



basic education

Department:
Basic Education
REPUBLIC OF SOUTH AFRICA

NATIONAL SENIOR CERTIFICATE

GRADE 12

MECHANICAL TECHNOLOGY

NOVEMBER 2014

MARKS: 200

TIME: 3 hours

This question paper consists of 18 pages and a 4-page formula sheet.

INSTRUCTIONS AND INFORMATION

1. Write your centre number and examination number in the spaces provided on the ANSWER BOOK.
2. Read ALL the questions carefully.
3. Answer ALL the questions.
4. Number the answers correctly according to the numbering system used in this question paper.
5. Start EACH question on a NEW page.
6. Show ALL calculations and units. Round off final answers to TWO decimal places.
7. You may use a non-programmable/scientific calculator and drawing/mathematical instruments.
8. The value of gravitational force should be taken as 10 m/s^2 .
9. All dimensions are in millimetres, unless stated otherwise in the question.
10. Write neatly and legibly.
11. A formula sheet appears at the end of the question paper.
12. Use the criteria below to assist you in managing your time.

QUESTION	CONTENT	MARKS	TIME
1	Multiple-choice questions	20	15 minutes
2	Safety	10	10 minutes
3	Tools and Equipment	12	10 minutes
4	Materials	13	10 minutes
5	Terminology	30	20 minutes
6	Joining Methods	25	25 minutes
7	Forces	30	30 minutes
8	Maintenance	15	15 minutes
9	Systems and Control	25	25 minutes
10	Turbines	20	20 minutes
TOTAL		200	180 minutes

QUESTION 1: MULTIPLE-CHOICE QUESTIONS

Various options are given as possible answers to the following questions. Choose the answer and write only the letter (A–D) next to the question number (1.1–1.20) in the ANSWER BOOK, for example 1.21 A.

- 1.1 What safety measure is applicable to the milling machine in terms of the Occupational Health and Safety Act, 1993 (Act 85 of 1993)?
- A Guards could be removed while cutting material.
 - B Do not leave spanners or keys on rotating parts of a machine.
 - C Make sure the dial on the cross slide is set to '0'.
 - D Use the milling machine table as an anvil. (1)
- 1.2 Which ONE of the following safety procedures relates to the cylinder leakage tester?
- A Use water to remove dust around the spark plug area.
 - B Make sure the high tension lead to the spark plugs is connected.
 - C Do not exceed the prescribed pressure in the cylinder.
 - D Exceed the prescribed pressure in the cylinder. (1)
- 1.3 What is the function of a gas analyser?
- A Analyse inlet gases
 - B Analyse oil gases
 - C Analyse fuel gases
 - D Analyse exhaust gases (1)
- 1.4 Which property of material is tested using a Brinell tester?
- A Tensile strength
 - B Elasticity
 - C Hardness
 - D Brittleness (1)
- 1.5 How does high carbon content affect the quality of carbon steel?
- A Makes it tough
 - B Makes only the surface soft
 - C Makes it easy to weld
 - D Makes it malleable (1)

1.6 Which ONE of the following is a property of pearlite?

- A It is ductile
- B It is elastic
- C It is malleable
- D It becomes brittle

(1)

1.7 Identify the type of milling process shown in FIGURE 1.1 below.

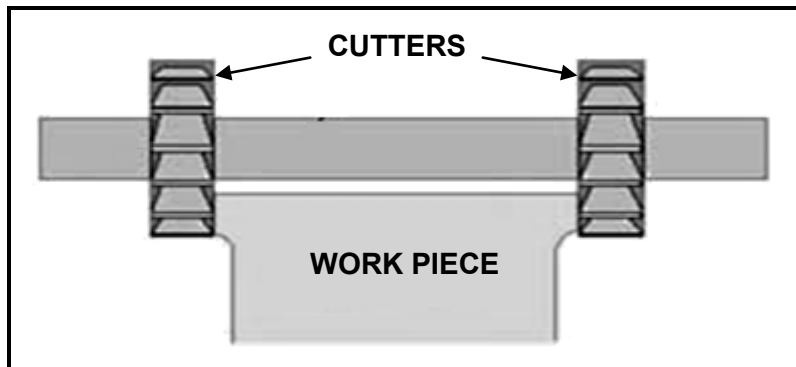


FIGURE 1.1

- A Slab milling
- B Gang milling
- C Side milling
- D Straddle milling

(1)

1.8 Which ONE of the following statements defines the pitch of a screw thread?

- A The distance from one crest point of a screw thread to the next corresponding crest point on the screw thread
- B The distance from any given point on the screw thread to a point on the flank
- C The distance from any given point on the screw thread to the centre line
- D The distance from any given point on the screw thread to a point corresponding in depth

(1)

1.9 What mixture of inert shielding gases is used in the MIGS/MAGS welding process?

- A Argon and acetylene
- B Argon and carbon dioxide
- C Argon and monoxide
- D Argon and helium

(1)

1.10 Which ONE of the following methods to test weld defects uses sound waves?

- A X-ray inspection
- B Free bend test
- C Ultrasonic test
- D Nick break test

(1)

1.11 Calculate Young's modulus of elasticity for a metal with a strain value of 2×10^{-3} caused by stress of 6 MPa:

- A 12 MPa
- B 3 MPa
- C 12 GPa
- D 3 GPa

(1)

1.12 Which ONE of the following statements describes Hooke's law regarding stress in materials?

- A Strain is indirectly proportional to the stress that causes it, provided the limit of elasticity is not exceeded.
- B Strain is directly proportional to the stress that causes it, provided the limit of elasticity is not exceeded.
- C Strain is indirectly proportional to the stress that causes it, provided the limit of elasticity is exceeded.
- D Strain is directly proportional to the stress that causes it, provided the limit of elasticity is exceeded.

(1)

1.13 The beam in FIGURE 1.2 below is in equilibrium. Calculate the distance between the support point and the 9 kN load.

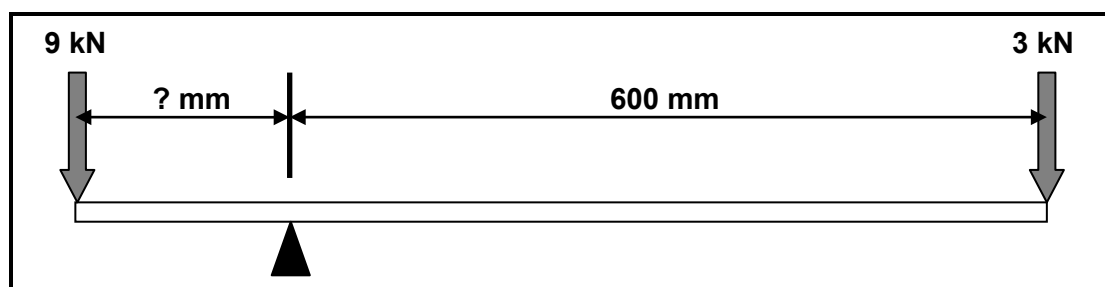


FIGURE 1.2

- A 300 mm
- B 200 mm
- C 150 mm
- D 600 mm

(1)

1.14 SAE 80 oil is used for ...

- A gearbox lubrication.
- B engine lubrication.
- C automatic transmission lubrication.
- D power steering lubrication.

(1)

1.15 What is understood by the term *viscosity* with reference to liquids?

- A Measure of the resistance to boiling
- B Measure of the resistance to foaming
- C Measure of the resistance to solidification
- D Measure of the resistance to flow

(1)

- 1.16 Which ONE of the following statements describes Boyle's law regarding a given mass of gas?
- A The volume of the gas is indirectly proportional to the pressure on the gas if the temperature remains constant.
 - B The volume of the gas is directly proportional to the pressure on the gas, if the temperature remains constant.
 - C The pressure on the gas is directly proportional to the volume of the gas, if the temperature remains constant.
 - D The volume of the gas is indirectly proportional to the pressure on the gas, if the temperature increases. (1)
- 1.17 An advantage of an air bag system compared to seat belts in a motor vehicle is that air bags ...
- A are much cheaper.
 - B do not have to be activated by passengers.
 - C prevent collisions.
 - D protect the inside of the vehicle. (1)
- 1.18 Traction control in a motor vehicle serves the following purpose:
- A Fuel consumption increases
 - B Prevents clutch slip
 - C Reduces engine wear
 - D Prevents wheel spin and slip (1)
- 1.19 Which method is used to drive a turbocharger?
- A Chain drive
 - B Belt drive
 - C Gas drive
 - D Gear drive (1)
- 1.20 The THREE stages of a gas turbine:
- A Inlet port, cooling, turbine
 - B Compression, combustion, thrust
 - C Compression, inlet port, turbine
 - D Cooling, inlet port, combustion (1)

[20]

