



## Biotechnology and Industry Microbiology

# Current applications and different approaches for microbial L-asparaginase production



Jorge Javier Muso Cachumba, Felipe Antonio Fernandes Antunes, Guilherme Fernando Dias Peres, Larissa Pereira Brumano, Júlio César Dos Santos, Silvio Silvério Da Silva\*

Universidade de São Paulo, Escola de Engenharia de Lorena, São Paulo, SP, Brazil

## ARTICLE INFO

## Article history:

Received 22 August 2016

Accepted 6 September 2016

Available online 27 October 2016

Associate Editor: Adalberto Pessoa Jr

## Keywords:

L-asparaginase

Microbial production

Industrial production

Pharmaceutical application

Acrylamide

## ABSTRACT

L-asparaginase (EC 3.5.1.1) is an enzyme that catalysis mainly the asparagine hydrolysis in L-aspartic acid and ammonium. This enzyme is presented in different organisms, such as microorganisms, vegetal, and some animals, including certain rodent's serum, but not unveiled in humans. It can be used as important chemotherapeutic agent for the treatment of a variety of lymphoproliferative disorders and lymphomas (particularly acute lymphoblastic leukemia (ALL) and Hodgkin's lymphoma), and has been a pivotal agent in chemotherapy protocols from around 30 years. Also, other important application is in food industry, by using the properties of this enzyme to reduce acrylamide levels in commercial fried foods, maintaining their characteristics (color, flavor, texture, security, etc.) Actually, L-asparaginase catalyzes the hydrolysis of L-asparagine, not allowing the reaction of reducing sugars with this aminoacid for the generation of acrylamide. Currently, production of L-asparaginase is mainly based in biotechnological production by using some bacteria. However, industrial production also needs research work aiming to obtain better production yields, as well as novel process by applying different microorganisms to increase the range of applications of the produced enzyme. Within this context, this mini-review presents L-asparaginase applications, production by different microorganisms and some limitations, current investigations, as well as some challenges to be achieved for profitable industrial production.

© 2016 Sociedade Brasileira de Microbiologia. Published by Elsevier Editora Ltda. This is an open access article under the CC BY-NC-ND license (<http://creativecommons.org/licenses/by-nc-nd/4.0/>).

## Introduction

L-asparaginase aminohydrolase (L-asparaginase, EC 3.5.1.1), has gained attention in recent years due to its important applications, as its use in pharmaceutical industry as an alternative for treatment of different cancers such

as acute lymphoblastic leukemia, malignant diseases of the lymphoid system and Hodgkin's lymphomas.<sup>1</sup> Also, this enzyme is used in food industry to prevent the acrylamide formation when foods are processed in high temperatures.<sup>2</sup> This use is important because acrylamide is a neurotoxin classified as potentially carcinogenic to humans.<sup>3</sup>

\* Corresponding author.

E-mail: [silviosilverio@usp.com](mailto:silviosilverio@usp.com) (S.S. Da Silva).

<http://dx.doi.org/10.1016/j.bjm.2016.10.004>

1517-8382/© 2016 Sociedade Brasileira de Microbiologia. Published by Elsevier Editora Ltda. This is an open access article under the CC BY-NC-ND license (<http://creativecommons.org/licenses/by-nc-nd/4.0/>).

Industrial L-asparaginase production presents some challenges, such as the search for new microorganisms able to produce it with less adverse effects. Nowadays, industrial production is carried out using bacteria such as *Escherichia coli* and *Erwinia chrysanthemi*.<sup>4</sup> However, the enzyme obtained from prokaryotic microorganisms usually presents some problems such as hypersensitivity and immune inactivation.<sup>5</sup> Within this context, eukaryotic microorganisms such as filamentous fungi<sup>6</sup> and yeasts<sup>7</sup> have been investigated for this enzymes production, due to better compatibility with the human system.

Currently, new studies have been carried out aiming to enhance production process and establish new ways for enzyme synthesis. Thus, some of these aspects are discussed, besides some generalities regarding L-asparaginase applications in pharmaceutical and food industries.

## Reactions and mechanism

The hydrolysis process occurs in two steps through an intermediate: beta-acyl-enzyme (Fig. 1). In the first process step, the nucleophilic residue of the enzyme is activated by a strong base and attacks the amide carbon atom of L-asparagine (substrate), generating a product beta-acyl-enzyme intermediate. The second reaction step is an attack on the ester carbon made by a nucleophile activated by a water molecule.<sup>8</sup>

This mechanism is comparable to serine-proteases classic mechanism, whose activities depends of an amino acid group, classified as catalytic triads. This catalytic triads is composed by one nucleophilic amino acid, serine (Ser), one base, histidine (His) and one amino acid with acid characteristic, aspartic acid (Asp), all connected by hydrogen bonds.<sup>8</sup>

L-asparaginase has also capacity to catalase other reactions. For example, L-asparaginase produced by *Serratia marcescens* is able to hydrolase 5% of L-glutamine when compared with L-asparaginase hydrolysis. The same effect occurs to L-asparaginase produced by *Escherichia coli* and *Erwinia chrysanthemi*. Other microorganisms, such as *Pseudomonas* sp. and *Acinetobacter glutaminasificans*, synthesize L-asparaginase with equal asparaginase and glutaminase activity. In some cases, L-asparaginase starts the L-glutamine hydrolysis only after complete conversion of L-asparaginase in aspartic acid. Actually, L-glutamine is a competitive inhibitor of L-asparagine hydrolysis.<sup>12</sup> L-glutamine and L-asparagine hydrolysis are similar due to the structural similarity from both amino acids. Therefore, the largest part of microbial L-asparagine presents cross glutaminase activity, with some exceptions such as L-asparaginase produced by *Wolinella succinogenes*, which do not present L-glutaminase activity.<sup>12</sup> Finally, L-asparaginase is also able to hydrolyze  $\beta$ -aspartyl peptide amide, however reaction yield is considerably low.<sup>13</sup>

## L-asparaginase applications

### Pharmaceutical industry: antineoplastic action

The L-asparagine enzymatic hydrolysis in L-aspartate and ammonium was observed in a first time by Lang (1904),<sup>14</sup> that

detected L-asparaginase activity in bovine's tissues. Results of this researcher were confirmed by Furth and Friedmann (1910),<sup>15</sup> that detected L-asparagine hydrolase in horse and pig organs, observing the same amount of L-asparaginase activity in both animals. Also, Clementi (1922)<sup>16</sup> related that L-asparaginase in guinea pig serum, although antitumor activity of the enzyme was identified only some years later. In addition, Mashburn and Wriston (1964)<sup>17</sup> demonstrated that L-asparaginase of *E. coli* had inhibitory capacity of tumors in rats. However, the large interest in enzyme started when Broome (1965)<sup>18</sup> found that the regression lymphosarcoma transplants in rats treated with guinea pig serum was due to nutritional dependence on malignant cells of exogenous L-asparagine.

