(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau

(43) International Publication Date
26 March 2020 (26.03.2020)

WIPO | PCT

(10) International Publication Number
WO 2020/058488 A1

(51) International Patent Classification:
A21D 2/36 (2006.01) *A21D 13/068* (2017.01)
A21D 13/062 (2017.01)

(21) International Application Number:
PCT/EP2019/075359

(22) International Filing Date:
20 September 2019 (20.09.2019)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:

18195921.4	21 September 2018 (21.09.2018)	EP
2018/02672	21 September 2018 (21.09.2018)	CL
19161719.0	08 March 2019 (08.03.2019)	EP
2019/00605	11 March 2019 (11.03.2019)	CL

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(81) Designated States *(unless otherwise indicated, for every kind of national protection available)*: AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DJ, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IR, IS, JO, JP, KE, KG, KH, KN, KP, KR, KW, KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States *(unless otherwise indicated, for every kind of regional protection available)*: ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, KM, ML, MR, NE, SN, TD, TG).

Declarations under Rule 4.17:
— *as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii))*
— *as to the applicant's entitlement to claim the priority of the earlier application (Rule 4.17(iii))*
— *of inventorship (Rule 4.17(iv))*

Published:
— *with international search report (Art. 21(3))*

(54) Title: FOODSTUFF PRODUCT

(57) Abstract: The present invention provides new products containing no added sugar and/or fat.

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FOODSTUFF PRODUCT

The present invention relates to the field of new foodstuffs, preferably baked products.

BACKGROUND

It is a recognised worldwide issue that greater numbers of the population are becoming overweight. It is also becoming apparent that rising numbers of children below 6 years old have obesity.

Implementation of laws or regulations that are aligned with OMS recommendations with the purpose of protect the health of children and avoid the problems mentioned above is a trend in a large number of countries.

For example, Chile started in the year 2016, with the “labelling law” which stablishes limits for calories, sugars, sodium, and saturated fats. Any foodstuff above these limits must be labelled with a warning sign and it is forbidden to have publicity oriented to children. Only foodstuff that contains less sugar, saturated fats and calories than the limits established or that does not have added sugar or saturated fats, is warning sign free.

The addition of saturated fats includes fats and oils from animal or vegetable source, milk cream, emulsions and additives that contains fats like myristic acid, palmitic acid and mono and diglycerides of fatty acids.

The addition of sugar comprises sugars like mono and disaccharides, white and brown sugar, syrups (including fruit concentrates) honey and food additives that contains sugars.

Accordingly, it is a challenge to produce feasible foodstuffs that the consumer enjoys but complying with these nutritional regulations and OMS recommendations.

The role of sugar and fat in bakery products is crucial. The omission of these ingredients can lead to problems in processing during manufacture. Additionally, the omission of fats and sugars will have an impact on texture and flavour profile, leading to an un-preferred product.

Alternatives for fat and sugar replacement in confectionary products have been developed. However, these ingredients are not considered healthy and/or desirable by the consumers due their chemical nature or their association with chemical ingredients (i.e. polyols, resistant starch, fructooligosaccharides, etc.).

Accordingly, what would be desirable is a consumable that does not contain any added fats, sugars (and optionally salts) but does not suffer from any problems of manufacture and any loss in consumer enjoyment.

The present invention is envisaged with the solving the above problems.

SUMMARY OF INVENTION

The present invention provides a, preferably baked, foodstuff product that comprises fruit, preferably as a sugar replacement agent and more preferably, the, preferably baked, foodstuff does not contain any added sugar.

The present invention provides a, preferably baked, foodstuff product that comprises a nut preferably as a fat and/or oil replacement and more preferably does not contain any added fat and/or oil.

In an embodiment, provided is a process for preparing the baked product that comprises rotary moulding, laminated biscuit, extruded and depositing.

DETAILED DESCRIPTION

Foodstuff Product

The present invention relates to foodstuffs formulated to not contain added sugar and added fat.

Baked foodstuffs used in the invention may be sweet or savoury. Preferred baked foodstuffs may comprise baked grain foodstuffs, which term includes foodstuffs that comprise cereals and/or pulses. Baked cereal foodstuffs are more preferred, most preferably baked wheat foodstuffs such as wafer(s), cracker(s), cookie(s), muffin(s), extruded snack(s) and/or biscuit(s).

Wafers may be flat or shaped (for example into a cone or basket for ice cream) and biscuits may have many different shapes. More preferred wafers are non-savoury wafers, for example having a sweet or plain flavour.

In an embodiment, the baked foodstuff may comprise a coating or a filing or both.

A non limiting list of those possible baked foodstuffs used in the present invention are selected from: biscuits, cakes, breads, pastries and/or pies; such as from the group consisting of: rusk, saltine, pretzel, ANZAC biscuit, biscotti, flapjack, kurabiye, lebkuchen, leckerli, macroon, bourbon biscuit, butter cookie, digestive biscuit, custard cream, extruded snacks, florentine, garibaldi gingerbread, koulourakia, kourabiedes, Linzer torte, muffin, oreo, Nice biscuit, peanut butter cookie, polvorón, pizzelle, pretzel, croissant, shortbread, cookie, fruit pie (e.g. apple pie, cherry pie), lemon drizzle cake, banana bread, carrot cake, pecan pie, apple strudel, baklava, berliner, bichon au citron and/or similar products

In a preferred embodiment of the present invention, the baked product is a biscuit or a cookie.

In an embodiment, the baked foodstuff comprises flour.

In an embodiment, the baked foodstuff comprises less than 70.0% of flour by weight of the baked foodstuff, preferably less than 67.5% of flour and more preferably less than 60.0% of flour.

In an embodiment, the baked foodstuff comprises greater than 25.0% of flour by weight of the baked foodstuff, preferably greater than 30.0%, preferably greater than 35.0%, preferably greater than 40.0%, and more preferably greater than 42.5%.

