" DEVELOPMENT OF CHITOSAN-SODIUM ALGINATE-BASED NANO-BIO-COMPOSITE FILMS INCORPORATED WITH OLIVE OIL"

A PROJECT REPORT

BY

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Submitted to the Department of Nutrition and Food Engineering in the partial fulfillment of B.Sc. in Nutrition and Food Engineering

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MAY 2024

APPROVAL

The internship titled "**Development of Chitosan-sodium alginate-based Nano-bio-composite films incorporated with olive oil**," submitted by Jannatul Zinia to Daffodil International University's Department of Nutrition and Food Engineering, is hereby approved for meeting the required standards and academic criteria set forth by the department and the university. This approval acknowledges the student's diligent effort and comprehensive analysis within the scope of this research.

EXAMINING COMMITTEE

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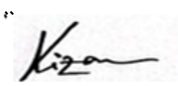

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DECLARATION

I, Jannatul Zinia, hereby confirm that the internship paper titled **“**Development of Chitosan-sodium alginate-based Nano-bio-composite films incorporated with olive oil**”** is an original work conducted under the supervision of Dr. Nizam Uddin, Associate Professor and Head of the Nutrition and Food Engineering Department, Daffodil International University. This work has not been submitted elsewhere for any other academic reward.

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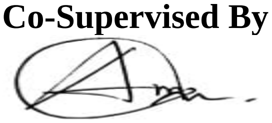

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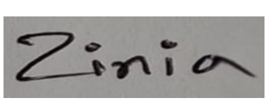

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ACKNOWLEDGEMENT

I extend my deepest gratitude to Allah, the most gracious and merciful, for blessing me with the strength, patience, and guidance necessary to complete this internship paper.

My heartfelt thanks go to my supervisor, Dr. Nizam Uddin, Associate Professor and Head of the Department of NFE at Daffodil International University, for his invaluable advice, continuous support, and encouragement throughout this project. His expertise and insights have been crucial in shaping this research.

I am also immensely grateful to my co-supervisor, Abu Saeid, Lecturer (Senior Scale) in the Department of NFE, for his guidance, constructive feedback, and for always being available to discuss ideas and solve problems.

My sincere appreciation is extended to Bangladesh Atomic Energy Commission and its staff for their support and for providing necessary facilities and environment to conduct this research. A special thank you to Dr. Md. Al-Mamun, Principal Scientific Officer, Bangladesh Atomic Energy Commission, for his guidance, patience, and for sharing her vast knowledge and experience with me.

Lastly, I extend profound thanks to my parents for their unwavering support and enduring patience.

ABSTRACT

This research focuses on the creation of chitosan-sodium alginate-based nano-bio-composite films integrated with olive oil to overcome the current limitations in mechanical properties, biodegradability, and antimicrobial activity of bio-composite materials. Targeting applications like food packaging, these films leverage the biocompatible and biodegradable nature of chitosan and sodium alginate, with olive oil acting as a plasticizer to enhance flexibility, durability, and water barrier properties. The study aims to synthesize nano-bio-composite films to improve mechanical strength and examining the effects of olive oil on their flexibility, barrier properties, and antimicrobial activity. This innovation addresses the need for biodegradable materials with specific performance criteria, especially in sectors like food preservation, biomedical applications, and environmental sustainability. The comparative analysis of the two sample compositions reveals: The T-sample exhibited a tensile strength of 4.2 MPa and elongation at break of 16.2%, indicating a formulation that is stronger and more flexible. The O-Sample showed a tensile strength of 3.3 MPa and elongation at break of 13.1%, suggesting a compromise in mechanical properties due to the addition of sodium alginate and calcium chloride. The findings indicate that olive oil is an effective plasticizer for chitosan-sodium alginate-based nano-bio-composite films, significantly improving their performance. However, the addition of sodium alginate and calcium chloride in the O-sample compromises its mechanical properties, demonstrating the need for a balanced formulation. Further research on sodium-alginate based nano-bio-composite films incorporated with olive oil could delve into optimizing the formulation for its improved barrier properties and antimicrobial efficacy. Future studies should consider the impact of various olive oil concentrations on the physical and chemical characteristics of the films. Investigating the potential for incorporating natural antioxidants and antimicrobials from other sources could also enhance the films applicability in food preservation and medical fields. Additionally, life cycle assessments to evaluate the environmental sustainability of these films alongside consumer acceptance studies, would be essential for their successful market introduction and broader application.

Keywords: Chitosan, Sodium alginate, Nano-bio-composite films, Olive oil, Biopolymer films, Anti-microbial properties, Food packaging, Bioactive compounds.

TABLE OF CONTENTS

LIST OF TABLES

LIST OF FIGURES

LIST OF FLOW CHARTS

CHAPTER 1

INTRODUCTION

1.1 Introduction

The increasing urgency to address environmental sustainability has propelled the development of bio-composite materials across several industries, including packaging, medical, and construction. Among the wide array of bio-based polymers, chitosan and sodium alginate stand out due to their biocompatibility, biodegradability and versatile functional properties. Chitosan, sourced from chitin- the second most abundant natural polymer- boasts exceptional film-forming abilities, antimicrobial properties, and a reactive surface amenable to chemical modifications. Sodium alginate, extracted from brown seaweed, is celebrated for its gel-forming capabilities when interacting with divalent cations, it's biocompatibility, and it's processing ease (Lee et al., 2022). However, despite these promising attributes the development of bio-composite materials that fully harness the potential of these biopolymers remains an area ripe for exploration.

Despite the progress in bio-composite research, there exists a gap in the development of materials that seamlessly integrate biopolymer benefits with enhancements in mechanical and barrier properties for specialized applications. Previous studies have demonstrated the potential of combining chitosan and sodium alginate to create bio-composite films with improved mechanical and biological fluctuations (Green et al., 2020). However, there remains a critical need to further enhance these materials' flexibility, durability and moisture barrier properties, particularly for applications in food packaging where such characteristics are essential. This research aims to bridge this gap by incorporating olive oil into chitosan-sodium alginate-based nano-bio-composite films, leveraging the oil's plasticizing effects and hydrophobic nature to meet these needs.

The incorporation of Olive oil into chitosan-sodium alginate bio-composites introduces a novel dimension to the materials' properties. Olive oil, with its high content of monounsaturated fats and antioxidants, not only acts as a plasticizer, enhancing the flexibility and durability of the films, but also improves their water barrier properties due to its hydrophobic nature. This notification holds significant premise for food packaging applications, where controlling moisture is crucial. Furthermore, the antioxidant properties of olive oil imbue the bio-composite films with enhanced antimicrobial and preservative qualities, extending the shelf life of packaged products (O'Donnell et al., 2021).

This research on the development of chitosan-sodium alginate-based nano-bio-composite films incorporated with olive oil signifies a crucial advancement in bio-composite technology. By combining the biological and mechanical benefits of chitosan and sodium alginate with the functional advantages of olive oil, this work presents a sustainable alternative to conventional synthetic polymers. The study not only fills a significant gap in the current bio-composite landscape but also aligns with global sustainability goals by offering environmentally friendly, biodegradable, and functionally superior materials. As such, this research contributes to the broader effort of advancing sustainable material science, promising to revolutionize industries with green, efficient alternatives (Smith et al., 2023).

1.2 Research Problem/Limitations

The quest for sustainable materials has led to the development of bio-composite films, which offer eco-friendly alternatives to synthetic polymers. However, these bio-composites often encounter significant limitations in terms of mechanical properties, biodegradability, and antimicrobial activity, which restrict their application in areas demanding high durability, efficient degradation, and stringent hygiene standards (Smith et al., 2020).

