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1 **Tailoring the properties of pea-enriched soft cakes using a multiobjective model** 2 **based on sensory-relevant instrumental characterization.**

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8
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11 12 **Highlights**

- 13 • Flour variability effects were corrected by the process thanks to an I-optimal response surface
14 design
- 15 • The correction efficiency of the multiobjective model was proved for pea/wheat proportions
16 variations
- 17 • A set of instrumental cake properties was shown to be representative of sensory perceptions
- 18 • Target instrumental cake properties were used to find adjusted processing parameters

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5 **19 Abstract:**

6 **20** Managing the quality of pea-enriched cakes made from mixes of wheat and pea flours in various proportions (10, 35 and
7
8 **21** 60 wt% of pea, flour basis) and with various particle size distributions (0, 50 and 100 wt% of particles < 63 µm) is a
9
10 **22** challenge for the industry. A “multiobjective” model based on an I-optimal response surface design was set up in a
11
12 **23** previous study. It allows obtaining target cake structural and textural properties by adjusting several processing
13
14 **24** parameters (mixing speed and time, baking program). As the model’s ability to correct the variations in cake properties
15
16 **25** due to variations in flour properties remained to be proven, two case studies concerning the proportion and the particle
17
18 **26** size of pea flour were studied. A variation of crumb stiffness (24 to 37 kPa), lightness (85,4 to 79,6 in L*) and cell
19
20 **27** fineness (4.9 to -4.8 in PC1 score) could be observed with the increase in the proportion of pea flour from 0 to 35 wt%,
21
22 **28** and these variations were properly corrected by the model (corrected values: 28 kPa; 83.2 in L*; 3.7 in PC1 score). A
23
24 **29** change in the particle size of pea flour caused variations in cake properties inferior to those due to processing
25
26 **30** reproducibility, except for cake symmetry (7.5 to 10.1 in symmetry index; corrected value: 7.2). A selection of products
27
28 **31** representative of the diversity of cakes from the original design space were investigated by 11 trained panelists through
29
30 **32** Quantitative Descriptive Analysis. A convergence between sensory and instrumental results was found concerning
31
32 **33** structural and textural properties. Additional sensory perceptions such as beany attributes or in-mouth drying aftertaste
33
34 **34** were pointed out.

35
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37 **35 Keywords:**

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39 **36** pea flour, cake quality, desirability function, reverse engineering, surface response methodology, I-optimal design
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43 **38 1. Introduction**

44
45 **39** There is an urgent need for an agroecological transition to improve the sustainability of our food chains from fields to
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47 **40** foods. The increasing pressure of climate change will affect cultural conditions. Moreover, better agricultural practices
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49 **41** will have to be adopted such as removing chemical inputs (pesticides and fertilizers). Thus, it is highly likely that one
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51 **42** will have to face an increase in the variability of raw materials in the future. Intercropping wheat and legumes crops is
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53 **43** an agroecological practice that allows to significantly decrease the carbon footprint and greenhouse gas emissions
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55 **44** associated to wheat growing (Nemecek et al. 2008). Thus, the formulation of legume-enriched cakes could promote the
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4 45 development of sustainable food chains including the use of composite flours made from wheat and legume grains grown
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6 46 and harvested together.
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8 47 However, in these conditions the composite flours would present consequential variations in their properties, among
9
10 48 which the proportions of both species in the mix and the particle sizes of both flours in the mix (Monnet et al. 2019a). In
11
12 49 our current standardized food chains, the quality of manufactured products needs to be stable to guarantee stable sensory
13
14 50 properties (texture, flavor, structure) to be perceived by the consumer, with the least processing constraints possible.
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16 51 Indeed, processing is usually rather inflexible and the raw materials are as standardized as possible. Being able to handle
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18 52 raw materials with more variability requires juggling the processing variables (De Vries et al. 2017). To be able to do so,
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20 53 specially designed tools are needed to monitor the quality of the end product as a function of the processing variables.
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25 55 In baked cereal products such as soft cakes, the main raw material is flour, and the functionalities of its two main
26
27 56 components, protein and starch, are essential to the structure of the final product. Proteins enhance batter viscosity and
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29 57 thermoset during baking through the formation of intermolecular disulfide bonds (Dewaest et al. 2017). Starch granules
30
31 58 swell and gelatinize during baking, to form the structuring “bricks” of the cell walls surrounded by a protein “mortar”
32
33 59 (Donovan 1977). Beyond the agricultural benefits of intercropping, introducing legume flour in 100% wheat cakes is a
34
35 60 way to improve their nutritional properties, as the essential amino acid profiles of wheat and legume proteins are
36
37 61 complementary (Berrazaga et al. 2019). While most wheat proteins are not suitable for emulsification or foaming due to
38
39 62 their poor solubility in water at neutral pH, legume proteins have moderate to high emulsifying and foaming properties
40
41 63 (Boye et al. 2010). Furthermore, higher protein denaturation and starch gelatinization temperatures have been reported
42
43 64 for legumes (Monnet et al. 2019b). Cake quality thus depends on both the raw materials and [the conditions under which](#)
44
45 65 [these are functionalized, which depend on](#) the processing parameters. Processing comprises single or multi-stage mixing
46
47 66 followed by baking. Monnet et al. (2019c) showed that, in multi-stage mixing, the order, speed and length of the mixing
48
49 67 steps of the ingredients might influence the cake end structure. Taking into account both raw material variability and
50
51 68 influential processing parameters, these authors built an experimental design to study the effect of [7 explanatory](#) variables
52
53 69 on 6 dependent variables of cake structure (cake density, cake symmetry, crumb stiffness, cell fineness, thickness of cell
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55 70 walls and crumb lightness). Experimental designs generally aim to account for a large number of effects with a minimum
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57 71 number of trials (Hunter and Muir 1991; [Weissman and Anderson 2015](#)). However, a review of [existing food studies on](#)

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5 72 [product optimization](#) show that experimental designs usually include only two or three [explanatory](#) variables (Battaiotto
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7 73 et al. 2013; Bitaraf et al. 2012; Kayacier et al. 2014; Milde et al. 2012; Saxena et al. 2012; Tan et al. 2012; Turabi et al.
8
9 74 2008).

10
11 75 Among the [explanatory](#) variables [chosen by Monnet et al. \(2019c\)](#), flour quality variables included the proportion of pea
12
13 76 flour in the total mass of flour, the particle size of the pea flour, and the particle size of the wheat flour. These properties
14
15 77 were identified as the most likely variabilities associated to the production of composite flours from wheat and legume
16
17 78 intercrops harvested and ground together. [The remaining explanatory variables corresponded to](#) processing variables
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19 79 used to adjust cake quality; [they](#) were related to batter mixing (liquids and oil mixing speeds, oil mixing time) and to the
20
21 80 baking program. They were chosen as the most influential among a broader set of variables following a phase of
22
23 81 preliminary tests (Monnet et al. 2019c).

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25 82 A full factorial experimental design with the quadratic variations of the dependent variables would require a total of
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27 83 19 683 trials. Consequently, the choice was made of an optimal design. Optimal designs are custom designs that make it
28
29 84 possible to reduce further the number of trials, and to include specific constraints such as blocking factors while
30
31 85 minimizing the variance of the estimators of parameters (Del Castillo 2007; Goos and Jones 2011). [An I-optimal design](#)
32
33 86 [was chosen. I- optimality refers to the orientation of the design towards a good prediction capacity of the model through](#)
34
35 87 [the minimization of the average variance of prediction, while D-optimality aims to minimize the variance of factor-effect](#)
36
37 88 [estimates thus giving priority to modelling precision \(Del Castillo 2007; Goos and Jones 2011; Goos et al. 2016\). In](#)
38
39 89 [order to build an efficient correction tool, I-optimality was thus preferred to D-optimality. This choice was supported by](#)
40
41 90 [the diagnosis of simulated optimal designs as well as existing literature guidelines \(Jones and Goos 2012\).](#)

42
43 91 The resulting experimental design only required 56 trials and 8 days of experiments, which was much more feasible.
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45 92 This I-optimal design allowed the building of a multiobjective model to correct variations in the physical properties of
46
47 93 the cake by adjusting the processing parameters. The multiobjective model was obtained by taking all responses into
48
49 94 account simultaneously in the selection of the most significant effects. The prediction capacity of the model was validated
50
51 95 [with two trials within the space design repeated three times each, several weeks apart.](#)

52
53 96 This specific approach from Monnet et al. (2019c) was contrasting with existing literature on modelling and optimization
54
55 97 based on experimental designs. Indeed, with two or three [explanatory](#) variables, experimental designs include generally
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57 98 less than 20 trials (Battaiotto et al. 2013; Bitaraf et al. 2012; Kayacier et al. 2014; Milde et al. 2012; Saxena et al. 2012;

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99 Tan et al. 2012; Turabi et al. 2008). They define the models for the variation of the responses independently and predict
100 an optimum condition with no experimental validation of the model. However, the study from Monnet et al. (2019c)
101 shared some gaps with available literature. In the literature, the prediction capacity of the models is rarely used to simulate
102 variations in responses following a change in the variables, or to simulate a correction of the variables needed to reach a
103 goal. Moreover, while the relationship between instrumental and sensory data has been widely studied with the aim of
104 reducing dependence on human involvement in predicting sensory perception (Jha et al. 2013; Lassoued et al. 2008;
105 Penci et al. 2013), the correction efficiency of a model designed using a response surface methodology has never been
106 evaluated from the viewpoint of descriptive sensory analysis. In the study of Monnet et al. (2019c), similarly, the
107 efficiency of the model in correcting variations in flour quality was not evaluated, and the resulting corrections were not
108 compared with the differences perceived by consumers.

