



(22) Date de dépôt/Filing Date: 2007/03/19  
(41) Mise à la disp. pub./Open to Public Insp.: 2007/09/20  
(30) Priorité/Priority: 2006/03/20 (US60/783,417)

(51) Cl.Int./Int.Cl. *A23C 9/15* (2006.01),  
*A23C 1/00* (2006.01), *A23C 9/00* (2006.01)

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(54) Titre : COMPOSITION ET METHODE DE BLANCHIMENT DE BOISSONS  
(54) Title: BEVERAGE WHITENING COMPOSITION AND METHOD

(57) **Abrégé/Abstract:**

A beverage whitening composition for replacing cream or milk in a reduced volume comprising: cream having a higher butter fat content than the cream or milk to be replaced; milk having a lower butter fat content than the cream or milk to be replaced; and serum solids, such as skim milk powder. The composition has the beverage whitening ability of the cream or milk to be replaced in a target volume of from 30% to 95% of the volume of cream or milk to be replaced. The composition is formulated so that from 300 mL to 950 mL of the composition has the whitening ability of 1 litre of the cream or milk to be replaced. The composition is useful for replacing conventional coffee cream in dispensers containing bags of cream so as to reduce frequency of bag replacement.



**ABSTRACT**

A beverage whitening composition for replacing cream or milk in a reduced volume comprising: cream having a higher butter fat content than the cream or milk to be replaced; milk having a lower butter fat content than the cream or milk to be replaced; and serum solids, such as skim milk powder. The composition has the beverage whitening ability of the cream or milk to be replaced in a target volume of from 30% to 95% of the volume of cream or milk to be replaced. The composition is formulated so that from 300 mL to 950 mL of the composition has the whitening ability of 1 litre of the cream or milk to be replaced. The composition is useful for replacing conventional coffee cream in dispensers containing bags of cream so as to reduce frequency of bag replacement.

## BEVERAGE WHITENING COMPOSITION AND METHOD

### FIELD OF THE INVENTION

**[0001]** The present invention relates generally to a beverage whitening composition. More particularly, the present invention relates to a liquid composition including primarily milk-based ingredients for whitening hot beverages such as coffee or tea.

### BACKGROUND OF THE INVENTION

**[0002]** The most common method of whitening a beverage such as coffee or tea is to add cream or milk. Coffee shops that dispense large volumes of cream or milk may use dispensing equipment that contains large fluid volumes. One example of such dispensing equipment is described in applicant's co-pending U.S. patent application 10/830,033 published as U.S. Patent Application Publication No. 2005/0236429 A1, the entirety of which is herein incorporated by reference. Control of dispensing volume may be an available feature of the dispensing equipment, having the advantage of rendering a consistent product when a customer orders, for example, a whitened beverage with "double cream". A coffee shop using dispensing equipment will periodically need to replace the bags of cream or milk contained therein. Bag replacement frequency may be, for example, every 3 or 4 hours. This replacement frequency increases during the busiest times of the day, which can create delays in customer service.

**[0003]** Cream dispensed to whiten a beverage such as coffee typically contains 10% or 18% butter fat (b.f.). It is not optimal to consumer acceptance to simply substitute 20% or 35% b.f. cream, respectively, at half of the normally dispensed volume, because although the b.f. content is increased, the whitening effect attributable to non-fat milk solids is not achieved. A beverage so whitened is not as acceptable to the customer, and can clearly be distinguished from the 10% or 18% cream to which a customer may have grown accustomed.

**[0004]** Beverage whitening products other than cream or milk are available, but rarely provide the same taste and organoleptic properties as cream or milk. Customers in a coffee shop who have become used to cream or milk would not find such substitutes acceptable. Condensed milk offers a highly viscous consistency, and is not easily dispensed or dispersed into a beverage. Powdered whitener formulations are not dispensable in a liquid form, and also require additional agitation to disperse properly into a beverage.

**[0005]** U.S. Patent No. 6,887,505 (Reaves *et al.*) teaches a milk concentrate formed through ultra-high temperature pasteurization (UHT), intended for reconstitution into a milk beverage. The concentrate is formed by evaporating liquid from a fresh milk product, which requires labor-intensive processing. In general, conventional concentrated or condensed milk products are formed in this way, by a processing-intensive step involving removal of water. Prior to reconstitution, such concentrates would not be an acceptable addition to beverages such as coffee or tea.

