

NUTRITIONAL EMULSIONS CONTAINING ENCAPSULATED OILS

5 The present invention relates to nutritional emulsions containing process-encapsulated oils in combination with low DE maltodextrins.

BACKGROUND OF THE INVENTION

 Nutritional liquids are well known and commercially available for a variety of
10 nutritional or disease specific applications in infants, children and adults. These liquids are often formulated as oil-in-water emulsions comprising proteins, carbohydrates, and fats, and typically also vitamins and minerals.

 These nutritional liquids have also been used to deliver variety of nutritional actives such as polyunsaturated fatty acids or fish oils. A growing body of evidence
15 suggests that certain long chain polyunsaturated fatty acids may be beneficial for maintaining overall health, and may be useful in treating a variety of human afflictions, including cardiovascular disease, rheumatoid arthritis, depression, Alzheimer's, ulcers, cancer, hyperactivity, asthma, and similar other diseases or conditions.

 Polyunsaturated fatty acids, however, often have or develop over time objectionable
20 flavors, odors, or both, especially when formulated within a nutritional liquid. When exposed to heat and atmospheric levels of oxygen, the unsaturated structure of these polyunsaturated fatty acids reacts to form free radicals. These free radicals can continue to break down the polyunsaturated fatty acids in an auto-oxidative process, which results in the development of fishy or other undesirable flavors and odors and the eventual
25 degradation of the beneficial polyunsaturated fatty acids.

 Oxidative stability has become especially challenging when formulating a nutritional liquid containing the relatively high concentrations of polyunsaturated fatty acids often needed to obtain a therapeutic response. Allowing even some oxidation in these products often results in a highly objectionable flavor and aroma, the characteristics of which are
30 often described as fishy, eggy, or otherwise having a rancid flavor or smell, depending upon the particular polyunsaturated fatty acid used in the formulation.

 Methods of controlling the undesirable oxidation of polyunsaturated fatty acids in a nutritional product include processing or manufacturing controls to limit conditions such as elevated temperatures, exposure to ultraviolet light, exposure to oxygen and other factors
35 that can promote oxidation. All such methods almost always include the concurrent formulation with one or more anti-oxidant additives such as ascorbic acid or ascorbyl

palmitate, tocopherols, beta-carotene, or others. Although these methods are often highly effective in reducing much of the undesirable oxidation that would otherwise occur, they are often not as effective when applied to liquid nutritional compositions that contain the relatively high polyunsaturated fatty acid concentrations often needed to achieve a desired therapeutic effect.

It has now been discovered herein that nutritional emulsions can be formulated with little or no detectable off-notes from high concentrations of polyunsaturated fatty acids. These nutritional emulsions comprise fat, protein, and carbohydrate, including up to about 5% by weight of the a polyunsaturated fatty acid that is process-encapsulated by an emulsifying agent having a melt point above about 25°C, and maltodextrin having a DE (Dextrose Equivalent) value of about 10 or less, wherein the weight ratio of the emulsifying agent to the polyunsaturated fatty acid is at least about 1:15 and the weight ratio of the maltodextrin to the oil is at least about 1:2.

It has also been discovered herein that these same nutritional emulsions can be prepared with most any oil having hydrophobic off-notes, not just polyunsaturated fatty acids, to effectively minimize or eliminate off-notes in the final nutritional product.

SUMMARY OF THE INVENTION

A first embodiment of the present invention is directed to nutritional emulsions comprising fat, protein, and carbohydrate, including from about 0.01% to about 5% by weight of an oil having hydrophobic off-notes that is process-encapsulated in an emulsifying agent having a melt point above about 25°C, and maltodextrin having a DE value about 10 or less, wherein the weight ratio of the emulsifying agent to the process-encapsulated oil is at least about 1:15 and the weight ratio of the maltodextrin to the oil is at least about 1:2.

A second embodiment of the present invention is directed to nutritional emulsions comprising fat, protein, and carbohydrate, including from about 0.01% to about 5% by weight of a polyunsaturated fatty acid that is process-encapsulated in an emulsifying agent having a melt point above about 25°C, and maltodextrin having a DE value about 10 or less, wherein the weight ratio of the emulsifying agent to the polyunsaturated fatty acid is at least about 1:15 and the weight ratio of the maltodextrin to the polyunsaturated fatty acid is at least about 1:2.

