

HIPS

TECHNICAL DATA SHEET

FILSHAPER HIPS

Support filament in VSHAPER offer. It is sold in natural color. HIPS filament is mainly used as support material. We recommend using HIPS in combination with styren materials such as ABS and ASA.

DELIVERY OF FILSHAPER HIPS

HIPS filament has the nominal diameter of 1,75mm and is fit for FDM/FFF printing. It's supplied in 1kg spool. The spools are packed in vacuumed plastic bags to prevent hygroscopicity.

STORAGE

Store the filament in airtight packaging in dry place. The filament is usable up to 6 months after opening.

DRYING RECOMMENDATIONS

It is recommended to dry the filament before every usage to avoid stringing, bubbling or other defects: 4h in 80°C

Mechanical properties	Value	Unit	Test Standard
Tensile Modulus	-	MPa	-
Tensile Strenght	28	MPa	ISO 527
Yield stress	-	MPa	-
Yield strain	-	%	-
Stress at break	-	MPa	-
Nominal strain at break	55	%	ISO 527
Flexural modulus	-	MPa	-
Flexural strength	-	MPa	-
Charpy impact strength, +23°C	-	kJ/m ²	-
Charpy impact strength, -30°C	-	kJ/m ²	-
Izod notched impact strength, +23°C	8	kJ/m ²	ISO 179
Izod notched impact strength, -30°C	-	kJ/m ²	-
Hardness (R-Scale)	77	-	ISO 2039

Thermal properties	Value	Unit	Test Standard
Melting temperature	-	°C	-
Glass transition temperature	-	°C	-

Temp. of deflection under load A, 1 .80 MPa (HDT)	94	°C	ISO 75
Temp. of deflection under load B, 0 .45 MPa (HDT)	-	°C	-

Physical properties	Value	Unit	Test Standard
Density	1,04	g/cm ³	ISO 1183
Filament Diameter	1.75	mm	-
Linear Shrinkage	0,4-0,7	%	-

Burning behavior	Value	Unit	Test Standard
Flammability class	HB	class	UL94

Rheological properties	Value	Unit	Test Standard
Melt mass-flow rate, MFR	-	g/10 min	-
Temperature	-	°C	-
Load	-	kg	-

Characteristics	
Key Feature, Industrial Sector	-
Key Feature, Processing	3D printing
Key Feature, Solvent	D-limonene
Key Feature, Electrical	Insulator
Example applications	Support
Processing	FFF/FDM
Special Characteristics	-
Color	Natural
Delivery form	Monofilament

Printing settings	VSHAPER 270			VSHAPER 500		
	STD	PRO	MED	STD	PRO	MED
Print temperature	-	240°C	240°C	265°C	265°C	265°C
Bed temperature	-	95°C	95°C	95°C	95°C	95°C
Chamber temperature	-	-	-	60°C	60°C	60°C
Adhesive plate material	-	V-SURFACE LT	V-SURFACE LT	V-SURFACE LT	V-SURFACE LT	V-SURFACE LT
Adhesive glue	-	Dimafix	Dimafix	Dimafix	Dimafix	Dimafix
Model shrinkage	-	~0,8%	~0,8%	~0,8%	~0,8%	~0,8%

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