Considering its properties, L-asparaginase has been an important chemotherapeutic agent used for treatment of lymphoproliferative and lymphoma diseases. Particularly, it presents large importance in chemotherapeutic protocols for acute lymphoblastic leukemia (ALL) and Hodgkin's lymphomas.<sup>19</sup>

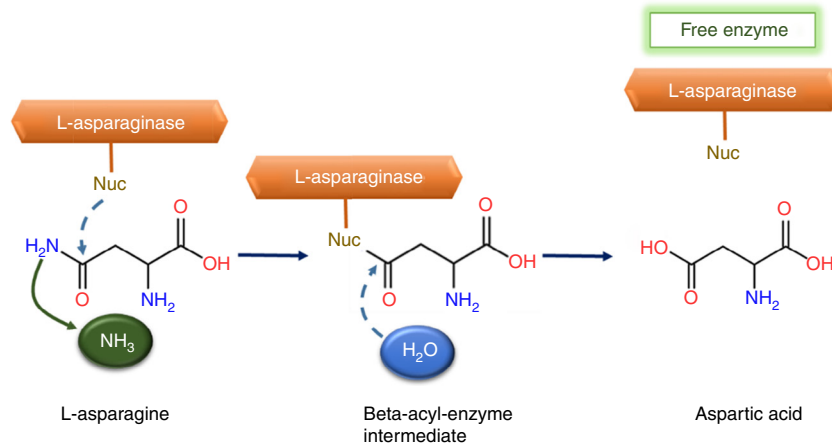
Cancer cells, mainly lymphatic cells, require high amount of asparagine for fast and malignant growth. In this way, cancer cells requires the amino acid from diet (blood serum) as well as amino acids produced by themselves. However, leukemic lymphoblasts and some others tumor cells do not have or present low quantity of L-asparagine synthetase used for L-asparagine syntheses. Thus, these malignant cells are dependent of asparagine from blood serum for their proliferation and survival.<sup>20,21</sup>

L-asparaginase hydrolyzes asparagine from blood serum, leading tumor cells to death by lacking of an essential factor for protein synthetases (p53-dependent apoptosis). However, healthy cells are not affected, because they are able to produce asparagine using L-asparagine synthetase present in enough quantities (Fig. 2). Considering these concepts, Fig. 2 schematically shows the antineoplastic action of L-asparaginase.

### Food industry: acrylamide formation

Acrylamide ( $C_3H_5NO$ ) is also known as 2-propenamide, acrylic amide, ethylene carboxamide, propenamide, propanoic acid amide, monomer of acrylamide or acrylic acid amide, presenting 71.08 g/mol of molecular mass.<sup>22</sup> Several studies show that L-asparagine is the main amino acid responsible for acrylamide production in fried and baked foods when reducing sugars are condensed with a carbonyl source. This phenomenon does not occur in boiled food.<sup>23</sup>

Acrylamide formation has been quite studied in the last years. Zyzak et al. (2003)<sup>24</sup> detected that the amide chain present in the acrylamide structure is provided from L-asparagine. Reagents (L-asparagine or reducing sugars) reduction or removal is one of the evaluated strategies for decreasing acrylamide quantity in foods. For L-asparagine reduction, several options have been investigated, such as: selection of vegetal species with lower level of L-asparagine in their composition; deletion of important enzymes for L-asparagine biosynthesis control by suppression of specific genes; acid hydrolysis of L-asparagine leading the formation of aspartic acid and ammonia; and acetylation process of L-asparagine to form N-acetyl-L-asparagine, preventing the formation of acrylamide from intermediate N-glycosides.<sup>22</sup>



**Fig. 1 – General mechanism of L-asparaginase reaction catalyzed. Dashed arrow shows nucleophilic attack.**  
 Source: Based on Hill (1967)<sup>9</sup> cited by El-Bessoumy et al. (2004),<sup>10</sup> and Shrivastava et al. (2016).<sup>11</sup>

In the study of Zyzak et al. (2003),<sup>24</sup> authors confirmed that the use of L-asparaginase enzyme before frying or baking food process could reduce more than 99% acrylamide level in the processed final product. This is because the enzyme reduces more than 88% of the L-asparagine concentration from the initial feedstock. In last years, other works have dealt with this application of L-asparaginase, that can decrease the negative effects of acrylamide containing foods without impair their characteristics.<sup>3,25-28</sup>

#### Production by different microorganisms

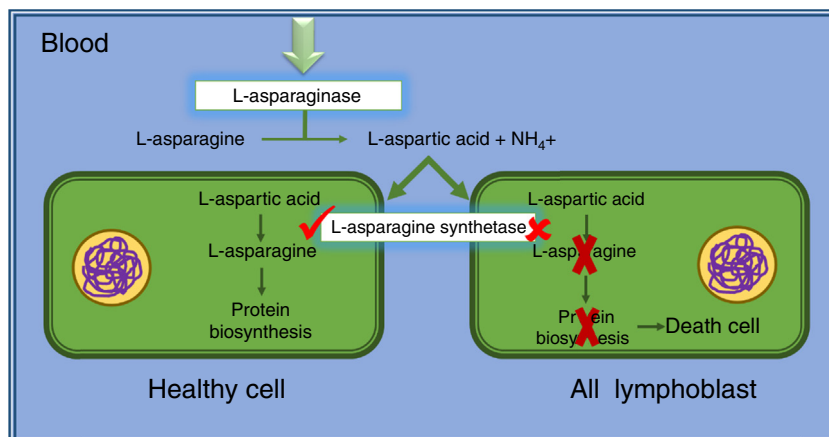
L-asparaginase is present in mammals, birds, plants, yeast, and a wide range of bacteria.<sup>10,29</sup> Although L-asparaginase production is observed in animals, plants,<sup>12,30</sup> the microorganisms are considered mainly source for L-asparagine synthesis.<sup>30,31</sup>

The production of this enzyme is mainly proceeded by submerged fermentation.<sup>30</sup> Several researchers have studied the isolation of microbial strains that produce this important enzyme, such as *Pseudomonas fluorescens*,<sup>32</sup> *Serratia marcescens*,<sup>33</sup> *Escherichia coli*,<sup>34</sup> *Erwinia carotovora*,<sup>35</sup> *Proteus*

*vulgaris*,<sup>36</sup> *Saccharomyces cerevisiae*, *Karnatakensis Streptomyces*, *Streptomyces venezuelae* and several genres of fungi as *Aspergillus*, *Penicillium* and *Fusarium*.<sup>37</sup>

Concerning to bacteria, the best producers of L-asparaginase are members of the Enterobacteriaceae family.<sup>30</sup> For example, in pharmaceutical industry, this enzyme is produced mainly from bacteria such as *Escherichia coli* and *Erwinia carotovora*, (also known as *Erwinia chrysanthemi*), generally used for leukemia and lymphoma treatment.<sup>4</sup> However, most of these treatments can result in immunological sensitization (hypersensitivity) and immune inactivation in patients that receive bacterial enzymes.<sup>5</sup> Another issue is that glutaminase activity generated by these enzymes can cause secondary effects such as allergic reaction, nausea, pancreatitis, diabetes and coagulation abnormalities.<sup>8,38</sup> Also, most of asparaginases has low stability and catalytic activity, presenting only active in a narrow pH range.<sup>39</sup>

