yeast Cells in a Packed Bed Bioreactor
Djumali Mangunwidjaja, Mulyorini Rahayuningsih and Titi Candra Sunarti

Fluidized Bed Drying and Quality Studies of Starfruit Beverage Powder
Lee Siew Yoong and Faridah Mohd Som

Production of Biodegradable Plastic using Sago Starch and Polystyrene
Noha Mohd. Yahya, Mohd Nordin Ibrahim, and Judy Lau Siew

Corn Grinding: Experimental and Simulation
Sergei Y. Spotar and Wee Choo L’ng

BAFE SESSION IX: AGRICULTURAL MECHANIZATION

Traction and Flotation in Paddy Fields
V.M. Salokhe

Traction Mechanics of a Tracked Vehicle on Peat Terrain
Md. Ataur Rahman and Azmi Yahya

Force Prediction Models for Failure of Wet Clay Soil by Simple Flat Tines.
Desa Ahmad

Optical, Mechanical and Rheological Properties for the Determination of Pisang Mas Banana Ripeness
Wan Ishak Wan Ismail, Muhamad Saufi Mohd Kassim and Lee Boon Huet

Design and Development of Chain Sawcutter End-effector for Oil Palm FFB Harvester Robot
Muhamad Saufi Mohd Kassim, Wan Ishak Wan Ismail and Victor Loh Keen Seong

Problems and Perspectives of the Agricultural Mechanization in the Russian Federation
Vassili M. Drintcha
BAFE SESSION X: BIO-PRODUCTION MACHINERY

Proposed Standard Testing of Farm Machinery in Malaysia
Ooi Ho Seng 283

Dynamic Load Measurement on Rear Axle of Tractor
R. Alimardani, Hossein Mobli and Yousef Abbaspour 289

Design, Development and Calibration of a Three Point Auto Fitch Dynamometer for Agricultural Tractor
A.F. Kheiralla and Azmi Yahya 293

Modeling of Power and Energy Requirement for Positive Draft Implement in Malaysia
A.F. Kheiralla, Azmi Yahya, Mohd Zohadie Bardaie and Wan Ishak Wan Ismail 301

Modeling of Power and Energy Requirement for Negative Draft Implement in Malaysia
A.F. Kheiralla, Azmi Yahya, Mohd Zohadie Bardaie, and Wan Ishak Wan Ismail 311

Mobile Automated 3-Axis Laser Soil Surface Profile Digitiser
Wee Beng Sui, Azmi Yahya, Bambang Sunarjo Suparjo and Isa Othman 319

Design, Development and Calibration of a PTO Shaft Torque Transducer for an Agricultural Tractor
A.F. Kheiralla, Azmi Yahya and T.C. Lai 327

BAFE SESSION XI: PRECISION FARMING

Suitability of 2 DGPS Machine Navigation Systems for Variable Rate Application in Precision Farming
C.W. Chan 335

The Coincidental Pattern in Spatial Nitrogen Fertilization Requirement of Winter Wheat
Mohd Noor, M., J. Rogasik, J. Peltonen, and E. Schnug 341

Field-Scale Variability of Paddy Soil Chemical Properties at Sawah Sempadan Irrigation Compartment, Malaysia

Spatial Variability of Soil Chemical Properties of Large Rice Field in Sawah Sempadan Malaysia
S.M. Eltaib, M.S.M. Amin, A.R.M. Shariff, and M.M. Hanafi 357

Determination of Soil Physical Properties in Lowland Rice Area of Tanjung Karang Irrigation Scheme Malaysia
W. Aimrun, M.S.M. Amin, M.M. Mokhtaruddin and S.M. Eltaib 363

BAFE SESSION XII: BIO-RESOURCE ENGINEERING

An Integrated Approach in Palm Oil Mill Effluent Treatment
Florence Wong Pin Sing and Wong Lin Siong 369

Effectiveness of Some Bio-Engineering Measures in Reducing Soil Erosion and Runoff Sediment
M.S.M. Amin, C.S. Wong and Y.S. Chow 375

Rapid Appraisal Study on the Effect of Agricultural Drainage on River Water Quality: A Malaysian Experience
Normala Hashim, Ayob Katimon and Johan Sohaili 381

Modeling of the Fate and Agrochemical Movement under Controlled Water Table Environment
M.M.A. Hakim, S. Salim and M.S.M. Amin 387

