

ASQ.CSSBB.v2026-10-28.q123

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NEW QUESTION: 1

Which of the following measurement scales classifies data into categories with no implied order?

- A. Interval
- B. Ordinal
- C. Ratio
- D. Nominal

Answer: (SHOW ANSWER)

The correct answer is D. Nominal . The CSSBB material defines nominal data as data consisting of names or categories only and explicitly states that no ordering scheme is possible . This is the exact wording needed to answer the question. Examples include labels such as colors, departments, shipping codes, or product categories where the values are simply different classes, not ranked positions.

By contrast, ordinal data do have an implied order, even though the differences between values may not be meaningful. Interval data have ordered values with meaningful differences but no true zero, and ratio data extend interval data by including an inherent zero so ratios are meaningful. The CSSBB table of measurement scales clearly distinguishes these four types. Therefore, when the question asks for the scale that classifies data into categories with no implied order, the correct and verified answer is D. Nominal .

NEW QUESTION: 2

Sally and Sara sell flower pots at their garage sale. Martha motivates Rose mentioning that they will sell a minimum of 16 pots per day if the outside temperature exceeds 60o F. From a sample, whose population is assumed to follow a Normal Distribution, taken for 30 days at 60 degrees or more an average of 15.2 pots per day were sold with a Standard Deviation of 0.6 pots. What is the Z value for this sales process?

- A. 2.66
- B. 1.13
- C. 0.67
- D. 1.33

Answer: (SHOW ANSWER)

NEW QUESTION: 3

The English words used for the 5S's are Sorting, Straightening, _____ , _____ and Sustaining. (Note: There are 2 correct answers).

- A. Signing

- B. Shining
- C. Standardizing
- D. Shaping

Answer: B,C ([LEAVE A REPLY](#))

NEW QUESTION: 4

The quality leader responsible for the term Total Quality Management (TQM):

- A. none of the above
- B. Feigenbaum
- C. Juran
- D. Ishikawa
- E. Taguchi
- F. Crosby

Answer: B ([LEAVE A REPLY](#))

NEW QUESTION: 5

A team wants a technique for improving consistency of assembly operations. They should use:

- A. written and diagrammed work instructions
- B. flow charts and process maps
- C. relationship matrix
- D. Pareto chart
- E. cause and effect diagrams

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 6

Which of the following tools is designed to reduce cycle time?

- A. Single-minute exchange of dies (SMED)
- B. Double sampling
- C. Work in process (WIP) holding areas
- D. Statistical process control (SPC)

Answer: A ([LEAVE A REPLY](#))

The correct answer is A. Single-minute exchange of dies (SMED) . In the CSSBB Improve-phase material, SMED is presented under Lean methods / cycle time reduction . The source explains that setup reduction, also called SMED, is one of the most important Lean tools and is specifically intended to take long setup changes and reduce them to minutes . It also states that reducing setup times expands production capacity, reduces inventories, increases flexibility, and improves responsiveness.

Because setup time is a major contributor to lead time and cycle time, reducing it directly supports faster flow and shorter overall process time. The other options do not fit this purpose. Double sampling is a sampling- plan concept, WIP holding areas generally increase delay rather than reduce cycle time, and SPC is used to monitor variation and stability rather than directly shorten cycle time. In Lean Six Sigma, SMED is a classic speed and flow improvement tool. Therefore, the verified CSSBB-based answer is A. Single-minute exchange of dies (SMED) .

NEW QUESTION: 7

A team working with a plant relocation is tasked with designing a process for moving 180 pieces of equipment. Incoming orders may need to be filled during the move at either the old site or the new one. Transportation equipment availability is uncertain. Construction schedules at the new site is very weather dependent. The team designs a chart that attempts to cover these and other contingencies with appropriate measures dealing with each. The tool best fitted for this task is:

- A. Process decision program chart
- B. Activity network diagram
- C. Prioritization matrix
- D. Tree diagram
- E. Inter-relationship digraph
- F. Affinity diagram
- G. Matrix diagram

Answer: A (LEAVE A REPLY)

NEW QUESTION: 8

Find the value of (8) in the ANOVA table. Assume:

$\alpha = 0.10:$

ANOVA Table						
Source	SS	df	MS	F ratio	F crit	P-value
A&Q	1.48	1	(1)	(2)	(3)	(4)
Y	18.6	1	(5)	(6)	(7)	(8)
xxY	12.2	1	(9)	(10)	(11)	(12)
Error	2.1	4	(13)			

- A. 12.2
- B. 0.525
- C. 4.54
- D. 2.82
- E. 0.01<P<0.05
- F. 35.4
- G. 0.005<P<0.01
- H. 0.10<P<1
- I. 18.6
- J. 1.48
- K. 16.4
- L. 0<P<0.005
- M. 0.05<P<0.10
- N. 23.2
- O. 3.2

Answer: (SHOW ANSWER)

NEW QUESTION: 9

A meeting is called for all three shifts to determine the settings to be used on machine #45. This is an example of:

- A. set up time reduction (SMED)
- B. poka-yoke
- C. visual factory
- D. standard work
- E. kanban

Answer: D ([LEAVE A REPLY](#))

NEW QUESTION: 10

Which of the following elements should be included with the documentation for a process failure mode and effects analysis (PFMEA)?

- A. Flowchart
- B. Stem-and-leaf plot
- C. Quality function deployment (QFD)
- D. Hoshin planning

Answer: (SHOW ANSWER)

The correct answer is A. Flowchart . In Six Sigma and process analysis, a PFMEA is built around understanding the process steps , potential failure modes at each step, their effects, and their causes. The supporting project-documentation material identifies both updated process maps and Failure Modes and Effects Analysis (FMEA) as part of project documentation. In addition, process analysis and documentation are explicitly carried out using process mapping and flow charting .

This means a flowchart is the most appropriate companion document for a PFMEA because it shows the actual sequence of process steps where failures may occur. It helps the team ensure that no major step is overlooked and that each failure mode is tied to the correct activity in the process. A stem-and-leaf plot is a data-display tool, not a process-documentation element for PFMEA. QFD is used for translating customer requirements into design characteristics, and Hoshin planning is a strategic planning tool. Neither serves as the direct process-step reference needed for PFMEA documentation. Therefore, the best verified answer is A.

Flowchart .

NEW QUESTION: 11

When analyzing the behavior of our process to assess customer satisfaction we are concerned about both the variation such that it stays within the spec limits and how well the Mean is _____ the process requirements.

- A. Twice as great as
- B. Over and above
- C. Centered relative to
- D. Balanced against

Answer: C ([LEAVE A REPLY](#))

NEW QUESTION: 12

A visual factory has which of the following characteristics?

- A. An automated visual inspection system for finished products
- B. A display of real-time information to the workforce
- C. A positive 5S audit record
- D. A focus on departmental rather than organizational issues

Answer: B ([LEAVE A REPLY](#))

The correct answer is B. A display of real-time information to the workforce . In the CSSBB material, visual controls and the visual factory are described as methods for making the current condition of the workplace immediately visible. The text explains that production boards, schedule boards, tool boards, kanban cards, and similar devices provide management and workers with a visible display of what is happening at any moment . It also says that production boards and schedule boards are examples of a visual factory , where daily production, maintenance items, or quality problems are posted for everyone to see and understand.

The concept is broader than a single inspection system or a simple audit result. A positive 5S audit may be displayed in a visual factory, but that alone does not define it. Likewise, a visual factory does not focus narrowly on one department; instead, it helps people see process status, targets, and problems across operations. Supporting material also notes that production boards can display quality problems, delivery information, trend charts, downtime, productivity, and 5S activities, reinforcing the idea of real-time operational visibility.

NEW QUESTION: 13

Approximately what percent of the data values are smaller than the mean?

- A. 50%
- B. 75%
- C. it varies from 0% and 99+% inclusive
- D. 25%

Answer: C ([LEAVE A REPLY](#))

NEW QUESTION: 14

If an experiment has 5 factors and no replicates for a 2-level Experimental Design with 16 experimental runs which statement(s) are correct? (Note: There are 3 correct answers).

- A. The Main Effects are confounded with only 4-way interactions
- B. The Experimental Design is half-fractional
- C. The experiment has only 4 experimental runs with the 5th factor at the high level
- D. The Main Effects for the 5 factors are not aliased or confounded but the 2-way interactions are confounded with the 3-way interactions
- E. The experiment has 8 experimental runs with the first factor at the high level

Answer: A,B,E ([LEAVE A REPLY](#))

NEW QUESTION: 15

Using the values shown, what is the process yield?

- A. 0.500
- B. 0.625
- C. 0.750
- D. 0.875

Answer: B ([LEAVE A REPLY](#))

The correct answer is B, 0.625. Process yield is the proportion of units or opportunities that successfully meet the required standard without defect. In Six Sigma Measure Phase work, yield is a basic but essential performance metric because it translates raw counts of good units and total units into a normalized measure of process effectiveness. A yield of 0.625 means that 62.5% of the output met requirements. This kind of calculation is often used to establish the current baseline before more detailed analysis is performed, and it can support related metrics such as rolled throughput yield, defect rates, and sigma level estimates. Black Belts use yield to help communicate process performance in a way that is easy for both technical teams and management to understand. The calculation depends on dividing conforming output by total output based on the values provided in the figure. Once those values are interpreted correctly, the result is 0.625. Therefore, the correct answer is B, because the process produces conforming output at a rate of 62.5% under the conditions shown.

NEW QUESTION: 16

In a failure mode and effects analysis (FMEA), the focus should be on

- A. classifying as failures those items with risk priority numbers greater than 100
- B. creating flowcharts for the items with high risk priority number or occurrence values
- C. implementing corrective action on items that have high alpha risk values
- D. implementing corrective action on items that have high risk priority number or severity values

Answer: D (LEAVE A REPLY)

The correct answer is D. implementing corrective action on items that have high risk priority number or severity values . The CSSBB source explains that after assigning probability (P) , severity (S) , and detection (D) , the risk priority number (RPN) is calculated as $RPN = P \times S \times D$. It further states that actions are then based on items that either have the highest RPN or have major safety issues .

This means the team should not rely on an arbitrary cutoff like $RPN > 100$. The source also emphasizes severity separately, especially for safety-related consequences and nonconformance risk. Therefore, the practical FMEA focus is to take action on the items with the highest combined risk and on any items with very high severity, even if the total RPN is not the absolute highest. The other choices are incorrect because alpha risk is unrelated to FMEA, and creating flowcharts is not the main prioritization rule. Thus, the verified CSSBB answer is D .

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NEW QUESTION: 17

An automatic gaging system is to be installed in a process. The gage will insert data values into a data base from which machine adjustments will be made automatically. A critical factor in specifying the equipment is:

- A. adequate manual over-rides
- B. communication link between gage and computer
- C. all of the above
- D. compatibility of software in the gage and in the computer

Answer: (SHOW ANSWER)

NEW QUESTION: 18

This QFD matrix was used in the design process for a ball point pen. What symbol is appropriate for the square labeled 8?



Key:
 Strong= ⊕
 Moderate= ○
 Weak= △

	Barrel design	Cartridge design	Ink material	Clip design			
Inexpensive	1	2	3	4			
Leak proof	5	6	7	8			
Won't smear	9	10	11	12			
Easy to grip	13	14	15	16			
Clip won't break	17	18	19	20			

Answer:

NEW QUESTION: 19

When we compare short-term and long-term Capability which of these is true?

- A. Cp is better for the long-term
- B. Both short-term and long-term performance are alike
- C. Performance tends to improve over time
- D. Cp is better for the short term

Answer: D ([LEAVE A REPLY](#))

NEW QUESTION: 20

The English words used for the 5S's are Sorting, Straightening, _____, _____ and Sustaining. (Note: There are 2 correct answers).

- A. Standardizing
- B. Shining
- C. Shaping
- D. Signing

Answer: A,B ([LEAVE A REPLY](#))

NEW QUESTION: 21

Ideally, project team members should be representatives of

- A. experts in process management
- B. experts in quality improvement
- C. workers who have no vested interest in the project

D. workers from areas affected by the project

Answer: D ([LEAVE A REPLY](#))

Project team members should ideally come from the areas affected by the project because those individuals bring direct process knowledge, operational experience, and practical understanding of how the work actually occurs. In Six Sigma team management, cross-functional representation is important so that the team reflects the real process interfaces, customer impacts, handoffs, and implementation conditions. People from affected areas can identify hidden issues, validate current-state understanding, evaluate feasibility of solutions, and support adoption once changes are made. While expertise in process management or quality improvement is valuable, a successful project team cannot rely only on specialists who are detached from the work. Likewise, selecting people solely because they have no vested interest would reduce ownership and may weaken implementation success. Teams need informed participants who understand the consequences of change and can represent the voices of departments touched by the project. This helps improve buy-in, speeds problem identification, and supports more realistic decision-making. Therefore, the correct answer is D, workers from areas affected by the project, because effective Six Sigma teams are built around relevant functional representation.

NEW QUESTION: 22

A company that is selecting a Six Sigma project from four potential projects should select the one that

- A.** focuses on the area with the highest DPMO
- B.** will reduce the overall cost of quality
- C.** offers the highest production yield
- D.** is aligned with the company's strategic goals

Answer: ([SHOW ANSWER](#)**)**

The correct answer is D. is aligned with the company's strategic goals . The CSSBB project-charter and business-case material explains that the business case is a short summary of the strategic reasons for the project and that project selection should be justified in terms of quality, cost, or delivery with financial rationale. The charter guidance also emphasizes that a relevant goal must align with organizational needs and the current environment.

This means the strongest project-selection criterion is strategic alignment. A project may have high DPMO or offer yield improvement, but if it does not support the organization's priorities, it may not be the best use of Six Sigma resources. Reducing overall cost of quality can be valuable, but even that should serve the broader strategic direction of the company. In Six Sigma deployment, projects are selected not just because they are measurable or technically attractive, but because they advance business objectives. Therefore, the verified answer is D. is aligned with the company's strategic goals .

NEW QUESTION: 23

The team in the above problem draws arrows from Post-It?notes that are causes to notes that are the effects of these causes. This step is best described by which approach to problem solving?

- A.** Process decision program chart
- B.** Prioritization matrix
- C.** Tree diagram
- D.** Activity network diagram
- E.** Inter-relationship digraph
- F.** Affinity diagram
- G.** Matrix diagram

Answer: E ([LEAVE A REPLY](#))

NEW QUESTION: 24

The distance between the Mean of a data set and the Point of Inflection on a Normal curve is called the _____.

- A.** Numerical Average

- B. Data Breadth
- C. Standard Deviation
- D. Curve Spread

Answer: C ([LEAVE A REPLY](#))

NEW QUESTION: 25

Successful Six Sigma projects always:

- A. use designed experiments
- B. are completed in a short time frame
- C. all of the above E. none of the above
- D. impact the bottom line of the enterprise

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 26

The distribution is:

- A. symmetric
- B. right skewed
- C. normal
- D. uniform
- E. left skewed

Answer: B ([LEAVE A REPLY](#))

NEW QUESTION: 27

A set of data from a process has 8 readings per sample and 50 samples. The mean of the 50 sample means is 12.62. The mean of the 50 ranges is 0.18. A customer requires that SPC charts be done on their forms which have spaces for only 5 readings per sample. What should be the UCL and LCL for the new averages chart?

- A. 12.53 and 12.71
- B. 12.58 and 12.66
- C. 11.61 and 13.63
- D. none of the above

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 28

Which of these graphs demonstrates conditions which would be sufficient to enable OCAP for the process?

- A. Time Series Chart
- B. Neither
- C. Both
- D. Xbar Chart

Answer: D ([LEAVE A REPLY](#))

NEW QUESTION: 29

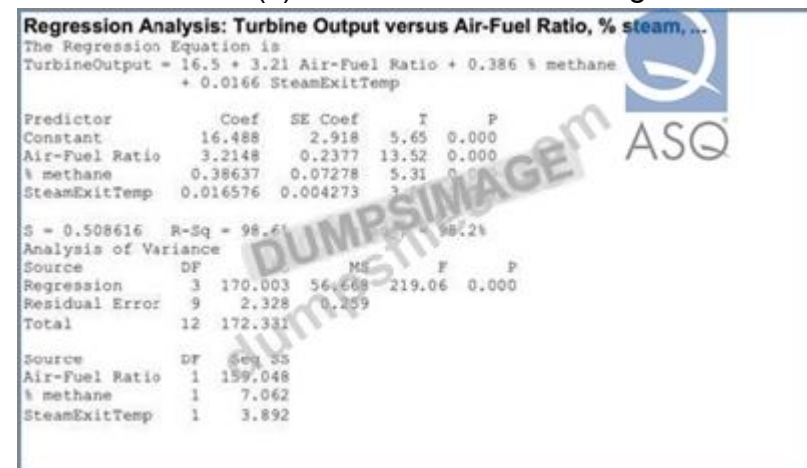
A set of data from a process has 8 readings per sample and 50 samples. The mean of the 50 sample means is 12.62. The mean of the 50 ranges is 0.18. Find the control limits for the xbar chart.

- A. 12.11 and 13.13
- B. none of the above
- C. 12.54 and 12.70
- D. 12.55 and 12.69

Answer: D ([LEAVE A REPLY](#))

NEW QUESTION: 30

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



- A. The SteamExitTemp explains the most variation of the TurbineOutput
- B. The air-fuel ratio explains most of the TurbineOutput variation
- C. If the air-fuel ratio increases by 1, the TurbineOutput more than triples
- D. The Regression explains over 98% of the process variation
- E. This Multiple Linear Regression has three statistically significant independent variables

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 31

Which of the following documents is intended to keep an improved process in place, prevent process tampering, and transfer ownership to the people who will use the new process?

- A. A control plan
- B. A control chart
- C. A process change order
- D. A failure mode and effects analysis

Answer: A ([LEAVE A REPLY](#))

The correct answer is A. A control plan . The CSSBB source states that the project control phase is necessary in order to sustain the project gains and that the control plan must remain a living document to monitor and control the process. It also says that a responsible person should be placed in charge of the control plan, and that the process owner is often the best person for that role. In the closing-phase guidance, the source specifically includes identifying the process owner , creating updated work instructions and procedures , training affected personnel , and attaining agreement between the team members and process owner .

These points directly support the idea of keeping the improved process in place and transferring ownership to those who will use and maintain it. A control chart is only one monitoring tool, not the full sustainment document. A process change order is an administrative record, and FMEA is a risk-analysis tool. Therefore, the document intended to sustain the gains, discourage tampering, and hand off responsibility is the control plan . The verified answer is A .

