

Duration: 30 Mins

Total Marks: 166

Q.ID: ITISKILL1668TL

1. Which method is non metallic threads are produced?

- A) Thread grinding B) Thread milling
C) Thread casting D) Thread chasing

Answer: C) Thread casting

2. Which thread is recommended for pipe and pipe fittings?

- A) BA thread B) BSP thread
C) BSF thread D) BSW thread

Answer: B) BSP thread

3. Calculate the driven gear to cut 1.5mm pitch thread on a job using a lathe having lead screw of 5mm pitch with driver gear of 30 teeth?

- A) 50 B) 60
C) 100 D) 120

Answer: C) 100

4. What is the main disadvantage of a braze welded joints?

- A) Dissimilar metals can be joined B) The joint not suitable for thicker sections
C) Heavy distortion due to heat D) It take more time for repairing

Answer: B) The joint not suitable for thicker sections

5. What will happen if threading tool is set below centre height?

- A) Major diameter will changed B) Pitch will changed
C) Difficult for catching D) Thread will be damaged

Answer: D) Thread will be damaged

6. Convert 8 Degree 44 minutes into minutes?

- A) 428 B) 536
C) 524 D) 424

Answer: C) 524

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

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

Answer: D) 2.25 mm

8. Which part of the lathe is locked while the form tool method is used for turning taper?

- A) Head stock B) Tail stock
C) Carriage D) Compound rest

Answer: C) Carriage

9. Which method of thread forming produce threads on non-metals?

- A) Thread rolling B) Thread milling
C) Thread casting D) Thread grinding

Answer: C) Thread casting

10. How many seconds is 1 Degree?

- A) 3600000% B) 360000%
C) 36000% D) 6000%

Answer: B) 360000%11. What is calculated by formula $0.75 \times \text{pitch}$?

- A) depth of acme thread B) depth of square thread
C) depth of buttress thread D) depth of metric thread

Answer: C) depth of buttress thread

12. What is the use of hand chaser?

- A) For production job B) To cut new thread
C) For making square thread D) Correcting and finishing a thread

Answer: D) Correcting and finishing a thread

13. Which bonding material is not affected by water, acid or normal temperature?

- A) Resinoid B) Vetrified
C) Backlite D) Rubber

Answer: B) Vetrified

14. What is the thread form cut by using chasers?

- A) Internal square thread B) Trapezoidal thread
C) External square thread D) External and internal V - Thread

Answer: D) External and internal V - Thread

15. Which parameter of a thread is measured by three wire method?

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

Answer: B) Effective diameter

16. Which formula is used to find depth of ACME thread?

- A) $0.5 \times \text{pitch}$
- B) $0.6403 \times \text{pitch}$
- C) $0.75 \times \text{pitch}$
- D) $0.6134 \times \text{pitch}$

Answer: A) $0.5 \times \text{pitch}$

17. How to measure the diameter of the small end of a external taper precisely?

- A) Precision roller with slip gauge
- B) Sine bar
- C) Screw gauge
- D) Vernier calipers

Answer: A) Precision roller with slip gauge

18. Which method is used for turning steep taper?

- A) Form tool
- B) Compound slide swivel
- C) Offset tail stock
- D) Taper turning attachment

Answer: B) Compound slide swivel

19. Calculate the least count of V.B.P if 23 div on main scale is divided into 12 equal parts

- A) 5 Degree
- B) 100 Degree
- C) 1 Degree - 50 Degree
- D) 28 Degree

Answer: A) 5 Degree

20. What is the schedule of lubrication for lathe bed?

- A) Frequently
- B) Daily
- C) Monthly
- D) Weekly

Answer: B) Daily

21. What is formula for finding depth of BSW external thread?

- A) $0.6134 \times \text{pitch}$
- B) $0.5 \times \text{pitch}$
- C) $0.6403 \times \text{pitch}$
- D) $0.7 \times \text{pitch}$

