Program Structure Q+A

The objective of these questions is to review the subjects relating to the program structure and its development.

#	Question	Answer
1	Define the structure of a CNC program	
2	What is the smallest element of a CNC program?	
3	Write the metric format notation for the X axis input	

4	Some - **but not all** - of the following program entries contain errors. Rewrite all words in a correct format
	
	Note - meaning of the words is unimportant here:
	Some words may have more than one correct answer:
	
	`G54      P0.2    J120.0    L20`
	`x45.0    M03     Z15000    /N120`
	`Y 0.5    H21     Z-1,5     -K0.75`
	`s30O0    X+4.5   XY100.0   M3`
	`F(10.0)  O1234   T6        1.75Y`	

5	What does an alpha-numerical input mean?	
6	a/ What is the percent sign (%) used for in a written CNC program? b/ Where in the program is it written?	a/ _____ b/ _____
7	Describe briefly what a program block is	

8	What are the parentheses used for in a program?	
9	Design a program header with al least six blocks	
10	When using a computer to write a part program, what are the *Ctrl* and *Alt* keys used for?	
11	What is a 'word' n a CNC program?	
12	The following block is incorrect - - rewrite the block correctly, using common format: `M03 X12.0 y56.0 G54 N17 G00 90G S1200`	
13	Specify at least five symbols that can be used in a standard - *not macro* - CNC program	
14	Write an example of a character, word and a block	Character: Word: Block:
15	When you create a part program as a computer file, which method would you use - explain why	a/ All characters will be entered in low case b/ All characters will be entered in capital case c/ All characters will be entered in mixed case d/ It makes no difference at all for items 1- 3 Answer: _____ Explanation: