

GAQM

Exam Questions CLSSGB

Certified Lean Six Sigma Green Belt (CLSSGB)



NEW QUESTION 1

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 2

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 3

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 4

The Accuracy of a Measurement System addresses _____.

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

Answer: A

NEW QUESTION 5

The Regression Model for an observed value of Y contains the term θ_0 which represents the Y axis intercept when $X = 0$.

- A. True
- B. False

Answer: A

NEW QUESTION 6

Hypothesis Tests determine the probabilities of differences between observed data and the hypothesis being solely due to chance. This is determined based on the result of the _____.

- A. Random acts
- B. P-values
- C. Standard Deviations
- D. R-values

Answer: B

NEW QUESTION 7

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 8

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 9

Measurement error is defined as the effect of all sources of measurement variability that caused an observed or measured value to deviate from the _____.

- A. Standard Deviation
- B. Mean
- C. Median
- D. True value

Answer: D

NEW QUESTION 10

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 10

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

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

Answer: D

NEW QUESTION 12

Contingency Tables are used to do which of these? (Note: There are 2 correct answers).

- A. Illustrate one-tail proportions.
- B. Compare more than two sample proportions with each other.
- C. Contrast the Outliers under the tail.
- D. Analyze the "what if" scenario.
- E. Applicable to data that is Attribute in nature

Answer: BE

NEW QUESTION 13

Typically a person who is trained to the skill level of a Black Belt is nearly 80% dedicated to applying Lean Six Sigma methodologies towards process solutions.

- A. True
- B. False

Answer: B

NEW QUESTION 14

The _____ is important because it provides an estimate of the probability of an event occurring depending on the Standard Deviation from the Mean.

- A. Shewhart Principle
- B. Pareto Rule
- C. Mean/Mode Spread
- D. Empirical Rule

Answer: D

NEW QUESTION 17

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 18

A periodic time frame can be used to arrange for Control Limit and Center Line calculations with good SPC implementation in a process.

- A. True
- B. False

Answer: A

NEW QUESTION 23

Which statement(s) are true about the Fitted Line Plot shown here? (Note: There are 2 correct answers).

- A. When Reactant increases, the Energy Consumed increases.
- B. The slope of the equation is a positive 130.5.
- C. The predicted output Y is close to -18 when the Reactant level is set to 6.
- D. Over 85 % of the variation of the Energy Consumed is explained by the Reactant via this Linear Regression.

Answer: CD

NEW QUESTION 28

The Regression Model for an observed value of Y contains the term θ_0 which represents the Y axis intercept when $X = 0$.

- A. True
- B. False

Answer: A

NEW QUESTION 33

The purpose of a Process Map is to identify the complexity of the process and to assist in identifying critical steps in the process.

- A. True
- B. False

Answer: A

NEW QUESTION 38

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 40

The essence of Lean is to concentrate effort on removing waste while improving process flow to achieve speed and agility at lower cost.

- A. True
- B. False

Answer: A

NEW QUESTION 41

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 46

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:

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

Answer: C

NEW QUESTION 49

The FMEA is used to analyze potential source of defects in the process of interest and stands for _____.

- A. Failure Measure for Effective Automation
- B. Failure Modes and Effect Analysis
- C. Focused Mental Efforts Analyze
- D. Failed Manufacturing Efforts Analyzed

Answer: B

NEW QUESTION 51

When looking at a distribution graph, the Mean is defined as the _____.

- A. Average based on the sample size
- B. Aggression measured
- C. Total sample size
- D. Measurement based off a quarter of the sample size

Answer: A

NEW QUESTION 55

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 58

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

_____ Distributions occur when data comes from several sources that are supposed to be the same yet are not.

- A. Skewed
- B. Bimodal
- C. Gaussian
- D. Tri-peaked

Answer: A

NEW QUESTION 62

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 64

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

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 71

The purpose of a Process Map is to identify the complexity of the process and to record all actions and decision points in the process.

- A. True
- B. False

Answer: A

NEW QUESTION 73

Hypothesis Testing can help avoid high costs of experimental efforts by using existing data.

- A. True
- B. False

Answer: A

NEW QUESTION 77

To draw inferences about a sample population being studied by modeling patterns of data in a way that accounts for randomness and uncertainty in the observations is known as _____.

- A. Influential Analysis
- B. Inferential Statistics
- C. Physical Modeling
- D. Sequential Inference

Answer: B

NEW QUESTION 78

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 82

When two Inputs have an impact on the Output together yet seem to have no or little impact on their own this is called a/an _____.

- A. Interaction
- B. Oddity
- C. Coincidence
- D. Impossibility

Answer: A

NEW QUESTION 83

A Belt experienced an Alpha of .05 and a Beta of .10 and knew these are the most common risk levels when running a Statistical test.

