What bed temperature does nylon need?

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Abstract. Bambu Lab sets 80 to 100 °C for its nylons on a glued PEI or Engineering plate, Prusa 110 °C on a PA Nylon sheet. Polymaker's nylons run at 25 to 50 °C.

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

1 What bed temperature does nylon need?

80 to 110 °C on Bambu Lab and Prusa sheets: Bambu Lab sets 80 to 100 °C for its PA6 and PAHT-CF grades on a glued Engineering or PEI plate, and Prusa 110 °C on its PA Nylon sheet. Polymaker differs: its nylons run at 25 to 50 °C, and its fiber grades must not exceed 50 °C.

1.1 The number

Nylon is a family of plastics called polyamides (PA). PA6, PA11 and PA12 are different polymers, and fiber-filled grades add chopped carbon fiber (CF) or glass fiber (GF). Each row is one maker's instruction for one product.

The Bambu Lab rows come from its PA6-CF, PA6-GF and PAHT-CF technical data sheets and the build plate tables in its filament guide. The Polymaker rows come from the PolyMide CoPA data sheet and the Fiberon product pages on Polymaker's wiki. The Prusa rows come from the Prusament PA11 Carbon Fiber datasheet, the Polyamide (Nylon) article in the Prusa Knowledge Base and Prusa's PA Nylon sheet product page.

Bambu Lab gives three ranges for its own nylons in two documents. The data sheets say 80 to 100 °C, the glue-stick table 90 to 110 °C and the plate table 100 to 120 °C. All three include 100 °C.

1.2 What is the best surface for nylon?

The three makers each name a different plate for their own nylon.

- **Bambu Lab:** the Engineering, High Temperature (smooth PEI, polyetherimide) or Textured PEI plate, always with glue. Its guide names Bambu Lab Glue Stick for PA6-GF/CF and PAHT-CF, rules out liquid glue for nylon

Table 1. The number

Filament or guide	Nylon type	Bed	Plate the maker specifies	Glue
Bambu Lab PA6-CF data sheet	PA6, carbon fiber	80 to 100 °C	Engineering, High Temperature or Textured PEI plate	Glue
Bambu Lab PA6-GF data sheet	PA6, glass fiber	80 to 100 °C	Engineering, High Temperature or Textured PEI plate	Glue
Bambu Lab PAHT-CF data sheet	High-temperature nylon, carbon fiber	80 to 100 °C	Engineering, High Temperature or Textured PEI plate	Glue
Bambu Lab filament guide, plate table	PA, PA-CF/GF, PAHT-CF/GF	100 to 120 °C	Engineering, Smooth PEI/ High Temperature or Textured PEI; Cool Plate "Not recommended"	Not stated in this table
Bambu Lab filament guide, glue table	PA, PA-CF/GF, PAHT-CF/GF	90 to 110 °C	Not stated in this table	Glue stick; liquid glue "Not Recommended"
Polymaker PolyMide CoPA	PA6/66 copolymer	25 to 50 °C	"PC and Texture PEI"	"Glue when needed"
Polymaker Fiberon PA6-CF20	PA6, carbon fiber	40 to 50 °C, "Do not set your build plate above 50˚C"	Not specified	Glue stick or Magigoo PA if adhesion fails
Polymaker Fiberon PA6-GF25	PA6, glass fiber	40 to 50 °C, not above 50 °C	Not specified	Glue stick or Magigoo PA if adhesion fails
Polymaker Fiberon PA12-CF10	PA12, carbon fiber	40 to 50 °C, not above 50 °C	Not specified	Glue stick or Magigoo PA if adhesion fails
Prusament PA11 Carbon Fiber	PA11, carbon fiber	110 ± 10 °C	PA Nylon spring sheet "treated with clean water"	None; Prusa says glue "is no longer required" on this sheet
Prusa Knowledge Base, polyamide in general	Not specified	110 °C	PA Nylon sheet	Not stated

