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Answer Key

Duration: 30 Mins

Total Marks: 166

Q.ID: ITISKILL2276JI

1. Which method is non metallic threads are produced?

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

**Answer: A) Thread casting**

2. 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**

3. How the thread are formed in thread rolling?

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

**Answer: A) Plastic deformation**

4. 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) 100                      B) 80  
C) 60                      D) 50

**Answer: B) 80**

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

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

**Answer: D) 127**

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

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

**Answer: A) Thread rolling**

7. 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**

8. What is the disadvantage of chaser?

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

**Answer: C) To cut V-thread only**

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

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

**Answer: D) 4.5 mm**

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

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

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

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

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

**Answer: B) V - thread**

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

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

**Answer: A) The joint not suitable for thicker sections**

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

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

**Answer: C) Thread casting**

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

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

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

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

**Answer: C) 07-Apr**

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

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

**Answer: D) Pitch/8**

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

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

**Answer: D) Cutting speed**

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

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

**Answer: B) Square thread**

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

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

**Answer: D) V-shape**

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

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

**Answer: C)  $0.75 \times \text{pitch}$**

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

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

**Answer: D) Torch brazing**

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

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

**Answer: D) Tapping**

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

- A) Major diameter will change                      B) Thread will be damaged

- C) Pitch will changed                      D) Difficult for catching

**Answer: B) Thread will be damaged**

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

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

**Answer: C) Helix angle**

25. How many carriers are available in a set?

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

**Answer: B) 10 numbers**

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

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

**Answer: C) To check eccentricity**

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

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

**Answer: C) 8 mm**

28. What is the shape of buttress thread flank?

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

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

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

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

**Answer: B) 2.5 mm**

30. What does BIS stand for?

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

**Answer: A) Bureau of Indian standard**

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

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

**Answer: C) Loading**

32. 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**

33. Which material is suitable for button die chaser?

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

**Answer: A) Low strength material**

34. 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) 60    B) 120  
C) 50    D) 100

**Answer: D) 100**

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

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

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

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

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

**Answer: C) 51.26 mm**

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

- A)  $0.75 \times \text{pitch}$                                       B)  $0.335 \times \text{pitch}$   
C)  $0.5 \times \text{pitch}$                                       D)  $0.317 \times \text{pitch}$

**Answer: D)  $0.317 \times \text{pitch}$**

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

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

**Answer: A) 1.35 mm**

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

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

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

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

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

**Answer: B) Pitch diameter**

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

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

**Answer: D) External V - thread**

42. Select a suitable instrument for measuring angles?

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

**Answer: A) Vernier bevel protractor**

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

- A) Suitable for big diameter thread                  B) Easily available  
C) Manufacturing cost is less                  D) Enable easy engagement

**Answer: D) Enable easy engagement**

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

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

**Answer: C) V - thread**

45. 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**

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

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

**Answer: B) Distance between the centres of the rollers**

47. 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**

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

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

**Answer: B) Rack and pinion mechanism**

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

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

**Answer: C) 0.083**

50. How is the vernier height gauge generally specified?

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

**Answer: D) Height of beam**

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

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

**Answer: A) In between centres**

52. 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      B) 90T on driver and 127T on driven  
C) 127T on driver and 60T on driven      D) 60T on driver and 127T on driven

**Answer: B) 90T on driver and 127T on driven**

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

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

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

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

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

**Answer: C)  $DR/DN = \text{Leads of screw to be cut} \times \text{No. Of threads per inch of lead screw}$**

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

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

**Answer: C) Precision roller with slip gauge**

56. 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) 100                                  B) 120

- C) 50                                  D) 60

**Answer: A) 100**

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

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

**Answer: C) Collect chuck**

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

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

**Answer: A) 0.15**

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

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

**Answer: C) Carriage**

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

- A) Taper length is limited              B) Only hand feed can be given  
C) 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**

61. What is the angle of saw tooth thread?

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

**Answer: C) 30 Degree**

62. Which method is used for turning steep taper?

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

**Answer: A) Compound slide swivel**

63. Which is the form of Trapezoidal thread?

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

**Answer: C) ACME**

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

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

**Answer: A) Forged copper**

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

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

**Answer: A) 0.6403 x 1/10 Inch**

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

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

**Answer: D) 0.5 x pitch**

67. Which device uses buttress thread?

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

**Answer: C) Carpentry vice**

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

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

**Answer: D) 0.084**

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

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

**Answer: A) By arc welding**

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

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

**Answer: A) Vernier bevel protractor**

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

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

**Answer: A) To measure the minor diameter of internal thread**

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

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

**Answer: A) By using slip gauge and precision rollers**

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

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

**Answer: C) Checking 45 Degree and 60 Degree**

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

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

**Answer: B) Pipe and pipe fittings**

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

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

**Answer: C) Hydraulic chuck**

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

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

**Answer: D) Dial**

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

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

**Answer: C) Surface plate**

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

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

**Answer: B) Steep taper can be produced**

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

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

**Answer: C) Taper Shank mandrels**

80. 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) 100      B) 25  
C) 50      D) 150

**Answer: C) 50**

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

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

**Answer: D) 60 Degree**

82. Which is used to support hollows end jobs?

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

**Answer: D) Pipe centre**

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

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

**Answer: A) Pitch of the thread**

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

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

**Answer: A) depth = 0.75 x pitch**

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

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

**Answer: B) Female centre**

86. 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**

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

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

**Answer: A)  $0.6134 \times \text{pitch}$**

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

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

**Answer: B) 6.75 mm**

89. 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) 150
- B) 100
- C) 60
- D) 120