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<https://www.trainingdump.com/ASQ/CSSBB-practice-exam-dumps.html> (287 Q&As Dumps, **40%OFF** Special Discount: **Exam-Tests**)

NEW QUESTION: 32

Find sd:

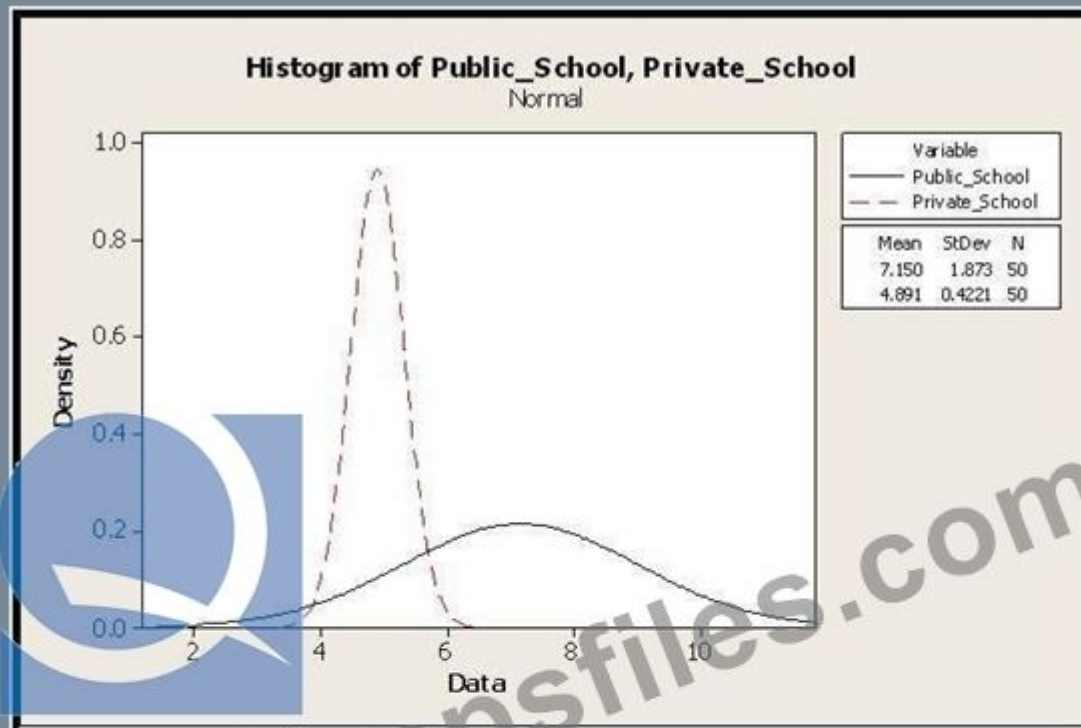
- A. 0.3502
- B. 0.2714
- C. 0.2295
- D. 0.2875

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 33

The class score distribution of schools in a metropolitan area is shown here along with an analysis output.

Comment on the statistical significance between the Means of the two distributions. Select the most appropriate statement.



Two-sample T for Private_School vs Public_School

	N	Mean	StDev	SE Mean
Private_School	50	4.891	0.422	0.060
Public_School	50	7.15	1.87	0.26

Difference = μ (Private_School) - μ (Public_School)

Estimate for difference: -2.259

99% CI for difference: (-2.985, -1.534)

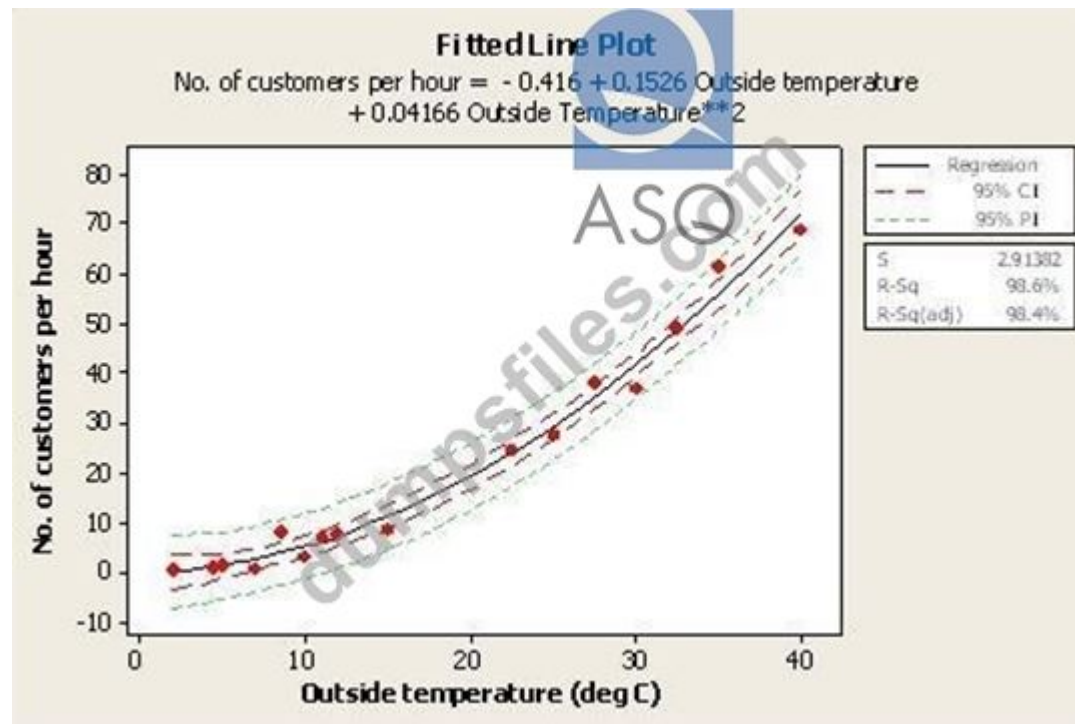
T-Test of difference = 0 (vs not =): T-Value = -8.32 p-Value = 0.000 DF = 53

- A. The two class Means statistically not different from each other
- B. A visual comparison shows that class Means are statistically different
- C. The two class Means are statistically different from each other
- D. Inadequate information on class Means to make any statistical conclusions
- E. A visual comparison shows that class Means are not statistically different

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 34

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



- A. The predicted number of customers per hour is close to 5 if the outside temperature is 10 deg C
- B. The dashed lines indicate with 95% confidence where all of the process data should fall between
- C. The dashed lines indicate with 95% confidence the estimate for the Quadratic Regression Line
- D. The relationship between outside temperature and number of customers per hour is a Linear Regression
- E. The dependent variable is the outside temperature

Answer: A,C ([LEAVE A REPLY](#))

NEW QUESTION: 35

Which of the following tools could be used during the optimize phase of a DMADOV project?

- A. Design of experiments
- B. Quality function deployment (QFD)
- C. Critical-to-quality (CTQ) tree
- D. Failure mode and effects analysis (FMEA)

Answer: ([SHOW ANSWER](#)**)**

The best answer is A. Design of experiments . The CSSBB DFSS material states that in the optimize stage of the IDOV model, the team uses process capability information, statistical tolerancing, and robust design .

Robust design and optimization commonly rely on experimental methods, and the DOE material further explains that design of experiments is used to determine settings for the inputs to optimize the response .

Although the cited optimize description is shown under IDOV, the same optimization intent carries into DMADOV , which explicitly contains an Optimize phase. Among the answer choices, DOE is the tool most directly associated with optimization. QFD and CTQ trees are primarily front-end customer-requirement tools, while FMEA is mainly used for anticipating failure modes and risk. Therefore, the tool that could be used during the optimize phase is Design of experiments , making A the verified best answer.

NEW QUESTION: 36

A Personal Trainer was assessing her workout class participants for their body fat content and had to include data for her analysis. One of the columns listed the range of weight of the people included in the studies. This required plotting a Histogram of the weight of the people assessed for their body fat content.

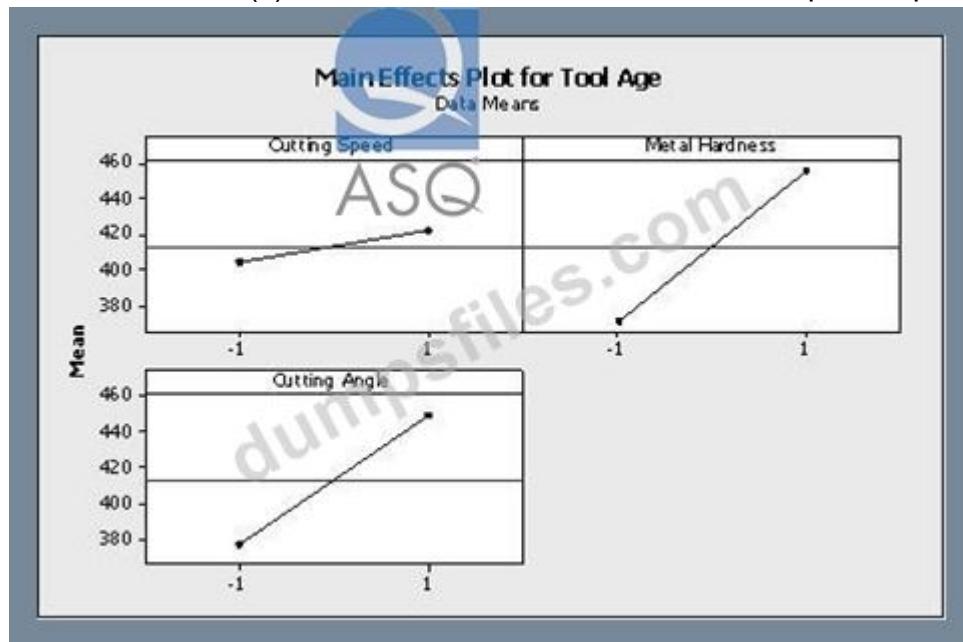
While drawing the Histogram the x-axis contained a certain scale of data. Pick the scale of data that is appropriate for Histograms.

- A. Ration Scale Data
- B. Ordinal Scale Data
- C. Nominal Scale Data
- D. Interval Scale Data

Answer: D ([LEAVE A REPLY](#))

NEW QUESTION: 37

Which statement(s) are correct about the DOE Factorial plot output here? (Note: There are 3 correct answers).



- A. Two factors were operated at 3 levels each
- B. The cutting speed and cutting angle are at the low level for the least tool age achieved
- C. All factors had 2 levels in the experiment
- D. The highest tool age was achieved with metal hardness at high level while keeping the cutting speed at the low level
- E. The design indicated above is a 32 factorial design

Answer: C,D,E ([LEAVE A REPLY](#))

NEW QUESTION: 38

A customer focus group is the most effective way for a company to

- A. measure customer satisfaction rates
- B. convert customer requirements to product specifications
- C. gain a deeper understanding of customer needs
- D. review customers' complaints

Answer: C ([LEAVE A REPLY](#))

The correct answer is C. gain a deeper understanding of customer needs. The CSSBB customer-focus material explains that organizations need a deep knowledge and understanding of the customer and must go beyond superficial feedback to uncover what customers truly want. It also states that companies can use focus groups, along with interviews and surveys, to identify customer needs and expectations. In related VOC material, focus groups are specifically listed as one of the ways a company can listen to the voice of the customer.

