



Role of Active Packaging in the Food Industry: A Review

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Authors' contributions

This work was carried out in collaboration among all authors. All authors read and approved the final manuscript.

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Review Article

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ABSTRACT

In response to shifting consumer demands, food packaging's conventional function is continuing to change. Consumer desire for healthier, safer and good quality meals with longer shelf-life is one of the current causes that are challenging the food packaging sector to produce new and better technology packaging solutions. Therefore, Active packaging (AP) can be used to satisfy these requirements. The biggest advantage of Active packaging (AP) is less food waste because the items have a longer shelf life. Undoubtedly, active packaging is a great option for a variety of food sector applications. In the upcoming years, the commercial success of active packaging systems should be anticipated as they represent the growth of food packaging in the future. In this review, a summary of active packaging technologies, including oxygen scavenger, moisture scavenger, ethylene absorber, antioxidant-releaser, CO₂ emitter, and antimicrobial packaging systems are provided. In particular, reviews of scientific studies emphasizing the advantages of these technologies for certain food products are conducted. However, the development of food nano-packaging is still in its early stage, despite having numerous opportunities to enhance packaging materials and functions. Although, due to the advancements in nanotechnology there might be higher chances of enabling the creation of better active packaging. This article also discusses current breakthroughs in food nano packaging based on active nanoparticles.

Keywords: *Oxygen scavengers; ethylene scavengers; antimicrobial; nanomaterial.*

NOMENCLATURES

AP	: Active Packaging
BHA	: Butylated Hydroxyanisole
BHT	: Butylated Hydroxytoluene
EDTA	: Ethylenediaminetetraacetic Acid
EVOH	: Ethylene Vinyl Alcohol
HDPE	: High-density Polyethylene
LDPE	: Low-density Polyethylene
LLDPE	: Linear low-density Polyethylene
NP's	: Nanoparticles
MA	: Modified Atmosphere
MAP	: Modified Atmosphere Packaging
OS	: Oxygen Scavenger
PCL	: Polycaprolactone
PE	: Polyethylene
PET	: Poly (Ethylene Terephthalate)
PLA	: Polylactic Acid
PLGA	: Poly (Lactide-co-glycolic) Acid
PP	: Polypropylene
PVC	: Poly (Vinyl Chloride)

1. INTRODUCTION

Packaging is a crucial component of the food supply chain. The main purpose of food packaging is to increase the shelf life of packaged food materials by inhibiting adverse variations brought on by chemical impurities, temperature changes, microbial spoilage, moisture, O₂, external force and light as well as to maintain the safety and quality of food items from the stage of manufacturing to the end of consumption [1]. The noticeable shifts in customer demand and behavior that are likely to have an impact on the way we utilize as well as anticipate packaging in the upcoming years are driving innovations in packaging [2].

Nanotechnology is the fabrication, modification, and characterization of items, structures, or materials with at least one dimension and a length of 1–100 nm. Additionally, nanotechnology has sparked a new technological growth by enabling a vast scope of opportunities or the creation and application of systems, materials, and structures with novel or better quality in several sectors, including food, agriculture, medicine, and others [3]. In order to increase shelf life, it is also possible to construct nano food packaging to release enzymes, antioxidants, antimicrobials as well as nutraceuticals. Food nanostructured ingredients and food nanosensing are the two main applications of nanotechnology in the food business [4]. The subject of food nanosensing improves the safety and quality of food, but nanostructured food ingredients have a broad spectrum like food packaging and food processing (Fig. 1). The biggest anticipated application of nanotechnology in the food business in the near future is novel food packaging technology, as recently described by Dasgupta and others regarding its usage in the agro-food industries, as one of the quickest developing fields in nano-research [5].

Several types of packaging materials utilized in food industry including improved packaging, active packaging, and smart packaging. The main goal of this article, however, is to give a general summary of active packaging systems which have recently been effectively used in food, emphasizing the advantages for the specific food products. The current commercialization of food packaging containing nanomaterials will also be highlighted.

