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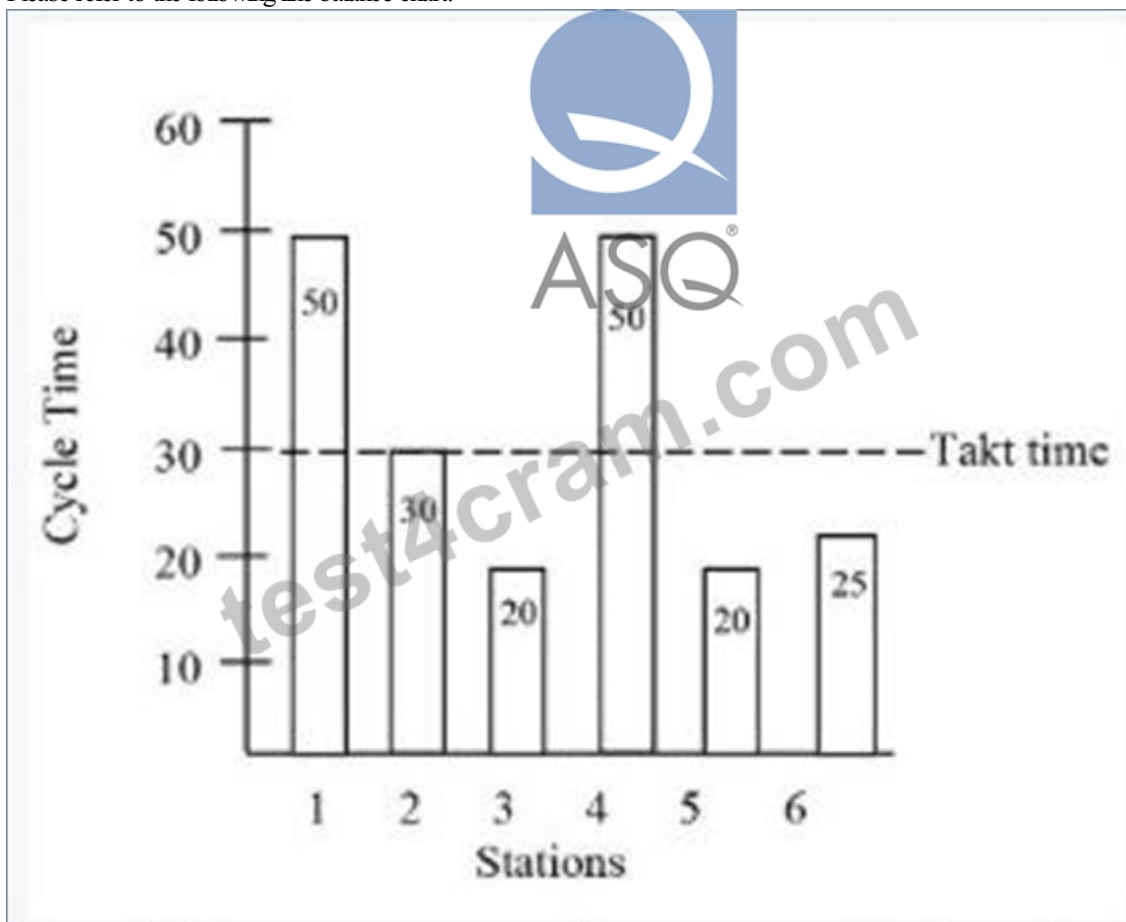
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### ASQ Six Sigma Black Belt Certification - CSSBB Sample Questions (Q23-Q28):

#### NEW QUESTION # 23

Please refer to the following line balance chart.



The work content of Station 3 is what percentage of takt time?

- A. 67%
- B. 50%
- C. 100%
- D. 33%

**Answer: A**

Explanation:

In line balancing, takt time represents the pace required to meet customer demand. To find the work content of a station as a percentage of takt time, divide the station's cycle time by the takt time and multiply by 100.

From the chart, takt time is 30 units and Station 3 has a cycle time of 20 units. Therefore, the percentage is  $20 \div 30 \times 100 = 66.67\%$ , which rounds to 67%.

This is an Improve Phase concept because line balancing is used to redesign work allocation so that stations are better aligned with demand and flow. A station operating at 67% of takt time has unused capacity relative to customer demand, meaning it is not a bottleneck. In contrast, stations above takt time would constrain throughput and require balancing action. Black Belts use this kind of analysis to identify imbalance, redistribute work, reduce waiting, and improve flow efficiency. The chart shows that Station 3 is below takt and therefore has capacity available. Therefore, the correct answer is C, 67%, because Station 3's work content is two-thirds of the takt requirement.

#### NEW QUESTION # 24

Which of the following is an example of an effective goal statement in a project charter?

- A. Reduce cycle time for parts to 3 days in two months
- B. Reduce defects to 10% per lot
- C. Reduce cycle time for parts from 10 days to 1 day by fiscal year end
- D. Increase productivity levels from 5 to 7 units per hour on all shifts

**Answer: C**

Explanation:

The correct answer is C. Reduce cycle time for parts from 10 days to 1 day by fiscal year end . The CSSBB source explains that effective project goals should follow SMART principles: Specific, Measurable, Assignable, Realistic, and Time-related . It also notes that a goal statement should be created and agreed to by the team and champion, with a clear sense of baseline, target, and time frame.

Option C is the strongest example because it includes a baseline (10 days), a target (1 day), the metric (cycle time for parts), and a deadline (by fiscal year end). That makes it both measurable and time-bound. Option A has a metric and target, but it lacks a time frame. Option B gives a target but lacks baseline and timing. Option D has a target and timing, but it does not provide the current baseline from which improvement will be measured. Because a good charter goal must clearly define what will improve, by how much, and by when, option C is the most effective goal statement under CSSBB guidance.

#### NEW QUESTION # 25

Gauge traceability requires an unbroken chain of calibrations from each gauge to

- A. a single set of standards used throughout the entire organization
- B. a certified standard that has a valid relationship to national or international standards
- C. an internal company standard that is correlated with the standard recommended by the gauge manufacturer
- D. an internal company standard that is correlated with appropriate ISO standards

**Answer: B**

Explanation:

The correct answer is B. a certified standard that has a valid relationship to national or international standards . In the CSSBB metrology and calibration material, calibration standards are described in levels, culminating in national and international standards , which are identified as the final authority of measurement to which all standards are traceable . The text also explains that working-level gauges are connected through an unbroken hierarchy of calibration standards, functional standards, and reference standards until they ultimately trace back to recognized national and international authorities.

This means traceability is not merely an internal company relationship or a manufacturer recommendation. It must connect to an accepted certified standard whose validity can be linked to recognized national or international standards, such as NIST-related references. Option A is too narrow because an organization- wide standard alone is not enough unless it is itself traceable upward. Options C and D are also insufficient because internal correlation does not establish full metrological traceability. In Six Sigma measurement systems, confidence in data depends on this documented calibration chain. Therefore, the correct and verified answer is B .

#### NEW QUESTION # 26

An x-bar and R chart has four part measurements per sample The control limits on the averages chart are 2.996 and 3.256. Assume the process data form a normal distribution. What is the probability that the next plotted point falls outside the control limits?

- A. 0.0054
- B. none of the above