The compositions of the present invention may be prepared by: (A) heating and blending together an emulsifying agent having a melt point above about 25°C and a non-encapsulated polyunsaturated fatty acid in a weight ratio of at least about 1:15; (C) adding the heated blend to a fat, protein, and carbohydrate mixture comprising maltodextrin

having a Dextrose Equivalent of about 10 or less, in a weight ratio of the maltodextrin to the polyunsaturated fatty acid of at least about 1:2; and (D) homogenizing, and then cooling the combination below the melt point of the emulsifying agent to form a nutritional emulsion comprising from about 0.01% to about 5% by weight of process-encapsulated polyunsaturated fatty acid.

It has been discovered herein that these oil-in-water emulsions effectively mask the flavor of oils having hydrophobic off-notes (e.g., polyunsaturated fatty acids). This is accomplished by combining process-encapsulated oils having hydrophobic off-notes (encapsulated in selected emulsifying agents) with certain maltodextrins.

It has been discovered herein that to effectively mask the hydrophobic off-notes in these emulsions, the process encapsulated oils (encapsulated during formulation with a high melting point emulsifier) must be used in combination with those maltodextrins defined by a DE value of about 10 or less.

DETAILED DESCRIPTION OF THE INVENTION

The nutritional compositions of the present invention are oil-in-water emulsions that comprise as essential elements fat, protein, and carbohydrate, including an oil having hydrophobic off-notes (e.g., polyunsaturated fatty acids), selected emulsifying agents, and selected maltodextrins. These and other essential or optional elements or limitations of the compositions of the present invention are described in detail hereinafter.

The term "nutritional emulsion" as used herein, unless otherwise specified, refers to oral liquids in the form of oil-in-water emulsions comprising fat, protein, and carbohydrates, which may be formulated as meal replacement products, nutritional supplements, or continuous (or intermittent) enteral feedings.

The terms "polyunsaturated fatty acid" or "PUFA" as used herein, unless otherwise specified, refer to any polyunsaturated fatty acid or source thereof, including short chain (less than about 6 carbon atoms per chain), medium chain (from about 6 to 18 carbon atoms per chain) and long chain (having at least about 20 carbon atoms per chain) fatty acids having two or more carbon:carbon double bonds, including n-3 (omega-3) and n-6 (omega-6) polyunsaturated fatty acids.

The term "process-encapsulated" as used herein refers to the combination of a oil having hydrophobic off-notes and a high melting point emulsifier, wherein the two are combined to form a liquid intermediate during processing but prior to incorporation into the nutritional emulsion, and are added in liquid form to one or more of fat, protein, and carbohydrate intermediate ingredients, to thereafter effectively result in solid

encapsulation of the oil having hydrophobic off-notes by the high melting point emulsifier in the finished product.

All percentages, parts and ratios as used herein are by weight of the total composition, unless otherwise specified. All such weights as they pertain to listed
5 ingredients are based on the active level and, therefore, do not include solvents or by-products that may be included in commercially available materials, unless otherwise specified.

All numerical ranges as used herein, whether or not expressly preceded by the term "about", are intended and understood to be preceded by that term, unless otherwise
10 specified.

Any reference to singular characteristics or limitations of the present invention shall include the corresponding plural characteristic or limitation, and vice versa, unless otherwise specified or clearly implied to the contrary by the context in which the reference is made.

15 Any combination of method or process steps as used herein can be performed in any order, unless otherwise specified or clearly implied to the contrary by the context in which the referenced combination is made.

The nutritional emulsions of the present invention may also be substantially free of any optional or a selected essential ingredient or feature described herein, provided that
20 the remaining formula still contains all of the required ingredients or features as described herein. In this context, the term "substantially free" means that the selected composition contains less than a functional amount of the optional ingredient, typically less than 0.1% by weight, and also including zero percent by weight, of such optional or selected essential ingredient.

25 The nutritional emulsions of the present invention may comprise, consist of, or consist essentially of the essential elements and limitations of the invention described herein, as well as any additional or optional ingredients, components, or limitations described herein or otherwise useful in a nutritional or pharmaceutical application.

