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**QUESTION 1**

When variation is removed from the output of a process then the process customer can have more confidence in the experience that results from the process.

- A. True
- B. False

Correct Answer: A

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**QUESTION 2**

To be an effective Lean Six Sigma practitioner one must understand the difference between \_\_\_\_\_.

- A. ANOVA and the Analysis of Variance
- B. Nonparametric tests and tests of Non-normal Data
- C. F-test and test of variances of 2 samples
- D. Practical and Statistical significance

Correct Answer: D

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**QUESTION 3**

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

Correct Answer: A

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**QUESTION 4**

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

- A. True
- B. False

Correct Answer: A

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**QUESTION 5**

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

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

Correct Answer: D

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**QUESTION 6**

The English words used for the 5S's are Sorting, Straightening, \_\_\_\_\_, \_\_\_\_\_ and Sustaining. (Note: There are 2 correct answers).

- A. Shaping
- B. Shining
- C. Standardizing
- D. Signing

Correct Answer: BC

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**QUESTION 7**

For a batch manufacturing process, while assessing short term process variation, which variation category(ies) should one need to focus on? (Note: There are 2 correct answers).

- A. Variation within consecutive pieces
- B. Variation among consecutive batches
- C. Variation among groups of pieces
- D. Variation among the completed product

Correct Answer: AB

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**QUESTION 8**

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 9

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

Correct Answer: A

#### QUESTION 10

The validity of the decision made with Hypothesis Testing is dependent upon all of the following except \_\_\_\_\_.

- A. Beta risk
- B. Range of data
- C. Alpha risk
- D. Sample size

Correct Answer: B

**QUESTION 11**

Use this data to calculate the Z Score. Average of: 92, Standard Deviation: 2, Upper Spec Limit: 101

- A. 0.75
- B. 1.5
- C. 2.25
- D. 4.50

Correct Answer: D

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**QUESTION 12**

If an experiment has 5 factors and no replicates for a 2-level Experimental Design with 16 experimental runs which statement is incorrect?

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

Correct Answer: C

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**QUESTION 13**

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

Correct Answer: C

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**QUESTION 14**

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 RandR and Crossed Study



- B. Destructive variable gage RandR and Nested Study
- C. Nondestructive variable gage RandR and Crossed Study
- D. Nondestructive variable gage RandR and Nested Study

Correct Answer: D

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#### QUESTION 15

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

Correct Answer: B

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