

Four-color limitations for decorative models

3DP-051 / REV A / 2026.09.01

A four-color setup needs a deliberate palette and a slicer preview that accounts for every transition. More colored surface area does not always mean more swaps; layer arrangement matters.

STATUS Needs Retest

CLASSIFICATION 3DP

MATERIAL 3D PRINT / MAKER

DISPOSITION PUBLIC / NEEDS RETEST

CATEGORY 3D Printing

RECORD TYPE project

GOAL

Run the first test described in this guide and record the result for four-color limitations for decorative models.

SOURCE STATE

Reference guidance with one recovered printer observation

EQUIPMENT

- FDM printer / slicer
- Slicer project
- Calipers or inspection method

MATERIALS

- Material requires confirmation

METHOD / STEPS

1. Reduce the artwork to four meaningful colors, grouping similar tones and preserving contrast at small features.
2. Assign colors to bodies or painted regions. Check hidden faces so accidental paint does not create unnecessary changes.
3. Slice with the actual four-material printer profile. Inspect per-layer transitions, purge use, supports and estimated material for each spool.

4. Print a small representative section, then save the verified 3MF with its filament mapping and process settings.

THINGS TO WATCH FOR

Do not remove a required prime tower just to reduce waste. The retained Creator 5 Pro history reports a freeze without the tower and successful printing with it; that is an observation, not a universal firmware diagnosis. Use compatible materials in the same print.

FIRST TEST / WHAT TO RECORD

Confirm no fifth color is required, all spools are mapped correctly, and the saved project reproduces the tested preview.

RESULT / WHERE THIS STANDS

Confirm no fifth color is required, all spools are mapped correctly, and the saved project reproduces the tested preview.

TROUBLESHOOTING

- Do not remove a required prime tower just to reduce waste. The retained Creator 5 Pro history reports a freeze without the tower and successful printing with it; that is an observation, not a universal firmware diagnosis. Use compatible materials in the same print.

SPECIFICATION

PRINTER	FDM printer / slicer
MATERIAL	Material requires confirmation
FOCUS	First layer, dimensions, surface, and function
VALIDATION	Small test print before release

DEVELOPMENT HISTORY

2026.09.01 / Rev A

Imported as an independent manifest record; public copy keeps uncertainty visible.

RELEASED MATERIAL / SOURCE LINKS

3dp-051-public-summary.txt

PUBLIC SUMMARY / RECOVERED NOTES

<https://u225x.com/downloads/manifest-records/3dp-051-public-summary.txt>

RETURN TO THE LIVING RECORD

Four-color limitations for decorative models

This PDF preserves the public notes at this revision. Visit the record for updates and attached images.

<https://u225x.com/record/3DP-051>