Currently, L-asparaginases from *E. coli* and *Erwinia chrysanthemi* (synonymous of *Erwinia carotovora*) are the only preparation available for medical use.<sup>12</sup> L-asparaginase from *E. coli* produces two types of enzyme, L-asparaginase I (EC1), found in the cytoplasm and L-asparaginase II (EC2), with



**Fig. 2 – Antineoplastic action of L-asparaginase.**  
 Source: Based on Van den Berg (2011).<sup>12</sup>

periplasmic origin.<sup>40</sup> However, only the second one has anti-cancer activity.<sup>41</sup> Some studies describes EC1 as a constitutive enzyme and EC2 as secreted only as a response to exposure to low concentrations of nitrogen.<sup>8</sup> EC2 has an estimated molecular weight of 141 kDa and its  $k_M$  is about 12.5  $\mu$ M, meaning a high affinity for substrate.<sup>42</sup> Its half-life is around  $1.24 \pm 0.17$  days and its optimum pH and temperature are 7–8 and 37 °C, respectively.<sup>12,42</sup>

As an alternative for treatment of patients allergic to L-asparaginase from *E. coli*, L-asparaginase from *E. chrysanthemi* (ErA) is used. It has half-life of  $0.6 \pm 0.13$  days, a  $k_M$  of 18  $\mu$ M, molecular mass about 140 and 150 kDa, optimal pH 8 and 50 °C as optimal temperature.<sup>43,44</sup> The difference between its  $k_M$  and that one from *E. coli*'s L-asparaginase is because glutaminase activity of ErA is higher.<sup>42,45</sup>

In recent years, different studies were developed aiming to find this enzyme with improved characteristics compared to L-asparaginase from *E. coli*, with economically viable production as well as causing minimal collateral effects. Searching from different L-asparagine sources, specifically eukaryotic microorganisms, can lead to enzymes with less adverse effects and different features, which are advantageous for its application.<sup>46</sup>

In the last years, eukaryotic fungi have been investigated as L-asparaginase source.<sup>47</sup> For L-asparaginase production by fungi, the genera *Aspergillus*, *Penicillium* and *Fusarium* have been studied.<sup>6</sup> Currently, fungal recombinant L-asparaginase from *Aspergillus oryzae* and *Aspergillus niger* has already been used in food industry for reduction of acrylamide formation in some foods.<sup>28</sup> Moreover, authors have reported positive results by using endophytic fungi of the genus *Colletotrichum*, *Eupenicillium*, *Talaromyces*.<sup>48,49</sup> Also, positive asparaginolytic activity were also shown by researchers that used fungi isolated from marine environments, endophytes seaweed, of genera *Alternaria*, *Chaetomium*, *Cladosporium*, *Colletotrichum*, *Curvularia*, *Nigrospora*, *Paecilomyces*, *Phaeotrichoconis*, *Phoma* and *Pithomyces*.<sup>50</sup> Within this context, Table 1 present some works related to L-asparaginase production by bacteria and fungi.

Also, several studies have shown that *Aspergillus* genus is available to produce significant amounts of L-asparaginase. For example, Sarquis et al. (2004)<sup>37</sup> presented filamentous fungi like *Aspergillus tamarii* and *Aspergillus terreus* as producers of L-asparaginase by submerged fermentation, resulting in 38 U/L and 58.8 U/L, respectively. Authors concluded that enzyme production was regulated by the nitrogen source. Moreover, Balasubramanian et al. (2012),<sup>51</sup> in a screening study of L-asparaginase producers, reported that *Aspergillus terreus* was able to produce 9.3 U/mL of enzyme. In other study of culture conditions optimization (temperature 35 °C, initial pH 6.3, inoculum size 1% (v/v), agitation rate 140 rpm, and incubation time 58.5 h), Gurunathan and Sahadevan (2012)<sup>52</sup> reported L-asparaginase production of *Aspergillus terreus* by submerged fermentation, reaching production of 44.38 U/mL. In another optimization project, but by using *Aspergillus niger*, Anjum Zia et al. (2013)<sup>53</sup> verified a L-asparaginase activity of 2.83 U/ml under submerged fermentation. In that work, authors observed that glucose concentrations above 1% inhibited the enzyme production.

Another interesting technique for asparaginase production is the solid-state fermentation, that allows the use of

agroindustrial residues as substrate or support.<sup>30</sup> Within this context, recently, Dias et al. (2015)<sup>76</sup> presented the use of different organic residues (wheat bran, soybean meal, cottonseed meal and orange peel), evaluating the production of L-asparaginase from *Aspergillus niger*. The maximum enzyme production (94.21 U/g) was obtained after 96 h of fermentation using mixture of wheat bran (1/3), soybean meal (1/3) and cottonseed meal (1/3).

In addition, yeasts have been becoming an interesting alternative for L-asparaginase production. Some investigations have reported, e.g., the use of the yeasts *Pichia polymorpha* and *Candida utilis*, for this enzyme production. L-asparaginase of *P. polymorpha* showed a  $k_M$  value of 13.7 mM and optimum pH 6.7.<sup>77</sup> On the other hand, the enzyme produced by *C. utilis* has  $k_M$  value of 77  $\mu$ M.<sup>78</sup> In a recent study, Soler et al. (2015)<sup>7</sup> tested 43 different strains of yeasts, verifying that only strains of *Issatchenkia orientalis* and *Rhodotorula glutinis* showed periplasmic L-asparaginase activity when growth in liquid CD-m. Also, Sajitha et al. (2015)<sup>79</sup> presented an investigation by using an expression study of gene *ansB* of *E. coli*, which encodes L-asparaginase enzyme, in yeast. This study was developed on a new protein expression system based on the yeast *Pichia pastoris*. The resulting enzyme was extracellular and showed activity of 2.5 U/mL at optimum temperature of 37 °C. By these results, authors concluded that this new system of expression could be effective for production of humanized enzyme by glycosylation patterns similar to mammals.<sup>79</sup>

## Industrial production of L-asparaginase

For industrial production of L-asparaginase, many factors need to be taken into account aiming to a process with higher yield and economic viability. For example, type and concentration of carbon and nitrogen sources, pH, aeration, temperature, fermentation time, and, mainly, the microbial agent, have great influence in the process.<sup>52,80</sup> As previously reported, several microorganisms are presented as L-asparaginase producers; however, bacteria *E. coli* and *E. chrysanthemi* are the current main microbial agents for industrial-scale production in pharmaceutical area, while the fungus *Aspergillus oryzae* is the most used in food industry.<sup>30,81</sup> Fig. 3 shows a schematic representation for an industrial process for L-asparaginase production.

