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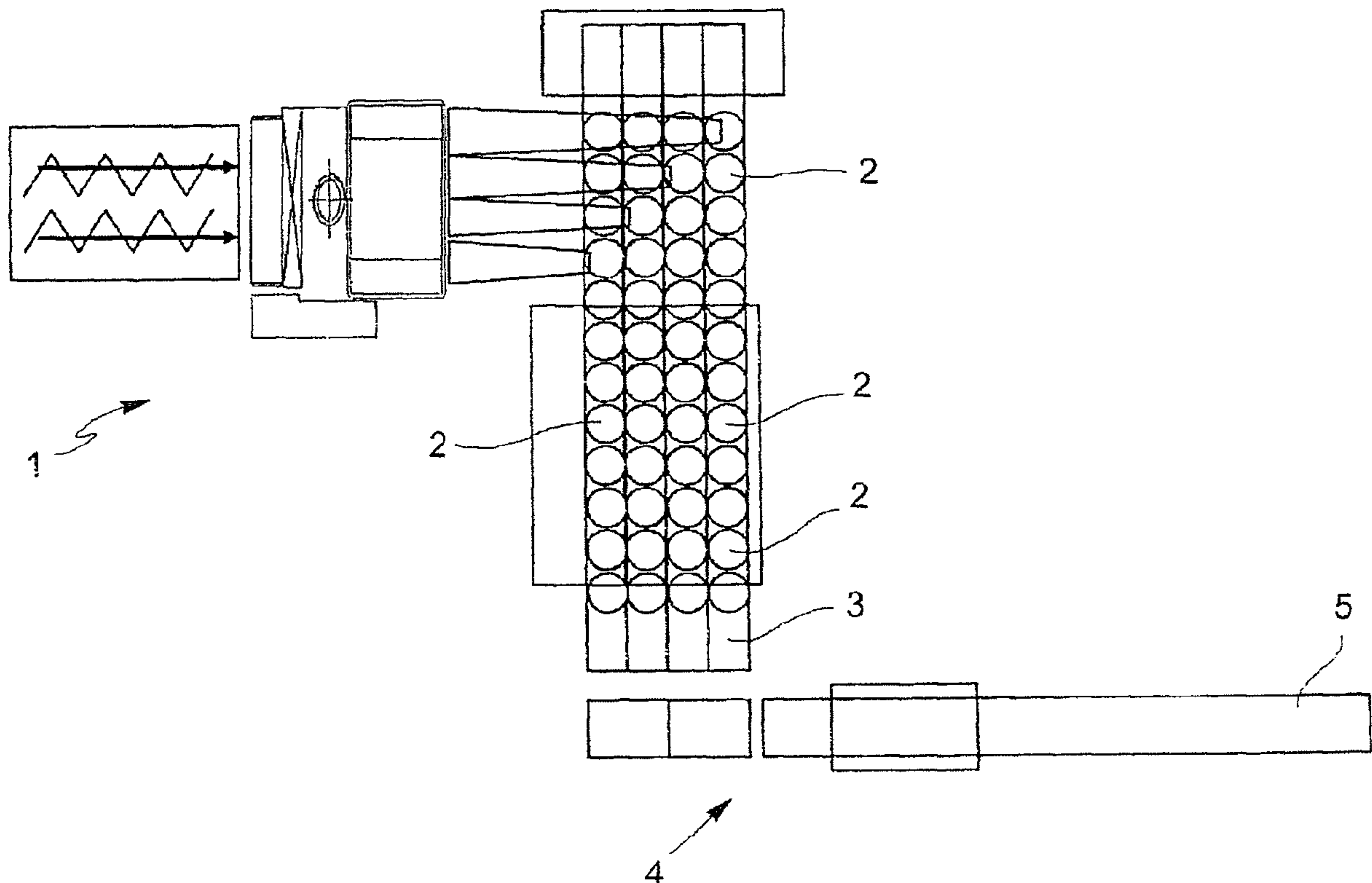
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(54) **Titre : METHODE DE PRODUCTION D'UN PRODUIT LAITIER ET SYSTEME D'EMBALLAGE CONNEXE**

