



# Accessory Mode with Palette 3

How to print in Accessory Mode with Palette 3. In this mode, external storage is used on the printer to start the print.

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# INTRODUCTION

In this guide, you will learn how to:

- How to select a printer preset (available if Palette 3 is connected to the Internet)
- Measure the loading offset for your extruder, and how this is used in calibration
- How to start a print

Accessory Mode printing is where Palette's splicing and the printer's execution of the G-Code are separate. A file is sent to Palette to create splices, while the G-Code is sent to the printer using a compatible method or storage device (e.g. over WiFi, USB drive, microSD/SD card).

In Accessory Mode, connection to Canvas and the Internet is optional. If you would like to connect Palette 3 to the Internet and Canvas, please follow the steps [here](#).

Please also see [here](#) on how to setup and slice for Palette 3 in Canvas.

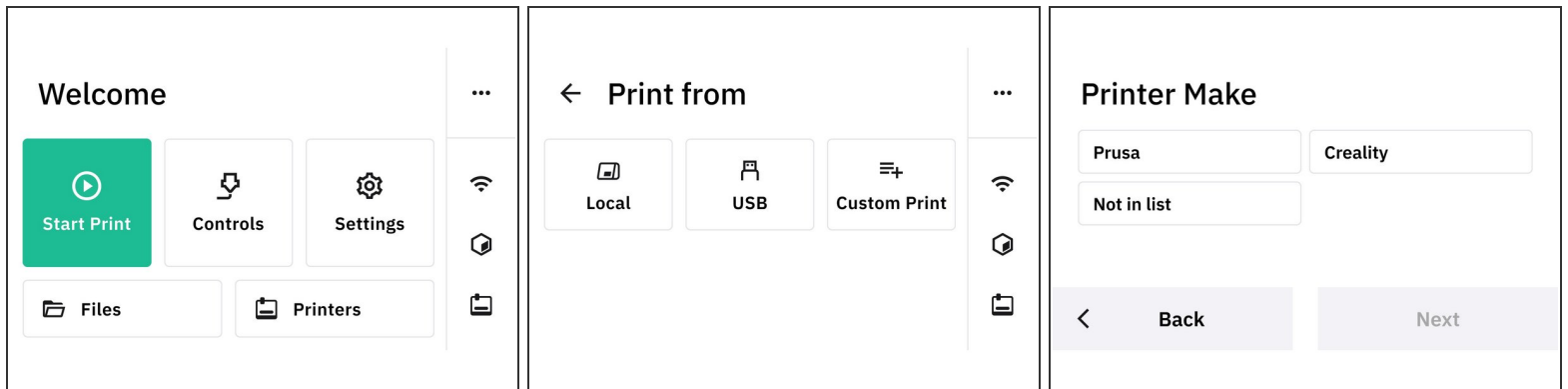
***Tutorial video coming soon, check back again later!***


## Step 1 — Slice and Transfer Files



- After [slicing your first multi-color project](#), download the files for printing.
- Transfer the .mafx file to Palette by copying the file to a USB drive, and send the .gcode file to the printer.

## Step 2 — Start Print and Enter Printer Details



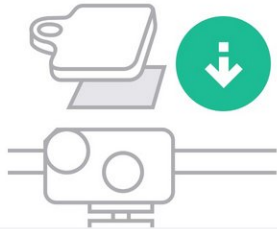
- From Palette's menu screen, tap on *Start Print*.
- Select the location for the MAF file.
-  If the printer setup was skipped during the initial setup, but Palette 3 is connected to the Internet, a list of common printer makes and models will be available to select from. Otherwise, you can enter custom details for the printer.

## Step 3 — Printer Check - Extruder Clip and Outgoing Tube

### Attach Guide Tube Clip

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This is secured to your extruder using provided Velcro squares. Press the Velcro together to secure the clip.



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### Outgoing Tube

Using a shorter outgoing tube when possible will provide better results.

  
80cm  
110cm

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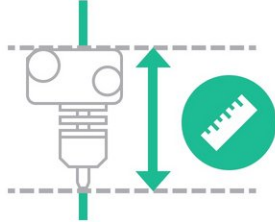
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- Check that the extruder clip is attached to the printer.
- Ensure that the correct outgoing tube length is selected on-screen.

