

TABLE 1. Parameter and levels of investigation according to Taguchi L_9 orthogonal array.

PROCESS PARAMETER	UNIT	LEVEL OF ADJUSTMENT		
Chloride	ppm	I	II	III
Organic-1	ml/L	I	II	III
Organic-2	ml/L	I	II	III
Organic-3	ml/L	I	II	III
Post-dip	g/L	I	II	III