TECHNICAL DATA SHEET HIPS-20

HIPS-20 - used as both support material and material suitable for 3D printing. Printed elements made of this filament can be subjected to post-processing, such as gluing, polishing or painting. Safe material, commonly used for the production of packaging, suitable for contact with food.

HARDNESS	
ELASTICITY	$\bullet \bullet \bullet \circ \circ \circ$
IMPACT STRENGTH	$\bullet \bullet \circ \circ \circ \circ$
TENSILE STRENGTH	$\bullet \bullet \circ \circ \circ \circ$

PHYSICAL PROPERTIES

	VALUE	UNIT	TEST METHOD
Density	1,04	g/cm^3	ISO 1183
Water Absorption	>0,1	%	ISO 62



MECHANICAL PROPERTIES

	VALUE	UNIT	TEST METHOD
Tensile strength	28	MPa	ISO 527-2
Tensile elongation	55	%	ISO 527-2
Charpy impact strength	8	kJ/m^2	ISO 179/1eA
Rockwell hardness	77	-	ISO 2039-2

THERMAL PROPERTIES

	VALUE	UNIT	TEST METHOD
Heat Deflection Temperature 1,8 MPa	94	°C	ISO 75-2A
VICAT Softening Temperature	95	°C	ISO 306B50
Surface resistivity	>10^13	Ω	ISO IEC 93

RECOMMENDED PRINTING PARAMETERS



Nozzle temperature >225°C {<u>}</u>

Bed temperature 80-100°C



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