

Duration: 30 Mins

Total Marks: 166

Q.ID: ITISKILL7162BO

1. Why the ball centre is preferred in tail stock offset method?

- A) For accurate setting B) For good surface finish
C) To avoid damage to the centre drilled hole of the job D) For provide power feed

Answer: C) To avoid damage to the centre drilled hole of the job

2. Find the change gear (driven gear) to cut 2.5mm pitch thread using a lathe having lead screw of pitch 5mm with driver gear 60 teeth?

- A) 100 B) 150
C) 60 D) 120

Answer: D) 120

3. How many number of teeth in translating gear used for cutting metric thread on British lathe?

- A) 100 B) 30
C) 63 D) 120

Answer: C) 63

4. What is the schedule of lubrication for lathe bed?

- A) Frequently B) Daily
C) Weekly D) Monthly

Answer: B) Daily

5. Which material is suitable for button die chaser?

- A) Low strength material B) H.S.S
C) H.C.S D) High strength material

Answer: A) Low strength material

6. What are the uses of B.S.P thread?

- A) General fastening B) Automobile industries
C) Load transmission D) Pipe and pipe fittings

Answer: D) Pipe and pipe fittings

7. Which is the advantage of taper turning by compound slide method?

- A) Long taper can be produced B) Steep taper can be produced
C) Thread on taper portion can be produced D) Most suitable for duplicate taper work

Answer: B) Steep taper can be produced

8. Which formula is used to find root width of a buttress thread?

- A) $0.125 \times \text{pitch}$ B) $0.5 \times \text{pitch}$
C) $0.317 \times \text{pitch}$ D) $0.335 \times \text{pitch}$

Answer: A) $0.125 \times \text{pitch}$

9. Which is the term used to express grinding wheels to hold the abrasive particle together?

- A) Grit B) Structure
C) Grain D) Bond

Answer: D) Bond

10. Calculate the least count of V.B.P if 23 div on main scale is divided into 12 scale divisions

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

Answer: D) 4 minutes

11. How many teeth are in translating gear for cutting metric thread on British lathe?

- A) 127 B) 125
C) 129 D) 122

Answer: A) 127

12. Which is the welding process, if base metal and filler is melted to form the joint?

- A) By tig welding B) By braze welding
C) By gas welding D) By arc welding

Answer: D) By arc welding

13. Which method is non metallic threads are produced?

- A) Thread grinding B) Thread chasing
C) Thread milling D) Thread casting

Answer: D) Thread casting

14. Which part is pivoted to the disc of vernier bevel protractor?

- A) Stock B) Disc
C) Dial D) Blade

Answer: C) Dial

15. Which mandrels is NOT used in between lathe centres?

- A) Stepped mandrels B) Cone mandrels
C) Gang mandrels D) Taper Shank mandrels

Answer: D) Taper Shank mandrels

16. Which is the method to produce accurate internal thread?

- A) Thread milling
- B) Thread rolling
- C) Using dies
- D) Thread chasers

Answer: A) Thread milling

17. What is the angle of a BIS metric thread?

- A) 55 Degree
- B) 60 Degree
- C) 45 Degree
- D) 27.5 Degree

Answer: B) 60 Degree

18. What is the formula for finding the depth of a BIS metric thread?

- A) $0.6043 \times \text{pitch}$
- B) $0.6134 \times \text{pitch}$
- C) $0.6403 \times \text{pitch}$
- D) $0.6431 \times \text{pitch}$

Answer: B) $0.6134 \times \text{pitch}$

19. How is the filler material distributed in the joint in braze welding?

- A) By fission
- B) By fusion
- C) By capillary action
- D) By splashing

Answer: C) By capillary action

20. What is the formula to find out core diameter of external thread by using prisms and micrometer?

- A) Core dia = Measurement over prisms + Height of prisms ? Single depth
- B) Core dia = Measurement over prisms ? Height of prisms ? Single depth of thread
- C) Core dia = Measurement over prisms ? Height of prisms + Single depth
- D) Core dia = Measurement over prisms ? Height of prisms + Two depth

Answer: B) Core dia = Measurement over prisms ? Height of prisms ? Single depth of thread

21. What is the name of chuck that hardend steel sleeve having slits cut partly?

- A) Hydraulic chuck
- B) Combination chuck
- C) Magnetic chuck
- D) Collect chuck

Answer: D) Collect chuck

22. What is protected by providing pieces between work and carrier while clamping?

- A) Dead centre
- B) Live centre
- C) Carrier
- D) Job surface

Answer: D) Job surface

23. How many un-numbered divisions on the British chasing dial?

- A) 4
- B) 12
- C) 3
- D) 18

Answer: A) 4

24. What is the use of hand chaser?

- A) For production job
- B) Correcting and finishing a thread
- C) For making square thread
- D) To cut new thread

Answer: B) Correcting and finishing a thread

25. What will happen if threading tool is set below centre height?

- A) Thread will be damaged
- B) Difficult for catching
- C) Pitch will changed
- D) Major diameter will changed

Answer: A) Thread will be damaged

26. How to measure the diameter of the small end of a external taper precisely?

- A) Vernier calipers
- B) Sine bar
- C) Precision roller with slip gauge
- D) Screw gauge

Answer: C) Precision roller with slip gauge

27. What is the core diameter of BSW thread of 1 inch outer dia and 8 TPI

- A) 0.80 Inch
- B) 0.84 Inch
- C) 0.83 Inch
- D) 0.81 Inch

Answer: B) 0.84 Inch

28. Which is the smallest unit of angular measurement?

- A) Radian
- B) Minutes
- C) Seconds
- D) Degree

Answer: C) Seconds

29. Which type of centre is used in the end of the job if no counter sink hole is permitted?

- A) Insert type centre
- B) Female centre
- C) Ball centre
- D) Revolving centre

Answer: B) Female centre

30. Which one is the example for transmission of motion using thread

- A) Rack and pinion
- B) Bevel gearing
- C) Crank and slotted link
- D) Worm and worm shaft

Answer: D) Worm and worm shaft

31. What is calculated by formula $0.75 \times \text{pitch}$?

- A) depth of metric thread
- B) depth of acme thread
- C) depth of buttress thread
- D) depth of square thread

Answer: C) depth of buttress thread

32. Which angle is provided on the metric screw thread micrometer anvil?

- A) 55 Degree
- B) 47.5 Degree

C) 30 Degree D) 60 Degree

Answer: D) 60 Degree

33. Which formula is used to find crest width of a buttress thread?

A) $0.5 \times \text{pitch}$ B) $0.317 \times \text{pitch}$
C) $0.335 \times \text{pitch}$ D) $0.125 \times \text{pitch}$

Answer: D) 0.125 x pitch

34. What is the core dia of square thread 62 x 10 mm pitch?

A) 52 mm B) 57.4 mm
C) 56.45 mm D) 52.7 mm

Answer: A) 52 mm

35. What percentage of cutting speed is reduced for tool life doubling?

A) 0.083 B) 0.084
C) 0.081 D) 0.082

Answer: A) 0.083

36. What is the reason for using dial indicator instead of scribe point in Vernier height gauge?

A) For accurate measuring B) For accurate marking
C) To check eccentricity D) For good appearance

Answer: C) To check eccentricity

37. Which method of thread forming produce threads on non-metals?

A) Thread milling B) Thread rolling
C) Thread grinding D) Thread casting

Answer: D) Thread casting

38. Which type thread is used in lathe lead screw?

A) Metric B) Buttress
C) ACME D) Square

Answer: C) ACME

39. Which type of thread is produced by tap and die?

A) V - thread B) Saw - tooth thread
C) ACME thread D) Square thread

Answer: A) V - thread

40. Which formula is used to find depth of ACME thread?

A) $0.6134 \times \text{pitch}$ B) $0.6403 \times \text{pitch}$
C) $0.5 \times \text{pitch}$ D) $0.75 \times \text{pitch}$

Answer: C) 0.5 x pitch

41. What is the formula for finding gear ratio for fractional pitch thread?

A) $DR/DN = \text{Leads of screw to be cut} \times \text{No. Of threads per inch of lead screw}$ B) $DR/DN = \text{Lead of head screw/ Lead of work}$

C) $DR/DN = \text{Lead of work/ No. Of threads per inch}$ D) $DR/DN = \text{TPI on lead screw/ TPI to cut}$

Answer: A) DR/DN = Leads of screw to be cut X No. Of threads per inch of lead screw

