

ICGB.95q

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IASSC Lean Six Sigma – Green Belt

Exam A

QUESTION 1

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



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- 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

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 2

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:



Explanation:

QUESTION 3

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

Correct Answer: CDE

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 4

Fractional Factorial designs for an experimental approach are used when _____ about the multiple metric interaction in a process.

- A. Much is known
- B. Little is known
- C. We don't care
- D. Data exists

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 5

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 6

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

Regression Analysis: HeatFlux versus %Cu, Thickness

The Regression Equation is

$$\text{HeatFlux} = 484 + 4.80 \% \text{Cu} - 24.2 \text{ Thickness}$$

Predictor	Coef	SE Coef	T	P
Constant	483.67	39.57	12.22	0.000
%Cu	4.7963	0.9511	5.04	0.000
Thickness	-24.215	1.941	-12.48	0.000

S = 8.93207 R-Sq = 85.9% R-Sq(adj) = 84.8%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	2	12607.6	6303.8	79.01	0.000
Residual Error	26	2074.3	79.8		
Total	28	14681.9			

Source	DF	Seq SS
%Cu	1	184.5
Thickness	1	12423.1

Unusual Observations

Obs	%Cu	HeatFlux	Fit	SE Fit	Residual	St Resid
1	40.6	271.80	274.74	5.08	-2.94	-0.40 X
22	36.3	254.50	230.91	2.39	23.59	2.74R

R denotes an observation with a large standardized residual.

X denotes an observation whose X value gives it large influence.

- 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.

Correct Answer: AD

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 7

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

- A. True
- B. False

Correct Answer: A

Section: (none)

Explanation

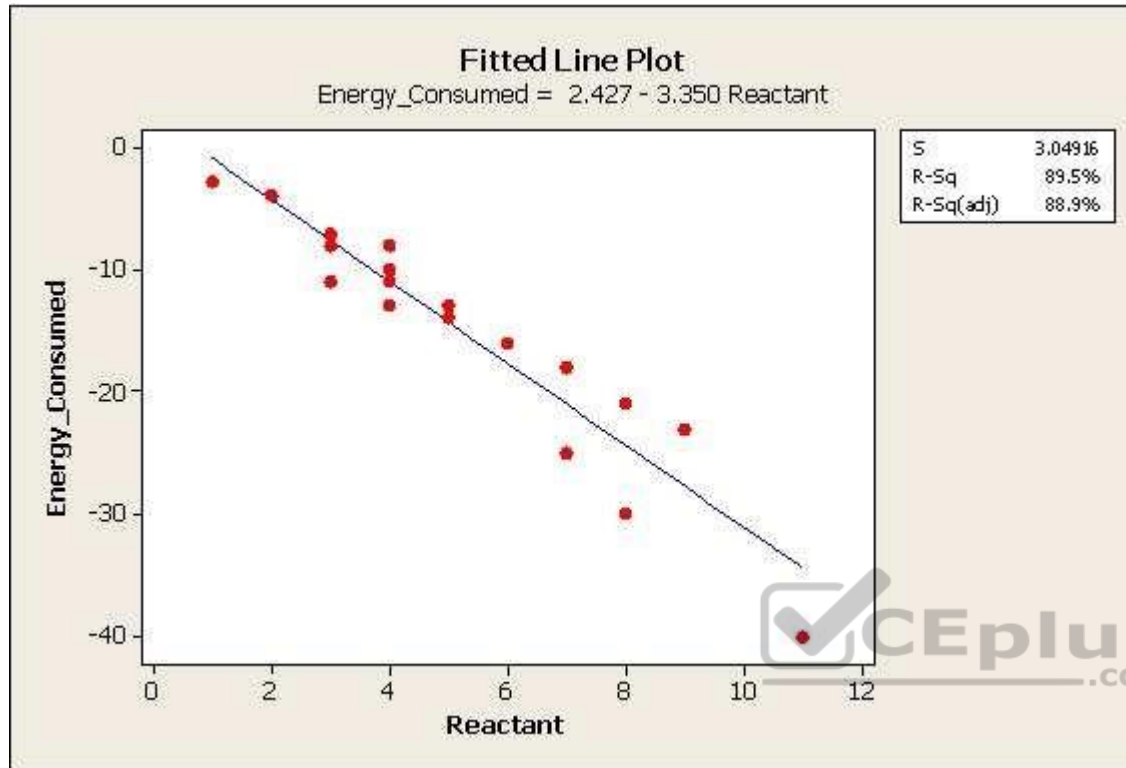
Explanation/Reference:

