Comparative Analysis of Phenolic Content and Chemical Composition of Agro-industrial By-products of Citrus Species

Oyinkansola Olubunmi OLOWU¹, Sema Yaman FIRINCIOĞLU^{2*}

^{1,2}Department of Animal Production and Technologies, Faculty of Agricultural Sciences and Technologies, Niğde Ömer Halisdemir University, Niğde, Turkey

*Corresponding author: semayaman@ohu.edu.tr

ORCID: 0000-0003-3005-1135¹, 0000-0001-9575-9981²

Abstract

Comparative analysis of phenolic content and nutritive value for agro-industrial byproducts (peel and pomace) of *Citrus aurantium* (Bitter orange), *Citrus paradisi* (Grapefruit), *Citrus reticulata* (Mandarin), *Citrus limon* (Lemon), and *Citrus sinensis* (Sweet orange) was done. All samples for phenolic content were extracted with 70% ethanol and absorbance reading taken at 765nm and nutritive value was also assessed by chemical analysis. The phenolic content of the five citrus peels significantly differed at P<0.01 from pomaces. Phenolic content from highest to lowest for peels was grapefruit > mandarin > lemon > bitter orange > orange while for pomaces, bitter orange > grapefruit > mandarin > lemon >orange. The principal component analysis showed that the phenolic content of citrus species had no correlation with the nutritive value hence they are non-dependent parameters. In addition, the dry matter of the citrus species was the most important component of the nutritive value. This study showed the high variation of the quality parameters (phenolics content and nutritive value) of citrus species among varieties and countries. Meta-analysis of quality parameters of citrus species is recommended to underpin the broad effects of fruit sourcing, maturation, genetics, sample preparation, extraction solvents and laboratory techniques on the agro-industrial by-products.

Keywords: Agro-industrial; Chemical Composition; Citrus; Phenolics; Principal Component Analysis

Research article Received Date: 7 October 2021 Accepted Date: 10 November 2021

INTRODUCTION

Citrus agro-industrial by-products

Citrus seeds, peels and pulps constitute mainly citrus agro-industrial by-products obtained from the about 50% industrially processed citrus fruits (Zema, 2018). All in the Rutaceae family, orange, lemon, grapefruit and mandarin are industrially important citrus species (Rafiq et al., 2018; Satari and Karimi, 2018) among the world citrus producing countries, and Turkey is included (FAO, 2016; Uzun and Yesiloğlu, 2012).

Citrus agro-industrial by-products are produced in significantly large quantities that pose a major burden on the environment and management cost to the industries hence the need for economically viable and sustainable waste management options such as utilization for animal feeds (Zema, 2018).

Improving Animal Nutrition

Using citrus agro-industrial by-products for improved nutrition and production of animals is growing interest (Volanis and Zoiopolous, 2003) although this is currently being sub-optimally utilized considerably due to low economic capacity, skill, and infrastructure particularly in the low to middle-income countries (Tayengawa and Mapiye, 2018). In addition to these, there are knowledge gaps in the phenolic and nutritive value as it relates to improving animal nutrition.

Knowledge Gap

Fruits contain many phenolic compounds- flavonoids, lignans, stilbenes, and phenolic acids (Manach et al., 2004) and some of these are found in the citrus peels and less in the pulp (Singh et al., 2020). Most studies focus on either peels or pulps of citrus however, their agroindustrial wastes are neither peels nor pulps alone but pomaces, a mix of peels and some pulps. Table 1 shows the phenolic content variations across five different species as this study focused. Reporting the phenolic content is a function of the calibration standard (Valencia-Avilés, et al., 2018) and extraction solvent plays a vital role in the phenol content (Hegazy and Ibrahim 2012). It's noteworthy that agro-climatic conditions of the environments where that citrus species are sourced are an important factor in the phenolic content in the citrus species (Singh et al., 2020). What remained unknown was if citrus species obtained for this study had different phenolic contents as previously reported and how the peels differed from the pomaces in the five citrus species examined.

Some studies of citrus species showed that dry matter for peels and pomaces ranged between 87 to 97%. Reported crude ash content was 1-10%, crude protein (2.8-9.5%), crude fiber (6-14%), and ether extract (0.5-5%) (Atta and El Shenawi, 2012; Beyzi et al., 2018; Castrica et al., 2019; El-ghfar et al., 2016; Figuerola et al., 2005; Ghanem et al., 2012; Gorinstein et al., 2001; Bejar et al., 2011; Lashkari and Tagizadeh, 2013; Marin et al., 2007; Magda et al., 2008; M'hiri et al., 2015; Nagarajaiah and Prakash, 2016; Özkan et al., 2017; Palangi et al., 2013; Vlaicu et al., 2020). The nutritive value variations may be associated with fruit source and maturation in addition to analytic techniques (Ammerman and Henry, 1991; Olowu and Yaman Firincioğlu, 2019).

