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1 **Monitoring residue concentrations in milk from farm and throughout a milk powder**
2 **manufacturing process**

3

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12 Short title: **Milk quality from farm to milk powder**

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29 **Summary**

30 The experiments reported in this research paper aimed to investigate differences in the levels
31 of chlorate (CHLO), perchlorate (PCHLO), trichloromethane (TCM) and iodine residues in
32 bulk tank (BT) milk produced at different milk production periods, and to monitor those
33 levels throughout a skim milk powder (SMP) production chain (BTs, collection tankers
34 [CTs], whole milk silo [WMS] and skim milk silo [SMS]). Chlorate, PCHLO and iodine
35 were measured in SMP, while TCM was measured in the milk cream. The CHLO, TCM and
36 iodine levels in the mid-lactation milk stored in the WMS were lower than legislative and
37 industrial specifications (0.0100 mg/ kg, 0.0015 mg/ kg and 150 µg/ L, respectively);
38 however, in late-lactation, those levels were numerically higher than the mid-lactation levels
39 and specifications. Consequently, CHLO and iodine levels in SMP were numerically higher
40 in late-lactation than in mid-lactation. Trichloromethane accumulated in the cream portion
41 after separation. Perchlorate was not detected in any of the samples. Regarding iodine, the
42 levels in mid-lactation reconstituted SMP were higher than that required by manufacturers
43 (100 µg/ L), indicating that the levels in milk should be lower than 142 µg/ L. The higher
44 residue levels observed in late-lactation could be related to the low milk volume produced
45 during that period and changes in sanitation practices, while changes in feed management
46 could have affected iodine levels. This study could assist in controlling and setting limits for
47 CHLO, TCM and iodine levels in milk, ensuring premium quality dairy products.

48

49 **Keywords:** chlorate, perchlorate, trichloromethane, iodine, milk quality

50

51 International markets are setting high specifications for milk and dairy product quality,
52 including stringent guidelines on concentrations of residues that could occur in milk.
53 Potential milk contaminants of most concern include chlorate (CHLO, ClO_3^-), perchlorate
54 (PCHLO, ClO_4^-) and trichloromethane (TCM, CHCl_3), which arise as a consequence of
55 sanitation with chlorine products.

56 Chlorate and PCHLO were reported to result in thyroid dysfunctions (EFSA, 2015), while
57 TCM could possibly be carcinogenic to humans (ICAR, 1999). There are a few studies
58 available that have discussed contributing factors on-farm (Gleeson *et al.*, 2013; Ryan *et al.*,
59 2013); however, the dynamic of residue concentrations when subjected to different milk
60 processing conditions is not fully understood. Sodium hypochlorite, chlorine gas or dioxide
61 may be used for the sanitation of water, while chlorine-based detergents are used for the
62 sanitation of milking or processing equipment. Chlorine products generally have good

63 bactericidal properties and are widely used because of their effectiveness and low cost
64 (Garcia-Villanova *et al.*, 2010). The decomposition of chlorine compounds results in the
65 production of oxyhalide species (ClO^- and ClO_2^-), which react and form CHLO. Further
66 reactions of CHLO with those oxyhalides result in the formation of PCHLO (Gordon &
67 Tachiyashiki, 1991). Residual chlorine, CHLO or PCHLO on the surfaces of processing
68 equipment can contaminate milk (Asami *et al.*, 2013). The contamination of infant formula
69 with CHLO is a major concern due to the risk of intoxication in infants, which have lower
70 tolerance than adults. The contact of chlorine with milk could also result in the formation of
71 TCM (Tiefel & Guthy, 1997). Chlorinated hydrocarbons accumulate in fat-rich fractions;
72 therefore, products such as butter and cream could contain high concentrations of TCM if
73 milk is contaminated with high levels (Hubbert *et al.*, 1996).

74 Excessive levels of residual iodine in raw milk are another concern in the Irish dairy industry,
75 especially in the manufacture of infant formula. Iodine is an essential micronutrient for the
76 synthesis of hormones by the thyroid gland (Leung & Braverman, 2014). Even though iodine
77 is a nutrient of extreme importance to the human organism, the daily consumption of iodine
78 at higher levels than recommended could result in dysfunctions of the thyroid gland. Bovine
79 milk is one of the main sources of iodine for humans and its content depends on the daily
80 iodine intake by dairy cows (Flachowsky *et al.* 2014). The US National Research Council
81 (2001) recommends that the daily iodine intake per cow should be 10 mg, which is the
82 reference value applied in Ireland. The utilisation of rations with higher levels of iodine than
83 required or overfeeding cows can result in excessive iodine concentrations secreted into milk.
84 Over supplementation of Irish herds is of most concern during early and late-lactation and
85 during winter milk production (O'Brien *et al.*, 2013). O'Brien *et al.* (1999) recorded an
86 average of 227 $\mu\text{g}/\text{L}$ iodine in Irish milk, while concentrations of 510 and 180 $\mu\text{g}/\text{L}$ were
87 recorded for December and June, respectively. Those levels were not a food safety concern at
88 the time; however, processors are currently requiring lower levels of iodine in raw milk
89 destined for the production of infant formula, in order to meet requirements of the
90 international market. Some Irish dairy processors require that raw milk should contain less
91 than 150 $\mu\text{g}/\text{L}$ of iodine. Other iodine sources in milk include mineral-added water, boluses,
92 mineral licks and grass (Magowan *et al.*, 2010). The use of iodine-based teat disinfectants
93 could also contribute to iodine content in milk, as those products are absorbed through the
94 teat skin if not completely removed prior to milking (Flachowsky *et al.* 2014).

