

Technical Data Sheet



Product name: LimoSolve™

Version: v3

LimoSolve HIPS is a high-performance and easy to print High Impact PolyStyrene type of 3D printer filament which doesn't contain any added colorants and dissolves completely in Limonene. Being soluble in Limonene in combination with similar thermal properties to ABS make LimoSolve an outstanding supporting material for complex dual extrusion ABS prints.

When not being used as support material LimoSolve HIPS prints in an extremely bright white colour and has exactly the same characteristics as our EasyFil HIPS filament range.

Properties	Typical value	Test Method	Test condition
Physical			
Specific gravity	1.04 g/cc	ISO 1183	-
Melt flow rate	3.4 cm ³ /10min	ISO 1133	220° C/5Kg
Water absorption	<0,1%	ISO 62	Saturated at 23° C
Moisture absorption	<0.1%	ISO62	Equilibrium 23° C/50% RH
Mechanical			
Impact strength	15 KJ/m ²	ISO 179	Charpy Notched @23° C (73° F)
Tensile strength	22 Mpa	ISO 527	Stress @ Yield 23° C
Tensile modulus	1550 Mpa	ISO 527	-
Elongation at break	50% (MD)	-	-
Flexural strength	± 51.2 Mpa	-	-
Flexural modulus	± 2126 Mpa	-	-
Hardness	-	-	-
Thermal			
Print temperature	± 220 - 260° C	-	-
Melting temperature	± 180 - 260° C	ISO 294	-
Viscat softening temp.	± 89° C	ASTM D1525	B/2 (120° C/h, 50N)
Optical			
Haze	-	-	-
Transmittance	-	-	-
Gloss	-	-	-

Product details, certifications and compliance		Diameter	Tolerance	Roundness
HS Code	39169090	1.75mm	± 0.05mm	≥ 95%
REACH compliant	Yes	2.85mm	± 0.10mm	≥ 95%
RoHS certified	Yes			

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