

From tuna viscera to added-value products: A circular approach for fish-waste recovery by green enzymatic hydrolysis

*Original*

From tuna viscera to added-value products: A circular approach for fish-waste recovery by green enzymatic hydrolysis / FRATERRIGO GAROFALO, Silvia; Cavallini, Nicola; Demichelis, Francesca; Savorani, Francesco; Mancini, Giuseppe; Fino, Debora; Tommasi, Tonia. - In: FOOD AND BIOPRODUCTS PROCESSING. - ISSN 0960-3085. - ELETTRONICO. - 137:(2023), pp. 155-167. [10.1016/j.fbp.2022.11.006]

*Availability:*

This version is available at: 11583/2974252 since: 2023-01-16T08:36:21Z

*Publisher:*

Elsevier

*Published*

DOI:10.1016/j.fbp.2022.11.006

*Terms of use:*

This article is made available under terms and conditions as specified in the corresponding bibliographic description in the repository

*Publisher copyright*

Elsevier postprint/Author's Accepted Manuscript

© 2023. This manuscript version is made available under the CC-BY-NC-ND 4.0 license  
<http://creativecommons.org/licenses/by-nc-nd/4.0/>. The final authenticated version is available online at:  
<http://dx.doi.org/10.1016/j.fbp.2022.11.006>

(Article begins on next page)

# Food and Bioproducts Processing

## From tuna viscera to added-value products: A circular approach for fish-waste recovery by green enzymatic hydrolysis --Manuscript Draft--

<b>Manuscript Number:</b>	FBP-D-22-00976R2
<b>Article Type:</b>	Full Length Article
<b>Keywords:</b>	Fish waste valorization; EPA and DHA; enzymatic extraction; design of experiments; life cycle analysis; principal component analysis
<b>Corresponding Author:</b>	Tonia Tommasi, Ph.D Polytechnic of Turin Department of Applied Science and Technology Torino, string:TO ITALY
<b>First Author:</b>	Silvia Fraterrigo Garofalo
<b>Order of Authors:</b>	Silvia Fraterrigo Garofalo Nicola Cavallini Francesca Demichelis Francesco Savorani Giuseppe Mancini Debora Fino Tonia Tommasi, Ph.D
<b>Abstract:</b>	<p>Tuna represents one of the most consumed foods in many parts of the world. It is estimated that about 70% of the tuna's weight is discarded in the production of canned fillets. This work is focused on the optimization of production of an oil rich in omega-3 from the tuna viscera, provided by a canned tuna production company, using the Alcalase enzyme. Combined use of Design of experiments (DoE), life cycle analysis (LCA), and principal component analysis (PCA) on the collected analytical data made it possible to define the best combination of the values of pH, enzyme/substrate (E/S) ratio, and reaction time, respectively (pH=8.5), E/S (1%), and time (120 minutes), and to better understand the environmental bottleneck of the process. The outcomes of the study demonstrated that the duration of the hydrolysis and the associated electricity consumption is the factor that affects the most the environmental sustainability of the process.</p>
<b>Suggested Reviewers:</b>	Francesco Fatone Polytechnic University of Marche f.fatone@univpm.it Michele Mascia University of Cagliari michele.mascia@unica.it Esperanza Batuecas University Carlos III of Madrid ebatueca@ing.uc3m.es Konstantinos Moustakas National Technical University of Athens konmoust@central.ntua.gr
<b>Response to Reviewers:</b>	

4<sup>th</sup> August 2022**Tonia Tommasi**Phone: +39 011 090 4774; e-mail: [tonia.tommasi@polito.it](mailto:tonia.tommasi@polito.it)Department of Applied Science and Technology (DISAT), Politecnico di Torino  
Corso Duca degli Abruzzi 24, 10129 Torino (TO) – Italy

Dear Editor,

We kindly ask you to consider the submission of our manuscript entitled “*From tuna viscera to added-value products: A circular approach for fish-waste recovery by green enzymatic hydrolysis*” for publication in the journal FOOD AND BIOPRODUCTS PROCESSING.

The present study proposes a circular economy strategy to valorize tuna viscera usually considered a food waste material by the production of oil with nutraceutical properties (rich in Omega 3, with EPA and DHA) through an enzymatic process. The extraction was optimized using a Design of Experiments and the data were analyzed throughout a life cycle assessment (LCA) and principal component analysis (PCA) to highlight the process bottleneck.

To the best of the author's knowledge, the present study proposes for the first time a combined approach of environmental sustainability analysis and PCA of the enzymatic extraction of tuna viscera, offering a novel strategy for the valorization of tuna waste material.

We believe that these results can be of great significance to any readership of your journal and make a profound resonance on hot topics such as “Biorefinery value chain optimisation”, “Integration of biorefinery concepts with food processing” or “New functional food ingredients and non-food materials made feasible through the biorefinery context”.

I confirm that this work has not been previously published, is not currently submitted for publication elsewhere, wholly or in part, nor will be submitted elsewhere while in the review process and the manuscript has not been submitted earlier to Food and Bioproducts Processing. Moreover, it has not previously appeared in printed or electronic online systems (such as in reviews, proceedings, or preprints).

All authors agree to the submission and the work is original.

On behalf of the authors,

Sincerely yours,

Prof. Tonia Tommasi

Department of Applied Science and Technology,  
Politecnico di Torino

**Dipartimento di Scienza Applicata e Tecnologia**

Politecnico di Torino Corso Duca degli Abruzzi, 24 – 10129 Torino – Italia

tel: +39 011.090.4774

[tonia.tommasi@polito.it](mailto:tonia.tommasi@polito.it)

## Replies to Reviewer's Comments and Changes Done in the Revised Manuscript

(text modification in green colour throughout the manuscript)

### Reviewers' comments:

#### Reviewer #1:

- 1) The last para of the introduction section should clearly mention the gaps in the literature and how this paper is addressing the same. The para before the Material and Methods should give brief of the work done and why it is done. The paper should clearly mention the novelty and compare the results with the previous work.

Thank you for your precious suggestions. We have improved the paragraph by clearly indicating the novelties of this work compared to the studies already published in the literature.

We have added the following sentences in the introduction:

“Several authors, in recent years, have dealt with the enhancement of tuna viscera through enzymatic hydrolysis. Je et al. (2009) tested the enzymatic hydrolysis of tuna using commercially available proteases such as Flavourzyme, Alcalase, Protamex, and Neutrase. Guerard et al. (2001), Ovissipour et al. (2012), and Klomklao et al. (2016) instead tested only the alclase focusing on the optimization of the reaction. All these authors have focused on the protein fraction as the only product of hydrolysis. Only De Oliveira et al. (2016) has focused on the possibility of extracting the oily fraction from yellowfin tuna head by enzymatic hydrolysis, making the enzymatic extraction of oil from tuna viscera still unexplored. This work aims to fill this gap, focusing on the optimization of the enzymatic extraction of oil from tuna viscera, through a design of experiments (DoE). The present work also, for the first time, analyzes the results of the DoE through a comparative study of life cycle assessment (LCA), in order to identify the environmental bottleneck of the process. To the best of the author's knowledge, there are no LCA works that deal with the enzymatic extraction of oil from tuna viscera. To compensate for the lack of literature data, and to have at the same time a critical analysis of the results obtained both from the experimental campaign and from the sustainability analysis, a chemometric study was applied through principal component analysis (PCA).”

- 2) Whether the enzymatic activity of the purchased enzyme was checked as claimed by the manufacturer?

Thank you for the interesting question. We choose to measure the activity of the enzyme because not all the experiment was performed at the same time, and we were concerned about the possible degradation of the enzyme in the time elapsed between experiments (the enzyme was already in solution). The measurement of the activity allowed us to monitor this parameter before each day of experiments and avoid errors due to the degradation of the enzyme. We clarified this adding a sentence in “2.3 Protease characterization”:

“The measurement of the activity was performed each day before of experiments and in order to avoid errors due to the degradation of the enzyme during time”

- 3) In LCA section: Please mention boundary, goal and scope.

Thank you for the suggestion. We stated goal and scope with the proper explanation of the reason for which we chose the functional unit (FU) and we described the boundary conditions and we draw them in Figure 1.

We added in 2.10 Life Cycle Assessment the following sentences:

“To be consistent with the goal of the study and with the function to which the process system was designed for, the chosen functional unit was 1g of fish oil. The adopted approach was from grave to cradle. The definition of the boundary conditions of the study includes the transported tuna waste feed as feedstock for the process, then the tuna pre-treatment, the enzymatic extraction, the thermal treatment, and last the centrifugation to recover the extracted oil. The scheme of the boundary condition is drawn in Fig 2.”

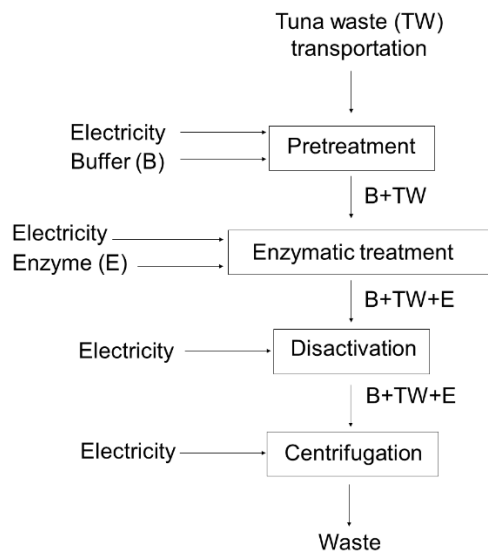


Figure 2. Scheme of the LCA boundary conditions. For each process, input and output of matter and energy are illustrated.

We also added the detailed life cycle inventory in the supplementary materials.

4) The assumptions made and what is excluded from the LCA studied should be clearly mentioned

Thank you for the suggestion. We highlighted the assumptions done. In detail we explained that tuna waste was considered a zero-burden according to (Buttol et al., 2007) and for tuna waste the only environmental credits were related to transport. To be more precautionary and avoided double discounting, all the environmental impacts and credit were allocated on the fish oil, which was the product target, and all the by-products and co-products generated in the studied system were considered as waste.

We added in 2.10 Life Cycle Assessment the following sentences:

“According to the zero-burden assumption, it was assumed that tuna waste did not contain any credits related to the impacts produced during the previous stages of its life cycle (Buttol et al., 2007). Furthermore, another assumption was the allocation criteria. To be more precautionary and avoided double discounting, all the environmental impacts and credit were allocated on the fish oil, which was the product target, and all the by-products and co-products generated in the studied system were considered as waste”

5) LCA results should be reported in absolute values and not in % as given in Table 6. Please refer any standard paper on LCA study.

Thank you for the advice. We modified Figure 4 (now figure 5) and we reported the results of each tested configuration for each impact category with the absolute value. Moreover, the contribute of each process step was referred as percentage of the absolute value.

We added in 3.5 Life Cycle Assessment the following sentences:

“Figure 5 reported the results of the 15 configurations for each impact category with the absolute value, where the contribution of each process step was referred as a percentage of the absolute value. Moreover, to underline the contribution of energy items in the total impact, it was highlighted in each process step in which it was required: pretreatment, enzymatic extraction phases, disactivation unit and oil recovery through centrifuge equipment.

Figure 5 proved that for all the tested configurations, the main contribution to the total environmental impact among the five investigated impact categories was the consumed energy and in particular the energy required for the enzymatic extraction and centrifugation phases.”

“Indeed, for the climate change category, the experiments with the longest enzyme extraction step (120 min) reached the highest energy contribution in that phase, which ranged between 30-52 % of the total impact in all the considered impact categories.

Furthermore, in all the considered impacts categories, the recovery of the oil is one of the highest energy consumer items, hence the present study underlined the importance of optimizing the downstream technology to recover the product target.

Another attentioned parameter in the present study of sustainability is the role of the enzyme. In the marine eutrophication the effect of the enzyme was highlighted, and it reached the highest contribution in the experiment in which the dose of the Alcalase was the highest one (1 mL) and the yield of fish oil was not the optimal one compared to the amount of tuna treated (0, 2 g/ g of tuna).

Among the investigated configurations, the one, reaching the highest impact of enzyme in marine eutrophication, was the experiment n°3 with a value equal to 72 % of the total enzymatic pretreatments (made up by the sum of the enzyme contribution and energy required to carry out the enzymatic extraction phase).

Among the five impact categories, the pretreatment unit, consisting in pH regulation with the addition of a buffer, had environmental impacts detectable in terrestrial acidification and freshwater eutrophication due to the adopted chemicals. Specifically, the configurations n° 1, 2 and 6 exhibited pretreatment unit impact in terrestrial acidification and freshwater eutrophication ranging between 6.5-8 and 6-8,10 % of the total environmental impacts in that categories.”

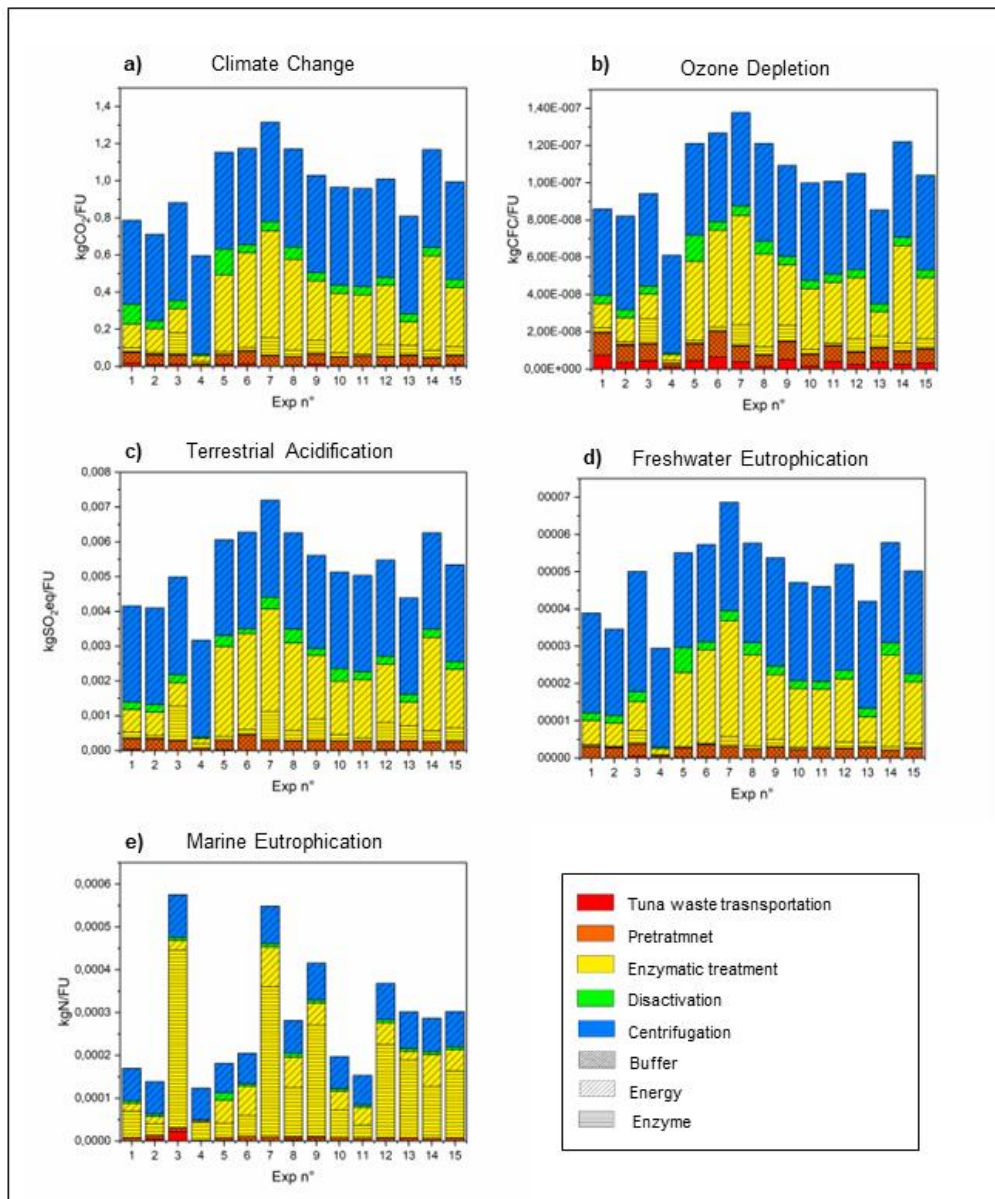


Figure 5 . Results of comparative LCA between the 15 experiments of the DoE in terms of five impact categories: (a) Climate change (kg CO<sub>2</sub> eq), (b) Ozone depletion (kg CFC-11 eq), (c) Terrestrial acidification (kg SO<sub>2</sub> eq), (d) Freshwater eutrophication (kg P eq) and (e) Marine eutrophication (kg N eq).

6) Compare your GHG KgCO<sub>2</sub> eq and other 4 indicators with the reported literature

Thank you for the suggestion.

We improved the discussion of LCA results, but the comparison with literature was not realisable because in literature there are not available studies about LCA of extractive process on tuna viscera or /and Alcalase application.

Moreover, the LCA study and results are strongly dependent on the choice of functional unit, boundary conditions and time and location chosen. Considering these aspects, it is very difficult comparing our study with not similar process.

However, considering this lack we did a comparison among the investigated configurations, and we reported a study about LCA of biorefinery systems which faced sustainability problems in a general biorefinery systems.

We added in 3.5 Life Cycle Assessment the following sentences:

“To the best of the author's knowledge, there are still no LCA studies on the enzymatic extraction of oil from tuna waste, so our discussion will be limited to the results obtained in this work. In the literature, there are no available studies to compare the environmental impacts and credits of the process and substrate investigated in the present paper. For this reason, in the present work, the discussion of LCA results was done as a comparison between the 15 investigated configurations of the DoE.”

“The transport of tuna exhibited a considerable impact in the ozone depletion category due to the necessity of transporting the feedstock with a refrigerated lorry for a distance of 1524 km (from the south of Italy to the north of Italy plant) in accordance with the study of (Khoo, et al 2019). The contribution of tuna transport in ozone depletion decreased by decreasing the amount of tuna, because according to the chosen FU ( 1g of fish oil), it means that the process is high performing.

According to the study of (Sillero et al,2021) about LCA of biorefinery systems in general and not specific for substrate or type of process, the enzyme application impacts on marine eutrophication due to its origin, whereas pretreatment impacts on terrestrial acidification and freshwater eutrophication due to the use of chemical and their post consume, whereas the product recovery exhibits great impacts on climate changes and ozone depletion due to the energy requirement.”

7) You can have different scenarios to check the effect on values of different indicators.

Thank you for the suggestion.

We focused on the 15 possible configurations and on how the impacts of the 5 categories analysed in the considered processes can change. The changes and further details have already been described in the answers to the previous questions

8) The conclusion section should be rewritten.

Thank you for your suggestion. We have completely rewritten and expanded the conclusions.

“The enzymatic hydrolysis of tuna waste represents an innovative technology to exploit canned tuna processing wastes to obtain products with high added value, such as tuna oil and FPH. This study has shown that it is possible to obtain good quality tuna oil rich in omega-3 fatty acids through enzymatic hydrolysis of tuna viscera derived by a canned tuna production company with commercial enzyme Alcalase.

The DoE made it possible to optimize oil extraction and identify the best pH (8.5 °C), E/S (1%), and time (120 minutes). It was possible to obtain a model able to compute the yield as a function of the three-factor analyzed. The study of the progress of the DH% over time showed that after one hour, the reaction slows down. The experiments of the DoE were compared to each other through an LCA analysis, and the results were investigated with a PCA. This innovative approach allowed to demonstrate that

the duration of the hydrolysis and the associated electricity consumption is the variable that most affects the environmental sustainability of the process.

Further studies would be needed to reduce the time of hydrolysis, analyze in more depth the FPH obtained and its properties and design a possible scale-up in order to evaluate the technical, economic and environmental feasibility of this process at an industrial level.”

9) The tables/Fig in LCA are not appropriate. Please check any published paper for reference.

Thank you for the advice.

We modified the Figure 4 (now 5), eliminated figure 6 and we separated the paragraph of LCA in two paragraphs: 3.5 for LCA results and 3. Evaluation of LCA results through PCA.

This separation could highlight both the results of LCA and the novelty of adopting PCA to analysed LCA results. Moreover, the application of PCA to LCA results could partially cover the impossibility of compare our results with literature data due to the absence of sustainability study of extractive process, fish oil production and enzyme application.

## **Reviewers' comments:**

### **Reviewer #2:**

Authors have used Alcalase enzyme for the digestion of Tuna waste. There are a lot of studies whose work is similar though this research team has done it on Tuna.

The data analyses has been done differently; however, many of the inferences are similar to the previous findings. LCA is comparatively newly employed.

Authors have not included a Table for ANOVA and have only considered R<sup>2</sup> and R as criteria; however lack of fit of the model and the adjusted R<sup>2</sup> should also be considered among other factors.

Thank you for suggesting the use of additional parameters to better describe the modelling of the percentage degree of hydrolysis (DH%) curve reported in Figure 3 (if we understood well!). We are not quite sure about including an ANOVA computed on the DH% data, as no groups or effects can be defined in relation to these experiments.

Regarding the use of an adjusted R<sup>2</sup>, it would probably be more suitable in the case of a modelling function with more than one explanatory variable  $x$ . In our case there is only time as explanatory variable, as expressed by equation 8, so we would state that the “basic” R and R<sup>2</sup> values, together with the visual representation of Figure 3 should be enough to clearly provide a description of how well this function fits the experimental data.

Also, as there is no consideration of the quadratic terms, there is no requirement of the RSM graphs, they can be removed.

Thank you for your precious suggestions.

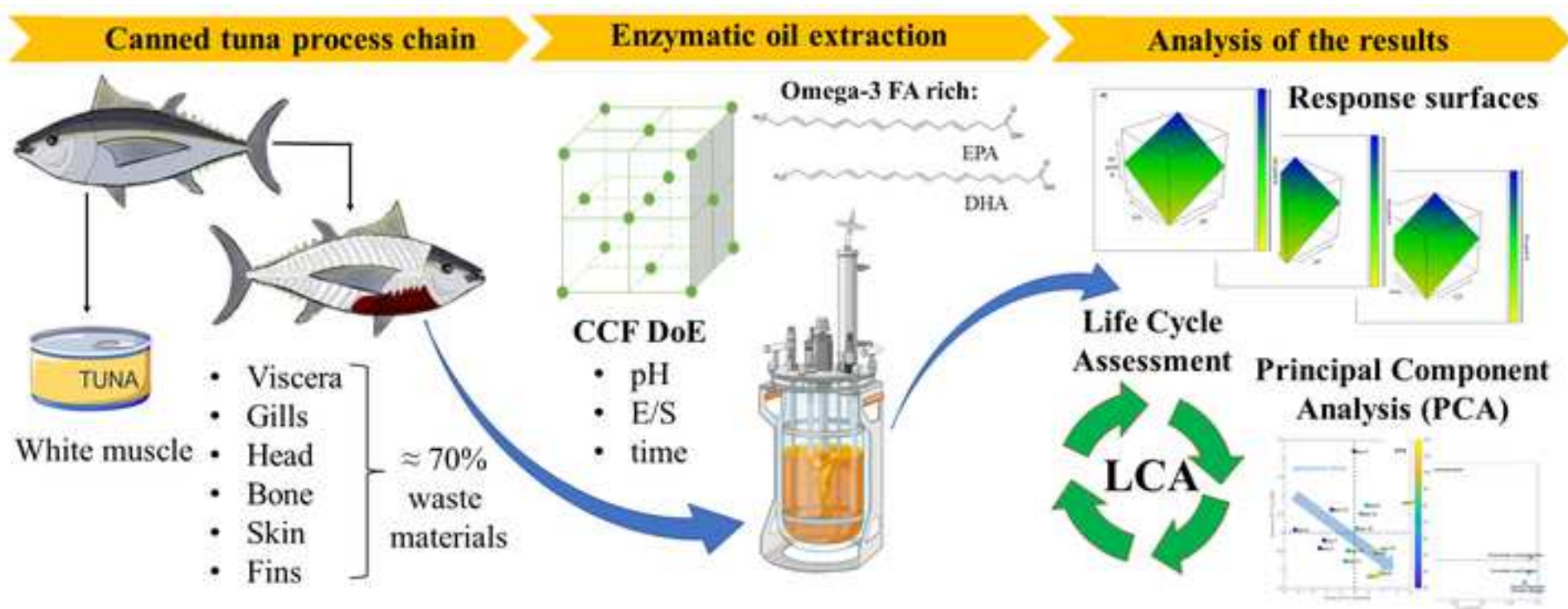
The quadratic terms were introduced in Section 2.5 when describing in more general terms the multilinear (MLR) regression technique, and it was specified in Section 3.2 that they were removed as non-significant. The phrasing of Section 3.2 was changed to make the changes to the model clearer:

“To model the percentage oil yield a full MLR regression model was first computed and after a preliminary elaboration, the model was simplified excluding the non-significant terms, i.e., the interaction and quadratic terms. Only the statistically significant terms were included, as described by equation 7.”

