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KANAKAPURA

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Answer Key

Duration: 30 Mins

Total Marks: 337

Q.ID: ITISKILL07587C

1. What is the standard colour code used for identifying the bin for the metal waste material?

- A) Violet B) Green
C) Blue D) Red

Answer: D) Red

2. Calculate the spindle speed to turn a 40mm dia M.S rod using a cemented carbide tool it cutting speed is 92mm/min?

- A) 685 rpm B) 731 rpm
C) 950 rpm D) 508 rpm

Answer: B) 731 rpm

3. What is the inclined angle of dead centre conical point?

- A) 30 Degree B) 50 Degree
C) 60 Degree D) 90 Degree

Answer: C) 60 Degree

4. Which work holding method is to be used if, high degree of concentricity is needed?

- A) In between centres B) Face plate
C) Three jaw chuck D) Four jaw chuck

Answer: A) In between centres

5. Which work holding device is used to hold irregular shaped work?

- A) 3 Jaw chuck B) Catch plate
C) Face Plate D) 4 Jaw chuck

Answer: C) Face Plate

6. Which method of holding is used for lengthy work to avoid over hanging?

- A) Angle plate B) In between centres
C) In face plate D) In four jaw chuck

Answer: B) In between centres

7. Which type of jig is used for large awkward shaped piece part is to drilled in many directions?

- A) Post jig B) Plate jig
C) Trunnion jig D) Table jig

Answer: C) Trunnion jig

8. Which of the following feed back devices can sense both speed and position?

- A) Tachometer B) Resolver
C) Encoder D) Motor

Answer: C) Encoder

9. How the two halves of split bearing is joined?

- A) On offset of shaft B) On length vice
C) On diameter line D) On chord line

Answer: C) On diameter line

10. Which code is suitable for multiple turning cycle in FANUC CNC control system?

- A) G96 B) G94
C) G92 D) G71

Answer: D) G71

11. What is the gear ratio if the lathe constant value is one?

- A) One B) Six
C) Three D) Two

Answer: A) One

12. Which one belongs to team work?

- A) Knowledge B) Soft skill
C) Technical skill D) Hard skill

Answer: B) Soft skill

13. Which heat process is increase the toughness and decrease the brittleness?

- A) Case hardening B) Normalizing
C) Annealing D) Tempering

Answer: D) Tempering

14. Which G-code is suitable for thread cutting?

- A) G30 B) G01
C) G34 D) G32

Answer: D) G32

15. What is lapping?

- A) Filing operation B) Grinding operation
C) Precision finishing operation D) Chiseling operation

Answer: C) Precision finishing operation

16. Which gear drives the fixed stud gear in lathe?

- A) Norton gear box
- B) Tumbler gear
- C) Feed shaft
- D) Apron mechanism

Answer: B) Tumbler gear

17. Which part of lathe slides over the bedways between headstock and the tailstock?

- A) Spindle
- B) Lead screw
- C) Feed rod
- D) Carriage

Answer: D) Carriage

18. Calculate pitch diameter of M16 x 2 mm square thread?

- A) 15.5 mm
- B) 14 mm
- C) 15 mm
- D) 16 mm

Answer: C) 15 mm

19. Which type of vice has a trigger for opening the movable jaw?

- A) Quick releasing vice
- B) Pipe vice
- C) Pin vice
- D) Bench vice

Answer: A) Quick releasing vice

20. What will happen if lap material used to make laps harder than work piece?

- A) Improve dimensional accuracy
- B) Refines surface finish
- C) Abrasives cut the lap instead of work piece
- D) Improve better geometrical accuracy

Answer: C) Abrasives cut the lap instead of work piece

21. What are the possible surface that can be produced by form turning?

- A) To generate conical surface
- B) To generating cylindrical surface
- C) To generating concave and convex profile
- D) To generate flat surface

Answer: C) To generating concave and convex profile

22. Which material is used for making lathe bed?

- A) Grey cast iron
- B) Mild steel
- C) Pig iron
- D) Nodular cast iron

Answer: A) Grey cast iron

23. What is the ratio between the pitch diameter and number of teeth of gear?

- A) Addendum
- B) Tooth thickness
- C) Module
- D) Dedendum

Answer: C) Module

24. What is the point angle of cold chisel to cut aluminium?

- A) 30 Degree
- B) 60 Degree

C) 45 Degree

D) 55 Degree

Answer: A) 30 Degree

25. Which mode execute that program continuously one block after another block?

- A) Auto mode
- B) Edit mode
- C) MPG mode
- D) Jog mode

Answer: A) Auto mode

26. What is the activity of code M06 based on FANUC CNC control system?

- A) The cutting tool has to be changed
- B) Switch of the coolant pump
- C) Spindle rotation in counter clockwise direction
- D) End of the program with rewind

Answer: A) The cutting tool has to be changed

27. Which surface is finished by honing?

- A) Flat surface
- B) Both external and internal surface
- C) Internal cylindrical surface
- D) External cylindrical surface

Answer: C) Internal cylindrical surface

28. What is the purpose of back gear unit in cone pulley headstock of a lathe?

- A) To double the spindle speed
- B) To get increased spindle speed
- C) For helping step turning
- D) To get reduced spindle speed

Answer: D) To get reduced spindle speed

29. What is the lead of M 24 x 3.5 triple start thread?

- A) 12.8 mm
- B) 10.5 mm
- C) 8.5 mm
- D) 3.5 mm

Answer: B) 10.5 mm

30. What is the advantage of preventive maintenance system?

- A) Improves quantity and quality of product
- B) Reduce the manpower for the maintenance
- C) Reduce the life of machine
- D) Reduce the cost of maintenance

Answer: A) Improves quantity and quality of product

31. What does the letter 's' stands in the equation $d = Y - 2(s+r)$ in taper measurement?

- A) Diameter over the rollers at small end
- B) Radius of the rollers
- C) Diameter over the roller at large end
- D) Distance from the centre of the roller to the end of the component

Answer: D) Distance from the centre of the roller to the end of the component

32. How can the unexpected breakdowns of machines reduced?

- A) By preventive maintenance
- B) By break down maintenance
- C) By productive maintenance
- D) By quality maintenance

Answer: A) By preventive maintenance

33. What is the name of gauge used to check the radius

- A) Feeler gauge
- B) Plug gauge
- C) Fillet gauge
- D) Radius gauge

Answer: D) Radius gauge

34. Which formula is used to find root width of a buttress thread?

- A) $0.335 \times \text{pitch}$
- B) $0.125 \times \text{pitch}$
- C) $0.317 \times \text{pitch}$
- D) $0.5 \times \text{pitch}$

Answer: B) $0.125 \times \text{pitch}$

35. How many speed will obtained from a 3 stepped cone pulley headstock of lathe with back gear arrangement?

- A) 6
- B) 5
- C) 3
- D) 4

Answer: A) 6

36. What is direction of finishing in surface texture?

- A) Flaw
- B) Waviness
- C) Lay
- D) Roughness

Answer: C) Lay

37. Which of the following abrasive is preferred for lapping soft steels and non-ferrous metal?

- A) Silicon carbide
- B) Aluminium oxide
- C) Natural corundum
- D) Boron carbide

