

IASSC

Exam Questions ICBB

IASSC Certified Lean Six Sigma Black Belt



NEW QUESTION 1

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

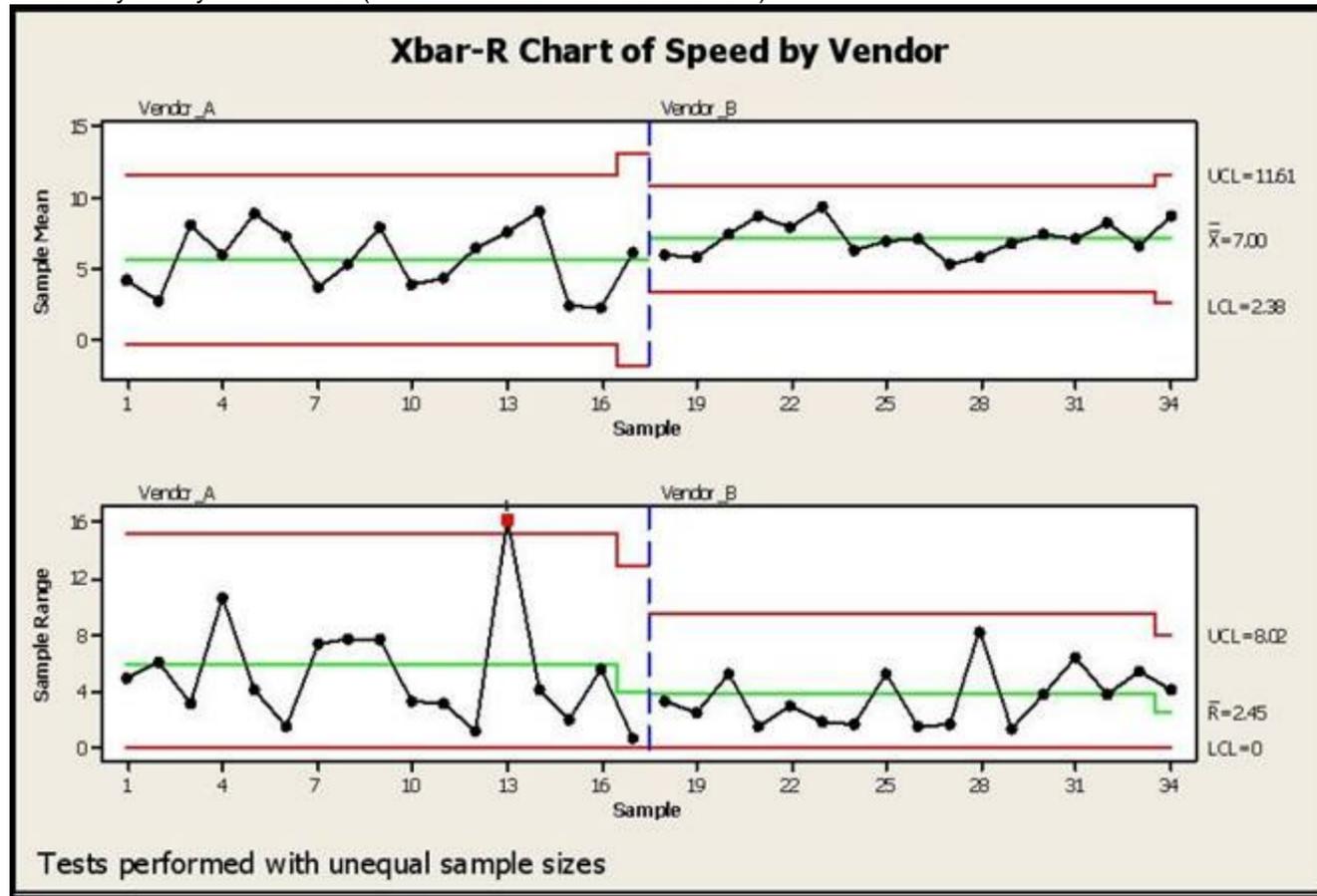
- A. Overprocessing
- B. Inventory
- C. Motion
- D. Conveyance

Answer: D

NEW QUESTION 2

SPC Charts are used extensively in different business and decision-making environments.

In this example a vendor is being selected based on speed of delivery. Which of the conclusions would help you pick a vendor for your needs regarding lead-time of delivery from your vendors?(Note:There are 4 correct answers).



- A. Vendor A with a much shorter lead time in delivery
- B. Vendor B as it has a better consistency (lower variance) on lead time
- C. Vendor B since Vendor A shows a situation out of control as shown in red
- D. Vendor B since the Control Limits are much narrower than Vendor A
- E. Vendor B has higher lead time, but a process with much narrower Control Limits

Answer: BCDE

NEW QUESTION 3

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. Market share
- C. Profitability
- D. Ownership

Answer: C

NEW QUESTION 4

The Japanese born function of a Kaizen event utilizes a specific, step-by-step approach meant to bring about major changes to a process.

- A. True
- B. False

Answer: A

NEW QUESTION 5

Appropriate measures means that measurements are _____.

