

Principles of Food Dehydration

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ABSTRACT

The basic principles involved in the food dehydration are reviewed. Major emphasis is placed on types of water held in foods, heat of vaporization of water in food product, equilibrium moisture and water activity relationship and dehydration rate mechanism.

In general, food dehydration refers to removal of moisture from a food product. There are many objectives for dehydration of food products. Preservation of food through dehydration is the most evident one. By reducing the moisture content of the product, the dehydration process makes it possible to limit microbial growth or other reactions. In addition to preserving the food from a microbiological standpoint, this process also enables preservation of its flavor and nutritional characteristics. Another obvious objective of dehydration is the significant reduction in product volume, which promotes efficiency in transportation and storage of the food product (6).

Dehydration of food is accomplished by a thermal process that uses heat to remove the moisture held in the food product. The delicate characteristics of food require skillful operation and design of the dehydration system to maintain the optimum quality of the product. Therefore, a thorough understanding of the principles of dehydration is necessary.

Many different types of dehydrators are used in the food industry. These have been developed to meet the rather special dehydration characteristics of specific food products. The objective of this paper is to review the basic principles involved in the food dehydration.

MOISTURE IN FOODS

Basically, water may be held in a food product in two distinct ways (5). Some water may be held in the interstitial spaces and within the pores of the material by purely physical force related to surface tension. This type of water is called "unbound water." It exerts the same vapor pressure and possesses the same latent heat of

vaporization as does pure water at the same temperature. The amount of unbound water in a food product is more closely related to the physical structures of the product than to the chemical structures of the product.

Another portion of water may be held on the internal and external surfaces of the solid material by interactions between the water molecules and those of the solid material to form a mono-layer of water molecules. Some water may be held by interactions between the water molecules to form a multi-layer of water molecules. This type of water is called "bound water," which exerts a vapor pressure less than that of pure water at the same temperature. Also, the heat of vaporization for bound water is greater than that of pure water at the same temperature. The amount of bound water held in a food product is closely associated with the chemical structures of the product. The intermolecular forces known as "van der Waals" forces are responsible for holding water on sorption sites on the adsorbent. In general, polar molecules such as H_2O , NH_3 and alcohol, or molecules possessing the following polar groups $-NH_2$, $-NH-$, $-OH$, $-COOH$, $-CONH_2$, etc., are considered to be sorptive sites on adsorbent.

Free moisture refers to the moisture contained by a product in excess of the equilibrium moisture content of a product. Only the free moisture in a product can be removed during a given dehydration process. The free moisture of a product depends upon the type of product, and temperature and water vapor concentration in the air.

The bound water in a food product is removed with a certain degree of difficulty during a dehydration process. A plot of the heat of desorption with respect to the moisture content of a product (6) would describe approximate ranges of both bound and unbound water in a product, based on the value of the heat of desorption. The heat of desorption also indicates the binding energy or the inter-molecular forces between water molecules and the surface of the adsorbent, and between adsorbed water molecules and molecules of water vapor. The energy required to evaporate the unbound water (above 23% moisture, d.b.) in corn starch is almost the same as the heat of vaporization of pure water. However, the energy required to evaporate the

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