

# Technical Data Sheet



**Product name:** LimoSolve™

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**Version:** v2

LimoSolve™ is a high-performance HIPS (High Impact PolyStyrene) type of 3D printer filament. LimoSolve™ doesn't contain any added colorants and dissolves completely in Limonene. This feature in combination with its similar thermal properties to ABS makes LimoSolve™ an outstanding supporting material for complex dual extrusion ABS prints.

Properties	Typical value	Test Method	Test condition
<b>Physical</b>			
Specific gravity	1.04 g/cc	ISO 1183	-
Melt flow rate	3.4 cm <sup>3</sup> /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
<b>Mechanical</b>			
Impact strength	15 KJ/m <sup>2</sup>	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	-	-	-
<b>Thermal</b>			
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)
<b>Optical</b>			
Haze	-	-	-
Transmittance	-	-	-
Gloss	-	-	-

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

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