

**TABLE 2.** Evaluation of Taguchi  $L_9$  experiments. Top – Process parameter importance based on ANOVA p-values as well as e-factor and validity of Taguchi prediction. Bottom – Optimal process parameter adjustment.

PARAMETER	ETCH RATE	FR-4 PEEL	FR-4 T260	RCC T270	IR REFLOW
Chloride	**	*	0	**	0
Org. 1	***	**	**	***	***
Org. 2	0	*	*	0	*
Post-Dip	**	***	**	*	0
e-factor	2%	9%	25%	4%	10%
Validity +/-	8%	20%	14%	1%	79%

0 = not important, \* less important, \*\* important, \*\*\* Control Factor

PARAMETER	ETCH RATE	FR-4 PEEL	FR-4 T260	RCC T270	IR REFLOW
Chloride	Level I-II	Level I	Level I	Level I-II	Level III
Org. 1	Level II-III	Level II- III	Level II	Level I	Level III
Org. 2	Level III	Level I	Level I	Level II	Level I
Post-Dip	No	No	Interaction	No	Interaction

Interaction = no logic correlation, ANOVA e-factor < 5% good & Validity < 10% good.