

General Roasting Guide

	Light	Medium	Medium dark
Development rate	10–18%	17–22%	>25%
Time	FC to FC+40s	End of FC to +1:30s	SC
Temp + FC (125 g)	4–8 °C	9–12 °C	+20 °C
Temp + FC (150 g+)	5–9 °C	11–14 °C	+20 °C

Default setting:

Start temp	183 °C
Power	60
Fan	30
Drum speed	70

Rule of thumb (normally):

Turning point should be around 25–40 s.

Begin – yellowing (“stage A”): 4:30–5:00

Yellowing – FC (“stage B”): stage A + 3:00

FC – finish (“stage C”): check table above

Procedures:

1. Warm up at 202°C for 1 min.
2. Set to 185 °C, let it reduce until 183–185 °C, hold for 1 min. Check if the air temperature is steady too.
3. Insert beans and adjust power to 60
4. When ROR = positive, adjust power to 90 to 100 (light roast = 100, medium roast = 95, dark roast = 90) OR the earlier the turning point, the lower the power is (e.g., 25s = turning point, power = 90)
5. From 2:00 to 2:30, reduce power by 5
6. When ROR begins to decrease, increase fan speed by 10 to make sure ROR steadily decrease (NOTE: increase fan speed may also increase ROR, keep an eye on ROR trend, reduce power by 5 if needed). Do this before yellowing (“stage A”).

7. After yellowing ("Stage B") + 20s, reduce power (by a step of 5) for steadily decrease in ROR (e.g., from 90 to 60 gradually). Reduce only if there is an upward trend >10 s. DON'T LET ROR TO CRASH
 8. Before FC (FC minus 10°C, typically ranged from 185–195°C):
 - Reduce power by 5 or 10, if there is **any sign of ROR increase (=exothermic stage)**. However, don't let power goes below 60.
 - Increase fan speed twice by 5 (total = 10).
 9. When FC is in progress:
 - reduce power (reduce by 5). **For washed bean:** During FC, ROR may drop drastically. To fix this, increase power and rotation to 70+.
 - If it still increases, drum speed = 70+.
 - If it still increases, fan = 50+.
 - Then, reduce power stepwise by 5 until it's finished.
 10. For medium and dark roast, final fan speed = [medium: 55, dark:60] + drum speed (70–80).
 11. Check table above for ideal roasting levels.
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