Hydrologic Dynamics of a Drained Peat Basin: Runoff Coefficients and Flow Duration Curves
Ayob Katimon, Lulie Meiling and Ahmad Khairi Abd Wahab 393
ABSTRACT: The ability of *Bacillus* sp BMN 14, an indigenous strain isolated from palm oil contaminated soil, to grow and produce lipopeptide biosurfactant on various sugar (glucose, fructose and sucrose with concentration of 1.0; 2.0; 3.0; 4.0; 5.0 and 6.0 %) was firstly studied on shake flask cultures. Among those various sugar tested, 4.0 % glucose in mineral salts medium supported maximum growth and highest biosurfactant yield. The production of biosurfactant was then investigated in a batch 2-L stirred tank bioreactor at temperature 30°C and pH 6.5-7.0. The highest performance of bioreactor was obtained at an aeration rate of 0.5 vvm. In this process, the maximum biomass of 4.19 g/L, biosurfactant concentration of 0.87 g/L, and lowest surface tension of 28.3 mN/m were obtained.

Key Words: Biosurfactant, Aeration, Batch bioreactor, *Bacillus* sp BMN 14

INTRODUCTION

Biosurfactants are microbially produced compounds that have hydrophobic and hydrophilic moieties and capable to decrease surface and interfacial tension. These compounds have important advantages, such as low toxicity and biodegradable, high specificity, effective physicochemical properties and temperature stability. These biological compounds are grouped as glycolipids, lipopeptides, phospholipids, fatty acids and neutral lipids (Mulligan and Gibbs, 1993). Interest in biosurfactant has increased considerably in recent years, as they are potential candidates for many commercial applications in petroleum, pharmaceuticals and cosmetics, pulp and paper, and food processing industries (Desai and Desai, 1993).

The strain *Bacillus* sp produces different lipopeptides biosurfactant named iturin A, iturin C, bacillomycin D and L, bacillomycin F, mycosubtilin and surfactin. These substances differ mainly by their peptidic moiety (Jacques, et al. 1994). Surfactin, a cyclic lipopeptide produced by *Bacillus subtilis* is one of the most effective biosurfactant known so far. It is capable to lowering the surface tension from 72.0 to 27.9 mN/m at a concentration as low as 0.005 % (Desai and Desai, 1993). Horowitz and Griffin (1991) found that surfactant BL-86 is a mixture of lipopeptides with the mayor components ranging in size from 979 to 1091 daltons with varying in increments of 14 daltons. There are seven amino acids per molecule, while lipid portion is composed of 8 to 9 methylene groups and mixture of linear and branch tail.

Unfortunately, up to now, biosurfactant are unable to compete economically, with the chemically synthesized compounds on the market, due to high production cost. These are primarily due to insufficient bioprocessing, methodology, poor strain productivity and the use of expensive substrates (Fiechter, 1992). In this paper, the production of biosurfactant by an indigenous isolate of *Bacillus* sp. BMN 14 on glucose, fructose and sucrose as substrate are presented. In addition, the effect of aeration rate for the production of biosurfactant in a batch stirred bioreactor was investigated.

METHODOLOGY

*Bacillus* sp. BMN 14 isolated from palm-oil contaminated soil by Richana (1997) and was found to be lipopeptide biosurfactant producing strain. It was maintained at 40°C in nutrient agar, was used in all experiments. The basic mineral salt medium for bacterial growth (Cooper, et al. 1981) modified by Sen, et al. (1997) contained (in g/L): NH₄NO₃ 4.002; MgSO₄. H₂O 0.1972; CaCl₂.2H₂O 0.001; EDTA 0.0017; FeSO₄.7H₂O 0.004; MnSO₄ 0.275; KH₂PO₄ 4. 0827; Na₂HPO₄ 7.12. The inoculum was prepared and cultivated at 37°C and 140 rpm in a shaking incubator for 30 h. The inoculum was added to the cultivation media by the volume ratio of 10.6 % (v/v). The production of biosurfactant was conducted in a 2.0 L Bioreactor (Bioskat M-B. Braun, Germany) at 37°C, pH 6.5-7.0 and agitation rate 200 rpm. The aeration rate was varied on 0.5; 1.0 and 1.5 vvm. The bioreactor was equipped with a collection vessel in its air-exhaust line to trap the foam overflow. Samples of cultivation culture
were taken at 3-6 h intervals for: biomass, biosurfactant, surface tension, and residual sugar determinations. The biomass was determined gravimetrically by the weight of cells (Scragg, 1991; Sheppard and Cooper, 1991). Crude biosurfactant was isolated from the culture broth by acid precipitation and analyzed by HPLC using the method of Juwarkar et al. (1994). Surface tension of the culture broth was measured with Du Nouy tensiometer CSC 70545 (Babu et al., 1994). Residual glucoses were analyzed by dinitro-salicylic acid method of Miller (1959) with modifications.

