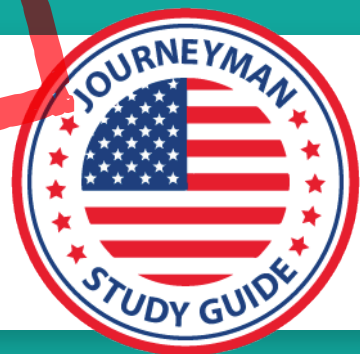


# JOURNEYMAN STUDY GUIDE MACHINIST

## YEAR 2

**SAMPLE**  
250 EXAM PREP QUESTIONS,  
WITH EXPLAINED ANSWERS



APPRENTICES | INSTRUCTORS | INSTITUTES

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UNITY CREST SOLUTIONS INC.

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— Jessica Taylor, Apprentice Ironworker

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1. *It's not easy:* Becoming a certified journeyman requires hard work, patience, and a real dedication to learning. This guide will help you navigate the complexity, but the journey itself requires you to commit to the process. At the end, you'll not only have earned your certification but also be in a stronger position for long-term success in your career.
2. *You will need to put in effort:* Our practice tests, questions, and explanations are incredibly useful, but they can only get you so far without your own effort. You need to engage with the material and be prepared to revisit concepts to fully understand them. This preparation will also help you manage test anxiety and give you the tools to stay focused and confident when exam day comes.
3. *It's hands-on:* While this guide provides the foundational knowledge and key concepts, your true growth comes from hands-on experience in the trade. This guide is designed to complement that experience and help you feel more prepared on the job. By understanding the 'why' behind the work, you'll find yourself better equipped for both the exam and your everyday trade responsibilities.

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# QUESTIONS



## **Year 2: Intermediate Machining Concepts**

### **Subject 3. CNC Machine Basics**

#### **1. What does CNC stand for?**

- a) Central Numeric Control
- b) Central Network Control
- c) Computer Network Control
- d) Computer Numeric Control

**Correct Answer: d) Computer Numeric Control**

**Explanation:** CNC stands for Computer Numeric Control. It refers to the automated control of machining tools and 3D printers by means of a computer. CNC machines use coded instructions to perform tasks with high precision and repeatability, essential for modern manufacturing processes in various industries, including aerospace, automotive, and metalworking.

#### **2. What is G-code used for?**

- a) Material selection
- b) Safety protocols
- c) Machine calibration
- d) Toolpath programming

**Correct Answer: d) Toolpath programming**

**Explanation:** G-code is a language used to instruct CNC machines on how to move and operate. It defines specific actions, such as movement along axes, tool speeds, and other machining parameters. Understanding G-code is crucial for machinists, as it enables them to create precise toolpaths for machining parts accurately.

#### **3. What does M-code control?**

- a) Material types
- b) Safety measures
- c) Tool speeds
- d) Machine functions

**Correct Answer: d) Machine functions**

**Explanation:** M-code, or Miscellaneous Code, is a set of commands that control various functions of a CNC machine beyond just movement. These codes can include commands for starting and stopping the spindle, coolant control, and tool changes. Knowing M-codes is essential for machinists to optimize machine operations and enhance workflow efficiency.



**4. What is the primary function of a CNC machine?**

- a) Reduce machine efficiency
- b) Increase human labor
- c) Manual tool operation
- d) Automate machining processes

**Correct Answer: d) Automate machining processes**

**Explanation:** The primary function of a CNC machine is to automate machining processes, allowing for consistent, precise, and efficient production of parts. By using programmed instructions, CNC machines can perform complex cuts and operations that would be challenging or impossible to do manually, thus improving productivity in modern manufacturing environments.

**5. Which tool is essential for CNC setup?**

- a) Wrench
- b) Hammer
- c) Screwdriver
- d) Calipers

**Correct Answer: d) Calipers**

**Explanation:** Calipers are essential tools for CNC setup because they allow machinists to measure dimensions accurately. Precise measurements are critical for ensuring that the parts produced meet specifications. During the setup phase, calipers help ensure that tools and workpieces are correctly aligned and that tolerances are maintained throughout the machining process.

**6. What unit measures CNC machine speed?**

- a) ft/sec
- b) gal per hour
- c) inches per minute
- d) mi per hour

**Correct Answer: c) inches per minute**

**Explanation:** CNC machine speed is typically measured in inches per minute (IPM), which indicates how fast the machine can move the cutting tool across the workpiece. This measurement is crucial for determining the efficiency of the machining process and ensuring that the machine operates within optimal parameters to produce quality parts without damaging the material.



