

Exam Questions CLSSGB

Certified Lean Six Sigma Green Belt (CLSSGB)

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NEW QUESTION 1

It is a Type I error if we reject the Null Hypothesis when it is actually true.

- A. True
- B. False

Answer: A

NEW QUESTION 2

The reported Cpk for a process with an average of 94 units, a spread of 22 units and upper and lower specification limits of 125 and 80 units would be?

- A. 0.64
- B. 1.27
- C. 1.84
- D. 2.12

Answer: B

NEW QUESTION 3

Which of these are correct if Cpk Upper is 2.0 and Cpk Lower is 1.0?

- A. The process is not stable.
- B. The process is shifted to the left.
- C. Cpk must be reported as 1.0.
- D. The process Mean is 1.5.

Answer: C

NEW QUESTION 4

A Six Sigma tool that helps to screen factors by using graphical techniques to logically subgroup multiple discrete X's plotted against a continuous Y is known as a _____ Chart.

- A. SIPOC
- B. Multi-Vari
- C. Box Plot
- D. Whisker

Answer: B

NEW QUESTION 5

Customers make a purchase decision based on a number of factors. In Lean Six Sigma we refer to these decision points as CTQ's which stands for _____.

- A. Cost of the quantity
- B. Conscious thought qualities
- C. Conspicuous time quandaries
- D. Critical-to-quality

Answer: D

NEW QUESTION 6

A Six Sigma tool that helps to screen factors by using graphical techniques to logically subgroup multiple discrete X's plotted against a continuous Y is known as a _____ Chart.

- A. SIPOC
- B. Multi-Vari
- C. Box Plot
- D. Whisker

Answer: B

NEW QUESTION 7

Measurement System Analysis is a procedure used to quantify all _____ in the method or system used for taking measurements.

- A. Totals
- B. People involved
- C. Variation
- D. Summations

Answer: C

NEW QUESTION 8

The Six Sigma methodology had its origins at _____ in the late 1980's when William Smith coined the name for quality related work being done there.

- A. Motorola
- B. Allied Signal
- C. General Electric
- D. Honeywell

Answer: A

NEW QUESTION 9

The very best way to begin an effort to map a process is to do which of these?

- A. Interview the process owner
- B. Interview the manager of the department
- C. Walk the actual process from beginning to end
- D. Take pictures of the factory floor at each shift

Answer: C

NEW QUESTION 10

The very best way to begin an effort to map a process is to do which of these?

- A. Interview the process owner
- B. Interview the manager of the department
- C. Walk the actual process from beginning to end
- D. Take pictures of the factory floor at each shift

Answer: C

NEW QUESTION 10

SPC charts typically have the most recent data point on the right hand side.

- A. True
- B. False

Answer: A

NEW QUESTION 15

When analyzing a data set we frequently graph one metric as a function of another. If the slope of the Correlation line is -2.5 we would say the two metrics are _____ correlated?

- A. Positively
- B. Not
- C. Negatively
- D. None

Answer: C

NEW QUESTION 16

To create standardization of financial benefit calculations project savings are typically based on savings over what period of time?

- A. 6 months
- B. 12 months
- C. 24 months
- D. The remainder of the calendar year
- E. The remainder of the fiscal year

Answer: B

NEW QUESTION 20

Fractional Factorial designs for an experimental approach are used when _____ about the multiple metric interaction in a process.

- A. Much is known
- B. Little is known
- C. We don't care
- D. Data exists

Answer: B

NEW QUESTION 22

The 80:20 rule is associated with which of these tools?

- A. Pareto Chart
- B. Simon's Cross-Functional Tool
- C. SIPOC
- D. Framing Tool

Answer: A

NEW QUESTION 24

Inferential Statistics is largely about Significance. There are both Practical and _____ Significance to consider during an analysis of data in a Lean Six Sigma project.

- A. Problematic
- B. Impractical
- C. Usable
- D. Statistical

Answer: D

NEW QUESTION 27

The Alpha level of a test (level of significance) represents the yardstick against which P-values are measured and the Null Hypothesis is rejected if the P-value is which of these?

- A. Less than the Alpha level.
- B. Greater than the Alpha level.
- C. Greater than the Beta and Alpha level.
- D. Less than one minus Alpha.
- E. Less than the power of one minus Beta.

Answer: A

NEW QUESTION 28

The actual experimental response data varied somewhat from what a Belt had predicted them to be. This is the result of which of these?

