

Food Research International

Raw milk preservation by hyperbaric storage: effect on microbial counts, protein structure and technological functionality

--Manuscript Draft--

Manuscript Number:	
Article Type:	Research Paper
Keywords:	Hyperbaric storage; raw milk; microbial inactivation; non-thermal pasteurization; protein interaction; foaming properties
Corresponding Author:	Lara Manzocco, Ph.D. Dipartimento di Scienze AgroAlimentari, Ambientali e Animali Udine, ITALY
First Author:	Federico Basso
Order of Authors:	Federico Basso Michela Maifreni Nadia Innocente Lara Manzocco Maria Cristina Nicoli
Abstract:	<p>The possibility to apply hyperbaric storage (HS) at room temperature (20 °C) as a sustainable approach for preservation of raw skim milk was studied. Samples were stored at 200 and 150 MPa for up to 6 days. Optimal pressure for milk HS was found to be 150 MPa, since no clotting was detected for up to 6 days. 150 MPa-HS caused the irreversible inactivation of inoculated <i>Escherichia coli</i> ($5.13 \pm 0.33 \log\text{CFU mL}^{-1}$) and <i>Staphylococcus aureus</i> ($5.66 \pm 0.93 \log\text{CFU mL}^{-1}$) within 2 and 6 days, respectively. Inactivation of total and faecal coliforms (3.0 log reductions) below the detection limit was achieved after just 2 days, whereas lactic acid bacteria and coagulase-positive <i>Staphylococci</i> were inactivated after 6 days. Pressurized storage also caused an increase in proteose peptones and the release of submicelles from casein micelles. Micelles progressively aggregated with pressure-unfolded β-Lactoglobulin. These phenomena led to milk presenting up to 4-fold better foaming capacity, probably due to β-Lactoglobulin unfolding or higher proteose peptones content.</p> <p>This work demonstrated the capability of HS to guarantee milk preservation during storage, and brought attention on the opportunity to consider the technology for milk pasteurization and functionality improvement.</p>
Suggested Reviewers:	<p>Amalia Conte University of Foggia Department of Agricultural Food and Environmental Sciences: Università degli Studi di Foggia Dipartimento di Scienze Agrarie degli Alimenti e dell'Ambiente amalia.conte@unifg.it Expert of Non-thermal technologies</p> <p>Francesca Bot University of Parma Department of Food and Pharmaceutical Sciences: Università degli Studi di Parma Dipartimento di Scienze degli Alimenti e del Farmaco francesca.bot@unipr.it Expert of milk protein structure and functionality</p> <p>Tara Grawuet KU Leuven: Katholieke Universiteit Leuven, Laboratory of Food Technology, Leuven Food Science and Nutrition Research Center (LFoRCe), Department of Microbial and Molecular Systems (M2S) tara.grauwet@kuleuven.be Expert of high hydrostatic pressure</p> <p>Siroli Lorenzo University of Bologna Department of Agri-Food Sciences and Technologies: Università</p>

degli Studi di Bologna Dipartimento di Scienze e Tecnologie Agro-Alimentari
lorenzo.siroli2@unibo.it
Expert of pressure effects on microbiological stability

Dear Editor,

We send to your attention the research article "**Raw milk preservation by hyperbaric storage: effect on microbial counts, protein structure and functionality**" by Federico Basso, Michela Maifreni, Nadia Innocente, Lara Manzocco and Maria Cristina Nicoli. All the authors have read and approved the manuscript.

Hyperbaric storage was investigated as a sustainable emerging technology for non-thermal preservation of milk. To the best of our knowledge, the efficacy of the technology in inactivating native microbial counts and inoculated pathogens has never been evaluated before. Only one paper has been published so far, reporting the effects of the technology on the profile of microbial metabolites in milk. In addition, no information is available on the effect of hyperbaric storage on protein structure and functionality.

In this paper, the application of hyperbaric storage was investigated to assess the effects of the technology on raw skim milk microbiological quality (*i.e.*, counts of naturally present total bacteria, lactic acid bacteria, coagulase-positive *Staphylococci*, faecal coliforms and total coliforms), safety (*i.e.* counts of inoculated *Staphylococcus aureus* and *Escherichia coli*), protein stability (*i.e.*, casein micelles size and whey protein content), colour, appearance and technological functionality (*i.e.* foaming properties). Results demonstrate the potentiality of hyperbaric storage for milk non-thermal pasteurization, defined as the achievement of at least 5 log reductions of the inoculated pathogens. Data also show the capability of the technology to improve milk protein functionality, as indicated by a remarkable enhancement in milk foaming without affecting colour and appearance.

We feel confident that the paper could provide a significant contribution to the understanding of the effects of one of the fastest growing technologies in the field of non-thermal food processing. We hope this article could satisfy the requirements of Food Research International, so that you might consider it for publication in this Journal.

Best regards,

Prof. Lara Manzocco, PhD

Section of Food Chemistry and Technology

Department of Agricultural, Food, Environmental and Animal Sciences

University of Udine

Via Sondrio 2/A

33100 Udine, Italy

lara.manzocco@uniud.it

- 1 HS (150 MPa; 6 days) reduces by 5 log units *E. coli* and *S. aureus* in raw skim milk
- 2 HS-induced microbial inactivation is irreversible (for up to 12 days at 4 °C)
- 3 Casein micelles serve as local aggregation points for HS-unfolded β -Lactoglobulin
- 4 HS activates milk proteases leading to an increase in proteose-peptones
- 5 Foaming capacity of HS-treated milk increases up to 4 times

Raw milk preservation by hyperbaric storage: effect on microbial counts, protein structure and technological functionality

Federico Basso, Michela Maifreni, Nadia Innocente, Lara Manzocco*, Maria Cristina Nicoli

Department of Agricultural, Food, Environmental and Animal Sciences, University of Udine, Via Sondrio 2/A, 33100 Udine, Italy

*Corresponding Author: Tel: +39 0432-558152

authors e-mails:

lara.manzocco@uniud.it

basso.federico.1@spes.uniud.it

nadia.innocente@uniud.it

michela.maifreni@uniud.it

mariacristina.nicoli@uniud.it

ABSTRACT

The possibility to apply hyperbaric storage (HS) at room temperature (20 °C) as a sustainable approach for preservation of raw skim milk was studied. Samples were stored at 200 and 150 MPa for up to 6 days. Optimal pressure for milk HS was found to be 150 MPa, since no clotting was detected for up to 6 days. 150 MPa-HS caused the irreversible inactivation of inoculated *Escherichia coli* (5.13 ± 0.33 logCFU mL⁻¹) and *Staphylococcus aureus* (5.66 ± 0.93 logCFU mL⁻¹) within 2 and 6 days, respectively. Inactivation of total and faecal coliforms (3.0 log reductions) below the detection limit was achieved after just 2 days, whereas lactic acid bacteria and coagulase-positive *Staphylococci* were inactivated after 6 days. Pressurized storage also caused an increase in proteose peptones and the release of submicelles from casein micelles. Micelles progressively aggregated with pressure-unfolded β -Lactoglobulin. These phenomena led to milk presenting up to 4-fold better foaming capacity, probably due to β -Lactoglobulin unfolding or higher proteose peptones content.

This work demonstrated the capability of HS to guarantee milk preservation during storage, and brought attention on the opportunity to consider the technology for milk pasteurization and functionality improvement.

Keywords: Hyperbaric storage, raw milk, microbial inactivation, non-thermal pasteurization, protein interaction, foaming properties.

1 Introduction

Hyperbaric storage (HS) is an innovative food technology based on hydrostatic pressurization of food inside steel vessels (Fernandes et al., 2014; Santos et al., 2020). Despite conceptually similar to high pressure processing (HPP), which is performed at 400 – 800 MPa for up to 30 min (Aganovic et al., 2020), HS is carried out at moderate pressure ($P < 250$ MPa) for days, weeks or even months. While HPP is used to achieve cold pasteurization or to assist sterilization, HS performed at room temperature has attracted substantial interest as an alternative to refrigeration for perishable food. The application of the technology is highly sustainable since the maintenance of pressurized conditions can be guaranteed by the sealing of the pressurized vessels solely, accounting for an extremely low energetic cost (Bermejo-Prada et al., 2017). HS has thus been

Abbreviations: HS, Hyperbaric storage; HPP, High pressure processing; UHT, Ultra-high-temperature sterilized milk; BHI, Brain heart infusion broth; MRD, Maximum recovery diluent; PCA, Plate count agar; SC+, Coagulase-positive *Staphylococci*; BP, Baird Parker agar; MRS, Man Rogosa Sharp agar; DLS, Dynamic light scattering; RP-HPLC, Reverse-phase high performance liquid chromatography; FC, faecal coliforms; TC, total coliforms.