In an embodiment, the baked foodstuff comprises between 25.0% and 70.0% by weight flour or between 35.0% and 70.0% by weight flour, more preferably between 40.0% and 60.0% and 42.5% and 52.5%.

In an embodiment, the baked foodstuffs of the present invention comprise wheat flour and/or comprise flour from non–wheat grains, optionally in one embodiment to replace the wheat flour, alternatively in another embodiment in addition to the wheat flour.

The wheat flour may be soft or hard wheat flour.

In an embodiment, any wheat flour or non-wheat flour present may be whole grain. In an embodiment, whole grain is a grain of any cereal or pseudo-cereal that contains the endosperm, germ, and bran, in contrast to refined grains, which retain only the endosperm

Soft flour as used herein denotes flour that has a low protein content, preferably having a protein content of less than 11%, more preferably less than 10%, most preferably less than 9%, by weight of total weight of flour. Usefully the protein content of soft flour is at least 5%, more usefully at least 6%, most usefully at least 7% by weight of total weight of flour. Conveniently, soft flour has a protein content from 5% up to 11%, more conveniently from 6% to 10%, most conveniently from 7% to 9% by weight of total weight of flour.

Hard flour as used herein denotes flour that has a high protein content, preferably having a protein content of more than 11%, more preferably at least 12%, most preferably at least 13%, for example at least 14% by total weight of flour. Usefully the protein content of hard flour is no more than 20%, usefully no more than 17%, more usefully no more than 15% by total weight of flour. Conveniently, hard flour has a protein content from 11% to 20%, more conveniently from 12% to 17%, most conveniently from 13% to 15% by total weight of flour.

In further embodiment of the invention, conveniently the flour comprises instead of or in additional to the wheat flour a non-wheat flour. More conveniently, the non-wheat flour is obtained and/or obtainable from one or more of the following sources of grain: non-wheat cereals such as rye, common oat (Avena sativa, also referred to herein as oats), rice and/or bran; legumes such as beans and/or soybeans; and/or suitable mixtures thereof.

Non-wheat food grade crops (such as cereal grains) and that are suitable for producing flours for use in the present invention are selected from the group consisting of: warm season cereals (such as maize kernels; finger millet; fonio; foxtail millet; Kodo millet; Japanese millet; Job's Tears; maize (corn); pearl millet; proso millet; and/or sorghum); cool season non wheat cereals (such as barley, oats, rice, rye, teff, triticale and/or, wild rice); pseudo cereal grains; (such as starchy grains from broadleaf plant families: amaranth buckwheat, smartweed and/or quinoa); grain legumes and/or pulses (such as lentil, pea, chickpeas, common beans, fava beans, garden peas, lentils, lima beans, lupins, mung beans, peas, peanuts, pigeon peas, runner beans and/or, soybeans), cassava (Maihot esculenta) and/or any suitable combinations and/or mixtures thereof.

Cassava is an important subsistence crop in many tropical areas including, for example, Asia, Africa and Latin America. The cassava roots are a major source of carbohydrates such as starch. This starch from the cassava root can be extracted to produce cassava starch also known as tapioca starch or tapioca flour. Cassava flour is made by cooking, drying and grinding cassava root to a fine powder. This is different from cassava starch, which is made from the starch of the cassava plant whereas the cassava flour is made from the ground root. Both tapioca flour and cassava flour can be used in the present invention. Flour from yucca may also be used.

Preferred flours are those obtained and/or obtainable from millet; maize, barley, oats, rice, rye and/or soybeans.

More preferred flours are those obtained and/or obtainable from barley, oats, rice and/or rye, most preferred flours are those obtained from rye and/or oats, such as from oats.

An example of oats as used herein is the common oat (Avena sativa).

The non-wheat flour where present may be present in an amount of at least 0.5%, preferably in an amount of at least 5% by weight, conveniently at least 6%, more conveniently at least

8%, even more conveniently at least 10%, most conveniently at least 15%, for example at least 20% of the total flour.

Advantageously in this embodiment the non-wheat flour may be present in an amount of 100%, less than or equal to 75%, less than or equal to 50%, more advantageously less than or equal to 40%, most advantageously less than or equal 30%, for example less than or equal 25% of the total flour.

Preferably in this embodiment the non-wheat flour may be present in the baked foodstuff in an amount of from 0.5% to 50%, preferably from 5 to 50%, more preferably from 6 to 40%, most preferably from 8 to 30%, for example from 10 to 25% of the total flour.

The above percentages preferably relate to the total non-wheat flours, not each individual non-wheat flours if a combination is present.

In the present invention, the terms “added sugar”, “intrinsic sugar”, “natural sugar” and alike have their standard meanings in the art. In line with the recognised meaning in the art, naturally occurring sugars are found naturally in foods such as fruit (fructose) and milk (lactose). Added sugars are sugars and syrups put in foods during preparation or processing.

For example, the US FDA have defined added sugars as: “*sugars that are either added during the processing of foods, or are packaged as such, and include sugars (free, mono and disaccharides), syrups, naturally occurring sugars that are isolated from a whole food and concentrated so that sugar is the primary component (e.g., fruit juice concentrates), and other caloric sweeteners. This would include single ingredient foods such as individually packaged table sugar. Sugar alcohols are not considered to be added sugars.*

Names for added sugars include: Brown sugar, corn sweetener, corn syrup, dextrose, fructose, fruit juice concentrates, glucose, high-fructose corn syrup, honey, invert sugar, lactose, maltose, malt sugar, molasses, raw sugar, turbinado sugar, trehalose, and sucrose”.

Preferably, as recited in Regulation (EC) No 1924/2006, the present invention relates to foodstuffs where sugars have not been added and the product does not contain any added mono- or disaccharides or any other food used for its sweetening properties other than sugars that are inherently naturally present in the ingredients.