Answer: B) Aluminium oxide

38. What heat treatment process the nitriding comes under?

- A) Hardening
- B) Case hardening
- C) Normalizing
- D) Tempering

Answer: B) Case hardening

39. What is the term of thread the advancement of mating part in one complete rotation?

- A) Pitch
- B) Helix angle
- C) Lead
- D) Depth

Answer: C) Lead

40. What is the recommended cutting speed for turning mild steel using H.S.S tool?

- A) 35-50 m/min
- B) 40-70 m/min
- C) 35-70 m/min
- D) 25-40 m/min

Answer: A) 35-50 m/min

41. Which material used for manufacturing a marking table?

- A) Mild steel
- B) Aluminium
- C) Cast iron
- D) Tool steel

Answer: C) Cast iron

42. Calculate the depth of buttress thread 60 mm diameter and 9 mm pitch?

- A) 7.75 mm
- B) 4.75 mm
- C) 5.75 mm
- D) 6.75 mm

Answer: D) 6.75 mm

43. Which one of the below is a work holding device?

- A) Face plate
- B) Four jaw chuck
- C) Driving plate
- D) Catch plate

Answer: B) Four jaw chuck

44. Which one of the code is used to rewind the program?

- A) M40
- B) M38
- C) M30
- D) M39

Answer: C) M30

45. What is the angle of BSW thread?

- A) 45 Degree
- B) 29 Degree
- C) 55 Degree
- D) 60 Degree

Answer: C) 55 Degree

46. Which thread has only one helical formation?

- A) Single start
- B) Triple start
- C) Double start
- D) Quadruple

Answer: A) Single start

47. How many ways CNC machine tool systems can be classified?

- A) 5
- B) 2
- C) 3
- D) 4

Answer: C) 3

48. What type of taper provided on the shank of lathe center?

- A) Jarno
- B) Morse
- C) Brown & sharp
- D) Metric

Answer: B) Morse

49. What is the name of work holding device were the irregular work could hold in lathe?

- A) Driving place
- B) B-Jaw chuck
- C) Catch plate
- D) Face plate

Answer: D) Face plate

50. Which letter represents basic hole?

- A) H
C) BH
B) Bh
D) h

Answer: D) h

51. What is the formula to calculate the core dia of the square thread?

- A) Major dia - minor dia
C) Major dia - Pitch dia
B) Major dia - 2 x depth
D) Major dia - Depth of thread

Answer: B) Major dia - 2 x depth

52. Which one of the following M-code is suitable for spindle rotation stop?

- A) M06
C) M03
B) M05
D) M04

Answer: B) M05

53. What is the shape of buttress thread flank?

- A) One flank is 60 Degree and the other 45 Degree
C) One flank is 30 Degree and the other 45 Degree
B) One flank is 90 Degree and the other 45 Degree
D) Two flanks are at 60 Degree

Answer: B) One flank is 90 Degree and the other 45 Degree

54. Which gas is used in Halon extinguisher?

- A) Carbon tetrachloride
C) Carbon dioxide
B) Hydrogen
D) Carbon monoxide

Answer: A) Carbon tetrachloride

55. Which one of the below accessory has provided U slot?

- A) Face plate
C) Angle plate
B) Catch plate
D) Driving plate

Answer: B) Catch plate

56. Which one of the following is disadvantage of tailstock offset method?

- A) Power feed can be given
C) Only external taper can be turned
B) Good surface finish can be obtained
D) External taper thread can be produce

Answer: C) Only external taper can be turned

57. Which one is the angle of buttress thread?

- A) 55 Degree
C) 45 Degree
B) 30 Degree
D) 60 Degree

Answer: C) 45 Degree

58. What is the expanded form of ABC in first aid?

- A) Airway, blood and circulation
B) Aspiration, blood and circulation

- C) Airway, breathing and circulation
D) Aspiration, breathing and circulation

Answer: C) Airway, breathing and circulation

59. Which of the following is not advantage of CNC machine?

- A) Improved quality
C) Improved strength of the components
B) Reduced scrap rate
D) Higher flexibility

Answer: C) Improved strength of the components

60. Why heat treatment of metal is necessary?

- A) To make good appearance on the component
C) To make the metal rust-proof
B) To increase strength of the metal
D) To produce certain desired properties

Answer: D) To produce certain desired properties

61. Which one is the golden hours related to first aid?

- A) First 15 minutes
C) First 45 minutes
B) First 20 minutes
D) First 30 minutes

Answer: D) First 30 minutes

62. Where the driver pin is used?

- A) Catch plate
C) Face plate
B) Driving plate
D) Angle plate

Answer: B) Driving plate

63. What is the type of fit if minimum size of the shaft is larger than maximum size of hole?

- A) Clearance
C) Interference
B) Running
D) Transition

Answer: C) Interference

64. Which is the operation in point to point system used?

- A) Drilling
C) Grooving
B) Facing
D) Parting

Answer: A) Drilling

65. Which of the following structures of steel is obtained due to the drastic cooling from the austenite structure?

- A) Martensite
C) Ferrite
B) Cementite
D) Pearlite

Answer: A) Martensite

66. Which one of the following M-code is suitable for chuck close?

- A) M13
C) M10
B) M09
D) M11

Answer: D) M11

67. What is the name of the centre with a carbide tip is

brazed into an ordinary steel shank?

- A) Insert type centre
- B) Tipped centre
- C) Half centre
- D) Ball centre

Answer: B) Tipped centre

68. What is the recommended feed rate for turning cast iron (grey) using H.S.S tool?

- A) 0.15-0.7 mm/rev
- B) 0.2-1.5 mm/rev
- C) 0.08-0.03 mm/rev
- D) 0.2-1.00 mm/rev

Answer: A) 0.15-0.7 mm/rev

69. Calculate the change gear to cut 6 mm pitch on a work having a lead screw of 5 mm pitch. Gears available from 20 to 120 teeth by 5 teeth range.

- A) Driver 100 teeth driven 25 teeth
- B) Driver 40 driven 20 teeth
- C) Driver 85 teeth driven 60 teeth
- D) Driver 60 driven 50 teeth

Answer: D) Driver 60 driven 50

70. What is the material of files?

- A) Low alloy steel
- B) High carbon steel
- C) Cast iron
- D) Mild steel

Answer: B) High carbon steel

71. What is the depth of 0.5 inch BSW 13TPI single start thread?

- A) 0.038"
- B) 0.025"
- C) 0.049"
- D) 0.082"

Answer: C) 0.049"

72. Which part of the lathe gives perpendicular movement to the tool?

- A) Tailstock
- B) Carriages
- C) Apron
- D) Cross slide

Answer: D) Cross slide

73. In Which mode we can input the program command manually?

- A) Jog mode
- B) Auto mode
- C) MDI mode
- D) Edit mode

Answer: C) MDI mode

74. Which part of a lathe is used to catch thread quickly?

- A) Tool post
- B) Top slide
- C) Chasing dial
- D) Cross - slide

Answer: C) Chasing dial

75. How is the minor diameter of external thread checked generally?

- A) Using screw thread gauge
- B) Using knife edge of vernier caliper
- C) Using pitch gauge
- D) Using thread ring gauge

Answer: B) Using knife edge of vernier caliper

76. What is the shape of telescopic gauge?

- A) C - shaped
- B) T - shaped
- C) S - shaped
- D) U - shaped

Answer: B) T - shaped

77. Which type of tap wrench is used to minimise the damage of taps?

- A) Double ended tap wrench
- B) Solid type tap wrench
- C) T handle type tap wrench
- D) Bar type tap wrench

Answer: B) Solid type tap wrench

78. What is the use of roller steady rest?

- A) To support irregular job
- B) To support long slender work
- C) To support long thin and thick rod
- D) To support the job and travel along job

Answer: C) To support long thin and thick rod

79. What is the relation between pitch and lead in multistart thread?

- A) Lead = No. start x pitch
- B) Lead = 1/3 x pitch
- C) Lead = Pitch
- D) Lead = 1/2 pitch

Answer: A) Lead = No. start x pitch

80. Which grade of angle plate are more accuracy and used for tool room work?

- A) Grade 1
- B) Grade 4
- C) Grade 3
- D) Grade 2

Answer: A) Grade 1

81. What is the maximum size of bore that can be checked with telescopic gauge?

- A) 53.9 mm
- B) 152.4 mm
- C) 88.9 mm
- D) 31.7 mm

Answer: B) 152.4 mm

82. Which part of centre lathe make angular movement?

- A) Top slide
- B) Saddle
- C) Cross slide
- D) Compound slide

Answer: D) Compound slide

83. What is 7 with expression of fit 30H7/g6?

- A) Shaft and hole allowance
- B) Shaft and hole tolerance
- C) Hole tolerance grade
- D) Shaft tolerance grade