95 The first objective of this study was to investigate changes in the CHLO, PCHLO, TCM and
96 iodine levels throughout the milk production chain, from farm to dairy product, in two

97 different milk production periods (mid- and late-lactation). Chlorate, PCHLO and iodine
98 were measured throughout the production stages of skim milk powder (SMP), while TCM
99 was measured throughout the production stages of milk and cream, which were destined for
100 butter manufacture. The second objective was to investigate differences in residue levels in
101 bulk tank (BT) milk produced during mid- and late-lactation. The milk used in this study was
102 produced on commercial dairy farms and processed in a commercial SMP processing plant.

103

104 **Materials & Methods**

105 *Sampling procedure at the farms and throughout a skim milk powder manufacturing process*

106 In Ireland a seasonal spring-calving production system is practiced, with all cows calving
107 within a 10-week period approximately (February to April). This experiment was performed
108 on one occasion during each of mid- (May; 80 DIM) and late-lactation (December; 290
109 DIM). The farms that supplied milk to the factory (mid-lactation: 67 farms; late-lactation:
110 150 farms), milk storage conditions on-farm, amount of milk produced, milk collection and
111 the skim milk powder manufacturing process was the same as described by Paludetti *et al.* (in
112 press). A schematic drawing of the SMP manufacturing process is shown in supplementary
113 Figure S1.

114 In mid-lactation, samples were collected at various points of the manufacturing process
115 between the farm BTs and the SMP [BTs, collection tankers (CTs), whole milk silo (WMS),
116 skim milk silo (SMS) and final SMP] and were tested for CHLO, PCHLO and iodine. In late-
117 lactation, samples were collected at various points between the CTs and the SMP [CTs,
118 WMS, cream silo (CS), SMS and final SMP] and were tested for CHLO, PCHLO and iodine.
119 In both lactation periods, TCM was quantified in all samples, with exception of the SMP
120 samples (supplementary Figure S1). Due to the high number of farms (150) necessary to
121 supply sufficient milk volume to undertake the manufacturing process in late-lactation
122 (December), it was not possible to undertake collection and analysis of all individual BT
123 samples. The collection of samples and preparation of SMP samples for analysis were
124 performed as described by Paludetti *et al.* (in press).

125

126 *Comparison between the residue levels in the same 67 farm bulk tanks in mid- and late-* 127 *lactation (May and November)*

128 The concentrations of CHLO, PCHLO, TCM and iodine residues were measured in raw milk
129 produced on the same 67 dairy farms sampled in mid-lactation (May, 80 DIM) and in late-

130 lactation period (November; 260 DIM), to investigate the effect of milk production period on
131 residue levels. Milk samples were collected as described by Paludetti *et al.* (in press).

132

133 *Quantification of chlorate and perchlorate*

134 The quantification of CHLO and PCHLO was performed by high-performance liquid
135 chromatography coupled to tandem mass spectrometry (LC/ MS-MS) with ESI electrospray
136 ionisation in negative mode (-ESI). The mid-lactation milk and SMP samples, as well as the
137 67 late-lactation farm BT samples, were analysed in the laboratory of Labor Friedle GmbH
138 group (Labor Friedle GmbH, Von-Heyden-Straße 11, D-93105, Tegernheim, Germany),
139 while the late-lactation samples from the factory (CT, WMS, SMS and SMP samples) were
140 analysed in Teagasc Ashtown (Dublin, Ireland). The methodologies used are based on the
141 procedures described in the European Quick Polar Pesticides method (QuPPE) (EURL-SRM,
142 2015). In the present study, some of the milk samples were analysed by both laboratories and
143 the results were statistically similar ($P>0.05$). The detection limit of CHLO and PCHLO in
144 milk was 0.0010 mg/ kg and in SMP was 0.010 mg/ kg.

145

146 *Quantification of trichloromethane*

147 Trichloromethane was quantified in the milk using static head-space gas chromatography
148 (HS-GC) with electron capture detector (ECD), fitted with a low thermal mass system (LTM)
149 (Agilent 7890A, Agilent Technologies, Santa Clara, California, USA). The trichloromethane
150 detection limit in this analysis was 0.0001 mg/ kg. The methodology applied was an adaption
151 of the procedure of Resch & Guthy (1999). This analysis was performed in the Milk Quality
152 laboratory in Teagasc Moorepark (Fermoy, Co. Cork, Ireland).

153

154 *Quantification of iodine*

155 Iodine was quantified in milk and reconstituted SMP samples using inductively coupled
156 plasma mass spectrometry (ICP-MS), using an Agilent ICP-MS 7700x (Agilent
157 Technologies, Santa Clara, California, USA). The methodology used was based on the
158 procedures described in the standard method for the determination of iodine compounds in
159 foodstuffs (BS EN 15111:2007, 2007). Standard solutions of Tellurium and 1% TMAH were
160 used to obtain a calibration curve. The limit of detection was 1.31 µg/ L. The mid-lactation
161 milk and SMP samples were analysed in Teagasc Moorepark (Fermoy, Co. Cork, Ireland),
162 while the late-lactation milk and SMP samples were analysed in FBA laboratories

163 (Capoquinn, Co. Waterford, Ireland). Those laboratories used the same methodology and
164 samples analysed by both laboratories had statistically similar results ($P>0.05$).

165

166 *Statistical analysis*

167 *Influence of individual farm milk volumes on the residue concentration in each CT and*
168 *influence of CT milk on the residue concentration in WMS*

169 The statistical analyses were performed using the software SAS 9.3 (SAS Institute, 2016). In
170 mid-lactation, the iodine and TCM concentrations of each CT were predicted using the
171 volume and iodine or TCM concentrations measured in the milk of all farms that supplied
172 each respective CT. In mid- and late-lactation, the iodine and TCM concentrations in the
173 WMS were also predicted using the volume and iodine or TCM concentrations in the milk of
174 all CTs that supplied that silo. Those predictions were calculated as volume-weighted means
175 with estimated confidence intervals. The actual iodine or TCM concentrations measured in
176 each CT and WMS samples were compared to the respective confidence interval for those
177 predicted means. Agreement plots were also used to check for bias in the relationship
178 between actual and predicted means. It was not possible to perform the same analyses with
179 the CHLO and PCHLO results, due to the low number of samples in which those residues
180 were detected.