(54) **Title: METHOD FOR PRODUCING A DAIRY PRODUCT AND SYSTEM FOR PACKAGING THE SAME**



(57) **Abrégé/Abstract:**

The present invention relates to a method for producing and packaging a dairy product, particularly mozzarella cheese, and a packaging method therefor which is studied to facilitate the handling and improve preservability of the latter. Particularly, the present invention relates to a method for preparing and packaging a pasta filata cheese, comprising a step of substantially dry packaging, i.e. without preserving liquid, and heat packaging of said pasta filata cheese.



**METHOD FOR PRODUCING A DAIRY PRODUCT AND SYSTEM FOR
PACKAGING THE SAME**

ABSTRACT

5 The present invention relates to a method for
producing and packaging a dairy product, particularly
mozzarella cheese, and a packaging method therefor which
is studied to facilitate the handling and improve
preservability of the latter.

10 Particularly, the present invention relates to a
method for preparing and packaging a pasta filata cheese,
comprising a step of substantially dry packaging, i.e.
without preserving liquid, and heat packaging of said
pasta filata cheese.

METHOD FOR PRODUCING A DAIRY PRODUCT AND SYSTEM FOR
PACKAGING THE SAME

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DIVISIONAL APPLICATION

This application is a divisional of application
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DESCRIPTION

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The present invention relates to a method for
producing and packaging a dairy product, particularly
mozzarella cheese, and a packaging method therefor which
is studied to facilitate the handling and improve
preservability of the latter.

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Mozzarella cheese is a fresh pasta filata cheese,
typical of Mediterranean tradition. Pasta filata cheese
is characterised by a particular processing of milk -
either cow or buffalo milk - which provides, after
curdling, the ripening of the paste either in or out the
20 whey until it reaches the proper curd demineralization
rate for stretching. In modern processing, in addition to
acidification with lactic microflora, proper
demineralization can be also obtained by acidifying the
milk with citric, lactic, acetic acid, in this case, a

2

ripening step will not take place, but only a step of drip/drying of the curd from excess whey.

The curd is then stretched, either mechanically or more traditionally manually by skilled operators, and
5 then modelled into traditional shapes, i.e. round or plaited or even in blocks.

The stretched paste can be left almost to dry or can be preserved in a so-called preserving liquid, which is typically water or salted water. In the first case, a
10 cheese is obtained that has a soft, elastic, compact and dry texture, which is typically used as a dressing for pizza, or however for kitchen use. For this stretched paste, cow milk is normally used.

In the second case, on the other hand, the stretched
15 paste that is preserved in the preserving liquid, generates a cheese that is fresh, soft, very wet, juicy, with milky fragrance, i.e. the actual mozzarella cheese, either made of cow or buffalo milk.

Mozzarella cheese is then sold packaged in sealed
20 bags, or trays, or air-tight sealed containers, in which the cheese is dipped within the preserving liquid thereof, which is indispensable for maintaining its peculiar freshness and humidity characteristics. Particularly, the preserving liquid serves to keep a

3

hydrated surface of the mozzarella cheese, thereby preventing yellowing due to dehydration.

However, this preservation system suffers from some drawbacks. First of all, upon consumption, the mozzarella
5 cheese must be dripped from the preserving liquid, which sometimes is uncomfortable and normally requires performing this operation in the vicinity of a sink or however a container receiving the dripped liquid. Furthermore, if the mozzarella is not entirely consumed,
10 the preservation of the latter is more difficult, due to the presence of the preserving liquid within a packaging which is no longer sealed, but opened. It should be noted that the mozzarella cheese which is normally available on the market is not single-portion packaged, therefore it
15 is very likely to require preservation after the package has been opened.

