

Duration: 30 Mins

Total Marks: 50

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Student Name: _____ Roll No: _____

1. 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 |

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

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

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

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

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

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

5. Encodor is used in CNC machine tool to sense and control?

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

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

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

7. Which mode is used to edit the program?

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

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

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

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

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

10. 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) G00 x 42.0 z 0.0 F 0.1; |
| C) G02 x 42.0 z 0.0 F 0.1; | D) G03 x 42.0 z 0.0 F 0.1; |

11. The CNC keyboards have with following keys?

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

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

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

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

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

14. What do you mean by simulation?

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

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

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

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

- | | |
|----------------------------------|--------------------------------|
| A) The diameter of the component | B) The length of the component |
|----------------------------------|--------------------------------|

C) The radius of the component

D) The centre axis of the component

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

A) G41

B) G32

C) G42

D) G40

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

A) M09

B) M11

C) M10

D) M13

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

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

B) Can read only the program

C) Execute the program

D) Simulation of the program

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

A) Tool geometrical value

B) Machine zero

C) Work zero

D) Reference mode

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

A) G02

B) G03

C) M04

D) M03

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

A) Tool returns from reference point to work place

B) The cutting tool has to be changed

C) The spindle rotation has to stop

D) Rewind the program once again

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

A) M01

B) M08

C) M06

D) M09

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

A) G34

B) G32

C) G30

D) G01

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

A) MDI mode

B) Jog mode

C) Auto mode

D) Edit mode

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

A) Switch of the coolant pump

B) End of the program with rewind

C) The cutting tool has to be changed

D) Spindle rotation in counter clockwise direction

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

A) Reference mode

B) MDI mode

C) Jog mode

D) Automatic mode

28. 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

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

A) G27

B) G21

C) G28

D) G20

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

A) Tool has return to reference point

B) Circular interpolation clockwise

C) Tool has to return from reference point

D) Circular interpolation counter clockwise

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

A) Drilling

B) Parting

C) Facing

D) Grooving

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

A) M08

B) M11

C) M09

D) M10

33. What is the purpose of MDI mode?

A) Editing of programmable Data

B) Move the axes by manually

C) Cross checking of the program graphically

D) For program execution

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

A) Auto mode

B) Edit mode

C) Incremental Jog mode

D) MDI mode

35. What is the full form of MDI?

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

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

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

37. How the part programming mistakes can be avoided?

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

38. 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) 2L, 2C
- C) 3L,2C
- D) 5C

39. Which axis is parallel to Z - axis?

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

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

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

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

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

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

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

43. 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

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

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

45. Which command activates in automatic mode?

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

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

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

47. 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) Cannot say
- C) Can be used again and again
- D) Can be used only once

48. What do you mean by MPG?

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

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

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

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

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