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A CRITICAL REVIEW ON BREWING OF BEER

Syed Sajid Jan, Muhammad Waqas, Noaman Yaseen and Sikander Ali*

Institute of Industrial Biotechnology, GC University, Pakistan.

***Corresponding Author: Sikander Ali**
Institute of Industrial Biotechnology, GC University, Pakistan.

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ABSTRACT

Human and yeast have very old relationship for the production of various beverages and food products through fermentation. Several discoveries have created better technologies and abilities for improved fermentation on a large scale. The importance of beer-making yeast in the brewing process is revised in this review and its role as the key character is emphasized. On considering the significances of several brewery functions, it has been documented that the central role of these processes is to support the growth of yeast for fermentation and to uphold the integrity and optimum product production. Typically, these procedures are: the supply of nutrients for the growth of yeast (supply of raw material for wort production in brewhouse); other services (providing water, optimum temperature and cooling); assurance of quality (measuring microbial integrity and hygienic practices); automation of the plant (centrifuges, vessels, stirrers, sensors, valves, pumps and pipes); filtration and final packaging (preservation of the product till its consumption); and its delivery to the market. Bearing these chains of standards in mind for the production of beer, the fermentation process has a central role, an ancient technique where yeast ferment wort to produce beer.

KEYWORDS: Brewing, Beer, Yeast, Fermentation, *Saccharomyces cerevisiae*.

INTRODUCTION

The brewing of beer is one of the human's oldest biotechnology. Its discovery remains a mystery, whether it could be credited to the natural curiosity of mankind or unintentional contamination of grains. The archaeological marks of brewing, dating back to around 1800 BC have been recorded in tablets of Sumaian though its origins might be traced back to 10,000 years ago (Katz & Maytag, 1991; Axcell, 2007). Owing to the selection of finest agent of fermentation, the ancient people have domesticated yeast, although it's microbial and biochemical functions was unknown. This close association between Saccharomyces cerevisiae and human has been demonstrate further in a study of genetically diverse 651 wine producing strain of yeast from 56 different geographical locations of the world (Legras *et al.*, 2007).

Yeast was described by Antonie van Leeuwenhoek in 1680 however its role in alcoholic fermentation was reported for the first time by Charles Cagniard de la Tour in 1838. In late 19th century, pure culture techniques were introduced and improved beer brewing yeast strains were selected. Emil Hansen separated yeast cells through serial dilution and documented that different pure cultures from several top and bottom fermenters yields reproducible and unique fermentations for different industrial products (Rank *et al.*, 1988).

Many modifications have been made since the earliest beer-brewing by humans, resulted in advanced fermentation process of beer production. Different type with various styles of beer have prepared over time, having their own distinctive flavor and character depending on the environment of the country origin (Glover, 200; Protz, 1995). The requirement of beer brewing yeast is a constant feature that did not changed, despite all alterations. Brewing yeast are classified into two types based their behavior of flocculation: lager yeast (bottom fermenting) and ale and weiss yeast (top fermenting) (Jentsch, 2007). They are so different from each other that the two principal varieties of beer classes (lagers and ales) are fermented by the two classes of yeast. The ale yeast are genetically much more varied and, just like weiss yeasts, its fermentation is carried out at higher temperatures around 18-24 ^{o}C, while fermentation process of lager yeast is carried out at lower temperature about 8-14 ^{o}C and are conserved genetically. Due to the occurrence of POF gene (PADI) the beer produced by weiss yeast are clove, spicy, nutmeg and vanilla flavor notes (Meaden & Taylor, 1991). Ferulic acid decarboxylation produce 4-vinyl guaiacol (a volatile phenolic compounds), that also contribute to different flavor of beer. The phenotypical features of various types

of yeast can be used to differentiated them that include colony structure, microscopic features (weiss yeast chain formation), fermentation characteristics (flavor and flocculation profiles), optimum growth and optimum product formation temperature, melibiose utilization (lager strains), and POF gene presence (weiss yeasts). In addition, the differentiation of brewing yeast can also be accomplished through chromosomal electrophoretic karyotyping (Casey, 1996).

Some important yeast species that are utilized in food industry are found in *Saccharomyces* sensu stricto species complex, namely, *S. bayanus* (cider and wine fermentations), *S. cerevisiae* (Meyen ex EC Hasen), the producer of bread, wine, weiss and ale beer, and *S. pastorianus* (syn Saccharomyces carlsbergensis) (EC Hansen), a fermentation agent of lager beer (Rainieri *et al.*, 2006; VaughanMartini & Martini, 1998). Saccharomyces carlsbergensis encompasses hybrid strains as well as lager brewing strains that might be originated through random natural hybridization between non-*S. cerevisiae* strain possibly *S. bayanus* and S. *Cerevisiae*. Two dissimilar lager-brewing yeast strains having different genome have been documented (Rainieri *et al.*, 2006). The value chain of graphical depiction for beer production in simplified form (Fig. 1) demonstrats the beginning of beer brewing procedure in Malting and Brewhouse.

Barely is converted to Malt by the process of Malting (that includes steeping, germination, kilning). In the process of Malting, barley is transformed to malt by steeping, germination and finally kilning it. There are two types of barley that occurs naturally (six- and two-rowed), the process of malting activates the enzyme systems, that helps in transformation of starch to sugars. Malt offers fermentable sugar for fermentation process, as well as color and flavor (depending on the kilning level). In the Brewhouse raw materials (cereals, hops, malted barley, water and adjunct) are transformed into a liquefied medium known as wort (Boulton and Quain, 2006; Goldammer, 2000a; Kunze, 1996; Rehberger and Luther, 1995).

Wort is abounded in nutrients, having a great amount of carbohydrates, lipids, amino acids and inorganic ions (Bamforth, 2003; Hammond, 1993). Furthermore, the addition of hops delivers a 'hoppy' note and bitterness with some other extra benefits of microbial spoilage resistance because of the effects of iso-a-acid present on Gram-nagative bacteria (Simpson, 1993). On the other hand, resistances have been reported form few Gram-positive bacteria (Pediococcus and Lactobacillus), that poses a certain treats to breweries processes (Sakamoto & Konings, 2003). This review article will focus on Cellar function of yeast in fermentation system; its propagation; handling (storage, cropping and pitching); fermentation; quality assurance (QA); and maturation of yeast for beer brewing.