109 The aim of the present study was to evaluate and explain the correction efficiency of a multiobjective model based on
110 instrumental evaluation of cake properties. To this end, two case studies were designed to evaluate variations in flour
111 quality. A desirability function (Costa et al. 2011) was used to define the changes in the processing settings required to
112 obtain the properties of the target product despite variations in the quality of the raw material. The physical properties of
113 the original, degraded and corrected products obtained were compared to evaluate the correction efficiency at
114 instrumental level. Based on a broad range of sensory attributes, their differences were then assessed by a trained panel
115 through descriptive sensory analysis. The products were tested alongside a set of products representative of the diversity
116 of cakes generated by the I-optimal design.

117 2. Materials and methods

118 1. Materials

119 Wheat flour (55% extraction rate, 9.5 wt% protein, 13.9 wt% moisture, 0.5 wt% ash) was supplied by Grands Moulins
120 de Paris (Ivry-sur-Seine, France) and pea flour (21.4 wt% protein, 9.8 wt% moisture, 2.1 wt% ash) was supplied by
121 Moulin Meckert-Diemer (Krautwiller, France). [Moisture contents were determined by oven drying for 90 min at 130 °C](#)
122 [\(French standard NF V03- 707\)](#), and [ash contents by dry combustion for 90 min at 900 °C \(French standard NF V03-](#)
123 [720\)](#). [Protein contents were analyzed using the Kjeldahl procedure \(AACC 46-12 standard method\) with the most usual](#)
124 [conversion factors of 5.7 for wheat flours and 6.25 for legume flours](#). The pea fine fraction, which was found to [impact](#)
125 the [cell](#) structure of cakes (Monnet et al. 2019c), was obtained by sieving pea flour and characterized as described in
126 Monnet et al. (2019a). Other cake ingredients and their suppliers are as follows: pasteurized liquid whole eggs containing
127 9.5 wt% of proteins and 82.6 wt% of water (Ovoteam, Locminé, France), rapeseed oil (Lesieur, Asnières-sur-Seine,
128 France), white sugar (Saint Louis Sucre, Paris, France), glucose syrup DE40 containing 17.40 wt% of water (Louis
129 François, Croissy-Beaubourg, France), glycerol (Louis François, Croissy-Beaubourg, France), emulsifier Spongolit ®
130 542 (BASF France S.A.S, Levallois-Perret, France) containing 6.8 wt% of proteins, 1.2 wt% of water and 92 wt% of
131 lactic and acetic esters of mono- and diglycerides of fatty acids, baking powder (Dr. Oetker France S.A.S, Schirmeck,
132 France), and salt of commercial grade.

133 2. Batter and cake preparation

134 The cake formula was an industrial formula taken from Dewaest et al. (2017). It was composed of 350 g flour, 135 g
135 eggs, 125 g sugar, 118 g glucose syrup, 110 g water, 80 g rapeseed oil, 62 g glycerin, 17 g emulsifier, 12 g baking
136 powder, and 2 g salt for a total batch of 1011 g of batter. The batter and cake were prepared following the reference
137 procedure in Monnet et al. (2019c) based on industrial standards. All baking conditions (temperature; time) were chosen
138 in order to obtain cakes with 0.75 as a_w value. Cake water content and water activity were verified to be the same for all
139 trials ([data available in Online Resource 1](#)).

140 [Online Resource 1](#) Cake water content and water activity

141 Two sets of products were prepared giving a total of 12 products. The first set was a selection of seven products amongst
142 the 56 trials generated by the I-optimal design (Monnet et al. 2019c). The selection logic is described and discussed in

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5 143 the results section. The settings of the [explanatory](#) variables for these products are presented in Table 1. The second set
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7 144 of products [was related](#) to the correction case studies.

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9 145 In the first case study, the proportion of pea flour was increased from 0% to 35% in a cake produced following the
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11 146 reference procedure. The proportion of 35% was chosen because it corresponded to the best estimated balance in the
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13 147 essential amino acid profile. The 0% pea cake was the “target product” (T1); its settings are listed in Table 2. Its physical
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15 148 properties were measured to define the target for the desirability function. The “degraded product” (D1) was the cake
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17 149 with 35% pea flour produced using the same processing settings as T1 above (Table 2). The desirability function was
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19 150 used to define the processing settings of the “corrected” 35% pea cake (C1). The correction consisted in increasing the
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21 151 liquids mixing speed from speed 171 to 266 rpm (rotation of the mixing arm in the planetary movement, corresponding
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23 152 to an increase of the KitchenAid setting from 4 to 8), the oil mixing time from 1 to 5 min, and decreasing the baking
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25 153 temperature from 180 °C to 179 °C. Baking time changed as a result from 18.0 to 18.3 min, following a linear dependency
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27 154 of cake water activity to baking time that was established previously in the range of baking temperatures covered by the
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29 155 study (results not shown). [This temperature and time adjustments were very small and might become negligible in real](#)
30
31 156 [industry conditions. However, baking temperature was shown to be the second most influential explanatory variable after](#)
32
33 157 [the proportion of pea flour and before the mixing parameters \(Monnet et al. 2019c\).](#)

34
35 158 In the second case study, the proportion of the pea fine fraction was increased from 50% to 100% in a cake with 35%
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37 159 pea flour produced following the reference procedure. The target product (T2) was a 35% pea cake with 50% pea fine
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39 160 fraction like product D1; it was experimentally the same product as the degraded product D1 (same batch of production).
40
41 161 The degraded product (D2) was a 35% pea cake with 100% pea fine fraction produced following the same procedure
42
43 162 (Table 2). The desirability function, set with the physical properties of T2 as the target, proposed the following changes
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45 163 to produce the corrected product C2: a decrease in liquids mixing speed from 171 to 104 rpm (KitchenAid setting from
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47 164 4 to 1), an increase in oil mixing speed from 104 to 115 rpm (Kitchen Aid setting from 1 to 2), and a decrease in baking
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49 165 temperature from 180 °C to 165 °C.

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51 166 After the experimental conditions were defined, all the products were produced in duplicate for assessment of their
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53 167 physical and sensory properties and evaluation of the reproducibility of cake processing at a given time. Moreover, the
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55 168 repetitions of target products T1 and T2, already produced a few months earlier for the desirability function, were named
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57 169 T1’ and T2’. Some differences in the physical properties of these repetitions were observed. The differences can be
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4 170 explained by seasonal variations in room temperature during the six-month period of the experiments and represent cake
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6 171 processing reproducibility taking into account flour aging phenomenon as pointed out by Dewaest et al. (2018).

8
9 172 [TABLE 1]

10
11 173 [TABLE 2]

12
13 174 **3. Cake instrumental properties**

14
15 175 The set of cake physical properties measured corresponded to the response variables taken into account in the I-optimal
16
17 176 design described in Monnet et al. (2019c). They comprised cake density ($\text{g}\cdot\text{cm}^{-3}$), symmetry index, crumb stiffness (kPa),
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19 177 cell fineness (PC1 score), cell wall thickness (PC2 score), and crumb lightness (L).

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21 178 The cakes were weighed immediately after being unwrapped, and their volume was measured using a laser-based scanner
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23 179 (VolScan Profiler, Stable Micro Systems, Surrey, UK) with an increment of 2 mm and a rotation speed of 1 rps. Cake
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25 180 density ($\text{g}\cdot\text{cm}^{-3}$) was calculated from the ratio of their mass (g) to their volume (cm^3). The laser-based scanner provided
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27 181 a profile of the cake representing the change in its circumference along its longitudinal axis through the succession of 46
28
29 182 to 47 slices separated by an increment of 2 mm (total cake length was approximately 90 mm). This data was used to
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31 183 calculate an adapted symmetry index as defined by the AACC method 10-91 (AACC, 2010). The height in the center of
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33 184 the slice was measured on three slices situated respectively at one fourth (B), one half (C), and three fourths (D) of the
34
35 185 cake length, and the usual calculation was done ($\text{symmetry index} = 2 \times C - B - D$).

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37 186 The mechanical properties of the cake were determined after 1 week of storage using a TAHD plus texture analyzer
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39 187 (Stable Micro Systems, Surrey, UK) equipped with a 750-kg load cell. Just after the cake was unwrapped, a cutting
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41 188 template and a bread knife were used to remove its top crust and a part of the four sides to obtain rectangular crumb
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43 189 samples (length 58 mm, width 26 mm, height 26 mm) located in the bottom center of the cakes. Each sample was
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45 190 subjected to 90% uniaxial compression with a 10-cm diameter aluminum plate at a constant speed of 2 mm/s (pre-test
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47 191 speed 1 mm/s, trigger force 0.5 N). The resulting curves of force (N) versus distance (mm) were converted into stress-
48
49 192 versus-strain curves using the sample dimensions. The apparent Young modulus of the aerated crumb, representing
50
51 193 crumb stiffness, was calculated as the initial slope of the stress-versus-strain curve.

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53 194 The cell structure of the crumb was characterized using image analysis by mathematical morphology described in
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55 195 Dewaest et al. (2018). For image acquisition, the cakes were cut with a bread knife along their longitudinal axis. Both
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57 196 sides were gently cleaned with a brush to remove loose crumbs from the cellular structure and the sample was placed on

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4 197 a flatbed scanner (HP Scanjet G31110, Hewlett-Packard, Palo Alto, CA, USA). A black box was placed on top of the
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6 198 sample, and a full color image was acquired at a resolution of 600 dpi. The program for image processing was run using
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8 199 Matlab Software version 7.9.1.705 (The MathWorks, Natick, MA, USA), and the PCA was realized with XLSTAT
9
10 200 Software version 18.06 (Addinsoft, Paris, France). In this study, interpretation of the similarity map of the cake crumb
11
12 201 structures gave PC1 as the expression of cell fineness and PC2 as the expression of cell wall thickness.
13
14 202 Crumb color was measured using a spectrophotometer (Spectro-guide 6834, BYK-Chemie GmbH, Wesel, Germany)
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16 203 with standard illuminant D65. One cake per batch was cut with a bread knife along its longitudinal axis, and one of the
17
18 204 two sides was chosen for color measurement. After calibration and verification of the measurement repeatability on the
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20 205 first sample, color measurement was made one time at the center of the longitudinal slice for each cake. Results are
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22 206 expressed in the CIE L*a*b space.
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26 27 208 **4. Descriptive sensory analysis**

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29 209 A panel of 11 volunteers (10 females, 1 male, aged between 22 and 56) were recruited among AgroParisTech staff. The
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31 210 panelists were recruited based on their willingness to participate and all the panelists gave their free and informed
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33 211 consent. They were in good health at the time of testing and were compensated for their participation at the end of the
34
35 212 study. The descriptive analysis procedure was based on conventional **Quantitative Descriptive Analysis** (Lawless and
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37 213 Heymann 2010). A total of six sessions was necessary to set up the panel: two sessions were dedicated to the generation
38
39 214 and selection of attributes and four sessions to training in the use of these attributes for quantitative description of the
40
41 215 products. All 12 products were used but were grouped differently in each session.

