

## TECHNICAL DATA SHEET FOR PRODUCT: HiPS FILAMENT

|                             |  |            |                              |
|-----------------------------|--|------------|------------------------------|
| <b>Use</b>                  | is a material for the FDM (FFF) 3D printing additive technology                              |            |                              |
| <b>Material</b>             | High impact polystyrene, petroleum product   |            |                              |
| <b>Diameters</b>            | 1,75 or 2,90 mm  |            |                              |
| <b>Tolerance</b>            | ± 0,05 mm  |            |                              |
|                             | 1,0 kg netto ± 5% / 1,3 kg brutto ± 5%   |            |                              |
| <b>Packing</b>              | spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil                            |            |                              |
| <b>Colours</b>              | views on web <a href="https://www.filament-pm.com/hips">https://www.filament-pm.com/hips</a> |            |                              |
| <b>Solvents</b>             | Acetone, limonenous  |            |                              |
| <b>Printing Properties:</b> |  |            |                              |
| <b>Temperature HE</b>       | 220 – 250 °C   |            |                              |
| <b>Temperature HB</b>       | 100 °C   |            |                              |
| <b>Surface bed</b>          | kapton, ultem, PET foil, commons for FDM printing  |            |                              |
| <b>Cooling print object</b> | NO   |            |                              |
| <b>Nozzle</b>               | All diameters  |            |                              |
| <b>Printer space</b>        | Open / Close   |            |                              |
| <b>Material Properties:</b> |  |            |                              |
| <b>Thermal</b>              | vicat softening temperature  | ISO 306    | <b>94 °C</b>                 |
|                             | heat deflection temperature  | ISO 75     | <b>89 °C</b>                 |
| <b>Mechanical</b>           | impact strength  | ISO 179    | <b>7 kJ/m<sup>2</sup></b>    |
|                             | flexural modulus   | ISO 178    | <b>1800 MPa</b>              |
| <b>Physical</b>             | Density  | ISO 1183/B | <b>1,04 g/cm<sup>3</sup></b> |
|                             | Melt Flow Index  | ISO 1133   | <b>7 g/10 min</b>            |