**Answer: D) 120**

90. Which thread is used for general purpose fastening?

- A) BA
- B) BSF

C) BSW

D) Unified

**Answer: C) BSW**

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

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

**Answer: D) 4 minutes**

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

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

**Answer: C) 0.1**

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

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

**Answer: C) For avoid catching the thread in each cut**

94. Which angle is ground on ACME threading tool?

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

**Answer: C) 29 Degree**

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

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

**Answer: A) 63**

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

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

**Answer: B) Effective diameter**

97. 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) 120
- B) 100
- C) 150
- D) 60

**Answer: B) 100**

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

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

**Answer: C) ACME**

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

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

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

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

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

**Answer: A) BSP thread**

101. What is the use of hand chaser?

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

**Answer: C) Correcting and finishing a thread**

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

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

**Answer: D) Daily**

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

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

**Answer: B) Thread rolling**

104. 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) 60
- B) 100
- C) 50
- D) 120

**Answer: A) 60**

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

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

**Answer: A) Driver 70T, Driven 50**

106. 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) 38.62
- B) 75
- C) 291.26
- D) 145.63

**Answer: B) 75**

107. Which is the smallest unit of angular measurement?

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

**Answer: D) Seconds**

108. Which wheel is used for grinding tough materials?

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

**Answer: B) Aluminium oxide**

109. What is the use of a sine bar?

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

**Answer: C) To determine the angle of tapered job**

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

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

**Answer: A) Thread rolling**

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

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

**Answer: A) 1.5 mm**

112. What is the use of BSW thread?

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

**Answer: D) General purpose fastening**

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

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

**Answer: C) Mica powder**

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

- A) Safety clamp type
- B) Bent tail
- C) Straight tail
- D) Clamp type

**Answer: D) Clamp type**

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

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

**Answer: C) Thread milling**

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

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

**Answer: C) Lathe carrier**

**117.** Which is main criteria to increase the tool life?

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

**Answer: D) Cutting speed**

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

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

**Answer: D) 52 mm**

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

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

**Answer: B) 0.84 Inch**

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

- A) 30 Degree
- B) 60 Degree
- C) 45 Degree
- D) 15 Degree

**Answer: A) 30 Degree**

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

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

**Answer: A) V-Thread**

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

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

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

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

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

**Answer: B) Expansion stud mandrel**

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

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

**Answer: A) 4 times**

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

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

**Answer: B) Protractor head**

**126.** What is the angle of metric ACME thread

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

**Answer: B) 30 Degree**

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

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

**Answer: B) Job surface**

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

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

**Answer: C) 32.98 mm**

**129.** 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**

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

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

**Answer: A) 64 mm**

**131.** What is the thread depth of square thread SQ60x9?

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

**Answer: D) 4.5 mm**

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

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

**Answer: A) Hand of thread**

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

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

**Answer: A) 60 Degree**

**134.** 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                          B) 40/150  
C) 50/120                          D) 30/120

**Answer: A) 40/120**

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

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

**Answer: A) Form tool method**

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

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

**Answer: B) Thread rolling**

**137.** What is calculated by formula  $0.75 \times \text{pitch}$ ?

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

**Answer: B) depth of buttress thread**

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

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

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

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

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

**Answer: A) By capillary action**

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

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

**Answer: A) 4.5 mm**

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

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

**Answer: B) (1/2)**

**142.** Convert 8 Degree 44 minutes into minutes?

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

**Answer: A) 524**

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

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

**Answer: B) Profile and pitch**

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

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

**Answer: A) Worm and worm shaft**

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

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

**Answer: D) Dressing**

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

- A) 18    B) 12  
C) 4    D) 3

**Answer: C) 4**

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

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

**Answer: B) Major diameter**

**148.** 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 20 teeth Driven 60 teeth      B) Driver 127 teeth Driven 90 teeth  
C) Driver 60 teeth Driven 20 teeth      D) Driver 90 teeth Driven 127 teeth

**Answer: D) Driver 90 teeth Driven 127 teeth**

**149.** What term indicate actual size of the abrasive grain?

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

**Answer: D) Grit size**

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

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

**Answer: A) Depth is 1/2 pitch**

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

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

**Answer: A) By vernier caliper**

**152.** What is the purpose of using thread micrometer?

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

**Answer: D) Measure effective diameter**

**153.** 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) 150      D) 60

**Answer: D) 60**

**154.** What is the angle of ACME thread

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

**Answer: A) 29 Degree**

**155.** How many seconds is 1 Degree?

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

**Answer: A) 360000%**

**156.** Which terms are needed to calculate tool life index?

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

**Answer: A) Cutting speed time and index**

**157.** What is the least count of vernier height gauge?

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

**Answer: B) 0.020 mm**

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

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

**Answer: C) Driver 70T, Driven 40T**

**159.** Which material is used for making nozzle for gas welding?

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

**Answer: B) Copper**

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

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

**Answer: A) Braze welding**

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

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

**Answer: D) 1.25 mm**

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

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

**Answer: B) Pressure acts at one flank**

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

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

**Answer: A) Vetrified**

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

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

**Answer: B) Bond**

**165.** Which is the angle of buttress thread?

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

**Answer: B) 45 Degree**

**166.** What is the purpose of tail on the lathe carrier?

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

**Answer: B) Locate and drive the work**