

LSSMBB^{Q&As}

Lean Six Sigma Master Black Belt

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QUESTION 1

Which of the following are true regarding the Central Limit Theorem?

- A. Sample averages are normally distributed as sample size gets larger.
- B. Sample averages converge on the population mean.
- C. Sample standard deviations are dependent upon the standard deviation of the population from which it was sampled.
- D. All of the above

Correct Answer: D

QUESTION 2

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

QUESTION 3

A Black Belt is reviewing a stable, normal process that has a $C_p = 3$ and a $C_{pk} = 1$. In order to achieve a 6 sigma process, what must be done?

- A. Reduce variation only
- B. Shift the mean only
- C. Reduce variation and shift the mean
- D. Not enough information given

Correct Answer: B

QUESTION 4

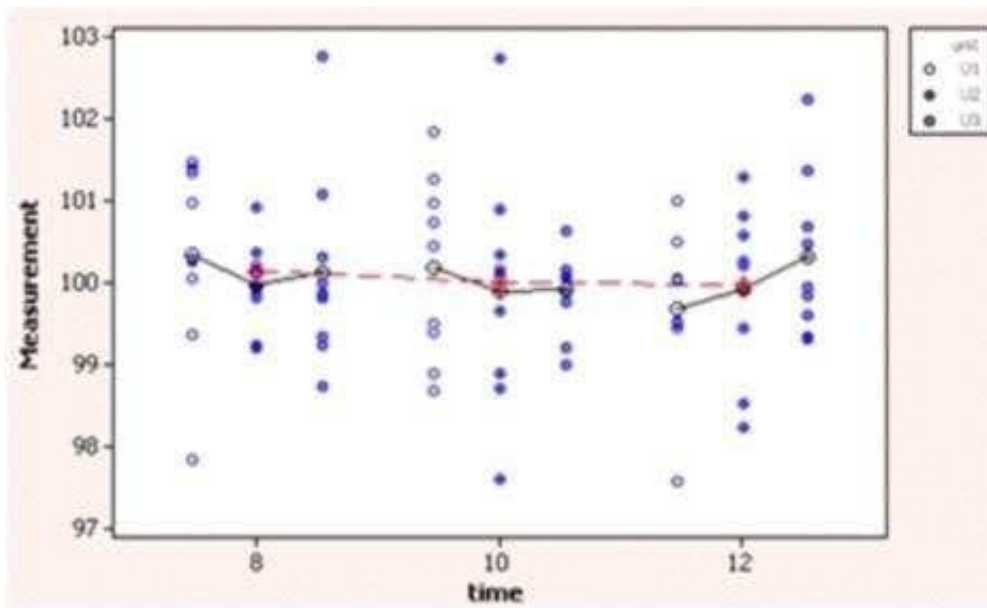
If you have a gauge study with a % RandR of 25% what should you do?

- 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

QUESTION 5

Your team has done a SOV study and produced the following Multi-Van chart. What is the largest source of variation?



- A. Time to Time
- B. Within Unit
- C. Unit to Unit
- D. None of the above

Correct Answer: B

QUESTION 6

Some of the sources for different types of error that can be quantified using Statistical Analysis are which of these?

- A. Error in sampling
- B. Bias in sampling
- C. Error in measurement

D. All of the above

Correct Answer: D

QUESTION 7

Fractional Factorial designs are used to reduce the _____ because the number of runs has been lowered.

- A. Time and cost of experiments
- B. Number of people involved
- C. Number of data measurement points
- D. Output summary

Correct Answer: A

QUESTION 8

When we compare short-term and long-term Capability which of these is true?

- A. Cp is better for the short term
- B. Both short-term and long-term performance are alike
- C. Performance tends to improve over time
- D. Cp is better for the long-term

Correct Answer: A

QUESTION 9

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

QUESTION 10

The reported Cpk for a process with an average of 98 units, a spread of 16 units and upper and lower specification limits of 115 and 90 units would be?

- A. 0.5
- B. 0.75
- C. 1.00
- D. 1.25

Correct Answer: C

QUESTION 11

Much of the Six Sigma methodology is used to identify and remove causes for _____ .

- A. Process Variation
- B. Material Costs
- C. Excess Inventory
- D. Lost Sales

Correct Answer: A

QUESTION 12

The main feature(s) that differentiate the Control Chart from the Run Chart are which the following?

- A. The presence of a statistically calculated center line and upper and lower limits
- B. The Run Chart shows data over time and the Control Chart shows data at one point in time
- C. The Run Chart requires more data than the Control Chart
- D. The Run Chart is used in the "Measure" Phase while the Control Chart is used in the "Control" Phases

Correct Answer: A

QUESTION 13

Kanban establishes a means of monitoring production, conveyance and delivery information such that efficient flow is established. The method used by Kanban is to require a _____ before anything moves.