Different types of culture medium have been explored for L-asparaginase production. However, carbon source and inductor (nitrogen source) are the more influencing components in the medium. For example, several studies have demonstrated that best inductors for reaching high yields are L-asparagina;<sup>82,83</sup> L-glutamine<sup>83</sup> and L-proline,<sup>37,84–86</sup> and the most common carbon source is glucose, in addition to alternative sources such as starch<sup>87</sup> and maltose.<sup>82,88</sup>

L-asparaginase extraction and purification are other pivotal steps for the production of this enzyme. For example, for pharmaceutical application, high level of purification is needed. Other important concern is that most of microorganisms produce intracellular L-asparaginases, with few exceptions.

Different methods for downstream process are reported such as centrifugation, filtration, liquid-liquid extraction, chromatography and protein precipitation. Regarding

**Table 1 – Recent studies about L-asparaginase production by bacteria and eukaryotic fungus.**

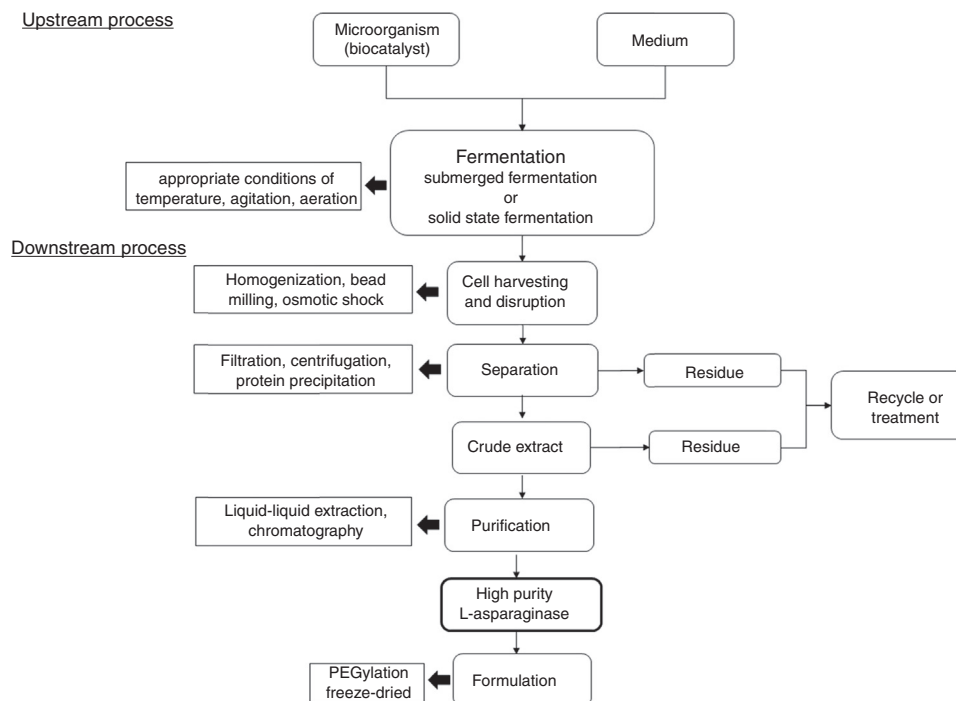
Microorganism	Fermentation type	L-asparaginase activity	k <sub>M</sub> (mM)	pH	T (°C)	Reference
<b>Bacteria</b>						
<i>Yersinia Pseudotuberculosis</i> Q66CJ	SmF	62.7 U mg <sup>-1</sup>	0.017	8.0	60	54
<i>Bacillus aryabhatai</i> ITBHU02	SmF	680.5 U mg <sup>-1</sup>	0.257	8.5	40	55
<i>Pseudomonas fluorescens</i>	SmF	168.4 U mL <sup>-1</sup>	110	8	37	56,57
<i>Bacillus licheniformis</i> RAM-8	SmF	697.1 U mg <sup>-1</sup>	0.014	6–10	40	58
<i>Nocardiosis alba</i> NIOT-VKMA08	SmF	158.1 U mL <sup>-1</sup>	0.127	8	37	59,60
<i>Streptomyces noursei</i> MTCC 10469	SmF	0.803 U mg <sup>-1</sup>	25 μM	7.5	50	61
<i>Pectobacterium carotovorum</i> MTCC 1428	SmF	35.24 U mg <sup>-1</sup>	657 μM	8–10	40	44
<i>Streptomyces parvulus</i> KUA106	SmF	146 U mL <sup>-1</sup>	25 μM	7.5	50	62
<i>Bacillus subtilis</i> hswx88	SmF	23.8 U mL <sup>-1</sup>	430 μM	7.5	40	63
<i>Streptomyces ginsengisoli</i>	SmF	3.32 U mL <sup>-1</sup>	25 μM	7.5	30	31
<i>Streptomyces thermoluteus</i> NBRC 14270	SmF	68.09 U mg <sup>-1</sup>	1830	8–9	63.6	64
<i>Photobacterium</i> sp. J15	–	20 U mg <sup>-1</sup>	760	7.0	25	65
<i>Pyrococcus furiosus</i>	SmF	550 U mg <sup>-1</sup>	12,000	9.0	85	66
<i>Bacillus licheniformis</i> MTCC 429	SmF	597.8 U mg <sup>-1</sup>	0.420	8	37	67
<b>Fungi</b>						
<i>Talaromyces pinophilus</i>	SmF	145 U mg <sup>-1</sup>	6.4	8	28	68
<i>Trichoderma viride</i>	SmF	78.2 U mg <sup>-1</sup>	0.003	6.5	37	69
<i>Aspergillus aculeatus</i>	SmF	207 U mg <sup>-1</sup>	12.5	9.0	30	70
<i>Cladosporium</i> sp.	SSF	83.3 U mg <sup>-1</sup>	100	6.3	30	71
<i>Rhizomucor miehei</i>	SmF	1985 U mg <sup>-1</sup>	–	7.0	45	26
<i>Penicillium digitatum</i>	SmF	833.15 U mg <sup>-1</sup>	10	7.0	30	72
<i>Penicillium</i> sp.	SmF	13.97 U mg <sup>-1</sup>	4000	7.0	37	73
<i>Penicillium brevicompactum</i> NRC 829	SmF	574.24 U mg <sup>-1</sup>	1050	8.0	37	74
<i>Mucor hiemalis</i>	SmF	69.43 U mg <sup>-1</sup>	4.3	7	37	75
U, international units for enzyme activity; SmF, submerged fermentation; SSF, solid-state fermentation.						

industrial production, protein precipitation is an advantageous technique due to features such as ease scale up, with simple equipment requirements, low costs and possibility to use large number of precipitants. Additionally, the precipitant agent can be recycled in the final process, reducing the environmental impact associated to its disposal. Actually, precipitation is one of the first steps in the downstream process and it is usually combined with traditional techniques to enhance biomolecules purification and process yield.<sup>30</sup> Also, other highlighted step used for high degree of enzyme purity is chromatography, such as ionic exchange, affinity chromatography, size exclusion, and gel filtration.<sup>71,89</sup> For example, Lopes et al. (2015)<sup>30</sup> reported that the most used purification steps are gel filtration and ion exchange

chromatography, which often are preceded by precipitation with (NH<sub>4</sub>)<sub>2</sub>SO<sub>4</sub>. According to authors, considering 50–80% of the total production costs of proteins are provided by extraction and purification steps, optimized downstream can result in significant economic viability.

