

## TECHNICAL DATE SHEET

HIPS

BASE MATERIAL: Shock-resistant polystyrene

### PROPERTIES

PROPERTIES	VALUE	METOD AND CONDICTION	
PHYSICAL & MECHANICAL	Density	1,04 g/cm <sup>3</sup>	ISO 1183
	IZOD Impact Strength, 3.2mm	125 J/m	ISO 180/4A
	Tensile strength	24 Mpa	ISO 527
	Flexure Modulus	1750 Mpa	ISO 527
	Flexure Strength	38 Mpa	ISO 527
	Heat Deflection Temperature	85 °C	ASTM D648
	Vicat	99° C	ISO 306/A
	Comportamento al fuoco	HB	UL94

### SUGGESTED PRINTER SETTING

	VALUE	UNIT
Extruder Temperature	210 - 230	°C
Print Speed	40 - 60	mm/s
Bed Material	70 - 90	°C
Drying Temperature	60 - 70 ° C for 2-4 hr	

### PRODUCT DETAILS & CERTIFICATION

Diameter	1,75 mm 2,85 mm	Tollerance ± 0,05mm Tollerance ± 0,10mm

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