1 The use of Tenax[®] films to demonstrate the migration of chemical

- 2 contaminants from cardboard into dry food.
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19 The use of Tenax[®] films to demonstrate the migration of chemical 20 contaminants from cardboard into dry foodstuffs.

21 Contaminants in food packaging are a challenge of our time since the packaging 22 material itself has been found to represent a source of food contamination 23 through the migration of substances from the packaging. Before first use, packaging materials destined for the packaging of dry foods can be evaluated by 24 performing migration experiments with the simulant for dry foods: Tenax[®]. This 25 simulant is commercially available as a powder that is more difficult to handle 26 during the migration experiments. In this contribution a Tenax[®] film was 27 28 developed. The film can be applied to the cardboard surface to conduct the 29 migration test. After the migration is completed, the film can be easily extracted to determine the concentration of the contaminants in the film. Finally, the 30 performance of the Tenax[®] film was compared to the conventional Tenax[®] 31 powder for the evaluation of 15 model migrants. 32

- 33 Keywords: Tenax[®]; film; food simulant; migration testing; food contact material
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36 Introduction

37 Recent improvements in food production and distribution have led to an increased sophistication of food packaging. Unfortunately, non-inert materials, like 38 39 paper and board, can be a direct source of chemical contaminants. Chemical partitioning 40 from the packaging into the food is known as migration. In 1999, Boccacci et al. 41 showed that diisopropylnaphtalene (DiPN) was transferred from cardboard to rice, pasta 42 and maize flour already after three days at ambient temperature (Boccacci et al. 1999). 43 Inevitably, several alerts for food contamination caused by migration have been 44 Examples are the presence of photo-initiator reported in the past. 2isopropylthioxanthenone (2-ITX) in instant baby milk and photo-initiator 4-45 methylbenzophenone (4-MBP) in breakfast cereals, leading to the temporary 46 47 withdrawal of these products from the market (IBFAN 2005, EFSA 2009).

48 Therefore, a careful evaluation of food contact materials and their interactions 49 with food is needed to ensure consumers' safety. Evaluation of the migration of 50 chemical contaminants in food is necessary but challenging due to the complexity of the 51 matrix and the wide variety of foods that need to be analysed. If a food contact material 52 is not yet in contact with food, the contact material can be checked for compliance using 53 food simulants. According to the European Regulation No 10/2011, the official simulant 54 for dry food is poly(2,6-diphenylphenylene oxide), also known under its commercial name Tenax[®] (Regulation (EU) N° 10/2011). 55

Numerous studies have been reported on the migration of contaminants from
FCM into Tenax[®]. A few examples are the migration of phthalates (Aurela et al. 1999),
diisopropylnaphthalene (Summerfield & Cooper 2001), dihydroabietic and abietic acids
(Ozaki et al. 2006), alkylbenzenes (Aurela et al. 2001) and fatty acid esters (Richter et

al. 2009). Furthermore, Cannelas et al. demonstrated the use of Tenax[®] in the
determination of non-intentionally added substances in acrylic adhesives (Cannelas et
al. 2012) and Zurfluh et al. studied the use of Tenax[®] for the analysis of mineral oil
saturated hydrocarbons (MOSH) from recycled paperboard (Zurfluh et al. 2013).
Furthermore, Triantafyllou (Triantafyllou et al. 2007), Bradley (Bradley et al. 2014) and
Nerín (Nerín et al. 2007a) demonstrated the use of Tenax[®] for a kinetic evaluation of
certain migrants.

Before use, Tenax[®] is usually cleaned multiple times by soxhlet and dried 67 afterwards. Next, Tenax[®] is applied on the food contact material surface for a certain 68 69 contact time and contact temperature. According to the internationally recognised 70 standard on overall migration from plastic materials and articles in contact with foodstuffs, 4 gram of Tenax[®] per square decimetre of surface area of the test specimen 71 72 is required to cover the food contact surface sufficiently (EN 1186-13:2002). Nevertheless, it was demonstrated that 1 gram of Tenax[®] is equally sufficient to cover a 73 74 0.15 dm² circular sample (Jakubowska et al. 2014). After the migration is completed, Tenax[®] is removed from the food contact material surface and extracted. Extracts are 75 usually analysed using gas or liquid chromatography. The use of the Tenax[®] powder as 76 a simulant for dry foodstuffs is rather inconvenient since the Tenax[®] powder has to be 77 78 entirely collected in a recipient prior to contaminant extraction. Hence, the concept of a practical Tenax[®] film was introduced. 79