In an embodiment, the baked foodstuff only comprises sugar that is intrinsic to ingredients present. In an embodiment, there is no added sugar, for example there are no added mono and disaccharides, white and brown sugar, syrups (including fruit concentrates, e.g. fruit-or plant-based syrups), honey and food additives that contain sugars.

In an embodiment, the baked foodstuff comprises a raising agent (leavening agent). In an embodiment, the agent is selected from the group consisting most likely of sodium bicarbonate, ammonium bicarbonate, mono-calcium orthophosphate, potassium bicarbonate, calcium phosphate, acid sodium pyrophosphate, potassium bitartrate or cream of tartar, sodium acid aluminium phosphate hydrate, gluconodeltalactone, adipic acid and yeast and combinations thereof.

In an embodiment, the baked foodstuff comprises inclusions. The inclusions may be any that are commonly used in the art, like fruit-based inclusions, nut-based inclusions, cereal-based inclusions and yogurt-based inclusions, for example. The inclusions may take the form of those commonly used, for example chips, flakes, crisps/crispies etc.

In an embodiment, the inclusions may comprise cereal-based inclusions, preferably oats.

Formulations of the, preferably baked, foodstuff may also comprise at least one of the following additional other ingredients: selected from one or more of: natural flavourings (e.g. fruit flavourings), cocoa powder, emulsifier (e.g. lecithin), high intensity sweetener, whole egg, salt, milk powder (whole or skimmed), soy flour, and/or mixtures thereof.

The cellular structure of the, preferably baked, foodstuff can be further strengthened using known stabilisers such as starch, modified starch, gums such as locust bean gum, guar gum, gum acacia, tragacanth, xanthan, karaya, gellan, tars, cellulose and cellulose derivatives, pectin or gelatin, maltodextrins, gelling agents such as alginates or carageenan, proteins or protein sources such as albumins, casein, caseinates, milk powders or whey powders.

In an embodiment of the present invention, the high intensity sweetener is a natural component, for example, a Luo Han Guo fruit extract (mogrosides), a steviol glycoside and combinations thereof. In an embodiment, the, preferably baked, foodstuff may comprise steviol glycosides selected from rebaudioside A, B, C, D, E, M and X and stevioside and combinations thereof. In a preferred embodiment, rebaudioside A, B or mixtures thereof is present.

The foodstuff of the present invention may include functional ingredients, for example, anti-oxidants, vitamins, probiotics, prebiotics and/or minerals.

In an embodiment, the present invention may also comprise polyols, for example, polyols may comprises sorbitol, xylitol, maltitol and lactitol or combinations thereof.

However, in an alternative embodiment, polyols are not present, i.e. at preferably 0.00wt% or 0.000wt% of the baked foodstuff.

Usefully the total amount of other ingredients (e.g. ingredients that are not flour, sugar replacement agent, fat replacement agent, water, milk powders, inclusions, if present) in the, preferably baked, foodstuff is no more than 20%, no more than 15% or no more than 10% by weight of the, preferably baked, foodstuff, preferably no more than 8.5%, or no more than 5.0%.

In a preferred embodiment, the total amount of other ingredients is greater than 2.5% by weight of the foodstuff, preferably greater than 5.0wt%.

In a preferred embodiment, the, preferably baked, foodstuff comprises at least one fruit flavouring, at least one high intensity sweetener and at least one type of inclusion.

In a preferred embodiment, the sum of, if present, flour, sugar replacement agent, fat replacement agent, water, milk powders, and inclusions and total amount of other ingredients is 100wt%.

In a preferred embodiment, the baked foodstuff of the baked foodstuff is prepared from dough or batter.

In an embodiment, the dough or batter comprises water.

Optionally the weight ratio of water to flour (denoted herein as R[w/f]) is no more than 0.45, optionally from 0.01 to 0.35.

Conveniently R(w/f/) is at least 0.01, more conveniently at least 0.02, most conveniently at least 0.05.

Advantageously R(w/f/) is less than or equal to 0.45, more advantageously less than or equal to 0.40, even more advantageously less than or equal to 0.35, most advantageously less than or equal 0.32.

Preferably, R(w/f/) is from 0.01 to 0.45, more preferably from 0.05 to 0.35.

In a preferred embodiment, the above ratios relate to the product of a biscuit.

In a preferred embodiment of the present invention, the foodstuff, preferably baked foodstuff post-baking, has a total moisture content of less than 10.0wt% based on the weight of the foodstuff, preferably less than 8.0wt%, preferably less than 7.5wt%, preferably less than 5.0wt% and preferably less than 3.0wt%. In a preferred embodiment, the moisture content is greater than 0.25wt% or greater than 0.50 wt%. In a preferred embodiment, the moisture content of the foodstuff, preferably baked foodstuff, is between 0.25 and 10.0wt%. Any suitable method for measuring this moisture content is applicable, for instance, by thermogravimetric analysis, e.g. using a drying oven and calculating a loss on drying, or using an infra-red moisture analyser.

Sugar Replacement

In an embodiment of the present invention, the sugar replacement agent comprises fruit. In an embodiment, the sugar replacement agent comprises a fruit paste and/or fruit purée and/or fruit juice.

In a preferred embodiment, the sugar replacement agent comprises fruit selected from the group comprising (preferably consisting of) date, apple, raisin, banana, peach, blueberry and prune and combinations thereof.

In a preferred embodiment, the sugar replacement agent comprises date palm fruit (fruit of the phoenix dactylifera), preferably in the form of a paste. The date palm fruit is a preferred sugar replacement agent owing to the interplay between sugar content and texture, preferably when in the form of a paste.

In a preferred embodiment, the sugar replacement agent comprises apple, preferably in the form of fruit purée.

