

TEN FREE MACHINIST RED SEAL PRACTICE QUESTIONS (429A).

QUESTIONS	COST	LAST CHECKED
10, multiple choice, answers explained	Free. No account, no email	October 3, 2026

Ten 429A Machinist questions in the format of the Red Seal exam: four options, one correct answer, no trick questions. They are free to use, print and share. There is nothing to sign up for on this page.

01 How to use these

The questions come from the TicketPrep 429A bank and are spread across the exam's work activities in the order and roughly the proportion the Red Seal Program publishes for this trade: A (performs common occupational skills), B (performs benchwork), D (machines using drill presses), E (machines using conventional lathes), F (machines using conventional milling machines), G (machines using precision grinding machines), H (machines using computer numerical control (CNC) machines). Answer each one before opening the explanation. Every explanation covers all four options, because on the real exam the wrong options are written to be plausible, and knowing *why* they are wrong is most of the skill.

- **Pace.** The exam allows four hours for 135 questions, so about 1 min 47 s per question. Try these at that pace.
- **Print.** The printed version shows the questions and the answer key without the explanations, so it works as a handout.
- **Mark.** The pass mark is 70 percent on every Red Seal trade; seven of ten here is the same bar.

The questions

Q1 · PROCEDURAL · PERFORMS COMMON OCCUPATIONAL SKILLS

A punch of water-hardening tool steel must be hardened and tempered, and its finished diameter is toleranced ± 0.0002 in. In what order should the work be done?

- A. Turn leaving stock, grind to size, then harden and temper.
 - B. Turn leaving stock, harden and temper, then grind.
 - C. Turn to finished size, then harden and temper.
 - D. Turn leaving stock, temper, then harden and grind.
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Q2 · CRITICAL · PERFORMS BENCHWORK

A new 14 tpi hacksaw blade loses several teeth within a few strokes while cutting thin-wall steel tubing. What is the cause?

- A. The blade has been tensioned too tightly.
 - B. The strokes are too slow and long.
 - C. The teeth face toward the handle.
 - D. The pitch is too coarse for the wall.
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Q3 · PROCEDURAL · MACHINES USING DRILL PRESSES

A 32 mm hole is to be drilled in steel. The 32 mm drill's web is 4 mm thick at the point, and a pilot hole is drilled first to take the load off its chisel edge. Which pilot drill suits it best?

- A. 5 mm
- B. 22 mm
- C. 30 mm
- D. 3 mm

Q4 • PROCEDURAL • MACHINES USING CONVENTIONAL LATHES

The chart gives 25 m/min for turning this steel with an HSS tool. The bar is Ø 45 mm, and the lathe's speeds include 110, 160, 250, 360 and 560 rpm. Which speed should be set?

- A. 160 rpm
- B. 560 rpm
- C. 250 rpm
- D. 360 rpm

Q5 • PROCEDURAL • MACHINES USING CONVENTIONAL LATHES

A taper 25 mm long runs from 40 mm to 30 mm in diameter. The compound rest's swivel scale reads the angle from the work axis. To two decimal places, at what angle is it set?

- A. 22.62°
- B. 21.80°
- C. 11.31°
- D. 78.69°

Q6 • RECALL • MACHINES USING CONVENTIONAL MILLING MACHINES

When gang milling with cutters of different diameters on one arbor, which cutter's diameter is used to calculate the spindle speed?

- A. The average of all the cutters'.
- B. The widest cutter's.
- C. The largest cutter's.
- D. The smallest cutter's.

A 6 mm drill is making a hole 45 mm deep in mild steel on a vertical mill. At about 20 mm deep, chips stop coming up the flutes and the drill starts to squeal. What should the machinist do?

- A. Flood more cutting fluid and keep feeding steadily.
- B. Raise the spindle speed so the flutes throw the chips clear.
- C. Raise the feed so the drill pushes the chips out faster.
- D. Withdraw the drill at intervals to clear out the chips.

While surface grinding soft, annealed low-carbon steel with a fine, dense wheel, the operator sees the finish turn scratchy and bright specks of metal embedded in the wheel face. What is the cause?

- A. The wheel face is glazed.
- B. The wheel grade is too soft.
- C. The wheel is out of balance.
- D. The wheel face is loaded.

Tool 5 has just been loaded with T05 M06, and its measured length is stored in offset number 5. Which block applies the length offset as the tool comes down to its clearance height?

- A. G00 H05 Z25.
- B. G00 G43 D05 Z25.
- C. G00 G41 D05 Z25.
- D. G00 G43 H05 Z25.

Four holes drilled from the work offset all measure 0.05 mm too far in the plus-X direction from datum A, and their spacing is correct. What is adjusted?

- A.** Each hole's X coordinate in the program, by 0.05 mm.
- B.** The drill's radius wear offset, reduced by 0.05 mm.
- C.** The X work offset, shifted 0.05 mm toward minus.
- D.** The drill's length offset, raised by 0.05 mm.

03 Answer key

QUESTION	ANSWER	WORK ACTIVITY
Q1	B	Performs common occupational skills
Q2	D	Performs benchwork
Q3	A	Machines using drill presses
Q4	A	Machines using conventional lathes
Q5	C	Machines using conventional lathes
Q6	C	Machines using conventional milling machines
Q7	D	Machines using conventional milling machines
Q8	D	Machines using precision grinding machines
Q9	D	Machines using computer numerical control (CNC) machines
Q10	C	Machines using computer numerical control (CNC) machines

More free questions

For the 429A exam itself, the 429A exam guide covers the work activities, their weights and how the exam is scored, and the 429A Machinist practice exam page describes the full TicketPrep 429A question bank. The same free format is available for the other 12 trades, plus the free guides on the pass mark, question counts, exam day and how to study.

310S**Automotive Service Technician questions****310T****Truck and Coach Technician questions****309A****Electrician questions****403A****Carpenter questions****421A****Heavy Duty Equipment Technician questions****332A****Hairstylist questions****433A****Industrial Mechanic Millwright questions****313A****Refrigeration & AC Systems Mechanic questions****415A****Cook questions****307A****Steamfitter/Pipefitter questions****456A****Welder questions****306A****Plumber questions****HUB****All free practice questions****GUIDES****The Red Seal exam, explained**

How these questions are written and checked: how our questions are made. Found a mistake? Tell us and we will fix it.

Questions by exam block

Working on one part of the 429A exam? Each block has its own page with five more free questions, the tasks the block covers and their weights.

BLOCK A • 9.6% OF THE EXAM

Safety, Drawings & Materials

BLOCK B • 8.1% OF THE EXAM

Benchwork & Hand Tools

BLOCK C • 5.9% OF THE EXAM

Band Saws & Power Saws

BLOCK D • 6.7% OF THE EXAM

Drill Press & Tapping

BLOCK E • 20.7% OF THE EXAM

Lathe, Tapers & Threading

BLOCK F • 20.7% OF THE EXAM

Milling, Indexing & Gears

BLOCK G • 8.1% OF THE EXAM

Precision Grinding & Wheels

BLOCK H • 20% OF THE EXAM

CNC Programming & Set-Up