42. What is the shape of interchangeable anvils used in screw thread micrometer?

A) Radius shape B) Square shape
C) Circular shape D) V-shape

Answer: D) V-shape

43. What is the only thread form cut using diehead is turret lathe?

A) ACME B) Saw - Tooth
C) V-Thread D) Square

Answer: C) V-Thread

44. What is the formula used to find flat width of a buttress thread?

A) $\text{Pitch}/6$ B) $\text{Pitch}/2$
C) $\text{Pitch}/4$ D) $\text{Pitch}/8$

Answer: D) Pitch/8

45. Which angle is ground on ACME threading tool?

A) 29 Degree B) 45 Degree
C) 60 Degree D) 55 Degree

Answer: A) 29 Degree

46. Calculate the change gear (driven gear) if driver is 50 teeth to cut 2.5mm pitch thread on a job by lathe having a lead screw of 5mm pitch?

A) 120 B) 60
C) 100 D) 150

Answer: C) 100

47. Calculate the depth of buttress thread 60 mm diameter of 9 mm pitch?

A) 6.75 mm B) 5.75 mm
C) 7.75 mm D) 4.75 mm

Answer: A) 6.75 mm

48. Which part of the combination set is used for measuring the angles?

A) Square head B) Centre head
C) Protractor head D) Rule

Answer: C) Protractor head

49. Which carrier with V-groove provided and used to hold small diameter and square sections?

- A) Bent tail B) Straight tail
C) Clamp type D) Safety clamp type

Answer: C) Clamp type

50. What is the angle of metric ACME thread

- A) 30 Degree B) 47.5 Degree
C) 45 Degree D) 29 Degree

Answer: A) 30 Degree

51. Which is the angle of buttress thread?

- A) 55 Degree B) 30 Degree
C) 45 Degree D) 60 Degree

Answer: C) 45 Degree

52. Which method of thread forming does not produce chips and used in mass production?

- A) Thread milling B) Thread rolling
C) Thread grinding D) Taps and dies

Answer: B) Thread rolling

53. What is the use of BSW thread?

- A) Fast movement B) General purpose fastening
C) Used in electrical appliances D) Load fitting

Answer: B) General purpose fastening

54. What is the relationship between pitch and depth of a buttress thread?

- A) depth = $0.6134 \times \text{pitch}$ B) depth = $0.5 \times \text{pitch}$
C) depth = $0.6403 \times \text{pitch}$ D) depth = $0.75 \times \text{pitch}$

Answer: D) depth = $0.75 \times \text{pitch}$

55. Calculate the amount of off-set if total length of job = 80 mm and $\tan = 5$ Degree 45 minutes?

- A) 10 mm B) 7 mm
C) 12 mm D) 8 mm

Answer: D) 8 mm

56. What is the main disadvantage of a braze welded joints?

- A) It take more time for repairing B) Heavy distortion due to heat
C) The joint not suitable for thicker sections D) Dissimilar metals can be joined

Answer: C) The joint not suitable for thicker sections

57. What is the use of a sine bar?

- A) To measure the length of a taper job B) To determine the angle of tapered job
C) To measure the diameter of the job D) To measure the gap

Answer: B) To determine the angle of tapered job

58. Calculate the width of flat of buttress thread 6 mm pitch?

- A) 1 mm B) 1.5 mm
C) 2 mm D) 0.75 mm

Answer: D) 0.75 mm

59. What is formula for finding depth of BSW external thread?

- A) $0.6134 \times \text{pitch}$ B) $0.6403 \times \text{pitch}$
C) $0.5 \times \text{pitch}$ D) $0.7 \times \text{pitch}$

Answer: B) $0.6403 \times \text{pitch}$

60. What is the accuracy of the protractor head of a combination set?

- A) 1 Degree B) 1 Degree
C) 1 Degree D) 5 Degree

Answer: A) 1 Degree

61. What is the purpose of the beveled edges of the rule in a vernier bevel protractor?

- A) Checking squareness B) Checking 45 Degree and 60 Degree
C) Checking parallelism D) Checking flatness

