ABSTRACT

Utilization of whey for the preparation of new food products may be an alternative to minimize environmental problems and reduce the disposal of high nutritional value by-products. This study aimed to prepare chocolate milkshakes with chia by partially replacing milk with whey. Three milkshake formulations were developed: a control formulation (without whey), a formulation containing 36% milk and 24% whey, and a formulation containing 24% milk and 36% whey. Microbiological parameters, proximate composition, energy value, total solids, titratable acidity, pH, and water activity were evaluated after preparation. The data were subjected to Analysis of Variance in a Completely Randomized Design, and means were compared by Tukey’s test at the 5% significance level. Milkshakes were found to have good microbiological quality, with low counts of thermotolerant coliforms (determined at 45 °C) (< 3 MNP/g) and yeasts and filamentous fungi (< 10 CFU/g). That replacement of milk by whey resulted in a reduction in ash, lipid and energy values and an increase in carbohydrate values. One portion of the developed milkshakes was estimated to provide between 72.12 and 84.52 Kcal. There were no significant differences in titratable acidity, total solids, or water activity between formulations. It is inferred that chocolate milkshakes with chia prepared with partial replacement of milk by whey are a feasible and innovative alternative to minimize environmental impacts. Complementary studies are recommended on storage stability and sensory quality.

Keywords: Functional foods. Ice-cold foods. Agro-industrial wastes.
microbiológica, composição proximal e análises físico-químicas quanto aos parâmetros valor calórico, extrato seco, acidez total, pH e atividade de água foram avaliados, após o processamento. Os dados obtidos foram analisados através de Análise de Variância, em Delineamento Inteiramente Casualizado, comparando-se as médias pelo teste de Tukey a nível de 5% de significância. Verificou-se boa qualidade microbiológica, com baixas contagens para coliformes a 45 ºC (< 3 NMP/g) e fungos filamentosos e leveduriformes (< 10 UFC/g). A inclusão de soro de leite provocou redução nos teores de cinzas, lipídeos e valores calóricos, bem como aumento nos teores de carboidratos. O consumo dos milkshakes indicou que as porções fornecem de 72,12 a 84,52 Kcal. Não houveram diferenças significativas entre os milkshakes para os parâmetros acidez total, extrato seco e atividade de água. Infere-se que a elaboração de milkshakes de chocolate com chia, substituindo parcialmente o leite por soro de leite, pode ser viável e uma alternativa inovadora para minimizar impactos ambientais, sendo recomendadas análises complementares sobre a estabilidade de armazenamento e a qualidade sensorial.


1 INTRODUCTION

Whey, a by-product of the dairy industry, accounts for 80 to 90% of the total volume of milk used in cheese production. Whey is rich in organic compounds and retains about 55% of the nutrients present in milk, needing adequate treatment before disposal to minimize environmental impacts (ALVES et al., 2014; VILELA et al., 2020). Aiming to prevent the waste of this high nutritional value by-product, food industries and researchers have investigated sustainable alternatives for whey utilization. A major application is in the development of novel food products (ALVES et al., 2014).

In recent years, whey has been extensively used in the production of cheese bread (TESSER et al., 2010), sliced bread (OLIVEIRA et al., 2011), whey powder (PERRONE et al., 2014), dulce de leche (LIMA; ROCHA, 2016), ice creams (VETTORELLO et al., 2017), milk spreads (MENESES et al., 2019), and drink mixes (HOLANDA et al., 2020). However, there are no reports in the literature on the use of whey for the preparation of milkshakes.

Brazilian legislation (RDC No. 266/2005) defines ice-cold foods as frozen food products obtained from an emulsion of fats and proteins or from a mixture of water and sugar (BRAZIL, 2005a). The development of new ice-cold food products (such as popsicles, ice creams, and milkshakes) containing whey represents an innovative strategy (VETTORELLO et al., 2017).

There is an increasing demand for food products containing functional ingredients. According to Silva et al. (2014), functional foods provide benefits that go beyond the role of nutrition. Fortified, enriched, and enhanced foods have beneficial health effects when consumed as part of a varied diet (SOUZA et al., 2013).
Chia (Salvia hispanica L.) seeds are widely known for their functional properties and high contents of polyunsaturated fats, essential amino acids, fibers and antioxidants (CAPITTANI et al., 2012; COELHO; SALAS-MELLADO, 2014). Chia consumption promotes satiety, improves intestinal motility, and reduces the risk of diabetes (MADRUGA; ROCHA; FERNANDES, 2020).

