

## Answers to Quiz

- 1      0.001 mm = one micron
- 2      X0.712
- 3      3a - G21      3b - G91      3c - G90      3d - G20
- 4      X axis in turning typically specifies an input of a diameter dimension.
- 5      Feedrate is measured in **mm/rev** or **in/rev**, depending on the units selected (Metric or English).
- 6      Metric mode - the minimum motion of 0.001 is smaller than 0.0001 inch (0.0001 inch = 0.00254 mm).
- 7      **IPM** or **ipm** means **inches per minute**.
- 8      The **W** address on a Fanuc CNC lathe means an incremental motion along the Z axis.
- 9      Absolute dimensions are always measured from the part zero, along X, Y and Z axes.
- 10     Incremental dimensions are always measured from the last point, along X, Y and Z axes.
- 11     G91 is the common default mode, because it is safer - it forces programming of G90 in the program.
- 12     For milling ..... :    X, Y, Z, I, J, K, A, B, C, Q, R
- 13     For turning ..... :    X, Z, U, W, I, K, R, C, E, F
- 14     Definitely NOT! Mixing G21 (metric) and G20 (English) can be dangerous, since not every control converts all data.
- 15     It is used in turning operations to identify an incremental motion along the X axis.
- 16     The minimum motion increment in English units is 0.0001 inch in any axis.
- 17     The modes **not** using decimal point are: Full address format, Leading zero suppression and Trailing zero suppression.
- 18     Z1000 in metric units - using leading zero suppression - is equivalent to Z1.0 (1 mm).
- 19     Calculator input allows whole numbers without decimal point to be used, i.e., Y45 is the same as Y45.0.
- 20     The abbreviation FPM means **feet per minute**, meaning surface speed designation (also known as SFPM).