

CERTIFIED SIX SIGMA GREEN BELT PRACTICE EXAM 13

(100 QUESTIONS)

This independent 100-question practice exam is organized around DMAIC and supporting Six Sigma methods. Select the one best answer for each question. Use the answer key and explanations after completing the exam.

1. At a DMAIC tollgate, a Green Belt is most likely to contribute to a Six Sigma project by
 - A. approving all corporate capital expenditures
 - B. performing only final product inspections
 - C. owning the organization-wide quality policy
 - D. leading limited-scope improvement work and supporting a Black Belt

2. When evaluating a process decision, in a process-improvement project, the primary purpose of identifying the customer is to
 - A. select the person who will run the project
 - B. determine who writes the project charter
 - C. understand which outputs and requirements define value
 - D. choose the team meeting schedule

3. In a Green Belt project, a critical-to-quality requirement is best described as
 - A. a task assigned to the project champion
 - B. a measurable characteristic that matters to the customer
 - C. a cost category used in accounting
 - D. a corrective action used after failure

4. While preparing the next improvement step, a process view is most useful because it

- A. connects inputs, activities, outputs, and customers
- B. eliminates the need for measurement
- C. assumes every variation has one cause
- D. replaces management sponsorship within the improvement project

5. At a DMAIC tollgate, which project is generally the strongest Six Sigma candidate?

- A. A topic selected solely because a manager prefers it
- B. A routine task with no identifiable customer
- C. A problem whose scope changes every day
- D. A problem with a meaningful performance gap and measurable business impact

6. When evaluating a process decision, the business case in a project charter should primarily explain

- A. why solving the problem matters to the organization
- B. which team member will collect every data point
- C. how all solutions will be implemented
- D. what the final control chart limits will be

7. In a Green Belt project, a well-written problem statement should state

- A. the team's preferred countermeasure and vendor within the improvement project
- B. every possible root cause before analysis within the improvement project
- C. the observed gap, location, timing, and magnitude without naming a solution
- D. the final financial benefit as a guarantee

8. While preparing the next improvement step, a project goal statement is strongest when it

- A. lists every task in the project plan
- B. sets a measurable target and time frame
- C. names one person as responsible for all work
- D. describes the history of the department

9. At a DMAIC tollgate, a project scope statement is intended to

- A. set clear boundaries for what the team will and will not address
- B. estimate the final process capability within the improvement project
- C. choose the sampling method within the improvement project
- D. replace stakeholder communications within the improvement project

10. When evaluating a process decision, a SIPOC diagram is normally used early in DMAIC to

- A. calculate control limits for a process
- B. test a hypothesis about two means
- C. define high-level suppliers, inputs, process steps, outputs, and customers
- D. rank risks after a design change

11. In a Green Belt project, a stakeholder analysis helps a project team

- A. calculate the standard deviation of data
- B. anticipate interests, influence, and communication needs
- C. set specification limits for a product
- D. determine the randomization sequence

12. While preparing the next improvement step, the project charter is most valuable because it

- A. proves that the proposed solution works
- B. substitutes for customer research within the improvement project
- C. sets the final process-control limits within the improvement project

D. formally aligns the team on purpose, scope, resources, and sponsorship

13. At a DMAIC tollgate, the voice of the customer is translated into operational requirements so that

- A. all customers receive identical products
- B. the project avoids collecting process data
- C. customer needs can be measured and managed
- D. the team can eliminate specification limits

14. When evaluating a process decision, in the Kano model, a basic requirement is one that

- A. delights customers when it is unexpectedly added
- B. has no effect on customer satisfaction within the improvement project
- C. is unrelated to product performance within the improvement project
- D. causes dissatisfaction when absent even if its presence is taken for granted

15. In a Green Belt project, a project communication plan should specify

- A. only the final presentation format within the improvement project
- B. what information is shared, with whom, when, and by which method
- C. the team's statistical software license within the improvement project
- D. the exact control-chart constants within the improvement project

16. While preparing the next improvement step, an operational definition provides

- A. a precise, repeatable rule for classifying or measuring something
- B. a broad statement of management intent
- C. a list of potential root causes
- D. a forecast of future demand

