

# KODAK 3D Printing Filament

## HIPS (High Impact Polystyrene)

### Benefits:

- A filament with some of the best characteristics of PLA and ABS.
- High-resolution smooth surfaces.
- Great interlayer adhesion.
- Resistance to shattering, low warp.
- It can be used as a dissolvable support material for ABS (soluble with limonene, citric acid).

### Main applications:

High impact resistant and silky surface. Rigid limonene-soluble support material.

### Description:

HIPS is as easy to print as ABS, although much less likely to warp, which makes it another great alternative to classic PLA for models requiring higher impact resistance. It works as a great dissolvable support material because it is easily removed with a limonene solution. The material is a good electrical insulator, which can be sanded and painted with acrylic paints.

This polymer complies with section 201(s) of the US Federal, Drug, and Cosmetic Act, and Parts 182, 184 and 186 of the Food Additive Regulations.

### Recommended printer settings

Print temperature: 220-260°C  
Print bed temperature: 105°C.  
Fans: on.  
Closed environment: not required.

### Tolerance

Diameter	Diameter tolerance	Roundness accuracy	Moisture content
1.75 mm	+/- 0.02 mm	99%	< 0.02%
2.85 mm	+/- 0.03 mm		

### Physical properties

Description	Value	Test method
Density	1.04 g/cm <sup>3</sup>	ISO 1183/B
Melt Mass-Flow Rate (MFR) (200°C/5kg)	3 g/10 min	ASTM 1238