Explanation:

QUESTION 8

Which statement(s) are true about the Fitted Line Plot shown here? (Note: There are 2 correct answers).





- A. When Reactant increases, the Energy Consumed increases.
- B. The slope of the equation is a positive 130.5.
- C. The predicted output Y is close to -18 when the Reactant level is set to 6.
- D. Over 85 % of the variation of the Energy Consumed is explained by the Reactant via this Linear Regression.

Correct Answer: CD

Section: (none)

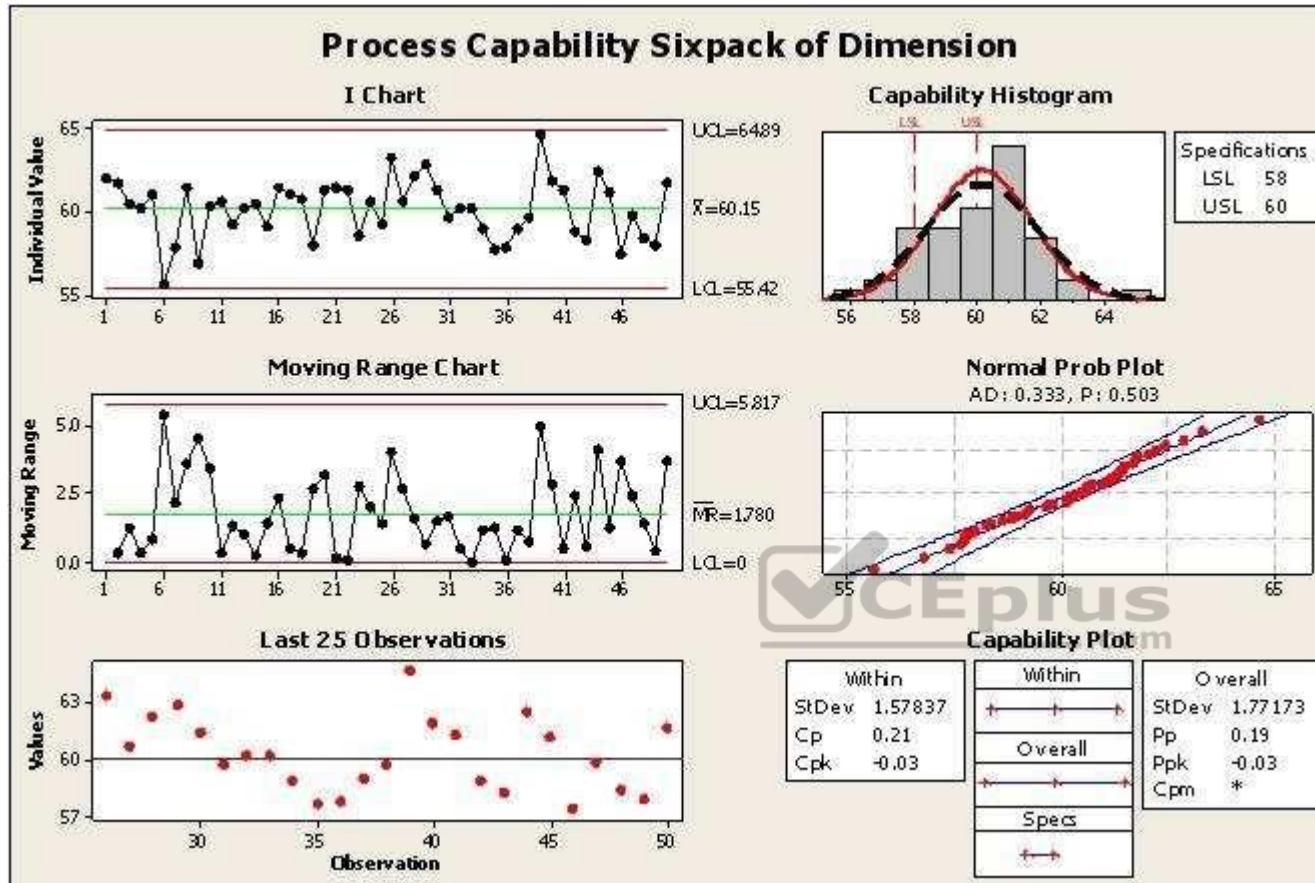
Explanation

Explanation/Reference:

Explanation:

QUESTION 9

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

Correct Answer: A

Section: (none)

Explanation**Explanation/Reference:**

Explanation:

QUESTION 10

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

Correct Answer: B

Section: (none)

Explanation**Explanation/Reference:**

Explanation:

QUESTION 11

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 them
- E. When it is very expensive or too late to measure the output

Correct Answer: ACDE

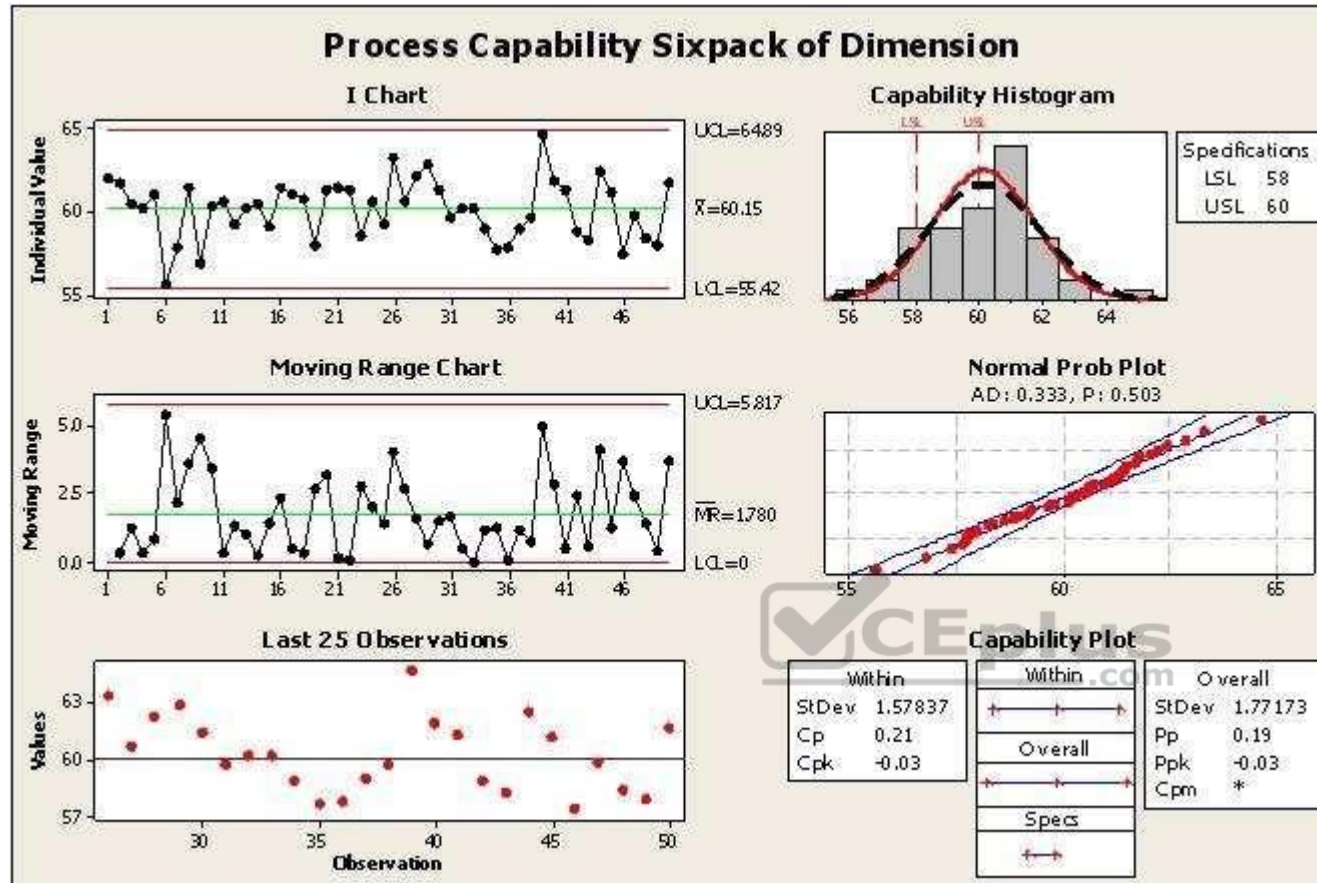
Section: (none)

