HARLEY-DAVIDSON MOTOR COMPANY
("H-D")

SUPPLIER QUALITY REQUIREMENTS MANUAL

4836-9367-4552.4

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HARLEY-DAVIDSON QUALITY POLICY

"Customers for life…
Harley-Davidson values the deep emotional connection that is created with our customers through our products, services and experiences. We are fueled by the brand loyalty and the trust that our customers place in us to deliver premium quality and the promise of a fulfilling lifetime ownership experience. We exemplify this commitment by embracing a culture of personal responsibility and stewardship for quality in everything we do."

PURPOSE

The intent of this Supplier Quality Requirements Manual (this "manual") is to define H-D's expectations and Supplier responsibilities to support H-D's business strategy. These requirements extend from new part development through part obsolescence – the lifecycle of a part.

SCOPE

Requirements specified in this manual apply to all Suppliers that produce original equipment (OE) and parts that are sold, directly or indirectly, to H-D. It is the responsibility of each Tier 1 Supplier to propagate these requirements to their supply chain, including all Sub-Tier Suppliers, and ensure their compliance with this manual. Nothing in this manual limits any of the rights or remedies of H-D under the Master Supply Agreement or other supply contract between H-D and the Supplier.

MANUAL LOCATION

This manual is distributed via H-D's Supplier web portal, *Harley-Davidson Supplier Network* (H-DSN.com). Supplier-specific information such as this manual, Forms, OE Scorecards, Training, etc. can be found in H-DSN, and this manual and other materials found in H-DSN may be updated and revised from time to time by H-D. Supplier is expected to remain up to date on H-D requirements by frequently visiting H-DSN. Printed copies of this manual are considered uncontrolled documents; the version of this manual found on H-DSN at any point in time is the binding document. Questions regarding this manual should be directed to your Supply Base contact.

QUALITY SYSTEM REQUIREMENTS

As a condition of doing business with H-D, Tier 1 Suppliers must be certified to the current version of ISO9001 and/or current version of IATF16949.

All Suppliers must comply with the Harley-Davidson quality expectations set forth in this section. Suppliers are fully responsible for the quality of their products. In order to ensure Zero Defects, Suppliers must have an effective Quality Management System in place. Suppliers who are not certified are expected to be compliant with the requirements described in ISO 9001 and be working toward certification. In addition, Suppliers shall reference Automotive Industry Action Group (AIAG) documents, including: Production Part Approval Process (PPAP), Failure Mode and Effects Analysis (FMEA), Advanced Product Quality Planning (APQP), Measurement Systems Analysis, and Statistical Process Control.

H-D reserves the right to conduct onsite audits of Supplier from time to time to assure continuing compliance with this manual and all quality and process documentation. H-D also reserves the right to conduct onsite audits of a Supplier's Sub-Tier Suppliers that produce H-D product, and Suppliers shall cause their Sub-Tier Suppliers to allow these audits preferably with a representative from the Supplier in attendance.

Suppliers may be required to submit quality performance data upon request. Suppliers are also responsible for assuring their Sub-Tier Suppliers' PPAPs are approved and are under a controlled system of evaluation and review. These records must be made available for H-D review when requested.

ADVANCED PRODUCT QUALITY PLANNING (APQP)

