In the ever-changing music world and the various demands on the 21st century singer, developing a genre flexible voice through informed technical modification significantly increases a singer's ability to engage at the professional level. Voices are capable of many different sounds and through proper pedagogy, accurate anatomical/physiological information, adept kinesthesia, and informed nuance most singers can be genre fluid. This presentation will include demonstration and discussion of the anatomical and physiological variations necessary to negotiate between genres, specifically classical and musical theater. Discussion will include evidence of sub-glottic pressure variance, modifications of the vocal tract, registration, and slight resonance adjustments. There will be a brief introduction on current scientific theories of registration and a discussion of muscular balances in the head, mix, and chest registers. Boundaries of passaggi in the Soprano, Mezzo Soprano, Tenor and Baritone voice will be discussed as well as a thorough explanation of the specific technical variations necessary for passaggi negotiation. Demonstrations will include singers transitioning and negotiating through musical theater and classical modifications in both traditional and non-traditional vocal exercise, and the practical application of these concepts in repertoire from Bellini to Rogers and Hammerstein to Sondheim. This presentation will help to inform the aesthetic and bring empathetic awareness for the teacher as well as hone a habilitative practice of genre specific technical teaching in the voice studio.