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DESCRIPTION

REFERENCE TO A SEQUENCE LISTING

[0001] This application contains a sequence listing in computer readable form. The computer readable form is incorporated herein by reference.

TECHNICAL FIELD OF THE INVENTION

[0002] The invention relates to a process for the production of a brewer's wort, comprising an enzymatic treatment of a grist comprising up to 100% unmalted (grain) form, and further relates to the wort obtainable by the process.

[0003] The invention further relates to the use of said wort for the further processing into high quality beverage products and relates to a process for the production of a high quality beer or beer product.

BACKGROUND OF THE INVENTION

[0004] Mashing is the process of converting starch from the milled barley malt and adjuncts into fermentable and unfermentable sugars to produce wort of the desired composition. Traditional mashing involves mixing milled barley malt and adjuncts with water at a set temperature and volume to continue the biochemical changes initiated during the malting process. The mashing process is conducted over a period of time at various temperatures in order to activate the endogenous enzymes responsible for the degradation of proteins and carbohydrates. After the mashing process the mash is filtered to obtain the wort for the fermentation to beer. Traditionally, beer has been brewed from malted barley, hops, yeast and water. Malting cereals such as barley activate the endogenous enzymes necessary for degradation of the starch. However, the malting process is energy and time-consuming and thereby rather costly. Thus, one way to reduce costs is to substitute some of the malt with readily available adjuncts such as refined starch or readily fermentable carbohydrates and/or substituting with unmalted cereals, such as barley corn, rice, sorghum, and wheat. However, unmalted cereals lack endogenous enzymes, which may result in incomplete saccharification, increased mash/wort viscosity, lautering difficulties, poor fermentability, beer filtration difficulties, colloidal instability and poor flavour. Exogenous enzymes such as alpha-amylase and β -glucanase have previously been added to compensate for the lacking malt enzymes. The following prior art describes the substitution of part of the malted cereals with unmalted cereals and exogenously added enzymes.

[0005] ZA9803237 describes a process for producing a beer by fermenting a wort obtained from partly unmalted barley and an enzyme blend of alpha-amylase, β -glucanase and proteinase. Wieg et.al. Process Biochemistry, 1970 also describes a process for brewing with a mixture of malted and unmalted barley and an enzyme blend of alpha-amylase, β -glucanase and proteinase. Further WO04/011591 describes a process for producing a wort adding a protease and a cellulase to a mash from malted and unmalted barley. A resume of barley brewing is given by Wieg et.al. Brewing science, 1987.

[0006] Another way to produce wort is known from the Japanese Happoshu beers. In Japan, taxes on malt-containing alcohol beverages are relatively high, which is why Happoshu beers are brewed with as less as 25% malted barley. Usually, mash prepared on such a low content of malt is impossible to filter in order to obtain the wort, as the mash is too thick for filtering. There are only few technical descriptions available concerning the composition of the Happoshu mash. However, it is known that it is necessary to add exogenous enzymes to the mash in order to obtain filterability, e.g. proteinases, β -glucanase and amylases. The Happoshu beers have different flavor characteristics even compared to traditional beers of the more plain lager type. JP 2004173533 describes the production of such a beer with use of pressed barley and lesser amount of malt. Different enzymes are used to aid e.g. saccharification.

[0007] The wort obtained in the prior art references are based on grist comprising considerable amount of malt. The enzyme composition in raw cereals is substantially different from malted cereals and the endogenous and the exogenous enzymes involved in the degradation of starch are working together in a complex manner during mashing and it is generally assumed that some malt should be present in the grist. Thus even with exogenously added enzymes some of the above mentioned problems e.g. with filterability, fermentability and turbidity of worts based on unmalted cereals still exists. Consequently, very few attempts have been made to substitute larger amount or all of the malted cereals with unmalted cereals.

[0008] One example is Goode et.al. describing the production of a wort from 100 % raw barley substrate and an enzyme blend of two different alpha-amylases and a beta-glucanase. Alpha amylase has a positive effect on mash separation, but the speed of filtration dropped when high amounts of unmalted barley were present. Also in US 3081172 producing a wort from unmalted raw material is suggested however nothing is mentioned about FAN (Free Amino Nitrogen), the amount of fermentable sugars and other crucial parameters of the resulting wort.

[0009] Consequently, problems such as low fermentability, non optimal amino acids composition and high viscosity and turbidity of the wort are not solved and these obstacles tend to increase with increasingly amounts of unmalted cereals.

[0010] Another disadvantages with the prior art brewing with unmalted cereals is that prolonged mashing time may be needed in order for the exogenous and endogenous enzymes in the mash produce a wort which is comparable e.g. with regards to fermentability to a wort produced from malted cereals. The prolonged mashing time is clearly uneconomic and may neutralize the economical advantages of substituting malted with unmalted cereals.

[0011] Thus until now no enzyme blend has fully compensated the malt enzymes, such that it when adding together with up to 100 % unmalted cereals could fully substitute for a grist based on malted cereals.

[0012] Thus even though producing wort from barley has been attempted since the late 1960 no real brewing process based on raw material from high amount of unmalted cereals has been developed.

[0013] In the light of a desire to reduce the costs related to malting of cereals, and further to obtain a wort suitable for producing a beer comparable in taste characteristics to traditional beers, there exists a need for a method to obtain a mash based on up to 100% unmalted cereals. The process should be easily adaptable to the brewing systems used in brewing based malted raw material. Thus the mash should be filterable and in addition other parameters such as the amino acid composition and amount of fermentable sugars should be comparable to mash based on the corresponding malted cereals even if the cereal(s) is/are 100% unmalted cereal(s). Finally, the mashing time should be comparable to that of mashing of malted raw material while still retaining the good characteristics e.g. the sugar profile of the mash and the beer product.

[0014] Thus, it is an object of the invention to develop a process for producing a wort from a grist comprising at least 70%, and even up to 100%, unmalted cereals.

SUMMARY OF THE INVENTION

[0015] The inventors of the present invention have surprisingly found that by addition of a suitable combination of exogenous enzymes to the mash, and by thermal activation/inactivation of endogenous enzymes, it is now possible to obtain a wort based on up to 100% unmalted cereals, such as barley.

[0016] A process for the production of a brewer's wort, comprising:

1. a. obtaining a mash by mashing a grist, of which at least 70wt% is unmalted cereal(s) comprising β -amylase activity and of which less than 30wt% is malted cereal(s), at a temperature at which exogenous (added) enzymes and the endogenous β -amylase are active;
2. b. contacting the mash with exogenous enzymes comprising:
 1. i. an α -amylase,
 2. ii. a pullulanase,
 3. iii. a protease,
 4. iv. a β -glucanase,
 5. v. a lipase, and
 6. vi. a xylanase;
3. c. mashing-off and filtering the mash to obtain the wort.

[0017] In a preferred embodiment, the unmalted cereal(s) are of the tribe *Triticeae*, e.g. barley, spelt, wheat, rye.

In another embodiment the unmalted cereal(s) are any unmalted cereal(s), such as but not limited to barley, spelt, wheat, rye, corn, oat or rice or any mixture thereof. Thus in another embodiment of the invention the grist comprises a mixture of unmalted

cereals, such as but not limited to a mixture of unmalted barley and unmalted wheat, a mixture of unmalted rice and unmalted barley.

[0018] In one embodiment, the invention relates to a process, where the grist further comprises other carbohydrate sources, such as brewing syrups or any mixture thereof.

[0019] In another embodiment, the exogenous enzymes of step b. above further comprise a phytase.

[0020] In a preferred embodiment, the mashing temperature is in a range optimizing the β -amylase activity and reducing the lipoxygenase activity.

[0021] A preferred embodiment of the invention concerns a process where the pullulanase is thermostable having a relative enzyme activity above 60% over a period of 30 min, at 65 °C and at pH level 5.

[0022] Further disclosed is a wort produced by the process of the invention. Furthermore, the invention relates to the use of the wort for the production of beers of any type, e.g. light and dark lager types, light and dark ale types, wheat beers, all porter, stout, ice concentrated (eg. eisbock), barley wine types or happoushu.

[0023] The wort produced comprises one or more amino acids selected from

1. a. proline at a concentration at less than 2 mM, preferably less than 1 mM, and most preferably less than 0.5 mM in the wort;
2. b. serine at a concentration above 0.1 mM, preferably above 0.125 mM, and most preferably above 0.15 mM; and
3. c. methionine at a concentration above 0.05 mM, preferably above 0.08 mM, and most preferably above 0.10 mM.

[0024] Further disclosed is an enzyme mixture comprising;

1. i. an α -amylase activity,
2. ii. a pullulanase activity, wherein the pullulanase is thermostable
3. iii. a proteolytic activity, and
4. iv. a β -glucanase activity;

an enzyme mixture comprising;

1. i. an α -amylase activity,
2. ii. a pullulanase activity,
3. iii. a proteolytic activity,
4. iv. a β -glucanase activity; and
5. v. a xylanase activity.

[0025] The enzyme mixture further comprises lipase activity.

FIGURES

[0026]

Figure 1 shows the turbidity (NTU) of a wort produced from increasingly amount of barley when only Ultraflo Max is exogenously added.

Figure 2 shows the fermentability of a wort produced from 100 % unmalted barley or 100 % malted barley.

DEFINITIONS

[0027] Throughout this disclosure, various terms generally understood by persons skilled in the art are used. Several terms are used with specific meanings, however, and are meant as defined by the following.

[0028] The term "malting" is a process whereby grains are made to germinate and are then dried.

[0029] The term "malted grain" is understood as any cereal grain, in particular barley, which has been subjected to a malting process.

[0030] The term "unmalted grain" is understood as any cereal grain, in particular barley, which has not been subjected to a malting process. The terms unmalted and non-malted could be used interchangeably in the present context.

[0031] The term "grist" is understood as the starch-containing or sugar-containing material that is the basis for beer production. It may include malted and unmalted cereal as well as adjunct.

[0032] The term "cereals" is understood as grains which are any starch containing material used as raw material e.g. for production of beer such as, but not limited to, barley, wheat, sorghum, maize, rice, oat and rye. The cereals may be malted or unmalted.

[0033] The term "adjuncts" is usually understood as raw material which may be added to the main ingredient of the grist, which traditionally are malted cereals. Thus since the unmalted grains usually only comprises a small part of the grist, unmalted cereals is typically defined as an adjunct together with liquid carbohydrates such as sugars and syrups. The adjuncts could be either solid or liquid or both, where the solid part may be unmalted cereals, such as barley, corn and rice whereas the liquid part may be readily fermentable carbohydrates such as sugar and syrups.

[0034] In this context however, what might be regarded as adjunct maybe the main ingredient. Thus unmalted cereals which in a traditional context are an adjunct may according to the present invention comprise 100 % of the raw material.

[0035] Accordingly, unmalted cereals is usually comprised in the term adjunct however since the unmalted cereals preferably comprise more than 70 % of the raw material and the malted cereals preferably is less than 30 % of the raw material the terms are in this contexts most easily understood as:

[0036] The grist may comprise malted and unmalted cereals and adjuncts. Adjuncts are in this context understood as the part of the grist which is not malted or unmalted cereal. Thus the adjuncts according to the present invention are preferably the liquid part such as brewing syrups and sugars.

[0037] Whereas unmalted cereals is any cereal not malted, thus any starch containing grains such as, but not limited to, barley, corn, rice, rye, oats, sorghum and wheat. Accordingly grist from 100 % unmalted grains may comprise unmalted barley and other non barley unmalted cereals such as rice and wheat.

[0038] In another embodiment of the invention the grist comprises a mixture of unmalted cereals, such as but not limited to a mixture of unmalted barley and unmalted wheat, a mixture of unmalted rice and unmalted barley. Thus the grist may comprise 50 % unmalted barley and 50 % unmalted other cereals, such as wheat and rice.

[0039] In a specially preferred embodiment of the invention the unmalted cereal(s) comprises more than 70% of the grist and the malted cereals comprise less than 30% of the grist.

[0040] The term "mash" is understood as a starch-containing slurry comprising crushed barley malt, other starch-containing material, or a combination thereof, steeped in water to make wort.

[0041] The term "mashing process" or mashing profile or simply mashing is understood as the process of combining grains with water and heating the mixture up with rests at certain temperatures to allow the enzymes in the mash to break down the starch in the grain into sugars, to create a wort.

[0042] "mashing off" or mashing out is when the temperature of the mash is raised. This frees up about 2% more starch, and makes the mash less viscous.

[0043] The term "wort" is understood as the unfermented liquor run-off following the extraction of the grist during mashing. The

terms brewers wort and wort is used interchangeably through out the application.

[0044] The term "spent grains" is understood as the drained solids remaining when the grist has been extracted and the wort separated.

