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AarhusKarlshamn
– your partner in creating solutions

Company
AAK is one of the world’s leading producers of high value-added, speciality vegetable fats.

The company’s leading position in speciality vegetable fats was strengthened in October 2005 as a result of the merger between Aarhus United and Karlshamns.

The company’s wide product portfolio meets customer requirements worldwide. Our customers represent a wide range of industries:

- Chocolate
- Confectionery
- Food
- Cosmetics
- Technical
- Feed

In line with our customers’ needs, AAK is organised in the business areas Chocolate & Confectionery Fats, Food Ingredients, Lipids for Care, and Technical Products & Feed.

Our production facilities in Denmark, Sweden, Mexico, the Netherlands, Uruguay, the UK, and the USA count 2,500 employees worldwide.

AAK’s objective is to supply innovative and creative, vegetable fat solutions to the benefit of our customers.

Products
AAK’s products are derived from natural and nutritious raw materials, e.g. palm, rape and exotic oils such as shea, illipe, sal and mango.

Our products are characterized by a high degree of technology and are used in such areas as cocoa butter alternatives, replacement for butter fat, solutions to eliminate trans fatty acids as well as ingredients in functional foods.

Research & Development
AAK’s wide product range is the result of longstanding, dedicated focus on research and development carried out in our own laboratories.

AAK’s knowledge and expertise regarding the properties of vegetable fats develops continuously through customer contacts, cooperation with research institutes and governmental authorities – regionally and worldwide.

Our research and development takes place in close coordination with the customer to tailor products to meet the customer’s requirements.

Service
We provide local service from regional sales offices and through our network of distributors and agents worldwide.

Understanding customer needs is AAK’s business.
Milk fat has a unique composition. Its chemical and physical properties make it a generally well-accepted ingredient in many food applications. Due to cost and performance reasons, the replacement of milk fat with vegetable fat blends has been interesting for the food manufacturer for a long time. However, there are some differences in behaviour that one must be aware of, when making this substitution. AAK has taken care to optimise these properties in the development of our range of vegetable Dairy Fat Alternative to facilitate the manufacturing process with vegetable fats.

**Good taste and taste stability**
Due to its composition, milk fat has a characteristic creamy/buttery flavour, that vegetable fats lack. In order to replace milk fat with vegetable fats and still maintain the quality of the finished product, the vegetable fat must have a bland taste without any off-flavour. It also has to have good flavour stability. The bland flavour and high flavour stability of AAK’s DFA products are based on careful selection of raw materials and appropriate, optimised refining of the oils.

**Improved nutritional value**
From a nutritional point of view, the high proportion of saturated fatty acids in milk fat is less desirable. Vegetable oils usually contain less saturated fatty acids and more unsaturated fatty acids compared to milk fat and they contain very little cholesterol. When using vegetable fats, in combination with milk fat or on their own, the balance between various fatty acids can be adjusted to a higher nutritional value.

AAK’s DFA products are designed to have a beneficial nutritional profile. When necessary they can also be adjusted to fulfil different objectives. This often means that the amount of saturated fat and trans fatty acids are reduced and the mono- and polyunsaturated fatty acids are increased. By carefully selecting and combining raw materials, followed by gentle processing, AAK’s DFAs are designed to satisfy both the nutritional aspects and the functional properties of a fat for dairy application.

**Desired crystallisation behaviour**
Milk fat crystallises and is stable in the beta-prime polymorph. This gives milk fat some desirable application characteristics: high crystallisation rate, good foam stabilising properties and small crystals. A vegetable fat, replacing milk fat, must conform to this crystallisation pattern, especially if used in mixtures with milk fat. Depending on the application, the desired crystallisation behaviour differs and AAK’s extensive knowledge in this area is essential in order to develop well-performing products.

**Accurate melting properties and consistency**
Milk fat has good melting properties, being quite hard at lower temperatures and melting completely at body temperature. This is important for the mouth feel and flavour release when eating the finished product. A vegetable fat should have similar melting properties in order to replace milk fat with a maintained quality of the finished product. The consistency of milk fat and vegetable fat blends is also affected by the melting profile, influencing for example the texture and eating properties of butter blends, ice-cream and cheese.