Answer: C) $0.6403 \times \text{pitch}$

22. What is the name of chuck that hardend steel sleeve having slits cut partly?

- A) Hydraulic chuck
- B) Combination chuck
- C) Magnetic chuck
- D) Collect chuck

Answer: D) Collect chuck

23. What is the purpose of tail on the lathe carrier?

- A) Locate and drive the work
- B) Protect the operator
- C) Give good finish
- D) Protect the work

Answer: A) Locate and drive the work

24. Calculate the change gear ratio to cut a thread of 7/16" lead on a lathe with lead screw of 4 TPI?

- A) 04-Jul
- B) 07-Apr
- C) 03-Apr
- D) 03-Jul

Answer: B) 07-Apr

25. What is the relationship between pitch and depth of a square thread?

- A) Depth is $3/4$ pitch
- B) Depth is $1/4$ pitch
- C) Depth is $1/2$ pitch
- D) Depth is equal to pitch

Answer: C) Depth is $1/2$ pitch

26. What is the shape of buttress thread flank?

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

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

27. What is the disadvantage of chaser?

- A) To cut knuckle thread only
- B) To cut square thread only
- C) To cut trapezoid thread only
- D) To cut V-thread only

Answer: D) To cut V-thread only

28. Which is the chip less method of thread production?

- A) Thread milling
- B) Thread grinding
- C) Thread rolling
- D) Die head

Answer: C) Thread rolling

29. Which is the method to produce accurate internal thread?

- A) Thread milling
- B) Thread rolling
- C) Using dies
- D) Thread chasers

Answer: A) Thread milling

30. Which mandrel is manufactured in order to reduce the number of mandrel?

- A) Solid mandrel
- B) Stepped mandrel
- C) Threaded mandrel
- D) Gang mandrel

Answer: B) Stepped mandrel

31. Which type thread is used in lathe lead screw?

- A) ACME
- B) Square
- C) Buttress
- D) Metric

Answer: A) ACME

32. What is the use of BSW thread?

- A) General purpose fastening
- B) Used in electrical appliances
- C) Load fitting
- D) Fast movement

Answer: A) General purpose fastening

33. What is the reason for using dial indicator instead of scribe point in Vernier height gauge?

- A) For good appearance
- B) For accurate measuring
- C) For accurate marking
- D) To check eccentricity

Answer: D) To check eccentricity

34. Which formula is used to find depth of buttress thread?

- A) $0.6403 \times \text{pitch}$ B) $0.75 \times \text{pitch}$
C) $0.5 \times \text{pitch}$ D) $0.6134 \times \text{pitch}$

Answer: B) $0.75 \times \text{pitch}$

35. Calculate the change gear required to cut 4mm pitch thread in a lathe having lead screw of 4mm (lathe stud gear driver has 50 teeth)

- A) 150 B) 25
C) 50 D) 100

Answer: C) 50

36. What is the thread depth of square thread SQ60x9?

- A) 4.5 mm B) 18 mm
C) 42 mm D) 9.0 mm

Answer: A) 4.5 mm

37. How many carriers are available in a set?

- A) 10 numbers B) 6 numbers
C) 8 numbers D) 4 numbers

Answer: A) 10 numbers

38. Which terms are needed to calculate tool life index?

- A) Cutting speed and rpm of job B) Depth of cut and rpm
C) Cutting speed time and index D) Cutting speed and feed

Answer: C) Cutting speed time and index

39. What is the core dia of square thread 62 x 10 mm pitch?

- A) 52.7 mm B) 57.4 mm
C) 52 mm D) 56.45 mm

Answer: C) 52 mm

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

- A) 0.35 B) 0.2
C) 0.15 D) 0.4

Answer: C) 0.15

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

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

Answer: D) In between centres

42. Which thread is used for general purpose fastening?

- A) BA B) BSF
C) Unified D) BSW

Answer: D) BSW

43. How can measure the minor diameter of a internal thread?

- A) By three wire method B) By screw thread micrometer
C) By vernier caliper D) Using slip gauge pack