42
43 216 The first training session was devoted to generating the attributes. During this session, the panelists developed a
44
45 217 vocabulary including appearance, texture when touched, oral texture, flavor, and aftertaste in order to describe
46
47 218 differences between the products. During the second training session, they selected 16 attributes to distinguish between
48
49 219 the products, agreed on their definition and on the limits of the intensity line scales (Table 3). **The panelists were trained**
50
51 220 **in the proper use of a 10-cm unstructured linear scale which extremities were defined as “very weak” and “very intense”**
52
53 221 **perceptions.**

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55 222 During the four following training sessions, they were trained to evaluate the intensities of the attributes on series of five
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57 223 products. Sessions were designed so that panelists were trained on all products, and all sessions were repeated twice.
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4 224 Then, evaluation of the 12 products was organized over six sessions, including repetitions. Only four samples were
5
6 225 evaluated during a session. The products were presented to the panelists successively and each attribute was rated on [the](#)
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8 226 10-cm unstructured line scale. The cakes (small individual, approx. 40 g) were presented on 3-digit coded plastic plates,
9
10 227 in monadic sequential order according to the Williams Latin Square to balance the order of presentation. As cake formula
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12 228 contained emulsifiers, the evolution of the crumb texture due to staling was so slow that it became noticeable only after
13
14 229 several weeks (Dewaest et al. 2018). Thus, samples were evaluated between one day and one week after fabrication
15
16 230 without any noticeable sensory bias. Training and evaluation sessions were conducted in individual booths under white
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18 231 light, in an air-conditioned room (20 °C). The panelists were asked to rinse their mouth with mineral water between
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20 232 samples.
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25 234 **5. Statistical analysis**

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27 235 JMP software version 13.1.0 (SAS Institute Inc., Cary, SC, USA) was used for multiobjective optimization of the
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29 236 responses based on the I-optimal design presented in Monnet et al. (2019c). A composite desirability function was used
30
31 237 to define the changes in the settings of the processing variables between degraded products (D1, D2) and corrected
32
33 238 products (C1, C2) in order to target the physical properties of the target products (T1, T2). The composite desirability
34
35 239 function corresponded to the weighted geometric average of individual desirability functions for the six responses of
36
37 240 §2.3 (weight = 1).

38
39 241 XLSTAT Software version 18.06 (Addinsoft, Paris, France) was used to perform hierarchical cluster analysis (HCA),
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41 242 principal component analysis (PCA), analysis of variance (ANOVA), and Generalized Procrustes Analysis (GPA)
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43 243 (Gower 1975). An HCA (Euclidian distances, Ward's criterion) and a PCA were performed on the instrumental properties
44
45 244 of the 56 trials from the I-optimal design to select a set of products representative of the design space amongst the clusters
46
47 245 of distinctive properties and to illustrate the distribution of the clusters as a function of the most distinctive response
48
49 246 variables, respectively. [The instrumental properties of the 56 trials from the I-optimal design from Monnet et al. \(2019c\)](#)
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51 247 [used for the analyses are available in Online Resource 2.](#)

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53 248 **[Online Resource 2 Instrumental properties of the 56 trials from the I-optimal design](#)**

54
55 249 A second PCA was performed of the instrumental properties of the 56 trials as principal observations and the instrumental
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57 250 properties of the products representative of the design space and of the products from the case studies as supplementary
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4 251 observations. This PCA revealed variations in instrumental properties through correction in the two case studies
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6 252 expressed as a function of the most distinctive response variables. The overall and individual homogeneity,
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8 253 discrimination ability and repeatability of the panel performances were validated using ANOVA; the consensus among
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10 254 panelists was checked with GPA. For each attribute, a three-way ANOVA (overall performance) or a two-way ANOVA
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12 255 (individual performance) was performed on the effects of product, repetition and panelist (only for overall performance)
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14 256 with their estimable interactions. In the ANOVA, when significant differences between products were revealed ($P \leq$
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16 257 0.05), mean intensities were compared using Tukey's HSD test ($P \leq 0.05$). The conclusion of the test was an ability of
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18 258 the panel to evaluate the cake sensory properties using the 16 attributes and to discriminate them in a homogeneous and
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21 259 repeatable way. Finally, a PCA was performed on the sensory properties of the 12 products tested by the panel with their
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23 260 instrumental properties as supplementary observations.

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25 261 [TABLE 3]
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29 263 **3. Results and discussion**

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31 264 **1. Selection of products representative of the design space**

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33 265 A hierarchical cluster analysis (HCA) was performed to select a reduced number of products to represent the differences
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35 266 in instrumental properties of the 56 trials generated by the I-optimal design. This approach assumed that two products
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37 267 with similar instrumental properties must have similar sensory properties. The dendrogram obtained from the HCA is
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39 268 shown in Fig. 1a. Six clusters of products were identified among the 56 trials. The clusters were unequal in size,
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41 269 containing between four (clusters A, B, F) and 18 products (clusters C and D). They are represented on the product maps
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43 270 of the principal component analysis (PCA) of the instrumental properties according to principal components 1 and 2
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45 271 (Fig. 1c) and principal components 2 and 3 (Fig. 1e). The corresponding loadings plots are presented in Fig. 1b and 1d.
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47 272 The six clusters were well separated according to the two first components that accounted for 72% of the variance (Fig.
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49 273 1c). The first component mainly represented the variation in crumb stiffness and discriminated cluster F from cluster E,
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51 274 and from clusters A to D. The second component, accounting for 24% of the variance, did not directly represent the
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53 275 variation of any response. Density and cell wall thickness (CWT) were expressed in the first quartile and discriminated
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55 276 cluster F and cluster D from the other clusters. Crumb lightness and cell fineness (CF) were expressed in the last quartile
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57 277 and discriminated cluster B from clusters A and C, and from clusters D to F. Thus density and CWT were not correlated
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4 278 with crumb lightness and CF. The third component, accounting for 15% of the variance, mainly represented the variation
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6 279 in symmetry index (Fig.1d) but it was not used by the HCA to discriminate the products.
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8 280 Clusters represent groups of products with similar instrumental properties. The clusters were used to identify the products
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10 281 whose value was the closest to the minimum, mean, or maximum of the response distribution for each of the six
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12 282 instrumental responses. The products that fulfilled this condition for several responses at the same time were selected in
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14 283 order to reduce the number of products to test in sensory analysis. Fig. 2 shows photos of the seven products selected (3
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16 284 & 17 from cluster A, 19 & 29 from cluster C, 9 from cluster D, 7 from cluster E, 18 from cluster F) plus product 8 from
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18 285 cluster B that was eliminated because its highly fragmented cell structure was judged unsuitable for sensory analysis.
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20 286 Indeed cluster B comprised the maximum values of the fineness and lightness distributions. Consequently product 8 was
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22 287 replaced by product 19 from cluster C and product 3 from cluster A, these products exhibited respectively the closest
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24 288 values of lightness and fineness at the time of the I-optimal design (product 3 exhibited a lower value of fineness when
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26 289 it was produced in the present study). The presence of a second product in clusters A and C (products 17 & 29) made it
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28 290 possible to cover the broadest range of symmetry values (Fig. 1d and 1e). The photos in Fig. 2 reveal the range of the
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30 291 instrumental properties, illustrated for example by products 18 and 19 that differ in density, crumb stiffness, CF, and
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32 292 crumb lightness.

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39 296 **Fig. 1** Hierarchical cluster analysis dendrogram (a) showing the distribution of the 56 trials in clusters according to their
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41 297 instrumental properties; (b-e) Principal component analysis (PCA) of instrumental properties with loadings plots (b; d)
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43 298 and product maps with qualitative identification of the clusters (c; e): (b-c) PCA on the PC1 and PC2 plan (71.6% of
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45 299 information); (d-e) PCA on the PC2 and PC3 plan (38.7% of information).

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49 301 **Fig. 2** Photos of the longitudinal sections of the cakes and (on the right) close ups of the crumb structure of the
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51 302 products representative of the six clusters. Mean values of the instrumental properties are given for each product, with
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53 303 minimum and maximum values in italics and bold. CF: cell fineness; CWT: cell wall thickness; L*: crumb lightness.

