Preface to Latest Edition (NSQF Level–4 Compliant)

Directorate General of Training (DGT) under the Ministry of Skill Development and Entrepreneurship (MSDE) is the apex body in the country as regards planning, formulating and prescribing norms, standards, procedures and guidelines in respect of various vocational training schemes of which Craftsmen Training Scheme (CTS) implemented in ITI's is the most important and wide-spread throughout the country. Prescribing well designed curriculum and putting in place appropriate assessment and certification procedure are among the vital aspects of vocational training.

Machinist (sector: Capital Goods and Manufacturing) is one among the most popular ITI designated trades and is of two-year duration. DGT issued latest revised version (version 2.0) of the syllabus. The main significant change has been that NSQF level for this trade has been revised from 5 to 4. The contents of the syllabus otherwise remain essentially the same as hitherto.

Thus, this book fully covers the latest syllabus related to trade theory subject in its easy-to-understand language supplemented by well-illustrated figures. Further to assist in self-test and thereby prepare well for the All-India Trade Test (CBT), each chapter is supplemented by an appropriate set of short Q – Ans. and MCQs with key.

- A set of 12 model papers (6 each for first and second year) inclusive of **all Multiple-Choice Questions given in three Sample Papers of Bharat Skills** on All India Annual Trade Test Pattern.

We do firmly believe and hope that this **3-in-1 volume** viz.,

1. **Trade Theory**
2. **Assignment (MCQs)**
3. **Model Papers (Solved) inclusive of all Multiple-Choice Questions given in three Sample Papers of Bharat Skills for Annual A.I.T.T. Exam (CBT)**

will be of great help to trainees to learn and understand theory subject of Machinist trade and prepare for the All India trade test with confidence

We sincerely hope that trainees will find this book very much helpful to adjust with the latest change in syllabus related to Machinist trade. We would welcome suggestions for further improvement of this book in its subsequent editions.

— Authors

Contents

NSQF (Level-4) Compliant Competency based Curriculum for Machinist (Latest Syllabus - 1200 Hrs.) ..... (ix–xii)

1st Year

1. Occupational Health and Safety 3–16

Job Role of a Machinist; Maintaining Discipline in ITI; General Workshop Safety; Personal Protective Equipment; Response to Emergency; Fire Extinguishers; Safety Signs and Symbols; Electric Shock; Housekeeping; 5 S Concept; First Aid; Hot Work; Confined Space

***Assignment/Test—Solved* 13–16**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

2. Marking and Marking Tools.....17–25

Purpose of Marking; Marking Media; Hints to be Noted while Marking; Equipment and Instruments; Marking Method; Testing Accuracy of 'V' Blocks; Precautions.

***Assignment/Test—Solved* 24–25**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

3. Hand Tools.....26–35

Points To be Noted While fixing a bench vice; Adjustment of Bench Vice Height; Some other spanners; Size and Identification of Spanners; Defects in spanners; Pliers.

***Assignment/Test—Solved* 30–35**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

4. Measurement and Measuring Tools 36–58

System of Units; International System of Units (SI); Conversion of Metric and British system of uniTs; Straight Edge; Methods Of Removing Zero Error; Digital Height Gauge; Vernier Depth Gauge; Vernier Bevel Protractor; Tool Maker's Microscope; Optical Comparator; Measuring Errors.

***Assignment/Test—Solved* 52–58**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

5. Cutting Tools and Operations.....59–93

Grades; Filing; Filing Techniques; File Handle; Hacksaw; Chisel; Chipping Operation; grinding of chisel; Method of Chipping; Scraper; Method of Scraping on Flat Surface; Sharpening a Flat Scraper; Drilling; Drilling operations; Reaming; Emery Paper; Boring; Hand Taps; Tap Wrench; Precautions; Threading Dies; Die Stock; Blank Size for Threading with Die; Grinding; Speed of Grinding Wheel; Grinding Machines.metals and non-metals.

***Assignment/Test—Solved* 81–93**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

6. Limits, Fits and Tolerance 94–109

Mass production, Interchangeability, Clearance Fit, Allowance, Symbols, Some Important Examples.

***Assignment/Test—Solved* 103–109**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

7. Drilling and Reaming 110–120

Drilling, Drilling Machine, Drilling operations, Reaming

***Assignment/Test—Solved* 116–120**

- *Short Q.-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

8. Lathe 121–153

Parts of Lathe; Specification of a Lathe; Methods for Changing Speed of a Lathe; Cutting Tools; Tool Angles; Effects of Wrong Tool Grinding; Tool Setting on Lathe; Cutting Tool Materials; Lathe Operations; Thread Cutting; Methods of Catching the Thread; Cutting Speed, Feed and Depth of Cut; Parting Off; Rate of Metal Removal; Safety Precautions.