In 2010, Alfeeli et al. developed thin Tenax[®] films as adsorbent material for micro preconcentration applications (Alfeeli et al. 2011). Tenax[®] was dissolved in dichloromethane and used to coat the embedded high-aspect-ratio three-dimensional micro pillars of the micro preconcentrator at room temperature or at frozen conditions (Alfeeli et al. 2011). Furthermore, Alfeeli et al. concluded that there was no difference 85 in the adsorption properties between the powder and the film form (Alfeeli et al. 2010).

Next, in 2013, Tenax[®]-coated silica nanoparticles were incorporated as an
adsorbent bed in silicon based micro-thermal preconcentrator chips (Akbar et al. 2013).
Tenax[®] was dissolved in dichloromethane and again evaporated to leave a thin film of
the polymer adsorbent on the cavity surfaces of the micro-thermal preconcentrator chips
(Akbar et al. 2013).

91 Recently, Tenax[®] was combined with the zeolite material ZSM-5 in order to 92 form a thin film microextraction device that was used as a novel alternative tool for 93 headspace volatile organic compound extraction and preconcentration (Goda et al. 94 2014). Tenax[®] was dissolved in chloroform and used to apply thin flat films via dip 95 coating. The coating took place at room temperature in ambient air (Goda et al. 2014).

96 In this contribution, Tenax[®] films were constructed by dissolvation in 97 chlorinated solvents, followed by evaporation under air. The Tenax[®] films were 98 evaluated for their application in compliance testing of cardboard food contact 99 materials.

100

101 Materials and methods

102

103 Chemicals

Neat certified standards of acetophenone (AP, 99%) benzophenone (BP, purity 99.9%),
benzyl butyl phthalate (BBP, 98%), dibutyl phthalate (DBP, 99%), dibutyl sebacate
(DBS, 97%), 2,6-diisopropylnaphthalene (DiPN, CPR), 2,2-dimethoxy-2-phenyl
acetophenone (DMPA, 99%), trans,trans-1,4-diphenyl-1,3-butadiene (DPBD, 98%),
2,6-di-tert-butylphenol (DTBP, 99%), 2-ethylhexyl-4-dimethylaminobenzoate (EDB ,
98%), 4-methylbenzophenone (MBP, 99.9%), methyl stearate (MS, 99%), naphthalene

(NPT, 99%), 4-phenylbenzophenone (PBZ, 99.8%) were purchased from SigmaAldrich (Bornem, Belgium). 2-Isopropyl-9H-thioxanthen-9-one (ITX, 100%) was
supplied by Rahn (Zürich, Switzerland). Chemical structures are given in Figure 1.

113 Tenax[®] (60/80 Mesh) was also purchased from Sigma-Aldrich (Bornem, Belgium).

114 Acetonitrile, chloroform, dichloromethane and methanol were purchased from Biosolve

115 (Valkenswaard, Netherlands). All solvents were HPLC-grade.

116 All stock solutions were prepared in methanol at a concentration of 1 mg mL⁻¹ and 117 stored at -20°C for 6 months.

118 **Development of the Tenax**[®] film

Prior to its use, Tenax[®] was cleaned by soxhlet extraction with acetonitrile for at least 119 6h, followed by drying in an oven (BINDER, Bohemia, NY). Next, Tenax[®] was 120 121 dissolved in chloroform or dichloromethane in concentrations ranging from 0.00625 up to 0.05 g mL⁻¹. After filtration using a 0.45 um PVDF filter (GRACE) and a 1-0.45 um 122 glass fibre + PVDF prefilter (CHROMAFIL[®]), a fixed volume (2, 4 or 6 mL) was 123 124 brought into a glass recipient and the solvent was evaporated at room temperature in air. A petri dish with a diameter of 58 mm was chosen as a recipient. To construct visibly 125 126 flat and smooth films, any form of air circulation such as fumehoods was avoided.

