PETG · Bambu Studio guide

1 kg and 3 kg filament spools

Select the correct printer and nozzle

In Bambu Studio, choose your exact printer, installed nozzle diameter and build plate. A profile for another printer or nozzle is not interchangeable. Confirm the material is supported by the printer and filament feed system.

Keep filament dry, tune retraction and temperature to control stringing, and follow your build-surface guidance. Some surfaces require a release layer.

Bambu profile reference

Values transcribed from the saved CaiLab manufacturer Bambu filament bundles previously used as our reference. These are manufacturer profile values, not a claim of individually tested Alba Labs settings. Keep the selected printer, nozzle and extruder variant matched; calibrate for your actual spool.

Bambu Lab H2D 0.4 nozzle

Source preset: CaiLab PETG Generic @Bambu Lab H2D 0.4 nozzle

Nozzle, first layer: 255 °C

Nozzle, other layers: 255 °C

Textured PEI, first layer: 70 °C

Textured PEI, other layers: 70 °C

Flow ratio: 0.95

Maximum volumetric speed: 13 mm³/s

Part fan, minimum: 10%

Part fan, maximum: 40%

Fan off for first: 3 layers

Bridge/overhang fan: 90%

Auxiliary fan: 0%

The source has no drying schedule here. Request grade-specific drying guidance. A volumetric limit is not a guaranteed linear printing speed.

Bambu Lab X1 Carbon 0.4 nozzle

Source preset: CaiLab PETG Generic @Bambu Lab X1 Carbon 0.4 nozzle

Nozzle, first layer: 255 °C

Nozzle, other layers: 255 °C

Textured PEI, first layer: 70 °C

Textured PEI, other layers: 70 °C

Flow ratio: 0.95

Maximum volumetric speed: 13 mm^3/s

Part fan, minimum: 10%

Part fan, maximum: 40%

Fan off for first: 3 layers

Bridge/overhang fan: 90%

Auxiliary fan: 0%

The source has no drying schedule here. Request grade-specific drying guidance. A volumetric limit is not a guaranteed linear printing speed.

Prepare and calibrate

• Request the Alba Labs TDS and recommended drying procedure for this grade; store filament dry after opening.

• Check spool dimensions and feed path, then select the correct plate and its recommended adhesive or release layer.

• After receiving the matched material preset, run a small calibration print. Check first-layer adhesion, flow, stringing, cooling and layer bonding before a long job.

• Record the printer, nozzle, plate and profile revision with your successful print. Recheck after changing any of these.

Applications and limits

PETG is a versatile material family for prototypes, organizers and many everyday functional parts. It balances approachable printing with useful toughness for suitable applications.

Check heat, chemical and load requirements before selecting a grade. Do not assume food-contact, medical or other regulated suitability from the material name.

Contact for TDS and matched Bambu settings

info@3baprinting.com · Material page

Edition: 2 November 2026. General preparation guidance. No tested-grade performance, certified specifications or guaranteed printing speed is claimed.