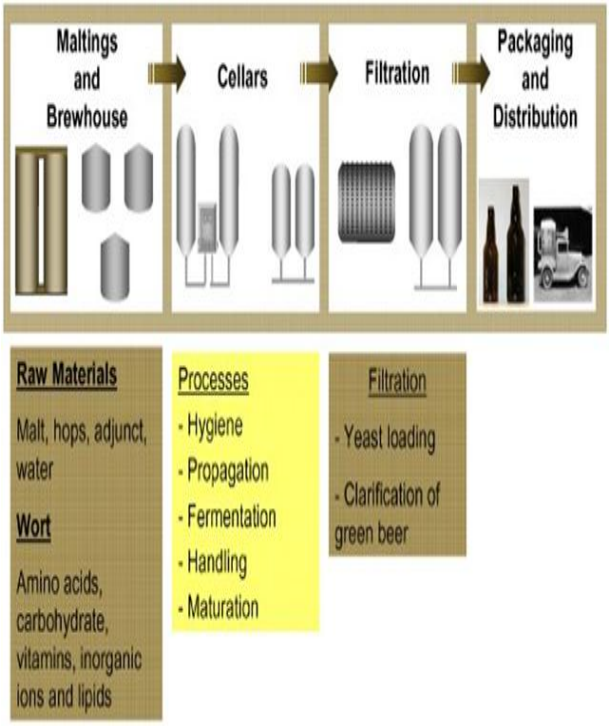

Fig. 1: Value chain of beer production in simplified graphical depiction beginning at the maltings and finalizing at distribution. Yeast linked focus area of cellars region is highlighted.

Cellars

The Systems of Fermentation

Fermentation systems have developed over many the years. The original designs have been based on the properties yeast (bottom vs. top fermenting yeast), culture, beer style and also the production material availability (Boulton & Quain, 2006). Fermenters types range from closed and open squares to vertical and horizontal vessels. Cylindroconical fermenter is the most common style of batch fermentations where the process of fermentaions is carried out in closed cylindrical vertical vessels having the base in cone shape known as cylindroconical vessels-CCVs. CVs have emerged as favored technology in modern breweries because of lower prices (operating and capital), efficiency (reduced osses of beerl, expanded vessel usage, collection of CO2 and cleaning of CIP) and footprint (less place). The best preferred material for construction of CCV is steel that are stainless. Its idyllic features consist of rigidity and strength, it's corrosion resistant and far inert, malleable, cleanable and has suitable thermal conductivity.

Continuous fermentation systems creates incomplete use in the industry of brewing mostly because of its absence of flexibility and the significances of microbial contamination or break-down (Inoue & Mizuno, 2008; Boulton & Quain, 2006). Smal-scale production has indicated that it was possible to yield beer with a immobilized, continuous system. The chief fermentation has been constant for about than 14 months equally in flavour compound formation and in fermentation efficiency (Virkaj¨arvi, 2001). The growth of viable

immobilized reactors was specific benefit after applied for fast maturation of beer (Pajunen, 1995). Though, another study was carried out to enhance the continuous fermentations was successful, particularly in attaining the desired profile of flavor (Dragone *et al.*, 2007; Inoue & Mizuno, 2008). There is need of further study and investigation for the continuouis systems optimization. There is need of more research as well as optimization for continuous systems before it can be replace the batch culture system in beer brewing.

QA management system – The final beverage quality assurance

Quality Assurance associates with 'customer loyalty and satisfaction' (Gryna, 2001). The ISO 9000 and Hazard Analysis and Critical Control Points (HACCP) are present to verify the passivity of the manufacturers for better practices of manufacturing (Kennedy & Hargreaves, 1997). HACCP is a defensive policy grounded on the examination of current circumstances by recognizing possible hazards to the safety of food.

Eventually, the aims of brewer are to yield a beer to please the customer again. To attain this capacity for the buyer, the product is required to fulfil with its qualities (style, appearance, and conten). Management of the microbial standing of raw materials (priming sugars, cereals and water,) wort, plant sterility, and yeast (method of gases intake, fermentation vessels, containers and post fermentation plant) (Campbell, 2003) is important to realize this pursuit. The challenge of brewer faces square measure. Various different microbic contaminants will be present in numerous elements of environments (anaerobic vs. aerobic nature, nutrient concentrations, pH changes, ethyl alcohol and concentrations of CO2). For a review of brewage spoilage organisms and also the stage of the production method at that they occur, talk over with vocalizer et al. (2005).

Certainly, the important groundwork for excellence is complete cleanliness practices. Hygiene raises to perform related with safeguarding good cleanliness and healthiness and can stand largely alienated into cleaning (in situ and environmental) and purification does. The brewer's job is to guarantee that the apparatus is as restricted from unwanted microbes as is nearly conceivable by rub on hygiene practices. Therefore, the goal of brewer is to disinfect tools rather than sterilize. Furthermore, sterilization refers to entire elimination of undesirable microbes, as well as spores, where sanitizing denotes to decrease down to adequate level using willingly obtainable technology and products (Goldammer, 2000b). Hygiene technology has grown into an automatic rehearsal due to the automatic environment of the current brewing procedure and the measure of the actions. Surrounded handling plant gear (piping, vessels, heat fittings and exchangers) is washed by means of an automatic cleaning in-place (CIP) procedure (Cluett, 2001; Curiel *et al.*, 1993). The CIP of brewer are usually led over rotary jets or spray balls placed to the upper of the container. The solutions are driven after a dominant CIP plant that grips caustic, water, sterilant solutions and acid (Cluett, 2001). Actual cleaning is attained over the synergistic association between the four factors temperature, time, mechanical action and chemical reaction (Boulton & Quain, 2006).