***Assignment/Test—Solved* 137–153**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

9. Cutting Tools 154–161

Cutting Tool Materials, Tipped Tools, Stable and Unstable Materials, Cutting Speed, Feed and Depth of Cut cor Shaping, Cutting Time

***Assignment/Test—Solved* .....160 –161**

- *Short Q.-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

10. Slotter 162–169

Types of Slotting Machines; Parts of A Slotting Machine; Slotter Size; Ram Drive Mechanism; Quick Return Mechanism of A Slotter; Feed Mechanism of A Slotter; Work Holding Devices; Slotter Tools; Slotter Operations; Cutting Speed Feed and Depth of Cut.

***Assignment/Test—Solved* 166–169**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

11. Shaper 170–184

Operation; Uses; Main Parts of A Shaper; Specification of A Shaper; Types of Shapers; Shaper Mechanism; Changing The Stroke; Shaper Feed Mechanism; Cutting Speed, Feed And

Depth of Cut; Cutting Time; Shaper Tools; Shaper Operations; Work-holding Devices.

Assignment/Test—Solved **.....179–184**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

12. Planer 185–192

Types of Planers; Size of A Planer; Parts of A Planer; Work Holding Devices; Planer Operations; Planer Tools; Quick Return Mechanism For Planer Table; Feeding Mechanism; Hydraulic Mechanism; Shaper Vs Planer; Cutting Speed, Feed And Depth of Cut; Safety on The Planer.

Assignment/Test—Solved **.....190–192**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

13. Lubricants and Coolants 193–198

Lubrication; Lubricants; Lubrication Methods; Coolant (Cutting Fluid) ; Degradation of Cutting Fluid

Assignment/Test—Solved **.....195–198**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

14. Milling.....199–229

Types of Milling Machines; Specifications of a Milling Machine; Parts of Milling Machine; Work Holding Devices; Milling Cutters; Standard Milling Cutters; Cutting Principle; Milling Methods; Milling Machine Operations; Cutting Speed; Milling Feed; Indexing; Methods of Indexing; Dividing Head; Gear and Gear Cutting; Calculation for Milling Helical Gear; Safety with Milling Machine; Helix and spiral Milling, Cutting of Helix or Spiral, Determination of helix angle, Direction for Swivelling the table, Cams and Cam Milling, Terms of Cams, Manufacturing of Cam.

Assignment/Test—Solved **.....215–229**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

15. Jigs and Fixtures.....230–238

JIG, Elements of a Jig, Fixture, Locating and Supporting in Jigs and Fixtures, Construction of Jigs and Fixtures, Fitting of Bushings, Materials for Jigs and Fixtures, Lathe Fixtures

Assignment/Test—Solved **.....234–238**

- *Short Q.-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

16. Metals 239–248

Metal, Properties Defined, Properties of Metals, Magnetic Properties, Types of Steels, Alloying Elements and their Influence on the Properties of Steel, Non-ferrous Metals, Non-ferrous Alloys, Non-metals, Identification of Metals

Assignment/Test—Solved **.....245–248**

- *Short Q.-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

17. Heat Treatment 249–258

Annealing; Normalising; Hardening; Tempering; Case Hardening; Age Hardening; Heat Treatment of Cutting Tools; Heat Treating of Alloy Steels; Heat Treating of Cast Iron; Furnaces For Heat Treatment; Measurement of Furnace Temperature; Heat Treatment of Non-ferrous Metals; Safety Precautions; Hardness Testing; Impact Testing.

Assignment/Test—Solved **.....254–258**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

18. Taper Turning 259–267

Brown and Sharpe Taper, Morse Taper, Jacobs Taper, Jarno Taper, Taper Turning, Categories of Taper Turning, Checking Taper, Form Tools

Assignment/Test—Solved **.....266–267**

- *Short Q.-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

19. Screw Threads and Thread Cutting 268–281

Screw Thread, Thread Measurement, Measurement of Effective Diameter

Assignment/Test—Solved **.....277–281**

- *Short Q.-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

20. Grinding 282–294

Grinding; Grinding Machines; safety in grinding operation; Grinding Wheel; Bonds; Grade; Shape; Specification of Grinding Wheel; Standard Grinding Wheel Marking System; Selection of Grinding Wheel; 1. Constant Factors 2. Variable Factors; Loading and Glazing; Truing and Dressing; Mounting a Wheel; Balancing of Grinding Wheel; Speed of Grinding Wheel; Feed; Bench Grinder; Pedestal Grinder; Portable Grinder; Flexible Shaft Grinder; Swing Frame Grinder; Surface Grinder; Cylindrical Grinder; Tool and Cutter Grinder; Wet and Dry Grinding; Work holding devices.

