



GAQM

Exam Questions CLSSGB

Certified Lean Six Sigma Green Belt (CLSSGB)

NEW QUESTION 1

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

Data: Cutting38 Forming17 Stitching56 Sealing42

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

Answer: C

NEW QUESTION 2

The reported Cpk for a process with an average of 94 units, a spread of 22 units and upper and lower specification limits of 125 and 80 units would be?

- A. 0.64
- B. 1.27
- C. 1.84
- D. 2.12

Answer: B

NEW QUESTION 3

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

- A. True
- B. False

Answer: A

NEW QUESTION 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

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

- A. True
- B. False

Answer: B

NEW QUESTION 6

Nominal Scale data consists of names, labels or categories and cannot be arranged in any mathematical ordering scheme. Complex arithmetic functions cannot be easily applied to Nominal Data:

- A. True
- B. False

Answer: A

NEW QUESTION 7

The Z score is a measure of the distance in Standard Deviations of a sample data point from the Median of the sample population.

- A. True
- B. False

Answer: B

NEW QUESTION 8

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 9

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

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

Answer: D

NEW QUESTION 10

This output is what type of advanced Capability Analysis?

- A. Continuous
- B. Binomial
- C. Poisson
- D. Discreet
- E. DPU

Answer: B

NEW QUESTION 10

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 13

To create standardization of financial benefit calculations project savings are typically based on savings over what period of time?

- A. 6 months
- B. 12 months
- C. 24 months
- D. The remainder of the calendar year
- E. The remainder of the fiscal year

Answer: B

NEW QUESTION 15

The Alpha level of a test (level of significance) represents the yardstick against which P-values are measured and the Null Hypothesis is rejected if the P-value is which of these?

- A. Less than the Alpha level.
- B. Greater than the Alpha level.
- C. Greater than the Beta and Alpha level.
- D. Less than one minus Alpha.
- E. Less than the power of one minus Beta.

Answer: A

NEW QUESTION 17

Some of the approaches used in Lean include station warning lights, tool boards and jidohka devices in order that which of these apply?

- A. Workers do not utilize individual methods of cleaning
- B. Problems are made highly visible
- C. Work stoppages are documented properly
- D. Lessen the amount of employee pilferage

Answer: B

NEW QUESTION 21

With the use of Statistics we define the population to be a large enough sample set of data such that you can analyze it and draw conclusions as to all of the data.

- A. True
- B. False

Answer: B

NEW QUESTION 25

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 26

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

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

Answer: A

NEW QUESTION 27

Process Capability is a function of which of these?

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

Answer: D

NEW QUESTION 30

The Central Limit Theorem helps us understand the _____ we are taking and is the basis for using sampling to estimate population parameters.

- A. Analysis
- B. Kurtosis
- C. Risk
- D. Route

Answer: C

NEW QUESTION 31

What is the Cycle Time, in minutes, for a process having a Throughput of 360 units per hour?

- A. 0.167
- B. 0.333
- C. 0.667
- D. 1.333

Answer: A

NEW QUESTION 35

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

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

Answer: A

NEW QUESTION 38

Multiple Linear Regressions (MLR) is best used when which of these are applicable? (Note: There are 3 correct answers).

- A. Non-linear relationships between the inputs X's and output Y
- B. Uncertainty in the slope of the linear relationship between an X and a Y
- C. Relationships between Y (output) and more than one X (Input)
- D. Preventing the use of a Designed Experiment if unnecessary
- E. We assume that the X's are independent of each other

Answer: CDE

NEW QUESTION 40

A Belt will occasionally do a quick experiment referred to as an OFAT which stands for _____ .

- A. Only a Few Are Tested
- B. Opposite Factors Affect Technique

- C. One Factor At a Time
- D. Ordinary Fractional Approach Technique

Answer: C

NEW QUESTION 42

When it comes to Control one of the most effective means of eliminating defects is to _____.

- A. Train personnel often and thoroughly
- B. Keep a Six Sigma project going on the process at all times
- C. Design defect prevention into the product
- D. Have each process consist of no more than five steps

Answer: C

NEW QUESTION 43

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 47

For the data shown here a Belt suspects the three grades are supplying the same results. Which statement(s) are true for proper Hypothesis Testing?

- A. The most appropriate Central Tendency to test is the Means
- B. An appropriate test to test Central Tendency is the Levene's test
- C. An appropriate test to test Central Tendency is the ANOVA test
- D. An appropriate test to test Central Tendency is the Mood's Median test

Answer: D

NEW QUESTION 48

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 50

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

- A. True
- B. False

Answer: A

NEW QUESTION 53

One of the metrics commonly used in Lean Six Sigma is DPU. This acronym stands for _____.