For pharmaceutical applications, a step of conjugation with polyethylene glycol (PEG), or PEGylation, has been used to improve the compound biostability and bioavailability, influencing in pharmacokinetics and pharmacodynamics properties of the enzyme and reducing the immunological response against this biomolecule.<sup>90</sup> However, this step of PEGylation can also result in loss of biological activity of the conjugate compared with the native enzyme.<sup>91</sup> On the other hand, this step is not required in food industry application.





**Fig. 3 – Schematic representation for an industrial process for L-asparaginase production.**

Freeze-drying is other important step to improve the long and short-term storage of the enzyme L-asparaginase formulation. It can prevent most water-related reactions by sublimating water from the frozen product under vacuum, also allowing sterile drying without heating or chemical sterilization. However, problems related to cold denaturation, freeze denaturation and osmotic pressure increase due to dehydration and cryoconcentration.<sup>92</sup>

## Conclusion and future recommendations

L-asparaginase is an interesting enzyme with important applications in pharmaceutical and food industry. However, its use in these industrial sectors requires some specific properties, as security for use by humans. As chemotherapeutic agent, an efficient action is required, in addition to reduced adverse effects, such as hypersensitivity and immune inactivation. In food, this enzyme helps to decrease the concentrations of acrylamide (carcinogenic compound for humans) formed in the process, maintaining their nutritional and sensory properties. Thus, research work seeking for new L-asparaginases, mainly produced by eukaryotic microorganisms, instead of bacterial enzymes currently used, has potential to obtain new enzymes with desirable properties. These discoveries have to be followed by an intensive work aiming to increase the process productivity to enable and extend the use of this enzyme, mainly in food industries. Taking this into account, tools of molecular biology are useful, although even a more traditional work of biochemical engineering have not been extensively related in literature, indicating needs of further works such as different process configuration evaluation, as well as use of bioreactors options.

## Acknowledgments

The authors would like to thank FAPESP (Process 2014/27055-2), CNPq, CAPES and Programa Estudantes-Convênio de Pós-Graduação – PEC-PG, da CAPES/CNPq – Brazil for financial support, and the Coleção de Culturas Tropical Fundação André Tosello.

## REFERENCES

1. Appel IM, van Kessel-Bakvis C, Stigter R, Pieters R. Influence of two different regimens of concomitant treatment with asparaginase and dexamethasone on hemostasis in childhood acute lymphoblastic leukemia. *Leukemia*. 2007;21(11):2377–2380, <http://dx.doi.org/10.1038/sj.leu.2404793>.
2. Mohan Kumar NS, Shimray CA, Indrani D, Manonmani HK. Reduction of acrylamide formation in sweet bread with L-asparaginase treatment. *Food Bioprocess Technol*. 2013;7(3):741–748, <http://dx.doi.org/10.1007/s11947-013-1108-6>.
3. Medeiros Vinci R, Mestdagh F, De Meulenaer B. Acrylamide formation in fried potato products – present and future, a critical review on mitigation strategies. *Food Chem*. 2012;133(4):1138–1154, <http://dx.doi.org/10.1016/j.foodchem.2011.08.001>.
4. Keating MJ, Holmes R, Lerner S, Ho DH. L-asparaginase and PEG asparaginase – past, present, and future. *Leuk Lymphoma*. 1993;10(suppl):153–157, <http://dx.doi.org/10.3109/10428199309149129>.
5. Narta UK, Kanwar SS, Azmi W. Pharmacological and clinical evaluation of L-asparaginase in the treatment of leukemia. *Crit Rev Oncol Hematol*. 2007;61(3):208–221, <http://dx.doi.org/10.1016/j.critrevonc.2006.07.009>.

