

EXAM 14: LEAN SIX SIGMA GREEN BELT SIMULATION

(100 QUESTIONS)

This 100-question practice simulation is aligned to the ASQ Certified Six Sigma Green Belt Body of Knowledge, proportionally scaled from its computer-delivered blueprint. Allow 4 hours and 18 minutes. Choose the single best answer for each question. This is an original study aid, not an ASQ examination.

1. A Green Belt is reviewing Six Sigma organizational goals. Which response is best?
 - A. Use it only to assign individual blame for documented outcomes
 - B. Use it to align project work to customer requirements and business performance
 - C. Use it to replace stated customer requirements and specifications
 - D. Use it only after project closure and final reporting

2. During a project tollgate, the team evaluates Lean principles. Which response is best?
 - A. Use it to remove non-value-added work while improving flow
 - B. Use it only to assign individual blame for documented outcomes
 - C. Use it to replace stated customer requirements and specifications
 - D. Use it only after project closure and final reporting

3. For a service-process improvement, consider process owners. Which response is best?
 - A. Use it only to assign individual blame for documented outcomes
 - B. Use it to replace stated customer requirements and specifications
 - C. Use it to retain accountability for process performance after improvement
 - D. Use it only after project closure and final reporting

4. In a manufacturing project, choose the statement about team roles. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to match responsibilities to appropriate project authority

5. A cross-functional team needs to apply project selection. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to favor a measurable problem with meaningful business value
- D. Use it only after project closure and final reporting

6. While planning a DMAIC project, assess voice of the customer. Which response is best?

- A. Use it to translate customer needs into measurable requirements
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

7. A Green Belt is reviewing cost of poor quality. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to quantify failure-related costs that improvement can reduce
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

8. During a project tollgate, the team evaluates process thinking. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to view work as linked inputs, steps, outputs, and customers

9. For a service-process improvement, consider DMAIC. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to improve an existing process through disciplined phases

10. In a manufacturing project, choose the statement about DMADV. Which response is best?

- A. Use it to design a new process or product to meet requirements
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

11. A cross-functional team needs to apply stakeholder management. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to identify affected groups and plan engagement
- D. Use it only after project closure and final reporting

12. While planning a DMAIC project, assess change management. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to address adoption risks as well as technical changes
- C. Use it to replace stated customer requirements and specifications

D. Use it only after project closure and final reporting

13. A Green Belt is reviewing team facilitation. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to structure participation so ideas and evidence are heard

14. During a project tollgate, the team evaluates ethics in data reporting. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to present evidence honestly without manipulating conclusions
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

15. For a service-process improvement, consider project charter. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to define problem, goal, scope, roles, and business case
- D. Use it only after project closure and final reporting

16. In a manufacturing project, choose the statement about problem statement. Which response is best?

- A. Use it to describe the current gap without assuming a solution
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

17. A cross-functional team needs to apply goal statement. Which response is best?

- A. Use it to state a measurable improvement target and timeframe
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

18. While planning a DMAIC project, assess SIPOC. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to summarize suppliers, inputs, process, outputs, and customers
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

19. A Green Belt is reviewing process map. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to show detailed steps, handoffs, decisions, and rework

20. During a project tollgate, the team evaluates CTQ tree. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to link customer needs to measurable process requirements
- D. Use it only after project closure and final reporting

21. For a service-process improvement, consider project scope. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to set clear inclusion and exclusion boundaries

22. In a manufacturing project, choose the statement about financial benefit estimate. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to use credible assumptions and distinguish hard from soft savings
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

23. A cross-functional team needs to apply risk assessment. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to identify likely threats and response actions early
- D. Use it only after project closure and final reporting

24. While planning a DMAIC project, assess communication plan. Which response is best?

- A. Use it to specify audiences, messages, channels, timing, and owners
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

25. A Green Belt is reviewing work breakdown structure. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications

- C. Use it only after project closure and final reporting
- D. Use it to decompose deliverables into manageable work packages

26. During a project tollgate, the team evaluates Gantt chart. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to track activities and milestones against a timeline
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

27. For a service-process improvement, consider network diagram. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to show task dependencies and critical paths
- D. Use it only after project closure and final reporting

