

**63055 Hwy 97  
Bend, OR 97701**

## **QUALITY ASSURANCE CREW**

### Directions from the West

Travel east on OR-22/OR 99E OR-22 E.  
At Santiam Junction OR-22 merges with US-20 E. Continue east.  
US-20 meets OR 99W in Bend.

### Directions from the East

Travel west on I-84 and take the US-97 exit (number 104) toward  
YAKIMA/BEND.  
Turn LEFT onto US-97 S.  
As you near Bend, turn RIGHT onto NW ROBAL RD.  
Turn LEFT onto US-20 E.

