

QUESTIONS BANK
MSME TOOL ROOM-KOLKATA
Course name: CERTIFICATE COURSE IN CNCTURNING & MILLING
Course code: MSME/CCCTM/25
Subject name: Workshop Technology

Choose the correct answer from the alternatives

- 1) Second cut in a file in the type of
a) section b) grade c) cut d) design **(Ans :- B)**
- 2) accuracy of surface plate is.....
a) 0.02500mm b) 0.25000mm
c) 0.00025mm d) 0.00250mm **(Ans :- D)**
- 3) Which one among the following materials can be cut with a rasp cut file ?
a) Steel b) Cast iron c) Wood d) Bronze **(Ans :- C)**
- 4) The point angle of centre punch is
a) 90° b) 100° c) 60° d) 120° **(Ans :- A)**
- 5) Try square is used to check up an angle of
a) 30° b) 45° c) 60° d) 90° **(Ans :- D)**
- 6) A divider is used for
a) Scribing circle b) Scribing arcs
c) transferring and stepping of distances d) All of the above **(Ans :- D)**
- 7) "V" block is used to hold round bars. It has a Vee groove which is usually
a) 30° b) 45° c) 60° d) 90° **(Ans :- D)**
- 8) The point angle of scriber is
a) 30° b) 5° to 10° c) 60° d) 12° to 15° **(Ans :- D)**
- 9) Scriber is made of
a) Copper b) High carbon steel c) Mild steel d) Cast iron **(Ans :- B)**

- 10) During marking, the reference surface is provided by
a) Sketch of the job b) work piece
c) Marking off table surface d) Surface gauge **(Ans :- C)**
- 11) The peen of a cross-peen hammer is
a) Angular to the handle b) Straight to the handle
c) Cross to the handle d) Bent towards the handle **(Ans :- C)**
- 12) The jaw plates of a bench vice are made of
a) Tool steel b) Mild steel c) Cast iron d) Bronze **(Ans :- A)**
- 13) The hand vice is used for
a) Fixing heavy jobs b) Tightening nuts and bolts
c) Holding round jobs d) Doing minute work **(Ans :- D)**
- 14) Steel rule is made of
a) Brass b) Zinc c) Stainless steel d) Cast iron **(Ans :- C)**
- 15) Which of the following is an indirect measuring tool ?
a) Inside caliper b) Vernier caliper
c) Universal bevel protractor d) Inside micrometer **(Ans :- A)**
- 16) Which of the following is a direct measuring tool ?
a) Try square b) Steel rule
c) Ring gauge d) None of the above **(Ans :- B)**
- 17) The least count of a vernier caliper is
a) 0.10 mm b) 0.01 mm c) 0.05 mm d) 0.02 mm **(Ans :- D)**
- 18) Surface table are made of
a) Cast iron b) granite c) Both A and B d) None of this **(Ans :- C)**
- 19) The suitable pitch of hacksaw for cutting solid brass is
a) 0.8 mm b) 1.0 mm c) 1.4 mm d) 1.8 mm **(Ans :- D)**
- 20) The length of the hammer handle for a 500 gm hammer should be about
a) 275 mm b) 300 mm c) 325 mm d) 350 mm **(Ans :- C)**
- 21) For general purpose, a bench vice is fixed at a height of
a) 80 cm b) 90 cm c) 106 cm d) 125 cm **(Ans :- C)**