RESULTS AND DISCUSSION

Effect of Various Sugar on Biosurfactant Production

In order to establish the most suitable carbon source for the production of biosurfactant by Bacillus sp BMN 14 strain, different sugars, i.e. glucose, fructose, sucrose was observed from 1.0 to 6.0 %. The experiments revealed that among three sugars used, glucose seemed to be was the best as a carbon source for growth and biosurfactant production. Among the six concentrations (1.0; 2.0; 3.0; 4.0; 5.0; and 6.0 %) tried, a 4.0 % was found to be the optimum for the cell growth as well as biosurfactant production. At glucose concentration of 4.0 %, the highest biomass and biosurfactant, the maximum specific growth, and lowest surface tension obtained were 6.35 g/l, 2.23 g/l, 0.065 h⁻¹ and 29.0 mN/m, respectively. The bacterial growth was observed at 30 h cultivation (Table I).

Table 1. Cultivation parameters for the biosurfactant production by Bacillus sp. BMN 14 using glucose as a carbon source.

<table>
<thead>
<tr>
<th>Glucose (%)</th>
<th>Biomass (g/l)</th>
<th>Surface Tension (mN/m)</th>
<th>Biosurfactant (g/l)</th>
<th>µ max. (h⁻¹)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>3.56</td>
<td>30.8</td>
<td>1.24</td>
<td>0.046</td>
</tr>
<tr>
<td>2</td>
<td>4.10</td>
<td>29.9</td>
<td>1.33</td>
<td>0.049</td>
</tr>
<tr>
<td>3</td>
<td>5.79</td>
<td>30.2</td>
<td>2.02</td>
<td>0.063</td>
</tr>
<tr>
<td>4</td>
<td>6.35</td>
<td>29.0</td>
<td>2.23</td>
<td>0.065</td>
</tr>
<tr>
<td>5</td>
<td>5.70</td>
<td>30.2</td>
<td>1.57</td>
<td>0.063</td>
</tr>
<tr>
<td>6</td>
<td>5.46</td>
<td>31.8</td>
<td>1.45</td>
<td>0.061</td>
</tr>
</tbody>
</table>

Table 2 shows the effect of fructose as carbon source on the bacterial growth and biosurfactant production. As shown in this table, the maximum growth rate (0.062 h⁻¹) and highest biosurfactant (1.48 g/L) were obtained when 3.0% fructose used as a carbon source. In this condition, the lowest surface tension of 29.4 mN/m was observed.

Table 2. Cultivation parameters for the biosurfactant production by Bacillus sp. BMN 14 using fructose as a carbon source.

<table>
<thead>
<tr>
<th>Fructose (%)</th>
<th>Biomass (g/l)</th>
<th>Surface Tension (mN/m)</th>
<th>Biosurfactant (g/l)</th>
<th>µ max. (h⁻¹)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>4.10</td>
<td>30.8</td>
<td>1.33</td>
<td>0.058</td>
</tr>
<tr>
<td>2</td>
<td>4.86</td>
<td>29.0</td>
<td>1.58</td>
<td>0.062</td>
</tr>
<tr>
<td>3</td>
<td>5.79</td>
<td>30.2</td>
<td>2.02</td>
<td>0.063</td>
</tr>
<tr>
<td>4</td>
<td>6.35</td>
<td>31.1</td>
<td>2.23</td>
<td>0.065</td>
</tr>
<tr>
<td>5</td>
<td>5.70</td>
<td>30.2</td>
<td>1.57</td>
<td>0.063</td>
</tr>
<tr>
<td>6</td>
<td>5.46</td>
<td>31.8</td>
<td>1.45</td>
<td>0.061</td>
</tr>
</tbody>
</table>

To investigate the possible utilization of sucrose for biosurfactant production the carbon source of medium was replaced by sucrose varied from 1.0 to 6.0 % (Table 3). From the results of the Table 3, 4.86 g/L dry biomass, 1.58 g/L biosurfactant, the growth rate of 0.062 h⁻¹ and lowest surface tension of 29.0 mN/m were observed from cultivation media containing 2.0% of sucrose. The results obtained revealed the importance contribution of glucose as carbon source for the production biosurfactants.

