

Tab. S.2: Vietnam Robusta grade 2 first hot air roasting series

Degree of roast	Colour SKT	Profile	time [sec]	Temp [°C]	RV/ORV [%]	AA [µg/kg]	Furan [µg/kg]	2-MF [µg/kg]	3-MF [µg/kg]	2,5-DMF [µg/kg]	ΣF [µg/kg]	HMF [mg/kg]	FFA [mg/kg]	HMFA [mg/kg]	FA [mg/kg]
<b>5 min roasts</b>															
light/P1	105	-	307	237	20/9,3	320	3940	11910	560	690	17100	70	815	92	57
light/P2	105	170/90	295	237	18,8/8,1	406	3510	9050	510	510	13580	67	680	79	53
light/P3	95	150/124	290	245	18,8/8,1	364	5660	18760	880	1230	26530	60	998	82	79
med/P1	68	-	318	245	18,8/8,1	352	5080	18030	660	940	24710	38	1106	69	86
med/P2	75	170/100	325	245	20,0/9,3	342	5950	21790	1170	1510	30420	48	1143	80	86
med/P3	71	150/125	309	248	18,8/8,1	388	5980	25580	1230	1690	34880	51	1138	81	88
dark/P1	41	-	322	255	20,0/9,3	259	5280	21000	820	1060	28160	25	1127	51	112
dark/P2	44	170/92	307	255	18,8/8,1	328	5180	22670	900	1400	30150	37	1130	49	107
dark/P3	41	150/121	301	256	18,8/8,1	270	5650	19020	860	930	26450	26	1079	58	117
<b>10 min roasts</b>															
light/P1	98	-	700	230	25,0/11,7	267	2316	5679	212	231	8438	24	827	59	88
light/P2	101	180/140	574	222	25,0/11,7	331	3320	3136	134	153	6744	24	6988	51	81

Tab. S.2 (cont.): Vietnam Robusta grade 2 first hot air roasting series

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<b>15 min roasts</b>															
med/P2	70	130/92	893	242	20,0/6,7	255	1073	17174	562	1048	29512	13	996	49	93
med/P3	75	180/538	900	245	26,3/13,0	314	1903	4305	160	208	6576	31	1181	52	110
dark/P1	40	-	944	238	25,0/11,7	134	5731	27450	682	1632	35495	4	553	19	113
dark/P2	41	150/80	844	250	10,0/-3,3	173	4304	18112	499	984	23899	7	829	37	119
dark/P3	45	180/538	825	255	10,0/-3,3	235	4426	1486	517	1033	20838	9	836	29	82
<b>20 min roasts</b>															
H/P1	96	177/450	1200	221	25,0/11,7	220	2909	9005	317	603	12834	14	713	44	81
H/P2	95	150/99	1160	227	17,5/4,2	303	2441	8497	293	467	11696	18	833	42	77
H/P3	99	180/692	1120	237	17,5/4,2	291	3531	9134	339	669	13673	38	950	71	83
M/P1	72	177/460	1137	235	20,0/6,7	218	3674	12017	371	712	16773	7	582	25	54
M/P2	69	150/92	1139	238	26,3/13,0	249	8086	16832	548	1550	27016	12	1006	31	104
M/P3	74	180/680	1130	245	15,0/1,7	253	3916	14245	526	1019	19706	23	1178	57	99

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<b>20 min roasts</b>															
D/P1	41	177/460	1174	247	26,3/13,0	130	3320	14255	376	630	18581	6	722	27	114
D/P2	47	150/99	1153	243	22,5/9,2	155	5318	29394	774	1759	37245	7	883	22	111
D/P3	44	180/675	1110	255	20,0/6,7	225	4826	17034	579	1060	23499	16	1124	36	133