

Contents

Samenvatting	i
Summary	v
Contents	ix
1. Introduction	
1.1 Background	1
1.2 Fundamentals and history of pulsed electric field (PEF) treatment	3
1.3 Pre- and post-packaging treatment	6
1.4 Problem definition	7
1.5 Objectives	12
1.6 Thesis layout	12
2. Literature review	
2.1 Introduction	15
2.2 Review of PEF treatment technology	16
2.2.1 Principles and process parameters	16
2.2.2 Taxonomy and properties of cells	21
2.2.3 Electrical product properties and required power	24
2.2.4 PEF treatment chambers	25
2.3 Review of liquid food packaging and treatment	28
2.3.1 Types of primary packages	29
2.3.2 Electrical material properties	33
2.3.3 Environmental effects	34
2.3.4 Treatment concepts	35
2.4 Electrically-conductive polymer materials	39
2.4.1 Intrinsically-conductive polymers	39
2.4.2 Extrinsically-conductive polymers	39
2.5 Outlook and industrial future	41
2.5.1 PEF technology	41
2.5.2 Packaging technology	42
2.6 Summary	43
3. Electric field in closed containers	
3.1 Introduction	45
3.2 Methods of generating an electric field inside food packages	46
3.2.1 Embedded electrodes	46

3.2.2	Dielectric barrier	47
3.2.3	Weakly conductive package	50
3.2.4	Magnetic induction	53
3.3	Selection of the most appropriate method	56
3.4	Processing concepts by using weakly conductive packages	57
3.4.1	One by one treatment of cartons or pouches	58
3.4.2	Continuous treatment	59
3.4.3	Power reduction	60
3.4.4	Control of high local electric fields	62
3.4.5	Submerged treatment	63
3.5	Applicator constructions	64
3.5.1	Submerged	64
3.5.2	Flat electrodes	65
3.5.3	Cylindrical electrodes	66
3.6	Vertical process	67
3.7	Packaging material specification for PEF in-pack	69
3.8	Conclusions	72
4.	Film characterisation and suitability	
4.1	Introduction	73
4.2	Conductive composite film survey	74
4.2.1	Conductivity of thin films	74
4.2.2	Carbostat TM film	76
4.3	Film characterisation	77
4.3.1	Composition	78
4.3.2	Intrinsic electrical film conductivity at DC	80
4.3.3	Pulsed intrinsic film conductivity	85
4.3.4	Surface structure	86
4.3.5	Final remarks	89
4.4	Contact resistance	90
4.4.1	Measurement of contact resistance	91
4.4.2	Bare-film to copper contact resistivity at DC	92
4.4.3	Film to copper contact resistivity (pulsed)	93
4.5	Membrane potential with composite electrodes	96
4.5.1	Electric field model	97
4.5.2	Comparison with full conductive electrodes	98
4.6	Proof of principle	99
4.6.1	Construction demonstrator and test set-up	100
4.6.2	Bacterial electric field validation	102
4.6.3	Experiments	103
4.6.4	Results	105
4.7	Conclusions and remarks	108

5.	Processes and constructions with conductive films	
5.1	Introduction	111
5.2	Effect of fringing on system design	112
	5.2.1 Required peak power due to fringing	113
	5.2.2 Pulse repetition versus effective length of the treatment zone	115
	5.2.3 Energy versus bacterial inactivation - comparison criterion	116
5.3	Applicator electric field distribution and submerged power calculation	117
	5.3.1 Electric field distribution for cylindrical electrodes - analytical	118
	5.3.2 Required power for cylindrical and flat electrodes - FE	122
	5.3.3 Flat electrodes and sets of multiple rollers	125
	5.3.4 Concluding remarks	129
5.4	Origin of electric field enhancements	131
	5.4.1 Modelling of seals	131
	5.4.2 Anisotropic conductive film	132
	5.4.3 Unequal conductivity of film and food	134
	5.4.4 Concluding remarks	136
5.5	Cases	136
	5.5.1 Treatment of orange juice in pouches	136
	5.5.2 Treatment of dairy sticks	140
	5.5.3 Cascading applicators and intermediate cooling	142
5.6	Conclusions	143
6.	Conclusions and recommendations	
6.1	Conclusions	145
	6.1.1 Summary of conclusions	145
	6.1.2 Results from literature	146
	6.1.3 Electric field generation inside a package	146
	6.1.4 Application of PEF in-pack	148
	6.1.5 Thesis contributions	149
6.2	Recommendations for further research	150
Appendices		
	belonging to Chapter 3	
	3A Electrical loss in the packaging material	153
	belonging to Chapter 4	
	4A Construction of the film clamp and pulse source	159
	4B Polymer analysis techniques (DMA, TGA & SPM)	163
	4C Conductive filler fraction versus conductive area fraction	167
	4D Construction of the demonstrator and test set-up	171
	4E Electric field distribution in the demonstrator	175

4F	Comparison of test set-ups and microbial data	179
4G	Thermal analysis of the demonstrator	183
belonging to Chapter 5		
5A	Electric field distribution of cylindrical electrodes	187
5B	Finite element model of a submerged pouch	195
References		199
List of abbreviations, symbols and indices		217
Dankwoord		221
List of publications		223
Curriculum Vitae		227