28. In a manufacturing project, choose the statement about FMEA planning use. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to anticipate risks before implementation decisions
- D. Use it only after project closure and final reporting

29. A cross-functional team needs to apply data collection strategy. Which response is best?

- A. Use it to connect measures to the project questions
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

30. While planning a DMAIC project, assess operational definitions. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to make classifications and measurements reproducible
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

31. A Green Belt is reviewing baseline performance. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to establish the starting state before changes

32. During a project tollgate, the team evaluates tollgate review. Which response is best?

- A. Use it to verify evidence and readiness before advancing phases
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

33. For a service-process improvement, consider sampling plan. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to define the population, sampling method, timing, and sample size
- D. Use it only after project closure and final reporting

34. In a manufacturing project, choose the statement about stratification. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to separate data by relevant sources to expose meaningful patterns

35. A cross-functional team needs to apply measurement-system analysis. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to verify that data are fit for the decision
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

36. While planning a DMAIC project, assess accuracy. Which response is best?

- A. Use it to assess closeness of a measurement to a reference value
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

37. A Green Belt is reviewing precision. Which response is best?

- A. Use it to assess consistency among repeated measurements
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

38. During a project tollgate, the team evaluates bias. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting

D. Use it to identify a systematic offset from the reference

39. For a service-process improvement, consider linearity. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to evaluate whether bias changes across the measurement range
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

40. In a manufacturing project, choose the statement about stability. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to evaluate measurement consistency over time
- D. Use it only after project closure and final reporting

41. A cross-functional team needs to apply repeatability. Which response is best?

- A. Use it to quantify equipment variation under the same conditions
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

42. While planning a DMAIC project, assess reproducibility. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to quantify appraiser-to-appraiser variation

43. A Green Belt is reviewing variable data. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to measure a quantity on a continuous scale
- D. Use it only after project closure and final reporting

44. During a project tollgate, the team evaluates attribute data. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to classify outcomes into categories or counts
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

45. For a service-process improvement, consider mean. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to summarize the arithmetic average of numerical observations

46. In a manufacturing project, choose the statement about median. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to summarize the central ordered observation
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

47. A cross-functional team needs to apply standard deviation. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to describe typical spread around the mean
- D. Use it only after project closure and final reporting

48. While planning a DMAIC project, assess confidence interval. Which response is best?

- A. Use it to estimate a plausible range for a population value
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

49. A Green Belt is reviewing normal distribution. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to model continuous data with a symmetric bell-shaped pattern

50. During a project tollgate, the team evaluates binomial distribution. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to model counts of successes across two-outcome trials
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

51. For a service-process improvement, consider process capability. Which response is best?

- A. Use it to compare stable process variation to specification limits
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications

D. Use it only after project closure and final reporting

52. In a manufacturing project, choose the statement about Cp index. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to assess potential capability from spread alone
- D. Use it only after project closure and final reporting

53. A cross-functional team needs to apply Cpk index. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to assess actual capability including process centering

54. While planning a DMAIC project, assess control chart selection. Which response is best?

- A. Use it to match the chart type to data and subgroup structure
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

55. A Green Belt is reviewing rational subgrouping. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to form samples so within-group variation reflects common causes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

56. During a project tollgate, the team evaluates Pareto analysis. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to prioritize categories by frequency, cost, or impact
- D. Use it only after project closure and final reporting

57. For a service-process improvement, consider cause-and-effect diagram. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to organize possible causes for systematic investigation

58. In a manufacturing project, choose the statement about 5 Whys. Which response is best?

- A. Use it to move from an observed symptom toward a causal mechanism
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

59. A cross-functional team needs to apply correlation analysis. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to describe association without claiming causation
- D. Use it only after project closure and final reporting

60. While planning a DMAIC project, assess regression analysis. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to model an output from one or more input variables
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

61. A Green Belt is reviewing hypothesis test. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to use sample evidence to evaluate a stated claim
- D. Use it only after project closure and final reporting

62. During a project tollgate, the team evaluates null hypothesis. Which response is best?

- A. Use it to represent the default claim tested against evidence
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

63. For a service-process improvement, consider p-value. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to quantify compatibility of observed data with the null hypothesis

