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Nutritional and technological quality of bread enriched with an intermediated pearled wheat fraction

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UNIVERSITÀ DEGLI STUDI DI TORINO

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1. Introduction

The consumption of whole grains, which are rich in dietary fibre (DF), vitamins, minerals and bioactive compounds, has been reported to offer many health benefits and help to reduce the incidence of several diseases. The regular consumption of whole-grain foods reduces coronary heart disease rates and several forms of cancer and helps to regulate the blood glucose level (Slavin, Jacobs, Marquart & Wiemer, 2001). Moreover, several phytochemicals of wheat grain, such as phenolic compounds and alkylresorcinols (AR), have been reported to exert antioxidant and anti-inflammatory effects (Anson et al., 2011). However, consumers' acceptance of whole grain foods is limited, due to their lower volume and coarser texture than refined ones (Zhang & Moore, 1999); thus, refined white bread remains the most commonly consumed type of bread.

The replacement of refined flour with a percentage of bran fractions, obtained during the roller milling process, is actually the main way of increasing the bioactive compound concentration in wheat flour and the derived products (Noort, van Haaster, Hemery, Schols & Hamer, 2010). Bran is a kernel fraction that contains the external kernel layers, in addition to hyaline and aleuronic layers rich in DF, phenolic compounds and ARs and shows high antioxidant properties (Beta, Nam, Dexter & Sapirstein, 2005). Nevertheless, the use of wheat bran in wheat flour for bread-making also results in changes in the dough properties, processing techniques and bread quality characteristics (lower volume, darker crust and denser crumb texture) (De Kock, Taylor & Taylor, 1999; Noort et al., 2010). Pre-treatments of bran, such as pre-hydration, fermentation or heat treatments, can be employed to modify its structure and composition, in order to enhance the bio-accessibility of nutritional compounds and minimize the negative effects related to dough rheology and bread volume (Nelles, Randall, & Taylor, 1998; de Kock et al., 1999). The addition of gluten or the use of surfactants and enzyme in the bread formula could partially

1 compensate the negative effects of bran replacement on the bread-making performance
2 and bread quality (Sanz Penella, Collar & Haros, 2008).

3 Another concern regarding the use of bran to partially replace refined flour is that this by-
4 product is the wheat fraction, that is most contaminated by mycotoxins, or heavy metals
5 and pesticides (Cheli et al., 2010). Among mycotoxins, deoxynivalenol (DON), that
6 belongs to type-B trichothecenes and that could contaminated wheat kernel and cereal
7 products, is associated with serious mycotoxicosis in humans and animals since it inhibits
8 protein biosynthesis (Bottalico & Perrone, 2002). The present EU admissible maximum
9 levels for DON are $1250 \mu\text{g kg}^{-1}$, $750 \mu\text{g kg}^{-1}$ and $500 \mu\text{g kg}^{-1}$ for unprocessed wheat
10 kernel, wheat flour or bran and bread, respectively (EC 2006),

11 An alternative strategy to maximize the health benefits of wheat-based products, and avoid
12 the defects derived from the use of whole grain or bran, could be to enrich refined flour
13 with fractions of external kernel layers, obtained using grain fractionation technologies in
14 order to separate the negative and positive elements (Delcour, Rouau, Courtin, Poutanen
15 & Ranieri, 2012). Among the fractionation processes, sequential pearling has provided
16 interesting results: the degree of pearling could efficiently be modulated to separate the
17 external bran fractions, which are characterized by a safety risk and coarse fibre, from the
18 fractions with potential high health benefits (Sovrani et al., 2012). Thus, an intermediate
19 wheat kernel pearled fraction could be used as a functional ingredient in order to enrich
20 wheat-based products in bioactive compounds but also to the risks associated with the use
21 of bran layers. In this work, a pearled fraction was chosen in order to offer the best
22 compromise between high nutritional value and low contamination risk. The first external
23 fraction (8% of kernel weight) was separated and the fraction resulting from a second
24 pearling (another 8% of kernel weight) was used for bread-making.

25 The aim of the study was to determine the effect of replacing refined white wheat flour with

1 increasing percentages of the selected pearled wheat fraction on the content of the
2 bioactive compounds and the antioxidant activity of composite bread. Moreover, in order to
3 analyze the impact of the wheat fractions derived from sequential pearling in the bread-
4 making process, the effect of their refined flour replacement on the dough rheological
5 parameters, DON contamination and the technological properties of composite bread has
6 been investigated.

7

1 **2. Materials and methods**

2 **2.1 Wheat grain pearling**

3 The Taylor winter wheat variety, classified as an improver on the basis of the Synthetic
4 Index of Quality method for the quality classification of common wheat (Foca et al., 2007),
5 was used. The pearling process consisted of an abrasive action on the wheat and pearled
6 wheat in an abrasive-type grain testing mill (TM-05C model, Satake, Tokyo, Japan) at a
7 constant speed of 55 Hz. The pearling process was monitored by means of time control.
8 After each pearling passage, the laboratory pearler was thoroughly cleaned with dust
9 aspiration and compressed air, to minimize equipment contamination.

10 The most appropriate pearled fraction was selected on the basis of results obtained in a
11 previous work (Sovrani et al., 2012). Starting from unprocessed grain, kernels were initially
12 pearled to remove 8% of the original grain weight and this most external fraction was
13 discarded. The remaining kernels were then pearled to remove a second 8% fraction of
14 the original grain weight (8-16%) and this fraction, presumably containing the aleurone
15 layer (Sovrani et al., 2012; Laca Mousia, Diaz, Webb & Pandiella, 2006), was used to
16 replace refined commercial flour for bread-making at different percentages.

