

HIPS220

High Impact Polystyrene (HIPS) is a co-polymer blend of butadiene to polystyrene. It is easy to process, has high dimensional stability and relatively high impact strength. HIPS is dissolvable in limonene making it one of the best sacrificial support materials for FDM 3D printing.

HIPS Filament

PRINTING PARAMETERS

Printer Type:	Cartesian / Delta
Extruder Type:	Direct Drive/Bowden Tube
Layer Height:	0.1 mm - 0.3mm
Fill Density:	0 - 100%
Shell Thickness:	>0.6 mm
Print Speed:	30 - 80 mm/s
Printing Temperature:	190 - 210°C
Build Bed Temperature:	50 - 80°C
Retraction Speed:	30 - 50 mm/s
Retraction Distance:	3 - 10 mm
Cooling Fan:	Yes

HIPS Filament

MATERIAL DATA SHEET

Diameter:	1.75 mm
Diameter Tolerance:	±0.03 mm
Specific Gravity:	1.04 g/cm ³
Tensile Strength:	4.9 Mpa
Impact Strength:	11 KJ/m ²
Surface Finish:	Matte
Transparency	Opaque
Processability	High

The data represented is intended as a general guide and results may differ