181

182 *Comparison between the residue levels in the same 67 farm bulk tanks in mid- and late-*
183 *lactation (May and November)*

184 Differences between the adjusted least square means of the 67 mid- and late-lactation milk
185 samples, collected in May and November, were calculated using the MIXED procedure in
186 SAS 9.3 (SAS Institute, 2016). The fixed effects included in each model were lactation
187 period (mid- and late-lactation) and farms (numbered from 1 to 67). Farms were considered
188 the experimental unit and the response variable was iodine or TCM. Residual checks were
189 made to ensure that the assumptions of the analysis were met.

190 It was not possible to statistically determine the differences between CHLO and PCHLO
191 levels measured in mid- and late-lactation milk samples, due to insufficient number of
192 samples in which those residues were detected. McNemar's test was applied to compare the
193 number of BT milk samples in mid- and late-lactation that had CHLO and TCM
194 concentrations ≥ 0.0010 and 0.0015 mg/kg, respectively. The GLM procedure was used to
195 determine the regression relationship between CHLO and TCM concentrations.

196

197 **Results**

198 The mean CHLO, TCM and iodine concentrations of samples collected during mid- and late-
199 lactation (May and December, respectively) throughout the milk powder production chain are
200 shown in Table 1.

201

202 *Chlorate and perchlorate*

203 In mid-lactation (May), CHLO was detected in 14 of the 67 BT and 6 of the 11 CT samples.
204 The weighted mean CHLO concentration was calculated at the basis of the milk volume
205 supplied by those farms and CTs (Table 1). The volume-weighted mean CHLO
206 concentrations of these farms and CTs were numerically similar.

207 In late-lactation (December), CHLO was detected in 6 of the 11 CT samples also, but the
208 volume-weighted mean of those samples was higher compared to mid-lactation (Table 1).

209 In both mid- and late-lactation, the mean CHLO concentration in the WMS and SMS were
210 numerically similar (Table 1).

211 The mean CHLO concentration of the SMP samples was higher in late-lactation (December)
212 compared to mid-lactation (May) (Table 1). In both lactation periods, the CHLO
213 concentration in powder increased approximately 50 times compared to the concentrations in
214 SMS samples. In mid-lactation, the CHLO levels in the SMP samples decreased throughout
215 the spray-dryer run. At the start, middle and end of the spray-drying process, the CHLO
216 levels were: 0.0630 ± 0.0020 , 0.0610 ± 0.0060 and 0.0470 ± 0.0020 mg/ kg, respectively. In
217 contrast, the CHLO concentration of the late-lactation SMP samples did not vary throughout
218 the spray-dryer run (start: 0.124 ± 0.003 mg/ kg; middle: 0.129 ± 0.011 mg/ kg; end: $0.126 \pm$
219 0.006 mg/ kg).

220 Perchlorate was not detected in any of the mid- and late-lactation samples collected
221 throughout the manufacturing process.

222

223 *Trichloromethane*

224 Trichloromethane was detected in all BT and CT samples collected in mid-lactation (May)
225 and in all CT samples collected in late-lactation (December). The volume-weighted mean
226 TCM concentration of those samples was calculated considering the milk volume supplied by
227 each BT or CT (Table 1). The volume-weighted mean TCM concentration of the CT milk
228 samples was higher in late-lactation compared to mid-lactation. In mid-lactation, the volume-
229 weighted mean TCM concentrations of the milk samples from the BTs and CTs were

230 numerically similar. The mean TCM concentrations of the milk samples from the CTs and
231 WMS were also numerically similar in both mid- and late-lactation.

232 The comparisons between the actual TCM concentration and the respective confidence
233 interval for the predicted means for each mid-lactation CT sample, are shown in the
234 supplementary Table S1. The TCM concentrations in all of the mid-lactation CT samples
235 were within their respective confidence intervals. A similar comparison for the mid- and late-
236 lactation WMS samples is shown in the supplementary Table S2. The TCM concentration in
237 the WMS samples were also within their respective confidence interval in mid- and late-
238 lactation.

239 In both lactation periods, the mean TCM concentration decreased in the SMS samples
240 compared to the WMS samples, as expected (Table 1).

241

242 *Iodine*

243 In mid-lactation, the volume-weighted mean iodine concentration was numerically higher in
244 the BT samples than in the CT samples. The volume-weighted mean iodine concentration of
245 all of the CTs was numerically higher in late-lactation than in mid-lactation. In mid-lactation,
246 the mean iodine concentrations in the CTs and WMS were similar, while in late-lactation, the
247 mean concentration was numerically higher in the CTs compared to the WMS (Table 1). In
248 both lactation periods, the iodine concentrations increased in SMS samples; and
249 consequently, as levels were higher in late-lactation BT milk, the iodine concentration in
250 SMP was higher in late-lactation than in mid-lactation.

251 The comparisons between the actual iodine concentrations of each mid-lactation CT sample
252 with the respective confidence interval for the predicted means are shown in the
253 supplementary Table S3, while such comparison for the mid- and late-lactation WMS
254 samples are shown in the supplementary Table S4. All the iodine concentrations measured in
255 each mid-lactation CT sample were within the respective confidence intervals, as well as the
256 WMS samples collected in mid- and late-lactation.