- 22) The box nut of a bench vice is made of
 a) Mild steel b) Phosphorous bronze
 c) White metal d) Alloy steel **(Ans :- B)**
- 23) The cutting action of a file depends upon.
 a) The kind of cut and spacing of teeth
 b) Arrangement of teeth on the file
 c) Size and shape of the file
 d) All of the above **(Ans :- D)**
- 24) A double cut file is used for filing on
 a) Wood b) Hard board c) Lather d) Steel **(Ans :- D)**
- 25) File card is used for
 a) Cleaning the work piece b) Cleaning the file teeth
 c) Renewing the file teeth d) Cleaning the chips **(Ans :- B)**
- 26) the best position to hold the job in the vice when filing is
 a) Eye level b) Shoulder level
 c) Elbow level d) All of the above **(Ans :- C)**
- 27) A rough file is used
 a) On irregular job b) To reduce the metal rapidly
 c) On wood d) If smooth file is not available **(Ans :- B)**
- 28) Single cut file has cutting teeth angle of.....degree to the centre line.
 a) 51 b) 60 c) 70 d) 90 **(Ans :- B)**
- 29) Desirable hardness in a file is generally
 a) 30 HRC b) 45 HRC c) 60 HRC d) 80 HRC **(Ans :- C)**
- 30) The general ratio of water & soluble oil used as a coolant is.....
 a) 1 : 20 b) 20 : 1 c) 1 : 10 d) 10 : 1 **(Ans :- B)**
- 31) Cutting fluid required for machining aluminium.....
 a) soluble oil b) dry air c) kerosene d) water **(Ans :- C)**
- 32) Which one of the following metals does not require any coolant during machining ?
 a) Aluminium b) Cast iron c) Copper d) Steel **(Ans :- B)**
- 33) The suitable cutting fluid for machining mild steel plate is
 a) Soluble oil b) Water c) Compressed air d) Kerosene **(Ans :- A)**

- 34) At the time of turning a single point cutting tool advances into the job in one complete revolution is known as
 a) R.P.M b) Cutting speed
 c) Feed d) Machine speed **(Ans :- C)**
- 35) The rate of feed depends upon
 a) Finish required b) Material of cutting tool
 c) Material to be machining d) All of the above **(Ans :- D)**
- 36) Least count of metric outside micrometer is
 a) 0.00001 mm b) 0.0001 mm c) 0.001 mm d) 0.01 mm **(Ans :- D)**
- 37) While machining cast iron, the coolant used should be
 a) Dry air b) Kerosene c) Machine oil d) Soft water **(Ans :-A)**
- 38) Which one of the following materials is used for manufacturing centre drills ?
 a) Cast steel b) Mild steel c) High speed steel d) Cast iron **(Ans :- C)**
- 39) For setting of tool for threading, it aligned with the work by using
 a) try square b) centre gauge c) thread plug gauge d) template **(Ans :- B)**
- 40) An accident is.....
 a) Unplanned event b) Non - controlled event
 c) Undesirable event d) All of the above **(Ans :- D)**
- 41) The safe way of working is....
 a) An effective and right way of working
 b) An accident way of working
 c) A way of handling the work in a hurry
 d) A way of normal working **(Ans :- A)**
- 42) Micrometer works on the principle of
 a) Screw b) Bolt c) Stud d) Nut & bolt **(Ans :- D)**
- 43) The angle which is less than 90° is called as..
 a) Obtuse angle b) Acute angle
 c) Right angle d) None of the above **(Ans :- B)**
- 44) A hole, which is not made through full depth of the component is known as
 a) Core hole b) Blind hole c) Pin hole d) Bore hole **(Ans :- B)**
- 45) The value of one micron is
 a) 0.00001 mm b) 0.0001 mm c) 0.001 mm d) 0.01 mm **(Ans :- C)**

- 46) The minimum measurement that can be read with the help of a steel rule is.....
 a) 1mm b) 0.05mm c) 0.50mm d) 0.02mm **(Ans :- C)**
- 47) Point included angle of twist drill is.....
 a) 90° b) 100° c) 118° d) 120° **(Ans :- C)**
- 48) A multipoint cutting tool used finish accurately size and shape of enlarging a hole is known as.....
 a) drill b) tap c) die d) reamer **(Ans :- D)**
- 49) The material of twist drill is generally
 a) H.S.S. b) Carbide steel c) Diamond d) Cast steel **(Ans :- A)**
- 50) A cutting tool used to cut out side threads is called
 a) Drill b) Reamer c) Die d) Tap **(Ans :- C)**
- 51) A cutting tool used to cut in side threads is called
 a) Drill b) Reamer c) Die d) Tap **(Ans :- D)**
- 52) While grinding one must be use
 a) Dark glass screen b) Mask
 c) Safety goggles d) Sun goggles **(Ans :- C)**
- 53) For tapping with M10 tap, what size drill will you use ?
 a) 8.00 mm b) 8.50 mm c) 9.00 mm d) 9.50 mm **(Ans :- B)**
- 54) The process of beveling the end of existing hole is called
 a) Spot-facing b) Boring
 c) Counter-boring d) Counter-sinking **(Ans :- D)**
- 55) The process of enlarging the end of an existing hole to accommodate the head of socket screw is called
 a) Spot-facing b) Boring
 c) Counter-boring d) Counter-sinking **(Ans :- C)**
- 56) Which one of the following is used to hold the straight shank drill having diameter less than 12 mm
 a) Sleeve b) Socket c) Drill chuck d) Drill drift **(Ans :- C)**
- 57) The taper shank drills should be removed from the machine spindle by means of
 a) Hammer b) Tang of file c) Punch d) Drift **(Ans :- D)**