127 Set-up migration experiment

Since a petri dish was chosen as a recipient, the Tenax[®] films could remain fixed on the glass to perform migration testing using a previously described set-up by Jakubowska et al. (Jakubowska et al. 2014). The Tenax[®] film was brought in contact with 0.15 dm² of spiked blank circular cardboard sample. The cardboard was spiked on the side of the cardboard intended for printing by homogeneously dotting 100 μ L of a solution with a concentration of 25 µg mL⁻¹ of the following contaminants: AP, BP, BBP, DBP, DBS, DiPN, DMPA, DPBD, DTBP, EDB, ITX, MBP, MS, NPT and PBZ. A smaller petri
dish with a diameter of 52 mm was used to cover the sample and the complete set was
wrapped in aluminium foil. Migration conditions were according to European
Regulation No 10/2011 (Regulation (EU) No 10/2011) for long-term storage of dry
foodstuffs at room temperature, resulting in a migration of 10 days at 60°C. Afterwards,
both film and cardboard were analysed and the concentration of the contaminants was
determined.

Additionally, a conventional migration experiment with 1 gram Tenax[®] powder was conducted by bringing spiked blank cardboard (100 μ L of a AP, BP, BBP, DBP, DBS, DiPN, DMPA, DPBD, DTBP, EDB, ITX, MBP, MS, NPT and PBZ solution with a concentration of 25 μ g mL⁻¹) in contact with Tenax[®]. Prior to its use, Tenax[®] was cleaned by soxhlet extraction. After the migration (10 days at 60°C) was completed, Tenax[®] and cardboard were analysed and the rate of migration was determined.

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148 Analysis of contaminants

149 Analysis of contaminants in the cardboard:

150 Cardboards were cut into pieces and extracted using 20 mL acetonitrile in 100 mL 151 flasks for 24h at 70°C (Sanches-Silva et al. 2008). Analyses were carried out using GC-152 MS. Quantification was done using a five point calibration curve ranging from 0.625 to 153 2.5 µg per cardboard circle, external calibration. The calibration curve was constructed 154 in the matrix. Hence, the cardboard was enriched with 100 µL of the contaminant solution (0, 6.25, 12.55, 18.75 and 25 μ g mL⁻¹). The enriched cardboards were also kept 155 156 in petri dishes for 10 days at 60°C to encounter the loss of substances due to 157 evaporation. Afterwards, cardboard samples were extracted prior to calibration.

159 Analysis of contaminants in Tenax[®] film:

Tenax[®] films were cut into pieces and extracted with 20 mL acetonitrile in 100 mL 160 161 flasks for 24h at 70°C. Analyses were carried out using GC-MS. Quantification was 162 done using a five point calibration curve ranging from 0.625 to 2.5 µg per film, external calibration. The calibration curve was constructed in the matrix. Hence, after bringing 4 163 mL of a 0.05 g Tenax[®] mL⁻¹ in the petri dish, the 'calibration-film' was spiked with 100 164 μ L of a contaminant solution (0, 6.25, 12.55, 18.75 and 25 μ g mL⁻¹) before evaporating 165 into a Tenax[®] calibration-film. The calibration-films were also placed in the oven for 10 166 167 days at 60°C prior to extraction for calibration purposes.

168

169 Analysis of contaminants in Tenax[®]

After the migration experiments, the simulant Tenax[®] was analysed and the 170 171 concentration of the model migrants was determined. A previously optimised method by Van Den Houwe et al. (Van Den Houwe et al. 2014) was used. Tenax[®] was extracted 172 173 twice with 20 mL of acetonitrile. Both extracts were combined and further diluted to 50 174 mL. For the quantification, a five point calibration curve in the matrix was constructed using 1.0 g Tenax[®] spiked at a concentration ranging from 0.625 μ g g⁻¹ up to 2.5 μ g g⁻¹. 175 176 Calibration samples were also kept in the migration oven for 10 days at 60°C before 177 being extracted.

178 GC-MS analysis

179 GC-MS analyses were carried out using a Agilent 7683 Automatic Liquid 180 sampler (Agilent Technologies, Palo Alto, USA). The GC-MS analyses were performed 181 on an Agilent 6890N gas chromatograph coupled to an Agilent 5973N single quad mass 182 selective detector. 2 μ L was injected into the GC-MS system in split injection mode 183 (split ratio 3,0:1). A VF-5ms column (Factor four, Agilent, California, VS) of 30 m (Ø 184 0.25 mm and film thickness of 0.30 μ m) was used. Helium was delivered as carrier gas 185 at a constant pressure of 14.65 psi with an initial flow of 1.3 mL min⁻¹.

