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# Modelling the Effect of Asparaginase in Reducing Acrylamide Formation in Biscuits

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1 **Modelling the effect of asparaginase in reducing acrylamide**  
2 **formation in biscuits**

3

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25

26 Abstract

27 The influence of asparaginase on acrylamide formation as well as colour development  
28 in short dough biscuits was studied. In particular, asparaginase concentration,  
29 incubation time and temperature were changed according to an experimental design. As  
30 acrylamide formation resulted to vary significantly between biscuits obtained by using  
31 the same ingredients and process, a mixed effect model was used to model variation of  
32 acrylamide concentration. By contrast a fixed effect model was used for colour  
33 polynomial analysis. Within the range of study, the overall results allowed to find the  
34 best conditions to minimise acrylamide formation. It can be suggested that acrylamide  
35 development is minimum at intermediate asparaginase concentrations and lowest time  
36 and temperature of incubation. Asparaginase addition did not affect significantly the  
37 colour of the final product, although the quadratic term of the incubation temperature  
38 slightly did.

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40 Keywords: Acrylamide, Asparaginase, Biscuits, Colour, Modelling.

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## 51 **1. Introduction**

52 Acrylamide is a toxic and probably human carcinogen molecule (IARC, 1994) that can  
53 form in heated foods as a consequence of the reaction between asparagine and a  
54 carbonyl source via Maillard-type reactions (Mottram, Wedzicha, & Dodson, 2002;  
55 Stadler et al., 2002; Zyzak et al., 2003; Becalski, Lau, Lewis, & Seaman, 2003;  
56 Yaylayan & Stadler, 2005). Important acrylamide dietary sources are staple foods such  
57 as potato derivatives, cereal products and coffee (IRMM, 2005; FDA, 2006). Many  
58 potential routes have been identified to reduce acrylamide levels in foods. These are  
59 relevant to agronomical and technological strategies (CIAA, 2009). Among the latter  
60 are interventions based on precursor consumption, i.e. fermentation and asparaginase  
61 pre-treatments.

62 Asparaginase pre-treatment of raw potatoes and doughs has been claimed to reduce  
63 effectively acrylamide levels without altering the appearance and taste of the final  
64 product (Zyzak et al., 2003; Ciesarová, Kiss, & Boegl, 2006; Hendriksen, Stringer,  
65 Ernst, Held-Hansen, Schafermayer, & Corrigan, 2006; Ciesarová, Kukurová,  
66 Bednáriková, Marková, & Baxa, 2009; Kukurová, Morales, Bednáriková, & Ciesarová,  
67 2009; Capuano et al, 2009; Ciesarová, Kukurová, & Benešová 2010). Also, the  
68 effectiveness of asparaginase in reducing acrylamide is testified by a number of patent  
69 applications concerning different processed foods, such as snack foods, chips, dough  
70 foods, etc. (Elder, Fulcher, & Leung, 2006; Elder, Fulcher, Kin-Hang Leung, & Topor,  
71 2007; Corrigan, 2008; de Boer, 2008). As it is well known asparaginase catalyzes the  
72 hydrolysis of asparagine into aspartic acid and ammonia, thereby specifically removing  
73 a key precursor for acrylamide formation. The commercial enzyme based on cloning of  
74 *Aspergillus oryzae* has received the generally recognized as safe status from the US and  
75 has been given a favourable evaluation by the Joint FAO/WHO Expert Committee on

76 Food Additives (JECFA, 2007). It is now permitted for use in the United States,  
77 Australia, New Zealand, and Denmark. In Canada, where enzymes used in food  
78 applications may be considered food additives, amendments to the Regulations that will  
79 allow the use of asparaginase as a food additive has been proposed (Health Canada,  
80 2009). In 2008, the Standing Committee on the Food Chain and Animal Health  
81 authorised the use of asparaginase for bakery product manufacturing in two EU Member  
82 States, as a processing aid, since the manufactures have stated that the enzyme is  
83 inactivated during heat processing such as baking (SANCO, 2008).

84 Studies have shown that asparaginase activity is affected by enzyme dose, reaction time,  
85 temperature and pH at which the reaction occurs (Hendriksen, Kornbrust, Østergaard, &  
86 Stringer, 2009). In particular, the *A. oryzae* asparaginase was shown to be most active in  
87 the neutral pH range and at temperatures up to 60 °C. Furthermore, the enzyme activity  
88 is influenced by the contact with the substrate. In fact, a limited mobility of substrate  
89 and enzyme would be responsible for incomplete hydrolysis of asparagine and only  
90 partial reduction in acrylamide formation. In this regard the food  
91 decompartmentalisation as well as the water content of the reaction environment could  
92 greatly affect asparaginase efficacy in reducing acrylamide formation. In fact, great  
93 reductions of acrylamide content could be achieved by using relatively low asparaginase  
94 concentrations in formulated foods (up to 1000 U/kg), such as bakery products and  
95 potato-based snacks, as a good enzyme distribution in the system can be reached. On the  
96 contrary, very high concentrations of asparaginase (>10000 U/L of pre-frying dipping  
97 solution) are necessary to obtain a significant reduction of acrylamide in fried potatoes  
98 (Pedreschi, Kaack, & Granby, 2008). However, also in this case, any technological  
99 operation which favours the substrate diffusion and its contact with the enzyme can lead  
100 to a greater reduction of acrylamide levels. This is the case of potato pieces treated with

