What bed temperature dries filament?

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Abstract. Bambu Lab's heated-bed drying table sets 60 to 70 °C for PLA, 75 to 85 °C for PETG and 80 to 90 °C for TPU, for 12 hours, spool covered and printer closed.

Keywords: pla, petg, tpu, enclosures

Table 1. The number

Filament	Bed setting, Bambu Lab	Bed setting, QIDI	Dryer or oven setting	Glass transition
PLA Basic, PLA Matte	60 to 70 °C, 12 h, flip every 6 h	65 to 75 °C, 12 h	Bambu 50 °C, 8 h; Prusa 45 °C, 6 h	60 °C
PETG, PETG-CF	75 to 85 °C, 12 h	75 to 85 °C, 12 h	Bambu 60 to 65 °C, 8 h; Prusa 55 °C, 6 h	69 °C
TPU 95A HF, TPU for AMS	80 to 90 °C, 12 h	80 to 90 °C, 12 h	Bambu 70 °C, 8 h; Prusa 60 °C, 4 to 6 h	not applicable
TPU 85A, TPU 90A	90 °C, 16 h	80 to 90 °C, 12 h	Bambu 70 °C, 8 h	not applicable
ABS, ASA	90 to 100 °C, 12 h	90 to 100 °C, 12 h	Bambu 75 to 85 °C, 8 h; Prusa ASA 80 °C, 4 h	not listed here
PC	90 to 100 °C, 12 h	90 to 100 °C, 12 h	Bambu 75 to 85 °C, 8 h; Prusa PC Blend 85 °C, 5 h	not listed here
Nylon composites (PA6-CF/GF, PAHT-CF/GF)	90 to 100 °C, 12 h	90 to 100 °C, 12 h	Bambu 75 to 85 °C, 8 to 12 h; Prusa PA11 CF 90 °C, 6 h	not listed here

1 What bed temperature dries filament?

Bambu Lab's heated-bed drying table sets 60 to 70 °C for PLA, 75 to 85 °C for PETG and 80 to 90 °C for most TPU, each for 12 hours, with the spool under a box and the printer closed. QIDI publishes the same figures, except 65 to 75 °C for PLA. Open-frame printers can't dry filament this way.

1.1 The number

Bed settings come from Bambu Lab's Filament Drying Recommendations wiki and QIDI's heatbed drying guide, which adds a flip every 6 hours for all of them. Dryer and oven settings come from the same Bambu wiki (forced-air oven) and the Prusa Knowledge Base (Prusament). Glass transitions come from Bambu's PLA Basic and PETG Basic data sheets. The TPU 95A HF sheet lists it as N/A.

1.2 Why

Filament soaks up water from the air. In the hot nozzle that water flashes to steam, which Bambu Lab blames for bubbles, stringing, oozing, holes, rough surfaces and weaker parts. Drying drives the water out below the point where the plastic softens.

The bed figures run 10 to 25 °C above the dryer figures because the plate isn't the filament. The spool sits on the plate under a cover, and the coils farther from the plate stay cooler. QIDI notes that the closer filament sits to the bed, the hotter it gets. That's why both makers tell you to flip the spool partway through.

That gap is also why PLA's bed setting starts at its own 60 °C glass transition and PETG's sits above its 69 °C one. The bottom coils run hottest. Leave a soft filament still too long and the coils fuse: Bambu keeps PLA and TPU out of the static drying mode on its AMS dryers for exactly that reason. Prusa warns that going over its temperatures makes the filament "soften and stick together." Each plastic's glass transition against its bed setting is tabled on the bed temperature explainer.

1.3 What bed temperature dries PLA?

For PLA (polylactic acid), set 60 to 70 °C for 12 hours on Bambu Lab's table, which the PLA Basic data sheet repeats. QIDI says 65 to 75 °C. Specialty PLAs run a little hotter on Bambu's table: 65 to 75 °C for Silk and the carbon or glass-filled grades, 70 to 75 °C for PLA Wood. Turn the spool over every 6 hours. If the bottom coils come out tacky, use the low end of the range.

1.4 What bed temperature dries PETG?

For PETG (glycol-modified polyethylene terephthalate), set 75 to 85 °C for 12 hours, from both Bambu Lab and QIDI. For comparison, the PETG Basic data sheet's dryer setting is 65 °C for 8 hours, and Prusa dries Prusament PETG at 55 °C for 6 hours.