Despite these reports on phenolics and chemical composition, there is a gap of knowledge on how the chemical composition of many citrus species correlate with the phenolics as Rehman et al. (2020) is one of the very few to have comparatively assessed the total phenolics within different varieties of certain citrus species using the principal component analysis.

SN	Citrus Species	Variety	Sample	Country	Phenolic content	Reference
1	Citrus sinensis Citrus sinensis	Hamlin Red blood Succuri	Pulp Pulp	Pakistan	222.3 (mgGAE/g) 207.0 (mgGAE/g)	Rehman et al (2020)
	Citrus sinensis		Pulp		243.3 (mgGAE/g)	
2	Citrus sinensis		Peel	Sudan	35.6 (mgGAE/g)	Sir Elkhatim et al. (2018)
3	Citrus sinensis	Baladi	Peel	Egypt	169.50 (mgGAE/g)	Hegazy and Ibrahium (2012)
4	Citrus sinensis	Novel	Peel	Egypt	559.32(mgTAE/100g FW)	El-aal and Halaweish (2010)
5	Citrus paradise	Macfed	Pulp	Pakistan	165.6 (mgGAE g)	Rehman et al (2020)
6	Citrus paradise		Peel	Sudan	77.3 (mgGAE/g)	Sir Elkahatim et al. (2018)
7	Citrus aurantium		Pulp	Pakistan	158.9 (mgGAE/g)	Rehman et al (2020)
8	Citrus aurantium		Peel	Turkey	487 (mgGAE/10g)	Ersus and Can (2007)
9	Citrus reticulata		Pulp	Pakistan	180.6 (mgGAE/g)	Rehman et al (2020)
10	Citrus limon		Peel	Sudan	49.8 (mgGAE/g)	Sir Elkahatim et al. (2018)
11	Citrus limon		Peel	Israel	190 (mgChA/100g FW)	Gorinstein et al. (2001)
12	Citrus reticulata		Peel	Israel	179 (mgChA/100g FW)	Gorinstein et al. (2001)
13	Citrus paradisi		Peel	Portugal	155 (mgChA/100g FW)	Guimarães et al. (2010)

Table 1. Reports of Phenolic Contents Based on Ethanol Extract

Study Objectives

This study had three clear objectives. Firstly, phenolic content of the peels and pomace samples of *Citrus sinesis* (sweet orange), *Citrus limon* (lemon), *Citrus reticulata* (mandarin), *Citrus paradisi* (grapefruit), and *Citrus aurantium* (bitter orange) were evaluated. Secondly, chemical composition assessments were carried out, and lastly, a comparative analysis was done on the phenolic content and chemical composition of the *Citrus* species.

MATERIAL and METHOD

Commercially mature *Citrus sinesis* (sweet orange), *Citrus limon* (lemon), *Citrus reticulata* (mandarin), *Citrus paradisi* (grapefruit), and *Citrus aurantium* (bitter orange) were obtained. Peels and pomaces samples were cut into pieces, oven-dried at 50°C for 48 h, and finely grounded using a 1mm sieve in a Retsch ZM 200 laboratory mill. (AOAC, 1995). All procedures were carried out in the animal nutrition laboratory of the Faulty of Agricultural Science and Technologies in Niğde Ömer Halisdemir University, Turkey.

Phenolic Content Assessment

Folin-Ciocalteu's reagent method (Waterhouse, 2001) for the assessment of phenolic content was adapted in this study. Sample extracts (2.5ml) and 70% ethanol was used to prepare 25ml stocks and sample dilutions were done. In duplicates, 100µl of the sample dilutions were marked up with distilled water (900µl), Folin-Ciocalteu reagent (5ml), and sodium carbonate (4ml). These samples were vortexed, stored in the dark for 2 h and at 765nm, a UV spectrophotometer was used to measure the absorbance for each *Citrus* sample. Gallic acid calibration curve was determined ($R^2 = 0.9959$) and phenolic contents of the samples were expressed as mg GAE/g.