30 **Low DE Maltodextrin**

The nutritional emulsions of the present invention comprise a maltodextrin having a dextrose equivalent (DE) of about 10 or less, including from about 1 to about 5, including from about 2 to about 4, and also including about 3. Suitable maltodextrins for use herein are those that are safe for use in oral nutritional products and that also have the requisite
35 DE value.

It has been found that only those maltodextrins having the requisite DE value will effectively work along with the process-encapsulated oil to minimize or eliminate hydrophobic off-notes associated the oil. It has also been found that DE 3 maltodextrin is even more effective in minimizing hydrophobic off-notes than either DE 1 or DE 5 maltodextrins.

The concentration of maltodextrin in the nutritional emulsion is selected so that the resulting weight ratio of maltodextrin to polyunsaturated fatty acid (or other oil having hydrophobic off-notes) is at least about 1:2, preferably from about 1:1 to about 20:1, including from about 2:1 to about 10:1, and also including from about 2.5:1 to about 4:1.

These maltodextrin concentrations most typically range from about 0.1% to about 20%, including from about 1% to about 10%, and also including from about 2% to about 7%, by weight of the nutritional emulsion.

Maltodextrins are known for use in a variety of foods and other nutritional products. Maltodextrins are partially hydrolyzed starch molecules comprising a series of D-glucose units linked primarily by (alpha)-1,4 bonds. Although maltodextrins, as an ingredient class, have DE values of 20 or less, only those having DE values of 10 or less are suitable for use herein.

DE values are conventional measurements of the average reducing power of maltodextrin or other polysaccharide as compared to a dextrose standard. DE values are derived from the formula [$DE = 100 \div DP$], where DP is the degree of polymerization of the maltodextrin or other material, i.e., the number of monosaccharide units in the polysaccharide. Glucose (dextrose) has a DE of 100; starch has a DE of approximately or close to zero.

The maltodextrins for use herein may also be characterized, in the alternative, in terms of DP values rather than DE values, wherein the DP value is about 10 or higher, including from 10 to 250, and also including from 40 to 150.

Non-limiting examples of suitable maltodextrins for use herein include STAR-DRI® 1 (DE 1) and STAR-DRI® 5 (DE 5) from AE Staley Mfr. Company, Decatur, Illinois, USA; and M-40 (DE 5) from Grain Processing Corporation, Muscatine, Iowa, USA. Other maltodextrins - those having a DE value greater than 10 - may be added, but only as optional ingredients in addition to the other required maltodextrin component.

Oil Having Hydrophobic Off-notes

The nutritional emulsions of the present invention comprise an oil having hydrophobic off-notes that is encapsulated during formulation (of the nutritional emulsion) by a high melting point emulsifying agent as described hereinafter.

It should be noted that the oil having hydrophobic off notes is not encapsulated prior to formulation, that it becomes encapsulated only during formulation of the nutritional emulsion.

The term "oils having hydrophobic off-notes" as used herein, unless otherwise
5 specified, means any hydrophobic material that inherently contains off-notes, or otherwise comprises an ingredient that contributes off-notes to the oil. Examples of oils having hydrophobic off-notes include polyunsaturated fatty acids, soy oil, beta-hydroxy-beta-methylbutyrate or oils containing it, and combinations thereof. The oil preferably comprises a polyunsaturated fatty acid as described herein.

10 The term "off-notes" as used herein refers to any flavor or aroma inherently associated with an oil or material within oil that a formulator would wish to minimize or eliminate when formulated into a nutritional emulsion.

The concentration of the oil having hydrophobic off-notes within the nutritional emulsion represents up to about 5%, including from about 0.01% to about 5%, also
15 including from about 0.3% to about 3%, and also including from about 0.5% to about 2.5%, by weight of the nutritional emulsion.

