

Technical Data Sheet

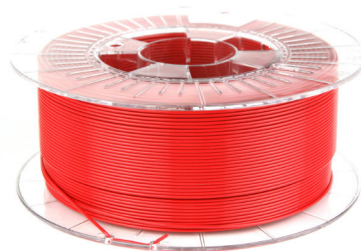
HIPS-X Filament

The material offered by Spectrum Group Sp. z o.o. has been developed and adapted to general modeling. Tests performed by Spectrum Group have showed that it is feasible to use the offered product in most 3D printers operating in FDM/FFF technology available on the market. Before the first use, it is advisable to print out a hard proof to check if the filament is compatible with your 3D printer.

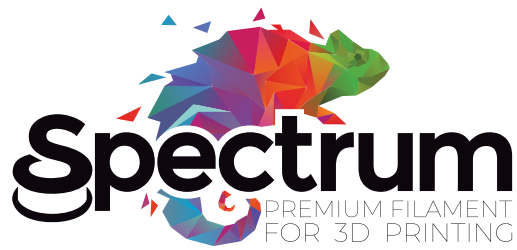
Physical properties	Typical value	Test Method
Material density	1.05 g/cm ³	ISO 1183
Melt Flow Rate (200°C, 5.0kg)	0.60	ISO 60
Dimensional tolerance	± 0.05mm	

Mechanical properties	Typical value	Test Method
Tensile Strength	16 Mpa	ISO 527-2/5
Tensile Elongation	6%	ISO 527-2/5
Flexural Modulus	2000 Mpa	ISO 178
Flexural Strength	50 Mpa	ISO 178
Notched Izod Impact	Compression Molded 90 J/m	ASTM D256

Thermal properties	Typical value	Test Method
Heat Distortion Temperature (annealed)	0.45 Mpa	88°C
	1.8 Mpa	84°C
Vicat Softening Temperature		96°C
		87°C



Technical data is provided according to the data of the base material and it is for information only.



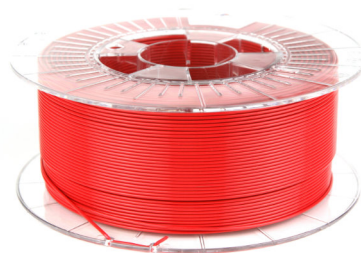
Technical Data Sheet

HIPS-X Filament

Electrical properties	Typical value	Test Method
Dielectric Constant (1 MHz)	2.50	ASTM D150
Dissipation Factor (1 MHz)	0.00040	ASTM D150

Flammability	Typical value	Test Method
Flame Rating UL (1.60mm)	HB	UL 94

Printing properties	Typical value	Test Method
Printing temperature	230-245°C	
Bed temperature	100°C	



Technical data is provided according to the data of the base material and it is for information only.

Spectrum Group Sp. z o.o.
Parkowa 85, 05-806 Pecice
Poland

office@spectrumfilaments.com
www.spectrumfilaments.com
+48 608 109 008