17 The particle size of the selected pearling fraction resulted similar to that of refined
18 commercial flour: in both cases more than 80% of the particles were distributed within the
19 size range < 200 µm.

20

21

22 **2.2 Bread making procedure**

1 Five mixtures of refined commercial flour for bread-making with an increasing replacement
2 rate (5%, 10%, 15%, 20%, 25%) of the selected pearled wheat fraction were obtained and
3 employed for bread preparation. Refined flour and the selected pearled wheat fractions
4 were accurately mixed using a rotary laboratory blender (Beccaria S.r.l., Cuneo, Italy). The
5 Chopin[®] alveograph parameters of the used commercial refined flour were: deformation
6 energy (W) $325 \text{ J } 10^{-4}$ and curve configuration ratio (P/L) 0.52.

7 The breads were prepared according to the AACC Method 10-10.03 for 3 kg of flour
8 (AACC, 2008). The formula contained salt (2% of flour weight), brewer yeast (3% of flour
9 weight) and the optimal water absorption. The dough was then mixed in a spiral mixer
10 (Esmach[®], Bonpard Group, Vicenza, Italy) for 15 minutes and divided into three pieces of
11 approximately 400 g/piece, to obtain three loaves, which were placed in baking pans (10.5
12 x 6 cm² and 6.5 cm deep). After fermentation (at 30°C and a relative humidity of 85% for
13 120 min), the loaves were baked at 215°C for 45 min.

14 The three composite loaves for each replacement level were used as replicates for
15 chemical and technological analyses.

16

17 2.3. Chemicals

18 The total Dietary Fibre (DF) and Mixed-Linkage β -Glucan kits for enzymatic determinations
19 were supplied by Megazyme (Megazyme International Ireland Ltd, Wicklow, Ireland). The
20 solvents (HPLC or GC grade) and formic acid (50%, LC–MS grade) were purchased from
21 Sigma–Aldrich (Milan, Italy). The water was obtained from Milli-Q instrument (Millipore
22 Corp., Bedford, MA, USA). The antibody-based immunoaffinity columns were supplied by
23 VICAM (Waters Corporation, Watertown, MA, USA). The analytical standards (purity \geq
24 95%) and all the other chemicals (reagent-grade level) were purchased from Sigma–
25 Aldrich (Milan, Italy).

1 300 °C and held for 20 min at 300 °C. H₂ was used as the carrier gas at an inlet pressure
2 of 0.7 bar and with a constant column flow rate of 1.0 mL min⁻¹. The injector and detector
3 temperatures were 250 and 350 °C, respectively. The used apparatus was equipped with
4 a split/splitless injector. Individual compounds (5-*n*-heptadecylresorcinol, 5-*n*-
5 nonadecylresorcinol, 5-*n*-heneicosylresorcinol, 5-*n*-tricosylresorcinol and 5-*n*-
6 pentacosylresorcinol) were quantified against the internal standard by automatically
7 integrating the peak areas. Finally, the results were expressed as the sum of the identified
8 ARs.

9 **2.4.6. DON contamination**

10 The DON content was analysed using a high performance liquid chromatography (HPLC-
11 MS-MS) method (range 80-4000 µg kg⁻¹). The bread was milled using a laboratory
12 centrifugal mill (ZM-100; Retsch, Haan, Germany) with a 1 mm opening. 25 g of milled
13 sample was extracted with 100 mL of water in a blender at a high speed for 30 minutes;
14 the extract was then filtered and collected. Antibody-based immunoaffinity columns (DON
15 testTM WB Columns VICAM) were used for the clean-up of the sample extracts. Before
16 sample loading, the column was conditioned with 1 mL of deionized water. 1 mL of the
17 sample was loaded into the column at a rate of approximately 1-2 drops s⁻¹. The column
18 was washed with 5 mL of distilled water. DON was eluted from the column using 2 mL of
19 methanol. DON was quantified by the injection of 10 µL of diluted eluate into the HPLC-
20 MS-MS system, which consisted of a Varian 212-LC Chromatography Pump and a 310-
21 MS TQ Mass Spectrometer. The analytical column was a reverse Varian Polaris C18-A
22 (100 x 2.00 mm, 3 µm) while the mobile phase was a gradient mixture of methanol and
23 water fed at a flow rate of 0.2 mL/min. The DON retention time was 4.1 min with a runtime
24 of 13 min. Mass spectrometric analyses were performed in the negative ion mode. The
25 nebulising gas was N₂ (20 psi), the drying gas was air (300 °C, 25 psi), the needle voltage

1 was -4500 V, the shield voltage was -600 V, the detector voltage was 1650 V, the capillary
2 voltage was -60 V and the collision energy voltage was 16 V. The deprotonated molecule
3 ($m/z = 295$) was fragmented to its product ion ($m/z = 265$) and used for quantification
4 purposes. The deprotonated molecule ($m/z = 295$) was fragmented to its product ion (m/z
5 $= 138$) and used for identification purposes.

6 The percentage of recovery, obtained using a Certified Reference Materials (CRM Trilogy[®]
7 Analytical Laboratory, $2.1 \text{ mg kg}^{-1} \pm 0.2 \text{ mg kg}^{-1}$) was 79% (Relative Standard Deviation =
8 6%). The limit of detection (LOD) and the limit of quantification (LOQ) were $5 \text{ } \mu\text{g kg}^{-1}$ and
9 $16 \text{ } \mu\text{g kg}^{-1}$, respectively.