A focus group is especially effective for exploring perceptions, motivations, unmet needs, and reactions in depth through interactive discussion. Measuring satisfaction rates is more directly associated with surveys and quantitative metrics. Converting requirements into product specifications is the role of QFD, not the focus group itself. Reviewing complaints

provides useful feedback, but it is narrower and more reactive than exploring broader customer needs. Therefore, the most accurate CSSBB-based answer is C. gain a deeper understanding of customer needs.

NEW QUESTION: 39

As a means of measuring the effects on other areas of a process as a result of changes in the primary metric we also define and track _____.

- A. Secondary metrics
- B. Industry standards
- C. Parallel process metrics
- D. Tertiary metrics

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 40

What tool is used to identify relationships that exist between groups of data?

- A. Tree diagram
- B. Interrelationship digraph
- C. Matrix diagram
- D. Prioritization matrix

Answer: C ([LEAVE A REPLY](#))

A matrix diagram is used to identify and display relationships between groups of data, factors, functions, or variables. In the CSSBB body of knowledge, matrix diagrams are especially useful when the team needs to understand how one set of items relates to another, such as customer requirements to process steps, causes to effects, departments to responsibilities, or inputs to outputs. The strength and pattern of those relationships can often be shown clearly in matrix form, making the tool valuable in analysis and planning. A tree diagram is used to break a broad objective into smaller and smaller tasks or elements. An interrelationship digraph is used to show cause-and-effect linkages among issues, especially when relationships are complex and directional. A prioritization matrix is used to rank alternatives based on weighted criteria. Since this question asks specifically about identifying relationships between groups of data, the matrix diagram is the best fit. For Black Belts, this tool is helpful when organizing complex information and tracing linkages across categories in a systematic and visual way. Therefore, the correct answer is C, Matrix diagram.

NEW QUESTION: 41

If item A is more likely to be detected than item B which will have the highest Severity value?

- A. item A
- B. cannot be determined
- C. item B

Answer: ([SHOW ANSWER](#)**)**

NEW QUESTION: 42

What dollar amount of savings would a project show if it reduced your outstanding Accounts Receivable by \$1.4 million dollars to \$5.3 million total and your organization's marginal cost of capital was 6.2%?

- A. \$328,600
- B. \$86,800
- C. \$43,400
- D. \$117,500

Answer: B ([LEAVE A REPLY](#))

NEW QUESTION: 43

Questions that can be best answered by a Visual Factory include all of these except _____.

- A. Are setups optimized for lower scrap levels?
- B. Are unneeded tools or supplies easily noted?
- C. Can extra inventory be seen easily?
- D. Can changeover challenges be recognized?

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 44

Find sd:

- A. 0.2295
- B. 0.2714
- C. 0.2875
- D. 0.3502

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 45

Which of the following tools focuses on maximizing equipment effectiveness throughout the life of the equipment?

- A. 6S
- B. OEE
- C. TPM
- D. Jidoka

Answer: C ([LEAVE A REPLY](#))

The correct answer is C. TPM . The CSSBB source states that Total Productive Maintenance (TPM) promotes coordinated group activities for greater equipment effectiveness and lists as a key feature "efforts to maximize equipment effectiveness" along with "a system of productive maintenance for a machine's life span." That wording matches the question almost exactly. TPM is not just a metric or housekeeping method. It is a broad maintenance system involving operators, engineering, maintenance, and management to sustain equipment performance throughout its useful life. OEE is a measurement of equipment effectiveness, but TPM is the management and maintenance approach designed to maximize that effectiveness over the equipment life cycle. 6S is a workplace-organization and safety method, and jidoka is an automation concept related to stopping for abnormalities.

Therefore, the verified CSSBB answer is C. TPM .

NEW QUESTION: 46

The _____ Distribution would be the most desirable for modeling the number of stitch defects in a portion of fabric.

- A. Extended
- B. Weibull
- C. Exponential
- D. Poisson

Answer: D ([LEAVE A REPLY](#))

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NEW QUESTION: 47

An advantage of using standard deviation rather than range for measuring dispersion of a large sample is that:

- A. calculators have a standard deviation key but not a range key
- B. range calculations are not normally distributed
- C. standard deviation uses information from each measurement
- D. standard deviation has a simpler formula

Answer: C ([LEAVE A REPLY](#))

NEW QUESTION: 48

Which of the following techniques will create sample bias?

- A. Using an acceptance sampling plan for product received in a continuous flow
- B. Using stratified sampling when lots come from different machines, shifts, or operators
- C. Collecting samples from the same location in each container, rack, or bin available
- D. Collecting samples from various locations in a homogeneous population

Answer: C ([LEAVE A REPLY](#))

Collecting samples from the same location in each container, rack, or bin creates sample bias because it systematically favors one portion of the population and may fail to represent the whole. In the Measure Phase, valid data collection depends on obtaining samples that reflect the actual variation present in the population. If the same location is used repeatedly, hidden patterns such as settling, temperature gradients, stacking effects, handling differences, or location-specific defects may distort the sample. Stratified sampling across machines, shifts, or operators is usually done specifically to improve representativeness when meaningful subgroups exist. Collecting from various locations in a homogeneous population is also a sound approach because it reduces location bias. Acceptance sampling in continuous flow may be appropriate depending on the plan design and context, but the clearly biased method among the listed choices is repeatedly sampling from the same location. In Six Sigma, sampling bias is dangerous because it produces misleading conclusions and weakens all downstream analysis. Therefore, the correct answer is C, because fixed-location sampling can systematically misrepresent the true population.

NEW QUESTION: 49

All the data points that represent the total set of information of interest is called the

-
- A. Frame
 - B. Sample
 - C. Population
 - D. Spread

Answer: C ([LEAVE A REPLY](#))

NEW QUESTION: 50

Which of the following actions should be taken during the control phase of a project?

- A. Transferring responsibility to the process owner
- B. Assessing the impact on customer requirements

- C. Providing follow-up of quality function deployment by management
- D. Requiring regularly scheduled stakeholder analysis

Answer: A ([LEAVE A REPLY](#))

During the Control Phase, responsibility for the improved process should be transferred to the process owner.

This is a fundamental step in sustaining project gains after the project team completes its work. In Six Sigma, the Black Belt and team lead the analysis, improvement, and implementation effort, but long-term ownership must shift to the person or function responsible for the daily operation of the process. This transfer includes handing over control plans, documentation, monitoring methods, reaction plans, and accountability for maintaining performance. Assessing customer requirements is important earlier in the project, especially in Define and Measure. Quality function deployment is associated with translating customer needs into requirements and is not the primary Control Phase action in this question. Regular stakeholder analysis may support broader project management, but it is not the defining action at closure. The key Control objective is sustainment through operational ownership. Therefore, the correct answer is A, Transferring responsibility to the process owner, because effective control depends on embedding the improved process into normal management and daily accountability.

NEW QUESTION: 51

Choose those characteristics of a Simple Linear Regression (SLR) Analysis that are applicable.

(Note: There are 3 correct answers).

- A. A Correlation does not explain causation but a Regression Analysis with a statistically valid mathematical equation does explain causation
- B. Non-linear Regressions can explain curvature when with more statistical confidence than Linear Regressions
- C. SLR can help quantify the significance of variation in X that influences the variation in Y via a mathematical equation
- D. The Correlation Coefficient is always greater than the Regression Coefficient in a SLR
- E. General Regression Analysis deals only with Continuous Data

Answer: A,C,D ([LEAVE A REPLY](#))

NEW QUESTION: 52

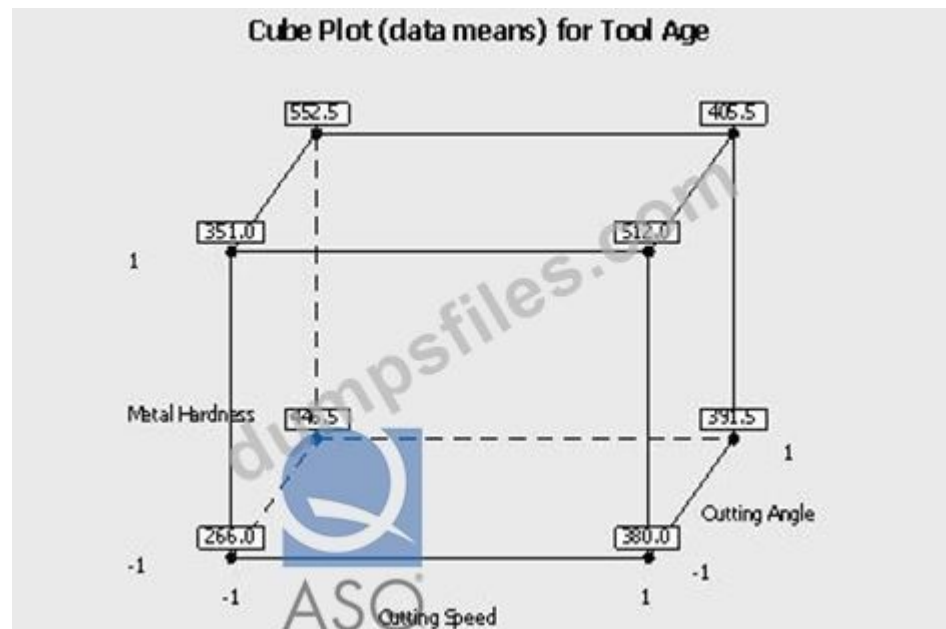
When the Inputs, X's, for your process are Normally Distributed about the Mean, the Outputs, Y's, will always be Normally Distributed.