**7. What is the purpose of toolpath generation?**

- a) Determine part dimensions
- b) Create material inventory
- c) Optimize safety procedures
- d) Define machine movement

**Correct Answer: d) Define machine movement**

**Explanation:** The purpose of toolpath generation is to define the movement of the cutting tool along the workpiece to achieve the desired shape and features. This process is critical in CNC programming, as it determines how effectively and efficiently the machine will remove material, ultimately influencing the quality of the finished part and operational efficiency.

**8. What does "zero point" refer to?**

- a) Tool diameter
- b) Reference position
- c) Cutting speed
- d) Workpiece material

**Correct Answer: b) Reference position**

**Explanation:** The "zero point" refers to the reference position in CNC machining, where the machine considers the starting point for all movements. Establishing a zero point is crucial for accurate machining, as it helps ensure that the toolpath is correctly aligned with the workpiece. This reference point allows for consistent part production and minimizes errors in machining.

**9. Which code initiates a tool change?**

- a) G00
- b) M06
- c) M03
- d) G20

**Correct Answer: b) M06**

**Explanation:** The M06 code is used to initiate a tool change in CNC programming. This command tells the machine to stop its current operation, change the tool, and prepare for the next machining phase. Understanding tool change commands is vital for machinists to maintain workflow efficiency and to ensure that the correct tools are used for various operations.



**10. What is the primary benefit of CNC machining?**

- a) Longer production times
- b) Increased manual labor
- c) Enhanced precision and repeatability
- d) Decreased material waste

**Correct Answer: c) Enhanced precision and repeatability**

**Explanation:** The primary benefit of CNC machining is enhanced precision and repeatability. CNC machines can produce parts with tight tolerances and consistent quality, which is essential for industries that require exact specifications, such as aerospace and medical. This technology reduces human error and ensures that parts are manufactured consistently, improving overall production efficiency.

**11. What does "feed rate" refer to in CNC?**

- a) Material feed size
- b) Tool change time
- c) Machine calibration
- d) Speed of tool movement

**Correct Answer: d) Speed of tool movement**

**Explanation:** In CNC machining, "feed rate" refers to the speed at which the cutting tool moves through the workpiece material. It is measured in units such as inches per minute (IPM) and is crucial for controlling the machining process. An appropriate feed rate helps achieve the desired surface finish and prevents tool wear or damage, ensuring optimal performance during machining.

**12. Which of the following is a CNC machine type?**

- a) Lathe
- b) Band saw
- c) Hammer
- d) Drill press

**Correct Answer: a) Lathe**

**Explanation:** A lathe is a type of CNC machine that rotates a workpiece against a cutting tool to create cylindrical parts. It is commonly used in various machining operations, such as turning, facing, and threading. Understanding different types of CNC machines, like lathes, helps machinists select the right equipment for specific tasks, optimizing productivity and precision.



**13. What does a CNC simulator do?**

- a) Analyzes material properties
- b) Measures tool wear
- c) Simulates machining operations
- d) Tests machine durability

**Correct Answer: c) Simulates machining operations**

**Explanation:** A CNC simulator is a software tool that allows machinists to simulate machining operations before running them on an actual machine. This helps in visualizing the toolpath, checking for potential collisions, and optimizing program parameters. By using a simulator, machinists can refine their programs, reduce the risk of errors, and enhance the efficiency of the machining process.

**14. Why is tool selection critical in CNC machining?**

- a) Determines material waste
- b) All of the above
- c) Impacts surface finish
- d) Affects production speed

**Correct Answer: b) All of the above**

**Explanation:** Tool selection is critical in CNC machining because it directly affects production speed, surface finish, and material waste. The right tool must be chosen based on the material being machined, the desired finish, and the complexity of the part. Proper tool selection ensures optimal performance, enhances the quality of the finished product, and minimizes costs associated with machining.

**15. What is the role of coolant in CNC machining?**

- a) Clean the work area
- b) Lubricate moving parts
- c) Increase machine speed
- d) Reduce tool wear and heat

**Correct Answer: d) Reduce tool wear and heat**

**Explanation:** The role of coolant in CNC machining is to reduce tool wear and heat generated during the cutting process. Coolant helps maintain optimal temperatures, preventing overheating that can damage both the tool and the workpiece. Additionally, it aids in chip removal, improving surface finish and extending tool life, which is critical for maintaining productivity and reducing operational costs.



