Printing Instructions

Once you've completed the calibration keychain, you're ready to start printing! Follow this guide for instructions on how to print with Palette.

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INTRODUCTION

Once you've completed the [calibration keychain](#), you're ready to start printing! Follow this guide for instructions on how to print with Palette. Before starting a print, please ensure that the following has been completed:

- Your printer's extruder is pre-heated
- Palette is positioned so that the filament path leads easily to your printer's extruder
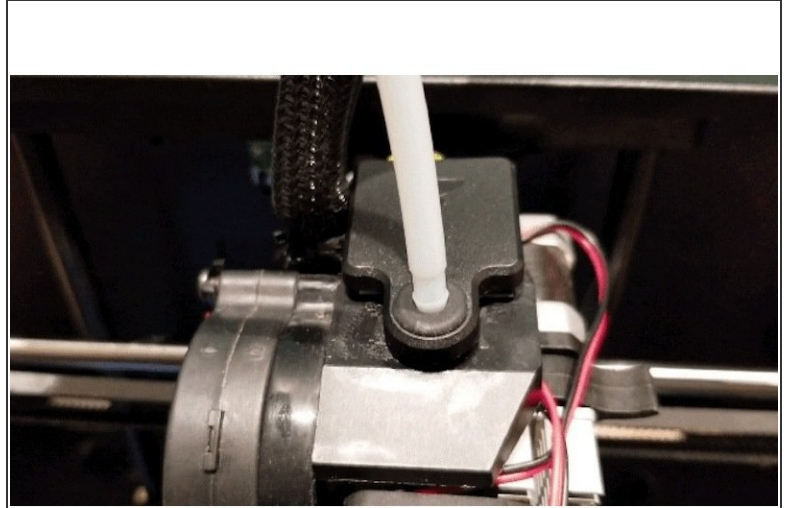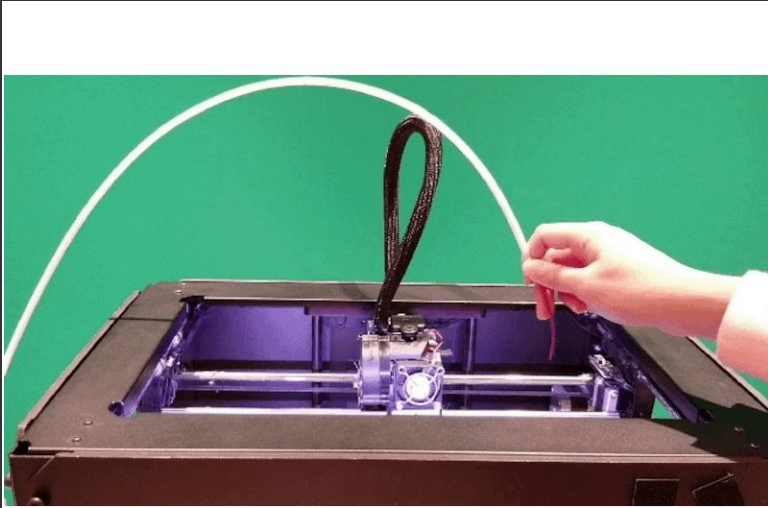- Palette inputs and outputs are clear of filament

While you're welcome to choose any multi-color model, we recommend trying out this [Multi-Color Ear Bud Case](#)! It's a simple and useful print with four different colors.