**[0006]** U.S. Patent No. 6,627,243 (Cherian *et al.*) describes a cream substitute containing butter, a thickening agent, and a food protein. The cream substitute is intended for cooked or baked food products normally requiring cream, such as sauces, soups or cream-filled pastries, and requires starch or gum as a thickening agent. European Patent EP 0 714 609 B1 describes whipping cream compositions with low fat content that are suitable for preparing whipped or frozen desserts. U.S. Patent No 6,248,389 (Biller *et al.*) describes a cream substitute for addition to food recipes that require cream. The substitute is provided in a non-liquid form, such as a cube, powder, or a semi-solid (extrudable) product. Such products as these are not appropriate as whiteners for beverages.

**[0007]** U.S. Patent No. 4,045,589 (Petrowski *et al.*) provides a non-dairy fat emulsion suitable for whitening coffee. The emulsion includes a variety of non-milk solids that would impact the taste of coffee when compared with cream. U.S. Patent No. 6,824,810 (Sargent *et al.*) describes a creamer composition that may be in either liquid or powdered form containing non-dairy ingredients that are microparticulated to specified dimensions so as to prevent aggregation of particles.

**[0008]** Others have attempted to provide concentrated coffee products to which water can be added. U.S. Patents No. 6,447,830 and No. 6,548,101 (both to Cevallos *et al.*) describe a whitened coffee concentrate that includes milk solids as well as coffee solids, which can be constituted to an appropriate strength for consumption. Patent GB 1415844 describes a whitened coffee concentrate, including a coffee extract, to which water may be added to reconstitute a coffee beverage.

**[0009]** There is a need for a beverage whitening composition capable of achieving taste, whitening, and organoleptic properties similar to cream or milk when added to a beverage, when delivered to the beverage in a reduced volume.

### **SUMMARY OF THE INVENTION**

**[0010]** It is an object of the present invention to obviate or mitigate at least one disadvantage of previous beverage whitening compositions.

**[0011]** According to an embodiment of the invention, there is provided a beverage whitening composition for replacing cream or milk in a reduced volume comprising: cream having a higher butter fat content than the cream or milk to be replaced; milk having a lower butter fat content than the cream or milk to be replaced; and skim milk powder; the composition having the beverage whitening ability of the cream or milk to be replaced in a target volume of from 30% to 95% of the volume of cream or milk to be replaced.

**[0012]** Further, an embodiment of the invention provides a method of whitening a beverage, comprising adding to the beverage the composition herein described.

**[0013]** According to another embodiment of the invention, there is provided a method of formulating a beverage whitening composition for replacing cream or milk in a reduced volume comprising the step of combining: cream having a higher butter fat content than the cream or milk to be replaced; milk having a lower butter fat content than the cream or milk to be replaced; and serum solids. The composition so formed has the beverage whitening ability of the cream or milk to be replaced in a target volume of from 30% to 95% of the volume of cream or milk to be replaced.

**[0014]** Other aspects and features of the present invention will become apparent to those ordinarily skilled in the art upon review of the following description of specific embodiments of the invention in conjunction with the accompanying figures.

#### **BRIEF DESCRIPTION OF THE DRAWINGS**

**[0015]** Embodiments of the present invention will now be described, by way of example only, with reference to the attached Figures.

**[0016]** Fig. 1 is a graphic depiction of parameters to be considered according to an embodiment of the invention.

#### **DETAILED DESCRIPTION**

**[0017]** Generally, the present invention provides a composition and method for whitening a beverage. The beverage to be whitened may be any drink that is served hot or cold to which cream or milk may be added. Examples of beverages to which cream or milk are traditionally added include coffee and tea.

**[0018]** As used herein, the term serum solids refers to non-fat solids, typically isolated from milk, but which may also be isolated from other non-milk sources. Examples of serum solids include skim milk powder, isolated non-fat milk components such as milk protein, and whitening products that may be from plant-based sources such as from soy. The term MSNF (milk solids, non-fat) may be used to indicate serum solids derived from milk sources.

**[0019]** As discussed herein, a target volume is defined as a percentage of the original volume. In all instances, the target volume is a reduced volume compared to the amount of cream or milk required to achieve the same whitening effect. For example, if a target volume is 80%, this means that for an original volume of 1000 mL of cream, the beverage whitening composition according to the invention would have a volume of 800 mL. The target volume of 80% results in a reduced volume of 800 mL, compared to the 1000 mL of cream that

would have otherwise been required to achieve the same beverage whitening effect, or a beverage whitening effect that is indistinguishable to a consumer of a beverage so whitened.

