



### 3D Printing Filament

## TECHNICAL DATA SHEET - Build Series HIPS

Commercial name: MatterHackers Build Series HIPS  
Raw material: HIPS  
Designation: 3D printing applications  
Manufacturer: MatterHackers

### Material Specifications

PROPERTY	VALUE
Density	1.05g/cm <sup>3</sup>
Heat Deflection Temperature	80C
Tensile Strength at Yield	27 MPa
Tensile Elongation at break	55%
Flexural Modulus	39 MPa
Flexural Strength	2280 MPa
Notched Izod Impact	11 J/M2

### Filament Specifications

PROPERTY	VALUE
Diameter 1.75mm	1.75 ± 0.05 mm
Diameter 2.85mm	2.85 ± 0.05 mm
Suggested printing bed material	Glass/Glue, Perforated plate, Garolite
Suggested print temperature	220-260c
Suggested print speed	30 - 100mm/s
Suggested bed temperature	90-110c