

Contents

| Chapters | Titles | Page No. |
|------------------|--|----------|
| Chapter 1 | Introduction | 1-4 |
| Chapter 2 | Literature Review | 5-30 |
| 2.1 | Oilseed Cell Wall Structure | 5 |
| 2.2 | Processes for Oil Extraction from Seeds | 9 |
| 2.3 | Factors Affecting Oil Yield During EACP and EAAE | 27 |
| Chapter 3 | Materials and Methods | 31-45 |
| 3.1 | Procurement of Oilseeds | 31 |
| 3.2 | Analytical Instruments Used Throughout the Work | 31 |
| 3.3 | Reagents, Chemicals, Standards and Enzymes | 32 |
| 3.4 | Extraction of Oil from Seeds | 32 |
| 3.4.1 | Solvent Extraction | 32 |
| 3.4.2 | Enzyme-assisted Cold Pressing (EACP) | 34 |
| 3.4.2.1 | Optimization of Parameters for EACP | 34 |
| 3.4.3 | Enzyme-assisted Aqueous Extraction (EA AE) | 36 |
| 3.4.3.1 | Optimization of Parameters for EA AE | 37 |
| 3.5 | Quality Evaluation of Oils and Oilseed Residues | 40 |
| 3.5.1 | Proximate Composition of Oilseed Residues | 40 |
| 3.5.2 | Analysis of Oils | 41 |
| 3.5.3 | Antioxidant Activity of Extracted Oils | 43 |
| 3.6 | Statistical Analysis | 45 |

| | | |
|------------------|--|---------|
| Chapter 4 | Results | 46-134 |
| Chapter 5 | Discussion | 139-160 |
| 5.1 | Factors Affecting Oil Yield during Enzyme-assisted Cold Pressing (EACP) | 139 |
| 5.2 | Factors Affecting Oil Yield during Enzyme-assisted Aqueous Extraction (EAAE) | 144 |
| 5.3 | Comparison of the Quality of Extracted Oils and Oilseed Residues | 153 |
| Chapter 6 | Summary | 161-163 |
| | References | 164-178 |

LIST OF TABLES

| Serial No. | Titles | Page No. |
|------------|--|----------|
| 2.1 | Typical Composition of Selected Seed Cell Wall Polysaccharides | 8 |
| 2.2 | Oil Extraction by Aqueous Extraction Process | 19 |
| 2.3 | Literature Cited for Enzyme-assisted Oil Extraction from Selected Seeds | 30 |
| 3.1 | Activity and Supplier of Enzyme Preparations | 33 |
| 4.1.1a | Comparison of Proximate Composition of Enzyme-assisted Cold Pressed Cottonseeds | 48 |
| 4.1.1b | Comparison of Proximate Composition of Enzyme-assisted Aqueous Extracted Cottonseeds | 48 |
| 4.1.2a | Comparison of Physico-chemical Properties of Enzyme-assisted Cold Pressed Cottonseed Oils | 49 |
| 4.1.2b | Comparison of Physico-chemical Properties of Enzyme-assisted Aqueous Extracted Cottonseed Oils | 50 |
| 4.1.3a | Comparison of Oxidative State of Enzyme-assisted Cold Pressed Cottonseed Oils | 51 |
| 4.1.3b | Comparison of Oxidative State of Enzyme-assisted Aqueous Extracted Cottonseed Oils | 51 |
| 4.1.4a | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Cold Pressed Cottonseed Oils | 52 |
| 4.1.4b | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Aqueous Extracted Cottonseed Oils | 53 |
| 4.1.5a | Comparison of Tocopherol of Enzyme-assisted Cold Pressed Cottonseed Oils | 54 |
| 4.1.5b | Comparison of Tocopherol of Enzyme-assisted Aqueous Extracted Cottonseed Oils | 54 |
| 4.1.6a | Comparison of Antioxidant Activity of Enzyme-assisted Cold Pressed Cottonseed Oils | 55 |
| 4.1.6b | Comparison of Antioxidant Activity of Enzyme-assisted Aqueous Extracted Cottonseed Oils | 55 |
| 4.2.1a | Comparison of Proximate Composition of Enzyme-assisted Cold Pressed Hempseeds | 56 |
| 4.2.1b | Comparison of Proximate Composition of Enzyme-assisted Aqueous Extracted Hempseeds | 56 |
| 4.2.2a | Comparison of Physico-chemical Properties of Enzyme-assisted Cold Pressed Hempseed Oils | 57 |
| 4.2.2b | Comparison of Physico-chemical Properties of Enzyme-assisted Aqueous Extracted Hempseed Oils | 58 |
| 4.2.3a | Comparison of Determination of Oxidative State of Enzyme-assisted Cold Pressed Hempseed Oils | 59 |
| 4.2.3b | Comparison of Determination of Oxidative State of Enzyme-assisted Aqueous Extracted Hempseed Oils | 59 |