QUESTION 2: SAFETY

- 2.1 Name THREE safety precautions that should be adhered to when handling gas cylinders. (3)
- 2.2 Why is it important to wear an arc welding helmet/shield during arc welding? (1)
- 2.3 State TWO safety precautions that should be adhered to before you start working on a centre lathe. (2)
- 2.4 When completing a given task on a milling machine, what safety aspects must be considered before leaving the machine? (1)
- 2.5 What is the maximum distance that the tool rest should be set from the grinding wheel of a bench grinder? (1)
- 2.6 A gas analyser is used to analyse the exhaust gases of a motor vehicle. Why is it important to make sure that there are no leakages in the exhaust pipe or inlet manifold? (2)
- [10]**

QUESTION 3: TOOLS AND EQUIPMENT

- 3.1 When a dry compression test is conducted on the first cylinder of a four-stroke spark ignition engine, the results are very low compared to the engine specification. State TWO possible causes of the low compression in the first cylinder. (2)
- 3.2 Most welding companies use MIGS/MAGS welding equipment extensively for their welding.
- 3.2.1 Give TWO reasons for using inert gas during MIGS/MAGS welding. (2)
- 3.2.2 Name TWO advantages of MIGS/MAGS welding. (2)
- 3.3 When assembling a cylinder head, the valve spring must be tested before installation. Give TWO reasons why the valve spring needs to be tested. (2)

- 3.4 FIGURE 3.1 below indicates a multimeter that is used to test different electrical components and electrical circuits. Label parts **A–D**.

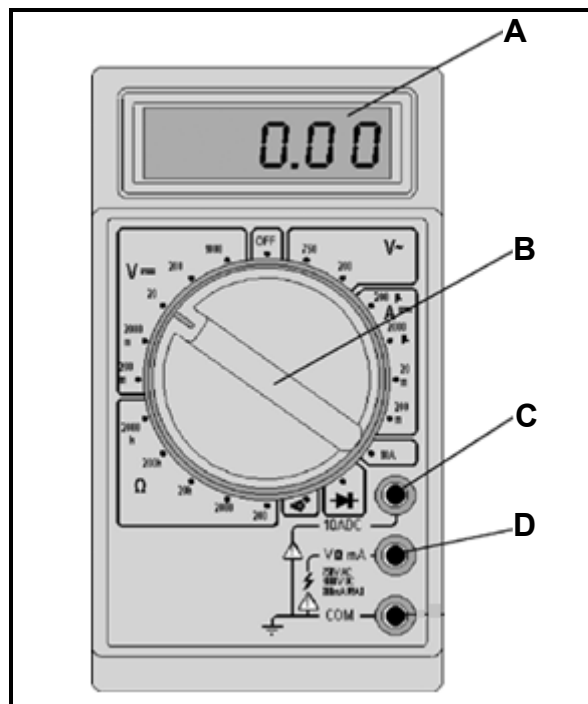
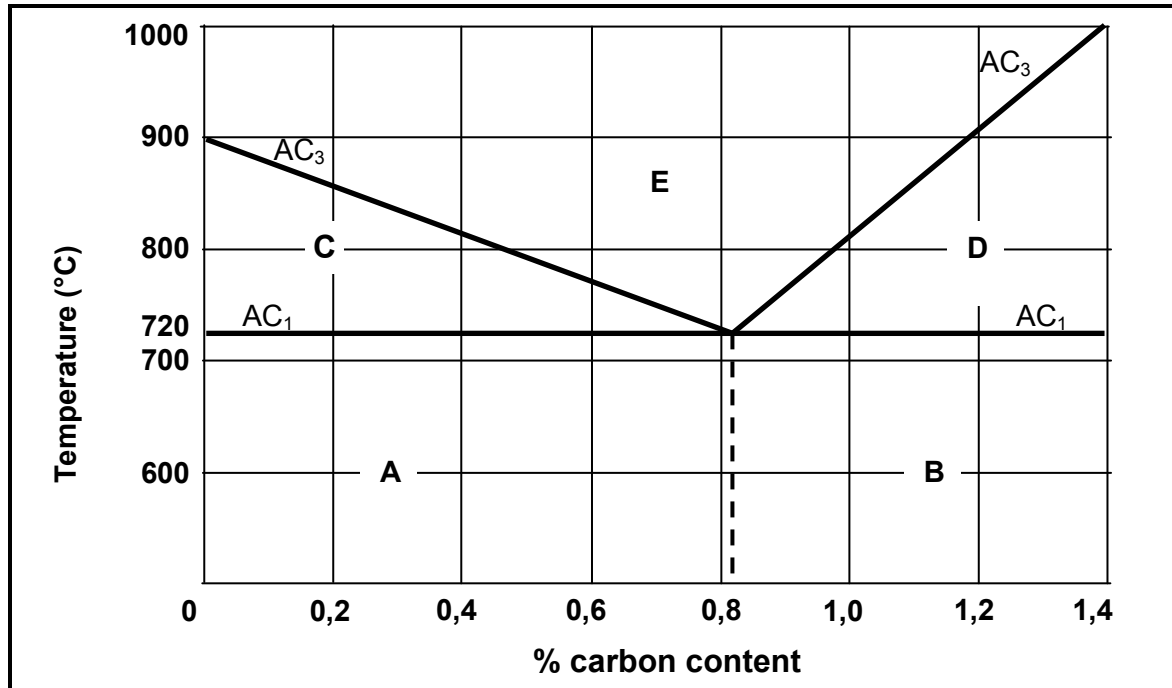


FIGURE 3.1

(4)
[12]

QUESTION 4: MATERIALS

- 4.1 FIGURE 4.1 below shows an iron-carbon equilibrium diagram. Answer the questions that follow.

**FIGURE 4.1**

- 4.1.1 Label parts **A–E**. (5)
- 4.1.2 What does the critical point **AC₁** represent? (2)
- 4.2 Name TWO characteristics of each of the following microscopic structures:
- 4.2.1 Cementite (2)
- 4.2.2 Ferrite (2)
- 4.3 Explain the composition of austenite. (2)
- [13]**

QUESTION 5: TERMINOLOGY

5.1 FIGURE 5.1 below shows a diagram of a metric V-screw thread. Label parts **A–G**.

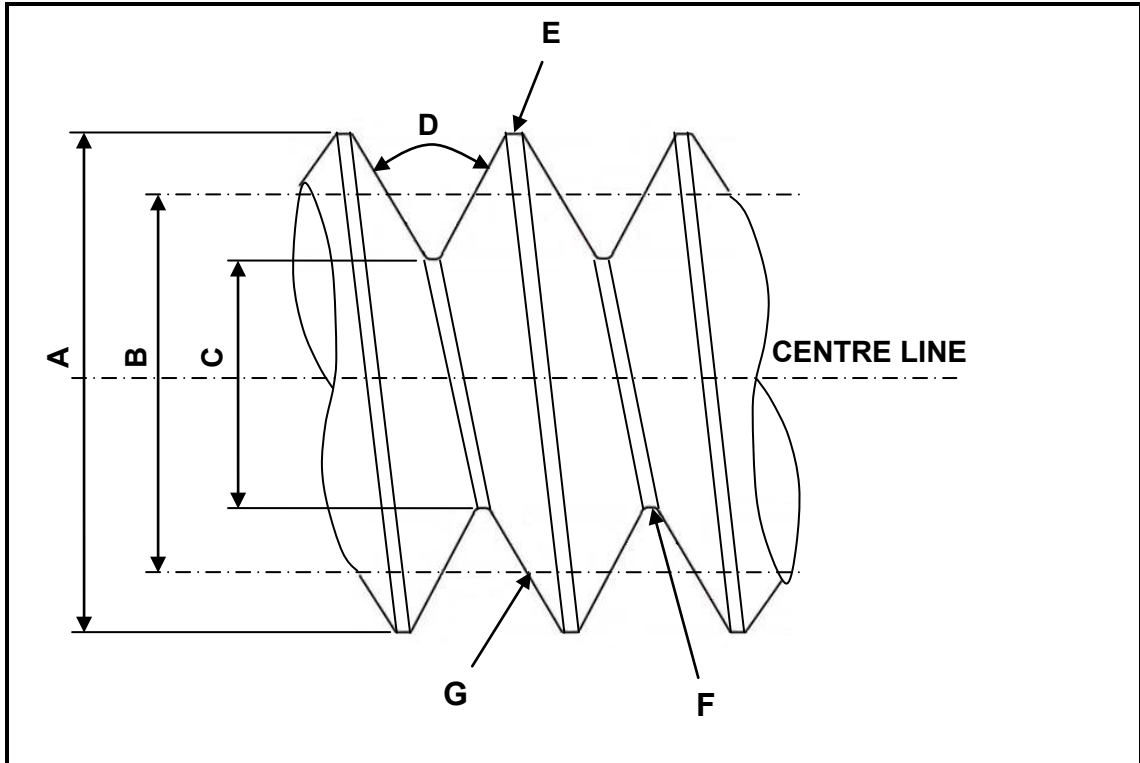


FIGURE 5.1

(7)

