Global Procurement

Supplier Quality Requirements Supplement

Power Systems and Home Energy

Power Systems

Kohler Home Energy

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Table of Contents

Appendices

Go to Table of Contents

Section 1.0 Introduction

At Rehlko we recognize the critical role quality plays in our success. We are committed to meeting our customer's quality needs and expectations of excellence by pursuing continuous quality, delivery and productivity improvements. A large segment of our quality performance is dependent on you as our supplier.

1.1 Purpose: This manual is a supplement to the *Rehlko Global Supplier Quality Manual*. Suppliers are expected to certify/acknowledge compliance with the manual and to the Rehlko Global Requirements (ref. 1.1.1).

1.1.1 Rehlko Global Supplier Manual. Click the link to access Global Supplier Quality Manual, Supplier Code of Conduct, Terms and Conditions Agreement, and other supplier documents. If the link does not work, go to www.rehlko.com, click Company, Suppliers, Conducting Business.

1.1.2 Rehlko Supplier Certification is an electronic automated system that allows suppliers to self-certify by acknowledging compliance with Rehlko requirements. If the link does not work, go to www.rehlko.com click Suppliers, Current Suppliers. Please see the FAQ on this site for further information.

1.1.3 Supplier Quality Requirements Supplement can be found on the Conducting Business page.

1.1.4 Additional Resources: Please refer to the Automotive Industry Action Group (AIAG) manuals for further details. These documents can be ordered from the AIAG on-line at www.aiag.org.

- Failure Mode and Effect Analysis, 4th Edition
- Advanced Product Quality Planning and Control Plan, 2nd Edition
- Production Part Approval Process, 4th Edition
- Quality System Requirements, 3rd Edition
- Statistical Process Control, 2nd Edition
- Measurement Systems Analysis, 4th Edition

1.2 Rehlko reserves the right to update this manual at any time, and the supplier is expected to verify the latest version of this manual at https://www.rehlko.com/conducting-business, or contact Rehlko Engines Supplier Quality for verification.

Section 2.0 Product Sourcing Process

2.1 Rehlko Change Management Lifecycle System

2.1.1. Product lifecycles are managed through lifecycle states.

Table 1: Drawing Lifecycle States

Drawing Lifecycle State	Definition	Authorized for quoting purposes?	Authorized for PPAP submission?	Authorized for production?
In Progress	Design is under development.	No	No	No
Prototype	Functional design is used to purchase or manufacture prototype material. Testing and validation are in progress.	Yes	No	No
Eng. Rel. - Task Review	Testing and validation are in progress.	Yes	No	No
Engineering Released	Design is validated.	Yes	Yes	No
Production Released	Process is validated. *This is the only lifecycle drawing state authorized for use in production.*	Yes	Yes	Yes
Canceled/Obsolete	Never released or void	No	No	No

2.2. Print Process Review

2.2.1. After supplier selection, but prior to the tooling kick off, a Print and Process Review (PPR) may be conducted. This will be a cross-functional review involving Rehlko Engineering, Purchasing, and Supplier Quality, as well as Engineering, Program Management, Quality and Sales representatives from the supplier. The intent of this review is to ensure transparency of the design, tooling, timing, and deliverables of the component. This process will be managed by the Rehlko Supplier Quality Engineer.

2.2.2. A PPR is required in the following scenarios:

- Initial release of a new component
- Significant change to fit, form, or function
- Change in manufacturing source (resourcing or outsourcing)
- Additional PPR requirements may be applied based on part complexity, risk, and program requirements, as determined by Supplier Quality.

Go to Table of Contents

Section 3.0 General Requirements

3.1 As part of the documented quality program, the supplier shall provide a key contact list. Supplier shall promptly notify Rehlko Purchasing and Quality of any changes to the key contact list.

3.2 Prohibited Practices:

3.2.1 Unauthorized Repairs: Supplier may not repair parts damaged or found to be faulty or non-conforming during fabrication without prior approval from Rehlko Supplier Quality. No tooling owned by Rehlko shall be “repaired” or changed in any way without consent and approval of Rehlko Supplier Quality and Purchasing.