Bambu's PLA and PETG data sheets list the spool as ABS (acrylonitrile butadiene styrene), rated to 70 °C. Bambu still sets PETG's bed above that, so it isn't expecting the spool to

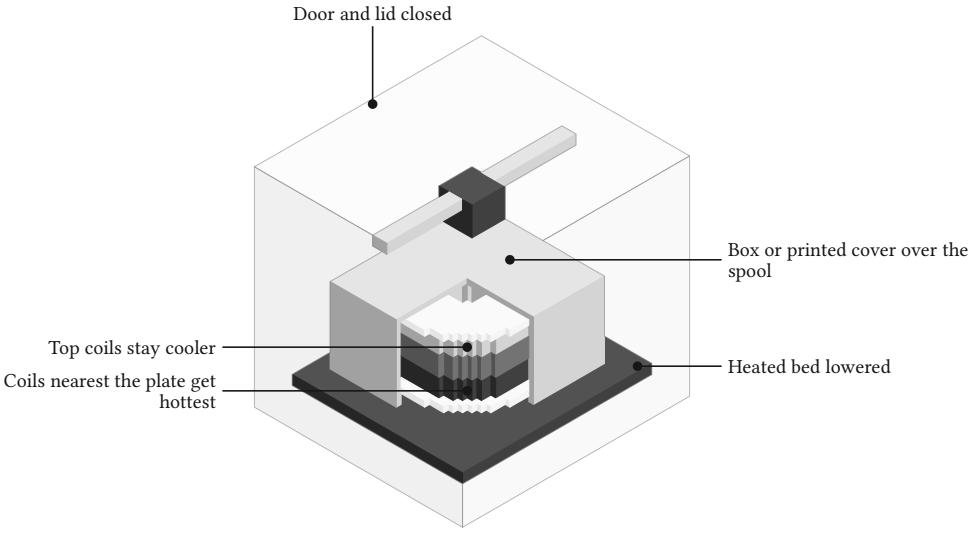


Figure 1. The spool sits on the plate under a cover, and the coils closest to the bed get hottest, which is why both makers say to flip it partway through.

reach the plate setting. Check the spool's rating before you go to the top of the range.

1.5 What bed temperature dries TPU?

For TPU (thermoplastic polyurethane), set 80 to 90 °C for 12 hours on TPU 95A HF and TPU for AMS. Bambu Lab's softer TPU 85A and 90A take 90 °C for 16 hours. Bambu marks drying as required before use for every TPU. The TPU 95A HF spool is PC (polycarbonate) and ABS, rated to 90 °C. Bambu also says its AMS 2 Pro dryer, at 65 °C, may not fully dry TPU and points to the heated bed instead.

1.6 Which printers can dry filament on the bed?

Only enclosed ones. Bambu Lab rules out the open-frame P1P, A1, A1 mini and A2L. The H series, X series, X2D and P2S have a built-in drying screen. Pick the filament type, set the bed temperature and the duration, then press Start. The P1S has no drying screen, so you lower the bed, set the temperature by hand and time it yourself. Prusa's drying article lists dryers, ovens and food dehydrators but no heated-bed method.

1.7 How to check it on your own print

- **Unload the filament from the toolhead first.** Both makers warn that filament softening in a hot extruder can clog it. QIDI also wants the bed lowered into the bottom half of the chamber.
- **Check the spool's heat rating.** Bambu and QIDI both warn that some third-party spools deform during drying. Prusament's current black spool takes up to 90 °C. The older black Prusament spool loosens above 45 °C unless a screw joins its two sides; Prusa uses an M4 x 65 mm.
- **Cover the spool and shut everything.** Use the filament's cardboard box with one side torn open (QIDI's method) or a cover printed in PC or PA-CF (carbon-fiber nylon), then close the door and the top lid.
- **Flip it partway through.** Wear gloves: the spool is hot.
- **Cool it on the bed.** Set the bed to 0 °C and wait until the spool is no longer hot to the touch before you lift it off.
- **Seal it straight away.** Bambu Lab says freshly dried filament at about 55 percent indoor humidity can pick up enough moisture to hurt print quality within 2 to 12 hours. Store it with desiccant below 20 percent RH (relative humidity).
- **Print a test.** If stringing, popping or bubbles remain, dry it again. If the coils have stuck together, run the next batch at the low end of the range.

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