[0045] The term "beer" is here understood as a fermented wort.

[0046] The term "beer product" is here understood as comprising "mash", "wort", "spent grains" and "beer".

[0047] The term "DP1" means glucose.

[0048] The term "DP2" means maltose.

[0049] The term "DP3" means maltotriose.

[0050] The terms "DP4+" or "DP4/4+" mean dextrin, or maltooligosaccharides of a polymerization degree of 4 or higher.

[0051] The term "Fru" means fructose.

[0052] The term "RDF" means real degree of fermentation.

[0053] The term "FAN" means free amino nitrogen.

[0054] The term "Plato" (°P) means grams extract pr 100 g wort (gram extract/100 g wort).

DETAILED DESCRIPTION OF THE INVENTION

[0055] By the addition of a combination of exogenous enzymes, e.g. α -amylase, isoamylase/pullulanase, FAN generating activity (proteases) and filterability promoting activities (beta-glucanase and/or xylanase), to the mash and by the simultaneous thermal activation of the maltose-generating endogenous β -amylase, it is possible to obtain a wort based on up to even 100% unmalted cereal(s).

[0056] Thus, in a first aspect, the invention relates to a process for the production of a brewer's wort, comprising:

1. a. obtaining a mash by mashing a grist, of which at least 70wt% is unmalted cereal(s) comprising β -amylase activity and of which less than 30wt% is malted cereal(s), at a temperature at which exogenous (added) enzymes and the endogenous β -amylase are active;
2. b. contacting the mash with exogenous enzymes comprising:
 1. i. an α -amylase,
 2. ii. a pullulanas,
 3. iii. a protease,
 4. iv. a β -glucanase,
 5. v. a lipase, and
 6. vi. a xylanase;
3. c. mashing-off and filtering the mash to obtain the wort.

[0057] In a preferred aspect, the invention relates to a process, where the grist comprises at least 70wt% unmalted cereal(s), such as at least 75wt%, more preferably at least 80wt%, more preferably at least 85wt%, more preferably at least 86wt%, more preferably at least 87wt%, more preferably at least 88wt%, more preferably at least 89wt%, more preferably at least 90wt%, more preferably at least 91wt%, more preferably at least 92wt%, more preferably at least 93wt%, more preferably at least 94wt%, more preferably at least 95wt%, more preferably at least 96wt%, more preferably at least 97wt%, more preferably at least 98wt%, even more preferably 99wt%, and most preferably 100wt% unmalted cereal(s).

[0058] It is to be understood that the at least 70 wt % unmalted cereal(s) may be one or more cereal(s) wherein at least one of the cereal(s) contain β -amylase activity.

[0059] In one aspect of the invention the grist comprises less than 30wt% malted cereals, more preferably less than 25wt%, more preferably less than 20wt%, more preferably less than 15wt%, more preferably less than 10wt%, more preferably less than 5wt% and even more preferably less than 3wt%, and most preferably the grist comprises 0 wt% malted cereals.

[0060] In a preferred embodiment, the unmalted cereal(s) are of the tribe *Triticeae*. Preferred within this tribe are barley, spelt, wheat and rye. *Triticeae* is a tribe within the *Pooideae* subfamily of grasses that includes genera with many domesticated species, EA Kellogg, R Appels, RJ Mason-Gamer - SYSTEMATIC BOTANY, 1996 . Major crop genera are found in this tribe including wheat, barley, and rye. In another preferred embodiment the grist comprises unmalted cereals other than from the *Triticeae* tribe, such as but not limited to rice, corn, oat, sorghum.

[0061] In another preferred embodiment the unmalted cereal(s) are selected from the group comprising barley, spelt, wheat, rye, corn, oat or rice or any mixture thereof.

[0062] Thus in one embodiment, the invention relates to a process, where the grist further comprises of one or more additional unmalted cereal(s) such as com grist, com starch and rice. The grist may therefore comprise a mixture of unmalted cereals, such as but not limited to a mixture of unmalted barley and unmalted wheat or a mixture of unmalted rice and unmalted barley.

[0063] In a particular preferred embodiment of the invention the unmalted cereal is barley.

[0064] In yet another aspect the grist further comprises 0- 50 wt% other carbohydrate sources, such as brewing syrups or any mixture thereof.

[0065] The exogenous xylanase of step b. above is preferably family GH10 (glycosyl hydrolase family 10) which may improve the filtration of wort and beer.

[0066] The exogenous lipase of step b. above may improve the wort filtration and reduce haze.

[0067] In another embodiment the exogenous enzymes of step b. above further comprise a phytase activity.

[0068] The mashing temperature, i.e. the temperature at which the exogenous (added) enzymes and the endogenous β -amylase are active, is in a range optimizing each of the different enzymes activity, at each heating step. The mashing process is preferably performed in three steps each optimized to the different enzymes. These steps may be referred to as enzyme rests or enzyme steps.

[0069] Thus a special aspect concerns the temperature profile of a mashing process for producing a brewers wort, wherein
A first step is carried out between 50 and 58 °C,
A second step is carried out between 60 and 65 °C, and
A third step is carried out between 70 and 80 °C.

[0070] The different enzymes in the mashing process both exogenous and endogenous have different temperature optimum and the mashing process may be run at different temperatures for a certain period of time in order to let the enzymes react. These periods is often referred to as enzyme rests.

[0071] In the first step, which might be termed the proteolytic step, the temperature is preferably within the range of optimising e.g. the proteolytic enzyme, the temperature is preferably between 45°C and 58°C, such as preferably between 46°C and 57°C, such as preferably between 47°C and 56°C, such as preferably between 48°C and 55°C, such as preferably between 49°C and 54°C, such as preferably between 50°C and 54°C, such as preferably between 51°C and 54°C, such as preferably between 52°C and 54°C, most preferably between 53°C and 54°C, such as 54°C.,

[0072] In the second step the temperature is preferably within the range of optimising e.g. the starch converting enzymes, such as the β -amylase and pullulanase. This step is often referred to as the saccharification step and the temperature is preferably between 60°C and 72°C, such as preferably between 60°C and 70°C, such as preferably between 62°C and 68°C, such as preferably between 63°C and 67°C, such as preferably between 64°C and 66°C, and most preferably between 64°C and 65 °C, such as 64°C.

[0073] In the third step, which also may be referred to as mashing off or mashing out, this frees up about 2% more starch, and makes the mash less viscous, allowing the lauter to process faster. The temperature of the mashing out is preferably between

72°C and 82°C, such as preferably between 73°C and 81°C, such as preferably between 74°C and 80°C, such as preferably between 75°C and 79°C, such as preferably between 76°C and 78°C, most preferably the temperature is between 78°C-80 °C, such as 80 °C.

[0074] Endogenous lipoxygenase is known to be a source of off-flavour, and in a preferred aspect the mashing temperature, in the first mashing step referred to above is in a range reducing the lipoxygenase activity with at least 50%, preferably 55%, preferably 60%, preferably 65%, preferably 70%, preferably 75%, preferably 80%, preferably 85% most preferably 90% relative to the activity at mashing at 54°C.

[0075] Also disclosed is an enzyme mixture comprising:

1. i. an α -amylase activity,
2. ii. a pullulanase activity, wherein the pullulanase is thermostable
3. iii. a proteolytic activity, and
4. iv. a β -glucanase activity;
or an enzyme mixture comprising;
5. v. an α -amylase activity,
6. vi. a pullulanase activity,
7. vii. a proteolytic activity,
8. viii. a β -glucanase activity; and
9. ix. a xylanase activity.

[0076] The enzyme mixtures may further comprise lipase activity.

[0077] The terms enzyme mixture and enzyme blend are used interchangeably in through out the application. The terms are to be understood as a mixture or blend of different enzymes or enzyme activities. The enzymes in the mixture or blend may be added in any order or together. The enzymes if not added together could be added in any order and is not necessarily added in the order listed above.

[0078] The enzymes could be added at anytime of the mashing or before mashing. Thus the enzymes may be added to the mash ingredients, e.g., the water and/or the grist before, during or after forming the mash. The enzymes may be added together or separately.

[0079] In a preferred aspect, the α -amylase activity is provided by an α -amylase of fungal origin, e.g. from *Aspergillus niger*, or bacterial origin, e.g. *Bacillus*. Thus the α -amylase might be a bacterial α -amylase variant having increased thermo stability at acidic pH and/or low Ca^{2+} concentration. Preferably, the α -amylase activity in the mash is 0.1-1.0 KNU(S)/g, more preferably 0.2-0.4 KNU(S)/g, and most preferably 0.25-0.35 KNU(S)/g dry weight cereal(s). Preferably the α -amylase has at least 50%, more preferably at least 60%, more preferably at least 70%, more preferably at least 80%, preferably at least 85%, more preferably at least 90%, preferably at least 91%, preferably at least 92%, preferably at least 93%, preferably at least 94%, more preferably at least 95%, preferably at least 96%, preferably at least 97%, more preferably at least 98%, and most preferably at least 99% identity to the amino acid sequence shown in SEQ ID NO:1 (a variant of the *B. stearothermophilus* α -amylase with the mutations I181* G182* N193F, described in WO99/19467 and available as Termamyl[®] SC from Novozymes A/S).

[0080] In a preferred embodiment of the invention, the starch debranching activity is provided by a pullulanase. It is further disclosed that the debranching activity is provided by other debranching enzymes such as but not limited to an isoamylase or limit dextrinase. In a certain embodiment of the invention the debranching activity is provided by a mixture of debranching enzymes such as but not limited to a pullulanase and an isoamylase.

[0081] Thus in a preferred embodiment of the invention, a pullulanase (E.C. 3.2.1.41) enzyme activity is exogenously supplied and present in the mash. The pullulanase may be added to the mash ingredients, e.g., the water and/or the grist before, during or after forming the mash.

[0082] The pullulanases according to the present invention is preferably pullulanase from e.g. *Pyrococcus* or *Bacillus*, such as *Bacillus acidopullulyticus* e.g. the one described in FEMS Microbiol. Letters 115: 97-106, or pullulanase is available from Novozymes as Promozyme 400L and having the sequence showed in SEQ ID NO: 2. The pullulanase may also be from *Bacillus naganocensis*, or *Bacillus deramificans* e.g. such as derived from *Bacillus deramificans* (US Patent 5,736,375) and having the

sequence showed in SEQ ID NO: 7. The pullulanase may also be an engineered pullulanase from, e.g. a *Bacillus* strain.

[0083] Other pullulanases may be derived from *Pyrococcus woesei* described in PCT/DK91/00219, or the pullulanase may be derived from *Fervidobacterium* sp. *Ven 5* described in PCT/DK92/00079, or the pullulanase may be derived from *Thermococcus celer* described in PCT/DK95/00097, or the pullulanase may be derived from *Pyrodictium abyssi* described in PCT/DK95/00211, or the pullulanase may be derived from *Fervidobacterium pennavorans* described in PCT/DK95/00095, or the pullulanase may be derived from *Desulfohalobium mucosus* described in PCT/DK95/00098.

[0084] Most preferably the pullulanase is derived from *Bacillus acidopullulyticus*. A preferred pullulanase enzyme to be used in the processes and/or compositions of the invention is a pullulanase having an amino acid sequence which is at least 50%, such as at least 55%, such as at least 60%, such as at least 65%, such as at least 66%, such as at least 70%, such as at least 75%, such as at least 80%, such as at least 85%, such as at least 86%, such as at least 87%, such as at least 88%, such as at least 89%, such as at least 90%, such as at least 91%, such as at least 92%, such as at least 93%, such as at least 94%, such as at least 95%, such as at least 96%, such as at least 97%, such as at least 98%, such as at least 99% or even 100% identical to the sequence shown in SEQ ID NO:8 (NS26062, PulC, from *Bacillus acidopullulyticus*); in particular when aligned using the Program Needle using Matrix BLO-SUM62; Gap initiation penalty: 10.0; Gap extension penalty: 0.5; Gapless Identity Matrix. The terms Pul C, NS26062 and pullulanase C is used interchangeably throughout the application.

[0085] The pullulanase is added in dosage of 0.1 to 3 PUN/g DM, such as 0.2 to 2.9, such as 0.3 to 2.8, such as 0.3 to 2.7 such as 0.3 to 2.6 such as 0.3 to 2.5 such as 0.3 to 2.4, such as 0.3 to 2.3, such as 0.3 to 2.2, such as 0.3 to 2.1, such as 0.3 to 2.0, such as 0.3 to 1.9, such as 0.3 to 1.8, such as 0.3 to 1.7, such as 0.3 to 1.6, most preferably pullulanase is added in dosage such as 0.3 to 1.5, preferably 0.4 to 1.4, more preferably 0.5 to 1.3, more preferably 0.6 to 1.2, more preferably 0.7 to 1.1, more preferably 0.8 to 1.0, more preferably 0.9 to 1.0. In a particular embodiment of the invention the enzyme is added in 0.3 PUN/g DM, such as 0.4 PUN/g DM, such as 0.5 PUN/g DM in a particularly preferred embodiment of the invention the enzymes dose is not larger than 1 PUN/g DM. Preferably the isoamylase or/and pullulanase activity in the mash is 0.1-2.0 PUN/g, more preferably 0.5-1.0 PUN/g dry weight cereal(s).