3.2.2 Change in Approved Processes, Material or Procedures: Supplier shall not change any process, material, or procedure without prior notification and re-submittal of samples and PPAP (reference Section 4.0 PPAP Requirements).

3.2.3 Unauthorized Submittal of Production Parts: No production parts will be shipped without an approved PPAP for the drawing level being supplied or an approved deviation (reference Section 10 Deviations) prior to shipment. PPAP samples shall be identified as PPAP samples and shipped in a separate carton from current production parts.

3.2.4 Facility Change: Supplier shall not relocate any production, manufacturing, and/or processing facilities during performance of the purchase agreement without approval from Rehlko Purchasing of an opportunity to examine such facilities for compliance as outlined in this manual. Rehlko Supplier Quality and Purchasing shall determine the level of requirements necessary prior to relocating manufacturing and provide approval to the supplier. Changes in supplier status, part approval, and incoming inspection requirements may result.

3.3 Advanced Product Quality Planning (APQP): Product quality begins with design. Therefore, from initial product concept through production, the supplier and Rehlko must understand and agree on all applicable quality standards and requirements. Agreement must be reached on all critical quality characteristics, control items, checking fixtures, packaging requirements, and all other quality related matters. Rehlko prefers that suppliers use the advanced product quality planning techniques (as they apply) described in the AIAG Advanced Product Quality Planning and Control Plan manual (www.aiag.org).

Go to Table of Contents

Section 4.0 Production Part Approval Process (PPAP)

4.1 The Production Part Approval Process (PPAP) has been benchmarked by the Automotive Industry Action Group (AIAG), Production Part Approval Process. The purpose of the PPAP is to determine if suppliers have understood all requirements, and if processes have the potential to produce parts that meet these requirements consistently. Permanent changes are documented through an internal change control system, which provides information to suppliers defining PPAP submission level as outlined in Table 2. In addition, submission of PPAP documentation may be the result of changes at the supplier as identified in Table 3.

Table 2: PPAP Levels and Requirements (AIAG-Aligned)*

PPAP Level	AIAG Requirement	Rehlko Part Types
Level 1	PSW only (supplier retains all other documents)	Off the shelf / catalog
Level 2	PSW + limited submission, rest retained	Low Volume / Service (see Section 4.4.2); Rev Change; Supplier Request for Change ES Parts (Power Systems ONLY): alternators, radiators, tanks, skids
Level 3 ***Default***	PSW + full submission of required elements	Standard production parts. New component, supplier, location, etc.
Level 4	PSW + Customer-defined	Same as Level 2
Level 5	Full PPAP reviewed onsite	Engines

**Additional PPAP requirements may be applied based on part complexity, risk, and program requirements, as determined by Supplier Quality.*

4.2 ***Rehlko prefers electronic submission of PPAP documentation in Adobe Acrobat (.pdf) or Microsoft Excel (.xls) format.*** PPAPs should be submitted to your Supplier Quality Representative (copy Purchasing).

4.3 Submission Requirements: The supplier shall meet all level 3 PPAP requirements, regardless of the requested PPAP submission level.

4.3.1 Rehlko reserves the right to require a capability study on drawings without critical/major characteristics, and to require additional documents for level 1 and 2 PPAP submissions. Rehlko may also adjust PPAP requirements based on unique situations to mitigate risk.

4.3.2 Suppliers can use their own forms. If needed, standard forms are provided in the appendix to this supplement.

4.4 PPAP Samples: Production samples shall be taken from a significant production run, using production tooling, processes, and operators, unless otherwise approved. Reference table in sections 4.3.1 The production run shall be conducted at the production site, using production tooling, production gauging, production process, production materials, and production operators. If any of the part specifications cannot be met, the supplier shall document their problem-solving efforts and shall contact the authorized Rehlko representative.

4.4.1 Pre-Production Runs/Samples. The supplier must have authorization from Supplier Quality prior to applying any exceptions. Rehlko reserves the right to add dimensions to these requirements accordingly.