- A. True
- B. False

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 53

Which statement(s) are correct about the Factorial Plot shown here? (Note: There are 3 correct answers).



- A. When the cutting speed increased from low to high level, the tool age increases
- B. The coefficient of the metal hardness is positively related to the output of tool age
- C. These plots prove a statistically significance factor with 95% confidence
- D. The coded coefficient is lower for cutting speed than the cutting angle related to the output of tool age
- E. These plots are an example of interaction plots

Answer: A,B,D ([LEAVE A REPLY](#))

NEW QUESTION: 54

As opposed to earlier emphases lean manufacturing tends to stress:

- A. eliminating, simplifying or reducing non-value added activities
- B. making value added activities more efficient

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 55

Which of these graphs demonstrates conditions which would be sufficient to enable OCAP for the process?

- A. Xbar Chart
- B. Time Series Chart
- C. Neither
- D. Both

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 56

Handling of warranty returns, process improvement team meetings and rework to meet customer expectations are all examples of business costs that are classified as _____.

- A. Necessary
- B. Nuisance
- C. Non-value Add
- D. Unavoidable

Answer: C ([LEAVE A REPLY](#))

NEW QUESTION: 57

Sally and Sara sell flower pots at their garage sale. Sally motivates Sara mentioning that they will sell a minimum of 22 pots per day if the outside temperature exceeds 60o F. From a sample, whose population is assumed to follow a Normal Distribution, taken for 30 days at 60 degrees or more an average of 18.2 pots per day were sold with a Standard Deviation of 0.9 pots.

What is the Z value for this sales process?

- A. 1.62
- B. 1.23
- C. 2.11
- D. 4.22

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 58

Approximately what percent of the data values are smaller than the mean?

- A. it varies from 0% and 99+% inclusive
- B. 25%
- C. 50%
- D. 75%

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 59

A dock worker for a feed supplier was tasked with assuring the proper weight in the feed bags as they left the dock. One of the columns listed the range of weight of the bags included in the studies. This required plotting a Histogram of the weight of the bags. While drawing the Histogram the x-axis contained a certain scale of data. Pick the scale of data that is appropriate for Histograms.

- A. Interval Scale Data
- B. Ordinal Scale Data
- C. Ration Scale Data
- D. Nominal Scale Data

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 60

The Mann-Whitney test is a powerful test and is unique to situations from which of the choices listed? (Note: There are 2 correct answers).

- A. Testing the identity of two populations
- B. Less powerful than the traditional "t-test"
- C. Focuses on equality of the Median of the two populations
- D. More widely applicable than the traditional "t-test"

Answer: C,D ([LEAVE A REPLY](#))

NEW QUESTION: 61

To establish a sample size that will allow the proper overlap of distributions we do which of these?

- A. Multiply Alpha by 1.75

- B. Calculate one minus Beta
- C. Calculate Beta plus 2
- D. Multiply Beta by 3

Answer: ([SHOW ANSWER](#))

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NEW QUESTION: 62

A set of data from a process has 8 readings per sample and 50 samples. The mean of the 50 sample means is 12.62. The mean of the 50 ranges is 0.18. Find the control limits for a median chart.

- A. 12.52 and 12.72
- B. 12.54 and 12.70
- C. 0.02 and 0.33
- D. none of the above

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 63

For her injection molding project a Belt needed to track the percentage of defectives of a particular sample set so she used a _____ to display the data?

- A. Individual Chart
- B. Xbar Chart
- C. C Chart
- D. P Chart

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 64

A Belt rearranged the location of the parts inventory for a rework station locating the most often used parts to be within hand reach of the repair person. This rearrangement resulted in quicker repair times by eliminating one of seven major elements of waste which is the Waste of _____.

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

Answer: C ([LEAVE A REPLY](#))

NEW QUESTION: 65

There have been some instances in which 1.5 inch sheet metal screws are used where 1.25 inch should have been used. This produces a critical defect. The decision is made to have all 1.25 inch screws have a square reduced head and all 1.5 inch screws be Phillips. This is an example of:

- A. poka-yoke

- B. set up time reduction (SMED)
- C. kanban
- D. visual factory
- E. standard work

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 66

Which of these might contribute to similar distributions having Unequal Variance?

- A. Extreme tails
- B. Outliers
- C. Multiple Modes
- D. All of the above

Answer: D ([LEAVE A REPLY](#))

Explanation/Reference:

NEW QUESTION: 67

There are 14 different defects that can occur on a completed time card. The payroll department collects 328 cards and finds a total of 87 defects. DPU =

- A. $87 / 328$
- B. $328 / 87$
- C. $14 / 87$
- D. $87 / (328 \times 14)$
- E. $87 / 14$
- F. $87 \times 1,000,000 / (14 \times 328)$

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 68

This table displays the inventory of fasteners in a storage cabinet. A bolt is selected at random from the fastener cabinet. Find the approximate probability it is size 7/8.

	size			
	.500	.625	.750	.875
Nut	146	300	74	41
Washer	280	276	29	32
Bolt	160	214	85	55

- A. .08
- B. none of the above
- C. .09
- D. 11
- E. .30

Answer: D ([LEAVE A REPLY](#))

NEW QUESTION: 69

A complex system has many causes and effects. These may be illustrated on which of the following:

- A. interrelationship digraph
- B. prioritization matrix
- C. matrix diagram
- D. tree diagram
- E. activity network diagram
- F. cause and effect diagram
- G. affinity diagram
- H. matrix diagram
- I. process decision program chart

Answer: I ([LEAVE A REPLY](#))

NEW QUESTION: 70

When a Black Belt is running a designed experiment, which of the following details can be determined only after data collection?

- A. Estimate of variance

- B. Resolution
- C. Factors
- D. Blocks

Answer: A ([LEAVE A REPLY](#))

In DOE, factors, blocks, and design resolution are determined during experiment planning, before data are collected. Factors are the independent variables selected for study, blocks are chosen to account for nuisance variation, and resolution is part of the experimental design selection. The CSSBB supplemental material explains that factors and blocks are design elements established in advance, while resolution reflects the level of confounding and is also chosen as part of the design setup. By contrast, the estimate of variance depends on the observed experimental results. The CSSBB materials describe the need for "an estimate of the inherent error variation" and place this in the context of replication, power, and post-data understanding of noise in the system. That variance estimate comes from the collected response data and is not fully known until the experiment has been run. This is fundamental in Analyze Phase thinking, because the team uses the experimental results to quantify error, assess significance, and separate signal from noise. Therefore, among the listed choices, the only item that can be determined only after data collection is the estimate of variance.

NEW QUESTION: 71

A Belt working in a supply chain environment has to make a decision to change suppliers of critical raw materials for a new product upgrade. The purchasing manager is depending on the Belt's effort requiring that the average cost of an internal critical raw material component be less than or equal to \$3,600 in order to stay within budget. Using a sample of 42 first article components, a Mean of the new product upgrade price of \$3,200 and a Standard Deviation of \$180 was estimated. Based on the data provided, the Z value for the data assuming a Normal Distribution is?

- A. 4.30
- B. 1.11
- C. 2.22
- D. 5.42

Answer: C ([LEAVE A REPLY](#))

NEW QUESTION: 72

A team working with a plant relocation is tasked with designing a process for moving 180 pieces of equipment. Incoming orders may need to be filled during the move at either the old site or the new one. Transportation equipment availability is uncertain. Construction schedules at the new site is very weather dependent. The team designs a chart that attempts to cover these and other contingencies with appropriate measures dealing with each. The tool best fitted for this task is:

- A. Inter-relationship digraph
- B. Process decision program chart
- C. Tree diagram
- D. Affinity diagram
- E. Prioritization matrix
- F. Matrix diagram
- G. Activity network diagram

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 73

Here is a partial ANOVA table. Use $\alpha = 0.05$.

Source	SS	df	MS	Fstatistic	Fcritical
A	1200	6	x	y	z
B	900	6			
A × B	180	3			
Error	100	10			

The values of x, y and z should be:

- A. 12, 1.2, 4.06
- B. 200, 20, 3.22
- C. none of the above
- D. 200, 20, 4.06

Answer: B ([LEAVE A REPLY](#))

NEW QUESTION: 74

If you can Poka-Yoke a defect out of the process entirely then you do not need use SPC on the characteristic of interest in the defect.

- A. False
- B. True

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 75

Using standard work will help increase

- A. shareholder value
- B. takt time
- C. process variation
- D. process stability

Answer: D ([LEAVE A REPLY](#))

The correct answer is D. process stability . In Lean Six Sigma, standard work defines the current best- known method for performing a task consistently. Its purpose is to reduce inconsistency in how work is done, which directly supports a more stable and predictable process. The CSSBB-aligned materials describe standard work as part of controlling and sustaining improvements by making the method repeatable and clear for operators. Standardized methods reduce variation caused by differences in technique, sequencing, and handling.

This does not increase takt time , because takt time is driven by available time and customer demand, not by documentation of the method. It also does not increase process variation ; it is used to reduce unnecessary variation. Shareholder value may benefit indirectly, but that is not the primary or most direct effect. Standard work improves repeatability, makes abnormal conditions easier to spot, supports training, and strengthens control. In the Control phase, it is one of the key ways to prevent the process from drifting back to older methods. Therefore, the best answer is D. process stability , because standard work helps the process perform the same way from one operator, shift, and cycle to the next.

NEW QUESTION: 76

The calculation of Column Total times Row Total divided by Grand Total yields expected values from what type of chart?

- A. Pareto Chart
- B. Sakami Table
- C. Contingency Table
- D. None

Answer: ([SHOW ANSWER](#))

Explanation/Reference:

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NEW QUESTION: 77

A statistical test or Hypothesis Test is performed to reject or fail to reject a stated hypothesis and it converts the Practical Problem into a Statistical Problem.

