



HIPS Support Filament

1.75 mm · 1 kg spool

OzFDM HIPS 1.75mm 1KG is a plastic filament made from HIPS 1180 and designed to offer support for ABS and ASA prints. It is completely soluble in limonene, making it an ideal support material.

✓ Support material for ABS & ASA

✓ Fully soluble in limonene

✓ HIPS 1180 base

RECOMMENDED PRINT SETTINGS

Nozzle temperature	220 – 240 °C (230 °C recommended)
Bed temperature	80 – 110 °C (100 °C recommended)
Print speed	40 – 60 mm/s (50 mm/s recommended)
Support material	HIPS
Drying	80 °C for ≥ 5 h

FILAMENT SPECIFICATIONS

Diameter	1.75 mm
Dimensional tolerance	± 0.05 mm
Net weight	1 kg
Density	1.04 – 1.06 g/cm ³

SPOOL & PACKAGING

Empty spool weight	150 g
Full spool weight	1.15 kg
Spool outer diameter	200 mm
Spool hub diameter	52 mm
Spool width	65 mm
Shipping weight	1.3 kg
Box dimensions	210 × 210 × 75 mm

AVAILABLE COLOURS (2)



Natural



Black

MECHANICAL PROPERTIES

Tensile Strength ISO 527	28.5 – 29.5 MPa
Elongation at Break ISO 527	6 – 6.5 %
Flexural Modulus ISO 527	1500 – 1650 MPa
Flexural Strength ISO 178	46.5 – 49 MPa
Impact Strength ISO 180	7 – 8 kJ/m ²

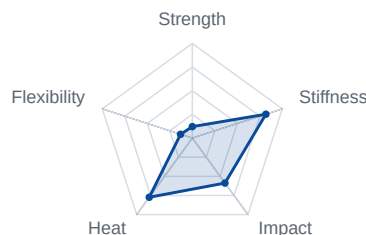
THERMAL & PHYSICAL PROPERTIES

Heat deflection (0.455 MPa) ISO 75	88 °C
Melt flow rate (250 °C/2.16 kg) ISO 1133	6 – 9 g/10 min
Moisture absorption (23 °C/24 h) ISO 62	1 %

STORAGE & HANDLING

Airtight bag or container with desiccant in a cool, dark, dry place. For long-term storage, dry the filament before vacuum-sealing it with desiccant.

PROPERTY PROFILE



Relative to the OzFDM filament range