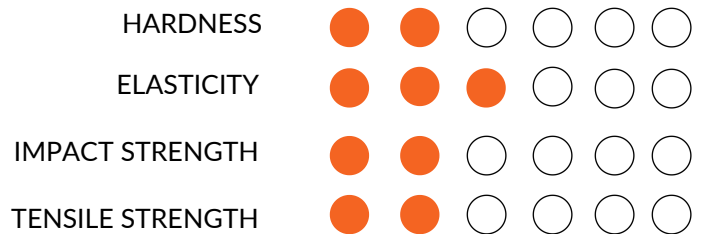


# TECHNICAL DATA SHEET

# 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.



## PHYSICAL PROPERTIES

	VALUE	UNIT	TEST METHOD
Density	1,04	g/cm <sup>3</sup>	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 <sup>2</sup>	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 <sup>13</sup>	Ω	ISO IEC 93

## RECOMMENDED PRINTING PARAMETERS



Nozzle temperature  
>225°C



Bed temperature  
80-100°C