1
2
3
4 proposed as a sustainable alternative to refrigeration for perishable foods, including meat, fish,
5 cheese, fruit juices, seafood and egg white (Basso, et al., 2021; Duarte et al., 2015; Fidalgo et al.,
6 2018; Freitas et al., 2016; Otero et al., 2019; Otero & Pérez-Mateos, 2021; Santos et al., 2019). In
7 these matrices, HS has been demonstrated to prevent microbial growth and to induce significant
8 inactivation of hygiene indices (*e.g.* total bacteria count, yeasts and molds, lactic acid bacteria)
9 and inoculated pathogens, with minimal effects on sensory properties. In particular, application of
10 100 MPa to watermelon juice reduced the count of total aerobic mesophiles and inoculated
11 *Escherichia coli* and *Listeria innocua* by about 3 log cycles (Pinto et al., 2017). Results of peculiar
12 interest were obtained in the case of fruit juices inoculated with heat- and pressure-resistant
13 sporogenic microorganisms (*i.e.*, *Alicyclobacillus acidoterrestris* and *Bacillus subtilis*) (Pinto et
14 al., 2018, 2019). In this case, HS at 50-100 MPa at room temperature allowed to achieve about 5
15 log reductions of total endospore count.

16
17
18
19 It could be inferred that HS can be used to decontaminate foods while storing them. Such
20 possibility could be of utmost value in the case of fresh milk, which is conventionally obtained by
21 pasteurization of raw milk (*i.e.*, thermal preservation), and subsequent storage under refrigerated
22 conditions (4 °C) (Vasavada, 1988). As well known, despite guaranteeing microbiological safety,
23 this approach is associated not only to milk thermal damage upon pasteurization (Syed et al., 2021),
24 but also to high environmental impacts of heat treatment and cold storage (James & James, 2010;
25 Swain et al., 2005; Syed et al., 2021).

26
27
28
29 Milk pressurization has been proven to be particularly challenging, due to the high sensitivity of
30 milk proteins to hyperbaric conditions (Huppertz, Fox, et al., 2006). In particular, casein micelles
31 disintegration has been often observed under pressure due to solubilization of colloidal calcium
32 phosphate, resulting in milk clotting (Anema et al., 2005; Huppertz et al., 2002; Huppertz, Kelly,
33 et al., 2006; Kielczewska et al., 2020; Needs, Capellas, et al., 2000). Nevertheless, this effect was
34 not detected when pressure was applied in the HS range (Huppertz et al., 2004). Although
35 circumstantial, this evidence suggests that HS might be applied to milk without inducing clotting
36 phenomena. Nevertheless, the effects of prolonged pressurizations (*e.g.*, days/weeks) on raw milk
37 and, in particular, on casein micelles structure, are unknown.

38
39
40
41
42
43
44
45
46
47
48
49
50
51
52
53
54
55
56
57
58
59
60
61
62
63
64
65
Based on these considerations, the aim of the present study was to investigate the possibility of HS
to be applied as sustainable milk preservation treatment, and to evaluate the potentiality of the
technology as a non-thermal pasteurization approach. To this aim, the effects of HS on milk
physical stability, colour, microbiological quality and safety, and functional properties were
evaluated in raw skim milk. The research was organized in different consequential steps: milk was
initially stored at different pressures (150, 200 MPa) and analyzed for absence of clotting (dynamic
light scattering) and colour changes (tristimulus colorimetry). Following, the attention was focused
on the HS treatment performed at pressure showing no clotting for up to 6 days, taken as average
shelf life of fresh pasteurized milk under refrigerated conditions (Palmeri et al., 2019). The
capacity of HS to achieve milk preservation was evaluated based on its capability to control the
naturally occurring milk microflora (*i.e.*, total bacteria, lactic acid bacteria, coagulase-positive
Staphylococci, faecal coliforms and total coliforms) and to reduce the microbial load of inoculated
E. coli and *S. aureus*. Finally, milk attitude to be processed into stable foams was assessed, and
foaming performance was related to protein profile changes.

2 Materials and Methods

2.1 Samples preparation

1
2
3
4 Ultra-high-temperature sterilized (UHT) and raw skim milk were obtained at a local food retailer
5 and a local milk processing plant, respectively. Approximately 100 mL aliquots of milk were
6 poured in polyethylene/ethylene vinyl alcohol/polypropylene pouches (15 × 30 cm; 80 μm
7 thickness, water vapor permeability < 1 g · m⁻² · 24 h⁻¹; Niederwieser Group S.p.A.,
8 Campogalliano, Italy), which were heat-sealed with headspace not exceeding 5% of samples
9 volume (Orved, VM-16, Musile di Piave, Italy).

10
11 Milk samples for microbiological analyses were prepared separately. For the inoculum, bacteria
12 suspensions containing *Escherichia coli* 8048 and *Staphylococcus aureus* 226 were prepared from
13 the bacterial culture collection of the Department of Agricultural, Food, Animal and
14 Environmental Sciences of the University of Udine (Italy). Strains were maintained at -80 °C in
15 Brain Heart Infusion broth (BHI, Oxoid, Milan, Italy) with 30% sterile glycerol as cryoprotectant
16 until use. From stock cultures, the strains were plated on BHI culture media, and incubated at 37
17 °C for 24 h. The inoculations were carried out by suspending plated pure cultures of each
18 microorganism in 5 mL of BHI at 37 °C for 24 h. Subsequently, the cells were collected by
19 centrifugation at 14,170 × g for 10 min at 4 °C (Beckman, Avanti TM J-25, Palo Alto, CA, USA)
20 and washed three times with Maximum Recovery Diluent (MRD, Oxoid, Milan, Italy). The final
21 pellet was suspended in MRD. An aliquot of the bacteria suspension was added to approximately
22 50 mL UHT milk or raw milk to obtain a final concentration of 10⁵ - 10⁶ CFU mL⁻¹.

27 **2.2 Hyperbaric storage**

28 A HS working unit assembled by Comer Srl (Bologna, Italy) was used. It consisted of a water-
29 tight steel vessel (Hystat, Slaithwaite, Huddersfield, UK) pressurized by a Haskel International
30 high pressure pump (Burbank, CA, USA). The pressure-mediating fluid was an aqueous solution
31 containing 0.2% (w/w) potassium sorbate and 0.2% (w/w) sodium benzoate (Carlo Erba Reagents
32 Srl, Milan, Italy) to prevent mold growth in the fluid reservoir. Packaged samples were introduced
33 in the vessel and pressurized at 200 and 150 MPa at room temperature (20 ± 2 °C). Control samples
34 were stored under refrigerated conditions (4 °C, 0.1 MPa). At increasing time during storage for
35 up to 6 days, samples were removed from the HS vessel or from the refrigerator, and analyzed.

39 **2.3 Image acquisition**

40 Images were acquired using an image acquisition cabinet (Immagini & Computer, Bareggio, Italy)
41 equipped with a digital camera (EOS 550D, Canon, Milano, Italy). The digital camera was placed
42 on an adjustable stand positioned at 45 cm from a cardboard base covered with white paper where
43 15 mL glass vials containing the milk samples were placed. Lighting was provided by 4100W
44 frosted photographic floodlights, positioned to minimize shadow and glare

48 **2.4 Colour**

49 A tristimulus colorimeter (Chromameter-2 Reflectance, Minolta, Osaka, Japan) equipped with a
50 CR-300 measuring head was used to determine milk colour. The instrument was standardized
51 against a white tile before analysis. Samples were poured into Petri dishes, positioned on top of
52 the standardization tile and analyzed. Colour was expressed in L*, a* and b* scale parameters.

56 **2.5 Microbiological analyses**

57 Decimal dilutions of milk samples were prepared in MRD (Oxoid, Milan, Italy) and plated in
58 specific culture media according to the microorganisms analyzed. Total bacterial count was
59 enumerated on Plate Count Agar (PCA, Oxoid, Milan, Italy) and the plates were incubated at 30
60
61
62
63
64
65

1
2
3
4 ± 1 °C for 48-72 h; *S. aureus* and coagulase-positive *Staphylococci* (SC+) were plated and counted
5 on Baird Parker agar (BP, Oxoid, Milan, Italy) after incubation at 37 ± 1 °C for 24-36h; *E. coli*,
6 and fecal and total coliforms were determined on ColiID (bioMerieux, Grassina, Italia) and the
7 plates were incubated at 37 ± 1 °C for 24h; lactic acid bacteria (LAB) were enumerated on Man
8 Rogosa Sharp agar (MRS, Oxoid, Milan, Italy) after incubation at 30 ± 1 °C for 48h. The results
9 were expressed as the decimal logarithm of colony forming units per milliliter of milk (logCFU
10 mL^{-1}); the detection of limit (L.o.D.) was 0 logCFU mL^{-1} for *E. coli* and coliforms, and 1 logCFU
11 mL^{-1} and *S. aureus*, coagulase-positive *Staphylococci*, TBC, LAB, respectively.
12
13
14

15 **2.6 Casein micelles size**

16 Casein micelles size was determined by dynamic light scattering (DLS) analysis adapting the
17 method from Segat et al. (2015). Milk samples were diluted 1:100 (v/v) with MilliQ water and
18 inserted into 1 cm optical pathway cuvettes. Particle size was determined at 20 °C by using a
19 dynamic light scattering system (NanoSizer 3000, Malvern Instruments, Malvern, UK) equipped
20 with a Peltier temperature control system. The refractive index was set at 1.333 and the viscosity
21 was approximated to that of pure water at 20 °C. The occurrence of milk clotting was identified in
22 correspondence of the formation of aggregates with size higher than 5 μm .
23
24
25

