### प्रश्न पत्रिका का तर्क न खोजना जब तक आपको इसके लिए पत्रिका न दिया जाय़।

Do not open this QUESTION BOOKLET until you are asked to do so.

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### प्रश्न पत्र / QUESTION PAPER

वैकल्पिक प्रश्न पत्र/OBJECTIVE(MCQ) TYPE TEST

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1. How does light normally travel?
A) In concentric circles  B) In a straight line  
C) Always towards a dark area  D) In a curved line

2. First Country to undergo industrial revolution:
A) France  B) Britain  
C) Germany  D) USA

3. A solar water heater can not be used to get hot water on
A) A sunny day  B) A cloudy day  
C) A hot day  D) A windy day

4. In India, the first cotton mill was set up in
A) Madras  B) Bombay  
C) Kanpur  D) Surat

5. Regur soil is the other name of
A) Black soil  B) Alluvial soil  
C) Arid soil  D) Laterite soil

6. The different group of stars is known as
A) Constellations  B) Celestial bodies  
C) Asteroids  D) Comet

7. Which country has two-party system?
A) India  B) Sri Lanka  
C) United Kingdom  D) Nepal

8. Which of the following is a macro nutrient?
A) Mn  B) Mg  
C) Cu  D) Zn

9. The process of evaporation causes
A) Cooling  B) Heating  
C) Dryness  D) None of these

10. Place directly above focus on Earth's surface is known as
A) Strike  B) Comma  
C) Epicenter  D) Origin

11. HCF of 84 & 270 is
A) 8  B) 6  
C) 4  D) 2

12. The sum of first five multiples of 3 is:
A) 45  B) 65  
C) 75  D) 90

13. 7:12 is equivalent to:
A) 28 : 40  B) 42 : 71  
C) 72 : 42  D) 42 : 72

14. Find the simple interest on the Rs. 2000 at 25/4% per annum for the period from 4th Feb 2005 to 18th April 2005
A) Rs. 35  B) Rs. 30  
C) Rs. 25  D) Rs. 40

15. The average of 20 numbers is Zero. Of them, at the most, how many may be greater than zero?
A) 0  B) 1  
C) 10  D) 19

16. An athlete runs 200 meters in 24 seconds. His speed is?
A) 10 km/hr  B) 17 km/hr  
C) 27 km/hr  D) 30 km/hr
17. Every rational number is
   A) A natural number      B) An integer      C) A real number      D) A whole number

18. What decimal of an hour is a second?
   A) .0025                B) .0256              C) .00027               D) .000126

19. A fruit seller had some apples. He sells 40% apples and still has 420 apples. Originally, he had how many?
   A) 588 apples           B) 600 apples        C) 672 apples           D) 700 apples

20. A does a work in 10 days and B does the same work in 15 days. In how many days they will do the same work together?
   A) 5 days               B) 6 days            C) 7 days               D) 8 days

21. Grinding is the process of removing materials by
   A) Rubbing               B) Cutting            C) Polishing            D) Wearing

22. The main purpose of the grinding wheel guard is to
   A) Limit grinding to a small part of the wheel
   B) Protects the operator from flying sparks
   C) Prevent pieces from being thrown from a broken grinding wheel
   D) All of these

23. After dressing a wheel it may be necessary to adjust the
   A) Tool rest      B) Eye Shield     C) Guard                D) All of these

24. Which one of the following grinding wheels (with grade, grit and bond) is suitable for cutter grinding?
   A) K 60 vitrified            B) K 320 vitrified             C) T 60 resinoid        D) T 320 resinoid

25. The material which holds the fine grains of abrasive material in grinding wheel is called as
   A) Compound      B) Bond         C) Hold                 D) None of the above

26. Which type of grinding wheel is shown in below diagram?

   A) Dish wheel         B) Cup wheel        C) Saucer wheel        D) Cylinder wheel

27. Which process is used for grinding splined shafts?
   A) External cylindrical grinding         B) Internal cylindrical grinding
   C) Surface grinding                      D) Form grinding
28. Rough grinding process is commonly used for
A) removing excess material from casting
B) cutting materials that are too hard to be machined by other conventional tools
C) producing surfaces on parts to higher dimensional accuracy
D) obtaining finer finish

29. Dressing and truing of a grinding wheel are
A) Exactly the same operation
B) Done with the same equipment
C) Done only for coarse grinding wheels
D) Only for form grinding wheels