257

258 *Comparison between the residue levels in the same 67 farm bulk tanks in mid- and late- 259 lactation (May and November)*

260 The number of BT samples in which CHLO was detected was significantly higher in late-
261 lactation (32 out of the 67 samples) than in mid-lactation (14 out of the 67 samples)
262 ($P < 0.0001$). Also, in contrast to mid-lactation, 8 out of the 67 late-lactation BT samples
263 contained 0.0010 mg/ kg of PCHLO.

264 The volume-weighted mean TCM concentration was significantly higher in late-lactation
265 (0.0015 ± 0.0014 mg/ kg; range: 0.0003 to 0.0074 mg/ kg) than in mid-lactation ($0.0009 \pm$
266 0.0008 mg/ kg; range: 0.0002 to 0.0043 mg/ kg) ($P < 0.0001$).

267 The volume-weighted mean iodine concentrations of the BT samples in mid- and late-
268 lactation (142.2 ± 129.2 and 119.7 ± 151.6 $\mu\text{g/ L}$, respectively) were not statistically different
269 ($P = 0.63$).

270

271 **Discussion**

272 *Residues related to the use of chlorine*

273 Concentrations of CHLO and PCHLO were monitored throughout the production chain of
274 SMP in mid- and late-lactation (May and December, respectively). In Europe, a default
275 threshold limit of 0.0100 mg/ kg of CHLO and PCHLO is applied for milk (EC no
276 396/2005). In mid-lactation (May), the volume-weighted mean CHLO concentration in the 14
277 BTs and 6 CTs (in which CHLO was detected) were lower than that limit; however, in late-
278 lactation (December), the mean CHLO concentration of the 6 CTs (in which CHLO was
279 detected) was higher than the EC limit and higher than the volume-weighted mean
280 concentration in mid-lactation.

281 In mid-lactation, the CHLO concentrations in each of the CTs could have been diluted as
282 CHLO was not detected in 53 of the BTs. For example, CHLO was not detected in 4 CT milk
283 samples, as only one of the BT milk volumes contributing to each of those CTs contained
284 CHLO. Additionally, CHLO was not detected in most of the BT milk supplied to the 6 CTs
285 in which CHLO was detected, indicating that the sanitation of those CTs could possibly have
286 influenced the CHLO levels. In both mid- and late-lactation, as CHLO was not detected in
287 most of the CT milk volumes, the CHLO concentrations could have also been diluted in the
288 WMS; therefore, it is likely that the sanitation practices of the silos did not influence the
289 CHLO levels. Consequently, the mean CHLO concentrations in the WMSs were lower than
290 the EC limit of 0.0100 mg/ kg. However, as the milk supplied to the factory during late-
291 lactation contained higher levels of CHLO than the mid-lactation milk, the CHLO levels in
292 the WMS in late-lactation were higher compared to mid-lactation; consequently, the CHLO
293 levels in the SMP were higher in late-lactation than in mid-lactation.

294 In mid-lactation, the mean CHLO concentration of the SMP samples was lower than the limit
295 applied by some Irish infant formula manufacturers (0.100 mg/ kg). The difference of 0.0016
296 mg/ kg between the mean CHLO concentration of the SMP samples collected at the end and
297 start of the spray-drying run, indicated that the sanitation of the spray-dryer could have

298 contributed to the CHLO levels in SMP. The interior surface of the spray-dryer could have
299 contained residual CHLO, and the majority of that residue was transferred to the first batch of
300 evaporated skim milk that entered the equipment. In late-lactation, the mean CHLO
301 concentration of the SMP samples was higher than 0.100 mg/ kg, indicating that the CHLO
302 level in the bulk milk stored in the WMS should had been lower than 0.0025 mg/ kg. Even
303 though no variations in the CHLO concentration were observed in SMP samples collected
304 throughout the spray-drying run in late-lactation, sanitation practices of that equipment could
305 have also contributed to the increased CHLO levels in SMP. Additionally, the variations in
306 CHLO concentrations throughout the spray-drying run that were observed in mid-lactation
307 and not observed in late-lactation could be due to differences in the sanitation practices
308 between production periods.

309 The concentrations of TCM were also monitored throughout the production chain of SMP in
310 mid- and late-lactation (May and December, respectively). There are no European regulations
311 that have defined a standard TCM limit for milk or dairy products; however, Irish dairy
312 processors apply a limit of 0.0015 mg/ kg to milk destined for the production of lactic butter
313 which should have less than 0.0300 mg/ kg of TCM, as required by the export market (Ryan
314 et al., 2013). In mid-lactation, the mean TCM concentrations of the BTs, CTs and WMS were
315 all lower than that limit; while, in late-lactation, the mean TCM concentrations of the CTs
316 and WMS were higher than that limit and higher than the concentrations in mid-lactation.
317 The agreement between the TCM concentrations of each mid-lactation CT sample and the
318 contributions of each BT milk volume supplied, as well as the agreement between the TCM
319 concentrations of the WMS samples and the contributions of each CT in both lactation
320 periods, indicated that the cleaning protocol of the CTs or WMS did not contribute to any
321 increases in the TCM levels in milk (Tables S1 and S2).

322 In both lactation periods, the decrease in the TCM concentrations in the SMS in relation to
323 the WMS was expected, due to the accumulation of TCM in the cream during separation
324 (Hubbert *et al.*, 1996; Table 1). As the levels of TCM were higher in late-lactation milk, the
325 TCM concentration in late-lactation cream was possibly higher than the levels expected in
326 cream produced with mid-lactation milk.