- A. Representative
- B. Sufficient
- C. Contextual
- D. Relevant

E. All of these answers are correct

Answer: E

NEW QUESTION 6

A Full Factorial experiment using a 3 level 3 factor approach has been proposed to test the viability of an extrusion machine experiment. How many treatment combinations will this approach involve?

- A. 6
- B. 9
- C. 27
- D. 54

Answer: C

NEW QUESTION 7

A Process Map is created in order that a Belt can _____.

- A. Follow the product to the end
- B. Get the line people's names correct
- C. Capture all the activities comprising the process
- D. Manage the input inventory delivery schedule

Answer: C

NEW QUESTION 8

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. True
- B. False

Answer: A

NEW QUESTION 9

A valid Multiple Linear Regression (MLR) is characterized by all of these except?

- A. It is an assumption that the X's (inputs) are not correlated to each other
- B. The X's (inputs) are assumed to be independent of each other
- C. The Residuals from MLR analysis have to be Normally Distributed
- D. MLR is conducted based on a deliberate form of experimentation
- E. It is not possible to evaluate interactions in a MLR analysis

Answer: D

NEW QUESTION 10

Data that can be measured on a continuum and has meaningful decimal subdivisions are _____ data.

- A. Continuous
- B. Surplus
- C. Discrete
- D. Variable

Answer: A

NEW QUESTION 10

The _____ is the most frequently occurring value in a distribution of data.

- A. Median
- B. Mean
- C. Mode
- D. Center Point

Answer: C

NEW QUESTION 15

On a _____ a Belt screens variables, or various inputs, to analyze their relative impact on the output of concern.

- A. X-Y Matrix
- B. Weighted Scale
- C. Multi-Vari Chart
- D. Poisson Chart

Answer: C

NEW QUESTION 19

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

NEW QUESTION 22

In a Fishbone Diagram the 6M's stand for Methods, _____, Machine, Man, Mother Nature and Materials.

- A. Measurements
- B. Merger
- C. Management
- D. Medical

Answer: A

NEW QUESTION 27

Range Charts are the technique used to determine if _____ are occurring within the subgroups of the SPC Charts.

- A. Common Causes
- B. Special inspections
- C. Unnatural forces
- D. Special Causes

Answer: D

NEW QUESTION 28

When conducting a Hypothesis Test using Continuous Data the proper sample size is influenced only by the extent to which we need to assess a Difference to be detected but not the inherent variation in the process.

- A. True
- B. False

Answer: B

NEW QUESTION 29

Calculate the Rolled Throughput Yield of this process using this data. Data: unit input: 1215, unit output: 1180, defects repaired: 184, scrap: 42

- A. 80.85%
- B. 81.40%
- C. 82.23%
- D. 84.96%

Answer: B

NEW QUESTION 32

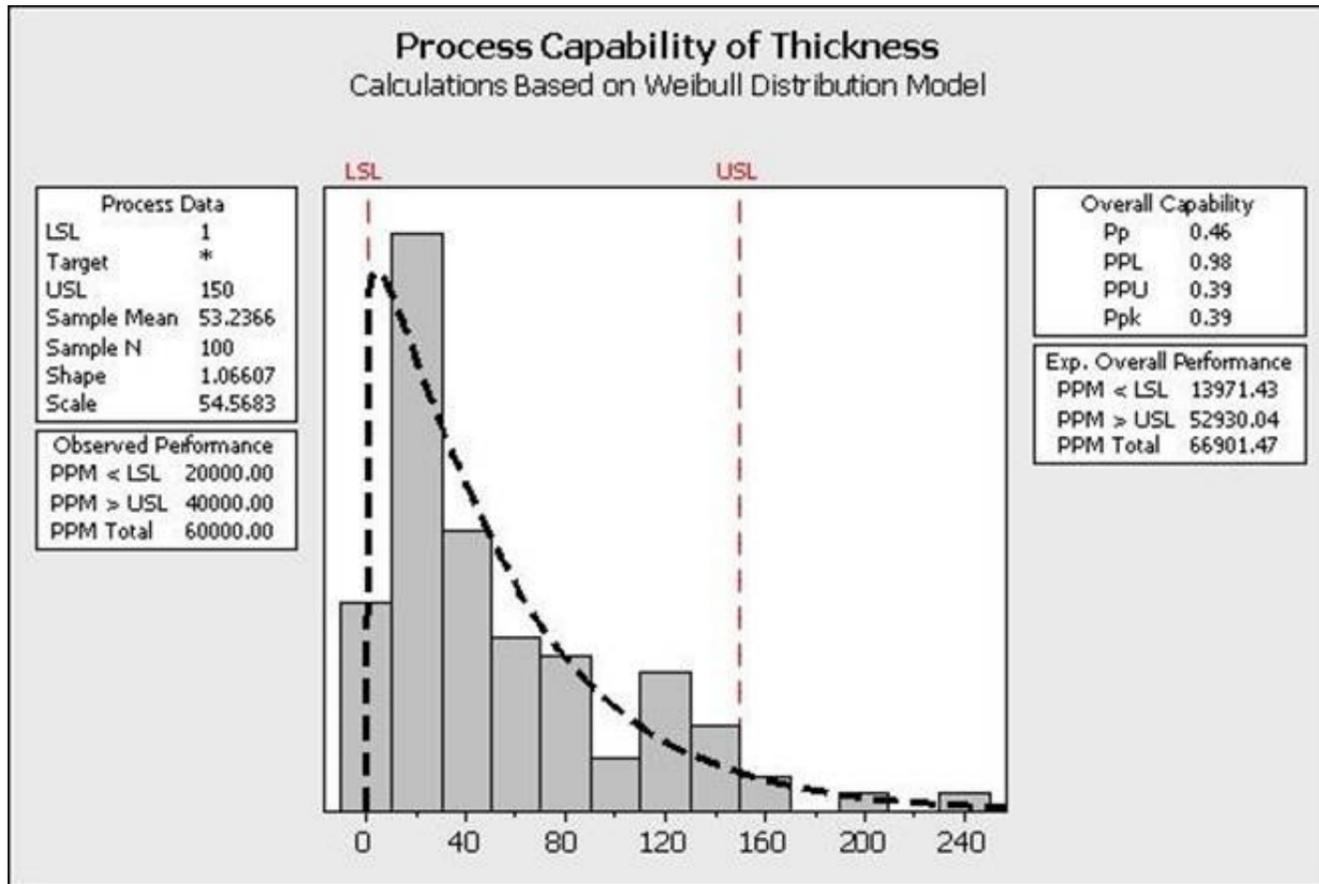
A Belt working in a supply chain environment has to make a decision to change suppliers of critical raw materials for a new product upgrade. The purchasing manager is depending on the Belt's effort requiring that the average cost of an internal critical raw material component be less than or equal to \$4,200 in order to stay within budget. Using a sample of 35 first article components, a Mean of the new product upgrade price of \$4,060, and a Standard Deviation of \$98 was estimated. Select the answer that best states the Practical Problem.