6. Dange V, Peshwe S. Purification and biochemical characterization of L-asparaginase from *Aspergillus niger* and evaluation of its antineoplastic activity. *Int J Sci Res*. 2015;4(2):564–569.
7. Soler MF, Pedreira VA, Longo FF, et al. BB 25. Seleção de leveduras produtoras de L-asparaginase em meios sólido e líquido: uma comparação de diferentes metodologias de screening. *J Basic Appl Pharm Sci*. 2015;36(1).
8. Verma N, Kumar K, Kaur G, Anand S. L-asparaginase: a promising chemotherapeutic agent. *Crit Rev Biotechnol*. 2007;27(1):45–62, <http://dx.doi.org/10.1080/07388550601173926>.
9. Hill JM. L-asparaginase therapy for leukemia and other malignant neoplasms. *J Am Med Assoc*. 1967;202(9):882, <http://dx.doi.org/10.1001/jama.1967.03130220070012>.
10. El-Bessoumy AA, Sarhan M, Mansour J. Production, isolation, and purification of L-asparaginase from *Pseudomonas aeruginosa* 50071 using solid-state fermentation. *J Biochem Mol Biol*. 2004;37(4):387–393, <http://dx.doi.org/10.5483/BMBRep.2004.37.4.387>.
11. Shrivastava A, Khan AA, Khurshid M, Kalam MA, Jain SK, Singhal PK. Recent developments in L-asparaginase discovery and its potential as anticancer agent. *Crit Rev Oncol Hematol*. 2016;100:1–10, <http://dx.doi.org/10.1016/j.critrevonc.2015.01.002>.
12. Van den Berg H. Asparaginase revisited. *Leuk Lymphoma*. 2011;52(2):168–178, <http://dx.doi.org/10.3109/10428199309149127>.
13. Noronkoski T, Stoineva IB, Ivanov IP, Petkov DD, Mononen I. Glycosylasparaginase-catalyzed synthesis and hydrolysis of -aspartyl peptides. *J Biol Chem*. 1998;273(41):26295–26297, <http://dx.doi.org/10.1074/jbc.273.41.26295>.
14. Lang S. Über desamidierung im Tierkörper. *Beitr Chem Physiol Pathol*. 1904;5:321–345.
15. Furth O, Friedmann M. Über die Verbreitung asparaginspaltender Organfermente. *Biochemistry*. 1910;26:435–440.
16. Clementi A. La desamidation enzymatique de l'asparagine chez les diferentes especes animals et la signification physiologique de sa presence dans l'organisme. *Arch Intern Physiol*. 1922;19:369–398.
17. Mashburn LT, Wriston JC. Tumor inhibitory effect of L-asparaginase from *Escherichia coli*. *Arch Biochem Biophys*. 1964;105:450–452.
18. Broome JD. Antilymphoma activity of L-asparaginase in vivo: clearance rates of enzyme preparations from guinea pig serum and yeast in relation to their effect on tumor growth. *J Natl Cancer Inst*. 1965;35(6):967–974.
19. Schrappe M, Reiter A, Ludwig WD, et al. Improved outcome in childhood acute lymphoblastic leukemia despite reduced use of anthracyclines and cranial radiotherapy: results of trial ALL-BFM 90. German-Austrian-Swiss ALL-BFM Study Group. *Blood*. 2000;95(11):3310–3322. <http://www.ncbi.nlm.nih.gov/pubmed/10828010> Accessed 09.02.16.
20. Kiriya Y, Kubota M, Takimoto T, et al. Biochemical characterization of U937 cells resistant to L-asparaginase: the role of asparagine synthetase. *Leukemia*. 1989;3(4):294–297. <http://www.ncbi.nlm.nih.gov/pubmed/2564453> Accessed 17.02.16.
21. Stams WAG, den Boer ML, Beverloo HB, et al. Sensitivity to L-asparaginase is not associated with expression levels of asparagine synthetase in t(12;21)+ pediatric ALL. *Blood*. 2003;101(7):2743–2747, <http://dx.doi.org/10.1182/blood-2002-08-2446>.
22. Friedman M. Chemistry, biochemistry, and safety of acrylamide. A review. *J Agric Food Chem*. 2003;51(16):4504–4526, <http://dx.doi.org/10.1021/jf030204+>.
23. Tareke E, Rydberg P, Karlsson P, Eriksson S, Törnqvist M. Acrylamide: a cooking carcinogen? *Chem Res Toxicol*. 2000;13(6):517–522. <http://www.ncbi.nlm.nih.gov/pubmed/10858325> Accessed 18.02.16.
24. Zyzak DV, Sanders RA, Stojanovic M, et al. Acrylamide formation mechanism in heated foods. *J Agric Food Chem*. 2003;51(16):4782–4787, <http://dx.doi.org/10.1021/jf034180i>.
25. Zhang S, Xie Y, Zhang C, et al. Biochemical characterization of a novel L-asparaginase from *Bacillus megaterium* H-1 and its application in French fries. *Food Res Int*. 2015;77:527–533, <http://dx.doi.org/10.1016/j.foodres.2015.08.031>.
26. Huang L, Liu Y, Sun Y, Yan Q, Jiang Z. Biochemical characterization of a novel L-asparaginase with low glutaminase activity from *Rhizomucor miehei* and its application in food safety and leukemia treatment. *Appl Environ Microbiol*. 2014;80(5):1561–1569, <http://dx.doi.org/10.1128/AEM.03523-13>.
27. Anese M, Quarta B, Peloux L, Calligaris S. Effect of formulation on the capacity of L-asparaginase to minimize acrylamide formation in short dough biscuits. *Food Res Int*. 2011;44(9):2837–2842, <http://dx.doi.org/10.1016/j.foodres.2011.06.025>.
28. Pedreschi F, Mariotti S, Granby K, Risum J. Acrylamide reduction in potato chips by using commercial asparaginase in combination with conventional blanching. *LWT – Food Sci Technol*. 2011;44(6):1473–1476, <http://dx.doi.org/10.1016/j.lwt.2011.02.004>.
29. Wriston JC, Yellin TO. L-asparaginase: a review. *Adv Enzymol Relat Areas Mol Biol*. 1973;39:185–248. <http://www.ncbi.nlm.nih.gov/pubmed/4583638> Accessed 23.06.16.
30. Lopes AM, Oliveira-Nascimento L, de Ribeiro A, et al. Therapeutic L-asparaginase: upstream, downstream and beyond. *Crit Rev Biotechnol*. 2015;8551(December):1–18, <http://dx.doi.org/10.3109/07388551.2015.1120705>.
31. Deshpande N, Choubey P, Agashe M. Studies on optimization of growth parameters for L-asparaginase production by *Streptomyces ginsengisoli*. *Sci World J*. 2014;2014:1–6, <http://dx.doi.org/10.1155/2014/895167>.
32. Degroot N, Lichtenstein N. The action of *Pseudomonas fluorescens* extracts on asparagine and asparagine derivatives. *Biochim Biophys Acta*. 1960;40:99–110.
33. Rowley B, Wriston JC. Partial purification and antilymphoma activity of *Serratia marcescens* L-asparaginase. *Biochem Biophys Res Commun*. 1967;28(2):160–165.
34. Kozak M, Jurga S. A comparison between the crystal and solution structures of *Escherichia coli* asparaginase II. *Acta Biochim Pol*. 2002;49(2):509–513. <http://www.ncbi.nlm.nih.gov/pubmed/12362993> Accessed 17.02.16.
35. Wade HE, Elsworth R, Herbert D, Keppie J, Sargeant K. A new L-asparaginase with antitumor activity? *Lancet*. 1968;2(7571):776–777.
36. Tosa T, Sano R, Yamamoto K, Nakamura M, Ando K, Chibahata I. L-asparaginase from *Proteus vulgaris*. *Appl Microbiol*. 1972;22:387–392.
37. Sarquis MI, de M, Oliveira EMM, Santos AS, da Costa GL. Production of L-asparaginase by filamentous fungi. *Mem Inst Oswaldo Cruz*. 2004;99(5):489–492, <http://dx.doi.org/10.1590/S0074-02762004000500005>.
38. Duval M. Comparison of *Escherichia coli*-asparaginase with *Erwinia asparaginase* in the treatment of childhood lymphoid malignancies: results of a randomized European Organisation for Research and Treatment of Cancer – Children's Leukemia Group phase 3 trial. *Blood*. 2002;99(8):2734–2739, <http://dx.doi.org/10.1182/blood.V99.8.2734>.

