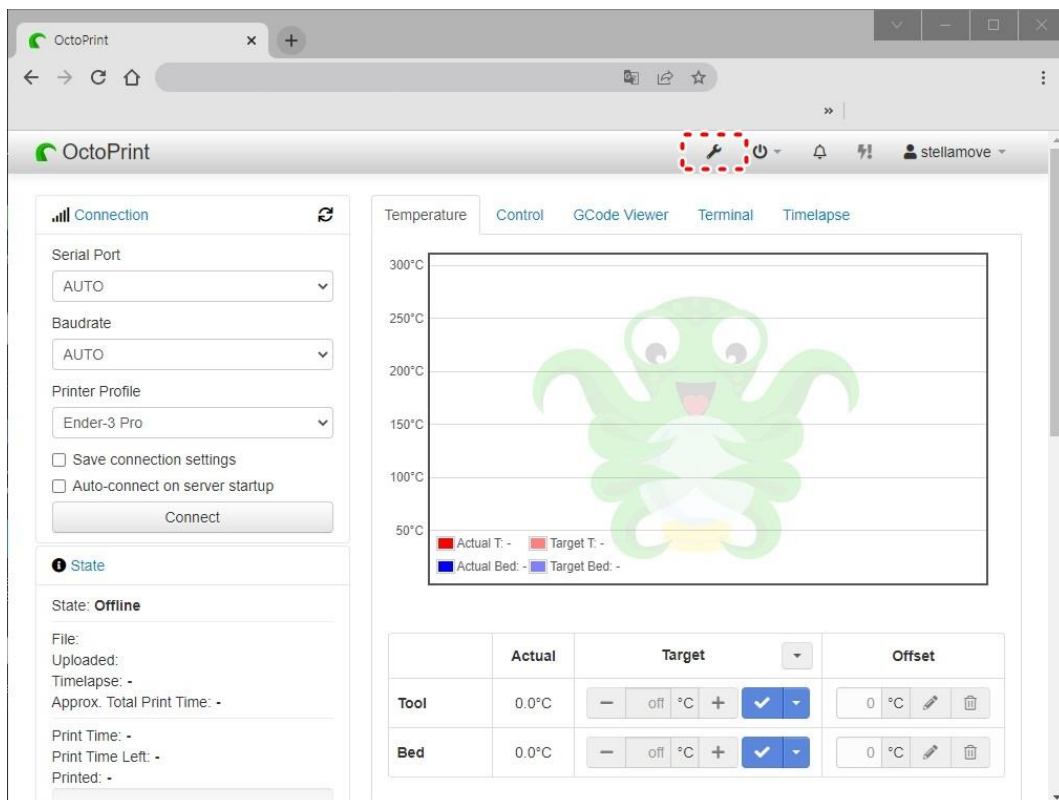


OctoPrint Setting

Since PITTA is a device that changes a general 3D printer to a printer that can use 8 colors of filament, you need to change the settings of the printer profile you are using. And through communication between the your 3D printer and the PITTA base, it takes about 40 seconds to change the filament. Therefore, you will need to change the serial timeout setting of OctoPrint to handle long periods of non-response.