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5 304 **2. Instrumental correction efficiency of the model**

6 305 To visualize the instrumental correction efficiency, the paths between the target, degraded and corrected products were
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8 306 drawn on the product maps of the PCA of the instrumental properties according to principal components 1 and 2 (Fig.
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10 307 3a for case study 1; Fig. 3b for case study 2) and principal components 2 and 3 (Fig. 3c for case study 1; Fig. 3d for case
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12 308 study 2). The most influent response variables of the loadings plots (Fig. 1b and 1c) are identified by the grey arrows on
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14 309 the product maps to help interpretation. The target products T1 and T2 used for the definition of the desirability function
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16 310 were not superimposed with their repetitions T1' and T2' on any of the maps. This corresponded to the differences due
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18 311 to cake processing reproducibility over the 6-month interval. The differences can be seen in Fig. 4 and 5. These
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20 312 differences were used as a benchmark in the analysis of the correction efficiency of the model; they were considered as
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22 313 the maximum acceptable difference between two products in the case studies for the model to correct efficiently.
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27 315 **Fig. 3** Paths for the optimization of cake quality for case studies 1 (a ;c) and 2 (b; d) on the product maps of the PCAs of
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29 316 the instrumental properties in the 56 trials as principal observations (●) and instrumental properties of the products
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31 317 representative of the design space (●) and of the products from the case studies (Δ) as supplementary observations: (a;
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33 318 b) PCAs on PC1 and PC2 (71.6% of information) from case studies 1 and 2 respectively; (b; d) PCAs on PC2 and PC3
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35 319 (38.7% of information) from case studies 1 and 2 respectively.
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4 322 In the first case study, D1 shifted to the right of the map in comparison to T1 and T1'. The introduction of 35% of pea
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6 323 flour in a 0% pea cake caused an increase in crumb stiffness according to the first component, that was further corrected
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8 324 as C1 shifted back near T1 and T1' (Fig. 3a). According to the other significant response variables in the PC1-PC2 map,
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10 325 there was a decrease in crumb lightness and cell fineness for D1 in comparison to T1 and T1' that was also corrected in
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12 326 C1. While the variation in crumb lightness is visible (Fig. 4), it is doubtful whether the variation in cell fineness would
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14 327 be perceived by trained panelists. Finally, the addition of pea flour did not cause any perceptible change in density and
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16 328 cell wall thickness, neither did the correction by adjusting the processing parameters (Fig. 3a). In PC2-PC3 map, all
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18 329 symmetry variations between the products are smaller than the distance between T1 and T1' (Fig. 3c) so it cannot be
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20 330 concluded a perceptible variation in symmetry.
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25 332 **Fig. 4** Photos of the longitudinal sections and (on the right) close ups of the crumb structure of the products of case study
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27 333 1. T1: initial target for the desirability function; T1': target assessed by descriptive sensory analysis; D1: degraded
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29 334 product; C1: corrected product. CF: cell fineness; CWT: cell wall thickness; L*: crumb lightness.
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33 336 In the second case study, the increase in the proportion of pea fine fraction from 50% to 100% in a 35% pea cake caused
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35 337 a modification of instrumental properties that barely outweighed the differences due to processing reproducibility (Fig.
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37 338 3b) except for symmetry (Fig. 3d). Indeed the photos of the cakes revealed fewer differences between the target and
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39 339 degraded products than in the first case study (Fig. 5). The position of C2 in comparison to D2 and T2 and T2' showed
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41 340 that the changes in processing parameters satisfactorily corrected symmetry (Fig. 3d). However, the other variables were
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43 341 not corrected (stiffness and crumb lightness), degraded (cell fineness) or overcorrected (density and wall thickness) (Fig.
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45 342 3b). Overall, these results show that the multiobjective model was able to satisfactorily correct some modifications in
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47 343 the cake properties when they exceed the differences corresponding to processing reproducibility. To further evaluate
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49 344 the model efficiency, the instrumental correction of the properties should now be compared to the changes in properties
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51 345 actually perceived by trained panelists.
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Fig. 5 Photos of the longitudinal sections and (on the right) close ups of the crumb structure of the products of case study 2. T2: initial target for the desirability function; T2': target assessed by descriptive sensory analysis; D2: degraded product; C2: corrected product. CF: cell fineness; CWT: cell wall thickness; L*: crumb lightness.

3. Sensory characterization

Fig. 6 Principal component analysis (PCA) on the PC1 and PC2 plan (80.1% of information) of sensory properties as principal observations and instrumental properties as supplementary observations: (a) loadings plot with sensory variables relative to PC1 axis (—), PC2 axis (- - -), relative to PC1 & PC2 axes (.....), and instrumental variables (-△-); (b) product map with the paths for the optimization of cake quality. In (a) the variables that are statistically significant in the plane are represented in bold characters.

A Principal component analysis (PCA) was performed of the sensory properties of the 12 products according to the 16 attributes with their instrumental properties as supplementary observations. Fig. 6a shows the loadings plot according to the two first dimensions with categorization of the attributes depending on their orientation. The first component accounted for 55% of the variance and expressed the attribute “pasty-sticky” versus, on one hand, the firmness attributes (oral firmness and firmness when touched) correlated with crumb color, and on the other hand, the “toasted” attribute correlated with crust color (Fig. 6a). Instrumentally, it was observed that crumb stiffness varied inversely with crumb lightness and cell fineness (Fig. 1b). Here, instrumental crumb lightness and cell fineness were negatively correlated with sensory “firmness when touched” (-0.798 and -0.854 respectively) and crumb color (-0.865 and -0.839), and positively correlated with the “pasty-sticky” attribute (+0.900 and + 0.853). Instrumental crumb stiffness was positively correlated with sensory “firmness when touched” (+ 0.726) and oral firmness (+ 0.685) although it did not appear clearly in the PC1-PC2 plane. The lower firmness value and the darker color of the crumb perceived by the panelists were thus related to a lower cell fineness measured instrumentally. The cakes with lighter and softer crumbs were perceived as stickier after chewing and before swallowing. The finer cell structure of these cakes could result in faster kinetics of hydration by saliva that would enhance cell breakage and collapse, and early amylolysis, giving rise to a more adhesive bolus. The correlation between toasted flavor and crust color reflected the baking intensity of the cake, driven by baking temperature. Cakes baked at a higher temperature (200 °C, 180 °C, 160 °C) were perceived as less sticky.

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375 The second component accounted for 25% of the variance and expressed the “in-mouth drying” attribute versus the
376 “crumbliness” attribute (Fig. 6a). The “volume”, “brightness” and “crumb aeration” attributes grouped in the third
377 quartile. Crumb aeration, defined as the dense or aerated aspect of the crumb, appeared to be related to the total amount
378 of air incorporated in the cake rather than to cell fineness *per se*. The measurement of cell fineness at the millimetric
379 scale, as well as cell wall thickness, provided additional information to that provided by the panelists’ perceptions.
380 According to the regression coefficients of the multiobjective model (Monnet et al. 2019c), cake density decreases with
381 an increase in mixing speed or baking temperature. The higher volume, crumb aeration and brightness of the cakes
382 perceived by the panelists could result from these factors. The “beany” and “beany persistency” attributes were grouped
383 in the fourth quartile. Finally, the perceptions of “sweet”, “friability” and “crack intensity” were slightly less well
384 represented in the plane of the two first dimensions. This was due to a very high degree of similarity between the products
385 as indicated by the three-way ANOVA on the panel performances (§2.5). The depth of the crack in the crust was
386 perceived as high as the volume of the cake, in accordance with physical observations made on pound cake structure
387 (Monnet et al. 2020). The correlation of the “sweet” perception with the instrumental cell fineness is an original result
388 that brings reflection back to the understanding of perception during oral processing. One can assume that a very fine
389 crumb is more extensively comminuted in mouth after one or two bites, as well as more extensively soaked by saliva
390 which quickly absorbs through the cellular structure thanks to efficient capillary mechanisms. Thus, saliva gets in a faster
391 contact with all cellular surface area, solubilizing more sucrose than for a coarser crumb.

392 Fig. 6b shows the product map. The 12 products were evenly distributed in all directions. In the first case study, the
393 introduction of 35% of pea flour in a 0% pea cake caused a modification according to the first component that was
394 properly corrected (Fig. 6b). Degraded 35% pea cakes (D1) were perceived as less sticky, with firmer and darker crumb,
395 with a darker crust and a more toasted flavor than target 0% cakes and corrected 35% pea cakes. The addition of pea
396 flour using the same processing settings led to the formation of a coarser and stiffer crumb as described in Monnet et al.
397 (2020). Bigger cells were obtained because of the reduced capability of the legume-enriched batter to retain air bubbles
398 during baking, due to its lower viscosity and/or the distribution of bubbles in the batter (Ronda et al. 2011). For the
399 corrected 35% pea cakes, the increase in both egg and sugar mixing rate and oil mixing time, led to a decrease in bubble
400 sizes in the batter and thus in the crumb cell sizes (*i.e.* an increase of the crumb fineness) (Monnet et al. 2020). This is in
401 agreement with the variation observed in instrumental crumb firmness and lightness. However, according to the second

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5 402 component, one modification was not corrected and was even increased by correction. It corresponded to the decrease in
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7 403 crumbliness and to the increase in the “in-mouth drying” attribute. Products 9 and 29 that also received high “in-mouth
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9 404 drying” scores were characterized by a high pea flour content (60%) and high mixing speeds (Table 1). The addition of
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11 405 pea flour from 0% to 35% caused a first increase in the “in-mouth drying” perception and the correction with a higher
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13 406 liquids mixing speed exacerbated it because this dimension was not taken into account in the multiobjective model **which**
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15 407 **focused only on structure and texture properties**. Furthermore, the addition of pea flour caused an increase in the “beany”
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17 408 and “beany persistency” perceptions that was not corrected. The presence of these sensory off-notes in high protein foods
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19 409 were described in literature. Indeed, legume proteins are known to introduce unpleasant **off-notes** (bitter, beany notes,
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21 410 etc.) whatever the food applications (Chumchuere et al. 2000; Jayasena and Nasar-Abbas, 2012; Roland et al. 2017). The
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23 411 reason of the increased perceptions of in-mouth drying, pasty, sticky attributes, and the reduced perception of crumbliness
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25 412 in the corrected 35% pea cake could be related to oral processing. The crumb of the corrected 35% pea cake might be
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27 413 more extensively soaked by saliva than that of the degraded 35% pea cake, becoming stickier on the tongue, without
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29 414 breaking into small pieces. This phenomenon might contribute to a slightly increased residence time in mouth, which
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31 415 could promote off-flavor perception. These off-notes could induce disliking by the consumers. This was also a dimension
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33 416 that was not monitored by the model, but that could be corrected -if desired- by a flavoring of the formula. Finally, the
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35 417 panelists perceived no change in the “volume”, “crumb aeration” and “brightness” attributes between T1’ and D1, but a
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37 418 decrease in them for C1. Compared to the instrumental variation in density, **one** can say that the panelists were highly
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39 419 sensitive to a small instrumental variation.