Regarding the inclusion of the RSM graphs of Figure 2, we believe that they can be very informative and useful to provide a complete and clear representation of the MLR model results, together with the regression parameters of Table 2, as the interpretation of the parameters alone can in general be misleading.

## Highlights

- Application of enzyme hydrolysis in the recovery of oil from tuna waste material
- Process optimization through the Design of Experiments
- Oil extracted from tuna waste material is rich in omega-3 fatty acids
- A combined approach of Life Cycle Assessment and Principal Component Analysis
- Electricity consumption is the most environmental impacting factor of the process



# From tuna viscera to added-value products: A circular approach for fish-waste recovery by green enzymatic hydrolysis

Silvia Fraterrigo Garofalo<sup>1</sup>, Nicola Cavallini<sup>1</sup>, Francesca Demichelis<sup>1</sup>, Francesco Savorani<sup>1</sup>, Giuseppe Mancini<sup>2</sup>, Debora Fino<sup>1</sup>, Tonia Tommasi\*<sup>1</sup>

<sup>1</sup>Department of Applied Science and Technology (DISAT), Politecnico di Torino, Corso Duca Degli Abruzzi 24, Torino (TO), 10129, Italy

<sup>2</sup>Department of Electric, Electronic and Computer Engineering, University of Catania, Viale A. Doria 6, Catania (CT), 95125, Italy

\*Corresponding author

email: [tonia.tommasi@polito.it](mailto:tonia.tommasi@polito.it)

## Abstract

Tuna represents one of the most consumed foods in many parts of the world. It is estimated that about 70% of the tuna's weight is discarded in the production of canned fillets. This work is focused on the optimization of production of an oil rich in omega-3 from the tuna viscera, provided by a canned tuna production company, using the Alcalase enzyme. Combined use of Design of experiments (DoE), life cycle analysis (LCA), and principal component analysis (PCA) on the collected analytical data made it possible to define the best combination of the values of pH, enzyme/substrate (E/S) ratio, and reaction time, respectively (pH=8.5), E/S (1%), and time (120 minutes), and to better understand the environmental bottleneck of the process. The outcomes of the study demonstrated that the duration of the hydrolysis and the associated electricity consumption is the factor that affects the most the environmental sustainability of the process.

1  
2 **Keywords:** Fish waste valorization, EPA and DHA, enzymatic extraction, design of  
3  
4 experiments, life cycle analysis  
5  
6  
7  
8  
9

## 10 **1. Introduction**

11  
12  
13 Tuna and particularly canned tuna is one of the most consumed fish globally; this  
14  
15 seafood is fished and processed in more than 70 countries and represents an affordable  
16  
17 and common source of protein worldwide (FAO, 2020). The main tuna species  
18  
19 processed are skipjack (*Katsuwonus pelamis*), albacore (*Thunnus alalunga*), yellowfin  
20  
21 (*Thunnus albacares*), bigeye (*Thunnus obesus*), and bluefin (*Thunnus thynnus*), which  
22  
23 are mainly fished in the Pacific Ocean (Allain et al., 2016; FAO, 2020). Around 5.2  
24  
25 million metric tons of tuna fish have been captured in 2018, and at least three-quarters  
26  
27 of all landed tuna have been canned (McKinney et al., 2020). Thailand is the leading  
28  
29 country for tuna processing, while the largest consumers among the European countries  
30  
31 are Spain, Italy, France, UK, and Portugal (Ababouch and Catarci, 2008; Allain et al.,  
32  
33 2016; FAO, 2020)

34  
35  
36 Tuna, after capture, is frozen and transported to production plants where it is subjected  
37  
38 to quality controls and then deprived of heads, viscera, and fins through mechanical  
39  
40 sawing systems (Ababouch and Catarci, 2008). After that, the tuna is cooked in various  
41  
42 ways that depend on the choice of industry. After the cooking step, the fillets are  
43  
44 manually cleaned with knives, then they get canned to be finally sterilized (Hospido et  
45  
46 al., 2006; Ababouch and Catarci, 2008; Ramakrishnan et al., 2013).

47  
48  
49 The principal product of the canned tuna industry is the fillet, consisting mainly of  
50  
51 white muscle, while viscera, gills, dark flesh/muscle, head, bone, and skin are  
52  
53 considered as waste or low-value by-products (Herpandi et al., 2011). These wastes can  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 reach up to 70 % of the total weight of the fish and still contain a high portion of  
2 valuable protein, lipid and nutritional components, which can represent a profitable  
3 resource for the nutraceutical, pharmaceutical and cosmetic industries (Araujo et al.,  
4 2021; Herpandi et al., 2011). With the increasingly problematic effects of climate  
5 change and the scarcity of natural resources, many researchers are now focusing on  
6 improving technologies to extract bioactive compounds from fish by-products. Two of  
7 the main products obtained from tuna waste are tuna oil and fish protein hydrolysates  
8 (Herpandi et al., 2011). There has been growing interest towards tuna oil because it is  
9 rich in polyunsaturated fatty acids (PUFAs), in particular eicosapentaenoic acid (EPA)  
10 and docosahexaenoic acid (DHA), omega-3 fatty acids, both responsible for preventing  
11 some cardiovascular and various inflammatory diseases (Calder, 2012). Fish protein  
12 hydrolysates (FPH) is obtained by subjecting fish proteins to chemical or enzymatic  
13 hydrolysis, producing peptides and free amino acids. Several studies demonstrated that  
14 enzymatic hydrolysis, in an optimum combination of process conditions, is able to  
15 produce FPH with excellent properties, like antioxidant activity with high amounts of  
16 antihypertensive, anticancer, anti-anemia peptides (Herpandi et al., 2011). Moreover,  
17 enzymatic hydrolysis can separate at the same time the protein fraction, the oil fraction  
18 and the insoluble solid, reducing the use of toxic solvents and the production of  
19 chemical waste compared to other extraction processes (Araujo et al., 2021). These  
20 characteristics make the enzymatic hydrolysis process environmentally sustainable and  
21 an excellent candidate for producing high added-value products from canned tuna waste  
22 materials.

23 Several authors, in recent years, have dealt with the enhancement of tuna viscera  
24 through enzymatic hydrolysis. Je et al. (2009) tested the enzymatic hydrolysis of tuna  
25 using commercially available proteases such as Flavourzyme, Alcalase, Protamex, and  
26 Neutrase. Guerard et al. (2001), Ovissipour et al. (2012), and Klomklao et al. (2016)

1 instead tested only the alcalase focusing on the optimization of the reaction. All these  
2 authors have focused on the protein fraction as the only product of hydrolysis. Only De  
3  
4 Oliveira et al. (2016) has focused on the possibility of extracting the oily fraction from  
5  
6 yellowfin tuna head by enzymatic hydrolysis, making the enzymatic extraction of oil  
7  
8 from tuna viscera still unexplored. This work aims to fill this gap, focusing on the  
9  
10 optimization of the enzymatic extraction of oil from tuna viscera, through a design of  
11  
12 experiments (DoE). The present work also, for the first time, analyzes the results of the  
13  
14 DoE through a comparative study of life cycle assessment (LCA), in order to identify  
15  
16 the environmental bottleneck of the process. To the best of the author's knowledge,  
17  
18 there are no LCA works that deal with the enzymatic extraction of oil from tuna viscera.  
19  
20 To compensate for the lack of literature data, and to have at the same time a critical  
21  
22 analysis of the results obtained both from the experimental campaign and from the  
23  
24 sustainability analysis, a chemometric study was applied through principal component  
25  
26 analysis (PCA).  
27  
28  
29  
30  
31  
32

## 33 **2. Material and methods**

### 34 **2.1 Raw materials and chemicals**

35  
36  
37 Around 10 kg of frozen tuna (*Thunnus albacares*) waste materials were provided by the  
38  
39 Company “Sebastiano DRAGO” (Siracusa, Italy), that produces canned tuna. The raw  
40  
41 material was shipped and maintained at controlled temperatures of  $-20\text{ }^{\circ}\text{C}$  until analysis  
42  
43 and experiments. All reagents used in this work were high purity grade and provided by  
44  
45 Sigma Aldrich-Merck (Germany). The enzyme applied for the hydrolysis was the  
46  
47 Alcalase 2.4 L, an aqueous solution of Protease from *Bacillus licheniformis* with a  
48  
49 declared specific activity  $\geq 2.4\text{ U/g}$ .  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

## 2.2 Pretreatment of waste material

The frozen tuna waste material was thawed at room temperature and drained from the blood. After that, the viscera were manually separated from the bones and the skin using a sharp knife. To obtain a sample as homogeneous as possible, the viscera were blended and homogenized using a kitchen blender.

## 2.3 Protease characterization

The enzyme chosen for this study was Alcalase, a highly studied enzyme that has already been used to produce FPH from various fish species (Tacias-Pascacio et al., 2020). To choose the enzyme/substrate ratio and to monitor any degradation of the Alcalase during the time, an activity assay was conducted. First of all, it was necessary to measure the total amount of enzyme in the Alcalase solution, in terms of total proteins, through the Bradford assay using Bovine Serum Albumin (BSA) as standard protein (Kruger, 1994).

The Bradford assay is a protein determination method that involves binding Coomassie Brilliant Blue G-250 dye to proteins. When the dye binds to the protein, it is converted to a stable unprotonated blue form with the maximum absorbance at 595 nm.

Hence, 100  $\mu\text{L}$  of diluted Alcalase was mixed with 1000  $\mu\text{L}$  of the Bradford reagent into an Eppendorf tube. After 15 minutes the absorbance of the sample was measured at 565 nm through a spectrophotometer (Hach Lange DR5000). The protein amount was then determined by comparing the absorbance value with a calibration curve obtained using different concentrations of BSA (from 0.1 mg/mL to 0.01 mg/mL) mixed with the Bradford reagent. All the solutions were maintained at  $\text{pH} = 7$  using a phosphate buffer.

This assay allowed the correct choice of Alcalase dilution to apply in the activity assay.

A non-specific protease activity assay using casein as substrate (Cupp-enyard, 2008)

was chosen. The measurement of the activity was performed each day before of experiments and in order to avoid errors due to the degradation of the enzyme during time. In this assay, casein is digested by the Alcalase liberating tyrosine, which reacts with Folin & Ciocalteus reagent to produce a chromophore. This complex has a maximum absorbance in the blue region of the UV-Vis, and it is measurable with a spectrophotometer. Briefly, the diluted Alcalase was mixed with 0.65 % of casein solution and incubated at 37 °C for 10 minutes. After this time, Trichloroacetic Acid (TCA) was added to stop the enzymatic reaction, and more Alcalase was put in the solution and incubated for 30 minutes at 37 °C. Then the solution was filtered and was supplemented with sodium carbonate and Folin's reagent, mixed, and incubated again for 30 minutes at 37 °C. After the incubation time, the mixture was filtered, and the absorbance was measured at 660 nm. The  $\mu\text{mol}$  tyrosine equivalents released were obtained, by comparing the absorbance of the sample with a tyrosine calibration curve. Then the activity of the Acalase was calculated by the following equation (1):

$$\frac{\text{Units}}{\text{mL enzyme}} = \frac{\mu\text{mol}_{\text{Teq}}}{V_E \cdot t \cdot V_C} \quad (1)$$

where  $\mu\text{mol}_{\text{Teq}}$  are the micromoles of tyrosine equivalent obtained from the calibration curve,  $V_{\text{tot}}$  is the total volume of the assay (mL),  $t$  is the time (min),  $V_E$  is the volume of the enzyme (mL) and  $V_c$  is the volume of the cuvette (mL). It was possible to convert Units/mL in Units/mg of protein contained in the liquid enzyme by applying the following equation (2):

$$\frac{\text{Units}}{\text{Protein (mg)}} = \frac{\frac{\text{Units}}{\text{Enzyme (mL)}}}{\frac{\text{protein (mg)}}{\text{Enzyme (mL)}}} \quad (2)$$

## 2.4 Tuna viscera characterization

The total amount of lipids contained in the tuna viscera was determined using the Bligh and Dyer method (Bligh, E.G. and Dyer, 1959), originally developed to quantify the

1 total lipid in the fish muscle and later become the standard rapid method for fat  
2 determination in marine biological tissue (Bligh, E.G. and Dyer, 1959). In summary,  
3  
4 100 g of homogenized sample was mixed with 100 mL of chloroform and 200 mL of  
5  
6 methanol. After that, 100 mL of chloroform and 100 mL of water were added to the  
7  
8 mixture, agitated for 30 seconds, and then filtered. The liquid part was transferred into a  
9  
10 graduated cylinder, where the separation between the polar and non-polar fraction of the  
11  
12 solution occurred. The volume of chloroform was noted and the alcoholic fraction was  
13  
14 removed using a glass pipette. The non-polar solution was evaporated through a  
15  
16 Rotavapor (Labrota 4000, Heidolph) and the oily residue was weighed with an  
17  
18 analytical balance. The measurement was performed in triplicate.  
19  
20  
21  
22  
23

24 The total N content was first quantified through the Dumas or combustion method  
25  
26 (Simonne, et al., 1997) utilizing an Elementar analyzer (Vario MACRO cube,  
27  
28 Elementar). Then, the N total was multiplied for a nitrogen-to-protein conversion factor  
29  
30 (equation 3). The factor chosen was 5.6, specific for fish protein, as suggested by  
31  
32 Mariotti et al. 2008 (Mariotti et al., 2008) and not the standard 6.25 conversion factor,  
33  
34 usually used for foodstuff.  
35  
36  
37  
38

$$39 \quad \text{Proteins \%} = N \cdot 6.5 \quad (3)$$

40  
41  
42 The moisture and ash contents were determined following the “Rapporto ISTISAN  
43  
44 1996/34”, and the total carbohydrate content was calculated by difference.  
45  
46  
47  
48

## 49 **2.5 Experimental design and data modeling**

50  
51 To understand the effect of pH, enzyme/substrate ratio (E/S) and time on the amount of  
52  
53 fish oil extracted and on the antioxidant activity of the fish protein hydrolysates, but  
54  
55 also to optimize the extraction technique by minimizing and at the same time the  
56  
57 number of experiments, a Design of Experiments (DoE) (Leardi, 2009) was put in  
58  
59  
60  
61  
62  
63  
64  
65

1 place. A three-factor and three-levels Central Composite Face Centered (CCF) design  
2 consisting of 15 experiments was employed, and 17 experimental runs, including three  
3 replicates at the center point, were performed. The design factors were pH (6.5, 7.5 and  
4 8.5), E/S (0.1, 0.55 and 1) and time (30, 75 and 120 min), while the response variable  
5 was the yield of fish oil expressed in percentage (oil yield %). Based on literature  
6 information, the temperature was kept constant at 55 °C, which has been determined to  
7 be the optimal temperature for Alcalase (Li et al., 2018; Glowacz-Rozynska et al., 2016;  
8 Wang et al., 2019).

9 The design was created using MODDE 7 software (version 7.0.0.1), and the list of  
10 experimental runs, i.e., the experimental plan (with the original values of each factor)  
11 and matrix (coded version of the original values) are reported in Table 1. In the CCF  
12 design, the three levels are conventionally named as -1, 0, and +1, where -1 represents  
13 the lowest value of the factor range, +1 is the highest value and 0 is the central point  
14 (Taylor et al., 2021). In the presence of three factors, the experimental domain spanned  
15 by the CCF design can be represented in 3D space as a cube, like it is shown in Figure  
16 1.

17 The data were analyzed using the R-based CAT (Chemometric Agile Tool, by Leardi  
18 R.) software, whose DoE modeling engine is based on the multiple linear regression  
19 (MLR) (Sergent, 1995) method. MLR is a regression method that allows modeling and  
20 inspecting each factor separately, but also in combination with one or more other  
21 factors. Its functioning provides enough flexibility to efficiently model the response  
22 under examination, while at the same time including or excluding the non-significant  
23 terms in the model equation, which can be represented as:

$$y = \beta_0 + \beta_A A + \beta_B B + \beta_C C + \beta_{AB} AB + \beta_{BC} BC + \beta_{AC} AC + \beta_{AAA} AA + \beta_{BB} BB + \beta_{CC} CC \quad (4)$$

1 where  $y$  is the predicted response (oil yield %),  $\varepsilon$  represents the noise and  $I$  are the  
2 regression coefficients of each factor ( $A = \text{pH}$ ,  $B = \text{E/S}$  and  $C = \text{time}$ ), including the  
3  
4 interaction between the factors ( $AB$ ,  $AC$  and  $BC$ ) and their quadratic terms ( $AA$ ,  $BB$   
5 and  $CC$ ).  
6  
7

8  
9 To better inspect the comparative LCA results (as described in Section 2.10) it was  
10 decided to study the obtained numerical values using the exploratory data analysis  
11 method principal component analysis (PCA, (Bro and Smilde, 2014)). PCA is a  
12 decomposition method that allows obtaining clear representations of the samples'  
13 distributions, together with the correlation patterns among the variables by inspecting  
14 the so-called scores and loadings, respectively. In our case, the samples were the 15  
15 experiments analyzed via LCA, and the variables were the five LCA impact categories.  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27

## 28 **2.6 Enzymatic extraction**

29 The enzymatic extraction was conducted following the procedure of Ramakrishnan et  
30 al. (2013) with some modifications. Around 20 g of homogenized tuna viscera were put  
31 into a 50 mL falcon tube and heated at 90 °C for 10 minutes in a water bath, to  
32 deactivate any endogenous enzymes (Ramakrishnan et al., 2013). After cooling down at  
33 room temperature, a buffer was added to control the pH during the reaction in a ratio 1:1  
34 (buffer:substrate). Three different buffers were used in different experiments of the  
35 DoE: phosphate buffer at different concentrations (pH = 6.5 and 7.5) and borate buffer  
36 (pH = 8.5). Then the mixture was thermostated at 55 °C for 30 minutes into an  
37 incubator with a shaking rate of 200 rpm (ES-20/60, Orbital Shaker- Incubator, Biosan).  
38 Different amounts of Alcalase were added to the mixture to obtain different E/S  
39 percentages (0.1, 0.55 and 1 %). The enzyme was then allowed to react for 30, 75 or  
40 120 minutes. When the reaction time had elapsed, the falcon tube was put again into the  
41 water bath at 90 °C for ten minutes to stop the reaction. The mixture was cooled at room  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 temperature and centrifuged at 5000 rpm for 20 minutes with a SL 16R Centrifuge  
2 (Thermo Fisher Scientific).  
3

## 4 5 **2.7 Oil yields**

6  
7  
8 The upper oil layer was collected using a plastic pipette and transferred into a glass  
9 sample holder. To make sure there was only fat in the sample, the oil was washed with a  
10 small amount of dichloromethane and left to evaporate under a chemical hood. The  
11 samples were then weighed on an analytical balance and the amount of oil was related  
12 to the total oil content present in the tuna viscera (see paragraph 2.4) to obtain the yield  
13 % according to the following equation (4).  
14  
15  
16  
17  
18  
19  
20  
21

$$22 \quad \text{oil yield \%} = \frac{\text{oil extracted (g)}}{\text{total oil in the sample (g)}} \cdot 100 \quad (5)$$

## 23 24 25 26 27 **2.8 Omega-3 quantification**

28  
29 The omega-3 content in terms of EPA and DHA was determined according to UNI EN  
30 ISO 12966-2:2017 standard methods. Fatty acids were analyzed in the form of methyl  
31 esters (FAME) using a gas chromatograph equipped with a mass analyzer. To prepare  
32 the FA methyl esters, around 100 mg of sample was dissolved in 3 mL of methanolic  
33 KOH (0.6 M) in a falcon tube and stirred for 10 s under an N<sub>2</sub> flow to avoid oxidation  
34 of compounds. The solution was heated under agitation for 10 minutes at 70 °C using a  
35 water bath. After this time, and the complete dissolution of the oil, 3 mL of 5 % H<sub>2</sub>SO<sub>4</sub>  
36 in methanol was added and the solution was heated at 70 °C for another 5 min. Then 2  
37 mL of a saturated solution of NaCl and 2 mL of hexane were added, and the falcon was  
38 centrifuged at 4000 rpm for 10 minutes. The supernatant was collected, diluted 1:2, and  
39 transferred in a vial for the GC-MS analysis. The omega-3 analysis was conducted  
40 using a gas chromatograph (Agilent 7890A GC System) equipped with a ZB-FAME  
41 column (30 m x 0.25 mm ID x 20 µm; Zebron Phenomenex) and a quadrupole mass  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 detector (Agilent 5975 C VL MSD). Helium was used as carrier gas with a flow of 0.4  
2 mL/min, the injection volume was 1  $\mu$ L using the split mode with a split ratio of 20:1 at  
3  
4 240 °C. The column was initially maintained at 100 °C for 2 min and then the  
5  
6 temperature was then increased to 240 °C at 5 °C/min and kept constant for 8 min  
7  
8 (Brotas et al., 2020). The mass analyzer worked in electron ionization mode with  
9  
10 ionization energy of 70 eV and in full scan mode between 50 and 600 a.m.u.. The  
11  
12 temperatures of the source and quadrupole were maintained at 230 °C and 150 °C,  
13  
14 respectively. Omega-3 quantification was determined through calibration curves  
15  
16 prepared using a DHA and EPA certified standard.  
17  
18  
19  
20  
21  
22  
23  
24

## 25 **2.9 Progress of protein hydrolysis**

26  
27 To understand the behavior of an enzyme-substrate system, at least five indicators must  
28  
29 be considered: the substrate concentration (S), the enzyme/substrate ratio (E/S), the pH,  
30  
31 the temperature (T) and the time (t). These indices can be substituted by the degree of  
32  
33 hydrolysis (DH) because, as affirmed by Alder-Niessen (1982) (Alder-Niessen, 1982) in  
34  
35 some conditions, the development of an enzymatic protein hydrolysis reaction depends  
36  
37 only on the pH and DH. The DH is defined as the ratio of the number of peptide bonds  
38  
39 broken by the total number of peptide bonds in the original protein (North and Zealand,  
40  
41 2010) and allows to obtain information on the progress of the reaction in real time. To  
42  
43 measure the DH, the pH-stat method was employed. This method is based on the fact  
44  
45 that, during the hydrolysis of the peptide bond, there is a pH decrease and, to maintain it  
46  
47 constant, it is necessary to add some base. It is possible to relate the amount of added  
48  
49 base to the DH by the following equation (6) (North and Zealand, 2010):  
50  
51  
52  
53  
54  
55  
56

$$57 \quad DH\% = \frac{B \cdot N_B}{\alpha \cdot m \cdot h_{tot}} \quad (6)$$

58  
59  
60  
61  
62  
63  
64  
65

1 Where B is the base consumption (mL),  $N_B$  is the normality of the base, m is the mass of  
2 the protein of the sample,  $\alpha$  is the average degree of dissociation of  $\alpha$ -NH<sub>2</sub> groups in the  
3 protein of the sample and  $h_{tot}$  is the total number of peptide bonds per unit mass of  
4 protein. The working conditions chosen for this experiment were the optimal conditions  
5 obtained from the DoE experiments. The base used was NaOH 0.5 N. The term  $1/\alpha$  is  
6 defined as a calibration factor and depends on the temperature and pH, in these working  
7 conditions (55 °C and pH 8.5) it values 1.03 (Navarrete del Toro and García- Carreño,  
8 2003). The term  $h_{tot}$  value depends on the source of protein, for fish, Navarrete et al.  
9 (2003) suggest using 8.6 meq/g. This experiment was conducted into a 1 Lbioreactor  
10 capable of automatically regulating the pH by a proportional integral derivative (PID)  
11 controller connected to a pH probe and a peristaltic pump. The reactor was also  
12 equipped with a heating jacket to keep a constant temperature of 55 °C, and Rushton  
13 impellers to stir the medium. The amount of base added over time was recorded by a  
14 computer. The model then was fitted to the experimental data using SigmaPlot (Version  
15 10.0, Systat Software Inc., USA).

## 37 **2.10 Life Cycle Assessment**

38 Life Cycle Assessment (LCA) was performed with SimaPro 9.0.4 software, database  
39 Ecoinvent 3.0. The goal of LCA was to compare all the experiments of the DoE, to  
40 choose the best extraction process in terms of environmental sustainability. To be  
41 consistent with the goal of the study and with the function to which the process system  
42 was designed for, the chosen functional unit was 1g of fish oil. The adopted approach  
43 was from grave to cradle. The definition of the boundary conditions of the study  
44 includes the transported tuna waste feed as feedstock for the process, then the tuna pre-  
45 treatment, the enzymatic extraction, the thermal treatment, and last the centrifugation to  
46 recover the extracted oil. The scheme of the boundary condition is drawn in Fig 1.

1 According to the zero-burden assumption, it was assumed that tuna waste did not  
2 contain any credits related to the impacts produced during the previous stages of its life  
3 cycle (Buttol et al., 2007). Furthermore, another assumption was the allocation criteria.  
4 To be more precautionary and avoided double discounting, all the environmental  
5 impacts and credit were allocated on the fish oil, which was the product target, and all  
6 the by-products and co-products generated in the studied system were considered as  
7 waste.

