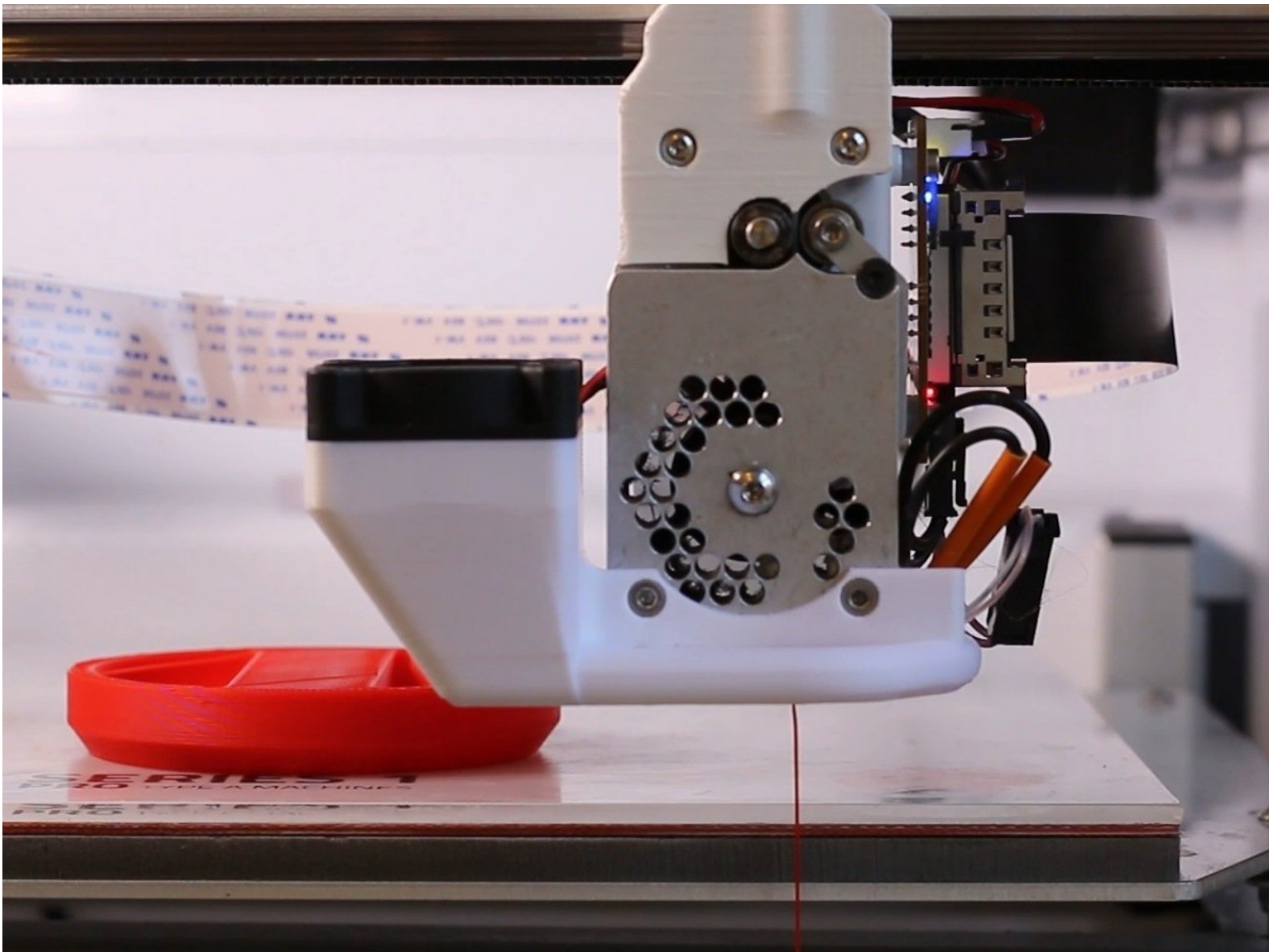




Side Transitioning in CANVAS

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 screenshot shows the 'Edit Printer' interface with a sidebar on the left containing links for General, Extruder, Bed, Firmware, Transition (selected), and Sequences. The main content area is titled 'Transition' and includes a 'Side transition type' section with a dropdown menu set to 'Along edge'. Below this is an 'Edge side' input field with a placeholder 'Enter the edge side.' and an 'Edge offset' input field with a placeholder 'Enter the edge offset.' and a unit 'mm'. At the bottom, there is a 'Pause off of the transition tower during pings' section with a checkbox labeled 'Enabled'.

- 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

Transition (1) Method: side transitions Length: 105 mm

Transition method

Transition method

Transition tower

Side transitions

Transition length

☐ Use variable transition lengths

Transition length: 105 mm

Transition target

Target position: 30 %

☐ Use infill for transitioning

Side transition speed

Speed: 4 mm/s

Transition tower

Minimum density: 5 X

Maximum density: 95 X

Minimum bottom density: 80 X

Minimum brim count: 1

Tower print speed: Auto

Tower extrusion width: Auto

- Start a new project or open an existing one.
- Go to Project Settings and 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.
- Set the Side transition speed - this should be much lower than other print speeds
- 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