



**GAQM**

## **Exam Questions CLSSGB**

Certified Lean Six Sigma Green Belt (CLSSGB)

#### NEW QUESTION 1

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 2

The Accuracy of a Measurement System addresses \_\_\_\_\_.

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

**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

The Regression Model for an observed value of Y contains the term  $\theta_0$  which represents the Y axis intercept when  $X = 0$ .

- A. True
- B. False

**Answer:** A

#### NEW QUESTION 5

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 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

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

**Answer:** D

#### NEW QUESTION 8

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 9

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 10

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 14

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 19

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.

**Answer:** CD

#### NEW QUESTION 22

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 26

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 29

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

- A. True
- B. False

**Answer:** A

#### NEW QUESTION 30

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 34

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 35

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 38

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 43

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 48

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 53

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 56

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 59

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 64

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

**Answer:** B

#### NEW QUESTION 69

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 74

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 78

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 81

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 85**

Hypothesis Tests determine the probabilities of differences between observed data and the hypothesis being solely due to \_\_\_\_\_ based on the result of the P-values.

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

**Answer:** D

**NEW QUESTION 86**

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 90**

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 91**

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

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

**Answer:** A

**NEW QUESTION 94**

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 99**

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 100**

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 103

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 108

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 110

When utilizing Statistics the population is defined as a collection of all the individual data points of interest.

- A. True
- B. False

**Answer:** A

#### NEW QUESTION 112

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

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

**Answer:** A

#### NEW QUESTION 116

The 80:20 rule is associated with which of these tools?

- A. Pareto Chart
- B. Simon's Cross-Functional Tool
- C. SIPOC
- D. Framing Tool

**Answer:** A

#### NEW QUESTION 117

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 120

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 125

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 130**

Use of the \_\_\_\_\_ approach is the most classic arrangement when constructing a Fishbone Diagram.

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

**Answer:** B

**NEW QUESTION 132**

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 137**

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 139**

The use of Kanbans work best with pull systems for determining the timing of which products or services are produced.

- A. True
- B. False

**Answer:** A

**NEW QUESTION 142**

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.

**Answer:** CD

**NEW QUESTION 143**

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 145**

Kanbans work best with pull systems for determining the timing of which products or services are produced.

- A. True
- B. False

**Answer:** A

**NEW QUESTION 146**



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 150

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 154

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

- A. True
- B. False

**Answer:** A

#### NEW QUESTION 158

If a process has Outliers which pair of charts is most preferable if subgroups will exist for the Continuous Data?

- A. Individual—Moving Range
- B. Xbar-R Charts
- C. Xbar-S Charts
- D. nP and P Charts

**Answer:** B

#### NEW QUESTION 161

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 163

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 165

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

**Answer:** A

#### NEW QUESTION 169

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 170

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

- A. True
- B. False

**Answer:** A

#### NEW QUESTION 173

Which element of waste best describes the cost of a resource being in the queue?

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

**Answer:** A

#### NEW QUESTION 174

The Accuracy of a Measurement System addresses \_\_\_\_\_.

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

**Answer:** A

#### NEW QUESTION 175

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

- A. True
- B. False

**Answer:** A

#### NEW QUESTION 179

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

**Answer:** AC

#### NEW QUESTION 183

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

- A. True
- B. False

**Answer:** A

#### NEW QUESTION 186

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 191

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