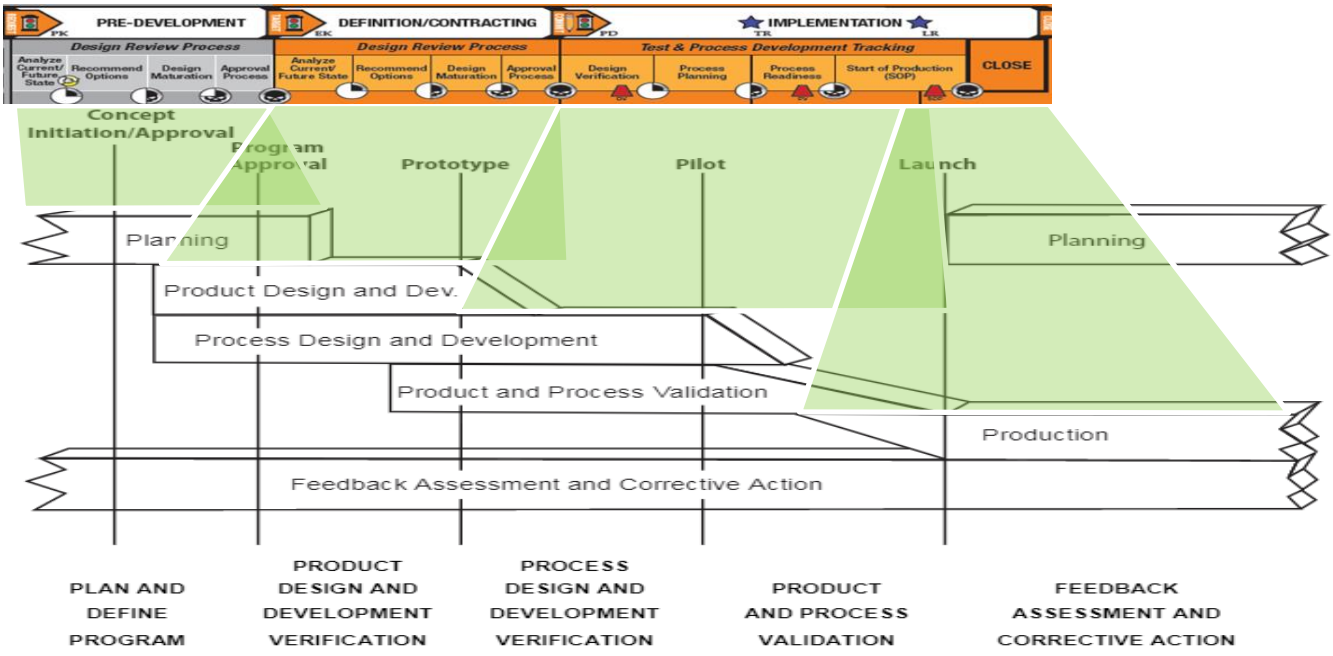
H-D's Product Development Methodology, known as "M9", is a phase gate methodology that ensures we Create, Design and Deliver Great Motorcycles. M9 aligns to the APQP tools as defined by the AIAG. H-D expects that your organization demonstrates competency in Advanced Product Quality Planning as part of its robust quality system. This includes the use of cross-functional teams, upfront planning, and quality tools such as:

- Manufacturing Feasibility
- Identification of Key Product/Process Characteristics
- Process Flows
- Process/Design Failure Modes and Effects Analysis (P/DFMEA)
- Control Plans
- Measurement Systems Analysis (MSA)
- Statistical Process Control (SPC)
- Production Part Approval Process
- After Action

Supplier shall incorporate and maintain the APQP results throughout the complete manufacturing process, which includes:

- Work instructions
- Gages and Checking Aids
- Equipment design and maintenance program
- Testing strategies
- Material handling and storage
- Packaging, labeling, and shipping
- Facility layout and maintenance
- Employee training
- Sub-Tier Supplier control

The evidence of Advance Product Quality Planning shall be documented and provided to H-D upon request. The graphic below demonstrates how M9 meshes with APQP per AIAG. Suppliers are required to review the "*APQP vs M9"* webinar, located on H-DSN.com.



PRODUCTION PART APPROVAL PROCESS (PPAP)

It is a requirement that our Suppliers follow proper Advanced Product Quality Planning methodology as part of a robust quality system. PPAP is an output of that methodology. The overall purpose of PPAP is to ensure the Supplier understands H-D's design record and specification requirements, as well as to determine if the Supplier's manufacturing process can consistently meet those requirements as demonstrated by an actual production run.

Suppliers are required to comply with the current edition of the AIAG *Production Part Approval Process (PPAP) Manual*. For additional requirements and expectations, refer to the PPAP Submission Guide, located in the *Doing Business with Harley-Davidson* manual on H-DSN.

H-D requires an AIAG Level 3 submission for new product. Level 2 may be acceptable, however, for designated off the shelf components with the prior written approval of H-D. Other appropriate submission levels may be acceptable as determined by an H-D representative.