Answer: B) Checking 45 Degree and 60 Degree

62. Which method of brazing is commonly used to braze of carbide tip on a shank?

- A) Furnace brazing B) Induction brazing
C) Arc brazing D) Torch brazing

Answer: D) Torch brazing

63. What term indicate actual size of the abrasive grain?

- A) Structure B) Grit size
C) Abrasive type D) Grade of bond

Answer: B) Grit size

64. Which method of threading is used in mass production?

- A) Using taps and dies B) Thread rolling
C) Thread grinding D) Use single point cutting tool

Answer: B) Thread rolling

65. What is the purpose of using v prism method in thread measurement?

- A) Measure minor diameter B) Measure effective diameter
C) Measure the pitch of the thread D) Measure major diameter

Answer: A) Measure minor diameter

66. Which is the chip less method of thread production?

- A) Thread grinding B) Thread rolling

- C) Thread milling D) Die head

Answer: B) Thread rolling

67. What is the purpose of tail on the lathe carrier?

- A) Protect the work B) Locate and drive the work
C) Protect the operator D) Give good finish

Answer: B) Locate and drive the work

68. Calculate the change gears to cut a worm of 0.35" lead on a lathe with a lead screw of 4TPI?

- A) Driver 30T, Driven 40 B) Driver 50T, Driven 30
C) Driver 40T, Driven 50 D) Driver 70T, Driven 50

Answer: D) Driver 70T, Driven 50

69. What is the criteria for the selection of interchangeable anvil of a screw thread micrometer?

- A) Root diameter B) Major diameter
C) Minor diameter D) Profile and pitch

Answer: D) Profile and pitch

70. Which thread is recommended for pipe and pipe fittings?

- A) BA thread B) BSF thread
C) BSP thread D) BSW thread

Answer: C) BSP thread

71. Find the gear required to cut 3 mm pitch in a lathe having a lead screw of 6 TPI gear available from 20 to 120 teeth by 5 teeth with a special gear of 127 teeth?

- A) Driver 60 teeth Driven 20 B) Driver 20 teeth Driven 60
teeth teeth
C) Driver 90 teeth Driven 127 D) Driver 127 teeth Driven 90
teeth teeth

Answer: C) Driver 90 teeth Driven 127 teeth

72. Which is the angle of inclination in the thread to the imaginary perpendicular line?

- A) Acute angle B) Obtuse angle
C) Right angle D) Helix angle

Answer: D) Helix angle

73. Find the gears required to cut 4.5mm pitch on a lathe having a lead screw of 4 TPI. Gears available from 20 to 120 teeth by 5 teeth with a special gear of 127T.

- A) 127T on driver and 90T on B) 90T on driver and 127T on
driven driven
C) 127T on driver and 60T on D) 60T on driver and 127T on
driven driven

Answer: B) 90T on driver and 127T on driven

74. What is the name of thread producing method by cold forging and by plastic deformation?

- A) Thread milling B) Thread grinding

- C) Thread rolling D) Thread casting

Answer: C) Thread rolling

75. Which is the cause of small particles of the material become embedded in the space between the grains of the grinding wheel?

- A) Loading B) Dressing
C) Grooving D) Glazing

Answer: A) Loading

76. Calculate the change gears necessary to cut a thread of 7/16" lead on a lathe with a lead screw of 4TPI?

- A) Driven 30T, Driver 40T B) Driven 70T, Driver 40T
C) Driver 70T, Driven 40T D) Driver 30T, Driven 40T

Answer: C) Driver 70T, Driven 40T

77. Which wheel is used for grinding tough materials?

- A) Silicon carbide B) Aluminium oxide
C) Cemented carbide D) Ceramic

Answer: B) Aluminium oxide

78. What is the reason for providing buttress thread in carpentry vice?

- A) For easy use B) Pressure acts at one flank
C) For easy manufacturing D) For better appearance

Answer: B) Pressure acts at one flank

79. Which one is the disadvantage of taper turning by compound slide method?

- A) Taper length is limited to B) Damages the centre
the movement of the top drilled holes of the work
slide
C) Steep taper cannot be D) Only external taper can be
produced turned