In a preferred embodiment, the sugar replacement agent comprises (i) date palm, raisin and/or prune in combination with (ii) apple, banana, peach and/or blueberry, preferably date palm and apple, banana, peach and/or blueberry, preferably date palm and apple. In a preferred embodiment the agents (i) are in the form of a paste and/or the agents (ii) are in the form of a puree.

In a preferred embodiment, the sugar replacement agent comprises both date palm fruit paste and apple fruit puree.

In an embodiment, the sugar replacement agent comprises intrinsic sugars selected from the group comprising glucose, sucrose, fructose, and combinations thereof.

In a preferred embodiment, the sugar replacement agent comprises intrinsic sugar in an amount of greater than 40% by weight of the agent, preferably greater than 50% by weight, and preferably greater than 60% by weight. In a preferred embodiment, the sugar replacement agent comprises sugar in an amount of less than 80% by weight, preferably less than 75% by weight and most preferably less than 70% by weight. For example, between 50% and 80%. In

a preferred embodiment, the above sugar amounts relate to the sugar replacement agent being in the form of a paste.

In a preferred embodiment, the sugar replacement agent comprises water in an amount of greater than 5% by weight of the agent, preferably greater than 9% by weight, and preferably greater than 10% by weight. In a preferred embodiment, the sugar replacement agent comprises water in an amount of less than 30% by weight, preferably less than 20% by weight and most preferably less than 15% by weight. For example, between 5% and 30%. In a preferred embodiment, the above water amounts relate to the sugar replacement agent being in the form of a paste.

In a preferred embodiment, the sugar replacement agent comprises intrinsic sugar in an amount of greater than 10% by weight of the agent, preferably greater than 15% by weight, and preferably greater than 17% by weight. In a preferred embodiment, the sugar replacement agent comprises sugar in an amount of less than 40% by weight, preferably less than 35% by weight and most preferably less than 30% by weight. For example, between 10% and 40%. In a preferred embodiment, the above sugar amounts relate to the sugar replacement agent being in the form of a puree.

In a preferred embodiment, the sugar replacement agent comprises water in an amount of greater than 50% by weight of the agent, preferably greater than 60% by weight, and preferably greater than 62% by weight. In a preferred embodiment, the sugar replacement agent comprises water in an amount of less than 90% by weight, preferably less than 85% by weight and most preferably less than 80% by weight. For example, between 60% and 90%. In a preferred embodiment, the above water amounts relate to the sugar replacement agent being in the form of a puree.

In a preferred embodiment, the above sugar and water amounts relate to the ingredients prior to baking.

In a preferred embodiment, the sugar replacement agent comprises paste and puree components. In a preferred embodiment, the proportion of puree of the total amount of sugar replacement agent is between 50% and 85% by weight of the total amount of sugar replacement agent, preferably between 55% and 80% and more preferably between 57% and 75%.

In a preferred embodiment, the proportion of paste of the total amount of sugar replacement agent is between 50% and 15% by weight of the total amount of sugar replacement agent, preferably between 45% and 20% and more preferably between 43% and 25%.

The above-mentioned ratios enable the balance between sweetness and dough rheology to be optimised.

In the embodiment of rotary moulding, preferably the sugar replacement agent comprises water in an amount of less than 65wt% by weight of the total amount of sugar replacement agent, preferably less than 60wt% and preferably less than 50wt%. In a preferred embodiment, this is based on a combination of puree and pulp as mentioned above. The above ranges allow the production of a dough that is particularly well suited to rotary moulding technology owing to the rheological properties.

In an embodiment, the sugar replacement agent is present in the, preferably baked, foodstuff in an amount of less than 35.0% of sugar replacement agent by weight of the, preferably baked, foodstuff, preferably less than 30% and more preferably less than 25.0%.

In an embodiment, the, preferably baked, foodstuff comprises greater than 5.0% of sugar replacement agent by weight of the, preferably baked, foodstuff, preferably greater than 7.5%, and more preferably greater than or equal to 10.0%.

In an embodiment, the, preferably baked, foodstuff comprises between 5.0% and 30.0% by weight sugar replacement agent, more preferably between 15.0% and 20.0%

In a preferred embodiment, no significant amount of additional sugar is added to any component of the present invention, i.e. there is no additive that may be considered a sugar. In an embodiment, the foodstuff comprises an added sugar between 0.0wt% and 1.0wt%, preferably between 0.0wt% and 0.25wt%, preferably between 0.00wt% and 0.004wt%, and most preferably 0.0wt%, more preferably 0.00wt% or 0.000wt%.

In a preferred embodiment, the foodstuff contains less than 100 ppm, preferably less than 50 ppm, preferably less than 25 ppm, and most preferably 0 ppm of an added sugar.

Fat Replacement

In a preferred embodiment of the present invention, the fat replacement agent provides substantially all of the fat for the foodstuff, preferably baked foodstuff, preferably a proportion of at least 80%, preferably at least 85%, more preferably at least 90%, most preferably at least 95%, especially at least 98%, for example about 100% of the fat in the foodstuff.

In an embodiment of the present invention, the fat replacement agent comprises a nut (chestnuts, hazelnuts, Brazilian nut, almond, peanut, cashew nut, pistachio, pili, pecan, pine, hazel nut or combinations thereof) and/or a seed (sunflower, rapeseed, sesame, flaxseed, hemp seed, linseed, pumpkin or combinations thereof). In an embodiment, the fat replacement agent comprises walnut and/or cashew nut. In an embodiment, the fat replacement agent comprises sesame and/or sunflower.

In a preferred embodiment, the fat replacement agent comprises walnut or peanut.

In a preferred embodiment, the fat replacement agent is in the form of a flour. In a preferred embodiment, the flour has an average particle size of between 0.5mm and 4.0mm, preferably between 1.0mm and 3.0mm.

In a preferred embodiment, the fat replacement agent is in the form of a paste.