64. In a manufacturing project, choose the statement about Type I error. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to reject a true null hypothesis
- C. Use it to replace stated customer requirements and specifications

D. Use it only after project closure and final reporting

65. A cross-functional team needs to apply Type II error. Which response is best?

- A. Use it to fail to reject a false null hypothesis
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

66. While planning a DMAIC project, assess power. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to measure the ability to detect a meaningful effect

67. A Green Belt is reviewing ANOVA. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to compare means among three or more groups
- D. Use it only after project closure and final reporting

68. During a project tollgate, the team evaluates root-cause verification. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to confirm a causal factor with evidence before acting
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

69. For a service-process improvement, consider multi-vari analysis. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to separate variation by position, cycle, or temporal source
- D. Use it only after project closure and final reporting

70. In a manufacturing project, choose the statement about brainstorming. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to generate many possible ideas before judging them
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

71. A cross-functional team needs to apply affinity diagram. Which response is best?

- A. Use it to group ideas into natural themes
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

72. While planning a DMAIC project, assess solution selection matrix. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to compare alternatives against explicit criteria

73. A Green Belt is reviewing cost-benefit analysis. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to compare expected gains with implementation and operating costs
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

74. During a project tollgate, the team evaluates pilot test. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to test a change on a limited scale before broad deployment
- D. Use it only after project closure and final reporting

75. For a service-process improvement, consider DOE. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to systematically study how inputs affect an output

76. In a manufacturing project, choose the statement about factor. Which response is best?

- A. Use it to identify a controlled input variable in an experiment
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

77. A cross-functional team needs to apply response variable. Which response is best?

- A. Use it to measure the outcome affected by experimental factors
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications

D. Use it only after project closure and final reporting

78. While planning a DMAIC project, assess interaction. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to recognize when one factor's effect depends on another

79. A Green Belt is reviewing randomization. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to reduce bias from uncontrolled nuisance factors
- D. Use it only after project closure and final reporting

80. During a project tollgate, the team evaluates replication. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to estimate experimental error and improve confidence
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

81. For a service-process improvement, consider blocking. Which response is best?

- A. Use it to control known nuisance variation in an experiment
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

82. In a manufacturing project, choose the statement about 5S. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to organize the workplace for visual control and efficient flow
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

83. A cross-functional team needs to apply standard work. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to document the best known current method
- D. Use it only after project closure and final reporting

84. While planning a DMAIC project, assess poka-yoke. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to prevent an error or detect it immediately

85. A Green Belt is reviewing kanban. Which response is best?

- A. Use it to signal replenishment based on downstream consumption
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

86. During a project tollgate, the team evaluates kaizen event. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to make focused, rapid, team-based improvements
- D. Use it only after project closure and final reporting

87. For a service-process improvement, consider future-state map. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to design an improved flow that meets customer demand

88. In a manufacturing project, choose the statement about control plan. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to specify monitoring, ownership, reaction, and documentation
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

89. A cross-functional team needs to apply reaction plan. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to define timely action when a control signal occurs
- D. Use it only after project closure and final reporting

90. While planning a DMAIC project, assess X-bar and R chart. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting

D. Use it to monitor subgroup averages and within-subgroup variation

91. A Green Belt is reviewing individuals chart. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to monitor single observations over time
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

92. During a project tollgate, the team evaluates p chart. Which response is best?

- A. Use it to monitor the proportion nonconforming
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

93. For a service-process improvement, consider u chart. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to monitor defects per unit when opportunities vary
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

94. In a manufacturing project, choose the statement about control limits. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to represent expected process behavior rather than specifications

95. A cross-functional team needs to apply special-cause signal. Which response is best?

- A. Use it to trigger investigation of an unusual source of variation
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

96. While planning a DMAIC project, assess standard operating procedure. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to document the approved method for consistent execution
- D. Use it only after project closure and final reporting

97. A Green Belt is reviewing document control. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it only after project closure and final reporting
- D. Use it to ensure people use current approved process information

98. During a project tollgate, the team evaluates training plan. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to replace stated customer requirements and specifications
- C. Use it to prepare affected people to execute the new standard
- D. Use it only after project closure and final reporting

