Choose Language (Translated by google)

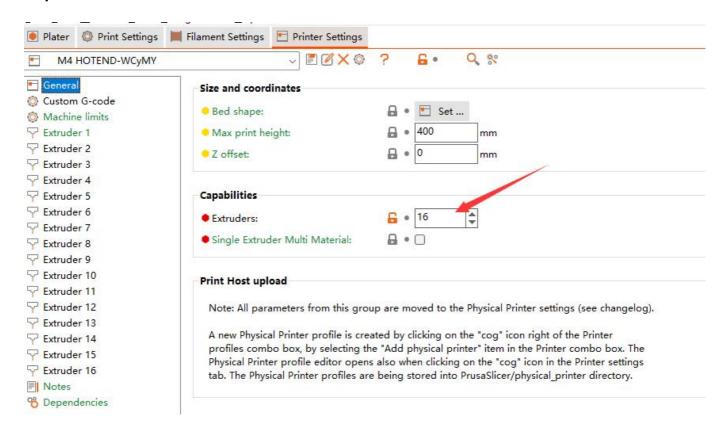


Mixed multi-color operation manual

This section will introduce how to use a virtual extruder to print 3D models with more colors than the number of extruders.

Slicing steps

Step 1: Set the number of extruders



Step 2: Set the mixing ratios of VTOOLs

Add mixing ratios of VTOOLs setting into the "Start G-code". How to set mixing ratio of Virtual extruder Print Settings Filament Settings Printer Settings Plater 9-Q 00 M4 HOTEND-WCyMY General Start G-code Custom G-code Machine limits T Extruder 1 ;White M163 SO P100 M163 S1 P0 T Extruder 2 M163 S2 P0 M163 S3 P0 T Extruder 3 TExtruder 4 M164 SO Cyan M163 SO PO M163 S1 P100 M163 S2 PO M163 S3 PO TExtruder 5 T Extruder 6 T Extruder 7 M164 S1 TExtruder 8 :Magenta M163 SO PO M163 S1 PO M163 S2 P100 M163 S3 PO Extruder 9 TExtruder 10 TExtruder 11 M164 S2 TExtruder 12 :Yellow M163 SO PO M163 S1 PO TExtruder 13 M163 S2 P0 M163 S3 P100 TExtruder 14 TExtruder 15 M164 S3 ;Ocean-Blue M163 SO PO M163 S1 P83 M163 S2 P17 M163 S3 PO TExtruder 16 Notes % Dependencies M164 S4 :Blue M163 SO PO M163 S1 P50 M163 S2 P50 M163 S3 P0 M164 S5

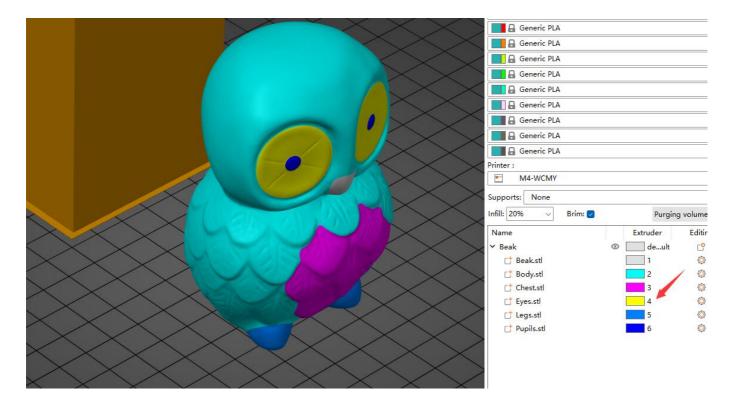


You can download the setting from the bewlow link and unzip it, and then import the setting to your slicing software (PrusaSlicer).

: Violet

- Download config file

Step 3: Assign an extruder to the components



Step 4: Slicing and save gcode to SD card

Step 5: Print the file from SD card

Examples

6 color OWL

- Wideo tutorial
- Download stl file
- Download 3mf & gcode file

10 color Noahs

- Video tutorial: Part1 Part2 Part3
- Download stl file
- Download 3mf & gcode file

Appendix: Color mixing ratio reference settings

Here is a set of reference mixing ratio settings for mixing Cyan, Magenta, and Yellow filament into other color filament.

