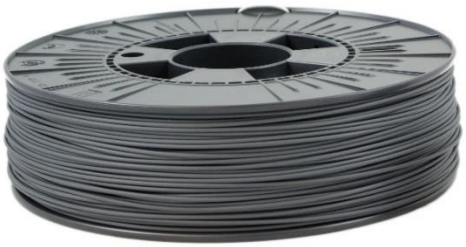
# HIPS @df

HIPS @df is an easy to print, High Impact Polystyrene filament with multifunctional properties. HIPS @df is an excellent support material in combination with ABS, because it dissolves in D'limonene @df and ABS remains unaffected.
HIPS @df is very suitable for detailed prints, but also for large objects because the material shows very limited warping. Furthermore HIPS @df is very light and durable, has good interlayer bonding, can be glued easily and the colours result in a smooth matt surface of the 3D printed objects. High Impact Polystyrene is therefore widely used in model building.

## Features:

- Dissolves in D'limonene
- High impact-resistance
- Can be glued easily
- For matt, detailed, complex or large prints
- Light and durable
- Virtually no "warping"



## Colours:

HIPS @df is available from stock in five matt colours.. Other colours on request

| | | | | | |
|---|---|---|---|---|---|
| na1 | bk1 | wh1 | rd1 | gy1 | bu2 |

## Packaging:

HIPS @df is available in nearly any type of packaging and labelling. Ask our team to help you customizing your product.

| Filament specs. | | |
|---|---|---|
| Size | Ø tolerance | Roundness |
| 1,75mm | ± 0,05mm | ≥ 95% |
| 2,85mm | ± 0,10mm | ≥ 95% |

| Material properties | | |
|---|---|---|
| Description | Testmethod | Typical value |
| Specific gravity | ISO 1183 | 1,04 g/cc |
| MFR 200°C/5 kg | ISO 1133 | 3,4 $cm^3$/10 min |
| Tensile strength at break | ISO 527 | 22 Mpa |
| strain at break | ISO 527 | 50% |
| Tensile modulus | ISO 527 | 1550 Mpa |
| Impact strength - Charpy notched 23˚C | ISO 179 | 15 $kJ/m^2$ |
| Printing temp. | DF | 220-260°C |
| Melting temp. | ISO 11357 | 180°C |
| Vicat softening temp. | ASTM D1525 | 89°C |

## Additional info:

Recommended temperature for heated bed is ± 65-110˚C.
The speed with which HIPS @df dissolves in D'limonene @df is depending on the volume and improves by movement..
HIPS @df can be used on all common desktop FDM or FFF technology 3D printers.
Storage: Cool and dry (15-25˚C) and away from UV light. This enhances the shelf life significantly