It has been further ascertained by the authors of the present invention that the preserving liquid favours the microbiological contamination of the mozzarella
20 cheese by ubiquitous microflora such as pseudomonadaceae and coliformi, such that, once opened, it rapidly deteriorates and takes an acid and bitter, quite unpalatable taste. As these micro-organisms use the mozzarella lactose for growing, the fresh sensation and

4

milk taste of which the lactose is the major responsible, also tend to rapidly fade.

The problem at the heart of the present invention is thus to provide a pasta filata cheese, typically a mozzarella cheese, and a packaging system that affords, on the one hand, the freshness and better preservability, on the other hand is more manoeuvrable and more comfortable to use.

This problem is solved by a method for producing and packaging a pasta filata cheese and a packaging system for the thus-obtained cheese, such as set forth in the annexed claims, the object of which is an integral part of the present description.

Further features and advantages of the present invention will be better understood from the description of an exemplary embodiment thereof, which is given below by way of non-limiting illustration, with reference to the following figures:

Fig. 1 shows a schematic view of the production line for the inventive method;

Fig. 2 shows a perspective view, in an opened condition, of a package according to the present invention.

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The problem addressed by the present invention is solved by a method for producing and packaging a pasta filata cheese which provides for eliminating the preserving liquid. The pasta filata cheese is preferably
5 a mozzarella cheese made of cow or buffalo milk.

It has been surprisingly found that the elimination of the preserving liquid not only has the advantage of reducing the danger of microbiological contamination of the cheese, thus improving the preservability thereof,
10 but also of extending the freshness sensation, the typical milk taste of mozzarella cheese and the sapidity thereof. In fact, the authors of the present invention have noticed that the preserving liquid tends to dilute both salt and lactose that are present in the cheese,
15 which accordingly, after several days of preservation, even within the closed package, tends to lose many of its organoleptic characteristics.

The following table shows the change of the chemical parameters of a traditional mozzarella cheese, i.e.
20 preserved within the preserving liquid, with the passing of time from the date of preparation. It should be considered that the shelf life of a mozzarella cheese is set at 21 days.

TABLE I - Change of chemical composition of mozzarella cheese and preserving liquid thereof as a function of the preservation stage

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	% weight	Mozzarella	Preserving liquid
BEGINNING OF LIFE	SOLID CONTENT	40,12	4,14
	LACTOSE	2,5	0,5
	NaCl	0,56	0,6
HALF LIFE	SOLID CONTENT	39,07	4,84
	LACTOSE	1,3	1,6
	NaCl	0,53	0,72
END LIFE	SOLID CONTENT	40,88	5,4
	LACTOSE	0,93	1,66
	NaCl	0,47	0,68

As may be seen from the data shown in Table I, as days go by, the mozzarella cheese is deprived of salt and mainly lactose, which pass to the preserving liquid.

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The production and packaging method of this invention allows, instead, to maintain unchanged the chemical parameters of the mozzarella cheese, thus

extending the freshness sensation, sapidity and milk taste of the cheese.

The method for producing the stretched paste according to the present invention differs from the method that is traditionally employed, in that the stretched paste is, after it has been modelled into the suitable shapes, hot-packaged without being subjected to a step of cooling and treatment with the preserving liquid.

10 The method for producing the stretched paste according to the present invention can be summarized as follows.

The milk, which is standardized such as to obtain a ratio of fat to protein = 1, is pasteurised. 15 Pasteurization is preferably carried out at about 74°C and for about 18 seconds.

Coagulation takes place by adding a suitable amount of citric acid and a coagulant such as a rennet enzyme or a chemical coagulant, preferably at a temperature ranging 20 between 30°C and 40°C, typically about 36°C. The coagulation takes place in about 3.5 minutes, after which a consolidation time, preferably about 2 minutes is followed.

