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

- A) G02
C) G03
B) **M03 (Correct)**
D) M04

2. What do you mean by simulation?

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

3. What do you mean by MPG?

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

4. The CNC keyboards have with following keys?

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

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

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

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

- A) G01
C) **G03**
B) G02 (Incorrect)
D) G04

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

- A) G50
C) G40
B) **G42 (Correct)**
D) G41

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

- A) **G21 (Correct)**
C) G20
B) G27
D) G28

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

- A) M09
C) M10
B) **M11**
D) M13 (Incorrect)

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

- A) M10
C) M09 (Incorrect)
B) M11
D) **M08**

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

- A) M38
C) M39
B) **M30**
D) M40 (Incorrect)

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

- A) **G71 (Correct)**
C) G96
B) G92
D) G94

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

- A) G30
C) G34
B) **G32 (Correct)**
D) G01

14. Which mode is used to edit the program?

- A) Jog mode (Incorrect)
C) MDI mode
B) **Edit mode**
D) Auto mode

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

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

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

- A) **Jog mode**
C) Auto mode
B) Edit mode
D) MDI mode (Incorrect)

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

- A) Auto mode
C) **MDI mode**
B) Jog mode
D) Edit mode (Incorrect)

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

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

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

- A) 2
C) 4
B) 3
D) 5 (Incorrect)

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

- A) Can be used only once
C) Can be used again but it has to be modified every time (Incorrect)
B) Can be used again and again
D) Cannot say

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

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

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

- A) Drilling**
C) Grooving
B) Parting
D) Facing (Incorrect)

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

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

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

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

25. Which axis is parallel to Z - axis?

- A) X - axis
C) Tool axis (Incorrect)
B) Spindle axis
D) Y-axis

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

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

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

A) The spindle rotation has to stop (Correct)

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

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

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

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

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

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

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

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

- A) End of the program with rewind
C) The cutting tool has to be changed (Correct)
B) Spindle rotation in counter clockwise direction
D) Switch of the coolant pump

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

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

33. What is the purpose of MDI mode?

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

34. What is the full form of MDI?

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

35. Which command activates in automatic mode?

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

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

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

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

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

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

- A) Jog mode
B) Edit mode
C) MPG mode
D) Auto mode (Correct)

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

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

40. 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 (Incorrect)
C) Combinations of co ordinates obtained from drives along the axis
D) Based on electrical power supply of the machine

41. How the part programming mistakes can be avoided?

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

42. 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) 3L,2C (Correct)
C) 5C
D) 2L, 2C

43. Which one of the following code is suitable for rapid

traverse?

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

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

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

45. Which one of the following M-code is suitable for spindle rotation stop?

- A) M05 (Correct)
B) M03
C) M06
D) M04

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

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

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

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

48. 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) G00 x 42.0 z 0.0 F 0.1;
B) G02 x 42.0 z 0.0 F 0.1;
C) G01 x 42.0 z 0.0 F 0.1;
D) G03 x 42.0 z 0.0 F 0.1; (Incorrect)

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

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

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

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