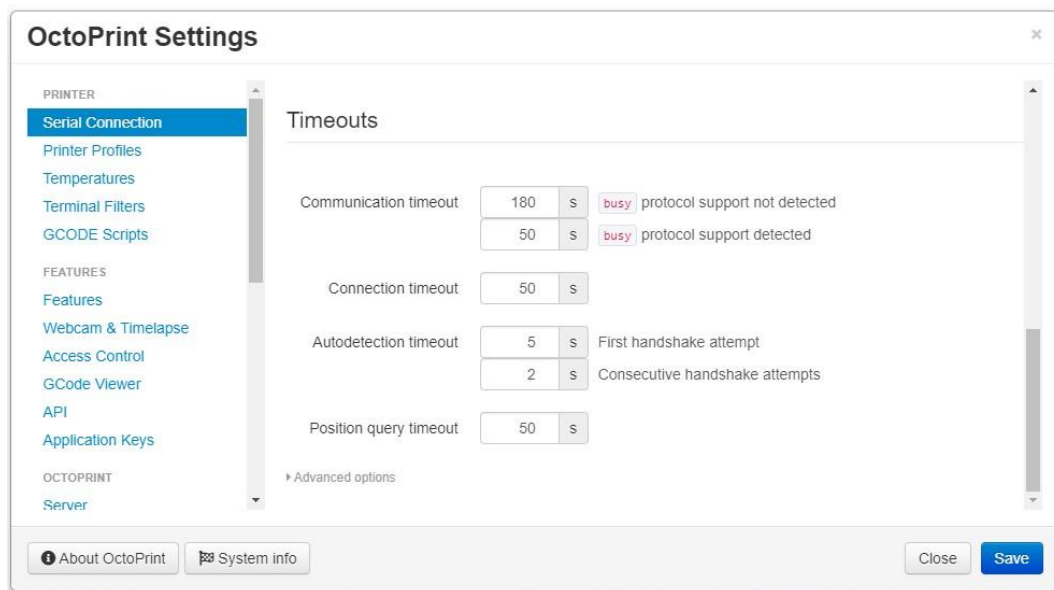
1. OctoPrint Settings Menu

- ① Click the Settings(wrench icon) menu of OctoPrint window.

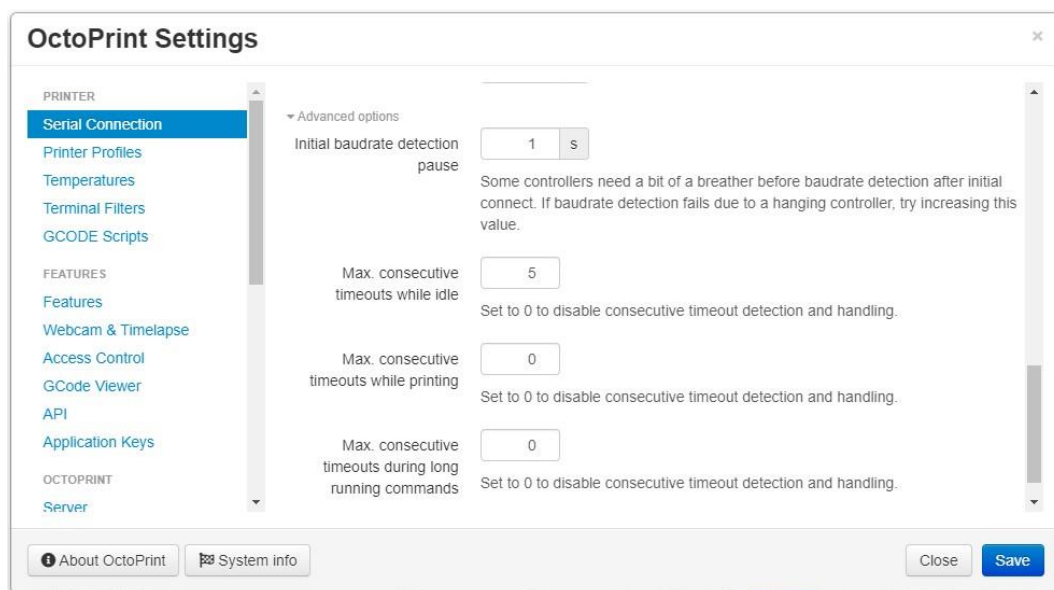


2. Serial timeout settings

- ① Select the “Serial Connection” menu from “PRINTER” on the left side of the “OctoPrint Settings” window
- ② Select “Intervals & timeouts” from the menus on the right side of the “OctoPrint Settings” window.
- ③ Change the values of “Timeouts” section
 - A. Communication timeout : 180 s / 50 s
 - B. Connection timeout : 50 s
 - C. Position query timeout : 50 s