99. For a service-process improvement, consider process ownership. Which response is best?

- A. Use it to assign ongoing accountability for results and response
- B. Use it only to assign individual blame for documented outcomes
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

100. In a manufacturing project, choose the statement about project closure. Which response is best?

- A. Use it only to assign individual blame for documented outcomes
- B. Use it to confirm results, transfer ownership, and capture lessons learned
- C. Use it to replace stated customer requirements and specifications
- D. Use it only after project closure and final reporting

Exam 14: Answer Key and Explanations

1. B — The best answer is the choice that recognizes how Six Sigma organizational goals should be used: it should align project work to customer requirements and business performance. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That

2. A — The best answer is the choice that recognizes how Lean principles should be used: it should remove non-value-added work while improving flow. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

3. C — The best answer is the choice that recognizes how process owners should be used: it should retain accountability for process performance after improvement. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

4. D — The best answer is the choice that recognizes how team roles should be used: it should match responsibilities to appropriate project authority. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

5. C — The best answer is the choice that recognizes how project selection should be used: it should favor a measurable problem with meaningful business value. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

6. A — The best answer is the choice that recognizes how voice of the customer should be used: it should translate customer needs into measurable requirements. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

7. B — The best answer is the choice that recognizes how cost of poor quality should be used: it should quantify failure-related costs that improvement can reduce. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach

8. D — The best answer is the choice that recognizes how process thinking should be used: it should view work as linked inputs, steps, outputs, and customers. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach

9. D — The best answer is the choice that recognizes how DMAIC should be used: it should improve an existing process through disciplined phases. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

10. A — The best answer is the choice that recognizes how DMADV should be used: it should design a new process or product to meet requirements. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

11. C — The best answer is the choice that recognizes how stakeholder management should be used: it should identify affected groups and plan engagement. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

12. B — The best answer is the choice that recognizes how change management should be used: it should address adoption risks as well as technical changes. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

13. D — The best answer is the choice that recognizes how team facilitation should be used: it should structure participation so ideas and evidence are heard. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

14. B — The best answer is the choice that recognizes how ethics in data reporting should be used: it should present evidence honestly without manipulating conclusions. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

15. C — The best answer is the choice that recognizes how project charter should be used: it should define problem, goal, scope, roles, and business case. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

16. A — The best answer is the choice that recognizes how problem statement should be used: it should describe the current gap without assuming a solution. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

17. A — The best answer is the choice that recognizes how goal statement should be used: it should state a measurable improvement target and timeframe. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

18. B — The best answer is the choice that recognizes how SIPOC should be used: it should summarize suppliers, inputs, process, outputs, and customers. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

19. D — The best answer is the choice that recognizes how process map should be used: it should show detailed steps, handoffs, decisions, and rework. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

20. C — The best answer is the choice that recognizes how CTQ tree should be used: it should link customer needs to measurable process requirements. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined

measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

21. D — The best answer is the choice that recognizes how project scope should be used: it should set clear inclusion and exclusion boundaries. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

22. B — The best answer is the choice that recognizes how financial benefit estimate should be used: it should use credible assumptions and distinguish hard from soft savings. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based

23. C — The best answer is the choice that recognizes how risk assessment should be used: it should identify likely threats and response actions early. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

24. A — The best answer is the choice that recognizes how communication plan should be used: it should specify audiences, messages, channels, timing, and owners. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

25. D — The best answer is the choice that recognizes how work breakdown structure should be used: it should decompose deliverables into manageable work packages. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

26. B — The best answer is the choice that recognizes how Gantt chart should be used: it should track activities and milestones against a timeline. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

27. C — The best answer is the choice that recognizes how network diagram should be used: it should show task dependencies and critical paths. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

28. C — The best answer is the choice that recognizes how FMEA planning use should be used: it should anticipate risks before implementation decisions. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

29. A — The best answer is the choice that recognizes how data collection strategy should be used: it should connect measures to the project questions. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

30. B — The best answer is the choice that recognizes how operational definitions should be used: it should make classifications and measurements reproducible. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and

31. D — The best answer is the choice that recognizes how baseline performance should be used: it should establish the starting state before changes. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