17. At a DMAIC tollgate, the number of customer complaints received each day is generally

- A. discrete data
- B. continuous data
- C. ordinal data only
- D. a nominal category

18. When evaluating a process decision, a sampling frame is

- A. the graph used to display individual values
- B. the specification range for a measurement within the improvement project
- C. the complete list or source from which a sample can be selected
- D. a method for assigning process owners within the improvement project

19. In a Green Belt project, random sampling is used chiefly to

- A. guarantee that every sample value is different
- B. reduce selection bias and improve representativeness
- C. eliminate all measurement error
- D. make subgroup sizes unnecessary

20. While preparing the next improvement step, stratifying data by shift, product family, or supplier can

- A. remove the need for a baseline measure
- B. prove causation without testing within the improvement project
- C. replace process mapping within the improvement project
- D. reveal patterns that are hidden in aggregated data

21. At a DMAIC tollgate, a detailed process map is especially useful for

- A. calculating a confidence interval
- B. assigning financial benefits to a project
- C. showing sequence, handoffs, decisions, and rework loops
- D. determining the final sample size

22. When evaluating a process decision, a value stream map differs from a basic process map because it emphasizes

- A. only the names of process owners
- B. material and information flow, including waiting and inventory
- C. only customer-survey responses within the improvement project
- D. only statistical distributions within the improvement project

23. In a Green Belt project, the risk priority number in a traditional FMEA is calculated from

- A. severity, occurrence, and detection ratings
- B. mean, median, and mode values
- C. yield, takt time, and lead time
- D. cost, revenue, and margin values

24. While preparing the next improvement step, before relying on process data, a team should verify that

- A. all measurements have the same numerical value
- B. the process mean equals the target
- C. the sample includes every possible unit
- D. the measurement system is sufficiently capable for the intended use

25. At a DMAIC tollgate, measurement accuracy refers to how close measurements are to

- A. one another in repeated trials
- B. the nearest specification limit

- C. the largest observed value
- D. the accepted reference or true value

26. When evaluating a process decision, measurement precision refers to

- A. the closeness of a mean to target
- B. the width of the specification range
- C. the consistency of repeated measurements
- D. the amount of customer demand

27. In a Green Belt project, measurement bias is best described as

- A. random scatter among repeated readings within the improvement project
- B. a consistent difference between observed values and a reference value
- C. a missing category in a survey
- D. a normal pattern of common-cause variation

28. While preparing the next improvement step, linearity in a measurement system concerns whether

- A. bias changes across the operating range
- B. repeatability changes by operator
- C. the process has no outliers
- D. the data follow a normal distribution

29. At a DMAIC tollgate, repeatability evaluates variation when

- A. different operators measure different items
- B. a process is observed across multiple shifts
- C. a sample is divided into strata
- D. the same operator measures the same item repeatedly

30. When evaluating a process decision, reproducibility evaluates variation attributable to

- A. differences among appraisers using the measurement system
- B. the same appraiser repeating a reading
- C. the product's specification limits
- D. the sampling interval within the improvement project

31. In a Green Belt project, a gauge R&R study is used to estimate

- A. the project's financial return
- B. measurement variation from repeatability and reproducibility
- C. the number of defects per opportunity
- D. the customer's willingness to pay

32. While preparing the next improvement step, calibration is the process of

- A. sorting product into conforming and nonconforming groups
- B. removing special causes from a process within the improvement project
- C. comparing an instrument with a traceable standard and adjusting as needed
- D. estimating a process mean from a sample

33. At a DMAIC tollgate, a histogram is most helpful for

- A. displaying the shape, center, and spread of continuous data
- B. ranking categories from most to least frequent
- C. showing tasks against calendar time
- D. mapping supplier relationships within the improvement project

34. When evaluating a process decision, a box plot is particularly useful for

- A. showing every step in a process
- B. testing a causal relationship within the improvement project
- C. comparing distributions and identifying potential outliers across groups
- D. calculating defect opportunities within the improvement project

