

## Proficiency Test For Machining Center

Name: \_\_\_\_\_ Date: \_\_\_\_\_

### Section One: General CNC Questions

- 1) The spindle speed for a particular tool in a program is increased and you wish to reduce it. The kind of GNC word you must change is:
- ☐ A) an F word    ☐ C) an S word  
☐ B) a G word    ☐ D) a T word
- 2) You determine that a feedrate for a particular tool must be 5.8 inches per minute (or 5 millimeters per minute in the metric mode). The correct designation in the program would be:
- ☐ A) F0.5    ☐ C) F5.8  
☐ B) G5.8    ☐ D) F0.005
- 3) You are running a proven program (see run before) for the first time in a new setup. You are cautiously allowing the first tool come into its approach position when you determine that the tool is not going where it is supposed to. It is most likely that:
- ☐ A) the spindle speed is not correct.  
☐ B) the program zero designation is not correct.  
☐ C) the dry run switch should be turned on.  
☐ D) the programmed coordinates are not correct.
- 4) When coordinates going into a program are specified relative to the program zero point, it is called:
- ☐ A) the incremental mode  
☐ B) the absolute mode  
☐ C) the up-d mode  
☐ D) the copied cycle mode
- 5) What mode switch position allows programs to be modified?
- ☐ A) Jog    ☐ D) Edit  
☐ B) Auto    ☐ E) Zero-return  
☐ C) MDI (manual data input)
- 6) What mode switch position allows a program to be run from within the CNC control?
- ☐ A) Jog    ☐ D) Edit  
☐ B) Auto    ☐ E) Zero-return  
☐ C) MDI (manual data input)
- 7) What mode switch position allows the activation of a single GNC command?
- ☐ A) Jog    ☐ D) Edit  
☐ B) Auto    ☐ E) Zero-return  
☐ C) MDI (manual data input)
- 8) What mode switch position allows you to send the machine to its reference (home) position?
- ☐ A) Jog    ☐ D) Edit  
☐ B) Auto    ☐ E) Zero-return  
☐ C) MDI (manual data input)
- 9) What mode switch position lets you move the machine axes manually?
- ☐ A) Jog    ☐ D) Edit  
☐ B) Auto    ☐ E) Zero-return  
☐ C) MDI (manual data input)
- 10) Which switch works in conjunction with a slash code in the program?
- ☐ A) Dry Run    ☐ D) Single Block  
☐ B) Optional Stop    ☐ E) Machine Lock  
☐ C) Optional Block Skip/Block Delete
- 11) Which switch works in conjunction with an M01 in the program?
- ☐ A) Dry Run    ☐ D) Single Block  
☐ B) Optional Stop    ☐ E) Machine Lock  
☐ C) Optional Block Skip/Block Delete
- 12) Which switch makes the control advance and continue in the program at a time-and then stop?
- ☐ A) Dry Run    ☐ D) Single Block  
☐ B) Optional Stop    ☐ E) Machine Lock  
☐ C) Optional Block Skip/Block Delete
- 13) The Feedrate-Override switch lets the operator control the machine's movement rate during cutting commands.
- ☐ A) True    ☐ B) False
- 14) The button used to activate a GNC program is:
- ☐ A) Feed    ☐ D) Cycle Start  
☐ B) Emergency Stop    ☐ E) Feedhold  
☐ C) Coolant On
- 15) The button used to temporarily stop the CNC cycle is:
- ☐ A) Feed    ☐ D) Cycle Start  
☐ B) Emergency Stop    ☐ E) Feedhold  
☐ C) Coolant On
- 16) The button that will restart the CNC program after temporary stoppage is:
- ☐ A) Feed    ☐ D) Cycle Start  
☐ B) Emergency Stop    ☐ E) Feedhold  
☐ C) Coolant On
- 17) The button that will clear data in the look-ahead buffer after a temporary program stoppage is:
- ☐ A) Feed    ☐ D) Cycle Start  
☐ B) Emergency Stop    ☐ E) Feedhold  
☐ C) Coolant On

# Machine Shop Machinist Questions And Answers

**J Ma**



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