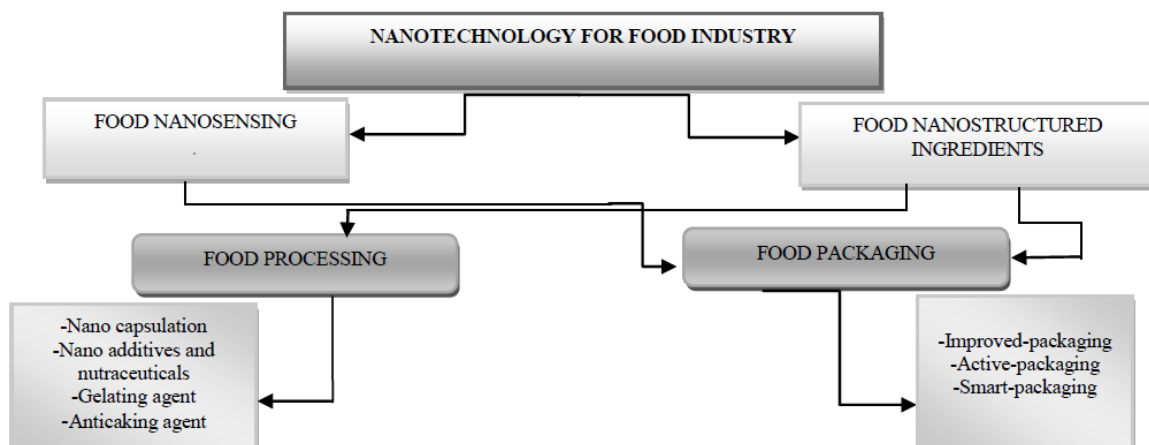


Fig. 1. Use of nanotechnology in several food business sectors

2. ACTIVE PACKAGING (AP)

In AP systems, active substances like ethylene removers, water vapour absorbers, oxygen absorbers, preservatives, and others are purposefully added to packages to increase their protection function [6]. Active packaging systems fall into two groups: active-releasing systems (emitters) and active scavenging systems (absorbers). While the former eliminates undesirable components like odour, ethylene, CO₂, O₂, or moisture from the food or its environment, the latter adds substances like antimicrobials, CO₂, antioxidants, flavours, ethylene, or ethanol to the packaged food or into the headspace (Fig. 2). Nanocomposites (metal NP's like copper, silver, and oxides like magnesium oxide and titanium dioxide), gas scavengers and antimicrobial film are the major components of active food packaging [7].

It extends the standard packaging's capabilities to offer protection, easy to use, prolonged shelf-life and storage period. It has been said that "packing of the future will not only be a barrier but it will also interact with packaged products" [8]. Expert predictions have also been stated that the future of food packaging lies with the newest generations of active packaging.

Active packaging, as opposed to conventional packaging materials, increases the shelf-life of food and maintains its superior quality while interacting with the internal environment and the product [9]. As a result, active packaging

solutions ought to be viewed as a novel approach to food packaging. They interact with the packaged item, alter its surroundings, and regulate its quality all at once.

3. ACTIVE PACKAGING TECHNOLOGIES

3.1 Oxygen Scavenger (OS)

The growth of microorganisms including yeasts, aerobic bacteria, and molds, the existence of O₂ in food packaging hastens product degradation and the oxidation of lipid and vitamins in food. It damages nutrients in food and causes color changes, disagreeable flavors, bad odors, and unpleasant tastes [10]. A high level of oxygen also reduces its shelf life.

The O₂ in headspace gases reacts with perishable food into the package and speeds up the spoilage of various food products (e.g., spices, milk powder, sausages or meat), the breakdown of vitamins, and the rancidification of fatty foods, nuts, and oils as it encourages the growth of microbes. The remaining oxygen levels inside the package are actively reduced by oxygen scavengers.

The oxidative mode of action of the various types of OS could be either: (a) chemical, using cobalt [11], ferrous or iron salts [12], gallic acid, ascorbic acid, fatty acids or photosensitive dyes, (b) biological (through the use of immobilized yeast on a solid material) or (c) biochemical (using enzymes) [13]. Iron is therefore the most prevalent kind of OS.

