

# **PHYSICO-CHEMICAL AND TECHNOLOGICAL STUDIES ON SOME FOOD LEGUMES**

**BY**

**KHALED ISMAIL ABD EL- SALAM AHMED**

B.Sc. Agric. Sc. (Food Science and Technology), Ain Shams University, 1980

M.Sc. Agric. Sc. (Food Science and Technology), Ain Shams University, 1999

**A thesis submitted in partial fulfillment  
of  
the requirements for the degree of**

**DOCTOR OF PHILOSOPHY**

**in**

**Agricultural Science  
(Food Science and Technology)**

**Department of Food Science  
Faculty of Agriculture, Ain Shams University**

**2005**

## **Approval sheet**

### **PHYSICO – CHEMICAL AND TECHNOLOGICAL STUDIES ON SOME FOOD LEGUMES**

**BY**

**KHALED ISMAIL ABD EL- SALAM AHMED**

B.Sc. Agric. Sc. (Food Science and Technology), Ain Shams University, 1980

M.Sc. Agric. Sc. (Food Science and Technology), Ain Shams University, 1999

This thesis for Ph.D. degree has been approved by:

**Prof.Dr. Adel Zaki M.A.Badee** .....

Prof.of Food Science and Technology, Faculty of Agriculture,  
Cairo University

**Prof. Dr. Ramadan M.Mahmoud** .....

Prof. Emerities of Food Science and Technology, Faculty of  
Agriculture, Ain Shams University

**Prof. Dr. Yehia A.Heikal** .....

Prof. Emerities of Food Science and Technology, Faculty of  
Agriculture, Ain Shams University

**Prof. Dr. Mamdouh H.O.El- Kalyoubi**.....

Prof. of Food Science and Technology, Faculty of Agriculture,  
Ain Shams University

Date of Examination 31/ 10/ 2005

# **PHYSICO – CHEMICAL AND TECHNOLOGICAL STUDIES ON SOME FOOD LEGUMES**

**BY**

**KHALED ISMAIL ABD EL- SALAM AHMED**

B.Sc. Agric. Sc. (Food Science and Technology), Ain Shams University, 1980

M.Sc. Agric. Sc. (Food Science and Technology), Ain Shams University, 1999

**Under the supervision of:**

**Prof. Dr. Mamdouh H.O.El- Kalyoubi**

Prof. of Food Science and Technology, Food Sc. Dep., Faculty of  
Agriculture, Ain Shams University (Principal supervisor)

**Prof. Dr. Yehia A.Heikal**

Prof. Emerities of Food Science and Technology, Food Sc. Dep.,  
Faculty of Agriculture, Ain Shams University

**Prof. Dr. Mohamed M.M. Khalaf**

Prof. of Food Science and Technology, Faculty of Agriculture,  
Ain Shams University

## **ABSTRACT**

**Khaled Ismail Abd EL- Salam Ahmed. Physico – chemical and technological studies on some food legumes. Unpublished Ph.D. Dissertation, University of Ain Shams, Faculty of Agriculture, Department of Food Science, 2005.**

Four food legumes (faba bean, cowpea, soy bean and lentil), from different growing locations obtained by the General Organization for Export and Import Control, Cairo, Egypt, were studied in comparison with the Egyptian cultivars. With respect to their physical and chemical characteristics, antinutritional factors content, supplementation raw and germinated legumes flour with wheat flour to prepare salt biscuit and application in meat products. On the other hand, the effect of soaking process at different temperatures (25, 50 and 80 °C) on hydration coefficient, swelling coefficient and hardness, was also studied. Significant variation in proximate composition in such legumes samples were found among the growing location. Soaking, germination and fermentation have affected on the legume samples content of antinutritional factors such as trypsin inhibitor, phytic acid and oligosaccharides. The higher significant effect was found in fermented legumes followed by germination and soaking treatments. Significant reduction in trypsin inhibitor content was found in all samples with increasing soaking, germination and fermentation time. The same reduction was observed in oligosaccharides content in samples, while phytic acid content was reduced after 3 days of germination process. Supplemented wheat flour samples at 20% and 30% with either raw or germinated faba bean, cowpea, soybean, lentil and their mixtures were used in biscuit making. The effect of such supplementations on the rheological properties (using farinograph and extensograph) of the resulting dough as well as the baking quality and nutritional properties of the produced biscuits were studied. It was found that the use of legume flours at 20% improved the rheological properties of the dough. Also,

