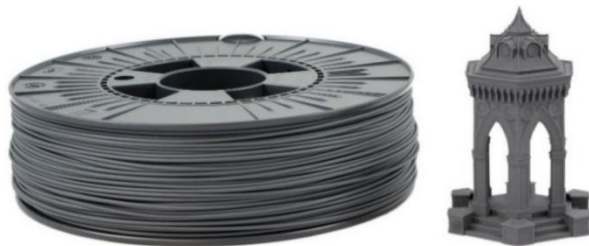


HIPS (COD.: HIPS)

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 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 colors result in a smooth matt surface of the 3D printed objects. High Impact Polystyrene is therefore widely used in model building.

Features:

- Dissolves in limonene;
- High impact-resistance;
- Can be glued easily;
- For matt, detailed, complex or large prints;
- Light and durable;
- Virtually no "warping".



Colours:

- K03003** Iron Grey
- K03004** Black
- K03005** Natural White

Additional info:

Recommended temperature for heated bed is $\pm 65-110^{\circ}\text{C}$.

The speed with which HIPS dissolves in 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 ($15-25^{\circ}\text{C}$) and away from UV light. This enhances the shelf life significantly.

Dimensions

Size	Ø Tolerance	Roundness
1,75mm	$\pm 0,05\text{mm}$	$\geq 95\%$

Physical Properties

Description	Test Method	Typical Value
Specific Gravity	ISO 1183	1,04 g/cc
MFR 200°C/5kg	ISO 1133	3,4 cm ³ /10 min.
Tensile Stress	ISO 527	22 Mpa
Elongation at Break	ASTM D638	50%
Tensile Modulus	ISO 527	1550 Mpa
Impact Strength Izod Method 23°C	ISO 179	15 KJ/m ²

Thermal Properties

Description	Test Method	Typical Value
Printing Temperature	-	220-270°C
Melting Temperature	ISO 294	220°C \pm 40°C
Vicat Softening Temp.	ASTM D1525	$\pm 89^{\circ}\text{C}$

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