10

11 2.5 Technological quality analyses

12 2.5.1. Rheological properties of the flour

13 The mixing and pasting behaviours of the control and different replaced flours was studied
14 using a Mixolab[®] analyser (Chopin Technologies, Paris, France), according to the ICC
15 Standard Method 173 (ICC, 2010). The instrument allows specific information to be
16 obtained about the behaviour of flour constituents (starch, protein, water) by continuously
17 measuring the torque (Nm) produced by the passage of the dough between two kneading
18 arms submitted to both shear stress and a temperature constraint. The resulting Mixolab[®]
19 curve is separated into five different stages. A detailed description of the physical changes
20 that occur during a Mixolab measurement has been reported in Rosell, Collar & Haros
21 (2007). The key parameters derived from the Mixolab curve are water absorption (g kg^{-1}),
22 or percentage of water required for the dough to produce a torque (peak C1) of 1.1 Nm,
23 Dough Development Time (DDT, min), or the time necessary to reach the maximum
24 torque (C1) at 30°C, dough stability, protein weakening i.e. decrease in dough consistency
25 due to shear and temperature stress (C2, Nm), starch gelatinization i.e. the starch

1 granules absorb water and this results in an increase in viscosity (C3, Nm), amylase
2 activity (C4, Nm) and starch gelling (C5, Nm).

3 **2.5.2. Crust color**

4 The chromatic characteristics of the bread crust were determined using a Minolta Chroma
5 Meter (Model CR-400, Minolta Co., Osaka, Japan) reflectance spectrophotometer.
6 Standard illuminant C was used as the reference. The analysis was performed in triplicate
7 at 3 different point for each loaf. The color values of L*, a*, b*, C and h* were determined
8 directly by the instrument in accordance with Commission Internationale de L'Eclairage
9 (1986).

10

11 **2.5.3. Combined acoustic-mechanical analysis of the bread crust**

12 A penetration test was carried out to assess the mechanical and acoustic properties of the
13 bread crust, using a TA-XT Plus Texture Analyzer (SMS-Stable Micro Systems, Surrey,
14 UK), combined with an AED Acoustic Envelope Detector supplied by from the same
15 manufacturer. Force and acoustic emission acquisitions of were made simultaneously
16 using the Texture Exponent software (Stable Micro Systems), with a data rate of 500
17 points per second during a compression/penetration test (Piazza, Gigli & Ballabio, 2007).
18 Each loaf was penetrated by a P/6 6-mm steel cylindrical probe, a deformation of 20 mm
19 was applied with a test speed of 1 mm s^{-1} and an instrumental trigger of 0.05 N was used.
20 The microphone was placed at a fixed distance of 10 mm from the sample for the acoustic
21 measurements. In order to minimize the noise, the acoustic measurements were filtered
22 through an integrated 1-kHz high pass filter, and a 24 dB instrumental gain was applied.
23 The analysis was performed in triplicate at 3 different points for each loaf. The following
24 mechanical and acoustic parameters were determined from the force-distance and
25 acoustic spectra according to Piazza et al. (2007) and Chen, Karlsson & Povey (2005).

1 Total energy (mJ), the maximum acoustic emission, (dB (SPL)), the acoustic emission
2 peak average (dB (SPL)) using two different threshold values of 5 and 15 dB (SPL),
3 respectively, during data integration, in order to discriminate between the total and "high"
4 acoustic emission peaks (Rolle, Giacosa, Torchio & Río Segade, 2012).

5

6 **2.5.4. Bread volume**

7 Loaf volume was determined 1 h after baking, by means of a rapeseed displacement
8 method, AACC Standard 10-05 (AACC, 2008).

9

10 **2.5.5. Breadcrumb texture profile analysis**

11 Texture measurements were performed on two slices (20 mm thick), cut out from the
12 central part of the three replicated loaves for each mixture of refined flour and pearled
13 fraction, 4 h after baking. On average, six measurements per slice were made. The bread
14 slices were compressed in the central area using a SMS P/35 flat probe (Stable Micro
15 Systems) for a 50% deformation of the slice (Wang, Rosell & Benedito de Barber, 2002)
16 with a waiting time between the two bites of 30 seconds, using 1 mm s^{-1} as the speed test
17 (Caballero, Gómez & Rosell, 2007). An instrumental trigger of 0.05 N was applied. The
18 typical texture profile analysis parameters were determined from the Force-Distances
19 curves and calculated by the software: hardness (N), cohesiveness (adimensional),
20 gumminess (N), springiness (mm), chewiness (mJ), and resilience (adimensional) (Fik &
21 Surówka, 2002).

22

23 **2.6. Statistical analysis**

1 The results of the chemical and technological analyses are reported as the means of the
2 three loaf replicates, with the exception of the Mixolab[®] analyses, which was only
3 performed on one replicate for each dough replaced mixture, according with the quantity of
4 sample available and required by the analyses.

5 The analysis of variance (ANOVA) was used to compare the chemical content and the
6 technological properties of the composite breads at different replacement levels with
7 refined commercial flour and the pearled wheat fraction. The residual normal distribution
8 was verified using the Kolmogorov-Smirnov test, while variance homogeneity was verified
9 using the Levene test. Multiple comparison tests were performed according to the Student-
10 Newman-Keuls test on treatment means. The SPSS for Windows statistical package,
11 Version 17.0 (SPSS Inc., Chicago) was used for the statistical analysis.

