

Exam Questions CLSSGB

Certified Lean Six Sigma Green Belt (CLSSGB)

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NEW QUESTION 1

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 2

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 3

As a type of measurement error, Linearity describes a change in accuracy through the expected operating range of the measurement instrument.

- A. True
- B. False

Answer: A

NEW QUESTION 4

The Regression Model for an observed value of Y contains the term ϕ_0 which represents the Y axis intercept when X = 0.

- A. True
- B. False

Answer: A

NEW QUESTION 5

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 6

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 7

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 8

The proper functioning of a Visual Factory is dependent upon which of these?

- A. Technically skilled workers
- B. Work space with active 5S
- C. Availability of visual tools
- D. Breakthrough projects

Answer: C

NEW QUESTION 9

A 1-Sample t-test is used when you want to compare the Median of one distribution to a target value.

- A. True
- B. False

Answer: B

NEW QUESTION 10

Lean focuses on the sequence of activities and work required to produce a product or a service. This flow is called a _____.

- A. Value-add Flow
- B. Production Map
- C. Value Stream
- D. Operating Procedure

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 15

SPC on the outputs is more preferred than SPC on the inputs when implementing SPC for your process.

- A. True
- B. False

Answer: B

NEW QUESTION 16

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

- A. True
- B. False

Answer: A

NEW QUESTION 21

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 24

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 25

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 29

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 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 36

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 40

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 43

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

- A. True
- B. False

Answer: A

NEW QUESTION 45

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 48

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 53

Lean focuses on the sequence of activities and work required to produce a product or a service. This flow is called a _____.

- A. Value-add Flow
- B. Production Map
- C. Value Stream
- D. Operating Procedure

Answer: C

NEW QUESTION 57

A Belt concludes a Lean Six Sigma project with the creation of a Control Plan. At what point can the Control Plan be closed?

- A. Never, a Control Plan is a living document
- B. As soon as the Champion signs off
- C. Within 30 days of the LSS project review team meeting
- D. After the project has been presented at the recognition event

Answer: A

NEW QUESTION 62

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 66

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

- A. A function of $Y=f(x)$
- B. Determines incremental Growth
- C. Isolates the increase throughput
- D. Accounts for rejects and reworks

Answer: D

NEW QUESTION 71

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 75

The reason(s) for not marking the customer Specification Limits (SL) on a Control Chart is which of these? (Note: There are 4 correct answers).

- A. Process control teams should not control a process based on SLs
- B. Displaying the SLs on a Control Chart sends a wrong signal toward process control
- C. Marking the SLs on a Control Chart is against the principle of charting
- D. By marking the SLs, one can confuse the operator as to what limits are critical
- E. By using mere Control Limits the process only needs to be in Statistical Control

Answer: ABDE

NEW QUESTION 79

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 82

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 83

As a type of measurement error, Linearity describes a change in accuracy through the expected operating range of the measurement instrument.

- A. True
- B. False

Answer: A

NEW QUESTION 85

Having an Alpha of .05 and a Beta of .10 are the most common risk levels when running a Statistical test.

- A. True
- B. False

Answer: A

NEW QUESTION 89

The following Business Case is constructed properly.

“In business unit A there are too many flashlight returns and flashlight sales have decreased by 25 percent.”

- A. True
- B. False

Answer: B

NEW QUESTION 94

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 96

When a Belt applies the practice of Poka-Yoke to a project challenge she is attempting to make certain the activity is _____.

- A. Well documented
- B. Removed from the line
- C. Mistake proofed
- D. Highly visible

Answer: C

NEW QUESTION 98

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 101

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 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. If the Standard Deviation is uncontrollable then the other option to increase the probability of coming in on time via personal vehicles to work could be _____ ?

- A. Increase the average time of commute
- B. Maintain the average time of commute and change route to work
- C. Reduce average commute time to work by departing earlier
- D. Change policy at work and request for flexible times based on location

Answer: C

NEW QUESTION 102

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 105

A Lean Principle that addresses efficiency by the process worker is called _____?

- A. Visual Factory
- B. Supervising
- C. Training
- D. Standardizing

Answer: D

NEW QUESTION 107

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 112

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 117

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

- A. True
- B. False

Answer: A

NEW QUESTION 119

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 122

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 123

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 124

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 127

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

- A. True
- B. False

Answer: B

NEW QUESTION 129

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 133

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 134

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 139

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 142

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 147

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 152

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

- A. People
- B. Machines

- C. Supervision
- D. Engineering

Answer: A

NEW QUESTION 154

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 156

The perfect sample size is the minimum number of data points required to provide exactly 6% overlap or risk if one wants a 95% confidence level.

- A. True
- B. False

Answer: B

NEW QUESTION 158

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

- A. True
- B. False

Answer: B

NEW QUESTION 159

The X-Y Diagram is a tool used to identify/collate potential X's and assess their relative impact on multiple Y's.

- A. True
- B. False

Answer: A

NEW QUESTION 162

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 163

Process Capability is a function of which of these?

- A. Customer requirements
- B. Process performance
- C. Output over time
- D. All of these answers are correct

Answer: D

NEW QUESTION 164

For a Normal Distribution the Mean, Median and Mode are the same data point.

- A. True
- B. False

Answer: A

NEW QUESTION 165

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 167

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 172

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 176

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 179

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 181

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 184

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

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 191

After reviewing the Capability Analysis shown here select the statement(s) that are untrue.

- A. The process is properly assumed to be a Normal process
- B. The Mean of the process moving range is 1.78
- C. The process is out of Control
- D. This Capability Analysis used subgroups
- E. Majority of the dimensional values are outside of the tolerance than within

Answer: A

NEW QUESTION 193

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

- A. True
- B. False

Answer: B

NEW QUESTION 195

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 199

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 203

Select all the statements that are true after reviewing the Capability Analysis shown here. (Note: There are 4 correct answers).

- A. The process is out of Control.
- B. The process is properly assumed to be a Normal process.
- C. The Mean of the process moving range is 1.78.
- D. This Capability Analysis used subgroups.
- E. Majority of the dimensional values are outside of the tolerance than within.

Answer: BCDE

NEW QUESTION 208

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

- A. True
- B. False

Answer: A

NEW QUESTION 210

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