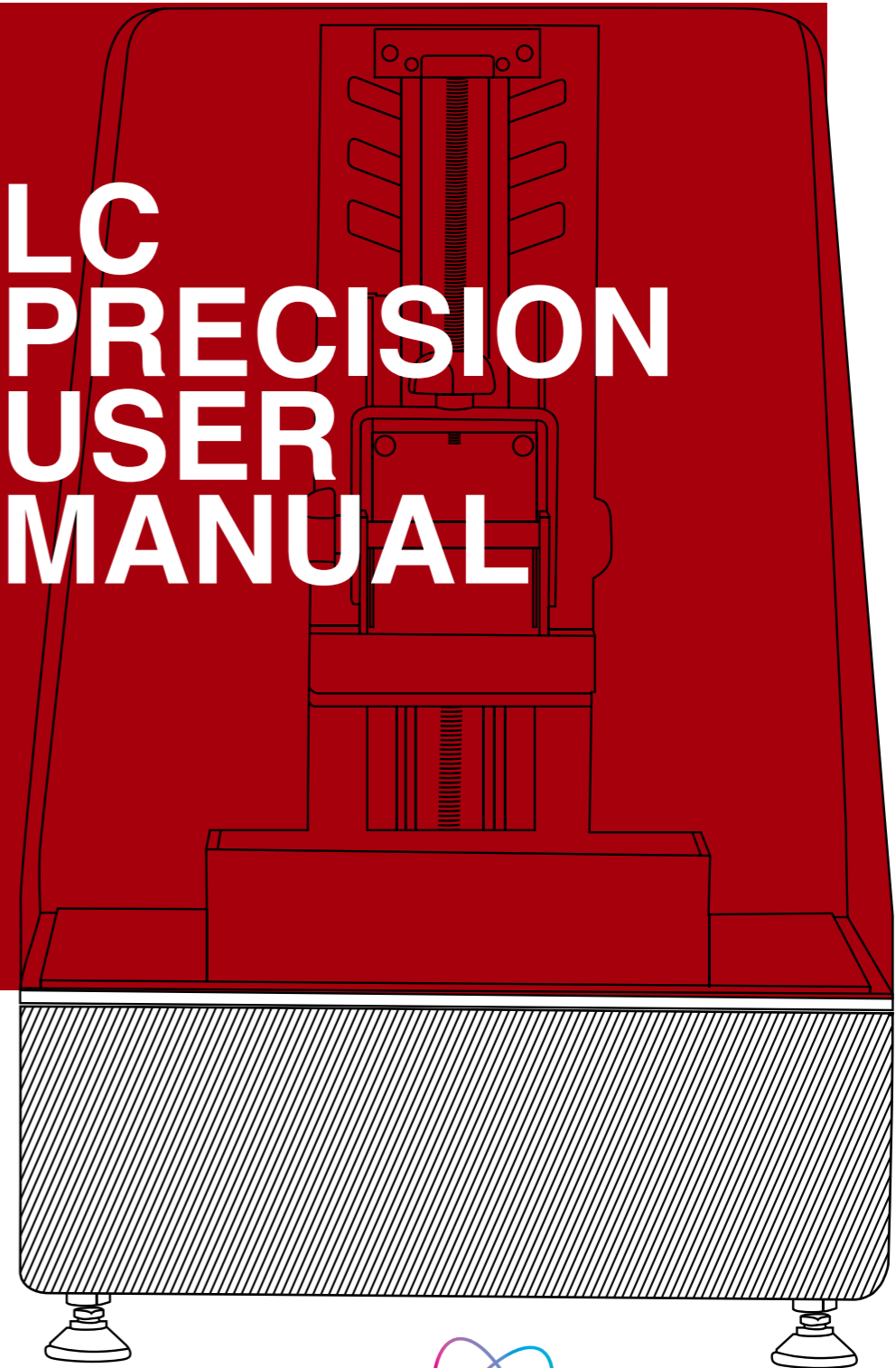


THE NEXT GENERATION
OF 3D PRINTING
IS HERE

LC PRECISION USER MANUAL



Liquid Crystal
PRECISION



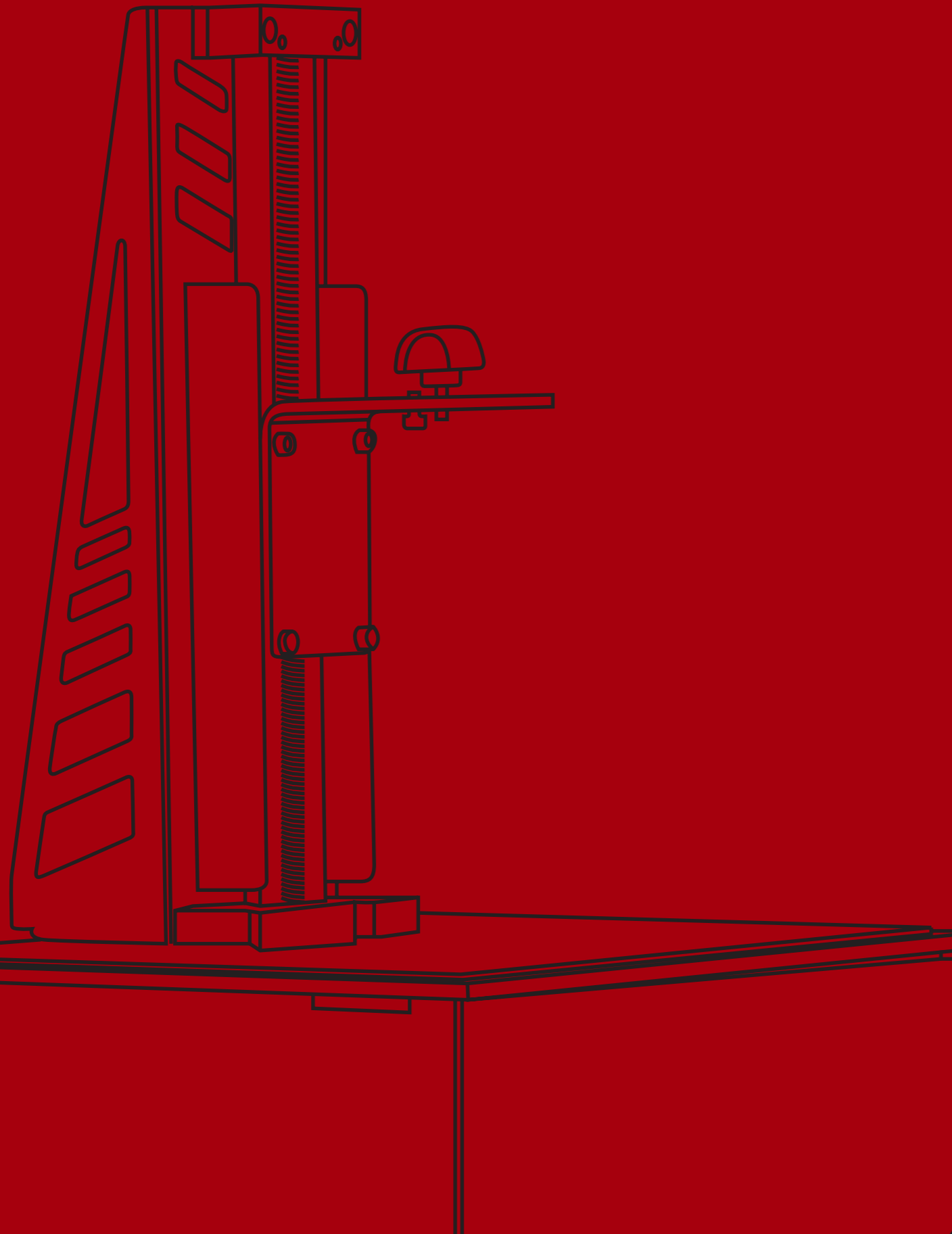
DISPOSAL INSTRUCTIONS

Do not throw this electronic device into the waste when discarding. To minimize pollution and ensure utmost protection of the global environment, please recycle or return to Photocentric for recycling.

UK
Cambridge House, Oxney Road
Peterborough PE1 5YW UK.
info@photocentric3d.com
www.photocentric3d.com

USA
2205 West Parkside Lane, Phoenix,
85027, AZ USA
info@photocentric3d.com
www.photocentric3d.com

LC PRECISION USER MANUAL



Liquid Crystal
PRECISION

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Liquid Crystal
PRECISION

EU DECLARATION OF CONFORMITY

LIQUID CRYSTAL 3D-PRINTER

Model: LC Precision

We hereby declare that the product above is in compliance with the essential requirements of the following:

Low Voltage (LV) Directive 2009/95/EC, 2014/35EU. Electromagnetic Compatibility Directive(EMC), 2004/108/EC,2014/30/EU.

Restriction of the use of certain hazardous substances (RoHS) Directive, 2011/65/EU Commission Regulation (EU) No. 453/2010 and IEC 60950-1 Safety of ITE

Technical Documentation is stored at the manufacturer's address above.

Date of Issue: 15. January 2018
Place of Issue: Peterborough

Amanda Keating
Director

Manufacturer
Photocentric Ltd
Cambridge House, Oxney Road
Peterborough, PE1 5YW, UK
Year of CE Marking: 2018



Liquid Crystal
PRECISION

USER MANUAL

NEW DAYLIGHT TECHNOLOGY
HIGH RESOLUTION
3D PRINTER



Congratulations!

You have just purchased a new type of 3D printer using Daylight Polymer Printing (DPP) technology. This is a patent applied-for method of image creation that hardens liquid with the normal visible light emitted from an LCD screen. This revolutionary system is a new method of Additive Manufacturing that uses the same intensity and part of the spectrum that we use to see. This is the energy providing source that initiates the free radical or cationic polymerisation necessary to change the liquid photopolymer resin into your hardened object. The light emitted from the screen is not modified and the images are safe for viewing.