Answer: C) Hole tolerance grade

84. Where the grinding attachment is mounted in centre lathe?

- A) Compound rest
- B) Lathe bed
- C) Rear tool post
- D) Tailstock

Answer: A) Compound rest

85. Which deviation is zero in hole basis system?

- A) Upper deviation is zero
- B) Lower deviation is zero
- C) Both upper and lower deviation is below basic size
- D) Both upper and lower deviation is zero

Answer: B) Lower deviation is zero

86. What is an accuracy of an independent four chuck in metric system?

- A) 0.001mm
- B) 0.02mm
- C) 0.01mm
- D) 0.002mm

Answer: B) 0.02mm

87. Which is the internal part of a bench vice?

- A) Fixed jaw
- B) Movable jaw
- C) Handle
- D) Box nut

Answer: D) Box nut

88. Which point in any CNC machine the position measuring systems has a starting point to each axis?

- A) Tool geometrical value
- B) Work zero
- C) Machine zero
- D) Reference mode

Answer: C) Machine zero

89. Which type of tool is suitable to produce form surface in mass production activities?

- A) Using carbide tipped form tool
- B) Using single point cutting tool
- C) High carbon steel tool
- D) High speed steel cutting tool

Answer: A) Using carbide tipped form tool

90. Which type of vice is used for marking of small jobs on the surface plate?

- A) Quick releasing vice
- B) Bench vice
- C) Tool Makers vice
- D) Pipe vice

Answer: C) Tool Makers vice

91. How much angle is to be added for lead angle of a square thread as clearance to the helix angle?

- A) 1 Degree 50 Minutes
- B) 1 Degree 45 Minutes
- C) 1 Degree 30 Minutes
- D) 1 Degree 55 Minutes

Answer: C) 1 Degree 30 Minutes

92. How many precision rollers required for measuring angle of tapered component?

- A) 2
- B) 4
- C) 3
- D) 1

Answer: A) 2

93. How many standard wires are used to check effective diameter very accurately?

- A) Four wire
- B) Three wire
- C) Two wire
- D) One wire

Answer: B) Three wire

94. What is the meaning of M24 in M 24 x 3 single start thread?

- A) Core dia of thread
- B) Major dia of thread
- C) Depth of thread
- D) Effective dia of thread

Answer: B) Major dia of thread

95. Which lap material inexpensive and can be expanded if worn out?

- A) Lead
- B) Cast Iron
- C) Brass
- D) Bronze

Answer: A) Lead

96. Which one of the program block may suitable to move the cutting tool 'x' axis 42.0 'z' axis 0.0 with the feed of 0.1 mm?

- A) G03 x 42.0 z 0.0 F 0.1;
- B) G02 x 42.0 z 0.0 F 0.1;
- C) G00 x 42.0 z 0.0 F 0.1;
- D) G01 x 42.0 z 0.0 F 0.1;

Answer: D) G01 x 42.0 z 0.0 F 0.1;

97. Which mode, the cutting tool returns back to its home position?

- A) Reference mode
- B) Jog mode
- C) MDI mode
- D) Automatic mode

Answer: A) Reference mode

98. What does M20 stands for?

- A) Metric thread 20 mm lead
- B) Metric thread 20 mm diameter
- C) Metric thread 20 mm pitch
- D) Metric thread 20 mm length

Answer: B) Metric thread 20 mm diameter

99. Which type of trapezoidal thread is used in places there motion is to be transmitted between shafts at right angle?

- A) Acme thread
- B) Buttress thread
- C) Saw-tooth thread
- D) Worm thread

Answer: D) Worm thread

100. Which is used to mark the center of a round rod?

- A) Jenny caliper
- B) Divider
- C) Outside caliper
- D) Inside caliper

Answer: A) Jenny caliper

101. Which one of the following code is suitable for rapid traverse?

- A) G03
- B) G00
- C) G02
- D) G04

Answer: B) G00

102. What is the drill point angle for drilling brass?

- A) 118 Degree
- B) 120 Degree
- C) 130 Degree
- D) 140 Degree

Answer: A) 118 Degree

103. Which grade of file is used for heavy reduction of material?

- A) Smooth file
- B) Bastard file
- C) Dead smooth file
- D) Second cut file

Answer: B) Bastard file

104. What is the body material of bench vice?

- A) Hardened steel
- B) Cast iron
- C) Wrought iron
- D) Mild steel

Answer: B) Cast iron

105. Which mode is used while loading / unloading the work piece in CNC machine?

- A) Simulation mode
- B) Automatic mode
- C) Edit mode
- D) Jog mode

Answer: D) Jog mode

106. What is the width of the tool to cut a square thread of 60 x 9 mm pitch?

- A) 9 mm
- B) 8.5 mm
- C) 4.5 mm
- D) 9.5 mm

Answer: C) 4.5 mm

107. What is the included angle of prick punch used for marking light punch marks needed to position dividers?

- A) 30 Degree
- B) 90 Degree
- C) 45 Degree
- D) 60 Degree

Answer: A) 30 Degree

108. What is the purpose of preventive maintenance?

- A) Maintain machine in good working order
- B) To keep the maintenance records
- C) Reduce the vibration of machine
- D) Increase the cost of inspection

Answer: A) Maintain machine in good working order

109. What is the types of fit for the expression 20H7/g6?

- A) Interference fit
- B) Transition fit

- C) Clearance fit
- D) Force fit

Answer: C) Clearance fit

110. What is the form of NO GO anvil of calliper gauge with roller type?

- A) Truncated shaped form
- B) Full thread form
- C) Half thread form
- D) Correct shaped form

Answer: A) Truncated shaped form

111. Where the follower is fixed to produce from turning?

- A) Top slide
- B) Tail stook
- C) Cross slide
- D) Tool part

Answer: C) Cross slide

112. What is the purpose of change gear train in centre lathe?

- A) Connecting quick change gear box to lead screw
- B) Connecting spindle gear to fixed stud gear
- C) Connecting lead screw to changing dial
- D) Connecting fixed stud gear to quick change gear box

Answer: D) Connecting fixed stud gear to quick change gear box

113. What is the purpose of idler gear in simple gear train?

- A) Reduce spindle speed
- B) Reduce gear ratio
- C) Transmit power between driver and driven gears
- D) Increase spindle speed

Answer: C) Transmit power between driver and driven gears

114. Which mode is used for moving the turret in X and Z direction?

- A) Edit mode
- B) MDI mode
- C) Auto mode
- D) Jog mode

Answer: D) Jog mode

115. What is the relationship between pitch and lead of a single start thread?

- A) Lead is half the pitch
- B) Lead is equal to pitch
- C) Lead is 1/4 pitch
- D) Lead is twice the pitch

Answer: B) Lead is equal to pitch

116. How we can protect the surface of marking table to maintain accuracy?

- A) Providing plastic coating
- B) Provide a stand
- C) By providing a guard
- D) By applying thin layers of oil

Answer: D) By applying thin layers of oil

117. What is the tool life index of cemented carbide tool for turning high carbon high chromium die steel?

- A) 0.35
- B) 0.4

- A) Power feed can be produced
C) Length taper can be produced
- B) Only limited taper angle can be turned
D) Both external and internal tapers can be produced

Answer: B) Only limited taper angle can be turned

136. Which mode is used to edit the program?

- A) Jog mode
C) Edit mode
- B) MDI mode
D) Auto mode

Answer: C) Edit mode

137. Which angle determines the rake angle at the cutting edge of twist drill?

- A) Helix angle
C) Wedge angle
- B) Point angle
D) Clearance angle

Answer: A) Helix angle

138. Which one of the advantage of mass production?

- A) Special purpose machinery are necessary
C) Jigs and fixture are needed
- B) Time for manufacturing of components is reduced
D) Gauges are to be used

