

Quiz

- 1) Which style of machining center is the most popular?
 A) C-frame style vertical C) Bridge-style vertical
 B) Knee-style vertical D) Horizontal
- 2) Specify the correct axis for each moving component below (C-frame style vertical machining center).
 a) ____ Table motion in/out
 b) ____ Headstock motion up/down
 c) ____ Table motion left/right
- 3) Specify the correct axis and polarity for each tool motion below (C-frame style vertical machining center).
 a) ____ Tool motion left
 b) ____ Tool motion away from you
 c) ____ Tool motion down
- 4) Provide the CNC word or command needed to activate the following:
 a) Start spindle (fwd) at 300 rpm: _____
 b) Start spindle (reverse) at 2,000 rpm: _____
 c) Stop spindle: _____
 d) Turn on the flood coolant: _____
 e) Turn off the coolant: _____
 f) Place tool station seven in spindle: _____
 g) Select inch mode: _____

Talk with experienced people in your company to learn more: Do your machining centers have more than one spindle range? If so, what are the cut-off points for each range? At what rpm does the spindle achieve maximum horsepower in each range? Do any of your machines have high pressure coolant systems? If so, what is the related M code? How many cutting tools can your machining centers hold?

Answers: 1: A, 2a: Y, 2b: Z, 2c: X, 3a: X-, 3b: Y+, 3c: Z-, 4a: S300 M03, 4b: S2000 M04, 4c: M05, 4d: M08, 4e: M09, 4f: T07 M06, 4g: G20

STOP! Do practice exercise number one at the end of this manual.