The Supplier must notify H-D in advance in writing of any planned changes, whether part design, process or site. Refer to the AIAG *PPAP Manual, Section 3, Customer Notification and Submission Requirements* for additional submission requirements. The Supplier is required to obtain H-D's written approval prior to proceeding. A Product Deviation Notice (PDN) may be required if change is in place prior to PPAP approval, see PDN section of this Manual for further detail.

The Supplier shall provide a PPAP submission to H-D, and must obtain written approval of that submission from H-D in its discretion, before shipment of production quantities of product. Parts cannot be PPAP-approved without part drawings that are fully approved and authorized by H-D engineering. It is the Suppliers responsibility to ensure that they submit the latest authorized drawing revision, accessed through their H-DSN portal.

Tier 1 Suppliers are required to manage PPAP activities, submissions and approvals with all of their Sub-Tier Suppliers. Sub-Tier Supplier PPAP submissions (including signed and approved Part Submission Warrant) must be available for review upon request by H-D.

The Supplier is required to retain a copy of the approved PPAP documentation and master product samples for each product in a manner that prevents document deterioration for the period of Life of Production + 15 years after the last production run. This documentation shall be made available to H-D upon request.

ANNUAL RE-QUALIFICATION

Annual Re-Qualification may become a requirement for a Supplier based on poor performance and will be determined at H-D's discretion. On an annual basis, a Supplier may be required to perform a dimensional layout of all of its part numbers supplied to H-D (including any Sub-Tier Supplier part numbers managed by the Tier 1 Supplier). This will include verifying capability of Special Characteristics, any performance testing and material qualifications in addition to reviewing and updating PFMEA/Control Plans accordingly. Re-qualification must be completed by July 1st of each year and data must be retained at the Supplier's location and provided to H-D upon request. If any non-conforming dimensions or tests are found, the Supplier must notify H-D per the *Non-Conforming Material (NCM) Management* section of this manual, and such notice must include an action plan and timing detail to resolve the finding.

PRE-LAUNCH MITIGATION STRATEGY

Suppliers that have been identified by the H-D project team as presenting risk to New Model Year launch will be required to implement an Escalated Control Plan (ECP). ECP is a documented launch control plan that is an additional control plan above and beyond the Supplier's production control plan. The ECP should take into consideration all known critical conditions of the part, as well as potential areas of concern identified during the PPAP. The ECP will consist of additional controls and inspection audits, and will factor in the production process (set-up, machinery, fixture, tooling, operation, material/components, preventative maintenance, and climate). The H-D project team and Supplier will mutually agree upon and develop the ECP, including implementation, timing and part quantity. The Supplier will be required to submit all data collected per the ECP to the H-D project team within the timeframe agreed upon. H-D may require pre-launch process audits and/or run-at-rate activities to assure process capability, capacity, and launch readiness.

Any failures found within the ECP implementation must be communicated by Supplier to H-D, and the Supplier must follow the 8D process to make Permanent Corrective Actions (PCA). If non-conforming material is generated during ECP period, the ECP must be restarted after PCA has been implemented and proven effective.

SPECIAL CHARACTERISTICS

Special Characteristics are defined as product and/or process parameters which can significantly affect safety, regulatory compliance, and/or functions of H-D products. These Characteristics are identified by H-D Engineering during the Advanced Product Quality Planning process using DFMEA and PFMEA principles. Special Characteristics are marked with various symbols requiring specific levels of special controls and process capability. At a minimum, Suppliers shall implement process controls for Special Characteristics as designated by H-D. It is the responsibility of the Supplier to ensure and demonstrate the required level of process capability for all Special Characteristics. Process capability shall be measured in accordance with the then-most recent edition of the AIAG *Statistical Process Control (SPC)*.

Suppliers are responsible for proper communication, control and monitoring of Special Characteristics requirements (where applicable) with their Sub-Tier Suppliers. The Supplier shall conduct ongoing SPC monitoring of all identified Special Characteristics, and shall collect and retain the SPC data on an ongoing basis, including their continuous Process Capability (Cpk). The Supplier must make SPC data available to H-D upon request.