8 The life cycle inventory (LCI) defined all inputs and outputs involved in the processes.  
9 The primary data came from the present study, the produced emissions, the consumed  
10 material, and the required energy were referred to the chosen FU. The reagents which  
11 were not present in the Ecoinvent database were computed on a stoichiometric basis.  
12 The detailed inventory is provided in the supplementary materials. The secondary data,  
13 taken from Ecoinvent 3.0 were:

- 14 - Electricity, medium voltage {Row}| market for | Alloc Rec, S
- 15 - Tap Water from natural resource

16 Electricity RoW (rest of the world), was chosen to avoid geolocalizing the process, not  
17 being in the scope of the analysis.

18 Life cycle impact assessment (LCIA) was performed with the ReCIPE Midpoint (H)  
19 method. In the present study, the analyzed impact categories were: Climate change (kg  
20 CO<sub>2</sub> eq), Ozone depletion (kg CFC-11 eq), Freshwater eutrophication (kg P eq), Marine  
21 eutrophication (kg N eq) and Terrestrial acidification (kg SO<sub>2</sub> eq) because they were the  
22 most used impact categories in the fish processing industry (Avadí and Fréon, 2013;  
23 Ruiz-Salmón et al., 2021). The results of the LCA were also analyzed through a  
24 Principal Component Analysis (PCA) performed with Matlab (R2020a).

### 3. Results and discussion

#### 3.1 Protease and Tuna viscera characterization

The commercial Alcalase solution shows an activity of  $5.559 \pm 0.004$  (Units/mg protein).

The defrosted tuna was not deprived of blood and water, so the moisture content resulted quite high ( $77.5 \pm 0.1$  %). The carbohydrate content is not revealed (NR) and also the percentage of ashes resulted very low ( $2.22 \pm 0.1$  %). The most interesting values for this study are the percentage of proteins and lipids, respectively  $17.70 \pm 0.20$  % and  $2.58 \pm 0.08$  %.

These results are in line with other works investigating the composition of different body parts of several tuna species (Karunarathna and Attygalle, 2009; Vlieg and Murray, n.d.). Karunarathna and Attygalle (2009) affirm that the moisture percentage of tuna viscera is around 70 %, the protein content is between 16-19 %, the lipids percentage can vary between 0.9 and 1.34 % and ash content is around 1 % while the amount of carbohydrates is negligible in all tuna species. Slight variations are possible and depend on several factors, such as the species, diet, age and other parameters of the tuna (Karunarathna and Attygalle,2009).

#### 3.2 Enzymatic extraction and interpretation of the Design of Experiments results

After extraction and centrifugation, the samples showed a four-layers separation with the oil floating on the top, followed by a light mixture of lipids and proteins, then by the FPH and a solid residue on the bottom of the falcon. The oil was collected using a plastic pipette, to be quantified and analyzed through a GC-MS instrument. The second and bottom layers were discarded, while the FPH layer was collected for future analysis.

1 Table 1 reports the results of the DoE in terms of oil yield %. The amount of extracted  
2 oil varies from 15 % up to 81.4 %. To model the percentage oil yield a full MLR  
3 regression model was first computed and after a preliminary elaboration, the model was  
4 simplified excluding the non-significant terms, i.e., the interaction and quadratic terms.  
5  
6  
7  
8  
9 Only the statistically significant terms were included, as described by equation 7.

$$12 \quad y = \beta_0 + \beta_{pH}pH + \beta_{E/S}E/S + \beta_t t + \varepsilon \quad (7)$$

14 The significant linear terms are reported in the plot of the coefficients (Figure 3a) and in  
15 Table 2, where the presence of \* indicates the significance of the coefficients: \*\* =  $p <$   
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65  
0.01, \*\*\* =  $p < 0.001$ .

Time was the factor with the lowest influence on the extraction yield. The positive  
values of all coefficients indicate that they positively influence the response, i.e., the oil  
yield % increases with the increase of pH, E/S and time. These results are confirmed by  
the response surfaces reported in Figures 3b,c,d. These surfaces represent a three-  
dimensional view of the relationship between pairs of factors (reported on the x and y  
axes) and the response (plotted on the z axis), providing a clear picture of how the  
response is related to the factors.

In this model the response surface takes the shape of a tilted plane, where the yield  
increases when the factors increase. The flat look of the surface is due to the fact that all  
quadratic and interaction terms were excluded from the MLR model, therefore no terms  
describing possible curvatures of the response were included. According to the model, it  
is possible to obtain the maximum oil yield % at maximum pH, E/S and time values (pH  
= 8.5; E/S % = 1; t = 120 min).

The influence of pH is one of the most important parameters to be analysed in  
enzymatic hydrolysis. Indeed, enzymes contain a catalytic active site with charger  
amino acids. The pH can affect the dissociation state of these amino acids changing the

1 ionic bonds that maintain the three-dimensional shape of the protein. This may lead to  
2 alteration in protein function or inactivation of enzymes (Shu et al., 2016).  
3

4 Alcalase was initially obtained from *Bacillus subtilis* and called “Subtilisin Carlsberg”  
5 (Tacias-Pascacio et al., 2020). Subtilisin, generally, work optimally in mildly alkaline.  
6

7 This kind of enzymes are serine proteases that contain catalytic triadin order of aspartic  
8 acid, histidine, and serine residues (Azrin et al., 2022) and in particular, Ser221, His64  
9 and Asp32 (Wells and Estell 1988). The activity of subtilisin increases at alkaline pH  
10 because His64 is deprotonated. Therefore, by increasing the pH there is a greater  
11 activity of the enzyme which hydrolyzes more proteins, releasing larger quantities of oil  
12 and increasing the yield.  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22

23 Results show a positive effect of the enzyme: substrate ratio on the enzymatic  
24 hydrolysis, the increase of the enzyme concentration resulted an higher oil yield.  
25  
26

27 At higher E/S, indeed, there are more enzyme active sites available to hydrolyze the  
28 substrate, resulting in a more effective cleavage of the peptide bonds, and consequently  
29 greater degradation of the proteins (Kurozawa et al, 2009).  
30  
31  
32  
33  
34  
35

36 To the best of the authors’ knowledge, this is the first study regarding the enzymatic  
37 extraction of tuna oil using Alcalase applying DoE. These results are in line with  
38 Ramakrishnan et al. (2013), who investigated the effects of E/S and time, separately, on  
39 the oil extraction from mackerel waste material using Alcalase at 55 °C and pH = 8.5  
40 (Ramakrishnan et al., 2013). They demonstrated that oil yield increases with the  
41 increase in the enzyme concentration (0.5, 1 and 2 %) and time (1, 2, 3 and 4 h),  
42 reaching a plateau around an hour and a half of elapsed time. Qi-yuan et al. (2016)  
43 extracted oil from mackerel viscera applying a DoE to investigate how the extraction is  
44 affected by enzyme concentration, pH and temperature (Qi-Yuan et al., 2016). Their  
45 work confirms that as the E/S ratio increases, the oil yield also increases. In their study,  
46 De Oliveira et al. (2017) extracted oil from tuna by-product through enzymatic  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 extraction using Alcalase and they affirmed that this technique allows obtaining an oil  
2 of better quality than other obtained with non-green extraction techniques (De Oliveira  
3 et al., 2017). However, there are very few literature studies in which oil is extracted  
4 from tuna waste, while there are many on enzymatic extractions from other fishes.  
5  
6

7 Wang et al. (2019) affirmed that Alcalase (at 55 °C and pH = 8) could be used as a good  
8 protease for extracting a good quality Antarctic krill oil (Wang et al., 2019). The present  
9 work results are also in line with Głowacz-Rozynska et al. (2016) who tried to extract  
10 the oil from salmon waste, showing that it is possible to achieve yields of around 82 %  
11 using Alcalase at 55 °C and pH = 8 (Głowacz-Rozynska et al., 2016). Other authors  
12 effectively extracted good quality oil from fish waste such as catla, rohu, perch,  
13 copepod, tilapia or trout, using Alcalase (Babajafari et al., 2017; Li et al., 2018; Taylor  
14 et al., 2013; Vlieg and Murray, n.d.). Araujo et al. (2021) treated fish scraps from a  
15 market with Alacase al pH = 8, 50 °C and 180 min and deduced that the E/S ratio was  
16 the main factor controlling the hydrolysis (Araujo et al., 2021).  
17  
18

19 To evaluate the prediction power of the MLR model, two replicated experiments of the  
20 central point of the design (not included to compute the model) were performed. Table 3  
21 reports the experimental values of the two experiments, the upper and lower values with  
22 their predicted values, and their residuals. The predictive capacity of the model is hence  
23 confirmed.  
24  
25

### 26 **3.3 Progress of protein hydrolysis**

27 To monitor the progress of the hydrolysis, the DH% as a function of time was measured  
28 using the pH-stat method in a 1 L Bioreactor, applying the optimum condition found  
29 with the DoE (55 °C, pH = 8.5 E/S = 1 %). As shown in the graph in Figure 4 DH%  
30 increases very quickly in the first hour of reaction and then stabilizes around 22 %.  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 The experimental sets of (DH%, t) were fit to Eq. (9) using Sigma Plot and the results of  
2 the fitting procedure are listed in Figure 3 (Babajafari et al., 2017; Taylor et al., 2013).

3  
4 The squared points of Figure 3 represent the experimental values with their standard  
5 deviation and the continuous line the values obtained from the Equation 8. To evaluate  
6 the quality of the fitting, the correlation coefficient R, and the coefficient of  
7 determination R<sup>2</sup> were evaluated. These values, very close to 1, indicate that the  
8 regression predictions fit the data almost perfectly. The model passed also the Shapiro-  
9 Wilk test and the constant variance test with a significance level of 99 %.

$$DH\% = \frac{a + bt}{1 + ct} \quad (8)$$

10  
11 These results are consistent with the work of Saidi et al. (2013), which hydrolyzed tuna  
12 by-products at the exact conditions of the present work and demonstrated that progress  
13 of hydrolysis increased roughly during the first hour and then no significant variation  
14 can be observed (Saidi et al., 2013). Ovissipour et al. (2010) obtained a trend in good  
15 agreement with our results, but the DH% stabilized around 16 %, probably because they  
16 did not work at controlled pH (Ovissipour et al., 2010). These results are also confirmed  
17 by Guerard et al. (2001) (Guérard et al., 2001). Klomklao and Benjakul (2016) obtained  
18 a curve with the same shape as the one in Figure 4, but their curve reached the plateau at  
19 an earlier time (20 min) and at higher DH% (35 %) (Klomklao and Benjakul, 2016).

20  
21 This is possibly caused by the fact that they used more severe T, pH and E/S conditions  
22 for the reaction compared to our experimental conditions. Valencia et al. (2014)  
23 identified the mechanisms responsible for the shape of the Alcalase hydrolysis curve for  
24 fish proteins (Valencia et al., 2014). They demonstrated that these curves are  
25 characterized by an initial “hydrolysis phase” followed by a slowdown and stabilization  
26 of the degree of hydrolysis. The cause for this decrease in reaction rate

1 could be associated with several factors, such as: a decrease in the concentration of  
2 peptide bonds of the substrate available for hydrolysis; a product inhibition caused by  
3 amino acids and soluble peptides released during the hydrolysis that act as a substrate  
4 competitor; and an enzyme deactivation (Klomklao and Benjakul, 2016; (Kurozawa et  
5 al, 2009).  
6  
7  
8  
9  
10

### 11 **3.4 Omega-3 quantification**

12 The oil fraction was analyzed through GC-MS to quantify the omega-3 FA in terms of  
13 EPA and DHA; they represent  $2,49 \pm 0,32$  % and  $10,83 \pm 1,13$  % of the extracted oil.  
14  
15

16 The percentages obtained in this work are lower than percentages achieved by De  
17 Oilivera et al. (2017). They extracted oil from tuna heads with Alcalase but applied  
18 different experimental conditions and reached 6 % of EPA and 27 % of DHA (De  
19 Oliveira et al., 2017). In general, the content of EPA and DHA in fish oil varies  
20 respectively from 5 to 26 %, and from 6 to 26 % of the total fatty acid, depending on  
21 fish species (Alkio et al., 2000). From the data found in the literature, tuna oil contains  
22 about 5 % of EPA and 25 % of DHA (Halldorsson et al., 2003; Zhang et al., 2017). In  
23 their work, Alkio et al. (2000) used tuna oil containing 4.6 % of EPA and 18.3 % of  
24 DHA, so these amounts are very variable (Alkio et al., 2000). Besides the study by De  
25 Oilivera et al. (2017), the tuna oil analyzed in these research works is never made from  
26 the tuna viscera, and the percentage composition of fatty acids can be very different.  
27 Moreover, even the extraction procedure is not consistent across the different studies,  
28 making the literature data hardly comparable to each other. In any case, the percentage  
29 of omega-3 found in the oil extracted in this study makes it a product with excellent  
30 qualities. As a matter of fact, EPA and DHA contribute to preventing some  
31 cardiovascular and various inflammatory diseases such as hyperlipidemia,  
32 atherosclerosis, inflammation, and cancer. Moreover, they present some beneficial  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 effects on the brain and nervous system (Alkio et al., 2000; Correa-Matos and Vaghefi,  
2 2013; De Oliveira et al., 2017; Halldorsson et al., 2003; Zhang et al., 2017).  
3  
4

### 5 **3.5 Life Cycle Assessment**

6  
7  
8 The comparison of the environmental sustainability of the different extractions defined  
9 by the DoE was analyzed through Life Cycle Assessment (LCA).  
10

11 Figure 4 shows the results of LCA among the 15 experiments of the DoE (the replicas  
12 of the central point were not considered) through five impact categories: Climate change  
13 (a, kg CO<sub>2</sub> eq), Ozone depletion (b, kg CFC-11 eq), Terrestrial acidification (c, kg SO<sub>2</sub>  
14 eq), Freshwater eutrophication (d, kg P eq) and Marine eutrophication (e, kg N eq). The  
15 analysis was limited to these five categories because, as indicated by Ruiz-Salmón et al.  
16 (2021), they are the most studied ones in LCA of fish and seafood processed products  
17 and, therefore, it would make the present study more comparable to what can be already  
18 found in the literature. By reviewing a considerable number of works on this topic,  
19 Ruiz-Salmón et al. (2021), highlighted that Ozone depletion was computed by 53 % of  
20 analyzed authors, followed by acidification (64 %) and eutrophication (66 %) (Ruiz-  
21 Salmón et al., 2021). However the study of Ruiz-Salmón et al. (2021) focused on the  
22 impact of landed fish, fish distribution and the process to make fish an edible product.  
23 The aim of the selected five impact categories is following defined. Climate change is  
24 the indicator of the global warming potential (GWP) caused by the emissions of  
25 greenhouse gasses into the atmosphere. Ozone depletion indicates the emissions to the  
26 atmosphere responsible for destroying the stratospheric ozone layer. Acidification is the  
27 indicator of the potential acidification of soils and water due to the release of gasses  
28 such as nitrogen oxides and sulfur oxides. The freshwater eutrophication indicator  
29 expresses the freshwater ecosystem's enrichment with nutritional elements attributable  
30 to the emission of compounds phosphor. Marine eutrophication is the indicator of  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 enhancing the marine ecosystem with nutritive elements due to nitrogen-containing  
2 compounds (Jessen et al., 2015). To the best of the author's knowledge, in the literature,  
3  
4 there are no available studies to compare the environmental impacts and credits of the  
5  
6 process and substrate investigated in the present paper. For this reason, in the present  
7  
8 work, the discussion of LCA results was done as a comparison between the 15  
9  
10 investigated configurations of the DoE.  
11  
12

13  
14 Figure 5 reported the results of the 15 configurations for each impact category with the  
15  
16 absolute value, where the contribution of each process step was referred as a percentage  
17  
18 of the absolute value. Moreover, to underline the contribution of energy items in the  
19  
20 total impact, it was highlighted in each process step in which it was required:  
21  
22 pretreatment, enzymatic extraction phases, deactivation unit and oil recovery through  
23  
24 centrifuge equipment.  
25  
26  
27

28  
29 Figure 5 proved that for all the tested configurations, the main contribution to the total  
30  
31 environmental impact among the five investigated impact categories was the consumed  
32  
33 energy and in particular the energy required for the enzymatic extraction and  
34  
35 centrifugation phases.  
36  
37

38  
39 As shown in Figure 5a-e, experiment n° 4 presented the lower contributions in all the  
40  
41 impact categories analyzed in this work. This experiment was conducted at pH of 8.5  
42  
43 with an E/S of 1 % and for 30 mins. It is important to notice that, according to the DoE,  
44  
45 this experiment does not correspond to the highest obtainable oil yield but with the  
46  
47 same quantity of oil produced, it is the most sustainable combination of experimental  
48  
49 conditions, from an environmental point of view. By analyzing Figure 5, it is possible to  
50  
51 note that all the experiments with a reaction time of 30 minutes, which correspond to  
52  
53 the lowest level of the time factor analyzed in the DoE, had minor impacts. It could be  
54  
55 deduced that the duration of the reaction greatly influences the sustainability of this  
56  
57 process. Indeed, for the climate change category, the experiments with the longest  
58  
59  
60  
61  
62  
63  
64  
65

1 enzyme extraction step (120 min) reached the highest energy contribution in that phase,  
2 which ranged between 30-52 % of the total impact in all the considered impact  
3 categories.  
4  
5

6  
7 Furthermore, in all the considered impacts categories, the recovery of the oil is one of  
8 the highest energy consumer items, hence the present study underlined the importance  
9 of optimizing the downstream technology to recover the product target.  
10  
11

12  
13 Another attentioned parameter in the present study of sustainability is the role of the  
14 enzyme. In the marine eutrophication the effect of the enzyme was highlighted, and it  
15 reached the highest contribution in the experiment in which the dose of the Alcalase was  
16 the highest one (1 mL) and the yield of fish oil was not the optimal one compared to the  
17 amount of tuna treated (0,2 g/ g of tuna).  
18  
19

20  
21 Among the investigated configurations, the one, reaching the highest impact of enzyme  
22 in marine eutrophication, was the experiment n°3 with a value equal to 72 % of the total  
23 enzymatic pretreatments (made up by the sum of the enzyme contribution and energy  
24 required to carry out the enzymatic extraction phase).  
25  
26

27  
28 Among the five impact categories, the pretreatment unit, consisting in pH regulation  
29 with the addition of a buffer, had environmental impacts detectable in terrestrial  
30 acidification and freshwater eutrophication due to the adopted chemicals. Specifically,  
31 the configurations n° 1, 2 and 6 exhibited pretreatment unit impact in terrestrial  
32 acidification and freshwater eutrophication ranging between 6,5-8 and 6-8,10 % of the  
33 total environmental impacts in those categories.  
34  
35

36  
37 The transport of tuna exhibited a considerable impact in the ozone depletion category  
38 due to the necessity of transporting the feedstock with a refrigerated lorry for a distance  
39 of 1524 km (from the south of Italy to the north of Italy plant) in accordance with the  
40 study of (Khoo, et al 2019). The contribution of tuna transport in ozone depletion  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 decreased by decreasing the amount of tuna, because according to the chosen FU (1g of  
2 fish oil), it means that the process is high performing.  
3

4 According to the study of (Sillero et al,2021) about LCA of biorefinery systems in  
5 general and not specific for substrate or type of process, the enzyme application impacts  
6 on marine eutrophication due to its origin, whereas pretreatment impacts on terrestrial  
7 acidification and freshwater eutrophication due to the use of chemical and their post  
8 consume, whereas the product recovery exhibits great impacts on climate changes and  
9 ozone depletion due to the energy requirement.  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20

### 21 **3.6 Evaluation of LCA results through PCA**

22 To better compare the LCA results, it was decided to organize the values reported in  
23 Figure 4 into a data matrix of dimensions  $15 \times 5$  (one column for each impact category)  
24 and to analyze it using PCA. Prior to analysis, the data table was scaled to unit variance  
25 and mean centered. The PCA results are reported in Figure 6. As already highlighted in  
26 Figure 5, Climate change (a), Ozone depletion (b), Terrestrial acidification (c) and  
27 Freshwater eutrophication (d) share the same overall trend, while Marine eutrophication  
28 (e) shows a rather different pattern. This aspect is confirmed by the PC1-PC2 loadings  
29 plot (Figure 6a), as all impact categories appear to be highly correlated, since they are  
30 located at positive PC1 values. PC2 accounts for the difference between Marine  
31 eutrophication and the other four impact categories. Regarding the DoE experiments'  
32 distribution in the scores plot of Figure 6b, it can be noticed a clear trend related to the  
33 extraction time (blue arrow and coloring). Moreover, from this plot it becomes clear that  
34 experiment n°4 has the lowest impact in all categories, while experiment n°7 has the  
35 largest impact in all categories.  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57

58 The pattern of correlations among the impact categories described by PC2-PC3 (Figure  
59 6a,b) seems to be related to the response, as the experiments' distribution colored  
60  
61  
62  
63  
64  
65

1 according to the oil yield % follow a rather clear trend (yellow arrow). The experiments  
2 with the highest response also have higher impacts in the Climate change and Terrestrial  
3 acidification categories, while the same experiments show much lower impacts in the  
4 Ozone depletion and Marine eutrophication categories.  
5  
6

7  
8  
9 Considering the results of the LCA expressed in figure 5 and of the PCA represented in  
10 figure 6, the following considerations can be made. Almost all impact is caused by  
11 electricity in all four categories. In this LCA study, non-geolocalized medium voltage  
12 electricity was used, referring to the whole world (Simapro). This electricity represents  
13 an average of all types of electricity used globally, from renewable and non-renewable  
14 sources (coal, oil, gas, biomass, nuclear, hydro, wind, geothermal, solar marine)  
15 (Schmidt et al., 2011). The production of this electricity causes emissions of greenhouse  
16 gasses, nitrogen oxides, and sulfur oxides, substances responsible for the depletion of  
17 the ozone layer and compounds rich in phosphorus and nitrogen, damaging the various  
18 ecosystems (Kalender and Alkan, 2019). For this reason, the DoE experiments with the  
19 shortest time are also those with the lowest environmental impact.  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35

36 The only impact category where the enzyme also contributes in large quantities to the  
37 total is Marine eutrophication. This LCA study assumed that the Alcalase is produced  
38 from potato starch along with a bacterial strain, as suggested by Rosa et al. (2020) (Rosa  
39 et al., 2020). It is possible that the cultivation of potatoes and the use of fertilizers  
40 greatly influence this impact category, increasing the emission of substances rich in  
41 nitrogen into rivers or coastal areas or the nitrogen applications to the soil  
42  
43  
44  
45  
46  
47  
48  
49  
50

51 These results are in line with the results obtained from the DoE. Indeed, the best  
52 experimental configuration is the one that uses a buffer at pH 8.5 and an E/S of 1 %.

53 The duration of the process seems to be most responsible for the environmental impact,  
54 but time seems to be the least significant factor among the variables analyzed using the  
55 DoE. Moreover, the study of hydrolysis kinetics has shown that the DH% stabilizes  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 around a plateau after one hour. Therefore, it would be possible to reduce reaction times  
2 by reducing the environmental impacts without losing much in oil yield. Another way to  
3 reduce the contribution of electricity could be to geolocate the process and use  
4 renewable resources. For what it concerns the contribution due to the use of the enzyme,  
5 new scenarios could be envisaged, changing the type of enzyme or its way of  
6 production.  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18

#### 19 **4. Conclusions**

21 The enzymatic hydrolysis of tuna waste represents an innovative technology to exploit  
22 canned tuna processing wastes to obtain products with high added value, such as tuna  
23 oil and FPH. This study has shown that it is possible to obtain good quality tuna oil rich  
24 in omega-3 fatty acids through enzymatic hydrolysis of tuna viscera derived by a  
25 canned tuna production company with commercial enzyme Alcalase.  
26  
27  
28  
29  
30  
31  
32

33 The DoE made it possible to optimize oil extraction and identify the best pH (8.5 °C),  
34 E/S (1%), and time (120 minutes). It was possible to obtain a model able to compute the  
35 yield as a function of the three-factor analyzed. The study of the progress of the DH%  
36 over time showed that after one hour, the reaction slows down. The experiments of the  
37 DoE were compared to each other through an LCA analysis, and the results were  
38 investigated with a PCA. This innovative approach allowed to demonstrate that  
39 the duration of the hydrolysis and the associated electricity consumption is the variable  
40 that most affects the environmental sustainability of the process.  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53

54 Further studies would be needed to reduce the time of hydrolysis, analyze in more depth  
55 the FPH obtained and its proprieties and design a possible scale-up in order to evaluate  
56 the technical, economic and environmental feasibility of this process at an industrial  
57 level.  
58  
59  
60  
61  
62  
63  
64  
65

## Acknowledgments

We thank “Ditta Drago Sebastiano di Giuseppe Drago” (Siracusa) for sending the tuna waste materials from their production chain.

**Funding:** This research did not receive any specific grant from funding agencies in the public, commercial, or not-for-profit sectors.