35. In a Green Belt project, a scatter plot is used primarily to

- A. rank categories by frequency
- B. display cumulative percentages within the improvement project
- C. track project milestones within the improvement project
- D. explore the relationship between two quantitative variables

36. While preparing the next improvement step, a Pareto chart helps a team

- A. determine whether data are normally distributed
- B. prioritize categories by showing their relative contribution
- C. calculate a process capability index
- D. set the project scope

37. At a DMAIC tollgate, a run chart plots data over time to

- A. compare two categorical variables
- B. measure appraiser agreement within the improvement project
- C. identify shifts, trends, or other nonrandom patterns
- D. show a bill of materials

38. When evaluating a process decision, which statistic is least affected by extreme outliers?

- A. The median
- B. The mean
- C. The range

D. The standard deviation

39. In a Green Belt project, standard deviation is a measure of

- A. the difference between target and specification
- B. the number of defects in a sample
- C. the order in which data were collected
- D. the typical spread of values around their mean

40. While preparing the next improvement step, for a normal distribution, approximately 68 percent of observations fall within

- A. one-half standard deviation of the mean
- B. one standard deviation of the mean
- C. two standard deviations of the mean
- D. three standard deviations of the mean

41. At a DMAIC tollgate, a distribution with a long tail to the right is

- A. negatively skewed
- B. positively skewed
- C. symmetric by definition
- D. uniform by definition

42. When evaluating a process decision, a confidence interval gives

- A. the exact value of every future observation
- B. the process specification limits within the improvement project
- C. a plausible range for a population parameter based on sample data
- D. the maximum allowable defect count within the improvement project

43. In a Green Belt project, the null hypothesis generally represents

- A. the improvement the team hopes to prove
- B. the customer requirement within the improvement project
- C. the selected corrective action within the improvement project
- D. the baseline assumption tested for evidence against it

44. While preparing the next improvement step, a Type I error occurs when a team

- A. rejects a true null hypothesis
- B. fails to reject a false null hypothesis
- C. uses an insufficient sample size
- D. finds a special cause on a chart

45. At a DMAIC tollgate, a Type II error occurs when a team

- A. rejects a true null hypothesis
- B. calculates the wrong mean
- C. fails to reject a false null hypothesis
- D. uses a control limit as a specification

46. When evaluating a process decision, a p-value is

- A. the probability of results at least as extreme as observed if the null is true
- B. the probability that the null hypothesis is true within the improvement project
- C. the project's probability of financial success within the improvement project
- D. the percentage of data within specifications within the improvement project

47. In a Green Belt project, a statistically significant result may still lack practical significance when

- A. the sample size equals the population size
- B. the data are displayed on a histogram
- C. the process has no specifications
- D. the observed effect is too small to matter operationally

48. While preparing the next improvement step, correlation between two variables demonstrates

- A. that one variable must cause the other
- B. an association but not necessarily a cause-and-effect relationship
- C. that both variables are normally distributed
- D. that the data have no variation

49. At a DMAIC tollgate, the 5 Whys technique is designed to

- A. rank possible causes by financial cost within the improvement project
- B. move from a symptom toward an underlying cause through repeated questioning
- C. set control limits for a chart within the improvement project
- D. calculate sample-size requirements within the improvement project

50. When evaluating a process decision, a cause-and-effect diagram is used to

- A. test whether two means are different
- B. measure the capability of a process
- C. organize possible causes of a defined effect
- D. schedule project tasks within the improvement project

51. In a Green Belt project, a suspected root cause should be confirmed by

- A. team consensus alone within the improvement project
- B. its position on a brainstorming list
- C. the number of people who proposed it

D. evidence showing that changing or controlling it changes the outcome

52. While preparing the next improvement step, a multi-vari study is valuable because it

- A. separates variation patterns by source such as within-piece, piece-to-piece, or time-to-time
- B. replaces all measurement-system studies within the improvement project
- C. sets financial targets for the project within the improvement project
- D. eliminates the need for sampling within the improvement project

53. At a DMAIC tollgate, simple linear regression is used to

- A. model the average relationship between a response and one predictor
- B. compare only categorical frequencies within the improvement project
- C. calculate an FMEA risk score within the improvement project
- D. set specification limits from customer data

54. When evaluating a process decision, residual analysis is important because residuals can

- A. prove that correlation is causation
- B. show whether model assumptions appear unreasonable
- C. replace the need for a model
- D. determine the project charter scope

55. In a Green Belt project, analysis of variance is commonly used to

- A. compare only two proportions
- B. rank defect categories within the improvement project
- C. compare means across three or more groups
- D. calculate a process sigma level

56. While preparing the next improvement step, a chi-square test is commonly associated with

- A. comparison of two continuous means only
- B. calculation of control limits
- C. measurement-system calibration within the improvement project
- D. relationships or differences involving categorical data

57. At a DMAIC tollgate, a nonparametric test is especially useful when

- A. all data are exactly normally distributed
- B. the team has no categories to compare
- C. data assumptions for a parametric test are not appropriate
- D. a regression line has already been fitted

58. When evaluating a process decision, the main advantage of a designed experiment is that it

- A. guarantees a process will be capable
- B. eliminates the need for randomization
- C. uses only one factor at a time
- D. allows planned study of factor effects and interactions

59. In a Green Belt project, in DOE terminology, a factor is

- A. an input deliberately varied in an experiment
- B. an output measured after the experiment
- C. a subgroup selected from production
- D. a type of control-chart limit

60. While preparing the next improvement step, an interaction exists when

- A. two factors have identical averages within the improvement project
- B. the effect of one factor depends on the level of another factor
- C. a factor has no effect on the response
- D. the response follows a normal distribution within the improvement project

61. At a DMAIC tollgate, randomizing experimental run order helps

- A. reduce the impact of time-related or nuisance variation
- B. ensure every factor is held constant
- C. eliminate replication from the design
- D. make blocking unnecessary in all cases

62. When evaluating a process decision, replication in an experiment helps estimate

- A. only the customer specification within the improvement project
- B. the project schedule within the improvement project
- C. the measurement instrument calibration within the improvement project
- D. experimental error and the stability of observed effects

63. In a Green Belt project, blocking is used in DOE to

- A. create a larger number of factor levels
- B. separate known nuisance variation from factor effects
- C. replace random assignment within the improvement project
- D. eliminate all experimental error

64. While preparing the next improvement step, a full factorial experiment studies

- A. only the best guess for each factor
- B. one factor while holding every other factor fixed
- C. all combinations of the selected factor levels

D. only factors with no interactions

65. At a DMAIC tollgate, a fractional factorial design is often chosen when

- A. every interaction must be estimated without aliasing
- B. many factors must be screened with fewer experimental runs
- C. there are no factors to test
- D. only one observation is available

66. When evaluating a process decision, before broad implementation, a pilot is used to

- A. test a change on a limited scale and learn before full rollout
- B. prove the project is complete without data
- C. replace training for affected employees within the improvement project
- D. set historical control limits within the improvement project

67. In a Green Belt project, a solution-selection matrix is useful for

- A. proving a root cause without evidence
- B. calculating a confidence interval
- C. determining the sampling frame
- D. comparing alternatives against weighted decision criteria

68. While preparing the next improvement step, poka-Yoke refers to

- A. using inspection to sort finished defects
- B. measuring the mean of a process
- C. designing a process so errors are prevented or immediately detected
- D. assigning causes to a fishbone branch

69. At a DMAIC tollgate, the primary purpose of 5S is to

- A. create an organized, visual, and disciplined workplace
- B. increase the number of process steps
- C. replace preventive maintenance within the improvement project
- D. calculate process capability within the improvement project

70. When evaluating a process decision, standard work supports improvement by

- A. allowing each operator to choose a unique method
- B. removing the need for training within the improvement project
- C. setting customer specification limits within the improvement project
- D. documenting the current best known method and making it repeatable

71. In a Green Belt project, a Kaizen event typically focuses on

- A. a multiyear redesign with no immediate action
- B. final inspection of every product
- C. rapid, team-based improvement of a defined process area
- D. a statistical test of one mean

