

**Duration: 30 Mins****Total Marks: 166****Q.ID: ITISKILL2621XZ**

1. 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 30T, Driven 40  
C) Driver 40T, Driven 50      D) Driver 50T, Driven 30

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

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

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

**Answer: B) 64 mm**

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

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

**Answer: B) Dressing**

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

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

**Answer: A) Profile and pitch**

5. What is the purpose of using thread micrometer?

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

**Answer: A) Measure effective diameter**

6. 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)  $0.5 \times \text{pitch}$**

7. 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) Driver 70T, Driven 40T  
C) Driven 70T, Driver 40T      D) Driven 30T, Driver 40T

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

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

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

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

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

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

**Answer: D) By capillary action**

10. 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) 46.64 mm                              D) 51.26 mm

**Answer: D) 51.26 mm**

11. Which is the smallest unit of angular measurement?

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

**Answer: A) Seconds**

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

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

**Answer: B) 127**

13. Which is used to support hollows end jobs?

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

**Answer: B) Pipe centre**

14. What is the use of BSW thread?

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

**Answer: B) General purpose fastening**

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

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

**Answer: B) Hydraulic chuck**

16. 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**

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

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

**Answer: D) 0.6134 x pitch**

18. Which angle is ground on ACME threading tool?

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

**Answer: D) 29 Degree**

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

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

**Answer: B) Expansion stud mandrel**

20. What is the use of a sine bar?

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

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

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

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

**Answer: A) 1.5 mm**

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

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

**Answer: C) Bond**

23. How is the vernier height gauge generally specified?

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

**Answer: B) Height of beam**

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

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

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

25. Which is the angle of inclination in the thread to the

imaginary perpendicular line?

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

**Answer: B) Helix angle**

26. 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) 100  
C) 60    D) 150

**Answer: A) 120**

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

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

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

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

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

**Answer: A) V - thread**

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

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

**Answer: C) Thread rolling**

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

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

**Answer: C) Effective diameter**

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

- A) 100    B) 120  
C) 30    D) 63

**Answer: D) 63**

32. 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**

33. 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?



- C) 0.6134 x pitch                      D) 0.6403 x pitch

**Answer: D) 0.6403 x pitch**

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

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

**Answer: A) 4 minutes**

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

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

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

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

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

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

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

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

**Answer: B) Dial**

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

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

**Answer: A) 07-Apr**

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

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

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

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

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

**Answer: C) 0.084**

**58.** Which mandrels is NOT used in between lathe centres?

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

**Answer: C) Taper Shank mandrels**

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

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

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

**60.** 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 feed                      D) Cutting speed and rpm of job

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

**61.** How many carriers are available in a set?

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

**Answer: A) 10 numbers**

**62.** 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) 30/120  
C) 50/120                                         D) 40/150

**Answer: A) 40/120**

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

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

**Answer: A) 360000%**

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

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

**Answer: B) Female centre**

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

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

**Answer: A) Pitch/8**

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

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

**Answer: A) To check eccentricity**

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

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

**Answer: A) 52 mm**

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

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

**Answer: C) Thread rolling**

69. 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**

70. What is the angle of ACME thread

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

**Answer: C) 29 Degree**

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

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

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

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

**Answer: A) Major diameter**

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

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

**Answer: B) 0.020 mm**

74. 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**

75. Convert 8 Degree 44 minutes into minutes?

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

**Answer: C) 524**

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

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

**Answer: A) Cutting speed**

77. 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**

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

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

**Answer: B) 4.5 mm**

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

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

**Answer: A) Daily**

80. 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) 100                                D) 50

**Answer: C) 100**

81. Which device uses buttress thread?

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

**Answer: D) Carpentry vice**

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

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

**Answer: A) V-shape**

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

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

**Answer: A) Surface plate**

84. Which wheel is used for grinding tough materials?

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

**Answer: D) Aluminium oxide**

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

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

**Answer: A) 6.75 mm**

86. 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)  $0.317 \times \text{pitch}$**

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

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

**Answer: B) Lathe carrier**

88. 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) 75  
B) 291.26  
C) 38.62  
D) 145.63