Table 3. Cultivation parameters for the biosurfactant production by Bacillus sp. BMN 14 using sucrose as a carbon source.

<table>
<thead>
<tr>
<th>Sucrose (%)</th>
<th>Biomass (g/l)</th>
<th>Surface Tension (mN/m)</th>
<th>Biosurfactant (g/l)</th>
<th>µ max. (h⁻¹)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>3.42</td>
<td>30.4</td>
<td>1.40</td>
<td>0.046</td>
</tr>
<tr>
<td>2</td>
<td>4.86</td>
<td>29.0</td>
<td>1.58</td>
<td>0.062</td>
</tr>
<tr>
<td>3</td>
<td>5.79</td>
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<td>4</td>
<td>6.35</td>
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<td>0.065</td>
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<td>5</td>
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<tr>
<td>6</td>
<td>5.46</td>
<td>31.8</td>
<td>1.45</td>
<td>0.061</td>
</tr>
</tbody>
</table>

Production of Biosurfactant in a Batch Bioreactor

The cultures obtained under optimal carbon source were then tested to produce biosurfactant in different aeration rate. The process was conducted in a 2.0 L batch stirred bioreactor (working volume 1.3 L) at 37°C, agitation rate 200 rpm, and pH 6.5-7.0. An agitation rate of 200 rpm was selected since high biosurfactant yield was achieved at this rate. The agitation rate of 0.5; 1.0; and 1.5 vvm were applied.
The pattern of biomass and biosurfactant production, surface tension and residual sugar depicted in Figure 1, 2, 3 and 4. The highest biomass, biosurfactant, the maximum specific growth, and lowest surface tension at 0.5 vvm were 4.19 g/l, 0.87 g/l, 0.07 h\(^{-1}\) and 28.3 mN/m, respectively.

The best yield of biosurfactant was obtained using 0.5 vvm aeration rate compared higher aeration rate. This suggest that biosurfactant formation by the cells under different degrees of aeration was best under low aeration rate or oxygen limitation. It led to speculate that the high aeration rate promoted foam production in short time.
The best yield of biosurfactant was obtained in a batch stirred bioreactor at 37°C, pH 6.5-7.0, agitation rate of 200 rpm and aeration rate of 0.5vvm. In this process, the maximum growth rate of 0.07 h⁻¹ and biosurfactant yield of 0.87 g/L and the lowest surface tension of 28.3 mN/m were obtained.

Cultivation parameters for the production of biosurfactant by *Bacillus* sp. BMN 14 with various aeration rate is presented in Table 4.

The significant amount of biosurfactant began to appear in the culture broth could be observed after 12 h cultivation, and increased during the exponential growth phase to 0.9 g/L, and then decreased after the onset of stationary growth phase (Figure 1 and 2). The result led to suggest that biosurfactant produced by *Bacillus* sp BMN 14 strain was synthesized during the exponential growth phase. It was also supported the parallel relationship between bacterial growth and surface tension of culture broth (Figure 3). From this result, we concluded that fermentative production of biosurfactant by *Bacillus* sp BMN 14 strain was found to be growth-associated.

The main technical problem in the production of extracellular biosurfactant under aerobic condition is the extensive formation of foam. The increase of foam production resulted in overflow of culture broth through the air exhaust line and decrease the culture broth volume (Kim et al., 1997). During our experiments, it was observed that biosurfactant were the main composition of the foam.

### CONCLUSION

The study revealed that the optimal glucose concentration was 4.0%, while above 4.0% there is an effect of substrate inhibition which was indicated by the decrease of maximum specific growth rate. Compared to other sugar (fructose and sucrose), glucose was the best carbon source for growth and biosurfactant production by an indigenous *Bacillus* sp. BMN 14 strain.

### ACKNOWLEDGEMENT

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FRUCTOSE PRODUCTION FROM DAHLIA TUBER INULIN BY 
IMMOBILIZED WHOLE YEAST CELLS IN A PACKED BED BIOREACTOR