Answer: B) Time for manufacturing of components is reduced

139. Which thread is more suitable to hold the tool maker button in position?

- A) 7BA thread
C) 5BA thread
- B) 4BA thread
D) 6BA thread

Answer: B) 4BA thread

140. How many numbers of gears having in a simple gear train?

- A) 2
C) 5
- B) 3
D) 4

Answer: B) 3

141. Which type of chisel is used to cut key ways?

- A) Half round nose chisel
C) Flat chisel
- B) Diamond point chisel
D) Cross cut chisel

Answer: D) Cross cut chisel

142. Calculate pitch diameter of f 24 x 3 mm square thread?

- A) 21 mm
C) 22.5 mm
- B) 24 mm
D) 21.5 mm

Answer: C) 22.5 mm

143. What is the roughness value of grade No N:12?

- A) 50 microns
C) 25 microns
- B) 0.1 microns
D) 12.5 microns

Answer: A) 50 microns

144. Find out the R.P.M of spindle for a 50mm bar (D) and cutting speed is 25m/min.

- A) 100rpm
C) 250rpm
- B) 168rpm
D) 159rpm

Answer: D) 159rpm

145. How much percentage of cutting speed could be increased by using super HSS tools?

- A) 20% to 25%
C) 5% to 10%
- B) 15% to 20%
D) 10% to 15%

Answer: B) 15% to 20%

146. Which gas is used in nitriding process?

- A) Hydrogen
C) Helium
- B) Ammonia
D) Carbon dioxide

Answer: B) Ammonia

147. Which is the advantage of CNC machine over conventional machines?

- A) High cutting speed
C) Mass production
- B) High feed
D) Feed back control

Answer: C) Mass production

148. Which victim has given CPR immediately?

- A) Severe blood loss
C) Severe head injury
- B) Difficulty in breathing
D) Dehydration

Answer: B) Difficulty in breathing

149. What is the angle between the adjustable jaws of a three jaw chuck?

- A) 119 Degree
C) 120 Degree
- B) 90 Degree
D) 118 Degree

Answer: C) 120 Degree

150. What is the normal lip clearance angle for standard drill?

- A) 13 Degree - 16 Degree
C) 2 Degree- 4 Degree
- B) 8 Degree - 12 Degree
D) 5 Degree - 7 Degree

Answer: B) 8 Degree - 12 Degree

151. What does Sq 60 x 9 IS 4694-1968 means?

- A) Buttress thread 60 mm dia x 9 mm pitch
C) Acme thread 60 mm dia x 9 mm pitch
- B) Worm thread 60 mm dia x 9 mm pitch
D) Square Thread 60 mm dia, 9 mm pitch

Answer: D) Square Thread 60 mm dia, 9 mm pitch

152. Which axis is parallel to Z - axis?

- A) Tool axis
C) Y-axis
- B) X - axis
D) Spindle axis

Answer: D) Spindle axis

153. The CNC keyboards have with following keys?

- A) Alphanumerical control keys electronic
- B) Alphabetic control keys
- C) Numerical Data based keys only
- D) CNC codes

Answer: A) Alphanumerical control keys electronic

154. What are the standard diameters of tool maker's button?

- A) 2mm, 4mm, 6mm
- B) 14mm, 16mm, 18mm
- C) 8mm, 10mm, 12mm
- D) 20mm, 22mm, 24mm

Answer: C) 8mm, 10mm, 12mm

155. Which parameter will decide the driver and driven gear ratio to cut thread on lathe?

- A) Angle of thread
- B) Pitch
- C) Root dia of work
- D) Major dia of work

Answer: B) Pitch

156. Which safety practice refers, Do not wear the ring?

- A) Personal safety
- B) General safety
- C) Machine safety
- D) Road safety

Answer: A) Personal safety

157. Which one of the following M-code is suitable for coolant pump ON?

- A) M11
- B) M10
- C) M08
- D) M09

Answer: C) M08

158. What is the purpose of MDI mode?

- A) Cross checking of the program graphically
- B) For program execution
- C) Editing of programmable Data
- D) Move the axes by manually

Answer: D) Move the axes by manually

159. What is the roughnes value of grade No N1?

- A) 6.3 microns
- B) 0.4 microns
- C) 12.5 microns
- D) 0.025 microns

Answer: D) 0.025 microns

160. What is the included angle of acme thread?

- A) 29 Degree
- B) 45 Degree
- C) 55 Degree
- D) 30 Degree

Answer: A) 29 Degree

161. Which one is chief constituent of ferrous tool material?

- A) Carbon
- B) Iron
- C) Tungsten
- D) Vanadium

Answer: B) Iron

162. Which gauge is used to position the cutter before cutting in milling fixture?

- A) Feeler gauge
- B) Fillet gauge
- C) Screw pitch gauge
- D) Radius gauge

Answer: A) Feeler gauge

163. What is the term the distance moved by the tool along the work for each revolution?

- A) Feed
- B) Depth
- C) Speed
- D) Cutting speed

Answer: A) Feed

164. Which is four jaw chuck?

- A) Self aligning chuck
- B) Collect chuck
- C) Independent chuck
- D) Self centring chuck

Answer: C) Independent chuck

165. Which lathe accessory is used to hold the previously bored job?

- A) Drive plate
- B) Mandrel
- C) Face plate
- D) Catch plate

Answer: B) Mandrel

166. Which type of thread is used in lathe head screw?

- A) Square thread
- B) Acme thread
- C) Buttress thread
- D) Knuckle thread

Answer: B) Acme thread

167. What does QA and QC stand for?

- A) Quality assurance and quenching control
- B) Quality assurance and quenching control
- C) Quality assurance and quality control
- D) Quality adjustment and quality complete

Answer: C) Quality assurance and quality control

168. Which code is suitable for tool nose radius compensation at right side?

- A) G50
- B) G40
- C) G42
- D) G41

Answer: C) G42

169. Which heat treatment process is used to reduce internal stresses of a hardened tool?

- A) Tempering
- B) Annealing
- C) Normalizing
- D) Stabilizing

Answer: A) Tempering

170. How the turning tool is moving in tail strock offset method?

- A) Vertical to lathe axis
- B) Angular to lathe axis

- C) Parallel to lathe axis D) Perpendicular to lathe axis

Answer: C) Parallel to lathe axis

171. What is the effect, if the cutting speed is more than the recommended?

- A) Reduce the tool life B) Accurate dimension
C) Normal tool life D) Better finish

Answer: A) Reduce the tool life

172. What is the advantage of maintenance records?

- A) Increase the cost of production B) Reduce the clerical work
C) Zero breakdown maintenance D) Monitor the frequent breakdown

Answer: D) Monitor the frequent breakdown

173. What is the use of CNC code of M05 to develop the command?

- A) Tool returns from reference point to work place B) The cutting tool has to be changed
C) The spindle rotation has to stop D) Rewind the program once again

Answer: C) The spindle rotation has to stop

174. Which mechanism is also called as reversing gear unit?

- A) Tumbler gear B) Apron mechanism
C) Change gear unit D) Quick change box

Answer: A) Tumbler gear

175. Which part of screw rod of 4 jaw chuck permits the screws to rotate but not to advance?

- A) Pinion B) Locating pin
C) Taper pin D) Finger pin

Answer: D) Finger pin

176. Which one of the following is possible in edit mode?

- A) Preparation of new programmable Data and correction / Alteration of an earlier program B) Can read only the program
C) Execute the program D) Simulation of the program

Answer: A) Preparation of new programmable Data and correction / Alteration of an earlier program