101 asparaginase after blanching (Hendriksen et al., 2009). In fact, blanching reduces the  
102 integrity of the potato, weakening the cell wall and membrane thereby improving the  
103 substrate-enzyme contact. Besides, especially when asparaginase is added to food  
104 formulations, the water content should be sufficiently high for mobility of reactants and  
105 facilitate the contact between enzyme and substrate (Amrein, Schoenbaechler, Escher,  
106 & Amadò, 2004; Hendriksen et al., 2009). For this reason the enzyme resulted more  
107 effective when added in the aqueous phase of the dough preparation instead of in the  
108 mixture.

109 No fundamental modelling of the effect of asparaginase on this process is available.  
110 Due to the complexity of the relationship between the environmental variables involved  
111 in the enzymatic process and acrylamide formation, ii) the effective enzymatic activity  
112 and iii) the final acrylamide concentration achieved, a study of these relationship is  
113 needed to find the best conditions to minimise acrylamide formation.

114 Natural variability in baking processes is an influencing factor and acrylamide  
115 formation has been seen to vary significantly between items with similar ingredients and  
116 cooking procedures (Levine & Smith, 2005). Evenmore, Bråthen and Knutsen (2005)  
117 showed how variability played an important role in starch systems affecting the final  
118 value of acrylamide after a baking process. If this process is to be scaled-up this  
119 variability needs to be assessed so that tolerances may be established within the normal  
120 ranges of variability of an industrial process (Aguirre, Frias, Barry-Ryan, & Grogan,  
121 2008).

122 The aim of this study was to investigate the influence of asparaginase in reducing  
123 acrylamide formation in short dough biscuits. The effect of asparaginase addition on  
124 browning development was also investigated. In particular, asparaginase concentration,

125 incubation time and temperature were modulated according to a three variable, three  
126 level central composite design.

127

## 128 **2. Materials and methods**

### 129 *2.1. Sample preparation*

130 Short dough biscuits were prepared according to the slightly modified formulation by  
131 Gallagher, Kenny and Arendt (2005). The formulation consisted of flour, margarine  
132 (Unigrà, Italy), sucrose (Carlo Erba, Milano Italy), water, glucose (Carlo Erba, Milano  
133 Italy), salt (Carlo Erba, Milano Italy), asparagine (Sigma-Aldrich, Italy) and baking  
134 powder (sodium hydrogen carbonate, disodium diphosphate, dried starch) (Cameo,  
135 Italy). The non-flour ingredients were added to the recipe at 40, 35, 20, 5, 0.7, 0.1 and  
136 0.5% flour weight, respectively. Different levels of asparaginase (Novozymes A/S,  
137 Denmark, 3500 U/g) in the range from 100 U/kg of flour to 900 U/kg of flour were  
138 added to this recipe according to a three-factor, three-level face centered cube central  
139 composite design (CCD) (Table 1). To assure a homogeneous distribution in the dough,  
140 asparaginase was dispersed in the aqueous phase before to be added to the dry  
141 ingredients. After mixing and a 30 min resting time at 4 °C, the dough was sheeted to  
142 0.3 cm thickness, cut to a diameter of 7 cm and left in a thermostatic cell at different  
143 incubation temperatures and times according to the CCD (Table 1). In particular, the  
144 incubation temperature ranged from 20 °C to 54 °C and the incubation time from 10  
145 min to 30 min. According to literature data, the enzyme is active within these variable  
146 ranges (Hendriksen et al., 2009). In addition, the chosen temperature and reaction time  
147 may roughly correspond to the resting temperatures and time generally applied for the  
148 dough at industrial level. The samples were baked in an air-circulating oven (Salvis  
149 Thermocenter, Oakton, Vernon Hills, IL, USA) at 200 °C up to a final moisture of 2%.

150 Biscuits prepared without asparaginase addition were taken as a control. In order to  
151 assess the variability of this process, simulating an industrial situation, this process was  
152 repeated with 6 different batches of dough biscuits.

