How to Use Variable Layer Thickness Tool

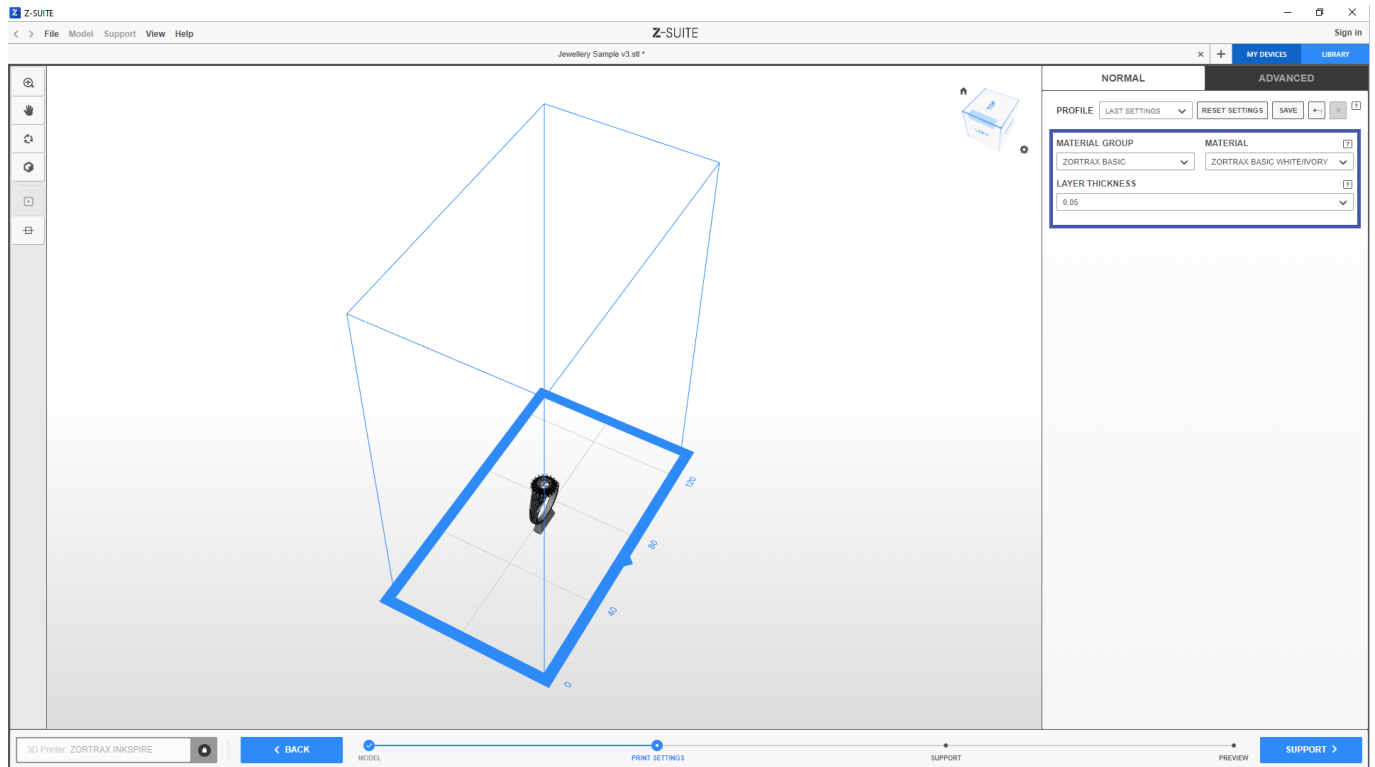**Table Of Contents**

Adding Dividers

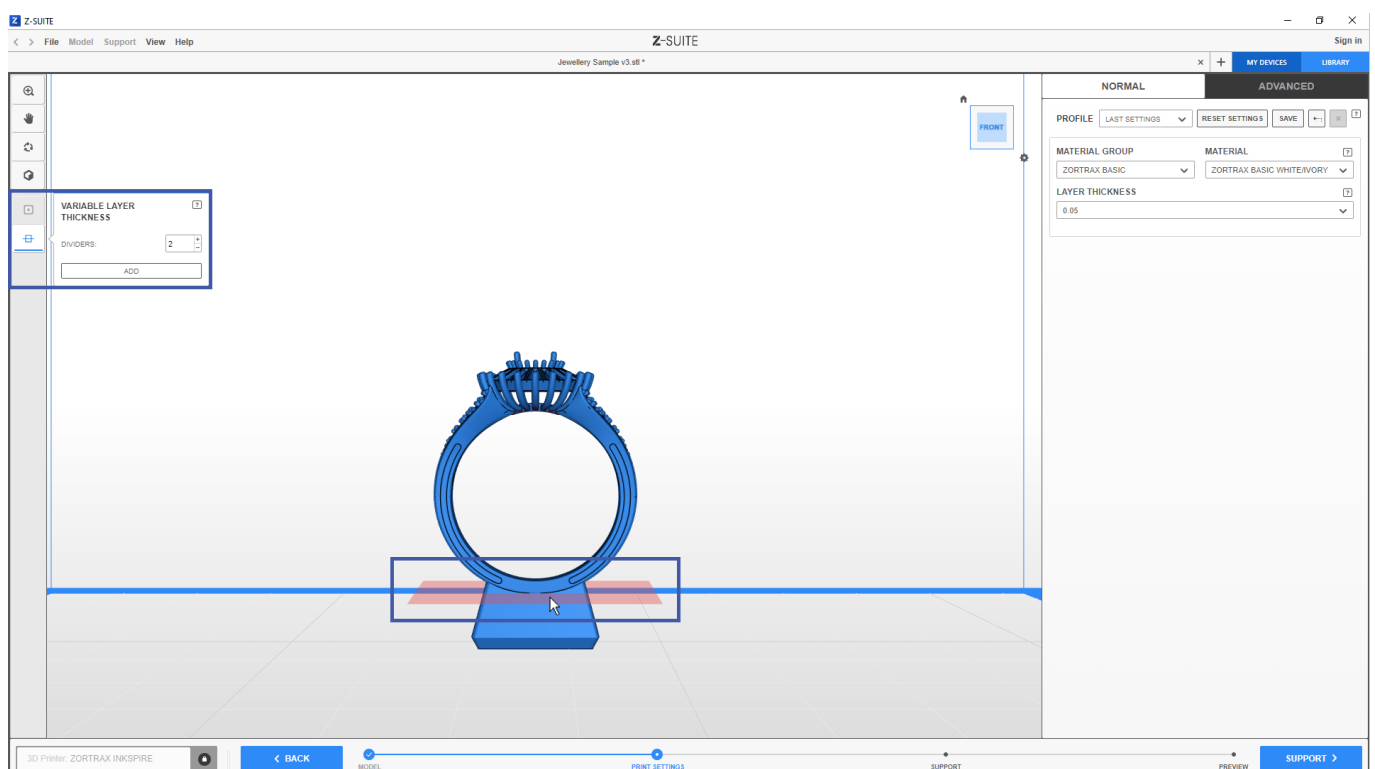Once you upload your model to the workspace and make the necessary changes to its size and position, move on to the **Print settings** step. First, select the **Material Group** and then **Material** type.

