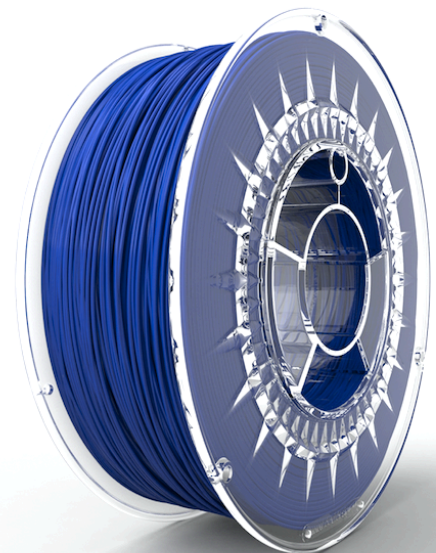


Product card: HIPS filament for 3D printing.

**Product description:** Filament HIPS - thermoplastic plastic in the form of fiber, used for 3D printing using the FFF method. Filament wound on a spool, vacuum packed with a moisture absorber. The reel contains 1 kg of net material. It can be used in all FFF printers that are not protected from external suppliers and open source structures before using. The HIPS filament can be used as a main or support material, among others for ABS material in double head printers. HIPS is easily machined such as grinding, drilling or smoothing, the material is soluble in D-limonene.

Physical properties of the product:

Diameter of filament	1.75 mm / 2.85 mm
Dimensional tolerance of filament	+/- 0.05 mm
Roundness of filament	+/- 0.02 mm
Surface of the material	Satin
Shrinkage of the material	Large
Product weight	1.0 kg net, 1.36 kg gross
Spool - material	Transparent polycarbonate
Weight of the empty spool	~250 g
The diameter of the spool	200 mm
Width of spool	~70 mm
Diameter of mounting hole	52 mm
Packaging	Printed cardboard
Package size	~205x205x80 mm
Vacuum packing	Yes
Moisture absorber	Yes



Suggested printing parameters:

Hotend	230-240°C
Heated bed	90-100°C
Cooling the printout	Not recommended

*Due to the structural differences of printers, the above figures should be considered as guidelines and the corresponding values must be determined experimentally.*

## Physical properties of the material:

Density	1.05 g/cm <sup>3</sup>	ISO 1183
Vicat Softening Temperature	96°C	ISO 306/A120
Flammability	HB	UL 94
Rockwell Hardness (R-Scale)	55	ISO 2039-2
Ball Indentation Hardness	70.0 MPa	ISO 2039-1
Tensile Strain - Yield	1.5%	ISO 527-2/5
Tensile Strain - Break	50%	ISO 527-2/5

## Availability of colors and diameters:

Color	Kolor	1.75
Natural	Naturalny	✓
Black	Czarny	✓