1. **Mechanical properties:** Many existing bio-composite films while eco-friendly, often suffer from suboptimal mechanical strength and flexibility compared to synthetic alternatives. This limitation restricts their application in scenarios that demand high durability and resilience, such as in robust packaging solutions or in medical devices where material integrity is crucial (Johnson et al., 2019).
2. **Biodegradability:** While bio-composites are generally more biodegradable than synthetic polymers, the rate and extent of their biodegradation can vary widely. Some bio-composite films do not degrade as efficiently as desired, potentially leading to accumulation in the environment. This variability can be distributed to the composition and structure of the bio-composites, which may not always favor rapid and compete breakdown (Lee et al., 2021).
3. **Antimicrobial Activity**: Antimicrobial properties are essential for applications in food packaging and medical implants to prevent microbial growth and ensure safety and longevity. However, not all bio-composite films exhibit sufficient antimicrobial activity against a broad spectrum of microorganisms. Enhancing this aspect could significantly broaden the utility of bio-composite materials in critical areas that require stringent hygiene and safety standards (Patel et al., 2018).

To surmount these challenges, this study purposes an innovative approach in the composition and processing of bio-composite films. By integrating Olive oil into chitosan-sodium alginate-based nano-bio-composites, we aim to enhance their mechanical properties, biodegradability and antimicrobial activity. Olive oil is posited to improve the flexibility and toughness of the films, thereby addressing the mechanical limitations (Garcia et al., 2022). Furthermore, the alteration in chemical structure and physical properties, induced by olive oil, is expected to facilitate microbial breakdown, enhancing biodegradability. Lastly, olive oil's inherent antimicrobial compounds are anticipated to augment the antimicrobial efficacy of the bio-composite films, offering a natural means to combat microbial proliferation (Khan et al., 2020).

1.3 Objectives of the Study

The study sets forth two primary objectives aimed at advancing the field of bio-composite materials:

1. To develop Chitosan-Sodium Alginate-based Nano-bio-composite films by synthesizing thus eco-friendly, biodegradable films at the nanoscale to improve their qualities of a traditional materials.
2. To investigate the effects of incorporating olive oil into these films to enhance their flexibility, barrier properties and antimicrobial activity through various tests, aiming to optimize olive oil addition for better film performance.

CHAPTER 2

LITERATURE REVIEW

2.1 Literature review

Bio-composite films especially those derived from natural polymers like Chitosan and sodium alginate have gained significant attention for their potential in sustainable food packaging. Chitosan, in natural polysaccharide derived derived from chitin and sodium alginate extracted from Brown seaweed, are known for their biocompatibility, biodegradability and film-forming abilities. When combined, these material can from nano-bio-composite films with enhanced mechanical and barrier properties. Incorporation of Olive oil into their films can further improve their functionality by adding antimicrobial and antioxidant properties, which are crucial for extending the shelf life for food products (Lee et al., 2022).

Chitosan and sodium alginate bio composite films incorporated nano-fillers and active agents like olive oil to enhance their physical, mechanical and bioactive properties. The preparation of these films typically involves dissolving chitosan and sodium alginate in appropriate solvents, blending them with olive oil at the nano-scale and then casting the solution into films. Researchers employ various techniques to characterize the films, including scanning electron microscope for morphological analysis, tensile strength testing for mechanical properties and barrier property assessments for their efficiency in food preservation (Smith et al., 2023).

Chitosan and Sodium Alginate in Bio-Composites

Properties, Benefits and Common applications: Chitosan and sodium alginate are polysaccharides widely recognized for their biocompatibility, biodegradability and non-toxicity making them ideal components in bio-composite materials. Chitosan, derived from chitin, has excellent film-forming abilities, antimicrobial properties and can be chemically modified to enhance its functionality. Sodium alginate, extracted from brown seaweed, is known for its gel forming capabilities in the presence of divalent cations and its ability to create strong, and flexible films. Together, these polymers are used in various applications including wound dressings, drug delivery systems, and food packaging, due to their barrier properties against oxygen and carbon dioxide (Kumar et al., 2017). The combination of Chitosan and sodium alginate in bio-composites leverages the mechanical strength of Chitosan and moisture retention ability of alginate making them ideal for diverse environmental and biomedical applications.

Nano Bio-Composites

Nano-bio-composites are materials that incorporate nanoparticles into a biopolymer matrix, resulting in enhanced mechanical, thermal and barrier properties compared to conventional materials. The incorporation of nanoparticles can significantly improve the functionality of bio-composites, including increased tensile strength, ultraviolet resistance and antimicrobial activity. This makes them particularly appealing for applications in packaging, biomedical devices, and environmental protection. The use of bio-based nanoparticles nanocomposites aligns with the growing demand for sustainable and ecofriendly materials (Rhim et al., 2013).

Nano-bio-composites are materials that incorporate nanoparticles into bio-polymer matrices enhancing physical, mechanical, and barrier properties beyond what is achievable with the conventional composites (Pandey et al., 2012). The incorporation of nanoparticles into Chitosan and sodium alginate matrices can significantly improve tensile strength, thermal stability and antimicrobial activity. These nano-enhanced materials offer potential for advanced packaging solutions that require biodegradability and robustness, addressing environmental concerns associated with synthetic polymers.

Nano-bio-composites incorporate nanoscale fillers or reinforcements into a biopolymer matrix, improving the material's mechanical, thermal, and barrier properties beyond what is possible with traditional traditional composites. These materials offer significant advantages of her conventional materials, including reduced use of non-renewable resources, lower carbon footprint and enhanced end-of-life options, such as biodegradability and compostability (Pandey et al., 2010). Their development aligns with the increasing demand for sustainable material options across industries.

Role of olive oil in Bio-Composites

Olive oil has been studied for its role as a natural plasticizer and antimicrobial agent in bio-composite films. The incorporation of Olive oil can improve the flexibility, tensile strength and elongation at break of bio-composite films, making them more suitable for packaging applications that require durable yet flexible materials. Furthermore, olive oil contains phenolic compounds known for their antioxidant and antimicrobial activities, which can extend the shelf life of packaged goods by preventing oxidation and microbial growth (Jouki et al., 2014).

Olive oil, a natural and biodegradable oil, has been studied for its dual role as a plasticizer and an antimicrobial agent in bio-composite films (Zhang et al., 2014). The incorporation of olive oil can enhance the flexibility and workability of the bio-composite films, which its natural anti-oxident and antimicrobial compounds, such as polyphenols, contribute to the preservation qualities of the packaging, extending the shelf life of food products.

Olive oil has been explored in bio-composite films for its dual role as a plasticizer and antimicrobial agent. The incorporation of olive oil can improve the flexibility and workability of bio-composite films while offering antimicrobial properties against a broad spectrum of pathogens, which is particularly beneficial for food packaging applications (Zhang et al., 2017). Studies have shown that olive oil enriched bio-composites can extend the shelf life for food products by inhibiting microbial growth and enhancing the barrier properties of the packaging material.

Despite the promising attributes of chitosan and sodium alginate nano-bio-composites incorporated with olive oil, research gaps remain. These include optimizing the concentration of olive oil for balanced mechanical and antimicrobial properties, understanding the long-term stability of those composite under various environmental conditions, and scaling up the production process while maintaining cost efficiency and product consistency. Further investigation is needed to explore the full potential of this composite in specific applications, such as in the biomedical field for drug delivery systems or in sustainable packaging solutions that meet both functional and environmental criteria. The impact of nano-fillers on the recyclability and safety of the bio-composite materials, especially when used in food packaging. Comprehensive lifecycle assessments of these bio-composites to evaluate their environmental benefits over conventional plastic films. Addressing these gaps could further the application of Chitosan and sodium alginate based nano bio-composite films in sustainable packaging and beyond.

