

SIX SIGMA GREEN BELT STUDY GUIDE 2026-2027: EXAM 13

(100 QUESTIONS)

This 100-question practice exam follows the ASQ CSSGB Body of Knowledge distribution: Overview 11, Define 20, Measure 20, Analyze 18, Improve 16, and Control 15. ASQ computer-delivered CSSGB exams contain 110 questions, with 100 scored and 10 unscored, and allow 4 hours 18 minutes of exam time. Use this set as a timed 100-question simulation.

1. When reviewing an improvement project, why do organizations use Six Sigma?
 - A. Potential failure modes, effects, and prioritized risks.
 - B. By multiplying severity, occurrence, and detection ratings.
 - C. To improve performance by reducing variation and defects.
 - D. Inventory while supplying what is needed when needed.
2. When reviewing an improvement project, what does a value stream map primarily reveal?
 - A. Value-added and non-value-added flow through a process.
 - B. The process owner responsible for the end-to-end process.
 - C. Translate broad customer needs into measurable requirements.
 - D. Conducting structured customer interviews or observations.
3. When reviewing an improvement project, what is takt time?
 - A. To detect unintended harm caused by an improvement.
 - B. The available production time divided by customer demand.
 - C. Who is responsible, accountable, consulted, and informed.
 - D. To assess readiness before moving to the next phase.
4. When reviewing an improvement project, what is the theory of constraints concerned with?
 - A. It narrows a list of options using structured team votes.
 - B. Assessing interests, influence, and engagement needs.
 - C. Documented results, lessons learned, and a handoff plan.
 - D. Managing the system constraint that limits overall throughput.
5. When reviewing an improvement project, what is a Gemba walk intended to do?
 - A. Observe the work where the process is actually performed.
 - B. The median, which is the middle ordered observation.
 - C. The typical spread of values around the mean.
 - D. The distribution of numerical data across intervals.
6. When reviewing an improvement project, what is a pull system designed to do?
 - A. A customer or engineering requirement for acceptable output.

- B. The process variation estimated from observed data.
 - C. Authorize work in response to downstream customer demand.
 - D. Specification width with potential process variation.
7. When reviewing an improvement project, in DMADV, what does the V represent?
- A. Whether data plausibly follow a normal distribution.
 - B. Verify that the design meets stated requirements.
 - C. The number of units and defect opportunities.
 - D. The strength and direction of a linear association.
8. When reviewing an improvement project, what is an FMEA used to identify?
- A. Failing to reject a false null hypothesis.
 - B. The probability of detecting a real specified effect.
 - C. When comparing two measurements from the same matched units.
 - D. Potential failure modes, effects, and prioritized risks.
9. When reviewing an improvement project, how is an FMEA risk priority number calculated?
- A. By multiplying severity, occurrence, and detection ratings.
 - B. An undesired top event and its contributing logic.
 - C. Current performance with the desired future state.
 - D. Positional, cyclical, and temporal sources of variation.
10. When reviewing an improvement project, what is just-in-time production intended to minimize?
- A. The measured outcome affected by factors and conditions.
 - B. Inventory while supplying what is needed when needed.
 - C. To reduce bias from uncontrolled nuisance influences.
 - D. An estimate of experimental error and stronger evidence.
11. When reviewing an improvement project, which metric best reflects a customer-focused business driver?
- A. The documented best current method for performing work.
 - B. Reducing setup or changeover time.
 - C. A focused, rapid improvement effort involving the workplace team.
 - D. Customer satisfaction measured against defined expectations.
12. When reviewing an improvement project, what is the main purpose of a SIPOC?
- A. To distinguish improvement effects from background changes.
 - B. Inherent variation from the stable process system.
 - C. To summarize suppliers, inputs, process, outputs, and customers.

D. Variation from an identifiable, nonroutine source.

13. When reviewing an improvement project, what makes a project goal SMART?

- A. A u chart that adjusts for changing opportunity.
- B. To specify how critical outputs will be monitored and reacted to.
- C. It is specific, measurable, achievable, relevant, and time-bound.
- D. Managing approved versions, access, changes, and retention.