**[0020]** Aside from target volume, most other quantitative amounts discussed herein are determined on a % wt/wt basis. For example, for butter fat content, or quantities of the components that make up the composition, these are generally given on a % wt/wt basis, as indicated.

**[0021]** The term "b.f." is used herein to mean butter fat.

**[0022]** The term "beverage whitening ability" refers to the lightness of color of a beverage to be whitened using cream or milk. This parameter can be evaluated using visual inspection, for example by a human subject who may be planning on consuming the whitened beverage, or can be determined using instrumentation capable of measuring color-related parameters. Adequate similarity in beverage whitening ability, as would be understood by a person of skill in the art, is deemed to be a level that is either indistinguishable, or acceptably distinguishable to a consumer who may be planning on consuming the whitened beverage. For example, the ability for 18% b.f. cream to whiten a beverage is unacceptably distinguishable to such a consumer in whitening ability as compared with skim milk. A consumer wishing to consume a coffee beverage whitened to the level obtainable by cream would deem this difference to be unacceptably distinguishable.

**[0023]** Beverage whitening ability depends on both the butter fat content and the serum solids content. Thus, for example, if the butter fat content alone is doubled in a cream product, it cannot be used in half the volume to achieve the same beverage whitening ability as the original volume of cream to be replaced. In other words, 10 mL of 20% cream does not have the same beverage whitening ability as 20 mL of 10% cream. As a further example, if the serum solids content alone is doubled in a milk product, it cannot be used in half the volume to achieve the same beverage whitening ability as the original volume of milk to be replaced. In other words, 20 mL of milk will not have the same beverage whitening ability as 10 mL of milk which has been formulated to have double the serum solids volume. The invention is founded on the findings that both serum solids and fat content must be adjusted

in order to achieve the same beverage whitening ability, as well as on careful experimentation to develop and optimize compositions able to achieve this objective.

**[0024]** In one embodiment, a beverage whitening composition is provided for replacing cream or milk in a reduced volume comprising: cream having a higher butter fat content than the cream or milk to be replaced; milk having a lower butter fat content than the cream or milk to be replaced; and serum solids. The composition has the beverage whitening ability of the cream or milk to be replaced in a target volume of from 30% to 95% of the volume of cream or milk to be replaced. In other words, a volume of from 300 mL to 950 mL of the composition, depending on the selected target volume, would have the beverage whitening ability of 1 Litre or the cream or milk to be replaced.

**[0025]** When so formulated, the composition contains from 105 % (100/95) to 333% (100/30) wt/wt of the butter fat content of the cream or milk to be replaced. The butter fat content of the composition may be calculated as the inverse of the target volume.

**[0026]** Further, the total non-fat solids content of the composition may be from 105% (100/95) to 333% (100/30) wt/wt of the non-fat milk solids content of the cream or milk to be replaced. The total non-fat solids content of the composition may be calculated as the inverse of the target volume.

**[0027]** The butter fat content of the composition (as % wt/wt) may be calculated as  $F_T = (F_C \times Q_C) + (F_M \times Q_M)$  wherein  $F_C$  is the % wt/wt butter fat content of the cream,  $Q_C$  is the % wt/wt of the composition attributable to cream,  $F_M$  is the % wt/wt butter fat content of the milk, and  $Q_M$  is the % wt/wt of the composition attributable to milk.

**[0028]** The total non-fat solids content of the composition may be calculated as  $S_T = (S_C \times Q_C) + (S_M \times Q_M) + (Q_P)$  wherein  $S_C$  is the % wt/wt non-fat milk solids content of the cream,  $Q_C$  is the % wt/wt of the composition attributable to cream,  $S_M$  is the % wt/wt non-fat milk solids content of the milk,  $Q_M$  is the % wt/wt of the composition attributable to milk, and  $Q_P$  is the % wt/wt of the composition attributable to serum solids.

**[0029]** Cream may comprise from 1 to 90% wt/wt of the composition, the cream component having from 5 to 40% wt/wt butter fat. Milk may comprise from 1 to 90% wt/wt of

the composition, the milk component having from 0 to 4% wt/wt butter fat. Serum solids may comprise from 1 to 30% wt/wt of the composition.

