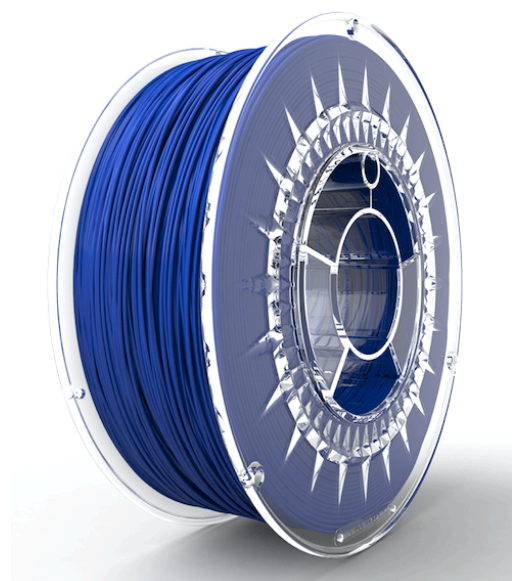**Product card:** HIPS filament for 3D printing.

**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 | ✓ | |

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