14. When reviewing an improvement project, what should a good problem statement include?

- A. A visual signal that calls attention to an abnormal condition.
- B. The current condition, baseline, and measurable business impact.
- C. Building in detection and response so defects do not flow onward.
- D. To improve performance by reducing variation and defects.

15. When reviewing an improvement project, who is accountable for ongoing process performance?

- A. To improve performance by reducing variation and defects.
- B. Value-added and non-value-added flow through a process.
- C. The available production time divided by customer demand.
- D. The process owner responsible for the end-to-end process.

16. When reviewing an improvement project, what is a CTQ tree used to do?

- A. Translate broad customer needs into measurable requirements.
- B. To improve performance by reducing variation and defects.
- C. Value-added and non-value-added flow through a process.
- D. The available production time divided by customer demand.

17. When reviewing an improvement project, which method collects direct Voice of the Customer detail?

- A. To improve performance by reducing variation and defects.
- B. Value-added and non-value-added flow through a process.
- C. Conducting structured customer interviews or observations.
- D. The available production time divided by customer demand.

18. When reviewing an improvement project, what is a Kano must-be requirement?

- A. A basic feature whose absence causes dissatisfaction.
- B. To improve performance by reducing variation and defects.
- C. Value-added and non-value-added flow through a process.
- D. The available production time divided by customer demand.

19. When reviewing an improvement project, what is the main use of a project charter?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. To authorize the project and clarify purpose, scope, and roles.
20. When reviewing an improvement project, what does a work breakdown structure provide?
- A. To improve performance by reducing variation and defects.
 - B. A hierarchical decomposition of the project work.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
21. When reviewing an improvement project, what does the critical path identify?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The longest sequence of dependent activities controlling duration.
 - D. The available production time divided by customer demand.
22. When reviewing an improvement project, why are consequential metrics tracked?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. To detect unintended harm caused by an improvement.
23. When reviewing an improvement project, what does a RACI chart clarify?
- A. Who is responsible, accountable, consulted, and informed.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
24. When reviewing an improvement project, what is the purpose of a tollgate review?
- A. To improve performance by reducing variation and defects.
 - B. To assess readiness before moving to the next phase.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
25. When reviewing an improvement project, what is benchmarking?
- A. To improve performance by reducing variation and defects.

- B. Value-added and non-value-added flow through a process.
 - C. Comparing performance or practices with relevant references.
 - D. The available production time divided by customer demand.
26. When reviewing an improvement project, what does a Pareto chart help a team prioritize?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. The few categories contributing most to the problem.
27. When reviewing an improvement project, which team stage commonly features conflict over roles?
- A. To improve performance by reducing variation and defects.
 - B. Storming, when members test boundaries and priorities.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
28. When reviewing an improvement project, what is nominal group technique useful for?
- A. Generating and ranking ideas with balanced participation.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
29. When reviewing an improvement project, what does multivoting accomplish?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. It narrows a list of options using structured team votes.
 - D. The available production time divided by customer demand.
30. When reviewing an improvement project, what is a stakeholder analysis used for?
- A. Assessing interests, influence, and engagement needs.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
31. When reviewing an improvement project, what should project closure include?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.

D. Documented results, lessons learned, and a handoff plan.

32. When reviewing an improvement project, what type of data is recorded as pass or fail?

A. To improve performance by reducing variation and defects.

B. Attribute data classified into discrete categories.

C. Value-added and non-value-added flow through a process.

D. The available production time divided by customer demand.

33. When reviewing an improvement project, which measurement scale has a meaningful zero?

A. To improve performance by reducing variation and defects.

B. A ratio scale, such as time or weight.

C. Value-added and non-value-added flow through a process.

D. The available production time divided by customer demand.

34. When reviewing an improvement project, why use stratified sampling?

A. To improve performance by reducing variation and defects.

B. Value-added and non-value-added flow through a process.

C. To ensure important subgroups are represented in the sample.

D. The available production time divided by customer demand.

35. When reviewing an improvement project, what is a check sheet?

A. To improve performance by reducing variation and defects.

B. Value-added and non-value-added flow through a process.

C. The available production time divided by customer demand.

D. A structured form for consistent data collection.

36. When reviewing an improvement project, which statistic is most resistant to extreme values?

A. The median, which is the middle ordered observation.

B. To improve performance by reducing variation and defects.

C. Value-added and non-value-added flow through a process.

D. The available production time divided by customer demand.

37. When reviewing an improvement project, what does standard deviation describe?

A. To improve performance by reducing variation and defects.

B. Value-added and non-value-added flow through a process.

C. The available production time divided by customer demand.

D. The typical spread of values around the mean.

38. When reviewing an improvement project, what does a histogram show?
- A. To improve performance by reducing variation and defects.
 - B. The distribution of numerical data across intervals.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
39. When reviewing an improvement project, what does a box plot display?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. Center, spread, and potential outliers in a distribution.
 - D. The available production time divided by customer demand.
40. When reviewing an improvement project, why perform a gauge R and R study?
- A. To quantify repeatability and reproducibility of measurement.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
41. When reviewing an improvement project, what is measurement bias?
- A. To improve performance by reducing variation and defects.
 - B. The consistent difference between observed and reference values.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
42. When reviewing an improvement project, what is measurement linearity?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. How measurement bias changes across the operating range.
 - D. The available production time divided by customer demand.
43. When reviewing an improvement project, what is a process specification limit?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. A customer or engineering requirement for acceptable output.
44. When reviewing an improvement project, what are natural process limits based on?
- A. The process variation estimated from observed data.

- B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
45. When reviewing an improvement project, what does Cp compare?
- A. Specification width with potential process variation.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
46. When reviewing an improvement project, what does Cpk additionally reflect?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. How centered the process is within specification limits.
 - D. The available production time divided by customer demand.
47. When reviewing an improvement project, when should capability indices be interpreted cautiously?
- A. To improve performance by reducing variation and defects.
 - B. When the process is unstable or markedly nonnormal.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
48. When reviewing an improvement project, what does the central limit theorem support?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. Approximate normality of sample means as samples grow.
49. When reviewing an improvement project, which distribution models rare counts over fixed opportunities?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. The Poisson distribution for event counts.
50. When reviewing an improvement project, what does a normal probability plot assess?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. Whether data plausibly follow a normal distribution.

D. The available production time divided by customer demand.

51. When reviewing an improvement project, what does DPMO normalize defects by?

- A. To improve performance by reducing variation and defects.
- B. The number of units and defect opportunities.
- C. Value-added and non-value-added flow through a process.
- D. The available production time divided by customer demand.

52. When reviewing an improvement project, what does correlation establish?

- A. The strength and direction of a linear association.
- B. To improve performance by reducing variation and defects.
- C. Value-added and non-value-added flow through a process.
- D. The available production time divided by customer demand.

53. When reviewing an improvement project, why does correlation not prove causation?

- A. To improve performance by reducing variation and defects.
- B. A relationship may be caused by confounding or coincidence.
- C. Value-added and non-value-added flow through a process.
- D. The available production time divided by customer demand.

54. When reviewing an improvement project, what does a regression equation provide?

- A. To improve performance by reducing variation and defects.
- B. Value-added and non-value-added flow through a process.
- C. The available production time divided by customer demand.
- D. A model for estimating a response from predictor values.

55. When reviewing an improvement project, what does a p-value represent?

- A. To improve performance by reducing variation and defects.
- B. Value-added and non-value-added flow through a process.
- C. Evidence against the null hypothesis under its assumptions.
- D. The available production time divided by customer demand.

56. When reviewing an improvement project, what is a Type I error?

- A. Rejecting a true null hypothesis.
- B. To improve performance by reducing variation and defects.
- C. Value-added and non-value-added flow through a process.
- D. The available production time divided by customer demand.