153

## 154 2.2. Analysis of acrylamide

155 Acrylamide determination was carried out according to the method of Anese,  
156 Bortolomeazzi, Manzocco, Manzano, Giusto and Nicoli (2009). Briefly, 1000  $\mu\text{L}$  of an  
157 aqueous solution of 2,3,3- $^2\text{H}_3$  acrylamide ( $\text{d}_3$ -acrylamide) (0.20  $\mu\text{g}/\text{mL}$ ) (Isotec, Sigma-  
158 Aldrich, Italy) as internal standard and 15 mL of water Milli Q (Millipore, Italy) were  
159 added to 1 g of finely ground biscuit weighed into a 100 mL centrifuge tube. After  
160 extraction at 60  $^\circ\text{C}$  for 30 min under magnetic stirring, the mixture was centrifuged at  
161 12000 x g for 15 min at 4  $^\circ\text{C}$  (Beckman, Avanti Centrifuge J-25, Palo Alto, CA, USA).  
162 Aliquots of 10 mL of the clarified aqueous extract were cleaned-up by solid phase  
163 extraction (SPE) on an Isolute Env+, 1 g (Biotage, Sweden). The volume of the eluted  
164 fraction was reduced under vacuum, to about 1.5 – 2 mL by using a rotary evaporator at  
165 a temperature of 80  $^\circ\text{C}$  and filtered through a 0.45  $\mu\text{m}$  membrane filter before the  
166 HPLC-MS analysis. LC-ESI-MS-MS in positive ion mode analyses were performed by  
167 a Finnigan LXQ linear trap mass spectrometer (Thermo Electron Corporation, San Josè,  
168 CA, USA) coupled to a Finnigan Surveyor LC Pump Plus equipped with a thermostated  
169 autosampler and a thermostated column oven. The analytical column was a Waters  
170 Spherisorb ODS2 (250 x 2.0 mm, 5  $\mu\text{m}$ ). Elution was carried out at a flow-rate of 0.1  
171 mL/min, in isocratic conditions, at 30  $^\circ\text{C}$  using as mobile phase a mixture of 98.9%  
172 water, 1% methanol and 0.1% formic acid (v/v/v). Full scan MS/MS was carried out by  
173 selecting the ions at  $m/z$  72 and  $m/z$  75 as precursor ions for acrylamide and  $\text{d}_3$ -  
174 acrylamide respectively. The area of the chromatographic peaks of the extracted ion at



175  $m/z$  55, due to the transition  $72 > 55$ , and at  $m/z$  58, due to the transition  $75 > 58$  were  
176 used for the quantitative analysis. The quantitative analysis was carried out with the  
177 method of the internal standard. The relative response factor of acrylamide with respect  
178 to  $d_3$ -acrylamide was calculated daily by analyzing a standard solution. For each run,  
179 analyses were made in duplicate on six replicated experiments. Acrylamide  
180 concentration was expressed as ng/g of dry matter.

181

### 182 *2.3. Analysis of colour*

183 Colour analysis was carried out on sample surface using a tristimulus colorimeter  
184 (Chromameter-2 Reflectance, Minolta, Osaka, Japan) equipped with a CR-300  
185 measuring head. The instrument was standardized against a white tile before  
186 measurements. Colour was expressed in  $L^*$  (lightness/darkness),  $a^*$  (redness/greenness)  
187 and  $b^*$  (yellowness/blueness) scale parameters. The total colour change in the  $L^*$ ,  $a^*$ ,  $b^*$   
188 colorimetric space,  $\Delta E^*$ , was then calculated from Eq. (1) (Clydesdale, 1978):

189

$$190 \quad \Delta E^* = (((L^* - L_0^*)^2 + (a^* - a_0^*)^2 + (b^* - b_0^*)^2)^{1/2}) \quad \text{Eq. (1)}$$

191

192 where  $L^*$ ,  $a^*$ ,  $b^*$  are the actual colour values and  $L_0^*$ ,  $a_0^*$  and  $b_0^*$  are the colour values  
193 for a control sample, i.e. obtained without asparaginase addition.

194 For each run, analyses were made at least in triplicate on three replicated experiments.

195

### 196 *2.4. Determination of total solid content*

197 Total solid content was determined by gravimetric method by drying the samples in a  
198 vacuum oven (1.32 kPa) at 75 °C until a constant weight.

199

200 2.5. Polynomial equations and statistical analysis

201 Modelling was aimed at describing the variation of acrylamide concentration and colour  
202 data as a function of the variables of the central composite design.

203 In the case of acrylamide analysis, coded variables were used to model this variation:

204

205 
$$x = \frac{x - \bar{x}}{\Delta x / 2} \quad \text{Eq. (2)}$$

206

207 where  $x$  is the explanatory variable normalised,  $\bar{x}$  is the average of the variable and  
208  $\Delta x$  is the range between the maximum and minimum value of  $x$ .

209 The lme and lme4 libraries of the R software package (R Development Core Team,  
210 2009) were used to fit a mixed effects model with the following components:

- 211 1. A fixed effect component containing a second order polynomial model to the  
212 dependant variables.  
213 2. A random effect component that contains the effect of variability on the  
214 acrylamide formation.

215

216 This resulted in the following model:

217

218 
$$y = B_0 + \sum B_i x_i + \sum B_{ii} x_i^2 + \sum B_{ij} x_i x_j + Zb + \varepsilon, \quad \varepsilon \sim N(0, \sigma^2), \quad b \sim N(0, \sigma^2 E) \quad \text{Eq. (3)}$$

219

220 where  $B_0$  is a constant and  $B_i, B_{ii}, B_{ij}$  are regression coefficients of the model and  $x_i$  and  
221  $x_j$  are independent variables in coded values. The vector  $b$  represents the random effects,  
222 i.e. variations due to random nature associated to a  $Z$  model matrix with a relative  
223 variance-covariance matrix  $E$  which contains possible predictors influencing the

224 variability of the acrylamide concentration. N denotes the multivariate normal  
225 distribution (Pineiro & Bates, 2000).