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41 420 In the second case study, displacement of the products within the **PCA** map was much less important. Only a slight
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43 421 modification according to the second component was observed between T2’ and D2, the latter being grouped with C2.
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45 422 Thus, the panelists perceived the degraded and corrected product as a little less crumbly and a little more “in-mouth
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47 423 drying” than the target product. This confirmed that the modification was barely perceptible from a sensory point of view
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49 424 like from an instrumental point of view. Secondly, this confirmed that the use of our multiobjective model **for flour**
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51 425 **granulometry variations** was neither necessary nor efficient for modifications smaller than differences corresponding to
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53 426 processing reproducibility. Interestingly, the panelists perceived C2 as almost the same as D2, while its instrumental
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55 427 properties were closer to D2 than were those of T2’ because of several overcorrections (Fig. 3b and 3d).

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5 429 **4. Conclusions**

6 430 Multiobjective models that make it possible to predict the best settings of several processing parameters to reach a trade-
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8 431 off between several target properties are very valuable tools for industry. Our model enabled monitoring of cake
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10 432 properties after a variation in flour quality (wheat-pea blend composition, pea fine fraction proportion) among a range
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12 433 of cake physical properties. Through two different case studies, **it was shown** that correction proposed by the model was
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14 434 effective when the modification caused by flour variation exceeded model sensitivity (*i.e. when the difference in*
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16 435 *properties to be corrected is less than once the difference due to usual processing reproducibility, for at least one property*).
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18 436 Otherwise, treatment by the model could lead to overcorrections like in the second case study. Sensory analysis of the
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20 437 products enabled the identification of convergences between measured physical properties and sensory attributes
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22 438 concerning cake volume or density, crumb firmness, color, cell fineness measured directly or through indirect attributes
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24 439 like “pasty-sticky”. In this respect, the sensory correction efficiency of the model was adequate. Moreover, the sensory
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26 440 analysis revealed additional modifications like beany taste, aftertaste, and in-mouth drying that were not taken into
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28 441 account in the model, but could be overcome by a change in the formula or could be considered as new aromatic profiles.
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30 442 Beany notes are unusual notes that consumers are not familiar with at the moment. However, one can imagine that these
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32 443 appreciations might change with time. Even if the multiobjective model is based on instrumental variables, it was shown
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34 444 to be a very efficient tool to manage variations in flour composition simply by modifying processing parameters.
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41 447 **5. Acknowledgements**

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53 453 **Data availability statement:** The authors declare that the data supporting the findings of this study are available within
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55 454 the article and its supplementary information files.
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Table 1 Experimental conditions for the seven products selected from I-optimal design

X_P Pea flour %; X_{PF} Pea fine fraction %; X_{WF} Wheat fine fraction %; X_{LS} Liquids speed; X_{OS} Oil speed; X_{OD} Oil time; X_B Baking schedule

<i>Flour variables</i>				
<i>Levels of explanatory variables</i>	X_P (wt% of total flour)	X_{PF} (wt% of pea flour)	X_{WF} (wt% of wheat flour)	
Trial #3	10	100	100	
Trial #7	60	50	100	
Trial #9	60	100	100	
Trial #17	10	100	50	
Trial #18	60	0	50	
Trial #19	10	0	100	
Trial #29	60	50	100	

<i>Processing variables</i>				
<i>Levels of explanatory variables</i>	X_{LS} (rpm)	X_{OS} (rpm)	X_{OT} (min)	X_B (°C ; min)
Trial #3	104	104	3	160; 22.5 min
Trial #7	104	104	1	180; 18.0 min
Trial #9	171	342	1	180; 18.0 min
Trial #17	104	104	1	200; 15.0 min
Trial #18	104	104	1	160; 22.5 min
Trial #19	266	218	5	180; 18.0 min
Trial #29	266	342	5	160; 22.5 min

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Table 2 Experimental conditions for the five products from the case studies

X_P Pea flour %; X_{PF} Pea fine fraction %; X_{WF} Wheat fine fraction %; X_{LS} Liquids speed; X_{OS} Oil speed; X_{OT} Oil time; X_B Baking schedule

<i>Levels of explanatory variables</i>	<i>Flour variables</i>			
	X_P (wt% of total flour)	X_{PF} (wt% of pea flour)	X_{WF} (wt% of wheat flour)	
<i>Case study 1</i>				
Target product (T1)	0	0	50	
Degraded product (D1) *	35	50	50	
Corrected product (C1)	35	50	50	
<i>Case study 2</i>				
Target product (T2) *	35	50	50	
Degraded product (D2)	35	100	50	
Corrected product (C2)	35	100	50	
<i>Levels of explanatory variables</i>	<i>Processing variables</i>			
	X_{LS} (rpm)	X_{OS} (rpm)	X_{OT} (min)	X_B (°C ; min)
<i>Case study 1</i>				
Target product (T1)	171	104	1	180; 18.0 min
Degraded product (D1) *	171	104	1	180; 18.0 min
Corrected product (C1)	266	104	5	179; 18.3 min
<i>Case study 2</i>				
Target product (T2) *	171	104	1	180; 18.0 min
Degraded product (D2)	171	104	1	180; 18.0 min
Corrected product (C2)	104	115	1	165; 22.0 min

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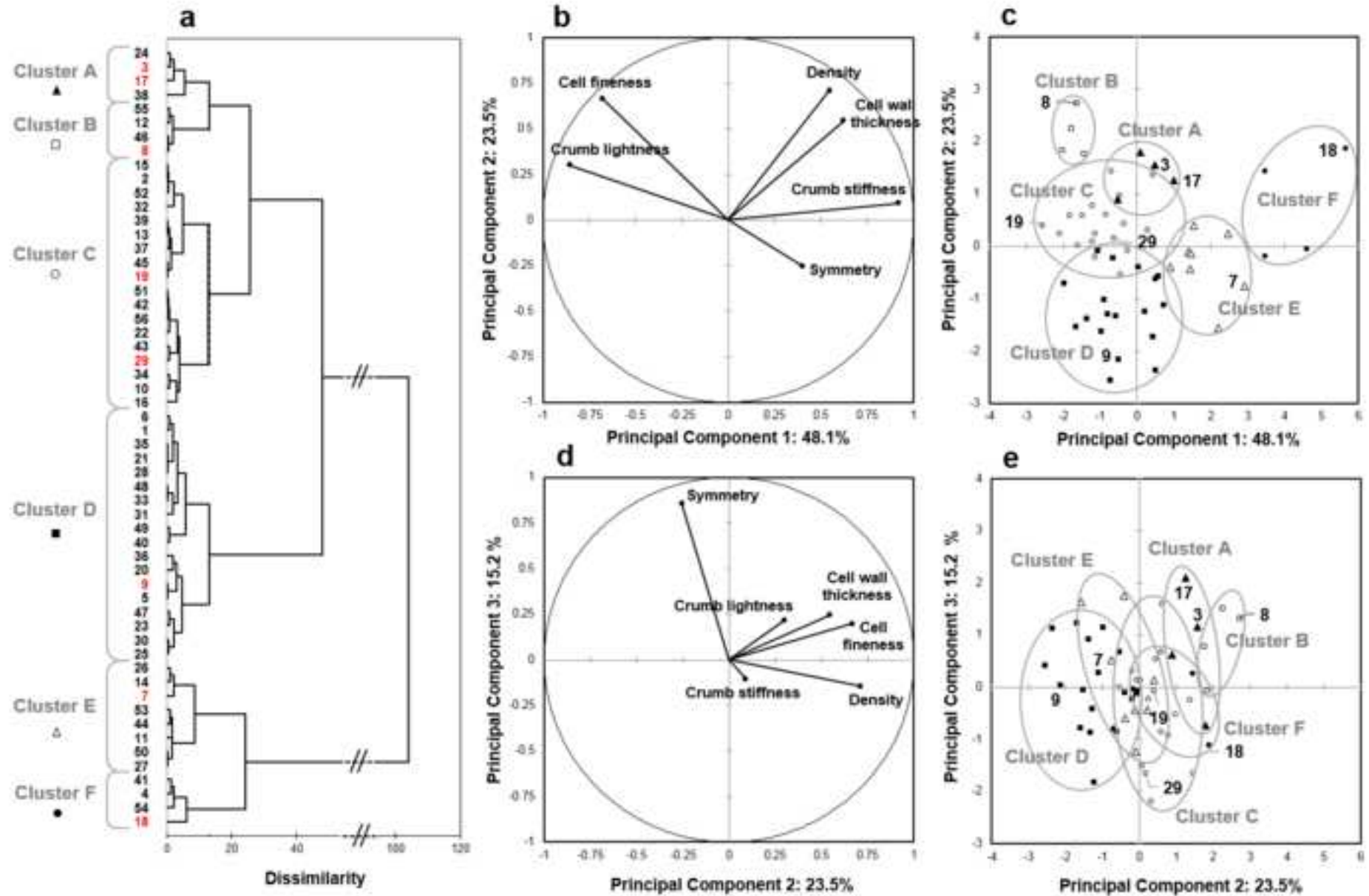
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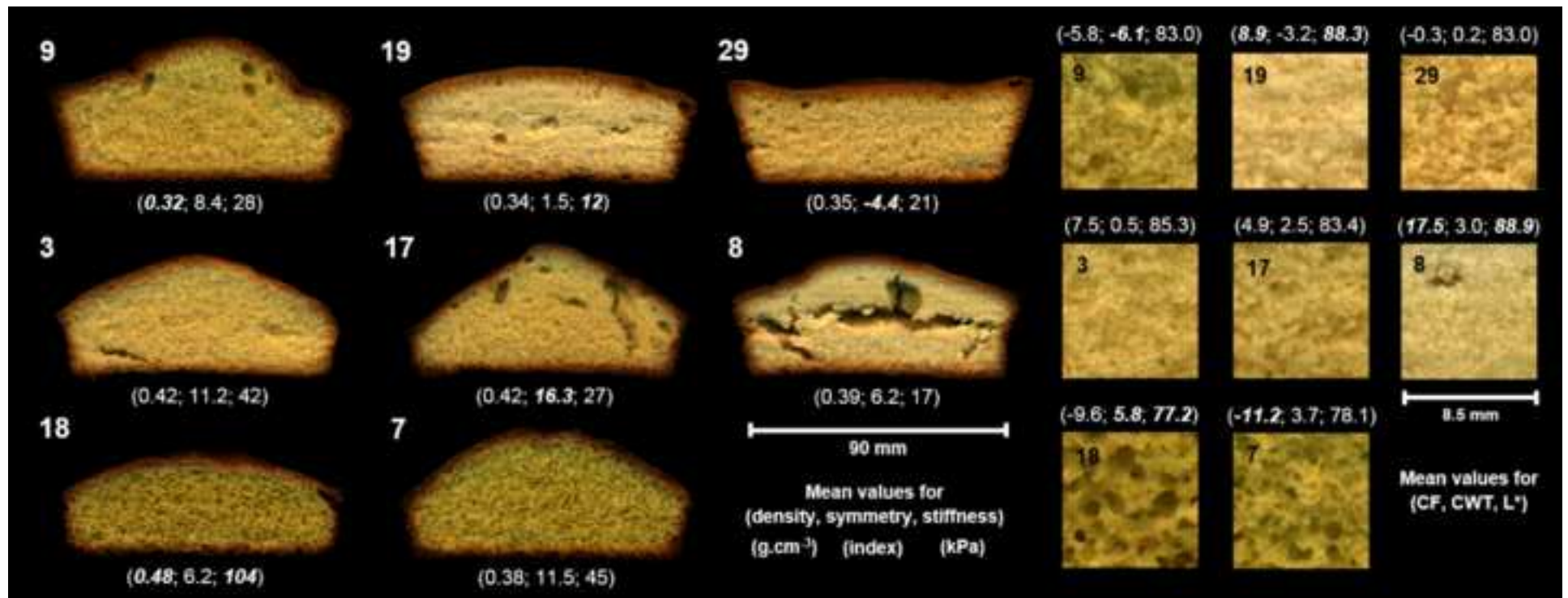
Table 3 List of the 16 attributes and their definitions and intensity scales for cake evaluation
 Scores for each attribute were rated on a 10-cm unstructured linear scale which extremities were defined as “very weak” and “very intense” perceptions.