[0086] The relative activity of the debranching enzymes, such as pullulanases, may vary considerably at different temperatures e.g. as demonstrated in example 2 of the application. The debranching enzymes are working together with the other enzymes in the mash, in particular the β -amylase, which is usually endogenous and the α -amylase which may be endogenous or exogenously added. Thus a preferred debranching enzyme according to the invention is an enzyme having high relative enzyme activity in the temperature range at which both the β -amylase and the α -amylase is active. The α -amylase is usually active at a higher temperature than the β -amylase and the saccharification step of the mashing process, the step where the starch is converted into fermentable sugars by α -amylase, β -amylase and a debranching enzyme, is preferably run at a high temperature, such as at least 63 °C. Thus the debranching enzyme according to the invention is preferably thermostable and thermoactive. The terms thermostable and thermo active is used interchangeably throughout the application.

[0087] In this context a thermostable enzyme is an enzyme having a relative enzyme activity above 60% measured over a period of 30 min, at 65 °C and at pH level 5.

[0088] The relative activity, which in this context is the relative enzyme activity, is calculated by setting the highest activity to 100% (maximum) and setting the activities at other temperatures relative to the temperature maximum.

[0089] Thus preferably the debranching enzyme is a pullulanase and even more preferably the pullulanase activity is provided by a pullulanase which is thermostable having a relative enzyme activity above 60% over a period of 30 min, at 65 °C and at pH level 5. An example of a thermostable pullulanase is given in example 2.

[0090] In one embodiment the pullulanase relative enzyme activity is above 60%, such as above 61%, such as above 62%, such as above 63%, such as above 64%, such as above 65%, such as above 66%, such as above 67%, such as above 68%, such as above 69%, such as above 70%, such as above 71%, such as above 72%, such as above 73%, such as above 74%, such as above 75%, such as above 76%, such as above 77%, such as above 78%, such as above 79%, such as above 80%, such as above 81%, such as above 82%, such as above 83%, such as above 84%, such as above 85%, such as above 86%, such as above 87%, such as above 88%, such as above 89%, such as above 90%, such as above 91%, such as above 92%, such as above 93%, such as above 94%, such as above 95%, such as above 96%, such as above 97%, such as above 98%, such as above 99% and even 100% at 65°C, when measured over a period of 30 minutes, at pH 5.0.

[0091] In a particular preferred embodiment of the invention a thermostable pullulanase has a relative enzyme activity above

80% over a period of 30 min, at 65 °C and at pH level 5.

[0092] In a certain embodiment the pullulanase has above 80%, such as above 85%, such as above 90% such as above 95%, or even 100% remaining enzyme activity over a period of 30 min under mashing conditions with 12 °P barley, at gelatinization temperature of unmalted barley, and at pH in the range of 5.6-6.2, compared to the activity before incubation at the gelatinization temperature of unmalted barley.

[0093] In another embodiment the protease activity is provided by a proteolytic enzymes system having a suitable FAN generation activity including endo-proteases, exopeptidases or any combination hereof, preferably a metallo-protease. Preferably the protease activity in the mash is 0.0005-0.002 AU/g, more preferably 0.001-0.0015 AU/g dry weight cereal(s). Preferably, the protease has at least 50%, more preferably at least 60%, more preferably at least 70%, more preferably at least 80%, more preferably at least 85%, more preferably at least 90%, more preferably at least 91%, more preferably at least 92%, more preferably at least 93%, more preferably at least 94%, more preferably at least 95% more preferably at least 96%, more preferably at least 97% more preferably at least 98%, and most preferably at least 99% or even 100 % identity to the amino acid sequence shown in SEQ ID NO:3 (a metalloprotease from *Bacillus amyloliquefaciens*, described in WO9967370, available as Neutrase® from Novozymes A/S).

[0094] In a further embodiment, β -glucanase (E.C3.2.1.4.) activity is added to the mash. Preferably the β -glucanase activity in the mash is 0.1-1.5 FBG/g, such as 0.2-1.2 FBG/g, such as 0.4-1.0 FBG/g, such as 0.5-1.0 FBG/g dry weight cereal(s). β -glucanase is also termed cellulase and may be of fungal or bacterial origin. Such as from *Aspergillus oryzae*, *Aspergillus niger* or from bacillus such as *B subtilis*. The added β -glucanase activity may also origin from malt. In one particular preferred embodiment of the invention the β -glucanase is added together with xylanase in an enzyme blend termed Ultraflo Max. Ultraflo Max is an enzyme blend of Xylanase and β -glucanase, the blend is described in the application WO2005/059084 A1.

[0095] In another embodiment, the xylanase activity is provided by a xylanase from glycosyl hydrolase family 10. Preferably the xylanase activity in the mash is 0.02-0.1 FXU-S/g, more preferably 0.04-0.08 FXU-S/g dry weight cereal(s). Preferably, the xylanase has at least 50%, more preferably at least 60%, more preferably at least 70%, more preferably at least 80%, more preferably at least 85%, more preferably at least 90%, more preferably at least 91%, more preferably at least 92%, more preferably at least 93%, more preferably at least 94% more preferably at least 95%, more preferably at least 96%, more preferably at least 97% more preferably at least 98%, and most preferably at least 99% or even 100% identity to the amino acid sequence shown in SEQ ID NO:4 (described in WO 94/21785, available as Shearzyme® from Novozymes A/S).

[0096] In another embodiment, the lipase activity is provided by a lipase having activity to triglycerides and/or galactolipids and/or phospholipids. Preferably, the lipase activity is provided by a lipase from *Fusarium* (including *F. oxysporum* and *F. heterosporum*), *Aspergillus* (including *A. tubigensis*), *Rhizopus* (including *R. oryzae*) or *Thermomyces* (including *T. lanuginosus*) or a variant of these. An example is Lipopan X (Lipopan Xtra), a variant of the *Thermomyces lanuginosus* lipase with the substitutions G91A +D96W +E99K +P256V +G263Q +L264A +I265T +G266D +T267A +L269N +270A +271 G +272G +273F (+274S), described in WO2004099400A2. Preferably, the lipase has at least 50%, more preferably at least 60%, more preferably at least 70%, more preferably at least 80%, more preferably at least 85%, more preferably at least 90%, more preferably at least 91%, more preferably at least 92%, more preferably at least 93%, more preferably at least 94%, more preferably at least 95%, more preferably at least 96%, more preferably at least 97% more preferably at least 98%, and most preferably at least 99% or even 100 % identity to residues 1-316 or 1-273 of the amino acid sequence shown in SEQ ID NO:5 (lipase/phospholipase from *Fusarium oxysporum*, described in EP 869167, available from Novozymes A/S as Lipopan® F). Preferably, the lipase activity in the mash is 0-50 LU/g, such as 0-40 LU/g, such as 0-30 LU/g, such as 0-20 LU/g dry weight cereal(s). In a specially preferred embodiment of the invention the lipase is Lipozyme TL or lipolase, this lipase has a significantly good effect on filtration speed and haze reduction. Thus in a special preferred embodiment of the invention the lipase has at least 50 %, more preferably at least 60%, more preferably at least 70%, more preferably at least 80%, more preferably at least 85%, more preferably at least 90%, more preferably at least 91%, more preferably at least 92%, more preferably at least 93%, more preferably at least 94%, more preferably at least 95%, more preferably at least 96%, more preferably at least 97% more preferably at least 98%, and most preferably at least 99% or even 100 % identity to the amino acid sequence shown in SEQ ID NO 9. The lipase may also be Lipex, a variant of Lipozyme having at least 50%, more preferably at least 60%, more preferably at least 70%, more preferably at least 80%, more preferably at least 95%, more preferably at least 98%, and most preferably at least 99% or even 100 % identity to the amino acid sequence shown in SEQ ID NO: 10. The lipases degrade the lipid from barley e.g. the triglycerids into partial glycerides and free fatty acids. This leads to a lower turbidity and much improved mash filtration and lautering properties.

[0097] In another embodiment, the phytase activity is provided by a phytase from *Aspergillus niger*, *Peniophora* or *Citrobacter*. Preferably, the phytase activity in the mash is 0-5 FYT/ g, more preferably 0.5-1.5 FYT/g dry weight cereal(s). Preferably, the

phytase has at least 50%, more preferably at least 60%, more preferably at least 70%, more preferably at least 80%, more preferably at least 85%, more preferably at least 90%, more preferably at least 91%, more preferably at least 92%, more preferably at least 93%, more preferably at least 94%, more preferably at least 95%, more preferably at least 96%, more preferably at least 97%, more preferably at least 98%, and most preferably at least 99% or even 100 % identity to the amino acid sequence shown in SEQ ID NO:6 (a variant of *Peniophora lycii* phytase, described in WO 2003/066847).

[0098] In some embodiment of the invention Flavourzyme is added. Flavourzyme is an enzyme composition obtained from *A. oryzae* strain NN000562 originally obtained as ATCC 20386. FLAVOURZYME contains alkaline and acid protease activities.

[0099] Further disclosed is a wort produced by the process of the invention, and the use of the wort for the production of beers of any type, e.g. light and dark lager types, light and dark ale types, wheat beers, all porter, stout, ice concentrated (e.g. eisbock), barley wine types or happoushu.

[0100] The nitrogen containing components are important components of the wort because they affect the character of the beer, such as the taste and fermentation pattern. The nitrogen containing compounds are important nutrients for the yeast with the exception of proline which is hardly assimilated by the yeast thus it is favourable to have a small amount of proline or no proline in the wort. The wort comprises one or more amino acids selected from

1. a. proline at a concentration at less than 2 mM, preferably less than 1 mM, and most preferably less than 0.5 mM in the wort;
2. b. serine at a concentration above 0.1 mM, preferably above 0.125 mM, and most preferably above 0.15 mM; and
3. c. methionine at a concentration above 0.05 mM, preferably above 0.08 mM, and most preferably above 0.10 mM.

[0101] Thus in one aspect the proline concentration is below 2 mM, such as below 1.5 mM, such as below 1 mM, such as below 0.5 mM, such as below 0.25 mM.

[0102] In another aspect the serine concentration is above 0.1 mM, such as 0.125 mM, such as 0.15 mM, such as 0.2 mM.

[0103] In another aspect the methionine concentration is above 0.005 mM, such as 0.008 mM, such as 0.1 mM, such as 0.125 mM, such as 0.15 mM.

[0104] The inventors has surprisingly found that even with very high amounts e.g. above 80 % of unmalted cereals such as unmalted barley a wort could be produced which has a high amount of fermentable sugars, which in this context is DP1-DP3 (glucose, maltose and maltotriose) and in a particular preferred aspect of the invention the amount of maltose is high compared to the amount of glucose, which is favorable because it prevents osmotic pressure on the yeast and regulates the ester production and therefore the flavour and aroma profile of the final beer.

[0105] Thus in one aspect, in the wort the maltose concentration is above 45%, preferably above 50%, preferably above 55%, preferably above 56%, preferably above 57%, preferably above 58%, preferably above 59%, preferably above 60%, preferably above 61 %, preferably above 62%, preferably above 63%, preferably above 64%, preferably above 65%, most preferably the maltose concentration is above 70% of the total concentration of carbohydrates.

[0106] In another aspect, in the wort the glucose concentration is below 10%, preferably below 9%, preferably below 8%, preferably below 7%, preferably below 6%, preferably below 5% most preferably below 4%.

[0107] Yet another aspect in the wort: the total of the glucose, maltose and maltotriose concentration is above 50%, preferably above 55%, preferably above 60%, preferably above 61%, preferably above 62%, preferably above 63%, preferably above 64%, preferably above 65%, preferably above 66%, preferably above 67%, preferably above 68%, preferably above 69%, preferably above 70%, preferably above 71%, preferably above 72%, preferably above 73%, preferably above 74%, preferably above 75%, preferably above 76%, preferably above 77%, preferably above 78%, preferably above 79% and preferably above 80% of the total concentration of carbohydrates.

[0108] RDF (Real degree of fermentation) is calculated as $RDF\% = 100 \cdot (OE\%P - ER\%) / OE\%P$ whereas OE means Original Extract in %P and ER means Real Extract % P measured by a densitometer (Analytica EBC reference).