**16. What does spindle speed control?**

- a) Program execution
- b) Material feed rate
- c) Tool rotation speed
- d) Machine power

**Correct Answer: c) Tool rotation speed**

**Explanation:** Spindle speed controls the rotation speed of the cutting tool on a CNC machine. It is a crucial parameter that influences the cutting process, as different materials and operations require specific spindle speeds to achieve optimal results. Proper spindle speed ensures effective material removal, enhances surface finish, and prolongs tool life, making it a vital aspect of CNC machining.

**17. What is the function of a CNC controller?**

- a) Monitor machine temperature
- b) Interpret G-code commands
- c) Control material feed
- d) Power supply management

**Correct Answer: b) Interpret G-code commands**

**Explanation:** The function of a CNC controller is to interpret G-code commands and translate them into precise movements of the machine's axes. This controller serves as the brain of the CNC system, processing the programmed instructions and managing the machine's operations, ensuring that the tool follows the designated path accurately to produce the desired part.

**18. What should be done before starting a CNC machine?**

- a) Adjust feed rate
- b) Program G-code
- c) Change coolant
- d) Inspect tools and workpiece

**Correct Answer: d) Inspect tools and workpiece**

**Explanation:** Before starting a CNC machine, it is essential to inspect both the tools and the workpiece to ensure they are in good condition and properly secured. This step helps prevent machining errors, tool breakage, and damage to the workpiece. A thorough inspection contributes to the overall safety and efficiency of the machining process, leading to higher-quality finished parts.



**19. What does a tool holder do?**

- a) Measures dimensions
- b) Holds the cutting tool
- c) Adjusts feed rate
- d) Stabilizes the workpiece

**Correct Answer: b) Holds the cutting tool**

**Explanation:** A tool holder is a device that securely holds the cutting tool in place during machining operations. It ensures that the tool is properly mounted and aligned with the workpiece, which is critical for accurate machining. Using the correct tool holder not only improves cutting precision but also enhances tool performance and safety during operations.

**20. What is the purpose of probing in CNC?**

- a) Change tools
- b) Clean the machine
- c) Measure part dimensions
- d) Adjust spindle speed

**Correct Answer: c) Measure part dimensions**

**Explanation:** The purpose of probing in CNC machining is to measure part dimensions and verify the workpiece's position and orientation. Probing systems can identify features on the part, ensuring that it aligns correctly with the machine's toolpath. This helps maintain high precision and quality in part production, reducing errors and enhancing workflow efficiency.

**21. What does a CNC program consist of?**

- a) Tool selection only
- b) Only G-code
- c) Workpiece dimensions only
- d) G-code and M-code

**Correct Answer: d) G-code and M-code**

**Explanation:** A CNC program consists of both G-code and M-code, which together instruct the CNC machine on how to perform machining operations. G-code specifies the tool movements and paths, while M-code controls auxiliary functions such as tool changes, coolant control, and spindle operations. A well-structured CNC program is crucial for achieving desired machining outcomes effectively.



**22. What is the advantage of using CAD/CAM?**

- a) Increased material waste
- b) Faster manual processes
- c) Enhanced design accuracy
- d) Longer setup times

**Correct Answer: c) Enhanced design accuracy**

**Explanation:** The advantage of using CAD/CAM (Computer-Aided Design and Computer-Aided Manufacturing) is enhanced design accuracy. CAD software allows machinists to create detailed digital models of parts, while CAM software translates these designs into CNC programs. This integration improves precision, reduces errors during machining, and streamlines the overall manufacturing process, leading to higher quality and efficiency in production.

**23. What does "tool offset" refer to?**

- a) Tool wear adjustment
- b) Machine calibration
- c) Workpiece material type
- d) Operator skill level

**Correct Answer: a) Tool wear adjustment**

**Explanation:** "Tool offset" refers to the adjustments made to account for tool wear or differences in tool lengths when machining. This ensures that the CNC machine accurately compensates for these variations to maintain precision in part production. Properly managing tool offsets is essential for achieving consistent results and maintaining high-quality standards in machining operations.

**24. What is backlash in CNC machines?**

- a) Cooling issue
- b) Material defect
- c) Movement error
- d) Tool wear

**Correct Answer: c) Movement error**

**Explanation:** Backlash in CNC machines refers to the movement error that occurs when the machine changes direction. It is caused by gaps or play in the mechanical components, leading to inaccuracies in positioning. Understanding and minimizing backlash is crucial for ensuring precise machining operations, as it can significantly affect part quality and dimensional accuracy.