The oil having the hydrophobic off-notes must be process-encapsulated by the high melting temperature emulsifying agent, wherein the oil having the hydrophobic off-notes preferably represents from about 50% to 100%, including from about 60% to about 90%,
20 also including from about 75% to about 85%, by weight of all material so encapsulated (excluding the high-melting point emulsifying agent). In this context, all other fats within the nutritional emulsion are preferably formulated into the nutritional emulsion separate from and external to the process-encapsulated oil/emulsify agent combination. In other words, the high melting temperature emulsifying agent is melted and combined with the oil
25 having the hydrophobic off-notes prior to formulating it into the nutritional emulsion. The encapsulation of the oil is achieved during processing when the blend is heat treated (UHT), homogenized and chilled.

Although the oils having hydrophobic off-notes can be added to the nutritional emulsion in addition to and separate from the process-encapsulated oils having
30 hydrophobic off-notes, the emulsions are preferably free of such additional oils having hydrophobic off-notes. In this context, "substantially free" means that the composition preferably contains less than about 0.1%, more preferably less than about 0.05%, including zero percent, by weight of such additional oils having hydrophobic off-notes, including both pre-encapsulated and non-encapsulated forms.

35 For polyunsaturated fatty acid embodiments of the present invention, the polyunsaturated fatty acids for use in the nutritional emulsions include any such fatty acid

material, or source thereof, that is suitable for use in oral nutritional products, non-limiting examples of which include n-3 polyunsaturated fatty acids, n-6 polyunsaturated fatty acids, and combinations thereof. Suitable sources of polyunsaturated fatty acids include free fatty acids as well as fatty acid esters such as triglycerides, diglycerides,

- 5 monoglycerides, ethyl esters, and so forth, including various concentrated forms thereof as well as those in structured lipid form.

Non-limiting examples of suitable polyunsaturated fatty acids for use herein include n-3 polyunsaturated fatty acids such as alpha-linolenic acid (ALA, C18:3n-3), stearidonic acid (C18:4n-3), eicosapentaenoic acid (EPA, C20:5n-3), docosapentaenoic acid (C22:5n-3), docosahexaenoic acid (DHA, C22:6n-3), and combinations thereof.

10 Sources of such n-3 fatty acids for use herein include flax seed oil, canola oil, transgenic oils, and fish oil.

Other polyunsaturated fatty acids suitable for use herein include n-6 polyunsaturated fatty acids such as linoleic acid (C18:2n-6), gamma-linolenic acid (GLA, C18:3n-6), eicosadienoic acid (C20:2n-6), arachidonic acid (ARA, C20:4n-6), di-homo-

15 gamma-linolenic acid (DGLA, C20:3n-6), and combinations thereof, sources of which include evening primrose oil, borage oil, black currant seed oil, flaxseed oil, transgenic sources, purified fatty acid sources, and combinations thereof.

20 **High Melting Point Emulsifier**

High melting point emulsifier for use herein includes any emulsifying agent suitable for use in a nutritional product that also has a melt point of at least about 25°C, preferably from about 30°C to about 75°C, more preferably from about 45°C to about 70°C.

The selected emulsifier and the oil having hydrophobic off-notes are melted

25 together to form a liquid, and this mixture is added to the rest of the nutritional formulation (a fat-carbohydrate-protein-mineral blend). The resultant blend is then UHT (Ultra High Temperature) heat-treated and homogenized. The homogenization divides the fish oil into very small droplets coated with the high melting temperature emulsifier. When this homogenized blend is cooled to below room temperature, the emulsifier solidifies, thus

30 resulting in encapsulation of the polyunsaturated fatty acid (also referred to herein as "process-encapsulated polyunsaturated fatty acid) or other hydrophobic oil having off-notes (referred to herein as "process-encapsulated oils having hydrophobic off-notes")

The amount or concentration of the high melting point emulsifier in the nutritional emulsions is selected so that the resulting weight ratio of the emulsifier to the oil having

35 hydrophobic off-notes is at least 1:15, preferably from 1:10 to 1:1, including from 1:9 to 1:2, and also including from 1:5 to 1:2 Such emulsifier concentrations most typically range

from about 2% to about 12%, including from about 4 to about 10%, and also including from 5 to 8%, by weight of the total oil in the emulsion. It is understood, however, that even higher concentrations of emulsifier can be used, especially when additional emulsifier is added for purposes other than encapsulation of the oil having hydrophobic off-notes, e.g., for emulsion stability.