In a preferred embodiment, the fat replacement agent is heat treated. In a preferred embodiment, the fat replacement agent has a moisture content of between 1.0% and 20.0% by weight, more preferably between 1.5% and 15.0%, more preferably between 2.0% and 10% and more preferably between 2.0% and 7.5%.

In a preferred embodiment, the fat replacement agent comprises between 35% and 70% by weight intrinsic fat, preferably between 45% and 65%, more preferably between 55% and 65%.

The processability of the dough was found to be acceptable within the broadest intrinsic fat content range mentioned above and was found to be superior in the preferred ranges. Similarly, the texture of the biscuit dough was found to be acceptable in the broadest range and superior in the preferred ranges.

In a preferred embodiment, the selection of a paste comprising peanut, sunflower, walnut or combinations thereof provides a dough that has beneficial mixing and extrusion properties without impacting sensorial properties.

The addition of saturated fats includes fats and oils from animal or vegetable source, milk cream, emulsions and additives that contains fats like myristic acid, palmitic acid and mono and diglycerides of fatty acids.

In an embodiment, the, preferably baked, foodstuff only comprises fat that is intrinsic to ingredients present. In an embodiment, there is no added fat, i.e. there are none added.

In an embodiment, the foodstuff does not contain any component selected from the list comprising palm fat, palm stearin, butter, margarine, vegetable oils (sunflower, soy, rapeseed oil, coconut, etc.), hydrogenated oils, and interestified fats and combinations thereof, preferably none of these fats is present.

In a preferred embodiment, the vegetable oil comprises a triglyceride extracted from a plant, for example a major oil (coconut, corn, cottonseed, olive, palm, peanut, rapeseed, safflower, seasame, soybean, sunflower, for example), a nut oil (almond, beech, brazil, cashew, hazelnut, macadamia, mongongo, pecan, pine nut, pistachio, walnut, pumpkin), citrus oils, and melon and gourd seed oils, or other edible oil.

In a preferred embodiment, no significant amount of additional fat is added to any component of the present invention, i.e. there is no additive that may be considered a fat. In an embodiment, foodstuff comprises an added fat between 0.0wt% and 1.0wt%, preferably between 0.0wt% and 0.25wt%, preferably between 0.00wt% and 0.004wt%, and most preferably 0.0wt%, more preferably 0.00wt% or 0.000wt%.

In a preferred embodiment, the foodstuff contains less than 100 ppm, preferably less than 50 ppm, preferably less than 25 ppm, and most preferably 0 ppm of an added fat.

In an embodiment, the fat replacement agent is present in the, preferably baked, foodstuff in an amount of less than 30.0% of fat replacement agent by weight of the, preferably baked, foodstuff, preferably less than 25.0%, preferably less than 20.0%, preferably less than 15% and more preferably less than 10.0%.

In an embodiment, the, preferably baked, foodstuff comprises greater than 5.0% of fat replacement agent by weight of the, preferably baked, foodstuff, preferably greater than 6.5%, and more preferably greater than or equal to 8.0%.

In an embodiment, the, preferably baked, foodstuff comprises between 5.0% and 20.0% by weight fat replacement agent, more preferably between 6.5% and 10.0%.

Production Process

In an embodiment of the present invention, the baked foodstuffs are prepared by a process that comprises the steps of mixing, forming and baking. Dough can be formed using rotary moulded, lamination or extrusion equipment.

In a preferred embodiment, the forming is carried out using rotary moulding.

In an embodiment, the baking temperature is between 100 and 200°C, between 120 and 150°C, between 130 and 140°C or between 135 and 145°C.

In an embodiment, the baking time is between 5 and 20 minutes, between 6 and 12 minutes, between 7 and 11 minutes or between 8 and 9 minutes.

In a preferred embodiment, the baking step is carried out between 135 and 145°C and between 8 and 9 minutes.

In an embodiment of the present invention, the mixing step comprises one or more stages.

In a preferred embodiment, the mixing step comprises a creaming step as a first step.

In an embodiment, the first step comprises the combining of the sugar and fat replacement agents. In an embodiment, the first step may comprise the combining the ingredients in the following order: fat replacement agent with emulsifier, sugar replacement agent mixed with flavours and sweeteners and raising agents along with water.

In an embodiment, the second stage comprises dough/batter formation. In an embodiment, flour and a portion of raising agent are added to the composition produced in the first stage.

In an embodiment, any inclusions are added after the formation of the dough/batter in a second or a third step.

In a specific embodiment, mixing of ingredients was carried out in three different stages: creaming, dough formation and the addition of inclusions (oat flakes). Emulsifier was added to the fat replacement agent and mixed together. A portion of the raising agents is mixed with milk powder. Sugar replacement agents are added along with sweetener (stevia extract) and natural flavour, and mixed together during 120 seconds. Pallets were scrapped and the ingredients were mixed another 30 seconds. Flour and another portion of raising agent were added together to the cream and mixed during 60 seconds. Inclusions were added and mixed along with the dough during 30 seconds. Biscuit pieces were formed using moulds. All biscuits were baked at 140°C during 8-10 minutes.

Specific Embodiments

A preferred embodiment of the present invention is a baked foodstuff comprising a sugar replacement agent and a fat replacement agent, wherein the sugar replacement agent comprises fruit and is present in an amount of between 5.0% and 35.0% by weight of the baked foodstuff and the fat replacement agent comprises a nut and is present in an amount of between 5% and 30% by weight of the baked foodstuff and the baked foodstuff does not comprise any added sugar nor any added animal and/or vegetable fat or oil.

In the above-preferred embodiment, preferably, the sugar replacement comprises fruit paste and fruit puree and the proportion of puree of the total amount of sugar replacement agent is between 50% and 85% by weight of the total amount of sugar replacement agent and the proportion of paste of the total amount of sugar replacement agent is between 50% and 15% by weight of the total amount of sugar replacement agent.