QA procedures are carried out to confirm the efficiency of the CIP procedure. Customary agar plating methods by means of selective cultivation media, like Raka Ray aimed at anaerobic bacteria, WL actidione agar (designed for aerobic bacteria), and lysine (as source of nitrogen) agar meant for choosing non-Saccharomyces wild yeast (Campbell, 2003; Walker, 1998), are in practice. The usage of swabs in the direction of confirming hygienic practice in designated areas for instance packaging halls are joint with a beer microbial finding medium for example NBBs (Back, 2005). Contemporary technology reinforced the expansions of fast microbiological approaches (Russell & Stewart, 2003) for instance real-time PCR, multiplex PCR, and ATP bioluminescence. The direct ATP analysis usage for the valuation of assessment of surface hygienists and the efficiency of CIP procedures have been described (Stanley, 2005; Storg˚ards *et al.*, 1999).

The significance of hygiene procedures cannot be exaggerated particularly upon seeing the 'key character' in brewing. The process of fermentation is microbiological procedure as well as the goal is to eliminate undesirable microorganisms (wild yeast, fungi or bacteria) (Campbell, 2003; Rainbow, 1981). It is important in brewer to uphold the reliability of specific yeast culture cast-off to yield the brands. Wild-yeast impurity will cause fermentations failure of the desired product and changes of flavour profile. The impurity of Obesum bacterium proteus produces in early fermentations and wort and can initiate in yeast slurries and ease of recycling it. This microorganism not only yields the hostile dimethyl sulphide (DMS) flavour as well as it degrades nitrate to nitrite, causing the production of nitrosamines. Impurities must be avoided in order to limit the risks to health such as unfriendly off-flavours, (nonvolatile nitrosamines), changes of pH and problems to filtration procedures.

As a whole, the verification of QA of the yeast culture is separated into culture reliability, microbial status (no impurities), identity and verification of culture and quality (vitality and viability). Detection of culture variant can be performed through the technique of agar plating and also through molecular procedures (Smart, 2007). The comparative comfort by which wider yeast groups can be distinguished have not verify to the circumstance of lager strains. Discrepancy of lager strains is restricted for the reason that the yeasts inside the group Saccharomyces sensu stricto, contain of strictly associated yeast that are conserved genetically (Montrocher *et al.*, 1998; Laidlaw *et al.*, 1996). The

ability to distinguish strain variants or lager strains changes reliant on on the experiment. Few genetic tests comprise gene mapping through restriction fragment length polymorphism (RFLP), amplified fragment length polymorphism (AFLP), karyotyping, that identifies variances in the length chromosome and PCR techniques for detecting the transposon (Coakley *et al.,* 1996; Cameron *et al.,* 1979). Additional discriminating tools that are powerful for distinguished nine strains of industrial yeast, by investigative their metabolite (exo-metabolomes) are described (Pope *et al.,* 2007). It was documented that for discrimination of few strains not attained genomically was identified metabolomically.

Resilience of the quality of yeast is linked to performance of fermentation is indefinable. The viability (living cells number) is defined as the cells' capability to grow and bud (Bendiak, 2000). The frequently performed viability tests are grounded at bright-field stains methylene violet (MV) and methylene blue (MB) (Smart *et al.,* 1999). The MB test, viable cells persist colorless while dead cells appear blue. The colorless 'leuco' form is due to sluggish uptake of dye by viable cells that can be oxidized while the dead cells cannot eliminate the dye. MB is regularly utilized stain in the industryof brewing though its dependability has been interrogated due to its viabilities underneath 90%. An alternate to MB is MV that comprises fewer contaminants and should cause in fewer individual mistakes by the worker (Smart *et al.,* 1999).

Determination of yeast vitality has historically been difficult due to complication of test and the requirements of brewers' which are rapid, reasonable, reproducible and simple. Plentiful reviews debating the numerous planned approaches are available (Heggart *et al.,* 2000; Bendiak, 2000; Imai, 1999). Vitality is the capability of yeasts to start the metabolism quickly after transmission from a poor nutrient medium source to a nutrient-rich medium, the capacity to tolerate pressure and still achieve the functional viable cell population state (Smart, 1996). Progresses in expertise afford science the chance to now education yeast population features at a level of cellular. Measurement of flow cytometric lets for the examination of single cells, and yeast cells goes through stream sensor. In this all-inclusive vitality method, the volume of the population of yeast to carry out after it is presented to wort production is calculated (Lodolo & Cantrell, 2007). Response of the yeast to the setting is measured by means of flow cytometry to detect the concentration of DNA deviations comparative to antimicrobial inhibitors that occurs naturally or nutrient restriction in wort for beer brewing (Van Nierop *et al.,* 2006).

The arrival of customer request for different and unique products necessitates further rigor in sanitization procedures because of changes in composition of new brands of beer. The new composition can cause in an high microbiological danger by reason of changes in pH, low-hopped beers or low alcohol or products having greater enduring concentrations of sugar at the fermentation end. Suitable methodologies for QA are needed in order to permit conformation of novel beer beverages.

Propagation

Propagation is aerobic process that is stepwise and the yeast strains is separated from the storage and grown such that enough numbers of cell that are contaminants free and have desired functional condition are achieved to sufficiently inoculate fresh zero-generation fermentations (Voigt & Walla, 1995).

Methodologies for maintenance culture are advanced over time in view of the primary selected usage of slants of agar that established into substitute approaches of storing in cryovials at -70^{o}C and liquid nitrogen at -196^{o}C (Hulse *et al.,* 2000) The storage methodology usage rest on on sample reliable preservation and maintenance, comfort in usage and implications of transport. There is need of more investment for the propagation process regardless of the excess yeast availability, as continuous cropping and re-pitching causes weakness of yeast strain. This weakening is related to non-hygiene practice (wild bacteria or yeast, cross-contamination), crops selection with specific features (increased flocculance, trub enriched, cell and age size) and quality of yeast is linked to (petite mutants, physiological changes because of pressure and genetic changes). Undesirable growth condition enforced on the growth of yeast in the course of fermentation and handling of yeast can cause stress and lead to death of cell (Powell *et al.,* 2000). In addition, replicative senescence is documented in some brewing strains of yeast. The average lifespan of brewing strain is specific to a series of 10 to 30 divisions per cell (Powell *et al.,* 2000). The familiarity of brewers in past verbalized the necessity of fresh propagations. Awareness of strain-specific lifespan and replicative senescence backs the basis of propagation practice.