5.2 Identify the milling process shown in FIGURE 5.2 below.

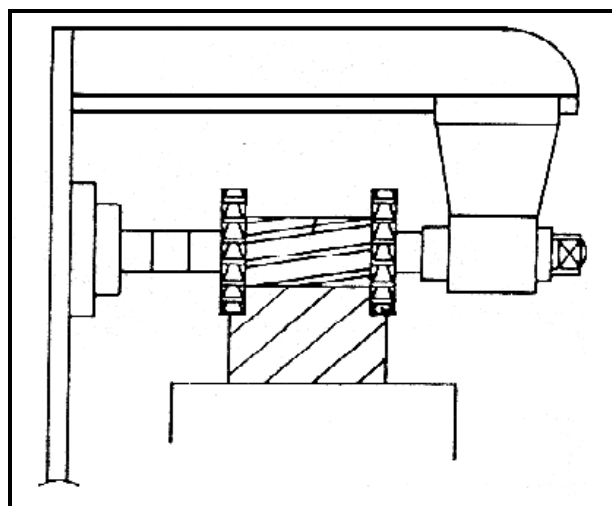


FIGURE 5.2

(2)

5.3 FIGURE 5.3 below shows a drawing of a keyway being cut with a 12 mm wide cutter on a 48 mm diameter shaft. Answer the questions that follow.

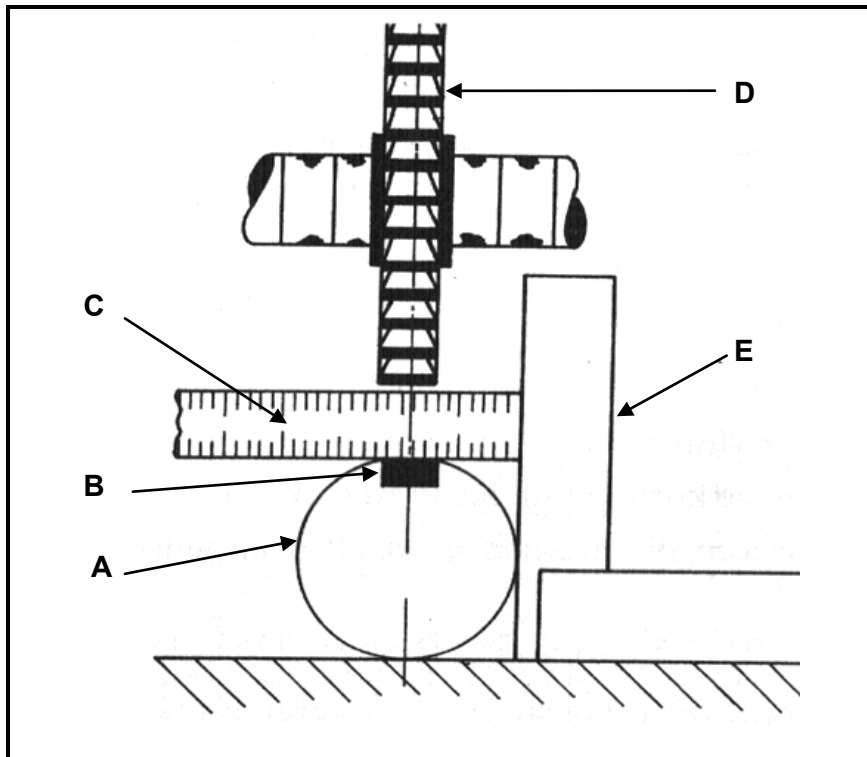
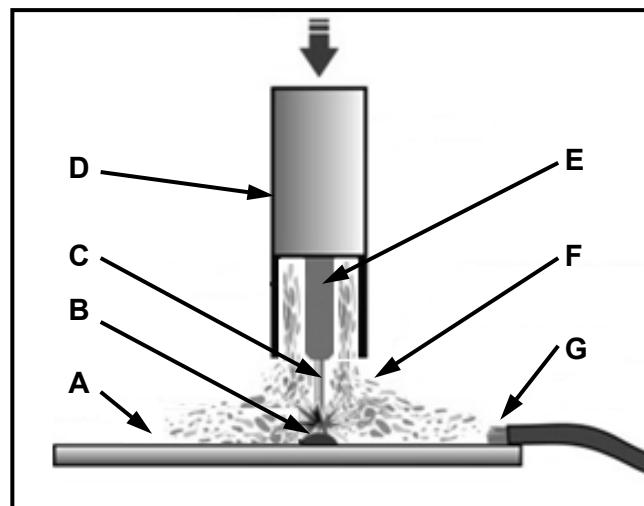


FIGURE 5.3

- 5.3.1 Identify the cutter used to cut the keyway. (1)
 - 5.3.2 Label parts **A–E**. (5)
- Determine by means of calculations:
- 5.3.3 The width of the key (2)
 - 5.3.4 The thickness of the key (2)
 - 5.3.5 The length of the key (2)
 - 5.3.6 The distance between the square and the side of the cutter facing the square (3)
- 5.4 Calculate the indexing needed to cut a gear with 14 teeth. (4)
 - 5.5 Name TWO methods used to cut screw threads using a centre lathe. (2)
- [30]**

QUESTION 6: JOINING METHODS

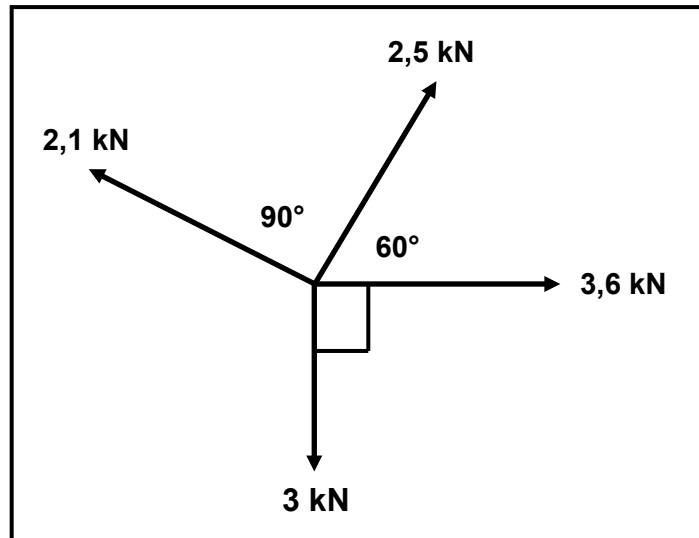
- 6.1 Give THREE reasons for each of the following welding defects:
- 6.1.1 Porosity (3)
- 6.1.2 Slag inclusion (3)
- 6.2 Explain the procedure followed during a nick break test on a welded joint. (5)
- 6.3 Explain how to conduct a dye penetration test on a welded joint to determine whether external defects exist. (5)
- 6.4 Name TWO advantages of non-destructive tests over destructive tests as applicable to testing welded joints. (2)
- 6.5 FIGURE 6.1 below shows the MIGS/MAGS welding process. Label parts A–G.

**FIGURE 6.1**

(7)
[25]

QUESTION 7: FORCES

- 7.1 Four forces of 3 kN, 2,1 kN, 2,5 kN and 3,6 kN respectively have the same acting point as shown in FIGURE 7.1.

**FIGURE 7.1**

Determine by means of calculations:

(**HINT:** Redraw the force diagram above to show the horizontal and vertical component of each force.)

- 7.1.1 The sum of the horizontal components (6)
- 7.1.2 The sum of the vertical components (6)
- 7.2 A tensile force of 50 kN is exerted onto a round bar with a diameter of 50 mm and an original length of 3 m.

Determine by means of calculations:

- 7.2.1 The stress in the material (4)
- 7.2.2 The strain if the final length of the bar is 3,005 m (3)

7.3 What do points **A–E** represent in FIGURE 7.2 below?

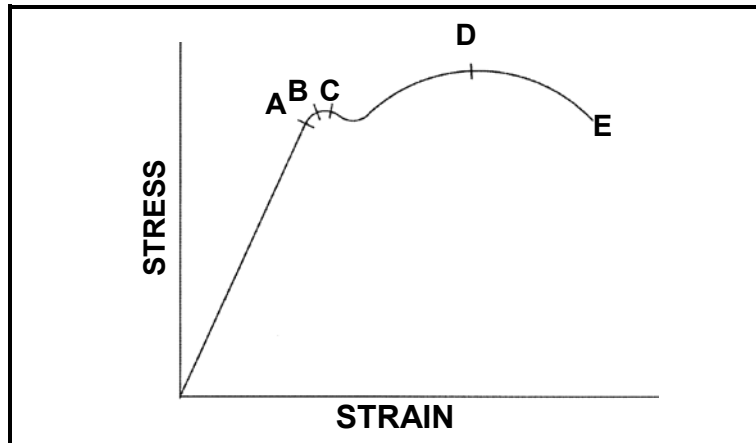


FIGURE 7.2

(5)

7.4 FIGURE 7.3 below shows a uniform beam that is supported by two vertical supports, **A** and **B**. Two vertical point loads are exerted onto the beam, as well as a uniformly distributed load of 100 N/m, over a length of 6 metres of the beam.