The temperature gradient started at 80°C (held for 2 min) and rose with 20°C min⁻¹ to reach 290°C, which was held for 10 min. The total run time was 22.5 min. Temperatures of injection port, ion source, quadrupole and interface were set at 160, 230, 150 and 280°C, respectively. For quantification of compounds, the mass spectrometer was operated in selective ion monitoring (SIM) mode (100 ms dwell times). Table 1 presents the specific m/z ratios and the retention times.

192 Instrument control and data acquisition were performed by Agilent software193 (Enhance Chemstation 2004, Agilent).

194 **Results and discussion**

195 Selection of contaminants

196 The contaminants were selected based on a literature search on contaminants in paper 197 and board. It was found that photo-initiators and phthalates are one of the most common 198 groups of compounds present in paper and board food packaging (Aurela et al. 1999; 199 Jakubowska et al., 2014; Jung et al., 2013; Summerfield et al. 2001; Van Den Houwe et 200 al., 2014). Hence, two phthalates (BBP and DBP) and six photo-initiators (BP, DMPA, 201 EDB, ITX, MBP and PBZ) were selected. Futhermore, the following contaminants were 202 also frequently studied: AP, DBS, DiPN, DPBD, DTBP, MS and NPT (Aurela et al., 203 2001; Bradely et al., 2014 and 2015; Isella et al., 2013; Nérin et al., 2007b; Poças et al., 204 2011; Sanches Silva et al., 2006 and Triantafyllou et al., 2007).

205

206 Optimisation of the production of the Tenax[®] film

207 Among different organic solvents that were tested, Tenax[®] or poly(2,6-208 diphenylphenylene oxide), was best dissolved in chloroform or dichloromethane

(DCM). Since it was practically not feasible to dissolve Tenax[®] at higher concentrations 209 than 0.05 gram per millilitre chloroform, solutions ranging from 0.00625 g mL⁻¹ to 0.05 210 g mL⁻¹ were used to construct films of 25, 50, 100, 150 and 200 mg by evaporating 4 211 mL of a Tenax[®] solution in a petri dish (Figure 2). In parallel, Tenax[®] films of 100, 200 212 and 300 mg were constructed by evaporating different volumes (2, 4 and 6 mL) of a 213 0.05 g mL⁻¹ chloroform solution (Figure 3). Tenax[®] films lighter than 200 mg were too 214 215 thin and broke easily when removed from the petri dish. Hence, films containing 200 mg and 300 mg Tenax[®] were found suitable to proceed. 216

Next, the performance of 200 mg and 300 mg films (evaporation of 4 mL and 6 mL of a 217 0.05 g mL^{-1} solution) was compared for Tenax[®] films constructed from chloroform and 218 Tenax[®] films constructed from DCM. The results for ITX, BBP and NPT are given in 219 220 Figure 4. The results, an average of triplicate experiments, demonstrated that the choice 221 of dissolution solvent, nor the weight of the film had an important impact on the 222 migration performance, for all compounds investigated. Additionally, 200 mg films 223 were more homogenous compared to 300 mg films because less evaporation time was 224 needed. Hence, 200 mg films constructed by evaporation of 4 mL of a chloroform solution (0.05 g mL^{-1}) were chosen for further experiments. 225

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227 Impact of the amount of Tenax[®] in a conventional migration experiment

In the conventional migration experiment 1 gram Tenax[®] is brought into contact with 0.15 dm² of cardboard sample (Jakubowska et al., 2014). The optimised Tenax[®] film only contained 200 mg Tenax[®]. Hence, the conventional migration from the selected compounds in 1 gram Tenax[®] powder was compared to the migration in 0.2 gram Tenax[®] powder. The results for ITX, BBP and NPT are shown in Figure 5. Despite the fact that the cardboard surface is barely covered using 0.2 gram Tenax[®], the migration results of the selected contaminants towards 0.2 gram Tenax[®] are comparable with the migration results towards 1 gram Tenax[®] for all contaminants investigated. Hence, the performance of the optimised Tenax[®] films can be compared with the conventional migration experiment using 1 gram Tenax[®] powder.

- 238
- 239 Evaluation performance Tenax[®] film

Finally the performance of the Tenax[®] film was compared to the performance of the 240 conventional 1 gram Tenax[®] powder for two available blank cardboards (cardboard A 241 and B) destined for the packaging of dry foodstuffs. Hence, the spiked cardboards were 242 each brought into contact with a Tenax[®] film for 10 days at 60°C. In parallel, spiked 243 cardboard was brought into contact with 1 gram Tenax[®] powder for the same contact 244 245 time and temperature. The experiment was performed in triplicate, using calibration curves constructed in the matrix. The results for ITX, BBP and NPT are given in figure 246 247 6. Except for NPT, all compounds showed a comparable or even a higher migration towards the Tenax[®] powder for cardboard A. Since different cardboards have different 248 249 properties, different migration results were observed for both migration into the conventional 1 gram Tenax[®] powder and the 200 mg Tenax[®] film. Nevertheless, 250 251 cardboard A is rather rough and probably a more intense contact is established between the cardboard and the Tenax^{\mathbb{R}} powder compared to the contact with the Tenax^{\mathbb{R}} film. 252 253 For cardboard B; BP, DTBP, EDB, ITX and MBP have a higher migration potential for the Tenax[®] powder, while DiPN, MS, NPT and PBZ migrate more towards the designed 254 Tenax[®] film . Probably the effect of a more intense contact between the cardboard and 255 the powder is lost because cardboard B was found to be much smoother compared to 256 cardboard A. Hence, the migration in Tenax[®] powder compared to the migration in the 257

258 Tenax[®] film is influenced by the surface properties of the cardboard with a more
259 favourable migration in Tenax[®] powder for rough surfaces.

260 In 2016, Van Den Houwe et al. performed migration experiments for the 261 migration of several photo-initiators from cardboard in cereals after a contact of 6 months at room temperature (Van Den Houwe et al., 2016). About 5.4% BP migrated in 262 263 cereals after a six months contact between the cereals and the cardboard at room 264 temperature (Van Den Houwe et al., 2016). The percentage of migration of BP in the Tenax[®] films was 26.1% using a smooth cardboard and 14.1% using a more rough 265 cardboard to establish the migration contact for 10 days at 60°C. Although the 266 migration rate in the Tenax[®] film (14.1% and 26.1%) is less compared to the migration 267 in the powder form (38.8% and 36.9%), the Tenax[®] film migration rate might be better 268 269 estimate of the migration in dry foods. Indeed, the migration of photo-initiators in other 270 dry foodstuffs such as bread crumbs, pasta and rice was more realistically simulated by the use of the Tenax^{\mathbb{R}} film in comparison with the conventional migration (Table 2). 271 272 However, a higher migration potential of photo-initiators towards rice was indicated in a 273 rice matrix (Table 2). These results are of great consistency with the market survey 274 performed in 2014 where significant amounts of photo-initiators were only found in 275 several rice samples (Van Den Houwe et al., 2014).

Nevertheless, Tenax[®] films were fast and easily applied to the cardboard surfaces and ensure the entire collection of Tenax[®] adsorbent prior to extraction, making the developed Tenax[®] films wordy for further optimisation and investigation.

279

280 Conclusion

The use of Tenax[®] films as a food simulant for dry foodstuffs for the migration of 15 chemical contaminants from cardboard was evaluated. Initially, the construction of the Tenax[®] films was optimised. Films with less than 200 mg Tenax[®] showed severe drawbacks, but 200 mg Tenax[®] films constructed from a Tenax[®]-chloroform solution were found suitable. The optimised films were brought into contact with two types of cardboard enriched with 15 chemical contaminants relevant for paper and board food contact materials.

Higher migration rates were observed towards conventional Tenax[®] powder compared to the migration in the designed Tenax[®] films. This tendency was explained by a more intense contact between the cardboard and the conventional Tenax[®] powder. Nevertheless, the designed Tenax[®] film is fast and easy applicable and can open new perspectives in the domain of testing food contact materials intended for contact with dry foodstuffs, since preliminary experiments have demonstrated that the migration rate is more realistic when compared to the migration in dry foodstuffs.