While milk fat shows seasonal variations in hardness, the vegetable fats are produced to an even consistency throughout the year. When air is incorporated into the products, such as whipped cream and ice-cream, the balance between solid fat and liquid oil becomes extra important for the stability. In such cases, care is taken to adjust the solid fat content at the appropriate temperatures.

**Good stability and long shelf-life**
The stability and shelf-life of dairy products are of course mostly dependent on the hygienic conditions in the production, and on the storage conditions. The development of rancidity has also to be considered. Hydrolytic rancidity is caused by fatty acids set free during storage and may be a problem with milk fat. Both milk fat and vegetable oils can also get rancid by lipid oxidation. The more unsaturated oils are more sensitive to this type of rancidity. Vegetable fat blends containing the nutritionally desired polyunsaturated fatty acids but with high resistance towards oxidative rancidity, are available in AAK’s DFA product range for many dairy applications.
This figure illustrates how one of AAK’s DFA products, Akoblend, can be mixed with butter oil in any proportion without changing the consistency.

The sensory analyse shows an oil bland taste without off-flavours.
The replacement of milk fat with a vegetable fat blend is often quite simple when using AarhusKarlshamn’s DFA products. They have been tailor-made to meet the requirements of the applications. A straight one-to-one replacement is then easily performed. In other cases there are some factors that need to be considered. Some of these are described below.

**Recipe**
When replacing milk fat with vegetable fat in dairy products, it is recommended to start with the currently used recipe. If butter is originally used in the recipe, a recalculation of the fat content has to be made, as vegetable fat is 100% fat without any content of water. A calculation is also to be made to obtain a cream with correct fat content, from vegetable fat and skimmed milk, or other milk raw material. The vegetable fat based cream is then used in the same way as ordinary cream.

**Flavour and colour**
In some applications the absence of a characteristic butter flavour, in vegetable fats, makes it necessary to add a flavour. Experience shows that flavour are normally not needed if the proportion of milk fat in the fat blend is more than 30-50%.

Colouring in the form of beta-carotene is normally added to the finished product in order to meet the different requirements for the various products and markets. AAK can add both flavouring and colouring agents to our products on request by the customer. This ensures safety and offers convenience in the customer’s production.

**Processing and equipment**
Using AAK’s DFA products in ordinary dairy production:
- The existing processing equipment can be used in most application areas.
- Only minor adjustments of the process parameters compared to ordinary dairy production.
- No expensive investments in new equipment are required.
- The productivity in the manufacturing line can be maintained or even improved.

There will of course be a need for the installation of equipment for handling of the vegetable oil and for its incorporation into the milk or cream.

**Process parameters**
Process parameters need normally only minor adjustments. In some cases the vegetable fat blends crystallise more rapidly than the milk fat. The cooling time and temperature must then be adjusted accordingly to obtain a satisfactory product. In other cases, special attention should be given to the polymorphic behaviour of the milk fat and vegetable fat blends, and you should consult your AAK representative to obtain the appropriate handling instructions. Most product and process related problems can be solved by adjusting the properties of the fat blend and/or the process parameters.

**Emulsification**
Manufacturing of an emulsion made from the fat is the first stage in the production of vegetable fat based dairy applications. This emulsion (vegetable fat based milk
The replacement of milk fat with a vegetable fat blend is often quite simple when using AAK’s DFA products.

The figure shows the process for making an emulsion from the vegetable fat and milk fat and protein source. The vegetable fat based milk or cream is then used in the ordinary dairy production.

or cream) is then used as the basis for the production, see figure.

When the vegetable fat is mixed into the milk source, the result is a coarse emulsion. This coarse emulsion must, at least for some applications, be homogenised, in order to reduce the droplet size and give sufficient stability. Sometimes, for example in ice-cream and whipped cream, the properties of the emulsion are critical parameters for optimal performance in the application. In such cases the emulsification process need to be further optimised.
Churned butter-blends

Butter-blends
According to the rules of the EU, the word blend is used for butter-like products containing both milk fat and other fats. The words "butter-mix" and "spread" can also be used.

Spreads, based on vegetable fat and small amounts of butterfat, are normally manufactured by using a chilled-tube scraped-surface type of equipment. For a normal dairy operation, this approach usually requires investments in new expensive equipment.