12

1 **3. Results and Discussion**

2 **3.1 Chemical characterization of the flour and pearled fraction**

3 First, the refined commercial flour, the selected pearled fraction and the whole wheat
4 kernel were characterized before the pearling process for their chemical composition
5 (protein, DF, β -glucan, total phenolic, AR and ash contents), TAA and DON contamination
6 (Table 1). The selected fraction, rich in outer kernel layers, but which was obtained
7 through a sequential pearling to discard the most external fraction, resulted in a higher
8 concentration of bioactive compounds than both the refined flour and the original whole
9 kernel, confirming previously reported data (Beta et al., 2005; Sovrani et al., 2012). The
10 proteins, DF, β -glucans, total phenols, ARs, ash and TAA were 1.2, 2.9, 1.4, 2.3, 2.5, 2.9
11 and 3.4 times higher in the pearled fraction than in the corresponding whole kernel,
12 respectively. The pearled fraction had a 15, 7, 10 and 27 higher content of DF, β -glucans,
13 TPC and ARs, respectively, than the refined commercial flour. The TAA of the pearled
14 fraction was 11.4 times higher than in the refined flour.

15 As far as the AR composition is concerned, the main identified compound was 5-*n*-
16 heneicosylresorcinol, which accounted for about 52% of the white flour and about 49% of
17 both the whole grain and pearled fraction of the Taylor cv. However, the internal
18 percentages of the individual compounds of the refined flour were slightly different from
19 those obtained for the Taylor cv samples (data not shown). In particular, 5-*n*-
20 nonadecylresorcinol was higher in the Taylor wheat samples (about 32%) than in the
21 commercial flour (about 18%), although the latter was richer in 5-*n*-pentacosylresorcinol
22 (about 9% and 3% in the commercial flour and Taylor cv samples, respectively). These
23 differences can be related to the specific characteristics of the considered cultivar.

1 As far as DON contamination is concerned, several studies have reported that the
2 outermost kernel layers had the highest DON content, which decreased from the external
3 to the internal layers showing biphasic behavior (Sovrani et al., 2012). The first external
4 fraction (8% of kernel weight) was therefore separated and only the fraction resulting from
5 the second pearling level was used for bread-making. Nevertheless, compared to the
6 whole kernel, the selected pearled fraction concentrated DON by 2.5 times and the
7 pearled fraction content of this mycotoxin was 68% higher than the refined flour. A careful
8 control of raw material contamination, especially of the pearled kernel fraction, is required
9 to minimize the DON level in derived products and to respect the maximum permitted DON
10 levels (European Commission, 2006).

11

12 3.2 Rheological parameters of the replaced flours

13 Five mixtures of refined flour for bread-making with an increasing replacement of the
14 selected pearled wheat fraction (5%, 10%, 15%, 20%, and 25%) were obtained and
15 characterized for their rheological properties; the refined flour (no replacement) was
16 analyzed as the control.

17 The refined flour control in the Mixolab test required a water supply of 59.8% (14% basis)
18 to reach the adequate dough consistency requested by the instrument. The progressive
19 replacement of flour with the pearled fraction increased the amount of water required for
20 the hydration process of the flour, 60.2%, 61.4%, 62.8%, 64.4%, 66.2% for flour
21 substitutions of 5%, 10%, 15%, 20% and 25%, respectively.

22 The dough development time (DDT) was similar for the control and the 5% replacement
23 level, while it increase clearly at 10% replacement level (Fig. 1); after the increasing
24 replacement of refined flour with the pearled fraction proportionally delayed the DDT. For
25 example, the DDT increased by 2 min compared to the control at 10% replacement level.

1 On the other hand, dough stability did not vary with the increase in pearled fraction (data
2 not shown).

3 Increasing the replacement level of refined flour with the pearled fraction did not affect the
4 C2 point (protein weakness), but it did decrease the dough consistency at the C3 (starch
5 gelatinization) and C5 (starch gelling) points. Compared to the control without pearled
6 fraction addition, the differences for these parameters are more pronounced for higher
7 replacement levels than 15%. The C4 point (amylase activity) was unaffected by the flour
8 substitution with the pearled kernel fraction percentage (data not shown).

9 The collected data confirm the effects on the rheological properties of dough when refined
10 flour is replaced by wheat bran (Sanz Penella et al., 2008; Gómez, Jiménez, Ruiz & Oliete,
11 2011). This different rheological dough behaviour is mainly related to the competition for
12 water of the added wheat fibres with the flour proteins and starch (Rosell, Santos & Collar,
13 2010) and to the physical and mechanical negative effect of fibre on the formation of the
14 gluten network (Noort et al., 2010). However, the addition of the pearled fraction seems to
15 lead to a higher DDT than that obtained with bran addition (Gómez et al., 2011). On the
16 other hand, Schmiele, Jaekel, Patricio, Stelle, & Chang (2012) reported that a substitution
17 of refined flour with wheat bran up to 20% decreased DDT, while DDT only increased at
18 40%-replacement level. Bonnand-Ducasse, Della Valle, Lefebvre & Saulnier (2010) have
19 reported that the water absorption and water-holding capacity of aleurone are higher than
20 those of the outer bran fractions and this effect could be related to a lower
21 arabinose/xylose ratio, These data have been also confirmed by Noort et al. (2010).