These are some of the advantages of DPP technology:

- i) Low cost- We use high resolution low cost LCD screens that are widely available in monitors, tablets, mobile phones and televisions. These provide phenomenal value for money, which we pass onto you.*
- ii) Reliable- Because we use visible light which is designed to function with LCDs and not UV light which shortens LCD screens life.*
- iii) Very large scale- The screen lights every pixel,*

which in turn exposes every voxel, so you can create large areas of custom product simultaneously. As the format grows this makes it much more efficient than all alternative means.

- iv) Very low energy usage- It uses the amount of electricity to run a tablet, this is an order of magnitude lower than that required to operate a laser or a digital light projector.*
- v) Low adhesion at the build interface- the heat created by the screen is very low and the small amount of initiation energy in the polymerisation creates very little attraction to the vat film.*
- vi) Limited over-exposure- Using this low intensity visible light, the energy is dissipated very quickly, it either strikes a photoinitiator and creates a free radical or it loses all the energy hitting solid material, so there is very limited ability to over-expose and create solid parts where you don't want them.*



Liquid Crystal
PRECISION

SAFETY INFORMATION



Read the instructions carefully. Keep this document for future reference. Follow all warnings and instructions marked on the product. Observe the following guidelines when connecting and disconnecting power to the external power supply unit:

- Install the power supply unit before connecting the power cord to the AC power outlet.
- Unplug the power cord before removing the power supply unit from the printer.
- Operate on a table or flat, stable surface, ensuring that the machine cannot fall and is level.
- Do not operate outdoors.
- Do not allow resin or any liquids to get inside the chassis, wipe up any liquid spills immediately.
- Do not spray solvents or soapy water directly onto the printer as they may damage the screen. Use a damp tissue to clean off any resin spills.
- Disconnect the printer from AC before storage or when not used for a long period of time. This 3D printer is connected to the electrical network with an input of 110 or 240 V AC, 50/60 Hz, and has an operational voltage of 48 V.
- Do not allow anything to rest on the power cord. Do not locate this product where people will walk on the cord.
- If an extension cord is used with this product, make sure that the total ampere rating of the equipment plugged into the extension cord does not exceed the extension cord ampere rating. Also, make sure that the total rating of all products plugged into the wall outlet does not exceed the fuse rating.

- Do not overload a power outlet, strip or receptacle by plugging in too many devices.
 - Use the product only with the supplied power supply cord set. If you need to replace the power cord set, make sure that the new power cord meets the following requirements: detachable type, UL listed/CSA certified, VDE approved or its equivalent, 4.5 meters (15 feet) maximum
 - In case of malfunction, disconnect the printer immediately from the power supply.
 - Do not attempt to fix this product by yourself, as opening or removing covers may expose you to dangerous voltage points or other risks. Refer all repairs to qualified service personnel. Please send an email to your national supplier or contact technical service at: info@photocentric.co.uk
- Unplug this product from the wall outlet and refer servicing to a qualified service personnel if:
- The power cord or plug is damaged, cut or frayed.
 - Liquid has been spilled in the machine.
 - The machine was exposed to rain or water.
 - The machine has been dropped or the case has been damaged.
 - The machine does not operate normally after following the operating instructions.



Liquid Crystal
PRECISION

SAFETY GUIDELINES



IRRITANT

- Keep the printer and resins out of the reach of children.
- The resin is an irritant to skin and eyes. Always wear gloves when coming into contact with the liquid resin. Always use in a well ventilated room.
- Resins are classified as irritants, not harmful, but in exceptional circumstances people can be sensitive to the resin and develop a skin irritation or rash. Avoid this possibility by always wearing gloves and avoid breathing fumes.
- The printer should be operated on a stable and level surface, preferably away from direct ambient light.

Please note that the latest instructions will always be available from:

www.photocentricgroup.com/support

DISPOSAL INSTRUCTIONS



Do not throw this electronic device into the waste when discarding. To minimise pollution and ensure protection of the environment, please recycle or return to Photocentric for recycling.



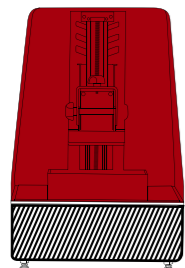
Liquid Crystal
PRECISION



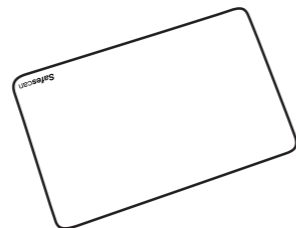
Liquid Crystal
PRECISION

CONTENTS

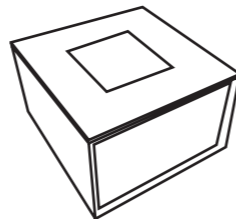
The box contains



Liquid Crystal Precision with red hood.



Vat cleaning tool



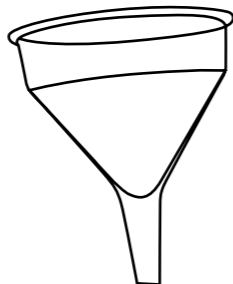
Print sample



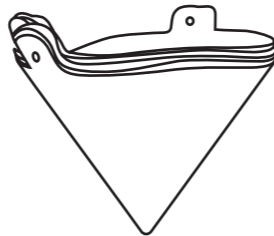
Spray Bottle



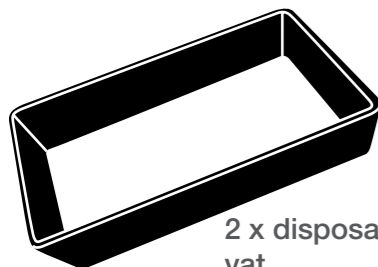
Scraper



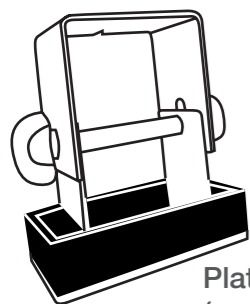
Funnel



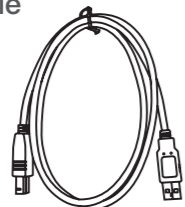
Paper resin filters



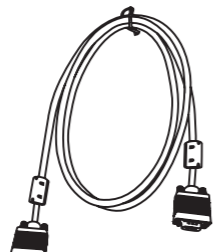
2 x disposable vat



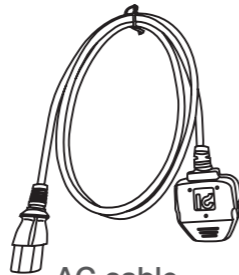
Platform (assembled)



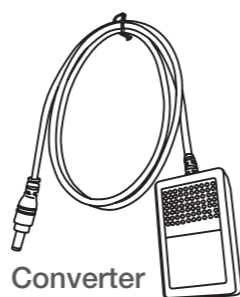
USB cable



HDMI cable



AC cable



Converter

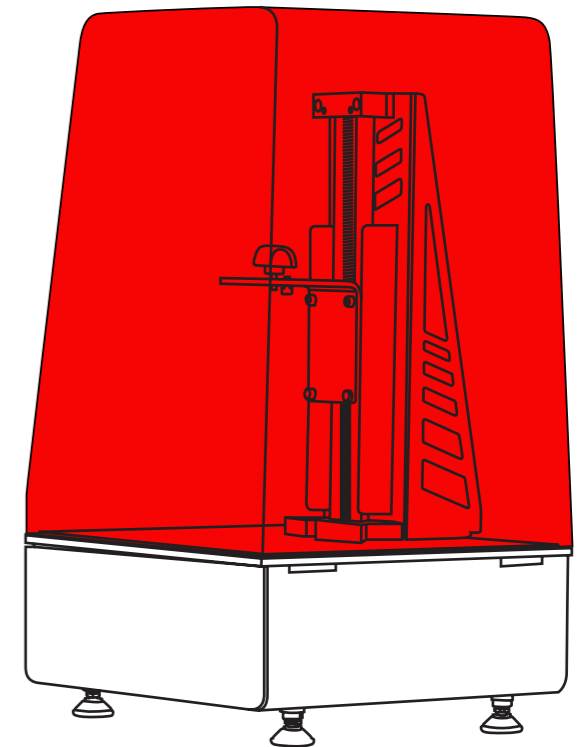
RECOMMENDED ITEMS

- Extra gloves.
- Paper towels.
- Access to a sink with hot water to clean the object.
- Liquid Soap (detergent) to clean the object.
- Soft brush or sponge to clean the object.
- Glass or clear plastic container to post expose the object in.
- Ultrasonic Cleaner (Optional)
- Isopropyl alcohol (IPA) to clean the product (Optional)

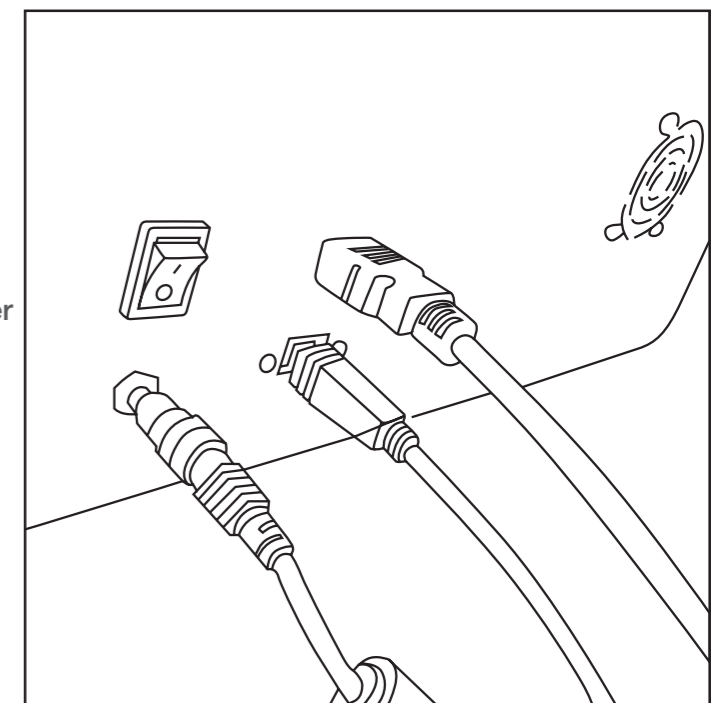
1. INSTALLATION & ASSEMBLY INSTRUCTIONS

ASSEMBLY INSTRUCTIONS

1. Open the box and carefully remove the printer package, by holding the side handles.
2. Remove the ancillary box from the bottom of the box.
3. Open up the printer package, remove the hood and then remove the printer.
4. Place the printer in the work area. Make sure the printer stands level and stable on four feet. If it is not level you can easily adjust the height of the feet by turning them clockwise or anti clockwise accordingly.