72. While preparing the next improvement step, a kanban system is used to

- A. calculate control-chart limits within the improvement project
- B. signal and control production or replenishment based on consumption
- C. perform a gauge R&R study
- D. identify special-cause variation within the improvement project

73. At a DMAIC tollgate, a pull system produces work primarily in response to

- A. the maximum capacity of upstream equipment
- B. downstream demand or consumption
- C. a fixed monthly forecast regardless of demand
- D. the number of process owners

74. When evaluating a process decision, takt time represents

- A. the total lead time of a product
- B. the maximum permitted cycle time
- C. the available production time divided by customer demand
- D. the number of defects per unit

75. In a Green Belt project, cycle time is

- A. the time required to complete one unit or process cycle
- B. the elapsed time from order to delivery only
- C. the interval between calibration checks within the improvement project
- D. the amount of customer demand per day

76. While preparing the next improvement step, lead time generally measures

- A. only hands-on processing time
- B. the standard deviation of processing times
- C. the staffing level required per shift
- D. total elapsed time from request to delivery

77. At a DMAIC tollgate, which is a classic lean waste?

- A. Waiting for information, materials, or approvals
- B. Training a new operator
- C. Measuring a process output

D. Clarifying a customer requirement

78. When evaluating a process decision, single-minute exchange of die is aimed at

- A. increasing batch size without limit
- B. eliminating all preventive maintenance
- C. reducing changeover time
- D. measuring product capability

79. In a Green Belt project, a process constraint should receive attention because

- A. it always has the highest defect rate
- B. it limits the throughput of the overall system
- C. it determines every customer requirement
- D. it makes measurement systems unnecessary

80. While preparing the next improvement step, after an improvement proves effective, standardization should

- A. allow each shift to return to its former method
- B. be delayed until the next annual review
- C. replace ongoing performance monitoring within the improvement project
- D. embed the new method in procedures, training, and daily work

81. At a DMAIC tollgate, a control plan documents

- A. only the project's original business case within the improvement project
- B. every possible solution considered by the team within the improvement project
- C. what to monitor, how to measure it, who acts, and what response is required
- D. the financial approval process within the improvement project

82. When evaluating a process decision, a control chart is used to

- A. determine whether output meets specifications
- B. rank root causes by importance
- C. calculate the project budget
- D. distinguish common-cause from special-cause variation over time

83. In a Green Belt project, control limits are calculated from

- A. customer requirements alone
- B. process behavior data
- C. the project charter
- D. the maximum allowable defect rate

84. While preparing the next improvement step, specification limits are determined by

- A. customer, design, or regulatory requirements
- B. the observed process mean and standard deviation
- C. the control-chart subgroup size
- D. the team's preferred sampling method

85. At a DMAIC tollgate, common-cause variation is

- A. a signal of a specific unusual event
- B. the natural, routine variation built into a stable process
- C. an error caused by one operator only
- D. a defect that always requires immediate containment

86. When evaluating a process decision, special-cause variation indicates

- A. an unusual source of variation not part of normal process behavior
- B. the normal spread expected in a stable system
- C. a customer specification is too wide within the improvement project
- D. the process average equals the target within the improvement project

87. In a Green Belt project, rational subgrouping means samples are formed so that

- A. each subgroup contains only defective units
- B. subgroup size always equals one within the improvement project
- C. all data are collected at the end of the month
- D. within-subgroup variation reflects short-term process variation

88. While preparing the next improvement step, an individuals and moving-range chart is commonly used when

- A. each sample has a large fixed subgroup
- B. the data are counts of defects
- C. data are collected one observation at a time
- D. the response is a category

89. At a DMAIC tollgate, an X-bar and R chart is commonly used for

- A. individual measurements with no subgroups
- B. continuous data collected in small, rational subgroups
- C. the number of defective units
- D. rare-event defect counts within the improvement project

90. When evaluating a process decision, a p chart monitors

- A. the count of defects per constant area
- B. individual continuous measurements within the improvement project

- C. the proportion of nonconforming units when sample sizes may vary
- D. the average of subgroup ranges within the improvement project

91. In a Green Belt project, an np chart monitors

- A. the proportion nonconforming with varying samples
- B. the number of defects per unit
- C. individual measurement values within the improvement project
- D. the number of nonconforming units with a constant sample size