- Suitable high melting point emulsifying agents include monoglycerides or other monoesters of polyhydric alcohols, including fatty acid esters of glycerol. Non-limiting examples of some suitable high melting point emulsifiers for use herein include GRINDSTED™ ACETEM (acetic acid esters of monoglycerides), GRINDSTED™ CITREM (citric acid esters of monoglycerides); GRINDSTED™ LACTEM (lactic acid esters of monoglycerides); GRINDSTED™ Mono-Di (mono and diglycerides); GRINDSTED™ PGE or PGPR (polyglycerol esters of fatty acids, polyglycerol polyricinoleate); GRINDSTED™ PGMS (propylene glycerol esters of fatty acids); GRINDSTED™ SMS or STS (sorbitan monostearate, sorbitan tristearate); and DIMODAN® distilled monoglycerides; all available from Danisco, Copenhagen, Denmark.

Other suitable high melting point emulsifying agents include MYVEROL® 18-99K, a distilled monoglyceride comprising a blend of about 82% monoacylglycerols (86.6% monoolein, 7.0% monostearin, 3.5% monopalmitin, 0.9% monoarachidin, 2.0% unidentified), available from Kerry Bio-Science, Hoffman Estates, Illinois, USA.

Macronutrients

The nutritional emulsions of the present invention comprise fat, protein, and carbohydrate macronutrients. Any source of such nutrients known or otherwise suitable for use in an oral nutritional product is also suitable for use herein, provided that such nutrients are compatible with the selected ingredients in the formulation.

Although concentrations or amounts of each macronutrient in the nutritional emulsion may vary depending upon the nutritional needs of the intended user, such concentrations or amounts most typically fall within one of the following embodied ranges.

Macronutrient	Embodiments		
	A	B	C
Carbohydrate¹ - % total calories	10-85	20-60	40-60
Fat² - % total calories	10-85	10-50	15-35
Protein - % total calories	5-80	10-30	15-25
Carbohydrate¹ g/100ml	1-40	4-30	10-20
Fat² g/100ml	0.2-30	0.5-15	1-5
Protein g/100ml	0.5-30	1-15	2-10

1. Includes maltodextrin component

2. Includes oil having hydrophobic off-notes; may also include emulsifying agent (if a fat)

The nutritional emulsions comprise a fat source, which includes the oil having hydrophobic off-notes (e.g., polyunsaturated fatty acid) as described herein. The oil having hydrophobic off-notes may represent all or just some of the fat source. Non-limiting examples of fats for use herein include (in addition to oils having hydrophobic off-
5 notes such polyunsaturated fatty acids) coconut oil, fractionated coconut oil, soy oil (without hydrophobic off-notes), corn oil, olive oil, safflower oil, high oleic safflower oil, MCT oil (medium chain triglycerides), sunflower oil, high oleic sunflower oil, palm and palm kernel oils, palm olein, canola oil, marine oils, cottonseed oils, and combinations thereof. The term "fat" as used herein includes both fats and oils, solid or liquid, unless
10 otherwise specified.

The nutritional emulsions comprise a carbohydrate source, which includes the maltodextrin component described herein. The maltodextrin may represent all or just some of the carbohydrate source. Non limiting examples of carbohydrates for use herein include additional hydrolyzed or modified starch or cornstarch, glucose polymers, corn
15 syrup, corn syrup solids, rice-derived carbohydrate, glucose, fructose, lactose, high fructose corn syrup, indigestible oligosaccharides (e.g., fructooligosaccharides), honey, sugar alcohols (e.g., maltitol, erythritol, sorbitol), and combinations thereof.

The nutritional emulsions comprise a protein source suitable for use in a nutritional emulsion. Proteins or protein sources suitable for use herein include hydrolyzed, partially
20 hydrolyzed or non-hydrolyzed proteins or protein sources, and can be derived from any known or otherwise suitable source such as milk (e.g., casein, whey), animal (e.g., meat, fish), cereal (e.g., rice, corn), vegetable (e.g., soy), or combinations thereof. Non-limiting examples of such proteins include milk protein isolates, casein protein isolates, milk protein concentrate, whole cows milk, partially or completely defatted milk, soy protein
25 isolates, and so forth.