327 The concentrations of CHLO and TCM were also monitored in the same 67 farm BTs in mid-
328 and late-lactation (May and November, respectively) to investigate if those concentrations
329 could differ in milk produced by the same farm during different production periods. None of
330 the mid-lactation BT samples contained CHLO levels higher than 0.0100 mg/ kg (EC limit),
331 while 5 late-lactation BT samples contained levels higher than that limit. In relation to TCM,

332 the number of BT samples that contained levels greater than 0.0015 mg/ kg was significantly
333 higher in late-lactation (21 BT samples; range: 0.0016 to 0.0074 mg/ kg) than in mid-
334 lactation (7 BT samples, range: 0.0017 to 0.0043 mg/ kg) ($P = 0.002$). Those increases in the
335 levels of those residues in late-lactation could be related to changes in the sanitation practices
336 on each farm. Chlorine detergent sterilisers should contain a maximum of 3.5% of chlorine
337 and should be prepared and applied according to the manufacturer's instructions (Gleeson,
338 2016). According to Ryan et al. (2012), 14 L of rinse water per milking unit are
339 recommended in order to totally remove the detergent solution, and the solutions should be
340 rinsed immediately after the wash cycle. Additionally, the lower volume of milk produced
341 per farm during late-lactation ($1,683 \pm 1,031$ L) could have also contributed to the increase in
342 CHLO or TCM levels during that period, as those residues could have been more
343 concentrated. The presence of CHLO and TCM in milk was not correlated; therefore, if milk
344 contains CHLO it will not necessarily contain TCM and *vice versa*. The contamination of
345 milk with CHLO or TCM might be related to a combination of specific sanitation practices
346 and further studies are necessary to determine them. In addition, the higher number of farms
347 in late-lactation that supplied milk containing higher levels of CHLO or TCM indicated that
348 extra care is required during that period for the production of milk powder or butter.

349

350 *Iodine*

351 Variations in the iodine concentrations were investigated throughout the production chain of
352 SMP in mid- and late-lactation (May and December, respectively). The EFSA (2005)
353 reported that the average iodine concentration in BT milk samples from several European
354 studies was predominately between 100 and 200 $\mu\text{g/ L}$, which were suitable to meet the
355 required iodine daily intake for children and adults. Some Irish dairy processors specify that
356 the iodine levels in raw milk should be lower than 150 $\mu\text{g/ L}$ to produce infant formula. In
357 mid-lactation, the mean iodine concentration of the BT, CT and WMS samples were all lower
358 than that limit; while in late-lactation, the mean concentrations of the CT and WMS were
359 higher than that limit.

360 Flachowsky *et al.* (2014) suggested that iodine could undergo sublimation throughout
361 processing, as more than 90% of iodine in milk is in the inorganic form. Small decreases in
362 the mean iodine concentration observed from the BTs to CTs (mid-lactation) and from the
363 CTs to WMS (late-lactation) could be associated with the sublimation of iodine (Table 1).
364 The actual iodine concentrations measured in each CT (Table S3) and WMS (Table S4) were
365 in agreement with the contributions of each BT and CT, respectively. However, the actual

366 concentrations of each CT and WMS were slightly lower than the predicted concentrations
367 (Tables S3 and S4), indicating that possibly a small amount of iodine underwent sublimation
368 during transport and storage, but not sufficient to be significant. Those small losses could
369 have resulted in those decreases in the mean iodine concentrations shown in Table 1.

370 In mid-lactation, two CT samples had levels higher than 150 $\mu\text{g}/\text{L}$ (390.8 and 202.9 $\mu\text{g}/\text{L}$).
371 One of those CTs collected milk from two farms that supplied milk containing 289.1 and
372 516.0 $\mu\text{g}/\text{L}$ of iodine. The other CT collected milk from 5 farms; however, most of the
373 volume collected was from one farm that supplied milk containing 561.2 $\mu\text{g}/\text{L}$ of iodine.
374 Therefore, it is important that individual milk suppliers control the iodine intake of their
375 herds and correctly apply iodine-based teat disinfectants (US National Research Council,
376 2001; O'Brien *et al.*, 2013). In late-lactation, all of the CT samples had levels higher than 150
377 $\mu\text{g}/\text{L}$, indicating that the iodine levels in BT milk were possibly higher in late-lactation than
378 in mid-lactation. Those higher levels could be due to the contribution of the increased number
379 of farms (150) and also due to high levels of iodine in ration supplied to the cows when
380 indoors.

381 In both lactation periods, the mean iodine concentrations increased in the SMS when
382 compared to the WMS. Prior to pasteurisation and cream separation, milk permeate (details
383 were not disclosure by the manufacture) is added to standardise the protein and lactose
384 content in milk; therefore, that permeate could have contributed to an increase in the iodine
385 content in the SMS.

386 The International Council for Control of Iodine Deficiency Disorders (ICCIDD; Delange *et*
387 *al.*, 1993) specified that the iodine content in reconstituted SMP should be lower than 100 $\mu\text{g}/$
388 L . The mean iodine concentrations of the SMP produced in mid- and late-lactation were
389 higher than that limit (Table 1). Therefore, in the case of the conditions of this study, the
390 iodine levels in the bulk milk supplied to the factory should be lower than 142 $\mu\text{g}/\text{L}$ to
391 produce SMP containing iodine levels within the specification. Also, as the iodine levels
392 were higher in late-lactation compared to mid-lactation milk, the iodine content in
393 reconstituted SMP was also higher in late-lactation than in mid-lactation.