92. While preparing the next improvement step, a c chart is appropriate for

- A. the number of defects when the inspection opportunity is constant
- B. the proportion of units defective within the improvement project
- C. continuous measurements in subgroups within the improvement project
- D. individual observations over time within the improvement project

93. At a DMAIC tollgate, a u chart is appropriate for

- A. defects per unit when the opportunity or sample size varies
- B. nonconforming units with a fixed sample size
- C. subgroup averages of continuous data within the improvement project
- D. the range of individual values within the improvement project

94. When evaluating a process decision, cp compares

- A. the process mean with the target only
- B. the number of defects with the sample size
- C. the control-limit width with the specification width
- D. the specification width with the process spread

95. In a Green Belt project, C_{pk} differs from C_p because C_{pk}

- A. uses only the upper specification limit
- B. accounts for how centered the process is within specifications
- C. ignores process variation within the improvement project
- D. is calculated only from attribute data

96. While preparing the next improvement step, a reaction plan should state

- A. only the date of the next team meeting
- B. the final project financial benefit within the improvement project
- C. the immediate action, escalation, and investigation steps after an out-of-control signal
- D. the original list of brainstormed causes within the improvement project

97. At a DMAIC tollgate, visual management is effective when

- A. all process information is kept confidential
- B. normal conditions and abnormalities are easy to see and understand
- C. employees must interpret complex reports before acting
- D. work instructions are removed from the workplace

98. When evaluating a process decision, a process audit after implementation should

- A. replace the control plan within the improvement project
- B. eliminate the need for performance data within the improvement project
- C. focus only on assigning blame within the improvement project
- D. check whether the new method is being followed and remains effective

99. In a Green Belt project, a formal project handoff should include

- A. only a list of project team names
- B. the original brainstorming notes
- C. ownership, controls, training, documentation, and follow-up expectations
- D. the final presentation slide deck

100. While preparing the next improvement step, benefit tracking after closure is important because it

- A. confirms that predicted gains are sustained and real
- B. proves that no further monitoring is needed
- C. replaces customer feedback within the improvement project
- D. eliminates process variation within the improvement project

Practice Exam 13: Answer Key and Explanations

1. D — The keyed choice accurately describes Six Sigma role within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

2. C — The keyed choice accurately describes customer focus within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

3. B — The keyed choice accurately describes CTQ within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

4. A — The keyed choice accurately describes process thinking within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

5. D — The keyed choice accurately describes project selection within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

- 6. A** — The keyed choice accurately describes business case within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.
- 7. C** — The keyed choice accurately describes problem statement within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.
- 8. B** — The keyed choice accurately describes goal statement within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.
- 9. A** — The keyed choice accurately describes scope within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.
- 10. C** — The keyed choice accurately describes SIPOC within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.
- 11. B** — The keyed choice accurately describes stakeholders within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.
- 12. D** — The keyed choice accurately describes charter authority within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.
- 13. C** — The keyed choice accurately describes VOC within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.
- 14. D** — The keyed choice accurately describes Kano model within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The

other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

15. B — The keyed choice accurately describes communication plan within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

16. A — The keyed choice accurately describes operational definition within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

17. A — The keyed choice accurately describes data types within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

18. C — The keyed choice accurately describes sampling frame within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

19. B — The keyed choice accurately describes random sampling within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

20. D — The keyed choice accurately describes stratification within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

21. C — The keyed choice accurately describes process map within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

22. B — The keyed choice accurately describes value stream map within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit

that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

23. A — The keyed choice accurately describes FMEA within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

24. D — The keyed choice accurately describes measurement system within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

25. D — The keyed choice accurately describes accuracy within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

26. C — The keyed choice accurately describes precision within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

27. B — The keyed choice accurately describes bias within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

28. A — The keyed choice accurately describes linearity within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

29. D — The keyed choice accurately describes repeatability within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

30. A — The keyed choice accurately describes reproducibility within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