**[0030]** An exemplary composition may have 30% wt/wt whole milk having 3.25% wt/wt butter fat, 67% wt/wt cream having 42% wt/wt butter fat, 2.7% wt/wt serum solids, and 0.3% wt/wt stabilizer. Further, another exemplary composition may have 28% wt/wt skim milk, 69% wt/wt cream having 42% wt/wt butter fat, 2.7% wt/wt serum solids, and 0.3% wt/wt stabilizer.

**[0031]** An exemplary target volume may be from 45% to 95%, and a more specific exemplary range for the target volume may be from 60 to 85% of the volume of cream or milk to be replaced. For example, an 18% wt/wt butter fat cream may be replaced in a target volume of 60% so that 600 mL of the composition according to the invention can replace 1 Litre of the 18% cream and still maintain the beverage whitening ability.

**[0032]** The invention also provides a method of whitening a beverage comprising adding to the beverage the inventive composition described herein. Such a beverage requires only the target volume of the inventive composition to be added to achieve the desired effect, which allows a reduced volume to be dispensed into the beverage, compared to using cream or milk.

**[0033]** The invention further provides a method of formulating a beverage whitening composition for replacing cream or milk in a reduced volume comprising the step of combining cream having a higher butter fat content than the cream or milk to be replaced; and milk having a lower butter fat content than the cream or milk to be replaced; with serum solids, so that the composition has the beverage whitening ability of the cream or milk to be replaced in a target volume of from 30% to 95% of the volume of cream or milk to be replaced.

**[0034]** For example, the method of formulating such a composition may comprise combining from 1 to 90% wt/wt of the composition as cream; from 1 to 90% wt/wt of the composition as milk; and from 1 to 30% wt/wt of the composition as serum solids.

**[0035]** In one embodiment of the invention, a cream composition that includes a higher butter fat content and a higher total non-fat solids content (the sum of the "serum

solids" plus non-fat solids from the milk and cream components) than the cream to be replaced is provided, thereby allowing a smaller volume to be dispensed into a cup of coffee in order to achieve the same whitening effect and the same butter fat content as 18% b.f. cream. Cream and milk provide the fluid, butter fat, and some serum solids content. Serum solids, such as from skim milk powder, provides remaining total non-fat solids required.

**[0036]** Possible lacteal (milk-based) ingredients for formulating a composition according to the invention include table cream (18% b.f.); half-and-half (10% b.f.) raw cream (41% b.f., 49.9% total solids); whole milk (3.25% b.f.); skim milk, and skim milk powder. These ingredients are readily purchased, but other percentages butter fat in cream or milk may be used. Non-lacteal ingredients may be used in the serum solids component, such as soy-based non-fat solids.

**[0037]** A cream stabilizer may be added to the composition. Possible stabilizers for use with the invention include coffee cream stabilizer CC471 (Continental Custom Ingredients, Oakville, Canada), which includes sodium citrate, disodium phosphate, carrageenan, and dextrose; coffee cream stabilizer Germantown Salvo (Danisco, Scarborough, Canada), containing sodium citrate, sodium phosphate, carrageenan, locust bean gum, and dextrose; or food grade disodium phosphate, such as provided by Astaris (St. Louis, MO).

**[0038] EXAMPLE 1**

**[0039] Composition for Replacement of 18% b.f. Cream**

**[0040]** A cream-based composition is provided which contains (%wt/wt): 30% whole milk (3.25% b.f.); 67% cream (42% b.f.); 2.7% skim milk powder; and 0.3% stabilizers. This composition is concentrated in both butter fat and serum solids, relative to the 18% cream to be replaced, and achieves a target volume of 60% of the 18% b.f. cream it is designed to replace. In other words, 600 mL of the composition will have the beverage whitening ability of 1 Litre of the 18% cream to be replaced. To state this in yet another way, the composition allows about a 40% reduction in the amount of cream dispensed, while achieving good

consumer acceptance. A corresponding 40% reduction in the frequency of cream bag replacement in a cream dispenser is realized.

