**Table S2.** ANOVA and equation coefficients (coded factors) of the linear model for the degree of esterification

| | **F-value** | **p-value** | **Coefficient Estimate** |
|---|---|---|---|
| **Model** | 4.83 | 0.014 | Intercept 36.08 |
| **A-Time** | 1.55 | 0.2309 | 4.29 |
| **B-Power** | 0.2459 | 0.6267 | -1.65 |
| **C-pH** | 12.7 | 0.0026 | 11.88 |