AarhusKarlshamn’s has developed vegetable fat mixtures, Akoblend, suitable for making butter-blends with ordinary butter-making equipment.

The advantages of using Akoblend
The advantages of Akoblend can be summarised as follows:

- The same equipment can be used for both ordinary butter and butter-blends.
- The same package and wrappings and equipment as for ordinary butter can be used.
- Any ratio of vegetable fat/butter fat can be used (20/80 to 90/10); also for total replacement.
- The consistency of the butter-blend can be adjusted:
  - to obtain the desired product spreadability.
  - also a high ratio vegetable fat/butter fat (50/50 to 90/10) gives the same consistency properties as butter.
  - the uniform product quality means less variation from summer/winter butterfat.
- A wide range of milk fat sources can be utilised: creams of different fat contents or butter.
- A wide range of milk raw materials can be utilised: skimmed milk, ordinary whole milk, low fat cream, skimmed milk powder, whole milk powder or cream powder.

Akoblend meets your consistency demands
Akoblend is 100 % vegetable fat blends, refined to obtain a bland taste and very good stability. The melting characteristics are similar to butter fat. In fig. 1 the solid fat content at various temperatures is given for two different Akoblend products and for butter fat. Akoblend BE is an example of products especially suitable for blends with high amounts of butter fat (40-60 %) and will give a product more spreadable than butter. Another product in the AAK’s range, Akoblend NH, can be used to give the same consistency as butter, if a lower butter fat content is requested. Other products are available to meet any other consistency demands.

As mentioned earlier colouring in the form of beta-carotene is normally added to the finished products. It can sometimes be necessary to add a butter flavour. On request by the customer, AAK can add both flavouring and colouring to the Akoblend products.

Melting curves for butter fat and Akoblend

AAK’s products developed for making butter-blends with ordinary butter-making equipment.
Cream applications

Properties of cream
An emulsion (cream) made from the fat, is used as the basis for most vegetable fat based dairy applications. Manufacturing of the emulsion is the first stage in the production of these products. This cream is characterized by its fat content, its stability against flocculation and coalescence, and its whipping properties. The creams are normally stabilised by a combination of particle size control, added emulsifiers and stabilisers, and the milk proteins present in the raw materials.

New opportunities with vegetable fat
The vegetable creams are used as such or as inter-mediates in the production of other dairy items such as butter blends, ice-cream or desserts. The vegetable creams can also be fermented to cultured products like soured cream or spray dried to powders. Creams are normally classified according to their fat content, with pouring (cooking) creams containing approximately 20 % fat, whipping creams 20-40 % fat and “double creams” 35-50 % fat. The vegetable creams are normally developed to match these qualities.

Liquid cream
Different types of products require different types of fats in order to make a successful application. Products like liquid coffee whiteners and cooking creams, where the whipping properties are less important, are formulated using Akoblend or other special nutritional blends. Akoblend is described in the butter-blend chapter. These products fulfill the most important requirements such as, the absence of rancidity and off-flavours, and good storage stability.

Cultured creams
Various kinds of cultured creams such as soured cream, crème fraîche and smetana are produced from vegetable fat blends. Except for differences in fat content, these products vary in taste, sourness and consistency. It is important to retain these properties when replacing milk fat with vegetable fat totally or partially. It is also vital to obtain a stable cream that does not separate the water phase. These properties are obtained by using Akoblend in combination with correct processing, and possibly an additional stabiliser.

If combined products of milk and vegetable fat are produced, then ordinary cream and cream based on vegetable fats are blended to the desired proportions. This mixed cream is then homogenised, heat treated and fermented in the usual way.

Whipped cream
For different types of aerated applications such as whipped creams, toppings and aerosols, the Akotop range of fat is to be preferred. These fat blends have the correct type, and amount, of solid fat crystals for the stabilisation of air cells, in order to produce stable foams that do not shrink or release the liquid phase. The balance between liquid and solid fat in the fat globules is important in order to produce sufficient overrun, and to give stability when the globules flocculate.

The performance of the product is determined by the processing conditions and the fat, together with the choice of emulsifiers and additional stabilisers. The droplet size and cooling conditions must be optimised in order to achieve the desired whipping properties and stability.

Akotop has a bland taste and a rapid melting that contributes to a good flavour release. Their crystallisation behaviour is optimised to meet the requirements for foam stabilisation and compatibility with other ingredients, including milk fat.