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ABSTRACT. At present, fructose is commonly produced from starch by the multi-step processes including hydrolysis into glucose followed by the treatment with isomerase and the chromatographic separation of fructose and glucose. In the present work, an alternative process for producing fructose from inulin was investigated. An immobilized biocatalyst with inulinase activity prepared by immobilization of non-growing whole yeast cells was tested in a packed-bed bioreactor for continuous fructose production from dahlia tuber inulin. The free whole cells was used for batch inulin conversion in a 2.0 L stirred reactor at substrate concentration of 25-200 g.L⁻¹, pH 5.0 and temperature 50°C for 10 h. The maximum conversion of 72.4% was obtained from a cultivation containing 125 g.L⁻¹ substrate after 6 h. In the second study, the whole yeast cells was immobilized in calcium alginate beads and used for the production at 50°C and pH 5.0. The optimal gel concentration and cell load were determined. The dilution rate of inulin solution (125 g.L⁻¹) was varied from 0.08 to 0.30 h⁻¹. The reactor performance was found to be highest at a dilution rate of 0.20 h⁻¹. In this process, the yield of 109.12 g.L⁻¹ fructose, conversion degree of 87.3% and reactor productivity of 21.83 g.L⁻¹.h⁻¹ were obtained, respectively. This bioreactor productivity is noticeably higher than that previously reported. The continuous process was then operated a period of 200 h. However, a good stability of process was achieved during the first 100 h.

INTRODUCTION

Fructose syrups are widely used in the food industry. It is an interesting sweetener because of its high sweetening power. Moreover, fructose is claimed to be less cariogenic than other sugars and to be more suitable for diabetics since its metabolism is insulin-non-dependent (Barker and Petch, 1985). Pure fructose, obtained by crystallizing from very high fructose syrups, is used in the pharmaceutical industry as an intravenous nutrient, in the production of the low calorie sweetener (Linden, 1994), and as a sugar source for the production of biosurfactant: fructose-esters (Seino and Uchibori, 1994).

At present, fructose is commonly produced from starch by the multi-step processes including hydrolysis into glucose followed by the treatment with isomerase and the chromatographic separation of fructose and glucose, or by the isomerization of a corn glucose syrup. From these processes, syrups containing 42% of glucose was obtained. Their fructose content can be increased up to 95% by chromatographic separation and subsequent recycling of the glucose component.

Because of their high content of fructose, inulin is an interesting substrate from which to produce fructose (Vandamme and Derycke, 1983). Inulin is composed of β(2-1) linked d-fructose residues, forming linear chains containing one terminal glucose residue on α(1-2) fructose chain (Groot-Wassink and Fleming, 1980). Inulin as a reserve carbohydrate, found in the roots and tubers of various plants of the family Compositae and Asteraceae, like Jerusalem artichoke, chicory, dahlia, and dandelion (Vandamme and Derycke, 1983). For several reasons, there is strong interest in tropical regions, like Indonesia or Malaysia in growing dahlia than the others three crops. Many dahlia cultivars are available and have been easily propagated and cultivated yielding satisfactory tubers. Furthermore, dahlia has no common diseases. Dahlia, therefore, can be considered as a promising inulin crops in tropical regions. (Anonymous, 2001). Although inulin is readily hydrolyzed by acid, pH 1 - 2 at 80-100°C, there are disadvantages on their use: undesirable colored and flavored materials in the form of anhydride. Enzymatic hydrolysis, therefore, may be the solution as it has no such problems (Barthomeuf et al, 1991; Mangunwidjaja, 1997).

Inulin hydrolyzing enzyme - inulinase (2.1 β-D-fructanohydrolase EC 3.2.1.7) have been extracted from roots and tubers of plants of family Asteraceae (Rutherford and Deacon, 1972), and from various fungi (Xiao et al, 1989; Barthomeuf et al, 1991) bacteria (Allais et al, 1986, 1987), and yeasts (Margarithis and Bajpai, 1982). Several yeast species, notably Kluyveromyces fragilis and K. marxianus have been reported as potential inulinase producer (Duvniak et al, 1981).
We have examined processes for the preparation of high fructose syrups from the dahlia inulin by using commercial inulinase enzyme (Novozym 230) and crude inulinase extract from Kluyveromyces culture broth. (Sunarti, et al 1994, Mangunwidjaja et al, 1994). Several studies have been elaborated to produce high fructose syrups from Jerusalem artichoke by yeasts fermentation (Giraud and Galzy,1990; Fontana, et al 1994.)

Although it has been showed that the enzyme biocatalyst are adequate from the technical point of view, their cost is high mainly due to the purification and pp cost. In order to reduce their cost, the purification may be avoided and the immobilization procedure simplified using whole cells (Gomez et al, 1994). Immobilization of enzyme on whole-microbial cells or nongrowing microbial cells represents in effective way of producing highly different enzyme catalysts applicable in many process of great industrial significance (Hasal, et al, 1992a,b).

In this paper, the intracellular inulinase activity of Kluyveromyces marxianus whole cells was investigated, and utilized for the production of ultra high fructose syrups from dahlia tuber inulin in a packed-bed bioreactor.

