


VOP - HELD ON 19.12.2020

12.12.20


11.	<p>A CNC lathe is programmed and set to turn a diameter of 50mm, but on trial run the diameter is found to be 50.1mm. Which one of the following will ensure correct diameter during production?</p> <p>a) Increase the tool offset by 0.1mm b) Decrease the tool offset by 0.05mm c) Increase the tool offset by 0.05mm d) Decrease the tool offset by 0.1mm.</p>
12.	<p>CNC Lathe machine have built in co-ordinate measuring system. The zero position on the co-ordinate system is called-</p> <p>a) reference point b) machine zero point c) work zero point d) programme zero point</p>
13.	<p>As per Indian Standard System of limits and fits, there are 18 grades of fundamental tolerances. These are-</p> <p>a) IT1, IT2,.....IT18 b) IT0, IT1, IT2,.....IT17 c) IT01, IT0,IT1, IT2,....IT16 d) IT00, IT01, IT0,IT1, ...IT15</p>
14.	<p>The process of removing metal by a cutter, which is rotated in a direction opposite to the feed of the work-piece is known as</p> <p>a) conventional milling b) climb milling c) gang milling d) end milling</p>
15.	<p>The copper-zinc alloys is known as</p> <p>a) bronze b) brass c) lead d) zinc</p>
16.	<p>In orthogonal cutting of metals, the cutting edge of the tool is</p> <p>a) parallel to the direction of tool travel b) perpendicular to the work piece c) perpendicular the direction of tool travel d) inclined at an angle less than 90° to the direction of the tool travel.</p>
17.	<p>A device which holds locate a work piece guides and controls one or more cutting tool is known as</p> <p>a) Jig b) Fixture c) template d) Mandrel</p>
18.	<p>The thickness of chip is maximum at the beginning of the cut and minimum at the end of the cut, in</p> <p>a) up-milling b) down milling c) end milling d) face milling</p>
19.	<p>The notation 70 H6 /g5 means</p> <p>a) basic size is 70mm b) basic size is 70mm and tolerance grade for shaft is 6 and the hole is 5 c) basic size is 70 mm and tolerance grade for a hole is 6 and for the shaft is 5 d) basic size is 30mm and tolerance grade is one.</p>
20.	<p>In an interchangeable assembly, shafts of size $25.000^{+0.040}_{-0.010}$ mm mate with holes of size $25.000^{+0.030}_{+0.020}$ mm. The maximum interference (in microns) in the assembly is</p> <p>a) 40 microns b) 30 microns c) 20 microns d) 10 microns</p>

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31	The important mechanical property for a material to be successfully rolled or forged is..... a) malleability b) ductility c) elasticity d) brittleness
32	The cutting fluid mostly used for machining alloy steels is a) water b) soluble oil c) dry d) sulphurised mineral oil
33	Which one of the following is NOT the property of a good lubricant for machine tools? a) no change in viscosity due to change in temperature. b) reduces friction between machine parts. c) take up the surface pressure between sliding parts d) becomes thicker after prolonged use.
34	Distance moved by table in mm in one minute in any direction is known as a) Feed per minute b) Feed per tooth c) Feed per revolution d) None of the mentioned
35	Major constituent of the gun metal alloy is : a) Nickel b) Copper c) Iron d) Zinc
36	The..... material is more elastic a) rubber b) plastic c) steel d) brass
37	In which of the following milling machine, the table can be tilted in a vertical plane by providing a swivel arrangement at the knee? a) universal milling machine b) plain milling machine c) Hand milling machine d) horizontal milling machine.
38	The swing diameter over the bed is _____ the height of the centre measured from the bed of the lathe. a) equal to b) twice c) thrice d) one-half
39	The function of independent programming of the U & V axes in wire cut EDM machines is for producing..... a) hexagonal workpieces b) fullerene shaped workpieces c) workpieces having a different shape on the top and bottom d) workpieces having intricate shapes
40	The tool having the..... will give better chip flow? a) Negative back rake angle b) Positive back rake angle c) Zero back rake angle d) Front clearance angle



17. R. W.

41	Which of the following code is used in programming in absolute coordinates? a) G90 b) G32 c) G92 d) G01
42	Maximum deviation in size of shaft or hole is known as a) Tolerance b) Fundamental deviation c) Clearance d) Interference
43	When size of smallest shaft is more than size of biggest hole then it is..... a) Clearance fit b) Interference fit c) Transition fit d) loose running fit
44	Angle of butters thread is.....degree a) 47 degree b) 55 degree c) 45 degree d) 29 degree
45	Which of the following code is used to select y-z plane in milling? a) G32 b) G00 c) G02 d) G19
46	In a CNC program block, N002 GO2 G91 X40 Z40....., GO2 and G91 refer to a) circular interpolation in a counterclockwise direction and incremental dimension b) circular interpolation in a counterclockwise direction and absolute dimension c) circular interpolation in a clockwise direction and incremental dimension d) circular interpolation in a clockwise direction and absolute dimension
47	The tool life increases with the..... a) increase in side cutting edge angle b) decrease in side rake angle c) decrease in nose radius d) decrease in back rake angle
48form mixtures ranging from emulsions to solutions. a) Water miscible fluids b) Neat oils c) Synthetics d) Kerosene oil
49	Tumbler gears in lathe are used to a) reduce the spindle speed b) cut gears c) give desired direction of movement to lathe carriage d) drill a work piece.
50	The law which states that within elastic limits strain produced is proportional to the stress producing it is known as a) Bernoulli's law b) Hooke's law c) Stress law d) Poisson's law


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Answer Key – Foreman (Tool Room)

Question Number	Answer		Question Number	Answer
1	b		26	b
2	c		27	d
3	b		28	a
4	b		29	d
5	a		30	b
6	d		31	a
7	b		32	d
8	a		33	d
9	b		34	a
10	c		35	b
11	c		36	c
12	b		37	a
13	c		38	b
14	a		39	c
15	b		40	b
16	c		41	a
17	a		42	a
18	b		43	b
19	c		44	c
20	c		45	d
21	b		46	c
22	b		47	a
23	c		48	a
24	c		49	c
25	b		50	b


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