[0109] Thus in one aspect the RDF in the wort is more than 60%, such as at least 65%, such as at least 70%, such as at least

75%, such as at least 76%, such as at least 77%, such as at least 78%, such as at least 79%, such as at least 80%, such as at least 81%, such as at least 82%, such as at least 83%, such as at least 84%, such as at least 85%, such as at least 86%, such as at least 87%, such as at least 88%, such as at least 89%, such as at least 90%, such as at least 91%, such as at least 92%, such as at least 93%, such as at least 94%, such as at least 95%, such as at least 96%, such as at least 97%, such as at least 98%, such as at least 99%, such as at least 100%.

[0110] Some breweries add brewery syrup, e.g. high maltose, brewing syrup to the wort kettle which may increase the amount of fermentable sugars. However, though brewing syrup may be added according to the invention this is not necessary for increasing the amount of fermentable sugars or RDF.

[0111] Also disclosed is a process, wherein the ratio of maltose:glucose in the wort is higher than 5:1, such as higher than 6:1, such as higher than 7:1, preferably higher than 8:1, preferably higher than 9:1, preferably higher than 10:1, preferably higher than 11:1 in a particular preferred embodiment the ratio of maltose:glucose in the wort is higher than 12:1.

[0112] During the mashing process starch is degraded into fermentable and unfermentable sugars and the proteinous material is converted the free amino acids which is used by the yeast. According to the invention the raw material used for mashing can be up to 100 % unmalted cereals, such as unmalted barley without reducing the fermentability of the wort or reducing the amount of amino acids available for the yeast.

[0113] In addition, brewing on unmalted cereals may give problems with filterability due to excess of non converted starch and β -glucan or xylan, which may also cause haze of the beer. Adding filtration aiding enzymes such as β -glucanase may increase the filterability of the wort. However, when unmalted cereal comprises main part of the grist, β -glucanase alone is not enough provide filterable wort.

[0114] The inventors have surprisingly found that adding exogenous enzymes according to the invention, comprising α -amylase activity, pullulanase activity, proteolytic activity, lipase activity and β -glucanase activity; to the mash prepared from a grist comprising at least 70 % unmalted cereal(s) produced a wort which is comparable or even better with regards to e.g. FAN, fermentable sugars (DP1-DP3) and which is filterable and also have an acceptable low turbidity when compared to a wort produced from a malted grist.

[0115] The lauter tun time, the time it takes to filter the mash in the lauter tun, if this is in a separate vessel, is influenced e.g. by the turbidity. Thus in a certain aspect of the invention the wort is filterable and has a low turbidity and in one embodiment of the invention the turbidity is below 20 NTU (The units of turbidity from a calibrated nephelometer, Nephelometric Turbidity Units), such as below 19 NTU, such as below 18 NTU, such as below 17 NTU, such as below 16 NTU, such as below 15 NTU, such as below 14 NTU, such as below 13 NTU, such as below 12 NTU, such as below 11 NTU, such as below 10 NTU.

[0116] One way of increasing the amount of fermentable sugars is by increasing the mashing time e.g. by increasing the saccharification step. However, in another important aspect of the invention the mashing time needed for producing a wort which is highly fermentable is not increased compared to the mashing time for producing an equally fermentable wort based on the same amount of malt.

[0117] This is surprising since generally longer mashing time is needed when the mash is based on high amount unmalted cereals e.g. 70% barley to give the same fermentability and FAN as in a wort produced on corresponding amounts (70%) of malt.

[0118] The mashing process is completed within 160 minutes, preferably within 120 minutes.

[0119] The mashing process comprising all the enzymes rests and all heating steps, is completed within 180 minutes, such as within 170 minutes, such as within 160 minutes, such as within 155 minutes, such as within 150 minutes, such as within 145 minutes, such as within 140 minutes, such as within 135 minutes, such as within 130 minutes, such as within 125 minutes, such as within 120 minutes, such as within 115 minutes, such as within 110 minutes, such as within 105 minutes, such as within 100 minutes, such as within 95 minutes, such as within 90 minutes, such as within 85 minutes, such as within 80 minutes, such as within 75 minutes, such as within 70 minutes, such as within 65 minutes, such as within 60 minutes.

[0120] When malt is substituted with grains such as rice and corn the grist may need to be treated by decoction or decoction mashing or adjunct decoction, which is process where a proportion of the grains are boiled separately with thermostable α -amylase and then returned to the mash. This process is often needed for these types of grains as the gelatinization temperature is higher than for barley, malt, and e.g. wheat. Thus pregelatinization is needed to make the starch accessible for all the needed endogenous and added enzymes. The process may also be used to give a malty flavor to the beer.

[0121] Unmalted cereals, such as barley shows a general different behaviour in milling than malted cereals, as an example barley has higher water content, is unmodified and is much harder than malt.

[0122] To run a lauter tun with malt and achieve an acceptable performance (yield and lauter time) a certain grist composition is necessary, the grist composition can be measured by a sieving test.

[0123] The grist composition made by roller mills are mainly influenced by the gap between the roller pair(s) (two roller mill = one pair, four roller mill = two pair). The first pair has always a wider gap than the second one. In order to obtain a lauter performance compared to a grist made of malt the inventors has changed, these roller gap(s).

[0124] The inventors found that a four roller mill and a six roller mill (three pairs) could mill with adjusted roller gaps are well suited to mill the barley into usable grist. This is important since a good lauter performances only can be achieved with an optimized grist composition that is different to the optimal grist composition of malt.

[0125] The sieving test was performed according to the sieving test described in Anger, H.: MEBAK Band Rohstoffe. 1. Auflage Brautechnische Analysenmethoden. 2006, Freising: Selbstverlag der MEBAK.

Table 1

Milled barley compared to malt		
	Barley	Malt
Sieve 1	25 %	18 %
Sieve 2	15 %	8 %
Sieve 3	38 %	33 %
Sieve 4	10 %	21 %
Sieve 5	3 %	10 %
Bottom	9 %	11 %

[0126] The results show that for a successful 100 % barley lauter performance more coarse grist with more focus on sieve 1-3 leads to a good lauter performance. It could also be seen that the barley grist is significantly different from the grist from malt.

EXAMPLES:

MATERIALS AND METHODS

Enzymes

Alpha-amylase activity (KNU)

[0127] The amyolytic activity may be determined by using potato starch as substrate. This method is based on the break-down of modified potato starch by the enzyme, and the reaction is followed by mixing samples of the starch/enzyme solution with an iodine solution. Initially, a blackish-blue color is formed, however, during the break-down of the starch the blue color gets weaker and gradually turns into a reddish-brown, which is compared to a colored glass standard.

[0128] One Kilo Novo alpha amylase Unit (KNU) equals 1000 NU. One KNU is defined as the amount of enzyme which, under standard conditions (i.e. at 37°C +/- 0.05; 0.0003 M Ca²⁺; and pH 5.6) convert 5.26 g starch dry substance (Merck Amylum solubile) into dextrins sufficiently small not to make a colour reaction with iodine.

Debranching activity (PUN)

[0129] Pullulanase activity may be determined relative to a pullulan substrate. Pullulan is a linear D-glucose polymer consisting substantially of maltotriosyl units joined by 1,6- alpha links. Endopullulanases hydrolyze the 1,6- α -links at random, releasing maltotriose, 6³- alpha-maltotriosyl-maltotriose, 6³- alpha -(6³- alpha -maltotriosyl-maltotriosyl)-maltotriose, etc. the number of links hydrolyzed is determined as reducing carbohydrate using a modified Somogyi-Nelson method.

[0130] .One pullulanase unit (PUN) is the amount of enzyme which, under standard conditions (i.e. after 30 minutes reaction time at 40°C and pH 5.0; and with 0.2% pullulan as substrate) hydrolyzes pullulan, liberating reducing carbohydrate with a reducing power equivalent to 1 micromol glucose per minute.

Proteolytic Activity (AU)

[0131] The proteolytic activity may be determined by using denatured hemoglobin as substrate. In the Anson-Hemoglobin method for the determination of proteolytic activity, denatured hemoglobin is digested, and the undigested hemoglobin is precipitated with trichloroacetic acid (TCA). The amount of the TCA soluble product is determined by using phenol reagent, which gives a blue color with tyrosine and tryptophan.

[0132] One Anson Unit (AU) is defined as the amount of enzyme which under standard conditions (i.e. 25°C, pH 7.5 and 10 min. reaction time) digests hemoglobin at an initial rate such that there is liberated an amount of TCA soluble product per minute which gives the same colour with phenol reagent as one milliequivalent of tyrosine.

β -glucanase activity (FBG)

[0133] One fungal beta glucanase unit (FBG) is the amount of enzyme, which, according to the standard conditions outlined below, releases reducible oligosaccharides or reduces carbohydrate with a reduction capacity equivalent to 1 mol glucose per minute.

[0134] Fungal beta glucanase reacts with beta glucan during the formation process to glucose or reducing carbohydrate which is determined as reducing sugar according to the Somogyi Nelson method.

[0135] The sample should be diluted to give an activity between 0.02-0.10 FBG/ml. The standard reaction conditions are: Substrate: 0.5% barley beta glucan, temperature: 30°C, pH: 5.0 and the reaction time 30 min.

[0136] However the cellulytic activity in the commercial product is measured in endoglucanase units (EGU), which can be converted to FBG. For celluclast the EGU can be converted to FBG by multiplying the EGU by a factor 3.2.

Xylanase (FXU(S))

[0137] The xylanolytic activity can be expressed in FXU(S)-units, determined at pH 6.0 with remazol-xylan (4-O-methyl-D-glucurono-D-xylan dyed with Remazol Brilliant Blue R, Fluka) as substrate.

[0138] An xylanase sample is incubated with the remazol-xylan substrate. The background of non-degraded dyed substrate is precipitated by ethanol. The remaining blue colour in the supernatant (as determined spectrophotometrically at 585 nm) is proportional to the xylanase activity, and the xylanase units are then determined relatively to an enzyme standard at standard reaction conditions, i.e. Substrate concentration 0.45% w/v, Enzyme concentration 0.04 - 0.14 FXU(S)/mL at 50.0 °C, pH 6.0, and in 30 minutes reaction time. Xylanase activity in FXU(S) is measured relative to a Novozymes FXU(S) enzyme standard (obtainable from Novozymes), comprising the monocomponent xylanase preparation Shearzyme from *Aspergillus aculeatus*.

Lipase (LU)

[0139] One Lipase Unit (LU) is the amount of enzyme which liberates 1 micromol of titrable butyric acid per minute at 30.0°C; pH

7.0; with Gum Arabic as emulsifier and tributyrine as substrate.

Phytase (FYT)

[0140] One phytase unit (FYT) is the amount of enzyme which liberates 1 micro-mol of inorganic ortho-phosphate per min. under the following conditions: pH 5.5; temperature 37°C; substrate: sodium phytate ($C_6H_6O_{24}P_6Na_{12}$) at a concentration of 0.0050 mol/l.

Leucine Amino Peptidase Unit (LAPU)

[0141] 1 Leucine Amino Peptidase Unit (LAPU) is the amount of enzyme, which decomposes 1 micro-M substrate per minute at the following conditions: 26 mM of L-leucine-p-nitroanilide as substrate, 0.1 M Tris buffer (pH 8.0), 40°C, 10 minutes reaction time.

Laboratory mashing method

[0142] Unless stated otherwise, the mashing method used in the examples was performed as follows:

[0143] First, barley is milled to fine grist (Bühler Unirvisale gab 0.2 mm), then 50 g milled barley is added to a mashing cup and 200 g pre heated water (with calcium chloride) is added. The cup is placed in the mashing bath (Lochner LB 12 Electronic with 12 cups), the mashing diagram is set (e.g. mashing-in at 50°C or 54°C, keep temperature for 20-30 minutes, increase by 1°C/minute to 64°C, keep for 40-60 minutes, increase by 1°C/minute 78 or 80°C, keep for 10-20 minutes and reduce temperature to 20°C). The enzyme solution is added at the start to the cups and the mashing is initiated giving a total mashing period of 140-160 minutes. After mashing water is added to a total of 300 g in the cup and the mash is filtered with a Whatman 597 1/2 (Schleicher & Schuell) folded filter to obtain the wort, where after the wort can be analyzed.

[0144] The wort sugar/dextrin (carbohydrate) concentrations were analyzed in a Waters HPLC system (Novozymes method: 345-SM-2004.01/01) with pre-column (Cation H refill cat. 1250129) two column BoiRad Aminex HPX 87 H heated to 60°C and flow of 0.4 ml/minutes with RI detection (Waters 2410 RI detector).

