

Public printing recommendation

Thorwell Standard HIPS HIPS Blue

MaterialID MAT0146



3DPiceland Labs
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WORKFLOW-RELIABILITY - Bug Fixes and Workflow
Reliability
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Guidance boundary: values below are shared base-material guidance resolved only through the canonical BaseMaterialId link. They are not manufacturer-, spool- or printer-specific validated settings. Missing fields remain Not recorded.

Overall
40/100

Engineering axes
6/5

Public rank
206 / 234

MSRP USD/kg
32.00

Engineering profile



Recommended applications

- Repeatable print jobs and production-style batches
- Cosmetic parts, concept models or low-load prototypes
- Avoid high tensile load applications

Measured strengths

- Consistency: 74/100. Repeatability is one of the stronger signals in this material profile.

Limitations

Engineering trade-offs

- Tensile: 14/100. Avoid using this as the primary choice for tensile-loaded parts.
 - Impact: 37/100. Avoid high impact or shock-loaded components without additional validation.
 - Layer adhesion: 11/100. Z-axis performance should be treated with caution.
- Good repeatability does not compensate for low tensile capability in load-bearing designs.
 - The report should be read as a suitability warning rather than a general-purpose recommendation.

Base-material printing guidance

Guidance	Minimum	Recommended	Maximum	Unit
Nozzle temperature	220	230	235	°C
Bed temperature	110	110	120	°C
Print speed	55	165	165	mm/s
Cooling	15	20	20	%

Guidance	Value	Unit
Cooling guidance	Low	
Drying temperature	75	°C
Drying time	6	hours
Enclosure	Required	
Printer / G-code reference	PrusaCoreOneL	
Slicer profile reference	Generic HIPS	

Print workflow checks

- Confirm nozzle temperature, bed temperature, speed, cooling and drying requirements from the manufacturer profile or spool label.
- Print a small validation part before committing to a long, costly or safety-relevant print.
- Orient the part so the governing load does not rely on an unverified or weak engineering axis.
- Layer-adhesion evidence is weak; avoid critical Z-axis loading without additional validation.

Decision guidance

- Use this material mainly for low-load, visual or experimental parts.
- Do not choose it as a tensile-strength benchmark material.

Stronger same-family alternatives

MaterialID	Material	Manufacturer	Overall	Tensile	Impact
Confirm exact settings against the manufacturer profile, spool label and actual printer/material combination. Results do not replace application-specific validation.					

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