**MATERIALS AND METHODS**

**Chemicals**

Inulin, D-glucose, D-fructose used were of analytical grade and purchased from Sigma, Co. Other chemicals were of reagent grade and were purchased from local sources. Alginate (Sigma) used was a medium viscosity grade. Enzyme stock (Novozyme 230) was obtained from NOVO Indonesia branch (Jakarta, Indonesia). Dahlia (Dahlia pinnata Cav) inulin was extracted from tubers by hot water extraction and sedimented to 9% dry matter using the method described by Rahayuningsih (1995) with modifications.

**Microorganism and growth conditions**

*Kluyveromyces marxianus* was obtained from Laboratoire de Biochimie microbienne, Universite Henri Poincare, Nancy, France. The medium for the cell cultivation was composed of (g.L⁻¹) : Dahlia inulin 20; bacto peptone 10; Medium without inulin was autoclaved at 105 °C for 30 minet. Inulin was sterilized separately and was added to the medium. The pH was adjusted to 7.0 prior sterilization. Pre-inoculum was prepared from the slant stock by inoculating 100 ml medium in 500 ml Erlenmeyer flask shaker at 300 rpm, 30°C, for 10-15 h. The cultivation was carried out in a 2.0 L bioreactor (Biostat M- Braun, Germany) with working volume of 1.5 L. The temperature was maintained at 30 °C with a thermostat; aeration and agitation were controlled at 1.0 vvm and 300 rpm. Culture growth was monitored by determining the dry weight of the biomass. Samples were taken at 8 h intervals for enzyme assays. The culture was harvested at the end of exponential growth phase (60 h) and used for immobilization.

**Inulinase assay**

The intracellular inulinase activity was determined by the method developed by Groot-Wassink dan Fleming (1980) with a modification (Mangunwidjaja, 1997). The 0.5 mL samples taken for enzyme activity measurements were centrifuged immediately at 5,000 g at 5 °C for 5 min., and the pellets were washed twice with and then suspended in 0.5 ml of 0.1 M sodium acetate buffer (pH 5.0) Samples (0.5 mL) and 0.05 µl of 0.02 % fresh lyozyme solution were homogenized and then incubated at a shaker flask (200 rpm) at 35°C for 4 h. The slurries were further centrifuged at 5,000 g (4°C) for 5 min. The pellets were suspended in 0.5 ml of 0.1 M acetic acid buffer (pH 5.0) was incubated at 50°C for 30 min. The total reducing sugar released was determined by 3,5 dinitrosaliclylic acid method (Miller, 1959) using fructose as a standard. One unit of inulase activity was calculated as 1.0 µ mol of fructose produced by 1.0 g. min⁻¹ under the assay condition.

**Preparation of cell immobilization**

The immobilization technique used was entrapment. The cell pellet obtained after harvesting was resuspended in 0.1 M acetate buffer (pH 5.0). An equal amount of cell suspension of known weight of cells and sodium alginate solution (2.0 %) prepared using the same buffer were mixed with slow agitation. The formation of gel beads was obtained by replacing the sodium ions with calcium ions (1.0 %). Different cell and bead ratios was prepared from 0.05 to 0.25 by varying cell concentration (Mangunwidjaja et al, 1994 with modification) The beads were allowed to gel in the calcium chloride solution for 30 min. and then dried on a paper towel for 2 h at room temperature. The alginate beads were then stored at 4°C.

**Packed Bed Bioreactor Design**

The continuous fructose production was performed in a packed bed bioreactor which was 410 mm tall, 60 mm internal diameter, and had a working volume of 850 ml (Figure 1) The sterilized medium was introduced to the column containing biocatalyst gel beads via a peristaltic pump. The working temperature was maintained at 50 °C by circulating water from a thermostat through a column jacket. The effluent was collected from the outlet pipe in
The batch process was conducted in a 2.0 L stirred bioreactor (with working volume of 1.50 L) (Biostat-Braun, Germany). The pH and temperature were adjusted to 5.0 with H₂SO₄, and to 50°C, respectively. To 1.2 L of inulin solution (varied from 25 to 200 g.L⁻¹) in the bioreactor were added 4% (w/v) of biocatalyst.

![Figure 1: Schematic diagram of the packed bed bioreactor for the production of fructose from inulin using whole cells of Kluyveromyces marxianus](image)

Figure 1: Schematic diagram of the packed bed bioreactor for the production of fructose from inulin using whole cells of *Kluyveromyces marxianus*.