H-D recognizes the following categories for Special Characteristics:

- **Key Product Characteristics ("KPC"); Supplier must exhibit >1.67 Cpk**
    - Product attributes (i.e., features, dimensions, specifications) which, if exceeding the tolerance or specification, could affect safe vehicle operation. KPC's are designated on H-D drawings by a closed diamond (♦).
- **Key Control Characteristics ("KCC"); Supplier must exhibit >1.67 Cpk**
    - Process characteristics for which variation must be controlled to some target value during the manufacturing process to ensure that variation of Key Product Characteristics or Significant Characteristics do not exceed their defined tolerance or specification. KCC's are designated on H-D drawings by an open diamond (◊).
- **Regulatory Characteristics ("RC"); Supplier must exhibit >1.67 Cpk**
    - Product process requirements (i.e., features, dimensions, specifications) which, if exceeding the tolerance or specification, could affect compliance with government regulations or statutory requirements. All RC's are designated on H-D drawings by an inverted closed delta (▼).
- **Significant Characteristics ("SC"); Supplier must exhibit >1.33 Cpk**
    - Product and/or process features that do not affect safety or regulatory requirements but could create an unacceptably high warranty condition or significant customer dissatisfaction. The symbol for an SC will be in the form of an ellipse with the letters (**SC**) inside of it.

SUPPLIER PRODUCT OR PROCESS CHANGE NOTIFICATION

Supplier shall establish a Product and/or Process Change Notification System. Any proposed changes to product or process, whether it is a tooling/fixture modification, equipment movement, change in gaging or processing, relocation of production to other facilities or to a different Sub-Tier Supplier, or otherwise, require that a Supplier provide written notice to H-D prior to implementation. Supplier is not permitted to move forward without H-D's written approval. The notice should include, at a minimum: part number; specifics of the change, desired implementation date and build out plan for old inventory (under previous process). H-D will review the nature of the proposed change and provide written guidance. In the event the change is approved by H-D, a new AIAG Level 3 PPAP submission is required unless H-D informs the Supplier otherwise in writing. Changes cannot be made unless and until H-D in its discretion approves the submitted PPAP.

A Supplier may not ship product under a modified process or a changed feature until an H-D-approved PPAP submission or PDN is in place. H-D and the Supplier will mutually determine the clean date for product incorporating an approved modified process or feature. "Clean date" is defined as the shipment date and time of product that is approved for production. This requirement is outlined in the current revision of the AIAG *PPAP Manual, Section 3, Customer Notification and Submission Requirements.*

NON-CONFORMING MATERIAL (NCM) MANAGEMENT

Notification and Containment of Shipment

NCM is defined as parts that are defective in design, material or workmanship, or fail to conform to all applicable H-D design record requirements. An NCM record will also be assigned to parts that are mislabeled on their packaging or on the part itself from the Supplier. When a Supplier becomes aware it has shipped NCM, or suspects it may have shipped NCM, the Supplier must notify H-D immediately in writing. The notification shall include, at a minimum, the following:

- Part number
- Quantity shipped
- Nature of non-conformance
- Lot number
- Production date
- Shipment date
- ASN number of suspected non-conforming material
- Containment plan at Supplier location
- Recommended containment plan required at H-D
- Clean date of conforming product

The Supplier shall also communicate the same information to any H-D directed tiered relationships to which the non-conforming material may have been shipped and used. Supplier is expected to immediately begin the Corrective Action process as described below.

Parts Per Million (PPM) is the number of non-conforming units divided by the total number of units shipped multiplied by one million. NCM parts will count against a Supplier's PPM performance metric.

An NCM transaction is defined as the activity of collecting, validating, and systematically dispositioning NCM in H-D's inventory system. A single NCM transaction can be a single part or multiple quantities of the same part number. Each NCM transaction will be recorded with a corresponding unique NCM number.

Corrective Action

Upon request from H-D, the Supplier shall investigate and report corrective actions for an NCM incident involving product shipped to H-D via the 8 Disciplines (8D) process. This process defines the key steps involved in problem resolution, including containment of the problem, root cause analysis, problem correction, and problem prevention. Suppliers are required to complete and submit the first 3 steps (step 3 is initial containment) of the 8D process within 48 hours of being notified by H-D. 8D documentation must be submitted by Supplier to the H-D requestor.

Containment

Upon notification of a containment event, the Supplier has 48 hours to provide conforming product. "Certified Material" is conforming product that has been reviewed, measured, and inspected by the Supplier, meets design specifications and is not NCM. The expected containment steps are described below:

1. Within 24 hours, the Supplier is required to communicate a containment plan to H-D.
2. Material already received by or shipped to H-D is to be sorted, at a location specified by the H-D contact, by Supplier designated 3rd party or Supplier resource at Supplier's expense.
3. Inventory at H-D will be sorted, but only in amounts necessary to identify enough conforming material to meet H-D's production needs until Certified Material is received from the Supplier;

Certified Material must be provided by Supplier as described in Controlled Shipment Level 1 below

4. Any additional parts in inventory at H-D will be shipped back to Supplier or a Supplier designated location at Supplier's expense.
5. Root Cause Analysis information shall be provided to H-D by Supplier within 5 days of the initial sort via the 4th D of the 8D process.

Controlled Shipment Level 1 (CS1): Certified Material per Supplier Sign Off

- Supplier shall confirm that material is Certified Material by having a leader sign a certification before material can be shipped to H-D.
    - If NCM was Functional/Cosmetic: the signer must be Supplier's Quality Manager
    - If NCM involved Mislabeling: the signer must be Supplier's Shipping Manager
- Supplier must provide Certified Material for 30 days beyond the implementation and sign- off of the corrective action without recurrence of any NCM.
- After the 30 -day period, if there has been no recurrence of NCM, the Supplier will no longer need to certify conformance before shipment.
- If any instance of NCM occurs within the 30- day period, the Supplier will be required to certify future shipments via **independent 3rd party sort** certification (level CS2) as provided in the following section.

Controlled Shipment Level 2 (CS2): Certified Material per Independent 3rd Party Sort

- Three (3) sorts within one (1) month out of any supplier plant requires CS2 containment.
- Formal H-D Corrective Action Request (CAR) will be issued
- Material shall be inspected and certified in writing as being fully conforming and free from defects by independent 3rd party (selected by Supplier) at Supplier's expense before material can be shipped to H-D
- 3rd party certification shall continue for a 30 day period
- After the 30 day period, if there has been no recurrence of NCM, 3rd party certification will not be required prior to shipment
- If any instance of NCM occurs within the 30 day period, the Supplier will be required to certify future shipments via **H-D directed 3rd party sort** certification
- In addition, if any instance of NCM occurs within the 30 day period, Supplier's management will be required to formally present to H-D plant leadership ongoing action plans to resolve the issue and identify ongoing containment strategy

The NCM management provisions set forth above are in addition to, and do not limit, the rights and remedies of H-D under the Master Supply Agreement or other supply contract between H-D and the Supplier arising from delivery of NCM.

Product/Process Deviation Notice

Any instance of shipment and use of product that is non-conforming requires approval from H-D. The Supplier shall not ship such product unless and until it has sought and received approval from H-D via a Product/Process Deviation Notice (PDN). In these cases, the Supplier will need to notify H-D and provide supporting data as requested by H-D to enable a decision on whether it should issue a PDN. This data may include, but not be limited to, dimensional/test information, Control Plan, PFMEA, number of parts affected, clean date of complying product, 8D report, and action plan. The data will be analyzed and reviewed by H-D for its impact to motorcycle form, fit, and function prior to approval/rejection. In the event that a PDN is rejected, the affected parts will be treated as an NCM per the provisions above.

PDN's may be issued by H-D in its discretion for the follow instances:

- Cosmetic Non-Conforming
    - Temporary substitution of a purchased or manufactured component that falls outside the cosmetic standard, but which has been evaluated by H-D as having little to no negative effect on customer satisfaction
- NCM
    - A temporary manufacturing condition that prevents producing components to the current design specification, may include sort/rework action to bring back into specification
- PPAP
    - *PDN issued to use a purchased part for which a new PPAP is not yet complete. The PDN covers a change within the current revision PPAP that requires a new PPAP.*
    - When PPAPs are not approved prior to current production launch or a production level build event (Product Validation, Pre-Production, Model Year launch), H-D will "authorize for shipment and use" of product via a Product Deviation Notice (PDN).
        - Duration of PDN will include allowance to ship and through use of product.
        - The PDN will be approved prior to shipment of product.
        - The Supplier will need to provide adequate data to show that the parts meet all requirements.
        - At minimum, supplier shall provide:
            - A copy of the H-D design record to which the parts were produced.
            - Process Control Plan that will be in use, until PPAP is approved.
            - Dimensional results of sample parts, or full layout of 2 pieces, as directed by H-D.
            - Test results as required by the design record.
- Running Change Pilot
    - Pilot builds of alternate designs/PPAP part verification prior to final change approval.

