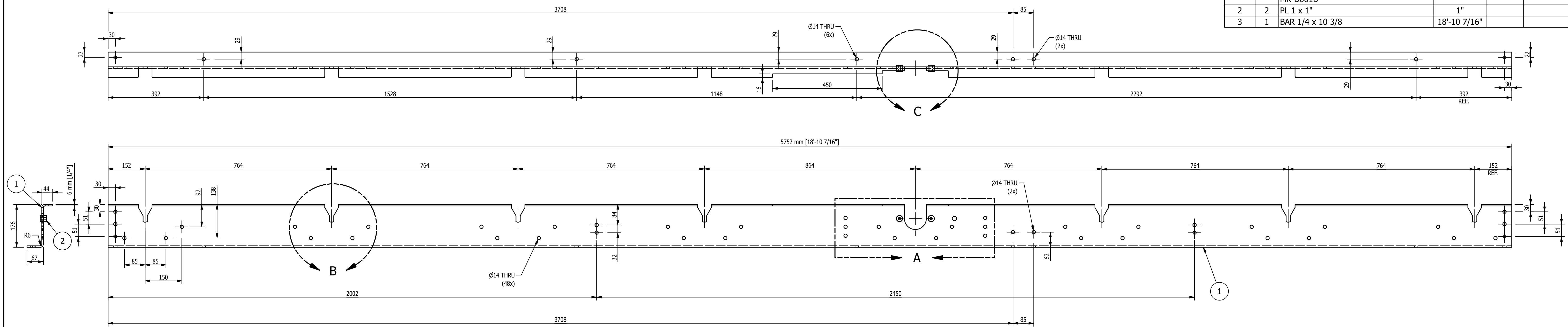
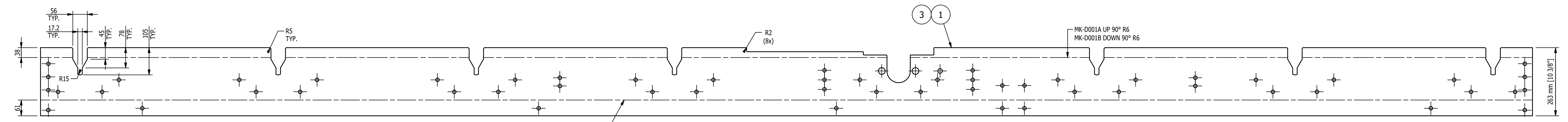