- A. If the average cost per component is \$4,200 or less, then the purchase manager will introduce the new product upgrade with new components.
- B. If the average cost per component is greater than \$4,200, then the purchase manager will introduce the new product upgrade with new components.
- C. Only if the average cost per product upgrade is \$4,060, will the purchase manager introduce new product upgrades with new components.
- D. If the average cost per new product upgrade is less than \$180, then the purchase manager will introduce the new product upgrade with new components.

Answer: C

NEW QUESTION 35

Review the analysis shown here.



Which statements are true about the process?(Note:There are 3 correct answers).

- A. The initial focus for this project would be to determine why the thicknesses are so frequently too low.
- B. The majority of the process is closer to the lower specification limit.
- C. This process is described with the Weibull Distribution.
- D. The process has more problems with Variation than Centering.
- E. The process follows a non-normal distribution with the given data.

Answer: BDE

NEW QUESTION 38

Which statement is most correct for the Regression Analysis shown here?

Regression Analysis: Turbine Output versus Air-Fuel Ratio, % steam, ...

The Regression Equation is
 $TurbineOutput = 16.5 + 3.21 \text{ Air-Fuel Ratio} + 0.386 \% \text{ methane} + 0.0166 \text{ SteamExitTemp}$

Predictor	Coef	SE Coef	T	P
Constant	16.488	2.918	5.65	0.000
Air-Fuel Ratio	3.2148	0.2377	13.52	0.000
% methane	0.38637	0.07278	5.31	0.000
SteamExitTemp	0.016576	0.004273	3.88	0.004

S = 0.508616 R-Sq = 98.6% R-Sq(adj) = 98.2%

Source	DF	SS	MS	F	P
Regression	3	170.003	56.668	219.06	0.000
Residual Error	9	2.328	0.259		
Total	12	172.331			

Source	DF	Seq SS
Air-Fuel Ratio	1	159.048
% methane	1	7.062
SteamExitTemp	1	3.892

- A. The Regression explains 50.8% of the process variation
- B. The air-fuel ratio explains most of the TurbineOutput variation
- C. This Simple Linear Regression explains 98+% of the process variation
- D. This Multiple Linear Regression has four statistically significant independent variables

Answer: B

NEW QUESTION 40

With Measurement System Analysis we are concerned with two issues that impact the potential variability of the data. They are _____.

- A. Precision and Accuracy
- B. Reliability and Repeatability
- C. Error and Spread
- D. Sensitivity and Deflection

Answer: A

NEW QUESTION 43

A valid mathematical Regression represents all of the characteristics shown except _____.

- A. All of the standardized residuals will be within ± 3 Standard Deviations
- B. The sum of the residuals is zero
- C. The residuals when plotted follow a Normal Distribution
- D. Most standardized residuals are within ± 2 Standard Deviations
- E. The Residual is equal to the difference between the observed and predicted values

Answer: A

NEW QUESTION 47

A _____ is used primarily 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

NEW QUESTION 50

Of the various types of data shown which is NOT representative of Variable Data.