| | | |
|--------|--|----|
| 4.2.4a | Comparison of Fatty acid (FA) Composition (g/100g FA) of Enzyme-assisted Cold Pressed Hempseed Oils | 60 |
| 4.2.4b | Comparison of Fatty acid (FA) Composition (g/100g FA) of Enzyme-assisted Aqueous Extracted Hempseed Oils | 61 |
| 4.2.5a | Comparison of Tocopherol of Enzyme-assisted Cold Pressed Hempseed Oils | 62 |
| 4.2.5b | Comparison of Tocopherol of Enzyme-assisted Aqueous Extracted Hempseed Oils | 62 |
| 4.2.6a | Comparison of Antioxidant Activity of Enzyme-assisted Cold Pressed Hempseed Oils | 63 |
| 4.2.6b | Comparison of Antioxidant Activity of Enzyme-assisted Aqueous Extracted Hempseed Oils | 63 |
| 4.3.1a | Comparison of Proximate Composition of Enzyme-assisted Cold Pressed Sunflower Seeds | 64 |
| 4.3.1b | Comparison of Proximate Composition of Enzyme-assisted Aqueous Extracted Sunflower Seeds | 64 |
| 4.3.2a | Comparison of Physicochemical Properties of Enzyme-assisted Cold Pressed Sunflower Seed Oils | 65 |
| 4.3.2b | Comparison of Physicochemical Properties of Enzyme-assisted Aqueous Extracted Sunflower Seed Oils | 66 |
| 4.3.3a | Comparison of Oxidative State of Enzyme-assisted Cold Pressed Sunflower Seed Oils | 67 |
| 4.3.3b | Comparison of Oxidative State of Enzyme-assisted Aqueous Extracted Sunflower Seed Oils | 67 |
| 4.3.4a | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Cold Pressed Sunflower Seed Oils | 68 |
| 4.3.4b | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Aqueous Extracted Sunflower Seed Oils | 69 |
| 4.3.5a | Comparison of Tocopherol in Enzyme-assisted Cold Pressed Sunflower Seed Oils | 70 |
| 4.3.5b | Comparison of Tocopherol in Enzyme-assisted Aqueous Extracted Sunflower Seed Oils | 70 |
| 4.3.6a | Comparison of Antioxidant Activity of Enzyme-assisted Cold Pressed Sunflower Seed Oils | 71 |
| 4.3.6b | Comparison of Antioxidant Activity of Enzyme-assisted Aqueous Extracted Sunflower Seed Oils | 71 |
| 4.4.1a | Comparison of Proximate Composition of Enzyme-assisted Cold Pressed Sesame Seeds | 72 |
| 4.4.1b | Comparison of Proximate Composition of Enzyme-assisted Aqueous Extracted Sesame Seeds | 72 |
| 4.4.2a | Comparison of Physico-chemical Properties of Enzyme-assisted Cold Pressed Sesame Seed Oils | 73 |
| 4.4.2b | Comparison of Physico-chemical Properties of Enzyme-assisted Aqueous Extracted Sesame Seed Oils | 74 |
| 4.4.3a | Comparison of Oxidative State of Enzyme-assisted Cold Pressed Sesame Seed Oils | 75 |

