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QUESTION 1

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

QUESTION 2

With Measurement System Analysis we are concerned with two issues that impact the potential variability of the data. They are _____.

- A. Precision and Accuracy
- B. Reliability and Repeatability
- C. Error and Spread
- D. Sensitivity and Deflection

Correct Answer: A

QUESTION 3

The Waste of Overproduction is defined as _____.

- A. The unnecessary movement of people and equipment
- B. The liability of materials that are bought, invested in and not immediately sold or used
- C. Producing more than the next step needs or more than the customer buys
- D. The extra movement of material

Correct Answer: C

QUESTION 4

A Belt is analyzing data and upon creation of the graphical analysis sees multiple modes. One of the primary reasons this could occur is because the process has experienced a _____.

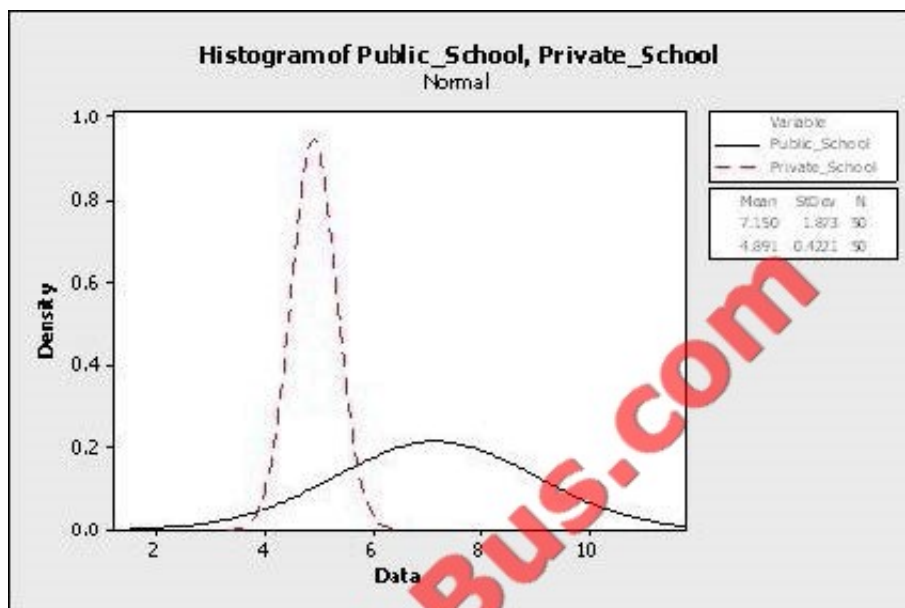
- A. Significant change from one shift to another
- B. Sizable Measurement System error
- C. Catastrophic failure of some sort
- D. Any one of these

Correct Answer: D

QUESTION 5

The class score distribution of schools in a metropolitan area is shown here along with an analysis output.

Comment on the statistical significance between the Means of the two distributions. Select the most appropriate statement.



Two-sample t for Private_School vs Public_School

| | N | Mean | StDev | SE Mean |
|----------------|----|-------|-------|---------|
| Private_School | 50 | 4.891 | 0.422 | 0.060 |
| Public_School | 50 | 7.15 | 1.87 | 0.26 |

Difference = μ (Private_School) - μ (Public_School)

Estimate for difference: -2.259

99% CI for difference: (-2.985, -1.534)

T-Test of difference = 0 (vs not =): T-Value = -8.32 p-Value = 0.000 DF



- A. The two class Means are statistically different from each other
- B. The two class Means statistically not different from each other
- C. Inadequate information on class Means to make any statistical conclusions
- D. A visual comparison shows that class Means are not statistically different

Correct Answer: A

QUESTION 6

Using this data calculate the percentage of DPU.

- A. 2.74
- B. 3.23
- C. 4.56
- D. 5.93

Correct Answer: B

QUESTION 7

For a Kanban to be successful which of these must occur?

- A. Consistent cycle times
- B. Fairly stable process demand of product or service
- C. Low defect rate of incoming product or service
- D. All of the above

Correct Answer: D

QUESTION 8

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

QUESTION 9

Following process modifications, the Null Hypothesis states that no improvement to the process has occurred. If we discover the Null Hypothesis Test was rejected when it was false that would be a(n) _____.

- A. Alpha Error
- B. Type I Error
- C. Type II Error
- D. Type III Error

Correct Answer: C

QUESTION 10

A valid mathematical Regression represents all of the characteristics shown except _____.

- A. All of the standardized residuals will be within ? Standard Deviations
- B. The sum of the residuals is zero
- C. The residuals when plotted follow a Normal Distribution
- D. Most standardized residuals are within ? Standard Deviations
- E. The Residual is equal to the difference between the observed and predicted values

Correct Answer: A

QUESTION 11

Early in a project a Belt will want to begin to identify and evaluate risk factors for the subject process and will therefore begin building a(n) _____.