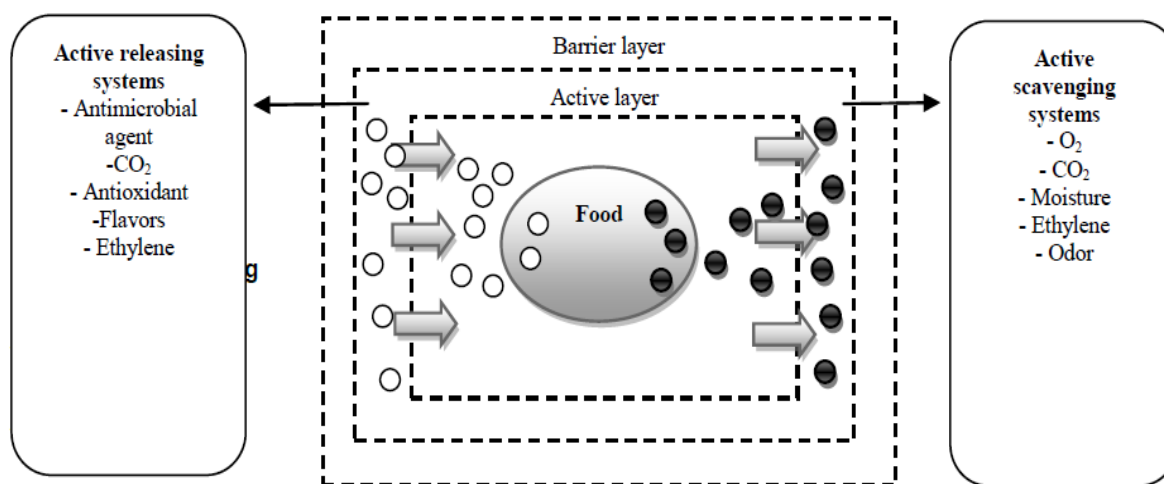
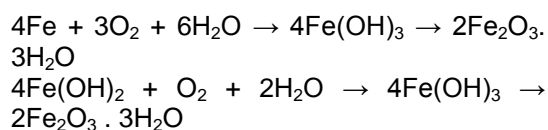


Fig. 2. Active packaging systems

As per the following general theoretical equations, water activates iron-based OS, which then scavenges oxygen:



Mu et al. have developed a nano- Fe based oxygen scavenger (Table 1). Fe-NPs incorporated with and CaCl_2 , NaCl and activated carbon and then filled into sachets [14].

3.2 Moisture Scavengers

The amount of moisture and the activity of the water in various types of meals are important elements impacting their quality and safety. According to Yildirim and others (2019), there are various types of moisture control strategies used in packaging, such as vacuum packaging, which involves removing the humid air from the headspace, moisture prevention (using barrier packaging), moisture reduction (by modified atmosphere packaging or MAP), which involves substituting the humid air in the headspace with dry MA gas, or and moisture elimination (by using a desiccant or absorber) [19]. Table 2 contains some examples of food product applications; however, pads are eliminated because they are already widely utilized in the market.

3.3 Ethylene Absorber

Climacteric respiration is the major metabolic process occurring in many fruits and vegetables after harvesting [24]. Thereby, ethylene, a natural plant hormone, accelerates respiration, leading to maturity, softening the product tissues, and therefore accelerating senescence. On the other side, its accumulation can cause the yellowing of green vegetables and may be responsible for a number of undesirable reactions, such as the development of bitter flavors and chlorophyll degradation.

The most common agent of ethylene removal is potassium permanganate [25], which oxidizes ethylene to acetate and ethanol. Due to its toxicity, however, potassium permanganate cannot be integrated into packaging material with food contact and is therefore usually applied in sachets [26]. Ethylene can also be removed by physical adsorption on active surfaces such as zeolite, clays, or activated carbon, which may be incorporated in packaging materials. Inorganic nanoparticles including metals such as palladium (Pd) or silver (Ag), and metal oxides, such as zinc oxide (ZnO) or titanium oxide (TiO_2), have gained interest due to their attractive physicochemical properties. The authors showed that the Palladium-promoted material efficiently scavenged ethylene that was either exogenously supplied or generated by avocado or banana (Table 3).

Table 1. Oxygen-scavenging packaging systems

Active Substance	Package Material/Application	Benefit	Reference
Iron	In sachets HDPE and LLDPE films + modified kaolinite, NaCl and CaCl_2 , activated carbon and Fe-NPs,	Inhibition of lipid oxidation [14]	[14]
Iron-(II)-chloride and α -tocopherol	Nanoencapsulated polycaprolactone in fish gelatin film	Possibility of use in retortable pouches	[15]
Titanium dioxide	Placed on various polymer films Ethyl cellulose film	Possibility of packets that scavenge oxygen	[16]
Palladium, platinum	Nylon 6,6, PET, LDPE, PP	Regulate the transport of oxygen through active membrane components	[17]
Palladium	Deposited on poly (ethylene terephthalate) film	Potential use in ham and bakery products	[18]
TiO_2 or Alumina (Al_2O_3) and ascorbate enzyme systems	TiO_2 -NPs, edible oils CaAsc /laccase, oleic acid, or Al_2O_3 -NPs Coated or printed on PET films	Formulation of oxygen-scavenging ink for interior packaging surfaces	[13]