226 In the case of colour analysis, Statistica for Windows (Statsoft Inc., 1993) was used to  
227 fit the second order models to the dependant variables using the following equation:

228

$$229 \quad y = B_0 + \sum B_i x_i + \sum B_{ij} x_i x_j + \sum B_{ii} x_i^2 \quad \text{Eq. (4)}$$

230 The criteria for eliminating a variable from the full regression equation was based on  
231  $R^2$ , standard error to estimate (SE) and significance F-test (and the derived p values).

232

### 233 **3. Results and discussion**

234 Table 2 shows acrylamide mean values and the corresponding standard deviations of  
235 short dough biscuits added with asparaginase according to the CCD. For each run of the  
236 CCD, the results of acrylamide concentration were based on two replicated analyses on  
237 six different batches of short dough biscuits, i.e. made using the same recipe and  
238 process. Although repetitions within each batch were good with standard deviations  
239 ranging from 0.1 to 10, results among batches of each run varied greatly. For instance,  
240 the acrylamide levels in asparaginase-treated made with 500 U/kg of flour and a 20 min  
241 incubation time at 20 °C (run 12) ranged from 49 to 120 ng/g<sub>dm</sub>, with an average of 90  
242 ng/g<sub>dm</sub> and a coefficient of variation of 25%. Similar experimental variations were  
243 found by Hendriksen et al. (2009) in semisweet biscuits. The variation components  
244 arising from the analysis of acrylamide or from replicates of the same experimental  
245 conditions with the same batch of biscuit were not big enough to contribute to this 25%  
246 of variation and therefore it was concluded that the origin of this arised from the

247 preparation and processing of different batches of biscuit. In the light of a possible  
248 variation between batches of biscuits been prepared, data were analysed by using a  
249 mixed effect model (Pineiro & Bates, 2000). The two components of the model were  
250 a) fixed effects, that included all the effects of the variation of the dependent variables  
251 (asparaginase dose, incubation temperature and time) which affect the acrylamide  
252 concentration in a statistically significant manner; b) random effects, which include the  
253 variation in final acrylamide concentrations that are due to changes among batches of  
254 the biscuit dough.

255 Table 3 shows the result of the polynomial mixed effect regression. All non-significant  
256 fixed terms were deleted from the model following an iterative process until the model  
257 was satisfactory. As it can be seen in the table there are two quadratic effects, pointing  
258 to two variables with possible minima-maxima. No significant correlation between  
259 estimates was found, indicating that these parameter estimates and the standard errors  
260 were estimated accurately. Fig. 1 diagnostic plots indicate that the residuals variance  
261 was constant and that it followed approximately a normal distribution.

262 Fig. 2 shows the importance of the different regression variables in the acrylamide  
263 formation. As it can be seen, within the margins of the present study, the variable that  
264 has a bigger effect is the concentration of asparaginase introduced, followed by the  
265 temperature effect. The incubation time of the asparaginase infused dough seems to be  
266 the least important variable, being found mainly at the bottom of the Pareto chart. This  
267 points to the result that within the present conditions, variations in temperature and/or  
268 asparaginase will affect a bigger change in the final acrylamide concentration of the  
269 biscuits. These results are in agreement with those reported by Hendriksen et al. (2009)  
270 for semisweet biscuits incorporated with asparaginase. Models including random effects

271 depending on the temperature, asparaginase inoculation and incubation time were built,  
272 however none of them contributed to increase the quality of the fit, as the log-  
273 likelihood ratio test did not proof significant for any of the models ( $p < 0.05$ ). As a result,  
274 the batch-to-batch variation was modelled as a random intercept process. The  
275 importance of this random process can be seen in the magnitude of the standard  
276 deviation of it compared to any of the normalised coefficients in the model.

277 The batch-to-batch variability can be attributed to a non homogeneous distribution of  
278 the enzyme in the dough. This in turn can be ascribable either to the fact  
279 that very small quantities of the enzyme are incorporated to  
280 the other ingredients of the dough so that it cannot be uniformly  
281 distributed, or to a matrix effect. In the latter case, it can be suggested that the presence  
282 of fat contributes to create hydrophobic zones where the activity of the aqueous  
283 enzymatic suspension is limited.

284 The matrix effect could also explain the lower average percentage reductions of  
285 acrylamide levels due to asparaginase activity as compared to most of the data reported  
286 in the literature. In fact, we found that asparaginase contributed to reduce acrylamide  
287 concentration by 27 to 70% (Table 4), while the reductions reported in the literature are  
288 on average higher than 85-90% (Zyzak et al., 2003; Ciesarová et al., 2006; Kukurová et  
289 al., 2009; Capuano et al., 2009). These differences in asparaginase efficiency can be  
290 attributable to the different complexity from the compositional standpoint of the  
291 systems considered. In fact, the above mentioned papers deal with food model systems,  
292 i.e. made with starch, sugar and water, whereas, in the present study, biscuits obtained  
293 by using additional ingredients, such as fat and salt, were considered. It must be pointed

294 out that our results are in agreement with those of Hendriksen et al. (2009), who also  
295 considered real food systems.

296 From Table 3 are two possible minima of acrylamide, in the asparaginase concentration  
297 and with the incubation time. In Fig. 3 and 4 contour plots of the acrylamide in respect  
298 of the experiment variables are presented. It can be seen that there is a minimum of  
299 acrylamide formed at intermediate asparaginase concentrations (500 U/kg of flour) the  
300 lowest incubation time and temperature.

