Sl.No	Questions				
1.	Electrically conductive materials are cut by WireEDM process by				
	mechanism.				
	a) thermal	b) electro-thermal			
	c) electro-dynamic	d) fused metal			
2.	Aluminium oxide is best suited abrasive for				
	a) brittle materials	b) hard materials			
	c) high tensile strength materials	d) ceramic materials			
3.	For motion transmission in CNC machines, recirculating ball screw is used to				
	a) to increase life of the screw.	b) to reduce friction			
		slides d) to increase friction			
4.		he tool has to be moved from point			
	(5, 4) to point (7, 2) along a circu				
		ion, the tool is at (5, 4). The correct G			
	and N codes for this motion are				
	a) N010GO3X7.0Y2.0I5.0J2.0	b) N010GO2X7.0Y2.0I5.0J2.0			
	c) N010GO1X7.0Y2.0I5.0J2.0				
5.	When a material is ductile and coare	utting speed is low, then chips formed			
		edge b) continuous			
	c) discontinuous				
6.	Morse standard taper is one of th	ne international accepted standard			
	tapers which is available in numl				
	a) 1 to 7 b) 1 to 8	c) 0 to 6 d) 0 to 7			
7.		e in diameters of taper and its length is			
	a) concentricity b) conicity	c) convexity d) eccentricity			
8.		of alloying elements in HSS tool			
	material are				
	a) 18% tungsten, 4%chromium 1 % vanadium				
	b) 18% chromium, 4% tungsten and 1% vanadium				
	c) 18% cobalt, 4% chromium and 1% vanadium				
	d) 18% tungsten, 4% vanadium and 1% chromium.				
9.	In Ultrasonic Machining (USM) the material is removed when the tool				
	is				
	a) rotating perpendicularly	b) axially oscillating			
	c) oscillating perpendicularly				
10.	Which among the following tolerance specifications has maximum				
	dimension less than 20mm				
	a) 20 (+0.2, -0.3)	b) 20 ± 0.2			
	c) 20 (-0.2, -0.3)	d) 20 (+ 0.0, -0.3)			
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11.	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? 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.			
12.	CNC Lathe machine have built in co-ordinate measuring system. The zero position on the co-ordinate system is calleda) reference point b) machine zero point c) work zero point d) programme zero point			
13.	As per Indian Standard System of limits and fits, there are 18 grades of fundamental tolerances. These area) IT1, IT2,IT18 b) IT0, IT1, IT2,IT17 c) IT01, IT0,IT1, IT2,IT16 d) IT00, IT01, IT0,IT1,IT15			
14.	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 a) conventional milling b) climb milling c) gang milling d) end milling			
15.	The copper-zinc alloys is known as a) bronze b) brass c) lead d) zinc			
16.	In orthogonal cutting of metals, the cutting edge of the tool is 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.			
17.	A device which holds locate a work piece guides and controls one or more cutting tool is known as a) Jig b) Fixture c) template d) Mandrel			
18.	The thickness of chip is maximum at the beginning of the cut and minimum at the end of the cut, in a) up-milling b) down milling c) end milling d) face milling			
19.	The notation 70 H6/g5 means 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.			
20.	In an interchangeable assembly, shafts of size $25.000 \frac{+0.040}{-0.010}$ mm mate with holes of size $25.000 \frac{+0.030}{+0.020}$ mm. The maximum interference (in microns) in the assembly is a) 40 microns b) 30 microns c) 20 microns d) 10 microns			

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21	With elastic limit in a loaded material, stress is a) inversely proportional to strain b) directly proportional to strain c) equal to strain d) none of the above.				
22	In ultra-sonic machining, the tool is made of a) tungsten carbide b) brass or copper c) diamond d) stainless steel				
23	Under the terminology of the IS system of limits, the term tolerance is defined as the difference between the a) maximum limit and the basic size b) minimum limit and the basic size c) maximum limit and minimum limit d) actual size and the basic size.				
24	In CNC machines velocity feedback is normally provided by a device called a) servomotor b) transducers c) tachogenerators d) photocell				
25	When a material is subjected to varying stresses, it fails under stresses considerably lower than the ultimate stress. Such type of failure of the material is known as a) creep b) fatigue c) stress concentration d) overstrain				
26	Holes of diameter $25.0\frac{+0.040}{+0.020}$ mm are assembled interchangeably with the pins of diameter $25.0\frac{+0.005}{-0.008}$ mm. The minimum clearance in the assembly will be a) 0.048 mm b) 0.015 mm c) 0.005 mm d) 0.008 mm.				
27	The electrode wires are usually made form a) graphite b) iron c) nickel d) brass				
28	Which of the following range of numbers represents dense structure of abrasives? a) 0-7 b) 8-10 c) 10-12 d) 12-16				
29	During groove cutting in a lathe using parting tools, which of the following forces are encountered. a) Tangential b) Tangential and Radial c) Radial d) Tangential, Radial and Axial				
30	Themilling operation is used for machining flat surface, parallel to the axis of cutter. a) face milling b) slab milling c) angular milling d) form milling				

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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				
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				
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				

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41	Which of the following code is used in programming in absolute					
41	coordinates? a) G90	b) G32	c) G92	d) G01		
	Maximum deviation in size of shaft or hole is known as					
42 a) Tolerance c) Clearance				b) Fundamental deviation d) Interference		
				,		
43	When size of s		s more than size	of biggest hole then		
15	a) Clearance fi	t	b) Int	erference fit		
	c) Transition fi	t	d) loo	se running fit		
44	Angle of butter					
	a) 47 degree b) 55 degree c) 45 degree d) 29 degree					
45		ollowing code b) G00	is used to select c) G02	y-z plane in milling? d) G19		
46	In a CNC prog GO2 and G91		02 GO2 G91 X4	0 Z40,		
			ounterclockwise	direction and		
	incremental dir	mension				
	b) circular interabsolute dimen		counterclockwise	direction and		
	c) circular interpolation in a clockwise direction and incremental					
	dimension d) circular interpolation in a clockwise direction and absolute					
	dimension					
47			ie			
	a) increase in sb) decrease in s					
	c) decrease in r					
10	d) decrease in b			am amulaiana ta		
48	solutions.	101111 11113	ctures ranging fro	om emuisions to		
	a) Water miscil	ole fluids	Z.	eat oils		
	c) Synthetics		d) K	erosene oil		
49	Tumbler gears		ed to			
	a) reduce the sp b) cut gears	oingle speed				
	c) give desired direction of movement to lathe carriage					
50	d) drill a work The law which		nin elastic limits	strain produced is		
	proportional to	the stress prod	lucing it is known	n as		
	a) Bernoulli's l c) Stress law	aw		oke's law sson's law		
	oj biress law		d) 1 01	SSOIL S 1444		

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Answer Key – Foreman (Tool Room)

Question	Answer	Question	Answer
Number		Number	
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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