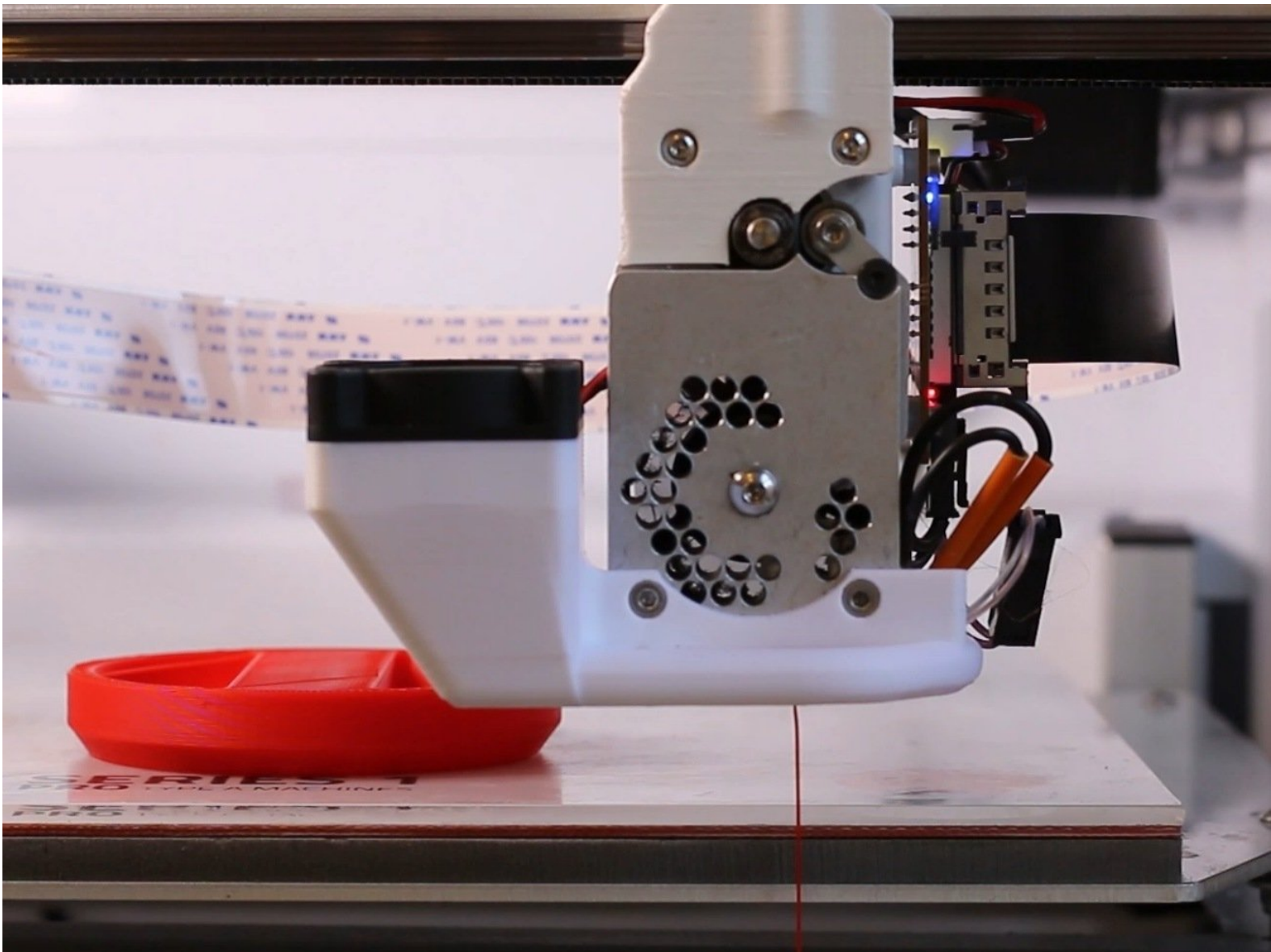




Side Transitioning in CANVAS

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.

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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

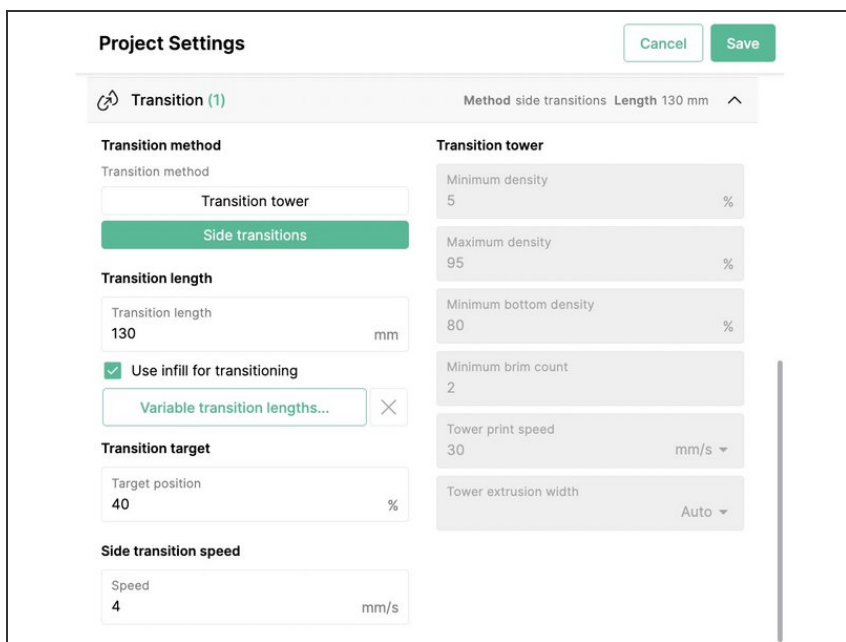
The screenshot shows the 'Edit Printer' window with a sidebar on the left containing links for General, Extruder, Bed, Firmware, Transition (which is highlighted), and Sequences. The main content area is titled 'Transition' and contains the following sections:

- Side transition type**: A dropdown menu with 'Along edge' selected. Below it, a text box for 'Edge side' with the instruction 'Enter the edge side.' and a text box for 'Edge offset' with the instruction 'Enter the edge offset.' and a unit 'mm'.
- Pause off of the transition tower during pings**: A checkbox labeled 'Enabled' which is currently unchecked. Below this is a small text block: 'When enabled, the printer will move away from the tower during ping pauses. This setting only affects behavior in accessory mode. Consider enabling this setting if your printer oozes significantly during ping pauses.'

At the top right of the 'Edit Printer' window are 'Cancel' and 'Save printer' buttons.

- On canvas3d.io, go to the side menu and go to: *Printers > Select Your Printer > Printer Settings > 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



Project Settings [Cancel] [Save]

Transition (1) Method side transitions Length 130 mm ^

Transition method

Transition method

Transition tower

Side transitions

Transition length

Transition length 130 mm

☒ Use infill for transitioning

Variable transition lengths... X

Transition target

Target position 40 %

Side transition speed

Speed 4 mm/s

Transition tower

Minimum density 5 %

Maximum density 95 %

Minimum bottom density 80 %

Minimum brim count 2

Tower print speed 30 mm/s

Tower extrusion width Auto

- 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