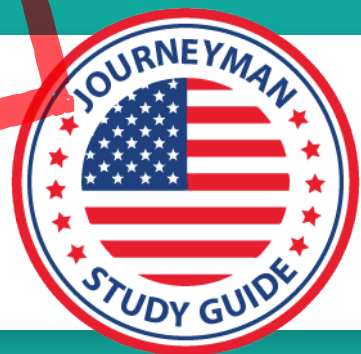


JOURNEYMAN STUDY GUIDE 3D PRINTING & ADDITIVE MANUFACTURING

YEAR 2

SAMPLE
250 EXAM PREP QUESTIONS,
WITH EXPLAINED ANSWERS



APPRENTICES | INSTRUCTORS | INSTITUTES

JourneymanStudyGuide.com

UNITY CREST SOLUTIONS INC.

Who Is Journeyman Study Guide For?

Welcome to *Journeyman Study Guide*—your key to unlocking success in your trade, earning the recognition you deserve, and building a solid career in America. Whether you're an apprentice just starting out, a seasoned professional, or someone new to the country and adjusting to U.S. trade standards, this guide is designed to complement your learning and support you along the way. While it provides valuable insights and resources, it's not a substitute for official materials required for certification.

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1. *Apprentices*: Looking to kickstart your career? Our study guides and practice tests will help you build the foundational skills you need to succeed.
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SNOW STUDS QUEST



Year 2: 3D Printing & Additive Manufacturing

Subject 3: Troubleshooting and Quality Control

1. What causes warping in 3D prints?

- a) Bed temperature too low
- b) Printer running too slow
- c) Filament too thick
- d) Cooling too quickly

Correct Answer: d) Cooling too quickly

Explanation: Warping occurs when the material cools unevenly, causing it to contract and pull away from the print bed. This is often exacerbated by low bed temperatures, which do not properly adhere the first layers of the print to the surface, leading to a loss of adhesion and subsequent warping.

2. How to reduce stringing in prints?

- a) Use more filament
- b) Decrease bed adhesion
- c) Increase printing speed
- d) Lower temperature settings

Correct Answer: d) Lower temperature settings

Explanation: Stringing happens when excess filament oozes from the nozzle while moving between printed areas. Lowering the nozzle temperature can reduce this effect by ensuring the filament remains less fluid, reducing the tendency to drip and creating cleaner transitions between printed sections.

3. What improves layer adhesion in 3D printing?

- a) Correct nozzle temperature
- b) Higher print speed
- c) Uneven layer height
- d) Lower filament quality

Correct Answer: a) Correct nozzle temperature

Explanation: Proper nozzle temperature is crucial for ensuring good layer adhesion. If the temperature is too low, the filament won't melt adequately, leading to poor bonding between layers. Conversely, if it's too high, it can cause oozing or burning, negatively affecting the print quality.



4. Which setting affects print accuracy most?

- a) Nozzle shape
- b) Color of filament
- c) Layer height
- d) Print speed

Correct Answer: c) Layer height

Explanation: Layer height significantly impacts print accuracy because it determines the thickness of each layer applied during the printing process. Thinner layers generally result in finer details and smoother finishes, whereas thicker layers can lead to a loss of detail and accuracy in the print.

5. What role does bed leveling play in printing?

- a) Reduces filament cost
- b) Increases print speed
- c) Prevents overheating
- d) Ensures uniform first layer

Correct Answer: d) Ensures uniform first layer

Explanation: Proper bed leveling is essential for a successful print, as it ensures that the nozzle is at the correct distance from the print bed across the entire surface. This uniformity allows for even adhesion of the first layer, which is critical for the overall success and quality of the print.

6. What is the main cause of under-extrusion?

- a) High filament quality
- b) Fast print speed
- c) Clogged nozzle
- d) Excessive temperature

Correct Answer: c) Clogged nozzle

Explanation: Under-extrusion often occurs when there is a blockage in the nozzle that prevents the filament from being pushed through properly. This can result in gaps or weak areas in the print, leading to structural issues. Regular cleaning and maintenance of the nozzle can help prevent this problem.