5. Connect the USB cable, HDMI cable and Power cable supplied to the back of the printer.



MINIMUM COMPUTER REQUIREMENTS

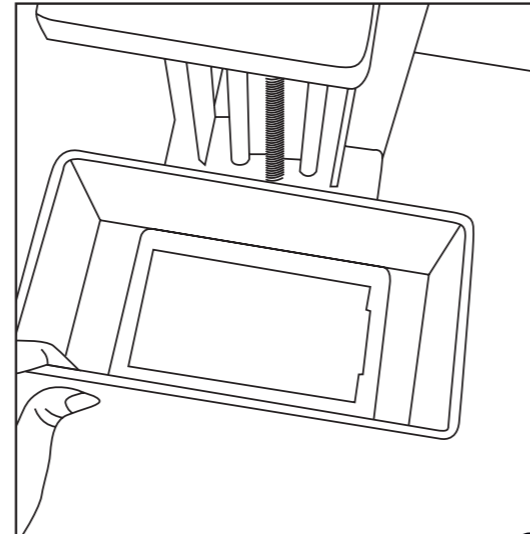
- 1.2 GHz processor or above.
- Windows
- 2 GB RAM memory or above.

A one year Creation Workshop License is included with this printer. Please activate your license number on initial printer set up. The license number can be found on the back of the printer.

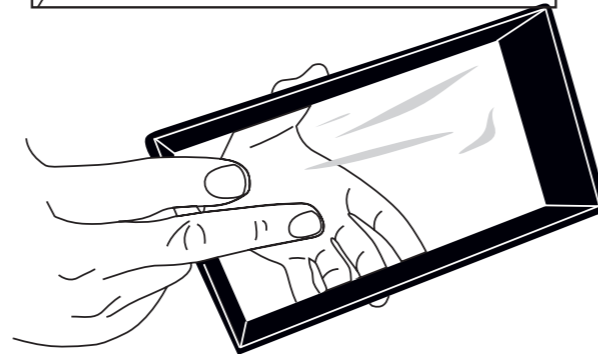


6. Do NOT remove the screen film which is protecting the upper surface of the screen and printer.

7. Remove one of the vats from the ancillary box and place it centrally over the screen.

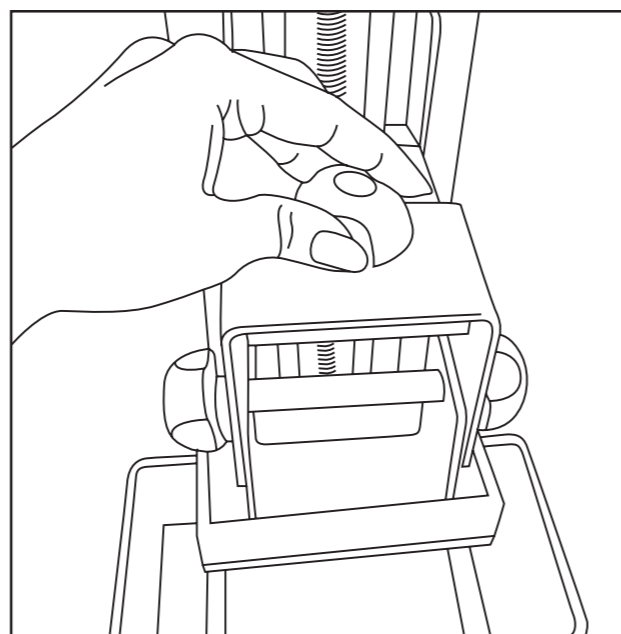


8. Check the film for any imperfections or holes; any problems with the film may cause a leak. The provided vats are disposable. You can use them as long as the film is not pierced or the vat is not damaged. However if you wish to you can change the film. To change the film, see section Re-Skinning Vat on pages 16-17. To check the integrity of the vat, fill it with water and stand for 5 minutes on absorbent paper, look for leaks and dry thoroughly before use. Once inspected, install the vat back into the machine. Before each print, wearing gloves, sweep the film completely down onto the screen to ensure that there are no objects on or under the film.



The vat should be tensioned, this can be checked by gently tapping on the film with your finger. not your fingernail!

9. Remove the platform from the ancillary box. Slide it onto the printer arm and tighten the top knob only, leave the two side knobs loose.



10. If you are experiencing difficulties setting up your printer please visit our website: www.photocentricgroup.com/support



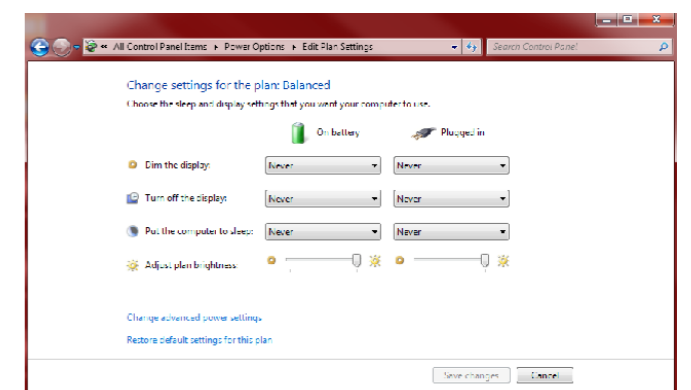
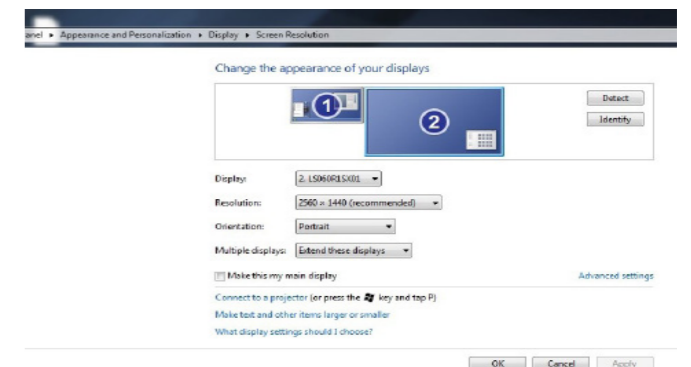
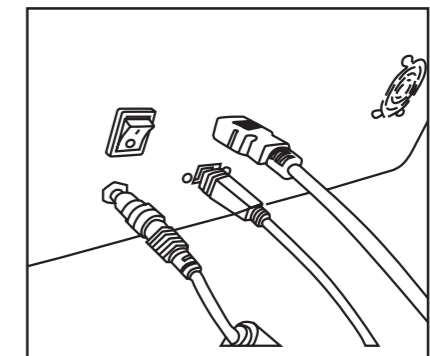
1.1. SOFTWARE INSTALATION

CREATION WORKSHOP

1. Go to www.photocentricgroup.com and download the “Liquid Crystal Precision Driver” and “Creation Workshop for Liquid Crystal Precision” which can be found on the support page. The latest version is always online.
2. Install the driver “CypressDriverinstaller_1” on your computer so that the USB port will recognize the Liquid Crystal Printer. Restart your computer.
3. Make sure the HDMI, USB and Power cables are plugged into the printer and then turn on the power using the rocker switch at the back.
4. Go to your computer desktop, right click and open “Screen resolution”. Set your screens to “Multiple Displays” and “Extend this display mode”, keeping your computer monitor as the main screen. Make sure that the printer’s screen is set to a resolution of 2560 x 1440. There are videos online if you need further help.
5. Configure your computer so that the screen-saver does not come on and ensure that it does not have the power-saving mode enabled. If you forget to do this your computer may shut down mid process and the printer will switch off.

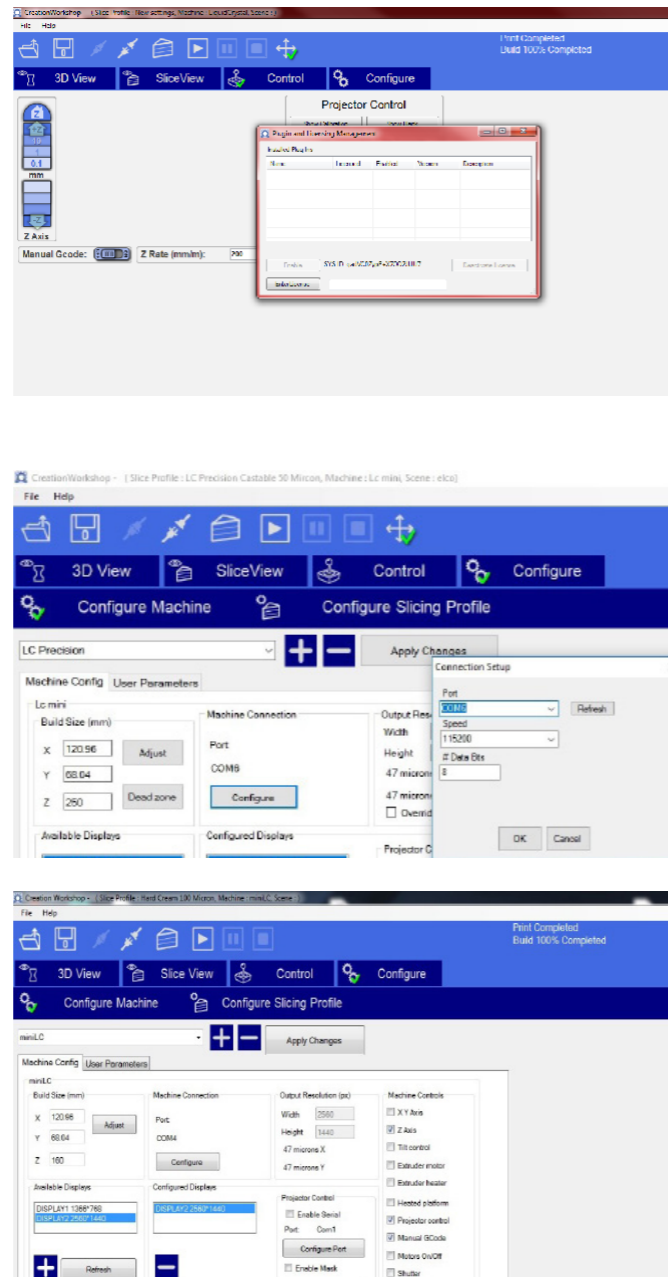
MINIMUM COMPUTER REQUIREMENTS

- Dual Core processor or above
- Windows
- Software NOT compatible with MAC and Linux
- 2 GB RAM memory or above



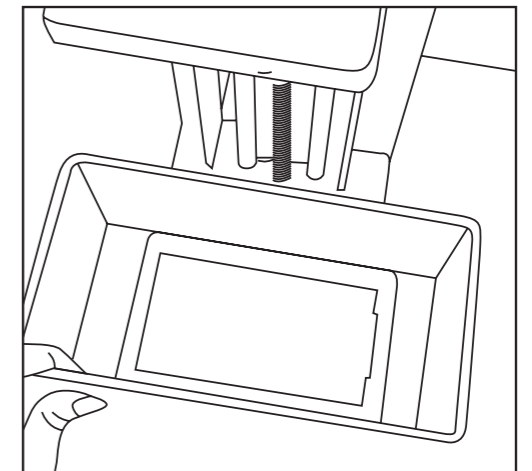


- Execute the Creation Workshop software by double clicking on "CreationWorkshop.exe". If the software requires a license number insert the license number supplied.
- In Creation Workshop, click on "Configure", and then open the subfolder "Configure Machine". In the configuration folder connect the printer to the computer by clicking on the button "Configure" in the Machine Connection section. Select the port you have connected the USB to and set the speed to 115200 and data bits to 8. Press "OK" on available displays and then select refresh. Once refreshed, choose Display 2560x1440 and press + to add it to Configured Screen and then press, Apply Changes. Now click [CONNECT ICON] to connect your computer and the Liquid Crystal.
- If you are experiencing difficulties to start or connect your printer, go to our website www.photocentricgroup.com, and visit "Support". You will find videos that will run you through the issues you may find due to specific computer settings. Should you still find difficulties, please contact your national supplier or contact us at info@photocentric.co.uk.

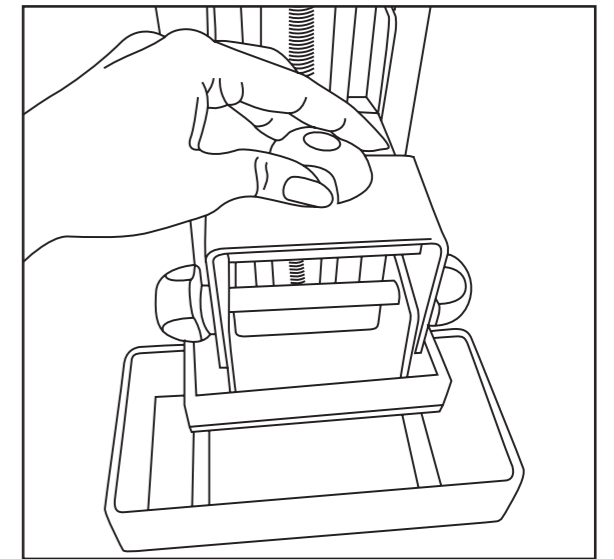


2. THE HOMING PROCEDURE

Ensure that the screen is clean (wipe with a little liquid soap and warm water if it's dirty) and dry. Place the vat centrally over the screen.

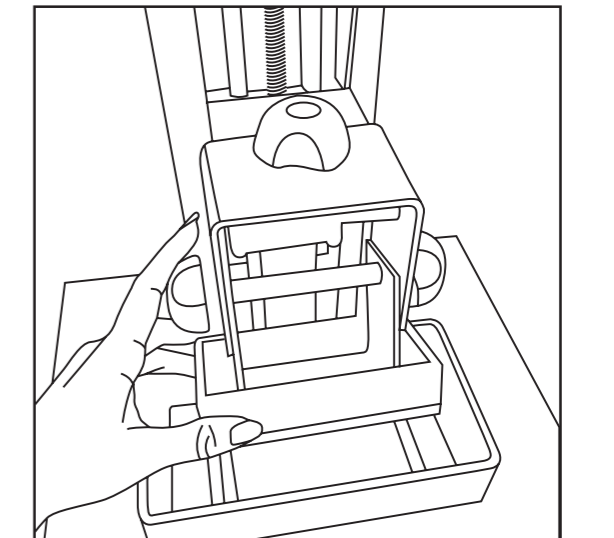


Ensure the base of the vat film is clean. Wearing gloves wipe the bottom of the vat film with a piece of absorbent paper. You can use soapy water or IPA to help cleaning. Make sure the print platform is clean by scrubbing with liquid soap and water and wipe dry. Place the platform on the print arm.



Tighten the upper bolt and loosen the two side bolts on the print platform.

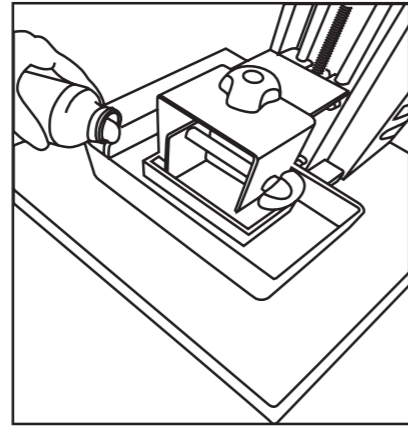
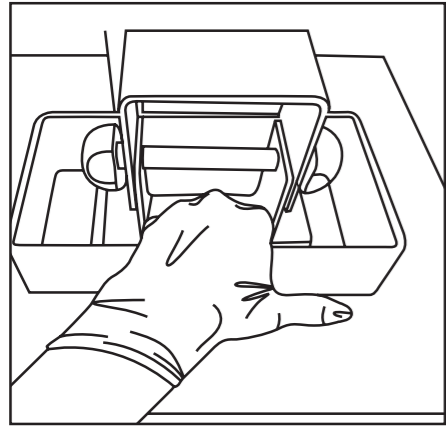
In Creation Workshop, go to the control tab and press the home button (located at the top of the z-Axis controls). This will lower the platform until the home switch is activated. Align the platform so that it is directly over the screen and tighten the central bolt.



Wearing gloves, press down hard in the middle of the metal platform and then tighten the two side bolts. Press '+10', and the platform will lift 10mm, pour the amount of resin you need, then press '-10' to return it to screen height and you are homed!



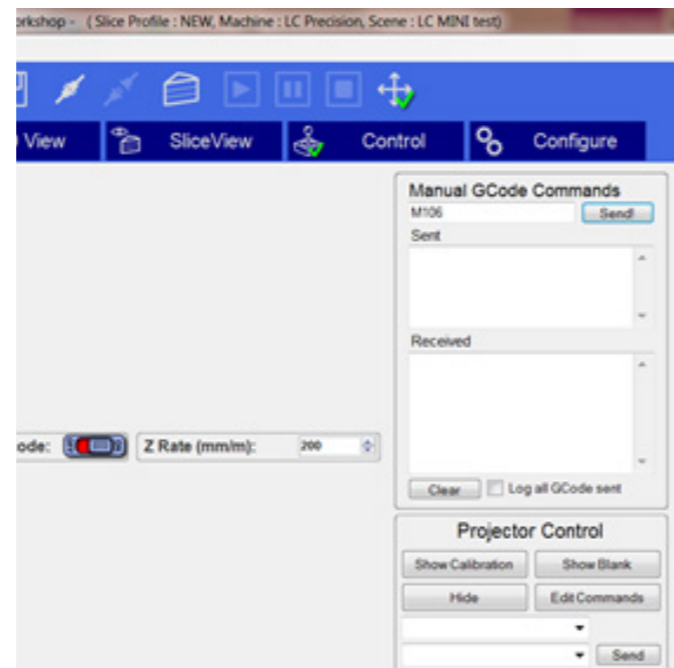
Liquid Crystal
PRECISION



NOTE: If you have an object that is 100 cm³ then it will use 115g of resin. Always overfill by at least 20% to ensure consistent resin flow. For most prints, filling the vat to 1/3 full is more than enough. Place the hood back on the printer.