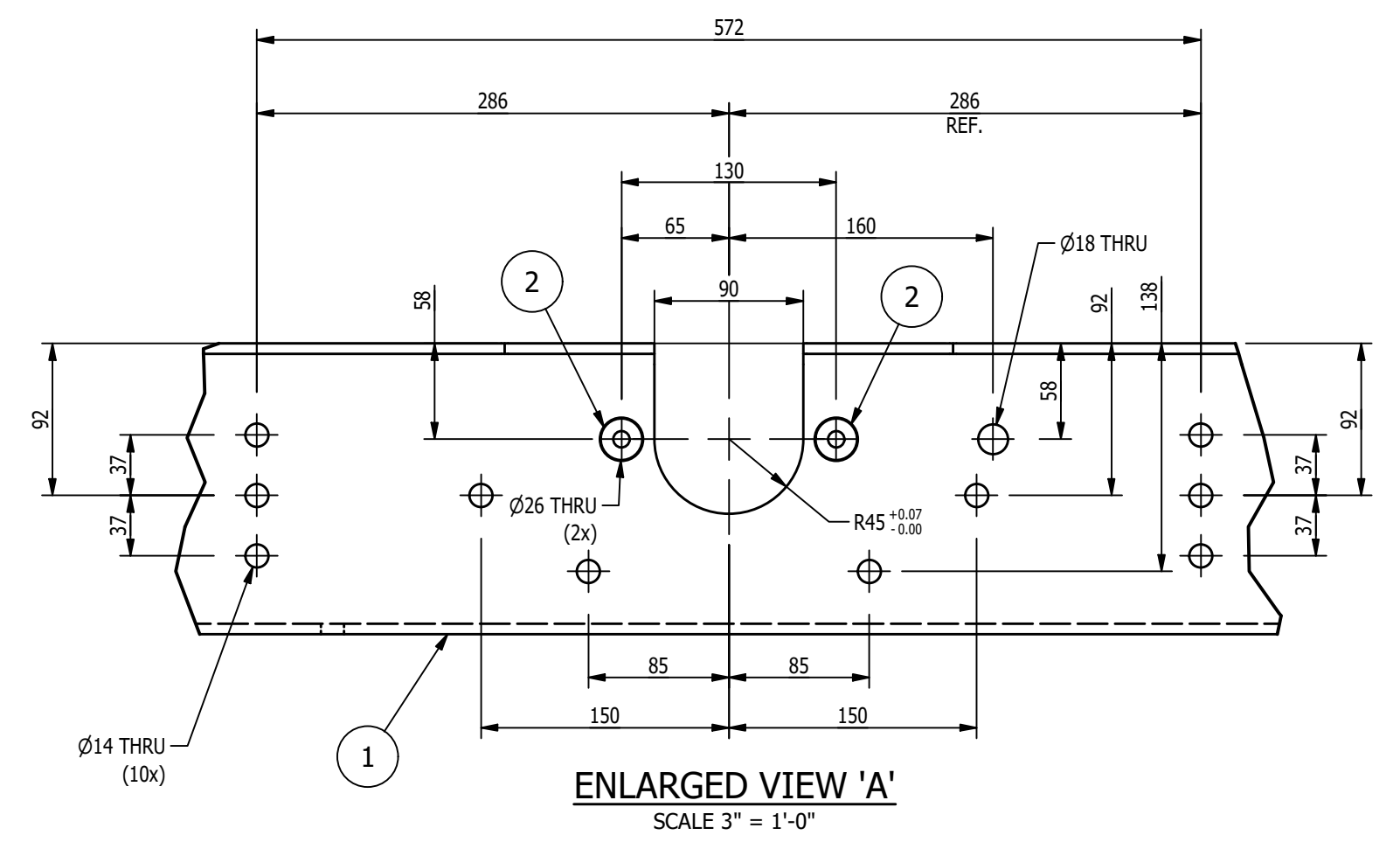
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D001A			
1	1	BAR 1/4 x 10 3/8	18'-10 7/16"		
2	2	PL 1 x 1"	1"		
		MK-D001B			
2	2	PL 1 x 1"	1"		
3	1	BAR 1/4 x 10 3/8	18'-10 7/16"		



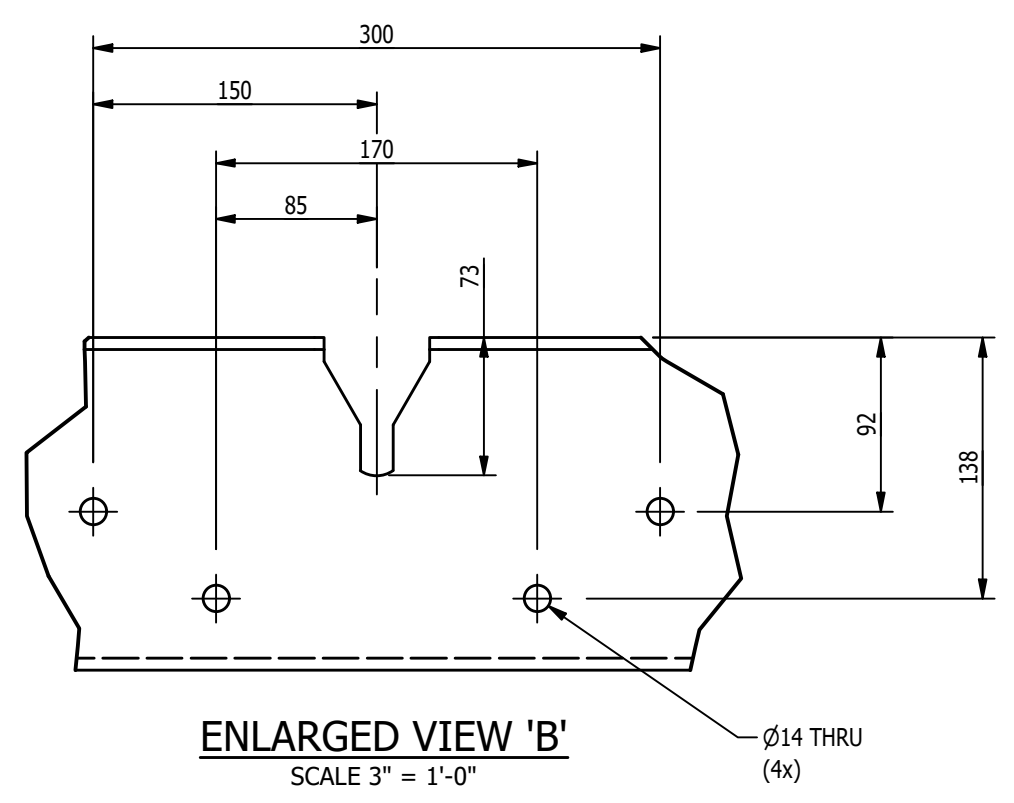
MK-D001A ~ 8-ROLL SIDE FRAME ASSY - RH (SHOWN)
 MK-D001B ~ 8-ROLL SIDE FRAME ASSY - LH (OPPOSITE)
 SCALE 1 1/2" = 1'-0"