Answer: C) By vernier caliper

44. Which form of thread is widely used for fastening purpose?

- A) Square thread B) Knuckle thread
C) Saw tooth thread D) V - thread

Answer: D) V - thread

45. Which is used to support hollows end jobs?

- A) Female centre B) Ball centre
C) Pipe centre D) Tipped centre

Answer: C) Pipe centre

46. What is the depth of cut for 10TPI BSW thread?

- A) $0.6134 \times 1/10$ Inch B) $0.6314 \times 1/10$ Inch
C) $0.6304 \times 1/10$ Inch D) $0.6403 \times 1/10$ Inch

Answer: D) $0.6403 \times 1/10$ Inch

47. How can measure the minor diameter of a internal thread accurately?

- A) By screw thread micrometer B) By plug gauge
C) By using slip gauge and precision rollers D) By three wire method

Answer: C) By using slip gauge and precision rollers

48. Calculate the driven gear to cut 1.5mm pitch thread on a job using a lathe having lead screw of 4mm pitch with driver gear 30 teeth?

- A) 80 B) 50
C) 60 D) 100

Answer: A) 80

49. What is the name of device used to drive the work during turning between centres?

- A) Driving plate B) Face plate
C) Lathe carrier D) Catch plate

Answer: C) Lathe carrier

50. Calculate the change gears to cut a worm of 0.35" lead on a lathe with a lead screw of 4TPI?

- A) Driver 30T, Driven 40 B) Driver 50T, Driven 30
C) Driver 70T, Driven 50 D) Driver 40T, Driven 50

Answer: C) Driver 70T, Driven 50

51. Which formula is to find crest width of ACME thread?

- A) 0.317 x pitch
C) 0.335 x pitch
- B) 0.75 x pitch
D) 0.5 x pitch

Answer: A) 0.317 x pitch

52. Which mandrel is used for machining similar part where internal diameter vary slightly?

- A) Stepped mandrels
C) Taper Shank mandrels
- B) Expansion stud mandrel
D) Gang mandrels

Answer: B) Expansion stud mandrel

53. Which is the form of Trapezoidal thread?

- A) BSF
C) BSW
- B) Metric
D) ACME

Answer: D) ACME

54. Calculate the least count of V.B.P if 23 div on main scale is divided into 12 scale divisions

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

Answer: A) 4 minutes

55. Which mechanism is used for converting linear motion into rotary motion in plunger dial gauge?

- A) Rack and pinion mechanism
C) Scroll and pinion mechanism
- B) Lever and scroll mechanism
D) Rack and scroll mechanism

Answer: A) Rack and pinion mechanism

56. How is the 'length of sine bars' specified?

- A) Length of datum surface
C) Total length of the sine bar
- B) Length of the rollers
D) Distance between the centres of the rollers

Answer: D) Distance between the centres of the rollers

57. What is the depth of square thread 60 x 5 mm pitch?

- A) 4 mm
C) 2.5 mm
- B) 3 mm
D) 5 mm

Answer: C) 2.5 mm

58. Which diameter is maintained in a job for making threads by rolling?

- A) Pitch diameter
C) Root diameter
- B) Minor diameter
D) Major diameter

Answer: A) Pitch diameter

59. What is the minor diameter of screw thread SQ 62 x 10.5 with depth clearance of 0.12 mm?

- A) 51.88 mm
C) 51.00 mm
- B) 51.26 mm
D) 46.64 mm

Answer: B) 51.26 mm

60. What is the purpose of using thread micrometer?

- A) Measure major diameter
C) Measure pitch of the thread
- B) Measure effective diameter
D) Measure minor diameter

Answer: B) Measure effective diameter

61. Which is the commonly used method to produce thread in nut?

- A) Tapping
C) Thread grinding
- B) Thread casting
D) Thread milling

Answer: A) Tapping

62. What is the purpose of using taper parallels in thread measurement?

- A) To measure the major diameter of internal thread
C) To measure the minor diameter of external thread
- B) To measure the major diameter of external thread
D) To measure the minor diameter of internal thread