8

The thus-obtained curd is dripped before being subjected to stretching. The dripping time preferably ranges between 30 minutes and 1 hour.

The stretching step is carried out by introducing
5 the curd in water or water added with salt and cream,
such as to have a salt ratio of 1-2% by weight,
preferably about 1.5%, and a percentage of fat ranging
between 7% and 12% by weight, preferably 10%. The
stretching liquid is brought to a temperature higher than
10 80°C, preferably about 90-91°C and the curd is stretched
and modelled according to conventional techniques,
preferably in moulds of a suitable shape.

The production method described above is detailed in
the patent publication EP 1 516 529 A1, with particular
15 reference to pages 4-16 and example 1.

At this stage, the inventive method differs from the
conventional method in that the stretched and modelled
paste is hot-packaged. Preferably, the packaging
operation, which is schematically shown in Fig. 1, takes
20 place when the stretched and modelled paste has a
temperature higher than 50°C, more preferably about 60°C.
The hot packaging is indispensable to obtain the desired
effects, particularly the preservability of the
organoleptic characteristics and the high humidity degree

also in the absence of the preserving liquid. The hot packaging further allows for a thermal decontamination of the product.

The paste stretched and modelled in the stretching
5 and moulding unit 1, is inserted within suitable
containers 2 that are placed on a conveyor belt 3, which
conveys the latter to a sealing unit (heat or ultrasonic
sealing). The thus-sealed packages are conveyed on a belt
5 to a cooling tunnel, for example a glycol/nitrogen
10 tunnel (not shown).

The packaging step is, in fact, followed by a
cooling step (which, on the contrary, in the conventional
technique is carried out prior to packaging), which can
be extended for a period ranging between 30 minutes and
15 1.5 hours, preferably about 1 hour.

By "packaging" is meant introducing the product
within the container thereof, and sealingly close the
container according to conventional methods known to
those skilled in the art, such as for example heat-
20 sealing two edges of the package or sealing a peelable or
non-peelable laminate to the opening of the container.

As stated above, the packaging is substantially a
dry packaging. By "substantially dry packaging" is meant

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the packaging of the stretched paste without feeding the preserving liquid within the container.

A pasta filata cheese is thus obtained, which has the following chemical-physical parameters:

5	humidity	62%
	dry matter	38%
	of which:	
	fat	17,5%
	sugar	2%
10	proteins	17,5%
	NaCl	0,6%
	Other dry matter	0,4%

In a preferred embodiment of the invention, the method for producing and packaging the stretched paste provides for a packaging system which favours the preservation of the product and comfort in using the latter.

The packaging system of the invention comprises a multi-portion container 2. In the embodiment illustrated in Fig. 2, this multi-portion container 2 consists of two half-shells 6, each of which is intended to receive a portion of pasta filata cheese. On the opening of each of the half-shells 6 a peelable or non-peelable film 7 is sealed, such as to maintain the cheese portions separated

and isolated from the external environment. This affords a suitable preservation of the chemical-physical and organoleptic characteristics of the cheese for a more extended time, as one portion at a time is opened,
5 according to the requirements.

The two half-shells 6 have a projecting edge 8 comprising a hinge portion 9, which connects the edges 8 of the two half-shells 6. A tab 10 arranged in a substantially opposing position relative to the hinge
10 portion 9 on both edges 8 of the half-shells 6 makes the container 2 easier to open, after the two half-shells 6 have been re-closed to form the shell of the container.

The container 2 can be made of multilayer PE-PET. Each half-shell 6 is sealed by means of a peelable or
15 non-peelable laminate of the type that is normally used for food, which will be heat- or ultrasonic sealed to the edge 8 of the half-shell 6.

Both half-shells 6, when re-closed to form the container 2, may be fixed to each other with adhesive or
20 heat- or ultrasonic sealing at preset locations along the contour. While a packaging containing two portions of cheese has been described herein above, it is not excluded that a single-portion or multi-portion can be used with three or more portions of stretched paste.

