

HIPS · Technical Data Sheet

General Features

Chemical Name High Impact Polystyrene	Benefits <ul style="list-style-type: none"> • High-resolution smooth surfaces • Great interlayer adhesion • Resistance to shattering 	Main Applications Dissolvable support material for ABS, mate finishing parts, d lemonelo soluble supports, aircraft models.
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Filament Characteristics

Diameter	Ø 1.75mm	Ø 2.85mm
Meters per spool	294.163m	110.911m
Weight per meter	2.55g	6.76g
Tolerance	±0.02mm	±0.03mm

Material Properties

		Typical value	ASTM Method
Tensile Strength at Yield	MPa (psi)	2.500 (17)	D 638
Tensile Strength	MPa (psi)	195.000 (1350)	D 638
Tensile Elongation	%	3.31	D 638
Izod Impact Strength Notched	ft-lb/in (J/m)	1.7 (95)	D 256
Elongation	%	>50%	-
Melt Flow Index	g/10min	3	D 1238
Heat Distortion	°C	89	D 648
Density	g/cm ³	1.06	D 792
Vicat Softening Temperature	°C	90	D 1525
Water Absorption	%	0.03/0.07	D 570

Recommended printer settings

Print temperature	235±5°C
Print bed temperature	95° First/100° Later
Cooling fans	Off
Closed environment	Required
Adhesive	Required

Available Colours

Colour	Pantone Code
Black	6C
Blue	2935 C
Red	485 C
White	11-4001

WARNING!

This product can expose you to chemicals including styrene, which is known to the State of California to cause cancer. For more information, go to www.P65Warnings.ca.gov

Disclaimer:

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