Assignment/Test—Solved **.....291–294**

- *Short Q-Ans. (Helpful in solving MCQs)*
- *Multiple Choice Questions*
- *Key to Multiple Choice Questions*

Appendix : 1st Year Model Papers 1 to 6 (A.I.T.T. Exam (CBT) including Bharat Skills MCQs – NSQF Level – 4) 295–316

2nd Year

1. **Tools and Cutter Grinder.....3–12**

   Grinding Machines, Grinding, Tool and Cutter Grinder, Internal Grinding Attachment, CNC Tool and Cutter Grinder, Thread Grinding, Thread Grinding of Tap, Radius Grinder, Jig Grinder, Creep-feed Grinding, Gear Grinder, Grindability

   ***Assignment/Test—Solved* 11–12**

   - *Short Q.-Ans. (Helpful in solving MCQs)*
   - *Multiple Choice Questions*
   - *Key to Multiple Choice Questions*

2. **Surface Finish and Geometrical Tolerance 13–26**

   Some other finishings, Temporary Protectives, Geometrical Tolerance

   ***Assignment/Test—Solved* 19–26**

   - *Short Q.-Ans. (Helpful in solving MCQs)*
   - *Multiple Choice Questions*
   - *Key to Multiple Choice Questions*

3. **Gauges.....27–42**

   Limit Gauges and Fixed Gauges, Grade as per indian standard, Protector Slips, Angle Gauges, Sine Bar, Method of use, Types of Sine Bar, Bevel protractor, Small Hole Gauge, Toolmaker's Buttons

   ***Assignment/Test—Solved* 40–42**

   - *Short Q.-Ans. (Helpful in solving MCQs)*
   - *Multiple Choice Questions*
   - *Key to Multiple Choice Questions*

4. **Gears.....43–51**

   Helical Gears, Bevel gear, Rack, Rack calculations, Methods of producing rack on milling machine, Worm and Worm Wheel, Worm calculations, Worm wheel calculations

   ***Assignment/Test—Solved* 50–51**

   - *Short Q.-Ans. (Helpful in solving MCQs)*
   - *Multiple Choice Questions*
   - *Key to Multiple Choice Questions*

5. **Basic Electricity 52–77**

   Resistor Colour Coding, Electrical Conductors and Insulators, Electrical Circuits, Single Phase and Three Phase Supply, Transformer, Electrical Measuring Instruments , Short Circuit and Safety Devices, Switch, Fuse, Circuit Breaker, Electrical Symbols, Solenoid, Inductor, Electric Motor, AC Motors, DC Motors, Proximity Sensor, Ultrasonic Sensor, Optical Sensor, Potentiometers, LVDTs

   ***Assignment/Test—Solved* 75–77**

   - *Short Q.-Ans. (Helpful in solving MCQs)*
   - *Multiple Choice Questions*
   - *Key to Multiple Choice Questions*

6. **CNC Basics and Programming.....78–121**

   Numerical Control, CNC Technology, Axis Convention, Features of CNC Machines, CNC Lathe, CNC Milling Machine, CNC Turning Centres, Classification of CNC Systems, Power Supply for CNC Machines, Popular CNC Control Systems, CNC Control Motion, Important Terms Relating to CNC Machining, CNC Programming, Alphabetic & Special Character Address Codes, Verifying CNC Programs Safely, Running the First Workpiece, Making Good Parts, Running Production and Optimizing, Cutting Tools, Turning, Drilling, Machine and Tool Offsets, Milling, Automatic Tool Changer, Quick Change Tooling, Cutting Parameters, Tool Life, Tool Path, CNC Program – An Example, Fanuc CNC Program Code, CNC Milling Machine Program, CNC Simulation, Tool Layout, CNC Machine Problems, CNC Milling Machine Trouble Shooting, Maintenance of CNC Machines, Fixed or Canned Cycles, Taper Threading, Direct Numerical Control (DNC), CAM, CNC Safety Practices

   ***Assignment/Test—Solved* 119–121**

   - *Short Q.-Ans. (Helpful in solving MCQs)*
   - *Multiple Choice Questions*
   - *Key to Multiple Choice Questions*

7. **Technical English and Reporting 122–136**

   Process Chart, Activity Log, Cycle Time, Manufacturing Cost Estimate, Productivity

   ***Assignment/Test—Solved* 135–136**

   - *Short Q.-Ans. (Helpful in solving MCQs)*
   - *Multiple Choice Questions*
   - *Key to Multiple Choice Questions*

8. **Machine Maintenance.....137–145**

   Routine Maintenance, Breakdown Maintenance / Corrective Maintenance, Preventive Maintenance, Predictive Maintenance, Zero - Hour Maintenance, Periodic Maintenance, Total Productive Maintenance

   ***Assignment/Test—Solved* 144–145**

   - *Short Q.-Ans. (Helpful in solving MCQs)*
   - *Multiple Choice Questions*
   - *Key to Multiple Choice Questions*

9. **CAMS 146–152**

   Methods of Manufacturing Camshaft, Applications of Cams

   ***Assignment/Test—Solved* 150–152**

   - *Short Q.-Ans. (Helpful in solving MCQs)*
   - *Multiple Choice Questions*
   - *Key to Multiple Choice Questions*

Appendix : 2nd Year Model Papers 1 to 6 (A.I.T.T. Exam (CBT) including Bharat Skills MCQs – NSQF Level – 4) 153–171