177. Which material used for manufacturing crown wheel of a three jaw chuck?

- A) Cast iron B) High carbon steel
C) Chrome vanadium steel D) Alloy steel

Answer: D) Alloy steel

178. What is the purpose of slots milled on two planes of angle plate?

- A) Good appearance B) Maintain accuracy
C) Clamp the job D) Reduce the weight

Answer: C) Clamp the job

179. Which is the cheapest tool material?

- A) High carbon steel B) Diamonds
C) High speed steel D) Carbide

Answer: A) High carbon steel

180. Which part is assembled in compound rest other than compound slide?

- A) Apron B) Cross slide
C) Swivel base D) Saddle

Answer: C) Swivel base

181. How the part programming mistakes can be avoided?

- A) Cannot be avoided in CNC machine B) CNC (Computer numerical control) machine only
C) NC (Numerical control) machine only D) Both NC and CNC machine

Answer: B) CNC (Computer numerical control) machine only

182. How many fundamental deviations are recommended by BIS?

- A) 25 B) 20
C) 30 D) 24

Answer: A) 25

183. Which type taper is provided at the hollow end of the tailstock barrel/spindle?

- A) Metric taper B) Jarno taper
C) Morse taper D) Brown & sharpe taper

Answer: C) Morse taper

184. What is the advantage of roller steady rest over fixed rest?

- A) It can fixed on tool post B) It rotates and moves along the work
C) It can fixed on saddle D) Easy to rotate the work

Answer: D) Easy to rotate the work

185. What is the indication of 'z' axis in CNC lathe machine?

- A) The diameter of the component B) The radius of the component
C) The centre axis of the component D) The length of the component

Answer: D) The length of the component

186. Which type of angle plate is used to hold work at an angle?

- A) Solid
C) Slotted
- B) Swivel
D) Box

Answer: B) Swivel

187. How many number of teeth gear is used to as translating gear to cut metric thread on British lathe?

- A) 140
C) 127
- B) 100
D) 135

Answer: C) 127

188. Which material is to used to make body of three jaw chuck?

- A) Cast iron
C) Cast steel
- B) Hardened steel
D) Alloy steel

Answer: C) Cast steel

189. What is the advantage of follower steady rest over fixed steady rest?

- A) It rotate and moves along the work
C) Support at fixed place of work
- B) Support continuous entire length of work
D) It rotate with the work

Answer: B) Support continuous entire length of work

190. What factor is important in free hand form turning?

- A) High speed
C) Skilled labour
- B) Unskilled labour
D) Sharp tool

Answer: C) Skilled labour

191. What is the recommended cutting speed for aluminium using H.S.S tool?

- A) 25 m/min - 40 m/min
C) 50 m/min - 80 m/min
- B) 35 m/min - 50 m/min
D) 70 m/min - 100 m/min

Answer: D) 70 m/min - 100 m/min

192. What is the purpose of normalizing steel?

- A) Increase the toughness and reduce brittleness
C) Improve machinability
- B) Soften the steel
D) Remove induced stresses

Answer: D) Remove induced stresses

193. Which of the following used buttress thread?

- A) Carpentry vice
C) General purpose nut and bolt
- B) Screw jack
D) Lead screw of lathe

Answer: A) Carpentry vice

194. Which axis the tool moves in taper turning attachment?

- A) Perpendicular to lathe axis
C) Vertical to lathe axis
- B) Angular to lathe axis
D) Parallel to lathe axis

Answer: B) Angular to lathe axis

195. Which is 3 jaw chuck?

- A) Self centring chuck
C) Magnetic chuck
- B) Combination chuck
D) 4 Jaw chuck

Answer: A) Self centring chuck

196. What is the formula used to find flat width of a buttress thread?

- A) Pitch/3
C) Pitch/4
- B) Pitch/2
D) Pitch/8

Answer: D) Pitch/8

197. What is the correct sequence of the operation of a simple fire extinguisher?

- A) Aim pull sweep and squeeze
C) Squeeze aim pull and sweep
- B) Pull, Aim squeeze & sweep
D) Sweep Aim pull and squeeze

Answer: B) Pull, Aim squeeze & sweep

198. What is the purpose of square slot provided on the top of the pinion of a 3 jaw chuck is?

- A) To accommodate the chuck key
C) To set the back plate on the machine
- B) To set the body of the chuck in spindle
D) To set chuck on machine

Answer: A) To accommodate the chuck key

199. What is the term the distance from a point on thread to the corresponding point on next thread?

- A) Pitch
C) Minor diameter
- B) Effective diameter
D) Depth

Answer: A) Pitch

200. Calculate the length of metal passing by cutting tool in one revolution if the diameter of work is 75mm and cutting speed is 120m/min.

- A) 485.7 mm
C) 235.5 mm
- B) 365.3 mm
D) 295.7 mm

Answer: C) 235.5 mm

201. What is the angle of saw tooth thread?

- A) 30 Degree
C) 90 Degree
- B) 45 Degree
D) 29 Degree

Answer: A) 30 Degree

202. Which metal is to be case hardened?

- A) Alloy steel parts
C) Low carbon steel parts
- B) Cast iron (heavy parts)
D) High carbon steel

Answer: C) Low carbon steel parts

203. Where the bend type lathe carrier is engaged?

- A) Driving plate
B) Catch plate

- C) Face plate D) Angle plate

Answer: B) Catch plate

204. Which part of the lathe helps to give angular movement during taper turning?

- A) Cross slide B) Tool Post
C) Saddle D) Compound slide

Answer: D) Compound slide

205. Which one of the following code is suitable for spindle rotation in clock wise direction?

- A) M03 B) M04
C) G02 D) G03

Answer: A) M03

206. What is the name of the centre accommodates in the main spindle sleeve?

- A) Dead centre B) Live centre
C) Half centre D) Pipe centre

Answer: B) Live centre

207. Which code suitable for circular interpolation counter clockwise direction?

- A) G04 B) G01
C) G03 D) G02

Answer: C) G03

208. What does the letter Y stands in the formula $d = Y \cdot 2(s+r)$ in taper measurement?

- A) Diameter over rollers at big end B) Radius of the roller
C) Diameter over rollers at small end D) Distance from the centre of the roller to the end of the component

Answer: C) Diameter over rollers at small end

209. What will happen to the tool life if the spindle is running higher speed?

- A) Medium B) Less
C) More D) Very less

Answer: B) Less

210. Which jaw of 3 jaw chuck is used to hold hollow job?

- A) Fixed jaw B) Internal jaw
C) Movable jaw D) External jaw

Answer: B) Internal jaw

211. What is the purpose of lapping vehicles?

- A) Improves dimensional accuracy B) Regulate cutting action and lubricate surface
C) Smooth effective operation D) Improves cutting ability

Answer: B) Regulate cutting action and lubricate surface

212. What is the lead of M 10 x 1.5 double start thread?

- A) 3 mm B) 3.5 mm
C) 2 mm D) 4 mm

Answer: A) 3 mm

213. Which lathe accessory is used to clamp the fixture?

- A) 3 jaw chuck B) Collet chuck
C) Face plate D) 4 jaw chuck

Answer: C) Face plate

214. Why lapping tools are provided groove?

- A) Prevent damage to tool B) Clearance
C) Expansion D) For accommodate lapping compound

Answer: D) For accommodate lapping compound

215. What is the cut of file used for deburring the job on lathe?

- A) Double cut file B) Rasp cut file
C) Single cut file D) Curved cut file

Answer: C) Single cut file

216. Calculate the pitch diameter of M 64 x 6 mm square thread?

- A) 61 mm B) 60 mm
C) 62 mm D) 58 mm

Answer: A) 61 mm

217. What is the advantage of jig?

- A) Hold and locate the work B) Cost is very low
C) Hold, locate and guide the tool D) It holds the job

Answer: C) Hold, locate and guide the tool

218. How does periodic inspection of the machines and equipments is carried out in preventive maintenance?

- A) As per the knowledge of manager B) As per the knowledge of instructor
C) As per checklist D) As per the knowledge of trainee

Answer: C) As per checklist

219. Which punch is used for locating center of the hole?

- A) Dot punch B) Prick punch
C) Center punch D) Hollow Punch

Answer: C) Center punch

220. What is the special benefit of using a fixture?

- A) Suitable for small batch production
B) Skilled worker required
C) Faster rate of production
D) Slower rate of production

Answer: C) Faster rate of production

221. What is the representation of zero line in limit and fits?

- A) Basic size
B) Nominal size
C) Tolerance size
D) Actual size

Answer: A) Basic size

222. A CNC machine tool has a continuous part control both linear and circular along x,y,z and control of table rotation about x axis and z axis, so the machine should be called?