301 It is interesting to note how high values of asparaginase seem to increase greatly the  
302 final amount of acrylamide found and that excessive asparaginase inoculation followed  
303 by high incubation times may actually increase the average acrylamide in the biscuits,  
304 in comparison with low additions of asparaginase. However, within the range of the  
305 study, if the final inoculum of asparaginase is well controlled and the incubation  
306 temperature is kept to a minimum, it is reasonable to admit that there will be a decrease  
307 of acrylamide concentration in the biscuit no matter what the incubation time will be.

308 Fig. 5 shows a stochastic simulation of the final levels of acrylamide under 500 U/kg of  
309 asparaginase with 10 min of incubation time at 20 °C, which are the conditions  
310 providing a minimum acrylamide concentration in the region of study. It can be seen  
311 that even with the variation between batches of biscuits, the optimal conditions can  
312 ensure that concentrations of acrylamide will not go over 138 ng/g<sub>dm</sub> with a coverage of  
313 95% of all batches. This is in contrast with the worse conditions observed (maximum  
314 asparaginase added, maximum temperature of incubation at the shortest incubation  
315 time) which produce an acrylamide 282 ng/g<sub>dm</sub> with coverage of 95% of all the batches  
316 of bread and samples.

317 Besides its feasibility and compatibility with the existing industrial process, acrylamide  
318 mitigation in biscuits by means of asparaginase addition has to take into account its  
319 effects on the sensory properties of foods. To this regard, the effect of asparaginase  
320 addition on the colour of the biscuits was studied. The results of the polynomial  
321 regression of total colour change data are shown in Table 5. In this case the mixed effect  
322 modelling was not included in the design because the colour data variability could be  
323 assigned to a single experimental error term. A random distribution of residuals was  
324 found. As it can be seen, the total colour change was significantly affected only by the  
325 quadratic term of the incubation temperature, while neither the asparaginase  
326 concentration nor the time influenced this parameter. This result is in agreement with  
327 observations made by other Authors who did not find any significant change in colour  
328 between asparaginase untreated and treated food systems (Capuano et al., 2009;  
329 Kukurová et al., 2009). It is likely that the temperature adopted during dough incubation  
330 may influence the development of non-enzymatic browning reactions: the higher the  
331 incubation temperature the higher the rate of the reaction that leads to the formation of  
332 brown molecules. It is worth to noting that, due to the low temperature estimate value,  
333 in the range of incubation temperatures compatible with the enzyme activity (20 to 60  
334 °C), the total colour change can vary in a narrow range of values, i.e. between 2 and 8.

335

#### 336 **4 Conclusions**

337 This study showed a strategy to assess the benefit of asparaginase in reducing the  
338 acrylamide formation in biscuits for managing the industrial process. The model used in  
339 this study allowed for the assessment of the effect of the natural variability associated to  
340 the baking process in final acrylamide concentration, besides the variation of the  
341 selected dependent variables. It can be concluded that, within the range of study, an

342 intermediate asparaginase concentration of 500 U/kg combined with the lowest time and  
343 temperature of incubation effectively reduced acrylamide formation in short dough  
344 biscuits without affecting the colour of the final product.

345

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349

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**Caption for figures**

**Fig. 1.** Residual against fitted values (left) and residual quantiles against standard normal quantiles (right) plots of the polynomial mixed effects model.

**Fig. 2.** Effects plot for the fixed part of the polynomial model.

**Fig. 3.** Dependence of acrylamide concentration with asparaginase concentration and incubation time at the lowest incubation temperature.

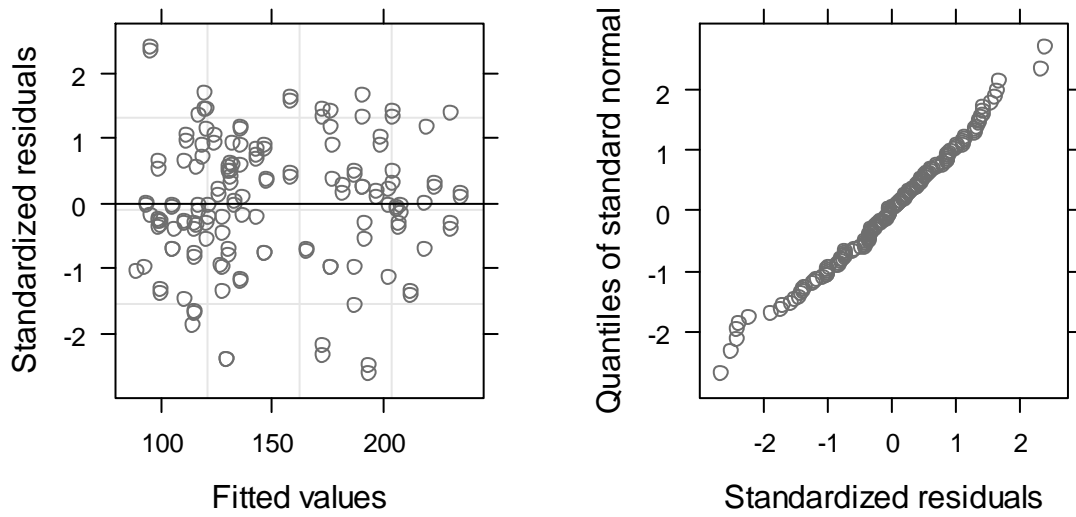
**Fig. 4.** Contour of the dependence of acrylamide concentration with the normalised asparaginase concentration and incubation temperature at the lowest incubation time.

