

Practice Exam Questions

PeopleCert
IASSC
LEAN SIX SIGMA CERTIFICATION



Lean Six Sigma Green Belt



EXAMKILLER

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Total Question: 200 Questions

Question No: 1

The use of station warning lights, tool boards and jidohka devices in the application of Lean accomplish which of these principles?

- A. Pilferage Minimization
- B. Visual Factory
- C. Management Awareness
- D. Operator Attentiveness

Answer: B

Question No: 2

A Lean Principle that addresses efficiency by the process worker is called _____?

- A. Visual Factory
- B. Supervising
- C. Training
- D. Standardizing

Answer: D

Question No: 3

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

Question No: 4

As part of a Visual Factory plan _____ cards are created and utilized to identify areas in need of cleaning and organization.

- A. Kanban
- B. Kaizen
- C. Poke-Yoke
- D. WhoSai

Answer: A

Question No: 5

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

Question No: 6

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

Question No: 7

The Lean Principle action in the 5S approach that deals with having those items needed regularly at hand and those items need less regularly stored out of the way is known as _____.

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

Answer: D

Question No: 8

SPC on the outputs is more preferred than SPC on the inputs when implementing SPC for your process.

- A. True
- B. False

Answer: B

Question No: 9

Significant variation in process performance is a consequence of several causes that can be classified using which of the terminologies shown. (Note: There are 2 correct answers).

- A. Common
- B. Random
- C. Uneducated
- D. Special
- E. Vital

Answer: A,D

Question No: 10

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

Question No: 11

A periodic time frame can be used to arrange for Control Limit and Center Line calculations with good SPC implementation in a process.

- A. True
- B. False

Answer: A

Question No: 12

The data on SPC charts are typically constructed such that they have the most recent data point on the right hand side.

- A. True
- B. False

Answer: A

Question No: 13

Which statement(s) describe an undesirable situation when implementing SPC?

- A. The lower Control Limit for the R chart is equal to zero
- B. Attempt to use SPC for tracking transaction times at a warehouse
- C. A process is in Statistical Control before implementation of SPC
- D. The Control Limits are wider than the customer specification limits

Answer: D

Question No: 14

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

Question No: 15

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

Question No: 16

A Belt concludes a Lean Six Sigma project with the creation of a Control Plan. At what point can the Control Plan be closed?

A. Never, a Control Plan is a living document

B. As soon as the Champion signs off

C. Within 30 days of the LSS project review team meeting

D. After the project has been presented at the recognition event

Answer: A

Question No: 17

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

Question No: 18

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: C,D,E

Question No: 19

Fractional Factorial designs for an experimental approach are used when _____ about the multiple metric interaction in a process.

A. Much is known

B. Little is known

C. We don't care

D. Data exists

Answer: B

Question No: 20

A Belt will occasionally do a quick experiment referred to as an OFAT which stands for _____.

A. Only a Few Are Tested

B. Opposite Factors Affect Technique

C. One Factor At a Time

D. Ordinary Fractional Approach Technique

Answer: C

Question No: 21

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: A,D

Question No: 22

The Regression Model for an observed value of Y contains the term β_0 which represents the Y axis intercept when $X = 0$.

A. True

B. False

Answer: A

Question No: 23

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: C,D

Question No: 24

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

Question No: 25

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

Question No: 26

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: C,D,E

Question No: 27

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: A,C,D,E

Question No: 28

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.