- A. Inefficiency of estimates
- B. Residuals
- C. Confounded data
- D. Gap Analysis

Answer: B

NEW QUESTION 31

Some of the approaches used in Lean include station warning lights, tool boards and jidohka devices in order that which of these apply?

- A. Workers do not utilize individual methods of cleaning
- B. Problems are made highly visible
- C. Work stoppages are documented properly
- D. Lessen the amount of employee pilferage

Answer: B

NEW QUESTION 34

Contingency Tables are used to perform which of these functions?

- A. Illustrate one-tail proportions
- B. Analyze the "what if" scenario
- C. Contrast the Outliers under the tail
- D. Compare more than two sample proportions with each other

Answer: D

NEW QUESTION 36

Unequal Variances can be the result of differing types of distributions.

- A. True
- B. False

Answer: A

NEW QUESTION 39

Significant variation in process performance is a consequence of several causes that can be classified using which of the terminologies shown. (Note: There are 2 correct answers).

- A. Common
- B. Random
- C. Uneducated
- D. Special
- E. Vital

Answer: AD

NEW QUESTION 41

Lean Six Sigma's general approach to solving significant challenges related to a process is called _____.

- A. DOE
- B. SIPOC
- C. DMAIC
- D. FMEA

Answer: C

NEW QUESTION 44

Which statement(s) are correct for the Regression Analysis shown here? (Note: There are 2 correct answers).

- A. This Regression is an example of a Multiple Linear Regression.
- B. This Regression is an example of Cubic Regression.
- C. %Cu explains the majority of the process variance in heat flux.
- D. Thickness explains over 80% of the process variance in heat flux.
- E. The number of Residuals in this Regression Analysis is 26.

Answer: AD

NEW QUESTION 47

A Belt gathered the following defect data for a shoe production line and wanted to assemble it into a Pareto Chart. The correct order from left to right in the chart would be:

Data: Cutting38 Forming17 Stitching56 Sealing42

- A. Forming, Sealing, Cutting, Stitching
- B. Sealing, Stitching, Forming, Cutting
- C. Stitching, Sealing, Cutting, Forming
- D. Forming, Cutting, Sealing, Stitching

Answer: C

NEW QUESTION 49

After a Belt has put data through the smoothing process which chart would be used to look for trends in the data?

- A. Moving Average Chart
- B. Multi-Vari Chart
- C. X bar Chart
- D. Pareto Chart

Answer: A

NEW QUESTION 52

For the data shown here a Belt suspects the three grades are supplying the same results. Which statement(s) are true for proper Hypothesis Testing?

- A. The most appropriate Central Tendency to test is the Means
- B. An appropriate test to test Central Tendency is the Levene's test
- C. An appropriate test to test Central Tendency is the ANOVA test
- D. An appropriate test to test Central Tendency is the Mood's Median test

Answer: D

NEW QUESTION 54

Multiple Linear Regressions (MLR) is best used when which of these are applicable? (Note: There are 3 correct answers).

- A. Non-linear relationships between the inputs X's and output Y
- B. Uncertainty in the slope of the linear relationship between an X and a Y
- C. Relationships between Y (output) and more than one X (Input)
- D. Preventing the use of a Designed Experiment if unnecessary
- E. We assume that the X's are independent of each other

Answer: CDE

NEW QUESTION 59

Conducting a viable Capability Analysis using Attribute Data one must obtain a fairly large sample set to be statistically sound.

- A. True
- B. False

Answer: A

NEW QUESTION 60

Which of these is Discrete data?

- A. Train arrived at 4:17 pm.
- B. Race car consumed 23 gallons of fuel.
- C. Of the 42 people on the bus, 12 went into the station.
- D. It took 3 hours and 32 minutes to complete the marathon.

Answer: C

NEW QUESTION 63

A Belt will occasionally do a quick experiment referred to as an OFAT which stands for _____ .

- A. Only a Few Are Tested
- B. Opposite Factors Affect Technique
- C. One Factor At a Time
- D. Ordinary Fractional Approach Technique

Answer: C

NEW QUESTION 65

Due to excessive pollution, GREEN Solutions Inc. is considering subsidizing public transportation to work for its employees. According to the manager it takes an average weekday commute of 39 minutes with a Standard Deviation of 7 minutes for the employees to get to work while they use their personal vehicles for their office commute while the management set a policy of not more than 40 minutes for their daily one-way commute. A survey conducted one day on 70 employees showed an average of 34 minutes commuting time using the metro public transportation system with a Standard Deviation of 21 minutes. Assuming a Normal Distribution for the commute times by either personal or public transportation, which of these is true?