22 Moreover, in fibre enriched wheat dough, the fibre replacement of flour generally
23 implicates a change in dough stability, although the reported effects are often discordant,
24 and a higher dough weakening as a consequence of a gluten-diluting effect (Rosell et al.,
25 2010; Noort et al., 2010; Gómez et al., 2011). However, in the present work, dough

1 stability and protein weakness were not affected by the replacement of refined flour,
2 probably because the added pearled fraction provided a non-negligible protein content that
3 could have prevented an excessive gluten dilution.
4

5 3.3 Bread technology properties

6 The control (no replacement) and the 5%-, 10%-, 15%-, 20%-, 25%-substituted breads
7 were produced using the previously described flours and were first analyzed for their
8 technology properties: crust color, bread crunchiness and volume, TPA test.
9

10 **3.3.1 Crust color**

11 ANOVA showed significantly differences in the L^* , a^* , b^* , C and h values for the crusts of
12 bread made with different replacement levels of the refined flour with the pearled wheat
13 fraction (Table 2). An increase in substitution with the pearled fraction resulted in a
14 reduction in the L^* (lightness) and h values and an increase in the a^* (redness) and
15 Chroma values. Less significant changes were found in the blue-yellow component (b^*). In
16 the bread made at replacement levels of 5% and 10%, the lightness (L^*), redness (a^*) and
17 h values of the crust were significantly different from those of the bread made only with the
18 refined flour, and no differences were observed for Chroma. Modifications in the crust
19 color increased drastically in the enriched bread for higher replacement levels of the
20 refined flour than 10%.

21 Jiang, Martin, Okot-Kotber, & Seib (2011) suggested that the high amount of TPC in whole
22 wheat flour could negatively affect the color of whole grain foods. In order to obtain the
23 pearled fraction, white wheat cultivars with a brighter appearance could be used to reduce
24 the impact of TPC on bread color. These varieties, mostly soft, although recently hard
25 white wheat cultivars presented a growing interest, especially in Australia and North

1 America, have agronomical characteristics and bread-making quality similar to that
2 observed for red wheat lines (Ransom, Berzonsky & Sorenson, 2006).

3

4 **3.5.2 Bread crust crunchiness**

5 The results of the mechanical and acoustical properties of the composite bread crust are
6 reported in Table 2. The total break energy, that is the energy necessary to break the crust
7 and to continue the compression until 20 mm of penetration, was found to be higher in the
8 0% and 5% flour substituted samples, with a descending trend when the flour replacement
9 level was increased (from 149 mJ to 99 mJ, -35.6%).

10 The acoustic emission released from crushed food is one of the most important
11 parameters for the evaluation of crispness (Saeleaw & Schleining, 2011) and is related to
12 the consumers' acceptance of the product. The acoustic emission measurements showed
13 that the addition of the pearled fraction influenced the crunchiness "sound" of the product.
14 The maximum acoustic peak only showed significant differences for the high substituted
15 formulations (20 and 25 %). Different behaviour was detected for both the 5 and 15 dB
16 (SPL) thresholds between 0-10% and 15-25% formulations. All the acoustic parameters
17 measured showed a high dispersion of the values, in accordance with the data reported in
18 scientific literature (van Nieuwenhuijzen, Primo-Martín, Meinders, Tromp, Hamer & van
19 Vliet, 2008). The instrumental crust crunchiness parameters are related with the structure
20 of the product, with the chemical composition and with the water activity/water content
21 (Duizer, 2001; van Nieuwenhuijzen, Primo-Martín, Meinders, Tromp, Hamer & van Vliet,
22 2008).

23 There were no significant differences in the total break energy or acoustic emissions
24 during compression from the control made with only refined flour until the 10%-

1 replacement level of refined flour with the pearled fraction. Thus the tactile and acoustic
2 sensation of crispness can be considered the same in these samples.

3

4 **3.5.3 Bread volume**

5 ANOVA showed a significant effect of the decrease in bread volume that corresponded to
6 the increasing percentage of refined flour replacement (Table 3). This effect began at 10%
7 of replacement of refined flour with the pearled fraction.

8 Gómez et al. (2011), replacing the refined flour with bran, observed a greater loaf volume
9 reduction: bran reduced the loaf volume by 22% and 31% for a replacement level of 10%
10 and 20%, respectively.

11 The reduction in bread volume seems to be related to the high amount of DF present in
12 the bran, which diluted the gluten protein and interfered with the optimal gluten matrix
13 formation during fermentation and baking. Moreover, the resulting gluten with fibre
14 addition became stiffer and less extensible, and this led to a lower ability of the dough to
15 retain gas (Wang, van Vliet & Hamer, 2004).

16 Gan, Gallieard, Ellis, Angold, & Vaughan (1992) showed that the outer layers of bran,
17 especially the epicarp hairs, are responsible for loaf volume depression authors
18 demonstrated that removing the outer kernel layers by pearling significantly improves the
19 baking performance of the resulting flour.

20 In our experiment, the outer pearled fraction was discarded and this could explain the
21 moderate impact of the intermediate pearled layer of the wheat kernel added at 10%-level
22 on the loaf volume.

23 Noort et al. (2010) reported that the addition of an aleurone kernel fraction to flour causes
24 a more adverse effect on bread volume than wheat bran. The authors suggested that the
25 higher ferulic acid content of the aleurone fraction, which results in interactions between

1 the arabinoxylan chain and gluten proteins, is reflected in ability of the glutens to
2 agglomerate. Han and Koh (2011) reported that the addition of purified phenolic acids,
3 mainly ferulic and caffeic, decreased the extension of dough and the bread volume.

4 **3.3.4 Breadcrumb texture profile analysis**

5 The TPA instrumental test reflects the sensory analysis of bread (Gámbaro, Varela,
6 Giménez, Aldrovandi, Fizman, & Hough, 2002), and it can therefore be used for an
7 objective assessment of the impact of the flour replacement on the perceived quality and
8 attributes of bread. In the TPA variable data (Table 3), small and insignificant differences
9 were found for the three less flour-substituted samples (0%, 5% and 10%), but when the
10 substitution was increased the bread crumb texture characteristics showed very important
11 changes and a great modification of all the mechanical parameters. The greatest
12 differences were found for the bread hardness parameter, with a very high increment (from
13 1,82 N to 7,00 N) between the 0% and 25% flour-substituted bread. Similar trends and
14 values of crumb hardness were reported by Schmiele et al. (2012) for an increasing
15 replacement of refined flour with wheat bran.

