

CONTENTS

| | |
|--|-----|
| RESUM | i |
| RESUMEN | iii |
| SUMMARY | v |
| ACKNOWLEDGEMENTS | vi |
| NOTATION | x |
| | |
| 1.INTRODUCTION | 1 |
| | |
| 1.1.DRY CURED HAM MANUFACTURING PROCESS | 4 |
| 1.1.1.Manufacturing process | 4 |
| 1.1.2.Drying equipment | 8 |
| | |
| 1.2. DESCRIPTION OF THE HAM | 10 |
| | |
| 1.3. MUSCLE AND MEAT | 13 |
| 1.3.1. Muscle Structure | 14 |
| 1.3.2. Postmortem biochemistry of muscle | 15 |
| 1.3.3. Water and meat | 17 |
| 1.3.3.1. Nature of water in the living muscle fibres | 17 |
| 1.3.3.1.1. Relation between fibre volume and muscle volume | 18 |
| 1.3.3.2. Nature of water in meat | 19 |
| 1.3.3.2.1. Bound water capacity | 19 |
| 1.3.3.2.2. Water holding capacity | 20 |
| | |
| 1.4. THE STRUCTURE OF WATER IN BIOLOGICAL SYSTEMS | 25 |
| | |
| 1.5. WET SOLID–HUMID GAS EQUILIBRIUM · WATER ACTIVITY | 29 |

| | |
|--|----|
| 1.5.1. Definition | 29 |
| 1.5.2. Measurement of water activity | 32 |
| 1.5.3. Sorption isotherm model | 33 |
| 1.5.4. Sorption isotherms of solid mixtures | 34 |
| 1.5.4.1. Linear mixing rule | 35 |
| 1.5.4.2. Salwin and Slawson method | 35 |
| 1.5.4.3. Ross's method | 36 |
| 1.5.4.4. Chuang and Toledo method | 36 |
| 1.5.4.5. Lang and Steinberg method | 36 |
| 1.5.5. Factors affecting water activity | 38 |
| 1.5.5.1. Temperature | 38 |
| 1.5.5.2. NaCl | 39 |
| 1.5.5.3. Heat treatment and freeze storage | 40 |
| 1.5.5.4. Composition | 40 |
| 1.5.6. Data of water activity and sorption isotherms in meat | 42 |
| 1.5.6.1. Reported data | 42 |
| 1.5.6.2. Reported models | 43 |
| 1.5.6.3. Predictive methods for solids mixtures | 47 |
| 1.5.6.4. Water activity and sorption isotherms in fat | 47 |
| | |
| 1.6. WATER DIFFUSION IN MEAT | 50 |
| 1.6.1. Mass transfer by diffusion in meat | 50 |
| 1.6.1.1. Fick's Laws | 52 |
| 1.6.1.2. Drying kinetics | 56 |
| 1.6.1.2.1. Drying curve | 59 |
| 1.6.2. Effective diffusivity determination | 62 |
| 1.6.2.1. Methods | 62 |
| 1.6.2.1.1. Sorption kinetics | 62 |
| 1.6.2.1.2. Permeation method | 64 |

| | |
|--|-----------|
| 1.6.2.1.3. Concentration-distance curves | 68 |
| 1.6.2.1.4. Drying methods | 70 |
| 1.6.3. Factors affecting water diffusivity | 76 |
| 1.6.3.1. Temperature | 76 |
| 1.6.3.2. Heat of sorption and activation energy | 77 |
| 1.6.3.3. Composition of meat | 78 |
| 1.6.3.3.1. Water Content | 78 |
| 1.6.3.3.2. Salt content | 80 |
| 1.6.3.3.3. Fat and protein | 84 |
| 1.6.3.4. pH | 84 |
| 1.6.3.5. Structure | 84 |
| 1.6.3.5.1. Shrinkage | 85 |
| 1.6.3.6. Air Relative Humidity | 87 |
| 1.6.3.7. Air Pressure and Air Components | 88 |
| 1.6.3.8. Other factors | 89 |
| | |
| 2. OBJECTIVES | 91 |
| | |
| 3. MATERIAL AND METHODS | 93 |
| | |
| 3.1. MEAT SORPTION ISOTHERMS | 93 |
| 3.1.1. Sorption Equipment | 93 |
| 3.1.2. Sample preparation | 94 |
| 3.1.3. Measurement procedure | 95 |
| 3.1.4. Preparation of the NaCl brine | 95 |
| 3.1.5. Procedure diagram | 96 |
| 3.1.6. Sorption isotherm mathematical models | 97 |
| 3.1.6.1. Theoretical and empirical sorption isotherm models applied to meat | 98 |

