

Tab. S.4: Vietnam Robusta grade 2: hot air roasting series with extreme profiles; T1: first partial roast, T2: final roast

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]
Sudden temperature rise															
H/P1	104	200 474	630	219	20,0/9,3	334	2370	4940	240	240	7790	71	744	98	60
H/P1	96	200 830	1150	218	13,8/3,1	291	2680	7040	290	330	10340	58	701	88	69
H/P3	105	180 190	325	229	-	370	2660	5030	250	270	8210	40	697	71	53
H/P3	102	205 458	608	222	-	314	1970	4600	220	220	7010	30	673	54	64
M/P1	75	205 450	630	228	17,5/6,8	264	3540	10860	440	580	15420	33	918	60	75
M/P1	71	200 820	1270	220	16,3/5,6	225	4800	19000	680	980	25460	18	672	31	71
D/P1	45	200 813	1181	234	17,5/6,8	167	5870	28440	740	1160	36210	24	1108	40	125
D/P3	46	220 440	567	237	13,8/3,1	253	8590	40890	1460	2430	53370	22	1010	40	101
D/P3	42	190 177	318	252	-	244	4140	14540	530	550	19760	15	820	25	89
D/P3	43	200 735	920	245	-	214	5070	20380	640	830	26920	14	736	25	97

Tab. S.4 (cont.): Vietnam Robusta grade 2: hot air roasting series with extreme profiles; T1: first partial roast, T2: final roast

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]
Double roasts			T1 [sec]	T1 [°C]											
			T2 [sec]	T2 [°C]											
light/P2	106	-	78	150	14,0/ 3,3	306	2920	7850	316	457	11543	42	722	64	59
			838	227											
light/P1	101	-	120	150	14,8/ 4,1	317	3480	8530	406	472	12888	45	772	71	69
			507	226											
light/P1	98	-	173	150	14,8/ 4,1	253	2930	8640	335	487	12392	55	690	31	62
			1032	221											
medium/P1	72	-	114	150	16,3/ 5,6	270	4050	13000	496	704	18250	44	973	30	79
			490	236											
medium/P1	69	-	190	150	16,8/ 6,1	258	4550	19430	679	1310	25969	21	907	34	78
			986	235											
dark/P3	52	-	169	150	16,3/ 5,6	344	4730	15660	653	1030	22073	36	1211	53	99
			462	252											
dark/P1	43	-	191	150	16,3/ 7,3	181	5299	20745	635	947	27626	16	820	28	89
			980	240											