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, 1.4 kg gross
Spool - material	Transparent policarbonate
Weight of the empty spool	~257 g
The diameter of the spool	200 mm
Width of spool	~70 mm
Diameter of mounting hole	52 mm
Packaging	Printed cardboard
Package size	~230x210x80 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/cm3	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	2.85
Natural	Naturalny	✓	✓
Bright Yellow	Jasnożółty	✓	
Red	Czerwony	✓	
Super Blue	Niebieski	✓	
Bright Green	Jasnozielony	✓	
Black	Czarny	✓	