**Professionally Approved products.**

Product datasheet

**HIPS**

**HIPS is an easy to print, High Impact Polystyrene filament with multifunctional properties. HIPS is an excellent support material in combination with ABS, because it dissolves in D'limonene and ABS remains unaffected**

**HIPS is very suitable for detailed prints, but also for large objects because the material shows very limited warping. Furthermore HIPS is very light and durable, has good interlayer bonding, can be glued easily and the colours result in a smooth matt surface of the 3D printed objects. High Impact Polystyrene is therefore widely used in model building**

|  |  |  |
| --- | --- | --- |
| **Dimensions** | | |
| Size | Ø tolerance | Roundness |
| 1,75mm | ± 0,05mm | ≥ 95% |
| 2,85mm | ± 0,10mm | ≥ 95% |
|  |  |  |
| **Physical properties** | | |
| Description | Testmethod | Typical value |
| Specific gravity | ISO 1183 | 1,04 g/cc |
| MFR 200˚C/5kg | ISO 1133 | 3.4 cm/³10 min |
| Tensile strength | ISO 527 | 22 MPa |
| Elong at break (MD) |  | 50% |
| Tensile modulus  (1mm/min) | ISO 527 | 1550 Mpa |
| Impact Strength  Izod method 23˚C | ISO 179 | 15 KJ/m² |
|  |  |  |
| **Thermal properties** | | |
| Description | Testmethod | Typical value |
| printing temp. | - | 220-270˚C |
| melting temp. | ISO 294 | 220˚C ± 40˚C |
| vicat softening temp. | ASTM D1525 | ± 89˚C |

**Features**:

* Dissolves in D'limonene
* High impact-resistance
* Can be glued easily
* For matt, detailed, complex or large prints
* Light and durable

Virtually no "warping

**Additional info:**

Recommended temperature for heated bed is ± 65-110˚C.

The speed with which HIPS dissolves in D'limonene is depending on the volume and improves by movement..

HIPS can be used on all common desktop FDM or FFF technology 3D printers.

Storage: Cool and dry (15-25˚C) and away from UV light. This enhances the shelf life significantly