- ④ Select "Advanced options" of "Timeouts" section
 - A. Max. consecutive timeouts while idle : 2
 - B. Max. consecutive timeouts while printing : 0
 - C. Max. consecutive timeouts during long running commands : 0



3. Printer Profiles settings

- ① Select the "Printer Profiles" menu from "PRINTER" on the left side of the "OctoPrint Settings" window
- ② Select pen icon from the menus on the right side for the printer you want to use.
- ③ Select "Hotend & extruder" in the "Edit Printer Profile XXX" window
 - A. Number of Extruders : 8

B. Shared nozzle : check

The screenshot shows the 'Edit Printer Profile' window for a printer named 'PITTA 8'. The window has a title bar with a close button. Below the title bar, there are four tabs: 'General', 'Print bed & build volume', 'Axes', and 'Hotend & extruder'. The 'Hotend & extruder' tab is selected and highlighted in blue. Inside this tab, there are three settings:

- Nozzle Diameter:** A text input field containing '0.4' followed by a unit dropdown menu set to 'mm'.
- Number of Extruders:** A text input field containing '8'. Below it is a note: 'Make sure to specify number of extruders available on your printer or you might run into issues'.
- Shared nozzle:** A checkbox that is checked (indicated by a blue checkmark). Below it is a note: 'Check this if your printer has a single nozzle and heater shared among its extruders instead of one nozzle and heater per extruder'.

4. GCODE Scripts settings

- ① Select the "GCODE Scripts" menu from "PRINTER" on the left side of the "OctoPrint Settings" window

The screenshot shows the 'OctoPrint Settings' window. On the left side, there is a sidebar with a 'PRINTER' section containing several links: 'Serial Connection', 'Printer Profiles', 'Temperatures', 'Terminal Filters', and 'GCODE Scripts'. The 'GCODE Scripts' link is highlighted in blue. Below the 'PRINTER' section, there are sections for 'FEATURES' and 'OCTOPRINT'. The main area of the window is divided into two sections: 'After print job is cancelled' and 'After print job is paused'. The 'After print job is cancelled' section contains a text area with the following G-code script:

```
{% if event.origin == 'sdcard' %}  
M24  
M524  
{% else %}  
T0  
  
; move print head up  
M114
```

Below the text area, there is a note: 'Anything you put here will be executed after any lines in your files. If you ever need to you can find the default cancel script that OctoPrint ships with [here](#).' The 'After print job is paused' section is currently empty. At the bottom of the window, there are buttons for 'About OctoPrint', 'System info', 'Close', and 'Save'.

- ② Select "After print job is cancelled" from the menus on the right side of the "OctoPrint Settings" window.
- ③ Copy the content below and paste it into the "After print job is cancelled" box

```
{% if event.origin == 'sdcard' %}  
M24  
M524  
{% else %}
```

T0

```
; move print head up
M114
{% if last_position.z < printer_profile.volume.height+2 %}
G1 Z{{last_position.z + 2}} F600
{% endif %}

G92 E0
G1 E-500 F3600

; present print
G1 X5 Y180 F2000

; move print head further up
{% if last_position.z < printer_profile.volume.height*0.6 %}
G1 Z{{printer_profile.volume.height*0.6}} F600
{% endif %}

;disable all heaters
{% snippet 'disable_hotends' %}
{% snippet 'disable_bed' %}

;disable fan
M106 S0

; disable motors
M84 X Y E ; disable motors
{% endif %}
```

- ※ If you click the “Cancel” button of OctoPrint when printing gcode file on the SD card of the 3D printer using OctoPrint, the 3D printer’s status changes to the paused status instead of stop SD printing. To handle this, an SD printing stop gcode, M524, was added to the GCODE Scripts(After print job is cancelled). But OctoPrint 1.8.0 will add the SD printing stop gcode(M524) option. Therefore, if you use the OctoPrint version with the M524 processing option added, you must change the temporarily processed Gcode script.