Explanation**Explanation/Reference:**

Explanation:

QUESTION 12

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



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

Correct Answer: BCDE

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 13

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 14

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

- A. True
- B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 15

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

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 16

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

A. True

B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:



QUESTION 17

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

A. True

B. False

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 18

A Belt experienced an Alpha of .05 and a Beta of .10 and knew these are the most common risk levels when running a Statistical test.

A. True

B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 19

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

Correct Answer: D

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 20

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



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A. Analysis

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 21

Hypothesis Tests determine the probabilities of differences between observed data and the hypothesis being solely due to _____ based on the result of the Pvalues.

- A. Human error
- B. Measurement error
- C. Shift differences
- D. Chance

Correct Answer: D

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 22

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.

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 23

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 24

When a Belt is analyzing sample data she should keep in mind that 95% of Normally Distributed data is within +/- 2 Standard Deviations from the Mean.

A. True

B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 25

The Standard Deviation for the distribution of Means is called the _____ and approaches zero as the sample size reaches 30.

A. Standard Error

B. Mean Deviation

C. Mean Spread

D. Mean Error

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 26

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 27

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 28

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

Correct Answer: D

Section: (none)

Explanation



Explanation/Reference:

Explanation:

QUESTION 29

For the data shown here a Belt suspects the three grades are supplying the same results.

Grade A	Grade B	Grade C
0.917	1.1	0.63
0.68	0.173	4.17
1.74	0.24	0.6
0.3	0.67	0.84
0.33	6.94	0.22
4.13		

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

Correct Answer: D

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 30

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

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 31

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 32

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

- A. True
- B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 33

Hypothesis Tests determine the probabilities of differences between observed data and the hypothesis being solely due to chance. This is determined based on the result of the _____.

- A. Random acts
- B. P-values
- C. Standard Deviations

D. R-values

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 34

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

A. True

B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:



QUESTION 35

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

A. True

B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 36

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

A. True

B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 37

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

- A. True
- B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 38

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

Correct Answer: BE

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 39

The higher the sigma level of a process the better the performance.

- A. True
- B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 40

The Six Sigma methodology had its origins at _____ in the late 1980's when William Smith coined the name for quality related work being done there.

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

Correct Answer: A

Section: (none)

Explanation



Explanation/Reference:

Explanation:

QUESTION 41

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 42

Lean Six Sigma's general approach to solving significant challenges related to a process is called _____.

- A. DOE
- B. SIPOC
- C. DMAIC
- D. FMEA

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 43

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 44

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%

Correct Answer: D

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 45

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

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:



QUESTION 46

Customers make a purchase decision based on a number of factors. In Lean Six Sigma we refer to these decision points as CTQ's or as _____.

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

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 47

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 48

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



Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 49

The following Business Case is constructed properly.

