

QUESTION 11: CENTER CUTS

- 11.1 Give a brief description of how the following center cuts work:
 - 11.1.1 Area or thread-in method (2)
 - 11.1.2 Drop method (2)
 - 11.2 Explain in your own words, TWO advantages (numbering them 11.2.1 and 11.2.2) and TWO disadvantages (numbering them 11.2.3 and 11.2.4) of the use of the lockless advance method when tap turning. (4)
 - 11.3 Name the TWO types of wire wheels used when working with long work pieces in a lathe. (2)
 - 11.4 State THREE factors which must be taken into account when programming a CNC lathe. (3)
 - 11.5 A taper of 7° to 100 mm is to be turned on a work piece, 100 mm long. Calculate the amount of lathe tool advance required. (2)
 - 11.6 A round shaft with a mean diameter of 50 mm must be provided with a three-start square thread with a 7 mm pitch. Calculate the lead angle of the thread. (2)
- (20)**

QUESTION 12: MILLING MACHINES AND MACHINING OPERATIONS

- 12.1 Identify the milling cutter types in FIGURE 4 on the attached spreadsheet (sheet 2) with the greatest mark in the question number (12.1.1 - 12.1.4) in the indicated blocks. (4)
 - 12.2 Name THREE factors used to perform milling operations. (3)
 - 12.3 State THREE possible factors which cause the loading of a grinding wheel. (3)
 - 12.4 Calculate the speed of the milling machine spindle in revolutions per minute. The cutter diameter is 50 mm and the cutting speed is 30 meters per minute. (2)
 - 12.5 State TWO advantages (12.5.1 and 12.5.2) and TWO disadvantages (12.5.3 and 12.5.4) of planar milling. (4)
 - 12.6 Give THREE reasons why it is more desirable to use a helical cutter with round teeth. (3)
- (20)**
- TOTAL SECTION B** (40)
GRAND TOTAL (100)

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FITTING AND MACHINING THEORY N2 (11022032) 17 November 2016 (X-Paper) 09:00-12:00 Calculators may be used. Candidates will require drawing instruments. This question paper consists of 9 pages and 1 formula sheet.

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PAST EXAM PAPER & MEMO N2

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