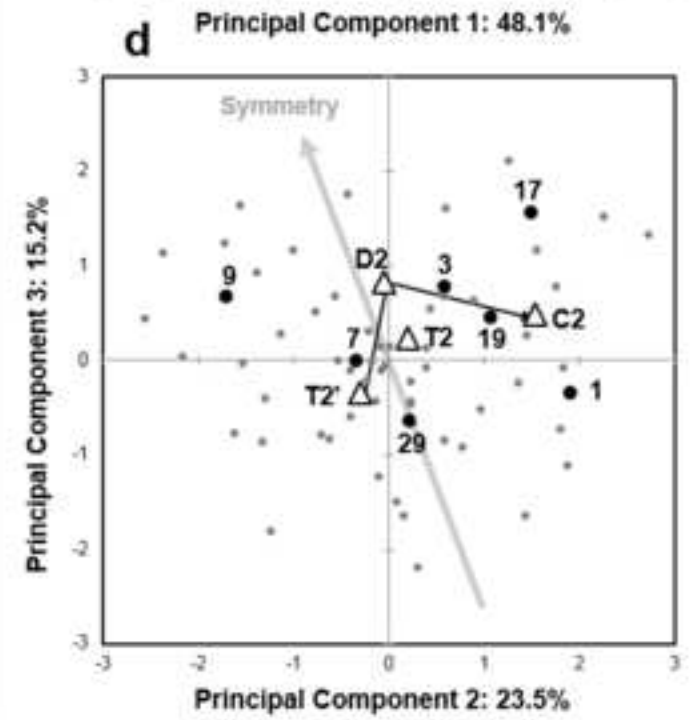
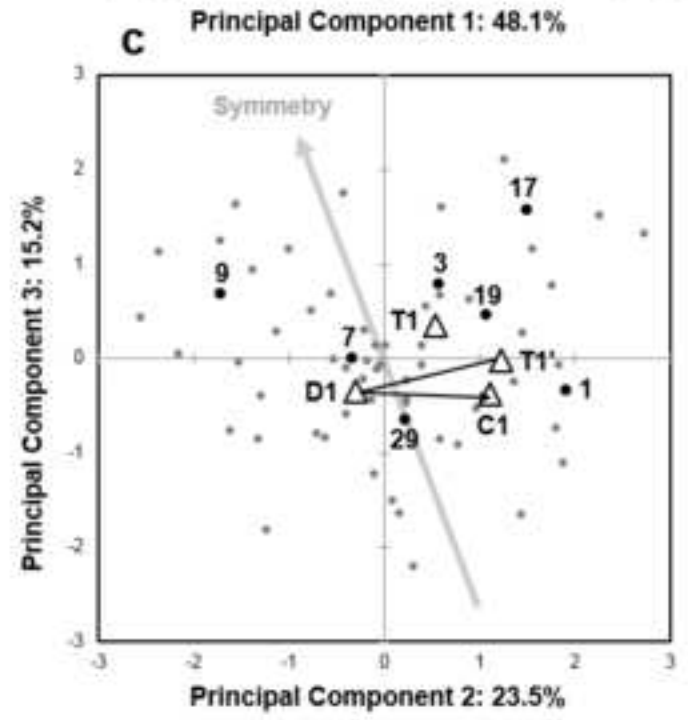
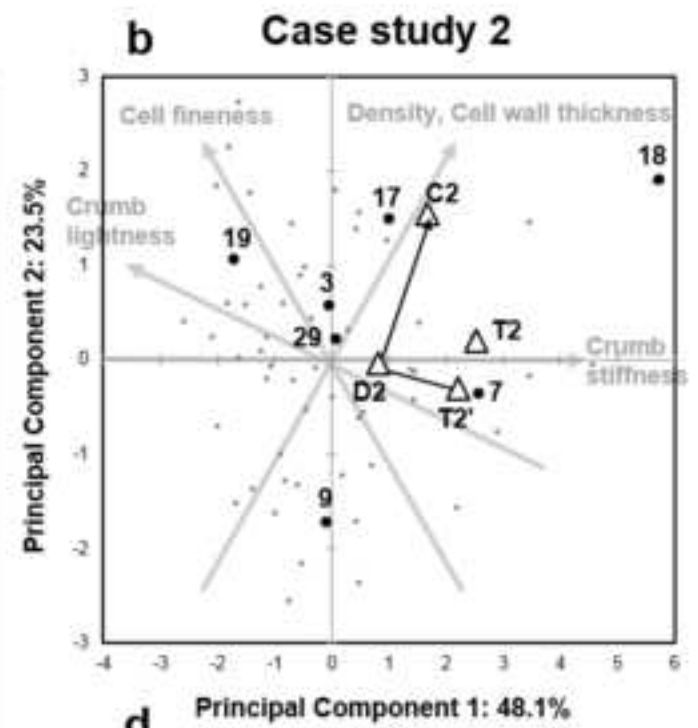
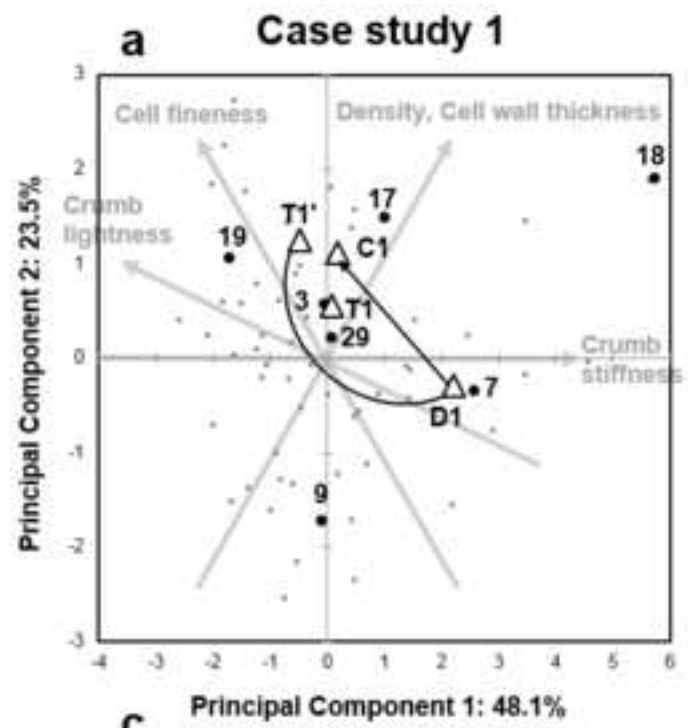
Attribute	Definition	Lower intensity	Upper intensity
<i>Appearance</i>			
Volume	Difference in height between minimum and maximum thickness of the cake along its longitudinal axis	Flat (negative difference)	Domed (positive difference)
Brightness	Intensity of light perception on the crust when tilting the cake with a constant angle, disregarding any cracks in the crust	Mat	Glossy
Crack intensity	Presence of a crack in the crust	No crack	Very marked crack
Crust color	Color of the upper surface of the cake	Light	Dark
Crumb color	Color of the crumb when cut along longitudinal axis	White	Green
Crumb aeration	Overall appearance of the crumb cell structure, disregarding big holes or cracks	Dense, Compact	Aerated
<i>Texture when touched</i>			
Firmness	Perceived firmness when compressing the cake held upside down, thumb on the crust (upwards) and three fingers on the bottom (downwards)	Soft	Firm
Friability	Sensitivity to the formation of crumbs and to overall breakage when breaking the cake longitudinally (i) breaking off a corner with one hand; (ii) breaking it down the center with two hands	Not friable, Keeps its shape	Very friable, Falls apart
<i>Oral texture</i>			
Pasty - Sticky	Overall pasty - sticky sensation after chewing and before swallowing	Dry	Pasty, Sticky
Crumbliness	Sensitivity to crumb formation when rubbing a piece of cake between tongue and palate	Not friable	Very friable
Firmness	Perceived firmness when compressing the central quarter of the second longitudinal half between the molars, during the first chewing	Soft	Firm
<i>Flavor</i>			
Beany	Intensity of beany or green flavor, evaluated on a piece of crumb	Not intense	Very intense
Toasted	Intensity of toasted flavor, evaluated on a piece of crumb and crust	Not intense	Very intense
Sweet	Intensity of sweet flavor, evaluated on a piece of crumb	Not intense	Very intense
<i>Aftertaste</i>			
In-mouth drying	Sensation of drying out of the mouth and lack of saliva, before rinsing	Not drying	Very drying
Beany persistency	Intensity of beany or green flavor 5 sec after swallowing, before rinsing	Not intense	Very intense