supplementation with legume flours has improved the baking quality and nutritional properties of produced biscuits, especially when germinated legume flours were used. Sensory evaluation proved that the use of supplemented wheat flour in biscuit formula gave the acceptable scores for most sensory attributes, except for that samples supplemented with lentil flours. Using of raw and germinated legumes at 30% for all legume samples and 40% for only lentil in preparation of beef burger improved the water holding capacity, plasticity, cooking yield, hardness and sensory properties of the produced samples. it could be noticed that, beef burger samples prepared with addition of the same levels of legume flours showed enhanced organoleptic acceptability.

**Key words:** Faba bean – Cowpea - Soy bean – Lentil – Physical and Chemical Properties - Soaking- Germination – Fermentation – Antinutritional Factors – Sorption isotherm's.

## ACKNOWLEDGEMENT

All praises and thanks are due to **ALLAH**, who blessed me with kind professors and colleagues, and gave me the support to present this thesis.

I would like to express my sincere appreciation and deepest gratitude to **Prof. Dr. Mamdouh H.O.El- Kalyoubi**, Professor of Food Science and Technology, Faculty of Agriculture, Ain Shams University for his close supervision, great helps, valuable suggestion and continuous encouragement during the whole period of this study.

Deepest thanks and sincere appreciation to **Prof. Dr. Yehia A.Heikal**, Professor of Food Science and Technology, Faculty of Agriculture, Ain Shams University for his guidance, constructive criticism and every possible help he kindly offered throughout the course of this work.

I wish to express my deepest sincere appreciation to **Prof. Dr. Mohamed M.M. Khalaf**, Professor of Food Science and Technology, Faculty of Agriculture, Ain Shams University for supervising this work, attention and efforts he made through the course of the implementation of this thesis.

Thanks due to all the staff members and colleagues in the Food Science and Technology Department, Faculty of Agriculture, Ain Shams University for giving all the facilities that made this work possible.

I would like to offer my gratitude to the General Organization for Export and Import Control, for the every kind help and encouragement.

Thanks also should be sent to *Academy of Scientific Research* to its fund help and facilities offered to make this work possible.

Also, I would like to express my deep thanks for **Prof. Dr. Herbert Kunzek and Dr. Dieter Glogna**. Dept. of Food Functionality,

Institute of Food Technology at Berlin University of Technology for the facilities provided through the HPLC-analysis of the oligosaccharides.

In this respect I can not forget my family for their continuous help and support through this work.

## LIST OF CONTENTS

	Page
1. INTRODUCTION .....	1
2. REVIEW OF LITRETURE .....	6
2.1. Thermal processing and water activity of food legumes .....	6
2.2. Food legumes characteristics as affected by technological processes .....	8
2.2.1. Soaking .....	8
2.2.2. Germination .....	10
2.2.3. Fermentation .....	15
2.3. Chemical proximate of some food legumes .....	17
2.4. Effect of processing on the antinutritional factors in food legumes .....	19
2.5. Nutritional evaluation of legumes blending in food products .....	24
3. MATERIALS AND METHODS .....	36
3.1. Materials .....	36
3.1.1. Food legume seeds.....	36
3.1.2. Raw materials used in biscuits .....	37
3.1.3. Raw material used in beef burger .....	37
3.1.4. Bacterial strains .....	38
3.1.5. Media .....	38
3.1.6. Lactobacilli agar (MRS-agar) .....	39
3.1.7. Lactobacilli fermentation medium .....	39
3.2. Technological and biological treatments .....	39
3.2.1. Soaking .....	39
3.2.2. Germination .....	40
3.2.3. Fermentation .....	40
3.2.4. Preparation of defatted soy flour .....	40
3.2.5. Hard salted biscuits .....	40