31. B — The keyed choice accurately describes gauge R&R within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The

other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

32. C — The keyed choice accurately describes calibration within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

33. A — The keyed choice accurately describes histogram within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

34. C — The keyed choice accurately describes box plot within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

35. D — The keyed choice accurately describes scatter plot within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

36. B — The keyed choice accurately describes Pareto chart within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

37. C — The keyed choice accurately describes run chart within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

38. A — The keyed choice accurately describes central tendency within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

39. D — The keyed choice accurately describes variation within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

40. B — The keyed choice accurately describes normal distribution within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred

solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

41. B — The keyed choice accurately describes skewness within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

42. C — The keyed choice accurately describes confidence interval within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

43. D — The keyed choice accurately describes hypothesis test within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

44. A — The keyed choice accurately describes Type I error within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

45. C — The keyed choice accurately describes Type II error within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

46. A — The keyed choice accurately describes p-value within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

47. D — The keyed choice accurately describes practical significance within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

48. B — The keyed choice accurately describes correlation within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

49. B — The keyed choice accurately describes 5 Whys within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

50. C — The keyed choice accurately describes fishbone diagram within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

51. D — The keyed choice accurately describes cause verification within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

52. A — The keyed choice accurately describes multi-vari study within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

53. A — The keyed choice accurately describes regression within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

54. B — The keyed choice accurately describes residuals within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

55. C — The keyed choice accurately describes ANOVA within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

56. D — The keyed choice accurately describes chi-square within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

57. C — The keyed choice accurately describes nonparametric tests within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred

solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

58. D — The keyed choice accurately describes design of experiments within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

59. A — The keyed choice accurately describes factors and levels within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

60. B — The keyed choice accurately describes interaction within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

61. A — The keyed choice accurately describes randomization within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

62. D — The keyed choice accurately describes replication within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

63. B — The keyed choice accurately describes blocking within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

64. C — The keyed choice accurately describes full factorial within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

65. B — The keyed choice accurately describes fractional factorial within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit

that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

66. A — The keyed choice accurately describes pilot test within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

67. D — The keyed choice accurately describes solution selection within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

68. C — The keyed choice accurately describes Poka-Yoke within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

69. A — The keyed choice accurately describes 5S within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

70. D — The keyed choice accurately describes standard work within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

71. C — The keyed choice accurately describes Kaizen within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

72. B — The keyed choice accurately describes kanban within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

73. B — The keyed choice accurately describes pull system within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

74. C — The keyed choice accurately describes takt time within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The

other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

75. A — The keyed choice accurately describes cycle time within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

76. D — The keyed choice accurately describes lead time within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

77. A — The keyed choice accurately describes waste within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

78. C — The keyed choice accurately describes SMED within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

79. B — The keyed choice accurately describes capacity constraint within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

80. D — The keyed choice accurately describes standardization within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

81. C — The keyed choice accurately describes control plan within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

82. D — The keyed choice accurately describes control chart purpose within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

83. B — The keyed choice accurately describes control limits within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

84. A — The keyed choice accurately describes specification limits within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

85. B — The keyed choice accurately describes common cause within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

86. A — The keyed choice accurately describes special cause within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

87. D — The keyed choice accurately describes rational subgrouping within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

88. C — The keyed choice accurately describes I-MR chart within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

89. B — The keyed choice accurately describes Xbar-R chart within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

90. C — The keyed choice accurately describes p chart within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

91. D — The keyed choice accurately describes np chart within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The

other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

92. A — The keyed choice accurately describes c chart within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

93. A — The keyed choice accurately describes u chart within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

94. D — The keyed choice accurately describes process capability within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

95. B — The keyed choice accurately describes process centering within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

96. C — The keyed choice accurately describes control response within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

97. B — The keyed choice accurately describes visual management within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

98. D — The keyed choice accurately describes audit within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

99. C — The keyed choice accurately describes handoff within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The

other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.

100. A — The keyed choice accurately describes benefit tracking within Six Sigma practice. This concept supports a disciplined, evidence-based decision rather than an assumption or a preferred solution. The other choices either describe a different quality tool, misuse the concept, or claim a benefit that the method cannot guarantee. Consistent use helps teams improve and sustain reliable process performance.