Furthermore, while a spherical or hemispheric shape has been described for the container or half-shells, it is not excluded that a cubic or generally polygonal shape can be provided.

5 To the purpose, the stretched paste will be modelled into suitable shape and size to be contained within the half-shell, preferably leaving as little empty space as possible. In case the half-shell has a hemispheric shape (as in Fig. 2), the stretched paste will be modelled to a
10 similar shape or ovoidal shape.

The packaging system of the invention allows obtaining a suitable portioning of the cheese, thus providing for single-doses of stretched paste which are isolated from each other, such that the consumption of a
15 cheese portion does not impair the preservability of the other portion. According to the same principle, packaging systems may be obtained which contain more than two portions of pasta filata cheese, which are separated from each other and individually sealed and containing the
20 pasta filata cheese without the preserving liquid.

The advantages of the invention have been all described above, and can be summarized as follows:

- improved preservability, due to the reduced microbiological contamination;

13

- improved preservation of the organoleptic characteristics of the cheese, particularly the freshness fragrance, sapidity and milk taste;

- with the packaging system of the invention,
5 an improved comfort of use and preservation of the product;

- an improved manoeuvrability of the cheese during the preparation for consumption, by preventing that hands and tools are wetted when the package is being
10 opened and the product dripped.

It will be appreciated that only a particular embodiment of the present invention has been described herein, to which those skilled in the art will be able to make any and all modifications necessary for its
15 adjustment to specific applications, without however departing from the scope of protection of the present invention.

For example, the two or more half-shells, which in the example illustrated in the figures consist of an
20 individual piece that can be hinged-opened, can be also provided as separated valves, which are finally coupled to each other with the methods described above to form the final shell.

CLAIMS:

1. A method for preparing and packaging a pasta filata cheese, comprising a step of substantially dry packaging, i.e. without preserving liquid, and heat packaging of said pasta filata cheese.

2. The method according to claim 1, wherein said step of substantially dry and heat packaging is carried out at a temperature higher than 50°C.

3. The method according to claim 2, wherein said temperature higher than 50°C is a temperature of about 60°C.

4. The method according to any claim 1 to 3, said method comprising the following steps:

(a) standardisation of the milk such as to obtain a ratio of fat to proteins = 1 and subsequent pasteurization of the standardized milk;

(b) coagulation of the pasteurized milk by adding citric acid and a coagulant at a temperature ranging between 30°C and 40°C;

(c) dripping of the curd obtained during step (b);

(d) stretching of said curd in water added with salt and cream, such as to have a stretching liquid with a salt ratio of 1-2% by weight and a percentage of

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fat ranging between 7% and 12% by weight at a temperature higher than 80°C and subsequent modelling into pieces of a preset shape;

(e) the packaging as defined in any claim 1 to 3 and subsequent cooling of the packaged stretched paste for a time ranging between 0.5 and 1.5 hours.

5. The method according to claim 4, wherein said pasteurization of the standardized milk is carried out at a temperature of about 74°C for about 18 seconds.

6. The method according to claim 4 or 5, wherein said coagulation is carried out at a temperature of about 36°C for a time of about 3.5 minutes and is followed by a consolidation step for a time of preferably about 2 minutes.

7. The method according to any claim 4 to 6, wherein said dripping is carried out for a time ranging between 30 minutes and 1 hour.

8. The method according to any claim 4 to 7, wherein said stretching step is carried out in water added with salt and cream, such as to have a salt ratio of about 1.5% and a percentage of fat ranging between 7% and 12%, and at a temperature ranging between 90°C and 91°C.

9. The method according to any claim 1 to 8,

16

wherein said pasta filata cheese is mozzarella cheese.