- A. Child's height is 4 foot 3 inches
- B. Three employees wore hard hats
- C. Car burned 2.7 gallons of gasoline
- D. Train was going 140 kilometers per hour

Answer: B

NEW QUESTION 52

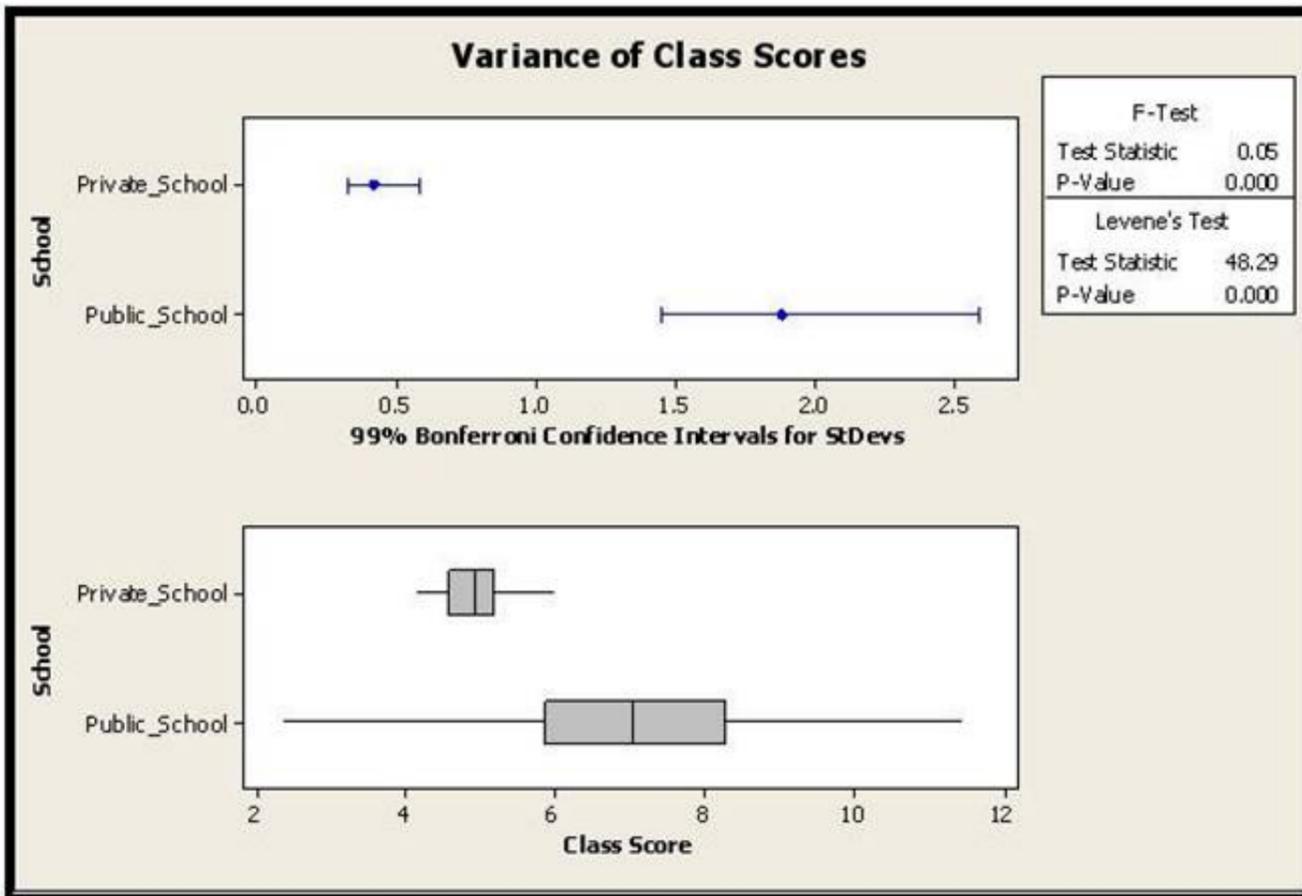
If a Six Sigma project was to reduce repair station inventory and the team found the inventory was creeping up over time which Lean tools should be considered in the Control Phase to reestablish and sustain the project success?

- A. Review the Visual Factory to assure inventory in excess of desired visible
- B. Improve the lighting to assure adequate visibility
- C. Analyze data from supplier deliveries
- D. Reword the standardized work instructions to use active verbs and not passive phrases

Answer: A

NEW QUESTION 55

From the variance F-test shown above, which of these conclusions is/are valid?



Test for Equal Variances: Class Score versus School

99% Bonferroni confidence intervals for standard deviations

School	N	Lower	StDev	Upper
Private_School	50	0.32753	0.42210	0.58233
Public_School	50	1.45338	1.87303	2.58404

F-Test (Normal Distribution)

Test statistic = 0.05, p-value = 0.000

- A. The variance between the class score distribution is significantly different
- B. The variance between the class score distribution is not significantly different
- C. This test applies only to Normal Distributed data at 99 % confidence
- D. This test applies only to Non-normal Data at 99 % confidence
- E. There are not enough data points to make any statistical conclusions