| | | |
|--------|--|----|
| 4.4.3b | Comparison of Oxidative State of Enzyme-assisted Aqueous Extracted Sesame Seed Oils | 75 |
| 4.4.4a | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Cold Pressed Sesame Seed Oils | 76 |
| 4.4.4b | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Aqueous Extracted Sesame Seed Oils | 77 |
| 4.4.5a | Comparison of Tocopherol of Enzyme-assisted Cold Pressed Sesame Seed Oils | 78 |
| 4.4.5b | Comparison of Tocopherol of Enzyme-assisted Aqueous Extracted Sesame Seed Oils | 78 |
| 4.4.6a | Comparison of Antioxidant Activity of Enzyme-assisted Cold Pressed Sesame Seed Oils | 79 |
| 4.4.6b | Comparison of Antioxidant Activity of Enzyme-assisted Aqueous Extracted Sesame Seed Oils | 79 |
| 4.5.1a | Comparison of Proximate Composition of Enzyme-assisted Cold Pressed Canola Seeds | 80 |
| 4.5.1b | Comparison of Proximate Composition of Enzyme-assisted Aqueous Extracted Canola Seeds | 80 |
| 4.5.2a | Comparison of Physico-chemical Properties of Enzyme-assisted Cold Pressed Canola Seed Oils | 81 |
| 4.5.2b | Comparison of Physico-chemical Properties of Enzyme-assisted Aqueous Extracted Canola Seed Oils | 82 |
| 4.5.3a | Comparison of Oxidative State of Enzyme-assisted Cold Pressed Canola Seed Oils | 83 |
| 4.5.3b | Comparison of Oxidative State of Enzyme-assisted Aqueous Extracted Canola Seed Oils | 83 |
| 4.5.4a | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Cold Pressed Canola Seed Oils | 84 |
| 4.5.4b | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Aqueous Extracted Canola Seed Oils | 85 |
| 4.5.5a | Comparison of Tocopherol of Enzyme-assisted Cold Pressed Canola Seed Oils | 86 |
| 4.5.5b | Comparison of Tocopherol of Enzyme-assisted Aqueous Extracted Canola Seed Oils | 86 |
| 4.5.6a | Comparison of Antioxidant Activity of Enzyme-assisted Cold Pressed Canola Seed Oils | 87 |
| 4.5.6b | Comparison of Antioxidant Activity of Enzyme-assisted Aqueous Extracted Canola Seed Oils | 87 |
| 4.6.1a | Comparison of Proximate Composition of Enzyme-assisted Cold Pressed <i>Moringa oleifera</i> Seeds | 88 |
| 4.6.1b | Comparison of Proximate Composition of Enzyme-assisted Aqueous Extracted <i>Moringa oleifera</i> Seeds | 88 |
| 4.6.2a | Comparison of Physico-chemical Properties of Enzyme-assisted Cold Pressed Extraction <i>Moringa oleifera</i> Seed Oils | 89 |
| 4.6.2b | Comparison of Physico-chemical Properties of Aqueous Enzyme-assisted Extraction <i>Moringa oleifera</i> Seed Oils | 90 |

