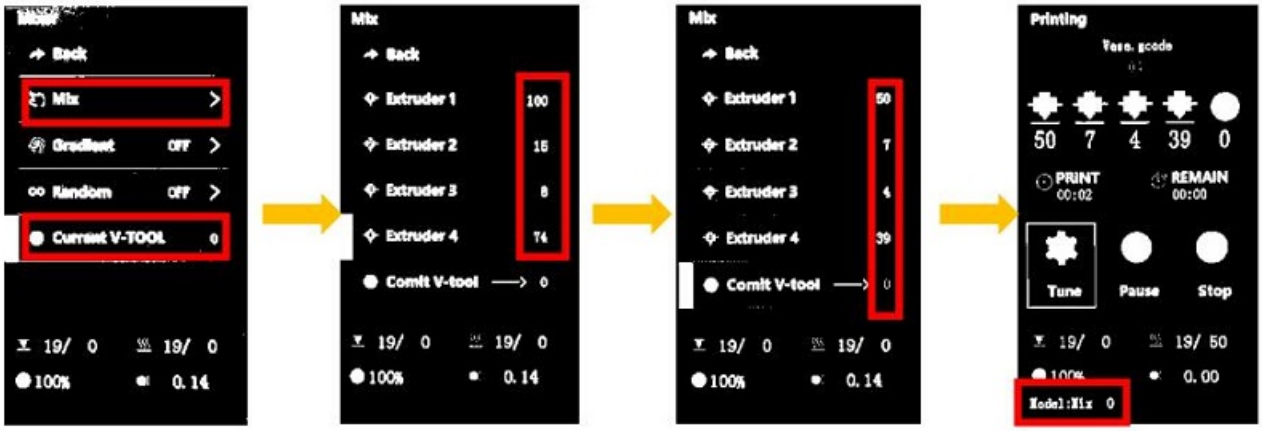
Choose Language (Translated by google)

Auto Color Mixing Feature User Guide

Change printing color by adjust mixing rate

- Start to print a singel color gcode file from SD card.
- Wait until the print start to print, set on the LCD menu.
- **Tune>>Mixer>>Current V-TOOL:** Set the vtool to 0.
- **Tune>>Mixer>>Mix>>Extruder1~4(M4):** Arbitrarily adjust the percentage of extruder 1 ~ 4, the range is 0 ~ 100.
- **Tune>>Mixer>>Mix>>Comit:** Redistribute the percentage of all extruders in proportion and send it to the current vtool. The current vtool value changes color. After setting up, on the ideal menu shows Current **VTOOL = 0**

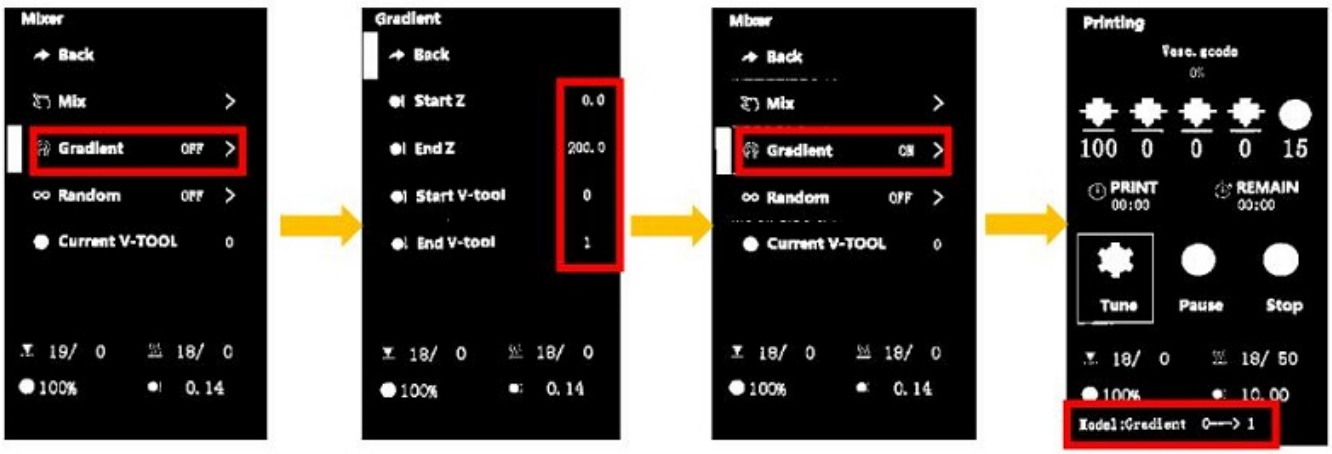


Auto gradient mixing

Video tutorial

- Start to print a one color gcode file from SD card.
- Set the paremeters for auto gradient mix printing on the LCD menu when the printer start to to print the first layer.
- **Tune>>Mixer>>Gradient:OFF>>**
  - **Start Z:** set the start Z heigth(such as:0mm)
  - **End Z:** set the END Z heigth(such as:200mm)
  - **Start V-tool:** set the start V-tool(such as:0)
  - **End V-tool:** set the end V-tool(such as:1)

After set **Start Z** isn't equal to **End Z**, and **Start V-tool** isn't equal to **End V-tool**, the LCD will shows **Gradient : ON**.



Realize gradient mixing by modifing gcode file

You can also add a M166 command into the "start G-code" of the machine setting when slicing, so it can automatically work when print from SD card.

```
Descitpion of M166 command
M166: Start a gradient mix
S[bool] - Enable / disable gradients
A[float] - Starting Z for the gradient
Z[float] - Ending Z for the gradient.
I[index] - V-Tool to use as the starting mix.
J[index] - V-Tool to use as the ending mix.

For example: M166 S1 A0 Z200 I0 J1
S1->Enable gradient mix
A0->startZ is 0mm
Z200-> EndZ is 200mm
I0 -> Start V-tool is 0
J1 -> End Vtool is 1
```

Auto random mixing

- Start to print a singel color gcode file from SD card.
- Wait until the print start to print, set on the LCD menu.
- **Tune>>Mixer>>Random Mix: OFF>>**
    - **Start Z:** Set the start Z heigth(such as:0mm)
    - **End Z:** Set the end Z heigth(such as:200mm)

- **Height:** Set interval distance(such as:10mm), when printing heigth changed beyond this value, the mixing ratio be changed once.
- **Extruders:** Set the number of extruders participating in printing(1~4). ⚠️ In particular, when the parameter is set to 1, all four extruders will participate in printing, but color mixing will not occur during printing. Instead, one of the extruders is randomly selected each time to print.

After set Start Z isn't equal to the End Z, the LCD will shows **Random : ON**.

🌟 Realize Random mixing by modifing gcode file

You can also add a M167 command into the "start G-code" of the machine setting when slicing, so it can automatically work when print from SD card.

```
Descitpion of M167 command.
M167: Start a random mix.
S[bool] - Enable / disable random mix.
A[float] - Starting Z for the random.
Z[float] - Ending Z for the random.
H[float] - Minimum height of changing mixing rate.
E[int] - how many extruders used on random mixing.

For example: M167 S1 A0 Z100 H0.2 E3
S1->Enable Random mix
A0->start Z heigth is 0mm
Z100->End Z heigth is 100mm
H0.2->change color every 0.2mm
E3->3 extruders (Extruder#1 to Extruder#3) will be used
```