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Reference: CSSGB Primer, Section II - 4 and 27/31. 2.2. Using six sigma methodology, a company at 4.5 sigma would have a failure rate of: a. 3.4 ppm b. 233 ppm c. 1350 ppm d. 6210

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ppm Solution: The six sigma approach allows for a ± 1.5 sigma shift. Answer b represents the 5 sigma level and answer d is the 4 sigma level. Answer c is correct.

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