PACKAGING AND LABELING

Labeling

Part quality, product integrity, production inventory and scheduling are highly dependent on accurate labeling of all products shipped to our plants. It is critical that Suppliers comply with all of the specifications in the *Harley-Davidson Bar Code Requirements* document located on H-DSN. Mislabeled product will be considered as NCM and adversely affect a Supplier's PPM performance. Mislabeling events will require an 8D report from the Supplier. For further detail refer to H-DSN under *Supplier Development Information > Webinar.*

Returnable Packaging

Returnable packaging is designed and owned by H-D. Suppliers are expected to take reasonable care in the use of all packaging provided. This includes ensuring containers are clean enough to ensure that the products being packaged maintain the quality necessary for their specific application. This also includes identifying packaging that is damaged or not suitable for use, segregating that packaging, and contacting your H-D Supply Chain representative.

When H-D implements returnable packaging, Suppliers are provided documentation on the basic design and package quantity, which should be used by the Suppliers to develop back-up packaging for use if returnable packaging is not available. Any time the use of expendable back-up packaging is being considered, approval from H-D is required. It is the Supplier's responsibility to have back-up expendable packaging available to ensure all shipments are made on time and to ensure all packaging is in good working order, appropriately clean prior to use to ensure safe transit, and the quality of parts is maintained.

Shortage of returnable packaging is not an acceptable excuse to miss scheduled shipments. Suppliers are expected to submit their expendable packaging design information as part of any new returnable packaging launch process initiated by H-D, on the forms provided by H-D.

Primary Expendable Packaging

When returnable packaging is not provided by H-D, it is the Supplier's responsibility to develop expendable packaging to ship products to H-D. The Supplier is responsible for ensuring the packaging will provide adequate protection of the parts in support of our production requirements. In addition, the Supplier is required to submit design information to H-D on the *Expendable Packaging Sketch Form* that will be provided by H-D packaging engineering.

Please see the Packaging Requirements section on H-DSN for details and forms used for both returnable and expendable packaging processes.

SUB – TIER SUPPLIER MANAGEMENT

Sub-Tier Suppliers have a tremendous impact on the quality of the final component. Whether they provide raw materials, services or sub-components, their influence is so profound that it is critical for each of H-D's Suppliers to have a Sub-Tier Supplier management system in place.

Suppliers to H-D shall have established processes to manage their respective Sub-Tier Suppliers (regardless of how directed). These processes shall include:

- Selection and evaluation of Sub-Tier Suppliers based on their capabilities to meet H-D quality, delivery, cost, and service requirements
- Ensuring adherence to APQP disciplines and PPAP submission requirements by Sub-Tier Suppliers
- Providing ongoing Sub-Tier Supplier performance and periodic auditing with subsequent corrective actions for identified gaps

As an H-D Tier 1 Supplier, you are responsible for:

- Demonstrating effective management of Sub-Tier Suppliers through documented corrective actions and verification activities and providing H-D with documentation of progress upon request
- Maintaining an established system that tracks and reports the quality, delivery, cost and service performance of your Sub-Tier supply base
- Having a process in place to assure the Sub-Tier supply chain understands all design record dimensions, specifications and requirements
- Assuring that manufacturing processes throughout the Sub-Tier supply chain are capable of meeting all design and capacity requirements
- Managing, reviewing, and approving PPAP submissions from all of your Sub-Tier Suppliers
- Ensuring that all requirements specified by this manual are flowed down to all affected Sub-Tier Suppliers
- Ensuring that all Sub-Tier Suppliers are compliant with all requirements specified by this manual

H-D requires Suppliers to require their Sub-Tier Suppliers to allow H-D to perform onsite audits of those Sub-Tier Suppliers from time to time to ensure that proper controls are in place throughout the entire value stream.