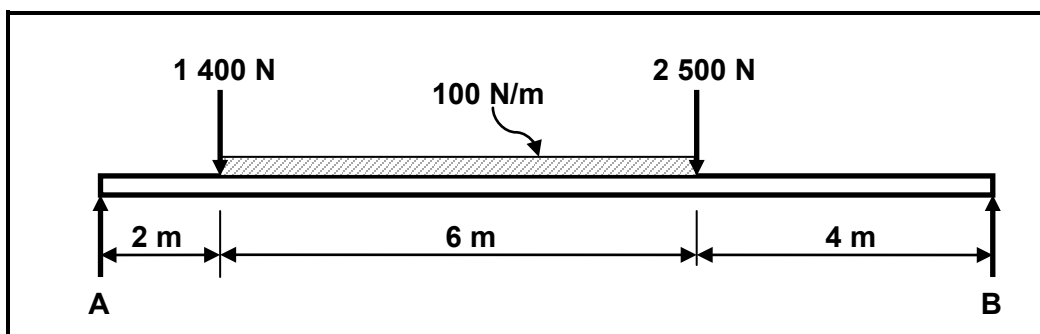


FIGURE 7.3

Determine, by means of calculations and using the turning points method, the magnitudes of the reactions in supports **A** and **B**.

(6)
[30]

QUESTION 8: MAINTENANCE

- 8.1 Where do we use EP oil (extreme pressure oil)? (1)
- 8.2 What do the following abbreviations stand for with reference to oil?
 - 8.2.1 SAE (1)
 - 8.2.2 ATF (1)
- 8.3 State TWO properties of grease. (2)
- 8.4 State TWO ways to maintain a V-belt drive. (2)

- 8.5 Give THREE reasons for clutch slip. (3)
- 8.6 The owner of a light motor vehicle has a problem with the clutch slipping. Name the components of the clutch assembly that should be replaced to solve the problem. (3)
- 8.7 State the effect if the viscosity of oil used in a four-stroke engine is too low. (2)
- [15]**

QUESTION 9: SYSTEMS AND CONTROL

- 9.1 FIGURE 9.1 shows a gear drive system on the shaft of an electric motor. Driver gear A has 40 teeth and meshes with a gear B (56 teeth) on a counter shaft. On this counter shaft is another driver gear, C (28 teeth), that meshes with a gear D (76 teeth) on the output shaft.

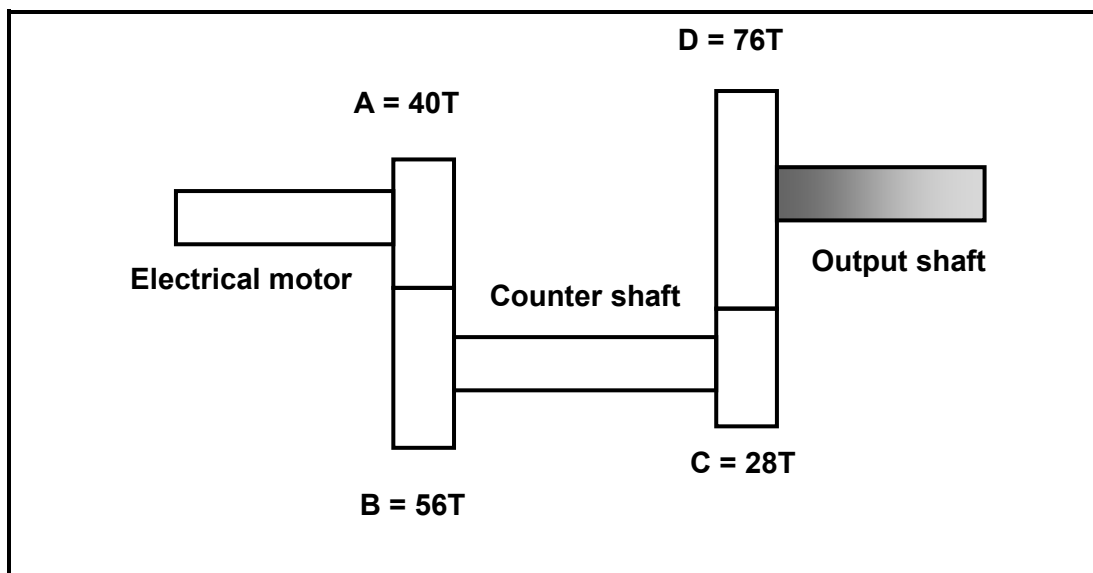
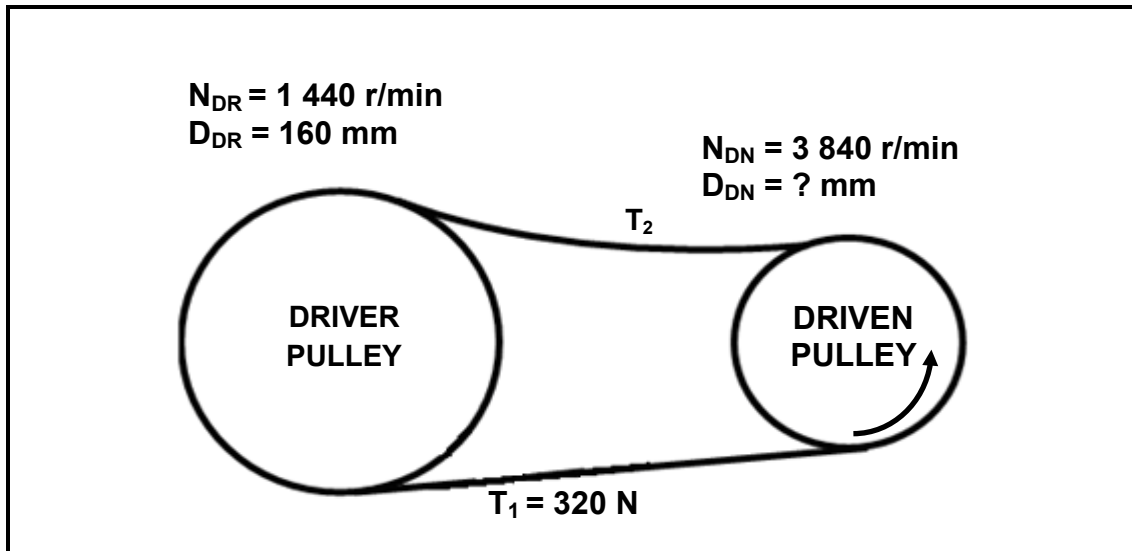


FIGURE 9.1

- Determine, by means of calculations, the rotation frequency of the electric motor if the output shaft needs to rotate at 800 r/min. (5)

- 9.2 A water pump must be driven at 3 840 r/min from a pulley with a diameter of 160 mm, which rotates at a speed of 1 440 r/min. The tensile force in the tight side of the belt is 320 N. The ratio between the tensile force in the tight side to the tensile force in the slack side is 2,5 : 1.

**FIGURE 9.2**

Determine by means of calculations:

- 9.2.1 The diameter of the pulley needed on the water pump (3)
- 9.2.2 The power transmitted (4)

- 9.3 A hydraulic system is used to lift goods when loading it into trucks. The specifications of the system are given in FIGURE 9.3 below.