Answer: A

NEW QUESTION 57

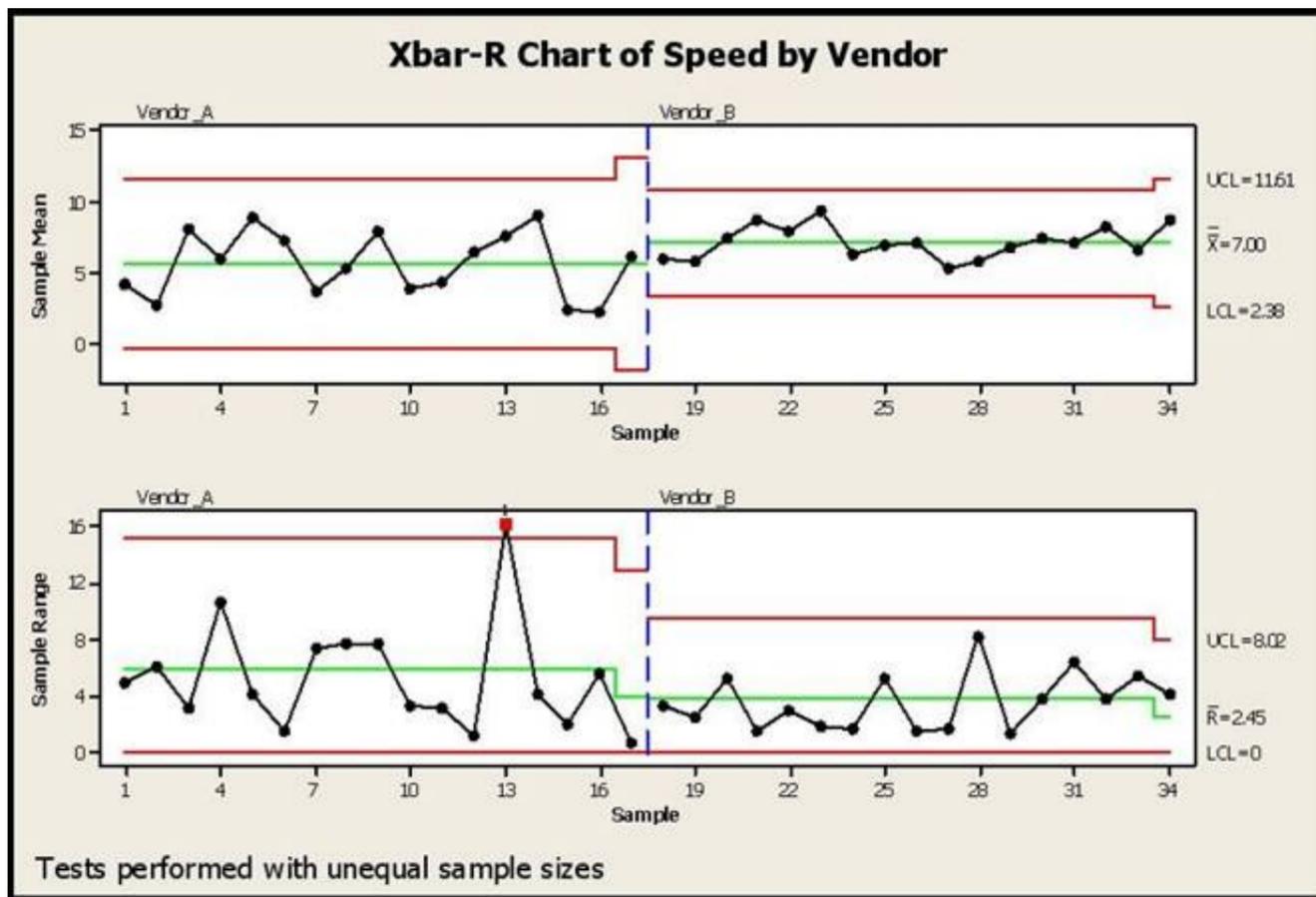
Sally bought a blender from her local appliance store. When she changed blades the blender would not function. For the manufacturer this would be categorized as what type of cost?

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

Answer: B

NEW QUESTION 58

SPC Charts are used extensively in different business and decision-making environments. In this example a vendor is being selected based on speed of delivery. Which of the conclusions would help you pick a vendor for your needs regarding lead-time of delivery from your vendors?(Note:There are 4 correct answers).



- A. Vendor A with a much shorter lead time in delivery
- B. Vendor B as it has a better consistency (lower variance) on lead time
- C. Vendor B as Vendor A shows a situation out of control as shown in red
- D. Vendor B as the Control Limits are much narrower than Vendor A
- E. Vendor B with higher lead time, but a process with much narrower Control Limits

Answer: BCDE

NEW QUESTION 61

Sally and Sara sell flower pots at their garage sale. Sally motivates Sara mentioning that they will sell a minimum of 15 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 13.6 pots per day were sold with a Standard Deviation of 0.7 pots. The statistical Degrees of Freedom for this example are?

- A. 1
- B. 29
- C. 30
- D. 31
- E. 2

Answer: B

NEW QUESTION 64

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

NEW QUESTION 69

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

Answer: D

NEW QUESTION 70

When a Belt implements an improvement that is automated thus requiring no particular understanding for use he has applied which Lean tool?

- A. Mistake Proofing
- B. Kaizen Event
- C. 5S

D. None

Answer: A

NEW QUESTION 71

A(n) _____ is best used to compare a Machine 1 average quality characteristic to the same quality characteristic of Machine 2.