NOTE: You can check the screen is working in the "Control" tab ; by activation manual Gcode, writing M106 in command bar, pressing send (backlight should come on at this stage), pressing the "Show calibration" button located and a blue grid will appear.

To turn off the backlight, send M107 command.



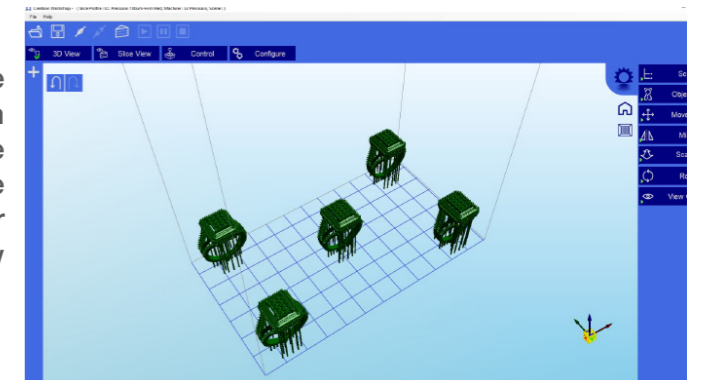
Liquid Crystal
PRECISION

3. STARTING A TEST PRINT

Now you have set up your printer, lets make your first print!

STARTING FROM CREATION WORKSHOP

Please download the CrossRings test file from the Liquid Crystal Precision support page. In Creation Workshop, click on the "Open" button in the top left and open the file "CrossRings x5". Please note this file is very large and depending on your computers processing power this make take few seconds to open up. Press the "Print" button.

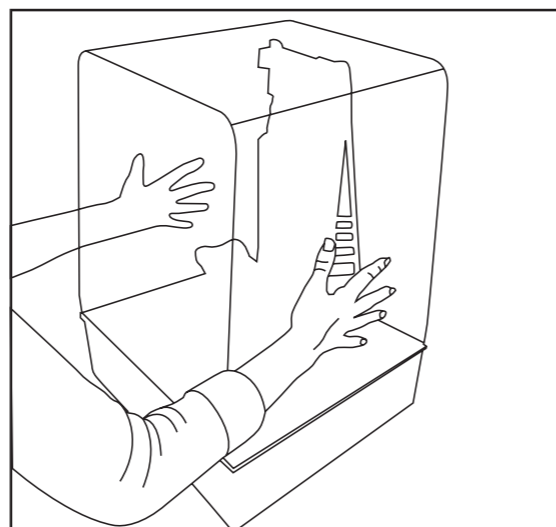
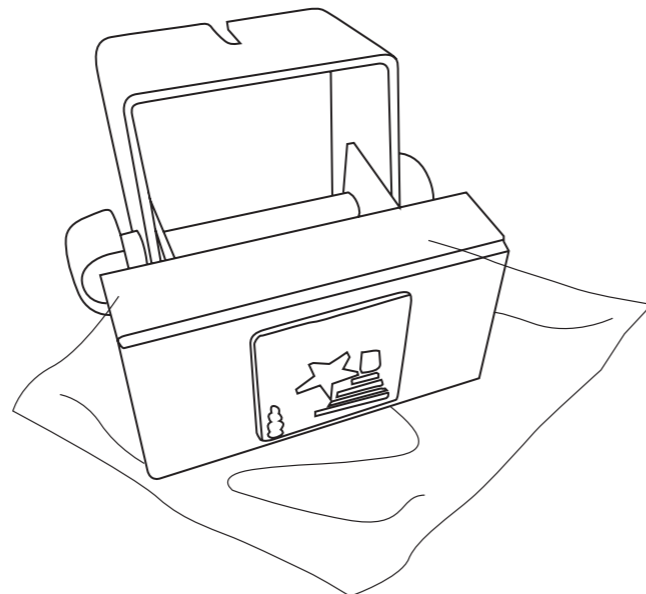
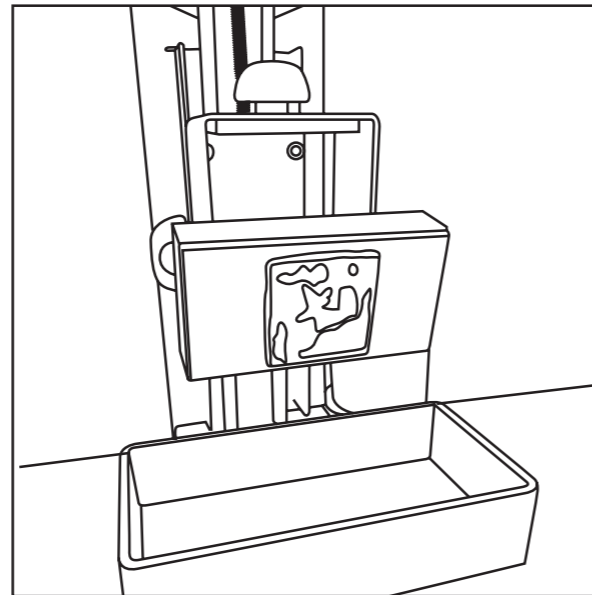




Liquid Crystal
PRECISION

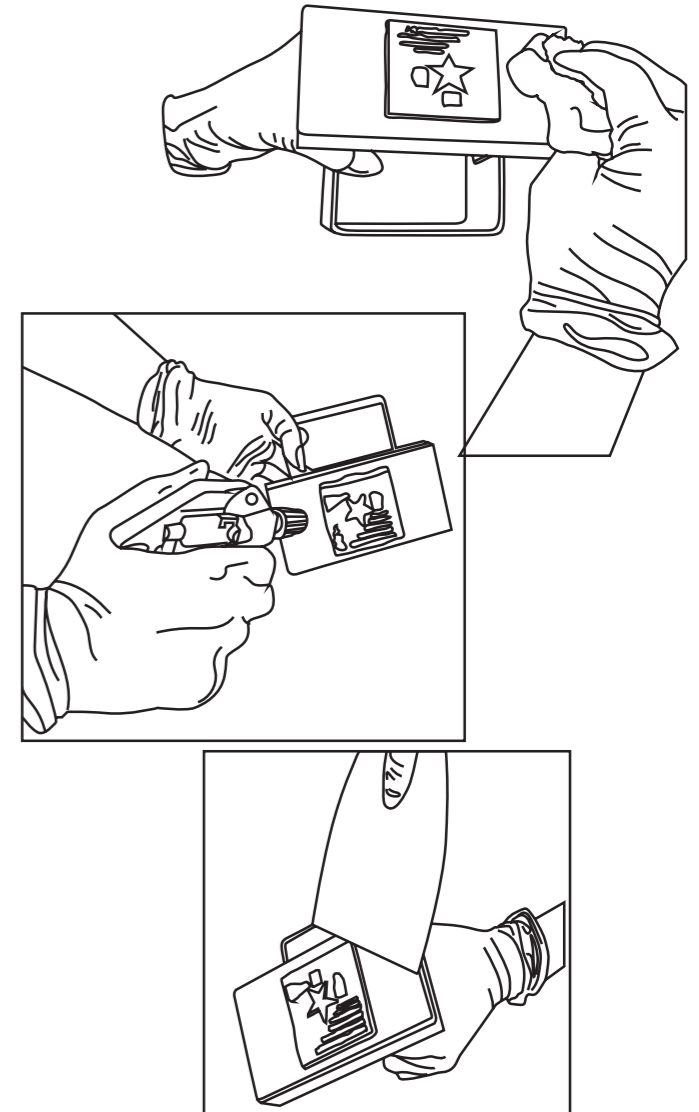
4. WASHING

1. When your print has finished, press the '+50' button and the platform will rise to above the level of the vat. Remove the hood and loosen the two side bolts, tilt the platform slightly to allow the resin to drip off. Adjust vat position on the tilted platform if needed. Put the hood back on and leave to drain for a few minutes.
2. Remove the hood again and with absorbent paper under it, remove the platform completely and set it down on the paper. Place the hood back on to protect the resin in the vat from light.



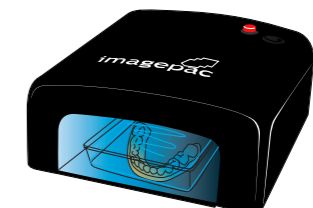
Liquid Crystal
PRECISION

3. After all the liquid resin has drained off, gently remove any excess polymer with absorbent paper. The fastest way to clean it and achieve a dry surface is by spraying or immersing it in IPA. Spray thoroughly to make sure all of the details, such as miniature holes, are free from excess resin. Alternatively, you can wash it in hot water and detergent. Likewise, you can use a hot soapy water spray to make sure excess resin has been cleaned from detailed areas. To avoid a fragile part being damaged, you can hold the part under running hot water and gently clean it with a soft brush or sponge and liquid detergent. To remove the object from the platform, slide a scraper in at the base and cut off the supports. Take care not to damage the print as it will not achieve its full hardness until after post exposing in light. A small ultrasonic cleaner filled with fresh soapy water or IPA is recommended to clean delicate objects.



5. HARDENING

1. When completely clean, place it underwater in light (UV, sunlight or a table light) for a least 30 minutes to remove the surface tack. The part will only have around 1/4 of its final strength before post-exposure and strength increases slowly with more light. Full strength is achieved with 30 mins in a UV unit, or 60 mins under a normal 60W table lamp. Then remove from water and dry.