**Fig. 5.** Uncertainty assessment of the variability of acrylamide for the optimal conditions of intermediate asparaginase content, minimum incubation temperature and minimum incubation time.

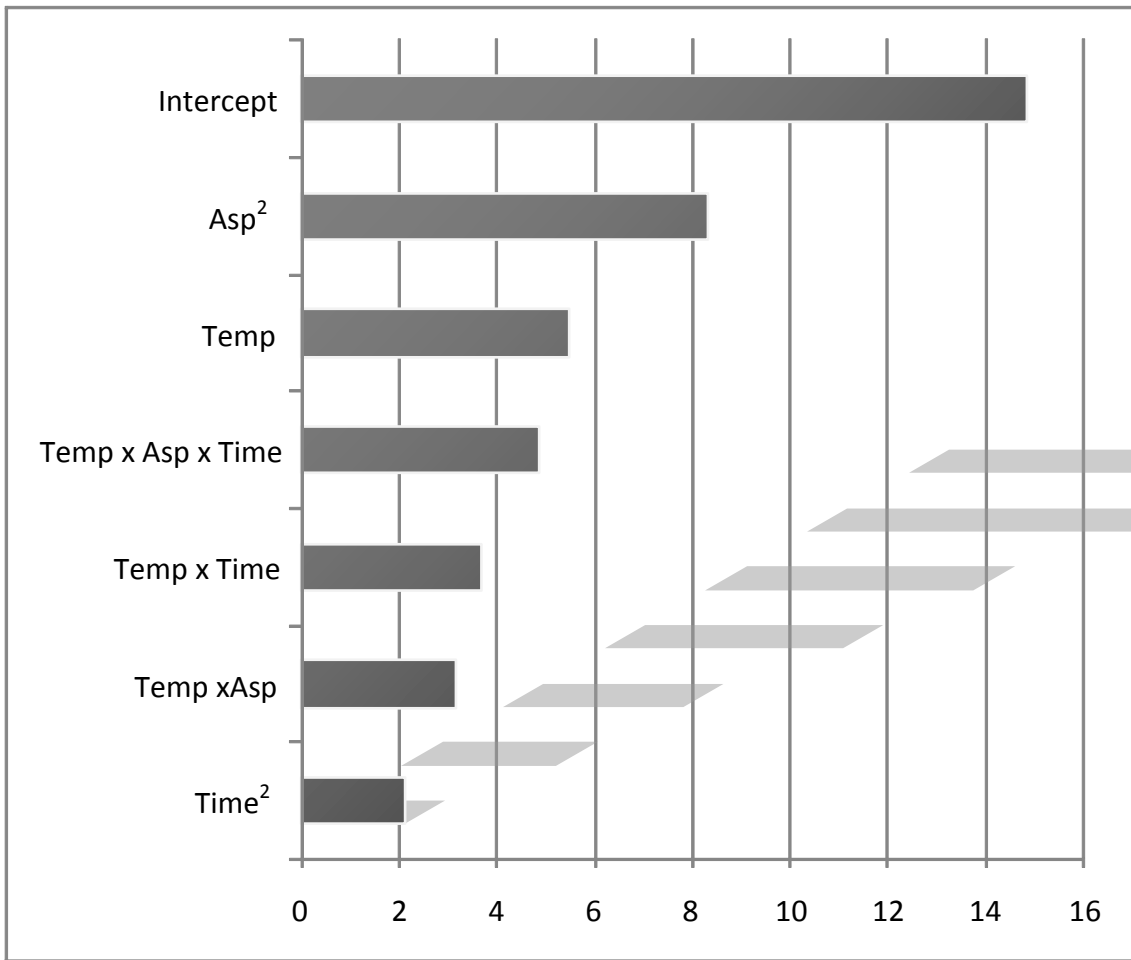
**Table 2**

Acrylamide mean values and corresponding standard deviations of short dough biscuits added with asparaginase according to the CCD