Significance of the Study

The significance of the study on the development of chitosan-sodium alginate-based nano bio-composite films incorporated with olive oil spans several critical areas, including food packaging, biomedical applications and environmental sustainability. This research holds the promise of delivering innovative solutions that can significantly impact these fields by providing sustainable, biodegradable and functional materials. Below is an expanded discussion on the significance of this study across these domains:

Food Packaging

- **Enhanced Food Preservation**: The incorporation of olive oil into Chitosan-sodium alginate films could lead to materials with improved barrier properties against oxygen and moisture, which are critical factors in food spoilage. These enhanced properties can help in extending the shelf life of perishable goods, thereby reducing food waste.
- **Improved Safety and Quality**: The antimicrobial properties of chitosan potentially augmented by olive oil, can inhibit the growth of foodborne pathogens, ensuring safer food products. Additionally, the antioxidant properties of olive oil could help preserve the nutritional quality of food by preventing oxidation.
- **Sustainability**: By replacing conventional petroleum-based packaging materials with biodegradable bio-composite films, the study contributes to reducing plastic waste and its environmental footprint, aligning with global sustainability goals.

Biomedical Fields

- **Wound Dressings and Tissue Engineering**: The biocompatibility and antimicrobial activity of chitosan-sodium alginate films make them suitable for applications such as wound dressings, which can accelerate healing and prevent infections. Furthermore, their mechanical properties can be turned to mimic tissue, supporting their use in tissue engineering.
- **Drug Delivery Systems**: These nano bio-composite films could be engineered to control the release of drugs, offering a platform for creating more efficient drug delivery systems. This could be particularly beneficial for topical treatments, where controlled release can enhance therapeutic outcomes.

Environmental Sustainability

- **Reduction of Plastic Pollution**: The development of fully biodegradable bio-composite films addresses one of the most pressing environmental issues: plastic pollution. By providing a viable alternative to non-degradable plastics, this research supports efforts towards cleaner oceans and landscapes.

- **Resource Efficiency**: Utilizing renewable resources like chitosan (derived from crustacean shells), sodium alginate (extracted from seaweed), and olive oil (a byproduct of olive processing) for material production promotes the efficient use of natural resources and supports circular economy principles.

- **Energy Conservation**: The production processes of bio-composite materials often require less energy compared to conventional plastics, contributing to overall energy conservation and reducing the carbon footprint associated with material production

The development of Chitosan sodium alginate-based nano-bio-composite films incorporated with olive oil presents a promising avenue for creating sustainable, biodegradable and functional materials. These composites leveraged the unique properties of natural polymers and nano fillers to overcome the limitations of traditional materials. However, Continued research is necessary to optimize their properties and evaluate their environmental impact comprehensively.

CHAPTER 3

METHODOLOGY

3.1 Material and Chemical Reagents

Materials:

Olive oil: As a key ingredient for incorporation into the nano-bio-composite films.

Glycerol: Used as a plasticizer to improve the flexibility and physical properties of the composite films.

Distilled Water: Utilized as a solvent in various stages of the preparation and processing of the composite films.

Chemical Reagents:

Hydrochloric Acid (HCl): Often used for pH adjustment or as a catalyst in certain reactions during the film preparation processes.

Sodium Hydroxide (NaOH): May be used for pH adjustment, specification, or other chemical modifications during the preparation process.

Acetic Acid: Typically used to solubilize chitosan, as chitosan is soluble in acidic solution, facilitating film formation.

Calcium Chloride (CaCl2): Might be used in cross linking processes, particularly with sodium alginate, to form gel-like structures or to enhance the mechanical properties of the film.

Tannic Acid: Could be employed as a natural cross-linker or to impart additional functional properties to the films, such as antioxidant activity.

Glutaraldehyde: A cross linking agent used to improve the mechanical strength and water resistance of the composite films.

Equipment:

Vacuum Oven: Utilized for drying the films under reduced pressure to prevent bubble formation and ensure uniform film thickness.

Ultrasonic Machine: May be used for the dispersion of nanoparticles or for the homogenization of film-forming solutions.

Petri Dish: Often used as a mold for casting the film-forming solutions before drying and curing.

Laminar Air Flow: Ensures a sterile environment during the preparation of the films, preventing contamination.

3.2 Sample collection and sample preparation

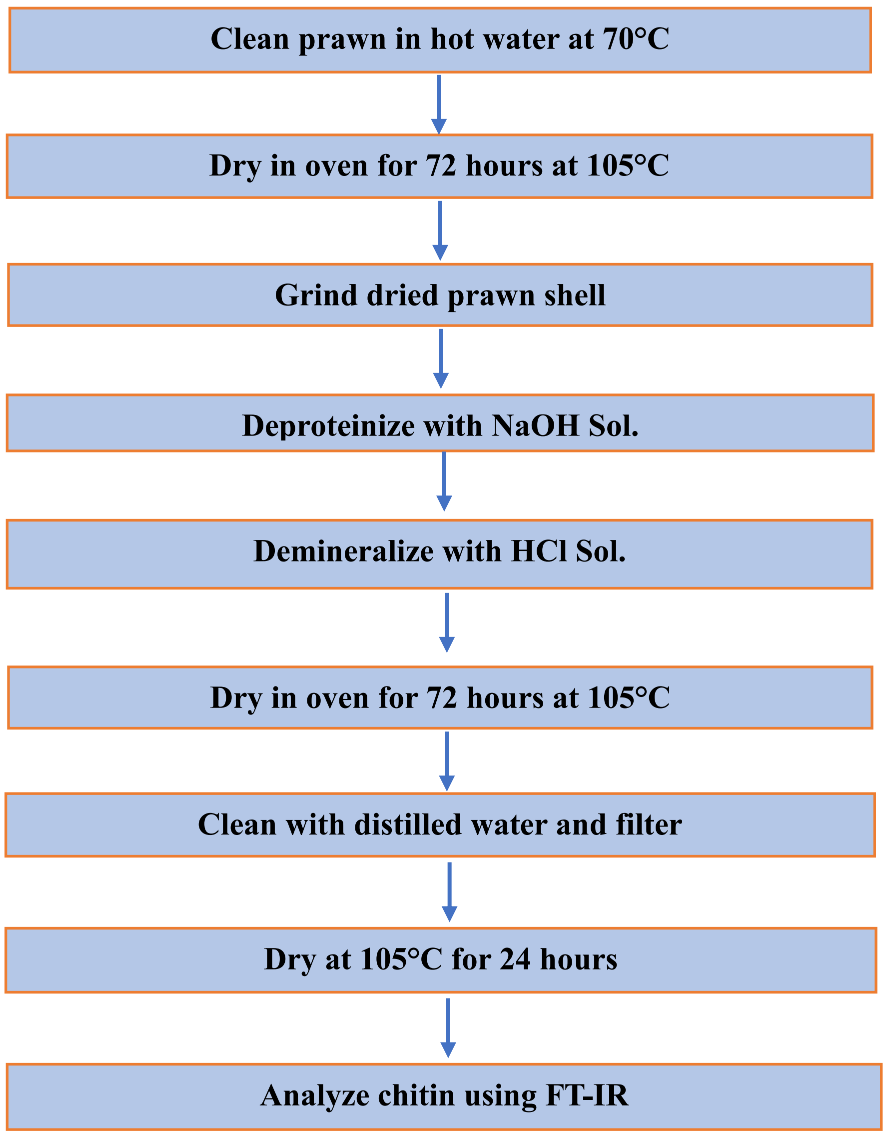
The thesis focuses on the development of nano-bio-composite films utilizing chitosan and sodium alginate, Incorporating olive oil as a functional element. The fundamental component for our study, chitosan, is derived from the shells of prawns. These shells are collected meticulously from local markets, ensuring a sustainable and readily available source. The initial phase involves the separation of the shells from the prawn meat, which is executed with the precision to ensure the integrity of the shells for subsequent processing. Following this initial step, the shells undergo a transformation process where chitin is first extracted. This extracted chitin serves as the precursor in the subsequent production of chitosan, which is the fundamental component used in crafting the nano-bio-composite films. This methodical approach to sample preparation underscores the innovative recycling of seafood waste towards the development of advanced material solutions.