## References

1. Ababouch, L., Catarci, C., 2008. Global production and marketing of canned tuna, Globefish Research Programme, Vol.94 Rome, FAO. p. 65
2. Adler-Nissen, J., 1982. ChemInform Abstract: Limited enzymic degradation of proteins: a new approach in the industrial application of hydrolases. Chem. Informations. 13, 138–156. <https://doi.org/10.1002/chin.198226331>
3. Alkio, M., Gonzalez, C., Jäntti, M., Aaltonen, O., 2000. Purification of Polyunsaturated Fatty Acid Esters from Tuna Oil with Supercritical Fluid Chromatography. J. Am. Oil Chem. Soc., 77, 3 <https://doi.org/10.1007/s11746-000-0051-3>
4. Allain, V., Pilling, G. M., Williams, P. G., Harley, S., Nicol, S., & Hampton, J. 2016. Overview of tuna fisheries, stock status and management framework in the Western and Central Pacific Ocean. In Pauwels, S., & Fache, E. (Eds.), Fisheries in the Pacific: The challenges of governance and sustainability. pacific-credo Publications. doi:10.4000/books.pacific.423
5. Araujo, J., Sica, P., Costa, C., Márquez, M.C., 2021. Enzymatic Hydrolysis of Fish Waste as an Alternative to Produce High Value-Added Products. Waste and Biomass Valorization 12, 847–855. <https://doi.org/10.1007/s12649-020-01029-x>
6. Avadí, A., Fréon, P., 2013. Life cycle assessment of fisheries : A review for fisheries scientists and managers. Fish. Res. 143, 21–38. <https://doi.org/10.1016/j.fishres.2013.01.006>
7. Babajafari, S., Moosavi-nasab, M., Nasrpour, S., 2017. Comparison of Enzymatic Hydrolysis and Chemical Methods for Oil Extraction from Rainbow Trout (*Oncorhynchus Mykiss* ) Waste and Its Influence on Omega 3 Fatty Acid

Profile. *J. Nutr. Sci.* 2, 2, 58-65.

8. Bligh, E.G. and Dyer, W.J., 1959. Canadian Journal of Biochemistry and Physiology. *Can. J. Biochem. Physiol.* 37.
9. Bro, R., Smilde, A.K., 2014. Principal component analysis. *Anal. Methods*, 2014, 6 ,2812 <https://doi.org/10.1039/c3ay41907j>
10. Brotas, M.S.C., Carvalho, G.A., Pereira, P.A.P., 2020. Determination, through derivatization and GC-MS analysis, of Omega-3 and Omega-6 fatty acids in fish oil capsules sold in Salvador, Bahia. *J. Braz. Chem. Soc.* 31, 447–455. <https://doi.org/10.21577/0103-5053.20190203>
11. Buttol, P., Masoni, P., Bonoli, A., Goldoni, S., Belladonna, V., Cavazzuti, C., 2007. LCA of integrated MSW management systems: case study of the Bologna district. *Waste Management* 27, 1059–1070
12. Calder, P.C., 2012. Omega-3 polyunsaturated fatty acids and inflammatory processes : nutrition or pharmacology. *Br. J. Clin. Pharmacol.* 75, 3, 645–662 [/https://doi.org/10.1111/j.1365-2125.2012.04374.x](https://doi.org/10.1111/j.1365-2125.2012.04374.x)
13. Correa-Matos, N.J., Vaghefi, S.B., 2013. Dairy Foods and Cardiovascular Diseases. In: *Bioactive Food as Dietary Interventions for Cardiovascular Disease*. Watson, R.R., Preedy, V.R. (eds). Elsevier Inc. pp. 319-332. <https://doi.org/10.1016/B978-0-12-396485-4.00018-9>
14. Cupp-enyard, C., 2008. Sigma’s Non-specific Protease Activity Assay - Casein as a Substrate.. *J. Vis. Exp.* 19. <https://doi.org/10.3791/899>
15. De Oliveira, D.A.S.B., Licodiedoff, S., Furigo, A., Ninow, J.L., Bork, J.A., Podestá, R., Block, J.M., Waszczyński, N., 2017. Enzymatic extraction of oil from yellowfin tuna (*Thunnus albacares*) by-products: a comparison with other extraction methods. *Int. J. Food Sci. Technol.* 52, 699–705. <https://doi.org/10.1111/ijfs.13324>
16. FAO. 2020. The State of World Fisheries and Aquaculture 2020. Sustainability in action. Rome. <https://doi.org/10.4060/ca9229en>
17. Glowacz-Rozynska, A., Tynek, M., Malonowska-Panczyk, E., Martysiak-Zurowska, D., Pawłowicz, R., Kolodziejska, I., 2016. Comparison of oil yield and quality obtained by different extraction procedures from salmon (*Salmo salar*) processing byproducts. *Eur. J. Lipid Sci. Technol.* 118, 1759–1767. <https://doi.org/10.1002/ejlt.201500269>
18. Guérard, F., Dufossé, L., De La Broise, D., Binet, A., 2001. Enzymatic

- 1 hydrolysis of proteins from yellowfin tuna (*Thunnus albacares*) wastes using  
2 Alcalase. *J. Mol. Catal. - B Enzym.* 11, 1051–1059.  
3 [https://doi.org/10.1016/S1381-1177\(00\)00031-X](https://doi.org/10.1016/S1381-1177(00)00031-X)  
4
- 5 19. Halldorsson, A., Kristinsson, B., Glynn, C., Haraldsson, G.G., 2003. Separation  
6 of EPA and DMA in Fish Oil by Lipase-Catalyzed Esterification with Glycerol.  
7 *J. Am. Oil Chem. Soc.* 80, 915–921. <https://doi.org/10.1007/s11746-003-0796-8>  
8
- 9 20. Herpandi, N., Huda, Rosma, A., and Wan Nadiah, W.A., 2011. The Tuna  
10 Fishing Industry : A New Outlook on Fish Protein Hydrolysates. *Compr. Rev.*  
11 *Food Sci.* 10, 195–207. <https://doi.org/10.1111/j.1541-4337.2011.00155.x>  
12  
13
- 14 21. Hospido, A., Vazquez, M.E., Cuevas, A., Feijoo, G., Moreira, M.T., 2006.  
15 Environmental assessment of canned tuna manufacture with a life-cycle  
16 perspective. *Resour. Conserv. Recycl.* 47, 56–72.  
17  
18 <https://doi.org/10.1016/j.resconrec.2005.10.003>  
19  
20
- 21 22. Je, J.Y., Lee, K.H., Lee, M.H., Ahn, C.B., 2009. Antioxidant and  
22 antihypertensive protein hydrolysates produced from tuna liver by enzymatic  
23 hydrolysis. *Food Res. Int.* 42, 1266–1272  
24  
25 <https://doi.org/10.1016/j.foodres.2009.06.013>  
26  
27
- 28 23. Jessen, C., Bednarz, V.N., Rix, L., Teichberg, M., 2015. Marine Eutrophication.  
29 In: Armon, R.H., Hañnininen, O. (eds.), *Environmental Indicators*, Springer  
30 Science+Business Media Dordrecht. pp 177-203. <https://doi.org/10.1007/978-94-017-9499-2>  
31  
32  
33  
34  
35  
36  
37
- 38 24. Kalender, S.S., Alkan, G.B., 2019. Air Pollution in: Hussain, C. M. (ed.),  
39 *Handbook of Environmental Materials Management*. Springer Nature  
40 Switzerland pp. 149-166  
41  
42
- 43 25. Karunarathna, U., 2009. Nutritional evaluation in five species of tuna. *VJS.* 6–  
44 16. <https://doi.org/10.31357/vjs.v15i0.211>  
45  
46
- 47 26. Klomklao, S., Benjakul, S., 2016. Utilization of tuna processing byproducts :  
48 protein hydrolysate from skipjack tuna ( *katsuwonus pelamis* ) viscera. *J. Food*  
49 *Process. Preserv.* <https://doi.org/10.1111/jfpp.12970>  
50  
51
- 52 27. Khoo, H.H., Eufrazio-espinoza, R.M., Koh, L.S.C., Sharratt, P.N., 2019.  
53 Sustainability assessment of biorefinery production chains : A combined LCA-  
54 supply chain approach. *J. Clean. Prod.* 235, 1116–1137  
55  
56  
57  
58 <https://doi.org/10.1016/j.jclepro.2019.07.007>  
59
- 60 28. Kruger, N.J., 1994. The Bradford method for protein quantitation. *Methods Mol.*  
61  
62  
63  
64  
65

Biol. 32, 9–15. <https://doi.org/10.1385/0-89603-268-x:9>

- 1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65
29. Leardi, R., 2009. Experimental design in chemistry: A tutorial. *Anal. Chim. Acta* 652, 161–172. <https://doi.org/10.1016/j.aca.2009.06.015>
30. Li, X., Cao, J., Bai, X., Zhang, F., 2018. Chemical composition and thermal properties of Tilapia oil extracted by different methods. *Int. J. Food Prop.* 21, 1575–1585. <https://doi.org/10.1080/10942912.2018.1503302>
31. Mariotti, F., Tomé, D., Mirand, P.P., 2008. Converting Nitrogen into Protein — Beyond 6 . 25 and Jones ' Factors. *Crit. Rev. Food. Sci. Nutr.* 48, 177-184. <https://doi.org/10.1080/10408390701279749>
32. Miyamoto, A., Allacker, K., De Troyer, F., 2019. Visual tool to integrate LCA and LCC in the early design stage of housing Visual tool to integrate LCA and LCC in the early design stage of housing. *IOP Conf. Series: Earth and Environmental Science*, 323, 012161 <https://doi.org/10.1088/1755-1315/323/1/012161>
33. Navarrete del Toro, M.A., García- Carreño, F.L., 2003. Evaluation of the Progress of Protein Hydrolysis. *Curr. Protoc. Food Anal. Chem.* 10, 1–14. <https://doi.org/10.1002/0471142913.fab0202s10>
34. North, P., Zealand, N., 2010. Methodology for Determining Degree of Hydrolysis of Proteins in Hydrolysates: A Review. *J. AOAC Int.* 93, 5, 1515–1522.
35. Ovissipour, M., Benjakul, S., Safari, R., Motamedzadegan, A., 2010. Fish protein hydrolysates production from yellowfin tuna *Thunnus albacares* head using Alcalase and Protamex. *Int. Aquat. Res.* 2, 87–95.
36. Qi-Yuan, L., Jun-Qing, Q., Xiao-Ge, W., 2016. Optimization of enzymatic fish oil extraction from mackerel viscera by response surface methodology. *Int. Food Res. J.* 23, 992–997.
37. R. Leardi, C. Melzi, G. Polotti, CAT (Chemometric Agile Tool), freely downloadable from <http://gruppochemiometria.it/index.php/software> Last access 20/07/2022
38. Ramakrishnan, V.V., Ghaly, A.E., Brooks, M.S., Budge, S.M., 2013. Extraction of Oil from Mackerel Fish Processing Waste using Alcalase Enzyme. *J. Bioprocess Biotech.* 3, 2 . <https://doi.org/10.4172/2155-9821.1000130>
39. Rapporti ISTISAN96/34. Analytical methods used in food chemical control. Collection edited by Massimo Baldini, Fabio Fabietti, Stefania Giammarioli,

Roberta Onori, Leucio Orefice and Angelo Stacchini, 1996, v. 265

- 1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65
40. Rosa, R., Spinelli, R., Neri, P., Pini, M., Barbi, S., Montorsi, M., Maistrello, L., Marseglia, A., Caligiani, A., Ferrari, A.M., 2020. Life Cycle Assessment of Chemical vs Enzymatic-Assisted Extraction of Proteins from Black Soldier Fly Prepupae for the Preparation of Biomaterials for Potential Agricultural Use. *ACS Sustain. Chem. Eng.* 8, 14752–14764.  
<https://doi.org/10.1021/acssuschemeng.0c03795>
41. Ruiz-salmón, I., Laso, J., Margallo, M., Villanueva-rey, P., Rodríguez, E., Quinteiro, P., Cláudia, A., Almeida, C., Leonor, M., Marques, A., Cortés, A., Teresa, M., Feijoo, G., Loubet, P., Sonnemann, G., Morse, A.P., Cooney, R., Clifford, E., Regueiro, L., Méndez, D., Anglada, C., Noirot, C., Rowan, N., Vázquez-rowe, I., Aldaco, R., 2021. Science of the Total Environment Life cycle assessment of fish and seafood processed products – A review of methodologies and new challenges. *Sci. Total Environ.* 761, 144094.  
<https://doi.org/10.1016/j.scitotenv.2020.144094>
42. Saidi, S., Belleville, M., Deratani, A., Amar, R. Ben, 2013. Optimization of peptide production by enzymatic hydrolysis of tuna dark muscle by-product using commercial proteases. *Afr. J. Biotechnol.* 12, 1533-1547  
<https://doi.org/10.5897/AJB12.2745>
43. Schmidt, J. H., Merciai, S., Thrane, M., Dalgaard, R. 2011. Inventory of country specific electricity in LCA – Consequential and attributional scenarios. Methodology report v2. 2.- 0 LCA consultants, Aalborg [http://www.lca-net.com/projects/electricity\\_in\\_lca/](http://www.lca-net.com/projects/electricity_in_lca/) Last access 20/07/2022
44. Sergent, M., 1995. Correct and incorrect use of multilinear regression. *Chemometr. Intell. Lab. Syst.* 27, 153–162.
45. Sillero, L., Morales, A., Fernández-marín, R., Hernández-ramos, F., 2021. Life Cycle Assessment of various biorefinery approaches for the valorisation of almond shells. *Sustain. Prod. Consum.* 28, 749–759  
<https://doi.org/10.1016/j.spc.2021.07.004>
46. Simonne, A.H., Simonne, E.H., Eitenmiller, R.R., Mills, H.A., Cresman, C.P., 1997. Could the dumas method replace the Kjeldahl digestion for nitrogen and crude protein determinations in foods *J. Sci. Food Agric.* 73, 39–45.  
[https://doi.org/10.1002/\(sici\)1097-0010\(199701\)73:1<39::aid-jsfa717>3.3.co;2-w](https://doi.org/10.1002/(sici)1097-0010(199701)73:1<39::aid-jsfa717>3.3.co;2-w)

- 1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65
47. Tacias-pascacio, V.G., Morellon-sterling, R., Siar, E., Tavano, O., Berenguer-murcia, Á., Fernandez-lafuente, R., 2020. International Journal of Biological Macromolecules Use of Alcalase in the production of bioactive peptides : A review. *Int. J. Biol. Macromol.* 165, 2143–2196.  
<https://doi.org/10.1016/j.ijbiomac.2020.10.060>
  48. Taylor, C.J., Baker, A., Chapman, M.R., Reynolds, W.R., Jolley, K.E., Clemens, G., Smith, G.E., Blacker, A.J., Chamberlain, T.W., Christie, S.D.R., Taylor, B.A., Bourne, R.A., 2021. Flow chemistry for process optimisation using design of experiments. *J. Flow Chem.* 11, 75–86. <https://doi.org/10.1007/s41981-020-00135-0>
  49. Taylor, P., Vang, B., Pedersen, A.M., Olsen, R.L., 2013. Oil extraction From the Copepod *Calanus finmarchicus* Using Proteolytic Enzymes. *J. Aquat. Food Prod. Technol.*, 37–41. <https://doi.org/10.1080/10498850.2012.686008>
  50. Understanding electricity in Simapro. <https://simapro.com/2019/understanding-electricity-in-simapro/> Last access 20/07/2022
  51. Valencia, P., Pinto, M., Almonacid, S., 2014. Identification of the key mechanisms involved in the hydrolysis of fish protein by Alcalase. *Process Biochem.* 49, 258–264. <https://doi.org/10.1016/j.procbio.2013.11.012>
  52. Vlieg, P., Murray, T., 2014. Proximate composition of albacore tuna, *Thunnus alalunga*, from the temperate South Pacific and Tasman Sea. *N. Z. J. Mar. Freshwater Res.* 22, 4, 491-496, .  
<https://doi.org/10.1080/00288330.1988.9516318>
  53. Wang, L., Yang, F., Rong, Y., Yuan, Y., Ding, Y., Shi, W., Wang, Z., 2019. Effects of different proteases enzymatic extraction on the lipid yield and quality of Antarctic krill oil. *Food Sci. Nutr.* 7, 2224–2230.  
<https://doi.org/10.1002/fsn3.1017>
  54. Zhang, Y., Wang, Xiaosan, Xie, D., Li, Y., Wang, Xingguo, 2017. One - Step Concentration of Highly Unsaturated Fatty Acids from Tuna Oil by Low - Temperature Crystallization. *J. Am. Oil. Chem. Soc.* 94, 475–483.  
<https://doi.org/10.1007/s11746-017-2949-3>
  55. Shu, G., Zhang, B., Zhang, Q., Wan, H., Li, H. "Effect of Temperature, pH, Enzyme to Substrate Ratio, Substrate Concentration and Time on the Antioxidative Activity of Hydrolysates from Goat Milk Casein by Alcalase" *Acta Universitatis Cibiniensis. Series E: Food Technology*, vol.20, no.2, 2016,

pp.29-38. <https://doi.org/10.1515/aucft-2016-0013>

- 1  
2 56. Wells, J. A., Estell, D. A., 1988, Subtilisin — an enzyme designed to be  
3 engineered. Trends in Biochemical Sciences, 13(8), 291–297. doi:10.1016/0968-  
4 0004(88)90121-1  
5
- 6  
7 57. Azrin, N., Ali, M., Rahman, R., Oslan, S., Noor, N., 2022. Versatility Of  
8 Subtilisin: A review on structure, characteristics, and applications. Biotechnol  
9 Appl Biochem. doi: 10.1002/bab.2309.  
10
- 11  
12 58. Kurozawa, L.E., Park, K.J., Hubinge, M.D., 2009, Production, Properties And  
13 Stability Ofchicken Meat Protein Hydrolysate Powder, in Handbook of  
14 Nutritional Biochemistry: Genomics, Metabolomics and Food Supply:  
15 Genomics, Metabolomics & Food Supply, Nova Science Publishers, Inc (eds)  
16 ISBN: 978-1-60741-916-7  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

### Figure Captions:

**Figure 1.** A representation of the three-factors, three-levels, Central Composite Face Centered (CCF) experimental domain. To model and explain the results of the DoE, a multiple linear regression (MLR) was applied, as described in Section 2.5.

**Figure 2.** Scheme of the LCA boundary conditions. For each process, input and output of matter and energy are illustrated.

**Figure 3.** (a) The coefficients plot of the MLR model (\*\*=  $p < 0.01$ , \*\*\* =  $p < 0.001$ ) and the response surfaces for oil yield %: (b) interaction between E/S and pH, (c) interaction between time and pH, (d) interaction between time and E/S.

**Figure 4.** Enzymatic extraction progress curve and results of the fitting procedure Black squares represent the experimental values. Each experiment was conducted in triplicate, and the error bars correspond to standard error. The continuous line represents the modeled values (eq. 9). a, b and c are the coefficients of equation 9. R and  $R^2$  represent the quality of the fitting.

**Figure 5.** Results of comparative LCA between the 15 experiments of the DoE in terms of five impact categories: (a) Climate change (kg CO<sub>2</sub> eq), (b) Ozone depletion (kg CFC-11 eq), (c) Terrestrial acidification (kg SO<sub>2</sub> eq), (d) Freshwater eutrophication (kg P eq) and (e) Marine eutrophication (kg N eq).

**Figure 6.** PCA scores and loadings plots of the comparative LCA results. Only the most informative combinations of principal components are reported: PC1-PC2 loadings (a)

and scores (b) plots; PC2-PC3 loadings (c) and scores (d) plots. The coloring in (b) corresponds to the extraction time, while in (d) it corresponds to the oil yield % (the response of the DoE). The coloring range values can be interpreted using the color bars on the right-hand side.

1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

**Tables:**

**Table 1** The experimental plan (i.e., the factors described with their original values) and matrix (i.e., the coded version of the factors' values) for tuna oil extraction optimization, whose yield values are reported in the last column on the right.

Experiment N°	pH (coded)	E/S (coded)	time (coded)	pH (original)	E/S (%) (original)	time (min) (original)	oil yield % (response)
1	-1	-1	-1	6.5	0.1	30	15.0
2	1	-1	-1	8.5	0.1	30	31.7
3	-1	1	-1	6.5	1	30	25.0
4	1	1	-1	8.5	1	30	49.3
5	-1	-1	1	6.5	0.1	120	24.1
6	1	-1	1	8.5	0.1	120	33.5
7	-1	1	1	6.5	1	120	56.0
8	1	1	1	8.5	1	120	81.4
9	-1	0	0	6.5	0.55	75	21.9
10	1	0	0	8.5	0.55	75	76.6
11	0	-1	0	7.5	0.1	75	27.7
12	0	1	0	7.5	1	75	47.0
13	0	0	-1	7.5	0.55	30	31.3
14	0	0	1	7.5	0.55	120	43.0
15	0	0	0	7.5	0.55	75	34.8
16	0	0	0	7.5	0.55	75	38.7
17	0	0	0	7.5	0.55	75	42.5

**Table 2.** Coefficients of the MLR model and their significance with the explained variance of the data. \*= p < 0,05 \*\*= p < 0.01, \*\*\* = p < 0.001

Coefficients				Explained Variance %
$\beta_0$	$\beta_{pH}$	$\beta_{E/S}$	$\beta_t$	
39.968	13.043	12.665	6.575	71.58
0.0000***	0.00009***	0.0011**	0.0148*	

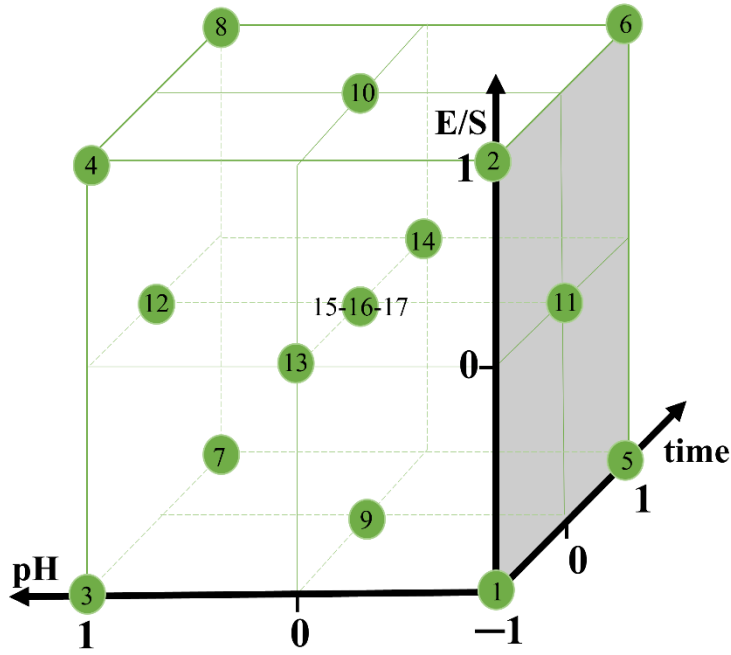
**Table 3.** Prediction results of experiments 18 and 19.

<b>Exp N°</b>	<b>Experimental value</b>	<b>Lower</b>	<b>Predicted value</b>	<b>Upper</b>	<b>Residuals</b>
18	24.16	34.90	39.97	45.04	-2.20
19	39.25	34.90	39.97	45.04	0.71

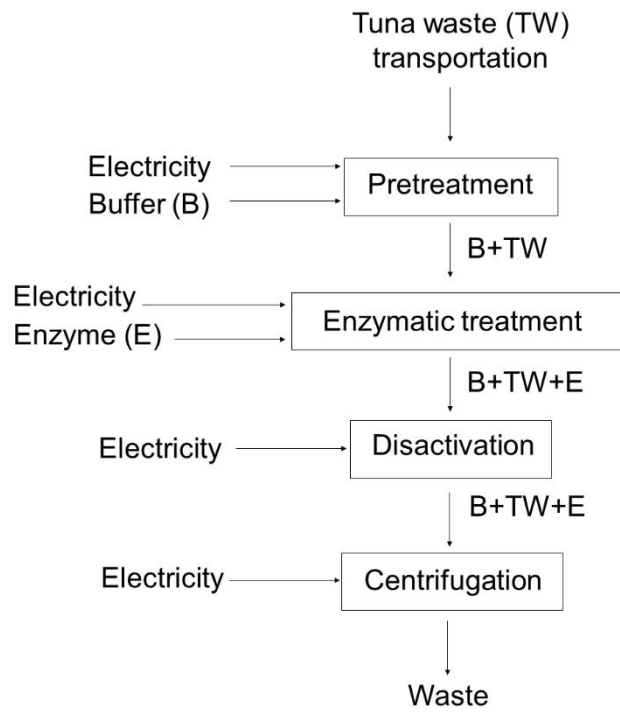
1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

Figures:

Figure 1.