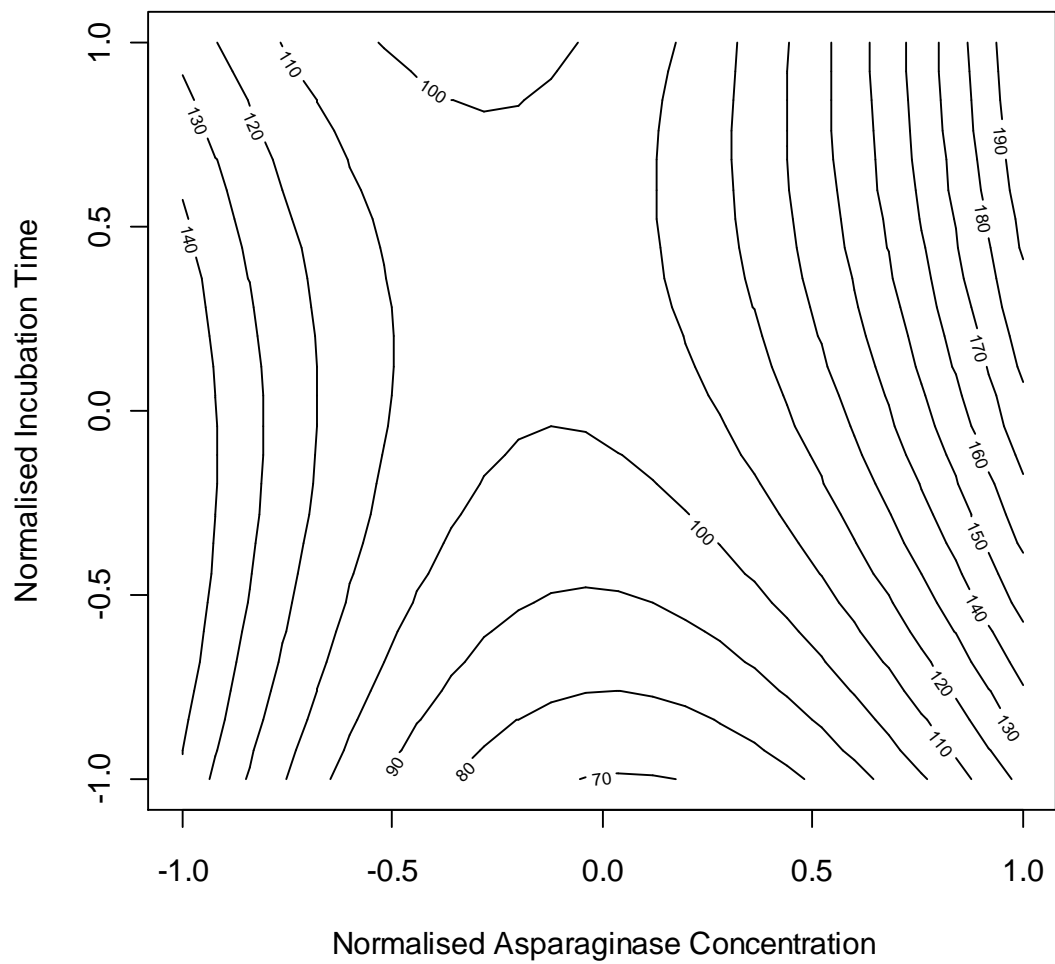
Run	Acrylamide concentration (ng/g <sub>dm</sub> )	Standard deviation
1	142.1	59.8
2	111.2	39.2
3	200.4	40.3
4	201.8	31.0
5	137.0	43.4
6	203.3	8.2
7	229.1	25.3
8	140.0	31.8
9	143.1	32.6
10	161.5	61.1
11	223.9	4.6
12	90.0	21.4
13	135.9	3.9
14	110.0	46.2
15	101.1	12.3



**Fig. 6.** Residual against fitted values (left) and residual quantiles against standard normal quantiles (right) for a mixed effects model.

