

# 3DP HIPS

HIPS is an easy-to-print, High Impact Polystyrene filament with multifunctional properties. HIPS is an excellent support material in combination with ABS, as it dissolves in D’limonene and ABS remains unaffected. HIPS is very suitable for detailed prints, as well as large objects, because the material shows very limited warping. HIPS is also light and durable, has good interlayer bonding, can be glued easily, and the colors result in a smooth matte surface.

## Features:

- Dissolves in D’limonene
- High Impact Resistance
- Works on Glue Applications
- For Matte, Detailed, Complex, and Large Prints
- Light and Durable
- Virtually No Warping

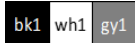
## Normal Stock:

- 2.85 dia (+/- 0.10mm)
- Roundness ≥ 95%
- 2.2 kg (5 lb.) spools

Contact 3DP for other spool sizes and diameter filaments: Diameters available - 1.75mm, 4.5mm, 6mm



Colors normally in stock:



Check stock on these colors prior to order:



Material Properties		
Description	Test Method	Typical Value
Specific Gravity	ISO 1183	1.04 g/cc
MFR 200°C/5 kg	ISO 1133	3.4 gr/10 min
Tensile Strength at Break	ISO 527	22 mpa
Strain at Break	ISO 527	50%
Tensile Modulus	ISO 527	1550 mpa
Impact Strength - Charpy Notched 23°C	ISO 179	15 kJ/m <sup>2</sup>
Printing Temp. Range	DF	220 - 260°C
Melting Temp.	ISO 11357	180°C
Vicat Softening Temp.	ASTM D1525	89°C

3DP WorkSeries Machine Settings	
Description	Setting
Volcano Extruder Default Print Speed	80 mm/s
HFA Extruder Default Print Speed	100 mm/s
Unspecified Machine Default Print Speed	60 mm/s
Extruder Temp. (Starting Point)	250°C
Heated build Platform Temp.	115°C
Bed Prep.	Hairspray Blue Tape
Extrusion Multiplier/Flow Rate	100%
Fan Speed	0%
Active Cooling (Fan)	N
Retraction Distance	1.10 mm

## Additional info:

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 FFF technology 3D printers.

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