

Table S2. Citrus Peel Based Hydrocolloid – Value Added Analysis*

A means of using a low valued material resulting from processing of citrus fruit for juice to produce a potentially high valued hydrocolloid based material in place of low valued citrus peel pellets (\$0.08 – \$0.10/lb).

Potential STEX Hydrocolloid Product Replacement Values

- Replace Hydroxy Propyl, Carboxy Methyl Guar @ \$2.75/lb
- Replace LM/HM Pectin @ \$6.00 – \$12.00/lb
- Replace Alginate @ \$5.00 – \$10.00/lb Food Grade

Material Costs / One lb STEX Hydrocolloid Product

• Processed citrus peel		
1 lb @ \$0.00/lb	=	\$0.00
• Natural Gas		
0.03 Therm/lb @ \$0.46/Therm	=	\$0.02
• Steam		
0.22 lb/lb peel @ \$0.05/lb	=	\$0.01
Total Material Cost / Pound Product	=	\$0.03

*Values taken from 2013-14