394 In order to investigate variations in the levels iodine in BT milk during different production
395 periods, the concentrations of such residue were also measured in the same 67 farm BTs in
396 mid- and late-lactation (May and November, respectively). In mid- and late-lactation, 13 and
397 12 BT samples had iodine concentrations higher than 150 $\mu\text{g}/\text{L}$, respectively. Questionnaires
398 were completed on some of those farms, capturing information regarding animal feed. It was
399 established that the majority of those farms were using concentrates from one manufacturer,

400 which contained at least 10 and a maximum of 43 mg of iodine/ kg of ration. Therefore, the
401 iodine intake from ration per cow on those farms was likely to be higher than that
402 recommended (10 mg per cow per day), as the average ration intake on those farms was 2.5
403 kg per cow per day. Other factors that were not included in the questionnaires could have
404 contributed to iodine levels in milk such as grass, boluses, mineral-supplemented water and
405 mineral licks. Furthermore, according to the questionnaires, five and two farms that were
406 using iodine-based teat disinfectants supplied milk with iodine levels higher than 150 µg/ L,
407 in mid- and late-lactation, respectively. O'Brien *et al.* (2013) also observed increases in the
408 iodine levels in milk when applying those teat disinfectants post-milking. Those increases are
409 associated with the absorption of iodine through the teat skin, particularly if pre-milking teat
410 preparation is not being conducted.

411

412 **Conclusion**

413 Incorrect sanitation practices on-farm can result in increases in the CHLO or TCM levels in
414 milk throughout the year, while the production of lower volumes of milk is an additional
415 contributing factor in late-lactation; therefore, extra care is necessary during that period.
416 Consequently, increases in the CHLO or TCM levels in milk result in increased residue levels
417 in SMP or cream, respectively. Therefore, it is important to control the initial residue levels in
418 milk destined for processing, especially considering that those could concentrate greatly after
419 evaporation and spray-drying processes or cream separation. Appropriate sanitation practices
420 should also be carried out within the processing plant to avoid increases in the residue levels
421 throughout the processing stages. In relation to iodine, this study indicated that some Irish
422 dairy herds are over supplemented with iodine, while the use of iodine-based teat
423 disinfectants also contributed to high levels in some BT samples. Also, the iodine content of
424 the SMP produced in mid-lactation was not within the required specification, even though the
425 WMS milk had lower iodine levels than specified, indicating that the levels in BT milk
426 should be even lower. Finally, it is possible to calculate the expected residue levels in milk
427 stored in the CTs or WMS based on the volumes and residue levels of milk supplied by each
428 dairy farm, which could aid dairy processors to identify the stages that may have contributed
429 to increases in those levels. This study highlights the importance of controlling the
430 contributing factors on-farm and in the processing plant in order to maintain residues at safe
431 and market-acceptable levels.

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438 Norann Galvin for the iodine quantification.

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564 **Table 1.** Mean (\pm SD) chlorate (CHLO), trichloromethane (TCM) and iodine concentrations in samples collected from the farm bulk tanks
 565 (BTs), collection tankers (CTs), whole milk silo (WMS), skim milk silo (SMS), cream silo (CS) and samples of skim milk powder (SMP) from
 566 the mid- and late-lactation periods.

Mid-Lactation			
	CHLO (mg/ kg)	TCM (mg/ kg)	Iodine (μ g/ L)
Farm BTs (n=67) †	0.0021 \pm 0.0019 (0.0010 to 0.0070) ‡	0.0009 \pm 0.0008 (0.0002 to 0.0043)	142.2 \pm 129.2 (10.4 to 561.2)
CT (n=11) †	0.0020 \pm 0.0010 (0.0010 to 0.0030) §	0.0009 \pm 0.0003 (0.0006 to 0.0015)	134.2 \pm 89.6 (58.3 to 390.8)
WMS (n=2)	0.0010 \pm 0.0000	0.0009 \pm 0.0000	135.5 \pm 7.6
SMS (n=2)	0.0010 \pm 0.0000	0.0002 \pm 0.0000	142.1 \pm 9.1
SMP (n=9)	0.0570 \pm 0.0090 ¶		142.2 \pm 10.0 (120.2 to 153.5)
Late-Lactation			
	CHLO (mg/ kg)	TCM (mg/ kg)	Iodine (μ g/ L)
CT (n=11) †	0.0410 \pm 0.0554 (0.0020 to 0.1550) §	0.0020 \pm 0.0007 (0.0010 to 0.0033)	437.6 \pm 155.2 (225 to 709)
WMS (n=2)	0.0025 \pm 0.0000	0.0018 \pm 0.0000	419.0 \pm 2.8
SMS (n=2)	0.0025 \pm 0.0000	0.0005 \pm 0.0000	450.0 \pm 7.1
CS (n=2)		0.0190 \pm 0.0000	
SMP (n=9)	0.1263 \pm 0.0071 ¶		398.2 \pm 22.8 (257 to 425)

567 n = number of samples; ranges are given between parentheses.

568 † Weighted means and standard deviations calculated considering the volumes of milk and residues concentrations of each farm or CT sample.

569 ‡ Weighted mean CHLO of the 14 bulk tank milk samples in which chlorate was detected.

570 § Weighted mean CHLO of the CT milk samples in which chlorate was detected (mid-lactation: 6 samples; late-lactation: 6 samples).

571 ¶ Results for non-reconstituted skim milk powder

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576 **Monitoring residue concentrations in milk from farm and throughout a milk powder**
577 **manufacturing process**

578

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587 Short title: **Milk quality from farm to milk powder**

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603 **SUPPLEMENTARY FILE**

604

605 **Materials & Methods**

606 *Comparison between the residue levels in farm bulk tanks in mid- and late-lactation*

607 In late-lactation (November 2016), the average (\pm SD) milk volume that was stored in each
608 BT of the 67 farms during sampling was $1,683 \pm 1,031$ L (range: 125 to 4,519 L), which were
609 stored for an average (\pm SD) of 34 ± 15 h, at 3.3 ± 1.2 °C.

