

JUSTIFICATION AND INTEREST OF THE WORK.....	1
INTRODUCTION.....	9
I. Edible films and coatings to prevent the detrimental effect of oxygen on food quality: possibilities and limitations.....	23
II. Recent patents on the use of antioxidant agents in food..	63
OBJECTIVES.....	119
RESULTS AND DISCUSSION	
III. Effect of basil and thyme essential oils and homogenization conditions on properties of chitosan based films.....	123
IV. Pork meat product preservation by using chitosan films containing essential oils.....	165
V. Properties of wheat starch film-forming dispersions and films as affected by chitosan addition.....	213
VI. Effect of antioxidant incorporation on the properties of wheat starch-chitosan films.....	269

VII. Physical, structural and antimicrobial properties of poly vinyl alcohol–chitosan biodegradable films.....	305
VIII. Physicochemical and antimicrobial properties of extruded polylactic acid films as affected by chitosan addition.....	349
CONCLUSIONS.....	391

TABLES

Table I.1. Oxygen permeability of edible and synthetic films.....	29
Table I.2. Measurement of the antioxidant capacity of disintegrated edible films.....	34
Table I.3. Peroxide value (PV) development in sunflower oil unprotected, protected with aluminium foil or with sodium caseinate (SC) films incorporated with cinnamon (SC-C) or ginger (SC-G) essential oils.....	40
Table I.4. Application of antioxidant edible films to nuts.....	45
Table I.5. Application of antioxidant edible films to meat and fish products.....	48
Table I.6. Application of antioxidant edible films to fruits and vegetable products.....	50
Table II.1. Composition of some essential oils.....	82
Table III.1. Average diameter $d_{3,2}$, maximum peak in size distributions and ζ -potential. Average values and standard deviations, in brackets.....	142

Table III.2. Water vapour permeability (WVP) and Gloss (60°) of the films at 58-100%RH gradient and 5°C. Average values and standard deviations, in brackets.....	158
Table IV.1: Thickness (mm), oxygen transference rate ($\text{cm}^3 \text{m}^{-2} \text{day}^{-1}$) and Oxygen permeability (OP, $\text{cm}^3 \text{mm m}^{-2} \text{atm}^{-1} \text{day}^{-1}$), at refrigerated conditions and intermediate relative humidity (10°C-58%RH) of all film formulations and both homogenization procedures (rotor-stator: H1; or additionally microfluidized: H2). Average values and standard deviations in brackets.....	188
Table IV.2. Oxygen transference rate ($\text{cm}^3 \text{m}^{-2} \text{day}^{-1}$) and oxygen permeability ($\text{cm}^3 \text{mm m}^{-2} \text{atm}^{-1} \text{day}^{-1}$) of films formulated with pure chitosan (CH), chitosan with basil essential oil 1:1 w/w (CH:B _{1,0}) and chitosan with thyme essential oil 1:1 w/w (CH:T _{1,0}). Average values and standard deviations in brackets.....	189
Table IV.3. Luminosity (L^*), hue (h_{ab}^*) and chroma (C_{ab}^*) of refrigerated minced pork meat samples coated with all film	

formulations and homogenization procedures. Average values and standard deviations in brackets. Initial conditions are in the text.....	196
Table V.1. ζ -potential and rheological parameters (K, n and apparent viscosity at 100s^{-1}) of all FFD.....	234
Table V.2. Thickness, gloss at 60° and roughness parameters (Ra, Rq and ISAD) of the films.....	240
Table V.3. Tensile properties (EM, TS and E%) of all films equilibrated at 58% RH. Mean values and 95% LSD intervals in brackets.....	246
Table V.4. Moisture content (MC) of films stored at 5°C -58%RH and 25°C -58%RH. Water vapour permeability (WVP) of the films at 58-100% RH and 5°C and 25°C	252
Table V.5. Oxygen permeability (OP) of the films at 58-100% RH and 10°C and 25°C	254
Table VI.1. Roughness parameters (Ra, Rq and ISAD) and gloss at 60° of the films. Mean values and standard deviation in brackets.	291