[0145] RDF: Real Degree of Fermentation, was determined by the method described in MEBAK method: 2.9.2. Principal: Reduction of wort dry matter, in %, by fermentation to alcohol and CO₂

[0146] NTU: Haze in wort was analyzed by MEBAK method 2.15.1

[0147] In general the enzyme doses are calculated as follows:

Enzyme dosage in the target dosage

[0148]

Enzyme	Target dosage/ g dm	Specific activity	g enzyme protein (EP)/ 1000 kg barley dm.
Termamyl SC	0.3 KNU(S)/g	43 KNU(S)/mg	6.98 g
Ultraflo Max	300 ppm	4000 EGU/g total protein	52.5 g
		30 FXU/mg	2.5 g
Pullulanase NS26062	1.0 PUN/g	57 PUN(G)/mg	17.54 g
Neutralse	0.001 AU/g	60 AU/g	33.3 g
Lipozyme TL	20 LU/g	6100 LU/mg	3.28 g

Example 1

[0149] The purpose of this example was to select the best suitable pullulanase for the production of wort based on RDF and DP2 (maltose). A grist comprising 100% unmalted barley was prepared as described above.

[0150] All cups were then added 50 ppm Na₂SO₃ and the enzymes:

α-amylase (Termamyl SC): 0.3 KNU(S)/g,

β-glucanase and xylanase (Ultraflo Max/Viscoflow XL): 300 ppm, Protease (Neutrase 0.8) 0.002 AU/g,

Flavourzyme™ 1000 L: 0.1 LAPU/g, and

[0151] Pullulanase as described in Table 2:

[0152] The mashing was performed and the cups were added city water to a total of 300 g after mashing. The mash was filtered, and the results in Table 1 below were obtained by analyzing the wort:

Table 1 100%barley: RDF, %and wort sugar.

Enzyme dosage PUN/g		DP2 % of total	DP4+ % of total	RDF %
-	0.00	48.7	33.2	62.0
Promozyme	0.1	49.4	31.6	64.0
Promozyme	0.2	49.7	30.6	65.0
Promozyme	0.3	50.3*	29.6*	65.8*
Promozyme	0.5	51.6	27.6	67.0
-	0.00	48.7	33.2	62.0
NS26062	0.1	50.0	30.2	64.6
NS26062	0.2	50.8	28.4	66.1
NS26062	0.3	51.3*	27.3*	67.3*
NS26062	0.5	52.4	25.0	69.5

* Estimated by linear regression

[0153] The RDF is above 60 % with both pullulanases, however RDF is a higher when NS26062 (PUL C) is added. The amount of maltose (DP2) relative to the amount of dextrans (DP4) was also higher for both pullulanase but again the amount of maltose relative to dextrans are higher for NS26062 (PUL C). Thus in conclusion: NS26062 (pullulanase C or PULC) showed the best performance, compared to Promozyme (promozyme 400 L) on PUN activity, on RDF% and maltose (DP2) generation. In this experiment the advantage of the thermostable NS26062 (pullulanase C or PULC) is clearly demonstrated.

Example 2

[0154] The following example demonstrates the different temperature optimum and the relative activity at different temperatures. The relative enzyme activity of three different pullulanases was analysed. The method of analyzing pullulanase activity is by detection of increased reducing sugar capacity (Somogyi-Nelson reaction) in the following conditions:

[0155] Substrate: 0.2% pullulan, pH 5.0, reaction time 30 minutes, stop of enzyme reaction by adding Somogyi copper reagent, followed by Nelson color reagent and boiling in 20 minutes. Samples were incubated at 30°C, 45°C, 55°C, 60°C, 62.5°C, 65°C and 70°C in 30 minutes. The samples were analyzed by spectrophotometer at OD520 nm, and the difference between sample and blank (increased by enzyme activity) were used in calculation of the results.

[0156] The highest activity was set to 100% (maximum) and activities at other temperatures set relative to the temperature maximum.

Table 2 Relative activity of different pullulanases at different temperatures

Temperature In 30 minutes	PulC/NS26062 %	Promozyme 400 L %	Promozyme D2/ Optimax 1000 L %
30°C	19.7	20.1	34.4
45°C	47.3	56.8	68.1
55°C	76.8	100.0	100.0
60°C	86.8	87.9	80.0
62.5°C	92.8	76.9	58.4
65°C	100.0	37.2	51.1
70°C	75.6	8.3	11.9

[0157] This example clearly demonstrates that Pul C is the most thermostable and thermoactive of the three pullulanase since it has a significant higher relative activity above 62.5 °C and since the highest activity measured over 30 minutes at 65°C. The Pul C pullulanase have highest activity of all three pullulanase between 62.5°C and 65°C, which is the preferred temperature for mashing thus using Pul C as debranching enzyme in a mashing process, is clearly advantageous.

Example 3

[0158] The purpose of this experiment was to evaluate the effective dosage enzyme protein (EP) per g dm (gram dry matter) of 3 of different pullulanases (NS26062/PulC, Promozyme 400 L and Promozyme D2 (Optimax 1000 L) in saccharification of either 100% unmalted barley or 100% malted barley when applied in infusion mashing for 2 hours.

[0159] All cups were added enzymes blend 2 kg /1000 kg barley:

α -amylase (Termamyl SC) 0.3 KNU(S)/g,

β -glucanase and xylanase (Ultraflo Max/Viscoflow XL) 300 ppm,

Protease (Neutrase) 0.001 AU/g,

Lipase (Lipozyme TL 20 LU/g)

[0160] Different pullulanases dosages were added.

[0161] Specific activity:

NS26062: 57 PUN/mg EP.

Promozyme 400 L: 136 PUN/mg EP

Promozyme D2:236 NPUN/mg EP

Iso-amylase from Hayashibara Co Ltd: Specific activity unknown

[0162] The specific activities were measured after the pullulanases were purified by standard chromatographic techniques

[0163] Mashing conditions: 54°C in 30 minutes, increase to 64°C in 10 minutes and maintain 45 minutes, increase to 80°C in 16 minutes and maintain 10 minutes, producing wort with 12.6 Plato.

Table 3: Pullulanase effect on degradation of dextrin in 100% unmalted barley mashing: showing % of non fermentable carbohydrate in wort (dextrin/DP4+) with different dosages (g (gram) EP (enzyme protein) / 1000 kg unmalted barley. Some experiments were done several times.

gEP/1000 kg dm unmalted barley	NS26062 PulC	Promozyme 400 L	Promozyme D2	Iso-amylase Hayashibara

gEP/1000 kg dm unmalted barley	NS26062 PulC	Promozyme 400 L	Promozyme D2	Iso-amylase Hayashibara
0(control)	30.5 - 30.8 %	30.5 - 30.8 %	30.5 - 30.8 %	30.5 - 30.8 %
8.77	20.1 - 21.4 % 22.3 %	-	-	-
17.5	15.4-18.8 % 17.9-18.3 %	19.8-20.4 %	27.4-27.5 %	-
26.3	13.6-16.1 % 16.0-16.7 %	-	-	-
35.0	14.9-15.5 %	17.1 %	-	-
52.5	13.2 %			
87.5	-	13.2- 13.7 %	21.9-22.4 %	-
175	-	11.8- 12.3 %	18.7-19.3 %	-

[0164] Table 3 shows that all three pullulanases but not the Hayashibara isoamylase could reduce the amount of non-fermentable sugars (dextrin DP4+) and thereby increase the amount of fermentable sugars. However, the best performing is clearly the NS26062 (Pul C) pullulanase, which reduced the amount of non-fermentable sugars relative to the amount of added enzymes much more than the Pullulanase 400 L and the pullulanase D2. This is a clear demonstration of the advantage of using the thermostable PulC. It is furthermore demonstrated that a DP4+ of less than 20%, corresponding to more than 80% glucose, maltose and maltotriose can be reached in 120 minutes of mashing.

[0165] Thus the choice of pullulanase is important for controlling the amount of fermentable sugars and for probably reduction of the non fermentable DP4+ dextrans. This is important since a good sugar profile (many fermentable sugars compared to non fermentable sugars) promote a good fermentation of the wort.

Example 4

[0166] The purpose of this example was to evaluate the effect of the pullulanase NS26062 on the DP2 (maltose) formation in the wort. A grist comprising 100% unmalted barley was prepared as described above.

[0167] All cups were then added 50 ppm Na₂SO₃ + 3.0 ml 1 M H₃PO₄ and enzymes:

α-amylase (Termamyl SC): 0.3 KNU(S)/g,

β-glucanase and xylanase (Ultraflo Max/Viscoflow XL): 300 ppm - 0.23 EGU/g,

Protease (Neutrase 0.8 L): 0.002 AU/g,

[0168] Pullulanases as described in Table 4:

[0169] The mashing was performed and the cups were added city water to a total of 300 g after mashing. The mash was filtered, and the results in Table 4 below were obtained by analyzing the wort:

Table 4. 100% barley: RDF, % and wort sugar.

Enzyme dosage PUN/g (NS26062)	DP1 % of total	DP2 % of total	DP4+ % of total	RDF %
-	3.8	47.5	34.0	61.2
NS26062	3.8	48.2	32.0	63.2
NS26062	3.8	49.8	28.8	65.7
NS26062	3.7		26.4	68.6
NS26062	3.7	52.6	23.9	71.0

Enzyme dosage PUN/g (NS26062)	DP1 % of total	DP2 % of total	DP4+ % of total	RDF %	
NS26062	2	3.6	55.6	20.1	74.3

[0170] The maltose concentration (DP2) was increased by increasing the dosage of NS26062 (Pul C), and the increase in maltose % was followed by an increase in attenuation (RDF%). The dextrin fraction (HPLC analysis DP4/4+) was at the same time decreasing.

[0171] Only barley β -amylase could produce maltose in this reaction, and NS26062 (Pul C) facilitated the action of the barley beta-amylase.

[0172] Thus the NS26062 (Pul C) was a suitable pullulanase, providing a wort with high RDF and low glucose.

Example 5

[0173] The purpose of this example was to evaluate the three proteases Neutrase 0.8 L, Alcalase and Flavourzyme for FAN development and maltose formation. A grist comprising 100% unmalted barley was prepared as described above. Then all cups (trials 1-3 below) were added enzymes as indicated in the tables 5-7 below. The mashing was performed and the cups were added city water to a total of 300 g after mashing. The mash was filtered, and the results in the tables 5-7 were obtained by analyzing the wort:

Trial 1:

[0174] All samples were added: α -amylase (Termamyl SC): 0.3 KNU(S)/g, β -glucanase and xylanase (Ultraflo Max): 300 ppm (0.23 EGU/g) and different activities of the proteases Alcalase and Neutrase 0.8 L as indicated in table 5.

Table 5. FAN and % wort sugar at different dosages of Alcalase and Neutrase 0.8 L (enzyme activity per g dm mash)

Cup no.	Alcalase AU/g	Neutrase 0.8 L AU/g	FAN mg/l/Plato	DP2 % of total	DP4/4+ % of total
1	-	-	5.05	42.2	37.4
2	-	0.0005	6.73	45.4	35.5
3	-	0.001	7.32	44.6	35.8
4	-	0.0015	7.92	46.5	34.4
5	-	0.002	8.33	46.0	34.7
6	-	0.003	9.00	46.1	34.6
7	0.001	0.002	8.59	46.1	34.6
8	0.002	0.002	8.38	45.9	34.7
9	0.0025	0.002	8.35	46.5	34.3
10	0.003	0.002	8.59	46.9	34.1
11	0.004	0.002	8.92	46.6	34.2
12	0.005	0.002	9.29	47.1	34.0

Trial 2:

[0175] All samples were added: α -amylase (Termamyl SC): 0.3 KNU(S)/g, β -glucanase and xylanase (Ultraflo Max): 300 ppm (0.23 EGU/g), Flavourzyme: 0.1 LAPU/g, and the proteases Alcalase and/or Neutrase 0.8 L as indicated in table 6.

Table 6. FAN and % wort sugar at different dosages of Alcalase and Neutrase 0.8 L (enzyme activity per g dm mash)

Cup no.	Alcalase AU/g	Neutrase 0.8 L AU/g	FAN mg/l/Plato	DP2 % of total	DP4/4+ % of total
1	-	-	5.47	43.8	36.0
2	-	0.0005	6.75	46.4	34.3
3	-	0.001	7.20	47.5	33.7
4	-	0.0015	7.57	47.1	33.8
5	-	0.002	8.26	47.3	33.7
6	-	0.003	8.64	47.3	33.6
7	0.001	0.002	9.09	47.1	33.9
8	0.002	0.002	8.46	48.2	33.1
9	0.0025	0.002	8.64	47.9	33.4
10	0.003	0.002	8.49	47.3	33.8
11	0.004	0.002	8.96	47.5	33.6
12	0.005	0.002	10.15	47.4	33.7

Trial 3:

[0176] All samples were added: α -amylase (Termamyl SC): 0.3 KNU(S)/g, β -glucanase and xylanase (Ultraflo Max): 300 ppm 0.23 EGU/g, Flavourzyme: 0.1 LAPU/g, and the proteases Alcalase or Neutrase 0.8 L as indicated in table 7.