- A. Sign-off
- B. Signal
- C. Bell to ring

D. Work order

Correct Answer: B

QUESTION 14

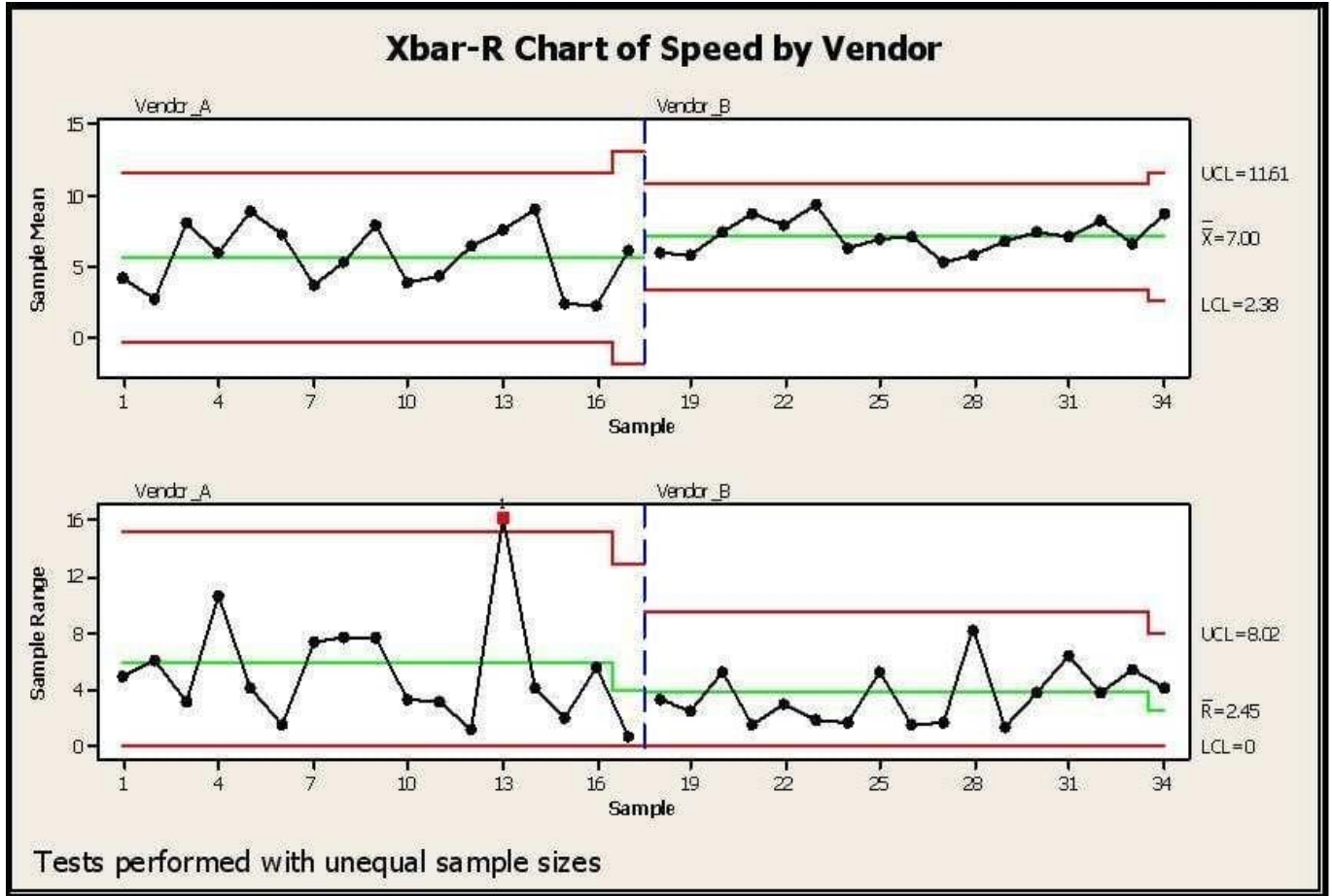
Range Charts are the technique used to determine if _____ are occurring within the subgroups of the SPC Charts.

- A. Common Causes
- B. Special inspections
- C. Unnatural forces
- D. Special Causes

Correct Answer: D

QUESTION 15

SPC Charts are used extensively in different business and decision-making environments. In this example a vendor is being selected based on speed of delivery. Which of the conclusions would help you pick a vendor for your needs regarding lead-time of delivery from your vendors? (Note: There are 4 correct answers).



- A. Vendor A with a much shorter lead time in delivery
- B. Vendor B as it has a better consistency (lower variance) on lead time
- C. Vendor B since Vendor A shows a situation out of control as shown in red
- D. Vendor B since the Control Limits are much narrower than Vendor A
- E. Vendor B has higher lead time, but a process with much narrower Control Limits

Correct Answer: BCDE

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