

- **M600 Commands (filament change)**

OrcaSlicer 1.8.1 / 1.9 (maybe other version, too):

The first filament change works fine, but on further filament changes Orca sometimes inserts "G1 E10 F2400" into the g-code, which leads to **quite a blob** shot out of the nozzle when the print **resumes**.

This probably happens only when switching between PETG presets, and probably never on the first filament change. I have no time to figure out the exact pattern.

Workaround: Add **Pause** instead of **Filament Change** commands, and unload the filament yourself.

- **Unnecessary move on print start / possibly ouzing**

After the Prime Spiral / Line has been printed, sometimes the print head moves to to print start coordinates, but then to X15 Y15, and then back to the print start coordinates. That move to X15 Y15 is a bug in OrcaSlicer 2.0.0 (possibly later releases too), which puts this move into the gcode-file.

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Thank you!

Christian 😊