**[0041]** To prepare the composition, dry ingredients were pre-hydrated in approximately the equivalent quantity of whole milk using a lab-scale Silverson high-speed mixer at 5500 rpm for about 5 minutes total mixing time. Following this, the pre-hydrated ingredients were slowly added to the remaining ingredients in a 40 L milk can and mixed for approximately 5 minutes using a pilot-scale Silverson high-speed mixer. All heavy cream samples were processed on a Microthermics HTST/UHT unit by pre-heating to 60 °C, and homogenized at 1500 PST (first stage), then at 500 PSI (second stage). The homogenized composition was then pasteurized at 80 °C/ 30 seconds, and immediately cooled to approximately 14 °C. Samples were packed into 10L Schole™ bags and refrigerated.

**[0042]** The resulting product contained 28.92% b.f. A contribution of 12 g of this composition to an 8 oz cup of coffee resulted in 0.49 g protein, 1.28 g of total non-fat solids, and the coffee had a pH of 5.86. Relative to the control, consisting of 18 g of 18% b.f. table cream, the contributions were nearly identical, with 0.49 g protein, 1.25 g milk solids (non-fat) and a pH of 5.85.

**[0043]** The Zahn cup measurement test for coffee whitened according to this example resulted in a measurement of 21.9 sec at 3°C. The control measurement was 18.5 sec at 6°C. The color measurements for whitened coffee was 48.1 (L); 4.8(a) and 20.3(b), versus 52.7(L); 4.2(a) and 20.3(b) for the control. Fat globule size in the whitened coffee was 1.93 µm using the composition; and 0.78 µm for the control, which was still deemed within the realm of consumer acceptability. The particle size distribution in terms of specific surface area (m<sup>2</sup>/mL) was 7.57 for coffee whitened using the composition, versus 10.37 for the control. Overall, these values illustrate the acceptability of the inventive composition as a beverage whitener. The whitening ability is considered adequately similar in the composition versus control to achieve consumer acceptability.

**[0044] EXAMPLE 2****[0045] Composition for Replacement of 18% b.f. Cream**

**[0046]** A cream-based composition is provided which contains (%wt/wt): 28% skim milk; 69% cream (42% b.f.); 2.7% skim milk powder; and 0.3% stabilizers. This composition is concentrated in both butter fat and total non-fat solids. The target volume for the composition is about 60% of the original volume of 18% b.f. cream. This allows about a 40% reduction in the amount of cream dispensed, while providing good consumer acceptance.

**[0047]** To prepare the composition, dry ingredients were pre-hydrated in approximately the equivalent quantity of skim milk using a lab-scale Silverson high-speed mixer at 5500 rpm for about 5 minutes total mixing time. Following this, the pre-hydrated ingredients were slowly added to the remaining ingredients in a 40 L milk can and mixed for approximately 5 minutes using a pilot-scale Silverson high-speed mixer. All heavy cream samples were processed on a Microthermics HTST/UHT unit by pre-heating to 60 °C, and homogenized at 1500 PST (first stage), then at 500 PSI (second stage). The homogenized composition was then pasteurized at 80 °C/ 30 seconds, and immediately cooled to approximately 14 °C. Samples were packed into 10L Schole™ bags and refrigerated.

**[0048]** The resulting product contained 28.92% b.f., and a contribution of 12 g of this composition to an 8 oz cup of coffee resulted in 0.49 g protein, 1.29 g of total non-fat solids, and the resulting whitened coffee had a pH of 5.86. Relative to the control, consisting of 18 g of 18% table cream, the contributions were nearly identical, with 0.49 g protein, 1.25 g milk solids (non-fat) and a pH of 5.85.

**[0049]** The Zahn cup measurement test for coffee whitened according to this example resulted in a measurement of 23.4 sec at 3°C. The control measurement was 18.5 sec at 6°C. The color measurements for whitened coffee was 46.4 (L); 5.4(a) and 20.5(b), versus 52.7(L); 4.2(a) and 20.3(b) for the control. Fat globule size in the test whitened coffee was 1.61 µm using the composition; and 0.78 µm for the control, which was deemed within the realm of consumer acceptability. The particle size distribution in terms of specific surface area (m<sup>2</sup>/mL) was 7.47 for coffee whitened using the test composition, versus 10.37 for the control. Overall, these values illustrate the acceptability of the inventive composition as a

beverage whitener. The whitening ability of the test composition was deemed to be adequate to replace 18% b.f. cream with good consumer acceptance.

**[0050]** The above-described embodiments of the present invention are intended to be examples only. Alterations, modifications and variations may be effected to the particular embodiments by those of skill in the art without departing from the scope of the invention, which is defined solely by the claims appended hereto.