39. Zuo S, Zhang T, Jiang B, Mu W. Recent research progress on microbial L-asparaginases. *Appl Microbiol Biotechnol*. 2014;99(3):1069–1079, <http://dx.doi.org/10.1007/s00253-014-6271-9>.
40. Casale T Del, Sollitti P, Chesney RH. Cytoplasmic L-asparaginase: isolation of a defective strain and mapping of ansA. *J Bacteriol*. 1983;154(1):513–515.
41. Whitecar JP, Bodey GP, Harris JE, Freireich EJ. L-asparaginase. *N Engl J Med*. 1970;282(13):732–734, <http://dx.doi.org/10.1056/NEJM197003262821307>.
42. Kumar D, Sobha K. L-asparaginase from Microbes: a comprehensive review. *Adv Biore*. 2012;3(December):137–157. <http://soeagra.com/abr/abrdec.2012/22.pdf>.
43. Müller HJ, Boos J. Use of L-asparaginase in childhood ALL. *Crit Rev Oncol Hematol*. 1998;28(2):97–113. <http://www.ncbi.nlm.nih.gov/pubmed/9768345> Accessed 18.02.16.
44. Kumar S, Dasu VV, Pakshirajan K. Localization and production of novel L-asparaginase from *Pectobacterium carotovorum* MTCC 1428. *Process Biochem*. 2010;45(2):223–229, <http://dx.doi.org/10.1016/j.procbio.2009.09.011>.
45. Aghaiypour K, Wlodawer A, Lubkowski J. Structural basis for the activity and substrate specificity of *Erwinia chrysanthemi* L-asparaginase. *Biochemistry*. 2001;40(19):5655–5664. <http://www.ncbi.nlm.nih.gov/pubmed/11341830> Accessed 17.02.16.
46. Sreenivasulu V, Jayaveera K, Rao PM. Solid-state fermentation for the production of L-asparaginase by *Aspergillus* Sp. *Res J Pharmacogn Phytochem*. 2009;1(1):21–25. <http://www.indianjournals.com/ijor.aspx?target=ijor:rjpp&volume=1&issue=1&article=006> Accessed 15.02.16.
47. Mishra A. Production of L-asparaginase, an anticancer agent, from *Aspergillus niger* using agricultural waste in solid state fermentation. *Appl Biochem Biotechnol*. 2006;135(1):33–42, <http://dx.doi.org/10.1385/ABAB:135:1:33>.
48. Theantana T, Hyde KD, Lumyong S. Asparaginase production by endophytic fungi from Thai medicinal plants: cytotoxicity properties sources of endophytic fungi isolation of endophytic fungi identification of endophytic fungi Identification was based on colony and hyphal. *Int J Integr Biol*. 2009;7(1):1–8.
49. Theantana T, Hyde KD, Lumyong S, Mai C. Asparaginase production by endophytic fungi isolated from some Thai medicinal plants. *KMITL Sci Tech J*. 2007;7:13–18.
50. Thirunavukkarasu N, Suryanarayanan TS, Murali TS, Ravishankar JP, Gummati SN. L-asparaginase from marine derived fungal endophytes of seaweeds. *Mycosphere*. 2011;2(2):147–155, <http://dx.doi.org/10.1111/j.1365-313X.2009.03887.x.zation>.
51. Balasubramanian K, Ambikapathy V, Panneerselvam A. Production, isolation and purification of L-asparaginase from *Aspergillus terreus* using submerged fermentation. *Int J Adv Pharm Res*. 2012;3(2):778–783.
52. Gurunathan B, Sahadevan R. Optimization of culture conditions and bench-scale production of L-asparaginase by submerged fermentation of *Aspergillus terreus* MTCC 1782. *J Microbiol Biotechnol*. 2012;22(7):923–929, <http://dx.doi.org/10.4014/jmb.1112.12002>.
53. Anjum Zia MAZ, Bashir R, Ahmed I, Iftikhar T. Production of L-asparaginase from *Aspergillus Niger* using agro wastes by-products in submerged fermentation process. *J Teknol*. 2013;62(2), <http://dx.doi.org/10.11113/jt.v62.1879>.
54. Pokrovskaya MV, Aleksandrova SS, Pokrovsky VS, et al. Cloning, expression and characterization of the recombinant *Yersinia pseudotuberculosis* L-asparaginase. *Protein Expr Purif*. 2012;82(1):150–154, <http://dx.doi.org/10.1016/j.pep.2011.12.005>.
55. Singh Y, Gundampati RK, Jagannadham MV, Srivastava SK. Extracellular L-asparaginase from a protease-deficient bacillus aryabhattai ITBH02: purification, biochemical characterization, and evaluation of antineoplastic activity in vitro. *Appl Biochem Biotechnol*. 2013;171(7):1759–1774, <http://dx.doi.org/10.1007/s12010-013-0455-0>.
56. Prema P, Devi MN, Alagumanikumar N. Production of tumor inhibitory L-asparaginase by wild and mutant strains of *Pseudomonas fluorescens*. *Int J Adv Res J*. 2013;1(4):163–171.
57. Kishore V, Nishita KP, Manonmani HK. Cloning, expression and characterization of L-asparaginase from *Pseudomonas fluorescens* for large scale production in *E. coli* BL21. *3 Biotech*. 2015;5(6):975–981, <http://dx.doi.org/10.1007/s13205-015-0300-y>.
58. Mahajan RV, Kumar V, Rajendran V, Saran S, Ghosh PC, Saxena RK. Purification and characterization of a novel and robust L-asparaginase having low-glutaminase activity from *Bacillus licheniformis*: in vitro evaluation of anti-cancerous properties, trackman PC. *PLoS ONE*. 2014;9(6):e99037, <http://dx.doi.org/10.1371/journal.pone.0099037>.
59. Meena B, Anburajan L, Dheenan PS, et al. Novel glutaminase free L-asparaginase from *Nocardiopsis alba* NIOT-VKMA08: production, optimization, functional and molecular characterization. *Bioprocess Biosyst Eng*. 2015;38(2):373–388, <http://dx.doi.org/10.1007/s00449-014-1277-3>.
60. Meena B, Anburajan L, Vinithkumar NV, et al. Molecular expression of L-asparaginase gene from *Nocardiopsis alba* NIOT-VKMA08 in *Escherichia coli*: a prospective recombinant enzyme for leukaemia chemotherapy. *Gene*. 2016, <http://dx.doi.org/10.1016/j.gene.2016.05.003>.
61. Dharmaraj S. Study of L-asparaginase production by *Streptomyces noursei* MTCC 10469, isolated from marine sponge *Callyspongia diffusa*. *Iran J Biotechnol*. 2011;9(2):102–108.
62. Usha R, Mala KK, Venil CK, Palaniswamy M. Screening of actinomycetes from mangrove ecosystem for L-asparaginase activity and optimization by response surface methodology. *Polish J Microbiol/Pol Tow Mikrobiol=Polish Soc Microbiol*. 2011;60(3):213–221. <http://www.ncbi.nlm.nih.gov/pubmed/22184928> Accessed 18.08.16.
63. Jia M, Xu M, He B, Rao Z. Cloning, expression, and characterization of L-asparaginase from a newly isolated *Bacillus subtilis* B11-06. *J Agric Food Chem*. 2013;61(39):9428–9434, <http://dx.doi.org/10.1021/jf402636w>.
64. Hatanaka T, Usuki H, Arima J, et al. Extracellular production and characterization of two *Streptomyces* L-asparaginases. *Appl Biochem Biotechnol*. 2011;163(7):836–844, <http://dx.doi.org/10.1007/s12010-010-9087-9>.
65. Yaacob MA, Hasan WANW, Ali MSM, et al. Characterisation and molecular dynamic simulations of J15 asparaginase from *Photobacterium* sp. strain J15. *Acta Biochim Pol*. 2014;61(4):745–752. <http://www.ncbi.nlm.nih.gov/pubmed/25337608> Accessed 18.08.16.
66. Bansal S, Gnaneswari D, Mishra P, Kundu B. Structural stability and functional analysis of L-asparaginase from *Pyrococcus furiosus*. *Biochemistry*. 2010;75(3):375–381, <http://dx.doi.org/10.1134/S0006297910030144>.
67. Sudhir AP, Agarwaal VV, Dave BR, Patel DH, Subramanian RB. Enhanced catalysis of L-asparaginase from *Bacillus licheniformis* by a rational redesign. *Enzyme Microb Technol*. 2016;86:1–6, <http://dx.doi.org/10.1016/j.enzmictec.2015.11.010>.
68. Krishnapura PR, Belur PD. Partial purification and characterization of L-asparaginase from an endophytic *Talaromyces pinophilus* isolated from the rhizomes of



