

An important basic skill of both *CNC Programmer* and *CNC Operator* is to master the control system of the CNC machine. The objective of these general questions is to review some important features of a typical control system.

#	Question	Answer
1	Describe the purpose of a CNC machine control system	
2	Name the two work panels located on a typical CNC machine	
3	What is the common name for the Manual Pulse Generator (MPG) used on Fanuc controls?	
4	If the control system has 20m of memory capacity, how many characters of a part program does it represent?	
5	What is another name for the "Auxiliary Functions Lock" ?	
6	Name at least five optional features of a control system	
7	What instructions in a part program can be overridden by the CNC operator at the machine? Name all that apply.	
8	What is the purpose of control system parameters?	
9	Describe the purpose of softkeys	
10	What is the "Dry Run" feature used for?	

#	Question	Answer
11	Name at least four ON/OFF switches on the control panel	
12	Name the EDIT options available to make changes in an existing CNC program	
13	What is the purpose of the TAPE mode on controls that do not support the paper tape input anymore?	
14	Explain all setting modes of coolant function switch found on the operation panel.	
15	Describe briefly the purpose of Single Block mode	
16	What are system defaults ?	
17	Name the typical MANUAL and AUTO modes that can be selected by the SELECT MODE switch	
18	Under what circumstances would you use the EMERGENCY STOP button?	
19	Specify at least five settings that are controlled by the system parameters	
20	What happens when the FEEDHOLD button is used?	