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**QUESTION: 187**

Long-term Data represents all the variation that one can expect within the subject process.

- A. True
- B. False

**Answer: A**

**QUESTION: 188**

The Z score is a measure of the distance in Standard Deviations of a sample data point from the Median of the sample population.

- A. True
- B. False

**Answer: B**

**QUESTION: 189**

A Belt gathered the following defect data for a shoe production line and wanted to assemble it into a Pareto Chart. The correct order from left to right in the chart would be:  
Data: Cutting38 Forming17 Stitching56 Sealing42

- A. Forming, Sealing, Cutting, Stitching
- B. Sealing, Stitching, Forming, Cutting
- C. Stitching, Sealing, Cutting, Forming
- D. Forming, Cutting, Sealing, Stitching

**Answer: C**

**QUESTION: 190**

Measurement error is defined as the effect of all sources of measurement variability that caused an observed or measured value to deviate from the .

- A. Standard Deviation
- B. Mean
- C. Median

D. True value

**Answer:** D

**QUESTION:** 191

Measurement System Analysis is a procedure used to quantify all in the method or system used for taking measurements.

- A. Totals
- B. People involved
- C. Variation
- D. Summations

**Answer:** C

**QUESTION:** 192

The Accuracy of a Measurement System addresses .

- A. Stability, Bias & Linearity
- B. Repeatability & Reproducibility
- C. Stability & Sensitivity
- D. Precision & Sensitivity

**Answer:** A

**QUESTION:** 193

As a type of measurement error, Linearity describes a change in accuracy through the expected operating range of the measurement instrument.

- A. True
- B. False

**Answer:** A

**QUESTION:** 194

The deviation of the measured value from the actual value regardless of the operator is

known as .

- A. Linearity
- B. Bias
- C. Repeatability
- D. Movement

**Answer:** B

**QUESTION:** 195

The ability to repeat the same measurement obtained with one measurement instrument used several times by one appraiser while measuring the identical characteristic on the same part is known as .

- A. Repeatability
- B. Bias
- C. Linearity
- D. Reproducibility

**Answer:** A

**QUESTION:** 196

Process Capability is a function of which of these?

- A. Customer requirements
- B. Process performance
- C. Output over time
- D. All of these answers are correct

**Answer:** D

**QUESTION:** 197

The reported Cpk for a process with an average of 94 units, a spread of 22 units and upper and lower specification limits of 125 and 80 units would be?

- A. 0.64
- B. 1.27

- C. 1.84
- D. 2.12

**Answer:** B

**QUESTION:** 198

A Stable process is a process whose output is consistent over time. A primary tool used to analyze Stability would be a \_\_\_\_\_.

- A. Data Forward Plot
- B. Bag Plot
- C. Min/Max Plot
- D. Time Series Plot

**Answer:** D

**QUESTION:** 199

Conducting a viable Capability Analysis using Attribute Data one must obtain a fairly large sample set to be statistically sound.

- A. True
- B. False

**Answer:** A

**QUESTION:** 200

This output is what type of advanced Capability Analysis?

- A. Continuous
- B. Binomial
- C. Poisson
- D. Discreet
- E. DPU

**Answer:** B



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