- A. True
- B. False

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 78

A population of size 1,000,000 has mean 42 and standard deviation 6. Sixty random samples, each of size 15 are selected. According to the Central Limit Theorem the distribution of the sixty sample means has a mean of approximately:

- A. 42/ 15
- B. none of the above
- C. 42
- D. 42/6
- E. 42/15

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 79

Which of these items contribute to what is necessary for successful Kaizen events?

- A. Operator support
- B. Analysis tools
- C. All of these answers are correct
- D. Management support

Answer: C ([LEAVE A REPLY](#))

NEW QUESTION: 80

A natural logarithmic base is not required for which of these distributions for probability calculations?

- A. Binomial
- B. Normal
- C. Poisson
- D. Weibull

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 81

A process improvement team will be most effective if it includes which of the following types of team members?

- A. Key stakeholders and process owners
- B. Management representatives of the affected work groups
- C. The project champion and representatives from executive management
- D. External subject matter experts

Answer: ([SHOW ANSWER](#))

The correct answer is A. Key stakeholders and process owners . In the CSSBB body of knowledge, effective Six Sigma projects depend on involving the people who are directly connected to the process and who are affected by the improvement effort. The CSSBB material states that during project preparation, organizations should identify and involve parties affected by the planned changes; these parties are called stakeholders . It also identifies process owners as one of the major Six Sigma roles, emphasizing that they have direct responsibility for the process and are essential for sustaining gains after improvement.

This makes key stakeholders and process owners the strongest team composition choice because they bring practical process knowledge, authority over implementation, and ownership of long-term control. By contrast, management representatives or executive leaders may provide support, but they are not usually the most effective core team members for day-to-day problem solving. External subject matter experts can be helpful resources, but they are generally supplemental rather than central. A strong process improvement team is most effective when it includes those who know the process best and will live with the results.

NEW QUESTION: 82

A Belt has determined that the inventory of repair parts at a rework station can be reduced by 45%.

According to Cost of Poor Quality (COPQ) definitions inventory reduction would be considered

_____.

- A. Hard Savings
- B. COPQ efficiency
- C. Median Savings
- D. Soft Savings

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 83

Which Element of Waste best describes "the unnecessary movement of materials and goods"?

- A. Motion
- B. Conveyance
- C. Overprocessing
- D. Inventory

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 84

The following control chart was developed by a continuous improvement team.



The process in this chart shows a pattern known as

- A. a shift
- B. a trend
- C. periodicity
- D. stratification

Answer: ([SHOW ANSWER](#))

The correct answer is C. periodicity . The chart shows a repeated up-and-down cycling pattern around the centerline rather than a sustained movement in one direction or a long cluster on one side of the centerline.

The CSSBB supplemental material describes a systematic variable pattern as one in which points are cycled , such as high-then-low or low-then-high. That description corresponds most closely to periodicity among the answer choices.

A shift would show a run of points staying mostly above or below the centerline. A trend would show several consecutive points steadily increasing or decreasing. Stratification refers to very small variation relative to the control limits, with points clustering unusually close to the centerline. In this chart, the more obvious signal is the regular oscillation pattern. That kind of repeating cycle often suggests a recurring external influence such as shifts, alternating methods, environmental cycles, or periodic adjustments.

Therefore, the best CSSBB-aligned answer is C. periodicity .

NEW QUESTION: 85

A team wants a technique for determining and displaying priorities based on frequency of various defect types. They should use:

- A. Pareto chart
- B. cause and effect diagrams
- C. relationship matrix
- D. flow charts and process maps
- E. written and diagrammed work instructions

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 86

The reported Cpk for a process with an average of 104 units, a spread of 18 units and upper and lower specification limits of 122 and 96 units would be?

- A. 0.5
- B. 0.89
- C. 1.00
- D. 2.00

Answer: (SHOW ANSWER)

Explanation/Reference:

NEW QUESTION: 87

Find the value of (9) in the ANOVA table. Assume:

$\alpha = 0.10$

ANOVA Table						
Source	SS	df	MS	F ratio	F crit	P-value
x	1.48	1	(1)	(2)	(3)	(4)
Y	18.6	1	(5)	(6)	(7)	(8)
xxY	12.2	1	(9)	(10)	(11)	(12)
Error	2.1	4	(13)			

- A. $0.10 < P < 1$
- B. 4.54
- C. 23.2
- D. $0 < P < 0.005$
- E. 0.525
- F. $0.01 < P < 0.05$
- G. 16.4
- H. 12.2
- I. 35.4
- J. $0.005 < P < 0.01$
- K. 18.6
- L. 3.2
- M. 1.48
- N. 2.82
- O. $0.05 < P < 0.10$

Answer: H (LEAVE A REPLY)

NEW QUESTION: 88

What conclusion is most correct about the Experimental Design shown here with the response in the far right column?

Adv	Bev	Des	Crux	Response
-1	-1	-1	-1	20
1	-1	-1	-1	14
1	1	-1	-1	17
1	-1	1	-1	10
1	-1	1	1	19
1	1	1	-1	13
-1	1	1	-1	14
1	1	1	1	10

- A. This design does not have enough experimental runs to conclude anything as evidenced by the lack of P-values in the MINITABTM output
- B. Constant, Adv and Bev are the only factors statistically affecting the response rate with 95% confidence or more
- C. No factor has enough statistical confidence greater than 95% to have an impact on the response rate
- D. If the Adv is increased from the low level to the high level, the response rate increases
- E. The response level is statistically concluded to only need the Adv and Bev factors set at the low level to get the largest response rate

Answer: E ([LEAVE A REPLY](#))

NEW QUESTION: 89

The financial perspective of a balanced scorecard provides stakeholders with an

- A. understanding of customer needs
- B. understanding of an organization's skills and capabilities
- C. overview of internal processes that have a customer focus
- D. insight into the well-being of an organization

Answer: D ([LEAVE A REPLY](#))

The correct answer is D. insight into the well-being of an organization . The balanced scorecard in the CSSBB and supporting Lean Six Sigma materials includes four perspectives: financial , customers , internal processes , and learning and growth . The financial perspective addresses how the organization is performing economically and whether strategy execution is creating business value. Additional CSSBB material on financial measures states that Six Sigma is fundamentally tied to profitability and that financial benefits are used to evaluate, prioritize, select, and track projects.

Because of that, the financial perspective gives stakeholders a picture of the organization's fiscal health, profitability, and overall business well-being. Understanding customer needs belongs to the customer perspective . Understanding skills and capabilities fits learning and growth . Reviewing internal processes with customer focus belongs to the internal process perspective . Therefore, the best answer is the one tied to the financial condition of the enterprise as a whole. In balanced scorecard terms, that means the financial perspective provides insight into the well-being of an organization , so D is the verified CSSBB-based answer.

NEW QUESTION: 90

A team has been asked to reduce the cycle time for a process.

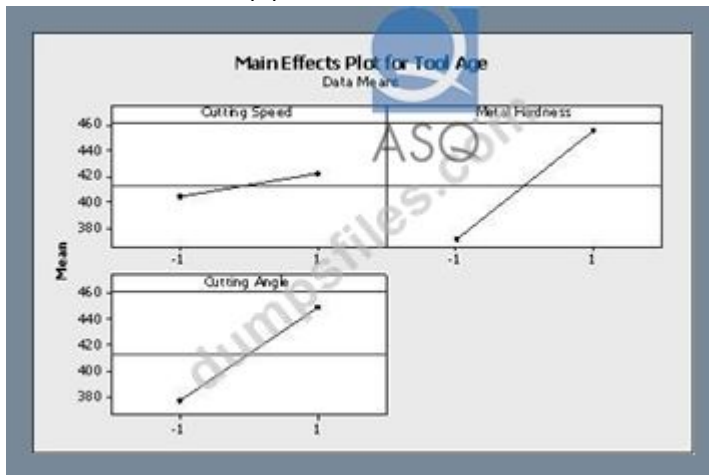
The team decides to collect baseline data. It will do this by:

- A. seeking ideas for improvement from all stakeholders
- B. researching cycle times for similar processes within the organization
- C. benchmarking similar processes outside the organization
- D. obtaining accurate cycle times for the process as it currently runs

Answer: D ([LEAVE A REPLY](#))

NEW QUESTION: 91

Which statement(s) are correct about the DOE Factorial plot output here? (Note: There are 3 correct answers).



- A. Two factors were operated at 3 levels each
- B. The design indicated above is a 32 factorial design
- C. The highest tool age was achieved with metal hardness at high level while keeping the cutting speed at the low level
- D. All factors had 2 levels in the experiment
- E. The cutting speed and cutting angle are at the low level for the least tool age achieved

Answer: B,C,D ([LEAVE A REPLY](#))

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NEW QUESTION: 92

As DMAIC projects are rolled out to process owners and staff, training needs to focus on

- A. obtaining top management support
- B. giving instruction on how to plan, administer, and control the work to top management
- C. motivating the staff to higher productivity and quality
- D. providing process owners and staff instructions on planning, doing, and controlling the process

Answer: D ([LEAVE A REPLY](#))

As improvements are implemented and transferred into daily operations, training must focus on enabling process owners and staff to run the process correctly and sustain the gains. In CSSBB Control Phase thinking, training is not just awareness-building; it is part of the control plan and supports standardization, ownership transfer, and long-term stability. Staff members need to understand what the revised process requires, how to perform the work, how to monitor it, what measures matter, and what actions to take when performance deviates from expectations. Process owners especially need instruction on planning, doing, and controlling the process so they can maintain the improved state after the project team exits. Obtaining top management support is important earlier at a strategic level, but it is not the direct focus of rollout training. Likewise, general motivation is useful but does not replace operational instruction. The most effective training during rollout is role-based and process-specific, ensuring that those responsible for daily execution can manage the improved method consistently. Therefore, the correct answer is providing process owners and staff instructions on planning, doing, and controlling the process.