3.2.6. Beef burger .....	41
3.3. Methods of Analysis .....	43
3.3.1. Physical properties of legume seeds, different biscuit samples and beef burger samples .....	43
3.3.1.1. Weight and volume of 1000-seeds .....	43
3.3.1.2. Seed dimensions .....	43
3.3.1.3. Hardness of legume seeds, biscuit and beef burger samples.....	45
3.3.1.4. Hydration coefficient .....	45
3.3.1.5. Swelling coefficient .....	45
3.3.1.6. Water activity .....	45
3.3.1.7. Rheological analysis .....	46
3.3.1.7.1. Rheological properties of dough .....	46
3.3.1.7.1.1. Farinograph test .....	46
3.3.1.7.1.2. Extensograph test .....	47
3.3.1.8. Baked biscuits analysis .....	49
3.3.1.9. Beef burgers analysis .....	49
3.3.1.9.1. Cooking yield .....	49
3.3.1.9.2. Cooking loss .....	49
3.3.1.9.3. Shrinkage .....	49
3.3.1.9.4. Water holding capacity (WHC) .....	50
3.3.2. Chemical analysis .....	50
3.3.2.1. Moisture content.....	50
3.3.2.2. Total nitrogen.....	50
3.3.2.3. Crude fat.....	50
3.3.2.4. Ash content .....	50
3. 3.2.5. Total Carbohydrates.....	50
3.3.2.6. Amino acid.....	51
3. 3.2.7. Iron content.....	52

3. 3.2.8. Antinutritional Factors.....	52
3. 3.2.8.1. Trypsin inhibitor activity (TIA) assay.....	52
3. 3.2.8.2. Phytic acid assay.....	53
3.3.2.8.3. Determination of sugars using High Pressure Liquid Chromatography (HPLC).....	53
3.4. Sensory evaluation .....	55
3.4.1. Sensory evaluation of biscuit samples .....	55
3.4.2. Sensory evaluation of beef burger samples .....	55
3.5. Statistical analysis .....	56
4. RESULTS AND DISCUSSION .....	57
4.1. Physico-Chemical Properties of the Investigated Egyptian and Imported Food Legume Seeds .....	57
4.2. Moisture sorption characteristic of tested food legumes...	63
4.2.1. Equilibrium moisture content of tested legumes .....	65
4.2.2. Kinetic of moisture sorption .....	80
4.2.3. Sorption isotherm curves of tested legumes .....	88
4.2.4. Mathematical description of sorption isotherms .....	94
4.2.4.1. The Guggenheim-Anderson-de Boer (GAB) equation	94
4.2.4.2. Henderson equation.. .....	96
4.2.4.3. Halsey equation .....	96
4.2.4.4. Chung-Pfost equation .....	96
4.2.4.5. Smith equation .....	97
4.2.4.6. Application of G.A.B. equation .....	97
4.2.4.7. Application of Henderson, Chung-Pfost, Halsey and Smith equations .....	101
4.2.5. Heat of sorption .....	107
4.2.5.1. Effect of equilibrium moisture content on hardness of legume seeds .....	109

4.3. Food legume quality as affected by soaking treatment .....	118
4.3.1. Hydration .....	118
4.3.2. Swelling.....	126
4.3.3. Hardness .....	138
4.4. Effect of processing on some antinutritional factors .....	151
4.4.1. Trypsin inhibitor .....	152
4.4.2. Phytic acid .....	160
4.4.3. Oligosaccharides .....	168
4.4.3.1. Sugars content of raw legume samples .....	168
4.4.3.2. Effect of technological treatments on sugars profile of legume seeds .....	175
4.4.3.2.1. Effect of technological treatments on sugar content of faba bean.....	175
4.4.3.2.2. Effect of technological treatments on sugar content of cowpea .....	182
4.4.3.2.3.. Effect of technological treatments on sugar content of soybean .....	187
4.4.3.2.4. Effect of technological treatments on sugar content of lentil .....	195
4.5. Application of Legume Seed Flours on Food Processing...	203
4.5.1. Biscuits .....	203
4.5.1.1. Chemical composition of biscuits .....	203
4.5.1.2. Sensory evaluation of biscuits .....	208
4.5.1.3. Baking quality characteristics of biscuit samples.....	218
4.5.1.4. Rheological properties of biscuit dough's .....	218
4.5.2. Beef Burger.....	235
4.5.2.1. Water holding capacity (WHC).....	235
4.5.2.2. Plasticity .....	238
4.5.2.3. Shrinkage.....	239
4.5.2.4. Cooking yield.....	243