Table VI.2. Lightness (L^*), hue (h^*_{ab}), chroma (C^*_{ab}) and whiteness index (WI) values of the film. Average values and standard deviations in brackets.....	293
Table VI.3. Tensile properties (Elastic modulus: EM, tensile strength: TS and deformation: E %, at break) and thickness of all films equilibrated at 58% RH. Mean values and standard deviations in brackets.....	296
Table VI.4. Moisture content (MC, g water/g dry film) of films equilibrated at 25°C-53% RH. Water vapor permeability (WVP, $\text{g}\cdot\text{mm}\cdot\text{kPa}^{-1}\cdot\text{h}^{-1}\cdot\text{m}^{-2}$) of the films at 58–100% RH and 25°C and Oxygen permeability (OP, $\text{cm}^3\cdot\text{mm}^{-2}\cdot\text{atm}^{-1}\cdot\text{day}^{-1}$) at 25°C-53% RH. Mean values and standard deviation in brackets.....	298
Table VI.5. Trolox equivalent antioxidant capacity (TEAC) of the incorporated antioxidant compounds, expressed as the amount (mg) of the compound which gives the same absorbance reduction as 1mM Trolox solution.....	299

Table VII.1. Thickness, tensile properties (E_{young} , TS and E%) and WVP of the films. Average values and standard deviations, in brackets. The same superscript means homogeneous group in LSD test.....	320
Table VII.2. Thermal characteristics of PVA, CH and PVA:CH blend films.....	336
Table VIII.1. Thermal properties of pure PLA and PLA:CH composite films (first heating scan): Glass transition temperature (T_g); crystallization temperature (T_c); enthalpy of crystallization (ΔH_c); Melting temperature (T_m); Enthalpy of melting (ΔH_m); crystallinity degree (X).....	373
Table VIII.2. Tensile properties and water vapour permeability (WVP) at 10°C and 58-100%RH gradient of pure PLA and PLA:CH composite films. Average values and standard deviations, in brackets.....	376

FIGURES

Figure I.1. Methacrylate cell used to test the antioxidant activity of stand-alone films.....	38
Figure II.1. Natural antioxidant solid line black plant extract....	68
Figure II.2. Chemical structure of α , β , γ and δ tocopherols.....	72
Figure II.3. Flavone (2-phenyl-1,4-benzopyrone) skeleton.....	73
Figure II.4. Chemical structure of resveratrol.....	76
Figure II.5. Chemical structure of anthocyanins.....	77
Figure II.6. Chemical structure of some carotenoids: β -carotene, cryptoxanthin and lycopene.....	79
Figure II.7. Chemical structure of chitosan.....	86
Figure III.1. Particle size distribution in terms of volume of film-formulations with basil (B) or thyme (T) essential oils, at 1% concentration in the film-forming dispersion.....	138
Figure III.2. Typical flow curves, at 25°C, of the film forming dispersions homogenised in rotor-stator (H1: dashed lines) or additionally microfluidized (H2: continuous lines).....	146

Figure III.3. Scanning electron microscopy micrographs of the cross section of films submitted to H1 and H2 homogenization process.....	149
Figure III.4. Typical true stress (σ) vs. Hencky strain (ϵ_H) curves obtained in tensile tests carried out on some composite films submitted to H1 (dotted lines) and H2 (solid lines) homogenization processes.....	153
Figure III.5. Mechanical properties of the films: a)Elastic modulus b)tensile strength and c)percentage of elongation (%E) at break. Mean values and 95% LSD intervals.....	154
Figure IV.1. Progression of the peroxide value (PV) of fat samples covered with the edible films (CH = chitosan, CH:B = chitosan and basil essential oil 1:1 w/w, CH:T = chitosan and thyme essential oil 1:1 w/w), and those unprotected, over storage at (a) 40°C and 43%HR and (b) 40°C and 83%RH. The dotted line represents the initial PV of the fat. Mean values and standard deviation. Different letters (^a , ^b , ^c) indicate significant differences (p<0.05).....	193

Figure IV.2. Microbial counts of minced pork meat samples coated with chitosan-based edible films. Evolution during storage at 10°C. Mean values and 95% LSD intervals. Control = non-coated samples.....	198
Figure IV.3. Microbial counts of minced pork meat samples inoculated with <i>L. innocua</i> or <i>E. coli</i> coated with chitosan-based edible films. Evolution during storage at 10°C. Mean values and 95% LSD intervals. Control = non-coated samples.....	200
Figure V.1. Typical ζ -potential distributions of pure polymers and CH-WS film-forming dispersions. CH: chitosan. WS: wheat starch. The percentage of each polymer in the film-forming dispersion is indicated as a subscript.....	231
Figure V.2. Scanning electron microscopy (SEM) images of cross-sections of the films. CH: chitosan. WS: wheat starch. The percentage of each polymer in the film-forming dispersion is indicated as a subscript.....	237
Figure V.3. AFM images of surface topography of films from pure polymers and selected CH-WS blends. CH: chitosan. WS:	

wheat starch. The percentage of each polymer in the film-forming dispersion is indicated as a subscript..... 239

