



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

Lean Six Sigma Master Black Belt

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**QUESTION 1**

If you have a gauge study with a % RandR of 25% what should you do?

- A. Pull the tool from production.
- B. This is fine-go ahead.
- C. This is not acceptable for critical measurements, you should look into improvements in the measurement process.
- D. This is only an issue if you fail calibration.

Correct Answer: C

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**QUESTION 2**

- A. Are setups optimized for lower scrap levels?
- B. Can extra inventory be seen easily?
- C. Can changeover challenges be recognized?
- D. Are unneeded tools or supplies easily noted?

Correct Answer: A

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**QUESTION 3**

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 4**

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

Correct Answer: C

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#### QUESTION 5

A Factorial Experiment based on a Level 2 Design with 6 factors would require 16 runs to fully assess the interactions.

A. True

B. False

Correct Answer: B

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#### QUESTION 6

Kaizens or Kaikakus and Six Sigma projects are intended to create breakthrough, significant process improvement versus minor, incremental improvements.

A. True

B. False

Correct Answer: A

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#### QUESTION 7

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 of the above

Correct Answer: A

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#### QUESTION 8

The Lean toolbox includes all of these items except \_\_\_\_\_.

A. Mistake Proofing

B. Visual Factory



C. Design of Experiments

D. Inventory Management

Correct Answer: C

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#### QUESTION 9

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

Correct Answer: A

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#### QUESTION 10

Range Charts are the technique used to determine if Special Causes are occurring within the subgroups of the \_\_\_\_\_.

A. Histograms

B. SPC Charts

C. NP Charts

D. Pareto Charts

Correct Answer: B

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#### QUESTION 11

Which item(s) listed would impact the Process Capability for a process with a continuous output? (Note: There are 4 correct answers).

A. Shape of process data distribution (e.g. Normal Distribution)

B. Process Technology

C. Process Standard Deviation

D. Presence of Special Causes or solely Common Causes

E. Seasonal variation in process



Correct Answer: ACDE

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#### QUESTION 12

A measurement system is said to have a consistent bias if:

- A. The standard deviation of the system is consistent across the measurement range
- B. The difference between the average reading of the measurement tool and reference value is the same across the operating range of the tool operation
- C. The standard deviations of the reading given by the measurement tool when measuring a standard is the same across the operating range of the tool operation
- D. All tools of the same type give the same variance reading

Correct Answer: B

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#### QUESTION 13

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

Correct Answer: A

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#### QUESTION 14

From this list select the best example of Bias in Sampling.

- A. Testing the completeness of cooking a cake but the testers cannot agree on how to measure internal temperature
- B. Testing the sharpness of a razor blade while the sample of 500 are from the same model razor
- C. Testing the weight of participants at a wrestling event and only measuring those who finished second or better
- D. Testing a hand-held GPS models for durability using samples only from Nokia Model P120

Correct Answer: C

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#### QUESTION 15



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

Correct Answer: A

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