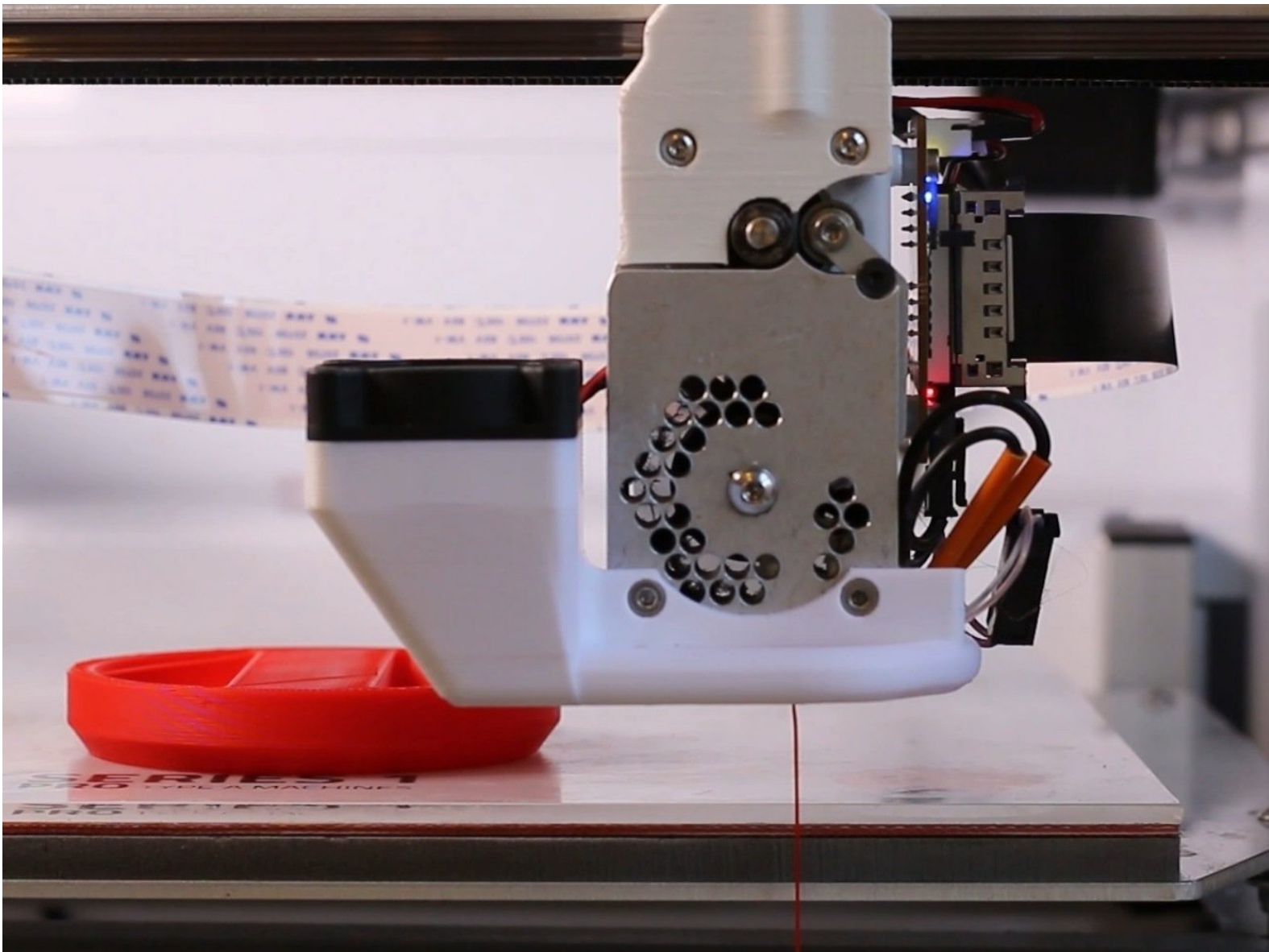




Side Transitioning in CANVAS

Side Transitioning allows you to select a specific region to the side of the bed where you would like your printer to transition between filaments.

Written By: Mosaic Support



INTRODUCTION

Side Transitioning allows you to select a specific region to the side of the bed where you would like your printer to transition between filaments. It's a great option to clear up some bed space and reduce print time by extruding faster. Side Transitioning is only possible on printers with nozzles that can move off of their print beds.

Step 1 — Edit Printer Profile for Side Transitioning

The image displays two side-by-side screenshots of the 'Edit Printer Profile' interface for side transitioning. Both screenshots show a form with tabs for GENERAL, EXTRUDER, BED, FIRMWARE, TRANSITION, and SEQUENCES. The 'TRANSITION' tab is active.