26 **2.7 Whey protein profile**

27 Whey was obtained from milk samples by isoelectric precipitation (pH 4.6) of casein by addition
28 of HCl 1 M. Whey samples were frozen and kept at -18 °C until analysis. Thawed samples were
29 diluted 1:5 (v/v) with MilliQ water and subjected to reverse-phase high performance liquid
30 chromatography (RP-HPLC) as previously described by De Noni et al. (2007). The RP-HPLC
31 apparatus was a 230 Pro Star (Varian Inc, Palo Alto, CA, USA), equipped with a 7725i injector
32 (Rheodyne, Cotati, CA, USA) and a PLRP-S column (4.6 mm i.d. \times 150 mm, 5 mm, 300 Å from
33 Polymer Laboratories, Shropshire, UK) kept at 40 °C. The detector was a Varian 330 Pro Star UV-
34 Vis spectrophotometer set at 205 nm. Samples were eluted by applying a gradient of solvents: A
35 (0.1% (v/v) trifluoroacetic acid in MilliQ water); B (0.1% (v/v) trifluoroacetic acid in acetonitrile;
36 Sigma Aldrich, Milan, Italy). Eluting solvents were filtered through 0.45 μm cutoff HV
37 DURAPORE® membrane filters (Merck Millipore Ltd., Tullagreen, Carrigtwohill, Cork, Ireland).
38 The elution gradient, as solvent B proportion (v/v), was as follows: 0-8 min, 25-35%; 8-10 min,
39 35-36%; 10-17 min, 36-38%; 17-23 min, 38-45%; 23-23.5 min, 45-100%; 23.5-25 min, 100-25%.
40 The flow rate was 1.0 mL min^{-1} . Peak assignment was performed according to Innocente et al.
41 (2011). β -Lactoglobulin (β -Lg) was quantified by using a calibration curve obtained from standard
42 solutions (Sigma Aldrich, Milan, Italy) in the 0-2 g L^{-1} concentration range ($R^2_{\text{adj}} = 0.9843$).
43
44
45
46
47

48 **2.8 Foaming properties**

49 Two different foaming methods, based on mechanical agitation or on steam injection, were used.
50 For the mechanical-based method, the procedures applied by Kamath et al. (2008) and Ho et al.
51 (2019) were adapted. In particular, 25 mL milk aliquots were poured into 100 mL beaker,
52 equilibrated at 20 °C for 1 h, heated to 50 ± 3 °C in a microwave oven (Panasonic Ne-1643, 1600
53 W, applied for 8 s) and foamed using a commercially available mechanical milk frother for 15 s.
54 For the steam-based method, 90 mL of milk was poured into 250 mL beakers and the foam was
55 generated using a steam injection system purposely built to simulate catering steam frothers.
56 Steam was injected in the samples for 5 s, so that milk reached a temperature of 70 ± 5 °C. For
57 both methods, the height of the milk surface (h_i) from the bottom of the beaker was measured with
58
59
60
61
62
63
64
65

1
2
3
4 a Metrica monobloc precision venier caliper (Metrica S.p.A., San Donato M.se, MI, Italy). Foam
5 height was measured after (h_0) and 15 min (h_{15}) and the foaming capacity and foam stability were
6 expressed as follows:
7

8
9
$$\text{Foaming capacity (\%)} = h_0/h_i \cdot 100 \quad (\text{Eq.1})$$

10
$$\text{Foam stability (\%)} = h_{15}/h_0 \cdot 100 \quad (\text{Eq.2})$$

11
12

13 **2.9 Data analysis**

14 Microbiological analyses were performed in single on samples from two independent experiments
15 and are reported as mean \pm standard deviation. Data of particle size, colour and foaming properties
16 were obtained by at least triplicate measurements. These data are reported as mean \pm standard
17 deviation and were subjected to one-way analysis of variance (ANOVA) and Tukey's Honest
18 Significant Differences test ($p < 0.05$) using R v. 3.6.1 for Windows (The R foundation for
19 statistical computing). RP-HPLC data were obtained in duplicate and reported as mean \pm standard
20 deviation.
21
22

23 **3 Results and discussion**

24 **3.1 Identification of pressure conditions for milk hyperbaric storage**

25 Preliminary trials were performed to identify the maximum pressure level that could be applied to
26 milk without leading to significant changes in its physical stability within the typical shelf life of
27 refrigerated pasteurized milk (*i.e.* up to 6 days) (Palmeri et al., 2019). To this aim, samples were
28 stored at 150 and 200 MPa until milk clotting was detected by DLS in correspondence of large
29 aggregates (Table 1).
30

31 Milk showed the presence of a monodispersed (Polydispersity index = 0.09 ± 0.04) particle family
32 with 169 nm size, representing casein micelles (De Kruif, 1999). Under HS at 200 MPa, two
33 distinct phenomena were observed (Table 1): a progressive increase in casein micelles size and the
34 appearance of a novel family of smaller particles (about 50 nm). The latter became evident after
35 30 min-HS, and can be associated to sub-micellar particles, which occurred as a consequence of
36 pressure-induced micelle fragmentation and reassociation (Gebhardt et al., 2006). After 1.5 h of
37 HS, casein micelles aggregated to form large particles exceeding 5 μm in size, indicating the onset
38 of clotting. When HS was performed at 150 MPa, the increase in casein micelle size and their
39 fragmentation occurred at a much slower rate. In particular, sub-micellar particles became
40 detectable only after 2 days (Table 1). As casein better tolerated less intensive HS, milk clotting
41 was detected only after 6 days. It is worth noting that, when milk clotted, casein micelles were
42 significantly larger (370 nm) if milk was stored at 150 MPa rather than at 200 MPa (250 nm). This
43 indicates that milk clotting was not the result of micelle enlargement solely. In fact, many Authors
44 reported that pressure-induced clotting primarily occurs due to aggregation of sub-micellar
45 particles, whereas an increased micelle size is mainly attributable to interactions between micelles
46 and pressure-unfolded whey proteins (Anema et al., 2005; Huppertz et al., 2004; Huppertz & De
47 Kruif, 2007; Needs, Capellas et al., 2000; Needs, Stenning, et al., 2000). Independently on storage
48 conditions, no changes in luminosity were observed in all samples (data not shown), indicating
49 that casein micelle modifications (Table 1) did not affect the optical properties of milk colloidal
50 system. The effects of pressurized storage on milk appearance were also evaluated by assessing
51 color parameters a^* (redness) and b^* (yellowness) (Figure 1).
52
53
54
55
56
57
58
59
60
61
62
63
64
65

1
2
3
4 While no significant changes in redness and yellowness were detected in refrigerated milk, a slight
5 but progressive increase in these parameters was detected upon milk HS (Figure 1). Although not
6 visually perceivable to the naked eye, this minor colour change could be attributed to pressure-
7 triggered non-enzymatic browning. Reportedly, the early condensation steps of the Maillard
8 reaction can be favoured by pressure since, in some cases, they can be characterized by a negative
9 activation volume (Hill et al., 1996; Isaacs & Coulson, 1996).

10
11 Based on these results, milk physical stability could be guaranteed for up to 6 days by storing it at
12 pressure as high as 150 MPa. The latter was thus deemed as the optimal pressure level for milk
13 HS, and further experiments were conducted by applying these conditions.
14
15

16 **3.2 Effect of hyperbaric storage on milk hygiene and microbiological safety**

17 Since milk is not an inherently sterile matrix, microbiological analyses were firstly performed to
18 assess the effect of HS on the naturally occurring microflora. To this aim, total bacteria count
19 (TBC), lactic acid bacteria (LAB), coagulase-positive *Staphylococci* (SC+), fecal coliforms (FC)
20 and total coliforms (TC) microbiological quality indexes were considered. The latter were
21 followed during pressurized storage for up to 6 days, using refrigerated milk as reference (Table
22 2).
23
24

25 In fresh raw milk, the value of all the considered indexes was relatively high, ranging from about
26 2 to circa 4 logCFU mL⁻¹. The detection of FC and SC+ indicated the potential occurrence of
27 dangerous microorganisms, such as *E. coli* and *S. aureus*. During refrigerated storage for up to 6
28 days, all the microbial indexes progressively increased with the only exception of SC+, which
29 remained relatively stable. In particular, TBC and FC grew by more than 2 logCFU mL⁻¹ after 6
30 days, whereas LAB and TC increased by less than 1 log unit. These results are in agreement with
31 the well-known weak bacteriostatic capacity of refrigeration in raw milk (Griffiths et al., 1987),
32 potentially allowing the development of pathogens. On the contrary, HS at 150 MPa caused the
33 reduction of all microorganisms below the detection limit. In particular, FC and TC were
34 inactivated within 1 and 2 days, respectively. Differently, the gram-positive species comprising
35 SC+ and LAB better withstood pressurized conditions and, similarly to TBC, were reduced below
36 the detection limit only after 6 days-HS.
37
38

39 Based on these results, the efficacy of HS as a potential approach for milk pasteurization was
40 evaluated. To this aim, counts of milk spiked with *E. coli* and *S. aureus* (5-6 logCFU mL⁻¹)
41 pressurized at 150 MPa for up to 6 days were compared to those of analogous samples submitted
42 to refrigeration. Possible interferences provided by the presence of native milk bacteria (Table 2)
43 were made negligible by firstly performing the challenge test using UHT skim milk. The results
44 are shown in Table 3.
45
46