Chemical Composition Assessment

Dry matter, crude ash, and crude protein analysis by the Kjeldahl method (AOAC, 1995) were carried out in duplicates on peels and pomaces samples of five Citrus species- (bitter orange, grapefruit, lemon, mandarin, and orange). Van Soest's (1991) method was used to assess the neutral detergent fiber (NDF) and acid detergent fiber (ADF) contents of peels and pomaces.

Statistical Analysis

With the JAMOVI, R-based statistical package (Jamovi project, 2021), analysis of Variance (ANOVA) was done to determine the statistical significance ($P \le 0.01$) of the phenolics concentrations and principal component analysis (PCA) were done to compare the phenolic concentrations to the chemical composition obtained.

RESULTS and DISCUSSION

Phenolic Content Assessment

Each Citrus species is significantly different from the other (P <0.01). Notably, pomaces of bitter orange, grapefruit, mandarin, and orange showed far higher concentrations of phenolics than their peels. Also, all the pomaces samples of the five Citrus species significantly differ from the peels except the lemon (peels and pomaces), mandarin (peels and pomaces), and orange pomace which did not significantly differ from each other (P> 0.05). In order of phenolic concentration among the citrus peels, grapefruit > mandarin > lemon > bitter orange > orange and for pomaces, bitter orange > grapefruit > mandarin > lemon > orange. *Citrus sinensis* (orange) had the lowest phenolic content for both peels and pomaces while bitter orange peels (Figure 1).

In this study, results had been expressed in mg GAE/ g given that gallic acid was the calibration differently from mg TAE/ 100g (El-aal and Halaweish, 2010) having calibrated with tannin and mg ChA/100g (Gorinstein et al., 2001) with a chlorogenic acid calibration. Calibration standards may be reported with the standard used or re-evaluated with any other standard given that reactions leading to phenolic content estimates are independent, quantitative, and predictable (Singleton et al., 1999).

Citrus sinensis (Orange) peel (277.2 mg GAE/ g) in this study had higher phenolic content than in Hegazy and Ibrahim (2012) and much lower (35.6 mg GAE/ g) was reported by Sir Elkahatim et al., (2018). Similarly, orange pomace had higher phenolic content (462.8 mg GAE/ g) compared to all three orange varieties reported by Rehman et al. (2020).

The phenolic content of *Citrus reticulata* (mandarin) in this study is significantly higher than Gorinstein et al., (2001). Although the phenolic content of the mandarin pomace did not significantly differ from the peel, it was higher than the mandarin pulps reported by Rehman et al., 2020. Citrus reticulata (lemon) peels had a higher phenolic concentration than Gorinstein et al. (2001) who reported 179 mg ChA/ 100g. Similarly, 180.6 mg GAE/g in lemon pulp (Rehman et at., 2020) was lower than both lemon peel and pomace in this study. Prior reports of Citrus paradisi (grapefruit) peel and pomace differed from results obtained in this study as phenolic contents of grapefruit peels and pomaces were found to be significantly higher than as previously reported (Sir Elkahatim et al., 2018; Rehman et al., 2020). Citrus aurantium (bitter orange) in this study stands out differently from the reports of Ersus and Cam (2007) (487 mg GAE/ 10g for peels) and Rehman et al., (2020) (158.9 mg GAE/ g for pulp).

The difference in phenolic contents may be attributed to the effect of agro-climatic conditions on fruit quality (Hussain et al., 2017; Singh et al., 2020) given the difference in the agro-ecological zones of Egypt, Israel, Pakistan, Portugal, Sudan, and Turkey as reported by the previous studies. For instance, Washington navel orange grown in the Mediterranean climate (cool and wet winters; hot and dry summers) similar to Adana, Antalya, and Izmir- the top three provinces with high production of citrus in Turkey (Yesiloğlu et al., 2007) has been reported to have higher fruit qualities compared to those grown in coastal to desert areas (Davies and Albrigo, 1994; Zekri, 2011). In addition, these results further agree with the variations in parameters that have been associated with fruit source and maturation in addition to analytic techniques (Ammerman and Henry, 1991; Olowu and Yaman Firincioğlu, 2019).