- A) 2L, 2C
B) 2C, L
C) 5C
D) 3L,2C

Answer: D) 3L,2C

223. What does BIS stands for?

- A) Bureau of International Society
B) Bureau of Indian Standard
C) Bureau of Indian Society
D) Bureau of International Standard

Answer: B) Bureau of Indian Standard

224. What is the swing over bed?

- A) Length of the bed
B) Distance between centres
C) Perpendicular distance from lathe axis to top of bed
D) Perpendicular distance from lathe and to the carriage

Answer: C) Perpendicular distance from lathe axis to top of bed

225. What is the value of tool life index for a cemented carbide tip to machine cast iron component?

- A) 0.125
B) 0.128
C) 0.2
D) 0.1

Answer: D) 0.1

226. Which material is used to make the tool maker's button?

- A) Tool steel
B) Stainless steel
C) Cast steel
D) Hardened steel

Answer: D) Hardened steel

227. What is the main use of using tool maker's button for face boring?

- A) Truing is not necessary
B) Unskilled labour can do
C) Easy to use
D) Easy to set square to the axis of rotation

Answer: D) Easy to set square to the axis of rotation

228. What is the specific use of tool maker's button in lathe operation?

- A) For producing tool to a high degree of positional accuracy
B) For producing bore to a high degree of positional accuracy
C) For producing a tool to high degree accuracy
D) For producing a button to a high degree of positional accuracy

Answer: B) For producing bore to a high degree of positional accuracy

229. What is the accuracy of measurement by a try square?

- A) 2 mm / 1 mm length
B) 0.2 mm / 1000 mm length
C) 0.02 mm / 100mm length
D) 0.002 mm / 10mm length

Answer: D) 0.002 mm / 10mm length

230. What is the formula for metric thread depth?

- A) 0.5 x pitch
B) 0.6134 x pitch
C) 0.6403 x pitch
D) 0.75 x pitch

Answer: B) 0.6134 x pitch

231. Which command activates in automatic mode?

- A) Tool changes automatically
B) Program executed
C) Work offset settings are taken
D) Program simulation

Answer: B) Program executed

232. What is the specification for shape of file?

- A) Cut
B) Grades
C) Length
D) Cross section

Answer: D) Cross section

233. Where is the dead centre fixed on lathe?

- A) Carriage
B) Tail stock
C) Head stock
D) Cross-Stock

Answer: B) Tail stock

234. Which material is used to make radius gauge?

- A) Stainless steel
B) Hardened steel
C) Cast steel
D) Tool steel

Answer: B) Hardened steel

235. Which angle plate is used to support jobs in different angles?

- A) Adjustable type
B) Box type
C) Slotted type
D) Plain type

Answer: A) Adjustable type

236. How many gears are assembled in tumbler gear mechanism?

- A) 4 gears
B) 3 gears
C) 5 gears
D) 2 gears

Answer: B) 3 gears

237. How the roughness value is expressed?

- A) Metre
- B) Micrometer
- C) Centimetre
- D) Millimetre

Answer: B) Micrometer

238. Which type of chisel is used for squaring materials at the corners and joints?

- A) Flat chisel
- B) Diamond point chisel
- C) Web chisel
- D) Cross cut chisel

Answer: B) Diamond point chisel

239. Why in CNC machine tool, the part program entered in edit mode is stored into the computer memory?

- A) Can be used again but it has to be modified every time
- B) Can be used again and again
- C) Cannot say
- D) Can be used only once

Answer: B) Can be used again and again

240. Which is a non-metallic tool material?

- A) Diamonds
- B) Stellite
- C) Carbide
- D) High carbon steel

Answer: A) Diamonds

241. What is the hole basis system?

- A) Size of the hole is varied
- B) Size of both hole and shaft are varied
- C) Size of shaft is constant
- D) Size of hole is constant

Answer: D) Size of hole is constant

242. What is angle between the two faces of angle plate?

- A) 90 Degree
- B) 30 Degree
- C) 45 Degree
- D) 60 Degree

Answer: A) 90 Degree

243. What is the representation IT in limits and fits?

- A) Tolerance number
- B) Tolerance grade
- C) Tolerance
- D) Tolerance unit

Answer: B) Tolerance grade

244. What type of thread is used in screw jack machine?

- A) Buttress thread
- B) V-thread
- C) Acme thread
- D) Square thread

Answer: D) Square thread

245. What do you mean by simulation?

- A) Editing of related part program
- B) Finding out of tool geometrical values
- C) Cross checking of programmable DATA
- D) Finding out of work offset values

Answer: C) Cross checking of programmable DATA

246. What is the use of drive pin in drive plate?

- A) Hold the job
- B) To locate the job
- C) To turn the job
- D) To rotate the job

Answer: D) To rotate the job

247. What is the use of Goo activates the command?

- A) Tool returns from reference point
- B) Rapid traverse
- C) Linear interpolation
- D) Return to reference point

Answer: B) Rapid traverse

248. How many adjusting bearing pad in fixed steady rest?

- A) Five
- B) Two
- C) Four
- D) Three

Answer: D) Three

249. How many types of split bearing?

- A) 3
- B) 4
- C) 5
- D) 2

Answer: D) 2

250. Which part of the universal surface gauge is used for fine adjustment?

- A) Spindle
- B) Rocker arm
- C) Scriber
- D) Guide pin

Answer: B) Rocker arm

251. Which file is used for filing surfaces at right angle on already finished surface?

- A) Needle file
- B) Curved cut file
- C) Safe edge file
- D) Flat file

Answer: C) Safe edge file

252. Which mode the program will be executed continuously one block after another block?

- A) Edit mode
- B) Jog mode
- C) Auto mode
- D) Manual mode

Answer: C) Auto mode

253. In Which case hardening process the ammonia gas is introduced?

- A) Induction hardening
- B) Gas nitriding
- C) Cyaniding
- D) Carburizing

Answer: B) Gas nitriding

254. Which part of carriage is only for possible manual operation?

- A) Saddle
- B) Top slide
- C) Apron
- D) Cross slide

Answer: B) Top slide

255. What is the preheating temperature of steel?

- A) Upto 600 Degree Centigrade
- B) Upto 500 Degree Centigrade
- C) Upto 300 Degree Centigrade
- D) Upto 400 Degree Centigrade

Answer: A) Upto 600 Degree Centigrade

256. What is the advantage of using idler gear in simple gear train?

- A) Easy to engage
- B) Does not affect gear ratio
- C) Change the speed
- D) Affect gear ratio

Answer: B) Does not affect gear ratio

257. What is the included angle of center punch?

- A) 60 Degree
- B) 30 Degree
- C) 45 Degree
- D) 90 Degree

Answer: D) 90 Degree

258. Which material is used to make back plate of a three jaw chuck?

- A) Alloy steel
- B) Cast iron
- C) Cast steel
- D) Wrought iron

Answer: B) Cast iron

259. Calculate the depth of buttress thread diameter 30 mm pitch 3 mm?

- A) 3.00 mm
- B) 1.5 mm
- C) 1.25 mm
- D) 2.25 mm

Answer: D) 2.25 mm

260. Which one is example of ferrous tool material?

- A) Diamonds
- B) High carbon steel
- C) Stellite
- D) Carbide tool

Answer: B) High carbon steel

261. How multi start threads are specified?

- A) By stating dia and angle of thread
- B) By stating dia, pitch, and no. of start
- C) By stating core dia and pitch
- D) By stating dia and pitch