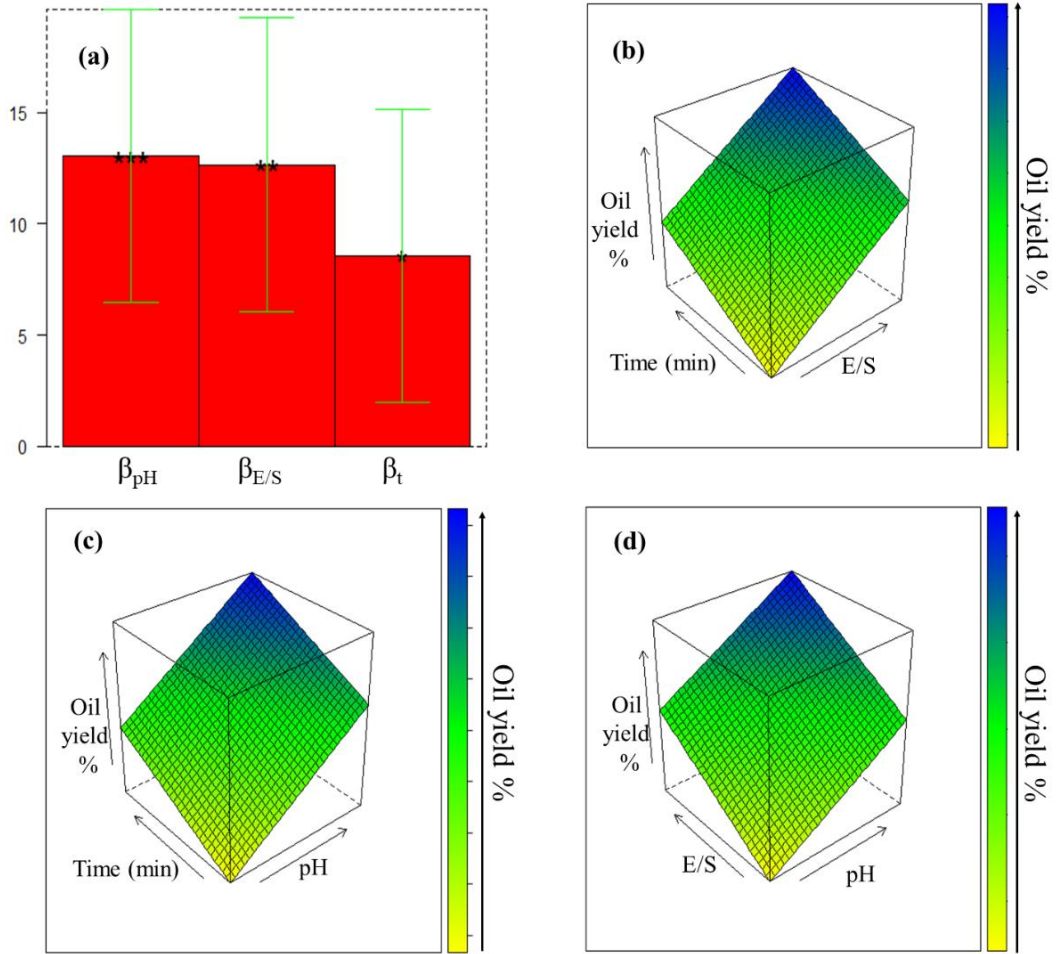


**Figure 2.**



1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

**Figure 3.**



**Figure 4.**

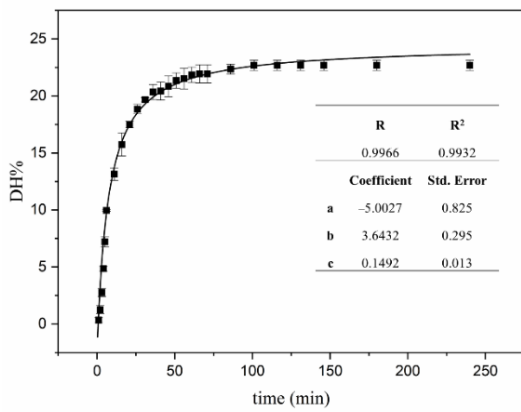


Figure 5.

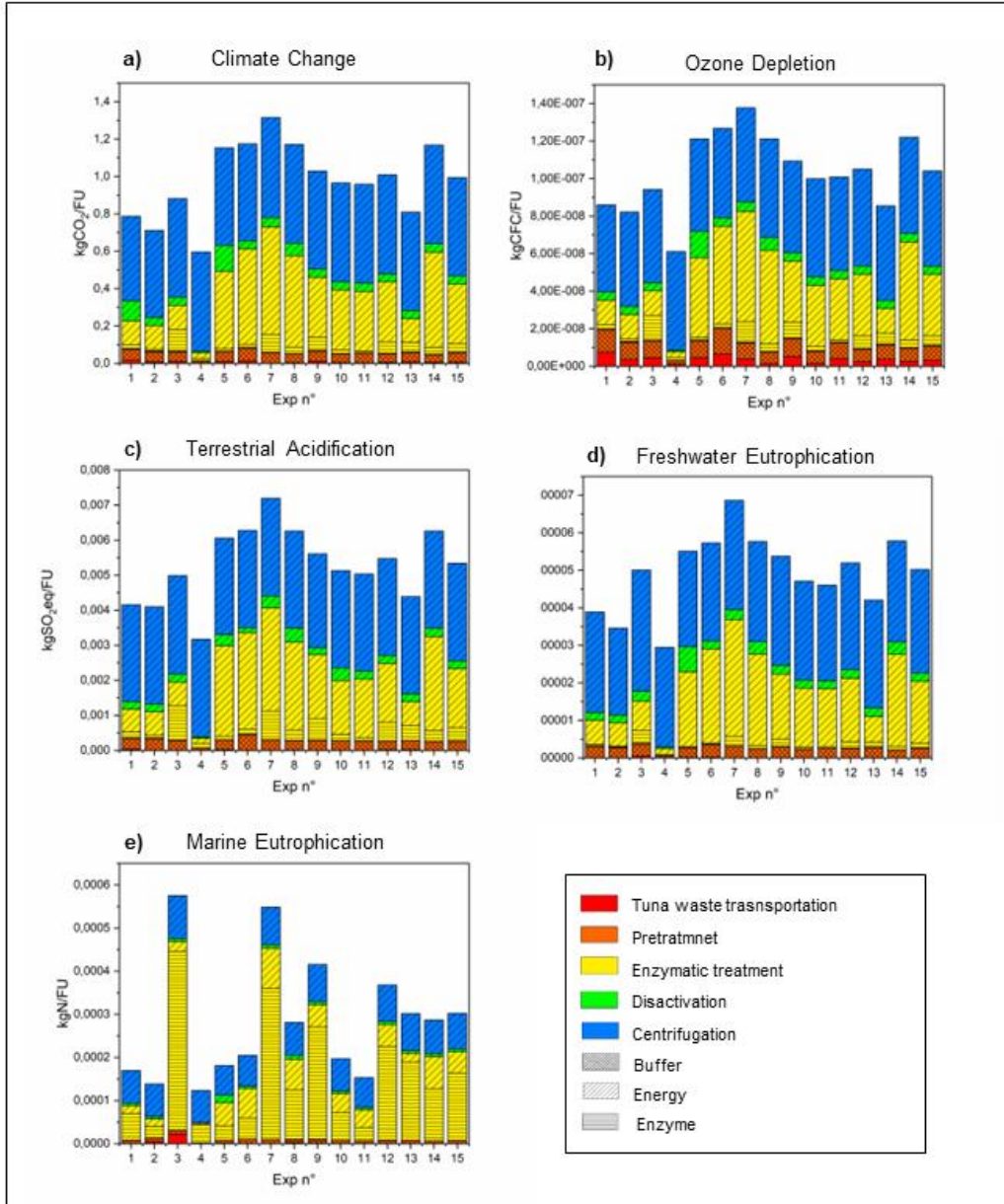
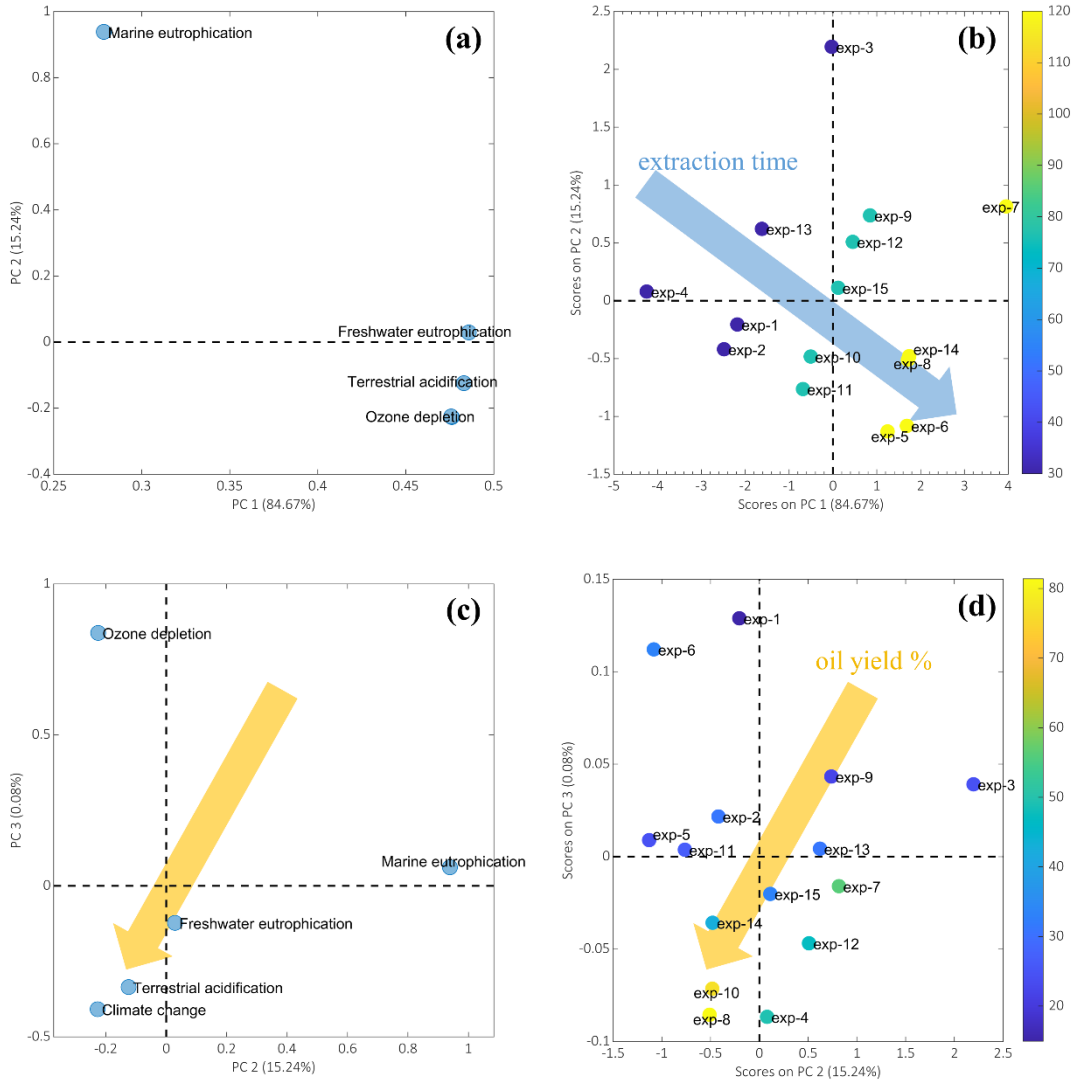


Figure 6.



# From tuna viscera to added-value products: A circular approach for fish-waste recovery by green enzymatic hydrolysis

Silvia Fraterrigo Garofalo<sup>1</sup>, Nicola Cavallini<sup>1</sup>, Francesca Demichelis<sup>1</sup>, Francesco Savorani<sup>1</sup>, Giuseppe Mancini<sup>2</sup>, Debora Fino<sup>1</sup>, Tonia Tommasi\*<sup>1</sup>

<sup>1</sup>Department of Applied Science and Technology (DISAT), Politecnico di Torino, Corso Duca Degli Abruzzi 24, Torino (TO), 10129, Italy

<sup>2</sup>Department of Electric, Electronic and Computer Engineering, University of Catania, Viale A. Doria 6, Catania (CT), 95125, Italy

\*Corresponding author

email: [tonia.tommasi@polito.it](mailto:tonia.tommasi@polito.it)

## Abstract

Tuna represents one of the most consumed foods in many parts of the world. It is estimated that about 70% of the tuna's weight is discarded in the production of canned fillets. This work is focused on the optimization of production of an oil rich in omega-3 from the tuna viscera, provided by a canned tuna production company, using the Alcalase enzyme. Combined use of Design of experiments (DoE), life cycle analysis (LCA), and principal component analysis (PCA) on the collected analytical data made it possible to define the best combination of the values of pH, enzyme/substrate (E/S) ratio, and reaction time, respectively (pH=8.5), E/S (1%), and time (120 minutes), and to better understand the environmental bottleneck of the process. The outcomes of the study demonstrated that the duration of the hydrolysis and the associated electricity consumption is the factor that affects the most the environmental sustainability of the process.

1  
2 **Keywords:** Fish waste valorization, EPA and DHA, enzymatic extraction, design of  
3  
4  
5 experiments, life cycle analysis  
6  
7  
8  
9

## 10 **1. Introduction**

11  
12  
13 Tuna and particularly canned tuna is one of the most consumed fish globally; this  
14  
15 seafood is fished and processed in more than 70 countries and represents an affordable  
16  
17 and common source of protein worldwide (FAO, 2020). The main tuna species  
18  
19 processed are skipjack (*Katsuwonus pelamis*), albacore (*Thunnus alalunga*), yellowfin  
20  
21 (*Thunnus albacares*), bigeye (*Thunnus obesus*), and bluefin (*Thunnus thynnus*), which  
22  
23 are mainly fished in the Pacific Ocean (Allain et al., 2016; FAO, 2020). Around 5.2  
24  
25 million metric tons of tuna fish have been captured in 2018, and at least three-quarters  
26  
27 of all landed tuna have been canned (McKinney et al., 2020). Thailand is the leading  
28  
29 country for tuna processing, while the largest consumers among the European countries  
30  
31 are Spain, Italy, France, UK, and Portugal (Ababouch and Catarci, 2008; Allain et al.,  
32  
33 2016; FAO, 2020)  
34  
35  
36  
37  
38  
39

40 Tuna, after capture, is frozen and transported to production plants where it is subjected  
41  
42 to quality controls and then deprived of heads, viscera, and fins through mechanical  
43  
44 sawing systems (Ababouch and Catarci, 2008). After that, the tuna is cooked in various  
45  
46 ways that depend on the choice of industry. After the cooking step, the fillets are  
47  
48 manually cleaned with knives, then they get canned to be finally sterilized (Hospido et  
49  
50 al., 2006; Ababouch and Catarci, 2008; Ramakrishnan et al., 2013).  
51  
52  
53  
54

55 The principal product of the canned tuna industry is the fillet, consisting mainly of  
56  
57 white muscle, while viscera, gills, dark flesh/muscle, head, bone, and skin are  
58  
59 considered as waste or low-value by-products (Herpandi et al., 2011). These wastes can  
60  
61  
62  
63  
64  
65

1 reach up to 70 % of the total weight of the fish and still contain a high portion of  
2 valuable protein, lipid and nutritional components, which can represent a profitable  
3 resource for the nutraceutical, pharmaceutical and cosmetic industries (Araujo et al.,  
4 2021; Herpandi et al., 2011). With the increasingly problematic effects of climate  
5 change and the scarcity of natural resources, many researchers are now focusing on  
6 improving technologies to extract bioactive compounds from fish by-products. Two of  
7 the main products obtained from tuna waste are tuna oil and fish protein hydrolysates  
8 (Herpandi et al., 2011). There has been growing interest towards tuna oil because it is  
9 rich in polyunsaturated fatty acids (PUFAs), in particular eicosapentaenoic acid (EPA)  
10 and docosahexaenoic acid (DHA), omega-3 fatty acids, both responsible for preventing  
11 some cardiovascular and various inflammatory diseases (Calder, 2012). Fish protein  
12 hydrolysates (FPH) is obtained by subjecting fish proteins to chemical or enzymatic  
13 hydrolysis, producing peptides and free amino acids. Several studies demonstrated that  
14 enzymatic hydrolysis, in an optimum combination of process conditions, is able to  
15 produce FPH with excellent properties, like antioxidant activity with high amounts of  
16 antihypertensive, anticancer, anti-anemia peptides (Herpandi et al., 2011). Moreover,  
17 enzymatic hydrolysis can separate at the same time the protein fraction, the oil fraction  
18 and the insoluble solid, reducing the use of toxic solvents and the production of  
19 chemical waste compared to other extraction processes (Araujo et al., 2021). These  
20 characteristics make the enzymatic hydrolysis process environmentally sustainable and  
21 an excellent candidate for producing high added-value products from canned tuna waste  
22 materials.

23 Several authors, in recent years, have dealt with the enhancement of tuna viscera  
24 through enzymatic hydrolysis. Je et al. (2009) tested the enzymatic hydrolysis of tuna  
25 using commercially available proteases such as Flavourzyme, Alcalase, Protamex, and  
26 Neutrase. Guerard et al. (2001), Ovissipour et al. (2012), and Klomklao et al. (2016)

1 instead tested only the alcalase focusing on the optimization of the reaction. All these  
2 authors have focused on the protein fraction as the only product of hydrolysis. Only De  
3 Oliveira et al. (2016) has focused on the possibility of extracting the oily fraction from  
4 yellowfin tuna head by enzymatic hydrolysis, making the enzymatic extraction of oil  
5 from tuna viscera still unexplored. This work aims to fill this gap, focusing on the  
6 optimization of the enzymatic extraction of oil from tuna viscera, through a design of  
7 experiments (DoE). The present work also, for the first time, analyzes the results of the  
8 DoE through a comparative study of life cycle assessment (LCA), in order to identify  
9 the environmental bottleneck of the process. To the best of the author's knowledge,  
10 there are no LCA works that deal with the enzymatic extraction of oil from tuna viscera.  
11 To compensate for the lack of literature data, and to have at the same time a critical  
12 analysis of the results obtained both from the experimental campaign and from the  
13 sustainability analysis, a chemometric study was applied through principal component  
14 analysis (PCA).

## 2. Material and methods

### 2.1 Raw materials and chemicals

34 Around 10 kg of frozen tuna (*Thunnus albacares*) waste materials were provided by the  
35 Company “Sebastiano DRAGO” (Siracusa, Italy), that produces canned tuna. The raw  
36 material was shipped and maintained at controlled temperatures of  $-20\text{ }^{\circ}\text{C}$  until analysis  
37 and experiments. All reagents used in this work were high purity grade and provided by  
38 Sigma Aldrich-Merck (Germany). The enzyme applied for the hydrolysis was the  
39 Alcalase 2.4 L, an aqueous solution of Protease from *Bacillus licheniformis* with a  
40 declared specific activity  $\geq 2.4\text{ U/g}$ .

## 2.2 Pretreatment of waste material

The frozen tuna waste material was thawed at room temperature and drained from the blood. After that, the viscera were manually separated from the bones and the skin using a sharp knife. To obtain a sample as homogeneous as possible, the viscera were blended and homogenized using a kitchen blender.

## 2.3 Protease characterization

The enzyme chosen for this study was Alcalase, a highly studied enzyme that has already been used to produce FPH from various fish species (Tacias-Pascacio et al., 2020). To choose the enzyme/substrate ratio and to monitor any degradation of the Alcalase during the time, an activity assay was conducted. First of all, it was necessary to measure the total amount of enzyme in the Alcalase solution, in terms of total proteins, through the Bradford assay using Bovine Serum Albumin (BSA) as standard protein (Kruger, 1994).

The Bradford assay is a protein determination method that involves binding Coomassie Brilliant Blue G-250 dye to proteins. When the dye binds to the protein, it is converted to a stable unprotonated blue form with the maximum absorbance at 595 nm.

Hence, 100  $\mu\text{L}$  of diluted Alcalase was mixed with 1000  $\mu\text{L}$  of the Bradford reagent into an Eppendorf tube. After 15 minutes the absorbance of the sample was measured at 565 nm through a spectrophotometer (Hach Lange DR5000). The protein amount was then determined by comparing the absorbance value with a calibration curve obtained using different concentrations of BSA (from 0.1 mg/mL to 0.01 mg/mL) mixed with the Bradford reagent. All the solutions were maintained at  $\text{pH} = 7$  using a phosphate buffer.

This assay allowed the correct choice of Alcalase dilution to apply in the activity assay.

A non-specific protease activity assay using casein as substrate (Cupp-enyard, 2008)

was chosen. The measurement of the activity was performed each day before of experiments and in order to avoid errors due to the degradation of the enzyme during time. In this assay, casein is digested by the Alcalase liberating tyrosine, which reacts with Folin & Ciocalteus reagent to produce a chromophore. This complex has a maximum absorbance in the blue region of the UV-Vis, and it is measurable with a spectrophotometer. Briefly, the diluted Alcalase was mixed with 0.65 % of casein solution and incubated at 37 °C for 10 minutes. After this time, Trichloroacetic Acid (TCA) was added to stop the enzymatic reaction, and more Alcalase was put in the solution and incubated for 30 minutes at 37 °C. Then the solution was filtered and was supplemented with sodium carbonate and Folin's reagent, mixed, and incubated again for 30 minutes at 37 °C. After the incubation time, the mixture was filtered, and the absorbance was measured at 660 nm. The  $\mu\text{mol}$  tyrosine equivalents released were obtained, by comparing the absorbance of the sample with a tyrosine calibration curve. Then the activity of the Acalase was calculated by the following equation (1):

$$\frac{\text{Units}}{\text{mL enzyme}} = \frac{\mu\text{mol}_{\text{Teq}}}{V_E \cdot t \cdot V_C} \quad (1)$$

where  $\mu\text{mol}_{\text{Teq}}$  are the micromoles of tyrosine equivalent obtained from the calibration curve,  $V_{\text{tot}}$  is the total volume of the assay (mL),  $t$  is the time (min),  $V_E$  is the volume of the enzyme (mL) and  $V_c$  is the volume of the cuvette (mL). It was possible to convert Units/mL in Units/mg of protein contained in the liquid enzyme by applying the following equation (2):

$$\frac{\text{Units}}{\text{Protein (mg)}} = \frac{\frac{\text{Units}}{\text{Enzyme (mL)}}}{\frac{\text{protein (mg)}}{\text{Enzyme (mL)}}} \quad (2)$$

## 2.4 Tuna viscera characterization

The total amount of lipids contained in the tuna viscera was determined using the Bligh and Dyer method (Bligh, E.G. and Dyer, 1959), originally developed to quantify the

1 total lipid in the fish muscle and later become the standard rapid method for fat  
2 determination in marine biological tissue (Bligh, E.G. and Dyer, 1959). In summary,  
3  
4 100 g of homogenized sample was mixed with 100 mL of chloroform and 200 mL of  
5  
6 methanol. After that, 100 mL of chloroform and 100 mL of water were added to the  
7  
8 mixture, agitated for 30 seconds, and then filtered. The liquid part was transferred into a  
9  
10 graduated cylinder, where the separation between the polar and non-polar fraction of the  
11  
12 solution occurred. The volume of chloroform was noted and the alcoholic fraction was  
13  
14 removed using a glass pipette. The non-polar solution was evaporated through a  
15  
16 Rotavapor (Labrota 4000, Heidolph) and the oily residue was weighed with an  
17  
18 analytical balance. The measurement was performed in triplicate.  
19  
20  
21  
22  
23

24 The total N content was first quantified through the Dumas or combustion method  
25  
26 (Simonne, et al., 1997) utilizing an Elementar analyzer (Vario MACRO cube,  
27  
28 Elementar). Then, the N total was multiplied for a nitrogen-to-protein conversion factor  
29  
30 (equation 3). The factor chosen was 5.6, specific for fish protein, as suggested by  
31  
32 Mariotti et al. 2008 (Mariotti et al., 2008) and not the standard 6.25 conversion factor,  
33  
34 usually used for foodstuff.  
35  
36  
37  
38

$$39 \quad \text{Proteins \%} = N \cdot 6.5 \quad (3)$$

40  
41  
42 The moisture and ash contents were determined following the “Rapporto ISTISAN  
43  
44 1996/34”, and the total carbohydrate content was calculated by difference.  
45  
46  
47  
48

## 49 **2.5 Experimental design and data modeling**

50  
51 To understand the effect of pH, enzyme/substrate ratio (E/S) and time on the amount of  
52  
53 fish oil extracted and on the antioxidant activity of the fish protein hydrolysates, but  
54  
55 also to optimize the extraction technique by minimizing and at the same time the  
56  
57 number of experiments, a Design of Experiments (DoE) (Leardi, 2009) was put in  
58  
59  
60  
61  
62  
63  
64  
65

1 place. A three-factor and three-levels Central Composite Face Centered (CCF) design  
2 consisting of 15 experiments was employed, and 17 experimental runs, including three  
3 replicates at the center point, were performed. The design factors were pH (6.5, 7.5 and  
4 8.5), E/S (0.1, 0.55 and 1) and time (30, 75 and 120 min), while the response variable  
5 was the yield of fish oil expressed in percentage (oil yield %). Based on literature  
6 information, the temperature was kept constant at 55 °C, which has been determined to  
7 be the optimal temperature for Alcalase (Li et al., 2018; Glowacz-Rozynska et al., 2016;  
8 Wang et al., 2019).

