

Table S1. Actual and coded values of formulation factors in the experimental design.

| Run | A | B | Particle Size (µm) | Quinoa Flour (%) |
|-----|--------------|-------|--------------------|------------------|
| | Coded Values | | Real Values | |
| 1 | +1.00 | +1.00 | 380 | 20 |
| 2 | +1.00 | +0.50 | 380 | 15 |
| 3 | +1.00 | 0.00 | 380 | 10 |
| 4 | +1.00 | −0.50 | 380 | 5 |
| 5 | +1.00 | −1.00 | 380 | 0 |
| 6 | 0.00 | +1.00 | 280 | 20 |
| 7 | 0.00 | +0.05 | 280 | 15 |
| 8 | 0.00 | 0.00 | 280 | 10 |
| 9 | 0.00 | −0.50 | 280 | 5 |
| 10 | 0.00 | −1.00 | 280 | 0 |
| 11 | −1.00 | +1.00 | 180 | 20 |
| 12 | −1.00 | +0.50 | 180 | 15 |
| 13 | −1.00 | 0.00 | 180 | 10 |
| 14 | −1.00 | −0.50 | 180 | 5 |
| 15 | −1.00 | −1.00 | 180 | 0 |