

Dry all engineering filaments before every print session — including freshly opened factory-sealed spools. Vacuum sealing does not guarantee zero moisture content.

Material	Temperature	Time	Priority	Notes
STANDARD FILAMENTS 6 items				
PLA	50°C	6 hrs	NORMAL	Low priority if recently opened. Improves surface quality.
PLA+ / PLA-CF	55°C	6 hrs	NORMAL	Slightly higher than standard PLA.
PETG	65°C	6 hrs	IMPORTANT	Noticeably improves quality. Reseal after each session.
ASA	65°C	6 hrs	IMPORTANT	Moderate sensitivity. Beneficial before long prints.
TPU	65°C	6 hrs	IMPORTANT	Dry if stringing is excessive.
ABS	80°C	6 hrs	IMPORTANT	Important for large prints. Reduces delamination risk.
ENGINEERING FILAMENTS 6 items				
PET-CF	65°C	6 hrs	IMPORTANT	Less moisture-sensitive than Nylon-based CF. Still benefits.
PA12 (Nylon)	80°C	8 hrs	CRITICAL	High priority. Absorbs moisture within hours of open-air exposure.
PA6 / PA6-CF	80°C	12 hrs	CRITICAL	Critical. Brief exposure degrades quality significantly.
PA12-CF	80°C	12 hrs	CRITICAL	Critical. Dry before every session without exception.
PC	80°C	8 hrs	CRITICAL	Very hygroscopic. Paper spool users can dry at 100°C.
PPA-CF	100°C	12 hrs	CRITICAL	Critical. PAPER SPOOL REQUIRED — plastic warps above 80°C.