16 The importance of this parameter is related to the hardness of the crumb, especially in
17 relation to the gumminess and the chewiness parameters (Gómez et al., 2011), which are
18 even higher in more flour-substituted bread crumbs. The 25%-substituted bread crumbs
19 has showed therefore a greater hardness and also less ability to regain their original height
20 after the first compression (resilience).

21

22 **3.4 Chemical characterization of bread**

23 The protein, DF, β -glucan, TPC, AR, ash content and TAA of bread increased linearly and
24 significantly as the refined flour was replaced with the selected pearled wheat fraction
25 (Table 4).

1 The maximum increase in the bioactive compounds was recorded at 25% of flour
2 replacement with the pearled fraction: 25%-substituted bread resulted in the highest
3 content of DF (+ 4.4 times higher than refined bread), β -glucans (+3.6 times), TPC (+ 3.6
4 times), ARs (+35 times), ash (+14%) and TAA (+2.2 times).

5 Considering the technological information, the 10%-substituted bread, compared to that
6 made with only refined flour, showed significantly higher contents of DF, β -glucans, TPC,
7 ARs and ash (2.7, 1.9, 2.0, 13 and 1.1 times higher, respectively). Moreover, the bread
8 made with 10% of pearled fraction could have been classified as a "Source of Fiber" (DF >
9 3%), and was close to being a "Good Source of Fiber" (DF > 6%), according to the
10 guidelines for the use of nutrition and health claims (Codex Alimentarius, 1997). At this
11 level of replacement, the TAA of bread was 42% higher than the control.

12 Ragae, Guzar, Dhull & Seetharaman (2011) used wholegrain wheat flour to replace a
13 portion of flour in the bread-making process. They reported that, at a 30% replacement
14 level, DF, TPC and TAA (measured as DPPH^{*} scavenging capacity) increased 1.7, 2.0 and
15 1.6 times, respectively, compared to control recipe without enrichment. In our study, a
16 greater increase in DF (+2.7 times) and similar increase in TPC and TAA were obtained at
17 a 10% replacement level, using the pearled fraction. The same increase in protein and ash
18 contents in the bread as that of Ragae et al. (2011) at 30% of substitution, was recorded
19 for the inclusion of the pearled fraction at a 20% level. Both DF (+ 1.6 times) and β -
20 glucans (+2.8 times) content of the breads was significantly increased with the inclusion at
21 15% level of pearled barley middlings (Sullivan, O'Flaherty, Brunton, Arendt & Gallagher,
22 2011).

23 These results confirm the potential of using the intermediate fraction obtained from
24 sequential pearling in bread-making as a functional ingredient, as it is an important
25 concentrated dietary source of natural wheat antioxidants and DF. The addition of this

1 functional ingredient, rich in the aleurone layer, seems to lead to a greater nutritional
2 improvement of composite bread than wheat bran or other milling fractions. Zhou, Laux &
3 Yu (2004) reported that aleurone extracts from intermediate kernel wheat layers had 19%
4 and 48% higher TAA and TPC contents than total bran fractions; this information could
5 explain the high nutritional improvement observed in the present study.

6 The DF, β -glucans and TPC were not reduced during the baking process, thus confirming
7 previously reported data (Ragaei et al., 2011). The TPC resulted in an increase in bread
8 compared to the raw materials, which was probably related to the newly generated
9 intermediate phenolic products, through Maillard reactions (Michalska, Amigo-Benavent,
10 Zielinski & del Castillo, 2008). Han & Koh (2011) reported that, at the end of bread-making
11 process, the TAA and residual free phenolic acid contents of bread are similar to those of
12 flour, although their values are reduced during mixing phases, but are increased by
13 fermentation and baking.

14 The AR content in breads was lower than that expected from the values obtained for both
15 the refined commercial flour and the pearled wheat fraction. In fact, in processed cereal
16 products, ARs could be trapped in starch-lipid complexes and not completely extracted
17 from the matrix (Ross et al., 2003), thus leading to an underestimation of their content in
18 bread samples.

19

20 3.5 DON contamination of bread

21 The DON contamination of bread made with the refined flour or with the five mixtures is
22 reported in Table 4.

23 The DON content was not reduced through the bread-making process, when the flour and
24 bread data were corrected on dry weight basis, thus confirming previous reports
25 (Scudamore, Hazel, Patel & Scriven, 2009), although other research works reported

1 opposite findings related to real industrial production processes (Bergamini et al., 2010).
2 The contamination of this mycotoxin in bread increased linearly as wheat flour was
3 replaced with the selected pearled fraction. The increase in DON content after bread-
4 making was 21% and 67%, respectively, compared to the control, for 10% and 25% of
5 substituted refined flour. Moreover, bread samples with higher levels of replacement
6 returned higher final DON contaminations than expected: Bergamini et al. (2010)
7 suggested that this increment could be due to the release of DON from some bound forms
8 that occur in the flour and which could be cleaved or solubilized during fermentation. In our
9 experiment, this effect might have been more effective on the DON content in the pearled
10 fraction. More research is required to investigate the effect of the bread-making process on
11 DON when bran or intermediate kernel layers are added to the refined flour.

12

1 **4. Conclusion**

2 The study has demonstrated the importance of enriching wheat bread with pearled
3 fractions from intermediate layers of wheat kernel in order to improve natural antioxidant
4 compound contents, e.g. phenolics, ARs, DF and β -glucans. As expected, the DON
5 content increased linearly in the composite bread as the refined flour was replaced with
6 the pearled fraction, while the dough rheology and the physical and technological
7 properties of the bread changed compared to the control.