**CLAIMS:**

1. A beverage whitening composition for replacing cream or milk in a reduced volume comprising:  
cream having a higher butter fat content than the cream or milk to be replaced;  
milk having a lower butter fat content than the cream or milk to be replaced; and  
serum solids;  
the composition having the beverage whitening ability of the cream or milk to be replaced in a target volume of from 30% to 95% of the volume of cream or milk to be replaced.
2. The composition of claim 1 comprising from 105 % (100/95) to 333% (100/30) wt/wt of the butter fat content of the cream or milk to be replaced.
3. The composition of claim 1 or claim 2 comprising a butter fat content, when expressed as a percentage relative to the cream or milk to be replaced, that is the inverse of the target volume (%).
4. The composition of any one of claims 1 to 3 comprising a total non-fat solids content from 105% (100/95) to 333% (100/30) wt/wt of non-fat milk solids content of the cream or milk to be replaced.
5. The composition of claim 4 comprising a total non-fat solids content, when expressed as a percentage relative to the cream or milk to be replaced, that is the inverse of the target volume (%).
6. The composition of any one of claims 1 to 5 wherein the butter fat content (% wt/wt) is calculated as  $F_T = (F_C \times Q_C) + (F_M \times Q_M)$  wherein  $F_C$  is the % wt/wt butter fat content of the cream,  $Q_C$  is the portion (% wt/wt) of the composition attributable to cream,  $F_M$  is the % wt/wt

butter fat content of the milk, and  $Q_M$  is the portion (% wt/wt) of the composition attributable to milk.

7. The composition of any one of claims 1 to 6 wherein total non-fat solids content (% wt/wt) of the composition is calculated as  $S_T = (S_C \times Q_C) + (S_M \times Q_M) + (Q_P)$  wherein  $S_C$  is the % wt/wt non-fat milk solids content of the cream,  $Q_C$  is the portion (% wt/wt) of the composition attributable to cream,  $S_M$  is the % wt/wt non-fat milk solids content of the milk,  $Q_M$  is the portion (% wt/wt) of the composition attributable to milk, and  $Q_P$  is the portion (% wt/wt) of the composition attributable to serum solids.

8. The composition of any one of claims 1 to 7 wherein cream comprises from 1 to 90% wt/wt of the composition.

9. The composition of any one of claims 1 to 7 wherein milk comprises from 1 to 90% wt/wt of the composition.

10. The composition of any one of claims 1 to 7 wherein serum solids comprise from 1 to 30% wt/wt of the composition.

11. The composition of any one of claims 1 to 10 wherein the milk contains from 0 to 4% wt/wt butter fat.

12. The composition of any one of claims 1 to 10 wherein the cream contains from 5 to 40% wt/wt butter fat.

13. The composition of any one of claims 1 to 12 additionally comprising a stabilizer.

14. The composition of claim 13 comprising 30% wt/wt whole milk having 3.25% wt/wt butter fat; 67% wt/wt cream having 42% wt/wt butter fat; 2.7% wt/wt serum solids; and 0.3% wt/wt stabilizer.

15. The composition of claim 13 comprising 28% wt/wt skim milk, 69% wt/wt cream having 42% wt/wt butter fat, 2.7% wt/wt serum solids, and 0.3% wt/wt stabilizer.
16. The composition of any one of claims 1 to 7 wherein the target volume is from 45 to 95% of the volume of cream or milk to be replaced; whereby from 450 mL to 950 mL of the composition has the beverage whitening ability of 1 litre of cream or milk to be replaced.
17. The composition of any one of claims 1 to 7 wherein the target volume is from 60 to 85% of the volume of cream or milk to be replaced; whereby from 600 mL to 850 mL of the composition has the beverage whitening ability of 1 litre of cream or milk to be replaced.
18. The composition of any one of claims 1 to 7 wherein 18% wt/wt butter fat cream is replaced in a target volume of 60%.
19. A method of whitening a beverage comprising adding to the beverage the composition of any one of claims 1 to 18.
20. A method of formulating a beverage whitening composition for replacing cream or milk in a reduced volume comprising combining:
  - cream having a higher butter fat content than the cream or milk to be replaced;
  - milk having a lower butter fat content than the cream or milk to be replaced; and
  - serum solids;the composition having the beverage whitening ability of the cream or milk to be replaced in a target volume of from 30% to 95% of the volume of cream or milk to be replaced.
21. The method of claim 20 wherein cream comprises from 1 to 90% wt/wt of the composition; milk comprises from 1 to 90% wt/wt of the composition; and serum solids comprise from 1 to 30% wt/wt of the composition.