Answer: D) To measure the minor diameter of internal thread

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

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

Answer: B) 6.75 mm

64. What is the purpose of the beveled edges of the rule in a vernier bevel protractor?

- A) Checking flatness
C) Checking 45 Degree and 60 Degree
- B) Checking squareness
D) Checking parallelism

Answer: C) Checking 45 Degree and 60 Degree

65. Which welding method is more suitable for joining dissimilar metals readily?

- A) Arc welding
C) Gas welding
- B) Tig welding
D) Braze welding

Answer: D) Braze welding

66. Which type of centre is used in the end of the job if no counter sink hole is permitted?

- A) Revolving centre
C) Female centre
- B) Ball centre
D) Insert type centre

Answer: C) Female centre

67. Find the gears for simple gear train, if pitch of lead screw is 6 mm and pitch of thread to be cut is 2 mm?

- A) 40/120
C) 30/120
- B) 40/150
D) 50/120

Answer: A) 40/120

68. Which part is pivoted to the disc of vernier bevel protractor?

- A) Disc
- B) Blade
- C) Dial
- D) Stock

Answer: C) Dial

69. Which type of thread is used in screw jack spindle?

- A) BSF thread
- B) Square thread
- C) BSW thread
- D) Worm thread

Answer: B) Square thread

70. How much times the spindle rotate the lead screw to cut 3 mm pitch thread in a 12 mm pitch lead screw?

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

Answer: B) 4 times

71. Which instrument can measure angle upto an accuracy of 5 minutes?

- A) Combination set
- B) Bevel gauge
- C) Angle gauge
- D) Vernier bevel protractor

Answer: D) Vernier bevel protractor

72. How metric chasing dial differ from British chasing dial?

- A) More than one worm wheel and different dial
- B) Same as British chasing dial
- C) One worm wheel and different dial
- D) One worm wheel and one dial

Answer: A) More than one worm wheel and different dial

73. Which material is used for making nozzle for gas welding?

- A) Copper
- B) High carbon steel
- C) Bronze
- D) Mild steel

Answer: A) Copper

74. Why the thread chaser is used to form threads?

- A) For easy thread cutting
- B) To get proper, crest, flat, root radius and profile
- C) To reduce labour
- D) To time saving

Answer: B) To get proper, crest, flat, root radius and profile

75. What is the isolating medium to prevent rapid cooling after brazing a tipped tool?

- A) Mica powder
- B) Water
- C) Wet sand
- D) Oil

Answer: A) Mica powder

76. Which mandrels is NOT used in between lathe centres?

- A) Gang mandrels
- B) Stepped mandrels
- C) Taper Shank mandrels
- D) Cone mandrels

Answer: C) Taper Shank mandrels

77. Which device uses buttress thread?

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

Answer: C) Carpentry vice

78. Which method of thread forming does not produce chips and used in mass production?

- A) Taps and dies
- B) Thread milling
- C) Thread rolling
- D) Thread grinding

Answer: C) Thread rolling

79. How the thread are formed in thread rolling?

- A) Plastic deformation
- B) Grinding
- C) Milling
- D) Casting

Answer: A) Plastic deformation

80. Which device is used as datum while marking with Vernier height gauge?

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

Answer: D) Surface plate

81. Which one is the example for transmission of motion using thread

- A) Bevel gearing
- B) Rack and pinion
- C) Worm and worm shaft
- D) Crank and slotted link

Answer: C) Worm and worm shaft

82. Which material is suitable for button die chaser?

- A) H.C.S
- B) H.S.S
- C) High strength material
- D) Low strength material

Answer: D) Low strength material

83. Calculate the driven gear required to cut 4mm pitch thread is a lathe having lead screw of 4mm with driven gear of 60 teeth?