8 Overall, the addition of an intermediate fraction obtained from pearling could lead to a
9 greater nutritional improvement but, at the same time, a generally lower impact on
10 technological quality of composite bread than wheat bran or other milling fractions.

11 The nutritional value of composite bread improved significantly at a 10%-substitution level,
12 while the increase in DON contamination was moderate and the rheological and
13 technological properties were acceptably similar to the control. Thus, refined flour could be
14 replaced at this level and this would lead to few differences in the quality properties
15 generally required on the market.

16 Since the food industry is presently focused on producing functional foods that
17 incorporated various cereals, according to a multigrain approach, the fractionation
18 technology proposed for wheat in the present work, with the inclusion of a functional
19 ingredient obtained by sequential kernel pearling, could also be applied to other cereals.

20

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11

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13

1 **Tables**

2
3

4 **Table. 1.**

5 Protein, DF, β -glucan, TPC, AR and ash content, DON contamination and TAA in refined
6 commercial flour, enriched fraction obtained through pearling and whole wheat kernel
7 before pearling.

Product	Proteins (%)	DF (%)	β -glucans (%)	TPC (mg kg ⁻¹)	ARs (g kg ⁻¹)	TAA (mmol TE kg ⁻¹)	Ash (μ g kg ⁻¹)	DON (μ g kg ⁻¹)
white flour	15.1	2.3	0.1	614	0.06	0.4	0.5	186
pearled fraction	18.3	34.9	0.9	6361	1.68	5.0	5.5	580
whole kernel for pearling	14.7	12.0	0.6	2812	0.68	1.5	1.9	363

8
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10

Results are expressed on a dw basis.

1 **Table. 2.**

2 Protein, DF, β -glucan, TPC, AR content and TAA in bread derived from different
 3 percentages of substitution of refined flour with an enriched fraction obtained through
 4 wheat.

Percentage of substitution	Proteins (%)	DF (%)	β-glucans (%)	TPC (mg kg⁻¹)	ARs (mg kg⁻¹)	TAA (mmol TE kg⁻¹)
0	14.9 d	2.0 f	0.13 e	836 f	4 f	0.33 d
5	15.5 c	2.6 e	0.22 d	1411 e	25 e	0.47 c
10	15.7 bc	5.5 d	0.25 d	1688 d	53 d	0.47 c
15	15.3 abc	6.8 c	0.35 c	1847 c	85 c	0.58 b
20	15.9 ab	8.0 b	0.40 b	2559 b	105 b	0.60 b
25	16.0 a	8.9 a	0.48 a	3066 a	149 a	0.73 a
<i>P</i> (F)	< 0.001	< 0.001	< 0.001	< 0.001	< 0.001	< 0.001
sem ^a	0.34	0.19	0.05	123	4.37	0.06

5

6 Results are expressed on a dw basis. Means followed by different letters are significantly different (the level
 7 of significance is shown in table).

8 ^a sem: standard error of mean.

9

1 **Table 3.**

2 Ash content and DON contamination in bread derived from different percentages of
3 substitution of refined flour with an enriched fraction obtained through wheat kernel
4 pearling.

Percentage of substitution	Ash (%)	DON ($\mu\text{g kg}^{-1}$)
0	2.20 d	185 f
5	2.31 c	209 e
10	2.44 b	225 d
15	2.54 a	254 c
20	2.57 a	279 b
25	2.54 a	310 a
<i>P</i> (F)	< 0.001	< 0.001
sem ^a	0.05	14

5
6 Results are expressed on a dw basis. Means followed by different letters are significantly different (the level
7 of significance is shown in table).

8 ^a sem: standard error of mean.

1 **Table 4.**

2 Color, texture and acoustic emission tests in bread crust derived from different percentage of substitution of refined flour with an
 3 enriched fraction obtained through wheat kernel pearling.

Percentage of substitution	Crust color					Crust crunchiness			
	L*	a*	b*	C	h*	Total break energy mJ	Maximum acoustic emission dB (SPL)	Acoustic emission peak average threshold 5 dB (SPL)	Acoustic emission peak average threshold 15 dB (SPL)
	(C)	(C)	(C)	(C)	(C)				
0	70.1 a	3.2 a	33.8 ab	34.0 a	84.6 a	147 a	77 a	41 a	43 a
5	65.7 b	4.6 b	33.7 a	34.0 a	82.2 b	149 a	76 a	41 a	43 a
10	61.6 c	6.5 c	34.8 ab	35.4 ab	79.4 c	137 a	73 a	40 a	42 a
15	57.9 d	8.9 d	35.3 b	36.5 b	75.8 d	118 b	71 a	29 b	32 b
20	55.8 d	9.4 d	35.2 ab	36.4 b	75.1 d	117 b	66 ab	21 b	22 b
25	52.9 e	9.9 d	35.0 ab	36.4 b	74.3 d	99 c	58 b	24 b	27 b
<i>P</i> (F)	< 0.001	< 0.001	0.01	< 0.001	< 0.001	< 0.001	0.004	< 0.001	< 0.001
sem ^a	3.1	1.2	1.6	1.7	1.7	11	9.4	9.0	9.5

4

5 Results are expressed on a dw basis. Means followed by different letters are significantly different (the level of significance is shown in table).

6 ^a sem: standard error of mean.

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1 **Table 5.**

2 Volume and Texture Profile Analysis in bread crumb derived from different percentage of substitution of refined flour with an enriched
3 fraction obtained through wheat kernel pearling.

