

**Duration: 50 Mins**

**Total Marks: 50**

**ID: ITISKILL1797M0**

Student Name: \_\_\_\_\_ Roll No: \_\_\_\_\_

**1.** The CNC keyboards have with following keys?

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

- |  |   |
|--|---|
| C) Cross checking of programmable DATA | D) Finding out of tool geometrical values |
|--|---|

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

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

**9.** 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) 5C     | B) 2C, L |
| C) 2L, 2C | D) 3L,2C |

**3.** Which M code is used to activate coolant pump in CNC machine?

- |        |        |
|--------|--------|
| A) M08 | B) M06 |
| C) M01 | D) M09 |

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

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

**4.** 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 |

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

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

**5.** 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) G01 x 42.0 z 0.0 F 0.1; | B) G00 x 42.0 z 0.0 F 0.1; |
| C) G02 x 42.0 z 0.0 F 0.1; | D) G03 x 42.0 z 0.0 F 0.1; |

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

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

**6.** Which of the following is not advantage of CNC machine?

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

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

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

**7.** What do you mean by MPG?

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

**14.** Which one of the following code used to switch off the coolant pump?

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

**8.** What do you mean by simulation?

- |                                    |                                      |
|------------------------------------|--------------------------------------|
| A) Editing of related part program | B) Finding out of work offset values |
|------------------------------------|--------------------------------------|

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

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

**16.** What is the use of Goo activates the command?

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

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

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

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

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

19. What is the purpose of MDI mode?

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

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

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

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

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

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

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

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

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

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

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

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

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

26. In Which mode we can input the program command

manually?

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

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

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

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

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

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

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

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

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

31. Which command activates in automatic mode?

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

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

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

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

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

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

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

35. What is the full form of MDI?

- A) Moderated Data input  
B) Mechanical Data Implantation

C) Manually Data Input

D) Mounting of Diagonal Impact

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

A) High cutting speed

B) High feed

C) Mass production

D) Feed back control

37. Which mode is used to edit the program?

A) Edit mode

B) Auto mode

C) Jog mode

D) MDI mode

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

A) The cutting tool has to be changed

B) Rewind the program once again

C) Tool returns from reference point to work place

D) The spindle rotation has to stop

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

A) G41

B) G42

C) G32

D) G40

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

A) Can be used again and again

B) Can be used again but it has to be modified every time

C) Cannot say

D) Can be used only once

41. How the part programming mistakes can be avoided?

A) NC (Numerical control) machine only

B) CNC (Computer numerical control) machine only

C) Cannot be avoided in CNC machine

D) Both NC and CNC machine

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

A) Edit mode

B) Jog mode

C) MPG mode

D) Auto mode

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

A) Facing

B) Drilling

C) Grooving

D) Parting

44. What is the purpose of G28 code based on FANUC CNC control system?

A) Tool has to return from reference point

B) Circular interpolation clockwise

C) Circular interpolation counter clockwise

D) Tool has return to reference point

45. Which axis is parallel to Z - axis?

A) X - axis

B) Tool axis

C) Y-axis

D) Spindle axis

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

A) 3

B) 5

C) 4

D) 2

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

A) G04

B) G03

C) G02

D) G01

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

A) Switch of the coolant pump

B) The cutting tool has to be changed

C) Spindle rotation in counter clockwise direction

D) End of the program with rewind

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

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

B) Execute the program

C) Can read only the program

D) Simulation of the program

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

A) M30

B) M40

C) M39

D) M38