



ENGLISH

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

	Ø tolerance	s
1,75mm	± 0,05mm	≥ 95%
	± 0,10mm	

Physical properties

n	Testmethod	Typical value
Specific gravity	ISO 1183	1,04 g/cc
	ISO 1133) min
Tensile strength	ISO 527	22 MPa
Elong at break (MD)		50%
Tensile modulus (1mm/min)	ISO 527	1550 Mpa
Impact Strength	ISO 179	15 KJ/m ²

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

Thermal properties

n	Testmethod	Typical value
printing temp.	-	220-270°C
	ISO 294)°C
vicat softening temp.	ASTM D1525	± 89°C