

## MakerPoint HIPS

MakerPoint HIPS is an easy to print, High Impact Polystyrene filament with multifunctional properties. HIPS can be used as support material in combination with ABS, because it dissolves in D'limonene and the ABS remains unaffected. MakerPoint HIPS is very suitable for detailed prints and for large objects, because the material shows very limited warping. HIPS is very light and durable, has good interlayer bonding, can be glued easily and the colors 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"

### Dimensions

Size	Ø tolerance	Roundness
1,75mm	± 0,05mm	≥ 95%
2,85mm	± 0,10mm	≥ 95%

### Colors

MakerPoint HIPS is available from stock in five matt colors, White, Red, Black, Gray and Blue. Special colors are available upon request with a minimum order quantity of 20kg.

### 3D-printing

Description	Typical value
Printing technology	FFF
Printing temp.	220-270°C
Heated bed temp.	± 65-110°C
Cooling fan	100%
Flow Rate	100%

### Physical properties

Description	Test method	Typical value
Density	ISO 1183	1,04 g/cc
MFR	ISO 1183	3,4 cm <sup>3</sup> /10 min
Tensile strength	ISO 527	22 MPa
Elongation at break	-	50 %
Tensile modulus	ISO 527	1550 MPa
Impact Strength	ISO 179	15 KJ/m <sup>2</sup>

### Thermal properties

Last change: 2014-03-31

The data correspond to our knowledge and experience at the time of publication. They do not on their own represent a sufficient basis for any part design, neither do they provide any agreement about or guarantee the specific properties of a product or part or the suitability of a product or part for a specific application. It is the responsibility of the producer or customer of a part to check its properties as well as its suitability for a particular purpose. This also applies regarding the consideration of possible intellectual property rights as well as laws and regulations. The data are subject to change without notice as part of MakerPoints continuous development and improvement processes.

Description	Test method	Typical value
Melting temp.	ISO 294	220°C ± 40°C
Vicat softening temp.	ISO 306	± 89°C

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