An aerobic process proceeded stepwise with gradual changes of temperature and volume is termed as propagation. Propagation can be described into two types namely plant/brewery propagation and laboratory propagation. Favorable conditions are provided for development of yeast growth in plant-scale propagation such as sufficient supply of oxygen (to create aerobic environment), hygienic design and supply of carbohydrates, amino acids, inorganic ions and vitamins (adequate nutrients). The beginning of laboratory propagation is stored culture which is firstly inoculated into 15mL broth, then it proceeds to 200mL and is finalized in the Carlsberg flask. Nowadays a variety of plant propagation systems are being used. The plan contemplations incorporate the yield required and the inoculation count of the objective that is required for the first fermentation. In light of these components the scale-up proportions can be outlined bringing about gradually

increasing sized vessels of propagation. One hindrance of propagation plants is the moderately high cost and option approaches are in this way of intrigue. Of these option approaches the utilization of dried yeast or culture of fed-batch type is upheld. Starting examinations concerning the use of dried yeast demonstrated that under practically identical conditions a similar strain of yeast performed correspondingly when it was dried or crisp/fresh (Lodolo, Kock, Axcell, & Brooks, 2008). Be that as it may, isolate examinations found that brew yeast which displayed comparative outcomes both in new states and dried states did not give off an impression of being influenced to an indistinguishable degree from the ale strains. Moreover, dried ale yeast tests demonstrated attributes unique in relation to those of the indistinguishable new examples as far as flocculation and cloudiness arrangement are concerned. It was observed that the normal viability was 20– 30% lower for dried yeast than that of naturally propagated yeast affecting on strength of haze and foam. Another option supported is the utilization of osmosis innovation/bolstered cluster yeast propagations. The procedure depends on keeping up cells in the exponential stage by leaving a specific amount of suspension of yeast in the fermentation tank after expulsion of acclimatized yeast trailed by fixing up with new wort. The execution of osmosis innovation/encouraged bunch yeast propagations in numerous business plants exhibited certain points of interest. In light of the high yeast concentration imperativeness fermentation times are shorter and drop of pH continues speedier. The danger of defilement likewise diminishes because of high yeast imperativeness. The subsequent brews are portrayed by uniform, great lager quality and less froth negative mixes(Lodolo et al., 2008).

Fermentation

Additive effect of yeast growth results in fermentation of wort which produces beer. Approximately 12 days are required for production of beer from warehouse type (lager) fermentation process and due to this large time period it usually results in a bottle neck. However bottle neck is usually reduced with the use of multiple fermenters of large size and with the use of stainless steel as a construction material. In order to produce flavored compounds of choice and to get high outcome of the fermentation process use of a pure strain of yeast is necessary. Moreover exact pitching rate (inoculation rate), correctly controlled temperature as well as sufficient supply of nutrient materials are also important and are also considered as the basis of process control. Furthermore correct quantity of dissolved oxygen (DO) is considered as the key for process control. Yeast flocculation qualities manage the outlines of a fermenter. Brew yeast (top yeast) show flotation and can trap CO2 rises at the highest point. CCVs (cylindro-concial vessels) are in a perfect world suited to ale strains (base yeasts) in light of the fact that the cells cluster together, bringing about flocs that residue from the fermentation media to get settled in the base of cylindro-conical vessel's cones. This sort of strain-subordinate wonder is termed as flocculation and confirm exists that various FLO genes assume a part. Different variables influence flocculation and these variables are the factors that influence FLO quality action (sustenance, ethanol and some others like temperature); the hereditary foundation of the strain (tactile instruments, interpretation of FLO gene, fuse of proteins in cell dividers) and components influencing cell-cell connections in arrangement of floc (agitation, concentration of calcium and carbohydrates, size and shape of cell and some others) (Strauss, 2006; Verstrepen, Derdelinckx, Verachtert, & Delvaux, 2003).

The adjustments in flocculation patterns can contrarily affect the procedure in two different ways. This kind of poor flocculation brings about hoisted number of cells which impact the filtration of lager. On the other hand untimely yeast flocculation is the early cell flocculation within the sight of high carbohydrate fixations. Cell to cell association of the lectin type was proposed to clarify flocculation in spite of the fact that hydrophobicity of the surface of cell has been established as the second central point in charge of beginning of flocculation. Amid fermentation inoculation of yeast into the wort is done from yeast propagated or yeast cropped from a past fermentation. The CCVs by and large features entry or leave mains, sampling points, programmed temperature control, anti-vacuum alleviation valve, CO2 outlet, CIP bay and a main way entryway. A few requirements of CCVs are blending efficiency, most extreme tallness to breadth proportions and homogeneous control of temperature.

Carbohydrate utilization

The two noteworthy supplement groups affecting fermenting execution are nitrogenous mixes and carbohydrates. Osmosis of the supplements is reliant on the reaction of yeast to different parts. Blending strains can use different sugars such as sucrose, glucose, maltose, fructose, and some others) with the major recognizing contrast amongst brew and ale strains being the ability of ale yeasts to cause fermentation of melibiose. The summed up take-up of carbohydrate sugar design starts with hydrolyzed sucrose which causes an expansion in fixations of fructose and glucose. The take-up then takes after the course of most routine sugars such as fructose and glucose followed in expanding request of multifaceted nature by disaccharides such as maltose and trisaccharides such as maltotriose (Lodolo *et al.,* 2008). Glucose and fructose are transported over the semi-permeable plasma membrane by basic transporters in an encouraged process of diffusion. Two glucose take-up frameworks are perceived: constitutively communicated low affinity framework and a high affinity framework which is curbed within the sight of high glucose fixations. Catabolite restraint (inactivation of the high-affinity transport framework) has been appeared to happen just in fermentative strains of yeast.

Maltose is the significant carbohydrate sugar of wort, representing approximately more than 55% of the aggregate sugar substance of wort contrasted with 10– 14 percent for maltotriose. Take-up instrument includes two frameworks for maltose: a vitality subordinate maltose permease which changes ATP to ADP and is responsible for transport of maltose in place over the cell layer and alpha-glucosidase which is responsible for hydrolysis of maltose yielding two glucose molecules. However maltotriose contains a free vitality subordinate permease for in place transport and it shares the alpha-glucosidase which is responsible for hydrolysis of maltotriose yielding three glucose molecules. Diverse sugar proportions have been appeared to influence maturation execution contrarily especially for glucose dominating worts.

