

**Duration: 30 Mins**

**Total Marks: 50**

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Student Name: \_\_\_\_\_ Roll No: \_\_\_\_\_

**1. Which axis is parallel to Z - axis?**

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

**2. Which code suitable for circular interpolation counter clockwise direction?**

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

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

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

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

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

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

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

**6. 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                            |

**7. 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) 2L, 2C | B) 3L,2C |
| C) 2C, L  | D) 5C    |

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

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

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

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

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

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

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

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

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

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

**13. 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) G02 x 42.0 z 0.0 F 0.1; | B) G01 x 42.0 z 0.0 F 0.1; |
| C) G03 x 42.0 z 0.0 F 0.1; | D) G00 x 42.0 z 0.0 F 0.1; |

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

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

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

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

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

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

17. 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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

25. 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

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

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

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

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

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

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

29. What is the purpose of MDI mode?

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

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

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

31. Which command activates in automatic mode?

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

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

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

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

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

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

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

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

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

36. What do you mean by MPG?

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

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

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

38. Which mode is used to edit the program?

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

39. The CNC keyboards have with following keys?

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

50. What is the full form of MDI?

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