**25. What is the main advantage of CNC over manual machining?**

- a) Higher precision and efficiency
- b) Increased labor costs
- c) Slower production rates
- d) More operator involvement

**Correct Answer: a) Higher precision and efficiency**

**Explanation:** The main advantage of CNC over manual machining is higher precision and efficiency. CNC machines can perform complex tasks with consistent accuracy, reducing human error and increasing production speeds. This automation allows for the rapid production of parts while maintaining quality standards, making CNC machining a preferred choice in modern manufacturing environments.



Subject - 1

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## About the Creators:

### Bobby Bedi:

Bobby Bedi, co-creator of the Journeyman Study Guide, calls the Pacific Northwest home, where he has built an extensive career spanning more than two decades. His diverse background, which includes architecture, digital innovation, and industrial marketing, has given him a unique ability to bridge traditional industries with cutting-edge digital solutions. Bobby has worked across a spectrum of industries, from agile startups to publicly traded companies and educational platforms, bringing a depth of experience that has been crucial to the platform's success.

Bobby's precision and problem-solving skills, refined through his years in architecture, have seamlessly transitioned into his work in digital marketing and technology. Since 2006, Bobby has been at the forefront of digital innovation, applying his expertise to transform trade education. He has been instrumental in developing cutting-edge, user-friendly platforms that make learning accessible across the globe, combining technology with education to create impactful online experiences.

As co-creator of the platform, Bobby also plays a key role in the industrial sector, where he helps companies scale by leveraging his expertise in digital marketing and business strategy. His dedication to making education affordable and impactful has driven the growth of the Journeyman Study Guide, ensuring that individuals at every stage of their careers have access to quality learning tools.

### Kris McFarlane:

Kris McFarlane, co-creator of the Journeyman Study Guide, has over two decades of experience in business development, education, and the trades. Based in the Pacific Northwest, Kris has worked with a range of organizations—from agile startups to publicly traded companies—driving business growth and developing successful strategies across industries. His expertise in scaling businesses and creating educational platforms has been key to the guide's reach and effectiveness.

Kris's deep roots in the trades and industrial sector, paired with his extensive experience in business development, give him a unique ability to understand both the practical and strategic needs of companies and individuals. His leadership and ability to mentor others have helped shape the platform, making it a go-to resource for tradespeople seeking career advancement and certification.

Having struggled with traditional education early in life, Kris understands the importance of making learning accessible for everyone. His passion for empowering others, especially those who feel underserved by conventional education systems, is reflected in every aspect of the Journeyman Study Guide. Kris's work is driven by a commitment to helping aspiring tradespeople succeed in their careers through affordable, practical, and accessible learning resources.

## Work with the Creators

As co-creators of the Journeyman Study Guide, Bobby Bedi and Kris McFarlane draw from extensive experience working with agile startups, publicly traded companies, and education platforms. Their combined expertise has shaped a platform that empowers businesses and individuals alike. To learn more or explore opportunities with the *Unity Crest Solutions team*, visit [UnityCrestSolutions.com](https://UnityCrestSolutions.com), where they continue to help organizations and people succeed.



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## What's Inside:

- **Detailed Overviews** of potential exam formats and key concepts.
- **Practical Tips** for effective study habits and exam strategies.
- **Practice Questions** to test your knowledge and sharpen your skills.

## Tailored to Your Needs:

Our guide is specifically designed for a variety of trades across all Canadian provinces, ensuring you receive the most relevant and comprehensive information possible.

## Testimonials:

"As an apprentice, the Journeyman Study Guide made complex topics manageable, boosting my confidence, income and career." - Emily Tran, Apprentice Carpenter

"Adapting to Canadian standards was really hard, but the guide bridged the gap between my previous experiences and Canadian requirements." - Ahmed Al-Sayed, Plumber, originally from Egypt

"As an instructor, I find the Journeyman Study Guide aligns well with the curriculum and significantly aids my students." - Derek Smith, Welding Instructor

## A Companion, Not a Substitute:

Remember, the Journeyman Study Guide is a tool to complement your study regimen. For optimal results, use this guide in conjunction with the latest official materials issued by government authorities.

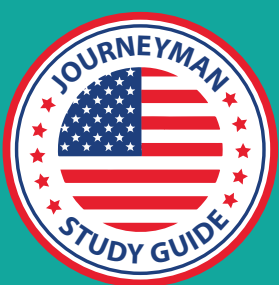
## Are You Ready to Take the Next Step?

With the Journeyman Study Guide in hand, you are well-equipped to tackle the challenges of the exam and step confidently into your career as a certified tradesperson.

**Join thousands of successful tradespeople who have advanced their careers with our guide.**

**Your journey to becoming Journeyman certified starts here!**

**Visit us at [JourneymanStudyGuide.com](http://JourneymanStudyGuide.com) today.**



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