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

- A. True
- B. False

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 50

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 51

The essence of Lean is to concentrate effort on removing waste while improving process flow to achieve speed and agility at lower cost.

- A. True
- B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 52

Lean had its origins in the development and practice of the _____ Production System.



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- A. Honda
- B. Toyota
- C. Ford
- D. Motorola

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:



QUESTION 53

Lean removes many forms of _____ so Six Sigma can focus on reducing _____.

- A. Waste, variability
- B. Inventory, defects
- C. Waste, cost
- D. Movement, variation

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 54

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

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 55

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

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



Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 56

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

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 57

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

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:



QUESTION 58

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

B.

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 59

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

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

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:



QUESTION 60

The 5 Why Analysis is only useful if the possible independent variable can be broken down into five possible causes.

- A. True
- B. False

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 61

The purpose of a Process Map is to identify the complexity of the process and to assist in identifying critical steps in the process.

True

False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 62

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



Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

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

Correct Answer: A

Section: (none)

Explanation

A.

B.

Explanation/Reference:

Explanation:

QUESTION 64

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

A. True B.

False

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 65

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



Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 66

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 67

Long-term Data represents all the variation that one can expect within the subject process.

True

False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 68

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

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 69

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

A.

B.

Forming17

Stitching56

Sealing42

A. Forming, Sealing, Cutting, Stitching

B. Sealing, Stitching, Forming, Cutting

C. Stitching, Sealing, Cutting, Forming

D. Forming, Cutting, Sealing, Stitching

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 70

Measurement error is defined as the effect of all sources of measurement variability that caused an observed or measured value to deviate from the _____.

A. Standard Deviation

B. Mean

C. Median

D. True value

Correct Answer: D

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 71

Measurement System Analysis is a procedure used to quantify variation of the method or system used for taking measurements.

A. True

B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 72

The Accuracy of a Measurement System addresses _____.

- Stability, Bias & Linearity
- Repeatability & Reproducibility
- C. Stability & Sensitivity
- D. Precision & Sensitivity

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:



QUESTION 73

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

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 74

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

- A.

B.

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

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:



QUESTION 75

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

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 76

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



Correct Answer: D

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 77

Which of these are correct if Cpk Upper is 2.0 and Cpk Lower is 1.0?

- A. The process is not stable.
- B. The process is shifted to the left.
- C. Cpk must be reported as 1.0.

D. The process Mean is 1.5.

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 78

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

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

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:



QUESTION 79

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 80

The practice of utilizing Poka-Yoke is also known as _____.

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 81

Examples of Mistake Proofing for a laptop computer include which of these? (Note: There are 2 correct answers).

- A. USB connection for a mouse
- B. Open/Close button for CD Drive
- C. Battery alignment pins
- D. On/Off switch for computer



Correct Answer: AC

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 82

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

Correct Answer: AD

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 83

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

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

Correct Answer: ABDE

Section: (none)

Explanation

Explanation/Reference:

Explanation:



QUESTION 84

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

- A. True
- B. False

Correct Answer: A

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 85

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 86

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

Correct Answer: C

Section: (none)

Explanation



Explanation/Reference:

Explanation:

QUESTION 87

The acronym for the defined approach taken by Lean Six Sigma to solve significant challenges related to a process is which of these?

- A. DOE
- B. DMAIC
- C. SIPOC
- D. FMEA

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 88

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 89

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 90

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

Correct Answer: D

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 91

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

Correct Answer: A

Section: (none)

Explanation



Explanation/Reference:

Explanation:

QUESTION 92

The FMEA is used to analyze potential source of defects in the process of interest and stands for _____.

- A. Failure Measure for Effective Automation
- B. Failure Modes and Effect Analysis
- C. Focused Mental Efforts Analyze
- D. Failed Manufacturing Efforts Analyzed

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 93

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

Correct Answer: B

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 94

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



Correct Answer: D

Section: (none)

Explanation

Explanation/Reference:

Explanation:

QUESTION 95

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

Correct Answer: C

Section: (none)

Explanation

Explanation/Reference:

Explanation:



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