- A. FMEA
- B. SIPOC
- C. X-Y Diagram
- D. Team Charter

Correct Answer: A

QUESTION 12

The Control Limits width varies if the sample size varies for which type of chart?

- A. P Charts
- B. NP Charts
- C. Xbar-R Charts
- D. Time Series Charts

Correct Answer: A

QUESTION 13

If a Six Sigma project was to reduce changeover times and the team found the project success was decreasing over time since changeover times began to creep back up, which Lean tools should be considered in the Control Phase to reestablish and sustain the project success?

- A. Improve the lighting to assure adequate visibility
- B. Confirm a Visual Factory exists to assure proper communication of status of machines
- C. Implement Kanbans to assure enough inventory for the process step
- D. Reword the standardized work instructions to use active verbs and not passive phrases

Correct Answer: B

QUESTION 14

On a _____ one can see a pattern from the graphed points such that conclusions can be drawn about the largest family of Variation.

- A. Multi-Vari Chart
- B. Weighted Scale
- C. X-Y Matrix
- D. Poisson Chart

Correct Answer: A

QUESTION 15

How many experimental runs exist in a Full Factorial and fully randomized design for 5 factors with 2 replicates for the Corner Points and no Center Points? The factors in the experiment are only at 2- levels.

- A. 10
- B. 128
- C. 256
- D. 64

Correct Answer: D

QUESTION 16

A Belt working in a supply chain environment has to make a decision to change suppliers of critical raw materials for a new product upgrade. The purchasing manager is depending on the Belt's effort requiring that the average cost of an internal critical raw material component be less than or equal to \$2,800 in order to stay within budget. Using a sample of 55 first article components, a Mean of the new product upgrade price of \$2,240 and a Standard Deviation of \$120 was estimated. Based on the data provided, the Z value for the data assuming a Normal Distribution is?

- A. 2.33
- B. 4.67
- C. 6.48
- D. 8.28

Correct Answer: B

QUESTION 17

During the _____ phase of 5S is when we might implement a Red Tag program.

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

Correct Answer: D

QUESTION 18

A valuable tool to use during the Measure Phase to show material and information flow throughout an entire process is the _____ .

- A. Value Stream Map
- B. FMEA
- C. Pareto Chart
- D. Standard Operating Procedure

Correct Answer: A

QUESTION 19

For Attribute Data, Process Capability is defined as the average proportion of nonconforming products.

- A. True
- B. False

Correct Answer: A

QUESTION 20

Which one of the listed tools is frequently used to help drill down to possible causes once a Fishbone Diagram is constructed?

- A. 3 When Analysis
- B. Skeleton Diagnostic
- C. Ishikawa Diagram
- D. 5 Why Analysis

Correct Answer: D

QUESTION 21

Which statement(s) are incorrect for the Regression Analysis shown here? (Note: There are 2 correct answers).

Regression Analysis: Turbine Output versus Air-Fuel Ratio, % steam, ...

The Regression Equation is
 TurbineOutput = 16.5 + 3.21 Air-Fuel Ratio + 0.386 % methane
 + 0.0166 SteamExitTemp

| Predictor | Coef | SE Coef | T | P |
|----------------|----------|----------|-------|-------|
| Constant | 16.488 | 2.918 | 5.65 | 0.000 |
| Air-Fuel Ratio | 3.2148 | 0.2377 | 13.52 | 0.000 |
| % methane | 0.38637 | 0.07278 | 5.31 | 0.000 |
| SteamExitTemp | 0.016576 | 0.004273 | 3.88 | 0.004 |

S = 0.508616 R-Sq = 98.6% R-Sq(adj) = 98.2%

Analysis of Variance

| Source | DF | SS | MS | F | P |
|----------------|----|---------|--------|--------|-------|
| Regression | 3 | 170.003 | 56.668 | 219.06 | 0.000 |
| Residual Error | 9 | 2.328 | 0.259 | | |
| Total | 12 | 172.331 | | | |

| Source | DF | Seq SS |
|----------------|----|---------|
| Air-Fuel Ratio | 1 | 159.048 |
| % methane | 1 | 7.062 |
| SteamExitTemp | 1 | 3.892 |



- A. The air-fuel ratio explains most of the TurbineOutput variation
- B. The Regression explains over 98% of the process variation
- C. This Multiple Linear Regression has three statistically significant independent variables
- D. If the air-fuel ratio increases by 1, the TurbineOutput more than triples
- E. The SteamExitTemp explains the most variation of the TurbineOutput

Correct Answer: DE

QUESTION 22

Measurement _____ is defined as the difference between the observed and the expected values for a given set of data.

- A. Bias
- B. Linearity
- C. Range
- D. Breadth

Correct Answer: A

QUESTION 23

Sally and Sara sell flower pots at their garage sale. Sally motivates Sara mentioning that they will sell a minimum of 22 pots per day if the outside temperature exceeds 60o F. From a sample, whose population is assumed to follow a Normal Distribution, taken for 30 days at 60 degrees or more an average of 18.2 pots per day were sold with a Standard Deviation of 0.9 pots. What is the Z value for this sales process?