Table 2. Moisture-scavenging packaging systems [20-23]

Active Substances	Package Material/Application	Food Tested	Benefit	Reference
CaCl ₂ / sorbitol	Powder in bags/trays in the package	Mushroom	Reduction in browning index (BI 14.8) compared to control (BI 18), better product appearance, and an increase in shelf-life from 1-5 days at 10°C. Decreased moisture condensation inside the packaging.	[20]
Poly (acrylic acid) sodium salt	Powder in porous “tea bag” in sealed containers	Corn	Decrease in the presence of aflatoxin	[21]
Sodium chloride	Thermoformed multilayer trays: polyethylene /foamed hygroscopic ionomer-sodium chloride/polyethylene	Strawberries and tomatoes	Control of in-package RH below 97 percent for seven days at various temperatures	[22]
	Thermoformed multilayer trays: Polypropylene /foamed and stretched polypropylene– Sodium chloride/PE/ethylene vinyl alcohol	Mushroom	Water loss at 5°C decreased from 4.5 to 1.3 g	[23]

Table 3. Ethylene-scavenging packaging systems [24,27-30]

Active Substances	Package Material/Application	Food Tested	Benefit	Reference
Palladium	Zeolite	Banana and avocado	Scavenged ethylene	[27]
ZnO	Coating a poly (vinyl chloride) film	Fresh cut apples	Showed a much lower rate of fruit deterioration	[28]
TiO ₂	LDPE film	Strawberries	The ethylene produced by strawberries in the nano-TiO ₂ LDPE-package was drastically reduced	[29]
Ag	Cellulose-hybrid material	Fresh cut melon	The senescence of the melon cuts was delayed, implying blockage of ethylene-mediated effects on the ripening, resulting in a lesser amount of ripe product.	[24]
Ag + Titanium dioxide	Polyethylene film (+kaolin)	Date, strawberries and bayberries	Browning with climate change were both severely hampered	[30]

3.4 Antioxidant Releaser

The creation of packaging that releases antioxidants for food applications has picked up in recent years. To stop the oxidation of lipid, synthetic antioxidants like butylated hydroxyanisole and butylated hydroxytoluene are frequently employed in food packaging.

On the other hand, due to potential negative effects on human health, customers today prefer to utilize foods devoid of any synthetic additives. Due to their biodegradability and safety, natural antioxidants would be a good replacement for synthetic antioxidants [31,32]. Today's research focuses on adding natural antioxidants to polymer- and biopolymer-based food films [33-36]. Natural antioxidants like essential oils (EOs), plant extracts, tocopherols, and polyphenols, are becoming more and more popular for use in active packaging materials [37,38]. Table 4 summarises a few recent advancements in this area.

3.5 Carbon Dioxide Emitter

CO₂ positively affects the preservation of food's initial freshness and prevents the development of odor-related deterioration [46]. CO₂ is widely

used in the food sector for quality preservation and increased shelf-life due to its beneficial antibacterial qualities.

For poultry, fish, fresh meat, and non-climacteric fruits, high CO₂ concentrations would typically be chosen to successfully inhibit the growth of microorganisms, which lengthens the lag phase and time during the logarithmic microorganism's phase through a complicated array of methods [47]. By incorporating CO₂ emitters into modified atmosphere packaging, it may be possible to boost fill levels, reduce package sizes, increase transport effectiveness, and reduce environmental impact overall. In addition to preventing packaging deformation, the release of CO₂ from a tailored emitter system can offset the initial storage-related CO₂ absorption into the food product.

The active chemicals inside the absorbent pad react when liquid is caught that is leaking out of the product, creating CO₂. When the absorbent pad catches liquid that is leaking out of the product, the active chemicals inside react, releasing CO₂. Table 5 summarises the carbon dioxide releaser techniques that are now present for preserving food, along with their uses and advantages for various food products.

Table 4. Antioxidant- releaser packaging systems

Active Substances	Package Material/Application	Food Tested	Benefit	Reference
Butylated hydroxytoluene	LDPE film	Fresh fish	Less tissue damage, less lipid oxidation, less protein denaturation, and preserved firmness	[39]
BHA, BHT and α Tocopherol	PLGA film	Dry buttermilk powder and dry whole milk	An increase in oxidative stability	[40]
α Tocopherol	Multilayer film: LDPE/high-density polyethylene/ethylene vinyl alcohol low-density polyethylene film Poly (lactic acid) film	Whole milk powder	An increase in oxidative stability	[41]
		Corn oil	An increase in oxidative stability	[42]
		Soyabean oil	An increase in oxidative stability	[43]
Green tea extract	Chitosan film	Pork sausage	Improvement of color and oxidative stability	[44]
Acerola and mango pulp	Cassava starch film	Palm oil	An increase in oxidative stability	[45]