NEW QUESTION: 93

The distribution of sample means will approach a normal distribution whenever the

- A. population distribution is expected to be normal
- B. population mean is centered between the specification limits
- C. sample size is sufficiently large
- D. sample mean is centered between the control limits

Answer: C ([LEAVE A REPLY](#))

The correct answer is C. sample size is sufficiently large . The CSSBB source states the Central Limit Theorem as follows: as n increases , the sampling distribution of $\bar{X}$ approaches a normal distribution with mean μ , regardless of the shape of the parent population, assuming finite variance. It further states that the distribution of sample means approaches normal regardless of the shape of the parent population .

This is a foundational concept in Six Sigma statistics because it supports many inferential methods and explains why $\bar{X}$ charts work well even when the original population is not perfectly normal. Option A is too restrictive because the theorem does not require the population itself to be normal. Options B and D confuse centering with distribution shape; being centered between specification or control limits has nothing to do with why the sampling distribution becomes normal. The key driver is the sample size . As subgroup size increases, the distribution of sample means becomes more nearly normal. Therefore, the verified CSSBB answer is C .

NEW QUESTION: 94

Find Cp

- A. 0.56
- B. 0.44
- C. 2.00
- D. 1.33

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 95

A Black Belt is managing a team that encounters an organizational problem caused by conflicting management goals. To help resolve this situation, the Black Belt should do which of the following first?

- A. Ask the team to prioritize the conflicting goals
- B. Facilitate a meeting with the managers whose goals are in conflict
- C. Instruct the team to ignore the conflict
- D. Prioritize the goals in terms of the seniority of the managers

Answer: (SHOW ANSWER)

The correct answer is B. Facilitate a meeting with the managers whose goals are in conflict . In CSSBB team management, the facilitator and team leader are expected to support conflict resolution , reinforce participation, and help the right people address issues that affect team progress. The team-meeting guidance specifically includes conflict resolution as part of effective meeting structure and asks teams to define how conflict will be managed.

Because this conflict is caused by management goals , the issue is above the team's authority level and should be addressed directly with the managers involved. Asking the team to prioritize management goals would push the team into a decision that belongs to leadership. Ignoring the conflict would allow misalignment to continue, and ranking goals by manager seniority is not a sound Six Sigma approach. The first step should be to bring the relevant managers together in a structured discussion so the competing goals can be clarified, aligned, or escalated appropriately. Therefore, the best CSSBB-based answer is B .

NEW QUESTION: 96

Company ABC provides components directly to Company XYZ, which incorporates them into its product before selling that product to the general public. Company XYZ is considered what type of customer to Company ABC?

- A. External
- B. Internal
- C. Final
- D. Distributor

Answer: A ([LEAVE A REPLY](#))

Company XYZ is an external customer to Company ABC because it is a separate organization receiving ABC's output. In Six Sigma terminology, an internal customer exists within the same organization and depends on the output of an upstream process, department, or function. An external customer exists outside the organization and receives the product, service, component, or information produced by the organization. In this case, Company XYZ purchases components from Company ABC and uses them in its own product, making XYZ an organizational customer outside ABC's internal structure. It is not the final customer because the general public ultimately buys the finished product from XYZ. It is also not necessarily a distributor, since the scenario describes incorporation into another product rather than simple resale. Understanding customer type is important in Black Belt work because customer requirements, quality expectations, and CTQs may differ between internal and external customers. Supplier-customer relationships across organizations must be managed carefully to ensure consistency, reliability, and fit-for-use performance. Therefore, the correct answer is A, External, because Company XYZ is outside Company ABC and directly receives its components.

NEW QUESTION: 97

A principle disadvantage of fractional factorial experimental designs is:

- A. confounding of effects
- B. reduced probability of type II errors
- C. improved accuracy
- D. reduced cost
- E. higher confidence level

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 98

A Belt working in a supply chain environment has to make a decision to change suppliers of critical raw materials for a new product upgrade. The purchasing manager is depending on the Belt's effort requiring that the average cost of an internal critical raw material component be less than or equal to \$2,800 in order to stay within budget. Using a sample of 55 first article components, a Mean of the new product upgrade price of \$2,240 and a Standard Deviation of \$120 was estimated. Based on the data provided, the Z value for the data assuming a Normal Distribution is?

- A. 2.33
- B. 4.67
- C. 6.48
- D. 8.28

Answer: B ([LEAVE A REPLY](#))

NEW QUESTION: 99

A complex system has many causes and effects. These may be illustrated on which of the following:

- A. process decision program chart
- B. cause and effect diagram
- C. tree diagram
- D. matrix diagram
- E. prioritization matrix

F. matrix diagram

G. activity network diagram

H. interrelationship digraph

I. affinity diagram

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 100

The preferred method for determining statistically whether factor A or B is significant requires what additional information?

Run #	A	B	Ave. Response
1	-	-	129
2	-	+	133
3	+	-	86
4	+	+	80

A. ambient conditions during the experiment

B. values of responses in replicate runs

C. blocking pattern

D. value of noise factors

E. number of repetitions

Answer: [\(SHOW ANSWER\)](#)

NEW QUESTION: 101

Using this partial Z Table, how many units from a month's production run are expected to not satisfy customer requirements for the following process?
Upper specification limit: 7.2 Lower specification limit: 4.3 Mean of the process: 5.9 Standard Deviation: 0.65 Monthly production: 450 units

- A. 7
- B. 3
- C. 12
- D. 10

Answer: D [\(LEAVE A REPLY\)](#)

NEW QUESTION: 102

Find the value of (11) in the ANOVA table. Assume:

$\alpha = 0.10$

ANOVA Table						
Source	SS	df	MS	F ratio	F crit	P-value
x	1.48	1	(1)	(2)	(3)	(4)
Y	18.6	1	(5)	(6)	(7)	(8)
xxY	12.2	1	(9)	(10)	(11)	(12)
Error	2.1	4	(13)			

Answer:

Choices Not available (but this Question Answer E)

NEW QUESTION: 103

Customers make their decisions based on Features, Integrity (of the seller) Delivery and _____?

- A. Color
- B. None
- C. Expense
- D. Season

Answer: [\(SHOW ANSWER\)](#)

NEW QUESTION: 104

A process has a specification of 5.2 ± 0.3 and yields the following data:
What is the Ppk of the process?

- A. 0.625

- B. 1.250
- C. 1.875
- D. 2.050

Answer: B (LEAVE A REPLY)

The process capability index Ppk measures how well a process is performing relative to its specification limits while accounting for how centered the process mean is. It is calculated using the formulas:

First determine the specification limits from the tolerance 5.2 ± 0.3 :

* $USL = 5.2 + 0.3 = 5.5$

* $LSL = 5.2 - 0.3 = 4.9$

Next compute both capability sides.

Upper side:

Lower side:

Ppk takes the minimum of these two values because capability is limited by the nearest specification limit.

Thus, the correct answer is A (0.625) . The process mean is closer to the upper specification limit, which reduces capability on that side and determines the overall Ppk value.

NEW QUESTION: 105

A team has calculated the following invoice processing time for accounting personnel. What is the employee' s takt time?

Time in the workday: 8 hours

Time for meetings and breaks: 1 hour

Total work time per invoice: 5 minutes

Invoices required: 60 per day

- A. 2 minutes
- B. 5 minutes
- C. 7 minutes
- D. 8 minutes

Answer: C (LEAVE A REPLY)

The correct answer is C. 7 minutes . The CSSBB material defines takt time as the available production time divided by the rate of customer demand and also gives the formula as net operating time per period

/ customer requirements per period . Here, the available work time is the 8-hour day minus 1 hour for meetings and breaks, leaving 7 hours of net operating time. Converting to minutes gives 420 minutes per day

. The customer requires 60 invoices per day , so:

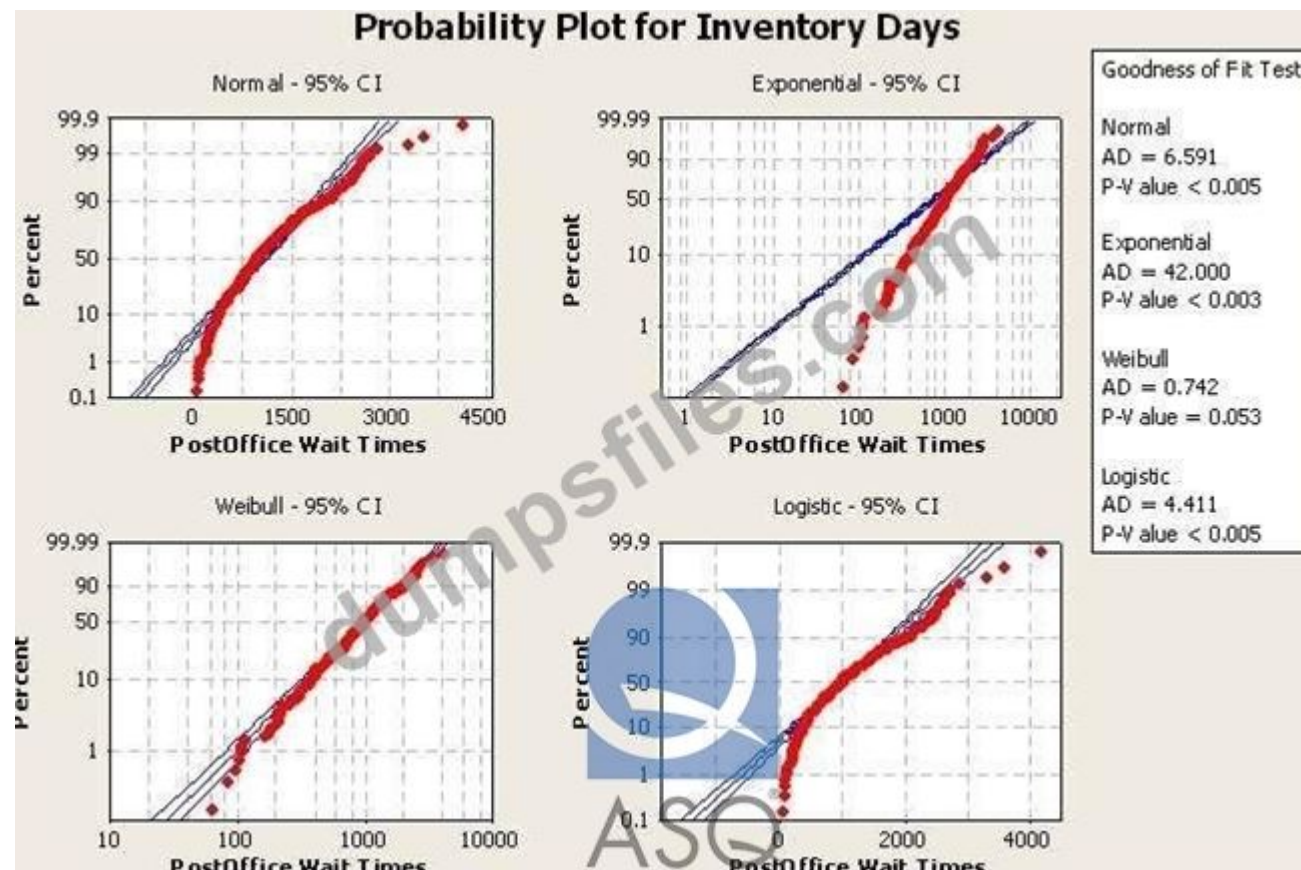
$Takt\ time = 420 / 60 = 7\ minutes\ per\ invoice$