7. How can you improve print consistency?

- a) Regularly calibrate printer
- b) Change printing location
- c) Increase print speed
- d) Use varying filament brands

Correct Answer: a) Regularly calibrate printer

Explanation: Regular calibration of the 3D printer is vital for maintaining print consistency. This includes checking and adjusting the bed level, nozzle height, and extrusion settings, which ensures that each print will have the same quality and characteristics, leading to a reliable output over time.

8. What is a common fix for layer separation?

- a) Increase filament temperature
- b) Reduce print speed
- c) Use lower quality filament
- d) Increase bed temperature

Correct Answer: a) Increase filament temperature

Explanation: Layer separation can often be resolved by increasing the filament temperature, which improves adhesion between layers. When the temperature is too low, layers may not bond sufficiently, resulting in weak prints. Ensuring that the temperature is set correctly can greatly enhance the strength of the final product.

9. What tool helps with printer calibration?

- a) Print bed
- b) Cooling fan
- c) Calipers
- d) Filament

Correct Answer: c) Calipers

Explanation: Calipers are essential tools for accurately measuring dimensions and ensuring that parts of the printer, such as the nozzle height or bed level, are calibrated correctly. Proper measurements lead to improved accuracy in prints and help to maintain consistency in future projects.



10. What is a benefit of using a heated bed?

- a) Lower filament costs
- b) Faster print speeds
- c) Better adhesion
- d) Nozzle cooling

Correct Answer: c) Better adhesion

Explanation: A heated bed helps in maintaining consistent temperatures for the printed material, which promotes better adhesion of the first layers. This prevents warping and shifting as the material cools, ensuring that the print adheres well to the bed throughout the printing process.

11. What is the best way to avoid clogs?

- a) Increase printing height
- b) Decrease print speed
- c) Regular maintenance
- d) Use low-quality filament

Correct Answer: c) Regular maintenance

Explanation: Regular maintenance is essential to avoid clogs in the nozzle and ensure smooth extrusion of filament. This includes cleaning the nozzle, checking for wear, and ensuring that the filament is dry and of good quality. Neglecting maintenance can lead to frequent printing issues and poor print quality.

12. How does print speed affect quality?

- a) Higher speed increases detail
- b) Speed reduces filament cost
- c) Speed has no effect
- d) Slower speed improves detail

Correct Answer: d) Slower speed improves detail

Explanation: Slower print speeds generally allow for more precise extrusion of filament, resulting in better detail and surface finish of the print. Faster speeds may cause issues like under-extrusion or misalignment, leading to a decrease in overall print quality.



13. What is the impact of filament moisture?

- a) Improves layer adhesion
- b) Causes bubbling and stringing
- c) Reduces print quality
- d) Increases print speed

Correct Answer: b) Causes bubbling and stringing

Explanation: Moisture in filament can lead to bubbling during extrusion, which causes irregularities like stringing and poor surface finish on prints. Filament should be stored in a dry environment to prevent moisture absorption and maintain optimal printing conditions for high-quality results.

14. What does retraction do in 3D printing?

- a) Decreases print speed
- b) Improves bed adhesion
- c) Increases filament cost
- d) Reduces stringing and oozing

Correct Answer: d) Reduces stringing and oozing

Explanation: Retraction is a process where the filament is pulled back into the nozzle during non-printing movements. This action helps to prevent excess filament from oozing out, which can lead to stringing and unsightly artifacts on the printed piece, ultimately improving the print's appearance.

15. What is the main purpose of a cooling fan?

- a) Helps solidify layers quickly
- b) Increases print speed
- c) Cools the nozzle
- d) Reduces filament cost

Correct Answer: a) Helps solidify layers quickly

Explanation: A cooling fan aids in the rapid solidification of printed layers, which is especially important for materials like PLA. This helps to prevent issues like warping and improves detail by ensuring that each layer retains its shape as the print progresses, leading to a higher-quality final product.