57. When reviewing an improvement project, what is a Type II error?
- A. Failing to reject a false null hypothesis.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
58. When reviewing an improvement project, what does statistical power describe?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The probability of detecting a real specified effect.
 - D. The available production time divided by customer demand.
59. When reviewing an improvement project, when is a paired t-test appropriate?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. When comparing two measurements from the same matched units.
60. When reviewing an improvement project, what does ANOVA test?
- A. To improve performance by reducing variation and defects.
 - B. Whether means differ across three or more groups.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
61. When reviewing an improvement project, what is a chi-square test often used for?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. Testing association or fit with categorical data.
 - D. The available production time divided by customer demand.
62. When reviewing an improvement project, what is the first purpose of a cause-and-effect diagram?
- A. To improve performance by reducing variation and defects.
 - B. To organize possible causes for systematic investigation.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
63. When reviewing an improvement project, what does the 5 Whys technique seek?
- A. To improve performance by reducing variation and defects.

- B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. A causal chain that reaches a controllable root cause.
64. When reviewing an improvement project, what does a fault tree begin with?
- A. An undesired top event and its contributing logic.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
65. When reviewing an improvement project, what does gap analysis compare?
- A. To improve performance by reducing variation and defects.
 - B. Current performance with the desired future state.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
66. When reviewing an improvement project, what variation does a multi-vari study help separate?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. Positional, cyclical, and temporal sources of variation.
67. When reviewing an improvement project, what is practical significance?
- A. Whether an effect is large enough to matter operationally.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
68. When reviewing an improvement project, what is a confounding variable?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. A factor associated with both variables being studied.
 - D. The available production time divided by customer demand.
69. When reviewing an improvement project, what should follow a suspected root cause?
- A. To improve performance by reducing variation and defects.
 - B. Data-based validation before selecting a corrective action.
 - C. Value-added and non-value-added flow through a process.

D. The available production time divided by customer demand.

70. When reviewing an improvement project, in a designed experiment, what is a factor?

- A. An input variable deliberately changed by the experimenter.
- B. To improve performance by reducing variation and defects.
- C. Value-added and non-value-added flow through a process.
- D. The available production time divided by customer demand.

71. When reviewing an improvement project, what is a response in design of experiments?

- A. To improve performance by reducing variation and defects.
- B. Value-added and non-value-added flow through a process.
- C. The measured outcome affected by factors and conditions.
- D. The available production time divided by customer demand.

72. When reviewing an improvement project, why is randomization used in an experiment?

- A. To improve performance by reducing variation and defects.
- B. Value-added and non-value-added flow through a process.
- C. The available production time divided by customer demand.
- D. To reduce bias from uncontrolled nuisance influences.

73. When reviewing an improvement project, what does replication provide?

- A. To improve performance by reducing variation and defects.
- B. Value-added and non-value-added flow through a process.
- C. An estimate of experimental error and stronger evidence.
- D. The available production time divided by customer demand.

74. When reviewing an improvement project, what does an interaction mean in DOE?

- A. To improve performance by reducing variation and defects.
- B. Value-added and non-value-added flow through a process.
- C. The available production time divided by customer demand.
- D. The effect of one factor depends on another factor level.

75. When reviewing an improvement project, what is a pilot test?

- A. A limited trial used to evaluate an improvement before rollout.
- B. To improve performance by reducing variation and defects.
- C. Value-added and non-value-added flow through a process.
- D. The available production time divided by customer demand.

76. When reviewing an improvement project, what is poka-yoke intended to do?
- A. To improve performance by reducing variation and defects.
 - B. Prevent an error or make it immediately detectable.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
77. When reviewing an improvement project, what does 5S create?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. An organized, visible, and standardized workplace.
 - D. The available production time divided by customer demand.
78. When reviewing an improvement project, what is standard work?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. The documented best current method for performing work.
79. When reviewing an improvement project, what does SMED target?
- A. Reducing setup or changeover time.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
80. When reviewing an improvement project, what is a kaizen event?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. A focused, rapid improvement effort involving the workplace team.
81. When reviewing an improvement project, what should an implementation plan specify?
- A. To improve performance by reducing variation and defects.
 - B. Tasks, owners, timing, resources, and risk responses.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
82. When reviewing an improvement project, what does a proof of concept demonstrate?
- A. Whether a proposed solution is feasible under defined conditions.