Answer: A) Taper length is limited to the movement of the top slide

80. What is the angle of ACME thread

- A) 45 Degree B) 29 Degree
C) 55 Degree D) 60 Degree

Answer: B) 29 Degree

81. What is the depth of buttress thread if the pitch is 1.8 mm of 45 Degree angle?

- A) 1.23 mm B) 1.35 mm
C) 0.910 mm D) 0.42 mm

Answer: B) 1.35 mm

82. What is the minor diameter of Trapezoidal square thread Tr 40 x 7 depth clearance of 0.01 mm?

- A) 33.00 mm B) 36.50 mm
C) 36.49 mm D) 32.98 mm

Answer: D) 32.98 mm

83. What is the minor diameter of screw thread SQ 62 x 10.5 with depth clearance of 0.12 mm?

- A) 51.26 mm
- B) 51.88 mm
- C) 46.64 mm
- D) 51.00 mm

Answer: A) 51.26 mm

84. What does BIS stand for?

- A) Bureau of international society
- B) Bureau of Indian society
- C) Bureau of international standard
- D) Bureau of Indian standard

Answer: D) Bureau of Indian standard

85. Which mandrel is used for machining similar part where internal diameter vary slightly?

- A) Taper Shank mandrels
- B) Gang mandrels
- C) Stepped mandrels
- D) Expansion stud mandrel

Answer: D) Expansion stud mandrel

86. What is 1.25 stands for a metric thread designated as M12 x 1.25?

- A) Pitch of the thread
- B) Depth of thread
- C) Minor dia of thread
- D) Major dia of thread

Answer: A) Pitch of the thread

87. What is the width of the tool to cut square thread of 30 x 3 mm pitch?

- A) 3 mm
- B) 2 mm
- C) 1.5 mm
- D) 6 mm

Answer: C) 1.5 mm

88. What type of thread can be produced by a die?

- A) Internal V - thread
- B) External square thread
- C) External V - thread
- D) Internal square thread

Answer: C) External V - thread

89. What is the depth of ACME thread of 1inch major diameter 6TPI?

- A) 0.082
- B) 0.08
- C) 0.09
- D) 0.084

Answer: D) 0.084

90. Calculate the change gear required to cut 4mm pitch thread in a lathe having lead screw of 4mm (lathe stud gear (driver has 50 teeth)

- A) 50
- B) 25
- C) 100
- D) 150

Answer: A) 50

91. Which material is used for making nozzle for gas

welding?

- A) Copper
- B) Mild steel
- C) High carbon steel
- D) Bronze

Answer: A) Copper

92. Find the gears for simple gear train, if pitch of lead screw is 6 mm and pitch of thread to be cut is 2 mm?

- A) 40/150
- B) 30/120
- C) 40/120
- D) 50/120

Answer: C) 40/120

93. How can measure the minor diameter of a internal thread?

- A) Using slip gauge pack
- B) By screw thread micrometer
- C) By three wire method
- D) By vernier caliper

Answer: D) By vernier caliper

94. What is the value of tool life index for cutting cast iron by cemented carbide tool?

- A) 0.128
- B) 0.125
- C) 0.1
- D) 0.2

Answer: C) 0.1

95. Calculate the depth of buttress thread diameter 30 mm of pitch 3mm?

- A) 1.25 mm
- B) 3.00 mm
- C) 2.25 mm
- D) 1.5 mm

Answer: C) 2.25 mm

96. What is removing dull grain in order to make grinding wheel sharp?

- A) Glazing
- B) Dressing
- C) Trueing
- D) Loading

Answer: B) Dressing

97. How can measure the minor diameter of a internal thread accurately?

- A) By screw thread micrometer
- B) By plug gauge
- C) By three wire method
- D) By using slip gauge and precision rollers

Answer: D) By using slip gauge and precision rollers

98. Which instrument can measure angle upto an accuracy of 5 minutes?

- A) Combination set
- B) Vernier bevel protractor
- C) Angle gauge
- D) Bevel gauge

Answer: B) Vernier bevel protractor

99. Which is the form of Trapezoidal thread?

- A) BSF
C) Metric
- B) ACME
D) BSW

Answer: B) ACME

100. Which one is the disadvantage of using tail stock offset method?

- A) External threads on taper can't produce
C) Taper turning is possible when work held between centre only
- B) Only hand feed can be given
D) Taper length is limited

Answer: C) Taper turning is possible when work held between centre only

101. What is the core dia of square thread 75 x 11 mm pitch?

- A) 64 mm
C) 65.8 mm
- B) 70 mm
D) 60 mm

Answer: A) 64 mm

102. Which terms are needed to calculate tool life index?

- A) Depth of cut and rpm
C) Cutting speed and rpm of job
- B) Cutting speed and feed
D) Cutting speed time and index