16. What is the effect of high ambient temperature?

- a) Lowers print speed
- b) Reduces stringing
- c) Increases warping risk
- d) Improves layer adhesion

Correct Answer: c) Increases warping risk

Explanation: High ambient temperatures can increase the risk of warping in 3D prints, especially for materials that are sensitive to temperature changes. Excessive heat can cause the print material to soften too quickly, leading to distortion and loss of shape as it cools unevenly.

17. Why calibrate your nozzle height?

- a) To enhance color quality
- b) To improve layer adhesion
- c) To increase print speed
- d) To save filament

Correct Answer: b) To improve layer adhesion

Explanation: Calibrating the nozzle height ensures that the nozzle is at the optimal distance from the print bed, allowing for better adhesion of the first layer. If the nozzle is too high, the filament won't stick properly; if too low, it can damage the bed and impede extrusion.

18. What material is commonly used for print beds?

- a) Aluminum
- b) Wood
- c) Plastic
- d) Rubber

Correct Answer: a) Aluminum

Explanation: Aluminum is a commonly used material for print beds due to its good thermal conductivity and rigidity. This allows for even heating across the surface, which helps to maintain a consistent temperature and improve the adhesion of prints, leading to higher quality results.



19. How can you minimize over-extrusion?

- a) Print with multiple colors
- b) Lower flow rate
- c) Use thicker filament
- d) Increase print speed

Correct Answer: b) Lower flow rate

Explanation: Over-extrusion can often be minimized by adjusting the flow rate settings on the printer. Lowering the flow rate allows for more controlled extrusion of filament, preventing excess material from being deposited on the print, which can lead to rough surfaces and imprecise details.

20. What is essential for successful 3D printing?

- a) Ignoring software updates
- b) Fast printing techniques
- c) Proper printer maintenance
- d) Using expensive materials

Correct Answer: c) Proper printer maintenance

Explanation: Successful 3D printing heavily relies on proper printer maintenance, including regular cleaning, calibration, and checks of mechanical components. Well-maintained printers have fewer issues and produce higher-quality prints consistently, ensuring reliability and reducing downtime during printing projects.

21. What should you do if prints warp?

- a) Decrease print speed
- b) Increase bed temperature
- c) Print with no cooling
- d) Use lower-quality filament

Correct Answer: b) Increase bed temperature

Explanation: Increasing the bed temperature can help reduce warping by keeping the material warm enough to adhere effectively during the printing process. This is particularly important for materials like ABS, which are more prone to warping due to their thermal properties, leading to higher-quality prints.



22. What type of filament is least prone to warping?

- a) ABS
- b) PLA
- c) Nylon
- d) PETG

Correct Answer: b) PLA

Explanation: PLA is generally the least prone to warping compared to other filaments like ABS or Nylon. This is due to its lower shrinkage rate when cooling, making it easier to adhere to the print bed and maintain shape during the printing process, resulting in more reliable prints.

23. What does a slicer do in 3D printing?

- a) Cools the printer
- b) Prepares the model for printing
- c) Cuts the filament
- d) Increases print speed

Correct Answer: b) Prepares the model for printing

Explanation: A slicer is software that converts a 3D model into instructions for a 3D printer. It translates the model into layers, determines the path for the nozzle, and generates G-code, which the printer uses to create the object layer by layer, ensuring accurate and efficient printing.

24. Why is bed adhesion important?

- a) Increases print speed
- b) Prevents overheating
- c) Reduces filament cost
- d) Ensures print stability

Correct Answer: d) Ensures print stability

Explanation: Bed adhesion is crucial for ensuring that the first layer of the print adheres firmly to the print bed. Proper adhesion prevents shifting or lifting during the print, which can lead to defects, misalignment, and ultimately failed prints. Good bed adhesion is foundational for successful 3D printing.



25. How often should you clean the nozzle?

- a) Monthly
- b) Every print
- c) Every few prints
- d) Never

Correct Answer: c) Every few prints

Explanation: It's advisable to clean the nozzle every few prints, especially when switching between different filament types or colors. Regular cleaning helps to prevent clogs and ensures consistent extrusion, which is essential for maintaining high-quality prints and prolonging the lifespan of the nozzle.



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, where they continue to help organizations and people succeed.



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