What bed temperature should you use for PETG?

Asked 3D Content Team
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Abstract. About 70 to 80 °C. Bambu Lab lists 60 to 80 °C for all its PETG, Prusa runs 85 then 90 °C. Put glue stick on smooth PEI or glass first.

Keywords: petg, bed-adhesion, build-plates

Table 1. The number

Source	PETG type	Build plate	Bed temperature	Glue rule
Bambu Lab filament guide	Basic, HF, CF, Translucent	Engineering, Smooth PEI, Textured PEI	60 to 80 °C	Glue stick or liquid glue recommended; original Cool Plate "Not recommended"
Bambu Lab data sheet	PETG Basic	Cool Plate SuperTack, Textured PEI, Smooth PEI	65 to 75 °C	Glue recommended (stick or liquid)
Bambu Lab data sheet	PETG HF	Smooth PEI, Textured PEI	65 to 75 °C	Glue
Bambu Lab data sheet	PETG-CF	Engineering, High Temperature, Textured PEI	65 to 75 °C	Glue
Bambu Lab build plate guide	Any PETG	Cool Plate SuperTack, 2nd generation	55 to 60 °C (around 65 °C on X and P series profiles)	No glue
Prusament data sheet	Prusament PETG	Satin, powder-coated, smooth PEI	80 ± 10 °C	Glue stick on smooth PEI
Prusa Knowledge Base	Any PETG	Powder-coated textured or satin	85 °C first layer, 90 °C after	Smooth PEI only with glue stick
Polymaker data sheet	PolyLite PETG	PC, textured PEI	70 to 80 °C	"Glue when needed"
UltiMaker support	UltiMaker PETG	Glass	85 °C	Thin layer of UHU glue

1 What bed temperature should you use for PETG?

About 70 to 80 °C. That band sits inside Bambu Lab's 60 to 80 °C for every PETG (glycol-modified polyethylene terephthalate) variant, Polymaker's 70 to 80 °C and Prusament's 80 ± 10 °C. Prusa's profile runs hotter, 85 °C then 90 °C. On smooth PEI (polyetherimide) or glass, glue stick goes on first, or PETG can damage the surface.

1.1 The number

The rows come from Bambu Lab's filament guide, build plate and glue guides and PETG Basic, PETG HF and PETG-CF data sheets, the Prusament PETG data sheet and Prusa Knowledge Base PETG article, Polymaker's PolyLite PETG data sheet and UltiMaker's PETG printing guide. PC is polycarbonate. Bambu Lab printed its PETG Basic, HF and CF test specimens on a 70 °C bed.

1.2 PETG bed temp vs PLA

PETG runs about 15 to 30 °C hotter. Bambu Lab sets PLA (polylactic acid) at 45 to 65 °C on its PEI plates and PETG at 60 to 80 °C. Prusa uses 60 °C for PLA against 85 to 90 °C for PETG, and says that "unlike PLA, PETG requires a heated bed." Bambu Lab's original Cool Plate, rated 35 to 45 °C for PLA, is "Not recommended" for PETG. The full PLA numbers are on the PLA bed temperature page.

1.3 Does PETG-CF or PETG HF need a different bed temperature?

No. Bambu Lab's data sheets give 65 to 75 °C for PETG Basic, PETG HF and PETG-CF alike. Its filament guide puts all three, plus PETG Translucent, at 60 to 80 °C. Their glass transitions sit within 3 °C: 66 °C for HF, 68 °C for CF and 69 °C for Basic. Only the plate lists differ. The PETG Basic sheet is the only one to include the Cool Plate SuperTack, and the PETG-CF sheet adds the Engineering and High Temperature plates.