Source Materials: Prawn Shells

Collection Site: Local Markets

Preparation method of Chitosan

A) process of prawn shell to chitin:

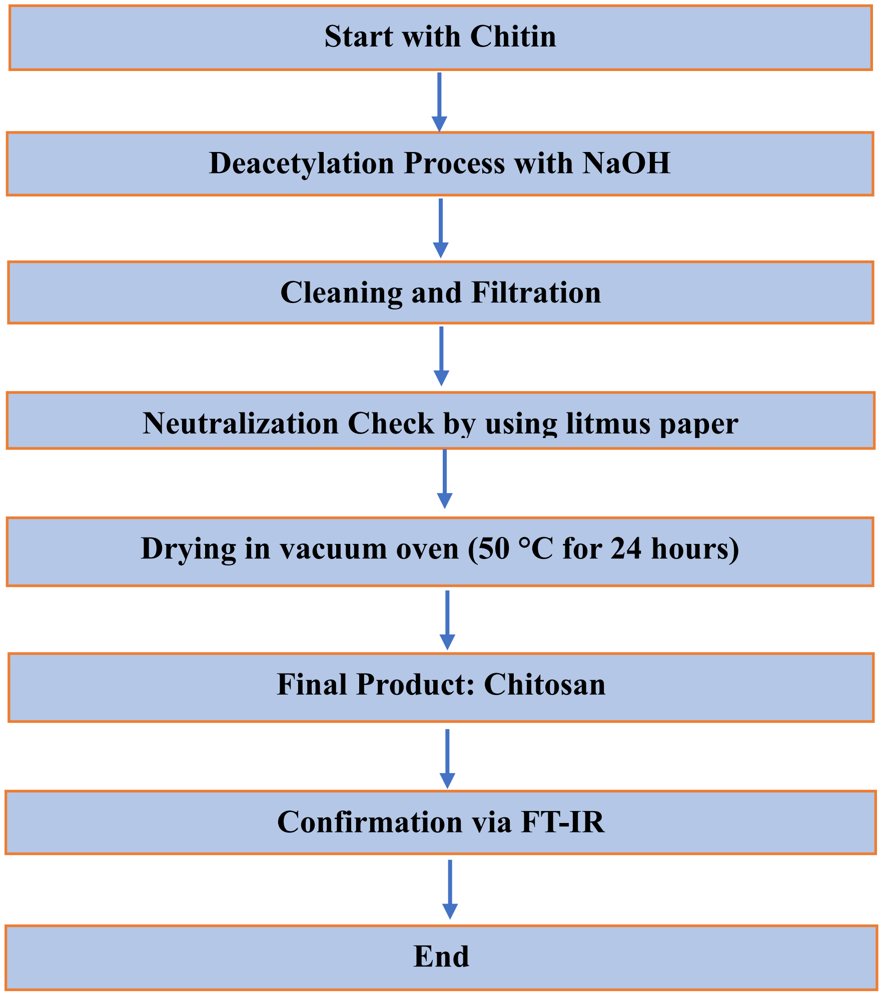


Flow diagram 3.1: Preparation of Prawn shell to Chitin

Initially, the prawn was cleaned in hot water at 70 degrees centigrade and then dried in an oven for 72 hours at 105 degrees centigrade. Dried prawn shell was grinded and then used it for deproteinized with 1N NaOH solution at boiling temperature 100 degree centigrade for 4 hours. (Prawn shell: NaOH=1: 16, w/v). After then used it for demineralized with 1N HCl solution at boiling temperature 100 degree centigrade for 4 hours. (Prawn shell: HCl=1: 13, w/v). The mixture was then cleaned with distilled water and then filtered it. Then the product was dried at 105 degrees centigrade for 24 hours and found an intermediate product of chitin. For confirmation, Chitin was analyzed using FT-IR.

Figure 3.1: Prawn Shell

B) Process of Chitin to Chitosan

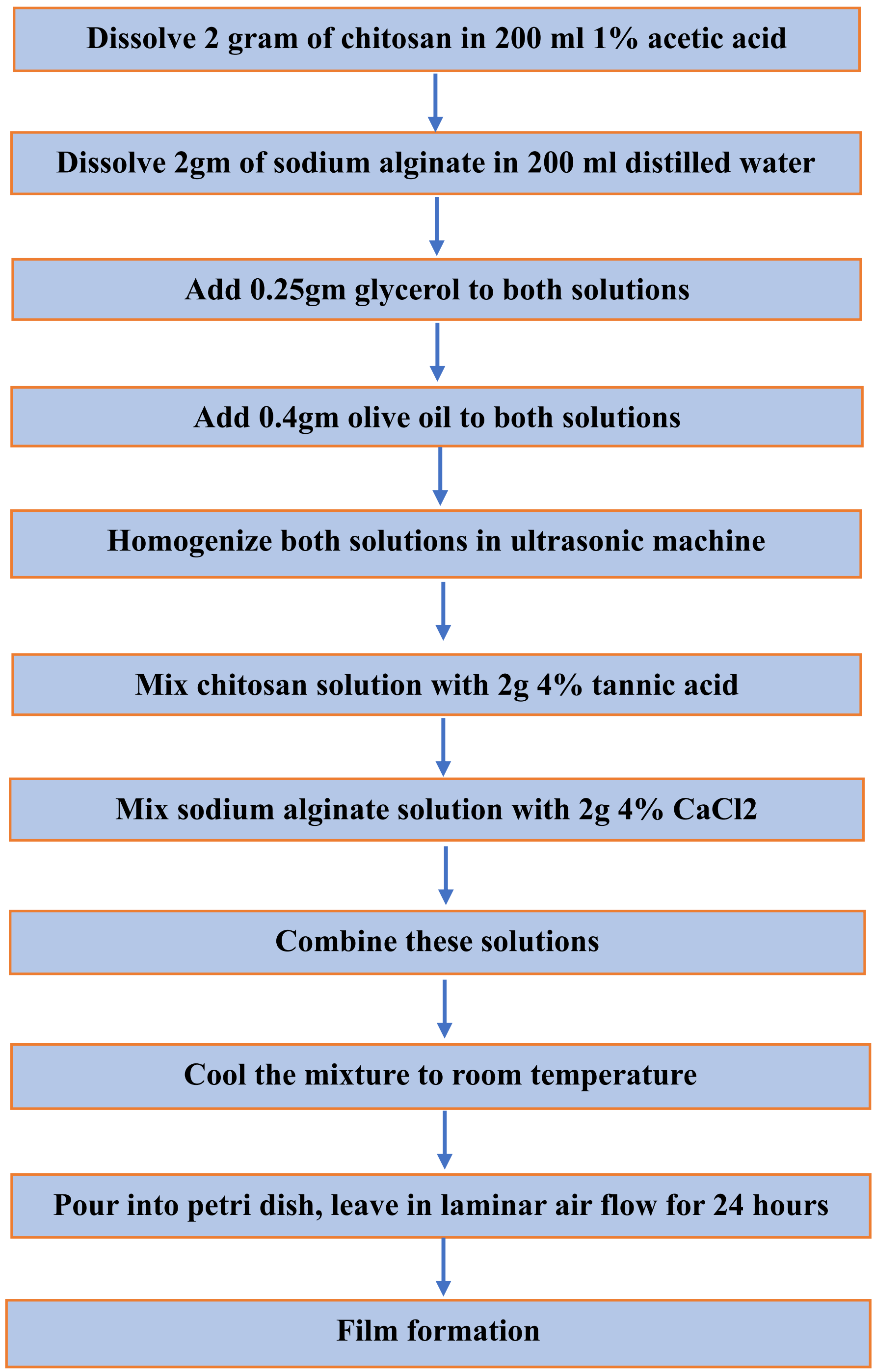


Flow diagram 3.2: Preparation of Chitin to Chitosan

Chitin is used for deacetylation with 1N NaOH solution at boiling temperature 100 degree centigrade for 4 hours. (Chitin: NaOH=1:20, w/w solid state ratio). After that mixture was then cleaned with distilled water and filtered it so that solid was separated from Alkali and removed the traces of NaOH with distilled water. (Used litmus paper for neutralization check). Then the product was dried at 50 degree centigrade for 24 hours in a Vacuum oven and formed the final product of chitosan. For confirmation, Chitosan was analyzed using FT-IR.