Nitrogen take-up

Continuous supply of digestible nitrogen to the culture organism is perhaps the most significant element. The fundamental wellsprings for this purpose are usually amino acids, dipeptides, tripeptides and some ammonium particles. Larger part of free amino nitrogen is used by culture organism for basic as well as enzymatic protein arrangement (Hohmann, 2002). Likewise the level and structure of free amino nitrogen vastly affects higher alcohol ester, vicinal diketone (VDK) and hydrogen sulfate development because of the role played by amino acid digestion in the arrangement of flavor mixes. Conditions that invigorate quick yeast development (high temperature and high DO fixations) will prompt high free amino nitrogen use which thence can prompt flavor uneven characters. Amino acids are used by culture organism in a succession that gives off an impression of being free of the maturation conditions. The take-up of the amino acids requires several permease enzymes and the take-up is subjected to nitrogen catabolite restraint which requires vitality and is dynamic too.

Mineral necessities

Micro molar to Nano molar concentration of trace minerals is required for development of culture organism. The trace minerals can be found in wort naturally in levels satisfactory for execution of fermentation process. Be that as it may, the coming of higher gravity maturations and poor grain yields can bring about deficiency of these trace minerals. With the end goal of this survey just the trace components such as calcium, copper, iron, magnesium and zinc will be talked about. These trace components play various important parts and are exhibited by the chosen cases underneath. Calcium take-up in culture organism plays a part as a second messenger in the regulation of development as well as in metabolic reactions of cells to external stimulus. Likewise it assumes a significant part in flocculation in spite of the fact that the correct capacity is as yet debatable. Moreover copper and iron go about as cofactors in a few catalysts. Iron is required as a basic element for development of haeme. Iron was additionally ensnared in oxidative stress resistance and life expectancy through the regulation of iron levels by inositol phospho-sphingo-lipid-phospholipase C (Isc1) (Lodolo *et al.,* 2008). Isc1 requires magnesium for ideal performance and is post translationally initiated by translocation. Moreover magnesium is the perhaps most bounteous divalent intracellular cation in yeast where it acts fundamentally as a chemical cofactor and a relationship has been shown between cell magnesium take-up and maturation of alcohal in mechanical strains of saccharomyces cerevisiae.

Examination of maturations/fermentations utilizing defined media demonstrated that yeast aging execution relied upon complex connections between potassium, magnesium and calcium. Measurable displaying in view of wort piece could turn out to be a helpful device to anticipate yeast execution; notwithstanding the malt wort maturations neglected to coordinate expectations demonstrating the influences of different segments. The genuine multifaceted nature of wort synthesis helps blending yeast maturations is as yet not completely comprehended.

Oxygen impacts

Dissolved oxygen (DO) is important for preparing culture fermentations bringing about the coveted finished result. Sub-atomic oxygen plays multifaceted parts in yeast physiology and different qualities are differentially communicated in light of various oxygen situations to manage cell metabolism. Moreover oxygen is a fundamental wholesome component for the biosynthesis of unsaturated fatty acids (UFAs). The UFAs and sterols such as ergosterol are consolidated into the plasma membrane of developing cells. Cell layers bolster cell work in light of the fact that the take-up of nutrients happens over this common obstruction. Yeast that isn't given a satisfactory oxygen supply will have sub-par membrane having a lessened capacity for transport and a decreased capacity of withstanding osmotic burdens. The potential negative effect of oxygen is established on the information of the various metabolic procedures that can prompt receptive oxygen species (ROS) such as hydrogen peroxide and hydroxyl radicals. The receptive oxygen species such as hydrogen peroxide and hydrogen radicals are capable of oxidizing nucleic acids, proteins, lipids and carbohydrates and thence can influence activity of membrane and cell capacities critical for feasibility (Belinha *et al.,* 2007). However potential negative effects of oxygen on blending yeast require advancement of the dissolved oxygen necessities which incorporate the measure of dissolved oxygen supply at the right time. Attributable to limit prerequisites, fermenter tank volumes surpass brew house limit, in this manner requiring fermenter filling with various blends. Different procedures have been taken after to accomplish the upgraded DO focus at the perfect time by applying distinctive DO fixations/blend (Jones, Margaritis, & Stewart, 2007).

Elective intends to supply oxygen to the culture organism incorporates air circulation of slurries of organism before pitching. The fundamental atomic systems activated by air circulation under nutrients lacking conditions reveal that higher hypoxic repressor gene (ROX1) levels came about with expanded air circulation. The expression of translation levels of D9 unsaturated fat desaturase gene (OLE1) were at first discouraged yet then expanded with expanded air circulation. The proportion of unsaturated fats to add up to unsaturated fat creation expanded with expanded air circulation. The findings proposed that air circulation of the culture organism containing media even under conditions of supplement lack invigorated oxygen flagging pathways.

Mitochondrial roles and petites

For the differentiation of promitochondria to mitochondria oxygen is necessary (Plattner *et al.,* 1971; O'ConnorCox *et al.,* 1996a). Several important metabolic functions (such as synthesis and oxidation of fatty acids, activity of manganese-SOD and synthesis of some amino acids) occurred in fully or partially established mitochondria. Functional mitochondria under extreme conditions of stress give rise to increase cell viability (Jiminez & Benitez, 1988).changes in mitochondrial membrane can also change the surface of cell and lead to respiratory deficiencies (Zaamoun *et al.,* 1995). Further links between mitochondrial functionality and cell surface changes also observed. Acetylsalicylic acid inhibit the formation of 3-hydroxy oxylipin (Strauss *et al.,* 2007). With the consideration of ferrochelates relationship between oxygen and mitochondria breakdown converts more motivating. Enzymes bound with inner membrane of mitochondria catalyses the amalgamation of ferrous iron into protoporphyrin ring. More apparent role of mitochondria is also observed in aging. Mitochondrial DNA is essential for oxidative stress and transmembrane proteins of mitochondria ensure longevity. Moreover Spanish researchers substantiated that in mitochondrial protected S. cerevisiae cells glutaredoxin GRX5 localized to these cells against Fe-S clusters containing enzymes cause oxidative damage (Rodr´ıguezManzaneque *et al.,* 2002).