- A) 50
- B) 120
- C) 100
- D) 60

Answer: D) 60

84. What is the depth of buttress thread if the pitch is 1.8 mm of 45 Degree angle?

- A) 1.23 mm
- B) 0.910 mm
- C) 0.42 mm
- D) 1.35 mm

Answer: D) 1.35 mm

85. What is removing dull grain in order to make grinding wheel sharp?

- A) Glazing
- C) Loading

- B) Trueing
- D) Dressing

Answer: D) Dressing

86. Calculate the gear ratio to cut a 1/4 inch lead on a lathe with lead screw of 2TPI?

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

Answer: C) (1/2)

87. Which one is the disadvantage of taper turning by compound slide method?

- A) Taper length is limited to the movement of the top slide
 - C) Steep taper cannot be produced
- B) Damages the centre drilled holes of the work
 - D) Only external taper can be turned

Answer: A) Taper length is limited to the movement of the top slide

88. What is the depth of ACME thread of 1inch major diameter 6TPI?

- A) 0.082
 - C) 0.09
- B) 0.084
 - D) 0.08

Answer: B) 0.084

89. What percentage of cutting speed is reduced for tool life doubling?

- A) 0.083
 - C) 0.081
- B) 0.082
 - D) 0.084

Answer: A) 0.083

90. Which wheel is used for grinding tough materials?

- A) Ceramic
 - C) Cemented carbide
- B) Aluminium oxide
 - D) Silicon carbide

Answer: B) Aluminium oxide

91. What is protected by providing pieces between work and carrier while clamping?

- A) Carrier
 - C) Live centre
- B) Dead centre
 - D) Job surface

Answer: D) Job surface

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

- A) Pitch/2
 - C) Pitch/6
- B) Pitch/4
 - D) Pitch/8

Answer: D) Pitch/8

93. How much the compound rest should be tilted for cutting metric thread by compound rest?

- A) 30 Degree
- B) 15 Degree

- C) 60 Degree

- D) 45 Degree

Answer: A) 30 Degree

94. What is the core dia of square thread 75 x 11 mm pitch?

- A) 65.8 mm
 - C) 64 mm
- B) 70 mm
 - D) 60 mm

Answer: C) 64 mm

95. What is the use of a sine bar?

- A) To measure the gap
 - C) To measure the length of a taper job
- B) To determine the angle of tapered job
 - D) To measure the diameter of the job

Answer: B) To determine the angle of tapered job

96. What is the thread depth of square thread SQ60x9?

- A) 9.0 mm
 - C) 4.5 mm
- B) 42 mm
 - D) 18 mm

Answer: C) 4.5 mm

97. What is the angle of ACME thread

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

Answer: B) 29 Degree

98. What is the width of the tool to cut square thread of 30 x 3 mm pitch?

- A) 3 mm
 - C) 2 mm
- B) 6 mm
 - D) 1.5 mm

Answer: D) 1.5 mm

99. Find the gears required to cut 4.5mm pitch on a lathe having a lead screw of 4 TPI. Gears available from 20 to 120 teeth by 5 teeth with a special gear of 127T.

- A) 127T on driver and 90T on driven
 - C) 90T on driver and 127T on driven
- B) 60T on driver and 127T on driven
 - D) 127T on driver and 60T on driven

Answer: C) 90T on driver and 127T on driven

100. How many number of teeth in translating gear used for cutting metric thread on British lathe?

- A) 100
 - C) 30
- B) 120
 - D) 63

Answer: D) 63

101. How many un-numbered divisions on the British chasing dial?

- A) 3
 - C) 4
- B) 12
 - D) 18

Answer: C) 4

102. What is the angle of metric ACME thread

- A) 47.5 Degree B) 45 Degree
C) 29 Degree D) 30 Degree

Answer: D) 30 Degree

103. Which is the angle of inclination in the thread to the imaginary perpendicular line?

- A) Acute angle B) Right angle
C) Obtuse angle D) Helix angle

Answer: D) Helix angle

104. What term indicate actual size of the abrasive grain?

- A) Grade of bond B) Grit size
C) Abrasive type D) Structure

Answer: B) Grit size

105. What is the effect of reversing the machine with out disengaging the half nut in thread cutting?

- A) For avoid catching the thread in each cut B) For improve the productivity
C) Reduce the wear and tear of half nut D) For the use of chasing dial