- B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
- 83.** When reviewing an improvement project, what does a main-effects plot show?
- A. To improve performance by reducing variation and defects.
 - B. Average response changes across factor levels.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
- 84.** When reviewing an improvement project, what is a treatment in DOE?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. A specific combination of factor levels applied to units.
 - D. The available production time divided by customer demand.
- 85.** When reviewing an improvement project, why use a control group in a pilot?
- A. To improve performance by reducing variation and defects.
 - B. To distinguish improvement effects from background changes.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
- 86.** When reviewing an improvement project, what is common-cause variation?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. Inherent variation from the stable process system.
- 87.** When reviewing an improvement project, what is special-cause variation?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. Variation from an identifiable, nonroutine source.
 - D. The available production time divided by customer demand.
- 88.** When reviewing an improvement project, what is rational subgrouping designed to reveal?
- A. Changes between subgroups while limiting within-subgroup variation.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.

- D. The available production time divided by customer demand.
- 89.** When reviewing an improvement project, which chart fits individual continuous observations?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. An individuals and moving range chart.
 - D. The available production time divided by customer demand.
- 90.** When reviewing an improvement project, which chart monitors fraction defective?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. A p chart for proportion nonconforming.
- 91.** When reviewing an improvement project, which chart monitors count of defects with constant opportunity?
- A. A c chart for count data with constant area or units.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
- 92.** When reviewing an improvement project, which chart fits defects per varying unit size?
- A. To improve performance by reducing variation and defects.
 - B. A u chart that adjusts for changing opportunity.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
- 93.** When reviewing an improvement project, what is the purpose of a control plan?
- A. To specify how critical outputs will be monitored and reacted to.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
- 94.** When reviewing an improvement project, what is document control?
- A. To improve performance by reducing variation and defects.
 - B. Managing approved versions, access, changes, and retention.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.

95. When reviewing an improvement project, what should a training plan include?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. Who needs training, required skills, method, timing, and verification.
 - D. The available production time divided by customer demand.
96. When reviewing an improvement project, what is a first-party audit?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. An internal audit performed by the organization itself.
97. When reviewing an improvement project, what is the Check step in PDCA?
- A. To improve performance by reducing variation and defects.
 - B. Evaluate results against the planned objectives and measures.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.
98. When reviewing an improvement project, what does total productive maintenance emphasize?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. Proactive equipment care to maximize reliable performance.
 - D. The available production time divided by customer demand.
99. When reviewing an improvement project, what is an Andon signal?
- A. To improve performance by reducing variation and defects.
 - B. Value-added and non-value-added flow through a process.
 - C. The available production time divided by customer demand.
 - D. A visual signal that calls attention to an abnormal condition.
100. When reviewing an improvement project, what is jidoka?
- A. Building in detection and response so defects do not flow onward.
 - B. To improve performance by reducing variation and defects.
 - C. Value-added and non-value-added flow through a process.
 - D. The available production time divided by customer demand.

EXAM 13: ANSWER KEY AND EXPLANATIONS

- 1. C** - The correct choice is the one stating that to improve performance by reducing variation and defects.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 2. A** - The correct choice is the one stating that value-added and non-value-added flow through a process.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 3. B** - The correct choice is the one stating that the available production time divided by customer demand.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 4. D** - The correct choice is the one stating that managing the system constraint that limits overall throughput.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 5. A** - The correct choice is the one stating that observe the work where the process is actually performed.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 6. C** - The correct choice is the one stating that authorize work in response to downstream customer demand.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 7. B** - The correct choice is the one stating that verify that the design meets stated requirements.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 8. D** - The correct choice is the one stating that potential failure modes, effects, and prioritized risks.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 9. A** - The correct choice is the one stating that by multiplying severity, occurrence, and detection ratings.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 10. B** - The correct choice is the one stating that inventory while supplying what is needed when needed.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 11. D** - The correct choice is the one stating that customer satisfaction measured against defined expectations.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools,

phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

12. C - The correct choice is the one stating that to summarize suppliers, inputs, process, outputs, and customers.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