4.4.2 For low-volume production (e.g., service or option parts), suppliers shall meet Level 2 PPAP requirements unless otherwise specified, including control Plan (approval required); measurement data for key characteristics; material certifications, as applicable; and evidence of meeting design and performance requirements.

4.4.3 Resubmission of PPAP documentation is required if any of the following conditions occur. Typical submission reasons and associated default PPAP levels are defined in Table 3.

Table 3: PPAP Submission Reasons (AIAG-Aligned)

Typical Reasons for PPAP Submission	Required PPAP Level	Notes / AIAG Intent
New part / first-time production (new part number)	**Level 3 (Default)**	AIAG default unless otherwise specified by customer
Engineering change affecting form, fit, function	**Level 3**	Customer approval required; level may be increased
Material change or substitution	**Level 3**	Includes new or alternate materials
New, modified, or replacement tooling (major)	**Level 3**	Includes significant refurbishment
Tooling transfer, replacement, or duplicate tooling	**Level 3**	Applies to production tools
Manufacturing location change	**Level 3**	Includes internal or supplier site moves
Process change (sequence, method, equipment)	**Level 3**	Includes automation or new technology
New subcontractor or supplier source	**Level 3**	Supplier change triggers full validation
Production restart after ≥12 months inactivity	**Level 3**	Re-validation required per AIAG
Change in inspection/test method affecting results	**Level 3**	If it impacts acceptance criteria
Correction of discrepancy on previously approved part	**Level 3**	Re-submission required
Minor engineering change (no impact to fit/function)	**Level 2**	Customer/SQE may reduce submission level
Minor process change (no impact to capability or control plan)	**Level 2**	Limited submission acceptable
Changes not affecting form, fit, function, or process	**Level 1**	PSW only; documentation retained
Customer-specific request or deviation approval	**Level 4**	Defined fully by customer
High-risk, safety, regulatory, or critical components	**Level 5 (or 3)**	May require onsite review

* Unless otherwise specified by the customer, PPAP submissions shall default to Level 3 in accordance with AIAG PPAP 4th Edition. Final submission level is subject to customer or SQE determination based on risk, change type, and program requirements.

4.4.4 Submission and retention requirements for each PPAP level, aligned with AIAG are shown in Table 4.

Table 4: PPAP Submission Requirements

PPAP Requirements	Level 1	Level 2	Level 3	Level 4	Level 5	Rehlko Form (if applicable)
1. Design Record	R	S	S	⋆	R	Current Part Print Revision
2. Engineering Change Documents	R	S	S	⋆	R	
3. Customer Engineering Approvals, if required	R	R	S	⋆	R	
4. Design FMEA	R	R	S	⋆	R	
5. Process Flow Diagrams	R	R	S	⋆	R	Template - Rehlko PPAP
6. Process FMEA	R	R	S	⋆	R	Template - Rehlko PPAP
7. Control Plan	R	R	S	⋆	R	Template - Rehlko PPAP
8. Measurement System Analysis Study	R	R	S	⋆	R	
9. Dimensional Results	R	S	S	⋆	R	Template - Rehlko PPAP
10. Material Performance Test Results	R	S	S	⋆	R	Template - Rehlko PPAP
11. Initial Process Capability Studies	R	R	S	⋆	R	
12. Qualified Laboratory Documentation	R	S	S	⋆	R	
13. Appearance Approval Report (AAR), if applicable	R	S	S	⋆	R	
14. Sample of Product	R	S	S	⋆	R	
15. Master Sample	R	R	R	⋆	R	Template - Rehlko PPAP
16. Checking Aids	R	R/S	R/S	⋆	R/S	
17. Records of Compliance	R	R	S	⋆	R	Regulatory and customer-specific requirements (e.g., IMDS, safety). Reference Rehlko G-Spec.
18. Part Submission Warrant	S	S	S	S	R	Template - Rehlko PPAP
19. Packaging Method	R	R	S	⋆	S	
20. PPAP Checklist	R	S	S	S	S	