- A. F test
- B. 1-Sample t-test
- C. 2-Sample t-test
- D. ANOVA test

Answer: C

NEW QUESTION 75

The method of Steepest Ascent guides you toward a target inside the original inference space.

- A. True
- B. False

Answer: B

NEW QUESTION 77

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

- A. Curve Spread
- B. Standard Deviation
- C. Numerical Average
- D. Data Breadth

Answer: B

NEW QUESTION 79

Following the completion of a LSS project the Belt not only creates a Control Plan he also develops a _____ so those involved in the process know what to do when the critical metrics move out of spec.

- A. Response Plan
- B. Call List
- C. Chain-of-Command
- D. Defect Analysis Plan

Answer: A

NEW QUESTION 82

The Central Limit Theorem says that as the sample size becomes large the sample Mean distribution will form a Normal Distribution, _____.

- A. If the Measurement System is properly calibrated
- B. When the data is collected accurately
- C. If the shape is evenly spread
- D. No matter what the shape of the population distribution of individuals

Answer: D

NEW QUESTION 87

Common and _____ Cause Variation are the focus of Statistical Process Control.

- A. Uncommon
- B. Ordinary
- C. Special
- D. Selective

Answer: C

NEW QUESTION 88

Common and Special Cause _____ are the focus of Statistical Process Control.

- A. Prediction
- B. Ideation
- C. Capability
- D. Variation

Answer: D

NEW QUESTION 89

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

- A. Cycle Time
- B. Defects
- C. N
- D. of Units Reworked
- E. Labor Hours
- F. All of these answers are correct

Answer: E

NEW QUESTION 94

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: A

NEW QUESTION 97

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

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

Answer: A

NEW QUESTION 100

Relative to a Design of Experiments the term Collinear refers to variables being a _____ of each other.

- A. Linear combination
- B. Directly parallel
- C. Mirror image
- D. None of the above

Answer: A

NEW QUESTION 105

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

Answer: BCD

NEW QUESTION 109

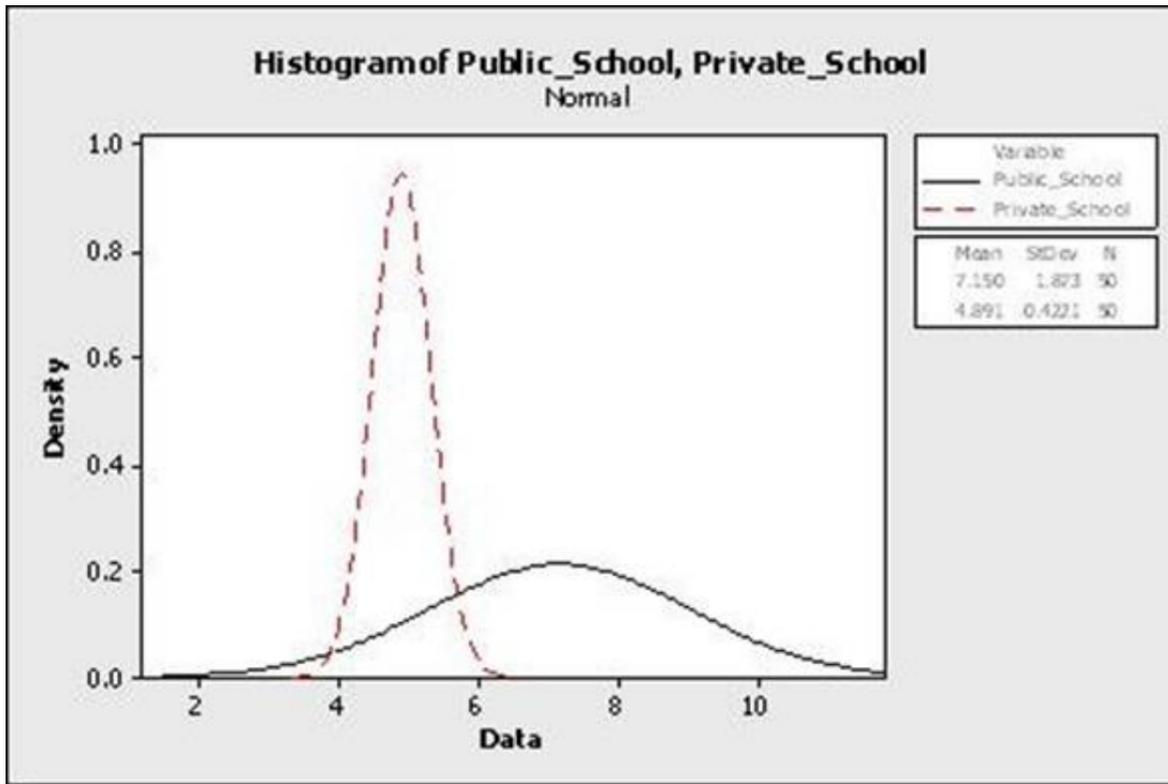
Screening experiments are the proper choice when a Belt is faced with the situation of highly Fractional Factorial Designs.

- A. True
- B. False

Answer: A

NEW QUESTION 110

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

Answer: A

NEW QUESTION 113

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

Regression Analysis: Turbine Output versus Air-Fuel Ratio, % steam, ...