13. C - The correct choice is the one stating that it is specific, measurable, achievable, relevant, and time-bound.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

14. B - The correct choice is the one stating that the current condition, baseline, and measurable business impact.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

15. D - The correct choice is the one stating that the process owner responsible for the end-to-end process.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

16. A - The correct choice is the one stating that translate broad customer needs into measurable requirements.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

17. C - The correct choice is the one stating that conducting structured customer interviews or observations.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

18. A - The correct choice is the one stating that a basic feature whose absence causes dissatisfaction.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

19. D - The correct choice is the one stating that to authorize the project and clarify purpose, scope, and roles.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing

20. B - The correct choice is the one stating that a hierarchical decomposition of the project work.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

21. C - The correct choice is the one stating that the longest sequence of dependent activities controlling duration.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

22. D - The correct choice is the one stating that to detect unintended harm caused by an improvement.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

23. A - The correct choice is the one stating that who is responsible, accountable, consulted, and informed.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

24. B - The correct choice is the one stating that to assess readiness before moving to the next phase.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

25. C - The correct choice is the one stating that comparing performance or practices with relevant references.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

26. D - The correct choice is the one stating that the few categories contributing most to the problem.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

27. B - The correct choice is the one stating that storming, when members test boundaries and priorities.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

28. A - The correct choice is the one stating that generating and ranking ideas with balanced participation.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

29. C - The correct choice is the one stating that it narrows a list of options using structured team votes.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing

30. A - The correct choice is the one stating that assessing interests, influence, and engagement needs.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

31. D - The correct choice is the one stating that documented results, lessons learned, and a handoff plan.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

32. B - The correct choice is the one stating that attribute data classified into discrete categories.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

- 33. B** - The correct choice is the one stating that a ratio scale, such as time or weight.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 34. C** - The correct choice is the one stating that to ensure important subgroups are represented in the sample.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 35. D** - The correct choice is the one stating that a structured form for consistent data collection.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 36. A** - The correct choice is the one stating that the median, which is the middle ordered observation.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 37. D** - The correct choice is the one stating that the typical spread of values around the mean.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 38. B** - The correct choice is the one stating that the distribution of numerical data across intervals.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 39. C** - The correct choice is the one stating that center, spread, and potential outliers in a distribution.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 40. A** - The correct choice is the one stating that to quantify repeatability and reproducibility of measurement.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 41. B** - The correct choice is the one stating that the consistent difference between observed and reference values.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 42. C** - The correct choice is the one stating that how measurement bias changes across the operating range.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 43. D** - The correct choice is the one stating that a customer or engineering requirement for acceptable output.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

- 44. A** - The correct choice is the one stating that the process variation estimated from observed data.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 45. A** - The correct choice is the one stating that specification width with potential process variation.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 46. C** - The correct choice is the one stating that how centered the process is within specification limits.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 47. B** - The correct choice is the one stating that when the process is unstable or markedly nonnormal.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 48. D** - The correct choice is the one stating that approximate normality of sample means as samples grow.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 49. D** - The correct choice is the one stating that the Poisson distribution for event counts.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 50. C** - The correct choice is the one stating that whether data plausibly follow a normal distribution.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 51. B** - The correct choice is the one stating that the number of units and defect opportunities.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 52. A** - The correct choice is the one stating that the strength and direction of a linear association.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 53. B** - The correct choice is the one stating that a relationship may be caused by confounding or coincidence.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 54. D** - The correct choice is the one stating that a model for estimating a response from predictor values.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