Answer: A) For avoid catching the thread in each cut

106. What is thread element that determine the direction of rotation on screw thread?

- A) Lead of thread B) Depth of thread
C) Hand of thread D) Pitch of thread

Answer: C) Hand of thread

107. Calculate the change gears necessary to cut a thread of 7/16" lead on a lathe with a lead screw of 4TPI?

- A) Driver 30T, Driven 40T B) Driven 30T, Driver 40T
C) Driver 70T, Driven 40T D) Driven 70T, Driver 40T

Answer: C) Driver 70T, Driven 40T

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

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

Answer: C) 1.25 mm

109. What does BIS stand for?

- A) Bureau of international standard B) Bureau of international society
C) Bureau of Indian standard D) Bureau of Indian society

Answer: C) Bureau of Indian standard

110. What should be the heights of gauge block to be built to check the work angle of 30 Degree using 150 mm sine bar?

- A) 291.26 B) 75

- C) 145.63 D) 38.62

Answer: B) 75

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

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

Answer: D) 4.5 mm

112. Which material is used for making the head of soldering iron?

- A) Forged copper B) Stainless steel
C) Forged steel D) Forged aluminium

Answer: A) Forged copper

113. What is the name of thread producing method by cold forging and by plastic deformation?

- A) Thread milling B) Thread grinding
C) Thread casting D) Thread rolling

Answer: D) Thread rolling

114. What is the angle of a BIS metric thread?

- A) 45 Degree B) 27.5 Degree
C) 60 Degree D) 55 Degree

Answer: C) 60 Degree

115. How many teeth are in translating gear for cutting metric thread on British lathe?

- A) 122 B) 129
C) 125 D) 127

Answer: D) 127

116. Which is the term used to express grinding wheels to hold the abrasive particle together?

- A) Bond B) Structure
C) Grit D) Grain

Answer: A) Bond

117. What is the least count of vernier height gauge?

- A) 0.001 mm B) 0.005 mm
C) 0.002 mm D) 0.020 mm

Answer: D) 0.020 mm

118. Which method of threading is used in mass production?

- A) Thread grinding B) Using taps and dies
C) Thread rolling D) Use single point cutting tool

Answer: C) Thread rolling

119. What is the core diameter of BSW thread of 1 inch outer dia and 8 TPI

- A) 0.84 Inch
C) 0.83 Inch
- B) 0.80 Inch
D) 0.81 Inch

Answer: A) 0.84 Inch

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

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

Answer: D) 0.125 x pitch

121. What are the uses of B.S.P thread?

- A) Automobile industries
C) Pipe and pipe fittings
- B) General fastening
D) Load transmission

Answer: C) Pipe and pipe fittings

122. What is the only thread form cut using diehead is turret lathe?

- A) ACME
C) Saw - Tooth
- B) Square
D) V-Thread

Answer: D) V-Thread

123. Which one is the disadvantage of using tail stock offset method?

- A) Taper length is limited
C) Only hand feed can be given
- B) External threads on taper can't produce
D) Taper turning is possible when work held between centre only

Answer: D) Taper turning is possible when work held between centre only

124. What is the shape of interchangeable anvils used in screw thread micrometer?

- A) V-shape
C) Circular shape
- B) Radius shape
D) Square shape

Answer: A) V-shape

125. What is 1.25 stands for a metric thread designated as M12 x 1.25?

- A) Major dia of thread
C) Minor dia of thread
- B) Pitch of the thread
D) Depth of thread

Answer: B) Pitch of the thread

126. Select a suitable instrument for measuring angles?

- A) Calipers
C) Vernier height gauge
- B) Vernier caliper
D) Vernier bevel protractor