- 58) Lathe bed is made of
- a) H.S.S b) Tool steel c) High carbon steel d) Cast iron **(Ans :- D)**
- 59) During turning operation tool bit should be set.....
- a) above the centre height b) below the centre height
c) at the centre of the job d) set any height **(Ans :- C)**
- 60) While drilling in lathe, the drill is held in the
- a) Headstock b) Tailstock c) Compound rest d) Bed **(Ans :- B)**
- 61) Carbon percentage in HSS tool is
- a) 0.75 to 1.00% b) 1.00 to 2.00%
c) 0.60 to 0.75% d) 0.20 to 0.30% **(Ans :- A)**
- 62) The commonly used proportions of alloying elements in HSS are
- a) 18% tungsten, 4% chromium and 1% vanadium
b) 18% chromium, 4% tungsten and 1% vanadium
c) 18% vanadium, 4% chromium and 1% tungsten
d) 18% cobalt, 4% chromium and 1% vanadium **(Ans :- A)**
- 63) Main alloying elements in H.S.S is
- a) Tungsten b) Chromium c) Vanadium d) Nickel **(Ans :- A)**
- 64) Which one of the following is not a part of a centre lathe ?
- a) Saddle b) Feed rod c) Arbor d) Lead screw **(Ans :- C)**
- 65) The headstock of a lathe is situated at the
- a) Right hand end of the lathe bed b) Left hand end of the lathe bed
c) Middle of the lathe bed d) Bottom of the lathe bed **(Ans :- B)**
- 66) The horizontal feed, cross feed and screw cutting movement in a lathe is controlled by
- a) Headstock b) Tailstock c) Cross-slide d) Apron **(Ans :- D)**
- 67) Which one of the following centres is suitable while cutting taper by set over method
- a) Plain centre b) Half centre c) Ball centre d) Revolving centre **(Ans :- C)**
- 68) The taper provided in the nose of the tailstock barrel is
- a) Morse taper b) Jarno taper c) Brown and Sharpe d) Metric taper **(Ans :- A)**
- 69) Which among the following centres is suitable when work piece held between centres is to be turned at high speed
- a) Pipe centre b) Half centre c) Ball centre d) Revolving centre **(Ans :- D)**

- 70) Cross-slide in a lathe moves
 a) parallel to the axis rotation b) at any angle to the axis rotation
 c) perpendicular to the axis rotation d) either "a" or "b" **(Ans :- C)**
- 71) Carriage in a lathe moves
 a) parallel to the axis rotation b) at any angle to the axis rotation
 c) perpendicular to the axis rotation d) either "a" or "b" **(Ans :- A)**
- 72) One of the taper turning methods is by offsetting the tailstock. Which part of the tail stock is offset ?
 a) Body b) Base c) Spindle d) Whole unit **(Ans :- A)**
- 73) Which type of taper is generally turned in tailstock method ?
 a) Internal b) External
 c) Both internal and external d) None of the above **(Ans :- B)**
- 74) The tailstock of a lathe is situated at the
 a) Right hand end of the lathe bed b) Left hand end of the lathe bed
 c) Middle of the lathe bed d) Bottom of the lathe bed **(Ans :- A)**
- 75) Which one of the following on a lathe is used to give depth cut at the time turning ?
 a) Compound slide b) Top slide
 c) By adjusting the tool d) Cross-slide **(Ans :- D)**
- 76) Three jaw chuck is also called
 a) Independent Chuck b) Magnetic chuck
 c) Self-centering chuck d) collect chuck **(Ans :- C)**
- 77) Which machine tool is known as the mother machine tool ?
 a) Drill b) Milling c) Lathe d) None of mentioned **(Ans :- C)**
- 78) Which type of surface is produced by turning operation in lathe machine ?
 a) Flat b) cylinder c) Taper d) None of mentioned **(Ans :- B)**
- 79) Which type of feed is needed in turning operation ?
 a) Longitudinal b) Cross
 c) Both cross and longitudinal d) None of mentioned **(Ans :- A)**
- 80) Work piece hold in lathe machine
 a) Chuck b) Tail stock c) Carriage d) Head stock **(Ans :- A)**
- 81) Lathe centre is used for.....
 a) Cutting b) Supporting c) Holding d) All of this **(Ans :- B)**