| | | |
|--------|---|----|
| 4.6.3a | Comparison of Oxidative State of Enzyme-assisted Cold Pressed <i>Moringa oleifera</i> Seed Oils | 91 |
| 4.6.3b | Comparison of Oxidative State of Enzyme-assisted Aqueous Extracted <i>Moringa oleifera</i> Seed Oils | 91 |
| 4.6.4a | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Cold Pressed <i>Moringa oleifera</i> Seed Oils | 92 |
| 4.6.4b | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Aqueous Extracted <i>Moringa oleifera</i> Seed Oils | 93 |
| 4.6.5a | Comparison of Tocopherol of Enzyme-assisted Cold Pressed <i>Moringa oleifera</i> Seed Oils | 94 |
| 4.6.5b | Comparison of Tocopherol of Enzyme-assisted Aqueous Extracted <i>Moringa oleifera</i> Seed Oils | 94 |
| 4.6.6a | Comparison of Antioxidant Activity of Enzyme-assisted Cold Pressed <i>Moringa oleifera</i> Seed Oils | 95 |
| 4.6.6b | Comparison of Antioxidant Activity of Enzyme-assisted Aqueous Extracted <i>Moringa oleifera</i> Seed Oils | 95 |
| 4.7.1 | Comparison of Proximate Composition of Aqueous Enzyme-assisted <i>Moringa concanensis</i> Seeds | 96 |
| 4.7.2 | Comparison of Physico-chemical Properties of Enzyme-assisted Aqueous Extracted <i>Moringa concanensis</i> Seed Oils | 96 |
| 4.7.3 | Comparison of Oxidative State of Enzyme-assisted Aqueous Extracted <i>Moringa concanensis</i> Seed Oils | 97 |
| 4.7.4 | Comparison of Fatty Acid (FA) Composition (g/100g FA) of Enzyme-assisted Aqueous Extracted <i>Moringa concanensis</i> Seed Oils | 97 |
| 4.7.5 | Comparison of Tocopherol of Enzyme-assisted Aqueous Extracted <i>Moringa concanensis</i> Seed Oils | 97 |

LIST OF FIGURES

| Serial No. | Titles | Page No. |
|------------|---|----------|
| 2.1 | Structure of an Oilseed | 7 |
| 2.2 | General Structure of a Primary Seed Cell Wall | 7 |
| 3.1 | Flow Chart for Enzyme-assisted Cold Pressing (EACP) | 35 |
| 3.2 | Flow Chart for Enzyme-assisted Aqueous Extraction (EAAE) | 38 |
| 4.1.1a | Effect of Temperature on Oil Recovery from Cottonseeds during EACP | 99 |
| 4.1.1b | Effect of pH on Oil Recovery from Cottonseeds during EACP | 99 |
| 4.1.1c | Effect of Moisture on Oil Recovery from Cottonseeds during EACP | 100 |
| 4.1.1d | Effect of Hydrolysis Time on Oil Recovery from Cottonseeds during EACP | 100 |
| 4.1.1e | Effect of Enzyme Concentration on Oil Recovery from Cottonseeds during EACP | 101 |
| 4.1.1f | Enzymes Offering Optimum Oil Recovery from Cottonseeds during EACP | 101 |
| 4.1.2a | Effect of Temperature on Oil Recovery from Cottonseeds during EAAE | 102 |
| 4.1.2b | Effect of pH on Oil Recovery from Cottonseeds during EAAE | 102 |
| 4.1.2c | Effect of Water/Seed Ratio (w/w) on Oil Recovery from Cottonseeds during EAAE | 103 |
| 4.1.2d | Effect of Hydrolysis Time on Oil Recovery from Cottonseeds during EAAE | 103 |
| 4.1.2e | Effect of Enzyme Concentration on Oil Recovery from Cottonseeds during EAAE | 104 |
| 4.1.2f | Enzymes Offering Optimum Oil Recovery from Cottonseeds during EAAE | 104 |
| 4.2.1a | Effect of Temperature on Oil Recovery from Hempseed during EACP | 105 |
| 4.2.1b | Effect of pH on Oil Recovery from Hempseed during EACP | 105 |
| 4.2.1c | Effect of Temperature on Oil Recovery from Hempseed during EACP | 106 |
| 4.2.1d | Effect of Hydrolysis Time on Oil Recovery from Hempseed during EACP | 106 |
| 4.2.1e | Effect of Enzyme Concentration on Oil Recovery from Hempseed during EACP | 107 |
| 4.2.1f | Enzymes Offering Optimum Oil Recovery from Hempseeds during EACP | 107 |
| 4.2.2a | Effect of Temperature on Oil Recovery of Hempseeds during EAAE | 108 |
| 4.2.2b | Effect of pH on Oil Recovery of Hempseeds during EAAE | 108 |
| 4.2.2c | Effect of Water/Seed Ratio (w/w) on Oil Recovery of Hempseeds during EAAE | 109 |