#1-18 match Retention/Submission Requirements Table 4.2 in AIAG PPAP 4th Edition.
#19-20 are Rehlko Specific Documents.
S = Submit and retain a copy of records at appropriate locations.
R = Retain and make available to customer upon request.
⋆ = Submission requirements defined by customer

4.4.5 PPAP Submission Status: Upon receipt of a PPAP submission, Supplier Quality shall review and assign one of the following statuses:

Table 5: PPAP Submission Status Definitions

Status	Actions
Approved	The submitted part and supporting documentation meet all customer and Rehlko requirements. The supplier is authorized to ship production quantities in accordance with release or purchase order requirements.
Interim Approval	Permits shipment of parts or materials for production use on a limited-time or quantity basis. Interim approval may be granted when: 1. Nonconformances preventing full approval are clearly identified, and 2. An action plan has been defined and approved by Rehlko. Re-submission is required to achieve full approval. Interim approval is temporary and subject to defined conditions. It is the supplier's responsibility to contact the appropriate SQE prior to expiration to request an extension.
Rejected	The PPAP submission does not meet requirements based on the production lot and/or supporting documentation provided. The supplier shall correct discrepancies and resubmit for approval.

4.5 PPAP Element-Specific Requirements (Rehlko Specific)

4.5.1 PSW Configuration Identification (Table 4. Item #18): Where optional materials or configurations (tool, press, etc.) may be used, specify the configuration used on the Part Submission Warrant (PSW) in the Explanation/Comments section. This applies to all submission levels.

4.5.2 Dimensional and Test Results Requirements (Table 4. Items #9 & 10):

A full-dimensional inspection report shall be included for all PPAP submissions and must cover all drawing requirements. The report shall include part number, revision level, tooling identification, and inspection date. All nonconformances shall be clearly identified.

ISIR Sample Size: 3 pieces per cavity and/or fixture or as specified by your Supplier Quality Representative.

Limited dimensional drawing is indicated by a note on the print and may require a scan of each showing data which is "datum aligned." A "best fit" scan could be requested by SQE in addition to the "datum align" data to help determine the best solution to dimensional issues.

4.5.3 Capability Requirements (Table 4. Item #11): Capability requirements shall meet AIAG expectations unless otherwise specified.

A preliminary capability study is required for each classified characteristic where variable data is available. Suppliers shall establish process controls and monitoring methods as defined in the control plan, including material verification, process parameters, and inspection frequency.

- Materials/Alloys: Process controls and inspection frequency defined in the control plan
- Materials (provided by Tier II suppliers or separate internal supplier process): Material certifications with each shipment, material testing by supplier or third party.
- Porosity/Internal Defects: process controls listed on the control plan.

- Heat treatment process: temperature uniformity of a fully loaded chamber.
- Attributes (presence of features or assembly components): inspection frequency defined in the control plan.

Table 6: Capability Samples Size Requirements

Capability Sample Size	Requirement
100-piece data set from a 300-piece minimum production run	Process capability for new production tooling, material or process settings for all major, critical and emission related dimensions.
If the initial production run is less than 300 pieces and greater than 30 pieces	Use 30-piece minimum for the preliminary capability study (CPK) for all required dimensions.
If the initial production run is less than 30 pieces	100% dimensional and visual inspection is required for each major, critical, and emission related dimensions. When additional orders arrive, continue to collect the data until a 30-piece sample is reached to complete process capability study (PPK).

4.5.4 Sample Requirements (Master, Boundary, Family Parts; Table 4. Item #15-16 as applicable)

- Master Samples: The supplier shall retain a master sample for the same retention period as PPAP records or until a new master is approved.
- Boundary samples shall be established for cosmetic characteristics and retained for comparison purposes. Approval is required prior to use.
- Family parts may be evaluated as a group only when produced from the same process, equipment, and materials.

4.5.5 Manufacturing Documentation Requirements: Suppliers shall maintain and make available all manufacturing documentation necessary to support PFMEA and Control Plan implementation, including process work instructions, inspection methods, and capacity verification.