To split your model into areas, select the **Variable Layer Thickness** icon on the toolbar on the left and add one or more dividers. You can do it by selecting the number of dividers and clicking the *Add* button, or by clicking directly on the spot where you want your model to be divided.
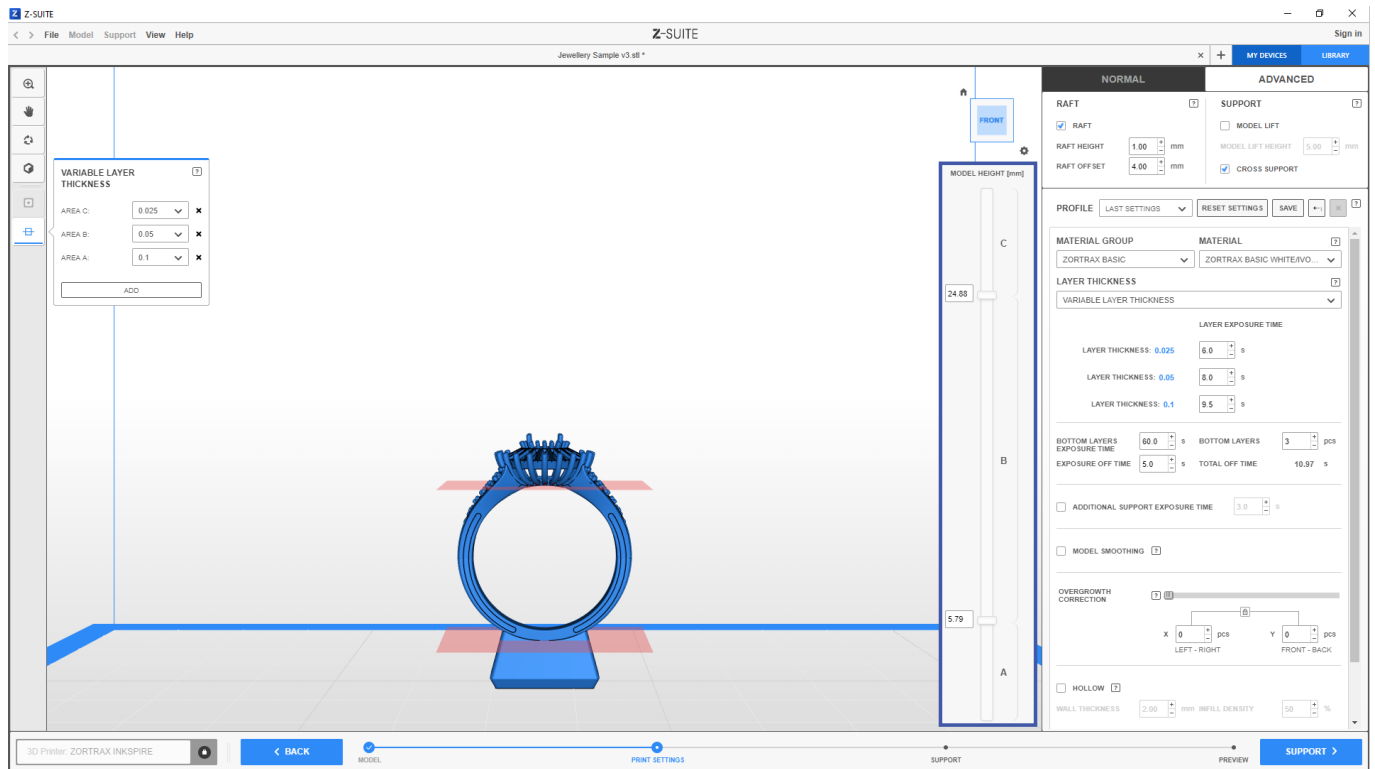