- 82) For plain turning a 60 mm diameter work piece using HSS tool with recommended cutting speed of 30 metre / min., the RPM should be
 a) 80 RPM b) 159 RPM c) 192 RPM d) 318 RPM **(Ans :- B)**
- 83) The tapping hole should be
 a) Larger than the tap size b) Smaller than the tap size
 c) Equal to the tap size d) Equal to the minor diameter of the tap **(Ans :- D)**
- 84) The pitch of 3-start thread is the lead divided by
 a) 1 b) 2 c) 3 d) 4 **(Ans :- C)**
- 85) The angle of metric thread (V-shaped) is
 a) 29° b) 45° c) 90° d) 60° **(Ans :- D)**
- 86) What type of threads are suitable for lead screw of lathe machine
 a) British Association threads b) Whitworth Screw threads
 c) Acme threads d) Square threads **(Ans :- C)**
- 87) Which one of the following is the reason for rough and broken threads ?
 a) Thread cutting tool blunt.
 b) The size of hole or diameter of the blank for bolt is not correct.
 c) The flutes of cutting tool are filled with chips. **(Ans :- D)**
 d) All of the above.
- 88) The distance between one point on a screw thread and the corresponding point on the next thread, measured parallel to the axis is called as
 a) Axis of thread b) Depth of thread
 c) Pitch of thread d) Lead of thread **(Ans :- C)**
- 89) In a single start thread
 a) Lead and pitch are equal b) Lead is double the pitch
 c) Pitch is double the lead d) Lead is half the pitch **(Ans :- A)**
- 90) Which one of the following screw thread forms has an included angle of 29° between the flanks of thread ?
 a) B. A. thread b) Acme thread
 c) Buttress thread d) Knuckle thread **(Ans :- B)**
- 91) Which one of the following threads, is used on mechanical jack ?
 a) Acme b) Square c) Buttress d) B.S.F. **(Ans :- B)**
- 92) B.S.F. screw threads have the included angle
 a) 29° b) 45° c) 55° d) 60° **(Ans :- C)**

103) Centre drilling should be done at
a) higher RPM with a slower feed
b) higher RPM with a higher feed
c) slower RPM with a higher feed
d) slower RPM with a Slower feed **(Ans :- D)**

104) RPM stands for
a) Revolution per minute b) Round per minute
c) Revolution per motor d) All of the above **(Ans :- A)**

105) Knurling is a _____ operation.
a) Shaping b) Forming c) Facing d) Turning **(Ans :- B)**

106) In a Plain Milling M/C, the table can be moved
a) Longitudinally b) Crosswise c) Vertically d) All of these **(Ans :- D)**

107) 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) Plane in Milling machine
c) Omniversal Milling machine d) Hand Milling Machine **(Ans :- C)**

108) Internal or external threads of different pitches can be produced by:
a) Pantograph Milling machine b) Profiling Machine
c) Planetary Milling machine d) Plano – Miller **(Ans :- C)**

109) The cutting tool in a milling machine is mounted on
a) Spindle b) Arbor c) Column d) Knee **(Ans :- B)**

110) In a plain milling cutter, the chip space between the back of one tooth and the face of the next tooth is called.
a) Face b) Fillet c) Gash d) land **(Ans :- C)**

111) The process of removing metal by a cutter which is rotated against the direction of travel of work piece is called ?
a) Up Milling b) Down Milling c) Face Milling d) End Milling **(Ans :- A)**