- 55. C** - The correct choice is the one stating that evidence against the null hypothesis under its assumptions.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 56. A** - The correct choice is the one stating that rejecting a true null hypothesis.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 57. A** - The correct choice is the one stating that failing to reject a false null hypothesis.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 58. C** - The correct choice is the one stating that the probability of detecting a real specified effect.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 59. D** - The correct choice is the one stating that when comparing two measurements from the same matched units.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 60. B** - The correct choice is the one stating that whether means differ across three or more groups.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 61. C** - The correct choice is the one stating that testing association or fit with categorical data.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 62. B** - The correct choice is the one stating that to organize possible causes for systematic investigation.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 63. D** - The correct choice is the one stating that a causal chain that reaches a controllable root cause.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 64. A** - The correct choice is the one stating that an undesired top event and its contributing logic.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 65. B** - The correct choice is the one stating that current performance with the desired future state.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

66. D - The correct choice is the one stating that positional, cyclical, and temporal sources of variation.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

67. A - The correct choice is the one stating that whether an effect is large enough to matter operationally.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

68. C - The correct choice is the one stating that a factor associated with both variables being studied.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

69. B - The correct choice is the one stating that data-based validation before selecting a corrective action.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

70. A - The correct choice is the one stating that an input variable deliberately changed by the experimenter.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

71. C - The correct choice is the one stating that the measured outcome affected by factors and conditions.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

72. D - The correct choice is the one stating that to reduce bias from uncontrolled nuisance influences.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

73. C - The correct choice is the one stating that an estimate of experimental error and stronger evidence.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

74. D - The correct choice is the one stating that the effect of one factor depends on another factor level.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing

75. A - The correct choice is the one stating that a limited trial used to evaluate an improvement before rollout.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing

76. B - The correct choice is the one stating that prevent an error or make it immediately detectable.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

- 77. C** - The correct choice is the one stating that an organized, visible, and standardized workplace.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 78. D** - The correct choice is the one stating that the documented best current method for performing work.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 79. A** - The correct choice is the one stating that reducing setup or changeover time.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 80. D** - The correct choice is the one stating that a focused, rapid improvement effort involving the workplace team.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 81. B** - The correct choice is the one stating that tasks, owners, timing, resources, and risk responses.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 82. A** - The correct choice is the one stating that whether a proposed solution is feasible under defined conditions.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 83. B** - The correct choice is the one stating that average response changes across factor levels.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 84. C** - The correct choice is the one stating that a specific combination of factor levels applied to units.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 85. B** - The correct choice is the one stating that to distinguish improvement effects from background changes.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 86. D** - The correct choice is the one stating that inherent variation from the stable process system.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 87. C** - The correct choice is the one stating that variation from an identifiable, nonroutine source.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

- 88. A** - The correct choice is the one stating that changes between subgroups while limiting within-subgroup variation.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 89. C** - The correct choice is the one stating that an individuals and moving range chart.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 90. D** - The correct choice is the one stating that a p chart for proportion nonconforming.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 91. A** - The correct choice is the one stating that a c chart for count data with constant area or units.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish
- 92. B** - The correct choice is the one stating that a u chart that adjusts for changing opportunity.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 93. A** - The correct choice is the one stating that to specify how critical outputs will be monitored and reacted to.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish
- 94. B** - The correct choice is the one stating that managing approved versions, access, changes, and retention.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 95. C** - The correct choice is the one stating that who needs training, required skills, method, timing, and verification.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 96. D** - The correct choice is the one stating that an internal audit performed by the organization itself.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 97. B** - The correct choice is the one stating that evaluate results against the planned objectives and measures.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.
- 98. C** - The correct choice is the one stating that proactive equipment care to maximize reliable performance.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing control.

99. D - The correct choice is the one stating that a visual signal that calls attention to an abnormal condition.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish ongoing

100. A - The correct choice is the one stating that building in detection and response so defects do not flow onward.. This directly answers the question and reflects standard Six Sigma practice. The other options refer to different tools, phases, measures, or purposes. Choosing precisely matters because teams need a shared definition before they collect data, test causes, improve work, or establish