Volatility of mitochondrial genome (mtDNA) leads to the conformation of short mutants. Mutations in mitochondrial DNA metabolism (recombination, repair and replication) can cause the complete loss of mtDNA or lead to the formation of shortened forms (rho) (Contamine & Picard, 2000). Mutation lie in genes controlling diverse functions such as ATP synthase,fatty acid metabolism, iron homeostasis, mitochondrial morphology and translation. Other facts in association with mitochondrial functions and process require the brewers's attention due to the existence of petite mutants. QA aim to avoid the potential negative performance effects such as reduced yeast growth, altered flavor profiles sluggish fermentation and changed flocculation. It also concerned to minimize the incidence of petite mutants (Ernandes *et al.,* 1993).

Flavour formation

Biochemical activities in yeast cell during fermentation largely attributed for the unique flavoures of beer. The flavor compounds are intermediates between two pathways, catabolism of wort components such as s\nitrogenous compounds, sugars and sulphur compounds and synthesis of components necessary for yeast growth include proteins, lipids, nucleic acids and amino acids (Fig. 3). Yeast derived flavour compounds such as higher/fusel alcohol, vicinal diketones (VDK), organic acids, sulphur compounds, fatty acids, ethanol, carbonyls, CO2 and esters. During fermentation primary by-products formed which are ethanol and carbon dioxide as indicated in figure. 3.

Functional group of carbonyls (aldehydes and ketones) contain carbon atom double bonded to an oxygen atom. Aldehydes are formed as a part of anabolic and catabolic pathways during wort preparation (such as lipid oxidation and Maillard reaction) for higher alcohol formation during fermentation. During the formation of ethanol and acetate acetaldehyde acts as a important intermediate and consider as major aldehyde due to its importance. Presence of acetaldehyde in beer having above threshold value results in grassy flavor. Acetaldehyde has a flavor threshold of 10-20mg L1 (Meilgaard, 1975). On the other hand many tasters can identify this comound at much lower level.

Various VDK can be present but diacetyl (2,3 butanedione) and 2,3 pentanedione are the most important in beer when considering beer flavor. Both VDK impart butterscotch aroma. Threshold value of 2,3-pentanedione is sixfold higher than that of diacetyle (0.15mg L1) (Meilgaard, 1975). VDK formation is associatd with the metabolism of amino acids (Boulton & Quain, 2006). Elevated level of diacetyl is present in valine due to deficiency of wort, on the other hand wort deficient leucine results in increased level of 2,3 pentadione. Diacetyl produce by contaminants such as Lactobacillus and Pediococus. Indication of wether is gained by the use of ratio of diacetyl pentanedione in brewers. Fermentation by-products and contaminants are responsible for the elevated level of diacetyl.

Fusel alcohols can be produce by two routes by means of a-keto/2-oxo-acids and contribute to overall beer flavor (Fig. 3). In first step wort carbohydrate is synthesis in anabolic pathway by means of pyruvate, whereas in second step amino acid as a byproduct formed in catabolic process (Ehrlich pathway) (A ¨yr¨ap¨ a¨a, 1968). In 'Ehrlich pathway' branched amino acid converted into higher alcohols by three steps (reduction, transmission and decarboxylation). Though the molecular mechanism involved in this pathway for gene encoding enzymes remain unclear. Gene analysis of yeast expression revealed a group of 117 genes when

cultured on L-leucine and ammonia, these groups of genes more than two folds up or downregulated (Schoondermark-Stolk *et al.*, 2006). Gene expression group involved in amino acid metabolism consisted of genes encoding proteins. It was concluded that in the formation of unstable compounds amino acid metabolism pathways play a significant role as compared to branched chain amino acid pathways (BCAA). In second step of pathway significant gene expression showed by PDX1 during flavour formation and the activity of ARO10 with oxo-acid decarboxylase was induced (Schoondermark-Stolk et al., 2006). To understand molecular mechanism these and many other genes play a significant role to fill the gaps in understanding. The metabolic purpose for the formation of fusel alcohols is not clear and appears extravagant. However Quain & Duffield (1985) suggest that overall cellular redox balance is done by these metabolites similar to glycerol. Plasma membrane of yeast is responsible to control the glycerol content and adapted to use of glycerol as osmolyte (Hohmann, 2002).

Ester formation is a product of fermentation is closely related to lipid metabolism and growth. Over 100 esters have been identified in the fruity aromas in beer (Meilgaard, 1975). For ester formation two routes have been identified. This reaction of alcohols with fatty acyl Co-A (Nordstr¨om, 1963) run in opposite direction by esterases (Soumalainen, 1981).

Identification of many alcohols like acetyl transferases (ATF genes) have been done and ester formation needs the expression of genes (Lyness et al., 1997). Evidences from different studies of expression analysis and gene disruption of ATF family members indicated that during alcoholic fermentation enzyme ester synthases are required for the formation of esters. Mechanisms that support the oxygen mediated gene transcription of ATF family also governed the regulation of fatty acid metabolism (Mason & Dufour, 2000). Esters such as ethyl acetate (fruity/ solvent), caproate (apple/aniseed) and isoamyl acetate (banana) that impact on beer flavor.

Previous studies reported more than 110 organic and short chain fatty acids (Meilgaard, 1975). These fatty acids formed from tricarboxylic acid cycle, pyruvate and during the course of fermentation. During fermentation organic acids i.e., citrate, malate, succinate, acetate and pyruvate contribute to give sour flavour and lowering of pH. Role of two oxo-acids (a-acetolactate and a-acetohydroxy acids) as precursor of diacetyl and 2,3-pentanedione are of particular interest (Fig. 3). Chen reported that in beer and wort fatty acids are present and concluded that in wort assimilation of long chain fatty acids (stearic, linoleic, palmitic, and oleic) done by growing yeast whereas in beer short chain fatty acids are the by-products of lipid synthesis. Due to the impact of short chain fatty acids on taste and foam they are undesirable commonly.

