

# tonerplastics

## HIPS 3D Filament Data Sheet

### High Impact Polystyrene (HIPS)

HIPS is a dissolvable thermoplastic which is ideal for printing supports with ABS parts. HIPS is easily dissolved in limonene and prints at similar settings to ABS. It is less prone to warping than ABS making it perfect for brims and rafts on small and large parts alike.

Mechanical Properties		Test Method
Tensile Strength @ Break, PSI	4400	ASTM D638
Yield Strength, KSI	340	ASTM D638
Tensile Elongation, %	45.0	ASTM D638
Notched Izod Impact, ft-lb/in	2	ASTM D256
Size Specifications		
Nominal Outer Diameter, mm	1.75/2.88	-
OD Tolerance, mm	±0.05	-
Ovality, mm	< 0.050	-

### Applications

- Dissolvable supports
- General purpose FFF 3D printing
- Impact resistant parts

### Recommended Printer Settings

- Extruder Temperature: 220-235 °C
- Printing Speed: 50-90 mm/s
- Bed Temperature: 80-100 °C
- Bed Adhesion: Hair Spray or ABS Glue

### Additional Information

- Standard Sizes Available: 1.75/2.88mm
- Custom packaging methods available upon request
- Spool Weight: 1kg., 1lb., 5lb., and 10lb
- All filaments are sealed with desiccants

### Regulatory Compliance

- RoHS
- REACH

#### Disclaimer:

The above information is provided in good faith. It is solely the customer's responsibility to determine if the product and information in this document are appropriate for the customer's end use. Customers are always advised to consult their 3D printer manufacturer before using Toner Plastic's filaments.