Table 7. FAN and % wort sugar at different dosages of Alcalase and Neutrase 0.8 L (enzyme activity per g dm mash)

Cup no.	Alcalase AU/g	Neutrase 0.8 L AU/g	FAN mg/l/Plato	DP2 % of total	DP4/4+ % of total
1	-	-	5.24	44.8	35.3
2	0.001		5.37	44.8	35.3
3	0.002		5.02	44.6	35.4
4	0.0025		5.20	45.7	34.6
5	0.003		5.29	44.2	35.7
6	0.004		5.66	44.4	35.0
7	0.005		5.91	45.0	35.0
8	-	0.002	5.66	44.4	35.5
9	0.004	0.001	8.45	47.1	33.9
10	0.004	0.0015	8.96	47.7	33.4
11	0.004	0.002	9.65	48.3	33.0
12	0.004	0.003	10.25	48.7	32.6

[0177] These examples clearly demonstrates that addition of the proteases Alcalase and Neutrase but not Flavorzyme has a positive effect on the generation of particular free available amino nitrogen (FAN) and that neutrase had the most positive effect on FAN generation. Thus the choice of protease is a critical parameter for FAN generation.

Example 6

[0178] A grist comprising 0-90% unmalted barley was prepared as described above. Then all cups were added the enzymes β -glucanase and xylanase. The mashing was performed and the cups were added city water to a total of 300 g after mashing. The mash was filtered, and the results in the table 8 were obtained by analyzing the wort:

[0179] The following experiment is to demonstrate the effect on the turbidity (NTU) with increasing amount of unmalted barley, when only filtration enzyme blend β -glucanase and xylanase (Ul-traflo Max 300 ppm) is added.

Table 8. NTU when increasing amount of malt barley is substituted with unmalted barley, from 0 % unmalted barley to 90 % unmalted barley.

	%barley	NTU
1	0	19.8
2	8	19.7
3	16	15.3
4	24	12.4
5	32	12
6	40	10.2
7	48	10.8
8	56	8.43
9	64	10.9
10	72	21
11	80	35.7
12	90	56.2

[0180] The result is also shown in Figure 1. It is evident from this experiment that mashing unmalted barley with simple enzyme blends (only filtration enzymes) becomes increasingly difficult with increasing amount of unmalted barley is substituted for malted barley and when the amount exceeds 80 % the turbidity is so high that the wort is difficult to filtrate. Thus when having high amount of unmalted barley adding filtration enzymes alone is not enough to get a wort which is filterable.

Example 7

[0181] The purpose of this example was to evaluate the turbidity (NTU) and the filtration of wort from 100% barley infusion mashing with a different dosage of Lipopan F, Lipopan X and β -glucanase and xylanase (Ultraflo Max). The study comprised two independent trials for Lipopan F and Lipopan X, respectively, i.e. 2 x 12 cups as indicated in table 9 below. A grist comprising 100% unmalted barley was prepared as described previously. Then all cups were added enzymes.

[0182] To each cup was added:

- 3.0 ml 1 M H_3PO_4 .
- 0.3 KNU(S)/g α -amylase (Termamyl SC),
- 0.002 AU/g protease (Neutrase 0.8 L),
- 0.5 PUN/g pullulanase (NS26062), and the enzymes in table 9.

[0183] The mashing was performed and the cups were added city water to a total of 300 g after mashing. The mash was filtered, and the results in Table 9 below were obtained by analyzing the wort:

Table 9. Enzyme dose Activity/g DM in mashing

Cup no.	Ultraflo Max EGU/g	Lipopan F LU/g	Lipopan X LU/g	NTU	Filtration ml/10 min	Filtration ml final
1	0.24	-		116	105	194
2	0.24	1		120	86.0	165
3	0.24	5		78.3	110	195
4	0.24	10		66.1	131	195
5	0.24	20		50.1	168	210
6	0.24	50		22.7	190	210

Cup no.	Ultraflo Max EGU/g	Lipopan F LU/g	Lipopan X LU/g	NTU	Filtration ml/10 min	Filtration ml final
7	0.16	50		19.7	170	208
8	0.08	50		19.8	178	205
9	-	50		18.5	142	195
10	0.16	10		67.8	114	200
11	0.08	10		69.2	130	200
12	-	10		49.7	95	180
1	0.24		-	110	105	200
2	0.24		1	92.0	70.0	165
3	0.24		5	50.0	100	200
4	0.24		10	107	94.0	198
5	0.24		20	5.91	135	205
6	0.24		50	3.36	160	210
7	0.16		50	3.53	150	205
8	0.08		50	3.84	151	205
9	-		50	4.96	100	200
10	0.16		10	24.9	110	200
11	0.08		10	21	110	200
12	-		10	8.9	75	180

[0184] Both Lipases Lipopan F and Lipopan X markedly reduced the turbidity (NTU) of the wort. Lipopan X is the most efficient (on enzyme activity LU(g)) for reduction of the turbidity in wort, but Lipopan F can reduce the turbidity to a level within the specification of wort. The amount of filtration enzymes can be reduced to 100 ppm in the presence of lipase without reducing the filtration speed significantly.

Example 8

[0185] The purpose of this example was to evaluate the effect of the protease Neutrase 0.8 L, phytase and the pullulanase NS26062 (Pul C) on the FAN generation and the wort sugar profile in a standard mashing. A grist comprising 100% unmalted barley was prepared as described above. Then all cups were added α -amylase (Termamyl SC) 0.3 KNU(S)/g, 300 ppm β -glucanase and xylanase (Ultraflo Max), adjusted to pH 5.3, and the the protease Neutrase 0.8 L, the phytase and the pullulanase NS26062 (Pul C) enzymes, where added as indicated in Tables 10A and 10B below, and the results obtained:

Table 10A. 100% barley: FAN generation in wort. The dosages is enzyme activity unit and ppm (100 ppm=100g/1000 kg unmalted barley). FYT is phytase unit, PUN is pullulanase activity and AU is proteolytic activity.

Enzyme dosages	FAN mg//Plato
0	5.09
1.5 FYT	5.09
0.5 PUN	5.11
1.5 FYT + 0.5 PUN	5.22
0.002 AU	8.58
0.002 AU + 1.5 FYT	7.53
0.002 AU + 0.5 PUN	7.85
0.002 AU + 1.5 FYT + 0.5 PUN	7.91
0.002 AU + 0.5 PUN + 0.5 FYT	7.87
0.002 AU + 0.5 PUN + 5 FYT	7.77

Enzyme dosages	FAN mg//Plato
0.001 AU + 0.5 PUN + 5 FYT	7.35

Table 10B. 100%barley: wort sugar profile.

Enzyme dosage Neutrased 0.8 L (AU)	DP1 %	DP2 %	DP3 %	DP4/4+ %	Fru %
0	4.15	31.80	14.82	38.13	1.82
0.002 AU	3.81	46.61	12.79	34.97	1.82
1.5 FYT	4.13	42.11	14.78	37.14	1.85
0.5 PUN	4.06	44.28	18.28	31.55	1.82
0	4.15	31.80	14.82	38.13	1.82
5.0 FYT + 0.5 PUN	4.14	47.01	18.17	28.82	1.86
5.0 FYT + 0.5 PUN + 0.001 AU	3.84	50.67	17.42	26.25	1.80
5.0FYT+0.5PUN+ 0.002 AU	3.88	49.26	17.61	27.41	1.83
0	4.15	31.80	14.82	38.13	-
0.002 AU	3.81	46.61	12.79	34.97	-
0.002 AU + 0.5 PUN	3.81	47.78	17.74	28.87	-
0.002 AU + 0.5 PUN + 0.5 FYT	3.88	49.26	17.61	27.41	-
0.002 AU + 0.5 PUN + 1.5 FYT	3.91	50.12	17.56	26.58	-
0.001 AU + 0.5 PUN + 5.0 FYT	3.84	50.67	17.42	26.25	-

[0186] Table 10 A shows that the protease increase the FAN in the wort, and table 10 B shows that when adding phytase and pullulanase to the protease a comparable high amount of DP1-DP3 could be generated with protease concentrations of 0.001 and 0.002 AU respectively. Thus the protease concentration could be reduced in the production of maltose wort when phytase and pullulanase is present without reducing the amount of fermentable sugars (DP1-DP3).

Example 9

[0187] The purpose of this example was to elucidate some general parameters concerning wort prepared on 100% unmalted barley in order to identify critical issues compared to wort prepared on malted barley.

[0188] Malt mashing (100%) with no enzyme added and unmalted barley (100%) mashing, with enzyme blend. The wort was boiled, and beer fermentation performed with 100% (barley) malt and a 100% unmalted barley wort.

Data:

[0189] Mashing:

Barley: Scarlet and malt from same batch of Scarlet.

Mash: 10 kg malt or barley, + 35 l mash liquor and spargings 25 l to a total of 60 l.

Profile: 54°C 30 minutes, increase to 64°C (1 °C/minute) and maintain for 60 minutes, increase to 80°C (1 °C/minute) and maintain for 10 minutes and transfer to lautering.

[0190] Enzymes blend in 100% barley mash:

- α -amylase (Termamyl SC): 0.3 KNU(S)/g dm
- β -glucanase and xylanase (Ultraflo Max): 300 ppm
- Protease (Neutrased 0.8 L): 0.0015 AU/g dm

- Pullulanase (NS26062, Pul C): 1.0 PUN/g dm

[0191] Wort amino acid composition (table 11) analyzed:

[0192] The free amino acid analyzed in the wort is organized according to the paper "Elucidation of the Role of Nitrogenous Wort Components in yeast Fermentation," (J. Inst. Brew. 113(1), 3-8, 2007)

Table 11. FAN in wort

	Malted barley wort	Unmalted barley wort
Group A, fast absorption:	mM	mM
Aspartic acid	0.076	0.151
Glutamic acid	0.244	0.210
Asparagine	0.310	0.273
Serine	0.007	0.187
Glutamine	0.074	0.048
Threonine	0.210	0.188
Arginine	0.149	0.265
Lysine	0.216	0.354
Sum	1.286	1.675 (130%)
Group B, intermediate absorption:		
Valine	0.245	0.252
Methionine	0.047	0.111
Leucine	0.236	0.446
Isoleucine	0.114	0.163
Histidine	0.157	0.091
Sum	0.798	1.064 (133%)
Group C, slow absorption:		
Glycine	0.149	0.158
Phenylalanine	0.196	0.206
Tyrosine	0.131	0.158
Tryptophan	0.087	0.062
Alanine	0.312	0.361
Sum	0.875	0.945 (108%)
Group D, little or no absorption		
Proline	2.500	0.413 (16.5%)
Total - sum	5.458	4.098

[0193] Table 11 shows that when mashing with 100 % unmalted barley and an enzyme blend comprising α -amylase activity, β -glucanase activity, protease activity and a pullulanase activity a wort can be produced which has considerably less of the for the yeast unusable amino acid proline, which is clearly advantageous since the presence of this amino acid in a beer product gives an unpleasant taste. In addition, the amount of amino acids in the groups A and B, which could be quickly metabolised by the yeast, is considerably increased when mashing unmalted barley and the enzyme blend comprising α -amylase activity, β -glucanase

activity, protease activity and a pullulanase. Thus it is clear from this example that the proline concentration is less than 2 mM, and the serine and methionine concentration is above 0.1 mM and 0.05 mM respectively.

Example 10

[0194] The following experiment analyses the wort obtained from grist comprising 100 % unmalted barley and 100 % malt. The trials have been executed at Ziemann GmbH, Ludwigsburg, Germany. All analysis has been done according to the Analytica EBC or MEBAK respectively. (van Erde, P., Analytica-EBC. 1998, Nürnberg: Verlag Hans Carl. ; Anger, H., MEBAK Band Rohstoffe. 1. Auflage ed. Brautechnische Analysenmethoden. 2006, Freising: Selbstverlag der MEBAK).

[0195] The barley used was a two rowed spring barley from Germany harvest 2008.

