

Duration: 90 Mins

Total Marks: 51

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

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

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

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

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

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

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

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

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

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

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

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

7. Which mode is used to edit the program?

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

16. What do you mean by simulation?

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

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

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

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

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

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

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

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

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

21. 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) Circular interpolation counter clockwise
D) Tool has to return from reference point

22. What is the purpose of MDI mode?

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

23. Which command activates in automatic mode?

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

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

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

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

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

26. 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) Combinations of coordinates obtained from drives along the axis
C) Based on electrical power supply of the machine
D) Skill of machine operator

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

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

28. 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

29. 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;

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

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

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

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

32. 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

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

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

34. How the part programming mistakes can be avoided?

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

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

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

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

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

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

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

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

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

39. What do you mean by MPG?

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

40. The CNC keyboards have with following keys?

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

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

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

42. What is the full form of MDI?

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

43. 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) Cannot say

C) Can be used again but it has to be modified every time

D) Can be used again and again

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

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

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

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

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

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

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

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

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

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

49. 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) 3L,2C
- B) 5C
- C) 2C, L
- D) 2L, 2C

50. Which axis is parallel to Z - axis?

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

51. 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 diameter of the component
- D) The length of the component