30 mins
post exposure

60 mins
post exposure

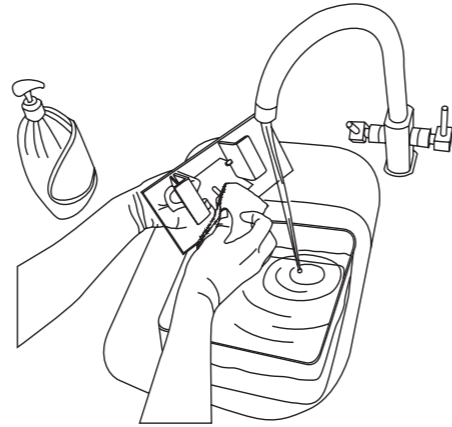
60 mins
post exposure



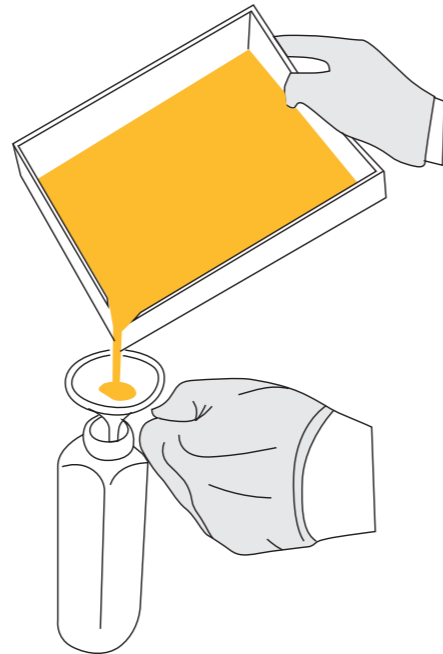


6. PREPARING FOR THE NEXT PRINT

1. Scrape off any cured resin and clean the build platform with hot water and liquid detergent. Dry it thoroughly before inserting it back into the printer.



2. Empty and clean the vat after every print. Be sure to clean it thoroughly as any solid pieces on the bottom of the vat would prevent the platform from homing correctly. Loosen the thumb screws and remove the vat from the printer; pour the resin back into the bottle through the funnel, using the strainer provided.



Refer to the video tutorial which can be found on the Liquid Crystal Precision support page.

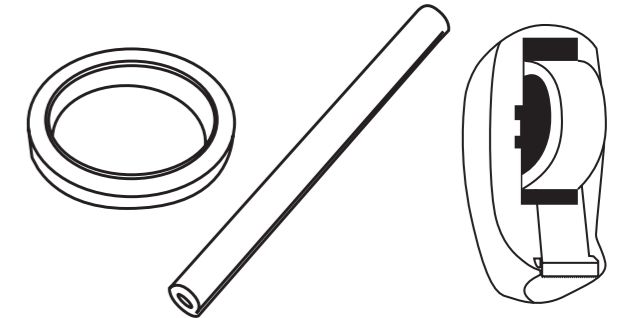
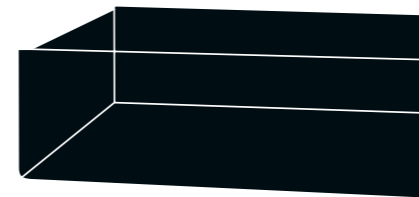
3. If you have a leak on the screen mop up the liquid resin immediately using absorbent paper, then clean the screen with a damp cloth with detergent. Hardened resin can be removed by chipping it off with a credit card or plastic scraper. Metal scrapers should only be used with extreme care to avoid scratching the screen.



7. RE-SKINNING THE VAT

Please read carefully.

A loose vat can have creases which create ridges in the base of the object.



TOOLS REQUIRED

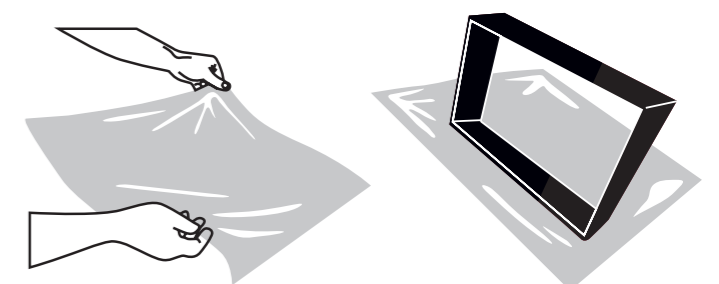
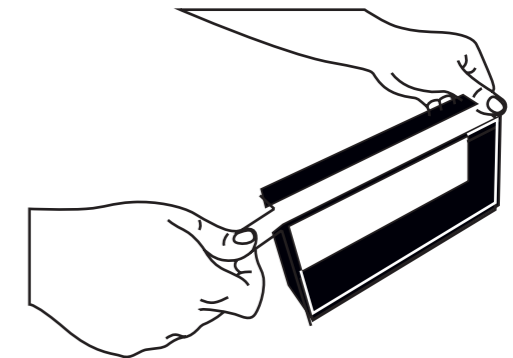
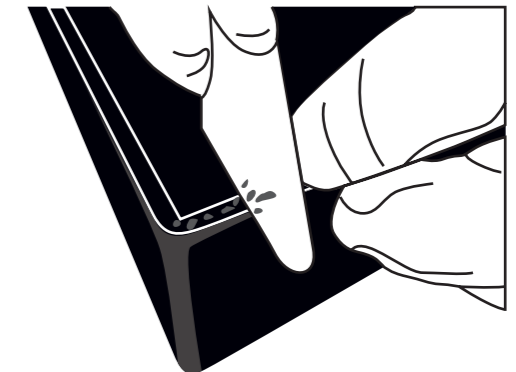
Scissors
Craft knife
Pallet knife

MATERIALS REQUIRED

Photocentric vat film replacement pack, single sided sticky tape, double sided tape and paper towel.

Re-skinning the vat is a simple process but care and attention must be paid to cleanliness and removing cured bits of resin. Make sure at each stage of the process that the work surface, vat, and your hands are very clean and free from debris that may cause holes in the film.

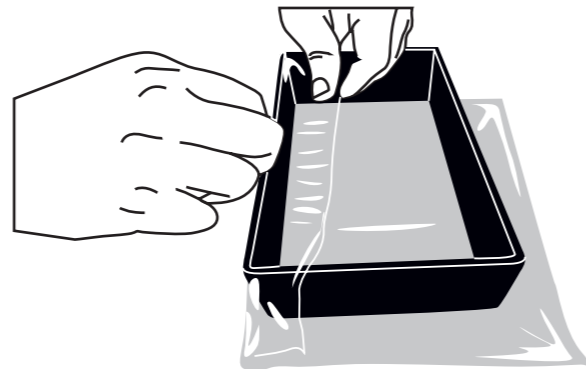
1. Remove the film currently taped to the vat and dispose of it. It may be possible to use the double-sided tape again if it has no resin on it. If the tape cannot be reused, remove it completely and replace on the lower edge of the vat.
2. Wipe the vat clean and wash all parts with soap and water. Pay attention to the underside of the vat, resin may have cured here. Remove any hard bits of resin as they may make a hole when tightening the new film over it.
3. Check the new vat film isn't pierced or dented and place it over the protective brown paper, on a flat work surface. Place one edge of the vat along the edge of vat film.



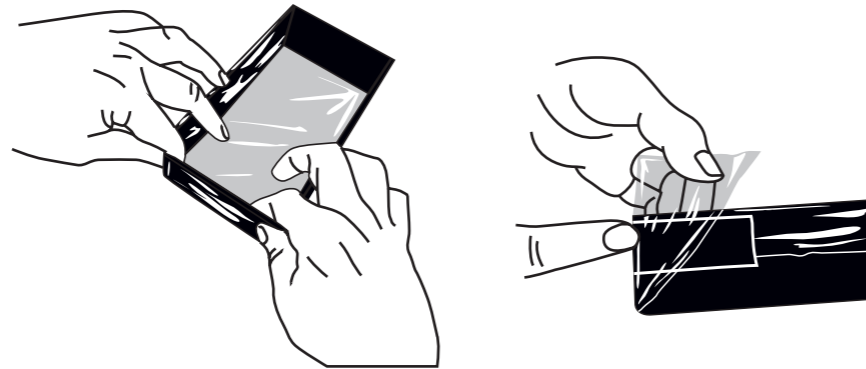


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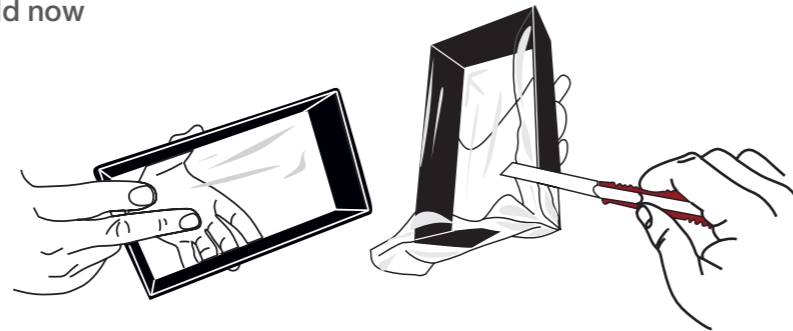
4. Fold over the other side of the film and pulling it firmly tight in the middle stretch the edges out so there are no creases.



5. Pull each side of the film up and onto the sides of the vat.



6. Apply single sided tape at the corners over the folds to keep the film tight. The vat should now be tensioned. Trim excess edges off.



7. Finally, fill with water and leave on absorbent paper to check for leaks. Drain and dry with paper towel before use.



If you are unsure of the process and need a video guide, then please visit the Support section of our website.



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8. PRINTING YOUR OWN PARTS

You should now have successfully printed the ring and it's time to print your own parts.