- A. Deferred planned usage
- B. Defects per unit
- C. Decreased production utilization
- D. Downtime per unit

Answer: B

NEW QUESTION 55

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

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

Answer: C

NEW QUESTION 60

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

- A. Interaction
- B. Oddity

- C. Coincidence
- D. Impossibility

Answer: A

NEW QUESTION 63

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

- A. True
- B. False

Answer: A

NEW QUESTION 68

According to a manager it takes an average weekday commute of 39 minutes with a Standard Deviation of 7 minutes for the employees to get to work while they use their personal vehicles for their office commute while the management set a policy of not more than 40 minutes for their daily one-way commute. A survey conducted one day on 70 employees showed an average of 34 minutes commuting time using the metro public transportation system with a Standard Deviation of 21 minutes. If the Standard Deviation is uncontrollable then the other option to increase the probability of coming in on time via personal vehicles to work could be _____ ?

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

Answer: C

NEW QUESTION 72

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 74

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 78

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

- A. True
- B. False

Answer: A

NEW QUESTION 83

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

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

Answer: A

NEW QUESTION 87

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 90

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 94

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 97

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

- A. A function of $Y=f(x)$
- B. Accounts for losses due to rework and scrap
- C. Isolates the increase throughput
- D. Determines incremental Growth

Answer: B

NEW QUESTION 101

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 104

The deviation of the measured value from the actual value regardless of the operator is known as _____.

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

Answer: B

NEW QUESTION 109

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 111

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 116

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 119

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

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

Answer: A

NEW QUESTION 121

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

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

Answer: A

NEW QUESTION 122

The difference between the largest observation and the smallest observation in the data set is known as the _____.

- A. Breadth
- B. Range
- C. Spread
- D. Median

Answer: B

NEW QUESTION 123

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

- A. True
- B. False

Answer: B

NEW QUESTION 125

Inferential Statistics is largely about Significance. There are both Practical and _____ Significance to consider during an analysis of data in a Lean Six Sigma project.

- A. Problematic
- B. Impractical
- C. Usable
- D. Statistical

Answer: D

NEW QUESTION 130

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

- A. True
- B. False

Answer: A

NEW QUESTION 133

Process Capability is a function of which of these?

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

Answer: D

NEW QUESTION 134

The Lean Principle action in the 5S approach that deals with having those items needed regularly at hand and those items need less regularly stored out of the

way is known as _____.

- A. Shining
- B. Standardizing
- C. Sustaining
- D. Sorting

Answer: D

NEW QUESTION 138

Bias in Sampling is an error due to lack of independence among random samples or due to systematic sampling procedures.

- A. True
- B. False

Answer: A

NEW QUESTION 140

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

- A. True
- B. False

Answer: A

NEW QUESTION 143

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 147

Nominal Scale data consists of names, labels or categories and cannot be arranged in any mathematical ordering scheme. Complex arithmetic functions cannot be easily applied to Nominal Data:

- A. True
- B. False

Answer: A

NEW QUESTION 149

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

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

Answer: D

NEW QUESTION 151

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

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

Answer: D

NEW QUESTION 153

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 156

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

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

Answer: B

NEW QUESTION 157

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

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

Answer: ACDE

NEW QUESTION 158

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 162

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 164

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 169

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

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

Answer: B

NEW QUESTION 174

If a Histogram displays two peaks the distribution would likely be _____.

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

Answer: C

NEW QUESTION 177

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 179

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

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

Answer: A

NEW QUESTION 181

According to a manager it takes an average weekday commute of 39 minutes with a Standard Deviation of 7 minutes for the employees to get to work while they use their personal vehicles for their office commute while the management set a policy of not more than 40 minutes for their daily one-way commute. A survey conducted one day on 70 employees showed an average of 34 minutes commuting time using the metro public transportation system with a Standard Deviation of 21 minutes. If the Standard Deviation is uncontrollable then the other option to increase the probability of coming in on time via personal vehicles to work could be _____?

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

Answer: C

NEW QUESTION 183

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 184

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

- A. True
- B. False

Answer: A

NEW QUESTION 189

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 193

In order to standardize project savings financial calculation such project benefits can be compared the financial savings are typically calculated over what period of time?

- A. 12 months
- B. 24 months
- C. The remainder of the calendar year
- D. The remainder of the fiscal year

Answer: A

NEW QUESTION 194

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