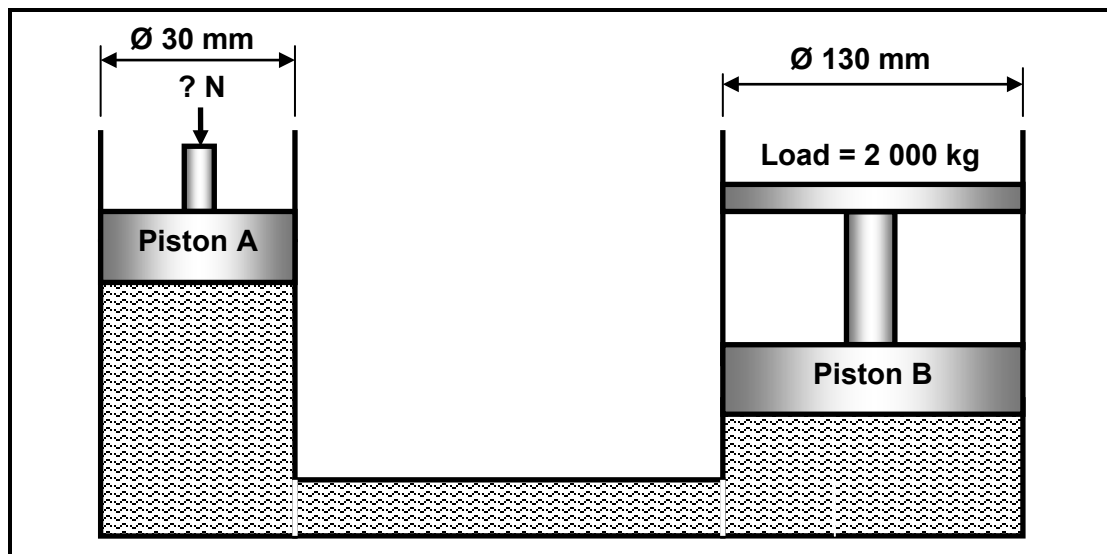


FIGURE 9.3

Determine the following by means of calculations:

- 9.3.1 The fluid pressure in the hydraulic system when the system is in equilibrium (3)
- 9.3.2 The force that needs to be exerted onto piston **A** (4)
- 9.4 Describe the functioning of the engine management system of a motor vehicle. (4)
- 9.5 An anti-lock brake system (ABS) operates effectively under certain circumstances. Name these circumstances when braking. (2)
- [25]**

QUESTION 10: TURBINES

- 10.1 What is the function of a steam turbine? (2)
- 10.2 Explain the following supercharger terms:
- 10.2.1 Boost (2)
- 10.2.2 Density ratio (2)

10.3 FIGURE 10.1 below shows a water turbine driving a generator. Answer the questions that follow.

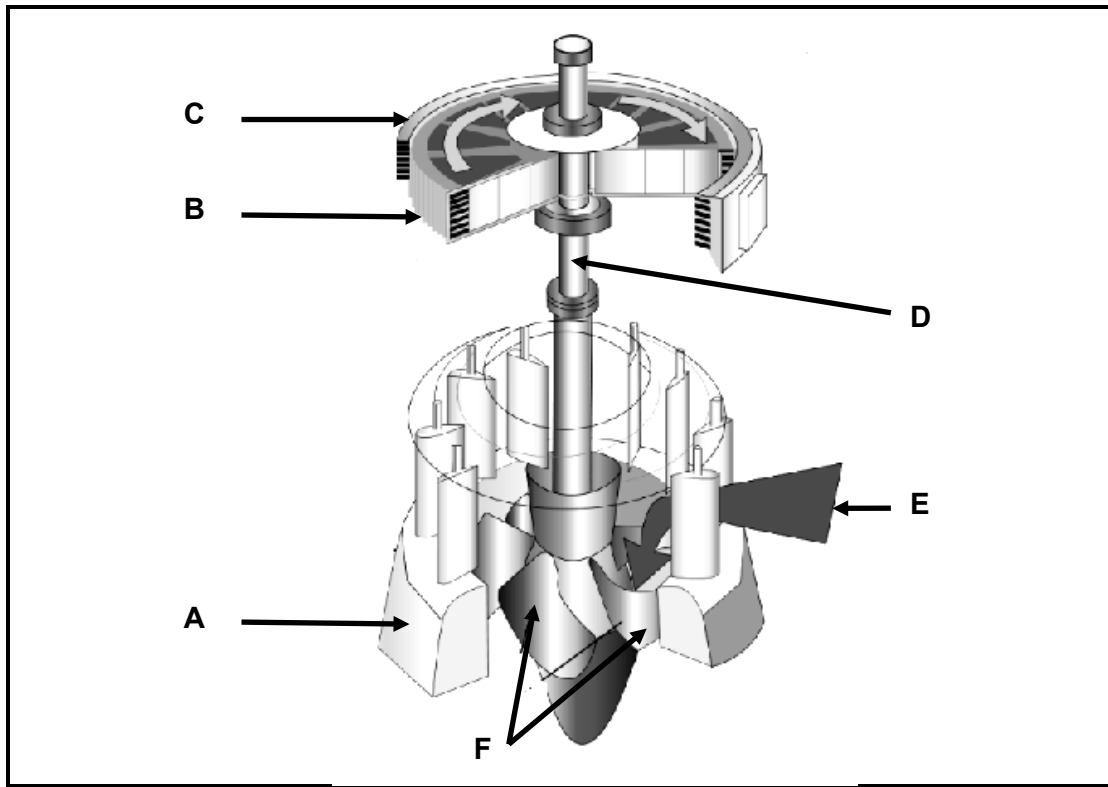


FIGURE 10.1

10.3.1 Identify the type of turbine shown in FIGURE 10.1. (1)

10.3.2 Label parts **A–F**. (6)

10.3.3 State **THREE** advantages of the turbine in FIGURE 10.1 above (3)

10.4 What is the purpose of the waste gate used in a turbocharger? (2)

10.5 Why is a turbocharged engine fitted with an oil cooler? (2)

[20]

TOTAL: 200

FORMULA SHEET FOR MECHANICAL TECHNOLOGY – GRADE 12**1. BELT DRIVES**

$$1.1 \quad \text{Belt speed} = \frac{\pi DN}{60}$$

$$1.2 \quad \text{Belt speed} = \frac{\pi (D + t) \times N}{60} \quad (t = \text{belt thickness})$$

$$1.3 \quad \text{Belt mass} = \text{area} \times \text{length} \times \text{density} \quad (A = \text{thickness} \times \text{width})$$

$$1.4 \quad \text{Speed ratio} = \frac{\text{diameter of driven pulley}}{\text{diameter of driver pulley}}$$

$$1.5 \quad N_1 D_1 = N_2 D_2$$

$$1.6 \quad \text{Open - belt length} = \frac{\pi (D + d)}{2} + \frac{(D - d)^2}{4c} + 2c$$

$$1.7 \quad \text{Crossed - belt length} = \frac{\pi (D + d)}{2} + \frac{(D + d)^2}{4c} + 2c$$

$$1.8 \quad \text{Power (P)} = \frac{2 \pi N T}{60}$$

$$1.9 \quad \text{Ratio of tight side to slack side} = \frac{T_1}{T_2}$$

$$1.10 \quad \text{Power (P)} = \frac{(T_1 - T_2) \pi D N}{60} \quad \text{where } T_1 = \text{force in the tight side}$$

$T_2 = \text{force in the slack side}$

$T_1 - T_2 = \text{effective force } (T_e)$

$$1.11 \quad \text{Width} = \frac{T_1}{\text{permissible tensile force}}$$

2. FRICTION CLUTCHES

$$2.1 \quad \text{Torque (T)} = \mu W n R$$

where $\mu = \text{coefficient of friction}$

$W = \text{total force}$

$n = \text{number of friction surfaces}$

$R = \text{effective radius}$

$$2.2 \quad \text{Power (P)} = \frac{2 \pi N T}{60}$$

3. STRESS AND STRAIN

$$3.1 \quad \text{Stress} = \frac{\text{force}}{\text{area}} \quad \text{or} \quad \left(\sigma = \frac{F}{A} \right)$$

$$3.2 \quad \text{Strain} (\varepsilon) = \frac{\text{change in length} (\Delta L)}{\text{original length} (L)}$$

$$3.3 \quad \text{Young's modulus} (E) = \frac{\text{stress}}{\text{strain}} \quad \text{or} \quad \left(\frac{\sigma}{\varepsilon} \right)$$

$$3.4 \quad \text{Area}_{\text{round bar}} = \frac{\pi D^2}{4} \quad \text{and} \quad \text{Area}_{\text{round tube}} = \frac{\pi(D^2 - d^2)}{4}$$

$$\text{Area}_{\text{square bar}} = L^2 \quad \text{and} \quad \text{Area}_{\text{square tube}} = L^2 - l^2$$