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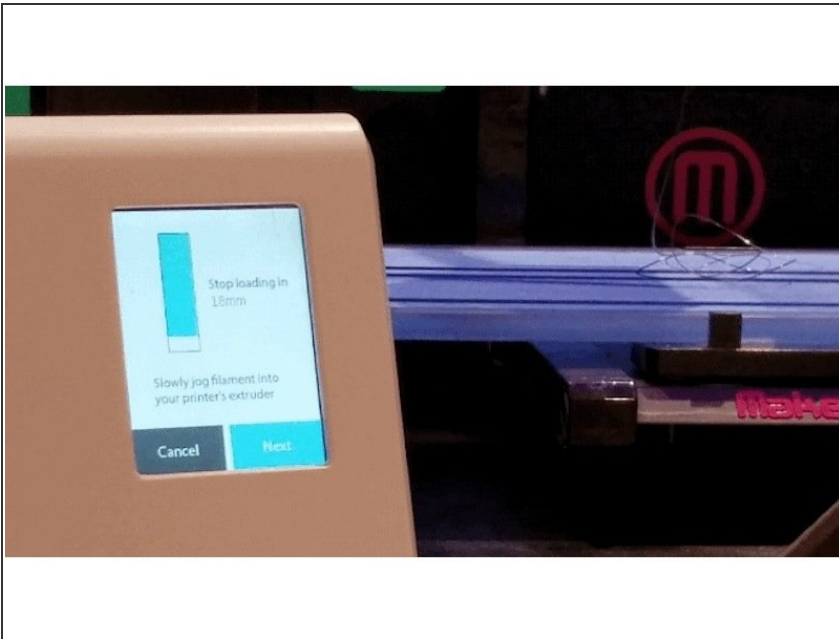
Step 1 — Start the Print on Palette 2
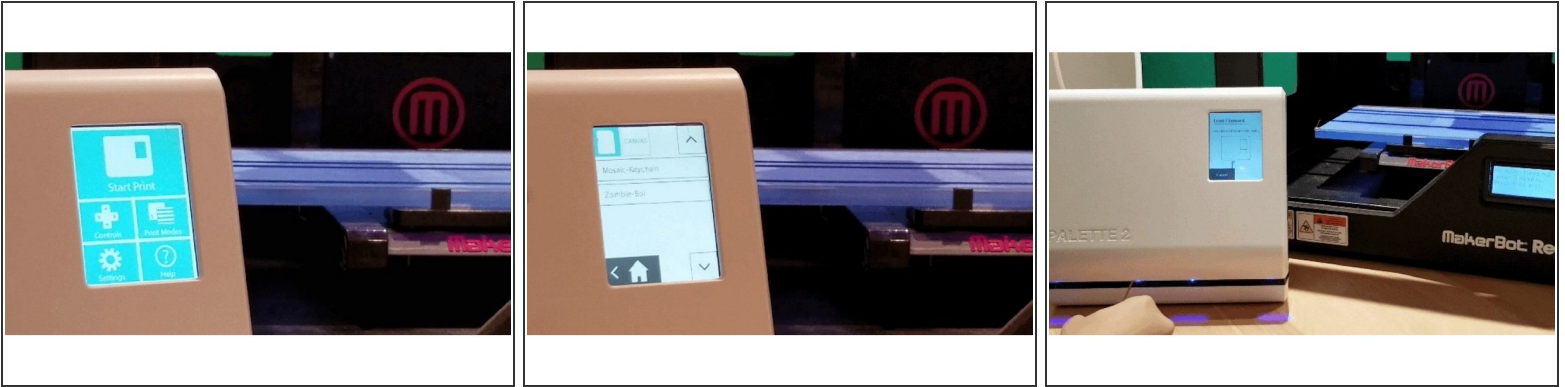
- Turn on Palette 2 and select **Start Print**.

- On the top left corner of the screen, you can select to load a file from Palette's SD card (MAF file). If you're in [Connected Mode](), send your MCF file to the Hub. From the Hub page, preheat your extruder and select **Print** on the desired file.

- Follow the on-screen instructions to load filament into Palette 2's inputs.

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Step 2 — Insert Filament into Tube Clip

- Palette 2 will begin to create filament, and you will see it pass through the output and through the Teflon tubing.

- Palette will create enough filament so that an additional 6-8 cm (2-3 inches) will stick out from the tubing. You can then feed this filament into your printer's extruder.

- With the Teflon tubing connected, attach the Teflon tube clip to your printer's extruder using the provided Velcro squares.

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Step 3 — Start the Print on the Printer

- On Palette 2's screen, you'll notice instructions to jog filament through your printer's extruder. There is a countdown that will tell you how many millimetres to load before starting your print.

- Using your printer's controls, manually extrude filament through the nozzle and stop loading as close to 0 mm as possible. For some printers with auto-load, you can time when to cancel the auto-load, while most printers have a **Move Extruder** operation. Once you've finished loading, tap **Next** on the screen.

  - ⓘ If you're in connected mode, you can control the extruder in the **Control** tab.

- Start the GCode file from your printer's screen/controls. Once you also indicate that the print has started on Palette's screen by pressing **Finished**, you will see a status screen displaying the time progress, splices completed, and total length of filament for the print.

  - ⓘ If you're in connected mode, you will not need to start GCode file on your printer.

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Step 4 — Stopping or Cancelling a Print

- While your print is in progress, on the status screen press the **Stop** button. Confirm you would like to stop the print.

- Unload filament from your printer and from Palette 2 by selecting *Controls > Clear Output* on Palette's home screen.

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

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