What bed temperature should you use for ASA?

Asked 3D Content Team
Published October 15, 2026 · Last verified October 15, 2026

Abstract. Set the bed to 100 °C for ASA, Bambu Studio's default. Data sheets run from 75 °C (Polymaker) to 110 °C (Prusa), always with glue and an enclosure.

Keywords: asa, bed-adhesion, build-plates, warping

Table 1. The number

Source	ASA bed	ABS bed, same maker	Plate and glue	Enclosure
Bambu Lab data sheets	80 to 100 °C	80 to 100 °C	Engineering, High Temperature or Textured PEI plate, with glue	45 to 60 °C chamber
Bambu Studio default profiles	100 °C on the Engineering, High Temp and Textured PEI plates	90 °C on the same plates	Cool Plate not offered (0 °C) for either	Enclosed printer required; not the P1P or A series
Prusa Knowledge Base	105 °C first layer, 110 °C after; at least 100 °C	100 °C, set from 80 to 110 °C by part size	Smooth or powder-coated PEI sheet with glue stick	Enclosure, or a draft shield without one
Prusament ASA	110 ± 5 °C	not listed	Satin sheet	Enclosure for large models
Polymaker	75 to 95 °C	90 to 100 °C	PC or textured PEI, glue when needed	"Closure chamber needed", cooling fan off

1 What bed temperature should you use for ASA?

Set the bed to 100 °C. That's Bambu Studio's default for Bambu ASA, Prusa's minimum and the top of Bambu Lab's 80 to 100 °C data-sheet range. Prusa runs 105 °C for the first layer and 110 °C after, and Polymaker lists 75 to 95 °C. Every maker also calls for an enclosure, and most for glue.

1.1 The number

ASA (acrylonitrile styrene acrylate) next to ABS (acrylonitrile butadiene styrene) from the same maker, with the plate, glue and enclosure each one asks for. PEI is polyetherimide; PC is polycarbonate.

Figures come from Bambu Lab's ASA and ABS technical data sheets (V3.0), the Bambu ASA and generic ABS filament profiles in Bambu Studio and Bambu Lab's ABS / ASA / PC usage guide, the Prusa Knowledge Base ASA and ABS articles, the Prusament ASA product page, and Polymaker's ASA and PolyLite ABS data sheets.

1.2 Is ASA's bed temperature the same as ABS?

Close, but the makers don't agree on which runs hotter. Bambu Lab's two data sheets give the same 80 to 100 °C. Its slicer then sets Bambu ASA 10 °C above ABS: 100 °C against 90 °C.

Prusa also runs ASA hotter, at 110 °C after the first layer against 100 °C for ABS. Polymaker goes the other way, with 75 to 95 °C for ASA and 90 to 100 °C for ABS. The full ABS range is on the ABS bed temperature page.

1.3 Which plate and glue does ASA need?

A PEI plate with glue. For ASA, Bambu Lab's guide says "Glue application required" and rules out the Low-Temp Engineering Plate. Its slicer offers no Cool Plate temperature for ASA at all. Prusa uses the smooth or powder-coated PEI sheet with a glue stick, and Prusament names the satin sheet.

Polymaker lists PC or textured PEI and adds glue only when needed. Applying glue to a textured sheet is covered on the glue stick page.

Glass is the exception. Prusa says glass "might require a layer of acetone with dissolved ASA (or ABS)", a slurry often called ABS juice. Prusa also warns: "Do not put acetone or ABS/ASA juice on the powder-coated sheet!"

1.4 Why ASA needs a hot bed and warm air

ASA shrinks as it cools. Bambu Lab's guide blames warping on that shrinkage plus a high glass transition: in cold surrounding air, the part builds "significant internal stress" and pulls up at the edges. Polymaker puts ASA's glass transition at 98 °C. A 100 °C bed keeps the bottom layers near that point, so they don't cool and shrink against the plate.

The bed can't do it alone. Prusa's rule is a bed of at least 100 °C and an enclosure "to keep a higher ambient temperature", and it calls an enclosure necessary for large parts. Bambu Lab's guide says that when you can't set the chamber temperature, raising the bed warms the enclosed air indirectly. Bambu's data sheet targets 45 to 60 °C air. What a heated chamber adds

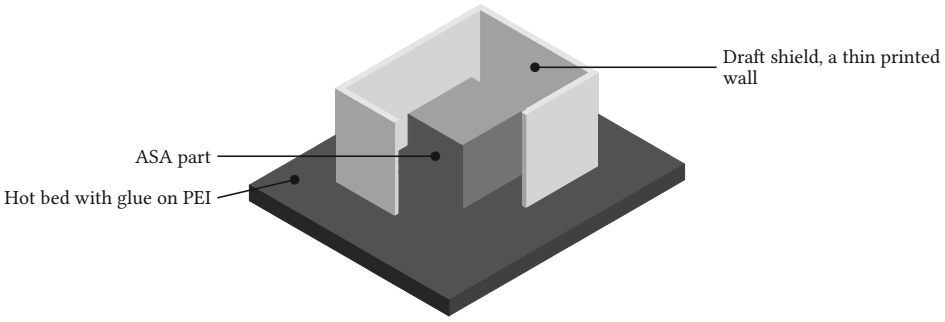


Figure 1. Without an enclosure, Prusa's fallback for ASA is a draft shield around the model, which keeps it slightly warmer.

over a plain enclosure is on the enclosure vs heated chamber page.

1.5 How to check it on your own print

- **Start at 100 °C.** In Bambu Studio the bed temperature is set per plate type in the filament profile, with separate first-layer and other-layer fields. Prusa's recommendation is 105 °C for the first layer, then 110 °C.
- **Clean the plate, then glue it.** Bambu Lab's guide lists both steps, in that order, and Prusa specifies a glue stick on its PEI sheets.
- **Close the printer and warm it up.** In a cold room, Bambu Lab's advice for the X1C and P1S is to run the bed at its maximum for 15 minutes before starting. Without an enclosure, turn on the draft shield in PrusaSlicer (Print Settings, Skirt and Brim), which keeps the model "slightly warmer".
- **Keep the part fan low.** Polymaker lists the fan off. Bambu Lab's data sheet allows 0 to 80 percent and the Bambu ASA profile caps it at 35 percent.
- **If a corner still lifts, add a brim and cut the shrink load.** Bambu Lab suggests a brim, infill at or below 50 percent and no more than 6 walls. Then raise the bed toward Prusament's 110 ± 5 °C, if your bed reaches it. If only one corner lifts, the warped corner page covers that case.
- **Mind the printer's own plastic.** Prusa warns that printing a lot of ASA in an unventilated enclosure can deform the fan shroud and extruder parts over time.

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Cite as: Asked 3D. "What bed temperature should you use for ASA?." October 15, 2026. https://asked3d.com/answers/asa-bed-temperature. Last verified October 15, 2026.