Table 5. Carbon dioxide emitters in packaging systems

Packaging Method with Emitter	Food tested	Quality Parameters	Benefit	Reference
Modified atmosphere packaging (60% carbon dioxide, 40% nitrogen) and vacuum	Cod	Drip loss, microbial assay, sensory analysis	Extension of sensory and microbiological shelf-life and improvement of initial freshness	[46]
MAP (60% CO ₂ , 40% N ₂)	Reindeer meat	Cooking loss, antioxidant capacity, drip loss, pH, sensory analysis, microbial analysis	Reduced drip loss (3.0 wt% in MAP packages without a carbon dioxide emitter, 1.0 wt% in MAP with a carbon dioxide emitter), and decreased growth of bacteria	[48]
MAP (100% CO ₂)	Chicken	Drip loss, microbial assay, pH	Increased sensory and microbiological shelf-life; 100% CO ₂ packing made easier; less drip loss; CO ₂ emitter	[49]
Modified atmosphere packaging (60% CO ₂ , 40% O ₂)	Cod	pH, sensory analysis, drip loss, microbial assay	At a reduced g/p ratio, sensory and microbiological shelf-life are maintained.	[50]

3.6 Antimicrobial Packaging Systems

The primary goal of antimicrobial packaging is to preserve and increase the shelf-life of the food item by prohibiting the microorganism growth. This could be achieved by incorporating an active substance inside the packing material or by adding a coating layer there [51]. Antimicrobial agents behave variably depending on the pathogenic bacteria because of different physiologies. There are two ways that an antimicrobial agent works: either by blocking a microorganism's vital metabolic processes (lactoferrin and ethylenediaminetetra acetic acid act as coupling agents of charged polymers), or by destroying the membrane structure or cell wall. Fig. 3 displays several antibacterial substances that could be used in food packaging methods.

Nanomaterials containing Ag, TiO₂ and ZnO NP's have a good antimicrobial activity which is a very suitable agent for antimicrobial AP systems [52]. Food packaging frequently uses TiO₂ nanoparticles, which are not toxic to humans as well as authorized as food additives and food contact materials [53].

However, the stabilization of essential oils during processing, enhancement of their physicochemical qualities, and enhancement of their health-promoting benefits are all possible by using nanoencapsulation techniques. Herbs and spices offer potentially extremely useful sources

of biodegradable, renewable compounds like polyphenols, which have strong antibacterial and antioxidant effects. They are therefore suitable materials to include in active food packaging [54]. Because of the prevention of microbial growth in various food products, essential oil-loaded biopolymeric nanocarriers in particular exhibit promising antibacterial and antioxidant activity and are appropriate material for active food packaging [55].

Allyl isothiocyanate, natamycin, chlorine dioxide, glucose oxidase, triclosan, silver zeolite and silver are also often utilized as active components in commercially available antimicrobial AP systems [56]. In a very recent study, researchers increased the shelf life of fresh chicken held at 4°C by several polyethylene films containing TiO₂ and Ag nanoparticles and created as potential active packaging films. The findings showed that the most effective antimicrobial film for both gram-negative bacteria (*Escherichia coli*) and gram-positive (*Staphylococcus aureus*) was one that contained 5% Ag and 5% TiO₂ nanoparticles [57]. Ag nanoparticles and Accasellowiana extracts functionalized into nanocomposite poly (ethylene oxide) films also showed antibacterial activity against *Escherichia coli* and *Staphylococcus aureus* [58]. Antimicrobial nanoparticles are examined independently because the nanosize boosts or permits antimicrobial action (Table 6).