Optional Ingredients

The nutritional emulsions of the present invention may further comprise other optional components that may modify the physical, chemical, aesthetic or processing
30 characteristics of the products or serve as pharmaceutical or additional nutritional components when used in the targeted population. Many such optional ingredients are known or otherwise suitable for use in other nutritional products and may also be used in the compositions herein, provided that such optional ingredients are safe and effective for oral administration and are compatible with the essential and other ingredients in the
35 selected product form.

Non-limiting examples of such optional ingredients include preservatives, antioxidants, other additional emulsifying agents, buffers, pharmaceutical actives, additional nutrients as described herein, sweeteners including artificial sweeteners (e.g., saccharine, aspartame, acesulfame K, sucralose) colorants, flavors, thickening agents
5 and stabilizers, and so forth.

The nutritional emulsions of the present invention may further comprise any of a variety of other vitamins or related nutrients, non-limiting examples of which include vitamin A, vitamin D, vitamin E, vitamin K, thiamine, riboflavin, pyridoxine, vitamin B₁₂, carotenoids, niacin, folic acid, pantothenic acid, biotin, vitamin C, choline, inositol, salts
10 and derivatives thereof, and combinations thereof.

The nutritional emulsions may further comprise any of a variety of other additional minerals, non-limiting examples of which include calcium, phosphorus, magnesium, iron, zinc, manganese, copper, sodium, potassium, molybdenum, chromium, chloride, and combinations thereof.

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Manufacture

The nutritional emulsion of the present invention may be prepared by any known or otherwise effective manufacturing technique for preparing a liquid nutritional, modified in accordance with the method as noted below for effectively formulating a process-
20 encapsulated oil having hydrophobic off-notes with a high melting point emulsifier and then subsequently incorporating the combination into the nutritional emulsion.

The nutritional emulsion may be prepared by separately formulating a protein-in-water slurry (majority protein and water), a carbohydrate-mineral slurry (mineral, carbohydrate including maltodextrin), a protein-in-fat slurry (protein, fat soluble vitamins,
25 fat) and then having these slurries combined to form a blend before the oil having hydrophobic off-notes/high melting temperature emulsifier is added to the blend. The resulting blend is then heat processed, homogenized, standardized with any water-soluble vitamins, flavored, and the resulting nutritional emulsion terminally sterilized or aseptically processed and filled and allowed to cool.

30 A method for making the nutritional emulsions of the present invention may therefore comprise:

(A) heating and blending together an emulsifying agent having a melt point above about 25°C and a oil having hydrophobic off-notes in a weight ratio of at least about 1:15; and

(C) adding the heated blend to a fat, protein, and carbohydrate mixture comprising a maltodextrin having a Dextrose Equivalent of about 10 or less, in a weight ratio of the maltodextrin to the oil having hydrophobic off-notes of at least about 1:2; and

5 (D) homogenizing and then cooling the combination below the melt point of the emulsifying agent to form a nutritional emulsion comprising from about 0.01% to about 5% by weight of process-encapsulated oil (or other oil having hydrophobic off-notes).

10 This particular method may be modified in accordance with any or all the variations directed to the nutritional emulsion embodiments as described herein.

EXAMPLES

The following examples illustrate specific embodiments of the nutritional emulsions of the present invention. These examples are given solely for the purpose of illustration and are not to be construed as limitations of the present invention, as many variations
15 thereof are possible without departing from the spirit and scope of the invention.

Each nutritional emulsion described below is prepared by separately formulating a protein-in-water slurry, a carbohydrate and mineral slurry, and an oil fiber slurry. The oil having the hydrophobic off-notes (e.g., fish oils) and emulsifier blend is prepared separately by heating and blending the two together at a temperature sufficient to melt the
20 solid emulsifier, to thus form a heated liquid blend. The formed slurries are then combined to form a single mixture, and thereafter the fish oil and emulsifier blend (as a heated liquid) is added to the single mixture. The resulting combination is then heat processed, homogenized, standardized with any water-soluble vitamins, flavored, and the resulting nutritional emulsion terminally sterilized or aseptically processed and filled and
25 allowed to cool.