Answer: D) Cutting speed time and index

103. Select a suitable instrument for measuring angles?

- A) Calipers
C) Vernier caliper
- B) Vernier bevel protractor
D) Vernier height gauge

Answer: B) Vernier bevel protractor

104. What is the thread depth of square thread SQ60x9?

- A) 4.5 mm
C) 9.0 mm
- B) 18 mm
D) 42 mm

Answer: A) 4.5 mm

105. What is thread element that determine the direction of rotation on screw thread?

- A) Pitch of thread
C) Hand of thread
- B) Depth of thread
D) Lead of thread

Answer: C) Hand of thread

106. Which device uses buttress thread?

- A) Screw jack
C) Carpentry vice
- B) General purpose nut and bolt
D) Lead screw of lathe

Answer: C) Carpentry vice

107. What is the depth of cut for 10TPI BSW thread?

- A) $0.6134 \times 1/10$ Inch
C) $0.6304 \times 1/10$ Inch
- B) $0.6403 \times 1/10$ Inch
D) $0.6314 \times 1/10$ Inch

Answer: B) $0.6403 \times 1/10$ Inch

108. Calculate the flat width of 10 mm pitch buttress thread?

- A) 4.25 mm
C) 2.25 mm
- B) 3.25 mm
D) 1.25 mm

Answer: D) 1.25 mm

109. Calculate the gear ratio to cut a 1/4 inch lead on a lathe with lead screw of 2TPI?

- A) (1/4)
C) (2/3)
- B) (1/2)
D) (3/4)

Answer: B) (1/2)

110. Calculate the driven gear to cut 1.5mm pitch thread on a job using a lathe having lead screw of 4mm pitch with driver gear 30 teeth?

- A) 100
C) 50
- B) 60
D) 80

Answer: D) 80

111. Calculate the least count of V.B.P if 23 div on main scale is divided into 12 equal parts

- A) 5 Degree
C) 28 Degree
- B) 1 Degree - 50 Degree
D) 100 Degree

Answer: A) 5 Degree

112. Which mandrel is manufactured in order to reduce the number of mandrel?

- A) Threaded mandrel
C) Gang mandrel
- B) Solid mandrel
D) Stepped mandrel

Answer: D) Stepped mandrel

113. What is the disadvantage of chaser?

- A) To cut V-thread only
C) To cut trapezoid thread only
- B) To cut knuckle thread only
D) To cut square thread only

Answer: A) To cut V-thread only

114. Which method is used for turning steep taper?

- A) Compound slide swivel
C) Offset tail stock
- B) Taper turning attachment
D) Form tool

Answer: A) Compound slide swivel

115. Which mechanism is used for converting linear motion into rotary motion in plunger dial gauge?

- A) Scroll and pinion mechanism
C) Rack and pinion mechanism
- B) Lever and scroll mechanism
D) Rack and scroll mechanism

Answer: C) Rack and pinion mechanism

116. Which type of thread is used in screw jack spindle?

- A) Square thread
B) BSW thread

- C) BSF thread D) Worm thread

Answer: A) Square thread

117. How the thread are formed in thread rolling?

- A) Grinding B) Milling
C) Casting D) Plastic deformation

Answer: D) Plastic deformation

118. Which chuck is mainly used for getting a very effective grip over the job?

- A) Push - out chucks B) Collect chuck
C) Hydraulic chuck D) Magnetic chuck

Answer: C) Hydraulic chuck

119. Why the thread chaser is used to form threads?

- A) To get proper, crest, flat, root radius and profile B) For easy thread cutting
C) To reduce labour D) To time saving

Answer: A) To get proper, crest, flat, root radius and profile

120. What is the thread depth of square thread SQ60x9?

- A) 18 mm B) 4.5 mm
C) 42 mm D) 9.0 mm

Answer: B) 4.5 mm

121. What is the purpose of using taper parallels in thread measurement?

- A) To measure the major diameter of external thread B) To measure the minor diameter of internal thread
C) To measure the minor diameter of external thread D) To measure the major diameter of internal thread

Answer: B) To measure the minor diameter of internal thread

122. How metric chasing dial differ from British chasing dial?

- A) One worm wheel and different dial B) More than one worm wheel and different dial
C) Same as British chasing dial D) One worm wheel and one dial