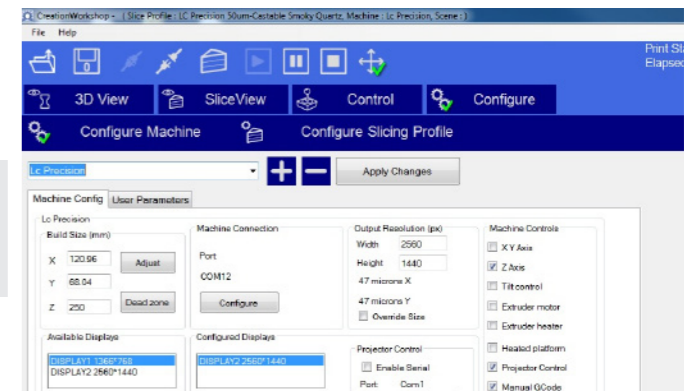
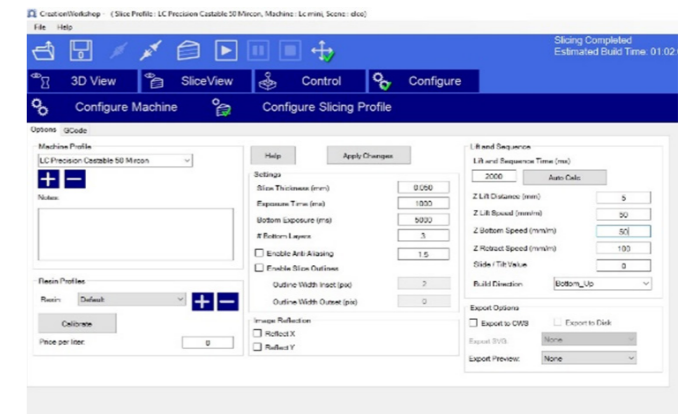
STARTING A PRINT WITH CREATION WORKSHOP

In this section, we will learn how to use Creation Workshop to prepare your 3D parts for printing.

1. Home the printer by consulting section 2 the homing procedur.
2. Open Creation Workshop.exe and load your objects (STL, OBJ or AMF).
3. With the object loaded and located in the build area check the settings of the printing profile. Go to the "Configure" screen and open the "Configure Slicing Profile" tab. Select the printing profile from the "Machine Profiles" list that matches your resin and desired resolution for example "LCPrecision High Tensile Cream 50 Microns".

Note: Always click "Apply Changes" to save if you had to change any values. If you don't click this your data will not be re-set.

4. Now click "3D View" and check that the object is correctly placed inside the printing area.
5. Press the slice button to start the slicing operation. A confirmation window will show. Always re-click the "Slice" button if you adjust the file in any way.
6. Now check the "Slice View" screen to check that the first layer of every object is in contact with the build base. If it is above the build platform it will not adhere. If you click on the view box located in the bottom left corner you can scroll forward through the slicing views using the slider bar and check that the object is always

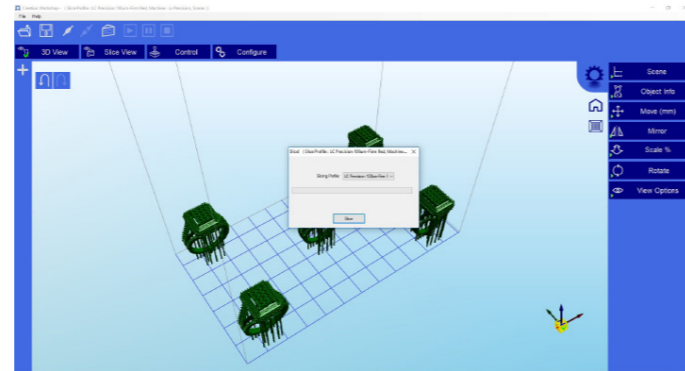




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inside the build area.

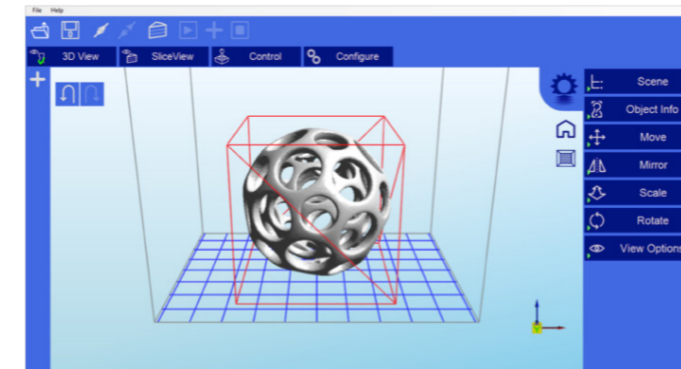
7. If you are happy with the slices, then press print



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9. DETAILED CREATION WORKSHOP SOFTWARE INSTRUCTIONS

Main screen



Click to open files in one of the following formats: **.STL**, **.OBJ**, **.3DS** or **.AMF**. You can also open scene files with the **.CWS** extension.



Click to save the current object as a **.STL** or **.CWS** file. The **.CWS** format allows you to prepare a scene to be printed repeatedly in the future, together with supports and positioning.



Click to start the connection between your computer and your Liquid Crystal 3d printer. Once the button is grayed out, this means that the printer is connected.



Click this button to disconnect your printer from the computer. If the button is grayed out, it means that the machine is currently disconnected.



These three buttons start, pause and stop a print. These buttons only become active once you have sliced your object.



3D View

Clicking this button allows you to view the 3D objects within their boundary box. You can add supports in this function.



Slice View

Clicking this button accesses the "Slicing" screen. You can see the individual slices that have been generated as well as the G-code.



Control

This allows you to control the z axis motor, home it and lift it after a print has finished.



Configure

This is the setup screen that allows you to configure the slicing and printing profiles.



1. Loading a Model



Click here to 'Load' your file. Multiple objects can be loaded and manipulated independently. You can also open scene files with the .CWS extension.

2. Scene View

The Scene View allows you to manipulate various aspects of the scene.

Selecting

You can select a model by double clicking on the model, or selecting it with the scene view

Removing a Model

You can remove a model by right-clicking on the name in the scene graph and selecting "Remove". The Minus sign "-" will also remove the current model. You can also delete a model by selecting it and then pressing the "delete" key on your keyboard.

Cloning a model

You can select a model in the scene and click the "+" sign to clone it. The cloned object will appear

3. Object Info

This tabs provides you with information about your model

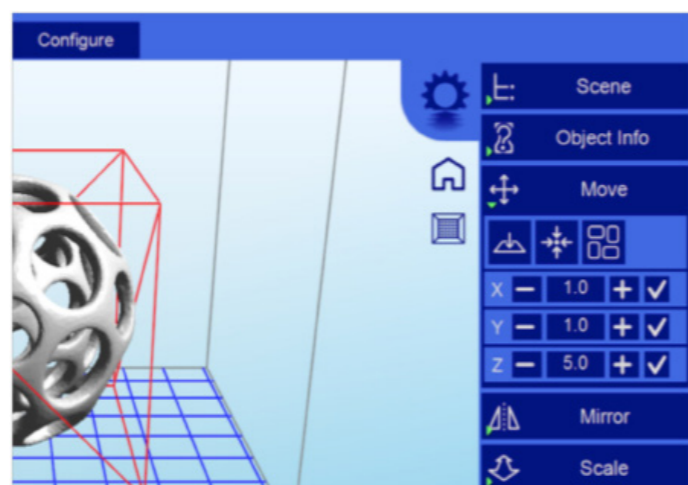
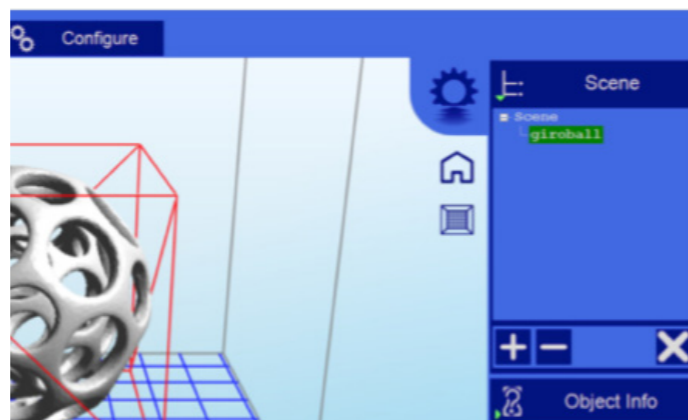
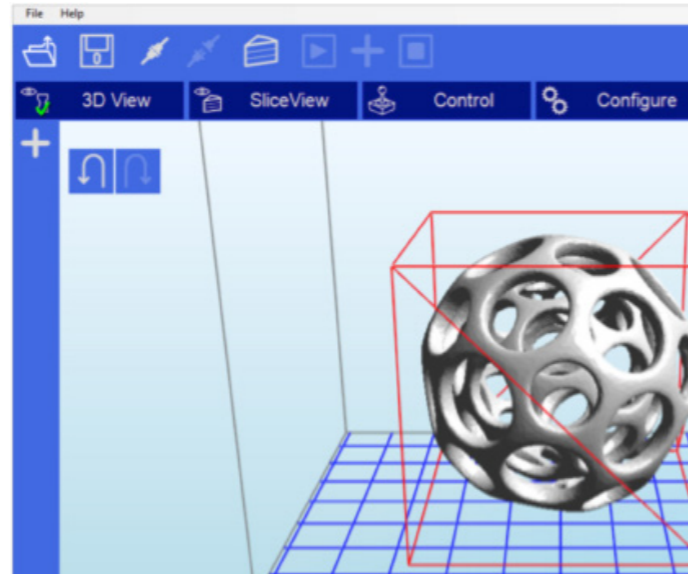
4. Move View

The Move function allows you to move objects on the build platform along the x:y:z axis by the distance entered.

From left to right, the other tools are:

The 'Place on Platform' button will position the bottom of the model to rest on the bottom of the build platform.
The 'Center' button will center the model at (0,0,0).