Answer: D) Vernier bevel protractor

127. What is the reason for using ACME thread in lathe lead screw?

- A) Suitable for big diameter thread
B) Enable easy engagement

- C) Manufacturing cost is less
D) Easily available

Answer: B) Enable easy engagement

128. What is the formula for finding the depth of a BIS metric thread?

- A) $0.6134 \times \text{pitch}$
C) $0.6431 \times \text{pitch}$
- B) $0.6403 \times \text{pitch}$
D) $0.6043 \times \text{pitch}$

Answer: A) 0.6134 x pitch

129. Which is the smallest unit of angular measurement?

- A) Radian
C) Degree
- B) Seconds
D) Minutes

Answer: B) Seconds

130. What is the criteria for the selection of interchangeable anvil of a screw thread micrometer?

- A) Minor diameter
C) Root diameter
- B) Profile and pitch
D) Major diameter

Answer: B) Profile and pitch

131. Which is main criteria to increase the tool life?

- A) Cutting speed
C) Feed
- B) Material
D) Depth of cut

Answer: A) Cutting speed

132. What is the formula to find out core diameter of external thread by using prisms and micrometer?

- A) Core dia = Measurement over prisms ? Height of prisms + Single depth
C) Core dia = Measurement over prisms ? Height of prisms ? Single depth of thread
- B) Core dia = Measurement over prisms + Height of prisms ? Single depth
D) Core dia = Measurement over prisms ? Height of prisms + Two depth

Answer: C) Core dia = Measurement over prisms ? Height of prisms ? Single depth of thread

133. Which angle is ground on ACME threading tool?

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

Answer: A) 29 Degree

134. Calculate the driven gear to cut 2mm pitch on a job using a lathe having lead screw of 4mm pitch with driven gear 50 teeth?

- A) 50
C) 60
- B) 100
D) 120

Answer: B) 100

135. Which carrier with V-groove provided and used to hold small diameter and square sections?

- A) Bent tail
B) Straight tail

- C) Clamp type D) Safety clamp type

Answer: C) Clamp type

136. A thread is represented as M12 x 1.5. What does represent the letter 12?

- A) Pitch B) Root diameter
C) Major diameter D) Minor diameter

Answer: C) Major diameter

137. Find the gear required to cut 3 mm pitch in a lathe having a lead screw of 6 TPI gear available from 20 to 120 teeth by 5 teeth with a special gear of 127 teeth?

- A) Driver 90 teeth Driven 127 B) Driver 20 teeth Driven 60 teeth
C) Driver 127 teeth Driven 90 D) Driver 60 teeth Driven 20 teeth

Answer: A) Driver 90 teeth Driven 127 teeth

138. What is the reason for providing buttress thread in carpentry vice?

- A) For better appearance B) For easy manufacturing
C) For easy use D) Pressure acts at one flank

Answer: D) Pressure acts at one flank

139. Which is the cause of small particles of the material become embedded in the space between the grains of the grinding wheel?

- A) Dressing B) Grooving
C) Glazing D) Loading

Answer: D) Loading

140. What is the value of tool life index for cutting cast iron by cemented carbide tool?

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

Answer: B) 0.1

141. What is the accuracy of the protractor head of a combination set?

- A) 1 Degree B) 1 Degree
C) 1 Degree D) 5 Degree

Answer: A) 1 Degree

142. Which is the angle of buttress thread?

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

Answer: D) 45 Degree

143. Which method of brazing is commonly used to braze of carbide tip on a shank?

- A) Induction brazing B) Torch brazing
C) Arc brazing D) Furnace brazing

Answer: B) Torch brazing

144. Which method is preferred for producing small length taper with least accuracy?

- A) Compound slide method B) Taper turning attachment method
C) Tail stock offset method D) Form tool method

Answer: D) Form tool method

145. How is the vernier height gauge generally specified?

- A) Width of beam B) Height of beam
C) Thickness of beam D) Size of base

Answer: B) Height of beam

146. Which is the welding process, if base metal and filler is melted to form the joint?

- A) By braze welding B) By gas welding
C) By arc welding D) By tig welding

Answer: C) By arc welding

147. What is the purpose of using v prism method in thread measurement?

- A) Measure the pitch of the thread B) Measure minor diameter
C) Measure effective diameter D) Measure major diameter