112) The process of removing metal by a cutter which is rotated in the same direction of travel of work piece, is called
a) Up Milling b) Down Milling c) Base Milling d) End Milling **(Ans :- B)**

113) In down Milling the thickness of chips is
a) Minimum at the beginning of the cut and maximum at the end of the cut
b) Maximum at the beginning of the cut and minimum at the end of the cut
c) Uniform throughout the cut
d) None of these **(Ans :- B)**

114) The operation of machining several severed surfaces of a work piece simultaneously is called.
a) Profile Milling b) Gang Milling
c) Saw Milling d) Helical Milling **(Ans :- B)**

115) The Saw Milling is an operation of
a) Producing Grooves around the periphery of a cylindrical or conical work piece.
b) Producing narrow slots or grooves on a work piece
c) Reproduction of an outline of a template on a work piece.
d) Machining several surfaces of a work piece simultaneously. **(Ans :-B)**

116) The Operation of producing grooves around the periphery of a cylindrical or conical work is called
a) Profile milling b) gang Milling
c) Saw milling d) Helical Milling **(Ans :-D)**

117) Gears can be best produced on mass production by
a) Shaping b) Casting c) Forming d) Hobbing **(Ans :-D)**

118) Gear finishing operation is called
a) Milling b) Hobbing c) shaping d) Burnishing **(Ans :-D)**

119) Down Milling is also called
a) Conventional Milling b) Climb Milling
c) End Milling d) Face Milling **(Ans :-B)**

120) Up Milling is also called
a) Conventional Milling b) Climb Milling c) End Milling d) Face Milling **(Ans :-A)**

121) Climb milling is chosen while machining because:
a) The chip thickness increase gradually
b) It enables the cutter to dig in and start the cut
c) The specific power consumption is reduced
d) Better surface finish can be obtained. **(Ans :-B)**

- 139) Which among the following is not correct?
 a) While using helical milling cutter, only one tooth is loaded at a time.
 b) Helical milling cutter does produce chatter
 c) Helical plain milling cutter has an angle of 45° to over 60°
 d) Plain milling cutter is also called slab milling cutter (Ans :- A)
- 140) To obtain good surface, the ideal machining allowance for finish milling would be. a) 0.1 mm b) 0.2 mm c) 0.5 mm d) 0.8 mm (Ans :- C)
- 141) Which one of the following is not important in rough milling operation a) Quality of surface finish b) Rigidity of machine
 c) Depth of cut d) Rigidity of work piece (Ans :- A)
- 142) Which among the following is the purpose of finish milling a) To bring the work piece to the required dimension
 b) To bring the work piece to the required surface finish
 c) 'a' and 'b' both
 d) Neither 'a' nor 'b' (Ans :- C)
- 143) In rough milling heavy feed and depth of cut depend upon the a) Rigidity of work piece b) Rigidity of machine
 c) Rigidity of operator d) 'a' and 'b' both (Ans :- D)
- 144) Gang milling of operation is usually performed when a) Single piece is to be milled
 b) Duplicate pieces are to be milled in mass production
 c) Repair work is to be done d) None of the above (Ans :- B)
- 145) As compared to a finish milling cutter, a rough milling cutter of the same diameter will have
 a) Less number of teeth b) More number of teeth
 c) Same number of teeth d) Either 'b' and 'c' (Ans :- A)
- 146) The round portion of the chip space on milling cutter is called as a) Round edge b) Corner slot
 c) Fillet d) Radius (Ans :- C)
- 147) Slitting saw cutter is used for
 a) Cutting convex groove b) Angular machining
 c) Cutting of length d) Cutting key way (Ans :- C)

148) Circular slots and dovetail can be milled by using
a) Indexing head attachment b) Rack milling
c) Rotary table d) Slotting attachment **(Ans :- C)**

149) Rotary table is used on milling machine to achieve
a) Longitudinal movement
b) Cross movement
c) Combination of Longitudinal and cross movement
d) Combination of Longitudinal, cross and vertical movement **(Ans :- C)**

150) Solid milling cutter manufactured from
a) Sintered carbide b) High speed steel c) Ceramic d) Stellite **(Ans :- B)**