SAFETY DATA SHEET

Rev 2.0 · Issue date 10-27-2026 · Supersedes Rev 1.0 (02-04-21)

HIPS 3D Printer Filament

High impact polystyrene (HIPS) · Product code CX06

1. Identification

Product identifier	HIPS 3D Printer Filament
Product code	CX06
Recommended use	3D printing (FFF/FDM) filament, thermoplastic
Restrictions on use	Not specified
Supplier	COEX LLC, 1228 Elizabeth St, Green Bay, WI 54302, USA
Telephone	(920) 757-1055
Emergency telephone	(920) 757-1055 (business hours)
Website	www.coex3d.com

2. Hazard identification

Classification	Not a hazardous substance or mixture. (GHS classification in accordance with the OSHA Hazard Communication Standard, 29 CFR 1910.1200.)
Label elements	GHS label elements: Not a hazardous substance or mixture.
Hazards not otherwise classified	No data available
Other information	Eye contact: Not Available. Skin contact: Not Available. Inhalation: Not Available. Ingestion: Not Available. Additional physical information: Not Available.

3. Composition / information on ingredients

Chemical name	CAS No.	Weight %
Styrene, polymers	9003-55-8	>= 94
White mineral oil (petroleum)	8042-47-5	<= 3

S2 3.1 Substance / Mixture: Not Applicable. The old COEX SDS listed only Styrene, 1,3-butadiene copolymer 9003-55-8 >= 94 %.

4. First-aid measures

Inhalation	Remove Person to fresh air and keep at rest in a position comfortable for breathing. If unconscious, place in recovery position and seek medical advice. If symptoms persist, call a physician.
Eye contact	Remove contact lenses. Rinse cautiously with water for several minutes. Protect unharmed eyes. If eye irritation persists, consult a specialist.
Skin contact	No data available
Ingestion	Keep respiratory tract clear. Do not give milk or alcoholic beverages. Do not induce vomiting. Never give anything by mouth to an unconscious person. If symptoms persist, call a physician.
Most important symptoms	None known. Ingestion: May cause gastrointestinal blockage.
Note to physicians	Treat symptomatically.

5. Fire-fighting measures

Suitable extinguishing media	Suitable: In case of fire: Use water spray for extinction. Use dry chemical powder for extinction. Use carbon dioxide for extinction. Use foam for extinction. Unsuitable: Pneumatic conveying and other mechanical handling operations can generate combustible dust. To reduce the potential for dust explosions, do not permit dust to accumulate. Dense smoke is produced when product burns.
Special hazards	Hazardous combustion products: No hazardous combustion products are known. Unusual fire and explosion hazards: Provide appropriate exhaust ventilation at places where dust is formed. Further information: Standard procedure for chemical fires. Use extinguishing measures that are appropriate to local circumstances and the surrounding environment.
Protective equipment	Wear self-contained breathing apparatus for firefighting if necessary.
Further information	Dispose of fire debris and contaminated extinguishing water in accordance with official regulations.

6. Accidental release measures

Personal precautions	Spilled filament or pieces may cause a slipping hazard. Ensure adequate ventilation.
Environmental precautions	Do not flush into surface water or sanitary sewer system. Keep out of waterways.
Cleaning up	Pick up or sweep up and place in a suitable container for disposal.

7. Handling and storage

Safe handling	Technical measures: Store with proper labeling. Advice on protection against fire and explosion: Provide appropriate exhaust ventilation at places where dust is formed. Advice on safe handling: For personal protection see section 8. Smoking, eating and drinking should be prohibited in the application area.
Fire and explosion	Dust from grinding or sanding can form an explosive mixture with air. Take precautionary measures against static discharges.
Storage	Electrical installations / working materials must comply with the technological safety standards. Materials to avoid: No materials to be especially mentioned. No decomposition if stored and applied as directed. Special packaging rules: Store with proper labeling.
Incompatibilities	Not applicable

8. Exposure controls / personal protection

Exposure limits	White mineral oil (petroleum), CAS 8042-47-5: ACGIH TLV TWA (inhalable fraction) 5 mg/m3; OSHA Z-1 TWA (mist) 5 mg/m3; ACGIH TWA (inhalable particulate matter) 5 mg/m3; OSHA P0 TWA (mist) 5 mg/m3; NIOSH REL TWA (mist) 5 mg/m3; NIOSH REL ST (mist) 10 mg/m3.
Engineering controls	Provide exhaust ventilation if dust or fumes are generated during processing.
Personal protection	Respiratory protection: No personal respiratory protective equipment normally required. Eye protection: Safety glasses. Skin and body protection: Protective suit. Protective measures: Protective Clothing, Protective Glasses, Gloves. Hand protection: Consistent with general hygienic practice for any material, skin contact should be minimized. Use gloves with insulation for thermal protection, when needed. Use gloves to protect from mechanical injury. Selection of gloves will depend on the task. Hygiene measures: General industrial hygiene practice.
Hygiene	Do not eat or drink while working. Handle in accordance with good industrial hygiene and safety practice.