**Analytical Methods**

The biomass was determined by the dry weight technique. Residual inulin in culture broth was determined by using the method of Kiersan (1978). Fructose was determined as reducing sugars following 3,5 dinitro salicylic acid hydrolysis (Miller, 1959). Protein was estimated according to Lowry et al. (1951) using bovine serum albumin as a standard.

**RESULTS AND DISCUSSION**

**Yeast Growth and Intracellular Inulinase Activity**

From the previous works, it was observed that *K. fragilis* and *K. marxianus* among strains were consistently highest inulinase producers (Groot Wassink dan Fleming, 1980; Mangunwidjaja *et al.*, 1994, Sunarti *et al.*, 1994). To obtain a biocatalyst having high intracellular inulinase, the intracellular inulinase activity of *K. marxianus* was investigated during the growth. In our previous studies, we noticed that during 48 h *K. fragilis* cultivation on either synthetic medium (10 g.L⁻¹ glucose) or inulin medium, the extracellular inulinase activity was detected in early growth phase and increased related with the biomass (i.e growth-associated) and reached a maximum after 10 h or exponential growth phase. Meanwhile, the intracellular inulinase activity could be observed in the early stationary phase of growth which increased in time and achieved a maximum at the stationary phase (Mangunwidjaja, 1999).

![Figure 2: Growth and inulinase production by *K. marxianus* on inulin medium( 20 g.L⁻¹) ( preparations)](image)

Figure 2: Growth and inulinase production by *K. marxianus* on inulin medium (20 g.L⁻¹) (residual inulin, < biomass, > inulinase activity in culture broth • intracellular inulinase activity).

The intracellular and extracellular activity of *K. marxianus* observed during 60 h cultures showed that the cells incubated at 50°C have the highest value of 200 Unit.g⁻¹ in 12 h and 1 Unit.g⁻¹ in 36 h, respectively (Figure 2).

The result confirmed the possibility of using whole cells containing intracellular inulinase activity for hydrolyzing inulin to fructose. The immobilization conditions and procedures for *K. marxianus* whole cells have been described in our previous work (Mangunwidjaja, 1999), showed that the highest activity was obtained at the highest cell load. However at the cell – bead ratio higher than 0.15 or cell concentration of 6.0 g.L⁻¹ inulinase activity was reduced. In addition, the maximum inulinase activity was obtained when cells were entrapped in 2% (w/v) calcium alginate at 50°C, and pH 45-50°C.

Therefore, in the present work, the experiments were carried out using the biocatalyst composed of 6.0 dry biomass, L⁻¹ gel, at 50°C and pH 5.0.

**Fructose Production in Batch Bioreactor**

The immobilized cells prepared under optimal conditions were then used to hydrolize dahila inulin solution. Several experiments were carried out at 50°C, pH 5.0 and a agitation rate of 60 rpm. The initial substrate...
The concentration was varied from 25 to 200 g L\(^{-1}\). The inulin conversion rate was determined by measuring the amount of fructose produced by 4\% (w/v) of biocatalyst in 100 mL of dahlia inulin solution after 6 h. As shown in Figure 3 the highest conversion rate of 17.4 and 15.08 g fructose L\(^{-1}\)h\(^{-1}\) was obtained, by using free and immobilized biocatalysts, respectively from substrate at concentration 125 – 150 g L\(^{-1}\). For the substrate concentration higher than 150 g L\(^{-1}\), the conversion rate decreased to 9.2 and 4.1 g fructose L\(^{-1}\)h\(^{-1}\).

Based on the above results, a batch process was then conducted in a 2.0 L stirred bioreactor (with 1.5 L working volume). The substrate and biocatalyst concentrations were 125 g L\(^{-1}\) and 4\% (w/v), respectively. The amount of inulin was converted predominantly during the initial state of the reaction, and reached maximum after 6 h. In this process, the yield of 90.5 g L\(^{-1}\) fructose or 72.4\% conversion was obtained. The bioreactor productivity was calculated to be 15.08 g L\(^{-1}\)h\(^{-1}\).

The present work offers a significant improvement over those previously reported using immobilized cells of \(K\). marxiana whole cells was conducted in a 1.0 L packed-bed bioreactor (with working volume 0.850 L). Figure 1, at 50\(^{\circ}\)C and pH 5.0. The feed flow rate of inulin solution (125 g L\(^{-1}\)) was varied from 0.068 to 0.255 L h\(^{-1}\). At steady state condition achieved after 3-6 h operation, the production of fructose was determined.

