Gradient Mode

Set Palette to gradually change from different inputs to produce a gradient effect!

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INTRODUCTION

In this guide you will learn how to:

- Access and print with gradient mode

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Step 1 — Slice Print in Single Color and Start Gradient Mode

Gradient Print

Gradually change from input 1 to 2, producing a gradient effect.

Press Next to create the rule.

| 2 |
| 1 |
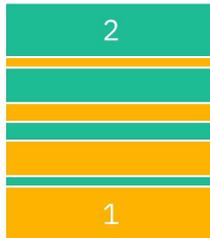
✕   Cancel   Next

- 📌 Before utilizing custom print modes, ensure that your filament has been splice tuned. The Splice Tuning feature will help you find the ideal settings so your Palette 3 can create optimal splices. A guide on how to do this can be found here.

- Slice a single-body STL file in Canvas or a slicer of your choice. Record the total print length, and transfer the file to the printer.

- On Palette's main screen, tap *Print From > Custom Print > Gradient Mode*

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Step 2 — Enter Range of Splice Length

Additional Length	1/3
Select the inputs to use for random print	
Additional Length	15 cm

Back

Range of Splice Length	2/3
Min. Length	10 cm
Max. Length	20 cm

Back   Next

Layer Info
Layer number: 19 ❌Solid layer
Layer height (mm): 4.85
GCODE commands in layer: 1315
Filament used by layer (mm): 170.84
Filament used, summed (mm): 1759.06
Print time for layer: 101.0sec

Layer Info
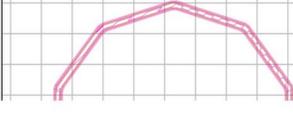Layer number: 146 ✔Perimeters and walls
Layer height (mm): 36.6
GCODE commands in layer: 313
Filament used by layer (mm): 62.03
Filament used, summed (mm): 9819.59
Print time for layer: 40.1sec

- Choose the inputs to use for the print.

  (i) Select the minimum and maximum length of your print. Load your GCode file into http://gcode.ws to determine filament length of your print.

- **Minimum Length**: When your model is loaded, under Layer Info ***locate the layer that uses the most filament by layer (mm)***. Enter that value into the *Minimum Length.*

  - For smoother transitions if the model is in vase mode, use the filament used by layer amount from the walls of the print.

  (i) Note: Palette's minimum splice length is 8 cm.

- **Maximum Length:** Input the maximum length as a ratio of the minimum length (max:min). This creates variation on the smoothness of the gradient.

  (i) Ex: If you want a ratio of 4:1 (4 layers of the first filament and 1 of the second), multiply the *Min Length* of the filament by 4 to obtain the value of the *Max Length*.

  (i) If you prefer smoother or more distinct colour changes, try increasing this ratio to 6:1 or 8:1.

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Step 3 — Enter Total Length of the Print

Total Length 3/3

Total Length to Print **15000 cm**

Back   Next

- Enter the total length of the model in centimeters. The Canvas print preview will display the total filament length for the print, which can be converted to centimeters.

- Follow the prompts displayed on Palette's screen to begin the print.

Step 4 — Start the Print

Total print length: 750cm
Minimum length: 8cm
Maximum lengths (L to R): 16, 32, 48cm

2:1   4:1   6:1

- Follow Palette's instructions to load the filament.

- Once Palette is finished making the initial splices with enough filament to come out of the outgoing tube, insert this filament into the printer's extruder.

- Jog the filament until you see filament come out of the nozzle (just enough to prime it), and then start the G-Code file on the printer.

If you have any additional questions, please send us a message at support@mosaicmfg.com!

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