Left Screenshot (Along edge selected):

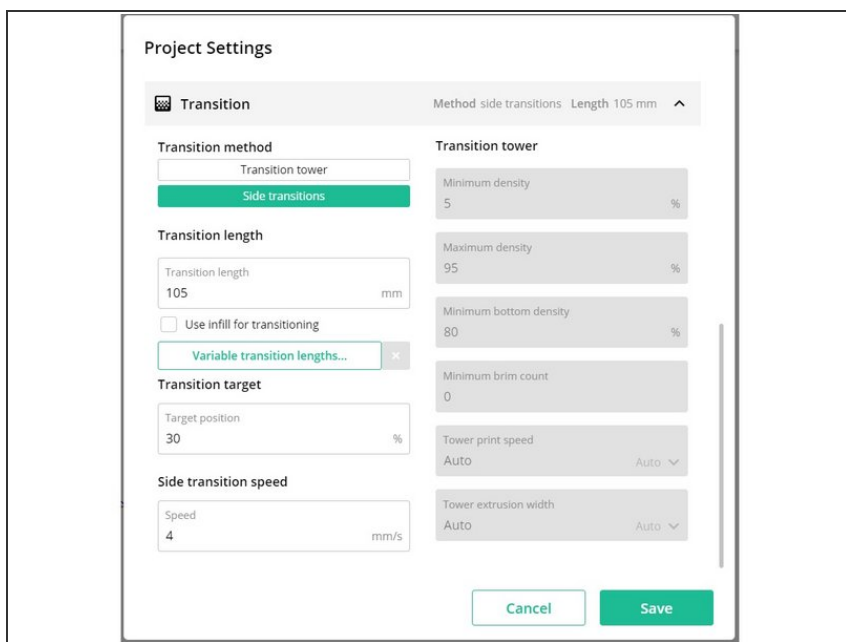
- Side transition type:** 'Along edge' is selected (highlighted in green), and 'In place' is an alternative option.
- Pause off of the transition tower during plings:** An unchecked checkbox.
- Side transition coordinates:** 'Side transition X' is 0 mm and 'Side transition Y' is 0 mm.
- Side transition edge:** 'Edge side' is set to 'North' (dropdown menu) and 'Edge offset' is 0 mm.
- Save:** A green button at the bottom right.

Right Screenshot (In place selected):

- Side transition type:** 'In place' is selected (highlighted in green), and 'Along edge' is an alternative option.
- Pause off of the transition tower during plings:** An unchecked checkbox.
- Side transition coordinates:** 'Side transition X' is 0 mm and 'Side transition Y' is 0 mm.
- Side transition edge:** 'Edge side' is set to 'North' (dropdown menu) and 'Edge offset' is 0 mm.
- Save:** A green button at the bottom right.

- On canvas3d.io, go to the side menu and go to: *Printer Profiles > Select Your Printer > Click the Edit Icon > Edit Printer > Transition*
- Select the side transition type to be used. With '**Along edge**' selected,, you can select which edge of the bed and how far off the bed the nozzle should move to. This option is used for printers that extrude too quickly while not moving.
- With '**In place**' selected, you can enter X/Y coordinates for the nozzle to move to.
- Save your settings.

Step 2 — Enable Side Transitions for a Project



The screenshot shows the 'Project Settings' dialog box with the 'Transition' tab selected. The settings are as follows:

- Transition method:** A dropdown menu with 'Transition tower' and 'Side transitions' (highlighted in green).
- Transition length:** A text input field with '105' and a unit dropdown set to 'mm'.
- Use infill for transitioning:** An unchecked checkbox.
- Variable transition lengths...:** A button with a small 'x' icon.
- Transition target:** A text input field with '30' and a unit dropdown set to '%'.
- Side transition speed:** A text input field with '4' and a unit dropdown set to 'mm/s'.
- Transition tower settings (disabled):** A list of settings including Minimum density (5%), Maximum density (95%), Minimum bottom density (80%), Minimum brim count (0), Tower print speed (Auto), and Tower extrusion width (Auto).
- Buttons:** 'Cancel' and 'Save' buttons at the bottom right.

- Start a new project or open an existing one.
- Go to *Settings > Expand* the Transition tab. Change the transition type from transition tower to side transitions to use the settings you created within your printer profile. Save your settings.
- Slice the project. The print preview will display the edge where the side transitioning will occur, or if transitions are occurring on the bed, previewing the travel movements will show the coordinates selected in your printer profile.

If you have additional questions, please contact us at support@mosaicmfg.com