4. HYDRAULICS

$$4.1 \quad \text{Pressure} (P) = \frac{\text{force} (F)}{\text{area} (A)}$$

$$4.2 \quad \text{Volume} = \text{cross-sectional area} \times \text{stroke length} (l \text{ or } s)$$

$$4.3 \quad \text{Work done} = \text{force} \times \text{distance}$$

$$4.4 \quad \text{Area} = \frac{\pi D^2}{4}$$

$$4.5 \quad \frac{F_1}{A_1} = \frac{F_2}{A_2}$$

5. GEAR DRIVES

$$5.1 \quad \text{Power} (P) = \frac{2\pi NT}{60}$$

$$5.2 \quad \text{Gear ratio} = \frac{\text{product of the number of teeth on driven gears}}{\text{product of the number of teeth on driving gears}}$$

$$5.3 \quad \frac{N_{\text{input}}}{N_{\text{output}}} = \frac{\text{product of the number of teeth on driven gears}}{\text{product of the number of teeth on driving gears}}$$

$$5.4 \quad \text{Torque} = \text{force} \times \text{radius}$$

$$5.5 \quad \text{Torque transmitted} = \text{gear ratio} \times \text{input torque}$$

$$5.6 \quad \text{Module } (m) = \frac{\text{pitch-circle diameter } (PCD)}{\text{number of teeth } (T)}$$

$$5.7 \quad N_1 T_1 = N_2 T_2$$

$$5.8 \quad \text{Pitch-circle diameter } (PCD) = \frac{\text{circular pitch } (CP) \times \text{number of teeth } (T)}{\pi}$$

$$5.9 \quad \text{Outside diameter } (OD) = PCD + 2 \text{ module}$$

$$5.10 \quad \text{Addendum } (a) = \text{module } (m)$$

$$5.11 \quad \text{Dedendum } (b) = 1,157 m \quad \text{or} \quad \text{Dedendum } (b) = 1,25 m$$

$$5.12 \quad \text{Cutting depth } (h) = 2,157 m \quad \text{or} \quad \text{Cutting depth } (h) = 2,25 m$$

$$5.13 \quad \text{Clearance } (c) = 0,157 m \quad \text{or} \quad \text{Clearance } (c) = 0,25 m$$

$$5.14 \quad \text{Circular pitch } (CP) = m \times \pi$$

6. PULLEY DRIVES

$$6.1 \quad N_1 D_1 = N_2 D_2$$

$$6.2 \quad \text{Power } (P) = \frac{2 \pi NT}{60}$$

$$6.3 \quad \text{Velocity Ratio} = \frac{\text{diameter of driven pulley}}{\text{diameter of driver pulley}}$$

7. KEYWAYS

$$7.1 \quad \text{Width of key} = \frac{\text{diameter of shaft}}{4}$$

$$7.2 \quad \text{Thickness of key} = \frac{\text{diameter of shaft}}{6}$$

$$7.3 \quad \text{Length of the key} = 1,5 \times \text{diameter of shaft}$$

$$7.4 \quad \text{Taper of key} = 1 : 100$$

8. LEVERS

$$8.1 \quad \text{Mechanical advantage (MA)} = \frac{\text{load (W)}}{\text{effort (F)}}$$

$$8.2 \quad \text{Input movement (IM)} = \text{effort} \times \text{distance moved by effort}$$

$$8.3 \quad \text{Output movement (OM)} = \text{load} \times \text{distance moved by load}$$

$$8.4 \quad \text{Velocity ratio (VR)} = \frac{\text{input movement}}{\text{output movement}}$$

9. SCREW THREADS

$$9.1 \quad \text{Pitch diameter} = \text{outside diameter} - \frac{1}{2} \text{ pitch}$$

$$9.2 \quad \text{Pitch circumference} = \pi \times \text{pitch diameter}$$

$$9.3 \quad \text{Lead} = \text{pitch} \times \text{number of starts}$$

$$9.4 \quad \text{Height of screw thread} = 0,866 \times \text{pitch (P)}$$

$$9.5 \quad \text{Depth of screw thread} = 0,613 \times \text{pitch (P)}$$

$$9.6 \quad \text{Number of turns} = \frac{\text{height}}{\text{lead}}$$

10. INDEXING**CINCINNATI DIVIDING HEAD TABLE FOR HOLE CIRCLES IN PLATE**

<i>Hole circles</i>											
<i>Side 1</i>	24	25	28	30	34	37	38	39	41	42	43
<i>Side 2</i>	46	47	49	51	53	54	57	58	59	62	66

$$10.1 \quad \text{Indexing} = \frac{40}{n}$$



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SENIOR CERTIFICATE**

GRADE 12

MECHANICAL TECHNOLOGY

NOVEMBER 2014

MEMORANDUM

MARKS: 200

This memorandum consists of 18 pages.

QUESTION 1: MULTIPLE-CHOICE QUESTIONS

- | | | |
|------|----------|-------------|
| 1.1 | B ✓ | (1) |
| 1.2 | C ✓ | (1) |
| 1.3 | D ✓ | (1) |
| 1.4 | C ✓ | (1) |
| 1.5 | A ✓ | (1) |
| 1.6 | A or C ✓ | (1) |
| 1.7 | D ✓ | (1) |
| 1.8 | A ✓ | (1) |
| 1.9 | B ✓ | (1) |
| 1.10 | C ✓ | (1) |
| 1.11 | D ✓ | (1) |
| 1.12 | B ✓ | (1) |
| 1.13 | B ✓ | (1) |
| 1.14 | A ✓ | (1) |
| 1.15 | D ✓ | (1) |
| 1.16 | A ✓ | (1) |
| 1.17 | B ✓ | (1) |
| 1.18 | D ✓ | (1) |
| 1.19 | C ✓ | (1) |
| 1.20 | B ✓ | (1) |
| | | [20] |

QUESTION 2: SAFETY**2.1 Gas cylinders:**

- Store full cylinders apart from empty cylinders. ✓
- Keep in cool place and protect them from sunlight and other sources of heat. ✓
- Always store and use gas cylinders in an upright position. ✓
- Store different gas cylinders separately. ✓
- Never stack cylinders on top of one another. ✓
- Do not bang or work on the cylinders. ✓
- Never allow cylinders to fall. ✓
- No oil and grease should come into contact with gas cylinders or fittings. ✓
- Keep the caps on the cylinders for protection. ✓
- Do not store near flammable materials. ✓
- Store in a well ventilated area. ✓
- Ensure the correct assembly of regulators ✓
- Close valves ✓

(Any 3x1) (3)

2.2 Arc welding:

To protect your skin and eyes against the dangerous ultra-violet rays. ✓ (1)

2.3 Safety before using a machine:

- Always clamp work pieces and holding devices properly. ✓
- Know where the ON/OFF switch is located. ✓
- Make sure that all guards are in place. ✓
- Make sure that there is no oil or grease on the floor around the machine. ✓
- Wear all necessary safety equipment. ✓
- Do not use machine without proper training. ✓
- Do not use machine without permission. ✓
- Make sure that the machine is in working order. ✓

(Any 2x1) (2)

2.4 Safety after using a machine:

Switch the machine off. ✓ (1)

2.5 Bench grinder:

The maximum is a 3 mm gap. ✓ (1)

2.6 Gas analyser:

To ensure a more accurate reading or no readings at all. ✓ ✓ (2)

[10]

QUESTION 3: TOOLS AND EQUIPMENT**3.1 Causes of low compression:**

- Worn cylinders ✓
- Worn inlet valves ✓
- Worn outlet valves ✓
- Worn compression rings ✓
- Worn piston ✓
- Worn head gasket ✓
- Leaking, cracked, wrong settings of valves and cylinder head ✓

(Any 2 x 1) (2)

3.2. MIGS/ MAGS:**3.2.1 MIGS/ MAGS: PURPOSE OF INERT GAS**

- Stabilises the arc on the parent metal ✓
- Shields the arc and weld pool from atmospheric gases like oxygen ✓

(2)

3.2.2 Advantages of MIGS/ MAGS:

- Can weld in any position ✓
- Less operator skill required ✓
- Long welds can be made without stops and starts ✓
- Causes less deformation ✓
- Faster than arc welding ✓
- Minimal post weld cleaning ✓
- No slag removal is required ✓
- Gives better finish ✓

(2)

3.3 Spring tester:

- To check for correct tension ✓
- To check for elasticity ✓
- Check according to manufacturer's specification ✓

(2)

3.4 Multimeter:

- A. LCD display screen/Reading screen ✓
- B. Range selector switch ✓
- C. 10A DC socket ✓
- D. VΩmA socket ✓

(4)

[12]

QUESTION 4: MATERIALS**4.1 Iron-carbon diagram:**

4.1.1 Labelling:

- A. Ferrite + Pearlite ✓
- B. Pearlite + Cementite ✓
- C. Ferrite + Austenite ✓
- D. Cementite + Austenite ✓
- E. Austenite ✓

(5)

4.1.2 **AC₁**

- It represents the lowest temperature ✓ to which steel must be heated to be hardened. ✓
- It is the temperature ✓ where the first change in structure ✓ takes place.