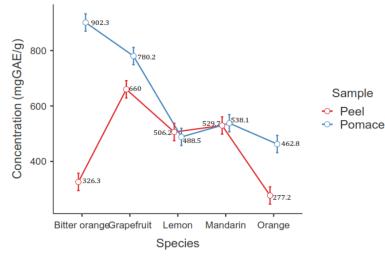


Figure 1. Analysis plot showing from highest (bitter orange pomaces) to lowest (orange peels) the different (P < 0.01) phenolic concentrations of the peels and pomaces for the five *Citrus* species-grapefruit peel; grapefruit pomace; lemon peel; lemon pomace; mandarin peel; mandarin pomace; orange pomace.

Comparative Analysis of Phenolic Content and Chemical Composition

The principal component analysis (PCA) showed high variability between the phenolic content and the chemical composition of the citrus species assessed in this study (Figure 2). Dry matter is generally attributed as the most important determinant component of available soluble carbohydrates (Lashkari and Taghizadeh, 2013; Mamma and Christakopoulos, 2014). Although, ash content was positively correlated to dry matter, acid detergent fiber and neutral detergent fiber were less correlated with the dry matter. Ash content is indicative of available minerals for animal nutrition (Shariff et al., 2021) and is as important as the dry matter for the delivery of minerals. Crude protein also showed a low correlation to other chemical components despite being an important parameter in the feed composition.

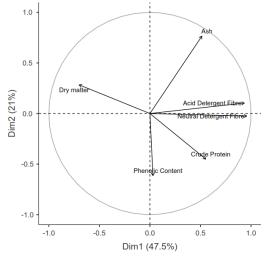


Figure 2. Result of PCA analysis showing three principal components (dry matter; ash, ADF; NDF, CP, and phenolics) that comparatively assesses phenolic content and chemical components (dry matter, ash, acid detergent fiber, neutral detergent fiber, and crude protein) of the *Citrus* species in this study

CONCLUSION

In this study, there is no correlation between chemical composition and phenolics of peels and pomaces of different citrus species. The importance of phenolics and chemical composition has been established by several authors and in this study as well. Noteworthy are the variations in the quality parameters of *Citrus species* by different studies and regions of the world which have mostly been attributed by researchers to effects of fruit sourcing, maturation, genetics, sample preparation, extraction solvents, and laboratory techniques. The limitation, however, is the determination of the major effect driving variation of quality parameters by the conventional experimental methods hence the need to further study this through a meta-analysis approach. Metaanalysis of the effect of quality parameters in *Citrus species* is recommended to provide an indepth understanding of the variations and perhaps what to do differently when considering citrus agro-industrial by-products for enhanced animal nutrition.

ACKNOWLEDGEMENT

This study quoted from a part of the MSc thesis of Oyinkansola Olubunmi Olowu

REFERENCES

- Ammerman C. B. & Henry P. R. 1991. Citrus and vegetable products for ruminant animals, Proceedings, Alternative Feeds for Dairy and Beef Cattle, National Invitational Symposium, St. Louis, MO 103–110.
- Association of Official Analytical Chemists (A.O.A.C). 1995. Official Methods of Analysis, Washington. DC 15.
- Atta M.B. & El- Shenawi G.M. 2012. Extraction of natural antioxidant from flavedo layer of Bitter orange (*Citrus aurantium*) peel, *CBAA*, *International Biotechnology Applications in Agriculture*. Benhar University, Moshtohor and Hurghada, Egypt 2, 51-59.
- Bejar A.K., Ghanem N., Mihoubi D., Kechaou N. & Boudhrioua Mihoubi N. 2011. Effect of Infrared Drying on Drying Kinetics, Color, Total Phenols and Water and Oil Holding Capacities of Orange (Citrus sinensis) Peel and Leaves, *International Journal of Food Engineering*, 7(5).
- Beyzi S., Ulger I., Kaliber M. & Konca Y. 2018. Determination of chemical, nutritional and fermentation properties of citrus pulp silages, *Turkish Journal of Agriculture Food Science and Technology* 6, 1833.
- Castrica M., Rebucci, R., Giromini, C., Tretola, M., Cattaneo D. & Baldi A. 2019. Totalphenolic content and antioxidant capacity of agri-food waste and by-products, *Italian Journal of Animal Science 18*(1), 336–341.
- Davies F.S. & Albrigo L.G. 1994. Environmental constraints on growth, development and physiology of citrus, *In Citrus*, *1 ed. (CAB International)*, 52–82.
- El-aal H. A. & Halaweish F. T. 2010. "Food preservative activity of phenolic compounds in orange peel extracts (*Citrus sinensis* L.)", *Lucrari Stiintifice*, 53, 233–240.
- El-ghfar, M. H. A. A., Ibrahim, H. M., Hassan, I. M., Abdel Fattah A. A. & Mahmoud M. H.2016. "Peels of Lemon and Orange as Value-Added Ingredients: Chemical and Antioxidant Properties", *International Journal of Current Microbiology and Applied Sciences* 5(12), 777–794.
- Ersus S. & Cam M. 2007. Determination of Organic Acids, Total Phenolic Content, and Antioxidant Capacity of Sour Citrus Aurantium Fruits, *Chemistry of Natural Compounds*, 43(5).
- Food and Agriculture Organization (FAO), 2016. Citrus fruit fresh and processed, *Statistical Bulletin*, 2016
- Figuerola F., Hurtado, M. L., Estevez, A. M., Chiffelle I. & Asenjo F. 2005. "Fiber concentrates from apple pomace and citrus peel as potential fiber sources for food enrichment" *Food Chemistry* 91(3), 395–401.
- Ghanem N., Mihoubi, D., Kechaou N. & Mihoubi N. B. 2012. Microwave dehydration of three citrus peel cultivars: Effect on water and oil retention capacities, color, shrinkage, and total phenols content, *Crops and Products 40*, 167–177.
- Gorinstein S., Martín-Belloso, O., Park, Y.-S., Haruenkit, R., Lojek, A., Ĉíž, M., Caspi, A., Libman I. & Trakhtenberg S. 2001. "Comparison of some biochemical characteristics of different citrus fruits", *Food Chemistry* 74(3), 309–315.
- Guimarães R., Barros, L., Barreira, J. C., Sousa, M. J., Carvalho A. M. & Ferreira I. C. 2010. Targeting excessive free radicals with peels and juices of citrus fruits: Grapefruit, lemon, lime and orange, *Food and Chemical Toxicology*, 48(1), 99–106.