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383	Overview of the figures
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386	Figure 2
387	Tenax [®] films constructed from different chloroform solutions with a weight of a) 25
388	mg, b) 50 mg, c) 100 mg, d) 150 mg and e) 200 mg.
389	Figure 3
390	Tenax [®] films constructed from a 0.05 g mL ⁻¹ chloroform soluton with a weight of a)
391	100 mg, b) 200 mg and c) 300 mg.
392	Figure 4
393	Comparison of the performance of 200 mg and 300 mg Tenax [®] films constructed from
394	DCM and chloroform, relative to the 200 mg film constructed from chloroform.
395	Figure 5
396	Comparison of the migration towards 1 gram and 0.2 gram Tenax [®] powder, relative to 1
397	gram Tenax [®] .
398	Figure 6

399	Comparison of the performance of Tenax [®] films and Tenax [®] powder for cardboard A,
400	resulting in a higher migration rate towards the Tenax [®] powder for ITX, a comparable
401	migration rate for BBP and a higher migration rate towards the Tenax [®] film for NPT.
402	
403	Overview of the tables
404	Table 1
405	Overview of the specific m/z ratios and retention times of the selected chemical
406	contaminants.
407	Table 2
408	Comparison of the conventional migration and the migration in $\text{Tenax}^{\mathbb{R}}$ films with the
409	actual migration in dry foodstuffs for several photo-initiators (average of 3 replicates).
410	
411	Overview of supplementary data
412	Figure 1
413	Comparison of the performance of 200 mg and 300 mg Tenax [®] films constructed from
414	DCM and chloroform, relative to the 200 mg film constructed from chloroform.
415	Figure 2
416	Comparison of the migration towards 1 gram and 0.2 gram Tenax [®] powder, relative to 1
417	gram Tenax [®] .
418	Figure 3
419	Comparison of the performance of Tenax [®] films and Tenax [®] powder for cardboard A,
420	resulting in a) a higher migration rate towards the Tenax [®] powder, b) a comparable
421	migration rate and c) a higher migration rate towards the Tenax ^{\mathbb{R}} film.
422	Figure 4

423 Comparison of the performance of Tenax[®] films and Tenax[®] powder for cardboard B
424 resulting in a) a higher migration rate towards the Tenax[®] powder, b) a comparable
425 migration rate and c) a higher migration rate towards the Tenax[®] film.

Table 1

N°	Chemical contaminant	Abbreviation	Specific m/z ratio	Retention time (min)
1.	Acetophenone	AP	105	4.76
2.	Naphthalene	NPT	128	5.97
3.	2,6-Di-tert-butylphenol	DTBP	191	8.44
4.	Benzophenone	BP	105	9.36
5.	2,6-Diisopropylnaphthalene	DiPN	197	9.95
6.	4-methylbenzophenone	MBP	119	10.16
7.	2,2-Dimethoxy-2-phenyl acetophenone	DMPA	151	10.87
8.	Dibutyl phthalate	DBP	149	11.21
9.	Trans,trans-1,4-diphenyl-1,3-butadiene	DBPD	206	11.78
10.	Methyl stearate	MS	74	11.96
11.	Dibutyl sebacate	DBS	241	12.22
12.	2-Ethylhexyl-4-dimethylaminobenzoate	EDB	165	12.80
13.	Benzyl butyl phthalate	BBP	149	13.22
14.	2-Isopropyl-9H-thioxanthen-9-one	ITX	239	13.55
15.	4-Phenylbenzophenone	PBZ	181	13.94

Table 2

	Conventional migration in	Migration in Tenax [®] film	Migration in dry foodstuffs (%) (6 months at room temperature)			
	Tenax [®] powder (%) (10 days at 60°C)	(%) (10 days at 60°C)	Cereals	Bread crumbs	Pasta	Rice
BP	50.5	26.1	5.4	5.11	5.98	17.58
EDB	69.4	23.4	8.9	11.08	17.81	36.77
ITX	54.7	21.7	7.4	8.14	14.57	30.78
MBP	50.2	17.1	5.4	14.01	16.98	42.87









DMPA



DPBD

0 II







MBP

MS







ITX

NPT

441

442 Fig1

443

- 444





- 454 Fig 3

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