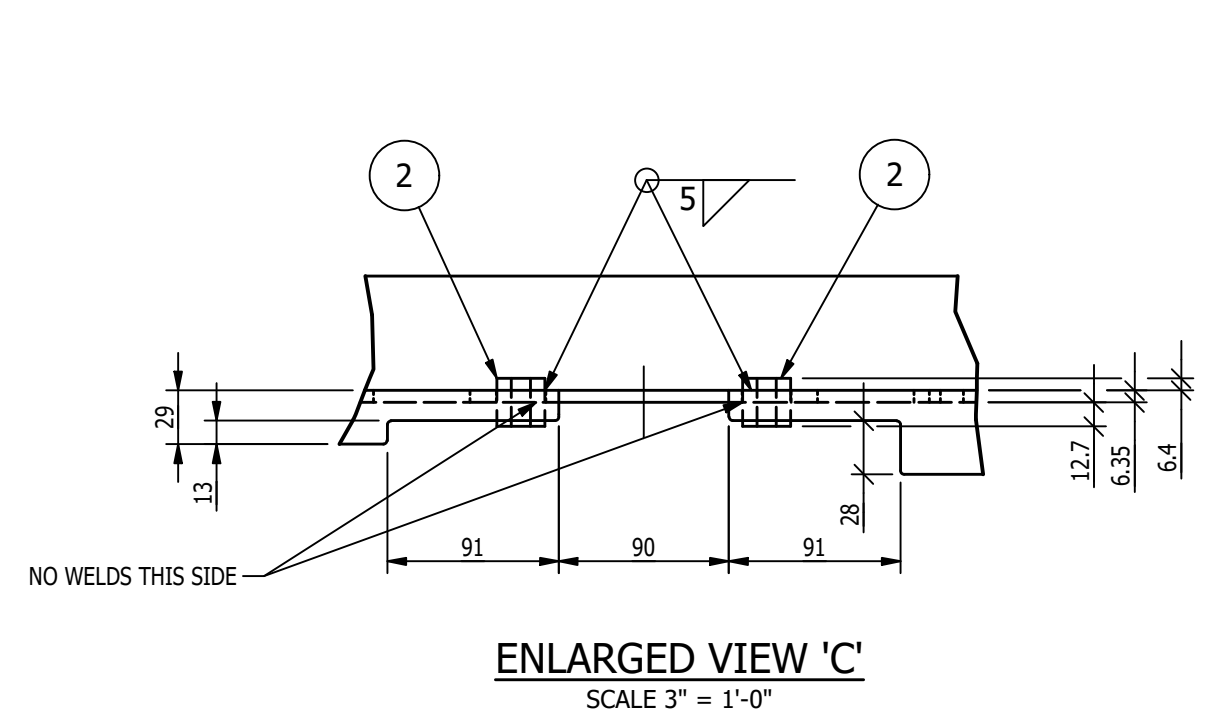
FLAT PATTERN OF ITEM '1' & '3'
 SCALE 1 1/2" = 1'-0"