The Regression Equation is

$$\text{TurbineOutput} = 16.5 + 3.21 \text{ Air-Fuel Ratio} + 0.386 \% \text{ methane} + 0.0166 \text{ SteamExitTemp}$$

Predictor	Coef	SE Coef	T	P
Constant	16.488	2.918	5.65	0.000
Air-Fuel Ratio	3.2148	0.2377	13.52	0.000
% methane	0.38637	0.07278	5.31	0.000
SteamExitTemp	0.016576	0.004273	3.88	0.004

S = 0.508616 R-Sq = 98.6% R-Sq(adj) = 98.2%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	3	170.003	56.668	219.06	0.000
Residual Error	9	2.328	0.259		
Total	12	172.331			

Source	DF	Seq SS
Air-Fuel Ratio	1	159.048
% methane	1	7.062
SteamExitTemp	1	3.892

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

E. The SteamExitTemp explains the most variation of the TurbineOutput

Answer: DE

NEW QUESTION 115

Following process modifications, the Null Hypothesis states that no improvement to the process has occurred. If we discover the Null Hypothesis Test was rejected when it was false that would be a(n) _____.

- A. Alpha Error
- B. Type I Error
- C. Type II Error
- D. Type III Error

Answer: C

NEW QUESTION 117

Sally and Sara sell flower pots at their garage sale. Sally motivates Sara mentioning that they will sell a minimum of 15 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 13.6 pots per day were sold with a Standard Deviation of 0.7 pots. For the sales accomplished above, what test would validate if they met their requirements?

- A. F Test
- B. Test for Equal Variance
- C. Chi Square Test
- D. One-Sample t-Test

Answer: D

NEW QUESTION 119

Which statement(s) are incorrect about Fractional Factorial Designs?

- A. A Half Fractional Design for 5 factors has the same number of experimental runs as a Full Factorial Design for 4 factors assuming no repeats or replicates or Center Points
- B. Quarter Fractional experiments can exist for those with 4 factors
- C. Resolution V design is desired while controlling costs of experimentation
- D. Half Fractional experiments do not exist for those designs with only 2 factors

Answer: C

NEW QUESTION 120

When a Belt decides to use written procedures and visual controls to improve the consistency of the tasks that must occur in the process he is improving he has utilized the _____ activity of 5S.

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

Answer: C

NEW QUESTION 122

Using this data calculate the percentage of DPU. Data:763 defects, 18,000 units.

- A. 2.12
- B. 3.42
- C. 4.24
- D. 5.72

Answer: C

NEW QUESTION 125

Special Cause Variation falls into which two categories?(Note:There are 2 correct answers).

- A. Natural
- B. Short term
- C. Assignable
- D. Pattern

Answer: CD

NEW QUESTION 126

Which Experimental Design typically is most associated with the fewest number of input variables or factors in the design?

- A. Response Surface design
- B. Full Factorial design
- C. Simple Linear Regression

D. Fractional Factorial design

Answer: A

NEW QUESTION 130

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

Answer: C

NEW QUESTION 133

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

- A. True
- B. False

Answer: B

NEW QUESTION 137

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

Answer: B

NEW QUESTION 142

Since Normality is required if we intend to use the data collected as a predictive tool. To test for Normality of data we must determine if the P-value is _____.

- A. Equal to 0.05
- B. Less than 0.05
- C. Greater than 0.05
- D. Greater than 0.5

Answer: C

NEW QUESTION 147

Which of the items listed do not define what an X-Y Diagram is?

- A. Created for every project
- B. Based on team's collective opinions
- C. Updated whenever a parameter is changed
- D. Used to show each step in a process
- E. A living document throughout project lifecycle

Answer: D

NEW QUESTION 152

The Greek letter "sigma" is used by mathematicians to signify _____.

- A. Curve Width
- B. Numerical Average
- C. Standard Deviation
- D. Data Spread

Answer: C

NEW QUESTION 157

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

Answer: C

NEW QUESTION 158

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

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

Answer: D

NEW QUESTION 160

If in an experiment all possible variable pairs sum to zero the design is Orthogonal.