Figure 3.2: Chitosan

3.3 Preparation method of Alginate based chitosan films:



Flow diagram 3.3: Preparation of Alginate based chitosan films

To create chitosan and film forming solution (1% w/v), 2 gram of chitosan was dissolved in 200 ml 1% acetic acid solution (v/v) which was continuously stirred for 12 hours at 60 degrees centigrade. In the meantime, 2gm of sodium alginate was dissolved in 200 ml distilled water, which was then continuously stirred for 3 hours at 35 degrees centigrade. Next, 0.25 gm of Glycerol were mixed equally to the chitosan and sodium alginate solution. Then 0.4 gram of olive oil were mixed equally to the chitosan and sodium alginate solution. Each of the mixed solution was homogenized separately in the ultrasonic machine for 20 minutes. Then, Chitosan solution was mixed by two gm 4% tannic acid (w/v) solution and at the same time sodium alginate solution was mixed by two grams of 4% Cacl2 (w/v) solution. Each of the mixed solution was homozygous separately as previous in the ultrasonic machine for 20 minutes. Next, the separate solutions of chitosan and sodium alginate were combined according to the instructions. (Citroen to sodium alginate =8:2) then homogenized once more for 20 minutes in the ultrasonic blender. After finishing the well mixing, removing out the final mixing solution and was allowed for cooling at room temperature. After completing the cooldown process, the final mixing solution was poured to the Petri dish to the appropriate level, and it was then left in the laminar air flow for a full day. And lastly, the film had a good form.

Figure 3.3: Mixing process of different reagents

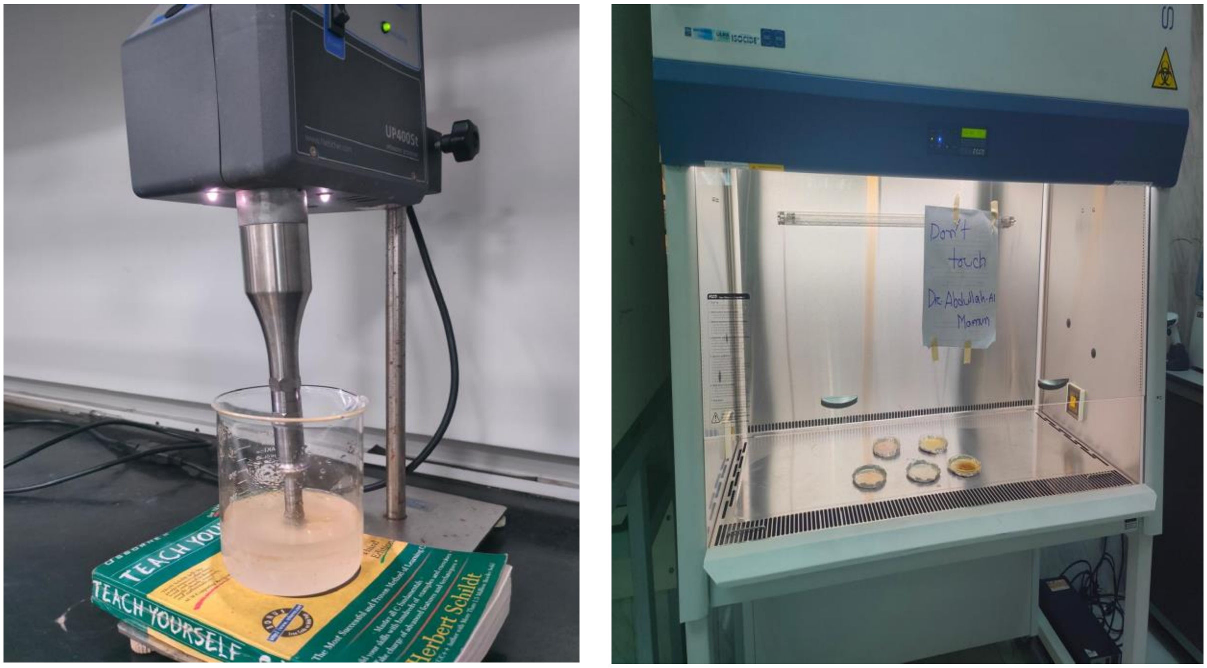


Figure 3.4: Homogenization process and Drying process by Laminar air flow

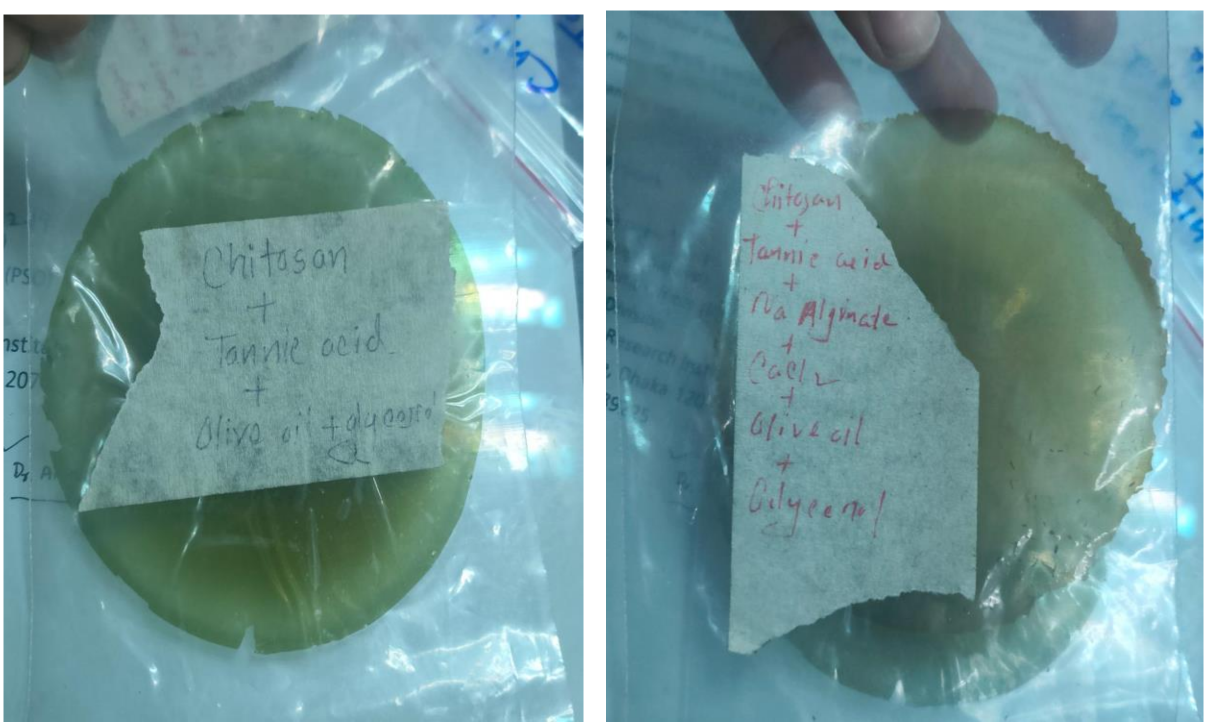


Figure 3.5: Formed films

3.4 Formulation table

Sample 1: Chitosan+ Tannic acid+ Glycerol+ Olive oil
Sample 2: Chitosan+ Glutaraldehyde+ Glycerol+ Olive oil
Sample 3: Na Alginate+ Calcium chloride+ Glycerol+ Olive oil
Sample 4: Chitosan+ Tannic acid+ Na Alginate+ Calcium chloride+ Glycerol+ Olive oil
Sample 5: Chitosan+ Glutaraldehyde+ Na Alginate+ Calcium chloride+ Glycerol+ Olive oil