47 The application of refrigerated conditions did not affect the load of the inoculated microorganisms,
48 which remained unchanged during the 6 days-storage. Oppositely, HS progressively reduced both
49 *E. coli* and *S. aureus* loads below the detection limit. The complete inactivation of *S. aureus*
50 required the application of 150 MPa for 6 days, whereas *E. coli* was undetectable in milk samples
51 after just 2 days. It is likely that the remarkably higher resistance of gram-positive bacteria to
52 pressure, which is due to their thick peptidoglycan cell wall layer, allowed *S. aureus* to better
53 withstand HS conditions as compared to *E. coli* (Wuytack et al., 2002). Similar results were
54 previously observed during HS of egg white inoculated with *Salmonella enterica* and *S. aureus* as
55 well as of watermelon juice spiked with *E. coli* and *L. innocua* (Basso, et al., 2021; Pinto et al.,
56 2017).
57
58
59
60
61
62
63
64
65

1
2
3
4 With the aim of validating the encouraging results obtained with UHT milk, the challenge test was
5 repeated on raw skim milk. In this case, the presence of native milk microorganisms was evaluated
6 by performing TBC counts concomitantly to *E. coli* and *S. aureus* ones. The results are reported
7 in Table 4.
8

9 Similar to what observed for UHT skim milk, the application of refrigeration did not induce any
10 variation in the counts of inoculated *E. coli* and *S. aureus* while increased TBC by roughly 1 log
11 unit. On the other hand, milk TBC counts decreased during HS, showing a reduction that ranged
12 from about 3 to 5 logCFU mL⁻¹. Moreover, pressurized storage promoted 5 log units-inactivation
13 of both *E. coli* and *S. aureus*, with high similarity with the inactivation efficacy observed in UHT
14 milk (Table 3). It is noteworthy that a 5-log reduction has been suggested as a reasonable criterion
15 by different Authors to assess the potential of non-thermal technologies for milk pasteurization
16 (Alberini et al., 2015; Matak et al., 2005; Mussa & Ramaswamy, 1997; Ruiz-Espinosa et al., 2013;
17 Stratakos et al., 2019). Data shown in Tables 3 and 4 clearly evidence that such a criterion can be
18 reached by storing milk at 150 MPa for 6 days. This result suggests the potentiality of HS for non-
19 thermal pasteurization of milk.
20

21 To evaluate the capability of HS to extend the shelf life of milk after depressurization, inoculated
22 and pressurized raw skim milk was further stored under refrigerated conditions for 12 days. During
23 this period, *E. coli* and *S. aureus* remained undetectable, and TBC values did not change (data not
24 shown). This result demonstrates the irreversibility of HS-induced microbial inactivation and
25 highlights the capability of the technology of extending milk microbiological stability for several
26 days after decompression.
27
28
29
30

31 **3.3 Effect of hyperbaric storage on whey proteins**

32 To better investigate the effect of hyperbaric storage on milk proteins, the attention was focused
33 on the role of whey proteins in micelle enlargement (Table 1). Whey was thus recovered from
34 differently stored milk and subjected to RP-HPLC. In accordance with De Noni et al. (2007),
35 chromatograms indicated the presence of the full whey protein spectrum in fresh milk (Figure 2).
36 In particular, α -lactalbumin (α -La), bovine serum albumin (BSA) and β -lactoglobulin (β -Lg) were
37 eluted at about 20, 22 and 25 min, respectively. Moreover, the presence of proteose-peptones was
38 clearly indicated by the occurrence of a broad, irregular peak at 13 min (Innocente et al., 2011).
39 During refrigerated storage, milk whey proteins content did not change (chromatograms not
40 shown), indicating optimal maintenance of their structure. Contrarily, a significant loss of β -Lg
41 was observed in the samples stored at 150 MPa (Figure 2). Quantitative analysis showed that β -
42 Lg concentration decreased from 2.38 ± 0.28 (fresh sample) to 0.44 ± 0.10 and 0.11 ± 0.08 g L⁻¹
43 after 1 and 6 days of hyperbaric storage, respectively. These results are probably due to extensive
44 pressure-induced unfolding of β -Lg, which is highly pressure-sensitive (Huppertz et al., 2004;
45 Huppertz, Fox, et al., 2006) and prone to interact with κ -casein molecules in relatively stable
46 complexes (Cho & Singh, 2003). It can be thus inferred that milk whey was deprived of β -Lg since
47 it separated along with casein. In other words, casein micelles would locally support aggregation
48 of pressure-unfolded β -Lg molecules, which would have accumulated onto their surfaces, thus
49 leading to the observed increase in milk casein size (Table 1) (Patel & Huppertz, 2014; Scollard
50 et al., 2000). This hypothesis was further confirmed by statistical analysis, which revealed strong
51 negative correlation ($r = - 0.838$) between β -Lg concentration and casein micelles size. HS also
52 induced a progressive increase in proteose-peptones content (Figure 2), suggesting that casein
53 hydrolysis by native milk proteases (*e.g.*, plasmin) was favoured by HS (Garcia et al., 2017).
54
55
56
57
58
59
60
61
62
63
64
65

1
2
3
4 According to García-Risco et al. (2003), this phenomenon resulted from pressure-induced
5 modification of casein structure, which made them prone to proteolytic enzymes.
6

7 8 **3.4 Effect of hyperbaric storage on milk foaming properties**

9 The observed effects of HS on milk proteins indicate the possibility to employ pressurized storage
10 to improve the technological performance of milk. For instance, due to their exceptional surface
11 activity, unfolded β -Lg and proteose-peptones formed by HS could be of peculiar interest for milk
12 foaming.
13

14 To assess whether protein structural changes induced by hyperbaric storage could steer the attitude
15 of milk to be further processed into foams, differently stored milk samples were analyzed for
16 foaming properties by using two alternative methods (Table 5). The first one was based on
17 mechanical agitation and moderate heating. According to the literature, besides being
18 representative of milk foaming processes carried out at domestic level (Silva et al., 2008), this
19 procedure allows to accurately evaluate foaming performances. Subsequently, a steam injection-
20 based method was also applied, which can be considered the gold standard for foamed milk
21 preparations (*i.e.*, *cappuccino*, *macchiato*, and *latte*) in the catering sector (Silva et al., 2008).
22

23 Refrigeration had almost no effect on milk foaming properties. This might have been due to slight
24 hydrolysis of milk proteins, as a result of the activity of microbial enzymes (Table 2) (Ho et al.,
25 2019). Differently, HS caused a remarkable progressive increase (~ 4-fold after 6 days) in
26 mechanically-induced foaming capacity, without detriment to the foam stability (Table 5). Similar
27 to the mechanical procedure, the steam injection foaming method highlighted a progressive
28 increase in the foaming capacity (about 35% after 6 days) and no changes in the foam stability of
29 pressurized milk (Table 5). These results indicate that the enhancement of milk foaming induced
30 by HS would be relevant for both domestic and catering-related uses, suggesting that preparations
31 based on foamed milk might be attained using lower amounts of milk if the latter was previously
32 subjected to pressurized storage. Data also confirm the hypothesis that unfolding of β -Lg and
33 formation of proteose-peptones during HS improved milk foaming capacity (Figure 2) (Buccioni
34 et al., 2013; Innocente et al., 2011). However, based on their excellent foaming activity, proteose-
35 peptones were reasonably the major driver of these phenomena, as also supported by the strong
36 positive correlation ($r=0.9085$) between foaming capacity and proteose-peptones RP-HPLC peak
37 area (data not shown).
38
39
40
41
42

43 **4 Conclusions**

44 This work demonstrates the efficacy of hyperbaric storage (150 MPa for 6 days) as a preservation
45 treatment for raw milk, and the potentiality of the technology for non-thermal milk pasteurization.
46 HS was actually capable to irreversibly reduce the load of *E. coli* and *S. aureus* by 5 log units with
47 minimal effects on milk physical stability, while significantly boosting foaming capacity. Besides
48 representing an efficacious alternative to milk thermal stabilization, hyperbaric storage might serve
49 as pretreatment in the manufacturing of dairy-based products where milk protein properties are
50 crucial. For instance, the pressure-induced enhancement of milk proteins surface activity could be
51 particularly interesting to improve the rheological properties of ice cream and recombined dairy
52 creams. Moreover, the possibility to integrate β -Lg in the curd could allow to significantly boost
53 yield, nutrient value and functional properties of cheese and fermented milk derivatives.
54

55 The application of hyperbaric storage could be easily extended to preserve liquid matrices other
56 than milk, for which non-thermal technologies can be applied for pasteurization. It also shows
57 potential as an alternative to thermal sterilization, whose inactivation capacity might be attained
58
59
60
61
62
63
64
65

1
2
3
4 by applying HS for sufficient time. Nevertheless, for each food matrix, a clear understanding of
5 the kinetics of alterative phenomena at pressurized conditions is needed, since they might be not
6 negligible during prolonged HS.