610

611 *Quantification of trichloromethane*

612 In each sample vial, 2 mL of milk or reconstituted SMP were added with 5 μ L of internal
613 standard and 5 μ L of ethanol. The internal standard consisted of a solution prepared using
614 2-bromo-1-chloropropane and ethanol (0.2 mg/ mL). Samples were placed on an autosampler
615 tray (CTC analytics Combi-pal; CTC Analytics AG Industriestrasse 20 CH-4222, Zwingen,
616 Switzerland) and were incubated for 15 min at 80 °C and agitated at 750 rpm. Samples were
617 injected (500 μ L) into an Agilent 19095J-121LTM column (10 m x 0.53 mm x 2.65 μ m;
618 Agilent Technologies, Santa Clara, California, USA) with a heated gas-tight syringe (90 °C).
619 Helium was used as the carrier gas, and the column temperature was kept at a constant
620 temperature of 200 °C, which decreased to 70 °C in the end of analysis.

621

622 *Quantification of total iodine*

623 In each vial, 1:1 (w/v) solutions of sample and 5% tetramethyl-ammonium hydroxide
624 (TMAH) extraction solution were added and gently swirled. Vials were placed in an oven at
625 90 °C for 3 h and afterwards they were allowed to cool. The standards used for the calibration
626 consisted of solutions of iodine with 0.5 mL of a Tellurium solution (1,000 μ g/ mL), which
627 contained 1% TMAH.

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Table S1. Comparison of mean trichloromethane (TCM) concentrations measured in each collection tanker (CT: 1, 2, 3, 4, 5, 6, 7, 8, 9, 10 and 11) during mid-lactation and those predicted (\pm standard error; S.E.) from the combined farm samples in each CT.

CT number	Number of farms	Total volume per tanker (L)	Mean (\pm SD) volume measured per farm (L)	Mean TCM concentration of each CT (mg/ kg)	Predicted TCM concentration (weighted means \pm S.E.) [†] (mg/ kg)	95% CI [‡]		Mean TCM concentration of each CT covered by predicted C.I.
						LCL	UCL	
1	4	23771	5,943 \pm 1,271	0.0015	0.0014 \pm 0.0009	0.0000	0.0043	Yes
2	5	26503	5,301 \pm 2,385	0.0008	0.0005 \pm 0.0002	0.0000	0.0011	Yes
3	6	29122	4,854 \pm 1,763	0.0012	0.0009 \pm 0.0003	0.0001	0.0016	Yes
4	6	23780	3,963 \pm 2,683	0.0012	0.0009 \pm 0.0003	0.0002	0.0016	Yes
5	8	27585	3,448 \pm 2,214	0.0008	0.0004 \pm 0.0001	0.0002	0.0005	Yes
6	7	28628	4,090 \pm 1,208	0.0011	0.0008 \pm 0.0004	0.0000	0.0018	Yes
7	7	27188	3,884 \pm 2,064	0.0006	0.0004 \pm 0.0001	0.0002	0.0006	Yes
8	7	28470	4,067 \pm 2,437	0.0007	0.0004 \pm 0.0002	0.0001	0.0008	Yes
9	2	27147	13,574 \pm 11,312	0.0010	0.0007 \pm 0.00004	0.0002	0.0012	Yes
10	5	25248	5,050 \pm 3,877	0.0007	0.0003 \pm 0.0001	0.0000	0.0006	Yes
11	10	28561	2,856 \pm 1,764	0.0008	0.0005 \pm 0.0001	0.0003	0.0008	Yes

[†] Weighted means were calculated considering the volume of milk supplied by each farm or by each CT.

[‡] Confidence interval (CI), lower (LCL) and upper (UCL) confidence limits.

Table S2. Comparison of mean trichloromethane (TCM) concentrations measured in the whole milk silo (WMS) during mid- and late-lactation and those predicted (\pm standard error; S.E.) from the combined collection tankers (CTs) samples.

	Mean TCM concentration of the WMS (mg/ kg)	Mean (\pm SD) volume measured per CT (L)	Predicted TCM concentration (weighted means \pm S.E.) [†] (mg/ kg)	95% CI [‡]		Mean TCM concentration of WMS covered by predicted C.I.
				LCL	UCL	
Mid-lactation	0.0009	26,909 \pm 1,902	0.0007 \pm 0.00009	0.0005	0.0009	Yes
Late-lactation	0.0018	24,357 \pm 3,768	0.0019 \pm 0.0002	0.0014	0.0024	Yes

[†] Weighted means were calculated considering the volume of milk supplied by each CT.

[‡] Confidence interval (CI), lower (LCL) and upper (UCL) confidence limits.

Table S3. Comparison of mean iodine concentrations measured in each collection tanker (CT: 1, 2, 3, 4, 5, 6, 7, 8, 9, 10 and 11) during mid-lactation and those predicted (\pm standard error; S.E.) from the combined farm samples in each CT.