Akotop can with preference also be used when making flavoured products, such as chocolate or vanilla toppings. Another possibility is to make blended cream, to combine the full flavour of dairy cream with the stability and reduced fat content of a topping.
Cheese

Fat improves the properties of cheese
Even though cheese is built up by a protein structure, the fat plays a significant role for some important basic properties of the cheese. The fat greatly influences both the texture and flavour of the various kinds of cheeses.

Cheeses are normally manufactured by one of the two basic methods for making curd from milk, acid or rennet coagulation. Vegetable fat is used to replace milk fat in both rennet and acid coagulated cheeses.

High quality vegetable fat for cheese
It is important to use vegetable fat blends that give the same properties to the final cheese as milk fat. AarhusKarlshamn’s speciality fats for cheese production are the Akoroma and Akocheese product ranges. These products have the correct balance between solid and liquid fat, as well as the correct consistency and melting behaviour. They also have the suitable crystallisation pattern to achieve optimal quality of the finished product in terms of consistency, appearance and shape integrity during ripening. Akoroma have a bland taste, which does not interfere with the final cheese flavour.

Akocheese is AAK’s specialised fat blend for use in all ripened cheeses. This vegetable fat blend gives an improved flavour development in the cheese during ripening compared to other fat blends. It is used much in the same way as Akoroma, but gives a more premium cheese taste.

Hard and soft cheese
Most major international varieties of cheese are included in this group. They are mainly produced by means of rennet coagulation. A wide variety of starter bacteria are used, and in most cases the cheeses are fully developed only after some time of ripening. In this group especially hard cheese can be successfully made from vegetable fat, using the Akoroma and Akocheese range.
Processed cheese
Processed cheeses exist mainly as spreadable cheese and as blocks, slices and grated cheese for industrial use. They are commonly manufactured by heating hard cheese together with melting salts in an agitation pan. This procedure breaks down the protein structure of the original cheese and produces a stable emulsion. Butter or vegetable fat, like Akoroma, is added during the melting process to achieve the desired texture of a cheese spread.

Another method used is the mixing of a protein blend with a vegetable fat, producing a processed cheese analogue. Akoroma is used for this application.

Fresh cheese
This group comprises quarg, cottage cheese, cream cheese and fromage frais, among others. They are primarily produced by acid coagulation and are ready for consumption without ripening. These types of cheeses can successfully be produced using Akoroma.

Cheese production using Akoroma and Akocheese
The production of vegetable fat based cheese starts with the emulsification of vegetable fat in skimmed milk. The size and uniformity of the fat globules are important parameters for the final quality of the cheese. The obtained recombined milk is then used in the ordinary cheese making equipment.

There are also variations to the mentioned production methods. For example, a fresh cheese spread can successfully be produced by mixing ordinary skim milk quarg with Akoroma and water in a Stephan cooker.
Other dairy applications

AarhusKarlshamn’s DFA products can be used in most kinds of dairy applications. As described earlier a milk or cream emulsion is made from a milk protein source and vegetable fat. This vegetable milk or cream is then used in the production in the same way as the ordinary dairy milk or cream.

**Milk**

Milk for consumption can be made from skimmed milk, a suitable vegetable fat, and food emulsifier. Besides price the main reason for making such a product is the nutritional value. Vegetable fats are then used to incorporate high amounts of mono- and polyunsaturated fatty acids or to decrease the amount of saturated fat. We recommend Akosun for this application, as it is very low in saturated fat and high in monounsaturated fat.

**Cultured milk products**

Yoghurt is one example of products that can be made by recombination using a suitable vegetable fat together with skimmed milk, or dry ingredients and water. This is especially useful for high-fat creamy dessert yoghurts. Akoblend, Akosun or other special nutritional blends are used for this application. Yoghurts with specific health claims, functional food, may be formulated combining above mentioned fats together with specific formulated products from AAK.

**Dairy desserts**

Milk and cream based desserts, like mousse and puddings, can be made from a vegetable fat based milk emulsion. The fat influences the rheological properties, like viscosity, of the dessert as well as contributing to the desired sensory profile.