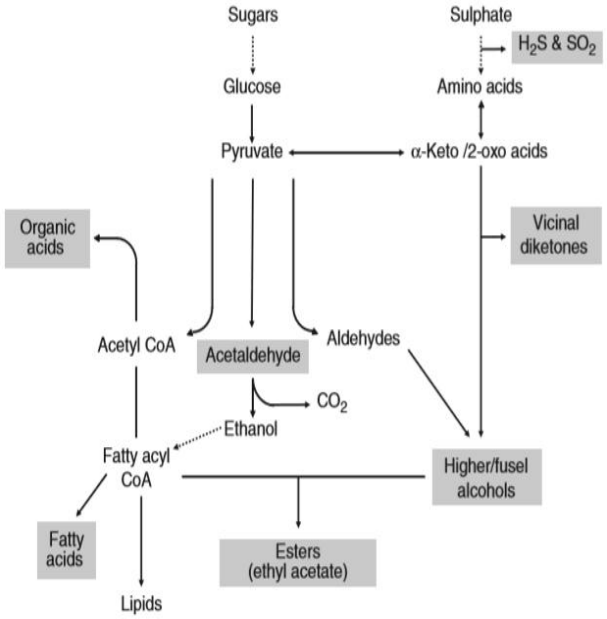

Fig. 3: Lationships among metabolic pathways causative to compounds that are flavour promoter in beer (adapted from Hammond, 1993).

Beer sulphur components

Major sulphur components such as hydrogen sulphide (H2S), sulphur dioxide (SO2), mercaptans and dimethyl sulphide (DMS) impacting mainly on beer flavour (Van Haecht & Dufour, 1995). The two main sulphur compounds such as H2S and SO2 are affected by yeast metabolism (Fig. 3). Reduced form of shulphur is an important constituent of coenzymes (thiamin, CoA, biotin, and pyrophosphate), proteins (sulphur-containg methionine and cysteine) and many other metabolites (thioles and glutathione). Radiochemical experiments exhibit that in wort all forms of sulphur formed during fermentation from sulphate and inorganic sulphur sources. During fermentation negative flavour impact control the production of SO2. Favour-inactive carbonyl-sulphite adducts are formed when sulphite reacts with carbonyls (trans-2-nonenal acetaldehyde and) and also function as antioxidant.

Sulphur metabolism regulation involves gene expression and feedback inhibition. Thomas and SurdinKerjan (1997) investigated the biosynthetic pathways of sulphur amino acids and then examined in wine yeast (Swiegers & Pretorius, 2007). S- Adenosyl-methionine (AdoMet/SAM) important role in sulphate uptake reaction by repressing the enzyme transcription and also act as co-factor in many reactions.

At an industrial level tracking production of sulphur has been challenging. Positive progress in industrial setting develops the production of H2S and SO2 was high throughout the process Duan et al., 2004). Yeast can produced both H2S and SO2 compounds in greater quantities when elevated level of cycteine is present. Methionine had no effect on the production of SO2 but repressed the level of H2S formation by cysteine. In wort

differences in the concentrations of H2S and SO2 were also seen produced in response to nitrogen level. Previous studies concluded that biochemical relation exists in the production of H2S and SO2 environmental conditions also affect their rate of production (Duan et al., 2004).

DMS can takes place by means of two routes; the first one is during wort boiling degradation of S-methylmethionine (SMM) takes place and second is during fermentation yeast reduce the dimethyl sulphonide Anness & Bamforth, 1982; Dickenson, 1983). The final concentration of DMS in beer is exactly that amount of DMS in wort present at pitching. During fermentation DMO formed by DMSO during reduction. The most important purpose of brewer is minimize the unpleasant sulphury flavour in end product.

Yeast handling (cropping, storage and pitching)

Yeast handling involves numerous yeast management treatments i.e., mechanical and physical (O'Connor-Cox, 1997, 1998a,b; Kennedy, 2000). Circuits for the movement of yeast from one vessel to another are designed. Brewing yeast can be recovered in the yeast handling cycle (Fig. 4), with the use of cropping pumps are used after the fermentation process. Recent circuits are designed of yeast handling for the movement of yeast from one vessel to be slanting in the next. During the yeast handling cycle (Fig. 4), cropping pumps are used after the fermentation process from the cone of the fermentation vessel (FV) to improve the brewing yeast (O'Connor-Cox, 1997).

Nutrients were utilized during fermentation process and the key metabolites (CO2 and ethanol) were produced. Yeast crop sensitive to numerous stresses consist of variations in pH, concentration of ethanol, pressure, nutrient limitation, carbon dioxide, DO concentration and temperature (Heggart *et al.*, 1999; Gibson *et al.*, 2007). Due to the existence of olderordead cell a small proportion of crop is damaged. These dead cells are deposited at the base of the cone (Powell *et al.*, 2003, 2004). Extended lag phase is the result of presence of aged yeast cells whereas if newly budded cells present in crop then they require time for division and hence delay the growth (Powell et al., 2000). It is therefore essential in brewery these practicing do not select yeast enriched population in young cells.

Potential negative impact (Van Uden et al., 1983; Lentini et al., 2003; Thiele & Back, 2007) can be decreased by treated the remaining crop with dilution liquor. Now this recovered crop is stored until needed for fermentation. If the crop fail QA test or older as compared to require for growth (numbers of cycles used), then the crop will be consider as a waste and freshly prepared culture required.

Storage, pitching and cropping of yeast need to hold up QA targets such as freedom from contamination, correct strain integrity, viability or vitality and phenotypical homogeneity (metabolism, flocculence and age). No adherence to good practice like atmospheric pressure, storage, sterilization, effective agitation and cleaning have concomitant impact on fermentation performance and will lead to crop deterioration condition.

To remove the bacterial contaminants acid washing of pitching yeast with phosphoric acid which is common practice as bactericidal substances in many breweries (Cunningham & Stewart, 1998). Value of pH for this procedure is from 2.2 to 2.5 at a temperature below 41C for a few hours. However this method has negative impact on yeast condition and may not kill all bacteria. Previous studies reported that when this practice applied correctly it can change cell surface hydrophobicity (Wilcocks & Smart, 1995) and can also decrease cell viability (Van Bergen & Sheppard, 2004) showed the potential danger.

