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(54) Titre : FLOCONS ALIMENTAIRES RICHES EN ENERGIE POUR POISSONS ET INVERTEBRES AINSI QUE
PROCEDE DE FABRICATION DESDITS FLOCONS
(54) Title: ENERGY-RICH FEED FLAKES FOR FISH AND INVERTEBRATES, AS WELL AS PROCESS FOR THE
PRODUCTION

(57) **Abrégé/Abstract:**

Homogeneous fat-rich feed in the form of feed flakes, as well as process for the production and its use for the promotion of growth, feed uptake and condition of fishes and invertebrates in fresh and sea water, for the improvement of the resistance against stress, for the prevention of losses in the case of unfavourable maintenance conditions, such as high temperatures in the summer and low temperatures in the winter, in the maintenance of pond fish, as well as for the reduction of nitrogen and phosphorus excretion promoting algal growth.

ABSTRACT

Homogeneous fat-rich feed in the form of feed flakes, as well as process for the production and its use for the promotion of growth, feed uptake and condition of fishes and invertebrates in fresh and sea water, for the improvement of the resistance against stress, for the prevention of losses in the case of unfavourable maintenance conditions, such as high temperatures in the summer and low temperatures in the winter, in the maintenance of pond fish, as well as for the reduction of nitrogen and phosphorus excretion promoting algal growth.

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**Energy-rich feed flakes for fish and invertebrates, as well
as process for the production**

Description

Usually, at present, fish feeds, especially for ornamental fish, are characterised by a relatively high protein content (about 40 - 50%) and amount of starch (about 16 - 30%) in the case of simultaneously relatively small energy content (about 0.5 - 8% fat). Such feeds can be produced industrially without problem in forms of application usual for the maintenance of fish (feed flakes, floatable extrudates, tablets) and lead to a good growth and to a sufficient nutrition of the animals.

On the other hand, for the breeding and feeding of useful fish, energy-rich feed in the form of extrudates or pellets are increasingly used which, besides a high protein content important for the growth, have fat contents of up to 25% (BioMar GmbH, company brochure "Fütterung/Umwelt - Ecoline"). The use of such feeds in the professional fish breeding leads, in comparison with fat-poorer products, to less water-contaminating, nitrogen-containing excretion products (ammonia, nitrite, nitrate) since the energy requirement of the animals is predominantly covered by the nitrogen-free fats. Therefore, the nitrogen-containing

proteins serve the growth as broadly as possible and do not have to be metabolised for the gaining of energy with formation of nitrogen-containing decomposition products. Furthermore, fats are superior to carbohydrates as carriers of energy in fish nutrition since fish - unlike evolutionary higher standing animals - can only limitedly utilise carbohydrates because of their metabolic characteristics. Therefore, the use of fat-rich fish feeds in the maintenance of useful fish has not only economic but also ecological advantages due to the saving of proteins and the smaller excretion of water-contaminating materials.

Such feeds were hitherto not used for ornamental fish in the aquarium or in the garden pond since serious technological disadvantages counter the said advantages. The production of slowly sinking feed flakes which, because of the size of the animals in the ornamental fish nutrition, are usual, with high fat proportions was hitherto not possible on a technical scale since fatrich feed mixtures for the production of flakes according to the usual processes stick on the roller driers normally used and cannot be removed to give a comminutable foil strip.

Surprisingly, it has now been found that, with a new production process, flaked feed with high energy content in the form of fat/oil can also be produced and thus the condition of fish can be distinctly improved.

The new process is based on the rolling out of formed bodies which can be produced e.g. by extrusion or pelleting, to give thin feed flakes slowly sinking in water.

Thus, energy-rich feed flakes were produced with the new process and tested on typical ornamental fish for aquaria with regard to suitability in comparison with traditional standard feeds with low fat contents: In a feeding experiment on two different ornamental fish species (*Labidochromis caeruleus*, *Barbus conchonus*), there was tested for effectiveness a flaked experimental feed with high energy content (33% fat) in comparison with a control feed (7% fat) over a period of time of 12 weeks in the case of a water temperature of 25°C.