CT	Number of farms	Mean (\pm SD) volume measured per farm (L)	Total volume per CT (L)	Iodine concentration measured in each CT sample ($\mu\text{g/L}$)	Predicted iodine concentrations (weighted means \pm SE) ($\mu\text{g/L}$) †	95% CI ‡		Mean iodine concentration of each CT covered by predicted CI
						LCL	UCL	
1	4	5,943 \pm 1,271	23,771	83.9	89.2 \pm 21.8	19.8	158.6	Yes
2	5	5,301 \pm 2,385	26,503	81.8	90.0 \pm 23.8	23.9	156.2	Yes
3	6	4,854 \pm 1,763	29,122	120.0	117.9 \pm 45.6	0.6	235.3	Yes
4	6	3,963 \pm 2,683	23,780	58.3	61.2 \pm 8.5	39.3	83.7	Yes
5	8	3,448 \pm 2,214	27,585	125.9	141.0 \pm 27.8	75.4	206.7	Yes
6	7	4,090 \pm 1,208	28,628	138.4	144.1 \pm 55.7	7.9	280.3	Yes
7	7	3,884 \pm 2,064	27,188	112.0	116.7 \pm 15.7	78.4	155.1	Yes
8	7	4,067 \pm 2,437	28,470	76.3	82.9 \pm 20.9	31.6	134.1	Yes
9	2	13,574 \pm 11,312	27,147	390.8	335.7 \pm 91.6	0	1,500	Yes
10	5	5,050 \pm 3,877	25,248	202.9	282.7 \pm 121.2	0	619.7	Yes
11	10	2,856 \pm 1,764	28,561	80.0	101.7 \pm 12.1	74.3	129.1	Yes

† Weighted means were calculated considering the volume of milk supplied by each farm.

‡ Confidence interval (CI), lower (LCL) and upper (UCL) confidence limits.

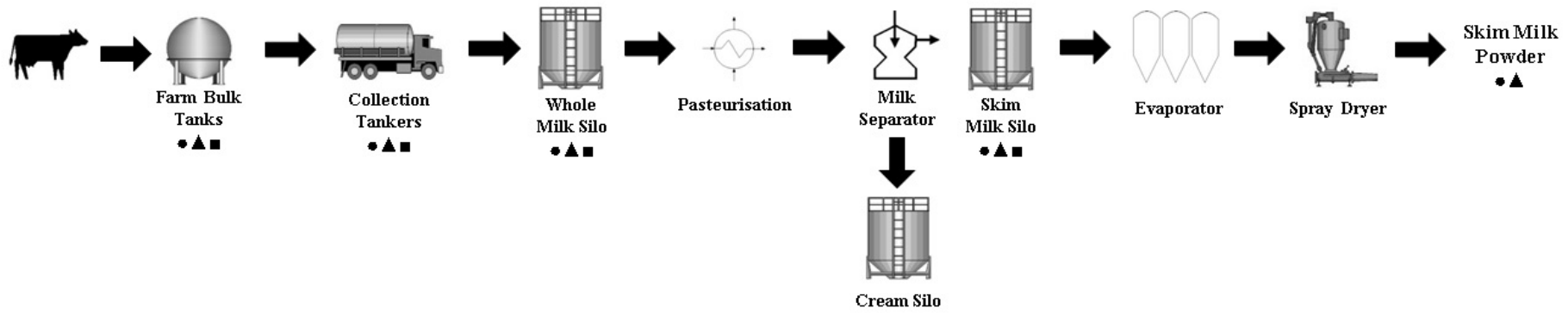
Table S4. Comparison of mean iodine concentrations measured in the whole milk silo (WMS) during the mid- and late-lactation periods and those predicted (\pm standard error; S.E.) from the combined collection tankers (CTs) samples.

	Mean (\pm SD) iodine concentration of the WMS ($\mu\text{g/L}$)	Mean (\pm SD) volume measured per CT (L)	Predicted iodine concentration (weighted means \pm SE) ($\mu\text{g/L}$) \dagger	95% CI \ddagger		Mean iodine concentration of the WMS covered by predicted CI
				LCL	UCL	
Mid-lactation	135.5 \pm 7.6	26,909 \pm 1,902	134.2 \pm 28.3	71.0	197.3	Yes
Late-lactation	419.0 \pm 2.8	24,357 \pm 3,768	421.4 \pm 50.5	308.8	534.0	Yes

\dagger Weighted means were calculated considering the volume of milk supplied by each CT.

\ddagger Confidence interval (CI), lower (LCL) and upper (UCL) confidence limits.

Mid-lactation



Late-lactation

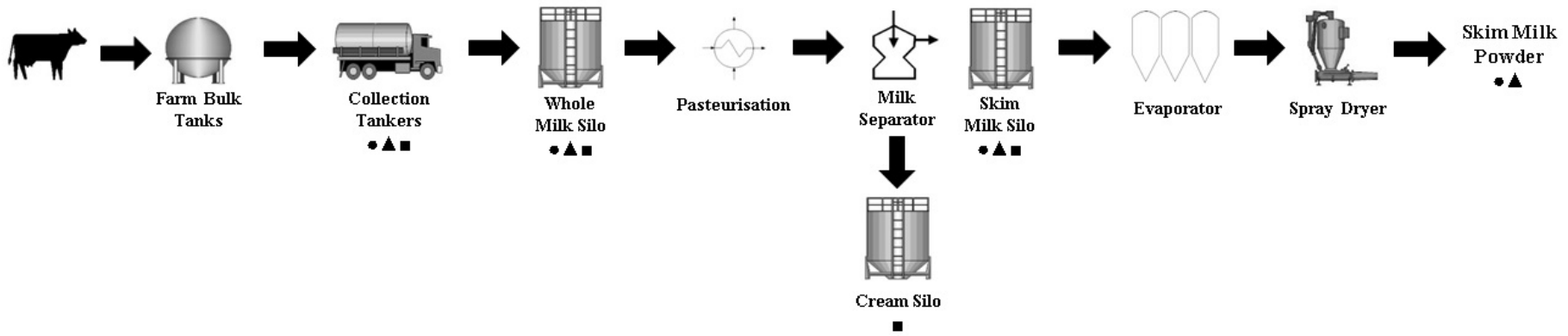


Figure S1. Milk supply chain and manufacturing process for conversion to low-heat skim milk powder, conducted in the mid- and late-lactation periods. The sampling points for chlorate (CHLO) and perchlorate (PCHLO), iodine and trichloromethane (TCM) are indicated with a •, ▲ and ■, respectively.