9 The design was created using MODDE 7 software (version 7.0.0.1), and the list of  
10 experimental runs, i.e., the experimental plan (with the original values of each factor)  
11 and matrix (coded version of the original values) are reported in Table 1. In the CCF  
12 design, the three levels are conventionally named as -1, 0, and +1, where -1 represents  
13 the lowest value of the factor range, +1 is the highest value and 0 is the central point  
14 (Taylor et al., 2021). In the presence of three factors, the experimental domain spanned  
15 by the CCF design can be represented in 3D space as a cube, like it is shown in Figure  
16 1.

17 The data were analyzed using the R-based CAT (Chemometric Agile Tool, by Leardi  
18 R.) software, whose DoE modeling engine is based on the multiple linear regression  
19 (MLR) (Sergent, 1995) method. MLR is a regression method that allows modeling and  
20 inspecting each factor separately, but also in combination with one or more other  
21 factors. Its functioning provides enough flexibility to efficiently model the response  
22 under examination, while at the same time including or excluding the non-significant  
23 terms in the model equation, which can be represented as:

$$y = \beta_0 + \beta_A A + \beta_B B + \beta_C C + \beta_{AB} AB + \beta_{BC} BC + \beta_{AC} AC + \beta_{AAA} AA + \beta_{BB} BB + \beta_{CC} CC \quad (4)$$

1 where  $y$  is the predicted response (oil yield %),  $\varepsilon$  represents the noise and  $I$  are the  
2 regression coefficients of each factor ( $A = \text{pH}$ ,  $B = \text{E/S}$  and  $C = \text{time}$ ), including the  
3  
4 interaction between the factors ( $AB$ ,  $AC$  and  $BC$ ) and their quadratic terms ( $AA$ ,  $BB$   
5 and  $CC$ ).  
6  
7

8  
9 To better inspect the comparative LCA results (as described in Section 2.10) it was  
10 decided to study the obtained numerical values using the exploratory data analysis  
11 method principal component analysis (PCA, (Bro and Smilde, 2014)). PCA is a  
12 decomposition method that allows obtaining clear representations of the samples'  
13 distributions, together with the correlation patterns among the variables by inspecting  
14 the so-called scores and loadings, respectively. In our case, the samples were the 15  
15 experiments analyzed via LCA, and the variables were the five LCA impact categories.  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27

## 28 **2.6 Enzymatic extraction**

29 The enzymatic extraction was conducted following the procedure of Ramakrishnan et  
30 al. (2013) with some modifications. Around 20 g of homogenized tuna viscera were put  
31 into a 50 mL falcon tube and heated at 90 °C for 10 minutes in a water bath, to  
32 deactivate any endogenous enzymes (Ramakrishnan et al., 2013). After cooling down at  
33 room temperature, a buffer was added to control the pH during the reaction in a ratio 1:1  
34 (buffer:substrate). Three different buffers were used in different experiments of the  
35 DoE: phosphate buffer at different concentrations (pH = 6.5 and 7.5) and borate buffer  
36 (pH = 8.5). Then the mixture was thermostated at 55 °C for 30 minutes into an  
37 incubator with a shaking rate of 200 rpm (ES-20/60, Orbital Shaker- Incubator, Biosan).  
38 Different amounts of Alcalase were added to the mixture to obtain different E/S  
39 percentages (0.1, 0.55 and 1 %). The enzyme was then allowed to react for 30, 75 or  
40 120 minutes. When the reaction time had elapsed, the falcon tube was put again into the  
41 water bath at 90 °C for ten minutes to stop the reaction. The mixture was cooled at room  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 temperature and centrifuged at 5000 rpm for 20 minutes with a SL 16R Centrifuge  
2 (Thermo Fisher Scientific).  
3

## 4 5 **2.7 Oil yields**

6  
7  
8 The upper oil layer was collected using a plastic pipette and transferred into a glass  
9 sample holder. To make sure there was only fat in the sample, the oil was washed with a  
10 small amount of dichloromethane and left to evaporate under a chemical hood. The  
11 samples were then weighed on an analytical balance and the amount of oil was related  
12 to the total oil content present in the tuna viscera (see paragraph 2.4) to obtain the yield  
13 % according to the following equation (4).  
14  
15  
16  
17  
18  
19  
20  
21

$$22 \quad \text{oil yield \%} = \frac{\text{oil extracted (g)}}{\text{total oil in the sample (g)}} \cdot 100 \quad (5)$$

## 23 24 25 26 27 **2.8 Omega-3 quantification**

28  
29 The omega-3 content in terms of EPA and DHA was determined according to UNI EN  
30 ISO 12966-2:2017 standard methods. Fatty acids were analyzed in the form of methyl  
31 esters (FAME) using a gas chromatograph equipped with a mass analyzer. To prepare  
32 the FA methyl esters, around 100 mg of sample was dissolved in 3 mL of methanolic  
33 KOH (0.6 M) in a falcon tube and stirred for 10 s under an N<sub>2</sub> flow to avoid oxidation  
34 of compounds. The solution was heated under agitation for 10 minutes at 70 °C using a  
35 water bath. After this time, and the complete dissolution of the oil, 3 mL of 5 % H<sub>2</sub>SO<sub>4</sub>  
36 in methanol was added and the solution was heated at 70 °C for another 5 min. Then 2  
37 mL of a saturated solution of NaCl and 2 mL of hexane were added, and the falcon was  
38 centrifuged at 4000 rpm for 10 minutes. The supernatant was collected, diluted 1:2, and  
39 transferred in a vial for the GC-MS analysis. The omega-3 analysis was conducted  
40 using a gas chromatograph (Agilent 7890A GC System) equipped with a ZB-FAME  
41 column (30 m x 0.25 mm ID x 20 µm; Zebron Phenomenex) and a quadrupole mass  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 detector (Agilent 5975 C VL MSD). Helium was used as carrier gas with a flow of 0.4  
2 mL/min, the injection volume was 1  $\mu$ L using the split mode with a split ratio of 20:1 at  
3  
4 240 °C. The column was initially maintained at 100 °C for 2 min and then the  
5  
6 temperature was then increased to 240 °C at 5 °C/min and kept constant for 8 min  
7  
8 (Brotas et al., 2020). The mass analyzer worked in electron ionization mode with  
9  
10 ionization energy of 70 eV and in full scan mode between 50 and 600 a.m.u.. The  
11  
12 temperatures of the source and quadrupole were maintained at 230 °C and 150 °C,  
13  
14 respectively. Omega-3 quantification was determined through calibration curves  
15  
16 prepared using a DHA and EPA certified standard.  
17  
18  
19  
20  
21  
22  
23  
24

## 25 **2.9 Progress of protein hydrolysis**

26  
27 To understand the behavior of an enzyme-substrate system, at least five indicators must  
28  
29 be considered: the substrate concentration (S), the enzyme/substrate ratio (E/S), the pH,  
30  
31 the temperature (T) and the time (t). These indices can be substituted by the degree of  
32  
33 hydrolysis (DH) because, as affirmed by Alder-Niessen (1982) (Alder-Niessen, 1982) in  
34  
35 some conditions, the development of an enzymatic protein hydrolysis reaction depends  
36  
37 only on the pH and DH. The DH is defined as the ratio of the number of peptide bonds  
38  
39 broken by the total number of peptide bonds in the original protein (North and Zealand,  
40  
41 2010) and allows to obtain information on the progress of the reaction in real time. To  
42  
43 measure the DH, the pH-stat method was employed. This method is based on the fact  
44  
45 that, during the hydrolysis of the peptide bond, there is a pH decrease and, to maintain it  
46  
47 constant, it is necessary to add some base. It is possible to relate the amount of added  
48  
49 base to the DH by the following equation (6) (North and Zealand, 2010):  
50  
51  
52  
53  
54  
55

$$56 \quad DH\% = \frac{B \cdot N_B}{\alpha \cdot m \cdot h_{tot}} \quad (6)$$

57  
58  
59  
60  
61  
62  
63  
64  
65

1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
Where  $B$  is the base consumption (mL),  $N_B$  is the normality of the base,  $m$  is the mass of the protein of the sample,  $\alpha$  is the average degree of dissociation of  $\alpha$ -NH<sub>2</sub> groups in the protein of the sample and  $h_{tot}$  is the total number of peptide bonds per unit mass of protein. The working conditions chosen for this experiment were the optimal conditions obtained from the DoE experiments. The base used was NaOH 0.5 N. The term  $1/\alpha$  is defined as a calibration factor and depends on the temperature and pH, in these working conditions (55 °C and pH 8.5) it values 1.03 (Navarrete del Toro and García- Carreño, 2003). The term  $h_{tot}$  value depends on the source of protein, for fish, Navarrete et al. (2003) suggest using 8.6 meq/g. This experiment was conducted into a 1 Lbioreactor capable of automatically regulating the pH by a proportional integral derivative (PID) controller connected to a pH probe and a peristaltic pump. The reactor was also equipped with a heating jacket to keep a constant temperature of 55 °C, and Rushton impellers to stir the medium. The amount of base added over time was recorded by a computer. The model then was fitted to the experimental data using SigmaPlot (Version 10.0, Systat Software Inc., USA).

## 37 **2.10 Life Cycle Assessment**

38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65  
Life Cycle Assessment (LCA) was performed with SimaPro 9.0.4 software, database Ecoinvent 3.0. The goal of LCA was to compare all the experiments of the DoE, to choose the best extraction process in terms of environmental sustainability. To be consistent with the goal of the study and with the function to which the process system was designed for, the chosen functional unit was 1g of fish oil. The adopted approach was from grave to cradle. The definition of the boundary conditions of the study includes the transported tuna waste feed as feedstock for the process, then the tuna pre-treatment, the enzymatic extraction, the thermal treatment, and last the centrifugation to recover the extracted oil. The scheme of the boundary condition is drawn in Fig 1.

1 According to the zero-burden assumption, it was assumed that tuna waste did not  
2 contain any credits related to the impacts produced during the previous stages of its life  
3 cycle (Buttol et al., 2007). Furthermore, another assumption was the allocation criteria.  
4 To be more precautionary and avoided double discounting, all the environmental  
5 impacts and credit were allocated on the fish oil, which was the product target, and all  
6 the by-products and co-products generated in the studied system were considered as  
7 waste. ~~The functional unit (FU) was 1 g of fish oil produced.~~

8 The life cycle inventory (LCI) defined all inputs and outputs involved in the processes.  
9 The primary data came from the present study, the produced emissions, the consumed  
10 material, and the required energy were referred to the chosen FU. The reagents which  
11 were not present in the Ecoinvent database were computed on a stoichiometric basis.

12 ~~The detailed inventory is provided in the supplementary materials.~~ The secondary data,  
13 taken from Ecoinvent 3.0 were:

- 14 - Electricity, medium voltage {Row}| market for | Alloc Rec, S
- 15 - Tap Water from natural resource

16 Electricity RoW (rest of the world), was chosen to avoid geolocalizing the process, not  
17 being in the scope of the analysis.

18 Life cycle impact assessment (LCIA) was performed with the ReCIPE Midpoint (H)  
19 method. In the present study, the analyzed impact categories were: Climate change (kg  
20 CO<sub>2</sub> eq), Ozone depletion (kg CFC-11 eq), Freshwater eutrophication (kg P eq), Marine  
21 eutrophication (kg N eq) and Terrestrial acidification (kg SO<sub>2</sub> eq) because they were the  
22 most used impact categories in the fish processing industry (Avadí and Fréon, 2013;  
23 Ruiz-Salmón et al., 2021). The results of the LCA were also analyzed through a  
24 Principal Component Analysis (PCA) performed with Matlab (R2020a).

### 3. Results and discussion

#### 3.1 Protease and Tuna viscera characterization

The commercial Alcalase solution shows an activity of  $5.559 \pm 0.004$  (Units/mg protein).

The defrosted tuna was not deprived of blood and water, so the moisture content resulted quite high ( $77.5 \pm 0.1$  %). The carbohydrate content is not revealed (NR) and also the percentage of ashes resulted very low ( $2.22 \pm 0.1$  %). The most interesting values for this study are the percentage of proteins and lipids, respectively  $17.70 \pm 0.20$  % and  $2.58 \pm 0.08$  %.

These results are in line with other works investigating the composition of different body parts of several tuna species (Karunarathna and Attygalle, 2009; Vlieg and Murray, n.d.). Karunarathna and Attygalle (2009) affirm that the moisture percentage of tuna viscera is around 70 %, the protein content is between 16-19 %, the lipids percentage can vary between 0.9 and 1.34 % and ash content is around 1 % while the amount of carbohydrates is negligible in all tuna species. Slight variations are possible and depend on several factors, such as the species, diet, age and other parameters of the tuna (Karunarathna and Attygalle,2009).

#### 3.2 Enzymatic extraction and interpretation of the Design of Experiments results

After extraction and centrifugation, the samples showed a four-layers separation with the oil floating on the top, followed by a light mixture of lipids and proteins, then by the FPH and a solid residue on the bottom of the falcon. The oil was collected using a plastic pipette, to be quantified and analyzed through a GC-MS instrument. The second and bottom layers were discarded, while the FPH layer was collected for future analysis.

1 Table 1 reports the results of the DoE in terms of oil yield %. The amount of extracted  
2 oil varies from 15 % up to 81.4 %. ~~To model the percentage oil yield, first a full MLR~~  
3 ~~regression model was computed but, after a preliminary elaboration, the model was~~  
4 ~~simplified excluding the non-significant terms. More specifically, the interaction terms~~  
5 ~~and the quadratic terms, to model only the statistically significant terms. To model the~~  
6 ~~percentage oil yield a full MLR regression model was first computed and after a~~  
7 ~~preliminary elaboration, the model was simplified excluding the non-significant terms,~~  
8 ~~i.e., the interaction and quadratic terms. Only the statistically significant terms were~~  
9 ~~included, as described by equation 7. The model equation was therefore reduced to the~~  
10 ~~following (equation 7):~~

$$y = \beta_0 + \beta_{pH}pH + \beta_{E/S}E/S + \beta_t t + \varepsilon \quad (7)$$

27 The significant linear terms are reported in the plot of the coefficients (Figure 3a) and in  
28 Table 2, where the presence of \* indicates the significance of the coefficients: \*\* = p <  
29 0.01, \*\*\* = p < 0.001.

34 Time was the factor with the lowest influence on the extraction yield. The positive  
35 values of all coefficients indicate that they positively influence the response, i.e., the oil  
36 yield % increases with the increase of pH, E/S and time. These results are confirmed by  
37 the response surfaces reported in Figures 3b,c,d. These surfaces represent a three-  
38 dimensional view of the relationship between pairs of factors (reported on the x and y  
39 axes) and the response (plotted on the z axis), providing a clear picture of how the  
40 response is related to the factors.

51 In this model the response surface takes the shape of a tilted plane, where the yield  
52 increases when the factors increase. The flat look of the surface is due to the fact that all  
53 quadratic and interaction terms were excluded from the MLR model, therefore no terms  
54 describing possible curvatures of the response were included. According to the model, it

1 is possible to obtain the maximum oil yield % at maximum pH, E/S and time values (pH  
2 = 8.5; E/S % = 1; t = 120 min).  
3

4 The influence of pH is one of the most important parameters to be analysed in  
5 enzymatic hydrolysis. Indeed, enzymes contain a catalytic active site with charged  
6 amino acids. The pH can affect the dissociation state of these amino acids changing the  
7 ionic bonds that maintain the three-dimensional shape of the protein. This may lead to  
8 alteration in protein function or inactivation of enzymes (Shu et al., 2016).  
9

10 Alcalase was initially obtained from *Bacillus subtilis* and called “Subtilisin Carlsberg”  
11 (Tacias-Pascacio et al., 2020). Subtilisin, generally, work optimally in mildly alkaline.  
12 This kind of enzymes are serine proteases that contain catalytic triad in order of aspartic  
13 acid, histidine, and serine residues (Azrin et al., 2022) and in particular, Ser221, His64  
14 and Asp32 (Wells and Estell 1988). The activity of subtilisin increases at alkaline pH  
15 because His64 is deprotonated. Therefore, by increasing the pH there is a greater  
16 activity of the enzyme which hydrolyzes more proteins, releasing larger quantities of oil  
17 and increasing the yield.  
18

19 Results show a positive effect of the enzyme: substrate ratio on the enzymatic  
20 hydrolysis, the increase of the enzyme concentration resulted in a higher oil yield.  
21

22 At higher E/S, indeed, there are more enzyme active sites available to hydrolyze the  
23 substrate, resulting in a more effective cleavage of the peptide bonds, and consequently  
24 greater degradation of the proteins (Kurozawa et al., 2009).  
25

26 To the best of the authors’ knowledge, this is the first study regarding the enzymatic  
27 extraction of tuna oil using Alcalase applying DoE. These results are in line with  
28 Ramakrishnan et al. (2013), who investigated the effects of E/S and time, separately, on  
29 the oil extraction from mackerel waste material using Alcalase at 55 °C and pH = 8.5  
30 (Ramakrishnan et al., 2013). They demonstrated that oil yield increases with the  
31 increase in the enzyme concentration (0.5, 1 and 2 %) and time (1, 2, 3 and 4 h),  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 reaching a plateau around an hour and a half of elapsed time. Qi-yuan et al. (2016)  
2 extracted oil from mackerel viscera applying a DoE to investigate how the extraction is  
3 affected by enzyme concentration, pH and temperature (Qi-Yuan et al., 2016). Their  
4 work confirms that as the E/S ratio increases, the oil yield also increases. In their study,  
5 De Oliveira et al. (2017) extracted oil from tuna by-product through enzymatic  
6 extraction using Alcalase and they affirmed that this technique allows obtaining an oil  
7 of better quality than other obtained with non-green extraction techniques (De Oliveira  
8 et al., 2017). However, there are very few literature studies in which oil is extracted  
9 from tuna waste, while there are many on enzymatic extractions from other fishes.  
10 Wang et al. (2019) affirmed that Alcalase (at 55 °C and pH = 8) could be used as a good  
11 protease for extracting a good quality Antarctic krill oil (Wang et al., 2019). The present  
12 work results are also in line with Głowacz-Rozynska et al. (2016) who tried to extract  
13 the oil from salmon waste, showing that it is possible to achieve yields of around 82 %  
14 using Alcalase at 55 °C and pH = 8 (Glowacz-Rozynska et al., 2016). Other authors  
15 effectively extracted good quality oil from fish waste such as catla, rohu, perch,  
16 copepod, tilapia or trout, using Alcalase (Babajafari et al., 2017; Li et al., 2018; Taylor  
17 et al., 2013; Vlieg and Murray, n.d.). Araujo et al. (2021) treated fish scraps from a  
18 market with Alacase al pH = 8, 50 °C and 180 min and deduced that the E/S ratio was  
19 the main factor controlling the hydrolysis (Araujo et al., 2021).  
20 To evaluate the prediction power of the MLR model, two replicated experiments of the  
21 central point of the design (not included to compute the model) were performed. Table 3  
22 reports the experimental values of the two experiments, the upper and lower values with  
23 their predicted values, and their residuals. The predictive capacity of the model is hence  
24 confirmed.

### 3.3 Progress of protein hydrolysis

To monitor the progress of the hydrolysis, the DH% as a function of time was measured using the pH-stat method in a 1 L Bioreactor, applying the optimum condition found with the DoE (55 °C, pH = 8.5 E/S = 1 %). As shown in the graph in Figure 4 DH% increases very quickly in the first hour of reaction and then stabilizes around 22 %.

The experimental sets of (DH%, t) were fit to Eq. (9) using Sigma Plot and the results of the fitting procedure are listed in Figure 3 (Babajafari et al., 2017; Taylor et al., 2013).

The squared points of Figure 3 represent the experimental values with their standard deviation and the continuous line the values obtained from the Equation 8. To evaluate the quality of the fitting, the correlation coefficient R, and the coefficient of determination R<sup>2</sup> were evaluated. These values, very close to 1, indicate that the regression predictions fit the data almost perfectly. The model passed also the Shapiro-Wilk test and the constant variance test with a significance level of 99 %.

$$DH\% = \frac{a + bt}{1 + ct} \quad (8)$$

These results are consistent with the work of Saidi et al. (2013), which hydrolyzed tuna by-products at the exact conditions of the present work and demonstrated that progress of hydrolysis increased roughly during the first hour and then no significant variation can be observed (Saidi et al., 2013). Ovissipour et al. (2010) obtained a trend in good agreement with our results, but the DH% stabilized around 16 %, probably because they did not work at controlled pH (Ovissipour et al., 2010). These results are also confirmed by Guerard et al. (2001) (Guérard et al., 2001). Klomklao and Benjakul (2016) obtained a curve with the same shape as the one in Figure 4, but their curve reached the plateau at an earlier time (20 min) and at higher DH% (35 %) (Klomklao and Benjakul, 2016).

This is possibly caused by the fact that they used more severe T, pH and E/S conditions for the reaction compared to our experimental conditions. Valencia et al. (2014)

1 identified the mechanisms responsible for the shape of the Alcalase hydrolysis curve for  
2 fish proteins (Valencia et al., 2014). They demonstrated that these curves are  
3  
4 characterized by an initial “hydrolysis phase” followed by a slowdown and stabilization  
5  
6 of the degree of hydrolysis. The cause for this decrease in reaction rate  
7  
8 could be associated with several factors, such as: a decrease in the concentration of  
9  
10 peptide bonds of the substrate available for hydrolysis; a product inhibition caused by  
11  
12 amino acids and soluble peptides released during the hydrolysis that act as a substrate  
13  
14 competitor; and an enzyme deactivation (Klomklao and Benjakul, 2016; (Kurozawa et  
15  
16 al, 2009).  
17  
18  
19  
20  
21

### 22 **3.4 Omega-3 quantification**

23  
24 The oil fraction was analyzed through GC-MS to quantify the omega-3 FA in terms of  
25  
26 EPA and DHA; they represent  $2,49 \pm 0,32$  % and  $10,83 \pm 1,13$  % of the extracted oil.  
27  
28 The percentages obtained in this work are lower than percentages achieved by De  
29  
30 Oilivera et al. (2017). They extracted oil from tuna heads with Alcalase but applied  
31  
32 different experimental conditions and reached 6 % of EPA and 27 % of DHA (De  
33  
34 Oliveira et al., 2017). In general, the content of EPA and DHA in fish oil varies  
35  
36 respectively from 5 to 26 %, and from 6 to 26 % of the total fatty acid, depending on  
37  
38 fish species (Alkio et al., 2000). From the data found in the literature, tuna oil contains  
39  
40 about 5 % of EPA and 25 % of DHA (Halldorsson et al., 2003; Zhang et al., 2017). In  
41  
42 their work, Alkio et al. (2000) used tuna oil containing 4.6 % of EPA and 18.3 % of  
43  
44 DHA, so these amounts are very variable (Alkio et al., 2000). Besides the study by De  
45  
46 Oilivera et al. (2017), the tuna oil analyzed in these research works is never made from  
47  
48 the tuna viscera, and the percentage composition of fatty acids can be very different.  
49  
50 Moreover, even the extraction procedure is not consistent across the different studies,  
51  
52 making the literature data hardly comparable to each other. In any case, the percentage  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 of omega-3 found in the oil extracted in this study makes it a product with excellent  
2 qualities. As a matter of fact, EPA and DHA contribute to preventing some  
3  
4 cardiovascular and various inflammatory diseases such as hyperlipidemia,  
5  
6 atherosclerosis, inflammation, and cancer. Moreover, they present some beneficial  
7  
8 effects on the brain and nervous system (Alkio et al., 2000; Correa-Matos and Vaghefi,  
9  
10 2013; De Oliveira et al., 2017; Halldorsson et al., 2003; Zhang et al., 2017).  
11  
12  
13

### 14 15 **3.5 Life Cycle Assessment**

16  
17 The **comparison of the** environmental sustainability of the different extractions defined  
18  
19 by the DoE was analyzed through Life Cycle Assessment (LCA).  
20  
21

22  
23 Figure 4 shows the results of LCA among the 15 experiments of the DoE (the replicas  
24  
25 of the central point were not considered) ~~in terms of~~ **through** five impact categories:

26  
27 Climate change (a, kg CO<sub>2</sub> eq), Ozone depletion (b, kg CFC-11 eq), Terrestrial  
28  
29 acidification (c, kg SO<sub>2</sub> eq), Freshwater eutrophication (d, kg P eq) and Marine  
30  
31 eutrophication (e, kg N eq). The analysis was limited to these five categories because, as  
32  
33 indicated by Ruiz-Salmón et al. (2021), they are the most studied ones in LCA of fish  
34  
35 and seafood processed products and, therefore, it would make the present study more  
36  
37 comparable to what can be already found in the literature. By reviewing a considerable  
38  
39 number of works on this topic, Ruiz-Salmón et al. (2021), highlighted that Ozone  
40  
41 depletion was computed by 53 % of analyzed authors, followed by acidification (64 %)  
42  
43 and eutrophication (66 %) (Ruiz-Salmón et al., 2021). **However the study of Ruiz-**  
44  
45 **Salmón et al. (2021) focused on the impact of landed fish, fish distribution and the**  
46  
47 **process to make fish an edible product.**  
48  
49  
50  
51  
52

53  
54 **The aim of the selected five impact categories is following defined.** Climate change is  
55  
56 the indicator of the global warming potential (GWP) caused by the emissions of  
57  
58 greenhouse gasses into the atmosphere. Ozone depletion indicates the emissions to the  
59  
60  
61  
62  
63  
64  
65

1 atmosphere responsible for destroying the stratospheric ozone layer. Acidification is the  
2 indicator of the potential acidification of soils and water due to the release of gasses  
3  
4 such as nitrogen oxides and sulfur oxides. The freshwater eutrophication indicator  
5  
6 expresses the freshwater ecosystem's enrichment with nutritional elements attributable  
7  
8 to the emission of compounds phosphor. Marine eutrophication is the indicator of  
9  
10 enhancing the marine ecosystem with nutritive elements due to nitrogen-containing  
11  
12 compounds (Jessen et al., 2015). To the best of the author's knowledge, ~~there are still no~~  
13  
14 ~~LCA studies on the enzymatic extraction of oil from tuna waste, so our discussion will~~  
15  
16 ~~be limited to the results obtained in this work.~~ in the literature, there are no available  
17  
18 studies to compare the environmental impacts and credits of the process and substrate  
19  
20 investigated in the present paper. For this reason, in the present work, the discussion of  
21  
22 LCA results was done as a comparison between the 15 investigated configurations of  
23  
24 the DoE.  
25  
26

27  
28  
29 Figure 5 reported the results of the 15 configurations for each impact category with the  
30  
31 absolute value, where the contribution of each process step was referred as a percentage  
32  
33 of the absolute value. Moreover, to underline the contribution of energy items in the  
34  
35 total impact, it was highlighted in each process step in which it was required:  
36  
37

38  
39 pretreatment, enzymatic extraction phases, deactivation unit and oil recovery through  
40  
41 centrifuge equipment.  
42  
43

44  
45 Figure 5 proved that for all the tested configurations, the main contribution to the total  
46  
47 environmental impact among the five investigated impact categories was the consumed  
48  
49 energy and in particular the energy required for the enzymatic extraction and  
50  
51 centrifugation phases.  
52  
53

54  
55 As shown in Figure 5a-e, experiment n° 4 presented the lower contributions in all the  
56  
57 impact categories analyzed in this work. This experiment was conducted at pH of 8.5  
58  
59 with an E/S of 1 % and for 30 mins. It is important to notice that, according to the DoE,  
60  
61

1 this experiment does not correspond to the highest obtainable oil yield but with the  
2 same quantity of oil produced, it is the most sustainable combination of experimental  
3 conditions, from an environmental point of view. By analyzing Figure 5, it is possible to  
4  
5  
6  
7 note ~~note~~ that all the experiments with a reaction time of 30 minutes, which  
8  
9 correspond to the lowest level of the time factor analyzed in the DoE, had minor  
10  
11 impacts. It could be deduced that the duration of the reaction greatly influences the  
12  
13 sustainability of this process. Indeed, for the climate change category, the experiments  
14  
15 with the longest enzyme extraction step (120 min) reached the highest energy  
16  
17 contribution in that phase, which ranged between 30-52 % of the total impact in all the  
18  
19 considered impact categories.  
20  
21  
22

23  
24 Furthermore, in all the considered impacts categories, the recovery of the oil is one of  
25  
26 the highest energy consumer items, hence the present study underlined the importance  
27  
28 of optimizing the downstream technology to recover the product target.  
29  
30

31 Another attentioned parameter in the present study of sustainability is the role of the  
32  
33 enzyme. In the marine eutrophication the effect of the enzyme was highlighted, and it  
34  
35 reached the highest contribution in the experiment in which the dose of the Alcalase was  
36  
37 the highest one (1 mL) and the yield of fish oil was not the optimal one compared to the  
38  
39 amount of tuna treated (0,2 g/ g of tuna).  
40  
41  
42

43 Among the investigated configurations, the one, reaching the highest impact of enzyme  
44  
45 in marine eutrophication, was the experiment n°3 with a value equal to 72 % of the total  
46  
47 enzymatic pretreatments (made up by the sum of the enzyme contribution and energy  
48  
49 required to carry out the enzymatic extraction phase).  
50  
51  
52

53 Among the five impact categories, the pretreatment unit, consisting in pH regulation  
54  
55 with the addition of a buffer, had environmental impacts detectable in terrestrial  
56  
57 acidification and freshwater eutrophication due to the adopted chemicals. Specifically,  
58  
59 the configurations n° 1, 2 and 6 exhibited pretreatment unit impact in terrestrial  
60  
61  
62  
63  
64  
65

1 acidification and freshwater eutrophication ranging between 6,5-8 and 6-8,10 % of the  
2 total environmental impacts in that categories.  
3

4 The transport of tuna exhibited a considerable impact in the ozone depletion category  
5 due to the necessity of transporting the feedstock with a refrigerated lorry for a distance  
6 of 1524 km (from the south of Italy to the north of Italy plant) in accordance with the  
7 study of (Khoo, et al 2019). The contribution of tuna transport in ozone depletion  
8 decreased by decreasing the amount of tuna, because according to the chosen FU ( 1g of  
9 fish oil), it means that the process is high performing.  
10

11 According to the study of (Sillero et al,2021) about LCA of biorefinery systems in  
12 general and not specific for substrate or type of process, the enzyme application impacts  
13 on marine eutrophication due to its origin, whereas pretreatment impacts on terrestrial  
14 acidification and freshwater eutrophication due to the use of chemical and their post  
15 consume, whereas the product recovery exhibits great impacts on climate changes and  
16 ozone depletion due to the energy requirement.  
17  
18

### 19 **3.6 Evaluation of LCA results through PCA**

20 To better compare the LCA results, it was decided to organize the values reported in  
21 Figure 4 into a data matrix of dimensions  $15 \times 5$  (one column for each impact category)  
22 and to analyze it using PCA. Prior to analysis, the data table was scaled to unit variance  
23 and mean centered. The PCA results are reported in Figure 6. As already highlighted in  
24 Figure 5, Climate change (a), Ozone depletion (b), Terrestrial acidification (c) and  
25 Freshwater eutrophication (d) share the same overall trend, while Marine eutrophication  
26 (e) shows a rather different pattern. This aspect is confirmed by the PC1-PC2 loadings  
27 plot (Figure 6a), as all impact categories appear to be highly correlated, since they are  
28 located at positive PC1 values. PC2 accounts for the difference between Marine  
29 eutrophication and the other four impact categories. Regarding the DoE experiments'  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 distribution in the scores plot of Figure 6b, it can be noticed a clear trend related to the  
2 extraction time (blue arrow and coloring). Moreover, from this plot it becomes clear that  
3  
4 experiment n°4 has the lowest impact in all categories, while experiment n°7 has the  
5  
6 largest impact in all categories.  
7

8  
9 The pattern of correlations among the impact categories described by PC2-PC3 (Figure  
10  
11 6a,b) seems to be related to the response, as the experiments' distribution colored  
12  
13 according to the oil yield % follow a rather clear trend (yellow arrow). The experiments  
14  
15 with the highest response also have higher impacts in the Climate change and Terrestrial  
16  
17 acidification categories, while the same experiments show much lower impacts in the  
18  
19 Ozone depletion and Marine eutrophication categories.  
20  
21

22  
23 ~~In order to better understand the reason for this statement, it is necessary to analyze the~~  
24 ~~so-called Sankey Diagram (Figure 6), whose concept was developed by Riall Sankey~~  
25 ~~(Jessen et al., 2015) with the aim of analyzing the thermal efficiency of steam engines.~~  
26  
27 ~~These diagrams are now extensively used to depict quantitative flows in several areas of~~  
28 ~~application. In this work, the Sankey Diagrams were used to visualize the contribution~~  
29 ~~of single steps to the total impact of the process. Figure 6b-f reports the Sankey~~  
30 ~~Diagrams of the five impact categories analyzed for experiment n°4. Each box~~  
31 ~~represents one component of the process, as described in figure 6a where the boundary~~  
32 ~~conditions are illustrated: "1" is the pretreatment step, "2" is the extraction step, "3" is~~  
33 ~~the deactivation step, "4" is the centrifugation step, "Electricity" is the electricity~~  
34 ~~needed to operate the equipment and "Enzyme" is the Alcalase used for the hydrolysis~~  
35  
36 ~~These boxes are connected in order by arrows whose size is proportional to the~~  
37 ~~normalized impact of that component. The centrifugation step (4) is the last one and it~~  
38 ~~contains the impacts of all the previous steps; therefore, it represents 100 % of the~~  
39 ~~impact (Jessen et al., 2015). Components that contribute less than 1 % of the total have~~  
40 ~~not been shown in the graph. As shown in Figure 6, almost all impact is caused by~~  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

~~electricity in all four categories.~~ Considering the results of the LCA expressed in figure 5 and of the PCA represented in figure 6, the following considerations can be made.

Almost all impact is caused by electricity in all four categories. In this LCA study, non-geolocalized medium voltage electricity was used, referring to the whole world (Simapro). This electricity represents an average of all types of electricity used globally, from renewable and non-renewable sources (coal, oil, gas, biomass, nuclear, hydro, wind, geothermal, solar marine) (Schmidt et al., 2011). The production of this electricity causes emissions of greenhouse gasses, nitrogen oxides, and sulfur oxides, substances responsible for the depletion of the ozone layer and compounds rich in phosphorus and nitrogen, damaging the various ecosystems (Kalender and Alkan, 2019). For this reason, the DoE experiments with the shortest time are also those with the lowest environmental impact.

The only impact category where the enzyme also contributes in large quantities to the total is Marine eutrophication. This LCA study assumed that the Alcalase is produced from potato starch along with a bacterial strain, as suggested by Rosa et al. (2020) (Rosa et al., 2020). It is possible that the cultivation of potatoes and the use of fertilizers greatly influence this impact category, increasing the emission of substances rich in nitrogen into rivers or coastal areas or the nitrogen applications to the soil

These results are in line with the results obtained from the DoE. Indeed, the best experimental configuration is the one that uses a buffer at pH 8.5 and an E/S of 1 %.

The duration of the process seems to be most responsible for the environmental impact, but time seems to be the least significant factor among the variables analyzed using the DoE. Moreover, the study of hydrolysis kinetics has shown that the DH% stabilizes around a plateau after one hour. Therefore, it would be possible to reduce reaction times by reducing the environmental impacts without losing much in oil yield. Another way to reduce the contribution of electricity could be to geolocate the process and use

1 renewable resources. For what it concerns the contribution due to the use of the enzyme,  
2 new scenarios could be envisaged, changing the type of enzyme or its way of  
3  
4 production.  
5  
6  
7  
8  
9  
10

## 11 **4. Conclusions**

12 ~~The enzymatic hydrolysis of tuna waste represents an innovative technology to exploit~~  
13 ~~canned tuna processing wastes. This study has shown that it is possible to obtain good~~  
14 ~~quality tuna oil rich in omega-3 fatty acids through enzymatic hydrolysis of tuna viscera~~  
15 ~~with Alcalase. For the first time, LCA and PCA analysis, combined with a DoE~~  
16 ~~approach, demonstrated that the duration of the hydrolysis and the associated electricity~~  
17 ~~consumption is the variable that affects the most the environmental sustainability of the~~  
18 ~~process.~~  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30

31 The enzymatic hydrolysis of tuna waste represents an innovative technology to exploit  
32 canned tuna processing wastes to obtain products with high added value, such as tuna  
33 oil and FPH. This study has shown that it is possible to obtain good quality tuna oil rich  
34 in omega-3 fatty acids through enzymatic hydrolysis of tuna viscera derived by a  
35 canned tuna production company with commercial enzyme Alcalase.  
36  
37  
38  
39  
40  
41  
42  
43

44 The DoE made it possible to optimize oil extraction and identify the best pH (8.5 °C),  
45 E/S (1%), and time (120 minutes). It was possible to obtain a model able to compute the  
46 yield as a function of the three-factor analyzed. The study of the progress of the DH%  
47 over time showed that after one hour, the reaction slows down. The experiments of the  
48 DoE were compared to each other through an LCA analysis, and the results were  
49 investigated with a PCA. This innovative approach allowed to demonstrate that  
50 the duration of the hydrolysis and the associated electricity consumption is the variable  
51 that most affects the environmental sustainability of the process.  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

1 Further studies would be needed to reduce the time of hydrolysis, analyze in more depth  
2 the FPH obtained and its proprieties and design a possible scale-up in order to evaluate  
3 the technical, economic and environmental feasibility of this process at an industrial  
4 level.  
5  
6  
7  
8  
9  
10  
11  
12  
13

## 14 **Acknowledgments**

15 We thank “Ditta Drago Sebastiano di Giuseppe Drago” (Siracusa) for sending the tuna  
16 waste materials from their production chain.  
17  
18  
19  
20  
21  
22  
23

24 **Funding:** This research did not receive any specific grant from funding agencies in the  
25 public, commercial, or not-for-profit sectors.  
26  
27  
28  
29  
30  
31

## 32 **References**

- 33 1. Ababouch, L., Catarci, C., 2008. Global production and marketing of canned  
34 tuna, Globefish Research Programme, Vol.94 Rome, FAO. p. 65
- 35 2. Adler-Nissen, J., 1982. ChemInform Abstract: Limited enzymic degradation of  
36 proteins: a new approach in the industrial application of hydrolases. Chem.  
37 Informations. 13, 138–156. <https://doi.org/10.1002/chin.198226331>
- 38 3. Alkio, M., Gonzalez, C., Jäntti, M., Aaltonen, O., 2000. Purification of  
39 Polyunsaturated Fatty Acid Esters from Tuna Oil with Supercritical Fluid  
40 Chromatography. J. Am. Oil Chem. Soc., 77, 3 [https://doi.org/10.1007/s11746-  
41 000-0051-3](https://doi.org/10.1007/s11746-000-0051-3)
- 42 4. Allain, V., Pilling, G. M., Williams, P. G., Harley, S., Nicol, S., & Hampton, J.  
43 2016. Overview of tuna fisheries, stock status and management framework in  
44 the Western and Central Pacific Ocean. In Pauwels, S., & Fache, E. (Eds.),  
45 Fisheries in the Pacific: The challenges of governance and sustainability.  
46 pacific-credo Publications. doi:10.4000/books.pacific.423
- 47 5. Araujo, J., Sica, P., Costa, C., Márquez, M.C., 2021. Enzymatic Hydrolysis of  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

- 1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65
- Fish Waste as an Alternative to Produce High Value-Added Products. *Waste and Biomass Valorization* 12, 847–855. <https://doi.org/10.1007/s12649-020-01029-x>
6. Avadí, A., Fréon, P., 2013. Life cycle assessment of fisheries : A review for fisheries scientists and managers. *Fish. Res.* 143, 21–38.  
<https://doi.org/10.1016/j.fishres.2013.01.006>
7. Babajafari, S., Moosavi-nasab, M., Nasrpour, S., 2017. Comparison of Enzymatic Hydrolysis and Chemical Methods for Oil Extraction from Rainbow Trout (*Oncorhynchus Mykiss* ) Waste and Its Influence on Omega 3 Fatty Acid Profile. *J. Nutr. Sci.* 2, 2, 58-65.
8. Bligh, E.G. and Dyer, W.J., 1959. *Canadian Journal of Biochemistry and Physiology.* *Can. J. Biochem. Physiol.* 37.
9. Bro, R., Smilde, A.K., 2014. Principal component analysis. *Anal. Methods*, 2014, 6 ,2812 <https://doi.org/10.1039/c3ay41907j>
10. Brotas, M.S.C., Carvalho, G.A., Pereira, P.A.P., 2020. Determination, through derivatization and GC-MS analysis, of Omega-3 and Omega-6 fatty acids in fish oil capsules sold in Salvador, Bahia. *J. Braz. Chem. Soc.* 31, 447–455.  
<https://doi.org/10.21577/0103-5053.20190203>
11. Buttol, P., Masoni, P., Bonoli, A., Goldoni, S., Belladonna, V., Cavazzuti, C., 2007. LCA of integrated MSW management systems: case study of the Bologna district. *Waste Management* 27, 1059–1070
12. Calder, P.C., 2012. Omega-3 polyunsaturated fatty acids and inflammatory processes : nutrition or pharmacology. *Br. J. Clin. Pharmacol.* 75, 3, 645–662  
[/https://doi.org/10.1111/j.1365-2125.2012.04374.x](https://doi.org/10.1111/j.1365-2125.2012.04374.x)
13. Correa-Matos, N.J., Vaghefi, S.B., 2013. Dairy Foods and Cardiovascular Diseases. In: *Bioactive Food as Dietary Interventions for Cardiovascular Disease.* Watson, R.R., Preedy, V.R. (eds). Elsevier Inc. pp. 319-332.  
<https://doi.org/10.1016/B978-0-12-396485-4.00018-9>
14. Cupp-enyard, C., 2008. Sigma’s Non-specific Protease Activity Assay - Casein as a Substrate.. *J. Vis. Exp.* 19. <https://doi.org/10.3791/899>
15. De Oliveira, D.A.S.B., Licodiedoff, S., Furigo, A., Ninow, J.L., Bork, J.A., Podestá, R., Block, J.M., Waszczynskyj, N., 2017. Enzymatic extraction of oil from yellowfin tuna (*Thunnus albacares*) by-products: a comparison with other extraction methods. *Int. J. Food Sci. Technol.* 52, 699–705.  
<https://doi.org/10.1111/ijfs.13324>

- 1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65
16. FAO. 2020. The State of World Fisheries and Aquaculture 2020. Sustainability in action. Rome. <https://doi.org/10.4060/ca9229en>
  17. Glowacz-Rozynska, A., Tynek, M., Malonowska-Panczyk, E., Martysiak-Zurowska, D., Pawlowicz, R., Kolodziejska, I., 2016. Comparison of oil yield and quality obtained by different extraction procedures from salmon ( *Salmo salar* ) processing byproducts. *Eur. J. Lipid Sci. Techno*, 118, 1759–1767. <https://doi.org/10.1002/ejlt.201500269>
  18. Guérard, F., Dufossé, L., De La Broise, D., Binet, A., 2001. Enzymatic hydrolysis of proteins from yellowfin tuna (*Thunnus albacares*) wastes using Alcalase. *J. Mol. Catal. - B Enzym.* 11, 1051–1059. [https://doi.org/10.1016/S1381-1177\(00\)00031-X](https://doi.org/10.1016/S1381-1177(00)00031-X)
  19. Halldorsson, A., Kristinsson, B., Glynn, C., Haraldsson, G.G., 2003. Separation of EPA and DMA in Fish Oil by Lipase-Catalyzed Esterification with Glycerol. *J. Am. Oil Chem. Soc.* 80, 915–921. <https://doi.org/10.1007/s11746-003-0796-8>
  20. Herpandi, N., Huda, Rosma, A., and Wan Nadiah, W.A., 2011. The Tuna Fishing Industry : A New Outlook on Fish Protein Hydrolysates. *Compr. Rev. Food Sci.* 10, 195–207. <https://doi.org/10.1111/j.1541-4337.2011.00155.x>
  21. Hospido, A., Vazquez, M.E., Cuevas, A., Feijoo, G., Moreira, M.T., 2006. Environmental assessment of canned tuna manufacture with a life-cycle perspective. *Resour. Conserv. Recycl.* 47, 56–72. <https://doi.org/10.1016/j.resconrec.2005.10.003>
  22. Je, J.Y., Lee, K.H., Lee, M.H., Ahn, C.B., 2009. Antioxidant and antihypertensive protein hydrolysates produced from tuna liver by enzymatic hydrolysis. *Food Res. Int.* 42, 1266–1272 <https://doi.org/10.1016/j.foodres.2009.06.013>
  23. Jessen, C., Bednarz, V.N., Rix, L., Teichberg, M., 2015. Marine Eutrophication. In: Armon, R.H., Hañninen, O. (eds.), *Environmental Indicators*, Springer Science+Business Media Dordrecht. pp 177-203. <https://doi.org/10.1007/978-94-017-9499-2>
  24. Kalender, S.S., Alkan, G.B., 2019. Air Pollution in: Hussain, C. M. (ed.), *Handbook of Environmental Materials Management*. Springer Nature Switzerland pp. 149-166
  25. Karunarathna, U., 2009. Nutritional evaluation in five species of tuna. *VJS.* 6–16. <https://doi.org/10.31357/vjs.v15i0.211>

- 1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65
26. Klomklao, S., Benjakul, S., 2016. Utilization of tuna processing byproducts : protein hydrolysate from skipjack tuna ( *katsuwonus pelamis* ) viscera. *J. Food Process. Preserv.* <https://doi.org/10.1111/jfpp.12970>
  27. Khoo, H.H., Eufrazio-espinoza, R.M., Koh, L.S.C., Sharratt, P.N, 2019. Sustainability assessment of biorefinery production chains : A combined LCA-supply chain approach. *J. Clean. Prod.* 235, 1116–1137 <https://doi.org/10.1016/j.jclepro.2019.07.007>
  28. Kruger, N.J., 1994. The Bradford method for protein quantitation. *Methods Mol. Biol.* 32, 9–15. <https://doi.org/10.1385/0-89603-268-x:9>
  29. Leardi, R., 2009. Experimental design in chemistry: A tutorial. *Anal. Chim. Acta* 652, 161–172. <https://doi.org/10.1016/j.aca.2009.06.015>
  30. Li, X., Cao, J., Bai, X., Zhang, F., 2018. Chemical composition and thermal properties of Tilapia oil extracted by different methods. *Int. J. Food Prop.* 21, 1575–1585. <https://doi.org/10.1080/10942912.2018.1503302>
  31. Mariotti, F., Tomé, D., Mirand, P.P., 2008. Converting Nitrogen into Protein — Beyond 6 . 25 and Jones ' Factors. *Crit. Rev. Food. Sci. Nutr.* 48, 177-184. <https://doi.org/10.1080/10408390701279749>
  32. Miyamoto, A., Allacker, K., De Troyer, F., 2019. Visual tool to integrate LCA and LCC in the early design stage of housing Visual tool to integrate LCA and LCC in the early design stage of housing. *IOP Conf. Series: Earth and Environmental Science*, 323, 012161 <https://doi.org/10.1088/1755-1315/323/1/012161>
  33. Navarrete del Toro, M.A., García- Carreño, F.L., 2003. Evaluation of the Progress of Protein Hydrolysis. *Curr. Protoc. Food Anal. Chem.* 10, 1–14. <https://doi.org/10.1002/0471142913.fab0202s10>
  34. North, P., Zealand, N., 2010. Methodology for Determining Degree of Hydrolysis of Proteins in Hydrolysates: A Review. *J. AOAC Int.* 93, 5, 1515–1522.
  35. Ovissipour, M., Benjakul, S., Safari, R., Motamedzadegan, A., 2010. Fish protein hydrolysates production from yellowfin tuna *Thunnus albacares* head using Alcalase and Protamex. *Int. Aquat. Res.* 2, 87–95.
  36. Qi-Yuan, L., Jun-Qing, Q., Xiao-Ge, W., 2016. Optimization of enzymatic fish oil extraction from mackerel viscera by response surface methodology. *Int. Food Res. J.* 23, 992–997.

