

Duration: 50 Mins

Total Marks: 50

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Student Name: _____ Roll No: _____

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

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

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

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

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

9. Which mode is used to edit the program?

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

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

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

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

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

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

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

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

- A) Circular interpolation clockwise
- B) Circular interpolation counter clockwise
- C) Tool has to return from reference point
- D) Tool has return to reference point

5. What is the full form of MDI?

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

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

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

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

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

13. What do you mean by simulation?

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

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

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

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

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

8. Which command activates in automatic mode?

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

15. 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) 2C, L
- B) 2L, 2C
- C) 3L,2C
- D) 5C

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

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

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

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

18. 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

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

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

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

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

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

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

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

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

23. How the part programming mistakes can be avoided?

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

24. What is the purpose of MDI mode?

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

34. 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) G01 x 42.0 z 0.0 F 0.1;
- C) G00 x 42.0 z 0.0 F 0.1;
- D) G02 x 42.0 z 0.0 F 0.1;

35. What do you mean by MPG?

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

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

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

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

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

38. What is the use of G00 activates the command?

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

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

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

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

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

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

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

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

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

43. Which axis is parallel to Z - axis?

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

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

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

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

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

46. The CNC keyboards have with following keys?

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

47. 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 |

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

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

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

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

50. Which mode execute the program continuously one block after another block?

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