**Ice-cream**

AAK’s range of speciality fats for ice-cream is called Akomix. The Akomix products are refined to the highest taste quality. This is of utmost importance in ice-cream, where off-flavours originating from fat can not be hidden. They have the correct balance between solid and liquid fat at different temperatures to be able to replace dairy fat with a maintained nice, creamy consistency and eating properties of the ice-cream.

The Akomix products differ from most other vegetable ice-cream fats with their unique, nutritional profile. It means that the amount of saturated fat and trans fatty acids is reduced and the content of mono- and polyunsaturated fatty acids is increased. This composition improves also the properties of the ice-cream as well as reduced shrinkage and improved melting resistance.

**Condensed milk**

Sweetened condensed milk is mainly used for industrial purposes. Production of confectionery, ice-cream and baby food are some examples. It is also used as drinking milk. The products are made by recombination of skimmed milk powder, sugar, water and fat. The fat can be either vegetable fat or butter oil. The Akoblend range is used for this application.

**Milk and cream powder**

Powdered dairy products, such as whole milk and cream powder, can also be made from vegetable fat. An emulsion, based on milk raw material and vegetable fat, is spray dried in the same way as when making dairy milk powder. The fat content in the emulsion recipe is calculated from the requirements of fat content in the final product. The Akoblend and the Akotop products are suitable for these applications. The vegetable fat can also be selected according to requirements regarding the final application of the powder.
Vegetable oils and fats – some basics

Vegetable oils and fats are extracted from oil-containing seeds, beans or nuts. Vegetable oils and fats consists of 100 % fat, without any water, in contrast to butter, which normally contains 80-83 % fat and 16 % water.

Vegetable fats and milk fats have basically the same chemical structure. They are triglycerides with a glycerol molecule linked to three fatty acids (figure 1). However, most vegetable oils and fats differ from milk fat in composition, since they do not contain any significant amounts of short chain fatty acids. The chain length and the degree of unsaturation of these fatty acids are characteristic for the individual fats. The more unsaturated and/or more short chain fatty acids the fat contains, the lower the melting point of a fat. Vegetable fats contain tocopherols (Vitamin E), which are natural antioxidants found mainly in vegetable sources.

There are three different groups of analyses used to characterise a fat:
- **Identification**
- **Physical properties**
- **Degree of oxidation**

**Identification**

Iodine value, refractive index and gas chromatography (GC) are methods used to identify a fat.
- **Iodine value** gives a measure of the degree of unsaturation. The higher the value the more unsaturated fatty acids the fat contains.
- **Refractive index** is characteristic for each fat.
- **Fatty acid composition** is determined by gas chromatography and specifies the different fatty acids in a fat.

**Physical properties**

The physical properties of a fat are determined by its composition in combination with its thermal history, described by the polymorphic behaviour (figure 2).
- **Solid fat content, SFC**, measures the ratio between solid and liquid fat at different temperatures. Data like hardness, heat resistance and melting off properties can be described from these analyses (figure 3).
- **Melting point** is determined according to different standardised methods. These can give different values since fats are melting within an interval and have no distinct melting point.

**Degradation of fats**

Oxidation and hydrolysis are the two main reactions in fat degradation. Hydrolysis will occur in the presence of water. Fatty acids and mono- and diglycerides are formed. The longer fatty acid chains from vegetable oils do not give rise to off-tastes. An exception is lauric fats (e.g. coconut and palmkernel oil) where free lauric fatty acids (C-12) develop an unpleasant soapy taste.

In the oxidation process, oxygen is added to a double bond in an unsaturated fatty acid. The more unsaturated a fat is the more sensitive it is to oxidation. Oxidation of fats result in development of unpleasant off-tastes. There are mainly four environmental factors that increase the rate of fat oxidation:
- **Heat**
- **Light**
- **Oxygen from the air**
- **Trace metals copper and iron**

The degradation of fats is measured with chemical and sensory methods.
- **Peroxide value** gives the amount of primary oxidation products.
- **Oxidation stability index**, measured for example by the rancimat method, is an indication of the ability of a fat to withstand oxidation. It can be measured at different temperatures. The most frequent are 110 and 120°C.
- **Free fatty acids, FFA** shows the amount of free fatty acids.
- A **Sensory test** is used for the final and decisive control before a fat is ready for delivery to customers. This test is performed by a panel that is specially trained for these kind of tests. A bland flavour in the fats is particularly important when replacing milk fat with vegetable fat.

