build direction

layer height
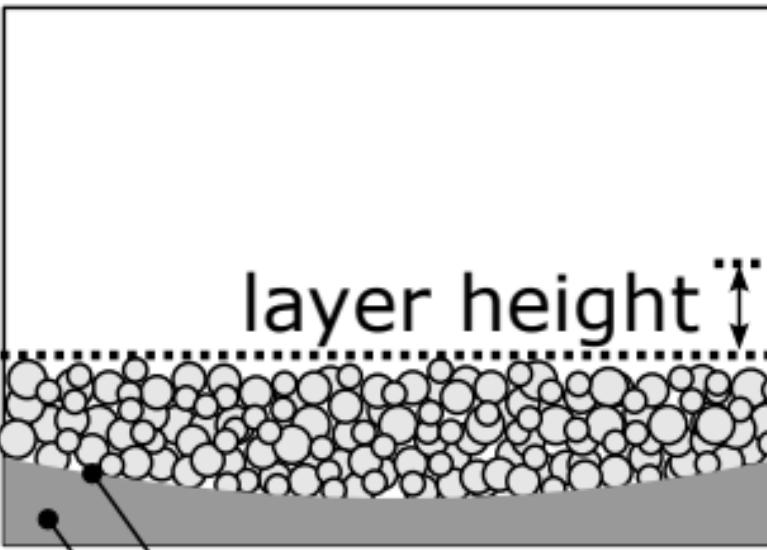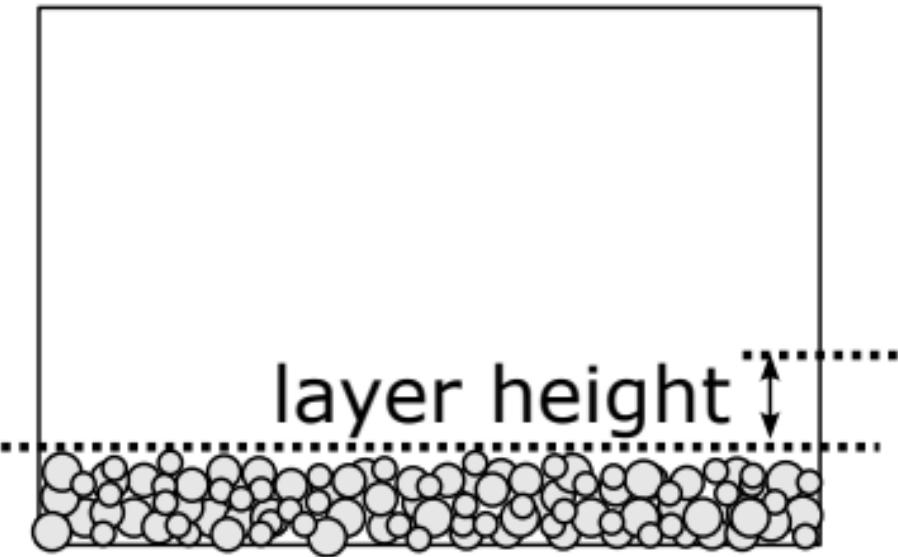
layer height

deformed surface

consolidated material