

Tab S 15: *Brazil Arabica* hot air roasting series alternate profiles

Degree of roast	Colour SKT	Profile	Time [sec]	RV/ORV [%]	AA [$\mu\text{g}/\text{kg}$]	Furan [$\mu\text{g}/\text{kg}$]	2-MF [$\mu\text{g}/\text{kg}$]	3-MF [$\mu\text{g}/\text{kg}$]	2,5-DMF [$\mu\text{g}/\text{kg}$]	Σ Furans [$\mu\text{g}/\text{kg}$]
Sudden temperature rise										
Light	118	P1	293	13,8/2,8	435	3817	10607	507	755	15686
Light	115	P1	911	15,0/4,1	324	2620	11170	520	830	15140
Medium	88	P1	1180	17,5/6,6	282	1670	7080	310	540	9600
Medium	87	P3	294	13,8/2,8	528	4719	14152	589	920	20379
Dark	71	P1	1300	20,0/9,1	206	3470	22740	600	1510	28320
Dark	72	P3	314	18,8/7,8	377	4658	18019	735	1436	24848
double roasts										
Light	120	P1	838	12,4/1,5	255	3050	10710	560	790	15110
Light	121	P2	547	12,4/1,5	312	3210	10260	610	730	14810
Medium	72	P1	1269	16,8/5,8	176	5140	29350	860	1880	37230
Medium	84	P2	514	14,9/4,0	226	4840	17980	822	1140	24782
Dark	72	P1	1222	17,3/6,4	194	5320	36990	1140	2820	46270
Dark	73	P2	507	15,7/4,8	268	7430	52740	2160	5860	68190