30. A hardened die block (work) has to be ground. It is required to retain the same hardness even after grinding. If the work is overheated in the grinding process, it may result in work being rejected or scrapped. Probable reason for rejection is that the work surface is
A) Discolored
B) Softened
C) Rough
D) Brittle

31. What can be the reason if a grinding wheel fails to grind?
A) Grinding wheel's grade is too soft
B) Grinding wheel is glazed
C) Grinding wheel is not securely mounted on spindle
D) Too much feed is given

32. The depth of in-feed per pass in dressing a grinding wheel should be not more than
A) 0.25 mm
B) 0.025 mm
C) 0.0025 mm
D) 0.00025 mm

33. The grade of a grinding wheel is specified by letters from A to Z. Which one is the hardest grade?
A) E
B) J
C) P
D) Y

34. It is required to finish grind a 050 mm mild steel shaft on a cylindrical grinding machine. What will be the surface speed if r.p.m. of the job is 191?
A) 20 meters/min.
B) 25 meters/min.
C) 30 meters/min.
D) 35 meters/min.

35. Which among the following is the natural abrasive?
A) Corundum
B) Diamond
C) Emery
D) All of the above.

36. By which unit the roughness value is expressed for grinding
A) μm
B) μin
C) μlfs
D) μft.

37. A Shaft is turned in one finish cut which one of the following parameters will directly influence the machining time?
A) Cutting depth
B) Setting angle
C) Diameter of work piece
D) Tool travel distance

38. The silicon carbide abrasive is chiefly used for grinding
A) Cemented carbide
B) Ceramic
C) Cast iron
D) All of these

39. The grinding operation is
A) Shaping operation
B) Forming operation
C) Surface finishing operation
D) Dressing operation

40. Grinding wheels should be tested for balance
A) Only at the time of manufacture
B) Before starting the grinding operation
C) At the end of grinding operation
D) Occasionally

41. In plunge grinding
A) The work is reciprocated as the wheel feeds to produce cylinders longer than the width of wheel face
B) The work rotates in a fixed position as the wheel feeds to produce cylinders equal to or shorter than the width of wheel face
C) The work is reciprocated as the wheel feeds to produce cylinders shorter than the width of wheel face
D) The work rotates in a fixed position as the wheel feeds to produce cylinders longer than the width of wheel face

1395_17 (A)
42. In grinding irregular, curved, tapered, convex and concave surfaces, the grinder used is
A) Cylindrical grinder  B) Internal grinder  C) Surface grinder  D) Tool and cutter grinder

43. Glazing in grinding wheels ________ cutting capacity.
A) Has no effect on  B) Increase  C) Decrease  D) None of these

44. In order to grind soft material
A) Coarse grained grinding wheel is used  B) Fine grained grinding wheel is used
C) Medium grained grinding wheel is used  D) Any one of these

45. For fast removal of materials during grinding, a ________ grinding wheel is used.
A) Coarse grained  B) Fine grained  C) Medium grained  D) None of these

46. The method of grinding used to produce a straight or tapered surface on a work piece, is
A) Internal cylindrical grinding  B) Form grinding
C) External cylindrical grinding  D) Surface grinding

47. In order to obtain a surface finish in the range of 0.75 μm to 1.25 μm, the operation used is called
A) Grinding  B) Lapping  C) Honing  D) Buffing

48. The trade name of a nonferrous cast alloy composed of cobalt, chromium and tungsten is called
A) Ceramic  B) Stellite  C) Diamond  D) Cemented carbide

49. The abrasive recommended for grinding materials of high tensile strength is
A) Silicon carbide  B) Aluminium oxide  C) Sand stone  D) Diamond

50. The structure of a grinding wheel depends upon
A) Hardness of the material being ground  B) Nature of the grinding operation
C) Finish required  D) All of these

51. A dense structure of a grinding wheel is used for
A) Hard materials  B) Brittle materials  C) Finishing cuts  D) All of these

52. In centreless grinding, work place centre will be
A) Above the line joining the two wheel centres
B) Below the line joining the two wheel centres
C) On the line joining the two wheel centres
D) At the intersection of the line joining the wheel centres with the work place plane

53. The hardness of a grinding wheel is specified by
A) Brinell hardness number  B) Rockwell hardness number
C) Vickers pyramid number  D) Letter of alphabet