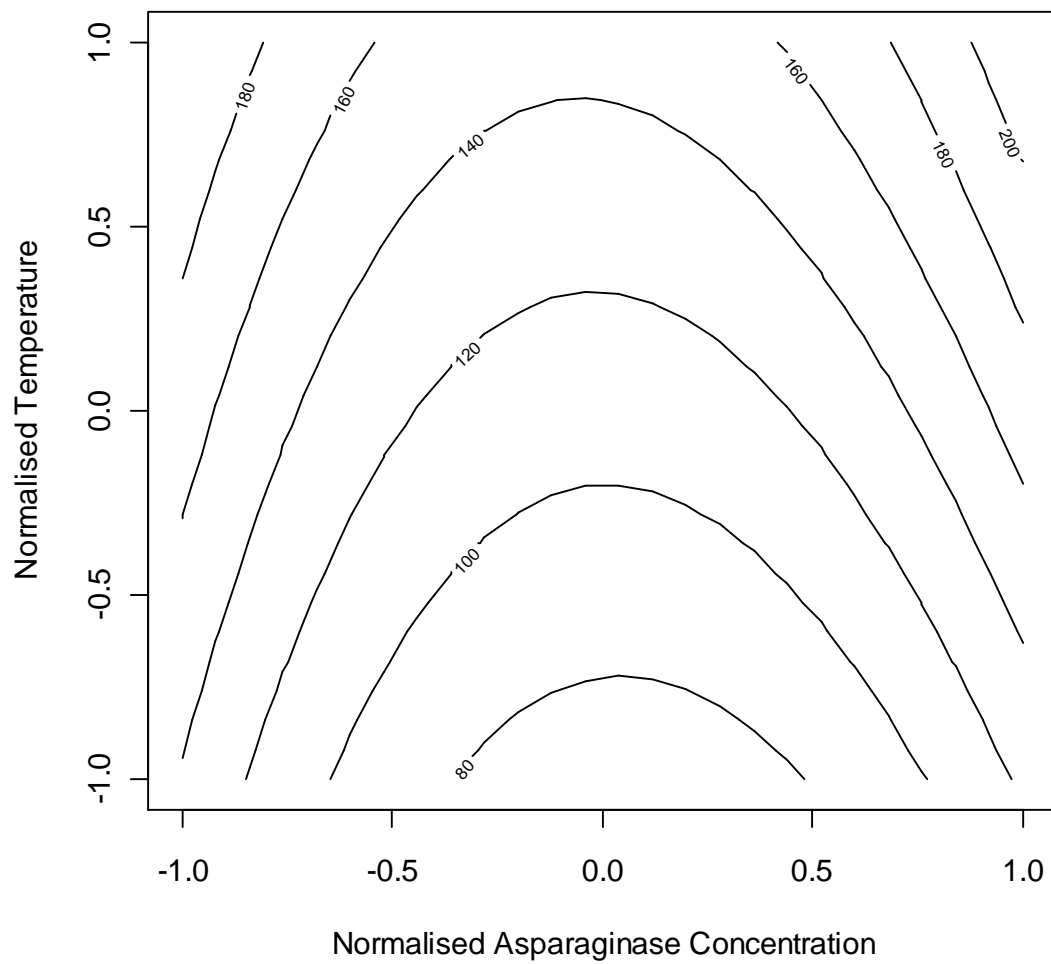


**Fig. 7.** Effects plot for the fixed part of the polynomial model.

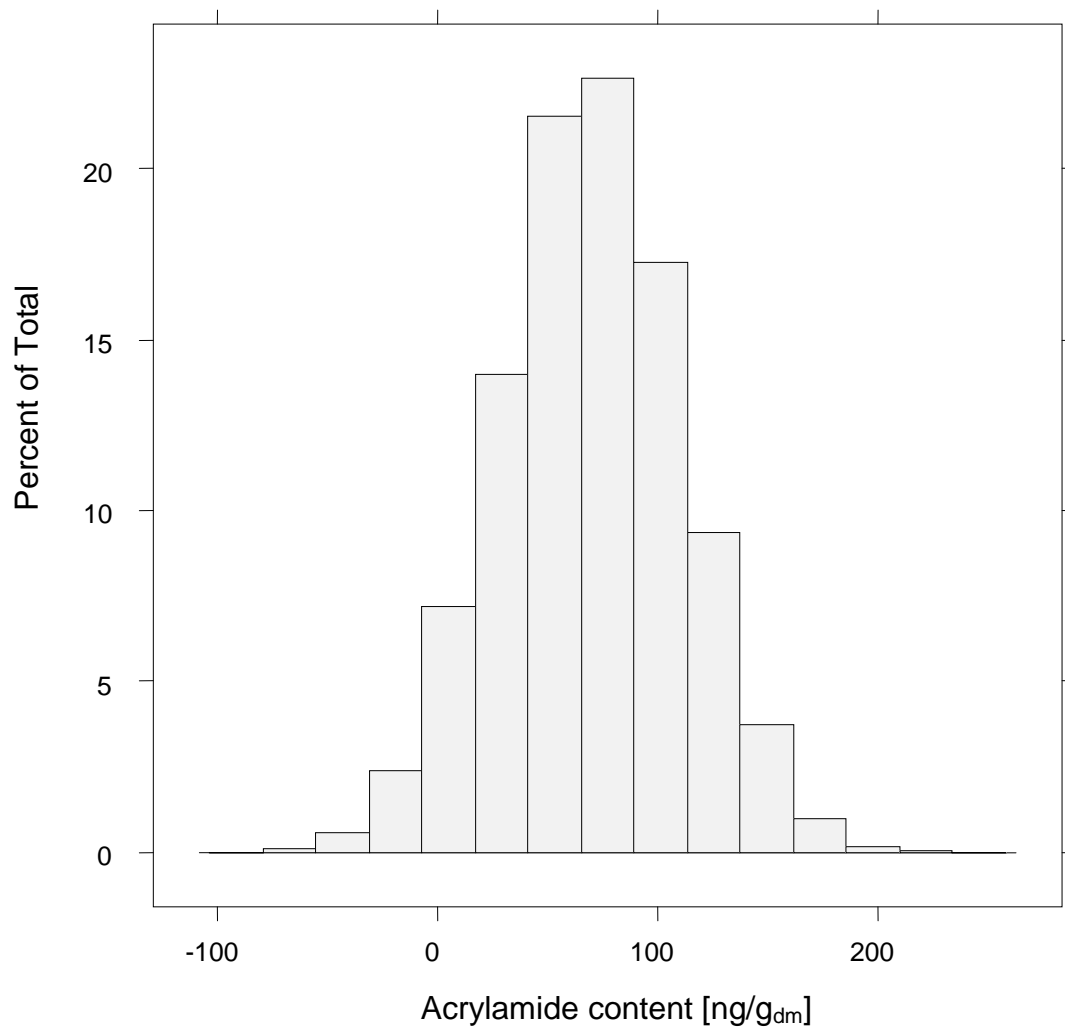


**Fig. 8.** Dependence of acrylamide concentration with asparaginase concentration and incubation time temperature.





**Fig. 9.** Contour of the dependence of acrylamide concentration ( $\text{ng/g}_{\text{dm}}$ ) with the normalised asparaginase concentration and normalized temperature at the lowest incubation time.



**Fig. 10.** Uncertainty assessment of the variability of acrylamide for the optimal conditions of intermediate minimum incubation temperature and minimum incubation time.

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