What temperature and how long should you dry PETG?

Asked 3D Content Team
Published October 17, 2026 · Last verified October 17, 2026

Abstract. Dry PETG at 55 to 65 °C (131 to 149 °F) for 6 to 8 hours. Prusa sets 55 °C, Bambu Lab 65 °C, Polymaker 60 to 65 °C. None of them goes above 65 °C.

Keywords: petg

Table 1. The number

Grade	Dryer or oven setting	In °F	Time	Glass transition	Margin below it
Bambu Lab PETG Basic	65 °C	149 °F	8 h	69 °C (156.2 °F)	4 °C
Bambu Lab PETG HF	65 °C	149 °F	8 h	66 °C (150.8 °F)	1 °C
Bambu Lab PETG-CF	65 °C	149 °F	8 h	68 °C (154.4 °F)	3 °C
Bambu Lab wiki, PETG and PETG-CF	60 to 65 °C	140 to 149 °F	8 h	not given	not given
Prusament PETG, all versions	55 °C	131 °F	6 h	not listed; heat deflection 68 °C (154.4 °F)	not listed
Polymaker PETG	60 °C	140 °F	6 h	71.2 °C (160.2 °F)	11.2 °C
Polymaker PolyLite PETG	65 °C	149 °F	6 h	81 °C (177.8 °F)	16 °C
Polymaker PolyMax PETG	65 °C	149 °F	6 h	79 °C (174.2 °F)	14 °C
Polymaker Fiberon PETG-rCF08	65 °C	149 °F	3 h	69.7 °C (157.5 °F)	4.7 °C

1 What temperature and how long should you dry PETG?

Dry PETG (glycol-modified polyethylene terephthalate) at 55 to 65 °C (131 to 149 °F) for 6 to 8 hours in a dryer or forced-air oven. Prusa sets 55 °C for 6 hours, Bambu Lab 65 °C for 8 hours, Polymaker 60 to 65 °C for 6 hours. None goes higher, since some grades start softening at 66 °C.

1.1 The number

Bambu Lab rows come from its three data sheets and its Filament Drying Recommendations wiki, and Polymaker rows from each grade's data sheet. The Prusament row comes from the Prusa Knowledge Base; Prusament's data sheet lists heat deflection, not a glass transition. Fahrenheit is the exact conversion, and the margin is the glass transition minus the drying setting.

1.2 Why

PETG pulls water from the air: Polymaker groups it with nylon, PVA (polyvinyl alcohol) and TPU (thermoplastic polyurethane) as highly hygroscopic. In the hot nozzle that water turns to steam. Bambu Lab blames the steam for bubbles, stringing, holes and weaker parts.

Heat drives the water out, and the softening point caps the heat. Prusa says going over its temperatures makes the filament "soften and stick together." Bambu Lab drops its AMS 2 Pro and AMS HT to 55 °C for PETG once a print starts, "usually below the filament's softening point," so it can't clog in the AMS.

1.3 What is the maximum temperature to dry PETG?

65 °C (149 °F). No maker in the table publishes a higher dryer or oven setting for PETG. Bambu Lab uses it on all three data sheets and in its AMS 2 Pro, which it rates for filaments that dry at no more than 65 °C.

Your grade's data sheet sets the real ceiling. At 65 °C the margin to the glass transition runs from 1 °C on PETG HF to 16 °C on PolyLite PETG, and Bambu Lab's ABS (acrylonitrile butadiene styrene) spools are rated to 70 °C. A hotter, shorter cycle is no fix: Prusa says high temperatures damage filament "even if left for less time than recommended."

Bambu Lab's 75 to 85 °C (167 to 185 °F) PETG figures are for drying on a heated bed, which the heated-bed drying table covers.

1.4 Is 50 °C enough to dry PETG?

No maker here publishes a PETG setting that low. The lowest is Prusa's 55 °C (131 °F) for 6 hours, and Bambu Lab and Polymaker both start at 60 °C. 50 °C (122 °F) is Bambu Lab's oven setting for PLA (polylactic acid) Basic, and no source here gives a PETG drying time at that temperature.