- A. 1.23
- B. 1.62
- C. 2.11
- D. 4.22

Correct Answer: D

QUESTION 24

Which one of these tools is frequently used to help drill down to possible causes once a Fishbone Diagram is constructed?

- A. 3 When Analysis
- B. 5 Why Analysis
- C. Ishikawa Diagram
- D. Skeleton Diagnostic

Correct Answer: B

QUESTION 25

One of the foundations of Lean Six Sigma is the concept that the output of a process (Y) is influenced by the process inputs (X's) and is commonly shown as which formula?

- A. $Y = Z(X^2)$
- B. $Y = f(X^3)$
- C. $Y = f(X_n)$
- D. $Y = g(X + 1.5)$

Correct Answer: C

QUESTION 26

Measurement _____ is defined as the difference between the observed and the expected values for a given set of data.

- A. Breadth
- B. Linearity
- C. Range
- D. Bias

Correct Answer: D

QUESTION 27

A valid mathematical Regression represents all of the characteristics shown except _____.

- A. The residuals when plotted follow a Normal Distribution
- B. The sum of the residuals is zero
- C. All of the standardized residuals will be within ? Standard Deviations
- D. Most standardized residuals are within ? Standard Deviations

Correct Answer: A

QUESTION 28

A Belt rearranged the location of the parts inventory for a rework station locating the most often used parts to be within hand reach of the repair person. This rearrangement resulted in quicker repair times by eliminating one of seven major elements of waste which is the Waste of _____.

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

Correct Answer: A

QUESTION 29

The Control Limits width varies if the sample size varies for which type of chart?

- A. P Charts
- B. NP Charts
- C. Xbar-R Charts
- D. Time Series Charts

Correct Answer: A

QUESTION 30

Each of the items listed would impact the Process Capability for a process with a continuous output except _____.

- A. Shape of process data distribution (e.g. Normal Distribution)
- B. Process Technology
- C. Process Standard Deviation
- D. Seasonal variation in process

Correct Answer: B

QUESTION 31

The _____ Distribution would be the most desirable for modeling the number of stitch defects in a portion of fabric.

- A. Exponential
- B. Extended
- C. Poisson
- D. Weibull

Correct Answer: C

QUESTION 32

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 33

An ANOVA used across many dependent variables could increase the Beta risk.

- A. True
- B. False

Correct Answer: B

QUESTION 34

Sally and Sara sell flower pots at their garage sale. Sally motivates Sara mentioning that they will sell a minimum of 15 pots per day if the outside temperature exceeds 60° F. From a sample, whose population is assumed to follow a Normal Distribution, taken for 30 days at 60 degrees or more an average of 13.6 pots per day were sold with a Standard Deviation of 0.7 pots. The statistical Degrees of Freedom for this example are?

- A. 1
- B. 29
- C. 30
- D. 31
- E. 2

Correct Answer: B

QUESTION 35

Fractional Factorial, _____ and Response Surface Method are types of planned experiments.

- A. Multi-Vari Analysis

- B. Baldrige Channels
- C. One Factor at a Time or OFAT
- D. Factorial Design

Correct Answer: D

QUESTION 36

Customers make their decisions based on Features, Integrity (of the seller) Delivery and _____?

- A. Color
- B. Expense
- C. Season
- D. None

Correct Answer: B

QUESTION 37

The Japanese born function of a Kaizen event utilizes a specific, step-by-step approach meant to bring about major changes to a process.

- A. True
- B. False

Correct Answer: A

QUESTION 38

From the variance F-test shown above, which of these conclusions is/are valid?

- A. The variance between the class score distribution is significantly different
- B. The variance between the class score distribution is not significantly different
- C. This test applies only to Normal Distributed data at 99 % confidence
- D. This test applies only to Non-normal Data at 99 % confidence
- E. There are not enough data points to make any statistical conclusions

Correct Answer: A

QUESTION 39

Accuracy can be assessed in several ways and a fairly accurate means of measurement is visual comparison.

A. True

B. False

Correct Answer: B

QUESTION 40

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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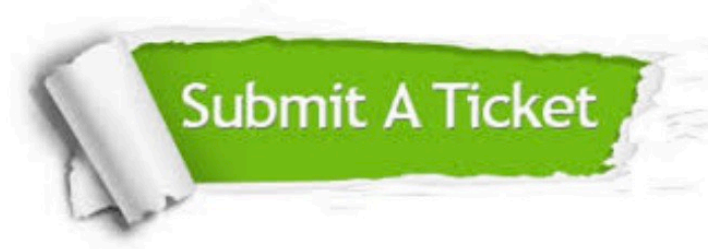
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