4.5.6 Pre-Submission Inspection Requirements (at vendor):

First Piece Inspection Requirements: Suppliers shall perform first piece inspection for all new or revised products to verify conformance prior to PPAP submission. Documented results shall demonstrate compliance with drawing requirements and control plan requirements. Nonconformances shall be corrected prior to submission.

Go to Table of Contents

Section 5.0 GD&T Gauge Set-Up

5.1 Geometric Dimensioning and Tolerancing (GD&T) requirements shall be applied as defined on the engineering drawing. Suppliers are responsible for interpreting and reporting dimensional results in accordance with this section as part of PPAP.

If special gauging is required, a quote shall be submitted with the initial part quotation, including gauge design for approval. Gauge information and validation must then be provided as part of the PPAP package.

5.2 Dimensional results shall be reported in a format that includes the control frame, print dimensions, and measured results.

5.2.1 All basic dimensions to have a measured numeric value.

5.2.2 Where dimensional values are not explicitly defined, suppliers shall reference tolerances from the drawing in the following order: print tolerances, drawing notes, specifications (G-spec), and title block.

5.2.3 Items with a feature control frame will have a minimum of four (4) lines reporting:

5.2.3.1 Line 1 is the measurement of the feature control frame itself.

5.2.3.2 Line 2 is the bonus tolerance applied, where applicable. If no bonus tolerance applies, report “N/A”.

5.2.3.3 Line 3 is the X value deviation from the basic dimension using the Cartesian coordinate system. This line shall reference the item number of the corresponding basic dimension.

5.2.3.4 Line 4 is the Y value deviation from the basic dimension using the Cartesian coordinate system. This line shall reference the item number of the corresponding basic dimension.

5.2.4 Out-of-tolerance conditions shall be clearly identified.

5.2.5 Report each occurrence for features dimensioned as multiple items (i.e.: 2X, 3X, 4X, etc.).

5.2.6 Features with key characteristic symbols shall include corresponding capability data.

Section 6.0 Rehlko Drawing Specifications

6.1 Classification of Significant Characteristics: On Rehlko prints, characteristics is classified as follows with corresponding process capability requirements:

Table 7: Characteristic Detail

Characteristic	Symbol	Required Cpk	Failure Mode
Emissions		> 1.67	Emissions; Regulatory & Compliance
Critical		> 1.67	Functional Failure; Safety
Major		> 1.33	Reduced usability or customer satisfaction
None		> 1.00	Minor effect on function or appearance

6.1.1 Non-dimensional features shall be identified and controlled by a process approved by Supplier Quality. (Examples: material, porosity, heat treating.)

6.1.2 Assignment of Critical, Emissions, or Major characteristics does not reduce the importance of other characteristics on the drawing. Every tolerance is absolute and shall not be exceeded regardless of classification.

6.2 Dimensional interpretation and reporting requirements are defined in Section 5.

6.3 G-specs provide additional requirements, specifications, or instructions supplementing drawing information.

Suppliers shall:

- Review all applicable Z-spec or G-spec requirements
- Include all applicable requirements in PPAP documentation
- Incorporate requirements into the Control Plan
- If G-spec requirements are not provided with the quote package, suppliers shall request copies. Updated versions shall be used as applicable.

Drawing requirements take precedence in the event of conflict unless otherwise specified.

As a supplier, the expectation is that you review the print for any G-specs, request copies with all quote requests or print updates if they are not included with the quote package (it may have changed since you last quoted), include applicable requirements into PPAP documents, and incorporate into control plan.

6.4 Tooling Variation (TV) notes are used to document approved deviations from drawing requirements specific to tooling or process limitations.

- TV notes apply to a specific tool, cavity, or supplier.
- Future tooling shall conform to drawing requirements unless otherwise approved.
- Supplier Quality and Design Engineering determine if tooling modification is required.
- The SQE and Design Engineer determine if a TV note is appropriate or if tool modification is required.
- TV notes last for the life of the tool or cavity for which they were issued.