54. The method of grinding used to produce internal cylindrical holes and tapers, is
A) Internal cylindrical grinding  B) Form grinding
C) External cylindrical grinding  D) Surface grinding

55. Glazing in grinding wheels takes place when the
A) Wheel is too soft or wheel revolves at a very slow speed
B) Wheel is too hard or wheel revolves at a very high speed
C) Wheel is too hard and wheel revolves at very slow speed
D) Wheel is too soft and wheel revolves at a very high speed

56. A grinding wheel becomes glazed (i.e., cutting edge takes a glass-like appearance) due to
A) Wear of bond  B) Cracks on grinding wheel
C) Wear of abrasive grains  D) Breaking of abrasive grains
57. The aluminium oxide abrasive is chiefly used for grinding
   A) High speed steel B) Carbon steel C) Wrought iron D) All of these

58. The size of abrasive grain required in a grinding wheel depends upon the
   A) Amount of material to be removed B) Hardness of material being ground
   C) Finish desired D) All of these

59. A ________ grinding wheel is used to grind soft materials.
   A) Course grained B) Medium grained C) Fine grained D) None of these

60. The abrasive recommended for grinding materials of low tensile strength is
   A) Sand stone B) Aluminium oxide C) Diamond D) Silicon carbide

61. The process of changing the shape of grinding wheel as it becomes worn due to breaking away of the abrasive and bond, is called
   A) Truing B) Dressing C) Facing D) Clearing

62. Surface grinding is done to produce
   A) Tapered surface B) Flat surface C) Internal cylindrical holes D) All of these

63. The soft grade grinding wheels are denoted by the letters
   A) A to H B) I to P C) Q to Z D) A to P

64. A coarse grained grinding wheel is used to grind
   A) Hard and brittle materials B) Soft and ductile materials
   C) Hard and ductile materials D) Soft and brittle materials

65. An open structure of a grinding wheel is used for
   A) Soft materials B) Tough materials C) Ductile materials D) All of these

66. The method of centreless grinding used to produce taper is
   A) In-feed grinding B) Through feed grinding C) End feed grinding D) Any one of these

67. Thread grinding requires work speed from
   A) 1 to 3 m/min B) 5 to 10 m/min C) 10 to 14 m/min D) 14 to 20 m/min

68. The grinding wheel speed (surface speed in m/min) usually varies from
   A) 500 to 1000 B) 1000 to 1500 C) 1500 to 2000 D) 2000 to 2500

69. The in-feed grinding is used to
   A) Produce tapers B) Grind shoulders and formed surfaces
   C) Grind long, slender shafts or bars D) All of these

70. A grinding wheel is said to be of ________ if the abrasive grains can be easily dislodged.
   A) Soft grade B) Medium grade C) Hard grade D) None of these

71. Glazing in grinding wheels can be decreased by
   A) Using a harder wheel or by increasing the wheel speed
   B) Using a softer wheel or by decreasing the wheel speed
   C) Using a harder wheel or by decreasing the wheel speed
   D) Using a softer wheel or by increasing the wheel speed

72. In centreless grinding, the surface speed of regulating wheel is
   A) 5 to 15 m/min B) 15 to 60 m/min C) 60 to 90 m/min D) 90 to 120 m/min
73. The hard grade grinding wheels are denoted by the letters
   A) A to H      B) I to P      C) Q to Z      D) A to P

74. A fine grained grinding wheel is used to grind
   A) Hard and brittle materials  B) Soft and ductile materials
   C) Hard and ductile materials  D) Soft and brittle materials

75. A grinding wheel is said to be of _______ if it holds the abrasive grains more securely.
   A) Soft grade      B) Medium grade    C) Hard grade      D) None of these

76. The grinding of long, slender shafts or bars is usually done by
   A) In-feed grinding    B) Through feed grinding   C) End-feed grinding    D) Any one of these

77. The example of snag grinding is
   A) Trimming the surface left by sprues and risers on castings
   B) Grinding the parting line left on castings
   C) Removing flash on forgings
   D) All of these

78. Crack in grinding wheel is developed due to
   A) High temperature developed at the contact of the wheel face and work
   B) Grinding hard work
   C) Low speed of wheel
   D) High speed of wheel