Answer: B) More than one worm wheel and different dial

123. What is the reason for using ACME thread in lathe lead screw?

- A) Easily available B) Manufacturing cost is less
C) Suitable for big diameter thread D) Enable easy engagement

Answer: D) Enable easy engagement

124. What is the purpose of using thread micrometer?

- A) Measure effective diameter B) Measure major diameter
C) Measure minor diameter D) Measure pitch of the thread

Answer: A) Measure effective diameter

125. How is the 'length of sine bars' specified?

- A) Total length of the sine bar B) Length of datum surface
C) Length of the rollers D) Distance between the centres of the rollers

Answer: D) Distance between the centres of the rollers

126. What should be the heights of gauge block to be built to check the work angle of 30 Degree using 150 mm sine bar?

- A) 291.26 B) 145.63
C) 38.62 D) 75

Answer: D) 75

127. Calculate the driven gear to cut 2mm pitch on a job using a lathe having lead screw of 4mm pitch with driven gear 50 teeth?

- A) 50 B) 60
C) 120 D) 100

Answer: D) 100

128. Which is main criteria to increase the tool life?

- A) Depth of cut B) Material
C) Cutting speed D) Feed

Answer: C) Cutting speed

129. How many carriers are available in a set?

- A) 6 numbers B) 10 numbers
C) 4 numbers D) 8 numbers

Answer: B) 10 numbers

130. Which diameter is maintained in a job for making threads by rolling?

- A) Minor diameter B) Pitch diameter
C) Major diameter D) Root diameter

Answer: B) Pitch diameter

131. What is the angle of saw tooth thread?

- A) 29 Degree B) 90 Degree
C) 45 Degree D) 30 Degree

Answer: D) 30 Degree

132. Which welding method is more suitable for joining dissimilar metals readily?

- A) Gas welding B) Tig welding
C) Arc welding D) Braze welding

Answer: D) Braze welding

133. A thread is represented as M12 x 1.5. What does represent the letter 12?

- A) Minor diameter B) Major diameter
C) Pitch D) Root diameter

Answer: B) Major diameter

134. Which part of the lathe is locked while the form tool method is used for turning taper?

- A) Head stock B) Tail stock
C) Compound rest D) Carriage

Answer: D) Carriage

135. Which method is preferred for producing small length taper with least accuracy?

- A) Form tool method B) Tail stock offset method
C) Compound slide method D) Taper turning attachment method

Answer: A) Form tool method

136. What is the relationship between pitch and depth of a square thread?

- A) Depth is 3/4 pitch B) Depth is equal to pitch
C) Depth is 1/2 pitch D) Depth is 1/4 pitch

Answer: C) Depth is 1/2 pitch

137. How much the compound rest should be tilted for cutting metric thread by compound rest?

- A) 60 Degree B) 30 Degree
C) 15 Degree D) 45 Degree

Answer: B) 30 Degree

138. Which formula is to find crest width of ACME thread?

- A) $0.317 \times \text{pitch}$ B) $0.5 \times \text{pitch}$
C) $0.335 \times \text{pitch}$ D) $0.75 \times \text{pitch}$

Answer: A) $0.317 \times \text{pitch}$

139. How much times the spindle rotate the lead screw to cut 3 mm pitch thread in a 12 mm pitch lead screw?

- A) 5 times B) 6 times
C) 4 times D) 3 times

Answer: C) 4 times

140. Which is the commonly used method to produce thread in nut?

- A) Thread milling B) Thread casting
C) Tapping D) Thread grinding

Answer: C) Tapping

141. What is the thread form cut by using chasers?

- A) Trapezoidal thread B) External square thread
C) Internal square thread D) External and internal V - Thread

Answer: D) External and internal V - Thread

142. Calculate the change gear ratio to cut a thread of 7/16" lead on a lathe with lead screw of 4 TPI?

- A) 03-Apr B) 04-Jul
C) 03-Jul D) 07-Apr

Answer: D) 07-Apr

143. Calculate the change gear (driver gear) if driven gear has 120 teeth to cut 3mm pitch on a job using lathe having 6 mm pitch lead screw?