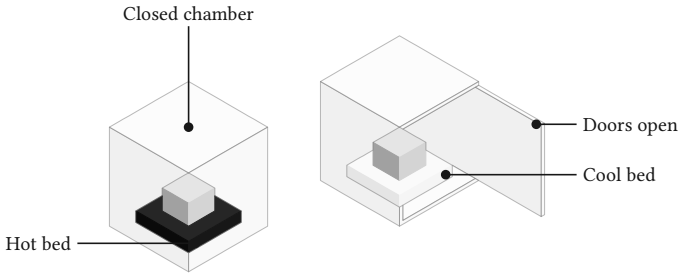


Figure 1. Bambu Lab keeps nylon warm with a hot bed and a closed chamber, while Polymaker prints its fiber nylons on a cool bed with the doors open and anneals the part afterward.

and marks the Cool Plate "Not recommended". Glue on a textured plate is covered in should you use glue stick on textured PEI.

- **Prusa:** its PA Nylon powder-coated sheet. Prusa says "PA11-type materials have generally a lower adhesion on textured or satin print sheets", and that this sheet holds nylon without glue. It lists the sheet as suitable "only for polyamide-based materials and PETG".
- **Polymaker:** "PC and Texture PEI" for CoPA, with glue when needed. For its Fiberon nylons it names no plate, only glue stick or Magigoo PA if the first layer will not stick.

1.3 Why some sheets want a hot bed and others a cool one

The makers use two opposite strategies against the same problem. Prusa's knowledge base calls warping "the main disadvantage of pure polyamide".

Bambu Lab goes hot. Its guide groups PA with ABS and PC as materials that "require higher heatbed and chamber temperatures to suppress warping and layer separation". Its 80 to 100 °C bed sits above the glass transition its data sheets measure: 68 °C for PA6-CF, 67 °C for PA6-GF and 70 °C for PAHT-CF. Each of those data sheets pairs the bed with a 45 to 60 °C chamber.

Polymaker goes cold. Its Fiberon nylons use what it calls Warp-Free technology: "we want to make sure the build plate and the ambient air temperatures are both below 50˚C. We then anneal the print after to get it's full strength." It tells you to keep the chamber doors open and anneal the finished part: 100 °C for 16 hours for PA6-CF20. CoPA's 25 to 50 °C bed also stays under its 66 °C glass transition.

Fiber filling also cuts warping. Prusa writes that carbon-filled polyamides "don't warp by far as much as the unaltered versions and can be printed without an enclosure." A setting written for one formula does not carry over to another maker's spool. Chamber options are compared in enclosure versus heated chamber.

1.4 How to check it on your own print

1. **Find the sheet for your exact spool.** The label names the base polymer (PA6, PA6/66, PA11, PA12) and any CF or GF fill. Set the bed to the middle of that sheet's range, never another maker's.
2. **Dry the filament before blaming the bed.** Bambu Lab dries its nylons at 80 °C for 8 to 12 hours. Prusa asks for at least 4 hours below 90 °C. Prusa notes that moist polyamide bubbles, which leaves uneven layers.
3. **Prepare the plate the maker names.** On Bambu Lab plates, apply a glue stick. On a Prusa PA Nylon sheet, wipe with clean water only: Prusa warns that IPA (isopropyl alcohol) or acetone deteriorates its surface.
4. **If corners lift on a hot-bed grade,** close the enclosure and work toward the top of the range: 100 °C on Bambu Lab's data sheets, 110 to 120 °C on its plate table. For large parts, Prusa's PA11 Carbon Fiber datasheet recommends a brim.
5. **If a Polymaker grade warps,** do the opposite: lower the bed to 50 °C or less and open the doors. Polymaker says ambient air above 50 °C risks "warping or ugly prints".
6. **Let the plate cool before you pull the part.** Bambu Lab's guide says to wait until the plate and model have fully cooled, then flex the plate to release the print.

Nozzle ranges for the same grades are in what nozzle temperature nylon actually needs. Every other filament's bed range sits side by side in the bed temperature chart.

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