HiPS natur + color masterbatch

- Temperature print: 220-250 °C for 2,90 mm filament / 200–230 °C for 1,75 mm filament
- Temperature pad: about 70-120 °C

PLASTY MLADEČ
Zemědělské družstvo Haňovice

Material data sheet for HiPS natur:

Physical	Nominal Value	(English)	Nominal Value	(SI)	Test Method
Density	1.05	g/cm³	1.05	g/cm³	ISO 1183
Apparent Density	0.60	g/cm³	0.60	g/cm³	ISO 60
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	12	g/10 min	12	g/10 min	ISO 1133
Mechanical	**Nominal Value**	**(English)**	**Nominal Value**	**(SI)**	**Test Method**
Tensile Stress					ISO 527-2/5
Yield	2320	psi	16.0	MPa	
Break	2320	psi	16.0	MPa	
Tensile Strain					ISO 527-2/5
Yield	1.5	%	1.5	%	
Break	50	%	50	%	
Flexural Modulus	290000	psi	2000	MPa	ISO 178
Flexural Strength	7250	psi	50.0	MPa	ISO 178
Impact	**Nominal Value**	**(English)**	**Nominal Value**	**(SI)**	**Test Method**
Charpy Notched Impact Strength					ISO 179/2
Compression Molded	3.3	ft·lb/in²	7.0	kJ/m²	
Notched Izod Impact					
Compression Molded	1.69	ft·lb/in	90.0	J/m	ASTM D256
Injection Molded	1.31	ft·lb/in	70.0	J/m	ASTM D256
--	13.4	ft·lb/in²	28.1	kJ/m²	ISO 180
Hardness	**Nominal Value**	**(English)**	**Nominal Value**	**(SI)**	**Test Method**
Rockwell Hardness (R-Scale)	55		55		ISO 2039-2
Ball Indentation Hardness	10200	psi	70.0	MPa	ISO 2039-1
Thermal	**Nominal Value**	**(English)**	**Nominal Value**	**(SI)**	**Test Method**
Heat Deflection Temperature					
66 psi (0.45 MPa), Annealed	190	°F	88.0	°C	ISO 75-2/B
264 psi (1.8 MPa), Unannealed	163	°F	73.0	°C	ISO 75-2/A
264 psi (1.8 MPa), Annealed	183	°F	84.0	°C	ISO 75-2/A
Vicat Softening Temperature					
--	205	°F	96.0	°C	ISO 306/A120
--	189	°F	87.0	°C	ISO 306/B50