

GAQM

CLSSBB Exam

Certified Lean Six Sigma Black Belt (CLSSBB)

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Question: 1		
A is used prima	rily to track the stability of the average value of a metric of interest.	
A. NP Chart B. Xbar-R Chart C. I-MR Chart D. C Chart		
	Answer: B	
Question: 2		
	ect a Belt needed to track the percentage of defectives of a particular to display the data?	•
A. Individual Chart		
B. C Chart C. Xbar Chart		
D. P Chart		
	Answer: D	
	.110	
Question: 3		
Which of these graphs demor process?	estrates conditions which would be sufficient to enable OCAP for the	
A. Xbar Chart		
B. Time Series Chart		
C. Neither		
D. Both		
	Answer: A	
Question: 4		

Control Charts were developed by Dr. Shewhart to track data over time. To detect Special Cause variation the Control Charts use which of these?

- A. Data shift analysis
- B. Outlier analysis methods
- C. Center Line and Control Limits
- D. None of the above

	Answe	er: C
Question: 5		
Common and	Cause Variation are the focus of Statistical Process Contro	ol.
A. Uncommon		
B. Ordinary C. Special		
D. Selective		
	Answe	er: C
Question: 6		
Special Cause Variation falls	s into which two categories?	
A. Natural & Unnatural		
B. Short Term & Long Term		
C. Assignable & Pattern		
D. Attribute & Discreet		
	Answe	 er: C
Question: 7		
Range Charts are the techni	ique used to determine if Special Causes are occurring within	tha
subgroups of the	ique useu to determine il special eduses die occurring within	tiic
2.2.0.2.2.2.2.3.3	· (C),	
A. Histograms		
B. SPC Charts		
C. NP Charts		
D. Pareto Charts		
	Answe	er: B
Question: 8		

If the production is for higher volume and monitoring and the Mean and variability is to be monitored for four machines producing product and the characteristic to be monitored is Variable Data, which SPC Chart is best to be selected?

- A. Xbar-R Chart
- B. Individual-MR Chart
- C. NP Chart
- D. CUSUM Chart

	Answer: A
Question: 9	
When a Belt Poka-Yoke's a defect out of the process entirely robust SPC system on the characteristic of interest in the defe	
A. True B. False	
	Answer: B
Question: 10	
Following the completion of a LSS project the Belt not only crease so those involved in the process know what out of spec. A. Response Plan B. Call List C. Chain-of-Command	
D. Defect Analysis Plan	Answer: A
Question: 11	
The Control Limits width varies if the sample size varies for w	hich type of chart?
B. NP Charts C. Xbar-R Charts D. Time Series Charts	
	Answer: A
Question: 12	
	.12

Which of these elements are not included in Implementation plans?

- A. Work breakdown structure
- B. Risk management plans
- C. Cost/Benefit ratios
- D. Planned audits of work completion

	Answer: C
Question: 13	

Upon completion and validation of an improvement to a process a Belt and the Project Team create a Control Plan that contains which of these?

- A. Standard operating work description of the process change
- B. Description of the monitoring system in place to assure continued compliance
- C. Summary of the targeted critical metrics for process performance measurement
- D. All of the above

Answer: D

Question: 14

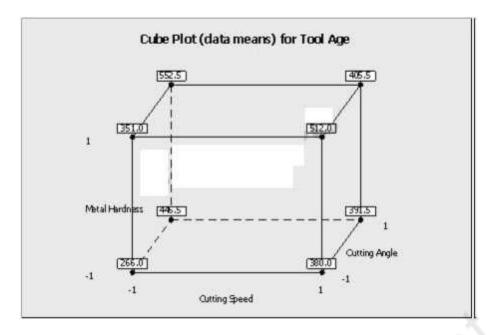
What conclusion is most correct about the Experimental Design shown here with the response in the far right column?

Adv	Bev	Des	Crux	Response
-1	-1	-1	-1	20
1	-1	-1	I.	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. No factor has enough statistical confidence greater than 95% to have an impact on the response rate
- B. Constant, Adv and Bev are the only factors statistically affecting the response rate with 95% confidence or more
- C. If the Adv is increased from the low level to the high level, the response rate increases
- D. 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
- E. This design does not have enough experimental runs to conclude anything as evidenced by the lack of P-values in the MINITABTM output

Question: 15

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. The coded coefficient is lower for cutting speed than the cutting angle related to the output of tool age
- D. These plots prove a statistically significance factor with 95% confidence
- E. These plots are an example of interaction plots

Answer: A,B,C

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