Answer: B) By stating dia, pitch, and no. of start

262. What will be the effect in helix angle if lead changes for a give diameter work?

- A) Lead decreases helix angle increases
- B) Helix angle have no change when lead decreases
- C) Helix angle have no change when lead increases
- D) Lead decreases helix angle decreases

Answer: D) Lead decreases helix angle decreases

263. Which method is suitable for measuring minor diameter of internal thread?

- A) By using three wire method
- B) By using precision rolles and vernier calliper
- C) By using slip gauge and precision roller
- D) By using screw thread micrometer

Answer: C) By using slip gauge and precision roller

264. Which formula to be used to find core diameter?

- A) Core diameter = Major diameter - pitch
- B) Core diameter = Major diameter - depth
- C) Core diameter = Major diameter - 2 depth
- D) Core diameter = Major diameter - minor diameter

Answer: C) Core diameter = Major diameter - 2 depth

265. Which portion of a hammer head is not hardened or left soft?

- A) Cheek
- B) Cross pein
- C) Face
- D) Pein

Answer: A) Cheek

266. What is the disadvantage of fixed steady rest over follower steady rest?

- A) It rotate and moves along the work
- B) It rotate with the job
- C) Support at one fixed place only
- D) Support continuous entire length

Answer: C) Support at one fixed place only

267. What is the name of last member in a simple gear train?

- A) Reversing gear
- B) Idler
- C) Driver
- D) Driven

Answer: D) Driven

268. Which mode is used to move the turret in micron level?

- A) Jog mode
- B) Auto mode
- C) Incremental jog mode
- D) MDI mode

Answer: C) Incremental jog mode

269. Which part of the lathe is situated at right hand side of the lathe bed?

- A) Head stock
- B) Tailstock
- C) Carriage
- D) Tool post

Answer: B) Tailstock

270. Which mode is used for five positioning (Micron level) of the axis movement?

- A) Auto mode
- B) MDI mode
- C) Edit mode
- D) Incremental Jog mode

Answer: D) Incremental Jog mode

271. Which is the device that can hold, locate and guide the

tool?

- A) Fixture
- B) Jig
- C) Collet chuck
- D) Chuck

Answer: B) Jig

272. Which is used to prevent concentration of abrasives on lapping surface?

- A) Retainer
- B) Holder
- C) Absorber
- D) Vehicle

Answer: D) Vehicle

273. What is the purpose of Square thread?

- A) For clamping
- B) To transmit power
- C) To make adjustment
- D) General fastening

Answer: B) To transmit power

274. What defect may occur during grinding a form tool cutting edge?

- A) Thickness of the tool reduced
- B) Shape of the form gets altered
- C) Form tool getting broken
- D) Clearance angle changed

Answer: B) Shape of the form gets altered

275. What is the process of increasing carbon percentage on the surface of low carbon steel?

- A) Carburizing
- B) Hardening
- C) Nitriding
- D) Tempering

Answer: A) Carburizing

276. Which one of the following heat treatment process produces a scale free surface on the components?

- A) Induction hardening
- B) Flame hardening
- C) Nitriding
- D) Case hardening

Answer: A) Induction hardening

277. Which accessory is used in between centre work?

- A) Three chuck
- B) Four jaw chuck
- C) Catch plate
- D) Face plate

Answer: C) Catch plate

278. Which type of instrument is generally used to check eccentricity?

- A) Dial test indicator
- B) Surface gauge
- C) Micrometer
- D) Vernier calipers

Answer: A) Dial test indicator

279. What is the unit of deviation in limits and fits?

- A) Millimeter
- B) Centimeter
- C) Micron
- D) Mill micron

Answer: C) Micron

280. Where the fixed steady rest clamped on a lathe?

- A) On tool post
- B) On a carriage
- C) On the lathe bed
- D) On a saddle

Answer: C) On the lathe bed

281. What is the type of fit in expression 75 H8/j7?

- A) Clearance fit
- B) Transition fit
- C) Force fit
- D) Interference fit

Answer: B) Transition fit

282. Which lathe part is used to mount the dial indicator for truing the bore?

- A) Tail stock
- B) Tool post
- C) Lathe bed
- D) Cross side

Answer: B) Tool post

283. Which one of the following CNC control systems are used on CNC machines?

- A) Excel and MS power point
- B) Siemens and FANUC
- C) MS office only
- D) Adobe reader and Microsoft

Answer: B) Siemens and FANUC

284. Which G-code is suitable for data input in mm?

- A) G27
- B) G28
- C) G21
- D) G20

Answer: C) G21

285. Which part of the lathe is H shaped cast iron on the bed ways?

- A) Saddle
- B) Tail stock
- C) Cross slide
- D) Top slide

Answer: A) Saddle

286. Which type of thread cut on the screw shaft of an independent chuck?

- A) Left hand acme thread
- B) Left hand square
- C) Left hand V thread
- D) Right hand V thread

Answer: B) Left hand square

287. What is the type of fit for the expression Fit 25H7/p6?

- A) Running fit
- B) Clearance fit
- C) Transition fit
- D) Interference fit

Answer: D) Interference fit

288. Where the knuckle threads are used?

- A) Screw jack
- B) Dead screw of lathe
- C) Railway carriage couplings
- D) Carpentry vice

Answer: C) Railway carriage couplings

289. Which one of the following code used to switch off the

coolant pump?

- A) M08
- B) M07
- C) M09
- D) M30

Answer: C) M09

290. What is the heating temperature in gas nitriding process?

- A) Up 200 Degree Celsius
- B) Up 500 Degree Celsius
- C) Up 400 Degree Celsius
- D) Up 300 Degree Celsius

Answer: B) Up 500 Degree Celsius

291. What is the most accepted method of representing roughness?

- A) Weight
- B) Units
- C) Symbol
- D) Grade number

Answer: D) Grade number

292. Which one is used for producing a bore to a high degree of positional accuracy?

- A) Reamer
- B) Boring tool
- C) Tool maker's button
- D) Drill

Answer: C) Tool maker's button

293. What is the use of gap bed lathe?

- A) To turn larger diameter work
- B) To turn small diameter work
- C) To turn irregular shaped work
- D) To turn lengthy work

Answer: A) To turn larger diameter work

294. What is the formula for pitch diameter of thread?

- A) Major diameters - single depth
- B) Major diameters - minor diameter
- C) Major diameter - Pitch
- D) Major diameters - 2 depth

Answer: A) Major diameters - single depth

295. What is 'L' in tailstock offset method?

- A) Length of the taper
- B) Length of offset
- C) Length of the job
- D) Amount taper

Answer: C) Length of the job

296. Which one of the following is the solid carburizing material?

- A) Ammonia
- B) Petrol
- C) Charcoal
- D) Kerosene

Answer: C) Charcoal

297. Which one is the cause for hazard in personal safety?

- A) Long hair
- B) Sleeve tightly rolled
- C) Safety boots
- D) Buttons fastened

Answer: A) Long hair

298. Which angle is preventing the cutting edge from rubbing action?

- A) Web angle
- B) Point angle
- C) Rake angle
- D) Clearance angle

Answer: D) Clearance angle

299. What is the name of first member in a simple gear train?

- A) Driven
- B) Idler
- C) Reversible gear
- D) Driver

Answer: D) Driver

300. What is the full form of MDI?

- A) Manually Data Input
- B) Mounting of Diagonal Impact
- C) Mechanical Data Implantation
- D) Moderated Data input

