

**Duration: 30 Mins**

**Total Marks: 50**

**Q.ID: ITISKILL6528TX**

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

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

**Answer: B) MDI mode**

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

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

**Answer: D) Circular interpolation clockwise direction**

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

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

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

4. Which command activates in automatic mode?

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

**Answer: B) Program executed**

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

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

**Answer: B) 3**

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

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

**Answer: D) M09**

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

- A) M39
- B) M38

- C) M30
- D) M40

**Answer: C) M30**

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

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

**Answer: C) Mass production**

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

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

**Answer: A) Combinations of co ordinates obtained from drives along the axis**

10. 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

**Answer: C) Improved strength of the components**

11. What is the use of Goo activates the command?

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

**Answer: A) Rapid traverse**

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

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

**Answer: C) The cutting tool has to be changed**

13. Which mode execute thet program continuously one block after another block?

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

**Answer: D) Auto mode**

14. 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

**Answer: C) Alphanumerical control keys electronic**

15. Which axis is parallel to Z - axis?

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

**Answer: C) Spindle axis**

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

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

**Answer: B) Encoder**

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

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

**Answer: B) M11**

18. 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 length of the component      D) The diameter of the component

**Answer: D) The diameter of the component**

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

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

**Answer: C) G00**

20. What is the purpose of MDI mode?

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

**Answer: A) Move the axes by manually**

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

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

**Answer: D) The spindle rotation has to stop**

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

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

**Answer: A) Jog mode**

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

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

**Answer: B) G03**

24. What do you mean by MPG?

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

**Answer: A) Manually Pulse Generator**

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

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

**Answer: B) The length of the component**

26. 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) G03 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;

**Answer: A) G01 x 42.0 z 0.0 F 0.1;**

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

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

**Answer: A) Incremental jog mode**

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

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

**Answer: D) Drilling**

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

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

**Answer: D) Machine zero**

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

- A) G71      B) G94

C) G92 D) G96

**Answer: A) G71**

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

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

**Answer: D) Siemens and FANUC**

**32.** 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) 5C  
C) 3L,2C D) 2L, 2C

**Answer: C) 3L,2C**

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

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

**Answer: C) Reference mode**

**34.** Which mode is used to edit the program?

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

**Answer: B) Edit mode**

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

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

**Answer: B) M08**

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

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

**Answer: B) Tool has return to reference point**

**37.** Which G-code is suitable for thread cutting?

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

**Answer: A) G32**

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

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

**Answer: C) Table position**

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

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

**Answer: C) M03**

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

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

**Answer: C) G42**

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

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

**Answer: A) Auto mode**

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

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

**Answer: D) G21**

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

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

**Answer: D) Incremental Jog mode**

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

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

**Answer: C) M08**

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

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

**Answer: D) G41**

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

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

**Answer: C) Jog mode**

**47.** How the part programming mistakes can be avoided?

A) CNC (Computer numerical control) machine only B) NC (Numerical control) machine only

C) Cannot be avoided in CNC D) Both NC and CNC machine

**Answer: A) CNC (Computer numerical control) machine only**

48. What do you mean by simulation?

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

**Answer: C) Cross checking of programmable DATA**

49. What is the full form of MDI?

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

**Answer: A) Manually Data Input**

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

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

**Answer: D) Can be used again and again**