7
8 The implementation of hyperbaric storage in food industries will strictly depend on the availability
9 of working units viable for industrial application, easy to operate, and feasible from an economic
10 perspective.
11

12 **5 Funding**

13
14 This research did not receive any specific grant from funding agencies in the public, commercial,
15 or not-for-profit sectors.
16

17 **6 Declaration of interest:** none

18 **7 Acknowledgments**

19
20 The Authors would like to thank Debora Pinamonti, Alessia Cossetini and Alessia Lena for
21 carrying out microbiological analyses.
22
23

24 **8 References**

- 25
26 Aganovic, K., Hertel, C., Vogel, R. F., Johne, R., Schlüter, O., Schwarzenbolz, U., Jäger, H.,
27 Holzhauser, T., Bergmair, J., Roth, A., Sevenich, R., Bandick, N., Kulling, S. E., Knorr, D.,
28 Engel, K-H., & Heinz, V. (2020). Aspects of high hydrostatic pressure food processing:
29 Perspectives on technology and food safety. *Comprehensive Reviews in Food Science and Food*
30 *Safety*, 20, 3225–3266. <https://doi.org/10.1111/1541-4337.12763>.
31
32 Alberini, F., Simmons, M. J. H., Parker, D. J., & Koutchma, T. (2015). Validation of
33 hydrodynamic and microbial inactivation models for UV-C treatment of milk in a swirl-tube
34 “SurePure Turbulator™”. *Journal of Food Engineering*, 162, 63–69.
35 <https://doi.org/10.1016/j.jfoodeng.2015.04.009>.
36
37 Anema, S. G., Lowe, E. K., & Stockmann, R. (2005). Particle size changes and casein
38 solubilisation in high-pressure-treated skim milk. *Food Hydrocolloids*, 19, 257–267.
39 <https://doi.org/10.1016/j.foodhyd.2004.04.025>.
40
41 Basso, F., Manzocco, L., Maifreni, M., & Nicoli, M. C. (2021). Hyperbaric storage of egg white
42 at room temperature: Effects on hygienic properties, protein structure and technological
43 functionality. *Innovative Food Science and Emerging Technologies*, 74, Article 102847.
44 <https://doi.org/10.1016/j.ifset.2021.102847>.
45
46 Bermejo-Prada, A., Colmant, A., Otero, L., & Guignon, B. (2017). Industrial viability of the
47 hyperbaric method to store perishable foods at room temperature. *Journal of Food Engineering*,
48 193, 76–85. <https://doi.org/10.1016/j.jfoodeng.2016.08.014>.
49
50 Buccioni, A., Minieri, S., & Rapaccini, S. (2013). Effect of total proteoseptone content on the
51 variability of bovine milk foaming property. *Italian Journal of Animal Science*, 12, 72–76.
52 <https://doi.org/10.4081/ijas.2013.e12>.
53
54 Cho, Y., Singh, H., & Creamer, L. K. (2003). Heat-induced interactions of β -lactoglobulin A and
55 κ -casein B in a model system. *Journal of Dairy Research*, 70, 61–71.
56 <https://doi.org/10.1017/S0022029902005642>.
57
58 de Kruif, C. G. (1999). Casein micelle interactions. *International Dairy Journal*, 9, 183–188.
59 [https://doi.org/10.1016/S0958-6946\(99\)00058-8](https://doi.org/10.1016/S0958-6946(99)00058-8).
60
61 De Noni, I., Pellegrino, L., Cattaneo, S., & Resmini, P. (2007). HPLC of proteose peptones for
62
63
64
65

1
2
3
4 evaluating ageing of packaged pasteurized milk. *International Dairy Journal*, 17, 12–19.
5 <https://doi.org/10.1016/j.idairyj.2005.12.010>.
6
7 Duarte, R. V., Moreira, S. A., Fernandes, P. A. R., Fidalgo, L. G., Santos, M. D., Queirós, R. P.,
8 Santos, D. I., Delgadillo, I., & Saraiva, J. A. (2015). Preservation under pressure (hyperbaric
9 storage) at 25 °C, 30 °C and 37 °C of a highly perishable dairy food and comparison with
10 refrigeration. *CyTA – Journal of Food*, 13, 321–328.
11 <http://dx.doi.org/10.1080/19476337.2014.971876>.
12
13 Fernandes, P. A. R., Moreira, S. A., Fidalgo, L. G., Santos, M. D., Queirós, R. P., Delgadillo, I.,
14 & Saraiva, J. A. (2014). Food preservation under pressure (hyperbaric storage) as a possible
15 improvement/alternative to refrigeration. *Food Engineering Reviews*, 7, 1–10.
16 <https://doi.org/10.1007/s12393-014-9083-x>.
17
18 Fidalgo, L. G., Lemos, Á. T., Delgadillo, I., & Saraiva, J. A. (2018). Microbial and
19 physicochemical evolution during hyperbaric storage at room temperature of fresh Atlantic
20 salmon (*Salmo salar*). *Innovative Food Science and Emerging Technologies*, 45, 264–272.
21 <https://doi.org/10.1016/j.ifset.2017.11.003>.
22
23 Freitas, P., Pereira, S. A., Santos, M. D., Alves, S. P., Bessa, R. J. B., Delgadillo, I., & Saraiva, J.
24 A. (2016). Performance of raw bovine meat preservation by hyperbaric storage (*quasi*
25 energetically costless) compared to refrigeration. *Meat Science*, 121, 64–72.
26 <https://doi.org/10.1016/j.meatsci.2016.05.001>.
27
28 Garcia, H. S., López-Hernandez, A., & Hill, C. G. (2017). Enzyme technology – Dairy industry
29 applications. In M. Y. Murray (Ed.), *Comprehensive biotechnology* (3rd ed., pp. 608–617).
30 Elsevier B.V. <https://doi.org/10.1016/B978-0-12-809633-8.09232-3>.
31
32 García-Risco, M. R., Recio, I., Molina, E., & López-Fandiño, R. (2003). Plasmin activity in
33 pressurized milk. *Journal of Dairy Science*, 86, 728–734. [https://doi.org/10.3168/jds.S0022-0302\(03\)73653-4](https://doi.org/10.3168/jds.S0022-0302(03)73653-4).
34
35 Gebhardt, R., Doster, W., Friedrich, J., & Kulozik, U. (2006). Size distribution of pressure-
36 decomposed casein micelles studied by dynamic light scattering and AFM. *European Biophysics*
37 *Journal*, 35, 503–509. <https://doi.org/10.1007/s00249-006-0058-6>.
38
39 Griffiths, M. W., Phillips, J. D., & Muir, D. D. (1987). Effect of low-temperature storage on the
40 bacteriological quality of raw milk. *Food Microbiology*, 4, 285–291.
41 [https://doi.org/10.1016/S0740-0020\(87\)80002-3](https://doi.org/10.1016/S0740-0020(87)80002-3).
42
43 Hill, V. M., Ledward, D. A., & Ames, J. M. (1996). Influence of high hydrostatic pressure and
44 pH on the rate of Maillard browning in a glucose-lysine system. *Journal of Agricultural and*
45 *Food Chemistry*, 44, 594–598. <https://doi.org/10.1021/jf950317w>.
46
47 Ho, T. M., Le, T. H. A., Yan, A., Bhandari, B. R., & Bansal, N. (2019). Foaming properties and
48 foam structure of milk during storage. *Food Research International*, 116, 379–386.
49 <https://doi.org/10.1016/j.foodres.2018.08.051>.
50
51 Huppertz, T., & de Kruif, C. G. (2007). Disruption and reassociation of casein micelles during
52 high pressure treatment: Influence of whey proteins. *Journal of Dairy Research*, 74, 194–197.
53 <https://doi.org/10.1017/S0022029906002263>.
54
55 Huppertz, T., Fox, P. F., de Kruif, K. G., & Kelly, A. L. (2006). High pressure-induced changes
56 in bovine milk proteins: A review. *Biochimica et Biophysica Acta*, 1764, 593–598.
57 <https://doi.org/10.1016/j.bbapap.2005.11.010>.
58
59 Huppertz, T., Fox, P. F., & Kelly, A. L. (2004). High pressure treatment of bovine milk: Effects
60 on casein micelles and whey proteins. *Journal of Dairy Research*, 71, 97–106.
61 <https://doi.org/10.1017/S002202990300640X>.
62
63
64
65

