

Table S3: Decision variables calculated by the method of ignoring phase transformations

individual	zones 1~5(°C)	zone 6(°C)	zone 7(°C)	zones 8~9(°C)	belt speed(cm/min)
1	179.316054610126	202.330966128912	226.630934861116	259.802984558950	93.901548603513
7	179.316047414169	202.331638544859	226.666412886039	259.793257677314	93.901303413763
9	179.345013744862	202.291774850297	227.021214404106	259.719394898866	93.895737902797
13	179.345065225426	202.291215538402	227.027917217949	259.718049523420	93.895639191728
20	179.317533282526	202.315919296434	227.201025030628	259.684675375952	93.894509120094
25	179.316120197450	202.315766726981	227.204833334926	259.684150958540	93.894537826261
29	179.316120193988	202.315766727770	227.204833335935	259.684150953054	93.894537834719
31	179.316120192544	202.315766727180	227.204833338168	259.684150955982	93.894537847072
32	179.316120232879	202.315766726871	227.204833339338	259.684150949540	93.894537849022
42	179.316120458099	202.315766718533	227.204833293272	259.684151039980	93.894538051604
71	179.316120458100	202.315766718533	227.204833293272	259.684151039980	93.894538051606