9. Physical and chemical properties

Appearance	Solid; granules; color: Clear
Odor	Odorless
Odor threshold	Not applicable
pH	Not applicable
Melting temperature	No data available
Freezing point	No data available
Boiling point	Decomposes; not determined
Flash point	Not applicable
Evaporation rate	Not applicable (solid)
Flammability	Upper/lower flammability or explosion limit: Not applicable
Explosive limits	No data available
Vapor pressure / vapor density	No data available
Density	Specific gravity: 1.04 (ASTM D792)
Solubility in water	No data available
Partition coefficient	No data available
Auto-ignition temperature	No data available
Decomposition temperature	No data available
Viscosity	Not applicable (solid)
Oxidizing properties	No data available

10. Stability and reactivity

Reactivity	No decomposition if stored and applied as directed.
Chemical stability	No decomposition if stored and applied as directed.
Hazardous reactions	Stable under recommended storage conditions. No hazards to be specially mentioned.
Conditions to avoid	No data available
Incompatible materials	Not applicable
Hazardous decomposition products	Decomposition products depend upon temperature, air supply and the presence of other materials. Processing may release fumes and other decomposition products. At temperatures exceeding melt temperatures, polymer fragments can be released. Fumes can be irritating. Decomposition products can include and are not limited to: Combustible gases.

11. Toxicological information

Routes of exposure	Inhalation, ingestion, eye or skin contact.
Acute toxicity	Acute toxicity: Not classified based on available information. Acute oral toxicity: Single dose oral LD50 has not been determined. Acute inhalation toxicity: The LC50 has not been determined. Acute dermal toxicity: Typical for this family of materials. Estimated LD50, Rabbit > 2,000 mg/kg.
Inhalation	Not inhalable in the form supplied.
Irritation	Skin corrosion/irritation: Not classified based on available information. Under normal processing conditions, material is heated to elevated temperatures; contact with the material may cause thermal burns. Serious eye damage/eye irritation: Not classified based on available information. Solid or dust may cause irritation or corneal injury due to mechanical action. Elevated temperatures may generate vapor levels sufficient to cause eye irritation. Effects may include discomfort and redness.
Sensitization, repeated dose, mutagenicity, carcinogenicity, reproductive toxicity	Respiratory or skin sensitization: Not classified. Germ cell mutagenicity: Not classified. Carcinogenicity: Not classified; no component present at levels >= 0.1% is identified as probable, possible or confirmed human carcinogen by IARC, is on OSHA's list of regulated carcinogens, or is identified as a known or anticipated carcinogen by NTP. Reproductive toxicity: Not classified. STOT single exposure: Not classified. STOT repeated exposure: Not classified. Repeated dose toxicity: Not classified. Aspiration toxicity: Not classified.
Aspiration hazard	None expected.

12. Ecological information

Aquatic toxicity	Styrene, polymers: LL50 (Leuciscus idus) > 10,000 mg/l 96 h; LC50 (Lepomis macrochirus) > 10,000 mg/l 96 h; LL50 (Oncorhynchus mykiss) > 100 mg/l 96 h; LL50 (Daphnia magna) > 100 mg/l. Not expected to be acutely toxic to aquatic organisms. White mineral oil (petroleum): practically non-toxic to aquatic organisms on an acute basis (LC50/EC50/EL50/LL50 > 100 mg/L in the most sensitive species tested). Mobility in soil: No data available. Ozone-depletion potential: this product neither contains, nor was manufactured with a Class I or Class II ODS as defined by the U.S. Clean Air Act Section 602.
Persistence and degradability	Styrene, polymers: This water-insoluble polymeric solid is expected to be inert in the environment. White mineral oil (petroleum): Based on stringent OECD test guidelines, this material cannot be considered as readily biodegradable. However, these results do not necessarily mean that the material is not biodegradable under environmental conditions.
Bioaccumulation	White mineral oil (petroleum): Species: Fish. Bioconcentration factor (BCF): 1,900. Method: Estimated. Bioconcentration potential is high (BCF > 3000 or Log Pow between 5 and 7).

13. Disposal considerations

Product	Dispose of in accordance with local, state and federal regulations. Check for recycling options. Do not release into the environment.
Packaging	Empty spools and packaging can be recycled if not contaminated.

14. Transport information

US DOT, IMDG, IATA/ICAO	UNRTDG, IATA-DGR, IMDG-Code, 49 CFR: Not regulated as a dangerous good. Transport in bulk according to Annex II of MARPOL 73/78 and the IBC Code: Not applicable for product as supplied. Special precautions for user: Not applicable.

15. Regulatory information

U.S. TSCA	All components listed on TSCA inventory.
SARA 313	SARA 313: This material does not contain any chemical components with known CAS numbers that exceed the threshold (De Minimis) reporting levels established by SARA Title III, Section 313. SARA 311/312 Hazards: No SARA Hazards. SARA 304 and 302: no components with an EHS RQ/TPQ.
California Prop 65	WARNING: This product contains a chemical(s), which is/are known to the State of California to cause cancer. For more information go to www.P65Warnings.ca.gov. In April 2016, the Office of Environmental Health Hazard Assessment's (OEHHA) Proposition 65 Department proposed an NSRL of 27 g/day for styrene. The objective of the warning statement above is to comply with the Prop 65 statute. Styrene 100-42-5, Ethylbenzene 100-41-4. (Text as printed by the resin maker.)

16. Other information

NFPA hazard codes	NFPA 704: Health 0, Flammability 1, Instability 0 (no special hazard) (read from the diagram on S2 page 11)
HMIS III rating	HMIS IV: Health 0 (no chronic hazard, shown as "/"), Flammability 1, Physical hazard 0 (read from the diagram on S2 page 11)
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Prepared by	COEX LLC

This data is based on the current state of our information and experience.

www.coex3d.com
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