- A. The probability that they would arrive on time using personal vehicles is much higher than using the metro public transportation system (MPTS)
- B. The probability that they would arrive on time using the MPTS is much higher than using their personal vehicles
- C. The two probabilities are about the same excepting in one case the consistency is higher than the other
- D. We need to compile more data around weekends to incorporate for traffic differences
- E. When Standard Deviation is higher the probability goes down and so the MPTS is worse

Answer: B

NEW QUESTION 68

As part of a Visual Factory plan Kanban cards are created and utilized to identify areas in need of cleaning and organization.

- A. True
- B. False

Answer: B

NEW QUESTION 72

Lean Enterprise is based on the premise that anywhere work is being done which of these is also occurring?

- A. Money is being spent
- B. Waste is being generated
- C. People are producing value added product
- D. Waste is being eliminated

Answer: B

NEW QUESTION 75

Hypothesis Tests determine the probabilities of differences between observed data and the hypothesis being solely due to _____ based on the result of the P-values.

- A. Human error
- B. Measurement error
- C. Shift differences
- D. Chance

Answer: D

NEW QUESTION 79

Fractional Factorial designs for an experimental approach are used when _____ about the multiple metric interaction in a process.

- A. Much is known
- B. Little is known
- C. We don't care
- D. Data exists

Answer: B

NEW QUESTION 84

An employee of ACME Corporation noticed that every loan application that gets approved is copied four times and is stored in different locations in the company for no apparent reason. This would be an example of _____.

- A. Internal Failure Costs
- B. Appraisal Costs
- C. External Failure Costs
- D. Prevention Costs

Answer: A

NEW QUESTION 85

Voice of the Customer is a Lean Six Sigma technique to determine _____ attributes of a product or service.

- A. At least 6
- B. The profitable
- C. Critical-to-Quality
- D. The majority of the

Answer: C

NEW QUESTION 88

The deviation of the measured value from the actual value is known as _____.

- A. Bias
- B. Linearity
- C. Repeatability
- D. Movement

Answer: A

NEW QUESTION 93

According to a manager it takes an average weekday commute of 39 minutes with a Standard Deviation of 7 minutes for the employees to get to work when they use their personal vehicles for their office commute while management set a policy of not more than 40 minutes for their daily one-way commute. A survey conducted one day on 70 employees showed an average of 34 minutes commuting time using the metro public transportation system with a Standard Deviation of 21 minutes. For the employees choosing to increase their chances to come on time using personal transportation their variation should be reduced to _____?

- A. 1 minute
- B. 6 minutes
- C. 3.5 minutes
- D. Eliminate it to 0.0 minutes

Answer: C

NEW QUESTION 94

According to the definition of Rolled Throughput Yield which of these items best describe the purpose of RTY?

- A. A function of $Y=f(x)$
- B. Accounts for losses due to rework and scrap
- C. Isolates the increase throughput
- D. Determines incremental Growth

Answer: B

NEW QUESTION 97

Which of the following is used to test the significance for the analysis of a Variance Table?

- A. t Test
- B. F Test
- C. Chi Square Test
- D. Acid Test

Answer: B

NEW QUESTION 98

The deviation of the measured value from the actual value regardless of the operator is known as _____.

- A. Linearity
- B. Bias
- C. Repeatability
- D. Movement

Answer: B

NEW QUESTION 99

If the data displayed in a Histogram displays two peaks the distribution would likely be _____.

- A. Transformed

- B. Multi-skewed
- C. Bi-attribute
- D. Bimodal

Answer: D

NEW QUESTION 104

Training cost \$6,500 and a project required an initial investment of \$47,500. If the project yields monthly savings of \$3,500 beginning after 4 months, what is the payback period in months, before money costs and taxes?

- A. 9.7
- B. 15.4
- C. 19.4
- D. 23.7

Answer: C

NEW QUESTION 109

Skewed, or Mixed, Distributions occur when data comes from several sources that are supposed to be the same yet are not.

- A. True
- B. False

Answer: A

NEW QUESTION 114

When utilizing Statistics the population is defined as a collection of all the individual data points of interest.

- A. True
- B. False

Answer: A

NEW QUESTION 115

The Central Limit Theorem helps us understand the _____ we are taking and is the basis for using sampling to estimate population parameters.

- A. Analysis
- B. Kurtosis
- C. Risk
- D. Route

Answer: C

NEW QUESTION 117

The data on SPC charts are typically constructed such that they have the most recent data point on the right hand side.