- A. True
- B. False

Answer: A

NEW QUESTION 85

The Purchase Orders for Glenn Manufacturing Company were being copied by an employee and sent to four different departments yet only one department took an action based on the information in the PO. This is an example of _____.

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

Answer: C

NEW QUESTION 88

Non-parametric testing is done when which of these are applicable? (Note: There are 3 correct answers).

- A. When the traditional t tests don't produce the results we need
- B. A Hypothesis Test for the Median of the population is in question
- C. It does not require data to come from Normally Distributed populations
- D. They look at the Median rather than the Mean of populations
- E. When there are no parameters to measure in the process

Answer: BCD

NEW QUESTION 92

Cost of Poor Quality (COPQ) can be classified as Tangible (Visible) Costs and Hidden Costs.

- A. True
- B. False

Answer: A

NEW QUESTION 96

Which element of waste best describes "the cost of an idle resource"?

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

Answer: A

NEW QUESTION 97

The Empirical Rule is important because it provides an estimate of the probability of an event occurring depending on the Standard Deviation from the Mean.

- A. True
- B. False

Answer: A

NEW QUESTION 102

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 107

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 109

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 111

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

- A. True
- B. False

Answer: A

NEW QUESTION 113

The practice of utilizing Poka-Yoke is also known as _____.

- A. Thorough integration
- B. Mistake proofing
- C. On site inspection
- D. Lean controls

Answer: B

NEW QUESTION 116

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 119

When constructing a Fishbone Diagram using the _____ approach is the most classic arrangement.

- A. 6M
- B. 4M
- C. 5M
- D. Alphabetical

Answer: A

NEW QUESTION 121

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 123

Standardized work instructions apply to which resource in the process of interest?

- A. People
- B. Machines
- C. Supervision
- D. Engineering

Answer: A

NEW QUESTION 127

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 132

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 134

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 139

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 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 144

What is the Cycle Time, in seconds, for a process having a Throughput of 7,200 units per hour?

- A. 0.5
- B. 2
- C. 4
- D. 10

Answer: A

NEW QUESTION 146

Six Sigma refers to a process whose output has at least 80% of its data points within +/- 6 Standard Deviations from the Mean.

- A. True
- B. False

Answer: B

NEW QUESTION 151

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 156

While management of a company must set the stage for all improvement efforts, which of these 5S's is primarily driven by management?

- A. Straighten
- B. Sort
- C. Shine
- D. Sustain

Answer: D

NEW QUESTION 157

Those who are trained to the skill levels of a Black Belt are typically utilized to apply Lean Six Sigma methodologies what percentage of their time?

- A. 25%
- B. 50%
- C. 75%
- D. 100%

Answer: D

NEW QUESTION 162

The use of Kanbans work best with pull systems for determining the timing of which products or services are produced.

- A. True
- B. False

Answer: A

NEW QUESTION 166

Which statement(s) are true about the Fitted Line Plot shown here? (Note: There are 2 correct answers).

- A. When Reactant increases, the Energy Consumed increases.
- B. The slope of the equation is a positive 130.5.
- C. The predicted output Y is close to -18 when the Reactant level is set to 6.
- D. Over 85 % of the variation of the Energy Consumed is explained by the Reactant via this Linear Regression.

Answer: CD

NEW QUESTION 170

The generation of a Regression Equation is justified when we _____. (Note: There are 4 correct answers).

- A. Expect the relationship to be Linear between the output and inputs
- B. Know that there is a non-linear relationship between output and input(s)
- C. Need to understand how to control a process output by controlling the input(s)
- D. Experience several process defects and have no other way to fix hem
- E. When it is very expensive or too late to measure the output

Answer: ACDE

NEW QUESTION 171

The following Business Case is constructed properly.

“During fiscal year 2008 the warranty returns for electric razor Model 312 were 1.3%. This represents a gap of 0.5% over target costing the company \$18,500 per month.”

- A. True
- B. False

Answer: A

NEW QUESTION 176

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 178

The ability to repeat the same measurement obtained with one measurement instrument used several times by one appraiser while measuring the identical characteristic on the same part is known as _____.

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

Answer: A

NEW QUESTION 180

Training cost is \$4,000 and a project required an initial investment of \$30,000. If the project yields monthly savings of \$2,000 beginning after 3 months, what is the payback period in months (before money costs and taxes)?

- A. 10
- B. 20
- C. 27
- D. 33

Answer: B

NEW QUESTION 183

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 186

The Mann-Whitney Test is used to test if the Means for two samples are different.

- A. True
- B. False

Answer: B

NEW QUESTION 191

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

- A. True
- B. False

Answer: A

NEW QUESTION 195

The Accuracy of a Measurement System addresses _____.

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

Answer: A

NEW QUESTION 200

A 1-Sample t-test is used to compare an expected population Mean to a target.

- A. True
- B. False

Answer: A

NEW QUESTION 203

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 205

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 207

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 208

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