Exam Questions CLSSGB

Certified Lean Six Sigma Green Belt (CLSSGB)

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NEW QUESTION 1
A Belt gathered the following defect data for a shoe production line and wanted to assemble it into a Pareto Chart. The correct order from left to right in the chart would be:
Data: Cutting38 Forming17 Stitching56 Sealing42

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

Answer: C

NEW QUESTION 2
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
A Six Sigma tool that helps to screen factors by using graphical techniques to logically subgroup multiple discrete X's plotted against a continuous Y is known as a _____ Chart.

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

Answer: B

NEW QUESTION 5
Customers make a purchase decision based on a number of factors. In Lean Six Sigma we refer to these decision points as CTQ's which stands for _____.

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

Answer: D

NEW QUESTION 6
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 7
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 8
Measurement System Analysis is a procedure used to quantify all _____ in the method or system used for taking measurements.

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

Answer: C

NEW QUESTION 9
In the late 1980's William Smith coined the name Six Sigma for a methodology that had its origins at _____ for quality related work being done there.

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

Answer: D

NEW QUESTION 10
Contingency Tables are used to do which of these? (Note: There are 2 correct answers).

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

Answer: BE

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

A. True
B. False

Answer: A

NEW QUESTION 17
A Stable process is a process whose output is consistent over time. A primary tool used to analyze Stability would be a _____.

A. Data Forward Plot
B. Bag Plot
C. Min/Max Plot
D. Time Series Plot

Answer: D

NEW QUESTION 18
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 21
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 22
The actual experimental response data varied somewhat from what a Belt had predicted them to be. This is the result of which of these?

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

Answer: B

NEW QUESTION 23
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 24
A Belt gathered the following defect data for a shoe production line and wanted to assemble it into a Pareto Chart. The correct order from left to right in the chart would be:
Data: Cutting38 Forming17 Stitching56 Sealing42

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

Answer: C

NEW QUESTION 28
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 31
After a Belt has put data through the smoothing process which chart would be used to look for trends in the data?

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

Answer: A

NEW QUESTION 33
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 37
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 39
Which of these is Discrete data?

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

Answer: C

NEW QUESTION 44
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 45
A primary benefit of using a Multi-Vari Chart is it provides a visual presentation of two-way interactions.

A. True
B. False

Answer: A

NEW QUESTION 46
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 49
As part of a Visual Factory plan Kanban cards are created and utilized to identify areas in need of cleaning and organization.

A. True
B. False

Answer: B

NEW QUESTION 53
The Purchase Orders for Glenn Manufacturing Company were being copied by an employee and sent to four different departments yet only one department took an action based on the information in the PO. This is an example of _____.

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

Answer: C

NEW QUESTION 56
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 57
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 58
Which of these statements describe an undesirable situation when implementing SPC? (Note: There are 2 correct answers).

A. The lower Control Limit for the R chart is equal to zero
B. The Control Limits are wider than the customer specification limits
C. A process is in Statistical Control before implementation of SPC
D. Attempt to use SPC for tracking transaction times at a warehouse
E. Indication of the specification limits on the Control Chart

Answer: BE

NEW QUESTION 59
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 61
The Empirical Rule is important because it provides an estimate of the probability of an event occurring depending on the Standard Deviation from the Mean.

A. True
B. False

Answer: A

NEW QUESTION 64
Voice of the Customer is a Lean Six Sigma technique to determine _____ attributes of a product or service.

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

Answer: C

NEW QUESTION 69
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 70
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 72
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 76
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 79
The practice of utilizing Poka-Yoke is also known as _____.

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

Answer: B

NEW QUESTION 83
If the data displayed in a Histogram displays two peaks the distribution would likely be _____.

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

Answer: D

NEW QUESTION 88
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 92
Training cost $6,500 and a project required an initial investment of $47,500. If the project yields monthly savings of $3,500 beginning after 4 months, what is the payback period in months, before money costs and taxes?

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

Answer: C

NEW QUESTION 93
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 95
Standardized work instructions apply to which resource in the process of interest?

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

Answer: A

NEW QUESTION 96
The data on SPC charts are typically constructed such that they have the most recent data point on the right hand side.

A. True
B. False

Answer: A

NEW QUESTION 97
A process can be defined as a repetitive and systematic series of steps or activities where inputs are modified or assembled to achieve a _____ result.

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

Answer: C

NEW QUESTION 101
The term FMEA is an abbreviation for Failures Measure Effective Automation.

A. True
B. False

Answer: B

NEW QUESTION 103
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 104
After a Belt has put data through the smoothing process which chart would be used to look for trends in the data?

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

Answer: A

NEW QUESTION 106
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 109
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 114
Six Sigma refers to a process whose output has at least 80% of its data points within +/- 6 Standard Deviations from the Mean.

A. True
B. False

Answer: B

NEW QUESTION 117
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?

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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 118
Examples of a Visual Factory include which of these? (Note: There are 2 correct answers).

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

Answer: AC

NEW QUESTION 121
Significant variation in process performance is a consequence of several causes that can be classified using terminologies shown here. (Note: There are 2 correct answers).

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

Answer: AD

NEW QUESTION 126
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 131
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 135
A Stable process is a process whose output is consistent over time. A primary tool used to analyze Stability would be a _____.

A. Data Forward Plot
B. Bag Plot
C. Min/Max Plot
D. Time Series Plot

Answer: D

NEW QUESTION 136
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 141
The Accuracy of a Measurement System addresses _____.

A. Stability, Bias & Linearity
B. Repeatability & Reproducibility

C. Stability & Sensitivity
D. Precision & Sensitivity

Answer: A

NEW QUESTION 145
A 1-Sample t-test is used to compare an expected population Mean to a target.

A. True
B. False

Answer: A

NEW QUESTION 150
Which element of waste best describes "the unnecessary movement of materials and/or goods"?

A. Overprocessing
B. Motion
C. Conveyance
D. Correction

Answer: C

NEW QUESTION 152
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