(Any 1 x 2)

(2)

4.2 Characteristics of:4.2.1 **Cementite:**

- Intensely hard ✓
- Brittle ✓

(2)

4.2.2 **Ferrite:**

- Soft ✓
- Ductile / malleable ✓

(2)

4.3 **Austenite:**

Austenite is a combination ✓ of iron and carbon which is called iron carbide. ✓

(2)

[13]

QUESTION 5: TERMINOLOGY**5.1 Screw thread terminology:**

- A. Crest / Outside / Normal / Major / Full / Basic diameter ✓
- B. Effective / Pitch diameter ✓
- C. Root / Core / Inside / Minor diameter ✓
- D. Angle (60° ✓) / Thread angle
- E. Crest ✓
- F. Root ✓
- G. Flank ✓

(7)

5.2 Milling operations:

Gang milling ✓✓

(2)

5.3 Keyway cutting:

5.3.1 Side and Face cutter ✓

(1)

- 5.3.2 A. Work piece / Shaft ✓
- B. Keyway ✓
- C. Ruler / Scale ✓
- D. Cutter (Side and face) ✓
- E. Square ✓

(5)

Key calculations:**Unit need to be specified – if omitted = no mark / Wrong unit = no mark**

$$5.3.3 \quad \text{Width of key} = \frac{\text{Diameter of shaft}}{4}$$

$$= \frac{48}{4}$$

$$= 12 \text{ mm}$$

✓

✓

(2)

$$5.3.4 \quad \text{Thickness of key} = \frac{\text{Diameter of shaft}}{6}$$

$$= \frac{48}{6}$$

$$= 8 \text{ mm}$$

✓

✓

(2)

$$5.3.5 \quad \text{Length of key} = 1,5 \times \text{Diameter}$$

$$= 1,5 \times 48$$

$$= 72 \text{ mm}$$

✓

✓

(2)

$$5.3.6 \quad \text{Distance} = \frac{1}{2} \text{ diameter of shaft} - \frac{1}{2} \text{ width of cutter}$$

$$= 24 - 6$$

$$= 18 \text{ mm}$$

✓

✓

✓

(3)

5.4 **Indexing:**

$$\begin{aligned} \text{Indexing} &= \frac{40}{n} && \checkmark \\ &= \frac{40}{14} \\ &= 2 \frac{6 \times 4}{7 \times 4} && \checkmark \\ &= 2 \frac{24}{28} && \checkmark \end{aligned}$$

2 full turns of the crank and 24 holes in a 28 hole circle
 2 full turns of the crank and 36 holes in a 42 hole circle
 2 full turns of the crank and 42 holes in a 49 hole circle

✓

(4)

5.5 **TWO methods for screw cutting:**

Cross slide ✓ and compound slide ✓

(2)

[30]

QUESTION 6: JOINING METHODS**6.1 Causes of welding defects:****6.1.1 Porosity:**

- Atmospheric contamination ✓
- Surface contamination / Dirty / Rusted ✓
- Dirty or wet electrodes with arc welding ✓
- Rusted wire with MIGS/MAGS ✓
- Incorrect flame / setting ✓
- Low current ✓

(Any 3x1) (3)**6.1.2 Slag inclusion:**

- Incorrect current settings / Low current setting / Weld temperature is too low ✓
- Included angle too narrow ✓
- Rapid chilling ✓
- High viscosity of molten metal ✓
- The previous weld slag has not been removed ✓

(Any 3x1) (3)**6.2 Nick break test:**

- Each edge of the weld is slotted by means of a saw. ✓
- Place the specimen on two steel supports / In a bench vice. ✓
- Use a hammer to break the specimen by striking it in the zone where the cut was made. ✓
- The weld metal exposed should be completely fused, free from slag inclusions and contain no gas pockets greater than 1,6 mm. ✓
- There should not be more than one pore or gas pocket per square centimetre. ✓

(5)**6.3 Dye penetration test:**

- Clean the weld that needs to be tested. ✓
- Spray dye onto the surface and leave to penetrate. ✓
- Excess dye is cleaned away with a cleaning agent. ✓
- Allow surface to dry. ✓
- Spray a developer onto the surface to bring out the dye trapped in the crack. ✓
- The dye will show all the surface defects. ✓

(5)**6.4 Advantages of non-destructive tests:**

- The test is done without destroying the usefulness of a finished product ✓
- It is the fastest and least expensive in terms of the finished product. ✓

(2)

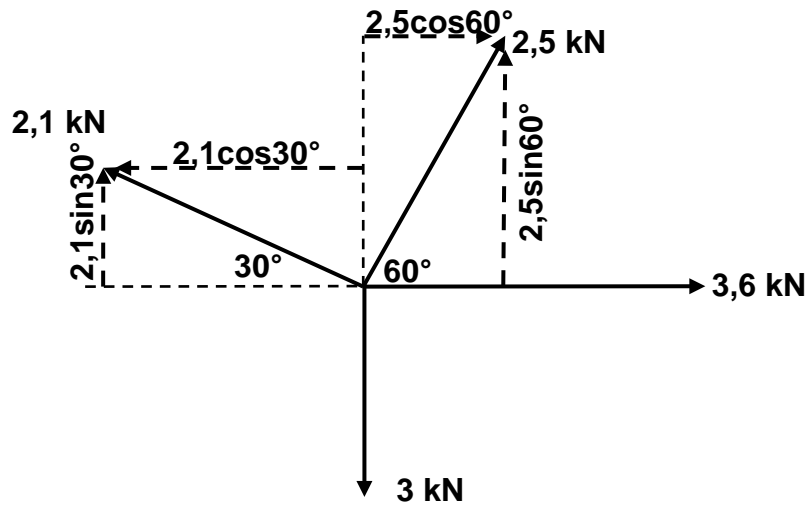
6.5 MIGS / MAGS welding process:

- A. Parent metal ✓
- B. Weld pool ✓
- C. Electrode wire ✓
- D. Gas shroud / Welding pistol ✓
- E. Contact tube / Nozzle ✓
- F. Shielding gas ✓
- G. Earth cable / Clamp / Ground ✓

(7)
[25]

QUESTION 7: FORCES

7.1 Resultant:



7.1.1 The sum of the horizontal components

$$\begin{aligned} \Sigma HC &= 3,6 + 2,5 \cos 60^\circ - 2,1 \cos 30^\circ && \checkmark \checkmark \checkmark \\ &= 3,6 + 1,25 - 1,82 && \checkmark \\ &= 3,03 \text{ kN} && \checkmark \checkmark \end{aligned}$$

7.1.2 The sum of the vertical components

$$\begin{aligned} \Sigma VC &= 2,5 \sin 60^\circ + 2,1 \sin 30^\circ - 3 && \checkmark \checkmark \checkmark \\ &= 2,17 + 1,05 - 3 && \checkmark \\ &= 0,22 \text{ kN} && \checkmark \checkmark \end{aligned}$$

OR

Horizontal component	Magnitudes	Vertical component	Magnitudes
2,1 cos30 ⁰ ✓	-1,82 kN	2,1 sin30 ⁰ ✓	1,05 kN
2,5 cos60 ⁰ ✓	1,25 kN ✓	2,5 sin60 ⁰ ✓	2,17 kN ✓
3,6 kN ✓	3,6 kN	-3 kN ✓	-3 kN
TOTAL	3,03 kN ✓✓	TOTAL	0,22 kN ✓✓

(12)

7.2.1

Stress:

$$A = \frac{F^2}{4} \quad \checkmark$$

$$A = \frac{(0,05)^2}{4} \quad \checkmark$$

$$A = 1,963495 \times 10^{-3} \text{ m}^2 \quad \checkmark$$

$$\text{Stress} = \frac{\text{Load}}{\text{Area}} \quad \checkmark$$

$$\sigma = \frac{F}{A}$$

$$\sigma = \frac{50 \times 10^3}{1,96 \times 10^{-3}}$$

$$\sigma = 25,51 \times 10^6 \text{ Pa} \quad \checkmark$$

OR

$$\sigma = 25,51 \text{ MPa}$$

No / wrong unit – no mark

(4)

7.2.2

Strain:

$$\text{Strain} = \frac{\text{Change in length}}{\text{Original length}} \quad \checkmark$$

$$\text{Strain} = \frac{0,005}{3} \quad \checkmark$$

$$= 1,6667 \times 10^{-3} \quad \checkmark$$

(3)

7.3

Stress/ strain diagram

A = Limit of proportionality ✓

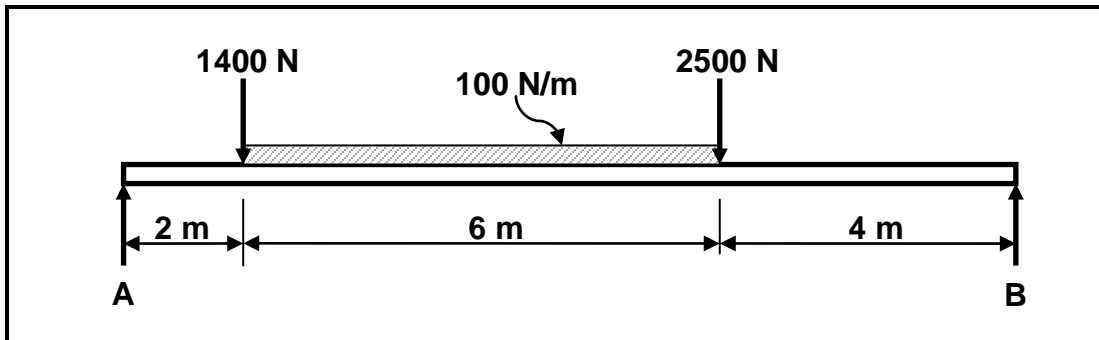
B = Limit of elasticity ✓

C = Yield point ✓

D = Maximum stress ✓

E = Break stress / Break point ✓

(5)