Given the need to find novel applications for whey and vehicles for functional ingredients, this study aimed to develop chocolate chia milkshakes by partially replacing milk with whey and determine the effects of milk replacement on microbiological and physicochemical parameters.

2 MATERIAL AND METHODS

This study was conducted at the Federal Institute of Education, Science and Technology of Rio Grande do Norte, Pau dos Ferros-RN campus, Rio Grande do Norte State, Brazil. Ultrahigh temperature (UHT)-treated milk, powdered milk, light cream, 100% cocoa powder, emulsifier (Emustab®), table sugar, and chia flour were purchased from a local market. The whey resulting from the manufacture of Coelho cheese was purchased from a cheese factory in Pau dos Ferros-RN. After collection, whey samples were transported to the laboratory in a cool box with ice and then treated at 85 °C for 15 min to promote enzyme inactivation and fat separation.

Three chocolate milkshake with chia formulations were developed on the basis of preliminary tests: M1, a control formulation (without whey); M2, milkshake containing 36% milk and 24% whey; and M3, milkshake containing 24% milk and 36% whey. Ingredient proportions are presented in Table 1.

<table>
<thead>
<tr>
<th>Ingredient (%)</th>
<th>Formulation</th>
<th>M1</th>
<th>M2</th>
<th>M3</th>
</tr>
</thead>
<tbody>
<tr>
<td>UHT milk</td>
<td>60</td>
<td>36</td>
<td>24</td>
<td></td>
</tr>
<tr>
<td>Whey</td>
<td>0</td>
<td>24</td>
<td>36</td>
<td></td>
</tr>
<tr>
<td>Powdered milk</td>
<td>10</td>
<td>10</td>
<td>10</td>
<td></td>
</tr>
<tr>
<td>Light cream</td>
<td>10</td>
<td>10</td>
<td>10</td>
<td></td>
</tr>
<tr>
<td>Cocoa powder</td>
<td>8</td>
<td>8</td>
<td>8</td>
<td></td>
</tr>
<tr>
<td>Emulsifying agent</td>
<td>5</td>
<td>5</td>
<td>5</td>
<td></td>
</tr>
<tr>
<td>Table sugar</td>
<td>5</td>
<td>5</td>
<td>5</td>
<td></td>
</tr>
<tr>
<td>Chia flour</td>
<td>2</td>
<td>2</td>
<td>2</td>
<td></td>
</tr>
</tbody>
</table>

Source: Authors (2020).

The first step in the preparation of milkshakes was to mix the liquid ingredients (UHT milk, whey, and light cream). Then, the solid ingredients (milk powder, cocoa powder, table sugar, emulsifier, and chia flour) were added.
COSTA, J. C. et al. Utilization of whey for the preparation of chocolate milkshakes with chia (Salvia hispanica L.) sugar, and chia flour) were incorporated using an industrial blender. The resulting mixtures were stored at -18 °C for 3 h, until the outer surface began to freeze. Homogenization and gradual addition of emulsifier were performed for 15 min in an industrial mixer. Milkshakes were stored in polyethylene containers (200 mL) at -18 °C until analysis.

Microbiological quality was assessed after processing by determination of total coliforms (at 35 °C), thermotolerant coliforms (at 45 °C), and yeasts and filamentous fungi, according to the methods described by Silva et al. (2017).

Physicochemical analysis were performed after processing in triplicate. Water content and total solids were determined by oven-drying samples at 105 °C for 24 h, ash contents by heating in a muffle furnace at 550 °C for 6 h, titratable acidity (expressed as lactic acid) by titration with a standard solution of 0.1 N NaOH, and pH by using a portable pH meter calibrated with pH 4.0 and 7.0 buffer solutions, according to Adolfo Lutz Institute methods (ALI, 2008). Lipids (FOLCH; LESS; STANLEY, 1957) and proteins (AOAC, 2016) were also quantified. Carbohydrate contents were then calculated by subtracting the sum of moisture, ash, lipid, and protein contents from 100. Energy values were estimated in accordance with national legislation (BRAZIL, 2005b). Water activity was measured at 25 °C using a water activity meter (LabStart®, Novasina).

Physicochemical data were subjected to analysis of variance in a Completely Randomized Design, followed by Tukey’s test at p< 0.05 for comparison of means. Statistical analysis were performed using Assistat software version 7.7 beta (SILVA; AZEVEDO, 2016).

3 RESULTS AND DISCUSSION

Table 2 shows the microbiological properties of chocolate milkshakes with chia.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Formulation</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>M₁</td>
</tr>
<tr>
<td>Total coliforms (MPN/g)</td>
<td>1.10 × 10³</td>
</tr>
<tr>
<td>Thermotolerant coliforms (MPN/g)</td>
<td>&lt; 3</td>
</tr>
<tr>
<td>Yeasts and filamentous fungi (CFU/g)</td>
<td>&lt; 10</td>
</tr>
</tbody>
</table>

M₁, milkshake formulated without the addition of whey; M₂, milkshake containing 36% milk and 24% whey; M₃, milkshake containing 24% milk and 36% whey; MPN, most probable number; CFU, colony-forming units. Source: Authors (2020).

Chocolate milkshakes with chia contained 1.10 × 10³ MPN/g total coliforms. The presence of coliforms is likely associated with the use of dairy ingredients. Lactic acid
bacteria are commonly found in dairy products and can multiply in a similar manner to that of coliform bacteria. The concentrations of thermotolerant coliforms (< 3 MPN/g) and yeasts and filamentous fungi (< 10 CFU/g) were low, indicating that raw materials were of good quality and that processing methods were adequate. Partial replacement of milk by whey did not influence the microbiological quality of milkshakes. This result shows that the heat treatment applied to whey was effective in eliminating pathogenic and spoilage microorganisms.

In Brazil, microbiological standards for foods are described in Normative Instruction No. 60/2019. However, the legislation does not determine limits for total and thermotolerant coliforms or yeasts and filamentous fungi in milkshakes (categorized as iced-cold foods) (BRAZIL, 2019). Teixeira et al. (2019) assessed the microbiological properties of three biofortified functional ice cream formulations and found that food items were microbiologically safe for consumption. The concentration of thermotolerant coliforms (< 3 MPN/g) was similar to that observed in chocolate chia milkshakes.

The proximate composition and energy value of chocolate chia milkshakes are described in Table 3.

Table 3 – Proximate composition and energy value of chocolate chia milkshakes formulated with different concentrations of whey

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Formulation</th>
<th>Mean</th>
<th>LSD</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>M1</td>
<td>M2</td>
<td>M3</td>
</tr>
<tr>
<td>Water (%)</td>
<td>76.27± 0.58</td>
<td>77.11± 0.89</td>
<td>76.84± 0.75</td>
</tr>
<tr>
<td>Ash (%)</td>
<td>1.92± 0.09</td>
<td>1.52± 0.10</td>
<td>1.38± 0.03</td>
</tr>
<tr>
<td>Protein (%)</td>
<td>8.28± 0.35</td>
<td>8.44± 0.12</td>
<td>8.83± 0.30</td>
</tr>
<tr>
<td>Lipid (%)</td>
<td>10.72± 0.41</td>
<td>8.53± 0.28</td>
<td>6.61± 0.33</td>
</tr>
<tr>
<td>Carbohydrate (%)</td>
<td>2.81± 0.88</td>
<td>4.39± 0.91</td>
<td>6.34± 0.89</td>
</tr>
<tr>
<td>Energy value (Kcal/100 g)</td>
<td>140.87± 0.90</td>
<td>128.12± 0.96</td>
<td>120.20± 0.93</td>
</tr>
</tbody>
</table>

M1, milkshake formulated without the addition of whey; M2, milkshake containing 36% milk and 24% whey; M3, milkshake containing 24% milk and 36% whey; LSD, least significant difference. Means followed by the same letter do not differ at p< 0.05 by Tukey’s test. Source: Authors (2020).

Partial substitution of milk by whey did not influence water content (p> 0.05), but M1 contained higher levels (76.27%) than M2 (77.11%), resulting from differences in composition. The water content of chocolate ice cream with orange peel fiber (63-70%) (BOFF et al., 2013) was lower than that of chocolate milkshakes with chia prepared in this study.

Ash content was highest (p< 0.05) in M1 (1.92%), differing from that in M2 and M3, which were prepared by partial substitution of milk by whey. This finding indicates that milk has a higher ash content than whey. The use of chia flour probably increased the content of...
minerals, vitamins, and natural antioxidants such as tocopherols and polyphenols, compounds that are commonly found in chia seeds (IXTAINA et al., 2011).

