

## CNC LATHE Pre-test

1. The axis that extends from the center of the rotating spindle is the \_\_\_\_\_ axis.
  - a. C Axis
  - b. Y Axis
  - c. Z Axis
  - d. X Axis
2. The G-code that tells the machine to cut in a straight line is \_\_\_\_\_.
  - a. G1
  - b. Go line
  - c. Gcut
  - d. GSL
3. CAD stands for \_\_\_\_\_?
  - a. Cubic Aligned Data
  - b. Cut Along Dots
  - c. Computer Aided Drafting
  - d. Computer and design
4. When you hear chatter do this \_\_\_\_\_?
  - a. Ask your neighbor to be quiet.
  - b. Slow the spindle speed.
  - c. Increase the spindle speed
  - d. Hit the emergency stop button
5. Absolute coordinates is a system that is \_\_\_\_\_?
  - a. Always right
  - b. Based on a given Zero position
  - c. Never to be used
  - d. Is a misspelling of obsolete coordinates
6. In Velocity CNC, a solid red lines means \_\_\_\_\_.
  - a. You made a mistake
  - b. Represents a cutting move to be done
  - c. A rapid move to be done
  - d. A rapid move already completed
7. The most common error in manually entering G Code is \_\_\_\_\_.
  - a. Omitting a period at the end of every line
  - b. Mistyping the letter "o" for the number "0"
  - c. Not Pressing enter at the end of the line
  - d. Skipping a line

8. The tape measure is practical for measurement down to \_\_\_\_ .
- 1/16<sup>th</sup> of an inch
  - 1/8<sup>th</sup> of an inch
  - 1/64<sup>th</sup> of an inch
  - 1 inch
9. The abbe' principal states \_\_\_\_.
- A measurement device should be on the same axis as the displacement to be measured.
  - The chips coming off the machine will fall to the right in the northern hemisphere
  - Cutting speeds will determine the principle quality of finish
  - Power tools may cause bodily harm when used improperly
10. The advantage of using a CNC machine over making a part manually is \_\_\_\_.
- Repeatability
  - Speed
  - Accuracy
  - All of the above
11. The Code M03 or M3 is used to \_\_\_\_.
- Turn off the spindle
  - Turn on the spindle
  - Do a tool change
  - Tell the machine the program is over
12. The axis that determines the diameter of the final part is \_\_\_\_.
- The Z Axis
  - The X Axis
  - The Y Axis
  - The C Axis
13. After loading a part in the chuck, do this \_\_\_\_.
- Rotate the spindle manually to check for clearance
  - Get the spindle turning quickly by hand to help it go
  - Turn the spindle on
  - Close the safety shield door
14. To pause the machine while running a part \_\_\_\_.
- Press the space bar
  - Press any key on the keyboard
  - Press the emergency stop
  - Both A&B

15. The F code is for controlling \_\_\_\_.
- The amount of error in the part
  - How fast the machine traverses during an operation
  - The speed the machine moves during a G0 move
  - The radius of an arc
16. The \_\_\_\_ center is attached to the tailstock for stabilizing longer parts. It has a bearing in it.
- Dead center
  - Bearing center
  - Live Center
  - None of the above
17. The post processor is used to \_\_\_\_\_.
- Apply a finish after cutting the part
  - Generate G-codes from a tool path in Surfcam
  - Create a post cut
  - Turn the raw stock into a post
18. There are 2 places that you can verify your program. Once in Surfcam, the other in Velocity. What is the difference between these verifications?
- Surfcam will produce a 3D rendering and Velocity shows lines
  - Velocity is showing what the machine will do based on the actual G-code
  - Surfcam is only based on the tool process, not the actual G-codes.
  - All of the above
19. To easily use more than one tool in a program you need to \_\_\_\_.
- Use a quick change tool holder
  - Enter tooling offsets so that the machine will know where the tools are
  - Stop the spindle prior to changing the tool
  - All of the above
20. Carbide insert tooling provides this advantage \_\_\_\_\_.
- Has a longer life than diamond tooling
  - Costs less than high speed steel
  - Does not brake no matter how hard it is tightened in the tool holder
  - None of the above