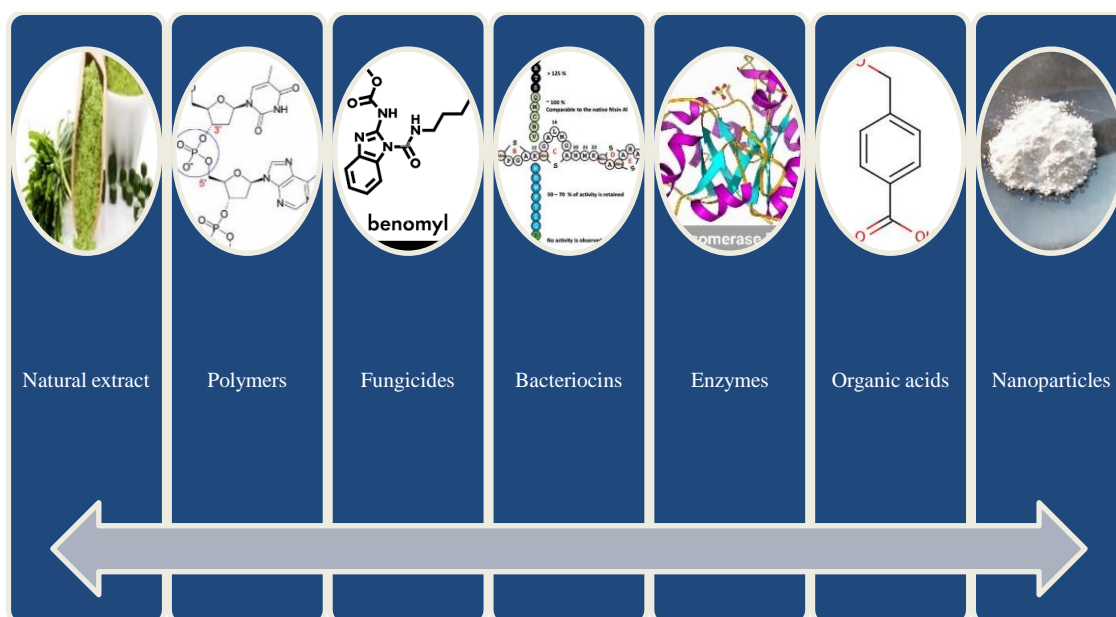


Fig. 3. Various antimicrobial substances for antimicrobial active packaging systems

Table 6. Antimicrobial food packaging systems [59-64]

Active substances	Package Material/ Application	Microorganisms tested	Food tested	Benefit	Reference
Silver/titanium dioxide	LLDPE/Low-density polyethylene	<i>Aspergillus flavus</i>	Cooked rice	Decrease of <i>A. flavus</i> by ten times	[59]
Ag	Polyethylene	<i>Bacillus cereus</i> , <i>Bacillus subtilis</i> , molds, yeasts	Bread	Increased shelf life by up to six days	[60]
Silver/Zinc oxide	Low-density polyethylene	<i>Listeria monocytogenes</i> , <i>Pseudomonas aeruginosa</i> and <i>Escherichia coli</i>	Chicken breast fillets	Reduction in the growth of bacteria (destruction of 99.99% of inoculated microorganisms)	[61]
Zinc oxide	Active films (based on glycerol, CaCl ₂ and sodium alginate)	<i>Staphylococcus aureus</i> , <i>Salmonella typhimurium</i>	Poultry meat	Initial bacterial count decline	[62]
TiO ₂	LDPE	<i>Rhodotorula mucilaginosa</i>	Fresh pears	Reduction of more than 2 log CFU/g in mesophilic bacteria and yeasts	[63]
Copper	Polylactic acid	<i>Pseudomonas</i> spp. isolated from spoiled fiordilatte cheese	Fiordilatte cheese	Extended shelf life of up to 9 days	[64]

4. CONCLUSION

Many studies have been conducted in recent years on the development of novel active packaging technologies, resulting in a diverse range of AP systems that could be utilized to increase the shelf-life of food products. This study highlights the huge scope of AP systems as well as concludes that all active packaging technology categories examined have similar implementation challenges when applied to practical food applications. Additionally, it is evident from all the research done over the past 10 years that nanotechnology presents a lot of potential for innovative advancements in food packaging that will benefit both consumers and businesses. Even at this early level, the use of nanotechnology has shown significant benefits in enhancing the characteristics of packaging materials, and it will continue to need expenditures to finance research as well as advancements to comprehend the benefits and drawbacks of involving nanotechnology in AP packaging systems. The application of nanotechnology in the fabrication of food packaging can offer several advantages in terms of increased functional qualities. Numerous nanomaterials have been evaluated *in vitro* towards microbes, particularly those used in antimicrobial packaging solutions. However, food tests are very essential since the ingredients in food may have an impact on the action of the active substances. The efficient and effective deployment of active nanoparticles in food packaging requires broad consumer acceptance and legislative support, as well as a cost that is consistent with the value realized by the particular food product.

CONSENT

It is not applicable.

ETHICAL APPROVAL

It is not applicable.

COMPETING INTERESTS

Authors have declared that no competing interests exist.

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