32. A — The best answer is the choice that recognizes how tollgate review should be used: it should verify evidence and readiness before advancing phases. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

33. C — The best answer is the choice that recognizes how sampling plan should be used: it should define the population, sampling method, timing, and sample size. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach

34. D — The best answer is the choice that recognizes how stratification should be used: it should separate data by relevant sources to expose meaningful patterns. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

35. B — The best answer is the choice that recognizes how measurement-system analysis should be used: it should verify that data are fit for the decision. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined

measures, documented assumptions, and review with the process owner. That evidence-based approach supports

36. A — The best answer is the choice that recognizes how accuracy should be used: it should assess closeness of a measurement to a reference value. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

37. A — The best answer is the choice that recognizes how precision should be used: it should assess consistency among repeated measurements. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and sustained

38. D — The best answer is the choice that recognizes how bias should be used: it should identify a systematic offset from the reference. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

39. B — The best answer is the choice that recognizes how linearity should be used: it should evaluate whether bias changes across the measurement range. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

40. C — The best answer is the choice that recognizes how stability should be used: it should evaluate measurement consistency over time. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and sustained

41. A — The best answer is the choice that recognizes how repeatability should be used: it should quantify equipment variation under the same conditions. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

42. D — The best answer is the choice that recognizes how reproducibility should be used: it should quantify appraiser-to-appraiser variation. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and sustained project results.

43. C — The best answer is the choice that recognizes how variable data should be used: it should measure a quantity on a continuous scale. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

44. B — The best answer is the choice that recognizes how attribute data should be used: it should classify outcomes into categories or counts. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

45. D — The best answer is the choice that recognizes how mean should be used: it should summarize the arithmetic average of numerical observations. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

46. B — The best answer is the choice that recognizes how median should be used: it should summarize the central ordered observation. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and sustained

47. C — The best answer is the choice that recognizes how standard deviation should be used: it should describe typical spread around the mean. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

48. A — The best answer is the choice that recognizes how confidence interval should be used: it should estimate a plausible range for a population value. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

49. D — The best answer is the choice that recognizes how normal distribution should be used: it should model continuous data with a symmetric bell-shaped pattern. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

50. B — The best answer is the choice that recognizes how binomial distribution should be used: it should model counts of successes across two-outcome trials. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined

measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

51. A — The best answer is the choice that recognizes how process capability should be used: it should compare stable process variation to specification limits. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

52. C — The best answer is the choice that recognizes how Cp index should be used: it should assess potential capability from spread alone. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

53. D — The best answer is the choice that recognizes how Cpk index should be used: it should assess actual capability including process centering. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

54. A — The best answer is the choice that recognizes how control chart selection should be used: it should match the chart type to data and subgroup structure. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based

55. B — The best answer is the choice that recognizes how rational subgrouping should be used: it should form samples so within-group variation reflects common causes. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

56. C — The best answer is the choice that recognizes how Pareto analysis should be used: it should prioritize categories by frequency, cost, or impact. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

57. D — The best answer is the choice that recognizes how cause-and-effect diagram should be used: it should organize possible causes for systematic investigation. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

58. A — The best answer is the choice that recognizes how 5 Whys should be used: it should move from an observed symptom toward a causal mechanism. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach

59. C — The best answer is the choice that recognizes how correlation analysis should be used: it should describe association without claiming causation. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and

60. B — The best answer is the choice that recognizes how regression analysis should be used: it should model an output from one or more input variables. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach

61. C — The best answer is the choice that recognizes how hypothesis test should be used: it should use sample evidence to evaluate a stated claim. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

62. A — The best answer is the choice that recognizes how null hypothesis should be used: it should represent the default claim tested against evidence. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

63. D — The best answer is the choice that recognizes how p-value should be used: it should quantify compatibility of observed data with the null hypothesis. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

64. B — The best answer is the choice that recognizes how Type I error should be used: it should reject a true null hypothesis. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

65. A — The best answer is the choice that recognizes how Type II error should be used: it should fail to reject a false null hypothesis. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

