



# CLSSBB<sup>Q&As</sup>

Certified Lean Six Sigma Black Belt (CLSSBB)

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#### QUESTION 1

What is the Ppk of a process with a spread of 24 units, an average of 68, an upper limit of 82 and a lower limit of 54?

- A. 1.68
- B. 2.00
- C. 4.00
- D. 4.42

Correct Answer: C

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#### QUESTION 2

Poka-yoke is best defined as

- A. improving machine efficiency
- B. reducing field failures to virtually zero
- C. capturing the voice of the customer
- D. preventing controllable defects

Correct Answer: D

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#### QUESTION 3

Positional, cyclical, and temporal variations are most commonly analyzed in

- A. SPC charts
- B. multi-vari charts
- C. cause and effect diagrams
- D. run charts

Correct Answer: B

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#### QUESTION 4

For a normal distribution, two standard deviations on each side of the mean would include what percentage of the total population?

- A. 47%



B. 68%

C. 95%

D. 99%

Correct Answer: C

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#### QUESTION 5

$P(A) = .42$ ,  $P(B) = .58$ ,  $P(A \text{ and } B) = .10$  Find  $P(A \text{ or } B)$ .

A. .90

B. 1.00

C. .24

D. none of the above

Correct Answer: A

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#### QUESTION 6

The primary reason that most companies implement six sigma is to

A. reduce defects

B. improve processes

C. improve profit

D. increase customer satisfaction

Correct Answer: C

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#### QUESTION 7

Which of these graphs demonstrates conditions which would be sufficient to enable OCAP for the process?

A. Xbar Chart

B. Time Series Chart

C. Neither

D. Both

Correct Answer: A

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### QUESTION 8

If item A is more likely to be detected than item B which will have the highest Detection value?

- A. item A
- B. item B
- C. cannot be determined

Correct Answer: B

### QUESTION 9

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

Adv	Bev	Des	Crux	Response
-1	-1	-1	-1	20
1	-1	-1	1	14
-1	1	-1	1	17
1	1	-1	-1	10
-1	-1	1	1	19
1	-1	1	-1	13
-1	1	1	-1	14
1	1	1	1	10

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

Correct Answer: D

### QUESTION 10

Cost of Poor Quality (COPQ) can be classified as Visible Costs and Hidden Costs. All these items are Hidden Cost except \_\_\_\_\_.



- A. Lost Customer Loyalty
- B. Returns
- C. Time Value of Money
- D. Late Delivery

Correct Answer: B

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#### QUESTION 11

The calculation of Column Total Times Row Total divided by Grand Total yields expected values from what type of chart?

- A. Pareto Chart
- B. Sakami Table
- C. Contingency Table
- D. None

Correct Answer: C

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#### QUESTION 12

A team studies a coil steel banding process and makes five changes resulting in productivity improvements of 2%, 2.8%, 2.4%, 2% and 3% respectively. These improvements are best described by which approach to problem solving?

- A. 5S
- B. Poka yoke
- C. Kaizen
- D. PDCA
- E. Re-engineering

Correct Answer: C

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#### QUESTION 13

A six sigma team has been formed to improve an existing process. Which of the following tools should the team use first to gain a clear understanding of the current process?

- A. Flowchart
- B. Pareto chart



C. Process FMEA

D. Latin square DOE

Correct Answer: A

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#### QUESTION 14

In regression analysis, which of the following techniques can be used to reduce the higher- order terms in the model?

A. Large samples

B. Dummy variables

C. Transformations

D. Blocking

Correct Answer: C

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#### QUESTION 15

Find the value of (4) in the ANOVA table. Assume:

$$\alpha = 0.10$$

ANOVA Table

Source	SS	df	MS	F ratio	F crit	P-value
x	1.48	1	(1)	(2)	(3)	(4)
Y	18.6	1	(5)	(6)	(7)	(8)
xxY	12.2	1	(9)	(10)	(11)	(12)
Error	2.1	4	(13)			

A. 16.4

B. 3.2

C. 18.6

D. 23.2

E. 4.54

F. 12.2



G. 0.525

H. 2.82

I. 1.48

J. 35.4

K. 0.10