

- **M600 Commands (filament change)**

**OrcaSlicer 1.9** note: 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.

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Thank you!

Christian 😊