In the above-preferred embodiments, the baked foodstuff comprises between 25.0% and 70.0% by weight flour.

In a preferred embodiment, the baked foodstuff comprises, preferably consists substantially of or consists of:

- a sugar replacement agent between 5.0% and 35.0% by weight of the baked foodstuff,
- a fat replacement agent between 5.0% and 30.0% by weight of the baked foodstuff,
- between 25.0% and 70.0% by weight of the baked foodstuff of flour, and

- less than or equal to 20.0% by weight of the baked foodstuff of other ingredients.

In a preferred embodiment, the above-preferred embodiments, the baked foodstuffs are prepared by a process that comprises the steps of mixing, forming and baking and, preferably a dough can be formed using rotary moulded, lamination or extrusion equipment.

Preferably, in all ranges defined above, the end points are included within the scope of the range as written. Additionally, the end points of the broadest ranges in an embodiment and the end points of the narrower ranges may be combined.

It will be understood that the total sum of any quantities expressed herein as percentages cannot (allowing for rounding errors) exceed 100%. For example the sum of all components of which the composition of the invention (or part(s) thereof) comprises may, when expressed as a weight (or other) percentage of the composition (or the same part(s) thereof), total 100% allowing for rounding errors. However where a list of components is non exhaustive the sum of the percentage for each of such components may be less than 100% to allow a certain percentage for additional amount(s) of any additional component(s) that may not be explicitly described herein.

The term ''substantially'' as used herein may refer to a quantity or entity to imply a large amount or proportion thereof. Where it is relevant in the context in which it is used ''substantially'' can be understood to mean quantitatively (in relation to whatever quantity or entity to which it refers in the context of the description) there comprises a proportion of at least 80%, preferably at least 85%, more preferably at least 90%, most preferably at least 95%, especially at least 98%, for example about 100% of the relevant whole. By analogy the term ''substantially-free'' may similarly denote that quantity or entity to which it refers comprises no more than 20%, preferably no more than 15%, more preferably no more than 10%, most preferably no more than 5%, especially no more than 2%, for example about 0% of the relevant whole. Preferably, where appropriate (for example in amounts of ingredient) such percentages are by weight.

Unless otherwise specified, the percentages listed are by weight.

The present invention is further described by reference to the non-limiting specific examples.

Examples

The present invention will be now be exemplified with the following specific examples.

All examples are prepared on a wt% basis.

Baked foodstuff

The following production process was used to prepare baked foodstuffs with the following compositions.

1	**Mixing Stage**	1. Creaming	Load Fat Replacement agent, Lecithin, Sugar Replacement Agents, Water, Milk Powders, Flavourings, Ammonium Bicarbonate and Sodium Bicarbonate. Mix at High Speed for 120 seconds, scrape pallets and mix for further 30 seconds.		
		2. Dough	Load flours and Mono-calcium Orthophosphate. Mix for 60 seconds under low speed.		
		3. Inclusions	Load inclusions under low speed and mix for 30 seconds.		
2	**Forming**		Forming of biscuits in rotary moulding equipment		
3	**Baking**		<u>Baking conditions:</u> **100% closed extraction**	**Time [min]**	**T° [°C]**
			Example 1	9	140
			Example 2	9	140
			Example 3	9	140
			Examples 4-6	8	140

Creaming is produced mixing the ingredients at high speed and dough is mixed at low speed to avoid gluten formation and obtain a proper consistency. High speed (125 RPM) low speed (76 RPM) in a MORTON Mixer]

Example 1 LEMON FLAVOUR BISCUIT		**Example 2** CHOCOLATE FLAVOUR BISCUIT		**Example 3** ORANGE FLAVOUR BISCUIT WITH ORANGE INCLUSIONS	
Technology: rotary moulded biscuit		**Technology**: rotary moulded biscuit		**Technology**: rotary moulded biscuit	
Ingredient name	**Percentage**	**Ingredient name**	**Percentage**	**Ingredient name**	**Percentage**
Sodium Bicarbonate	0.84	Sodium Bicarbonate	0.83	Sodium Bicarbonate	0.8
Ammonium Bicarbonate	1.30	Ammonium Bicarbonate	1.30	Ammonium Bicarbonate	0.5
Soy lecithin	0.80	Soy lecithin	0.80	Soy lecithin	0.3
Lemon flavour	0.33	Chocolate flavour	0.34	Orange flavour	0.3
Wheat flour	43.79	Wheat flour	41.20	Wheat flour	50.38
Oat flakes	5.06	Orange flakes	5.06	Orange flakes	5.2
Monocalcium Orthophosphate	0.83	Monocalcium Orthophosphate	0.83	Monocalcium Orthophosphate	0.8
Apple Puree	16.52	Banana Puree	16.53	Banana Puree	13.8
Milk powder	5.04	Milk powder	5.04	Milk powder	5.2
Walnuts flour	6.45	Walnuts flour	6.45	Walnuts flour	8.5
Dates fruit paste	11.57	Dates Paste	11.57	Dates fruit paste	8.0
Water	2.48	Rice flour	5.00	Stevia powder	0.02
Triticale flour	5.00	Cocoa powder	2.50	Water	6.2
Stevia powder	0.02	Stevia extract	0.02		
Total	**100**	**Total**	**100.00**	**Total**	**100.00**

Example 4 - WHITE + TRITICALE FLOURS LEMON FLAVOR / APPLE PULP	**Example 5** - WHITE + TRITICALE FLOURS STRAWBERRY FLAVOR / APPLE PULP	**Example 6** - WHITE + TRITICALE FLOURS PEACH FLAVOR/BANANA PURÉE
Technology: rotary moulded biscuit	**Technology**: rotary moulded biscuit	**Technology**: rotary moulded biscuit