Answer: B) Measure minor diameter

148. Which one of the following factor greatly causes to reduce tool life?

- A) Depth of cut B) Material
C) Cutting speed D) Feed

Answer: C) Cutting speed

149. Which angle is provided on the metric screw thread micrometer anvil?

- A) 55 Degree B) 47.5 Degree
C) 60 Degree D) 30 Degree

Answer: C) 60 Degree

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

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

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

151. What is the formula for finding gear ratio for fractional pitch thread?

- A) $DR/DN = \text{Lead of work/}$ B) $DR/DN = \text{TPI on lead}$
No. Of threads per inch screw/ TPI to cut

- C) DR/DN = Leads of screw to be cut X No. Of threads per inch of lead screw
D) DR/DN = Lead of head screw/ Lead of work

Answer: C) DR/DN = Leads of screw to be cut X No. Of threads per inch of lead screw

152. What is the angle of saw tooth thread?

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

Answer: A) 30 Degree

153. Which part of the combination set is used for measuring the angles?

- A) Protractor head
B) Square head
C) Centre head
D) Rule

Answer: A) Protractor head

154. Why the ball centre is preferred in tail stock offset method?

- A) For good surface finish
B) To avoid damage to the centre drilled hole of the job
C) For provide power feed
D) For accurate setting

Answer: B) To avoid damage to the centre drilled hole of the job

155. What type of thread can be produced by a die?

- A) Internal square thread
B) External square thread
C) External V - thread
D) Internal V - thread

Answer: C) External V - thread

156. Find the change gear (driven gear) to cut 2.5mm pitch thread using a lathe having lead screw of pitch 5mm with driver gear 60 teeth?

- A) 120
B) 60
C) 150
D) 100

Answer: A) 120

157. Which chuck is mainly used for getting a very effective grip over the job?

- A) Hydraulic chuck
B) Magnetic chuck
C) Push - out chucks
D) Collect chuck

Answer: A) Hydraulic chuck

158. Calculate the change gear (driver gear) if driven gear has 120 teeth to cut 3mm pitch on a job using lathe having 6 mm pitch lead screw?

- A) 100
B) 50
C) 60
D) 150

Answer: C) 60

159. What is the minor diameter of Trapezoidal square thread Tr 40 x 7 depth clearance of 0.01 mm?

- A) 33.00 mm
B) 36.49 mm
C) 36.50 mm
D) 32.98 mm

Answer: D) 32.98 mm

160. Which is the advantage of taper turning by compound slide method?

- A) Thread on taper portion can be produced
B) Long taper can be produced
C) Most suitable for duplicate taper work
D) Steep taper can be produced

Answer: D) Steep taper can be produced

161. How is the filler material distributed in the joint in braze welding?

- A) By splashing
B) By capillary action
C) By fission
D) By fusion

Answer: B) By capillary action

162. Calculate the width of flat of buttress thread 6 mm pitch?

- A) 1 mm
B) 1.5 mm
C) 2 mm
D) 0.75 mm

Answer: D) 0.75 mm

163. What is the relationship between pitch and depth of a buttress thread?

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

Answer: B) depth = 0.75 x pitch

164. Calculate the change gear (driven gear) if driver is 50 teeth to cut 2.5mm pitch thread on a job by lathe having a lead screw of 5mm pitch?

- A) 150
B) 100
C) 120
D) 60

Answer: B) 100

165. Calculate the amount of off-set if total length of job = 80 mm and tan = 5 Degree 45 minutes?

- A) 7 mm
B) 10 mm
C) 12 mm
D) 8 mm

Answer: D) 8 mm

166. Which type of thread is produced by tap and die?

- A) Square thread
B) ACME thread
C) V - thread
D) Saw - tooth thread

Answer: C) V - thread