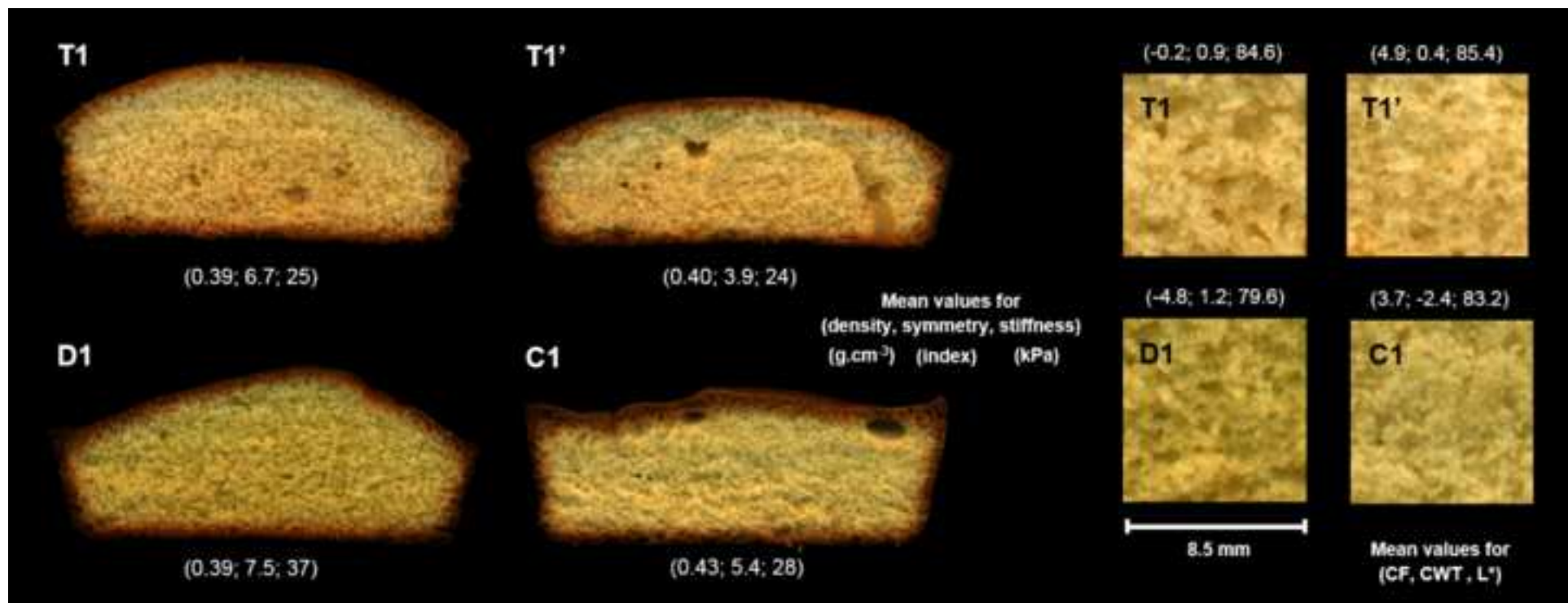
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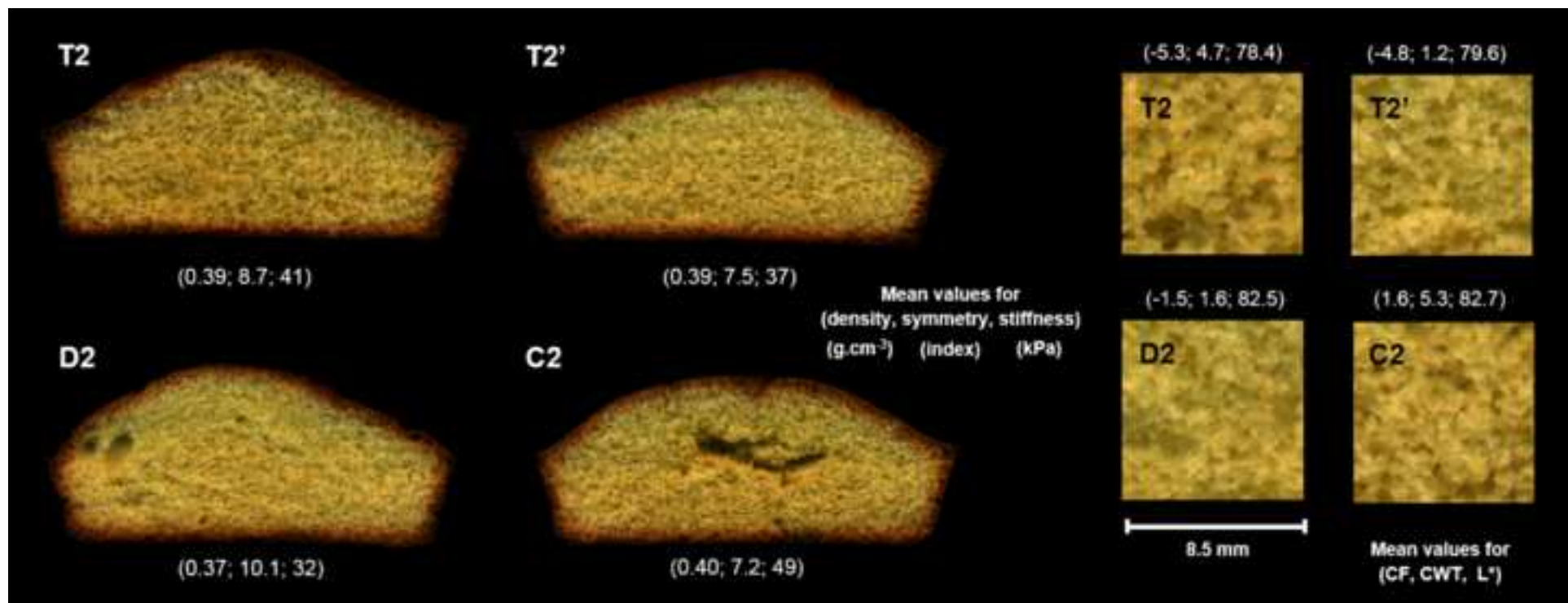
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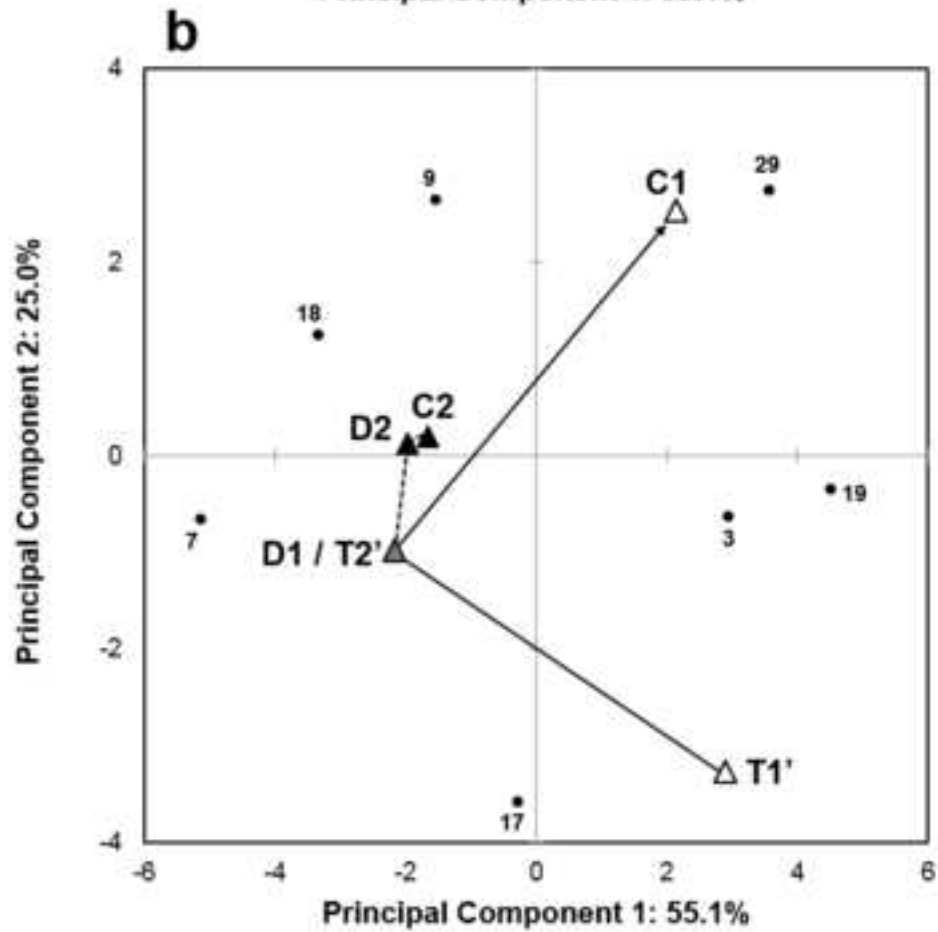
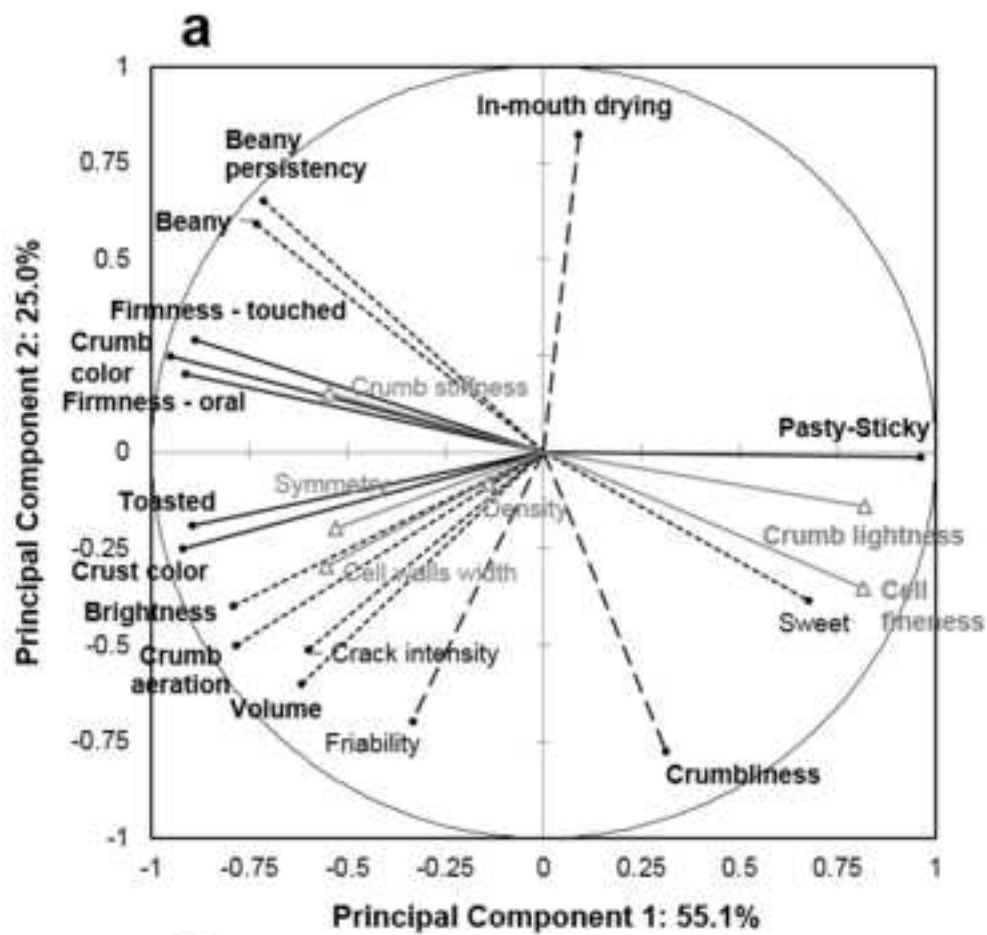