Section 7.0 Defect Resolution

7.1 Rejected material shall be documented with a Defective Material Report (DMR) and require a Return Material Authorization (RMA). Disposition can be one of the following:

- Reject (Scrap or Return)
- Sort / Screen / Rework
- Deviation to Use-as-is

7.1.1 **Reject (Scrap or Return):** Material is not acceptable and shall be dispositioned as scrap or return.

An RMA shall be provided within 48 hours including disposition. If disposition instructions are not received within the required timeframe, the supplier shall disposition the material as scrap unless otherwise directed by Rehlko.

The supplier is responsible for all costs associated with rejected material, including return, replacement, or disposal. Return instructions shall be coordinated with Rehlko.

7.1.2 **Sort / Screen / Rework:** Activities used to inspect and/or restore nonconforming material to meet requirements.

Sort, screening, or rework activities shall be approved by Rehlko prior to implementation.

The supplier shall:

- Submit a containment and rework plan, including verification methods, for approval
- Implement containment within 24 hours unless otherwise approved
- Segregate all nonconforming material from production and control disposition
- Ensure all reworked products meet drawing and specification requirements prior to release
- Obtain Quality approval prior to release of screened or reworked material
- Maintain records of screening, rework activities, and final disposition

The supplier is responsible for all costs associated with sorting, screening, rework, and any third-party services required.

Supplier-controlled or third-party rework activities shall:

- Be coordinated with Rehlko Quality
- Be performed in accordance with an approved plan
- Include documented results submitted to Rehlko upon request

If material is returned to the supplier during or after sorting/rework, the supplier shall process material under an approved RMA.

Containment and corrective actions shall be implemented using an 8D or equivalent method when required.

Reworked or screened material shall not be shipped without documented Quality approval.

7.1.3 **Deviation to Use-as-is:** Request to accept nonconforming material without rework.

Deviation requests shall be submitted and approved prior to shipment. Where applicable, deviations shall be submitted through the Supplier Request for Change (reference Appendix C) process in accordance with the Global Supplier Quality Manual, Section 6.01.

Material shall not be shipped or used without approved deviation.

7.2 Defective Material Report (DMR) and Supplier Corrective Action Request (SCAR)

7.2.1 Suppliers shall immediately notify Rehlko Supplier Quality and Purchasing upon identification of suspected or confirmed nonconforming material, including issues identified prior to or after shipment.

7.2.2 Upon Receipt of a DMR:

- Disposition shall be provided within 48 hours (refer to Section 7.1 for details)
- Contain all suspect inventory located at Rehlko, supplier facilities, and distribution locations
- Document containment actions and provide upon request
- Replace nonconforming material with certified material, as applicable
- Implement corrective actions to prevent recurrence
- Report results of containment or sorting activities to Supplier Quality

7.2.3 Upon Receipt of a SCAR:

- Complete actions defined in Sections 7.2.2 and this section
- Perform root cause analysis using the 8D method or equivalent
- Submit a corrective action response within the required timeframe defined by SCAR priority levels (see Section 7.2.4)

No specific format is required, provided all required elements are addressed. Responses shall be submitted to the Supplier Quality Representative with a copy to the DMR/SCAR Coordinator.

7.2.4 Response Time: Due Dates are set according to a priority level determined by problem severity. All reasonable requests for additional time will be considered. Priority level definitions and corresponding days to respond are shown below.

Table 8: Priority Level Definitions and Response Times

Priority Level	Response Time	Definition
Urgent	3 days	Reached an outside customer
High	5 days	Reached internal manufacturing process
Normal	30 days	Caught at Supplier Audit or notified in advance by supplier
Low	notification only (no response required)	non-repeat single issue, non-critical, notification only

**These response timelines supersede the general expectations defined in the Global Supplier Quality Manual for Power Systems and Home Energy suppliers.*

7.3 Failure to implement effective corrective actions or repeated DMR occurrences is unacceptable.

7.4 In such cases, Rehlko reserves the right to implement additional controls at the supplier's expense to ensure production and customer protection. Controls may include increased inspection, third-party certification, or additional oversight.