Ingredient name	**Percentage**	**Ingredient name**	**Percentage**	**Ingredient name**	**Percentage**
Sodium Bicarbonate	0.84	Sodium Bicarbonate	0.84	Sodium Bicarbonate	0.84
Ammonium Bicarbonate	1.30	Ammonium Bicarbonate	1.30	Ammonium Bicarbonate	1.30
Lecithin Soya Liquid	0.80	Lecithin Soya Liquid	0.80	Lecithin Soya Liquid	0.78
Flavor Lemon	0.33	Flavor Strawberry	0.33	Flavor Banana	0.22
Flour Wheat Gluten 7.4%	43.78	Flour Wheat Gluten 7.4%	43.78	Flavor Orange	0.06
Flour Triticosecale 12% Protein	5.00	Flour Triticosecale 12% Protein	5.00	Flour Wheat Gluten 7.4%	45.11
Oat Pounded	5.06	Oat Pounded	5.06	Flour Triticosecale 12% Protein	5.04
Monocalcium OrthoPhosphate	0.83	Monocalcium OrthoPhosphate	0.83	Oat Pounded	5.06
Apple Pulp	16.52	Apple Pulp	16.52	Monocalcium OrthoPhosphate	0.84
Milk Cow Powder Whole 26-28%	5.04	Milk Cow Powder Whole 26-28%	5.04	Banana Puree	16.64
Flour Walnut Toasted	6.45	Flour Walnut Toasted	6.45	Milk Cow Powder Whole 26-28%	5.10
Dates Paste	11.57	Dates Paste	11.57	Flour Walnut Toasted	6.50
Water	2.48	Water	2.48	Dates Paste	11.65
				Water	0.84
TASTEVA (TATE&LYLE)	0.02	TASTEVA (TATE&LYLE)	0.02	TASTEVA (TATE&LYLE)	0.02
Total	**100**	**Total**	**100**	**Total**	**100**

Example 7

Example 5 was sensory tested against a regular biscuit made of sugar and palm fat and a commercially available biscuit which uses maltitol as a sugar replacement and vegetable oil to reduce saturated fats.

Sensory attribute	Example 5	Regular biscuit	Commercially available biscuit†
Colour	6.04	5.7	4.63
Overall odour	6.32	4.64	6.33
Hardness	5.52	5.67	6.35
Crunchiness	5.28	5.02	5.58
Dryness	5.66	5.66	5.81
Overall flavour	6.16	5.79	6.33
Sweetness	4.34	4.57	4.40
Bitterness	1.59	0	0.06

As can be seen, the present invention provides superior, or at the worst, comparable sensory properties to a regular biscuit and provides an alternative solution to the commercially available product without the need for additives (i.e. maltitol) and added fats (i.e. vegetable oil).

Example 8

Examples 4 and 5 were tested by a panel of 150 children (75 male and female, 7-8 years 50, 9-10 years 50 and 11-12 year 50). The samples received positive results in respect of general appearance (Example 4 – 74%, Example 5 – 77%), general flavour (Example 4 – 82%, Example 5 – 85%), aroma (Example 4 – 77%, Example 5 – 81%) and texture (Example 4 – 85%, Example 5 – 88%). Hence, these results show that the present invention provides sensorial-acceptable products containing no added fat or sugar.

Example 9

The below recipes were prepared for lamination using a laminator.

Sodium Bicarbonate	0.834
Ammonium Bicarbonate	0.500
Lecithin Soya Liquid	0.300
Flavor Peach	0.333
Flour Wheat Gluten 7.4%	56.011
Monocalcium OrthoPhosphate	0.834
Milk Cow Powder Whole 26-28%	5.084
Peach Pulp	13.599
Walnuts Sliced Natural	5.001
Dates Paste	6.501
Water	10.982
Sweetener Stevia Powder Rebaudioside A 95%	0.020

Sodium Bicarbonate	0.921
Ammonium Bicarbonate	0.798
Lecithin Soya Liquid	0.798
Oat Pounded	5.046
Flour WheatGln Strong 59.4%	36.073
Starch Corn	5.026
Monocalcium OrthoPhosphate	0.828
Apple Pulp	15.445
Milk Cow Powder Whole 26-28%	1.986
Peanut Paste	15.353
Dates Paste	10.235
Water	2.047
Flour Rice 12-15% Moisture	4.986
Sweetener Stevia Powder Rebaudioside A 95%	0.020
Flavor	0.438

Morton Mixer M24209

Parameter	Value
High speed, creaming (s)	350

Rondo STM 503

Parameter	Value
Mould (name)	Manual
Lamination	
final thickness	4 mm

SALVA convection oven

Parameter	Value
Baking time (min)	10
Temperature (°C)	140

Example 10

The below recipe was prepared for extrusion:

Flavor Sugar Powder SweetGem FRM	0.02
Cinnamon Powder Spice	0.41
Sodium Bicarbonate	0.82
Ammonium Bicarbonate	1.24
Lecithin Soya Liquid	0.82
Sweetener Stevia Powder Rebaudioside A 95%	0.02
Dates Paste Omni	10.31
Peanut Paste	20.62
Apple Pulp Agrozzi	15.47
Flavor Vanilla Nat	0.62
Starch Corn	4.12
Flour Wheat Gluten 7.4%	11.34
Wheat Flour With Wheat Germ	15.64

Monocalcium OrthoPhosphate	1.13
Rice Crisps	7.11
Oat Flakes Large	10.31

Mixing:

A) Creaming: Mix Apple pulp, flavors, stevia, date paste, lecithin, peanut paste, starch. High speed, 120 s.
B) Dough: Add flours, monocalcium. Lox speed, 60 s.
C) Inclusions: Add inclusions and oat flakes.

Forming: extrude using manual nozzle, 26 mm diameter.

Baking: Bake at 140°C for 3 min, then 125°C for 5 min.