## Step 4 — Measure Loading Offset

### Measure Loading Offset

To estimate loading offset, measure the distance from where the tube is clipped onto the extruder to the tip of the nozzle.

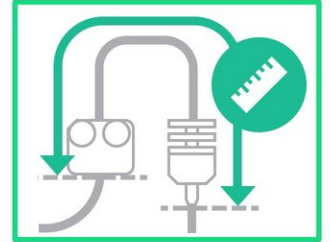


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### Measure Loading Offset

If your printer uses a bowden extruder, include the bowden tube length when measuring.



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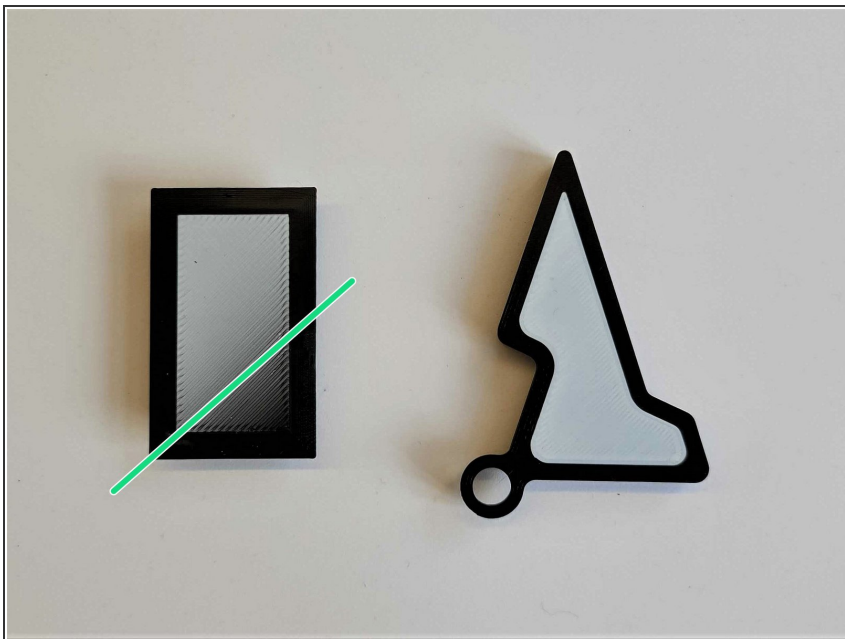
- Enter the loading offset (LO) distance. To do this, please enter the distance between the tube clip on the extruder to the tip of the nozzle.
  - For bowden printers, please measure from the bottom of the extruder, the bowden tube length, and hot end to the nozzle point.
- After saving the LO, your printer's calibration data will be saved. If you are not using one of the preset printer profiles on Palette, feel free to rename the printer for easier identification.
  - ☐ If a preset printer was selected, the loading offset is already stored with the preset. If the printer has a modified extruder, the loading offset will require measurement.
- ☐ For calibration purposes, the loading offset is used to determine how much filament to create in order to start the print.

## Step 5 — Start Print



- Palette will initialize, before prompting to load filament into the inputs.
- Preheat printer while Palette produces splices.
- Once Palette is done creating the initial splices, feed filament into the extruder.
  - Once the filament is gripped by the extruder's gears, jog the filament to insert the tube end into the clip grommet.
  - Jog the remaining filament prompted on Palette's screen.
- Clear the purged filament from the nozzle, and tap "finish" on Palette.
- Start the G-Code on the printer.

## Step 6 — Finished Print and Next Steps



- If the loading offset for the printer is accurate, the first transition on the tower will appear approximately 30-40% from the bottom-right. The keychain will have a clean border from the interior section.
- The next set of [multi-material prints](#) completed with this same printer profile will be further tuned by selecting to [save or ignore the print](#) based on calibration data.
  - Example multi-material models for profile tuning can be items like coasters, small animals or figurines.
- [Click here to learn more about Palette's calibration system in depth.](#)
- In the event you find that transitions are happening too early or too late, it's possible that the loading offset for the printer profile is inaccurate. To learn how to adjust this, please see [this guide](#).

If you have any questions, please don't hesitate to contact us at [support@mosaicmfg.com](mailto:support@mosaicmfg.com).