Answer: A) Manually Data Input

301. Encoder is used in CNC machine tool to sense and control?

- A) Table position
- B) Work position
- C) Spindle position
- D) Spindle speed

Answer: A) Table position

302. What is the name of precision finishing operation carried out by using fine abrasive materials?

- A) Lapping
- B) Filing
- C) Polishing
- D) Grinding

Answer: A) Lapping

303. Calculate the flat width of 10 mm pitch buttress thread?

- A) 2.25 mm
- B) 4.25 mm
- C) 3.25 mm
- D) 1.25 mm

Answer: D) 1.25 mm

304. What is the indication of 'x' axis in CNC lathe machine?

- A) The radius of the component
- B) The length of the component
- C) The diameter of the component
- D) Centre axis of the component

Answer: C) The diameter of the component

305. Calculate the pitch diameter of M 36 x 4 mm square thread?

- A) 32 mm
- B) 35 mm
- C) 33 mm
- D) 34 mm

Answer: D) 34 mm

306. Which deviation is zero in shft basis system?

- A) Upper deviation is zero
- B) Both upper and lower deviation is below basic size

- C) Lower deviation is zero D) Both upper and lower deviation is zero

Answer: A) Upper deviation is zero

307. Where the milling attachment is mounted in centre lathe?

- A) Cross - slide B) Compound rest
C) Tailstock D) Rear tool post

Answer: A) Cross - slide

308. What is the length a spacing collar used in inside micrometer?

- A) 25 mm B) 13 mm
C) 38 mm D) 12 mm

Answer: D) 12 mm

309. Calculate the change gear to cut 8 mm pitch on a work having a lead screw of 4 mm pitch gear 20 to 120 teeth by 5 teeth range

- A) Driver 40 teeth Driven 20 teeth B) Driver 50 teeth Driven 60 teeth
C) Driver 60 teeth Driven 35 teeth D) Driver 80 teeth Driven 25 teeth

Answer: A) Driver 40 teeth Driven 20 teeth

310. Calculate change gears to cut a three start thread having a pitch of 1.5 mm; the lead screw has a pitch of 6 mm.

- A) Driver 60 teeth, Driven 50 teeth B) Driver 30 teeth, Driven 70 teeth
C) Driver 50 teeth, Driven 100 teeth D) Driver 45 teeth, Driven 60 teeth

Answer: D) Driver 45 teeth, Driven 60 teeth

311. Which device is used as a reference surface for marking?

- A) Plate angle B) Marking table
C) Lathe bed D) Anvil surface

Answer: B) Marking table

312. Which gauge is to be selected for checking the corner radius of the job?

- A) Radius gauge B) Feeler gauge
C) Fillet gauge D) Plug gauge

Answer: A) Radius gauge

313. Which method of multi-start thread cutting is depends upon the graduations marked on the dial and the number of teeth in worm wheel?

- A) Dividing the first drive method B) Method using slotted face plate
C) Method by moving the top slide D) Thread chasing dial method

Answer: D) Thread chasing dial method

314. What is the minimum size of bore that can be checked with telescopic gauge?

- A) 12.7 mm B) 13.7 mm
C) 31.7 mm D) 19.00 mm

Answer: A) 12.7 mm

315. How many roughness grade numbers are used?

- A) N1 to N30 B) N1 to N25
C) N1 to N20 D) N1 to N12

Answer: D) N1 to N12

316. What is the type of fit if minimum size of hole is larger than maximum size of shaft?

- A) Transition B) Clearance
C) Interference D) Force

Answer: B) Clearance

317. How the complex cutting motion involving X, Y and Z moments is carried out by CNC machining?

- A) Use of jigs, cams, templates and tracers B) Skill of machine operator
C) Based on electrical power supply of the machine D) Combinations of co ordinates obtained from drives along the axis

Answer: D) Combinations of co ordinates obtained from drives along the axis

318. Which one of the following command the G02 code indicates?

- A) Circular interpolation clockwise direction B) Linear interpolation
C) Cross sectional interpolation D) Circular interpolation counter clockwise direction

Answer: A) Circular interpolation clockwise direction

319. What is the least count of inside micrometer - metric?

- A) 0.01 mm B) 0.1 mm
C) 0.02 mm D) 0.001 mm

Answer: A) 0.01 mm

320. Which one of the following code is used for tool nose compensation at left side?

- A) G40 B) G32
C) G42 D) G41

Answer: D) G41

321. Which is the blank size M10 x 1.5mm of external thread?

- A) 9.65mm B) 9.75mm
C) 10.85mm D) 9.85mm

Answer: D) 9.85mm

322. Which of the following property of metal is imparted by

annealing?

- A) Surface hardness
- B) Hardness
- C) Toughness
- D) Ductility

Answer: D) Ductility

323. What do you mean by MPG?

- A) Manually Pulse Generator
- B) Manual Procedure to Calculate Geometrical Values
- C) Manually Procure the Digital Graphics
- D) Manual Program Graphics

Answer: A) Manually Pulse Generator

324. What is the use of inside micrometer?

- A) Determine the distance between internal parallel surface
- B) Measuring the external surface
- C) Measuring keyways and small slots
- D) To measure the depth of hole

Answer: A) Determine the distance between internal parallel surface

325. Which material is used to make the stylus of mechanical surface indicator?

- A) Diamond
- B) High speed steel
- C) High carbon steel
- D) Mild steel

Answer: A) Diamond

326. What will be the effect in helix angle if diameter changes for a given lead?

- A) No change in helix angle if diameter increases
- B) No change in helix angle if diameter decreases
- C) Diameters decreases helix angle increases
- D) Diameters decreases helix angle decreases

Answer: C) Diameters decreases helix angle increases

327. Where multistart threads are used?

- A) For easy engagement
- B) For easy alignment
- C) For general fastening
- D) For quick transmission

Answer: D) For quick transmission

328. Which material is used to make angle plate?

- A) Cast iron
- B) Mild steel
- C) Tool steel
- D) Wrought iron

Answer: A) Cast iron

329. Where the taper threads are used?

- A) Wood screw
- B) Bolt
- C) Nut
- D) Stud

Answer: A) Wood screw

330. Which cutting tools have highest cutting efficiency?

- A) Carbide
- B) Mild steel
- C) High carbon steel
- D) High speed steel

Answer: A) Carbide

331. Which lapping material used for easy charging and rapid cutting?

- A) Close grained iron
- B) Copper and brass
- C) Cast iron
- D) White cast iron

Answer: B) Copper and brass

332. Which gauge is used to check the radius formed at the steps of component?

- A) Fillet gauge
- B) Radius gauge
- C) Feeler gauge
- D) Plug gauge

Answer: A) Fillet gauge

333. What does AQL stands for?

- A) Another quality limit
- B) Aquired quality limit
- C) Acceptance quality limit
- D) Acceptance quality level

Answer: C) Acceptance quality limit

334. What is the nose cutter width of the square threads tool?

- A) $2 \times \text{Pitch}$
- B) equal to pitch
- C) $\text{Pitch} / 0.5$
- D) $0.5 \times \text{Pitch}$

Answer: D) $0.5 \times \text{Pitch}$

335. Which formula is used to find crest width of a buttress thread?

- A) $0.335 \times \text{pitch}$
- B) $0.5 \times \text{pitch}$
- C) $0.317 \times \text{pitch}$
- D) $0.125 \times \text{pitch}$

Answer: D) $0.125 \times \text{pitch}$

336. Why the ball centre is used in taper turning by offset method?

- A) Easy setting
- B) Minimum wear and strain
- C) Minimum friction
- D) Economical

Answer: B) Minimum wear and strain

337. What is the name of the pattern of work surface caused by the movement of cutting tool?

- A) Roughness
- B) Waviness
- C) Surface texture
- D) Roughness facing

Answer: C) Surface texture