Figure V.4. Typical true stress (σ) vs. Hencky strain (ϵ_H) curves obtained in tensile tests carried out on pure biopolymer and WS-CH blend films a) after 7 days of storage, b) after 90 days of storage. CH: chitosan. WS: wheat starch. The percentage of each polymer in the film-forming dispersion is indicated as a subscript..... 242

Figure V.5. Effect of storage time on mechanical properties of pure wheat starch films. Mean values and standard deviation. Different letters indicate 95% significant differences..... 249

Figure V.6: Total aerobic and coliform counts of non-coated minced pork samples (control) and samples coated with WS, CH and WS-CH blend films. Mean values and 95% LSD intervals. Dashed line indicates initial counts in minced meat samples. CH: chitosan. WS: wheat starch. The percentage of each polymer in the film-forming dispersion is indicated..... 256

Figure VI.1. Scanning electron microscopy micrographs of the film surface.....	288
Figure VI.2. Scanning electron microscopy micrographs of the cross-sections of the films.....	289
Figure VI.3. Typical AFM images of the surface topography of the films.....	290
Figure VI.4. Typical spectra of internal transmittance (Ti) of the films.....	294
Figure VII.1. Field emission scanning electron microscopy (FESEM) images of cross-sections of the films. PVA: Polyvinyl alcohol, CH: chitosan.....	322
Figure VII.2a. FTIR spectra for pure PVA, pure CH and PVA:CH blend films.....	325
Figure VII.2b. UV-VIS spectra for pure PVA and PVA:CH blend films.....	326
Figure VII.3. Typical true stress (σ) vs. Hencky strain (ϵ_H) curves obtained in tensile tests carried out on pure PVA, pure CH and PVA:CH blend films.....	327

Figure VII.4. a) TG and b) DTG typical curves of pure PVA, pure CH and PVA:CH blend films.....	333
Figure VII.5. DSC thermograms a) Cooling scan and b) Second heating scan for pure PVA and PVA:CH blend films.....	334
Figure VII.6. Microbial counts of minced pork meat samples coated with PVA:CH films after 7 days storage at 10°C. Mean values and 95% LSD intervals. Control = non-coated samples. Different letters indicate significant differences ($p < 0.05$) due to film formulation (^{a, b, c}).....	338
Figure VIII.1. Images of pure PLA films and PLA:CH composite films. PLA: Polylactic acid, CH: chitosan. The percentage of each polymer is indicated as a subscript.....	363
Figure VIII.2. UV-VIS spectra of pure PLA and PLA:CH composite films. PLA: Polylactic acid, CH: chitosan. The percentage of each polymer is indicated as a subscript.....	364
Figure VIII.3. Field emission scanning electron microscopy (FESEM) images of different granulometries of chitosan: a) G1 and b) G2.....	365

Figure VIII.4a. Field emission scanning electron microscopy images of the surface of PLA and PLA:CH composite films. Polylactic acid, CH: chitosan. The percentage of each polymer in the film is indicated as a subscript.....	367
Figure VIII.4b. Scanning electron microscopy images of the cross-sections of PLA and PLA:CH composite films. Polylactic acid, CH: chitosan. The percentage of each polymer in the film is indicated as a subscript.....	368
Figure VIII.5. a) TG and b) DTG curves of PLA and different PLA:CH composite films. PLA: Polylactic acid, CH: chitosan. The percentage of each polymer is indicated as a subscript.....	370
Figure VIII.6. First heating DSC scan for pure PLA and PLA:CH composite films. PLA: Polylactic acid, CH: chitosan. The percentage of each polymer is indicated as a subscript.....	372
Figure VIII.7. Typical true stress (σ) vs. Hencky strain (ϵ_H) curves obtained in tensile tests carried out on PLA and PLA:CH composite films. PLA: Polylactic acid, CH: chitosan. The percentage of each polymer is indicated as a subscript.....	374

Figure VIII.8. Microbial counts of minced pork meat samples coated with PLA and PLA:CH after 10 days of cold-storage. Mean values and 95% LSD intervals. Control = non-coated samples. Initial count is indicated by the dashed line..... **378**