Example 11

Sodium Bicarbonate	0.96
Ammonium Bicarbonate	1.40
Lecithin Soya Liquid	0.87
Oat Pounded	9.16
Flour Wheat	25.7
Starch Corn	4.6
Monocalcium OrthoPhosphate	1.2
Apple concentrate	7.8
Cranberry	7.4
Sunflower Paste	16.6
Dates Paste	10.2
Water	3.0
Flour Rice 12-15% Moisture	5.9
Corn fibre	4.0
Sweetener Stevia Powder Rebaudioside A 95%	0.020
Flavor	1.2

The above recipe was prepared using the above process from Example 10 but baked at 140°C for 4 min, then 130°C for 6 min. Sunflower paste performed well in terms of procesability (dough mixing, extrusion), in terms of analytical parameters (moisture, water activity) and sensorially (off flavors).

Accordingly, contrary to know prior art products, the combination of sugar and fat replacement agents enable the production of baked products, preferably biscuits, that do not contain added fats (e.g. vegetable oils, butter etc.) or added, isolated sugars (e.g. sugar syrups, honey etc.) without a loss of rheological properties in the dough and organoleptic properties in the product.

CLAIMS

1. A foodstuff comprising a sugar replacement agent and a fat replacement agent, preferably the foodstuff is a baked foodstuff.

2. The foodstuff of claim 1, wherein the baked foodstuff is selected from the group consisting of a biscuit, a cookie, a wafer and a cracker.

3. The foodstuff of any of claims 1 to 2, wherein the sugar replacement agent comprises fruit.

4. The foodstuff of any of claims 1 to 3, wherein the fat replacement agent comprises nut, preferably a nut flour.

5. The foodstuff of any of claims 3 to 4, wherein the sugar replacement agent comprises a fruit paste, a fruit purée or juice.

6. The foodstuff of any of claims 3 to 5, wherein the fruit is selected from the group consisting of date palm fruit, raisins, plums, prunes, apples, banana, blueberry, peach or combinations thereof.

7. The foodstuff of any of claims 4 to 6, wherein the fat replacement agent is selected from the group consisting of chestnuts, hazelnuts, Brazilian nut, almond, peanut, cashew nut, pistachio or combinations thereof.

8. The foodstuff of claim 7, wherein the sugar replacement agent comprises apple purée and date palm fruit, and the fat replacement agent comprises walnut flour.

9. The foodstuff of any of claims 1 to 8, wherein the foodstuff does not comprise any added sugar nor any added animal and/or vegetable fat or oil.

10. The foodstuff of any of claims 1 to 9, wherein the foodstuff comprises between 5% and 30% by weight of the sugar replacement agent, preferably between 15% and 20%.

11. The foodstuff of any of claims 1 to 10, wherein the foodstuff comprises between 5% and 20% by weight of the fat replacement agent, preferably between 6.5% and 10%.

12. The foodstuff of any of claims 5 to 11, wherein the sugar replacement agent comprises a fruit paste and a fruit puree, preferably the proportion of puree of the total amount of sugar replacement agent is between 50% and 85% by weight of the total amount of sugar replacement agent and the proportion of paste of the total amount of sugar replacement agent is between 50% and 15% by weight of the total amount of sugar replacement agent.

13. The foodstuff of claim 12, wherein the fruit paste comprises date palm fruit and the fruit puree comprises apple, banana, blueberry or peach or combinations thereof.

14. The foodstuff of any of claims 1 to 13, wherein the baked foodstuff is prepared using rotary moulded, laminator or an extrusion machine.

15. A process for preparing a foodstuff of any of claims 1 to 13, comprising the steps of creaming, dough or batter production, optional inclusion addition, foodstuff formation in a rotary moulding apparatus and baking.

INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2019/075359

A. CLASSIFICATION OF SUBJECT MATTER
INV. A21D2/36 A21D13/062 A21D13/068
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
A21D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DATABASE GNPD [Online] MINTEL; 11 December 2017 (2017-12-11), anonymous: "Raw Strawberry Cookie Bar", XP055524212, retrieved from www.gnpd.com Database accession no. 5305891 the whole document ----- DATABASE GNPD [Online] MINTEL; 3 January 2014 (2014-01-03), anonymous: "Spelt Filled Speculoos Cake without Added Sugar", XP055524217, retrieved from www.gnpd.com Database accession no. 2273289 the whole document ----- -/--	1-15
X		1-15

[X] Further documents are listed in the continuation of Box C. [ ] See patent family annex.

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Date of the actual completion of the international search	Date of mailing of the international search report
9 October 2019	18/10/2019

Name and mailing address of the ISA/	Authorized officer
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C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DATABASE GNPD [Online] MINTEL; 18 March 2016 (2016-03-18), anonymous: "Guilt-Free Brownie", XP055524214, retrieved from www.gnpd.com Database accession no. 3876413 the whole document -----	1-15
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X	Anonymous: "Bananen-Tonka-Plätzchen ¦ BRIGITTE.de", , 1 January 2017 (2017-01-01), pages 1-2, XP055524220, Retrieved from the Internet: URL:https://www.brigitte.de/rezepte/plaetzchen/bananen-tonka-plaetzchen-10976048.html [retrieved on 2018-11-15] the whole document -----	1-15
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C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	Anonymous: "Low Carb Schokokekse ohne Zucker ¦ Backen macht glücklich", , 23 January 2017 (2017-01-23), pages 1-32, XP055524223, Retrieved from the Internet: URL:https://www.backenmachtgluecklich.de/rezepte/low-carb-schokoladenkekse-ohne-zucker.html [retrieved on 2018-11-15] the whole document -----	1-15
X	Anonymous: "Fruit Seed and Nut Crackers - Averie Cooks", , 11 May 2013 (2013-05-11), pages 1-35, XP055524277, Retrieved from the Internet: URL:https://www.averiecooks.com/fruit-seed-and-nut-crackers/# [retrieved on 2018-11-15] the whole document -----	1-15

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