79. In centerless grinders, the regulating wheel is inclined at
   A) 0° to 8°      B) 9° to 15°      C) 16° to 20°      D) 21° to 25°

80. Which of the following statement is correct regarding grinding of high carbon steel?
   A) Grinding at high speed results in the reduction of chip thickness and cutting forces per grit
   B) Aluminium oxide wheels are employed
   C) The grinding wheel has to be of open structure
   D) All of the above

81. The grain size of a grinding wheel is indicated by numbers, which range of grain size referred to as ‘Very Fine’?
   A) 10 – 24      B) 30 – 60      C) 80 – 180      D)220 - 600

82. While grinding and lapping cemented carbide tipped tool with diamond wheels a good flow of coolant should be
directed to cover the grinding zone, the coolant suitable is?
   A) Soluble oil      B) Mineral oil
   C) Sulphurised oil   D) Mixture of paraffin and water

83. It is commonly observed that the face of a grinding wheel becomes shiny and smooth or glazed after some use due
to one of the reasons stated below?
   A) Grade of wheel is too hard
   B) Abrasive of the wheel not suitable for the purpose
   C) Grain size is too coarse
   D) Structure of the wheel is too open

84. It is required to finish grind a dia 50mm hardened steel shaft on a cylindrical grinding machine, if the recommended
   surface speed of the work is 33 metres/minute, the rpm of the work is?
   A) 190      B) 150      C) 210      D) 250

85. The pattern on the work surface caused by the movement of the cutting tool is called?
   A) Waviness      B) Roughness      C) Surface texture      D) Lay

86. While machining cast iron coolant should be?
   A) Dry air      B) Kerosene      C) Machine oil      D) soft water
87. A steel work piece of height tensile strength is to be machined with a HSS milling cutter, which one of the following rake angles is best suited for the cutter?
A) 8°  B) 12°  C) 20°  D) 28°

88. A hole whose lower deviation is zero is called basic hole, which one of the following letters indicates basic hole?
A) E  B) F  C) G  D) H

89. The component of the surface texture upon which the roughness is superimposed is known as?
A) Surface roughness  B) Surface texture  C) Lay  D) Waviness

90. Why it is necessary to maintain an approach distance between the cutting tool and the work while working on shaping machine?
A) To cool down the cutting edge of the tool bit  B) To avoid any rigger at the end of work piece
C) To allow the chips to fall and clear the cutting edge  D) To enable the clapper box to return to cutting

91. A high carbon steel has to be forged, which colour indicates the most suitable forging temperature?
A) Yellow red  B) Dark cherry red  C) white  D) Light yellow

92. It is required to machine a single start worm of 2 module (m) and 60 mm pitch diameter, the speed ration is 40:1, to what length should the worm be cut?
A) 21 mm  B) 14.6 mm  C) 29.3 mm  D) 33.3 mm

93. The tensile strength of a metal is its ability to resist fracture when subjected to tensile loads, the tensile strength of metals are expressed in?
A) N/mm sq.  B) Kg/mm sq.  C) N. Metre  D) Kg. Metre

94. Which one of the following operations can be done on slotting machine?
A) External keyway on long shaft  B) Internal grooves
C) Woodruff keyway on a shaft  D) Keyway for feather keys

95. Zero setting of the two point bore dial gauge before the measurement is necessary to?
A) Account for the errors in the gauge  B) Facilitate comparison
C) Setup initial pressure in the gauge  D) Eliminate inaccuracy of the measurement

96. Dressing and turning of a grinding wheel are?
A) Exactly the same operation  B) Done with the same equipment
C) Done only for coarse grinding wheels  D) Only for form grinding

97. The web of twist drill, due to repeated grinding causes resistance to feeding while drilling a 12 mm diameter hole, the above effect is reduced by providing?
A) Negative rake of web  B) Thinning of web
C) Less feeding force  D) More feeding force

98. While grinding one must use
A) Dark glass screen  B) B mask  C) safety goggles  D) Sun goggles

99. The best way of avoiding accident is by
A) Doing work in accident way  B) Doing work in one’s own way
C) Observing safety rules related to job, machine and work place  D) Using safety equipment

100. What is a built up edge in respect of a turning tool?
A) Job material embedded on tool edge  B) A carbide tip soldered on a tool shank
C) A method of reconditioning worn out cutting tool edge  D) A tool cutting edge with a crater on it