The results clearly demonstrate that, in the case of the application of the energy-rich flake feed, the feed uptake is clearly increased and the growth of the fish is significantly better in comparison with the control. Similar results are shown in the case of the feeding of experimental flakes with 18% or 23% of fat in comparison with a test diet with 8% fat.

Therefore, having regard to these surprising new findings, the production and the use of fat-rich flaked feed is also advantageous for the maintenance of ornamental fish.

Therefore, the subject of the present invention is an energy-/fat-rich flake feed for fish and invertebrates, as well as the production and use of these flakes.

According to one aspect of the present invention, there is provided homogeneous fat-rich flake feed for fish and invertebrates, comprising a fat content of 12 to 40% and a residual moisture of 1 to 30% in the form of uniformly formed flakes.

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A flaked ornamental fish feed is preferred which, in homogeneous distribution, contains energy in the form of 12 - 40% fat, preferably 12 to 20% and quite especially preferably about 15 to 19% fat in the case of a moisture content of 1 to 30%, preferably 4 to 25% and quite especially preferably of about 8%. In addition, this feed

contains the usual basic components, such as 25 - 50% protein, preferably 43%, 10 to 25% starch, preferably 13% and 10 to 60% N-free extract materials, preferably 20%, whereby all statements of amount are referred to the weight of the product.

For the production of energy-rich feed flakes, there can be used, according to the methods set out in the following, all commercially available liquid and solid fats and oils of animal or vegetable origin, individually or in combination (e.g. soya oil, fish oils, marine animal fats, tallow, sunflower oil, maize oil).

The energy addition in the form of fat/oil in high dosagings for flaked feed for fish and invertebrates takes place during the mixing of the flour-formed and liquid feed components. Thus, a homogeneous distribution is already ensured in the raw material mixture before the subsequent extrusion or pelleting process and following rolling out to give flakes.

In the case of the production of extrudates, the weighed out recipe components are homogeneously mixed in a mixer with the necessary amounts of energy in the form of fat/oil and extruded. Thereby, for example, first 330 kg of energy-rich raw material mixture are extruded with a barrel extruder speed of 60 - 98%, preferably 75%, and a temperature at the meal introduction region of 40 - 160°C, preferably 75°C, and in the nozzle head of 40 - 190°C, preferably 75°C, with addition of 1 - 100 l, preferably 30 l of water per hour to give 1 to 50, preferably 2 - 4 mm long extrudates with a stick diameter of 1 to 10 mm, preferably 2 - 4 mm.

Brought about by the geometry of the outlet nozzle of the extruder and of the desired section length of the extrusion billet, sections are obtained with equal three-dimensional form.

Subsequently, these extrudates are rolled out directly in a cylinder mill to give uniformly formed flakes with a thickness between 10 μm and 5 mm and a diameter between 1 to 100 mm, which also possess an equal three-dimensional form.

Formed bodies with substantially equal three-dimensional form suitable for rolling out can also be obtained by pelletisation of the fat-rich raw material mixture which can subsequently be rolled out to give uniformly formed flakes.

In the case of the production of formed bodies by means of extrusion, the temperature is reducible to $< 80^{\circ}\text{C}$.

In the case of this process, after the production no additional working steps, such as e.g. spraying or coating with oils/fats for the energy enrichment - as in the case of conventional pellets - are necessary.

A further subject of the invention is the use of the homogeneous fat-rich feed according to the invention for the promotion of growth, feed uptake and condition of ornamental fish in fresh and sea water, for the improvement of the resistance against stress, for the prevention of losses in the case of unfavourable maintenance conditions, such as high temperatures in the summer and low temperatures in the winter in the case of the maintenance of pond fish, as well as for the reduction of the nitrogen and phosphorus excretion promoting algal growth.