- 1
2
3
4 Huppertz, T., Kelly, A. L., & de Kruif, C. G. (2006). Disruption and reassociation of casein
5 micelles under high pressure. *Journal of Dairy Research*, 73, 294–298.
6 <https://doi.org/10.1017/S0022029906001725>.
- 7 Huppertz, T., Kelly, A. L., & Fox, P. F. (2002). Effects of high pressure on constituents and
8 properties of milk. *International Dairy Journal*, 12, 561–572.
9 <https://doi.org/10.1109/pac.1989.73210>.
- 10 Innocente, N., Biasutti, M., & Blecker, C. (2011). HPLC profile and dynamic surface properties
11 of the proteose-peptone fraction from bovine milk and from whey protein concentrate.
12 *International Dairy Journal*, 21, 222–228. <https://doi.org/10.1016/j.idairyj.2010.11.004>.
- 13 Isaacs, N. S., & Coulson, M. (1996). Effect of pressure on processes modelling the Maillard
14 reaction. *Journal of Physical Organic Chemistry*, 9, 639–644.
15 [https://doi.org/10.1002/\(SICI\)1099-1395\(199609\)9:9<639::AID-POC833>3.0.CO;2-Q](https://doi.org/10.1002/(SICI)1099-1395(199609)9:9<639::AID-POC833>3.0.CO;2-Q).
- 16 James, S. J., & James, C. (2010). The food cold-chain and climate change. *Food Research*
17 *International*, 43, 1944–1956. <https://doi.org/10.1016/j.foodres.2010.02.001>.
- 18 Kamath, S., Huppertz, T., Houlihan, A. V., & Deeth, H. C. (2008). The influence of temperature
19 on the foaming of milk. *International Dairy Journal*, 18, 994–1002.
20 <https://doi.org/10.1016/j.idairyj.2008.05.001>.
- 21 Kielczewska, K., Jankowska, A., Dąbrowska, A., Wachowska, M., & Ziajka, J. (2020). The
22 effect of high pressure treatment on the dispersion of fat globules and the fatty acid profile of
23 caprine milk. *International Dairy Journal*, 102, Article 104607.
24 <https://doi.org/10.1016/j.idairyj.2019.104607>.
- 25 Matak, K. E., Churey, J. J., Worobo, R. W., Sumner, S. S., Hovingh, E., Hackney, C. R., &
26 Pierson, M. D. (2005). Efficacy of UV light for the reduction of *Listeria monocytogenes* in
27 goat's milk. *Journal of Food Protection*, 68, 2212–2216. [https://doi.org/10.4315/0362-028X-](https://doi.org/10.4315/0362-028X-68.10.2212)
28 [68.10.2212](https://doi.org/10.4315/0362-028X-68.10.2212).
- 29 Mussa, D. M., & Ramaswamy, H. S. (1997). Ultra high pressure pasteurization of milk: Kinetics
30 of microbial destruction and changes in physico-chemical characteristics. *LWT - Food Science*
31 *and Technology*, 30, 551–557. <https://doi.org/10.1006/fstl.1996.0223>.
- 32 Needs, E. C., Capellas, M., Bland, A. P., Manoj, P., Macdougall, D., & Paul, G. (2000).
33 Comparison of heat and pressure treatments of skim milk, fortified with whey protein
34 concentrate, for set yogurt preparation: Effects on milk proteins and gel structure. *Journal of*
35 *Dairy Research*, 67, 329–348. <https://doi.org/10.1017/S0022029900004301>.
- 36 Needs, E. C., Stenning, R. A., Gill, A. L., Ferragut, V., & Rich, G. T. (2000). High-pressure
37 treatment of milk: Effects on casein micelle structure and on enzymic coagulation. *Journal of*
38 *Dairy Research*, 67, 31–42. <https://doi.org/10.1017/S0022029999004021>.
- 39 Otero, L., Pérez-Mateos, M., Holgado, F., Márquez-Ruiz, G., & López-Caballero, M. E. (2019).
40 Hyperbaric cold storage: Pressure as an effective tool for extending the shelf-life of refrigerated
41 mackerel (*Scorpaenopsis scorpaenoides*, L.). *Innovative Food Science and Emerging Technologies*, 51, 41–
42 50. <https://doi.org/10.1016/j.ifset.2018.05.003>.
- 43 Otero, L., & Pérez-Mateos, M. (2021). Hyperbaric storage of atlantic razor clams: Effect of the
44 storage conditions. *Food and Bioprocess Technology*, 530–541. [https://doi.org/10.1007/s11947-](https://doi.org/10.1007/s11947-021-02596-0)
45 [021-02596-0](https://doi.org/10.1007/s11947-021-02596-0).
- 46 Palmeri, R., Parafati, L., Trippa, D., Siracusa, L., Arena, E., Restuccia, C., & Fallico, B. (2019).
47 Addition of olive leaf extract (OLE) for producing fortified fresh pasteurized milk with an
48 extended shelf life. *Antioxidants*, 8. <https://doi.org/10.3390/antiox8080255>.
- 49 Patel, H. A., & Huppertz, T. (2014). Effects of high-pressure processing on structure and
50
51
52
53
54
55
56
57
58
59
60
61
62
63
64
65

1
2
3
4 interactions of milk proteins. In H. Singh, M. Boland, & A. Thompson (Eds), *Milk Proteins* (2nd
5 ed., pp. 243–267). Elsevier Inc. <https://doi.org/10.1016/b978-0-12-405171-3.00008-8>.
6
7 Pinto, C. A., Martins, A. P., Santos, M. D., Fidalgo, L. G., Delgadillo, I., & Saraiva, J. A. (2019).
8 Growth inhibition and inactivation of *Alicyclobacillus acidoterrestris* endospores in apple juice
9 by hyperbaric storage at ambient temperature. *Innovative Food Science and Emerging*
10 *Technologies*, *52*, 232–236. <https://doi.org/10.1016/j.ifset.2019.01.007>.
11
12 Pinto, C. A., Moreira, S. A., Fidalgo, L. G., Santos, M. D., Vidal, M., Delgadillo, I., & Saraiva, J.
13 A. (2017). Impact of different hyperbaric storage conditions on microbial, physicochemical and
14 enzymatic parameters of watermelon juice. *Food Research International*, *99*, 123–132.
15 <https://doi.org/10.1016/j.foodres.2017.05.010>.
16
17 Pinto, C. A., Santos, M. D., Fidalgo, L. G., Delgadillo, I., & Saraiva, J. A. (2018). Enhanced
18 control of *Bacillus subtilis* endospores development by hyperbaric storage at
19 variable/uncontrolled room temperature compared to refrigeration. *Food Microbiology*, *74*, 125–
20 131. <https://doi.org/10.1016/j.fm.2018.03.010>.
21
22 Ruiz-Espinosa, H., Amador-Espejo, G. G., Barcenas-Pozos, M. E., Angulo-Guerrero, J. O.,
23 Garcia, H. S., & Welte-Chanes, J. (2013). Multiple-pass high-pressure homogenization of milk
24 for the development of pasteurization-like processing conditions. *Letters in Applied*
25 *Microbiology*, *56*, 142–148. <https://doi.org/10.1111/lam.12027>.
26
27 Santos, M. D., Castro, R., Delgadillo, I., & Saraiva, J. A. (2019). Improvement of the
28 refrigerated preservation technology by hyperbaric storage for raw fresh meat. *Journal of the*
29 *Science of Food and Agriculture*, *100*, 969–977. <https://doi.org/10.1002/jsfa.10083>.
30
31 Santos, M. D., Fidalgo, L. G., Pinto, C. A., Duarte, R. V., Lemos, Á. T., Delgadillo, I., &
32 Saraiva, J. A. (2020). Hyperbaric storage at room like temperatures as a possible alternative to
33 refrigeration: evolution and recent advances. *Critical Reviews in Food Science and Nutrition*, *61*,
34 2078–2089. <https://doi.org/10.1080/10408398.2020.1770687>.
35
36 Scollard, P. G., Beresford, T. P., Needs, E. C., Murphy, P. M., & Kelly, A. L. (2000). Plasmin
37 activity, β -lactoglobulin denaturation and proteolysis in high pressure treated milk. *International*
38 *Dairy Journal*, *10*, 835–841. [https://doi.org/10.1016/S0958-6946\(01\)00028-0](https://doi.org/10.1016/S0958-6946(01)00028-0).
39
40 Segat, A., Misra, N. N., Cullen, P. J., & Innocente, N. (2015). Atmospheric pressure cold plasma
41 (ACP) treatment of whey protein isolate model solution. *Innovative Food Science and Emerging*
42 *Technologies*, *29*, 247–254. <https://doi.org/10.1016/j.ifset.2015.03.014>.
43
44 Silva, S., Espiga, A., Niranjana, K., Livings, S., Gumy, J.-C., & Sher, A. (2008). Formation and
45 stability of milk foams. In G. M. Campbell, M. G. Scanlon, & D. L. Pyle (Eds.), *Bubbles in Food*
46 *2: Novelty, Health and Luxury* (pp. 153–161). Elsevier Inc. <https://doi.org/10.1016/B978-1-891127-59-5.50020-1>.
47
48 Stratakos, A. C., Inguglia, E. S., Linton, M., Tollerton, J., Murphy, L., Corcionivoschi, N.,
49 Koidis, A., & Tiwari, B. K. (2019). Effect of high pressure processing on the safety, shelf life
50 and quality of raw milk. *Innovative Food Science and Emerging Technologies*, *52*, 325–333.
51 <https://doi.org/10.1016/j.ifset.2019.01.009>.
52
53 Swain, M. J., Evans, J. A., & James, S. J. (2005). Energy consumption in the UK food chill chain
54 – primary chilling. *Food Manufacturing Efficiency*, *2*, 25–33. <https://doi.org/10.1616/1750-2683.00xx>.
55
56 Syed, Q. A., Hassan, A., Sharif, S., Ishaq, A., Saeed, F., Afzaal, M., Hussain, M., & Anjum, F.
57 M. (2021). Structural and functional properties of milk proteins as affected by heating, high
58 pressure, gamma and ultraviolet irradiation: a review. *International Journal of Food Properties*,
59 *24*, 871–884. <https://doi.org/10.1080/10942912.2021.1937209>.
60
61
62
63
64
65

1
2
3
4
5
6
7
8
9
10
11
12
13
14
15
16
17
18
19
20
21
22
23
24
25
26
27
28
29
30
31
32
33
34
35
36
37
38
39
40
41
42
43
44
45
46
47
48
49
50
51
52
53
54
55
56
57
58
59
60
61
62
63
64
65

Vasavada, P. C. (1988). Pathogenic bacteria in milk - A review. *Journal of Dairy Science*, 71, 2809–2816. [https://doi.org/10.3168/jds.S0022-0302\(88\)79876-8](https://doi.org/10.3168/jds.S0022-0302(88)79876-8).