The continuous production of fructose from dahlia inulin solution using immobilized non-growing \(K\). marxiana whole cells was conducted in a 1.0 L packed-bed bioreactor (with working volume 0.850 L). Figure 1, at 50\(^{\circ}\)C and pH 5.0. The feed flow rate of inulin solution (125 g L\(^{-1}\)) was varied from 0.068 to 0.255 L h\(^{-1}\). At steady state condition achieved after 3-6 h operation, the production of fructose was determined.

The continuous production of fructose from dahlia inulin solution using immobilized non-growing \(K\). marxiana whole cells was conducted in a 1.0 L packed-bed bioreactor (with working volume 0.850 L). Figure 1, at 50\(^{\circ}\)C and pH 5.0. The feed flow rate of inulin solution (125 g L\(^{-1}\)) was varied from 0.068 to 0.255 L h\(^{-1}\). At steady state condition achieved after 3-6 h operation, the production of fructose was determined.

Table 1: Fructose yield, inulin conversion and bioreactor productivity at different substrate flow rate on hydrolysis of dahlia inulin (125 g L\(^{-1}\)) in a packed-bed bioreactor.

<table>
<thead>
<tr>
<th>Substrate flow rate (L.h(^{-1}))</th>
<th>Fructose yield (g.L(^{-1}))</th>
<th>Inulin conversion (%)</th>
<th>Bioreactor productivity (g.L.h(^{-1}))</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.08</td>
<td>28.12</td>
<td>22.5</td>
<td>5.62</td>
</tr>
<tr>
<td>0.12</td>
<td>30.00</td>
<td>34.0</td>
<td>6.00</td>
</tr>
<tr>
<td>0.16</td>
<td>80.00</td>
<td>62.4</td>
<td>16.00</td>
</tr>
<tr>
<td>0.20</td>
<td>109.13</td>
<td>87.3</td>
<td>21.83</td>
</tr>
<tr>
<td>0.24</td>
<td>51.50</td>
<td>41.2</td>
<td>10.30</td>
</tr>
<tr>
<td>0.30</td>
<td>48.75</td>
<td>39.0</td>
<td>9.75</td>
</tr>
</tbody>
</table>

The inulin conversion and bioreactor productivity as a function of substrate flow rate is presented in Table 1, and it can be observed that the conversion increased with increase in substrate flowrate. The highest conversion of 87.3\% was obtained at a flow rate of 0.170 L h\(^{-1}\). Based on the results, the bioreactor was then run for longer time to test the biocatalyst stability.

Operational Stability

The stability of the inulinase activity of the biocatalyst was examined in a continuous packed-bed bioreactor at constant substrate flowrate (0.170 L h\(^{-1}\)) at 50\(^{\circ}\)C, pH 5.0 and constant inlet inulin concentration (125 g L\(^{-1}\)). The total duration of the trial was 200 h. The result is presented in Figure 4.
The initial value of the conversion was 87%. The result indicated that a good stability of continuous operation was achieved during the first 100 h. After that time, the inulin conversion decreased drastically with increasing operation time to 8.2%. The bioreactor productivity has also reduced from 21.83 to 2.05 g fructose L⁻¹ h⁻¹.

The drastic reduction of biocatalyst activity probably due to the thermal inactivation of the enzyme because cell must be maintained at high temperature (50 °C) for long run operation, and due to the mechanical abrasion of beads (Kim et al 1982). Therefore, alternatives immobilizing gels like carrageenan, chitosan are proposed. In addition, stabilizing treatments of the immobilized whole cells preparation by covering the beads with hardening reagents, i.e. glutaraldehyde, hexamethylene diamine, and polyethylene are also considered (Santoyo et al, 1998, Dobreva et al, 1998).

CONCLUSION

The experiments summarized in this paper showed that the biocatalyst with inulinase activity prepared by immobilization of whole cells of K. marxianus can be utilized in a continuous packed-bed bioreactor for the production of fructose from dahlia inulin.

In a continuous process using the biocatalyst, a conversion rate as high as 87% was achieved at a substrate (125 g L⁻¹) of 0.170 L h⁻¹. Bioreactor productivity was obtained up to 21.83 g fructose L⁻¹ h⁻¹, and a good stability of operation was achieved for a period of 100 – 120 h.

Due to the low cost of the immobilization procedure, production of ultra high fructose syrups from dahlia inulin by means of the biocatalyst promises to be economically very attractive.

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