

# HIPS

*High Impact Polystyrene*

<b>Category:</b>	Breakaway
<b>When to use:</b>	Simple and complex geometries with overhangs; supported features must be easy to reach (hand or tool), to break the supports from the main part.

Print Settings	
<b>Extruder Temperature</b>	240°C
<b>Bed Temperature</b>	70°C
<b>Bed Preparation</b>	Use corresponding WolfBite adhesive that the primary build material calls for.
<b>Cooling Fan</b>	Yes
<b>Closed Chamber</b>	Yes
<b>Heated Chamber</b>	No
<b>Chamber Temperature</b>	-
<b>Notes</b>	

Material Management	
<b>Material Feeding Style</b>	<ul style="list-style-type: none"> <li>• Can be loaded on the spool holders within the printer.</li> <li>• No moisture-controlled box is necessary during printing.</li> </ul>
<b>Compatible Materials</b>	<ul style="list-style-type: none"> <li>• ABS</li> </ul>
<b>Support Removal Suggestions</b>	<ul style="list-style-type: none"> <li>• Separate support material with hands, picks, pliers, etc.</li> </ul>
<b>Storage</b>	<ul style="list-style-type: none"> <li>• Keep container dry. Keep in a cool place. Ground all equipment containing material. Keep container tightly closed. Keep in a cool, well-ventilated place. Combustible materials should be stored away from extreme heat and away from strong oxidizing agents.</li> </ul>

Slicer Settings	APEX
<b>Layer Height</b>	0.24
<b>Nozzle Diameter</b>	0.5 mm
<b>Loops</b>	0.6
<b>Skin</b>	1.2
<b>Infill (%)</b>	42 %
<b>Material Profile Name</b>	HIPS PC with HIPS ASA with HIPS