7.5 These measures are intended to protect Rehlko production and product quality.

Section 8.0 Requirements for Tooling and Gauging

8.1 Tooling Acceptance:

Tooling acceptance is achieved through PPAP approval or approval of a Supplier Request for Change (refer to Appendix C) when tooling or process changes are required. Submission and capability requirements are defined in Section 4 (PPAP Requirements).

8.2 Tooling Changes and Control:

Tooling or process changes required to meet capability or quality requirements shall be approved through the Supplier Request for Change (refer to Appendix C).

8.3 Tooling Life and Deviations:

Tooling deemed beyond useful life requires deviation approval through Rehlko Purchasing, Operations, and Quality. Additional controls may be required.

8.4 Gauging Requirements:

Special gauging shall be approved prior to implementation, and validation shall be included in the PPAP documentation.

Section 9.0 Equipment Control

9.1 Refer to the Global Supplier Manual Section 8.03 for Specific Details

9.2 New Equipment Capability

Suppliers shall document and control the integration of new equipment or technology into production. Requests for new equipment or technology shall be submitted for approval and include:

- Equipment identification and quantity required for qualification (e.g., qualification plan)
- Potential impact on product or manufacturing processes (e.g., PFMEA)
- Method for evaluating manufacturing operations, including subcontracted processes (e.g., control plan)
- Plan for updating quality documentation, including control plans, maintenance records, calibration schedules, and operator training
- Any additional PPAP requirements resulting from the equipment or technology change, which shall be included in the updated PPAP where applicable

Section 10.0 Stop-Ship / Stop Build Procedures

10.1 Quality Problem Notification:

The supplier shall notify Rehlko of any quality, reliability, or safety issues that may affect product performance, regardless of source or identification method.

Notifications shall include potential issues affecting Rehlko product or processes. This includes issues identified at the supplier, sub-supplier, or by other customers. Rehlko reserves the right to implement stop shipment or stop build actions to protect production and product quality.

10.2 Problem Communication:

The supplier shall establish a formal process to notify Rehlko Supplier Quality and Purchasing of quality or reliability issues. Immediate notification shall be made via telephone. An 8D or equivalent process shall document all actions.

10.3 Urgency:

Stop ship and stop build actions shall be treated with maximum urgency and shall not be lifted until root cause is understood and corrective actions are implemented. The supplier shall provide immediate technical support for root cause analysis and corrective actions. The resolution process shall be documented, including root cause, corrective actions, and material disposition.

10.4 Product Disposition:

The supplier shall ensure no quality compromise when dispositioning suspect or nonconforming product. Suspect product shall not be shipped to Rehlko without approved deviation.

10.5 Supplier Costs:

Costs resulting from the supplier's inability to meet Rehlko production or quality requirements shall be the responsibility of the supplier. Refer to the commercial agreement.

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Approval: **Applicable Supplier Quality Managers**

Steven Crumley (Power Systems)

Juliana Van Winkle (Home Energy)

Revision History:

REV #	CHANGE	AUTHOR	DATE
A	Initial Release	J. Seger	01/12/2021
B	Triennial review; no process changes	S. Zeckmeister	01/18/2024
C	Replace all Kohler with Rehlko throughout document and in logo. Further updates coming on next revision	J. Yosick	07/28/2025
D	Add Section 5.7 regarding suppliers finding nonconforming product in their facility or in transit to Rehlko	J. Yosick	07/29/2025
E	Entire document updated from Kohler to Rehlko. Streamlined content by removing administrative details, training explanations, and work instructions to focus on clear, enforceable requirements. Added Sections 2-3 and 5-10 (adapted from Engines). Section 4 restructured in accordance with AIAG requirements. Duplicate content and inconsistent direction across sections were eliminated. Section 7 restructured to define nonconforming material dispositions and requirements. Removed detailed work instructions and execution-specific content to focus on clear, enforceable requirements. Simplified sort/rework section and clarified supplier responsibilities and cost ownership.	J. Yosick	06/29/2026