66. D — The best answer is the choice that recognizes how power should be used: it should measure the ability to detect a meaningful effect. The other choices confuse the concept with a different tool, phase,

or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

67. C — The best answer is the choice that recognizes how ANOVA should be used: it should compare means among three or more groups. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

68. B — The best answer is the choice that recognizes how root-cause verification should be used: it should confirm a causal factor with evidence before acting. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

69. C — The best answer is the choice that recognizes how multi-vari analysis should be used: it should separate variation by position, cycle, or temporal source. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

70. B — The best answer is the choice that recognizes how brainstorming should be used: it should generate many possible ideas before judging them. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

71. A — The best answer is the choice that recognizes how affinity diagram should be used: it should group ideas into natural themes. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and

72. D — The best answer is the choice that recognizes how solution selection matrix should be used: it should compare alternatives against explicit criteria. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

73. B — The best answer is the choice that recognizes how cost-benefit analysis should be used: it should compare expected gains with implementation and operating costs. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

74. C — The best answer is the choice that recognizes how pilot test should be used: it should test a change on a limited scale before broad deployment. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based

75. D — The best answer is the choice that recognizes how DOE should be used: it should systematically study how inputs affect an output. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

76. A — The best answer is the choice that recognizes how factor should be used: it should identify a controlled input variable in an experiment. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

77. A — The best answer is the choice that recognizes how response variable should be used: it should measure the outcome affected by experimental factors. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

78. D — The best answer is the choice that recognizes how interaction should be used: it should recognize when one factor's effect depends on another. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

79. C — The best answer is the choice that recognizes how randomization should be used: it should reduce bias from uncontrolled nuisance factors. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and

80. B — The best answer is the choice that recognizes how replication should be used: it should estimate experimental error and improve confidence. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and

81. A — The best answer is the choice that recognizes how blocking should be used: it should control known nuisance variation in an experiment. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures,

documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

82. B — The best answer is the choice that recognizes how 5S should be used: it should organize the workplace for visual control and efficient flow. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

83. C — The best answer is the choice that recognizes how standard work should be used: it should document the best known current method. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

84. D — The best answer is the choice that recognizes how poka-yoke should be used: it should prevent an error or detect it immediately. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

85. A — The best answer is the choice that recognizes how kanban should be used: it should signal replenishment based on downstream consumption. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and

86. C — The best answer is the choice that recognizes how kaizen event should be used: it should make focused, rapid, team-based improvements. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and

87. D — The best answer is the choice that recognizes how future-state map should be used: it should design an improved flow that meets customer demand. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

88. B — The best answer is the choice that recognizes how control plan should be used: it should specify monitoring, ownership, reaction, and documentation. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions

89. C — The best answer is the choice that recognizes how reaction plan should be used: it should define timely action when a control signal occurs. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

90. D — The best answer is the choice that recognizes how X-bar and R chart should be used: it should monitor subgroup averages and within-subgroup variation. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

91. B — The best answer is the choice that recognizes how individuals chart should be used: it should monitor single observations over time. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and

92. A — The best answer is the choice that recognizes how p chart should be used: it should monitor the proportion nonconforming. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable decisions and sustained

93. B — The best answer is the choice that recognizes how u chart should be used: it should monitor defects per unit when opportunities vary. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

94. D — The best answer is the choice that recognizes how control limits should be used: it should represent expected process behavior rather than specifications. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

95. A — The best answer is the choice that recognizes how special-cause signal should be used: it should trigger investigation of an unusual source of variation. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

96. C — The best answer is the choice that recognizes how standard operating procedure should be used: it should document the approved method for consistent execution. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using

defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

97. D — The best answer is the choice that recognizes how document control should be used: it should ensure people use current approved process information. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

98. C — The best answer is the choice that recognizes how training plan should be used: it should prepare affected people to execute the new standard. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports

99. A — The best answer is the choice that recognizes how process ownership should be used: it should assign ongoing accountability for results and response. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports reliable

100. B — The best answer is the choice that recognizes how project closure should be used: it should confirm results, transfer ownership, and capture lessons learned. The other choices confuse the concept with a different tool, phase, or managerial activity. A Green Belt should apply this method using defined measures, documented assumptions, and review with the process owner. That evidence-based approach supports