KEY SYSTEMS SUPPLIERS

A Key System Supplier provides H-D with safety and regulatory systems. The Key System Suppliers are required to participate in an on-site Quality Management System (QMS) and process assessment based on performance. Suppliers are required to achieve and maintain an acceptable assessment rating that is determined by the quantity and type of noncompliance found during the assessment. Suppliers will be notified and briefed on their performance as part of the onsite closing meeting immediately following the assessment. Suppliers that do not achieve an acceptable assessment rating within 12 months of initial assessment, or that fail to maintain an acceptable assessment rating, will be subject to potential new business hold, expediting or being required to provide Certified Material at Supplier's expense, and/or supplier exit.

SUPPLIER PERFORMANCE REPORTING

Supplier performance is monitored by H-D based on key product development, quality, and delivery metrics. At a minimum, performance will be monitored for Integrated and Extended suppliers; Build to Order suppliers will be monitored on a case by case basis. Supplier reviews will be conducted and if performance gaps are identified, the supplier will be required to provide an action plan to address the gaps. Performance gaps that persist for multiple months could potentially result in new business hold, being required to provide certified material (at supplier's expense) and/or supplier exit. Questions related to H-D's overall supplier performance process can be directed to your Supply Base Analyst contact; discrepancies or questions related to specific supplier performance data on H-DSN can be directed to your Supply Chain Analyst contact.

CHARGE BACK

Suppliers are responsible for the quality, on-time delivery, and reliability of the products they supply. Supplied parts must be free from defects and meet all applicable specifications and H-D's design and drawing requirements.

Starting January 1st 2017, Suppliers will be debited $20 USD per NCM transaction in both Kansas City and York full vehicle assembly facilities. The Supplier shall also be held financially responsible for the costs, losses and damages incurred by H-D arising from or associated with non-conforming product or late deliveries including, but not limited to, the costs, losses and damages identified below:

- 3rd Party sorting
- Expedited freight
- Rework
- Replacement of defective material
- Unplanned overtime
- Other out of pocket 3rd party expenses paid by H-D (related to NCM processing)

This process will be executed on a per incident basis, with cumulative costs identified to the Supplier and recovered through a debit memo.

If you have questions, please contact your Supply Chain Management and/or Supply Base representative.

REVISION RECORD

Date	Nature of Change
12/2016	Initial Revision
11/2017	Added addendum. - Additions were made for Containment, CS2, and Returnable Packaging. - Clarifications were made on CS1, Returnable Packaging, and Primary Expendable Packaging. - Split out Intro paragraph into Purpose and Scope (no change to content). Removed P&A from Approver List (P&A not in scope).
05/2018	Incorporated addendum items into the manual and removed addendum attachment. Annual Re-qualification, removed the following: If you are a Supplier of any of the following Key Systems--Brake systems, Windshields, Grab Straps, and Locksets--a full AIAG level 3 PPAP submission and approval per the *Production Part Approval Process (PPAP)* section of this manual will be required on an annual basis per requirements above. PDNs related to PPAP, added the following and removed redundant verbiage: • When PPAPs are not approved prior to current production launch or a production level build event (Product Validation, Pre-Production, Model Year launch), H-D will "authorize for shipment and use" of product via a Product Deviation Notice (PDN). • Duration of PDN will include allowance to ship and through use of product. • The PDN will be approved prior to shipment of product. • The Supplier will need to provide adequate data to show that the parts meet all requirements. • At minimum, supplier shall provide: o A copy of the H-D design record to which the parts were produced. o Process Control Plan that will be in use, until PPAP is approved. o Dimensional results of sample parts, or full layout of 2 pieces, as directed by H-D. o Test results as required by the design record. Returnable Packaging, added the following: • It is the responsibility of the supplier to ensure all packaging is in good working order and appropriately clean prior to use to ensure safe transit and the quality of parts is maintained. Key System Suppliers, removed the following: • Removed the word “annual” for on-site QMS and process assessment and added “based on performance”. • Removed reference to SPE group. Supplier Performance Reporting • Updated verbiage to align with new supplier performance process.