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HIPS filament

Printing Parameters		
Item	Results	Unit
Nozzle Temp	210-260	°C
Ideal Temp	240°C	°C
Heated Bed Temp	80°C~110°C	°C
Print speed	30~45	mm/s
Materials Parameters		
Density	1.04	g/cm ³ ,
Melt Flow Index	5.5	g /10 min, 200°C/5kg
Heat Distortion Temp	88	°C
Tensile Strength	240	Kg/cm ²
Tensile Elongation	45	%
Flexural Strength	440	Kg/cm ²
Flexural Modulus	2260	MPa
Impact Strength	11	Kg-cm/cm
Diameter Accuracy	1.75mm: 1.70~1.78mm; 3.0mm: 2.90~3.0mm	