**Handling of fats**

There are different matters to consider in the handling of fats. Oxidative deterioration is the main risk to be aware of. However, properly handled fats can be stored for a long time. Unlike many food products, for instance cream and butter, vegetable fats have not any micro-biological activity, as they do not contain any water. For the same reason, hydrolysis of vegetable fat is normally not a problem. Melted fat should be stored at 10-15°C above the melting point of the fat. Solid fat packed in boxes or drums should be stored cool (room temperature or below) in an odourless place.
Vegetable oils and fats – some basics

Fig. 1  Triglyceride

- glycerol
- saturated fatty acid
- monounsaturated
- polyunsaturated

Fig. 2  Polymorphic behaviour of fats

Fig. 3  Solid Fat Content

- Hardness
- Heat Resistance
- Melting of properties

Temperature (°C)

Solid fat content (%)
Recipes

Recipes for producing 1000 kg of 45+ semi hard cheese

**Ratio vegetable fat/milk fat 50/50**

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Milk standardised to 1.5% fat</td>
<td>985 kg</td>
</tr>
<tr>
<td>Akoroma</td>
<td>15 kg</td>
</tr>
<tr>
<td>Starter</td>
<td>Acc. to suppliers recommendations</td>
</tr>
<tr>
<td>Rennet</td>
<td>Acc. to suppliers recommendations</td>
</tr>
<tr>
<td>CaCl₂ + NaCl</td>
<td></td>
</tr>
<tr>
<td>Brine salted</td>
<td></td>
</tr>
</tbody>
</table>

**Procedure:**

Heat Akoroma to 55°C. Heat 100-200 kg milk to 55°C. Add Akoroma to the milk while agitating. Sufficient agitation to emulsify the fat and avoid separation is important, but also not to agitate so much that air is incorporated into the emulsion. The addition of fat should be slow. Homogenisation at low pressure. The suitable homogenisation pressure varies from equipment to equipment. An alternative can be to circulate with a centrifugal pump. HTST pasteurisation 72°C 15 sek. Normal cheese making procedure.

Recipes for producing 1000 kg of butter-blend

**Ratio vegetable fat/butter fat 40/60**

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cream (40 % fat)</td>
<td>1200 kg</td>
</tr>
<tr>
<td>Skimmed milk</td>
<td>480 kg</td>
</tr>
<tr>
<td>Akoblend</td>
<td>320 kg</td>
</tr>
</tbody>
</table>

The melted Akoblend is dispersed into the mixture of cream and skimmed milk, pasteurised and cooled. After maturing for 4-16 hours the blend cream is churned.

**Ratio vegetable fat/butter fat = 90/10**

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cream (40 % fat)</td>
<td>200 kg</td>
</tr>
<tr>
<td>Skimmed milk</td>
<td>1080 kg</td>
</tr>
<tr>
<td>Akoblend</td>
<td>720 kg</td>
</tr>
<tr>
<td>Butter flavour</td>
<td></td>
</tr>
</tbody>
</table>

The melted Akoblend is dispersed into the skimmed milk, homogenised, pasteurised, cooled and then mixed with cream. After maturing for 4-16 hours the cream blend is churned.

Recipes for producing 1000 kg of soured cream with 20 % fat

**Ratio vegetable fat/milk fat 75/25**

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Akoblend</td>
<td>150 kg</td>
</tr>
<tr>
<td>Cream (40 % fat)</td>
<td>125 kg</td>
</tr>
<tr>
<td>Skimmed milk powder</td>
<td>15 kg</td>
</tr>
<tr>
<td>Stabiliser*</td>
<td>4.8 kg</td>
</tr>
<tr>
<td>Skimmed milk</td>
<td>702-706 kg</td>
</tr>
</tbody>
</table>

**Procedure:**

Dry mixed skimmed milk powder and stabilisers are added to skimmed milk while agitating. After a non-agitated hydration period the milk is heated to 60°C. Melted Akoblend is carefully added at the same temperature while agitating continuously. Dairy cream (40°C) is blended into the emulsion. Homogenisation at 150/50 bar is followed by heat treatment at 90-95°C for 3-5 min. Fermantation is carried out at 18-23°C until pH 4.5. The soured cream is cooled, packed, and kept in cold storage before distribution.

