

ICE FILAMENTS ICE-HIPS PRODUCT CARD

ICE Filaments ICE-hips is an easy to print, High Impact Polystyrene filament with multifunctional properties. ICE-hips is an excellent support material in combination with ABS, because it dissolves in D'limonene and ABS remains unaffected. ICE-hips is very suitable for detailed prints, but also for large objects because the material shows very limited warping. Furthermore, ICE-hips is very light and durable, has good interlayer bonding, can be glued easily and the colors result in a smooth matt surface of the 3D printed objects. High Impact Polystyrene is therefore widely used in model building.

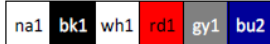
FEATURES:

- ∞ Dissolves in D'limonene
- ∞ High impact-resistance
- ∞ Can be glued easily
- ∞ For matt, detailed, complex or large prints
- ∞ Light and durable
- ∞ Virtually no "warping"



COLOURS:

ICE Filaments ICE-Flexiglass is available from stock in a variety of colors. Other colors on request.



FILAMENT SPECS		
Size	Ø tolerance	Roundness
1.75mm	± 0,05mm	≥ 95%
2.85mm	± 0,10mm	≥ 95%

MATERIAL PROPERTIES		
Description	Testmethod	Typical value
Specific Gravity	ISO 1183	1,04 g/cc
MFR 200°C/5 kg	ISO 1133	3,4cm³/10 min
Tensile strength at break	ISO 527	22 Mpa
Strain at break	ISO 527	50 %
Tensile Modulus	ISO 527	1550 Mpa
Impact Strength – Charpy notched 23°C	ISO 179	15 Kj/m²
Printing temperature	ICE FILAMENTS	220 – 260°C
Melting temperature	ISO 11357	180°C
Vicat softening temperature	ASTM D1525	89°C

ADDITIONAL INFO:

Recommended temperature for heated bed is ± 65 – 110°C.

The speed with which ICE-hips dissolves in D'limonene is depending on the volume and improves by movement.

ICE Filaments ICE-hips can be used on all common desktop FDM or FFF technology 3D printers.

Storage: cool and dry (15 – 25°C) and away from UV light. This enhances the shelf life significantly.