- Hegazy A. E. & Ibrahim M. I. 2012. Antioxidant activities of orange peel extracts. *World Applied Sciences Journal*, 18(5), 684–688.
- Hussain S.B., Anjum M.A., Hussain S., Ejaz S. & Kamran H.M. 2017. Agro-climatic conditions affect fruit quality of mandarin (*Citrus reticulata* Blanco) cultivars. *International Journal of Tropical and Subtropical Horticulture*.
- Lashkari S. & Taghizadeh A. 2013. Nutrient digestibility and evaluation of protein and carbohydrate fractionation of citrus by-products, *Journal of Animal Physiology and Animal Nutrition* 97(4), 701–709.
- Magda R.A., Awad A.M. & Selim K.A. 2008. Evaluation of mandarin and orange peels as natural sources of antioxidant in biscuits, *Journal of Food Science and Technology* 75–82.
- Mamma D. & Christakopoulos P. 2014. Biotransformation of citrus by-products into value added products, *Waste and Biomass Valorization 5*(4), 529–549.
- Manach C., Scalbert A., Morand C., Remesy C. & Jimenez L. 2004. Polyphenols: food sources and bioavailability. *The American Journal of Clinical Nutrition*, 79:727-747.
- Marin F. R., Soler-Rivas C., Benavente-García O., Castillo J. & Pérez-Alvarez J. A. 2007. By-products from different citrus processes as a source of customized functional fibers, *Food Chemistry 100*(2), 736–741.
- M'hiri N., Ioannou I., Ghoul M. & Boudhrioua N. M. 2015. Proximate chemical composition of orange peel and variation of phenols and antioxidant activity during convective air drying, *Journal of New Sciences*, *AT*.
- Nagarajaiah S. B. & Prakash J. 2016. "Chemical composition and bioactivity of Pomace from Selected Fruits", *International Journal of Fruit Science 16*(4), 423–443.
- Olowu O.O & Yaman Firincioğlu S. 2019. Feed Evaluation Methods: Performance, Economy and Environment, *Eurasian Journal of Agricultural Research* 3 (2), 48-57.
- Özkan Ç. Ö., Kaya E., Ülger İ., Güven İ. & Kamalak A. 2017. Effect of species on nutritive value and methane production of citrus pulps for ruminants, *Hayvansal Üretim* 58(1), 8–12.
- Palangi V., Taghizadeh A. & Sadeghzadeh M. K. 2013. Determine of nutritive value of dried citrus pulp various using in situ and gas production techniques, *Journal of Biodiversity and Environmental sciences* 3(6), 8-16.
- Rafiq S., Kaul R., Sofi S. A., Bashir N., Nazir F. & Ahmad Nayik G. 2018. Citrus peel as a source of functional ingredient: A review, *Journal of the Saudi Society of Agricultural Sciences* 17(4), 351–358.
- Rehman U. S., Abbasi S.K., Quayyum A., Jahangir M., Sohail A., Nisa S., Tareen M.N., Tareen M.J. & Sopade P. 2020. Comparative analysis of citrus fruits for nutraceutical properties. *Food science and Technology*, Campinas, 40 (Suppl. 1): 153-157. Doi: https://doi.org/10.1590/fst.07519
- Satari B. & Karimi K. 2018. Citrus processing wastes: Environmental impacts, recent advances, and future perspectives in total valorization, *Resources, Conservation and Recycling 129*, 153–167.
- Shariff A. H., Wahab P. Z., Jahurul A.H., Romes N. B., Zakaria M., Roslan J., Wahab R.A. & Huyop F. 2021. Nutrient composition, total phenolic content, and antioxidant activity of tropical Kundasang-grown cucumber at two growth stages, *Chilean Journal of Agricultural Research*. 81(2).