*For example modified starch, guar gum, or/and pectin. Stabilisers to be used according to instructions from the supplier.

Recipes for producing 1000 kg of whipping cream

**Oil phase:**

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Akotop</td>
<td>300 kg</td>
</tr>
<tr>
<td>Emulsifier (monoglyceride, lactylated monoglyceride, lecithin)</td>
<td>10 kg</td>
</tr>
<tr>
<td>Colouring agent (beta-carotene, 30 %-solution)</td>
<td>0,02 kg</td>
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</table>

**Water phase:**

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Skimmed milk</td>
<td>684 kg</td>
</tr>
<tr>
<td>Stabiliser*</td>
<td>6 kg</td>
</tr>
</tbody>
</table>

**Procedure:**

Stabilisers are added to heated (40-60°C) skimmed milk while agitating. Let the stabiliser hydrate. Melted Akotop with added emulsifier and colouring agent is then carefully pumped into the milk at the same temperature while agitating continuously. Sterilise 4 sec at 137°C, cool to 75°C. Homogenisation at 150 bar or in two stages at 150/30 bar. Cool rapidly to below 10°C. Keep the whipping cream cool for at least 10 h before whipping.

*For example guar gum, carrageenan. Stabilisers to be used according to instructions from the supplier.
AarhusKarlshamn
– wherever you are

Head office
AarhusKarlshamn AB
World Trade Center
Skeppsrgatan 19
SE-211 19 Malmö
Sweden
Telephone: +46 40 627 83 00
Fax: +46 40 627 83 11
E-mail: info@aak.com
www.aak.com

Production and Sales
AarhusKarlshamn USA Inc.
131 Marsh Street
Port Newark
NJ 07114
USA
Telephone: +1 973 344 1300
Fax: +1 973 344 9049

AarhusKarlshamn México S.A. de C.V.
Av. Héroes de Nocupetaro 1022
Col. Industrial, C.P. 58130
Morelia, Michoacan
Mexico
Telephone: +52 443 312 0175
Fax: +52 443 312 5822

AarhusKarlshamn Latin America
Camino al Paso de la Arena 2460
12600 Montevideo
Uruguay
Telephone: +5 982 313 513 5203
Fax: +5 982 313 5075

Sales offices
Unit 19A-10-2 Wisma UOA
19 Jalan Pinang
50450 Kuala Lumpur
Malaysia
Telephone: +60 327 108 493
Fax: +60 327 108 496

AarhusKarlshamn Australia Pty Ltd
4 Endeavour Close
Castle Hill
NSW 2154
Australia
Telephone: +61 288 503 522
Fax: +61 288 503 422

AarhusKarlshamn Croatia
Praska 8
10000 Zagreb
Croatia
Telephone: +38 514 873 872
Fax: +38 514 873 875

AarhusKarlshamn Czech Republic Spol. s r.o.
P.O. Box 263
Visiting address: Vaclavské nám. 64
CS-111 21 Prague 1
Czech Republic
Telephone: +420 222 210 406
Fax: +420 222 212 087

AarhusKarlshamn do Brasil
Desenvolvimento de Negocios Ltda.
Alameda Rio Negro 585
06454-000 Alphaville, Barueri
Sao Paulo
Brazil
Telephone: +55 11 121 352135
Fax: +55 11 121 352100

AarhusKarlshamn Hongkong
Representative Office
1/F, House No. 166
20 Tai Wai, Shatin
New Territories
Hong Kong
Telephone: +852 9029 3338
Fax: +852 2604 4469

AarhusKarlshamn Kiev
Representative office
Pavlo Taranenko
Telephone +380 503 814 480
E-mail: pavlo.taranenko@aak.com

AarhusKarlshamn Poland Sp. z o.o
ul. Walecznych 44/3
PL-03-916 Warszawa
Poland
Telephone: +48 226 164 182
Fax: +48 226 160 255

AarhusKarlshamn Russia ZAO
Zemlyanoy Val 54, Office 2
109004 Moscow
Russia
Telephone: +7 495 748 6000
Fax: +7 495 748 6001

For further information
visit www.aak.com or e-mail info@aak.com