- A. True
- B. False

Answer: A

NEW QUESTION 121

The 80:20 rule is associated with which of these tools?

- A. Pareto Chart
- B. Simon's Cross-Functional Tool
- C. SIPOC
- D. Framing Tool

Answer: A

NEW QUESTION 125

The difference between the largest observation and the smallest observation in the data set is known as the _____.

- A. Breadth
- B. Range
- C. Spread
- D. Median

Answer: B

NEW QUESTION 128

A process can be defined as a repetitive and systematic series of steps or activities where inputs are modified or assembled to achieve a _____ result.

- A. Revenue total
- B. Month end
- C. Customer desired
- D. Budgeted

Answer: C

NEW QUESTION 131

When creating a Cause and Effect Diagram the team needs to continually broaden their view as well as drill down until they identify all the potential _____ impacting their process.

- A. Line operators
- B. Root Causes
- C. Inventory issues
- D. Customer requests

Answer: B

NEW QUESTION 134

Lean had its origins in the development and practice of the _____ Production System.

- A. Honda
- B. Toyota
- C. Ford
- D. Motorola

Answer: B

NEW QUESTION 136

The Lean Principle action in the 5S approach that deals with having those items needed regularly at hand and those items need less regularly stored out of the way is known as _____.

- A. Shining
- B. Standardizing
- C. Sustaining
- D. Sorting

Answer: D

NEW QUESTION 140

Voice of the Customer is a Lean Six Sigma technique to determine _____ attributes of a product or service.

- A. At least 6
- B. The profitable
- C. Critical-to-Quality
- D. The majority of the

Answer: C

NEW QUESTION 145

Nominal Scale data consists of names, labels or categories and cannot be arranged in any mathematical ordering scheme. Complex arithmetic functions cannot be easily applied to Nominal Data:

- A. True
- B. False

Answer: A

NEW QUESTION 150

Use of the _____ approach is the most classic arrangement when constructing a Fishbone Diagram.

- A. Chronological
- B. 6M
- C. 5M
- D. Alphabetical

Answer: B

NEW QUESTION 153

The use of station warning lights, tool boards and jidohka devices in the application of Lean accomplish which of these principles?

- A. Pilferage Minimization
- B. Visual Factory
- C. Management Awareness
- D. Operator Attentiveness

Answer: B

NEW QUESTION 157

Lean removes many forms of _____ so Six Sigma can focus on reducing _____.

- A. Waste, variability
- B. Inventory, defects
- C. Waste, cost
- D. Movement, variation

Answer: A

NEW QUESTION 160

Examples of a Visual Factory include which of these? (Note: There are 2 correct answers).

- A. White outlines on floor for proper inventory placement
- B. Documented procedures with a numerical outline
- C. Bad/Good indications of gauge readings with red and green outlines
- D. Implementing a defect inspection device

Answer: AC

NEW QUESTION 165

Long-term Data represents all the variation that one can expect within the subject process.

- A. True
- B. False

Answer: A

NEW QUESTION 169

If a process has Outliers which pair of charts is most preferable if subgroups will exist for the Continuous Data?

- A. Individual—Moving Range
- B. Xbar-R Charts
- C. Xbar-S Charts
- D. nP and P Charts

Answer: B

NEW QUESTION 172

If a Histogram displays two peaks the distribution would likely be _____.

- A. Transformed
- B. Multi-skewed
- C. Bimodal
- D. Bi-attribute

Answer: C

NEW QUESTION 173

Which element of waste best describes the cost of a resource being in the queue?

- A. Waiting
- B. Motion
- C. Inventory
- D. Correction

Answer: A

NEW QUESTION 175

The Accuracy of a Measurement System addresses _____.

- A. Stability, Bias & Linearity
- B. Repeatability & Reproducibility
- C. Stability & Sensitivity
- D. Precision & Sensitivity

Answer: A

NEW QUESTION 177

Which element of waste best describes "the unnecessary movement of materials and/or goods"?

- A. Overprocessing

- B. Motion
- C. Conveyance
- D. Correction

Answer: C

NEW QUESTION 180

Bias in Sampling is an error due to lack of independence among random samples or due to systematic sampling procedures.

- A. True
- B. False

Answer: A

NEW QUESTION 184

Measurement System Analysis is a procedure used to quantify variation of the method or system used for taking measurements.

- A. True
- B. False

Answer: A

NEW QUESTION 189

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