[0196] The enzymes added were:

- α -amylase (Termamyl SC): 0.3 KNU(S)/g cereal
- β -glucanase and xylanase (Ultraflo Max): 300 ppm
- Protease (Neutrase 0.8 L): 0.001 AU/g dm
- Pullulanase (NS26062, Pul C): 2.0 PUN/g dm
- Lipase (Lipozyme TL 100): 20 LU/g dm

[0197] The mashing profile used was 54 °C at 30 min; increase the temperature 1°C/min to 64°C and rest for 60 min increase the temperature 1°C/min to 78 °C and rest for 30min, total mashing time 144 min.

Table 12 Wort composition of 100 %barley brews in comparison with all malt specifications

Analysis	unit	method	100% unmalted barley	100 % malted barley
Viscosity (1.2 %)	mPas	MEBAK II	1,76	< 1.8
iodine value		MEBAK II	0,28	< 0.35
RDF	%	MEBAK II	69,2	68-72
sol Nitrogen (12 %)	mg/100 ml	MEBAK II	102,5	
FAN (12 %)	ppm	MEBAK II	180	
Turbidity	EBC	MEBAK II	< 80 NTU	< 80 NTU

[0198] The results show 100 % unmalted barley in combination with the enzyme blend comprising α -amylase activity, β -glucanase activity, proteolytic activity and pullulanase debranching activity can fully match all malt specification in all key parameters like viscosity, turbidity, free amino nitrogen supply, yield and final attenuation are within all malt (100 % malt) specifications.

[0199] The lauter performance was also investigated. The turbidity in the lauter wort describes the quality of the lauter performance. The lipase component in the enzyme blend was able to reduce the normally significant higher haze level of unmalted barley approaches to haze levels below 80 NTU within a comparable lauter time.

[0200] Also the fermentation performance was tested: 8 hl of wort from 100 % malt and 8 hl of wort from 100 % unmalted barley was fermented. The result is demonstrated in figure 2.

[0201] Both worts have been fermented with bottom fermenting yeast strain W34, figure 2 shows the comparable extract drop of both brews. Furthermore, no differences in ethanol production have been found.

[0202] Finally the barley beer has been tasted by a professional taste panel at the institute for brewing technology 1 in Weihenstephan, Germany. The results show comparable result to a standard lager beer with indications of enhanced flavour stability.

	100 % unmalted barley	100 % unmalted barley	100 % unmalted barley	100 % unmalted barley
	Fresh	forced aged	fresh	Forced aged
Taste	4.0	3.5	3.8	3.5
Flavor	4.0	3.4	3.8	3.4
Body	4.0	3.8	4.0	3.8
Bitterness total	4.1	3.9	4.1	3.9
Total	4.03	3.61	3.91	3.56

General evaluation: DLG 5 = very good, 1 unacceptable.

Example 11

[0203] The following examples was to evaluate different important parameters when mashing on a grist comprising 30% corn grist or rice (unmalted) with 70% unmalted barley main mash and an enzyme blend comprising α -amylase activity, β -glucanase activity, protease activity and a pullulanase.

[0204] The process used were decoction mashing where the rice or corn grist part where boiled with thermostable α -amylase and then mixed with the mash comprising unmalted barley. The enzymes added to 70% barley mash + 30 % corn grist or rice:

- α -amylase (Termamyl SC): 0.3 KNU(S)/g dm
- β -glucanase and xylanase (Ultraflo Max): 300 ppm (0.23 EGU/g)
- Protease (Neutrase 0.8 L): 0.001 and 0,002 AU/g dm

[0205] Pullulanase was also added to the unmalted barley mash and the concentration was varied, se table 14 and 15, the pullulanase added is (NS26062, Pul C).

[0206] The mashing was performed as follows: The milled barley was added to mashing, cup (40.0 g as is) and added 115 g water at 60°C, CaCl (330 g/1000 kg barley) was added in addition with the enzyme blend indicated above. The mixture was maintain at 54°C for 30 minutes, then the decoction mash are added (15.4 g dm) and temperature maintained at 64°C in 60 minutes, increased to 80°C and maintained 10 minutes, cooled and filtrated. All the mashes could be filtrated without any problem and no significant differences between the different enzymes dosage.

[0207] The preparation of the decoction mash was performed as follows: The rice or corn grist was mixed with water (5.66 part) at a temperature of 60°C - 70°C, CaCl₂ (220 g/1000 kg grist) was added in addition with an α -amylase (Termamyl SC 0.600 kg/1000 kg grist). The mixture was heated to 85°C and kept at that temperature for 20 minutes, the heat was increased 100°C (boiling) and kept at that temperature (boiling) for 15 minutes. The mixture was cooled to 80°C and mixed with the barley containing mash.

[0208] The mashing was performed and the cups were added city water to a total of 300 g after mashing. The mash was filtered, and the results in Table 14 below were obtained by analyzing the wort. In some examples the wort was boiled 10 minutes diluted 9.7 Plato and fermented by Forced Fermentation, Analytica - EBC nr. 8.6.

Table 14: FAN, RDF and sugar content of a wort from mash based on decoction of 30 % corn grist and 70 % unmalted barley mash which is mixed.

Cup No	Neutrase AU/g	NS26 062 PUN/ 9	Wort carbohydrate profile in %				Plato°	FAN ppm	RDF%
			DP1:	DP2:	DP3:	DP4+:			
1	0.001	-	5.17	54.31	12.02	28.50	14.48	106	64.4
2	0.001	0.5	5.47	58.23	14.73	21.56	14.45	106	70.7
3	0.001	1.0	5.48	60.48	15.79	18.25	14.54	107	73.6
4	0.001	1.5	5.59	61.77	16.35	16.29	14.45	107	75.3

Cup No	Neutrase AU/g	NS26 062 PUN/ 9	Wort carbohydrate profile in %				Plato°	FAN ppm	RDF%
			DP1:	DP2:	DP3:	DP4+:			
5	0.001	2.0	5.57	62.88	16.66	14.89	14.49	108	76.5
6	0.001	2.5	5.60	63.35	16.96	14.09	14.46	106	77.2
7	0.002	-	5.54	54.29	12.50	27.67	14.28	131	64.6
8	0.002	0.5	5.60	58.37	15.13	20.90	14.34	131	70.8
9	0.002	1.0	5.53	60.43	16.10	17.93	14.83	129	73.8
10	0.002	1.5	5.66	61.83	16.58	15.93	14.34	130	75.3
11	0.002	2.0	5.66	62.71	16.92	14.70	14.33	131	76.4
12	0.002	2.5	5.73	63.21	17.18	13.88	14.31	130	77.3

Table 15: FAN, RDF and sugar content of a wort from mash based on decoction of 30 % rice grist and 70 % unmalted barley mash which is mixed.

Cup no	Neutrase AU/g	NS26 062 PUN/ g	Wort carbohydrate profile in %				Plato°	FAN ppm	RDF%
			DP1:	DP2:	DP3:	DP4+:			
1	0.001	-	5.37	53.14	12.33	29.16	14.37	103	62.0
2	0.001	0.5	5.40	57.06	15.03	22.50	14.75	104	68.8
3	0.001	1.0	5.57	59.18	16.02	19.24	14.53	106	72.1
4	0.001	1.5	5.57	60.72	16.65	17.15	14.61	1.04	74.1
5	0.001	2.0	5.59	61.64	17.00	15.77	14.51	104	75.5
6	0.001	2.5	5.65	62.38	17.28	14.67	14.52	105	76.6
7	0.002	-	5.50	53.23	12.79	28.48	14.45	125	62.4
8	0.002	0.5	5.55	57.09	15.28	22.08	14.45	124	69.0
9	0.002	1.0	5.65	59.17	16.32	18.86	14.44	126	72.1
10	0.002	1.5	5.68	60.38	16.95	16.99	14.45	127	73.9
11	0.002	2.0	5.67	61.37	17.38	15.58	14.45	126	75.3
12	0.002	2.5	5.72	62.11	17.56	14.59	14.39	127	76.7

[0209] Table 14 and 15 shows the sugar profile, Plato, FAN and RDF of the wort based on mashing a grist comprising 30 % corn or rice and 70 % unmalted barley (100 % unmalted grains). The result shows clearly that the amount of fermentable sugars (DP1-3) is very high (above 80 %), the RDF is above 60 % and increasing with increasing pullulanase concentration and the FAN is high and increasing with increasing protease concentration, when the wort is produced from 100 % unmalted grains comprising 70 % unmalted barley and 30 % unmalted corn grist or rice and an enzyme blend comprising α -amylase activity, β -glucanase activity, protease activity and a pullulanase. There were no significant difference between using rice or corn grist.

Example 12

[0210] The following examples were to evaluate different important parameters when mashing on a grist comprising 50% barley + 50% wheat mash and the following enzymes.

- α -amylase (Termamyl SC): 0.3 KNU(S)/g dm (dry matter)
- β -glucanase and xylanase (Ultraflo Max): 300 ppm/0.23 EGU/g dm
- Protease (Neutrase): 0.001 AU/g dm
- Lipase (Lipozyme TL): 20 LU/g dm
- Pullulanase (NS26062, Pul C): 0-3.0 PUN/g dm

[0211] In one example the pullulanase concentration was varied, see table 17, the pullulanase added is (NS26062, Pul C).

[0212] In the other two examples the enzyme blend concentration per kg raw material was varied, see table 18.

[0213] The mash was prepared by mixing milled barely and wheat (25 g of each (total 50.0 g) with 200 g water added to mashing cups, then Ca²⁺ and the enzyme blend indicated above were added and mashing started.

[0214] The mashing profile was as follows: The mash was heated to 54°C (1°C/min.) and kept at that temperature for 30 minutes, the temperature was increased to 64°C within 10 minutes and maintain at that temperature for 45 minutes, the temperature was increased to 80°C within 16 minutes and maintain at that temperature for 10 minutes. Water to 300 g total was added and the mash was filtered.

[0215] The wort was filtrated and in some examples the wort was boiled 10 minutes diluted 9.7 Plato and fermented by Forced Fermentation.

[0216] The results are showed in Figure 3 and in table 16 and 17.

Table 16: The enzyme blend was as described above Termamyl SC, Ultraflo Max, Neutrase, and Lipozyme TL with different concentrations (PUN/g) of pullulanase (NS26062) added.

Enzymes	filtration		Plato	pH	NTU	RDF%
	ml after 10 minutes	ml total				
0 PUN/g + enzyme blend	158	208	12.96	5.80	4	64.2
0.5 PUN/g + enzyme blend	179	215	12.84	5.70	4	69.8
1.0 PUN/g + enzyme blend	159	206	13.06	5.70	3	72.0
1.5 PUN/g + enzyme blend	154	213	13.08	5.70	3	72.5
2.0 PUN/g + enzyme blend	159	209	13.05	5.50	3	73.0
2.5 PUN/g + enzyme blend	146	206	13.10	5.6	3	73.4
3.0 PUN/g + enzyme blend	159	208	13.08	5.70	3	73.6

[0217] Table 16 shows that a wort made from a grist comprising 50 % wheat and 50 % barley, that is 100 % unmalted grains and mashed with an enzyme blend comprising α -amylase activity, β -glucanase activity, protease activity, lipase activity and a pullulanase is filterable and with low turbidity and importantly the RDF is high (above 65 %) and increasing with increasing amount of pullulanase NS26062 (Pul C).

[0218] In table 17 the enzyme blend was as described above Termamyl SC, Ultraflo Max, Neutrase, and Lipozyme TL in the same relative amount, but in this example the amount of the blend relative to amount of raw material was varied. All blend were with 1.0 PUN of pullulanase (NS26062) added.

Table 17: Different doses of enzyme blend

Enzymes	filtration			pH	NTU	RDF%
	ml after 10 minutes	ml total	ml total			
100% enzyme blend	159	206	13.06	5.70	3	72.0
125% enzyme blend	169	208	13.12	5.70	4	72.0
150% enzyme blend	164	204	13.12	5.70	3	72.4
175% enzyme blend	145	204	13.06	5.70	3	72.9
200% enzyme blend	147	205	13.10	5.70	3	72.9
300% enzyme blend	150	204	13.21	5.70	3	73.5

[0219] With all tested amounts of enzyme blend comprising α -amylase activity, β -glucanase activity, protease activity, lipase activity and a pullulanase the wort produced had a very high amount of RDF above 70 %, it was slightly increasing with increasing amounts of enzyme blend. However, a high RDF and good filterability was obtained with 2 kg/1000 kg enzyme blend/ raw material, which corresponded to 100 % enzyme blend. Importantly the total mashing time was 2 hours.