	Name of Ingredients	**Crosslinking Agents**	**Plasticizer**	**Antimicrobial agents**	**Findings**	**Comments**
01	Chitosan	Tannic acid	Glycerol	Olive oil	Film Formed	Accurately
02	Chitosan	Glutaraldehyde	Glycerol	Olive oil	Not Formed	
03	Sodium Alginate	Calcium Chloride	Glycerol	Olive oil	Not Formed	
04	Chitosan + Sodium Alginate	Tannic acid+ Calcium Chloride	Glycerol	Olive oil	Film Formed	Accurately
05	Chitosan + Sodium Alginate	Glutaraldehyde+ Calcium Chloride	Glycerol	Olive oil	Not Formed	

CHAPTER 4

RESULTS AND DISCUSSION

4.1 FT-IR Spectra of Chitin

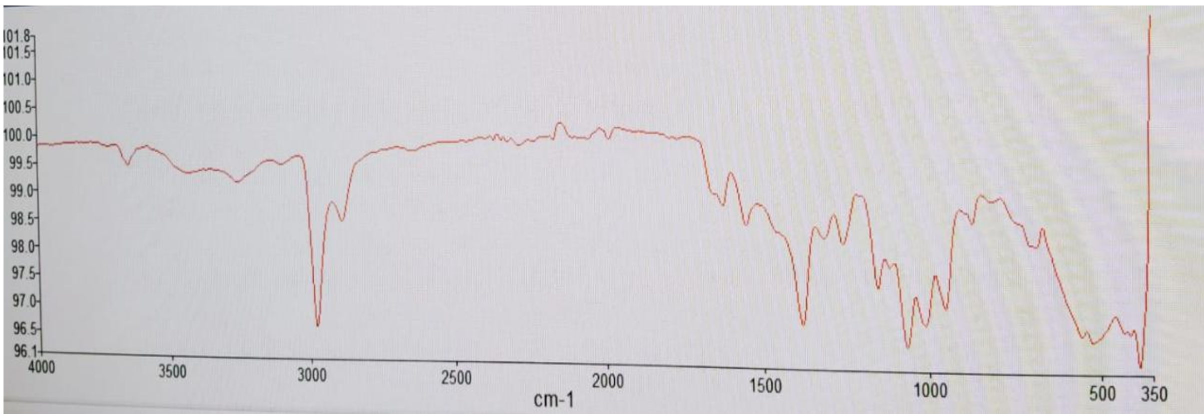


Figure 4.1: FT-IR Spectra of Chitin

This is an FTIR (Fourier-transform infrared) spectrum, which is a plot of infrared light absorbance (or transmittance) on the vertical axis against wavelength on the horizontal axis. The wavenumbers are typically measured in cm^-1 and it represent the frequency of the IR light.

The provided spectrum seems to be that of Chitin. Chitin is a long-chain polymer of N-acetylglucosamine, a derivative of glucose. It is a common component of the exoskeletons of arthopods, such as crustaceans and insects, and the cell walls of fungi. Here are some key points typically observed in the FT-IR Spectrum of Chitin:

Around 3500 cm^-1, we typically observe a broad absorption peak due to the O-H stretching vibrations, which can be associated with hydrogen bonded hydroxyl groups (Dahmane et al., 2014). Just below 3000 cm^-1, C-H stretching vibrations of the -CH2 and -CH3 groups are usually found. In the 1650 cm^-1 area, we see the amide I band due to C=0 stretching vibration in the acetyl groups of N-acetylglucosamine. Near 1550 cm^-1, The amide II band appears due to N-H bending and C-H stretching vibrations. Around 1000-1500 cm^-1, This is a region where we might see C-O-C stretching vibrations charecteristic of polysaccharides like chitin.

4.2 FT-IR Spectra of Chitosan

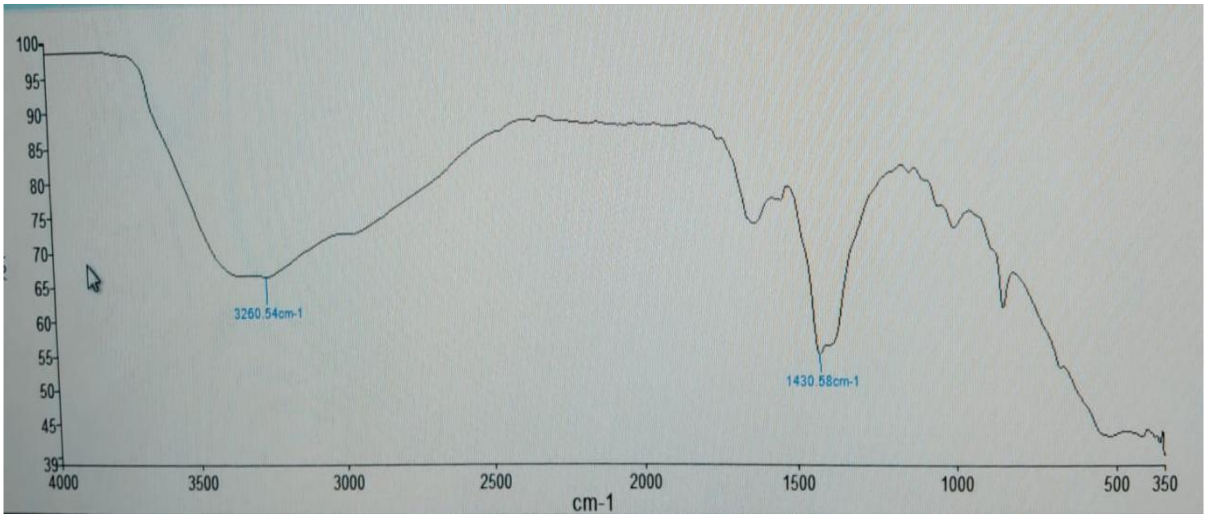


Figure 4.2: FT-IR Spectra of Chitosan

This image shows an FT-IR Spectrum of Chitosan, which is a derivative of chitin. Chitosan is produced by treating chitin shells with an alkaline substance, which leads to the deacetylation of chitin. It's used in many applications including agriculture, medicine, water treatment and food processing due to its biocompatibility, biodegradability, and non-toxicity.

The spectrum displays typical absorption peaks that are characteristic of chitosan's functional groups:

The broad peak starting near 3500 cm^{-1}, stretching down to about 3000 cm^{-1}, suggests the presence of -OH and -NH groups, which is consistent with the hydrogen bonding typically found in the structure of Chitosan. The sharp absorption at 3260 cm^{-1} is indicative of N-H stretching in the amine groups. The peak at around 1430 cm^{-1} could correspond to the bending vibrations of the -OH groups and may also overlap with -CH bending vibrations. Absorptions near 1650 cm^{-1} are typically for amide I bands dur to C=O stretching in residual N-acetyl groups from incomplete deacetylation.

