

## **NIMS CNC OPERATOR TEST Actual 2023 Questions and Answers with complete solution**

Given an 18 3/4" length of stock, how many 2 1/2" pieces can be cut from it?  
7.5 (18.75/2.5)

How often should you check the lubrication levels on a machine?

Daily

On a blueprint, what do you call a dimension in a box (boxed dimension)?

Base

When should you wear your safety glasses in the shop?

Always

What is the RPM formula for drilling?

What is the code for rapid traverse?

G00

What is the code for linear feed (must have an F word with it)?

G01

Q. What is the code for program stop?

M00

What is the code for optional stop?

M01

What is the code for program end rewind?

M30

What is the code for zero return?

G28

What is the code for constant surface speed (SFM)?

What is the code for fixture offset (work offset #1)?

What is the code for incremental positioning?

G91

What is the code for absolute positioning?

G90

What is the code for inch mode?

G20

What is the code for metric mode?

G21

What is the code for tool change ON THE MILL?

What is the code for spindle activation clockwise OR FORWARD?

M03

What mode would you select for changing a tool on a mill or lathe?

M06

What is the difference between the 1.384 dimension and the .945 dimension?

What screen gives you the information for height offset value?

What mode on a CNC milling center would you select to send the machine home?

G28

# Nims 702a Test Answers

**J Elliott**

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