

DISSOLVABLE SUPPORT MATERIAL

HIPS Support Filament

1.75 mm · 1 kg spool · ±0.05 mm tolerance

High impact polystyrene designed as a support material for ABS and ASA. Supports dissolve in d-limonene, leaving clean surfaces without manual removal.

- ✓ Dissolves in d-limonene
- ✓ Pairs with ABS and ASA
- ✓ Similar print settings to ABS
- ✓ Easy to sand and paint

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	Use as support for ABS or ASA (dissolves in d-limonene)

- ⓘ Print alongside ABS or ASA in an enclosed printer, then dissolve supports in d-limonene.

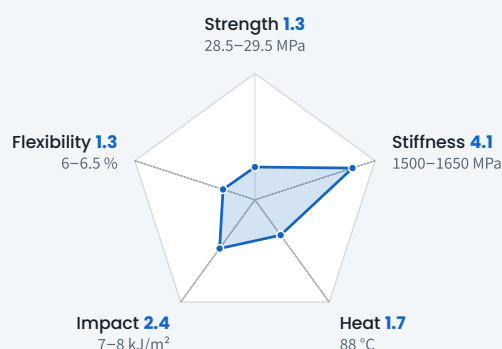
Filament Specifications

Material	High impact polystyrene (HIPS)
Diameter	1.75 mm
Diameter tolerance	±0.05 mm
Net filament weight	1 kg

Spool & Packaging

Empty spool weight	150 g
Spool with filament	1.15 kg
Spool outer diameter	200 mm
Hub diameter	52 mm
Spool width	65 mm
Shipping weight	1.3 kg
Box dimensions	210 × 220 × 75 mm

Property Profile



Scores from 1 to 5 relative to the OzFDM filament range, based on the typical values in this sheet (stiffness and impact on a log scale).

Storage & Handling

Drying

80 °C for a minimum of 5 hours in a filament dryer or food dehydrator.

Storage

Airtight bag or container with desiccant in a cool, dark and dry area to prevent moisture absorption. For optimal long term storage we recommend drying the filament prior to sealing the filament spool in a vacuum bag with desiccant.

Mechanical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Tensile strength	ISO 527	28.5–29.5 MPa
Elongation at break	ISO 527	6–6.5 %
Tensile modulus	ISO 527	1500–1650 MPa
Flexural strength	ISO 178	46.5–49 MPa
Impact strength	ISO 180	7–8 kJ/m²

Physical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Density	ISO 1183	1.04–1.06 g/cm³
Melt flow rate (220 °C, 5 kg)	ISO 1133	6–9 g/10min
Moisture absorption (23 °C, 24 h)	ISO 62	1 %

Thermal Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Heat deflection temperature (0.455 MPa)	ISO 75	88 °C

Available Colours 2



Natural



Black

Swatches are indicative only. Colours vary between screens and with print settings.

NOTES

Values shown are typical results measured on test specimens and are provided for guidance only. They are not guaranteed specifications and should not be used as design limits. Printed part properties vary with printer, settings, print orientation and part geometry. Test your parts for suitability before use in critical applications.