4.5.2.5. Cooking loss.....	244
4.5.2.6. Hardness.....	244
4.5.2.7. Organoleptic evaluation.....	248
4.5.2.7.1. Color .....	248
4.5.2.7.2. Taste.....	251
4.5.2.7.3. Aroma .....	251
4.5.2.7.4. Tenderness .....	252
4.5.2.7.5. Juiciness.....	253
4.5.2.7.6. Overall acceptability .....	253
5-SUMMARY .....	255
6-REFERENCES .....	264
7-APPENDEX .....	294
8-ARABIC SUMMARY	

## LIST OF TABLES

No.	Title	Page
1	Mean values of Production and Imported amounts (tons) of Faba bean, Cowpea, Soybean and Lentil during 2000 – 2004 .....	2
2	Composite different ratio of wheat flour substitutes with different amounts of prepared legumes flour for Biscuits dough's.....	42
3	Composite different ratio of beef meat extended with different legumes flour for beef burger samples.....	44
4	The saturated salt solutions and their relative Humidity...	46
5	Mean values of dimensions, weight and hardness of the Egyptian and imported (faba bean, cowpea, soybean and lentil) legume seeds.....	58
6	Proximate chemical composition of some raw Egyptian and imported food legumes.....	60
7	Amino acid composition (%) of some raw Egyptian and imported food legumes.....	62
8	Amino acid composition of some raw and germinated imported food legumes.....	64
9	Equilibrium moisture content of Egyptian and British faba bean at different water activity levels and temperatures.....	66
10	Equilibrium moisture content of Egyptian and Burma cowpea at different water activity levels and temperatures.....	67
11	Equilibrium moisture content of Egyptian and Argentina soybean at different water activity levels and temperatures.....	68

12	Equilibrium moisture content of Egyptian and Turkey lentil at different water activity levels and temperatures...	69
13	Rate of moisture desorption and absorption of Egyptian and imported faba bean (K-values) during sorption experiment (g H <sub>2</sub> O / g DM.d <sup>-1</sup> ).....	82
14	Rate of moisture desorption and absorption of Egyptian and imported cowpea (K-values) during sorption experiment (g H <sub>2</sub> O / g DM.d <sup>-1</sup> ).....	83
15	Rate of moisture desorption and absorption of Egyptian and imported soybean (K-values) during sorption experiment (g H <sub>2</sub> O / g DM.d <sup>-1</sup> ).....	84
16	Rate of moisture desorption and absorption of Egyptian and imported lentil (K-values) during sorption experiment (g H <sub>2</sub> O / g DM.d <sup>-1</sup> ).....	85
17	Activation energy values for moisture sorption of different legume samples at different water activity values.....	87
18	Values of constant parameters of G.A.B equation for the tested legumes.....	98
19	Calculated Parameters of equilibrium moisture content evaluated in some food legumes by different isotherm equations.....	102
20	Excess binding energy for moisture sorption (qst) as (Kcal / g mole H <sub>2</sub> O) of Egyptian and imported investigated legumes.....	106
21	Effect of equilibrium relative humidity on hardness (kgf) of some legume at 6°C.....	110
22	Effect of equilibrium relative humidity on hardness (kgf) of some legume at 25°C.....	111

23	Effect of equilibrium relative humidity on hardness (kgf) of some legume at 40°C.....	112
24	Hydration coefficient values (%) of Egyptian and imported faba bean as affected by soaking process at different temperatures.....	119
25	Hydration coefficient values (%) of Egyptian and imported cowpea as affected by soaking process at different temperatures.....	122
26	Hydration coefficient values (%) of Egyptian and imported soybean as affected by soaking process at different temperatures.....	124
27	Hydration coefficient values (%) of Egyptian and imported lentil as affected by soaking process at different temperatures.....	127
28	Swelling coefficient values (%) of Egyptian and imported faba bean as affected by soaking process at different temperatures.....	129
29	Swelling coefficient values (%) of Egyptian and imported cowpea as affected by soaking process at different temperatures.....	132
30	Swelling coefficient values (%) of Egyptian and imported soybean as affected by soaking process at different temperatures.....	134
31	Swelling coefficient values (%) of Egyptian and imported lentil as affected by soaking process at different temperatures.....	136
32	Effect of soaking on the hardness (kgf) of Egyptian and imported faba bean at different temperatures.....	139
33	Effect of soaking on the hardness (kgf) of Egyptian and imported cowpea at different temperatures.....	141