- A. True
- B. False

Answer: A

NEW QUESTION 164

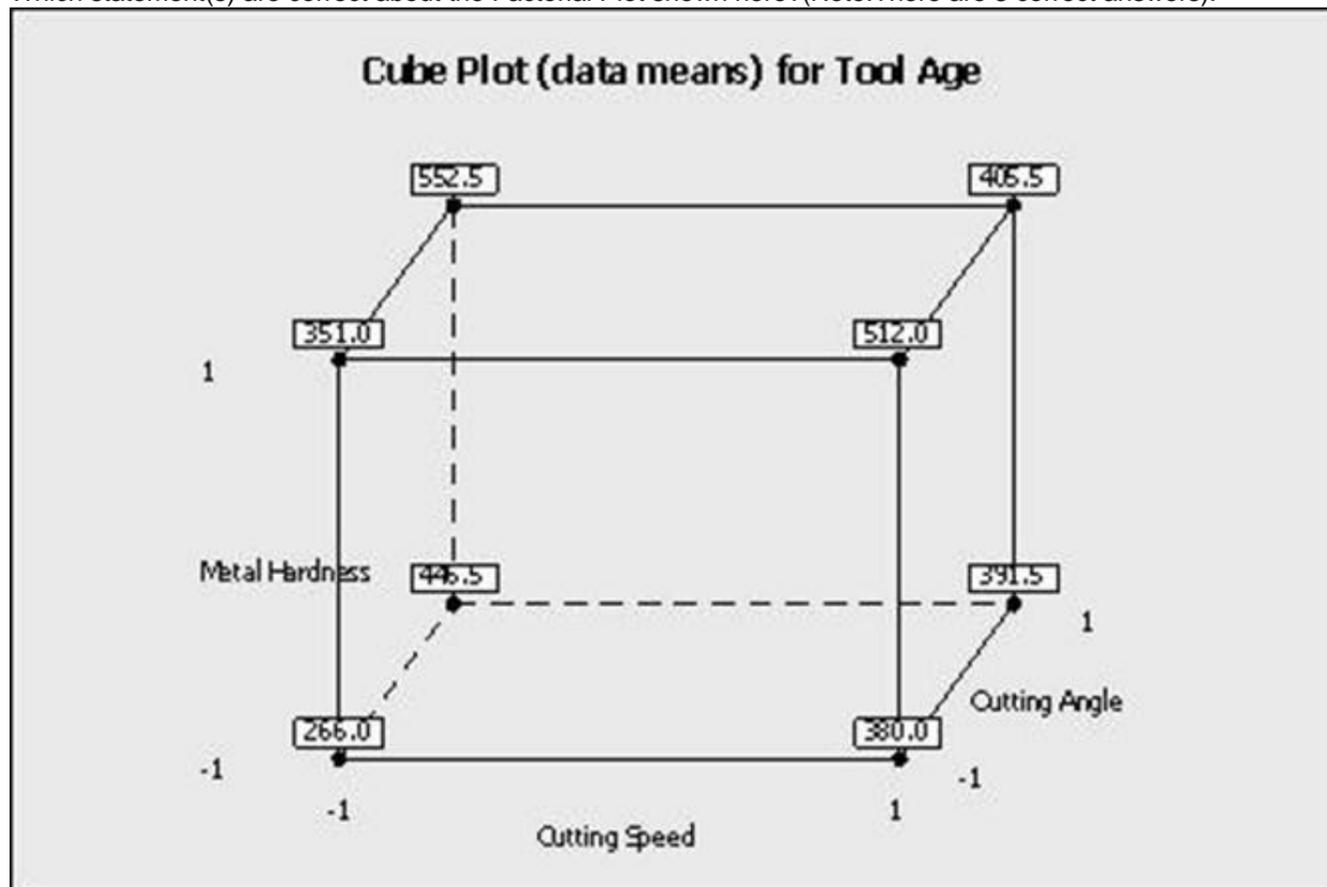
Contingency Tables are used to test for association, or dependency, between two or more classifications.

- A. True
- B. False

Answer: A

NEW QUESTION 168

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: ABC

NEW QUESTION 172

The Normal Distribution is considered to be the most important distribution in statistics and, among other things is defined as having a total area under the curve of 1, is mounded and symmetrical and the Mean, Median and Mode are _____.

- A. All evenly divisible by 3
- B. Twice the Standard Deviation
- C. Within 10% of each other
- D. The same number

Answer: D

NEW QUESTION 174

Fractional Factorial Designs are used to analyze factors to model the output as a function of inputs if Hypothesis Testing in the Analyze Phase was inadequate to sufficiently narrow the factors that significantly impact the output(s).

- A. True
- B. False

Answer: A

NEW QUESTION 179

What aspects of Measurement Systems Analysis (MSA) studies are applicable when the process used to measure does not damage the part?

- A. Destructive variable gage R&R and Crossed Study
- B. Destructive variable gage R&R and Nested Study
- C. Nondestructive variable gage R&R and Crossed Study
- D. Nondestructive variable gage R&R and Nested Study

Answer: D

NEW QUESTION 181

Sally and Sara sell flower pots at their garage sale. Sally motivates Sara mentioning that they will sell a minimum of 15 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 13.6 pots per day were sold with a Standard Deviation of 0.7 pots. The statistical Degrees of Freedom for this example are?

- A. 1
- B. 29
- C. 30
- D. 31
- E. 2

Answer: B

NEW QUESTION 186

Production Line 1 is able to complete 500 units per shift. Production Line 2 is able to finish 1,500 units per shift. Production Line 2 is 3 times faster than Production Line 1. This analysis is an example of _____ Scale Data.

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

Answer: B

NEW QUESTION 188

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

Answer: D

NEW QUESTION 190

A _____ is used primarily 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

NEW QUESTION 195

The primary objective in removal of waste is to improve the Order Production Cycle where the time from _____ to the time of receipt of payment is compressed.

- A. Shift start
- B. Product development
- C. Receipt of an order
- D. New fiscal year

Answer: C

NEW QUESTION 197

For a Normal Distribution as samples size increases the Range in Mean and Standard Deviation decrease relative to the Mean and Standard Deviation of the population.

- A. True
- B. False

Answer: A

NEW QUESTION 200

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