Polymaker says airflow matters more than heat: strong airflow speeds up drying at a lower temperature, and without it drying "may take longer or require higher temperatures." If your dryer tops out at 50 °C, judge it by a test print, not the timer.

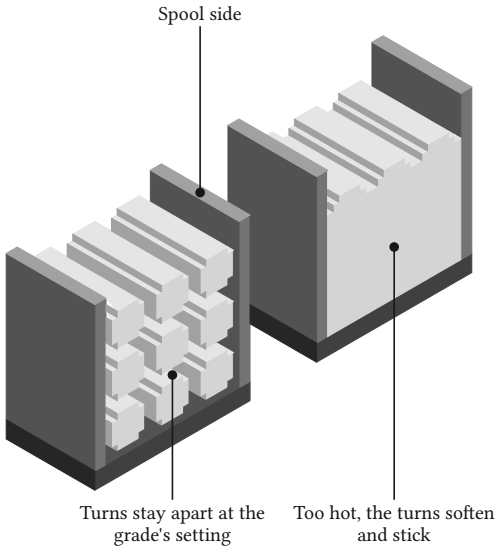


Figure 1. Dried past the grade's softening point, the turns pressed together on the spool soften and stick, so the coils are the thing to check afterwards.

1.5 How long should you dry PETG?

6 hours at Prusa's and Polymaker's settings, 8 hours at Bambu Lab's in an oven, and 12 hours in a Bambu Lab AMS 2 Pro or AMS HT or on a heated bed. Bambu Lab's AMS figures disagree: the wiki says 12 hours at 65 °C, the PETG Basic data sheet 8 hours. Prusa says to keep to the listed times to prevent overdrying.

1.6 What temperature dries PETG-CF?

65 °C (149 °F) for 8 hours for Bambu Lab PETG-CF, per its data sheet, or 65 °C for 12 hours in an AMS 2 Pro or AMS HT per the wiki. Polymaker's Fiberon PETG-rCF08 takes 65 °C for 3 hours, and Prusa's 55 °C, 6 hour setting covers every version of Prusament PETG. The carbon fiber (CF) adds no headroom: Bambu Lab's PETG-CF glass transition is 68 °C, against 69 °C for PETG Basic.

1.7 How do you dry PETG HF?

Bambu Lab's PETG HF data sheet gives a forced-air oven at 65 °C (149 °F) for 8 hours, or an X1 Series heated bed at 75 to 85 °C for 12 hours. In an AMS 2 Pro or AMS HT, the wiki sets 65 °C for 12 hours. Insert the filament, select the type and start drying; the AMS won't dry while auto-feeding runs. Don't round up: at 66 °C, PETG HF has the lowest glass transition in the table.

1.8 How to check it on your own print

- **Use a dryer or a forced-air oven.** Bambu Lab rules out microwaves and kitchen ovens, whose heat near the elements can damage the spool or filament. If you use a home oven anyway, Prusa says to check it with an external thermometer.
- **Check the spool before you heat it.** Bambu Lab warns that some third-party spools deform during drying. Prusa's current black spool takes up to 90 °C, but the older black Prusament spool is safe only to 45 °C, under Prusa's own 55 °C PETG setting. Join its two sides with a screw at least 65 mm long first.
- **Look at the coils afterwards.** If they've stuck together, it ran too hot for that grade; drop to the bottom of the maker's range next time.
- **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), which Bambu Lab says keeps it dry for 2 to 7 days.
- **Print a test.** If bubbles, stringing or rough surfaces remain, dry it again. Polymaker says the before-and-after difference in PETG is easy to spot.

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Cite as: Asked 3D. "What temperature and how long should you dry PETG?." October 17, 2026. https://asked3d.com/answers/petg-drying-temperature. Last verified October 17, 2026.