

TECHNICAL DATA SHEET

Date of issue: 12.12.2014 | Update: 03.01.2018 | Version: 2.00

Z-HIPS

Smooth and Stable

Z-HIPS is a versatile thermoplastic perfect for 3D printing prototypes which can be used in thorough tests before starting the production processes. It exhibits a high level of hardness, allowing you to complete durable prints without compromises on their quality. With Z-HIPS, your boldest models can acquire a unique, smooth, semimat surface and resemble elements manufactured with mass production plastics, therefore, imitate complete consumer products or end-use parts. Z-HIPS is also fully suited for creating prototypes of mechanical parts or casing elements for performance tests.



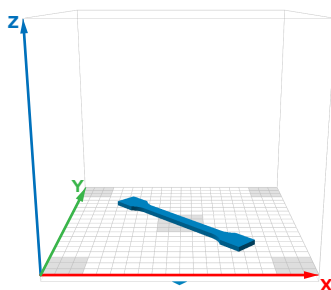
| Mechanical Properties | Metric | English | Test Method |
|----------------------------------|--|--|------------------|
| Tensile Strength | 16.90 MPa | 2450 psi | ISO 527:1998 |
| Breaking Stress | 13.02 MPa | 1890 psi | ISO 527:1998 |
| Elongation at max Tensile Stress | 1.87% | 1.87% | ISO 527:1998 |
| Elongation at Break | 7.75% | 7.75% | ISO 527:1998 |
| Bending Stress | 29.30 MPa | 4250 psi | ISO 178:2011 |
| Flexural Modulus | 1.18 GPa | 171 ksi | ISO 178:2011 |
| Izod Impact, Notched | 4.82 kJ/m ² | 2.29 ft-lb/in ² | ISO 180:2004 |
| Thermal Properties | Metric | English | Test Method |
| Glass Transition Temperature | 98.68° C | 210° F | ISO 11357-3:2014 |
| Other Properties | Metric | English | Test Method |
| Melt Flow Rate | 7.14 g/10 min Load 5 kg Temperature 200° C | 0.0157 lb/10 min Load 11 lb Temperature 392° F | ISO 1133:2006 |
| Specific Density | 1.136 g/cm ³ | 9.48 lb/gal | ISO 1183-3:2003 |
| Shore Hardness (D) | 73.2 | 73.2 | ISO 868:1998 |

| Compatible with | Layer Thickness Range | | Available Colors | | | | |
|-----------------|-----------------------|-----------|------------------|---------------|-------|--------|-----|
| ZORTRAX M200 | 0.14 mm | 0.0055 in | grey | natural white | black | yellow | red |
| ZORTRAX M300 | 0.19 mm | 0.0075 in | | | | | |
| | 0.29 mm | 0.0114 in | green | blue | | | |

The data presented in this document are intended for information and comparison purposes only. They should not be used for project specifications or its quality evaluation. The material's actual properties depend on the printing process conditions, the design structure and its purpose, test conditions, etc.

Samples of Z-HIPS used to carry out the tests were built on Zortrax M200. The general print parameters utilized are noted below:

- Z-SUITE: v2.2.0.0
- Layer thickness: 0.19 mm;
- Quality: High;
- Seam: Normal;
- Infill: Solid,
- Fan Speed: Auto;
- Surface Layers:
 - Top: 7 (default);
 - Bottom: 4 (default);



Product specifications are subject to change without notice.

Each user is responsible for complying with product safety standards, its intended use as well as the law and waste disposal (and recycling) rules for electrical and electronic equipment. Zortrax does not make any express or implied warranties, including but not limited to implied warranties of merchantability or fitness for a particular purpose.



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