1.4 What stops PETG fusing to smooth PEI?

Glue, not a lower number. Prusa warns that PETG's adhesion to its smooth PEI sheet "may be too strong, and you can damage your Smooth PEI sheet". Its fix is a basic PVA (polyvinyl alcohol) glue stick as a separation layer. Bambu Lab says that except for PLA, glue "must be applied" on its Smooth PEI Plate. Prusa adds two cleaning rules for this sheet. Don't use acetone before printing PETG. And don't print PETG on a sheet that has had only an IPA (isopropyl alcohol) wipe: "IPA + PETG will cause the print to adhere very strongly to the sheet."

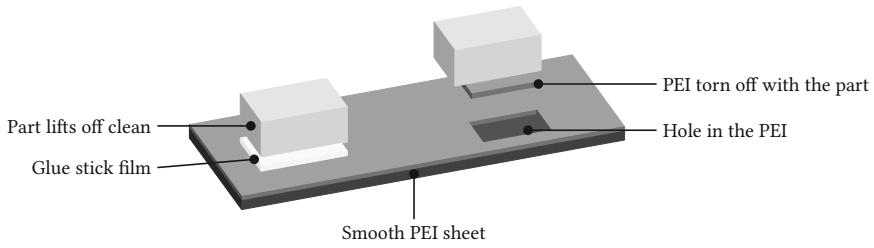


Figure 1. Glue stick works as a separation layer; without it, PETG can bond to smooth PEI hard enough to damage the sheet.

Temperature helps at the margin. Polymaker suggests dropping the bed 5 to 10 °C below the recommended setting and letting it cool below 40 °C before removal.

1.5 PETG bed temp on textured PEI

Use the same 60 to 80 °C. Bambu Lab and Prusa both print PETG on bare textured PEI, and Prusa calls its textured sheet "ideal for extensive printing of PETG". Bambu Lab adds glue only when a part is hard to remove, so its underside doesn't turn white when forced off. Polymaker disagrees: its sticking guide calls a release agent mandatory for PETG on textured PEI and says bare printing "guarantees damage on removal". The glue stick on textured PEI page covers the other materials.

1.6 PETG bed temp on a glass bed

UltiMaker sets 85 °C on its glass plate and applies a thin layer of UHU glue first. The glue serves two jobs: reliable adhesion and less chance of the glass chipping when the part comes off. On the flexible plates of its Factor and S Series printers, it uses no glue.

1.7 Why

PETG's first layer has to stay soft enough to wet the plate. Bambu Lab's data sheets put PETG's glass transition at 66 to 69 °C, and Polymaker measures 81 °C for PolyLite PETG. A bed in the 70 to 80 °C band holds the bottom layer around that point. Bambu Lab's textured PEI troubleshooting guide says a higher bed temperature increases adhesion.

Go too hot and the effect flips. Polymaker says excessive heat "softens bottom layers into a glue", and Bambu Lab warns of elephant foot and nozzle clogging with PETG. Its filament guide also advises opening the front door or removing the top glass cover on enclosed printers once a PETG bed goes above 60 °C, so chamber heat doesn't soften the filament in the extruder. The heat isn't there to stop warping. Prusa says PETG "does not shrink or warp" because it has very little thermal expansion.

The release comes from cooling. Bambu Lab waits until its textured PEI plate reaches 35 °C or lower, then flexes the sheet. UltiMaker says to let the plate cool down completely.

1.8 How to check it on your own print

- **Start at 70 °C, or mid-range on your spool's data sheet.** Bambu Lab printed all three of its PETG test sets on a 70 °C bed.
- **Prepare the surface for the plate.** Textured PEI: wipe with about 90 percent IPA while cold, per Prusa. Smooth PEI or glass: a thin glue-stick layer before every print.
- **If the first layer lifts, raise the bed toward the top of your maker's range.** Add a brim as well. It's UltiMaker's default adhesion setting for PETG.
- **If you see elephant foot or the nozzle clogs, lower the bed.** On an enclosed printer, open the door as well.
- **If the part won't come off, wait.** Let the plate drop to 35 °C or lower, then flex it. For the next print, Polymaker suggests a bed 5 to 10 °C cooler and a release agent. More removal steps are on the print removal page.

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