Article Title: Tailoring the properties of pea-enriched soft cakes using a multiobjective model based on sensory-relevant instrumental characterization

Journal Name: Food and Bioprocess Technology

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Online Resource 1 Cake water content and water activity

<i>Products selected from I-optimal design</i>	Water content (wt% of cake)	Water activity, a_w
Trial #3	22.4 ± 0.1	0,757
Trial #7	21.6 ± 0.3	0,752
Trial #9	21.7 ± 0.2	0,713
Trial #17	22.3 ± 0.6	0,737
Trial #18	22.6 ± 0.9	0,733
Trial #19	21.5 ± 1.2	0,718
Trial #29	22.0 ± 0.6	0,711

<i>Products from the case studies</i>	Water content (wt% of cake)	Water activity, a_w
Target product (T1)	21.4 ± 0.1	0,746
Degraded product (D1) *	21.6 ± 0.4	0,755
Corrected product (C1)	21.2 ± 0.1	0,729
Target product (T2) *	21.6 ± 0.4	0,755
Degraded product (D2)	21.4 ± 0.3	0,742
Corrected product (C2)	22.0 ± 0.4	0,738

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Online Resource 2 Instrumental properties of the 56 trials from th

Trial #	Cake density (g.cm-3)	Symmetry (index)
Trial #1	0.33	0.63
Trial #2	0.33	4.27
Trial #3	0.42	11.17
Trial #4	0.42	11.17
Trial #5	0.32	10.20
Trial #6	0.33	5.83
Trial #7	0.38	11.53
Trial #8	0.39	6.23
Trial #9	0.32	8.37
Trial #10	0.39	2.23
Trial #11	0.40	2.57
Trial #12	0.37	0.73
Trial #13	0.34	5.33
Trial #14	0.37	15.80
Trial #15	0.35	5.30
Trial #16	0.42	-2.97
Trial #17	0.42	16.30
Trial #18	0.48	6.17
Trial #19	0.34	1.50
Trial #20	0.31	9.63
Trial #21	0.35	5.00
Trial #22	0.36	-3.23
Trial #23	0.31	13.23
Trial #24	0.40	8.63
Trial #25	0.35	8.33

Trial #26	0.35	17.10
Trial #27	0.38	4.60
Trial #28	0.35	3.50
Trial #29	0.35	-4.37
Trial #30	0.37	10.27
Trial #31	0.36	5.97
Trial #32	0.35	10.77
Trial #33	0.37	5.00
Trial #34	0.38	1.23
Trial #35	0.34	3.50
Trial #36	0.32	9.80
Trial #37	0.34	4.87
Trial #38	0.47	4.00
Trial #39	0.35	4.47
Trial #40	0.37	0.43
Trial #41	0.37	8.27
Trial #42	0.35	-1.77
Trial #43	0.37	-5.43
Trial #44	0.40	6.00
Trial #45	0.35	1.80
Trial #46	0.39	8.07
Trial #47	0.34	14.23
Trial #48	0.37	4.97
Trial #49	0.38	4.60
Trial #50	0.36	3.50
Trial #51	0.36	-1.50
Trial #52	0.36	6.07
Trial #53	0.41	8.47
Trial #54	0.41	7.93
Trial #55	0.39	6.33
Trial #56	0.34	0.13

using a multiobjective model based on sensory-relevant ins

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e I-optimal design

Crumb stiffness (kPa)	Cell fineness (PC1 score)
22.13	1.21
25.84	-2.00
42.31	7.47
89.01	-11.46
20.79	-7.86
19.14	-3.07
44.62	-11.16
16.77	17.49
28.18	-5.83
33.69	-0.18
33.21	-4.70
15.09	17.24
17.03	1.62
35.85	-1.28
30.52	-1.02
21.29	6.41
27.19	4.86
103.67	-9.62
12.29	8.89
10.87	2.65
24.61	-3.78
22.66	0.44
32.90	-7.85
22.38	6.95
27.97	-8.06

42.57	-10.25
43.76	-7.38
22.59	-3.98
20.98	-0.34
28.60	-3.85
52.62	-1.61
19.90	8.10
28.26	0.32
26.54	2.53
24.15	-4.77
25.99	-3.66
15.90	8.16
40.56	3.24
16.35	5.70
32.71	-4.29
79.36	-9.82
14.26	4.36
31.85	-2.61
55.44	-7.47
17.53	6.74
10.81	18.52
24.22	-6.58
17.68	1.84
37.98	-2.32
37.01	-5.35
18.42	5.83
26.12	0.91
37.84	-3.82
81.58	-4.91
18.42	14.90
20.40	1.30

strumental characterization

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Cell wall thickness (PC2 score)	Crumb lightness (L*)
-5.60	86.86
-0.07	84.42
0.50	85.32
3.25	77.58
-6.27	83.66
-6.40	86.52
3.65	78.13
3.03	88.94
-6.09	83.03
3.83	85.15
-0.65	78.78
-0.47	86.20
-1.28	85.78
1.75	81.08
-0.11	85.11
-2.21	83.39
2.48	83.66
5.79	77.24
-3.17	88.26
-3.54	83.78
-5.25	84.22
-2.54	85.14
-2.01	81.75
-2.12	84.88
-0.02	82.06

1.35	80.06
1.92	81.80
-5.53	82.47
0.24	82.98
-0.56	82.83
-3.16	85.64
1.03	85.92
-3.65	85.03
0.44	85.39
-6.31	83.96
-1.12	87.50
-0.22	87.67
-4.08	86.31
-2.93	86.00
-5.97	79.58
4.48	79.68
-0.40	85.62
0.30	81.26
2.68	80.19
-3.38	87.39
1.49	87.66
-2.44	82.25
-3.64	85.23
-4.18	81.07
0.77	81.53
-0.62	84.79
1.69	85.85
0.99	81.49
6.99	81.94
-0.56	86.55
0.57	86.00