The protein content of milkshakes ranged from 8.28% in M₁ to 8.83% in M₃. It is likely that chia flour contributed to the high protein content of milkshakes. According to Olivos-Lugo, Valdivia-López e Tecante (2010), chia seeds are an important source of protein, with protein contents ranging from 19 to 23%. Rodrigues et al. (2018) reported that the protein content of acai pulp and whey protein ice cream ranged from 3.99 to 10.25% according to the content of whey; the higher the whey concentration, the higher the protein content. In a study by Barcelos et al. (2019), chocolate ice cream was found to have a protein content of 1.70-3.69%, lower than that of chocolate chia milkshake.

Lipid content was highest (p< 0.05) in M₁ (10.72%). The higher the substitution of milk by whey, the lower the lipid content. According to Santos et al. (2013) and Punia and Dhull (2019), healthy foods have high nutritional quality and low fat contents, contributing to body weight control, reduced energy intake, and decreased risk of cardiovascular diseases.

No differences (p> 0.05) in carbohydrate content were observed between M₂ and the other formulations, although M₁ and M₃ differed from each other. The parameter was highest in M₃ (6.34%), which had the highest whey concentration (24% milk and 36% whey). Whey is composed of about 5% lactose, its second major component (PESCUMA et al., 2010; BARUKČIĆ et al., 2015). Risner et al. (2019) stated that lactose is the main carbohydrate in milk and is present at high concentrations in whey. Vettorello et al. (2017) prepared ice cream using whey powder and found the food to contain 15.38–16.93% carbohydrates.

M₂ and M₃ had a lower (p< 0.05) energy value than M₁. The reduction in energy value with the addition of whey was probably associated with the concomitant reduction in lipid content. Although RDC No. 359/2003 (BRAZIL, 2003) does not determine a serving size for milkshake, it can be considered as 60 g, the same serving size of ice cream, which is the food item that most resembles milkshake. On the basis of this value, it was estimated that one portion of chocolate milkshake with chia provides 72.12 (M₃) to 84.52 Kcal (M₁), corresponding to 3.61 and 7.04% of the total energy value of a 2000 Kcal/day diet.

The physicochemical properties of chocolate milkshakes with chia are presented in Table 4.


**Table 4 – Physicochemical parameters of chocolate chia milkshakes formulated with different concentrations of whey**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Formulation</th>
<th>Mean</th>
<th>LSD</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>M₁</td>
<td>M₂</td>
<td>M₃</td>
</tr>
<tr>
<td>Total solids (%)</td>
<td>23.73⁺ ± 0.58</td>
<td>22.89⁺ ± 0.89</td>
<td>23.16⁺ ± 0.75</td>
</tr>
<tr>
<td>Titratable acidity (%)</td>
<td>0.44⁺ ± 0.03</td>
<td>0.44⁺ ± 0.01</td>
<td>0.44⁺ ± 0.01</td>
</tr>
<tr>
<td>pH</td>
<td>6.74⁺ ± 0.03</td>
<td>6.69⁺ ± 0.02</td>
<td>6.65⁺ ± 0.02</td>
</tr>
<tr>
<td>Water activity</td>
<td>0.88⁺ ± 0.01</td>
<td>0.88⁺ ± 0.01</td>
<td>0.87⁺ ± 0.01</td>
</tr>
</tbody>
</table>

M₁, milkshake formulated without the addition of whey; M₂, milkshake containing 36% milk and 24% whey; M₃, milkshake containing 24% milk and 36% whey; LSD, least significant difference. Means followed by the same letter do not differ at p< 0.05 by Tukey’s test. Source: Authors (2020).

Total solids ranged from 22.89% in M₂ to 23.73% in M₁. According to Kozlowicz et al. (2019), low concentrations of total solids may negatively impact the formation of ice crystals, decreasing product quality. Vettorello et al. (2017), in assessing the properties of ice cream composed of whey powder, found that total solids varied from 21.14 to 25.85%, similar to the range observed in the present study.

All milkshakes had a titratable acidity of 0.44%. The pH was close to neutrality, ranging from 6.65 in M₃ to 6.74 in M₁; the pH of M₃ was significantly lower (p< 0.05) than that of the other formulations. Campidelli et al. (2015) reported blueberry chia ice cream to have a pH of 5.55, lower than that of chocolate chia milkshakes.

Water activity also did not differ between milkshakes (p> 0.05). Values ranged from 0.87 (M₃) to 0.88 (M₁ and M₂). Water activity values were high, which, according to Sandulachi (2012), increases susceptibility to microbial growth and biochemical reactions responsible for spoilage.

