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At 4.5 Sigma Would Have A Failure Rate Of: A. 3.4 Ppm B. 233 Ppm C. 1350 Ppm D. 6210 Ppm Solution: The Six Sigma Approach Allows For A  $\pm 1.5$  Sigma Shift. Answer B Represents The 5 Sigma Level And Answer D Is The 4 Sigma Level. Answer C Is Correct. Jan 11th, 2024.  
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