• Filament color:

- o E1: White
- o E2: Cyan
- o E3: Magenta

o E4: Yellow

• mix ratio and extruder color:

VTOOL number	mixing ratio	mixed filament color	Extruder color *
0	100/0/0/0	White	R255 G255 B255
1	0/100/0/0	Cyan	R0 G255 B255
2	0/0/100/0	Magenta	R255 G0 B255
3	0/0/0/100	Yellow	R255 G255 B0
4	0/0/0/100	Ocean-Blue	R255 G255 B0
5	0/50/50/0	Blue	R0 G0 B255
6	0/17/83/0	Violet	R169 G0 B255
7	0/0/83/17	red	R255 G0 B0
8	0/0/50/50	Orange	R255 G159 B0
9	0/17/0/83	Spring-Green	R191 G255 B0
10	0/50/0/50	Green	R0 G255 B0
11	0/50/0/50	Turquoise	R0 G255 B191
12	75/0/25/5	skin	R255 G210 B255
13	0/25/50/25	Magenta-Brown	R106 G83 B83
14	0/25/25/50	Yellow-Brown	R106 G106 B83
14	0/33/33/34	Brown	R83 G83 B83

Print settings : Elament: Colour Generic PLA Basic colours: 🔒 Generic PLA 📙 🔒 Generic PLA 📙 🔒 Generic PLA 🔣 🔒 Generic PLA 📕 🔒 Generic PLA 📕 🔒 Generic PLA 📕 🔒 Generic PLA Custom colours: 📙 🔒 Generic PLA Hue: 160 Red: 224 Generic PLA Sat: 0 Green: 224 Colour|Solid 📙 🔒 Generic PLA Define Custom Colours >> Lum: 211 Blue: 224 🔒 Generic PLA OK Cancel Add to Custom Colours Generic PLA

Generic PLA

* Extruder color: RGB value of the extruder color is used to set the extruder color in slicint software.

Gcodes list

You can copy the blow to the "Start G-code" in slicint software to set the virtual extruders.

```
;White
M163 S0 P100
M163 S1 P0
M163 S2 P0
M163 S3 P0
M164 S0
;Cyan
M163 S0 P0
M163 S1 P100
M163 S2 P0
M163 S3 P0
M164 S1
;Magenta
M163 S0 P0
M163 S1 P0
M163 S2 P100
M163 S3 P0
M164 S2
;Yellow
M163 S0 P0
M163 S1 P0
M163 S2 P0
M163 S3 P100
M164 S3
;Ocean-Blue
```

```
M163 S0 P0
M163 S1 P83
M163 S2 P17
M163 S3 P0
M164 S4
;Blue
M163 S0 P0
M163 S1 P50
M163 S2 P50
M163 S3 P0
M164 S5
;Violet
M163 S0 P0
M163 S1 P17
M163 S2 P83
M163 S3 P0
M164 S6
;Red
M163 S0 P0
M163 S1 P0
M163 S2 P83
M163 S3 P17
M164 S7
;Orange
M163 S0 P0
M163 S1 P0
M163 S2 P50
M163 S3 P50
M164 S8
;Spring-Green
M163 S0 P0
M163 S1 P17
M163 S2 P0
M163 S3 P83
M164 S9
;Green
M163 S0 P0
M163 S1 P50
M163 S2 P0
M163 S3 P50
M164 S10
;Turquoise
M163 S0 P0
M163 S1 P83
M163 S2 P0
M163 S3 P17
M164 S11
;skin
M163 S0 P18
M163 S1 P0
M163 S2 P5
```

M163 S3 P1
M164 S12
;Magenta-Brown
M163 S0 P0
M163 S1 P25
M163 S2 P50
M163 S3 P25
M164 S13
;Yellow-Brown
M163 S0 P0

;Yellow-Brown M163 S0 P0 M163 S1 P25 M163 S2 P25

M163 S3 P50 M164 S14

;Brown

M163 S0 P0 M163 S0 P33

M163 S1 P33

M163 S2 P34

M164 S15