- Singleton V. L., Orthofer R. & Lamuela-Raventos R. M. 1999. Analysis of total phenols and other oxidation substrates and antioxidants by means of Folin-Ciocalteu Reagent. *Methods in Enzymology*, 299, 152-178.
- Singh B., Singh J.P., Kaur A. & Singh N. 2020. Phenolic composition, antioxidant potential and health benefits of citrus Peel, *Food Research International* 132.
- Sir Elkhatim K.A., Elagib R.A.A. & Hassan A.B. 2018. Content of phenolic compounds and vitamin C and antioxidant activity in wasted parts of Sudanese citrus fruits. *Food Science and Nutrition*, 6:1214–1219. https://doi.org/10.1002/fsn3.660
- Tayengwa T. & Mapiye C. 2018. Citrus and winery wastes: Promising dietary
for sustainable ruminant animal nutrition, health, production, and meatsupplements
quality,
guality,Sustainability 10(10), 3718, 2018.Sustainability 10(10), 3718, 2018.Sustainability
- The jamovi project. 2021. jamovi.(Version1.8)[Computer Software].Retrieved from https://www.jamovi.org
- Uzun A. & Yesiloglu T. 2012. Genetic Diversity in Citrus, Genetic Diversity in Plants. Published byInTech . ISBN : 978-953-51-0185-7
- Valencia-Avilés E., García-Pérez M. E., Garnica-Romo M. G., Figueroa-Cárdenas J.D., Meléndez-Herrera E, Salgado-Garciglia R. & Martínez-Flores H. E. 2018. Antioxidant Properties of Polyphenolic Extracts from Quercus Laurina, Quercus Crassifolia, and Quercus Scytophylla Bark, *Antioxidants* 7(7),81. https://doi.org/10.3390/antiox7070081
- Van Soest P.J, Robertson J.D. & Lewis B.A. 1991. Methods for dietary fiber, and neutral detergent fiber and non-starch polysaccharides in relation to animals' nutrition, *Journal of Dairy Science* 74, 3583-3597.
- Vlaicu Petru Alexandru., Untea A. E., Panaite T. D. & Turcu R. P. 2020. Effect of dietary orange and grapefruit peel on growth performance, health status, meat quality and intestinal microflora of broiler chickens, *Italian Journal of Animal Science*, 19(1), 1394–1405.
- Volanis M. & Zoiopoulos P. 2003. Effects in utilizing locally available agro-industrial byproducts and crop surpluses in dairy sheep feeding, *EAAP book of Abstracts, Rome, Italy* 9, 345.
- Waterhouse A. L. 2001. Determination of total phenolics. In R. E. Wrolstad (Ed.), *Current protocols in food analytical chemistry*. New York, NY: John Wiley and Sons.
- Yesiloglu T., Emeksiz F., Tuzcu O. & Alemdar T. 2007. Safe and high quality supply chains and networks for the citrus industry between Mediterranean partner countries. National citrus sector analysis: Turkey. *EuroMedCitrusNet*. P39.
- Zekri M. 2011. Factors affecting citrus production and quality. Citrus Industry 92, 6-9.
- Zema D.A., Calabro P.S., Folina A., Tamburino V., Zappia G. & Zimbone S.M. 2018. Valorisation of citrus processing waste: A review, *Journal of Waste management* 80, 252-273