- Auto-Arrange will automatically lay out all models to fit on the build platform. Any model that does not fit within the build platform will be moved outside the build area.



5. Mirroring Objects

The Mirror view allows you to mirror the selected object on the specified axis.

6. Scaling objects

A model can be scaled (reduced or increased) by selecting it, and using the 'Scale' view to enter in a new scaler value. Press the tick button to re-scale your object.

7. Rotating Objects

Rotating a model works in a similar way to moving a model. Simply select the model you want to work with, and use the X/Y/Z +/- buttons to rotate the model by your specified degrees.

8. View Options

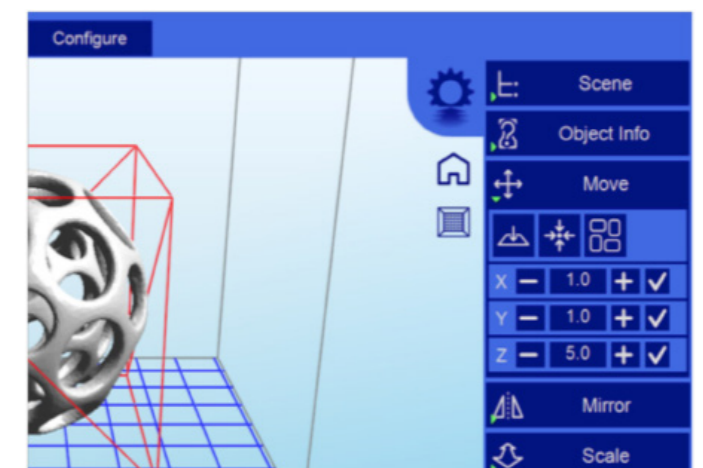
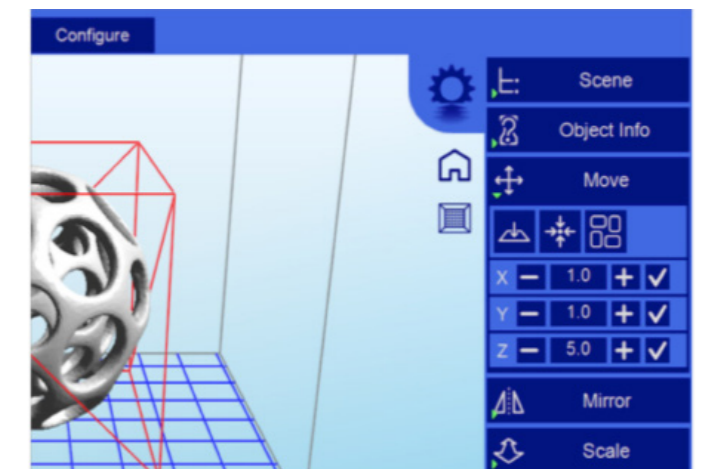
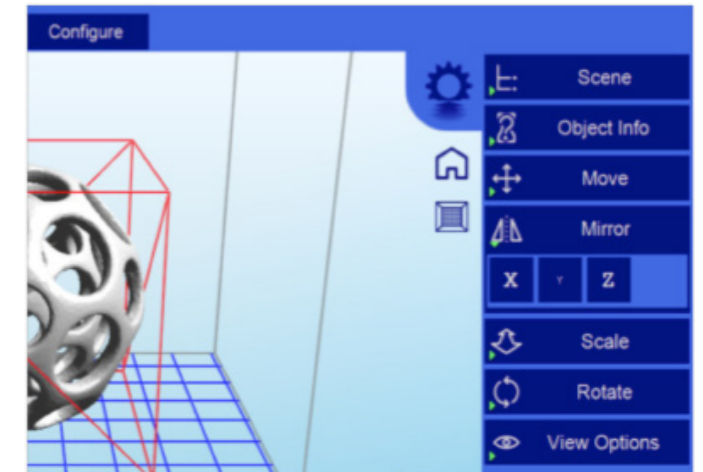
The view option allows you to manipulate various views and models.

On the top row from left to right:

- 50% Alpha-Blending toggle. This will allow you to see through the objects in the scene to see the geometry
- Show Slice Preview on Scene. After slicing this toggles on/off the view of the 3D view of the current slice layer as selected by the horizontal scrollbar.
- Show Console. This toggle button shows or hides the debug window. This window is used for debugging purposes.

On the bottom row from left to right are tools to change the way the objects appear on the screen:

- Show objects with a bounding box.





9. Working with Model Support tools

Using Supports

Supports are sometime required to properly attach a model to the build space. Because of the nature of DPP the lower layers must be supported by the supports unless it has a wide surface in the first layers. We recommend checking no supports pass through your object. If they do, you can delete them and manually add others if needed.

Adding a single Support

A single support can be generated by clicking the manual support button.

Moving Supports

After a manual or automatic support has been generated, individual supports can be moved around the x:y plane the same way models can be moved. Select the support by double clicking on it to select it, and hold down the 'Shift' key on your keyboard and move the mouse. Supports will automatically scale vertically under the model they support.

Angled Supports

Supports can be angled inwards towards the objects they support. This can often resolve clearance issues with vertical supports. You can turn a vertical support into an angled support by selecting it, and holding the 'Ctrl' key and clicking on the model you want to support.

Manual Configuration

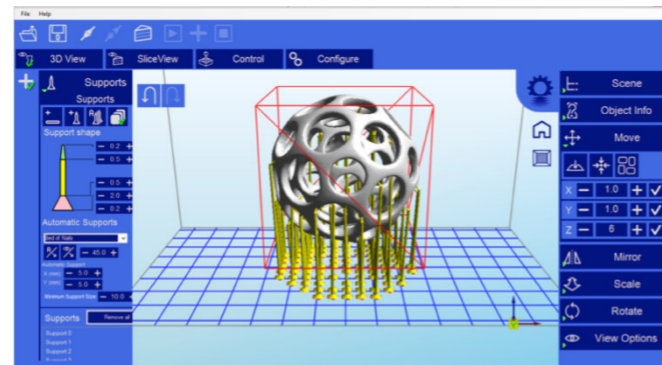
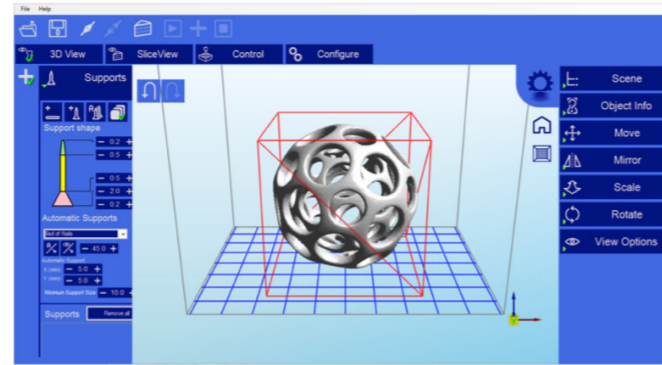
Under the Support Generation view, you can click 'show downward facing polys'. This will highlight all polygons in the model that are pointed downward by the specified degree. This helps you manually place supports under un-supported downward facing areas of a model.

Auto Support on Grid

After a model is loaded into the scene and selected, you can automatically generate a 'bed of nails' support for the model by selecting . You can specify the grid spacing and the size of the generated supports. If you wish to only generate supports on downward facing polygons, check the boxes under 'support general' and 'generate only on downward'

Adaptive supports

You can add supports to areas in the model that are unsupported. There are 2 algorithms to help you accomplish this.



10. Saving a Scene



Click to save the current object as a .STL or .CWS file. The .CWS format allows you to prepare a scene to be printed repeatedly in the future, together with supports and positioning.

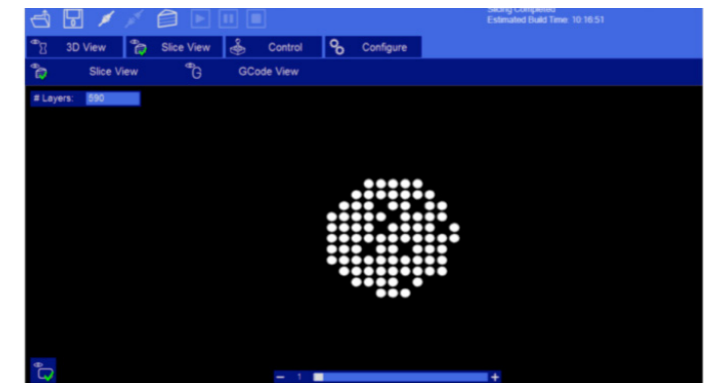
After one or more models have been loaded and manipulated on the build platform, the entire scene can be saved as an STL model for later use. Simply click on the 'File->Save Scene STL' menu item to save the scene model. This will flatten all models in a scene into a single STL file. Scenes can also be saved to CWS files.. These scene files can be used to create a scene with supports, slice the scene, and later load to print your scene without the need for re-slicing.

11. Slice View

In the Slice View screen we get the following information:

There are two buttons for each of the available options.

- The first option has the same name as the screen itself (Slice View). In this setting we can see (as shown in the image) each successive layer of the generated "Slicing". With the lower bar we can scroll through the entire slicing result to check each of the layers. In the upper left corner we can see the total number of layers that have been generated. In the lower left corner we have a () button to turn the projector on and expose the selected layer. This can be useful to check the positioning of the vat.
- G-Code View: On this screen you can see the G-code generated during the "Slicing" operation. This option is intended for advanced users. We recommend to leave this screen untouched.



12. Slicing a Model



Once you have loaded one of the models, configured your machine profile, and configured your build & slicing profile, you can slice a model. Choose the slice icon from the toolbar to bring up the slicing screen.