Ingredients used in preparation of the exemplified embodiment are listed in the following table. The finished emulsion is orally administered, on a daily basis, to individuals as a dietary source of polyunsaturated fatty acids, in an amount sufficient to provide sole or supplement nutrition to the targeted users. These Individuals fail to detect
30 any off-flavors or odors associated with the fatty acid component, during or within two hours following consumption.

Nutritional Emulsion (1000 kg)

Ingredient	Amount	Amount		Amount
Protein in water slurry				
Water	430 kg	430 kg	430 kg	5.64 kg
Sodium caseinate (92% protein)	10.8 kg	10.8 kg	10.8 kg	10.8 kg
ALANATE® 166 (92% protein) partially hydrolyzed sodium caseinate, New Zealand Milk Products, Santa Rosa, CA, USA	5.64 kg	5.64 kg	5.64 kg	5.64 kg
Allapro 4900 (84% protein) Milk protein isolate, New Zealand Milk Products	30.8 kg	30.8 kg	30.8 kg	30.8 kg
Carbohydrate and mineral slurry				
Water	194.5 kg	194.5 kg	194.5 kg	194.5 kg
STAR-DRI® DE-1 Maltodextrin, AE Staley Mfr. Company, Decatur, IL, USA	45.45 kg	--	45.45 kg	45.45 kg
Maltodextrin DE-5	--	45.45 kg	--	--
Maltitol syrup (70% solids)	34.36 kg	34.36 kg	34.36 kg	34.36 kg
Fructose crystalline	28.00 kg	28.00 kg	28.00 kg	28.00 kg
MALTRIN® M-200, corn syrup solids, Grain Processing Corp., Muscatine, IA, USA	22.55 kg	22.55 kg	22.55 kg	22.55 kg
Fructooligosaccharides	12.73 kg	12.73 kg	12.73 kg	12.73 kg
Magnesium phosphate dibasic	1.10 kg	1.10 kg	1.10 kg	1.10 kg
Sodium citrate	2.40 kg	2.40 kg	2.40 kg	2.40 kg
Potassium chloride	1.20 kg	1.20 kg	1.20 kg	1.20 kg
Tricalcium phosphate	0.899 kg	0.899 kg	0.899 kg	0.899 kg
Calcium carbonate	0.802 kg	0.802 kg	0.802 kg	0.802 kg
AVICEL® (microcrystalline cellulose), FMC Biopolymer, Philadelphia, PA, USA	0.526 kg	0.526 kg	0.526 kg	0.526 kg
Magnesium chloride	0.802 kg	0.802 kg	0.802 kg	0.802 kg
Potassium phosphate dibasic	0.350 kg	0.350 kg	0.350 kg	0.350 kg
Choline chloride	0.343 kg	0.343 kg	0.343 kg	0.343 kg
Trace and ultra trace mineral premix	0.269 kg	0.269 kg	0.269 kg	0.269 kg
Potassium citrate	0.549 kg	0.549 kg	0.549 kg	0.549 kg
Gellan gum	0.200 kg	0.200 kg	0.200 kg	0.200 kg
Guar gum	3.27 kg	3.27 kg	3.27 kg	3.27 kg
Konjac	5.64 kg	5.64 kg	5.64 kg	5.64 kg
Potassium Iodide	0.002 kg	0.002 kg	0.002 kg	0.002 kg