Wuytack, E. Y., Diels, A. M. J., & Michiels, C. W. (2002). Bacterial inactivation by high-pressure homogenisation and high hydrostatic pressure. *International Journal of Food Microbiology*, 77, 205–212. [https://doi.org/10.1016/S0168-1605\(02\)00054-5](https://doi.org/10.1016/S0168-1605(02)00054-5).

Table 1: Size and content of casein micelles and sub-micellar particles in raw skim milk during HS for increasing time at 200 and 150 MPa.

Pressure (MPa)	Time (h)	Micelles size (nm)	Intensity (%)	Sub-micellar particles size (nm)	Intensity (%)	Aggregates size (nm)	Intensity (%)
0	0	169.1 ± 2.6 ^g	100.0 ± 0.0 ^a	-	-	-	-
150	0.5	173.2 ± 2.3 ^g	100.0 ± 0.0 ^a	-	-	-	-
	1	170.9 ± 2.8 ^g	100.0 ± 0.0 ^a	-	-	-	-
	2	167.1 ± 4.6 ^g	100.0 ± 0.0 ^a	-	-	-	-
	3	172.5 ± 5.0 ^g	100.0 ± 0.0 ^a	-	-	-	-
	15	217.1 ± 5.2 ^e	100.0 ± 0.0 ^a	-	-	-	-
	18	223.1 ± 4.1 ^e	100.0 ± 0.0 ^a	-	-	-	-
	24	237.0 ± 4.0 ^d	100.0 ± 0.0 ^a	-	-	-	-
	48	275.8 ± 7.9 ^b	96.7 ± 3.1 ^a	52.1 ± 8.0 ^a	6.5 ± 1.4 ^{ab}	-	-
120	377.9 ± 11.0 ^a	96.5 ± 3.3 ^a	51.1 ± 2.8 ^a	5.9 ± 0.9 ^{ab}	-	-	
144	371.1 ± 8.1 ^a	99.8 ± 0.5 ^a	-	-	5280.0 ± 396.0 ^a	2.0 ± 0.8 ^a	
200	0.17	175.4 ± 3.1 ^{fg}	100.0 ± 0.0 ^a	-	-	-	-
	0.33	186.8 ± 3.2 ^f	100.0 ± 0.0 ^a	-	-	-	-
	0.5	212.6 ± 4.9 ^c	97.2 ± 0.2 ^a	46.0 ± 2.2 ^a	2.8 ± 0.2 ^b	-	-
	1	248.5 ± 6.2 ^{cd}	92.7 ± 0.5 ^{ab}	58.4 ± 2.8 ^a	7.3 ± 0.5 ^{ab}	-	-
	1.5	256.3 ± 11.8 ^c	90.9 ± 2.5 ^b	52.6 ± 4.7 ^a	9.1 ± 2.6 ^a	5344.5 ± 304.8 ^a	1.7 ± 0.8 ^a

- : not detectable

a, b, c, d, e, f, g: Different letters indicate significantly different means (ANOVA; p<0.05) in the same column.

Table 2: Total bacteria (TBC), lactic acid bacteria (LAB), coagulase-positive *Staphylococci* (SC+), fecal coliforms (FC) and total coliforms (TC) counts in raw skim milk stored for up to 6 days under refrigerated (0.1 MPa, 4.0 ± 0.5 °C) or hyperbaric conditions (150 MPa, 20 ± 1 °C). Results are expressed as logCFU mL⁻¹.

Storage	Time (days)	TBC	LAB	SC+	FC	TC
Fresh	0	3.89 ± 0.16	3.44 ± 0.42	2.91 ± 0.28	2.38 ± 0.03	2.70 ± 0.22
Refrigerated	1	3.85 ± 0.15	3.82 ± 0.03	2.95 ± 0.12	2.13 ± 0.29	2.66 ± 0.17
	2	3.88 ± 0.07	3.43 ± 0.28	2.57 ± 0.03	2.22 ± 0.01	2.50 ± 0.11
	4	3.80 ± 0.03	3.41 ± 0.52	3.11 ± 0.05	2.72 ± 0.17	2.88 ± 0.08
	6	5.98 ± 0.09	4.12 ± 1.08	2.51 ± 0.22	4.69 ± 0.44	3.56 ± 0.16
Hyperbaric	1	3.41 ± 0.38	3.59 ± 0.05	2.41 ± 0.57	< L.o.D.**	1.70 ± 0.29
	2	3.41 ± 0.30	2.99 ± 0.50	2.10 ± 0.45	< L.o.D.**	< L.o.D.**
	4	2.95 ± 0.31	2.29 ± 0.25	1.95 ± 0.24	< L.o.D.**	< L.o.D.**
	6	< L.o.D.*	< L.o.D.*	< L.o.D.*	< L.o.D.**	< L.o.D.**

*L.o.D.: 1 logCFU mL⁻¹

** L.o.D.: 0 logCFU mL⁻¹

Table 3: Counts of inoculated *E. coli* and *S. aureus* in UHT skim milk stored for up to 6 days under refrigerated (0.1 MPa, 4.0 ± 0.5 °C) or hyperbaric conditions (150 MPa, 20 ± 1 °C). Results are expressed as logCFU mL⁻¹.

Storage	Time (days)	<i>E. coli</i>	<i>S. aureus</i>
Fresh	0	5.49 ± 0.13	5.33 ± 0.08
Refrigerated	1	5.49 ± 0.16	5.32 ± 0.09
	2	5.56 ± 0.11	5.38 ± 0.00
	4	5.55 ± 0.24	5.29 ± 0.05
	6	5.25 ± 0.09	5.19 ± 0.02
Hyperbaric	1	1.47 ± 0.18	4.94 ± 0.08
	2	< L.o.D.*	4.13 ± 0.18
	4	< L.o.D.*	2.43 ± 0.19
	6	< L.o.D.*	< L.o.D.**

*L.o.D.: 0 logCFU mL⁻¹

** L.o.D.: 1 logCFU mL⁻¹

Table 4: Counts of inoculated *E. coli* and *S. aureus*, and relevant TBC (in brackets) in raw skim milk stored for up to 6 days under refrigerated (0.1 MPa, 4.0 ± 0.5 °C) or hyperbaric conditions (150 MPa, 20 ± 1 °C). Results are expressed as logCFU mL⁻¹.

Storage	Time (days)	<i>E. coli</i> (TBC)	<i>S. aureus</i> (TBC)
Fresh	0	5.13 ± 0.33 (5.16 ± 0.02)	5.66 ± 0.93 (5.56 ± 0.83)
Refrigerated	1	5.00 ± 0.17 (5.15 ± 0.15)	5.67 ± 1.04 (5.51 ± 0.67)
	2	5.12 ± 0.28 (5.30 ± 0.08)	5.50 ± 0.71 (6.07 ± 1.52)
	4	4.97 ± 0.21 (5.13 ± 0.07)	5.47 ± 0.81 (5.52 ± 0.93)
	6	4.99 ± 0.30 (6.07 ± 0.11)	5.59 ± 0.94 (6.05 ± 0.26)
Hyperbaric	1	2.25 ± 0.25 (3.69 ± 0.04)	5.20 ± 0.92 (5.20 ± 0.85)
	2	< L.o.D.* (3.02 ± 0.17)	3.83 ± 1.86 (4.28 ± 1.27)
	4	< L.o.D.* (2.43 ± 0.19)	2.67 ± 1.02 (2.94 ± 0.08)
	6	< L.o.D.* (<L.o.D.**)	< L.o.D.** (2.10 ± 0.02)

*L.o.D.: 0 logCFU mL⁻¹

** L.o.D.: 1 logCFU mL⁻¹

Table 5: Foaming capacity and foam stability determined by mechanical agitation or steam injection in raw skim milk stored for up to 6 days under refrigerated (0.1 MPa, 4.0 ± 0.5 °C) or hyperbaric conditions (150 MPa, 20 ± 1 °C).

Storage	Time (days)	Mechanical agitation		Steam injection	
		Foaming capacity (%)	Foam stability (%)	Foaming capacity (%)	Foam stability (%)
Fresh	0	72.5 ± 4.4 ^d	72.6 ± 4.1 ^a	112.7 ± 6.0 ^b	50.2 ± 6.6 ^{ab}
Refrigeration	4	83.4 ± 9.5 ^d	62.3 ± 15.5 ^a	-	-
	6	92.8 ± 5.1 ^d	71.4 ± 6.8 ^a	106.6 ± 6.9 ^b	60.2 ± 0.8 ^a
Hyperbaric	1	119.5 ± 7.9 ^c	75.0 ± 5.6 ^a	N.D.	N.D.
	2	123.4 ± 8.5 ^c	79.6 ± 6.6 ^a	122.4 ± 0.7 ^{ab}	51.6 ± 0.7 ^{ab}
	4	197.2 ± 6.5 ^b	71.2 ± 0.8 ^a	127.4 ± 2.9 ^{ab}	54.9 ± 3.5 ^{ab}
	6	267.3 ± 15.7 ^a	71.7 ± 1.5 ^a	147.5 ± 15.3 ^a	49.3 ± 2.2 ^b

a, b, c, d: Different letters indicate significantly different means (ANOVA; p<0.05) in the same column.