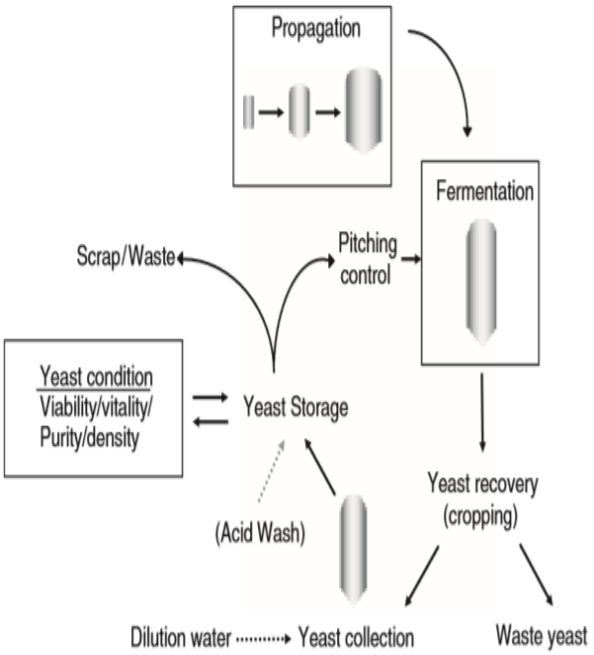

Fig. 4: The chief activities throughout handling of lager yeast in CCVs.

Maturation (conditioning, lagering, ageing and diacetyl stand)

Green beer maturation is necessary to clarity of larger beer, flavour anf refine the fimished aroma. The main purpose of maturation of green beer is for yeast sedimentation, carbonation and adjustment of flavour (DMS, diacetyl and SO2). There are two parts of green beer maturation one is warm maturation and other one is cold (lagering) process. Reduction in flavour active components (2,3-pentanedione and diacetyl) is possible with the procedure of warm maturation. In lager beer style high level of diketones than threshold level is not acceptable due to the presence of butterscotch aroma. During fermentation performance or at the completion of fermentation high level of diacetyl is not limited to balance. Diacetyl concentration can be increase due to

pediococcus contaminations and respiratory deficient petite mutants (Ernandes et al., 1993).

Total diacetyl profile concentration with longer transition phases due to the contribution of valine concentration of wrot (between 130 and 140mgL1) and maximum appeared later (Petersen *et al.,* 2004). Due to the presence of diacetyl reduction times extended. The removal of diacetyl in the maturation of beer is the rate limiting step. Brewers manage diacetyl profile by using various strategies in beer. For the conversion of decarboxylation of a-acetolactate to diacetyl hold by the fermenter at high temperature (relative to the fermentation temperature). Diacetyles reduces to less flavour active products as butanediol and acetoin by yeast. Other strategies such as the use of enzymes (a-acetolactatedecarboxylase) and immobilization technology (Yamauchi *et al.,* 1995; Moll & Duteurtre, 1996) in which enzymes without the formation of diacetyl convert the a-acetolactate to acetoin. Fermentation and other strategies control the concentration of final product (Yamano et al., 1995). Aim for the maturation process of cold part is to improve colloidal stability of beer. Factors that have important acticity are proteins and polyphenol (tannin) complexes that aerformed as well as glucan excreted during fermentation by yeast. A visible haze for consumer's perspective may not b attractive is result. Insoluble protein- complexes at 21C precipitate and then remove by subsequent filtration process. The final step is the packaging of product and then ensures delivery of beverages to consumers.

Future yeast research

Arguably, the first complete genome sequencing of eukaryotes (Goffeau et al., 1996) in 1996 of yeast was the biggest break throughout the history. Microarrary technology was develoed with the help of this sequencing. Analysis of transcription levels with DNA microarrary become a tool to study metabolic changes and gene expression and also applied this to brewing yeast (Olesen et al., 2002). Genetic background of lager yeast is more complex than S.cerevisiae. Future developments during optimization of yeast performance, fermentation and yeast handling are the best brewing practices (Kobayashi et al., 2007). Recent study on metabolites reported that there is a potential in future development not only differentiate but also select stains of brewing for new brands. Fluctuations in wort compositions have impact on yeast performance.

The scientific basis of industrial strains for genetic manipulation is provided by progressive developments in molecular biology of laboratory cultures and yeast genetics. Transformation of brewing yeast includes yeast flocculation genes (FLO1), glucoamylase from S. cerevisiae var, maltose-permease gene introduction, diastaticus, ex Bacillus subtilis b-glucanase, MET10 elimination (Boulton & Quain, 2006). However, in brewing industry (Stewart & Russell, 1986) future application of genetic engineering were not realized. Consumer discretion and median interest make it nonviable option about genetically modified food in global market. Fortunately exploitation opportunity as a model of S. cerevisiae not lost (Goffeau *et al.,* 1996). Experimental system of eukaryotics is used to comprehend the molecular mechanism of disease like plague (Czabany et al., 2007). as well as ageing (Belinha et al., 2007). Besides this mankind diseases yeast also serves as model to cure diseases. Yeast also has beneficial impact for consumers.

CONCLUSION

S. cerevisiae the major character in the beer brewing procedure is not only important but yeast also has the centre stage role in other biotechnological industries which are benefiting mankind (bread baking, alcoholic beverage production, fine chemicals and bioethanol). The earlier estimates that yeast fermentation as replenish able energy source for the production of bioethanol is being recognized because industry is now taking on this technology. Bioethanol fermentation and beer fermentation have main difference of final product requirements. Bioethanol fermentations require ethanol as the main product at the utmost yield for the process. In contrast, beer fermentation targets for ethanol containing well-balanced flavourful products. The script of the process is centered on years of studies to understand the requirements of yeast and how best to treat the yeast for balanced flavour production and enhanced performance. The different aspects under cellars (hygiene requirements, propagation, yeast handling and fermentation) indicated that the multifaceted process has various intertwined factors that need to be considered in the scheme of economic and effective brewing processes. After careful planning and optimization, based on the requirement of the central character S. cerevisiae, the reward ultimately results in an enjoyable and energizing beverage.

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