- A) 50 B) 100
C) 60 D) 150

Answer: C) 60

144. Calculate the driven gear required to cut 4mm pitch thread is a lathe having lead screw of 4mm with driven gear of 60 teeth?

- A) 60 B) 120
C) 50 D) 100

Answer: A) 60

145. What is the shape of buttress thread flank?

- A) One flank is 30 Degree and the other 45 Degree B) Two flanks are at 60 Degree
C) One flank is 60 Degree and the other 45 Degree D) One flank is 90 Degree and the other 45 Degree

Answer: D) One flank is 90 Degree and the other 45 Degree

146. Which is used to support hollows end jobs?

- A) Tipped centre B) Female centre
C) Ball centre D) Pipe centre

Answer: D) Pipe centre

147. Which formula is used to find depth of buttress thread?

- A) $0.75 \times \text{pitch}$ B) $0.5 \times \text{pitch}$
C) $0.6403 \times \text{pitch}$ D) $0.6134 \times \text{pitch}$

Answer: A) $0.75 \times \text{pitch}$

148. Which material is used for making the head of soldering iron?

- A) Forged aluminium B) Forged copper
C) Forged steel D) Stainless steel

Answer: B) Forged copper

149. What is the width of the tool to cut a square thread of 60 x 9 mm pitch?

- A) 9.5 mm B) 8.5 mm
C) 4.5 mm D) 9 mm

Answer: C) 4.5 mm

150. How many seconds is 1 Degree?

- A) 3600000% B) 6000%

C) 360000%

D) 36000%

Answer: C) 360000%

151. Which one of the following factor greatly causes to reduce tool life?

A) Cutting speed

B) Depth of cut

C) Feed

D) Material

Answer: A) Cutting speed

152. Which method of holding is used for lengthy work to avoid over hanging?

A) In between centres

B) Angle plate

C) In face plate

D) In four jaw chuck

Answer: A) In between centres

153. What is the name of device used to drive the work during turning between centres?

A) Lathe carrier

B) Driving plate

C) Face plate

D) Catch plate

Answer: A) Lathe carrier

154. What is the effect of reversing the machine with out disengaging the half nut in thread cutting?

A) Reduce the wear and tear of half nut

B) For avoid catching the thread in each cut

C) For improve the productivity

D) For the use of chasing dial

Answer: B) For avoid catching the thread in each cut

155. Which form of thread is widely used for fastening purpose?

A) Knuckle thread

B) V - thread

C) Saw tooth thread

D) Square thread

Answer: B) V - thread

156. Which thread is used for general purpose fastening?

A) Unified

B) BSF

C) BA

D) BSW

Answer: D) BSW

157. How is the vernier height gauge generally specified?

A) Width of beam

B) Thickness of beam

C) Size of base

D) Height of beam

Answer: D) Height of beam

158. Which device is used as datum while marking with Vernier height gauge?

A) Driving plate

B) Surface plate

C) Face plate

D) Angle plate

Answer: B) Surface plate

159. Which parameter of a thread is measured by three wire method?

A) Minor diameter

B) Major diameter

C) Pitch

D) Effective diameter

Answer: D) Effective diameter

160. Which bonding material is not affected by water, acid or normal temperature?

A) Rubber

B) Resinoid

C) Backlite

D) Vetrified

Answer: D) Vetrified

161. What is the isolating medium to prevent rapid cooling after brazing a tipped tool?

A) Mica powder

B) Wet sand

C) Water

D) Oil

Answer: A) Mica powder

162. What is the depth of square thread 60 x 5 mm pitch?

A) 4 mm

B) 5 mm

C) 3 mm

D) 2.5 mm

Answer: D) 2.5 mm

163. What is the least count of vernier height gauge?

A) 0.020 mm

B) 0.001 mm

C) 0.005 mm

D) 0.002 mm

Answer: A) 0.020 mm

164. What is the tool life index of cemented carbide tool for turning high carbon steel?

A) 0.4

B) 0.15

C) 0.2

D) 0.35

Answer: B) 0.15

165. Calculate the driven gear to cut 1.5mm pitch thread on a job using a lathe having lead screw of 5mm pitch with driver gear of 30 teeth?

A) 60

B) 50

C) 120

D) 100

Answer: D) 100

166. Convert 8 Degree 44 minutes into minutes?

A) 424

B) 428

C) 536

D) 524

Answer: D) 524