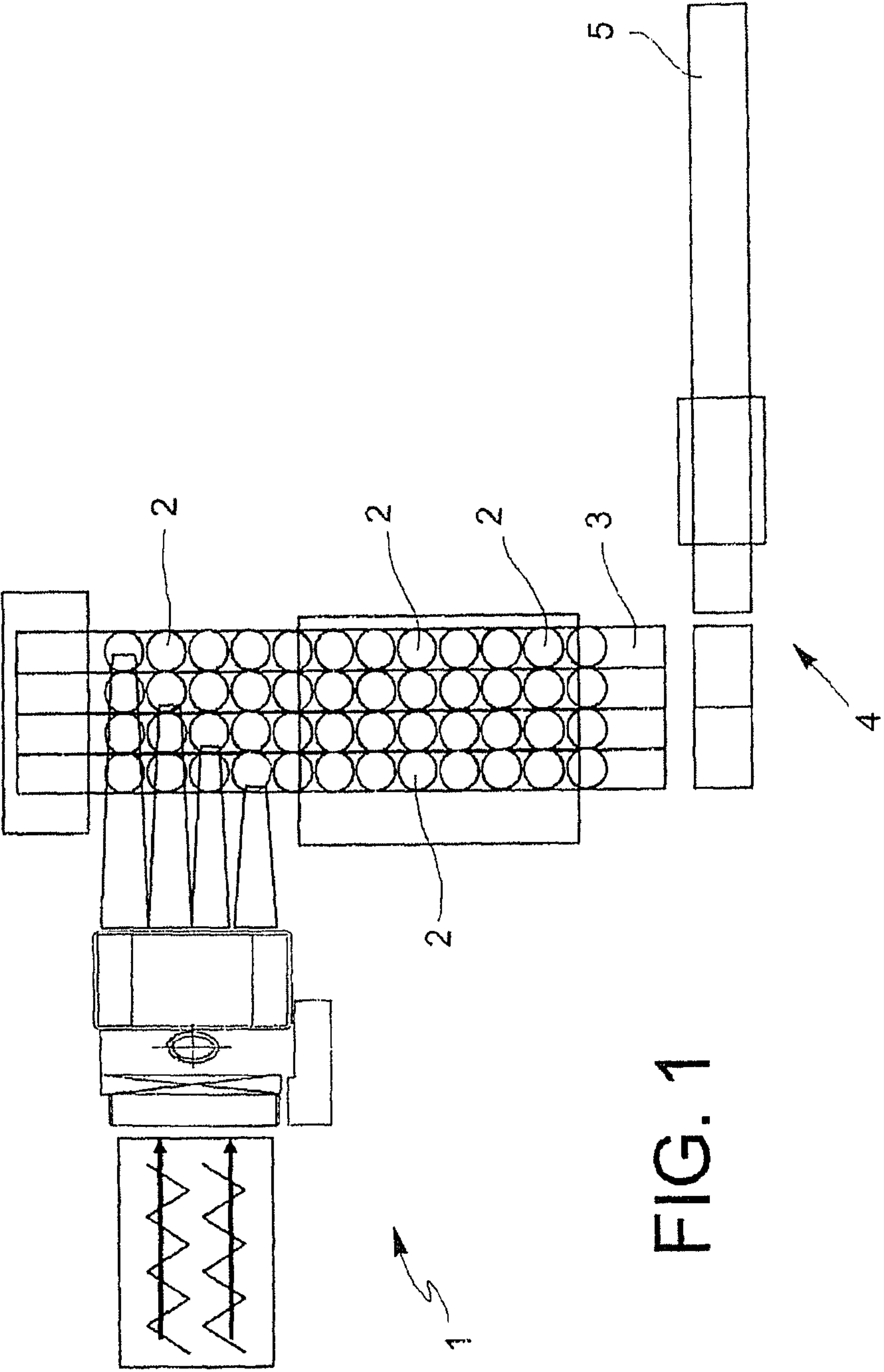


FIG. 1