| | |
|---|------------|
| 3.1.6.1.1. Model type I. Isotherm equations considering the effect of temperature and salt content by means of coefficients | 98 |
| 3.1.6.1.2. Model type II. GAB and Mujica models considering the effect of NaCl content by means of coefficients and considering the effect of temperature using Clausius-Clapeyron equation | 100 |
| 3.1.6.2. Predictive methods for solid mixtures | 101 |
| 3.1.6.2.1. Mixing rules | 101 |
| 3.1.6.2.2. Application of the predictive methods | 102 |
| 3.2. EFFECTIVE WATER DIFFUSIVITY | 105 |
| 3.2.1. Method 1: experiments developed in a drying tunnel | 105 |
| 3.2.1.1. Experimental equipment | 106 |
| 3.2.1.2. Sample preparation | 107 |
| 3.2.1.3. Drying procedure | 107 |
| 3.2.1.4. Mathematical model | 110 |
| 3.2.1.4.1. The Fickian diffusion approach | 110 |
| 3.2.1.4.2. Equation fitting procedure | 114 |
| 3.2.2. Method 2: experiments developed in a drier-box | 115 |
| 3.2.2.1. Experimental equipment | 116 |
| 3.2.2.2. Sample preparation | 117 |
| 3.2.2.3. Salting process | 118 |
| 3.2.2.4. Preparation of the NaCl Brine | 119 |
| 3.2.2.5. Drying Procedure | 119 |
| 3.2.2.6. Procedure diagram | 120 |
| 3.2.2.7. Diffusion model | 123 |
| 3.2.2.7.1. Definition of the model | 123 |
| 3.2.2.7.2. Equation fitting procedure | 124 |
| 3.2.3. Chemical analysis | 125 |
| 3.2.4. Statistical analysis | 125 |

| | |
|---|------------|
| 3.2. REMARKS ABOUT THE METHODOLOGY USED | 127 |
| 4. RESULTS AND DISCUSSION | 129 |
| 4.1. WATER ACTIVITY | 129 |
| 4.1.1. Theoretical and empirical sorption isotherm models applied to meat | 134 |
| 4.1.1.1. Model type I. Isotherm equation considering the effect of temperature and NaCl content by means of coefficients | 134 |
| 4.1.1.2. Model type II. GAB and Mujica models considering the effect of NaCl content by means of coefficients and considering the effect of temperature using Clausius-Clayperon equation | 136 |
| 4.1.2. Predictive methods for solid mixtures | 145 |
| 4.2. EFFECTIVE WATER DIFFUSIVITY | 151 |
| 4.2.1. Method 1: experiments developed in a drying tunnel | 151 |
| 4.2.1.1. Effect of boundary conditions on De | 151 |
| 4.2.1.2. Effect of water content dependence and shrinkage on De | 155 |
| 4.2.2. Method 2: experiments developed in a drying-box | 160 |
| 4.2.3. Air relative humidity used in the drying-box method | 160 |
| 4.2.4. Study of the De estimation using different number of terms on the analytical solution | 161 |
| 4.2.5. Effect of sample length on the estimated De value | 162 |
| 4.2.6. Remarks on the drying-box methodology | 164 |
| 4.2.7. Effect of NaCl content and temperature on De | 165 |
| 4.2.8. Effect of meat fiber direction on De | 169 |
| 4.2.9. Effect of muscle on De | 171 |
| 4.2.10. Effect of DFD muscle on De | 172 |

| | |
|---|-----|
| 5. CONCLUSIONS | 175 |
| 6. REFERENCES | 177 |
| APPENDIX A: DERIVATION OF THE GOVERNING EQUATION FOR SOLID DRYING WITH SHRINKAGE | 187 |
| APPENDIX B: SORPTION ISOTHERM EXPERIMENTAL DATA | 193 |