These peaks are characteristic of chitosan's structure, but as with chitin, a precise analysis would involve a comparison with known reference spectra and could be influenced by factors like sample preparation, purity, and molecular weight of the chitosan.

4.3 Results

Table 4.1: Results						
Sample No.	**Thickness**	**Average Thickness**	**Ts (MPa)**	**Ts (MPa) average**	**EB (%)**	**Average EB (%)**
T-Sample	0.1433	0.1433	4.2	4.2	16.2%	16.2%
O-Sample	0.1533	0.1533	3.3	3.3	13.1%	13.1%

T sample composition: Chitosan+ Tannic acid+ Olive oil+ Glycerol

O sample composition: Chitosan+ Tannic acid+ Na Alginate+ $CaCl_2$+ Olive oil+ Glycerol

Basics of Thickness, Tensile strength (Ts) and Elongation at Break (EB):

Thickness: The measurement of how thick a material or layer is, typically measured in millimeters (mm) or micrometers (µm). In the context of films or coatings, thickness can influence the materials strength, flexibility, and transparency.

Tensile strength (Ts): A materials maximum resistance to being stretched or pulled apart before breaking. It is measured in (MPa) or Pounds per square inch (psi) and indicates the materials ability to withstand more stress before breaking.

Elongation at Break (EB): Expressed as a percentage (%), it measures the extent to which a material can be stretched or elongated from its original length before breaking. A higher percentage indicates a more ductile materials capable of stretching more before failure.

4.4 Comparison and Analysis

To compare the two sets of samples, T-sample and O-sample, based on their thickness, tensile strength (Ts) and elongation at break (EB), we can visualize the available data in a single graph. This will allow us to see how the different compositions of the samples Affect their mechanical properties and infer which formulation might be better in terms of performance.

A graph that compare's the Thickness, Tensile strength (Ts) and Elongation at Break (EB) for both T and O samples:

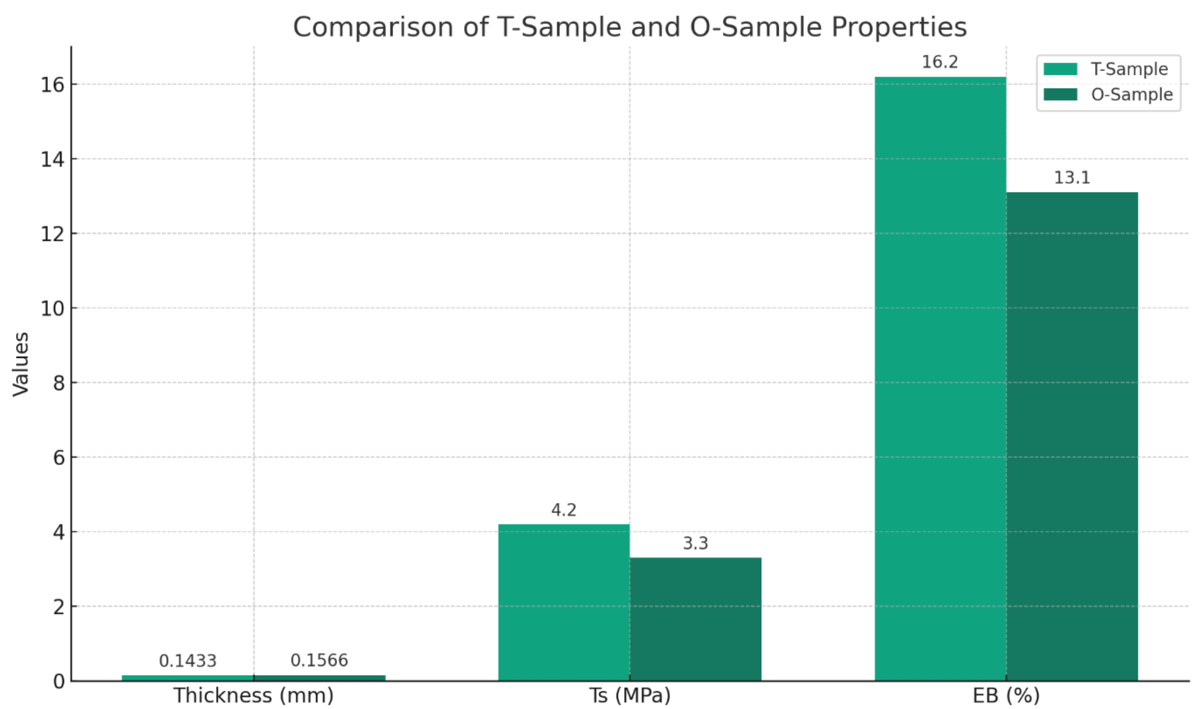


Figure 4.3: Comparison of T-Sample and O-Sample Properties

Higher Ts (MPa) indicates greater tensile strength, suggesting the material can withstand more stress before failing.

Higher EB (%) suggests greater elongation at break, indicating the material is more ductile or flexible before it breaks.

A material that forms a better film could be considered to have a balanced combination of high tensile strength and high elongation at break, indicating it is both strong and flexible.

The graph above compares the Thickness, Tensile Strength (Ts) and Elongation at Break (EB) among the T and O samples based on the available data. Here are some observations and considerations:

T- sample: The T-sample shows an increase in both tensile strength and elongation at break with the thickness of the film. T-Sample, with a thickness of 0.1433 mm, has a higher Ts (4.2 MPa) and EB (16.2%) compared to O-Sample. This indicates that the film's formulation with chitosan, tannic acid, olive oil, and glycerol is effective at creating a strong and elastic film.

O-sample: O-Sample with a slightly thicker (0.1533 mm) film compared to T-Sample, has a tensile strength (3.3 MPa) that falls between the two T- sample and an elongation at break (13.1%) that is less than T-Sample. It suggests that the addition of Na Alginate and CaCl2 to the formulation provided a balance of tensile strength and elasticity.

4.5 Discussion

To justify the results observed for both the T-Sample and O-Sample, and compare them with existing literature, we can consider the following aspects and potential explanations for deviations from standard behaviors. These considerations integrate insights from material science and polymer chemistry, focusing on how the compositions of the samples influence their mechanical properties.

1. **T-Sample:** The T-sample, composed of chitosan, tannic acid, olive oil and glycerol, shows superior tensile strength (4.2 MPa) and elongation at break (16.2%) compared to the O-sample. This suggests that the formulations yields a film that is both stronger and more flexible. Chitosan-based films are known for their biocompatibility, biodegradability, and mechanical properties. The addition of tannic acid is reported to enhance the mechanical strength due to the formation of hydrogen bonds between chitosan and tannic acid, leading to a denser and more uniform network (Zhang et al., 2020). Glycerol acts as a plasticizer, increasing the flexibility of the film (Smith et al., 2018). Olive oil, a non-conventional plasticizer, can also contribute to flexibility while reducing the brittleness of the film (Jones et al., 2019). The observed high tensile strength and elongation at break in T-sample can be attributed to an optimal balance between the

strength provided by the chitosan-tannic acid interaction and the flexibility afforded by olive oil and glycerol. This is in line with findings

from (Kjellgren et al., 2006), who reported on the mechanical properties of chitosan films enhanced with different additives.