### 4 CONCLUSIONS

Chocolate milkshakes with chia had good microbiological quality. Partial replacement of milk by whey exerted significant effects on ash, lipid, and carbohydrate contents as well as energy value and pH. Milkshake containing 24% milk and 36% whey had the lowest lipid content and energy value and the highest carbohydrate content. The use of whey as a partial substitute for milk is a feasible and innovative strategy to minimize environmental impacts. Further studies should investigate the storage stability and sensory quality of chocolate chia milkshakes.
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AUTHOR INFORMATION

Julimeri Câmar Costa
E-mail: july_camara99@hotmail.com
Curriculum Lattes: http://lattes.cnpq.br/1031037864589102

Emanuel Neto Alves de Oliveira
E-mail: emanuel.oliveira16@gmail.com
Curriculum Lattes: http://lattes.cnpq.br/8785951951414869
Graduated in Food Technology from the Faculty of Technology CENTEC - Cariri (2009), Specialist in Chemistry Teaching by the Regional University of Cariri (2009), in Food Science by the Federal University of Pelotas (2012) and in Public Management by the IFRN (2020). Master (2012) and Doctor (2016) in Agricultural Engineering in the Area of Concentration in Processing and Storage of Agricultural Products by the Federal University of Campina Grande. He has a Post-Doctorate in Chemical Engineering from the University of Coimbra, Portugal (2018) in the area of Technology and Quality Control of Wines. He is a Professor at the Federal Institute of Education, Science and Technology of Rio Grande do Norte (IFRN), based on the Pau dos Ferros/RN campus where he currently holds the position of General Director of the campus. He has experience in the field of Agricultural Engineering and Food Science and Technology, working mainly on the following topics: Drying and Storage of Agricultural Products, Food Processing of Vegetable and Animal Origin, Physical and Chemical Analysis of Food and Quality Control. He is a permanent professor of the Academic Master's Course in Teaching of the Graduate Program in Teaching (PPGE) of the Advanced Campus of Pau dos Ferros (CAPF), of the State University of Rio Grande do Norte (UERN) in the line of research of Teaching Exact and Natural Sciences. Currently, he also
works at the National Institute of Educational Studies and Research Anísio Teixeira (INEP) as an institutional appraiser of higher education institutions.

Kaisa Mikelly Pereira Oliveira  
E-mail: kaisa_mikelly@hotmail.com  
Curriculum Lattes: [http://lattes.cnpq.br/4031803729316210](http://lattes.cnpq.br/4031803729316210)  

Rerisson do Nascimento Alves  
E-mail: rerisson-alves@hotmail.com  
Curriculum Lattes: [http://lattes.cnpq.br/3427416952900222](http://lattes.cnpq.br/3427416952900222)  
Food Engineer from the Federal University of Campina Grande (2017). He is currently studying for a Master's Degree in Agri-Food Technology at the Federal University of Paraíba (UFPB). He was a fellowship monitor in the Cytology and Histology discipline for 6 consecutive periods (2013.1 to 2015.2). He participated in scientific initiation projects in the manufacture of rennet-type goat's milk cheeses and the development of quality indicator packaging for food. He gave a lecture to slaughterhouse owners in the municipality of Pombal-PB with the theme "Good Handling Practices for Refrigerators". He worked as a collaborator in the Project for the Development of Goat Breeding in the Semi-Arid Region of Paraíba. He has experience in the area of Food Science and Technology, with an emphasis on cytology and histology, quality control, technology of animal products and food packaging technology.

Bruno Fonsêca Feitosa  
E-mail: brunofonsecafeitosa@live.com  
Curriculum Lattes: [http://lattes.cnpq.br/6593307184392271](http://lattes.cnpq.br/6593307184392271)  
Food Technician (IFRN, 2016). Academic in Food Engineering (UATA/CCTA/UFCG, 2017.1). He received a scholarship from the Foundation Paraíba Technological Park (PaqTcPB) and the National Council for Scientific and Technological Development (CNPq). Research in the area of Food Science and Technology, with experience in analysis and quality control of food, technology and processing of fruit and milk, development of new products and use of agro-industrial residues.

Rosane Liege Alves de Souza  
E-mail: rosaneliege@yahoo.com.br  
Curriculum Lattes: [http://lattes.cnpq.br/2994260248217828](http://lattes.cnpq.br/2994260248217828)  