Percentage of substitution	Bread Volume (ml)	Bread crumb					
		Hardness N	Cohesiveness (-)	Springiness mm	Gumminess N	Chewiness mJ	Resilience (-)
0	2146.7 a	1.82 a	0.88 a	9.99 a	1.60 a	16.00 a	0.52 a
5	2135 a	1.74 a	0.89 a	9.97 a	1.55 a	14.00 a	0.53 a
10	1978.3 b	1.99 a	0.88 a	9.99 a	1.76 a	17.59 a	0.54 a
15	1893.3 c	2.89 b	0.88 a	9.98 a	2.61 b	25.28 b	0.54 a
20	1720 d	4.39 c	0.86 b	10.00 a	3.77 c	37.71 c	0.50 b
25	1506.7 e	7.00 d	0.84 c	10.00 a	5.91 d	57.84 d	0.49 b
<i>P</i> (F)	< 0.001	< 0.001	< 0.001	0.06	< 0.001	< 0.001	< 0.001
sem ^a	24.94	0.62	0.01	0.02	0.44	4.76	0.02

4

5 Results are expressed on a dw basis. Means followed by different letters are significantly different (the level of significance is shown in table).

6 ^a sem: standard error of mean.

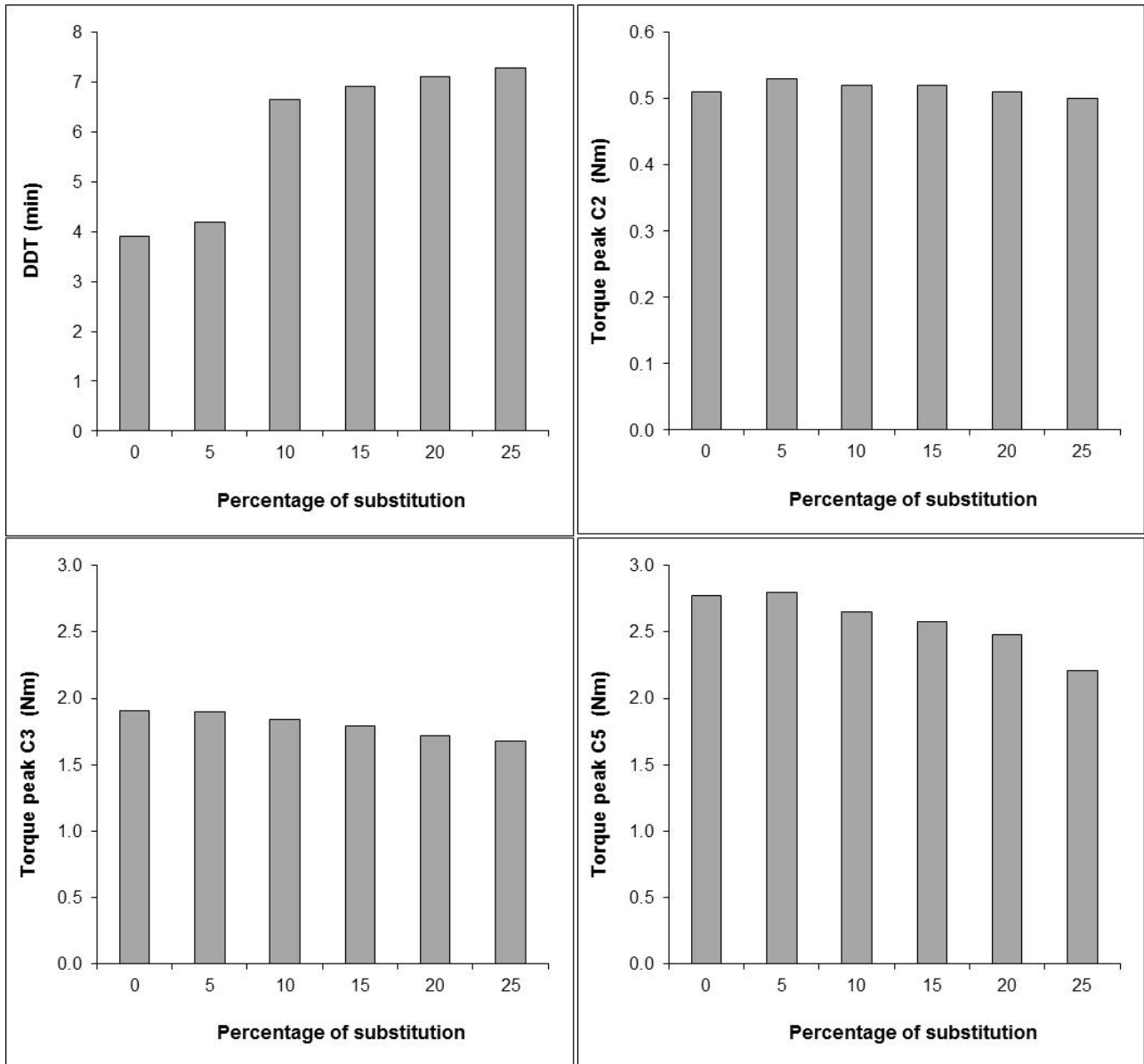
7

1 **Figure legend**

2

3 **Figure 1.**

4 Mixolab parameters^a for dough with different replacement percentages of refined flour with
5 an enriched fraction obtained through wheat kernel pearling.



6

7 ^a Mixolab parameters: DDT = Dough Development Time; C2 = protein weakness; C3 = starch gelatinization;
8 C5 = starch gelling; C2, C3 and C5: end points of the corresponding mixing stages.

9