

# HIPS

## Technical Data Sheet

Description	HIPS, or High Impact Polystyrene, is a dis-solvable support material that is commonly used with ABS. When used as a support material, HIPS can be dissolved in limonene, leaving your print free of any markings caused by support removal.
Key Features	1)Dissolves in limonene at normal temperature,leaving the ABS printed parts untouched. 2)For complex models with hollow structures or high inclination angles.
Applications	Prototypes,fabrication of home appliances, toys,& product packaging.

### 1. Identification

Trade name	HIPS
Chemical name	High Impact Polystyrene
Chemical family	Polystyrene
Use	Monofilament for 3D printing

### 2. Filament Processing Parameters

Nozzle Temperature	220 ± 40°C
Bed Temperature	~ 80 - 100 °C

### 3. Material Properties - Tensile Test

Test Method: ASTM D 792

<b>Test Parameters</b>	<b>Results</b>
Tensile Strength (MPa)	≥ 25
Elongation at Break (%)	65.29
Flexural Strength (MPa)	32.94
Flexural Modulus (MPa)	2279.9
Izod Impact Strength(KJ/m <sup>2</sup> )	10.89
Density (g/cm <sup>3</sup> )	1.02-1.06
Distortion temperature(°C)	≥ 90