That matches option C . The listed "total work time per invoice = 5 minutes" is useful for comparing actual process cycle time to takt time, but it is not used to calculate takt time itself.

In Lean Six Sigma, takt time reflects the pace required to meet demand , not the actual current processing time. Since the process must complete one invoice every 7 minutes to satisfy customer demand, the verified answer is 7 minutes per invoice .

NEW QUESTION: 106

A Lean Six Sigma project is attempting to reduce inventory days. The Process Capability will be monitored as part of the Control Phase to track the sustainability of the improvement.



Which distribution type is best used for performing the Capability Analysis?

- A. Weibull Distribution
- B. Normal Distribution
- C. Exponential Distribution
- D. Logistic Distribution
- E. Gaussian Distribution

Answer: ([SHOW ANSWER](#))

Explanation/Reference:

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NEW QUESTION: 107

If the probability that event A occurs is 0.51, the probability that event B occurs is 0.64 and that probability that both A and B occur is 0.23 then:

- A. events A and B are not mutually exclusive
- B. events A and B are statistically independent
- C. events A and B are supplementary
- D. events A and B are complementary
- E. events A and B are mutually exclusive

Answer: A ([LEAVE A REPLY](#))

NEW QUESTION: 108

A set of data from a process has 8 readings per sample and 50 samples. The mean of the 50 sample means is 12.62. The mean of the 50 ranges is 0.18. Find the control limits for a median chart.

- A. none of the above
- B. 12.54 and 12.70
- C. 12.52 and 12.72
- D. 0.02 and 0.33

Answer: C ([LEAVE A REPLY](#))

NEW QUESTION: 109

A normal population has a known variance of 5.9 mm². What sample size would be required to obtain a 95% confidence interval for a mean that is ±0.5 mm wide?

- A. 5
- B. 10
- C. 64
- D. 91

Answer: D ([LEAVE A REPLY](#))

The correct answer is D. 91 . The CSSBB material gives the variable-data sample-size formula for estimating a mean when the standard deviation is known or estimated:

$$n = (Z \# / E)^2$$

For a 95% confidence interval , Z = 1.96 . The population variance is 5.9 mm² , so the standard deviation is:

$$\# = \sqrt{5.9} \# 2.43$$

The desired half-width is E = 0.5 mm . Substituting:

$$n = (1.96 \times 2.43 / 0.5)^2$$

$$n \# (9.52)^2 \# 90.7$$

Since sample size must be rounded up to ensure the desired precision, the required sample size is 91 . This matches option D .

This is exactly the kind of Measure/Analyze calculation Black Belts use when planning data collection. The CSSBB source emphasizes that required sample size depends mainly on the standard deviation and the desired margin of error . Therefore, the verified answer is 91 .

NEW QUESTION: 110

Proposed Six Sigma projects that are not in some way linked to organizational goals:

- A. use statistical inference
- B. should not be approved
- C. none of the above
- D. will typically be short term
- E. have a high risk of failure

Answer: B ([LEAVE A REPLY](#))

NEW QUESTION: 111

A project whose definition does not include performance metrics:

- A. have a high risk of failure
- B. use statistical inference

- C. will typically be short term
- D. should not be approved
- E. none of the above

Answer: D ([LEAVE A REPLY](#))

NEW QUESTION: 112

If a Six Sigma project was to reduce changeover times and the team found the project success was decreasing over time since changeover times began to creep back up, which Lean tools should be considered in the Control Phase to reestablish and sustain the project success?

- A. Improve the lighting to assure adequate visibility
- B. Confirm a Visual Factory exists to assure proper communication of status of machines
- C. Implement Kanbans to assure enough inventory for the process step
- D. Reword the standardized work instructions to use active verbs and not passive phrases

Answer: ([SHOW ANSWER](#))

NEW QUESTION: 113

Which of the following levels of the work breakdown structure (WBS) includes an explanation of the purpose of the project?

- A. Project
- B. Phase
- C. Activity
- D. Task

Answer: A ([LEAVE A REPLY](#))

The correct answer is A. Project . The CSSBB material explains that the work breakdown structure (WBS) expands the project or statement of work into a detailed listing of activities required to complete the work.

This means the highest level of the WBS is the project itself , and that top level carries the overall objective, scope, and purpose. Lower levels such as phases, activities, and tasks are breakdown elements used to organize and execute the work, but they do not define the fundamental purpose of the project.

The CSSBB source also describes a project as a series of activities and tasks with a specified objective , along with starting and ending dates and necessary resources. That objective is what explains the reason or purpose for the effort. Once the project is defined, the WBS decomposes it into smaller pieces for planning and control. Therefore, the explanation of the project's purpose belongs at the project level , not at the phase, activity, or task level. In Six Sigma project management, this top-level definition aligns with the charter and statement of work, making Project the correct answer.

NEW QUESTION: 114

When we gather information for the Voice of the Business we are primarily interested in information concerning the _____ of the business.

- A. Advertising budget
- B. Profitability
- C. Ownership
- D. Market share

Answer: B ([LEAVE A REPLY](#))

NEW QUESTION: 115

The average number of defects is 21.6. Find the upper control limit for the c-chart.

- A. 26.2

- B. 24.6
- C. 18.8
- D. 26.4
- E. none of the above

Answer: E ([LEAVE A REPLY](#))

NEW QUESTION: 116

A Belt is analyzing data and upon creation of the graphical analysis sees multiple modes. One of the primary reasons this could occur is because the process has experienced a _____.

- A. Sizable Measurement System error
- B. Significant change from one shift to another
- C. Catastrophic failure of some sort
- D. Any one of these

Answer: D ([LEAVE A REPLY](#))

NEW QUESTION: 117

A fundamental rule is that both Standard Deviation and Variance can be added.

- A. True
- B. False

Answer: B ([LEAVE A REPLY](#))

NEW QUESTION: 118

Special Cause Variation falls into which two categories?

- A. Attribute & Discreet
- B. Assignable & Pattern
- C. Natural & Unnatural
- D. Short Term & Long Term

Answer: B ([LEAVE A REPLY](#))

NEW QUESTION: 119

A team's goal is to improve information flow in a payroll function. They make thirty-three Post-It@ notes, each listing an issue for further investigation. After some discussion, they group them into four categories: mandated record keeping, privacy concerns, insurance concerns and transfer concerns. This grouping process is best described by which approach to problem solving?

- A. Inter-relationship digraph
- B. Affinity diagram
- C. Process decision program chart
- D. Tree diagram
- E. Prioritization matrix
- F. Matrix diagram
- G. Activity network diagram

Answer: B ([LEAVE A REPLY](#))

NEW QUESTION: 120

Which of the following roles is responsible for reviewing and approving any changes to a Six Sigma project charter?

- A. Team members
- B. Facilitator
- C. Sponsor
- D. Team leader

Answer: C ([LEAVE A REPLY](#))

The sponsor is responsible for reviewing and approving changes to a Six Sigma project charter because the sponsor owns the business commitment behind the project. In the Define Phase, the charter serves as the formal agreement on the project's purpose, business case, scope, goals, and expected impact. Any significant change to those elements can affect resources, timing, priorities, and alignment with organizational objectives.

Since the sponsor authorizes the project and provides the organizational backing needed for its success, that role must also approve any major charter revision. Team members and the team leader may recommend changes based on what they learn during project execution, and a facilitator may help structure the discussion, but they do not normally hold authority to approve charter modifications. In Black Belt practice, this governance is important because uncontrolled charter changes can lead to scope creep, confusion, and weakened accountability. Therefore, the correct answer is C, Sponsor, because that role has the responsibility and authority to confirm that any change remains aligned with the project's intended business purpose.

NEW QUESTION: 121

The most appropriate type of FMEA for a product before going into manufacturing is a _____ FMEA.

- A. Design
- B. Consumer
- C. Survey
- D. Test Process

Answer: A ([LEAVE A REPLY](#))

Explanation/Reference:

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NEW QUESTION: 122

Which of these are examples of business metrics or Key Performance Indicators commonly referred to as KPI's?

- A. No. of Units Reworked
- B. Labor Hours
- C. All of these answers are correct
- D. Defects
- E. Cycle Time

Answer: ([SHOW ANSWER](#)**)**

NEW QUESTION: 123

A Factorial Experiment based on a Level 2 Design with 6 factors would require 16 runs to fully assess the interactions.

A. True

B. False

Answer: B ([LEAVE A REPLY](#))

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