22. The method of claim 20 or claim 21 wherein the target volume is from 45% to 95%.
23. The method of claim 22 wherein the target volume is from 60% to 85%.

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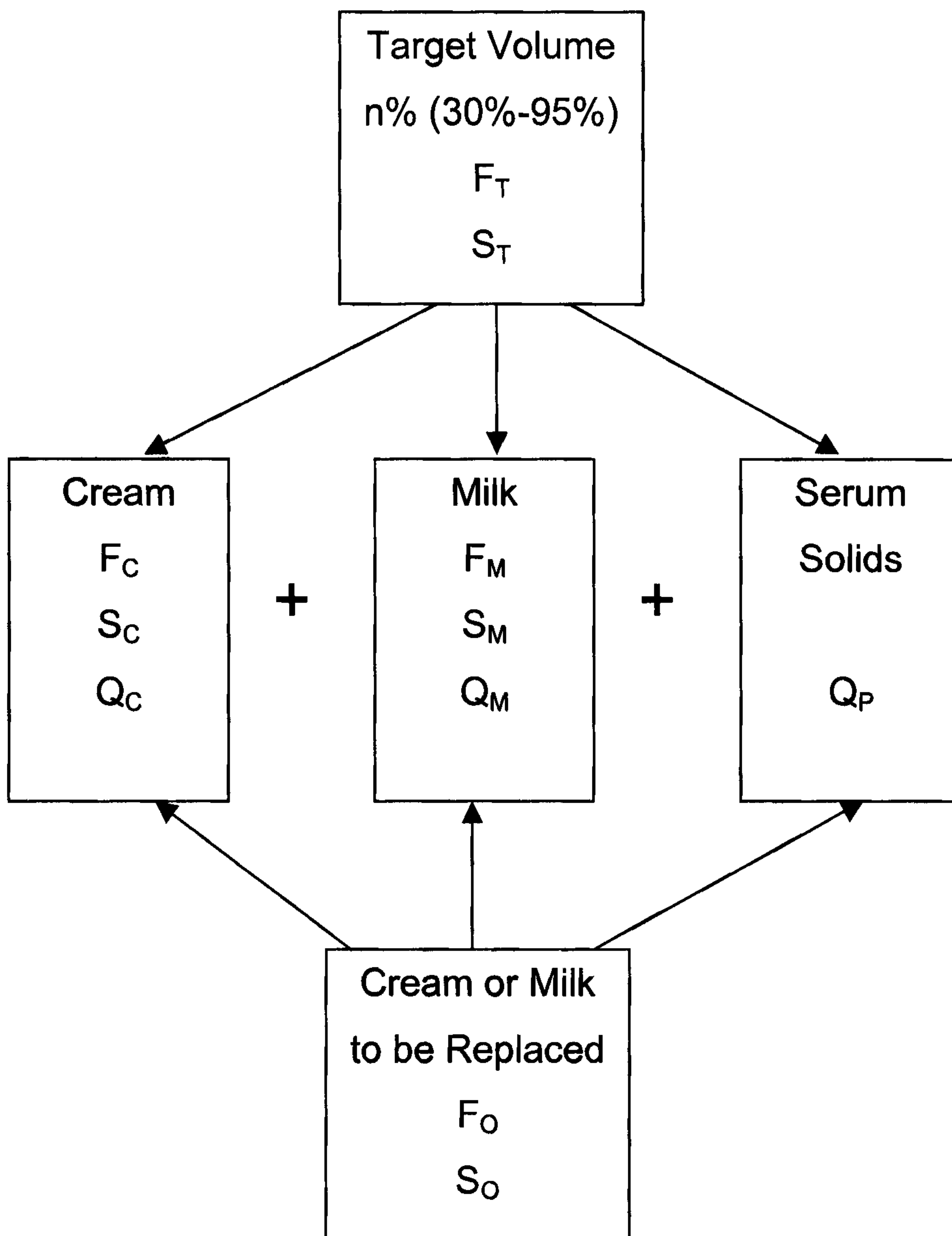


FIG.1