Gradient Mode

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

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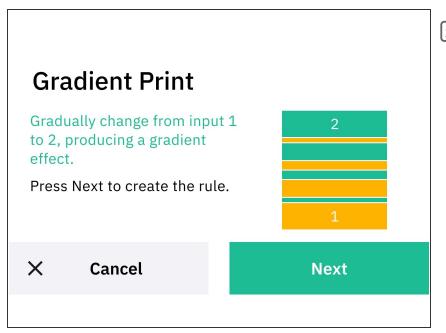

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INTRODUCTION

In this guide you will learn how to:

- Access and print with gradient mode

Tutorial video coming soon, check back again later!

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Step 1 — Access 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.

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

Step 2 — Splice Tuning

Splice Tuning

Heat ⓘ	Compress ⓘ	Cool ⓘ
− 2 +	− +1.5 +	− -5 +

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Next

- Choose the heat, compression and cool values for the material being used.

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Step 3 — Enter Range of Splice Length

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

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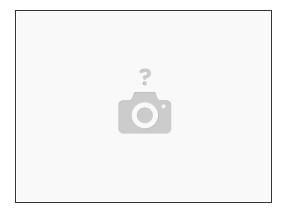| Range of Splice Length	2/3
Min. Length	**10 cm**
Max. Length	**20 cm**

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- 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, locate the layer that uses the maximum filament by layer (mm). Enter that value into the *Minimum Length.* This information can be located in the Layer Info.

  (i) Note: Palette's maximum splice length is 30 mm.

- **Maximum Length:** Input the maximum length as a ratio of the minimum length. This would depend on how smooth you prefer the gradient to be.

  (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/more distinct colour changes, increase this ratio.

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Step 4 — Enter Total Length of the Print

Total Length

3/3

Total Length to Print	**15000 cm**

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Next

- Enter the total length of your model.

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

Step 5 — Start the Print

- 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, 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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