Once you add the first divider, you can add more dividers by double-clicking on the **Model height** bar that appears on the right. Also, you can click and hold the divider on the Model height bar to move the added divider along the model in both directions.

Deleting Areas
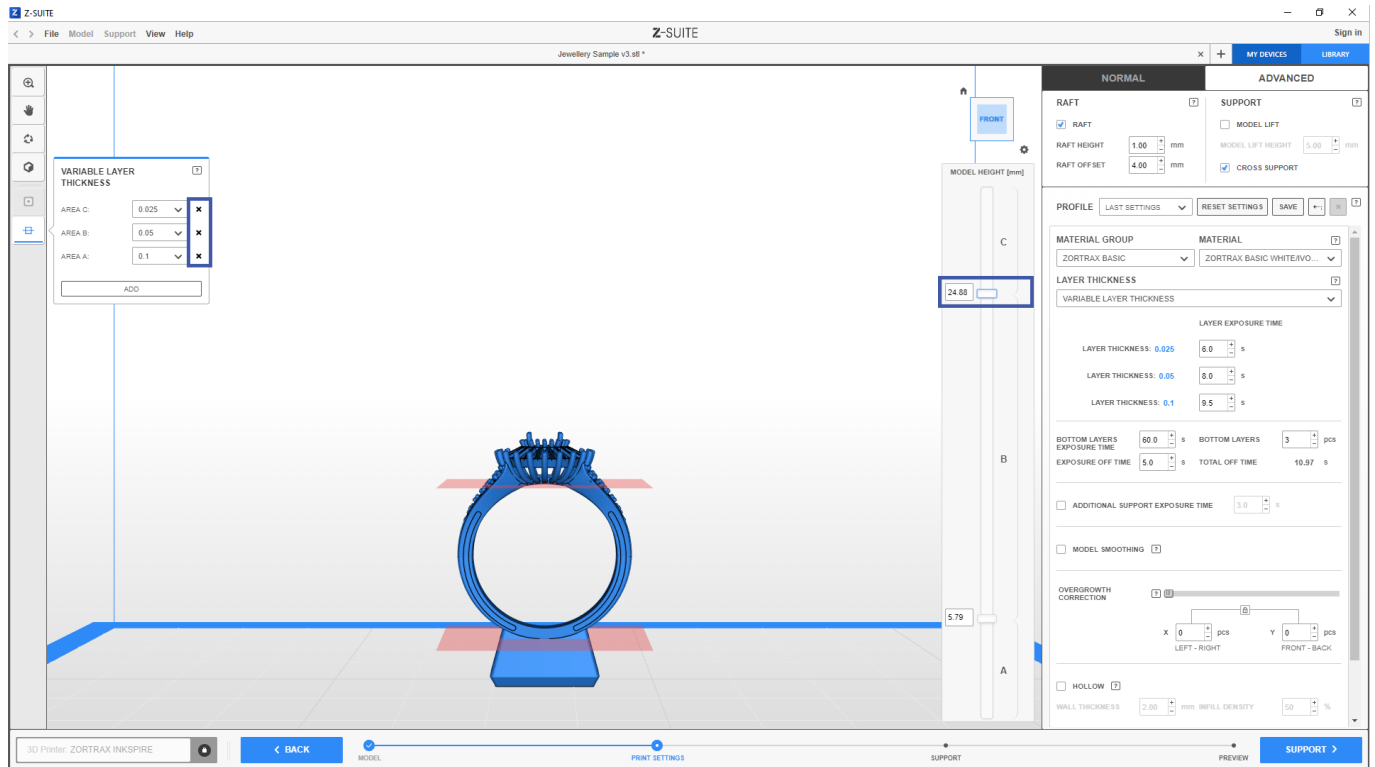
You can delete an area with the cross icons (**x**) in the Variable Layer Thickness menu on the left or by clicking on a divider on the Model height bar on the right and pressing the *Del* button on the keyboard.