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CLAIMS:

1. Homogeneous fat-rich flake feed for fish and invertebrates, comprising a fat content of 12 to 40% and a residual moisture of 1 to 30% in the form of uniformly
5 formed flakes.
2. Homogeneous fat-rich feed according to claim 1, wherein the fat content and residual moisture are in homogeneous distribution, the fat content is 12 to 20% and the moisture content is 4 to 25%.
- 10 3. Homogeneous fat-rich feed according to claim 2, wherein the fat content is 18% and the moisture content is 8%.
4. Homogeneous fat-rich feed according to any one of claims 1 to 3, further comprising in homogeneous
15 distribution, 25-50% protein, 10 to 25% starch, and 10 to 60% N-free extract materials.
5. Homogeneous fat-rich feed according to claim 4, wherein the protein content is 43%.
6. Homogeneous fat-rich feed according to claim 5,
20 wherein the starch content is 13%.
7. Homogeneous fat-rich feed according to claim 6, wherein the N-free extract material content is 20%.
8. Feed according to any one of claims 1 to 7, wherein the fat is selected from the group consisting of
25 soya oil, fish oils, marine animal fats, tallow, sunflower oil, maize oil and mixtures thereof.
9. Homogeneous fat-rich feed according to any one of claims 1 to 8 produced by mixing of components of the feed; extruding the mixed components to give formed bodies with

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equal spatial form and subsequently rolling out of the formed bodies to give flakes of equal form.

10. Homogeneous fat-rich feed according to any one of claims 1 to 8 produced by mixing of components of the feed, pelletising of the mixed components to give formed bodies with equal spatial form and subsequent rolling out of the formed bodies to give flakes of equal form.

11. Process for production of fat-rich flake feed as defined in any one of claims 1 to 8, comprising mixing components of the feed defined in any one of claims 1 to 8, extruding the mixed components to give formed bodies with equal spatial form and subsequently rolling out of the formed bodies to give flakes of equal form.

12. Process according to claim 11, wherein the components are homogeneously mixed in the mixing step and then extruded with a barrel extruder in the extruding step, wherein the extruder is run at a speed of 60 - 98%, and a temperature in a meal introduction region of 40 - 160°C, and in a nozzle head of 40 - 190°C, with addition of 1 - 100 litres of water per hour to give 1 to 50 mm long extrudates with a stick diameter of 1 to 10 mm and the extrudates are subsequently rolled out to give flakes with a thickness between 10 µm and 5 mm and a diameter between 1 mm and 100 mm.

13. Process according to claim 12, wherein the meal introduction region temperature is 75°C.

14. Process according to claim 12 or 13, wherein the nozzle head temperature is 75°C.

15. Process according to any one of claims 12 to 14, wherein the water addition rate is 30 litres per hour.

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16. Process according to any one of claims 12 to 15, wherein the extrudates are 2 to 4 mm long.

17. Process according to any one of claims 12 to 16, wherein the stick diameter of the extrudates is 2 to 4 mm.

5 18. Use of a homogeneous fat-rich feed as defined in any one of claims 1 to 10, for the promotion of growth, feed uptake and health of fresh-water or sea-water ornamental fish.

10 19. Use of a homogeneous fat-rich feed as defined in any one of claims 1 to 10, for maintenance and improvement of resistance against stress of fresh-water or sea-water ornamental fish.

15 20. Use of a homogeneous fat-rich feed as defined in any one of claims 1 to 10, for ornamental fish maintenance and prevention of losses under unfavourable maintenance conditions.

20 21. Use according to claim 20, wherein the ornamental fish are pond fish and the unfavourable maintenance conditions are one or both of high summer temperatures and low winter temperatures.

22. Use of a homogeneous fat-rich feed as defined in any one of claims 1 to 10 for ornamental fish maintenance with a reduction of nitrogen and phosphorus excretion by the ornamental fish, thereby limiting algal growth.

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