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Ala Arg Pro Phe Thr Asp Pro Lys Tyr Glu Phe Leu Asn Asp Phe Val
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Tyr Thr Phe Gly Val Ala Asp Leu Leu Pro Phe Gly Ala Asn Gln Ser
85 90 95
Tyr Gln Thr Gly Thr Asp Met Tyr Thr Arg Tyr Ser Thr Leu Phe Glu
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Gly Gly Asp Val Pro Phe Val Arg Ala Ala Gly Asp Gln Arg Val Val
115 120 125
Asp Ser Ser Thr Asn Trp Thr Ala Gly Phe Gly Asp Ala Ser Gly Glu
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145 150 155 160
Thr Leu Cys Asn Asn Met Cys Pro Asn Trp Val Lys Gly Asp Glu Ser
165 170 175
Thr Thr Trp Leu Gly Val Phe Ala Pro Asn Ile Thr Ala Arg Leu Asn
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Met Asp Met Cys Pro Phe Asp Thr Leu Ser Ser Gly Asn Ala Ser Pro
210 215 220
Phe Cys Asp Leu Phe Thr Ala Glu Glu Tyr Thr Ser Tyr Glu Tyr Tyr
225 230 235 240
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Pro Val Gln Gly Val Gly Tyr Val Asn Glu Leu Leu Ala Arg Leu Thr
260 265 270
Gly Gln Ala Val Arg Asp Glu Thr Gln Thr Asn Arg Thr Leu Asp Ser
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Gln Pro Leu Glu Phe Cys Gly Gly Val Asp Gly Val Cys Glu Leu Ser
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<212> PRT

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 Thr Gln Asp Trp Thr Lys Asp Val Ser Ala Asp Arg Tyr Ile Asp Leu
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 Ser Lys Gly Asn Glu Val Trp Leu Val Glu Gly Asn Ser Gln Ile Phe
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 Tyr Asn Glu Lys Asp Ala Glu Asp Ala Ala Lys Pro Ala Val Ser Asn
 100 105 110
 Ala Tyr Leu Asp Ala Ser Asn Gln Val Leu Val Lys Leu Ser Gln Pro
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 Leu Thr Leu Gly Glu Gly Ala Ser Gly Phe Thr Val His Asp Asp Thr
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 Ala Asn Lys Asp Ile Pro Val Thr Ser Val Lys Asp Ala Ser Leu Gly
 145 150 155 160
 Gln Asp Val Thr Ala Val Leu Ala Gly Thr Phe Gln His Ile Phe Gly
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 Gly Ser Asp Trp Ala Pro Asp Asn His Ser Thr Leu Leu Lys Lys Val
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 Thr Asn Asn Leu Tyr Gln Phe Ser Gly Asp Leu Pro Glu Gly Asn Tyr
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 Gln Tyr Lys Val Ala Leu Asn Asp Ser Trp Asn Asn Pro Ser Tyr Pro
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 Ser Asp Asn Ile Asn Leu Thr Val Pro Ala Gly Gly Ala His Val Thr
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Phe Ser Tyr Ile Pro Ser Thr His Ala Val Tyr Asp Thr Ile Asn Asn
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 Pro Asn Ala Asp Leu Gln Val Glu Ser Gly Val Lys Thr Asp Leu Val
 260 265 270
 Thr Val Thr Leu Gly Glu Asp Pro Asp Val Ser His Thr Leu Ser Ile
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 Trp Asn Ser Asp Lys His Ile Thr Pro Lys Asn Ile Glu Asp Glu Val
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 Gly Val Asn Met Asp Val Val Tyr Asn His Thr Phe Ala Thr Gln Ile
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 Ser Asp Phe Asp Lys Ile Val Pro Glu Tyr Tyr Tyr Arg Thr Asp Asp
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 Ala Gly Asn Tyr Thr Asn Gly Ser Gly Thr Gly Asn Glu Ile Ala Ala
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 Glu Arg Pro Met Val Gln Lys Phe Ile Ile Asp Ser Leu Lys Tyr Trp
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 Val Asn Glu Tyr His Ile Asp Gly Phe Arg Phe Asp Leu Met Ala Leu
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 Leu Gly Lys Asp Thr Met Ser Lys Ala Ala Ser Glu Leu His Ala Ile
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 645 650 655
 Ala Leu Pro Asp Asp Gln Leu Leu Thr Lys Gly Ala Gln Lys Gly Met
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 Gly Val Ala Val Phe Asn Asp Asn Leu Arg Asn Ala Leu Asp Gly Asn
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 Val Phe Asp Ser Ser Ala Gln Gly Phe Ala Thr Gly Ala Thr Gly Leu
 690 695 700
 Thr Asp Ala Ile Lys Asn Gly Val Glu Gly Ser Ile Asn Asp Phe Thr
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 Ser Ser Pro Gly Glu Thr Ile Asn Tyr Val Thr Ser His Asp Asn Tyr
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 Thr Leu Trp Asp Lys Ile Ala Leu Ser Asn Pro Asn Asp Ser Glu Ala
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 Asp Arg Ile Lys Met Asp Glu Leu Ala Gln Ala Val Val Met Thr Ser
 755 760 765
 Gln Gly Val Pro Phe Met Gln Gly Gly Glu Glu Met Leu Arg Thr Lys
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 Gly Gly Asn Asp Asn Ser Tyr Asn Ala Gly Asp Ala Val Asn Glu Phe
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 Gly Leu Ile His Leu Arg Leu Asp His Pro Ala Phe Arg Met Thr Thr
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 835 840 845
 Thr Val Ala Tyr Glu Leu Thr Asp His Val Asn Lys Asp Lys Trp Gly
 850 855 860
 Asn Ile Ile Val Val Tyr Asn Pro Asn Lys Thr Val Ala Thr Ile Asn
 865 870 875 880
 Leu Pro Ser Gly Lys Trp Ala Ile Asn Ala Thr Ser Gly Lys Val Gly
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<212> PRT

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 35 40 45
 Lys Ala Asp Val Gln Val Pro Gly Asp Asp Thr Gln Val Gly Leu Ile
 50 55 60
 Val Arg Thr Asn Asp Trp Ser Gln Lys Asn Thr Ser Asp Asp Leu His
 65 70 75 80
 Ile Asp Leu Thr Lys Gly His Glu Ile Trp Ile Val Gln Gly Asp Pro
 85 90 95
 Asn Ile Tyr Tyr Asn Leu Ser Asp Ala Gln Ala Ala Ala Thr Pro Lys
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 130 135 140
 Asp Lys Thr Thr Gly Glu Gln Ile Pro Val Thr Ala Ala Thr Asn Ala
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 Asn Ser Ala Ser Ser Ser Glu Gln Thr Asp Leu Val Gln Leu Thr Leu
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 Tyr Glu Ala Val Asn Leu Ile Pro Arg Asn Val Leu Asn Leu Pro Arg
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 290 295 300
 Met Ile Val Asp Leu Glu Asp Thr Asn Pro Pro Gly Trp Lys Glu Asp
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 His Gln Gln Thr Pro Ala Asn Pro Val Asp Glu Val Ile Tyr Glu Val
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 His Val Arg Asp Phe Ser Ile Asp Ala Asn Ser Gly Met Lys Asn Lys
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 Gly Lys Tyr Leu Ala Phe Thr Glu His Gly Thr Lys Gly Pro Asp Asn
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Gln Leu Gln Pro Ile Glu Glu Phe Asn Ser Ile Asp Glu Thr Gln Pro
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Thr Asn Gly Ser Gly Val Gly Asn Glu Ile Ala Thr Glu Arg Pro Met
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Val Gln Lys Phe Val Leu Asp Ser Val Lys Tyr Trp Val Lys Glu Tyr
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His Ile Asp Gly Phe Arg Phe Asp Leu Met Ala Leu Leu Gly Lys Asp
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Ser Ala Gln Gly Phe Ala Thr Gly Asp Pro Asn Gln Val Asn Val Ile
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Glu Thr Ile Asn Tyr Val Thr Ser His Asp Asn Met Thr Leu Trp Asp
 625 630 635 640

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Glu Val Ser Gln Asp Leu Phe Asn Gln Phe Asn Leu Phe Ala Gln Tyr
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 Asn Ile Thr Cys Thr Gly Asn Ala Cys Pro Glu Val Glu Lys Ala Asp
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 Arg Gly Ser Arg Ser Ile Glu Asn Trp Ile Gly Asn Leu Asn Phe Asp
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 Leu Lys Glu Ile Asn Asp Ile Cys Ser Gly Cys Arg Gly His Asp Gly
 100 105 110
 Phe Thr Ser Ser Trp Arg Ser Val Ala Asp Thr Leu Arg Gln Lys Val
 115 120 125
 Glu Asp Ala Val Arg Glu His Pro Asp Tyr Arg Val Val Phe Thr Gly
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 His Ser Leu Gly Gly Ala Leu Ala Thr Val Ala Gly Ala Asp Leu Arg
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 Gly Asn Arg Ala Phe Ala Glu Phe Leu Thr Val Gln Thr Gly Gly Thr
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 Ala His Leu Trp Tyr Phe Gly Leu Ile Gly Thr Cys Leu
 260 265

REFERENCES CITED IN THE DESCRIPTION

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PATENTKRAV

1. Fremgangsmåde til fremstilling af en ølurt, hvilken fremgangsmåde omfatter:

- 5 a. opnåelse af en mask ved mæskning af en maltskrå, hvoraf mindst 70 vægtprocent er umaltet korn, som omfatter β -amylase, og hvoraf mindre end 30 vægtprocent er maltet korn, ved en temperatur, ved hvilken eksogene (tilsatte) enzymer og den endogene β -amylase er aktive;
- 10 b. etablering af kontakt mellem masken og eksogene enzymer, hvilke enzymer omfatter:
- i. en α -amylase,
 - ii. en pullulanase,
 - iii. en protease,
 - iv. en β -glucanase,
 - v. en lipase og
 - vi. en xylanase;
- 15 c. afmæskning og frafiltrering af masken for at opnå urten.

2. Fremgangsmåde ifølge krav 1, hvor maltskråen omfatter mindst 75 vægtprocent umaltet korn.

20 3. Fremgangsmåde ifølge krav 1 eller 2, hvor det umaltede korn er byg, spelt, hvede, rug, majs, havre eller ris eller en hvilken som helst blanding deraf.

4. Fremgangsmåde ifølge et hvilket som helst af kravene 2 eller 3, hvor det umaltede korn er byg.

25 5. Fremgangsmåde ifølge et hvilket som helst af de foregående krav, hvor maltskråen endvidere omfatter andre carbohydrtkilder, såsom brygsirupper.

30 6. Fremgangsmåde ifølge et hvilket som helst af de foregående krav, hvor de eksogene enzymer i trin b. i krav 1 endvidere omfatter en phytase.

7. Fremgangsmåde ifølge et hvilket som helst af de foregående krav, hvor mæskningstemperaturen ligger i et interval, som optimerer β -amylasen.

8. Fremgangsmåde ifølge et hvilket som helst af de foregående krav, hvor proteasen tilvejebringes af et system med proteolytiske enzymer, der indbefatter endoproteaser, eksopeptidaser eller en hvilken som helst kombination deraf.

5 9. Fremgangsmåde ifølge krav 1, hvor lipasen tilvejebringes i form af en lipase fra *Fusarium*, *Aspergillus* eller *Rhizopus*.

10. Anvendelse af en fremgangsmåde ifølge et hvilket som helst af de foregående krav til fremstilling af øl.

10

DRAWINGS

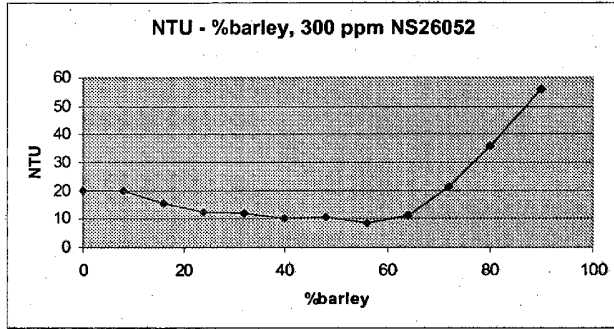


Figure 1

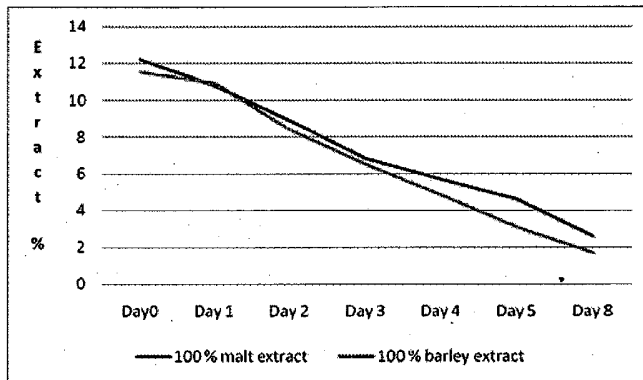


Figure 2