Fish oil/high melting temperature emulsifier				
Marine oil (Mochida-Nissui) (50% Omega-3 Sardine Oil)	8.0 kg	8.0 kg	--	16.0 kg
MYVEROL® 18-06 Grindsted Products ²	8.0 kg	8.0 kg	8.0 kg	8.0 kg
Soy oil	--	--	8.0 kg	
Oil fiber slurry				
Diacylglycerol Oil	17.64 kg	17.64 kg	17.64 kg	17.64 kg
Canola Oil	1.58 kg	1.58 kg	1.58 kg	1.58 kg
High Oleic Safflower Oil	9.41kg	9.41kg	9.41kg	9.41kg
Soy Lecithin	0.732 kg	0.732 kg	0.732 kg	0.732 kg
Vitamin E	0.072 kg	0.072 kg	0.072 kg	0.072 kg
Lutein	0.050 kg	0.050 kg	0.050 kg	0.050 kg
Vitamin A Palmitate (54% in corn oil)	0.0078 kg	0.0078 kg	0.0078 kg	0.0078 kg
Vitamin DEK	0.047 kg	0.047 kg	0.047 kg	0.047 kg
Water soluble vitamin/ flavor Solution				
Water	7.55 kg	7.55 kg	7.55 kg	7.55 kg
Ascorbic Acid	0.424 kg	0.424 kg	0.424 kg	0.424 kg
Liquid Sucralose (25%)	0.300 kg	0.300 kg	0.300 kg	0.300 kg
Vitamin Premix	0.071 kg	0.071 kg	0.071 kg	0.071 kg
Choline chloride	0.343 kg	0.343 kg	0.343 kg	0.343 kg
Raspberry flavor	2.3 kg	2.3 kg	2.3 kg	2.3 kg
FD&C Red #3	0.003 kg	0.003 kg	0.003 kg	0.003 kg
FD&C Blue #1	.00035 kg	.00035 kg	.00035 kg	.00035 kg
Dilution Water	55 kg	55 kg	55 kg	55 kg

1. Provides 3.93 kg polyunsaturated fatty acids, including docosahexaenoic acid
2. Emulsifying agent - melting point 69-75°C

WHAT IS CLAIMED IS:

1. A nutritional emulsion comprising fat, protein, and carbohydrate, including:
 - (A) from about 0.01% to about 5% by weight of an oil having hydrophobic off-notes
5 that is process-encapsulated by an emulsifying agent having a melt point above
 about 25°C, and
 - (B) maltodextrin with a DE of about 10 or less,
 wherein the weight ratio of the emulsifying agent to the oil having hydrophobic off-
 notes is at least about 1:15 and the weight ratio of the maltodextrin to oil having
10 hydrophobic off-notes is at least about 1:2.
2. A nutritional emulsion according to claim 1 wherein the oil having hydrophobic off-
notes is selected from the group consisting of polyunsaturated fatty acids, soy oil, beta-
hydroxy-beta-methylbutyrate containing oil, and combinations thereof.
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3. A nutritional emulsion according to claim 1 wherein the oil having hydrophobic off-
notes is a polyunsaturated fatty acid.
4. A nutritional emulsion according to claim 3 wherein the weight ratio of emulsifying
20 agent to the process-encapsulated polyunsaturated fatty acid is from 1:9 to 1:2 and the
weight ratio of maltodextrin to process-encapsulated polyunsaturated fatty acid is from 1:1
to 20:1.
5. A nutritional emulsion according to claim 3 wherein the weight ratio of emulsifying
25 agent to the process-encapsulated polyunsaturated fatty acid is from 1:5 to 1:2 and the
weight ratio of maltodextrin to process-encapsulated polyunsaturated fatty acid is from
2.5:1 to 4:1.
6. A nutritional emulsion according to claim 3 wherein the emulsion comprises from about
30 0.3% to about 3% by weight of the process-encapsulated polyunsaturated fatty acid.
7. A nutritional emulsion according to claim 3 wherein the emulsion is substantially free of
polyunsaturated fatty acids other than the process-encapsulated polyunsaturated fatty
acid.
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8. A nutritional emulsion according to claim 3 wherein the emulsifying agent has a melt
point of from about 45°C to about 70°C.

9. A nutritional emulsion according to claim 3 wherein the emulsifying agent is a monoglyceride.
10. A nutritional emulsion according to claim 3 wherein the polyunsaturated fatty acid
5 includes eicosapentaenoic acid, docosahexaenoic acid, or both.
11. A nutritional emulsion according to 3 wherein the emulsion comprises from about 0.1 to about 20% of the maltodextrin and the maltodextrin has a DE of from about 1 to about 5.
- 10 12. A nutritional emulsion according to claim 3 wherein the maltodextrin has a DE value of about 3.
13. A nutritional emulsion according to claim 3 wherein the emulsion comprises, as a
15 percentage of total calories, from about 10% to about 85% carbohydrate, from about 10% to about 85% fat, and from about 5% to about 80% protein.