- Curcuma amada. *J Mol Catal B Enzym*. 2016;124:83–91, <http://dx.doi.org/10.1016/j.molcatb.2015.12.007>.
69. Lincoln L, Niyonzima FN, More SS. Purification and properties of a fungal L-asparaginase from trichoderma viride pers: sf grey. *J Microbiol Biotechnol food Sci*. 2015, <http://dx.doi.org/10.15414/JMBFS.2014.4.4.310-316>.
  70. Dange VU, Peshwe SA. Production, purification and characterization of fungal L-asparaginase. *Bionano Front*. 2011;4:162–167.
  71. Mohan Kumar NS, Manonmani HK. Purification, characterization and kinetic properties of extracellular L-asparaginase produced by *Cladosporium* sp. *World J Microbiol Biotechnol*. 2013;29(4):577–587, <http://dx.doi.org/10.1007/s11274-012-1213-0>.
  72. Shrivastava A, Khan AA, Shrivastav A, Jain SK, Singhal PK. Kinetic studies of L-asparaginase from *Penicillium digitatum*. *Prep Biochem Biotechnol*. 2012;42(6):574–581, <http://dx.doi.org/10.1080/10826068.2012.672943>.
  73. Patro KR, Gupta N. Extraction, purification and characterization of L-asparaginase from *Penicillium* sp. by submerged fermentation. *Int J Biotechnol Mol Biol Res*. 2012;3(3):30–34, <http://dx.doi.org/10.5897/IJBMBr11.066>.
  74. Elshafei AM, Hassan MM, Abouzeid MA-E, Mahmoud DA, Elghonemy DH. Purification, characterization and antitumor activity of L-asparaginase from *Penicillium brevicompactum* NRC 829. *Br Microbiol Res J*. 2012;2(3):158–174.
  75. Thakur M, Lincoln L, Niyonzima FN, More SS. Isolation, purification and characterization of fungal extracellular L-asparaginase from *Mucor hiemalis*. *J Biocatal Biotransform*. 2013;2(2), <http://dx.doi.org/10.4172/2324-9099.1000108>.
  76. Dias FFG, de Castro RJS, Ohara A, Nishide TG, Bagagli MP, Sato HH. Simplex centroid mixture design to improve L-asparaginase production in solid-state fermentation using agroindustrial wastes. *Biocatal Agric Biotechnol*. 2015, September, <http://dx.doi.org/10.1016/j.bcab.2015.09.011>.
  77. Foda MS, Zedan HH, Hashem Sa. Characterization of a novel L-asparaginase produced by *Rhodotorula rubra*. *Rev Latinoam Microbiol*. 1980;22(2):87–95.
  78. Sakamoto T, Araki C, Beppu T, Arima K. Extracellular asparaginase from *Candida utilis*, its properties as glycoprotein and antitumor activities extracellular asparaginase from *Candida utilis*, its properties as glycoprotein and antitumor activities. *Agric Biol Chem Agric Biol Chem*. 1977;418(418):1365–1371, <http://dx.doi.org/10.1080/00021369.1977.10862699>.
  79. Sajitha S, Vidya J, Varsha K, Binod P. Cloning and expression of L-asparaginase from *E. coli* in eukaryotic expression system. *Biochem Eng J*. 2015;102:14–17, <http://dx.doi.org/10.1016/j.bej.2015.02.027>.
  80. Batool T, Makky EA, Jalal M, Yusoff MM. A comprehensive review on L-asparaginase and its applications. *Appl Biochem Biotechnol*. 2016;178(5):900–923, <http://dx.doi.org/10.1007/s12010-015-1917-3>.
  81. Hendriksen HV, Kornbrust BA, Østergaard PR, Stringer MA. Evaluating the potential for enzymatic acrylamide mitigation in a range of food products using an asparaginase from *Aspergillus oryzae*. *J Agric Food Chem*. 2009;57(10):4168–4176, <http://dx.doi.org/10.1021/jf900174q>.
  82. Farag AM, Hassan SW, Beltagy EA, El-Shenawy MA. Optimization of production of anti-tumor L-asparaginase by free and immobilized marine *Aspergillus terreus*. *Egypt J Aquat Res*. 2015;41(4):295–302, <http://dx.doi.org/10.1016/j.ejar.2015.10.002>.
  83. Kiranmayi MU, Poda S, Vijayalakshmi M. Production and optimization of L-asparaginase by an actinobacterium isolated from Nizampatnam mangrove ecosystem. *J Environ Biol*. 2014;35:799–805.
  84. Baskar G, Renganathan S. Production of L-asparaginase from natural substrates by *Aspergillus terreus* MTCC 1782: effect of substrate, supplementary nitrogen source and L-asparagine. *Int J Chem React Eng*. 2009;7.
  85. Baskar G, Renganathan S. Evaluation and screening of nitrogen source for L-asparaginase production by *Aspergillus terreus* MTCC 1782 using latin square design. *J Math Stat*. 2009;1(2):55–58.
  86. Tippani R, Sivadevuni G. Nutritional factors effecting the production of L-asparaginase by the *Fusarium* sp. *Afr J Biotechnol*. 2012;11(15):3692–3696, <http://dx.doi.org/10.5897/AJB10.2355>.
  87. Akilandeswari K, Kavitha K, Vijayalakshmi M. Production of bioactive enzyme L-asparaginase from fungal isolates of water sample through submerged fermentation. *Int J Pharm Pharm Sci*. 2012;4(suppl 4):363–366.
  88. Varalakshmi V, Raju K. Optimization of L-asparaginase production by *Aspergillus terreus* mtcc 1782 using bajra seed flour under solid state fermentation. *Int J Res Eng Technol*. 2013;02(09):121–129. <http://ijret.org/Volumes/V02/I09/IJRET.110209020.pdf>.
  89. Khushoo A, Pal Y, Singh BN, Mukherjee KJ. Extracellular expression and single step purification of recombinant *Escherichia coli* L-asparaginase II. *Protein Expr Purif*. 2004;38(1):29–36, <http://dx.doi.org/10.1016/j.pep.2004.07.009>.
  90. Mehvar R. Modulation of the pharmacokinetics and pharmacodynamics of proteins by polyethylene glycol conjugation. *J Pharm Pharm Sci*. 2000;3(1):125–136. <http://www.ncbi.nlm.nih.gov/pubmed/10954682> Accessed 18.08.16.
  91. Veronese FM, Pasut G. PEGylation, successful approach to drug delivery. *Drug Discov Today*. 2005;10(21):1451–1458, [http://dx.doi.org/10.1016/S1359-6446\(05\)03575-0](http://dx.doi.org/10.1016/S1359-6446(05)03575-0).
  92. Singh S, Kolhe P, Wang W, Nema S. Large-scale freezing of biologics – a practitioner's review, part one: fundamental aspects. *Bioprocess Int*. 2009;7(7):32–44.