

Quiz

- 1) Which style of turning center is the most popular?
 A) Universal slant bed style C) Twin spindle
 B) Chucker style D) Gang style
- 2) Specify the correct axis letter for each moving component below (universal style slant bed turning center).
 a) _____ Diameter controlling axis
 b) _____ Length controlling axis
 c) _____ Rotation of the spindle (live tooling machines only)
- 3) Specify the correct axis letter and polarity for each tool motion below.
 a) _____ Tool motion bigger in diameter
 b) _____ Tool motion toward the chuck
- 4) Provide the CNC word or command needed to activate the following:
 a) Feedrate of 0.015 ipr: _____
 b) Feedrate of 50.0 mmpm : _____
 c) Stop spindle: _____
 d) Turn on the flood coolant: _____
 e) Turn off the coolant: _____
 f) Index to station number seven: _____
 g) Select inch mode: _____

Talk with experienced people in your company to learn more: Do your turning centers have more than one spindle range? If so, what are the speeds for each range? At what rpm does the spindle achieve maximum horsepower in each range? Do any of your machines have automatic doors? If so, what are the related M codes? How many cutting tools can your turning centers hold?

Answers: 1: A, 2a: X, 2b: Z, 2c: C, 3a: X+, 3b: Z-, 4a: G20 G99 F0.015, 4b: G21 G98 F50.0, 4c: M05, 4d: M08, 4e: M09, 4f: T0707, 4g: G20

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