

Table S2

Independent process variables with experimental ranges and levels of response surface methodology.

Independent Variable	Code				
	-1.68 ($-\alpha$)	-1	0	+1	+1.68 ($+\alpha$)
X ₁ : Water content (WC, %)	4.77	15	30	45	55.23
X ₂ : Ultrasonic time (t, min)	3.18	10	20	30	36.82
X ₃ : Ultrasonic temperature (T, °C)	23.18	30	40	50	56.82