**Answer: A) 75**

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

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

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

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

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

**Answer: A)  $0.6403 \times 1/10$  Inch**

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

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

**Answer: B) Thread rolling**

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

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

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

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

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

**Answer: C) Collect chuck**

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

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

**Answer: A) Loading**

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

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

**Answer: D) Vernier bevel protractor**

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

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

**Answer: C) Tapping**

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

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

**Answer: A) Pitch diameter**

98. 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 90 teeth Driven 127 teeth  
D) Driver 60 teeth Driven 20 teeth

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

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

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

**Answer: B) 1.25 mm**

100. Select a suitable instrument for measuring angles?

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

**Answer: B) Vernier bevel protractor**

101. Which material is suitable for button die chaser?

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

**Answer: C) Low strength material**

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

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

**Answer: B) Mica powder**

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

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

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

**104.** 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) 50                                B) 25  
C) 100                              D) 150

**Answer: A) 50**

**105.** 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) 90T on driver and 127T on B) 127T on driver and 90T on  
driven                              driven  
C) 60T on driver and 127T on D) 127T on driver and 60T on  
driven                              driven

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

**106.** Which method is used for turning steep taper?

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

**Answer: D) Compound slide swivel**

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

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

**Answer: B) Braze welding**

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

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

**Answer: B) Grit size**

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

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

**Answer: D) 0.84 Inch**

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

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

**Answer: A) In between centres**

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

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

**Answer: B) By arc welding**

**112.** How metric chasing dial differ from British chasing dial?

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

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

**113.** 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) 50                                B) 150  
C) 100                              D) 60

**Answer: D) 60**

**114.** Which type thread is used in lathe lead screw?

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

**Answer: A) ACME**

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

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

**Answer: B) Enable easy engagement**

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

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

**Answer: B) Vetrified**

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

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

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

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

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

**Answer: B) 0.75 mm**

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

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

**Answer: B) Clamp type**

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

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

**Answer: D) Square thread**

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

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

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

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

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

**Answer: B) Thread casting**

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

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

**Answer: B) 4 times**

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

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

**Answer: B) Torch brazing**

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

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

**Answer: D) 0.15**

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

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

**Answer: C) Form tool method**

**127.** Which thread is recommended for pipe and pipe fittings?

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

**Answer: C) BSP thread**

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

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

**Answer: B) Forged copper**

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

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

**Answer: B) 1.35 mm**

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

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

**Answer: A) 2.5 mm**

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

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

**Answer: B) 0.083**

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

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

**Answer: C)  $(1/2)$**

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

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

**Answer: D) Job surface**

**134.** How is the 'length of sine bars' specified?

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

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

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

- A) Taper length is limited to the movement of the top slide  
B) Steep taper cannot be produced  
C) 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**

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

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

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

**137.** What is the use of hand chaser?

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

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

**138.** 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**

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

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

**Answer: C) 4.5 mm**

**140.** What is the shape of buttress thread flank?

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

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

**141.** 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**

**142.** 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**

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

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

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

**144.** What does BIS stand for?

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

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

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

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

**Answer: A) 45 Degree**

**146.** Which is the form of Trapezoidal thread?

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

**Answer: C) ACME**

**147.** What is the thread form cut by using chasers?

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

**Answer: B) External and internal V - Thread**

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

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

**Answer: B) 30 Degree**

**149.** 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 avoid catching the thread in each cut  
C) For the use of chasing dial  
D) For improve the productivity

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

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

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

**Answer: C) 5 Degree**

**151.** 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  
B) 100  
C) 60  
D) 120

**Answer: B) 100**

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

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

**Answer: D) 60 Degree**

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

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

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

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

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

**Answer: D) V - thread**

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

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

**Answer: D) Measure minor diameter**

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

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

**Answer: C) Copper**

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

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

**Answer: C) Cutting speed**

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

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

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

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

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

**Answer: B) 0.1**

**160.** Which thread is used for general purpose fastening?

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

**Answer: B) BSW**

**161.** What is the angle of a BIS metric thread?

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

**Answer: A) 60 Degree**

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

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

**Answer: C) V-Thread**

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

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

**Answer: B) Carriage**

**164.** Which is the method to produce accurate internal thread?

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

**Answer: C) Thread milling**

**165.** Which formula is used to find crest 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)  $0.125 \times \text{pitch}$**

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

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

**Answer: D) 4**