7.4 **Moments:**

Calculate A

Take moments about B

$$A \times 12 = (2500 \times 4) + (600 \times 7) + (1400 \times 10) \quad \checkmark$$

$$A \times 12 = 10000 + 4200 + 14000 \quad \checkmark$$

$$\frac{12A}{12} = \frac{28200}{12}$$

$$A = 2350 \text{ N} \quad \checkmark$$

Calculate B

Take moments about A

$$B \times 12 = (1400 \times 2) + (600 \times 5) + (2500 \times 8) \quad \checkmark$$

$$B \times 12 = 2800 + 3000 + 20000 \quad \checkmark$$

$$\frac{12B}{12} = \frac{25800}{12} \quad \checkmark$$

$$B = 2150 \text{ N}$$

(6)
[30]

QUESTION 8: MAINTENANCE**8.1 EP – oil:**

Manual Gearbox and differential. ✓ (1)

8.2 Abbreviations:

8.2.1 SAE: Society of Automotive Engineers ✓ (1)

8.2.2 ATF: Automatic Transmission Fluid ✓ (1)

8.3 Properties of grease:

- It must be water resistant; it must not mix with water. ✓
 - Prevents rust / corrosion. ✓
 - Good for load pressures. ✓
 - High melting point. ✓
 - Low freezing point. ✓
 - Prevent gumming ✓
 - Be able to lubricate ✓
- (Any 2x1) (2)**

8.4 Maintenance of V belt drives:

- Check the contact surfaces of the pulley to prevent the belt from being damaged. ✓
 - Check the belt condition and replace if it is worn. ✓
 - Correct installation procedure must be followed. ✓
 - Belt drives should be well guarded to prevent foreign objects to come into contact with the belts and pulleys. ✓
 - Keep guard mesh free of papers, rags etc. that can cause insufficient air flow. ✓
 - Check that belt deflection is according to specification. ✓
 - Store replacement belts in a cool, well ventilated place. ✓
 - Correct alignment of pulleys
- (Any 2x1) (2)**

8.5 Causes of clutch slip:

- Worn friction material ✓
 - Oil on friction material ✓
 - Over loading ✓
 - Lack of pressure on friction surfaces ✓
 - Broken clutch plate / pressure plate ✓
 - Incorrect adjustment (free play) ✓
 - Worn flywheel ✓
- (Any 3x1) (3)**

8.6 Clutch replacement:

- Clutch plate ✓
 - Pressure plate / Fly wheel ✓
 - Thrust bearing / Release bearing / pilot bearing ✓
- (Any 3x1) (3)**

8.7 Viscosity of engine oil:

- The oil will not stay between the surfaces in contact, it will just flow through. ✓
- The oil will not have enough time to carry away the heat generated by the friction of the moving parts. ✓

(2)

QUESTION 9: SYSTEMS AND CONTROL**9.1 Gear drives:****Rotation frequency of the electric motor:****One mark – magnitude / one mark for the unit**

$$\frac{N_A}{N_D} = \frac{T_B \times T_D}{T_A \times T_C} \quad \checkmark$$

$$N_A = \frac{T_B \times T_D}{T_A \times T_C} \times N_D \quad \checkmark$$

$$N_A = \frac{56 \times 76}{40 \times 28} \times 800 \quad \checkmark$$

$$= 3040 \text{ rpm} \quad \checkmark \checkmark$$

(5)

9.2 Belt Drives:**9.2.1 Diameter of the driven pulley:**

$$N_{DN} \times D_{DN} = N_{DR} \times D_{DR} \quad \checkmark$$

$$D_{DN} = \frac{N_{DR} \times D_{DR}}{N_{DN}} \quad \checkmark$$

$$D_{DN} = \frac{1440 \times 0,16}{3840}$$

$$D_{DN} = 0,06 \text{ m} \quad \checkmark$$

$$= 60 \text{ mm}$$

(3)

9.2.2 Power transmitted:

$$\frac{T_1}{T_2} = 2,5 \quad \checkmark$$

$$T_2 = \frac{320}{2,5} \quad \checkmark$$

$$T_2 = 128 \text{ N} \quad \checkmark$$

$$P = \frac{(T_1 - T_2) \times D_{DN}}{60} \quad \checkmark$$

$$P = \frac{(320 - 128) \times 0,16 \times 1440}{60} \quad \checkmark$$

$$P = 2316,23 \text{ Watt} \quad \checkmark$$

(4)

NOTE: If driven diameter and speed is used to calculate power, mark correct, i.e. 2 316,23 Watt.

9.3 **Hydraulics:**9.3.1 **Fluid pressure:**

$$A_B = \frac{F^2}{4}$$

$$A_B = \frac{(0,13)^2}{4}$$

$$A_B = 13,273228 \times 10^{-3} \text{ m}^2 \quad \checkmark$$

$$P = \frac{F}{A} \quad \checkmark$$

$$P = \frac{20 \times 10^3}{13,273228 \times 10^{-3}}$$

$$P = 1506792,36 \text{ Pa} \quad \checkmark$$

(3)

9.3.2 **Force needed on piston A:**

$$A_A = \frac{F^2}{4}$$

$$A_A = \frac{(0,03)^2}{4}$$

$$A_A = 0,000706858 \text{ m}^2$$

$$A_A = 0,706858 \times 10^{-3} \text{ m}^2 \quad \checkmark$$

$$P = \frac{F}{A} \quad \checkmark$$

$$F = P \times A \quad \checkmark$$

$$F = (1506792,36) \times (0,706858 \times 10^{-3}) \quad \checkmark$$

$$F = 1065,09 \text{ N} \quad \checkmark$$

OR

$$\frac{F_A}{A_A} = \frac{F_B}{A_B} \quad \checkmark$$

$$F_A = \frac{F_B \times A_A}{A_B} \quad \checkmark$$

$$= \frac{2000 \times 10 \times 0,706858 \times 10^{-3}}{13,273228 \times 10^{-3}} \quad \checkmark$$

$$= 1065,09 \text{ N} \quad \checkmark$$

(4)

9.4 Functioning of vehicle management system:

- Electronic systems use sensors to supply ECU with data. ✓
- The sensor data is read and compared with pre-programmed information. ✓
- A response is calculated and actuators are adjusted. ✓
- The results are checked and the process is repeated. ✓

(4)

9.5 Anti-lock brake system:

ABS comes into play in poor road surface and weather conditions ✓ and also during emergency stops. ✓

(2)

[25]

QUESTION 10: TURBINES

- 10.1 **Turbine:**
A steam turbine is a mechanical device that extracts thermal energy✓ from pressurised steam and converts it into mechanical work / rotary motion.✓ (2)
- 10.2 **Supercharger terminology:**
- 10.2.1 **Boost:**
This refers to the increase in manifold pressure that is generated by the turbocharger in the intake path or specifically intake manifold which exceeds normal atmospheric pressure.✓✓ (2)
- 10.2.2 **Density ratio:**
The density of the inlet air compared to the density of the outlet air in comparison to the inlet manifold.✓✓ (2)
- 10.3 **Water turbine:**
- 10.3.1 Reaction turbine / Water turbine / Kaplan turbine✓ (1)
- 10.3.2 A – Wicket gate ✓
B – Rotor ✓
C – Stator ✓
D – Shaft ✓
E – Water-flow / Inlet port✓
F – Blades / Vanes / Propeller / Fins / Turbine wheel✓ (6)
- 10.3.3 **Advantages of water turbine:**
- Water turbines do not emit carbon. ✓
 - No water is consumed in the process of generating electricity. ✓
 - Water turbines are more reliable. ✓
 - Water turbine blades continue to turn on cloudy windless days unlike sun and wind systems. ✓
 - It is environmental friendly with no pollution. ✓
 - More economical than steam turbines✓
- (Any 3x1) (3)
- 10.4 **Waste gate:**
A waste gate is a valve that diverts exhaust gases away from the turbine wheel. It regulates the turbine speed, rotating speed of the compressor as well as regulates maximum boost pressure in the turbocharger system.✓✓
- 10.5 **Oil cooler:**
To cool the oil that lubricates the turbocharger bearings. ✓ and shaft ✓ (2)

[20]**TOTAL: 200**