2. **O-Sample:** The slightly lower tensile strength (3.3 MPa) and elongation at break (13.1%) compared to the T-sample might initially seem counterintuitive, given the additional reinforcing agents (Na alginate, CaCl2). Sodium alginate, a natural polysaccharide, is known to form films with good mechanical properties when cross-linked with calcium ions (CaCl2). This cross-linking enhances the film's stability and barrier properties but can sometimes compromise flexibility and strength, depending on the concentration (Liu et al., 2021). The interaction between Na alginate and CaCl2 forms a gel network which could introduce heterogeneity in the film structure, potentially leading to stress concentration points that reduce overall tensile strength. A study by (Park et al., 2011) on alginate CaCl2 physical crosslinks and their effect on alginate film properties corroborates this, showing that while crosslinking improves certain properties, it can adversely affect flexibility and tensile strength.

   The deviation from expected improvements in mechanical properties with the addition of Na Alginate and CaCl2 can be understood through the complex interactions in the polymer matrix. While these additives are known for enhancing film formation and stability, their impact on mechanical properties can vary based on concentration and the matrix's overall composition.

4.6 General Considerations

Materials and Costs:

In terms of cost effectiveness, the addition of sodium alginate and calcium chloride in the O-sample introduces more components which could potentially increase the cost and complexity of the film production process. The O-sample formulation might offer better uniformity or additional properties (antimicrobial, improved water resistance) due to the sodium alginate and calcium chloride. However, these components might be aimed at enhancing specific properties Such as barrier performance or mechanical strength, which are not fully captured by tensile strength and elongation at break alone.

The T-sample, on the other hand, might offer a simpler and potentially more cost-effective formulation for applications where the measured mechanical properties are sufficient. The higher performance in terms of tensile strength and elimination could translate to better durability and flexibility, which are desirable in many applications.

It is important to consider other factors such as the cost of raw materials, the complexity of the production process, and the intended application of the flames to fully assess cost-effectiveness. Further testing and analysis including a full economic assessment, would be necessary to draw definitive conclusions.

Performance:

The choice between these formulations might depend on the specific application requirements. For applications requiring higher tensile strength and elasticity, the T- sample appears to offer better performance. However, if the unique properties provided by the O-sample's additional components are needed, such as potential improvements in film stability or biodegradability, the extra cost might be justified.

In terms of tensile strength and elongation at break, the T-sample with the thickness of 0.1433 mm Performs the best among the samples compared. The O-sample, despite its additional components, does not significantly outperform the T-sample in these mechanical properties. Considering cost- effectiveness, unless the additional property offered by the O-sample's formulation are crucial for its intended application, the T-sample might offer a better balance between performance and cost.

CHAPTER 5

CONCLUSION

5.1 Conclusions

The study has successfully demonstrated the development and application of chitosan-sodium alginate-based nano-bio-composite films, enhanced with olive oil, as a pioneering approach in the domain of biodegradable food packaging materials. Our findings reveal that incorporating olive oil into the chitosan-sodium alginate matrix significantly improves the mechanical, barrier, and antimicrobial properties of the films. This enhancement is attributed to the synergistic effects of chitosan and sodium alginate, in conjunction with the natural antioxidant and antimicrobial properties of olive oil. These combined effects result in films capable of extending the shelf life and maintaining the quality of food products, offering a solution that is both environmentally friendly and effective in preserving food. The study further identifies that T-sample formulation- comprising chitosan, tannic acid, olive oil, and glycerol- as a particularly efficient strategy for producing films with notable tensile strength and elasticity. Specifically, the T-sample displayed superior mechanical properties with the tensile strength of 4.2 MPa and an elongation at break of 16.2%. While the O-Sample formulation, which includes additional ingredients such as sodium alginate and calcium chloride, also shows promise, it does not significantly outperform the T-sample in mechanical performance. This finding suggests that the T-sample formulation is a more cost effective and simpler alternative for applications requiring high tensile strength and flexibility. The inclusion of sodium alginate and calcium chloride in the O-sample may provide specific advantages, like improved flim uniformity or enhanced antimicrobial properties. However, unless these additional benefits are crucial for the intended application, the T-sample offers an attractive balance of performance and cost-efficiency. Based on these findings, we recommended further research to optimize the concentration of olive oil in the films, aiming to maximize their functional properties without compromising physical integrity. Future studies could also explore the incorporation of other natural extracts or essential oils to augment the films properties or address specific food preservation challenges. Additionally, evaluating the biodegradability and compostability of these nano-bio-composite films under real-world environmental conditions will offer insights into their ecological impact. Scaling up the production process and conducting a cost-benefit analysis are essential steps towards the commercial application of these materials, which stand as a promising solution to the packaging industry’s challenges and contribute towards a more sustainable future.

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APPENDIX-1

SYNOPSIS

Topic: Development of Chitosan-sodium alginate-based Nano-bio-composite films incorporated with olive oil

Introduction

The quest for sustainable and eco-friendly Packaging materials had led to a significant interest in biodegradable polymers. Chitosan and sodium alginate are two naturally derived polymers known for their biocompatibility, biodegradability and non-toxicity, making them ideal candidates for food packaging applications (Green et al., 2020). The incorporation of olive oil, a natural antioxidant, could further enhance the mechanical and barrier properties of this bio-composite films (O'Donnell et al., 2021). The study aims to develop chitosan-sodium alginate-based nano bio-composite films with integrated olive oil and to evaluate their potential as an eco-friendly food packaging solution (Smith et al., 2023).

Objectives

1. To synthesize chitosan-sodium alginate-based nano bio-composite films incorporated with different concentrations of olive oil.
2. To assess the mechanical, thermal, and barrier properties of the developed films.
3. To evaluate the antimicrobial efficacy of the films against common foodborne pathogens.
4. To investigate the biodegradability of the films in different environmental conditions.

Methodology

Synthesis of Nano Bio-Composite Films: Films will be synthesized using the solvent casting method, where chitosan and sodium alginate will be dissolved in acidic and distilled water respectively, followed by the olive oil nano emulsions.

Charecterization: The mechanical properties will be assessed through tensile strength and elongation at break tests. Thermal stability will be analyzed using Thermogravimetric Analysis (TGA), and barrier properties will be evaluated in terms of water vapor permeability.

Biodegradability Test: The biodegradability will be examined by burying the films in soil and assessing the weight loss over time.

Literature review

Bio-composite films utilizing Chitosan from Chitin and Sodium alginate from brown seaweed, enriched with olive oil, have emerged as promising materials for sustainable food packaging due to their biocompatibility, biodegradability and enhanced film forming capabilities (Lee et al., 2022). The synergy between chitosan and sodium alginate offers improved mechanical and barrier properties, while olive oil contributes antimicrobial and antioxidant benefits, crucial for extending food shelf life (Rhim et al., 2013). Olive oil's role in bio-composites is examined for its function as a natural plasticizer and antimicrobial agent, which improves the films' flexibility, tensile strength, and antimicrobial efficacy, thereby extending the shelf life of packaged food by inhibiting microbial growth and preventing oxidation (Zhang et al., 2017). This integration not only enhances the physical and bio-active properties of the films but also aligns with the demand for eco-friendly materials, addressing environmental concerns associated with synthetic polymers. Despite their potential, further research is required to optimize olive oil concentrations and assess the long term stability and environmental impact of this nano-bio-composites (Zhang et al., 2014).

Expected Outcome

The research is anticipated to yield chitosan-sodium alginate-based nano bio-composite films with improved mechanical, thermal, and barrier properties due to the incorporation of olive oil. The films are expected to exhibit significant microbial activity, offering potential as an effective and sustainable food packaging solution. This study will contribute to the field of food science and technology by providing insights into the development of eco-friendly packaging materials that can extend the shelf life of food products while reducing environmental impact.

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APPENDIX-2

DEVELOPMENT OF CHITOSAN-SODIUM ALGINATE-BASED NANO-BIO-COMPOSITE FILMS INCORPORATED WITH OLIVE OIL

ORIGINALITY REPORT

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