| | | |
|--------|--|-----|
| 4.2.2d | Effect of Hydrolysis Time on Oil Recovery of Hempseeds during EAAE | 109 |
| 4.2.2e | Effect of Enzyme Concentration on Oil Recovery of Hempseeds during EAAE | 110 |
| 4.2.2f | Enzymes Offering Optimum Oil Recovery from Hempseeds during EAAE | 110 |
| 4.3.1a | Effect of Temperature on Oil Recovery from Sunflower Seeds during EACP | 111 |
| 4.3.1b | Effect of pH on Oil Recovery from Sunflower Seeds during EACP | 111 |
| 4.3.1c | Effect of Moisture on Oil Recovery from Sunflower Seeds during EACP | 112 |
| 4.3.1d | Effect of Hydrolysis Time on Oil Recovery from Sunflower Seeds during EACP | 112 |
| 4.3.1e | Effect of Enzyme Concentration on Oil Recovery from Sunflower Seeds during EACP | 113 |
| 4.3.1f | Enzymes Offering Optimum Oil Recovery from Sunflower Seeds during EACP | 113 |
| 4.3.2a | Effect of Temperature on Oil Recovery of Sunflower Seeds during EAAE | 114 |
| 4.3.2b | Effect of pH on Oil Recovery from Sunflower Seeds during EAAE | 114 |
| 4.3.2c | Effect of Water/Seed Ratio (w/w) on Oil Recovery from Sunflower Seeds during EAAE | 115 |
| 4.3.2d | Effect of Hydrolysis Time on Oil Recovery from Sunflower Seeds during EAAE | 115 |
| 4.3.2e | Effect of Enzyme Concentration on Oil Recovery from Sunflower Seeds during EAAE | 116 |
| 4.3.2f | Enzymes Offering Optimum Oil Recovery from Sunflower Seeds during EAAE | 116 |
| 4.4.1a | Effect of Temperature on Oil Recovery from Sesame Seeds during EACP | 117 |
| 4.4.1b | Effect of pH on Oil Recovery from Sesame Seeds during EACP | 117 |
| 4.4.1c | Effect of Moisture on Oil Recovery from Sesame Seeds during EACP | 118 |
| 4.4.1d | Effect of Hydrolysis Time on Oil Recovery from Sesame Seeds during EACP | 118 |
| 4.4.1e | Effect of Enzyme Concentration on Oil Recovery from Sesame Seeds during EACP | 119 |
| 4.4.1f | Enzymes Offering Optimum Oil Recovery from Sesame Seeds during EACP | 119 |
| 4.4.2a | Effect of Temperature on Oil Recovery of Sesame Seeds during EAAE | 120 |
| 4.4.2b | Effect of pH on Oil Recovery of Sesame Seeds during EAAE | 120 |
| 4.4.2c | Effect of Water/Seed Ratio (w/w) (w/w) on Oil Recovery of Sesame Seeds during EAAE | 121 |
| 4.4.2d | Effect of Hydrolysis Time on Oil Recovery from Sesame Seeds during EAAE | 121 |

| | | |
|--------|---|-----|
| 4.4.2e | Effect of Enzyme Concentration on Oil Recovery of Sesame Seeds during EAAE | 122 |
| 4.4.2f | Enzymes Offering Optimum Oil Recovery from Sesame Seeds during EAAE | 122 |
| 4.5.1a | Effect of Temperature on Oil Recovery from Canola Seeds during EACP | 123 |
| 4.5.1b | Effect of pH on Oil Recovery from Canola Seeds during EACP | 123 |
| 4.5.1c | Effect of Moisture on Oil Recovery from Canola Seeds during EACP | 124 |
| 4.5.1d | Effect of Hydrolysis Time on Oil Recovery from Canola Seeds during EACP | 124 |
| 4.5.1e | Effect of Enzyme Concentration on Oil Recovery from Canola Seeds during EACP | 125 |
| 4.5.1f | Enzymes Offering Optimum Oil Recovery from Canola Seeds during EACP | 125 |
| 4.5.2a | Effect of Temperature on Oil Recovery from Canola Seeds during EAAE | 126 |
| 4.5.2b | Effect of pH on Oil Recovery from Canola Seeds during EAAE | 126 |
| 4.5.2c | Effect of Water/Seed Ratio (w/w) on Oil Recovery from Canola Seeds during EAAE | 127 |
| 4.5.2d | Effect of Hydrolysis Time on Oil Recovery from Canola Seeds during EAAE | 127 |
| 4.5.2e | Effect of Enzyme Concentration on Oil Recovery from Canola Seeds during EAAE | 128 |
| 4.5.2f | Enzymes Offering Optimum Oil Recovery from Canola Seeds during EAAE | 128 |
| 4.6.1a | Effect of Temperature on Oil Recovery from <i>Moringa oleifera</i> Seeds during EACP | 129 |
| 4.6.1b | Effect of pH on Oil Recovery from <i>Moringa oleifera</i> Seeds during EACP | 129 |
| 4.6.1c | Effect of Moisture on Oil Recovery from <i>Moringa oleifera</i> Seeds during EACP | 130 |
| 4.6.1d | Effect of Hydrolysis Time on Oil Recovery from <i>Moringa oleifera</i> Seeds during EACP | 130 |
| 4.6.1e | Effect of Enzyme Concentration on Oil Recovery from <i>Moringa oleifera</i> Seeds during EACP | 131 |
| 4.6.1f | Enzymes Offering Optimum Oil Recovery from <i>Moringa oleifera</i> Seeds during EACP | 131 |
| 4.6.2a | Effect of Temperature on on Oil Recovery from <i>Moringa oleifera</i> Seeds during EAAE | 132 |
| 4.6.2b | Effect of pH on Oil Recovery from <i>Moringa oleifera</i> Seeds during EAAE | 132 |
| 4.6.2c | Effect of Water/Seed Ratio (w/w) on Oil Recovery from <i>Moringa oleifera</i> Seeds during EAAE | 133 |
| 4.6.2d | Effect of Hydrolysis Time on Oil Recovery from <i>Moringa oleifera</i> Seeds during EAAE | 133 |

| | | |
|--------|---|-----|
| 4.6.2e | Effect of Enzyme Concentration on Oil Recovery from <i>Moringa oleifera</i> Seeds during EAAE | 134 |
| 4.6.2f | Enzymes Offering Optimum Oil Recovery from <i>Moringa oleifera</i> Seeds during EAAE | 134 |
| 4.7.1 | Typical GLC Chromatogram Showing the Separation of FAs of Enzyme-assisted Aqueous Extracted Sunflower Oil | 135 |
| 4.7.2 | Typical GLC Chromatogram Showing the Separation of FAs of Enzyme-assisted Cold Pressed Canola Oil | 135 |
| 4.7.3 | Typical HPLC Chromatogram Showing the Separation of Tocopherol Standards | 136 |
| 4.7.4 | Typical HPLC Chromatogram Showing the Separation of Tocopherols of Enzyme-assisted Cold Pressed Hempseed Oil | 136 |
| 4.7.5 | Typical HPLC Chromatogram Showing the Separation of Tocopherols of Enzyme-assisted Cold Pressed Canola Seed Oil | 137 |
| 4.7.6 | Typical Rancimat Profile Showing Rancimat Analysis of Enzyme-assisted Cold Pressed Cottonseed Seed Oil | 137 |
| 4.7.7 | Typical Rancimat Profile Showing Rancimat Analysis of Enzyme-assisted Aqueous Extracted sesame seed oil | 138 |