- 1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65
37. R. Leardi, C. Melzi, G. Polotti, CAT (Chemometric Agile Tool), freely downloadable from <http://gruppochemiometria.it/index.php/software> Last access 20/07/2022
38. Ramakrishnan, V.V., Ghaly, A.E., Brooks, M.S., Budge, S.M., 2013. Extraction of Oil from Mackerel Fish Processing Waste using Alcalase Enzyme. *J. Bioprocess Biotech.* 3, 2 . <https://doi.org/10.4172/2155-9821.1000130>
39. Rapporti ISTISAN96/34. Analytical methods used in food chemical control. Collection edited by Massimo Baldini, Fabio Fabietti, Stefania Giammarioli, Roberta Onori, Leucio Orefice and Angelo Stacchini, 1996, v. 265
40. Rosa, R., Spinelli, R., Neri, P., Pini, M., Barbi, S., Montorsi, M., Maistrello, L., Marseglia, A., Caligiani, A., Ferrari, A.M., 2020. Life Cycle Assessment of Chemical vs Enzymatic-Assisted Extraction of Proteins from Black Soldier Fly Prepupae for the Preparation of Biomaterials for Potential Agricultural Use. *ACS Sustain. Chem. Eng.* 8, 14752–14764. <https://doi.org/10.1021/acssuschemeng.0c03795>
41. Ruiz-salmón, I., Laso, J., Margallo, M., Villanueva-rey, P., Rodríguez, E., Quinteiro, P., Cláudia, A., Almeida, C., Leonor, M., Marques, A., Cortés, A., Teresa, M., Feijoo, G., Loubet, P., Sonnemann, G., Morse, A.P., Cooney, R., Clifford, E., Regueiro, L., Méndez, D., Anglada, C., Noiro, C., Rowan, N., Vázquez-rowe, I., Aldaco, R., 2021. Science of the Total Environment Life cycle assessment of fish and seafood processed products – A review of methodologies and new challenges. *Sci. Total Environ.* 761, 144094. <https://doi.org/10.1016/j.scitotenv.2020.144094>
42. Saidi, S., Belleville, M., Deratani, A., Amar, R. Ben, 2013. Optimization of peptide production by enzymatic hydrolysis of tuna dark muscle by-product using commercial proteases. *Afr. J. Biotechnol.* 12, 1533-1547 <https://doi.org/10.5897/AJB12.2745>
43. Schmidt, J. H., Merciai, S., Thrane, M., Dalgaard, R. 2011. Inventory of country specific electricity in LCA – Consequential and attributional scenarios. Methodology report v2. 2.- 0 LCA consultants, Aalborg [http://www.lca-net.com/projects/electricity\\_in\\_lca/](http://www.lca-net.com/projects/electricity_in_lca/) Last access 20/07/2022
44. Sergent, M., 1995. Correct and incorrect use of multilinear regression. *Chemometr. Intell. Lab. Syst.* 27, 153–162.
45. Sillero, L., Morales, A., Fernández-marín, R., Hernández-ramos, F., 2021. Life

Cycle Assessment of various biorefinery approaches for the valorisation of almond shells. *Sustain. Prod. Consum.* 28, 749–759  
<https://doi.org/10.1016/j.spc.2021.07.004>

46. Simonne, A.H., Simonne, E.H., Eitenmiller, R.R., Mills, H.A., Cresman, C.P., 1997. Could the dumas method replace the Kjeldahl digestion for nitrogen and crude protein determinations in foods *J. Sci. Food Agric.* 73, 39–45.  
[https://doi.org/10.1002/\(sici\)1097-0010\(199701\)73:1<39::aid-jsfa717>3.3.co;2-w](https://doi.org/10.1002/(sici)1097-0010(199701)73:1<39::aid-jsfa717>3.3.co;2-w)
47. Tacias-pascacio, V.G., Morellon-sterling, R., Siar, E., Tavano, O., Berenguer-murcia, Á., Fernandez-lafuente, R., 2020. International Journal of Biological Macromolecules Use of Alcalase in the production of bioactive peptides : A review. *Int. J. Biol. Macromol.* 165, 2143–2196.  
<https://doi.org/10.1016/j.ijbiomac.2020.10.060>
48. Taylor, C.J., Baker, A., Chapman, M.R., Reynolds, W.R., Jolley, K.E., Clemens, G., Smith, G.E., Blacker, A.J., Chamberlain, T.W., Christie, S.D.R., Taylor, B.A., Bourne, R.A., 2021. Flow chemistry for process optimisation using design of experiments. *J. Flow Chem.* 11, 75–86. <https://doi.org/10.1007/s41981-020-00135-0>
49. Taylor, P., Vang, B., Pedersen, A.M., Olsen, R.L., 2013. Oil extraction From the Copepod *Calanus finmarchicus* Using Proteolytic Enzymes. *J. Aquat. Food Prod. Technol.*, 37–41. <https://doi.org/10.1080/10498850.2012.686008>
50. Understanding electricity in SimaPro. <https://simapro.com/2019/understanding-electricity-in-simapro/> Last access 20/07/2022
51. Valencia, P., Pinto, M., Almonacid, S., 2014. Identification of the key mechanisms involved in the hydrolysis of fish protein by Alcalase. *Process Biochem.* 49, 258–264. <https://doi.org/10.1016/j.procbio.2013.11.012>
52. Vlieg, P., Murray, T., 2014. Proximate composition of albacore tuna, *Thunnus alalunga*, from the temperate South Pacific and Tasman Sea. *N. Z. J. Mar. Freshwater Res.* 22, 4, 491-496, .  
<https://doi.org/10.1080/00288330.1988.9516318>
53. Wang, L., Yang, F., Rong, Y., Yuan, Y., Ding, Y., Shi, W., Wang, Z., 2019. Effects of different proteases enzymatic extraction on the lipid yield and quality of Antarctic krill oil. *Food Sci. Nutr.* 7, 2224–2230.  
<https://doi.org/10.1002/fsn3.1017>

- 1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65
54. Zhang, Y., Wang, Xiaosan, Xie, D., Li, Y., Wang, Xingguo, 2017. One - Step Concentration of Highly Unsaturated Fatty Acids from Tuna Oil by Low - Temperature Crystallization. *J. Am. Oil. Chem. Soc.* 94, 475–483. <https://doi.org/10.1007/s11746-017-2949-3>
55. Shu, G., Zhang, B., Zhang, Q., Wan, H., Li, H. "Effect of Temperature, pH, Enzyme to Substrate Ratio, Substrate Concentration and Time on the Antioxidative Activity of Hydrolysates from Goat Milk Casein by Alcalase" *Acta Universitatis Cibiniensis. Series E: Food Technology*, vol.20, no.2, 2016, pp.29-38. <https://doi.org/10.1515/aucft-2016-0013>
56. Wells, J. A., Estell, D. A., 1988, Subtilisin — an enzyme designed to be engineered. *Trends in Biochemical Sciences*, 13(8), 291–297. doi:10.1016/0968-0004(88)90121-1
57. Azrin, N., Ali, M., Rahman, R., Oslan, S., Noor, N., 2022. Versatility Of Subtilisin: A review on structure, characteristics, and applications. *Biotechnol Appl Biochem.* doi: 10.1002/bab.2309.
58. Kurozawa, L.E., Park, K.J., Hubinge, M.D., 2009, Production, Properties And Stability Of chicken Meat Protein Hydrolysate Powder, in *Handbook of Nutritional Biochemistry: Genomics, Metabolomics and Food Supply: Genomics, Metabolomics & Food Supply*, Nova Science Publishers, Inc (eds) ISBN: 978-1-60741-916-7

1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

### Figure Captions:

**Figure 1.** A representation of the three-factors, three-levels, Central Composite Face Centered (CCF) experimental domain. To model and explain the results of the DoE, a multiple linear regression (MLR) was applied, as described in Section 2.5.

**Figure 2.** Scheme of the LCA boundary conditions. For each process, input and output of matter and energy are illustrated.

**Figure 3.** (a) The coefficients plot of the MLR model (\*\*=  $p < 0.01$ , \*\*\* =  $p < 0.001$ ) and the response surfaces for oil yield %: (b) interaction between E/S and pH, (c) interaction between time and pH, (d) interaction between time and E/S.

**Figure 4.** Enzymatic extraction progress curve and results of the fitting procedure. Black squares represent the experimental values. Each experiment was conducted in triplicate, and the error bars correspond to standard error. The continuous line represents the modeled values (eq. 9). a, b and c are the coefficients of equation 9. R and  $R^2$  represent the quality of the fitting.

**Figure 5.** Results of comparative LCA between the 15 experiments of the DoE in terms of five impact categories: (a) Climate change (kg CO<sub>2</sub> eq), (b) Ozone depletion (kg CFC-11 eq), (c) Terrestrial acidification (kg SO<sub>2</sub> eq), (d) Freshwater eutrophication (kg P eq) and (e) Marine eutrophication (kg N eq).

**Figure 6.** PCA scores and loadings plots of the comparative LCA results. Only the most informative combinations of principal components are reported: PC1-PC2

loadings (a) and scores (b) plots; PC2-PC3 loadings (c) and scores (d) plots. The coloring in (b) corresponds to the extraction time, while in (d) it corresponds to the oil yield % (the response of the DoE). The coloring range values can be interpreted using the color bars on the right-hand side.

1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

**Tables:**

**Table 1** The experimental plan (i.e., the factors described with their original values) and matrix (i.e., the coded version of the factors' values) for tuna oil extraction optimization, whose yield values are reported in the last column on the right.

Experiment N°	pH (coded)	E/S (coded)	time (coded)	pH (original)	E/S (%) (original)	time (min) (original)	oil yield % (response)
1	-1	-1	-1	6.5	0.1	30	15.0
2	1	-1	-1	8.5	0.1	30	31.7
3	-1	1	-1	6.5	1	30	25.0
4	1	1	-1	8.5	1	30	49.3
5	-1	-1	1	6.5	0.1	120	24.1
6	1	-1	1	8.5	0.1	120	33.5
7	-1	1	1	6.5	1	120	56.0
8	1	1	1	8.5	1	120	81.4
9	-1	0	0	6.5	0.55	75	21.9
10	1	0	0	8.5	0.55	75	76.6
11	0	-1	0	7.5	0.1	75	27.7
12	0	1	0	7.5	1	75	47.0
13	0	0	-1	7.5	0.55	30	31.3
14	0	0	1	7.5	0.55	120	43.0
15	0	0	0	7.5	0.55	75	34.8
16	0	0	0	7.5	0.55	75	38.7
17	0	0	0	7.5	0.55	75	42.5

**Table 2.** Coefficients of the MLR model and their significance with the explained variance of the data. \*= p < 0,05 \*\*= p < 0.01, \*\*\* = p < 0.001

Coefficients				Explained Variance %
$\beta_0$	$\beta_{pH}$	$\beta_{E/S}$	$\beta_t$	
39.968	13.043	12.665	6.575	71.58
0.0000***	0.00009***	0.0011**	0.0148*	

**Table 3.** Prediction results of experiments 18 and 19.

<b>Exp N°</b>	<b>Experimental value</b>	<b>Lower</b>	<b>Predicted value</b>	<b>Upper</b>	<b>Residuals</b>
18	24.16	34.90	39.97	45.04	-2.20
19	39.25	34.90	39.97	45.04	0.71

1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

Figures:

Figure 1.

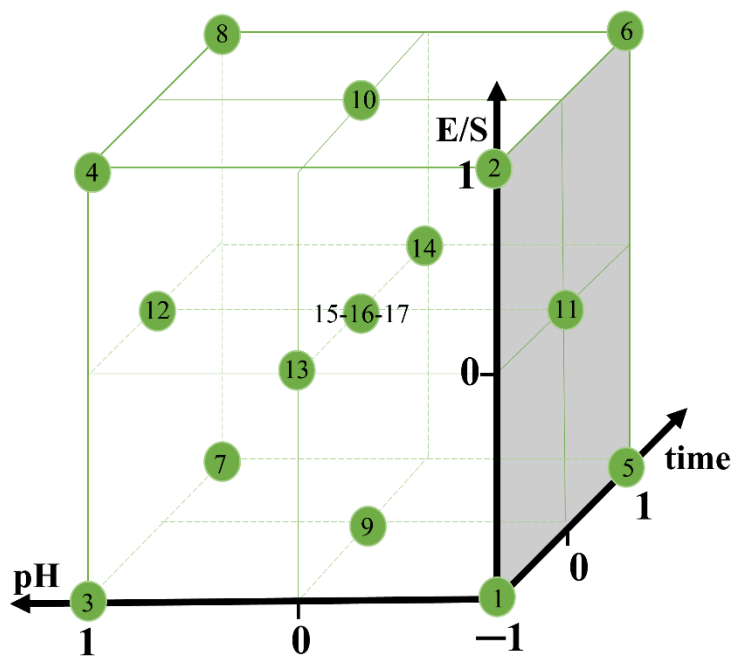
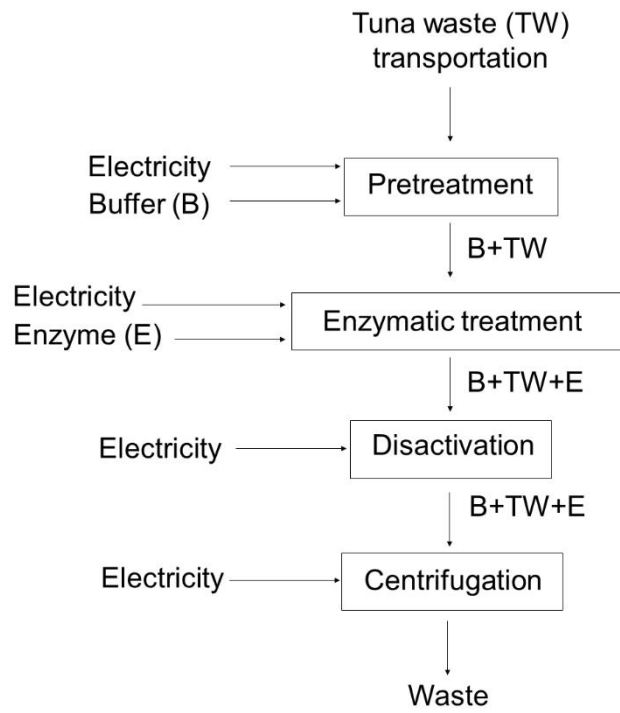
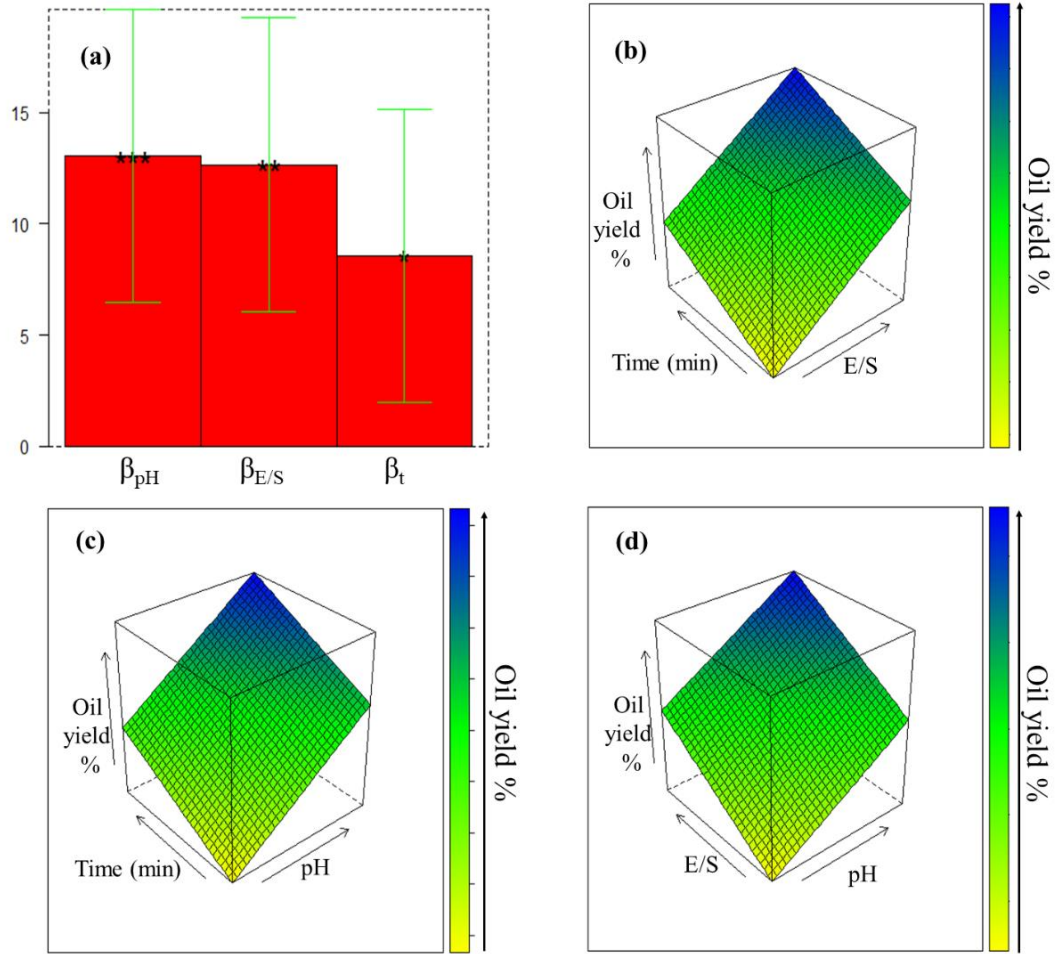


Figure 2.



1  
2  
3  
4  
5  
6  
7  
8  
9  
10  
11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48  
49  
50  
51  
52  
53  
54  
55  
56  
57  
58  
59  
60  
61  
62  
63  
64  
65

**Figure 2-3.**



**Figure 3-4.**

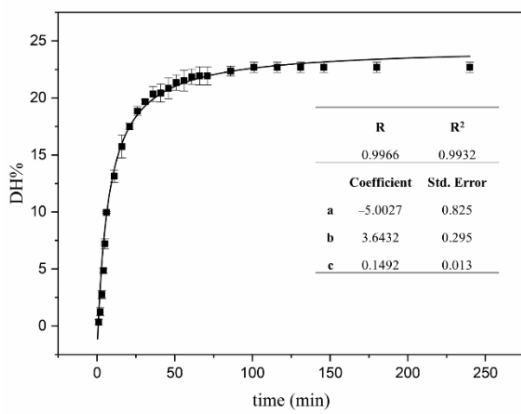


Figure 4.5.

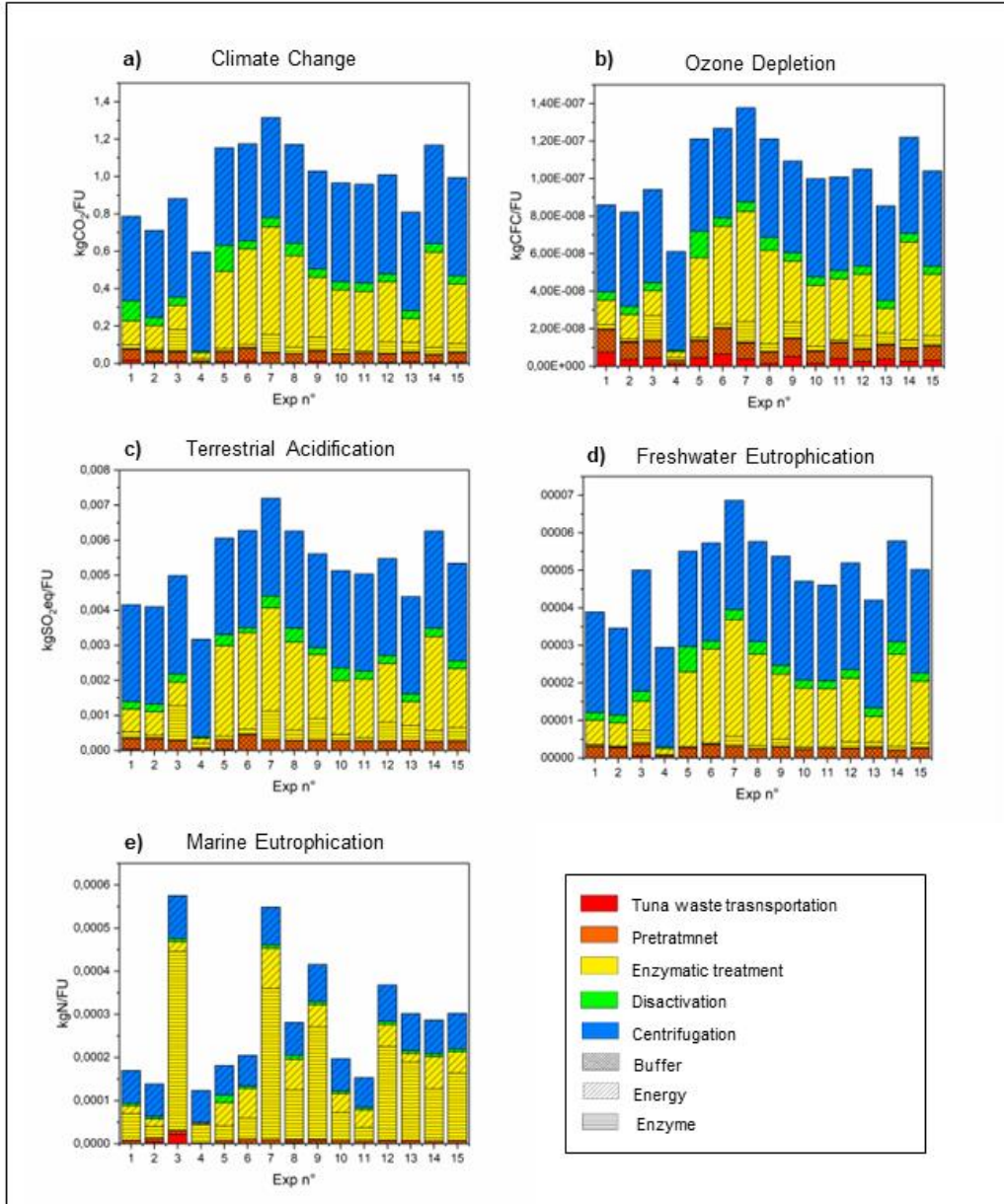
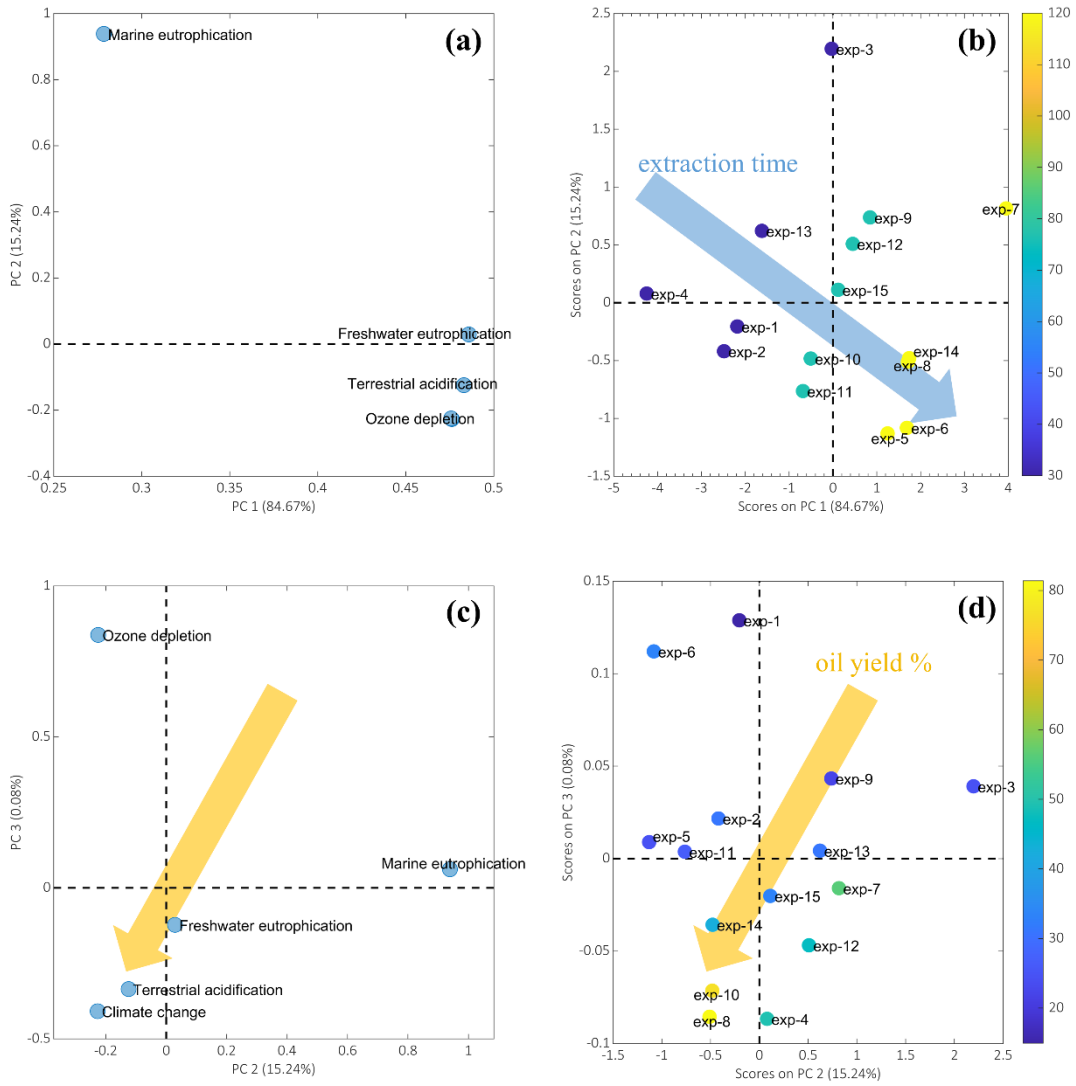


Figure 5 6.



**Declaration of interests**

The authors declare that they have no known competing financial interests or personal relationships that could have appeared to influence the work reported in this paper.

The authors declare the following financial interests/personal relationships which may be considered as potential competing interests:

04/09/2022

Toma Tommas



Click here to access/download  
**Supplementary Material**  
supplementary.docx