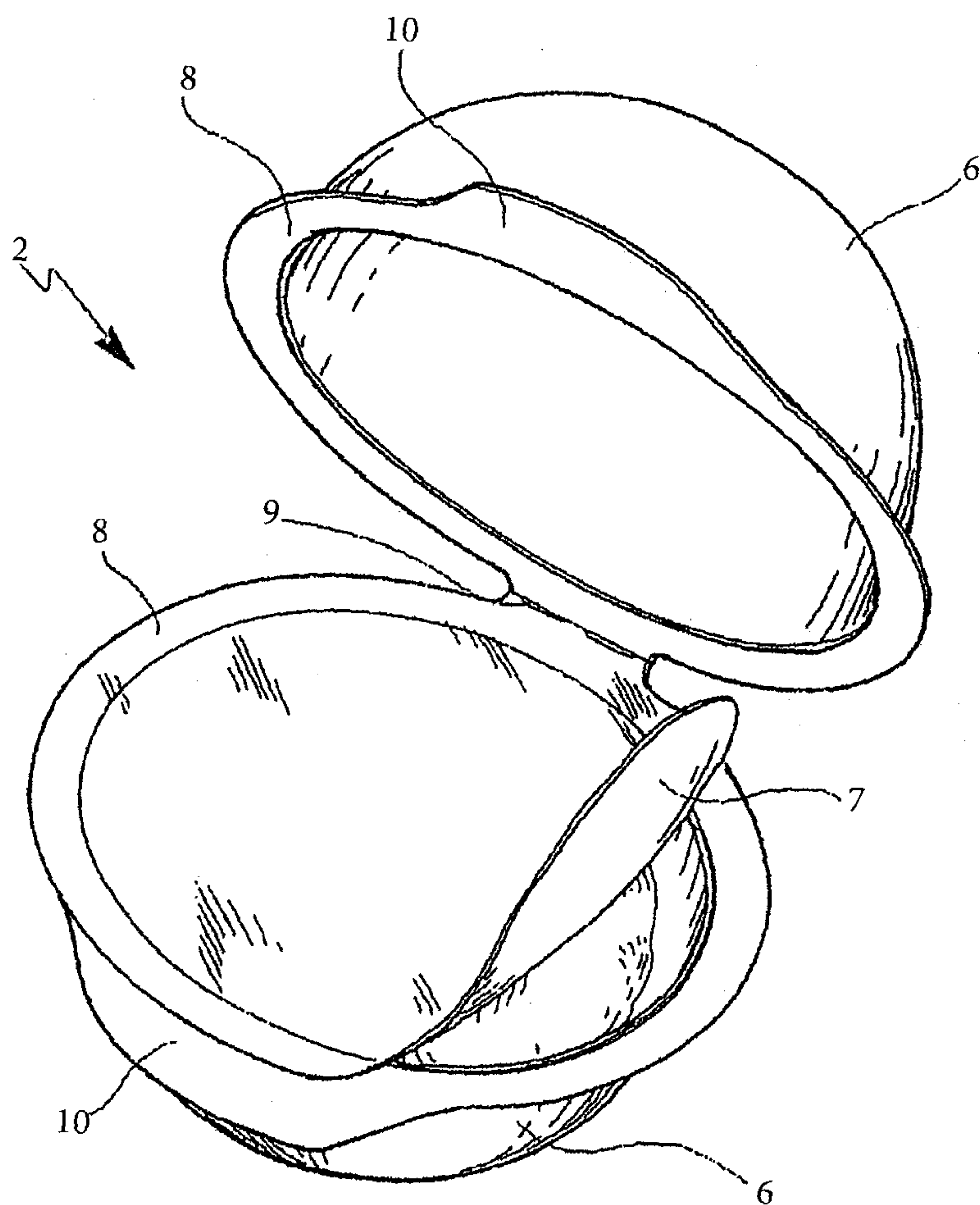


FIG. 2