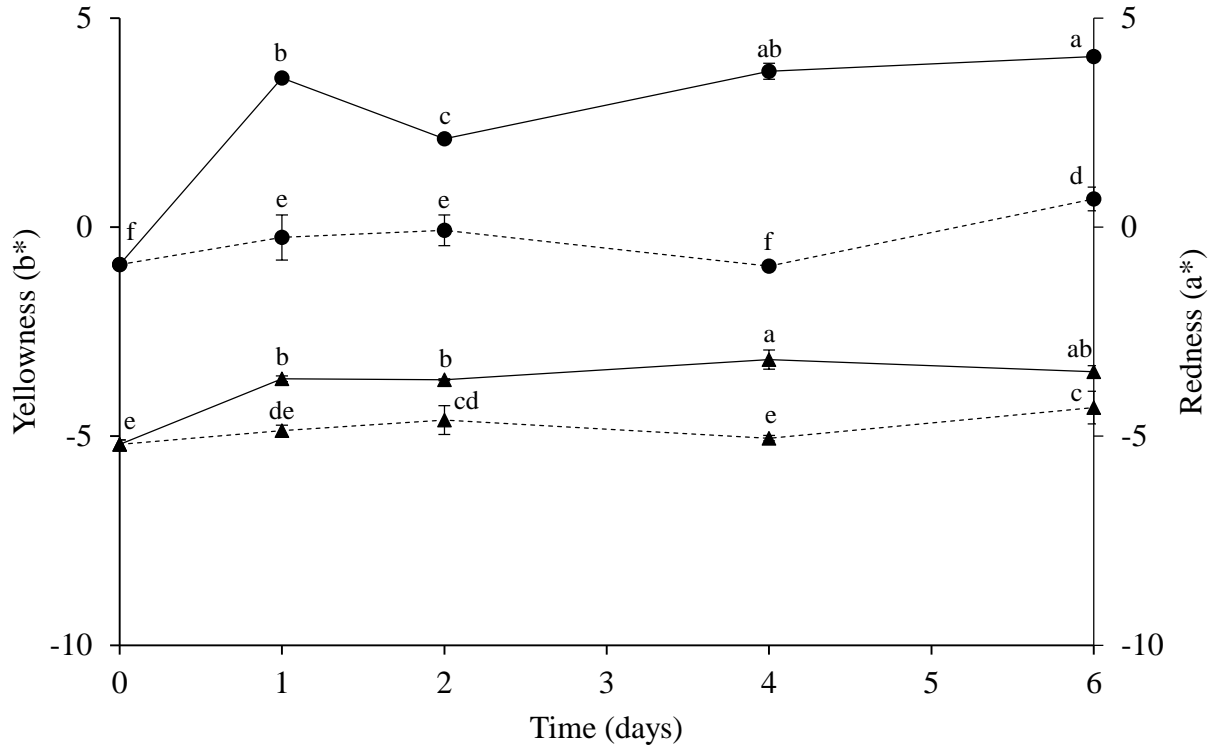


Figure 1: Redness (a^*) and yellowness (b^*) of raw skim milk stored for up to 6 days under refrigerated (0.1 MPa, 4.0 ± 0.5 °C) or hyperbaric conditions (150 MPa, 20 ± 1 °C). a, b, c, d, e, f: Different letters for the same colour parameter indicate significantly different means (ANOVA; $p < 0.05$).

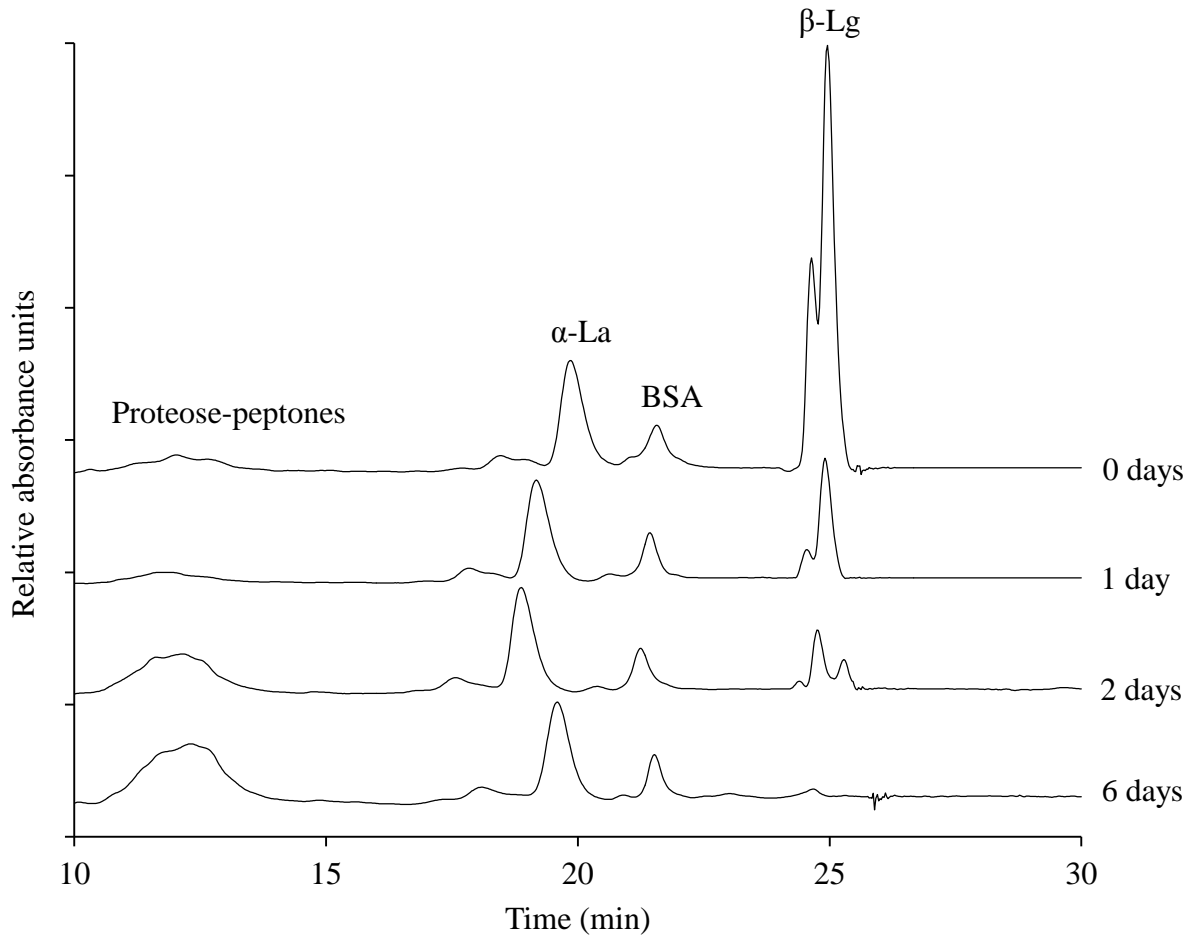
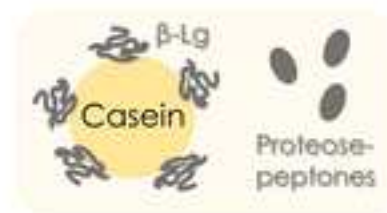


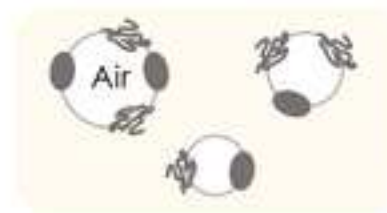
Figure 2: RP-HPLC chromatogram of raw skim milk samples during HS at 150 MPa (20 ± 1 °C) for up to 6 days. Peak assignment of proteose-peptones, α -La, BSA and β -Lg is also displayed.



5 irreversible log reductions



Formation of complex micelles and proteose-peptones



Enhanced foaming properties

Federico Basso: Investigation, Formal analysis, Data curation, Writing - Original Draft, Visualization; **Michela Maifreni:** Investigation, Formal analysis, Data curation, Writing - Original Draft; **Nadia Innocente:** Conceptualization, Data curation, Writing - Review & Editing; **Lara Manzocco:** Conceptualization, Data curation, Resources, Writing - Original Draft, Writing - Review & Editing, Supervision; **Maria Cristina Nicoli:** Conceptualization, Resources, Writing - Review & Editing, Supervision.

Conflict of Interest and Authorship Confirmation Form

The Authors declare that:

- ✓ All authors have participated in (a) conception and design, or analysis and interpretation of the data; (b) drafting the article or revising it critically for important intellectual content; and (c) approval of the final version.
- ✓ This manuscript has not been submitted to, nor is under review at, another journal or other publishing venue.
- ✓ The authors have no affiliation with any organization with a direct or indirect financial interest in the subject matter discussed in the manuscript.