

Filament Dryer Temperatures

Material	Tg (°C)	Dryer (°C)
PLA	55–60	40–45
PLA+ / Tough PLA	60–65	45
PETG	75–80	50–55
ABS	100–105	55–60
ASA	100–105	55–60
HIPS	~95	50–55
TPU (95A)	–30 to –10	45–50
TPU (soft)	—	40–45
Nylon PA6*	50–60	65–70
Nylon PA12*	40–50	55–60
Nylon CF/GF*	(base)	65–70
PC	145–150	65–70
PC Blends	110–140	60–65
PMMA	~105	60–65
PVA	~85	45–50
BVOH	80–90	45–50
PEEK	~143	80–90
PEI (Ultem)	~215	80–90

*Nylon dryer temp may exceed dry-state Tg (moisture-suppressed)