Tutorial:

Files folders include both AMS and standard versions in various thicknesses. The 0.7 mm works perfect for 0.4 mm nozzle (turn on ARACHNE wall generator to ensure 2 perimeters everywhere. The different thicknesses are there so you can work with different scales and nozzles.

Without AMS (Manual Color Change)

https://www.youtube.com/watch?v=xxNzknUepws

1. **Prepare Filament**: Start with wood PLA loaded.
2. **Single-Body File**: Import the single-body file in your slicer.
3. **Print Settings**:
    - **Layer Height**: 0.2 mm or smaller.
    - **Wall Generator**: Enable ARACHNE.
    - **Seam Position**: Set to "nearest."
4. **Pause for Color Change**:
    - Slice the file, and check where the transparent section starts.
    - Insert a pause command (using your slicer's "Pause" "Color Change" or function) at this layer height. (it is usually added by a PLUS icon in the layer slider)
5. **Switch Filaments**:
    - When the printer pauses, replace wood PLA with transparent mystic clear UV PLA.
    - Resume the print and let it complete the transparent section.
6. **Switch Back to Wood PLA**:
    - Insert another pause command where the transparent section ends.
    - When the printer pauses again, switch back to wood PLA for the top part of the vase.
7. **Resume and Finish**: Resume the print and complete the vase.

With AMS (Automatic Material System)

1. **Load Filaments**: Load wood PLA in slot 1, transparent mystic clear UV PLA in slot 2.
2. **Multibody File**: Import the multibody file into your slicer.

3. **Assign Colors**: Set wood PLA for the bottom and top sections, and transparent PLA for the middle.
4. **Print Settings**:
    - **Layer Height**: 0.2 mm or smaller.
    - **Wall Generator**: Enable ARACHNE.
    - **Seam Position**: Set to “nearest.”
    - **Wall Thickness**: Use the standard 0.7 mm for a 0.4 mm nozzle or choose a version that suits your nozzle size.
5. **Start Printing**: Begin the print and let AMS automatically handle material changes.