

Duration: 30 Mins

Total Marks: 50

ID: ITISKILL6528TX

Student Name: _____ Roll No: _____

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

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

2. What is the full form of MDI?

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

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

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

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

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

5. Which mode is used to edit the program?

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

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

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

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

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

8. The CNC keyboards have with following keys?

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

9. Which axis is parallel to Z - axis?

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

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

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

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

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

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

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

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

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

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

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

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

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

16. 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) G03 x 42.0 z 0.0 F 0.1; | B) G01 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; |

17. What is the purpose of MDI mode?

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

29. What do you mean by MPG?

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

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

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

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

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

32. Which command activates in automatic mode?

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

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

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

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

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

35. What do you mean by simulation?

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

36. How the part programming mistakes can be avoided?

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

47. 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 |

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

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

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

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

50. 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 |
| C) Combinations of co ordinates obtained from drives along the axis | D) Based on electrical power supply of the machine |