Layer Exposure Time Settings
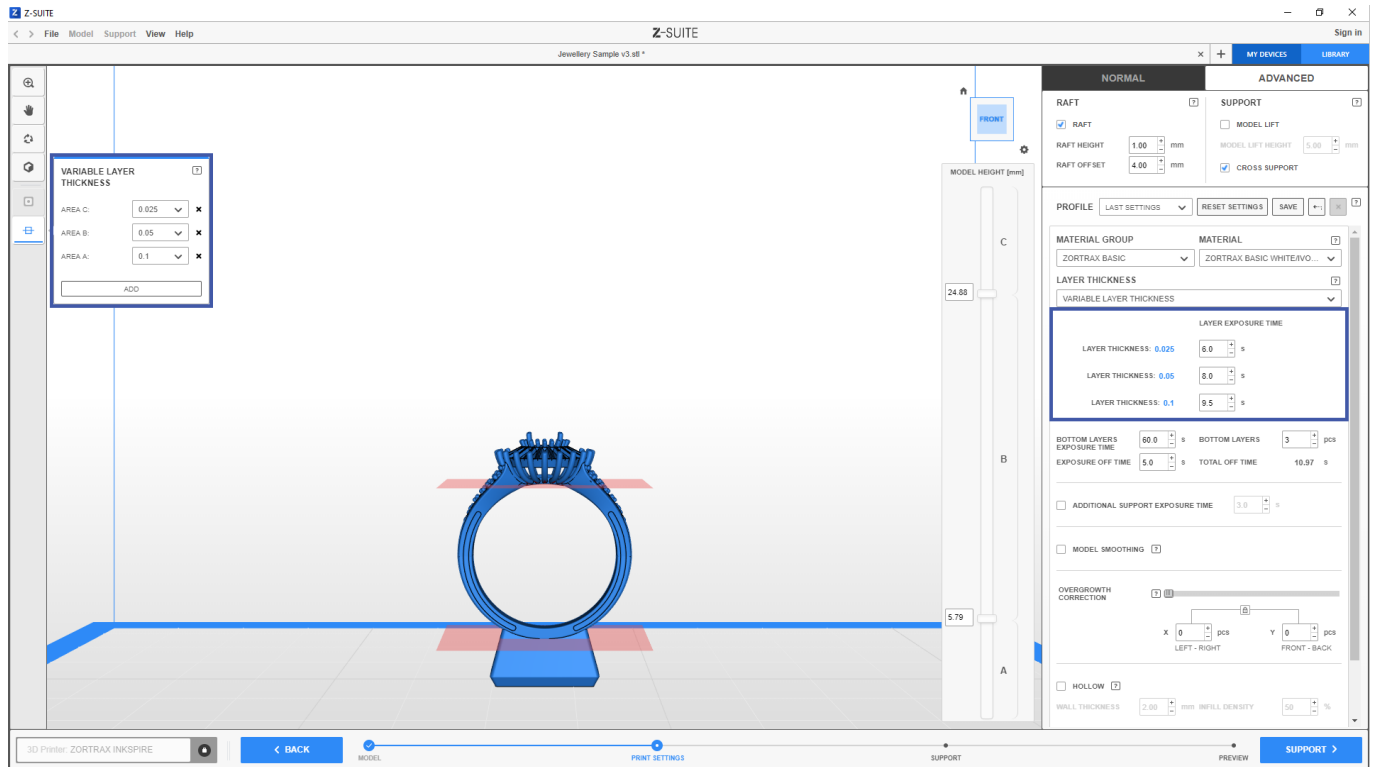
Once you add a selected number of dividers to your model, adjust layer thickness settings for each created area in the Variable Layer Thickness menu on the left. Select the desired layer thickness values from the drop-down list. Next, move on to the *Advanced Print Setting* menu on the right. In the *Layer thickness* section, you will see the default **Layer exposure time** values for the resin type you have chosen earlier. If you want to change the Layer exposure time settings for in the assigned areas, type in the desired value or use the +/- icons.

Remember that the same layer thickness values will have exactly the same layer exposure time settings, even when selected for different areas in your model.

Next, move on to the **Preview** step where the program will generate a .zcodex file. Layer thickness settings for your model are also saved in a .zprojx file and are available once you open the Variable layer thickness menu after loading a project.