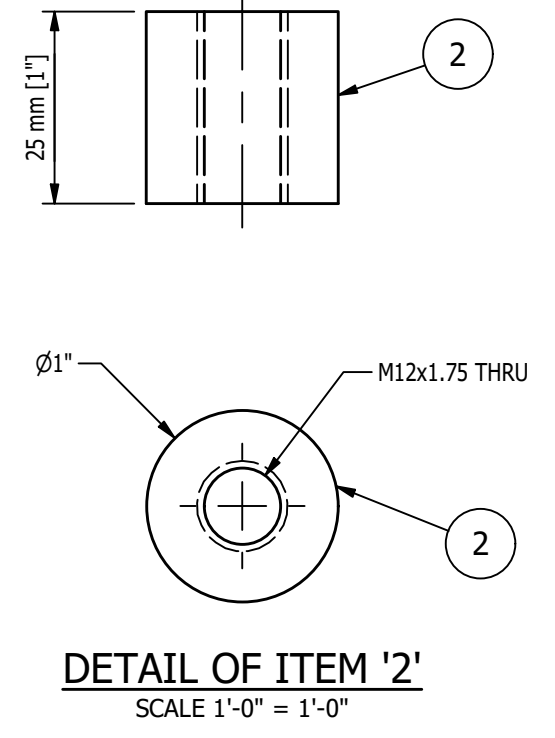
ENLARGED VIEW 'A'
 SCALE 3" = 1'-0"



ENLARGED VIEW 'B'
 SCALE 3" = 1'-0"



ENLARGED VIEW 'C'
 SCALE 3" = 1'-0"



DETAIL OF ITEM '2'
 SCALE 1'-0" = 1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
 PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER

ONE SHOP COAT OF PURE ORANGE RAL 2004
 OR
 ONE SHOP COAT OF LIGHT GREY RAL 7035
 DO NOT PAINT MACHINED ITEMS, FASTENERS
 OF PURCHASED ITEMS.

MAGNUM CONSULTING
 41100 QuakerRoad Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D001

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLE:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/25/2022	UPDATED LENGTH & POSITION OF ITEM '2'; UPDATED PAINT NOTES	
A	MC	7/19/2022	FOR FABRICATION	

REVISION HISTORY

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D001

REV: B

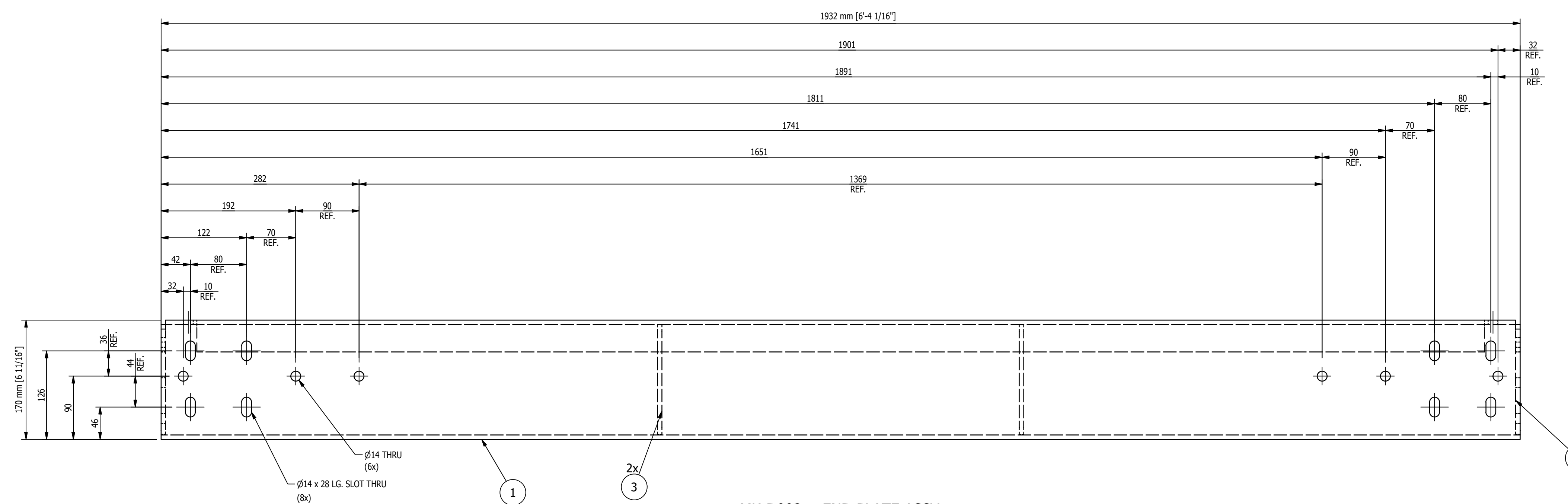
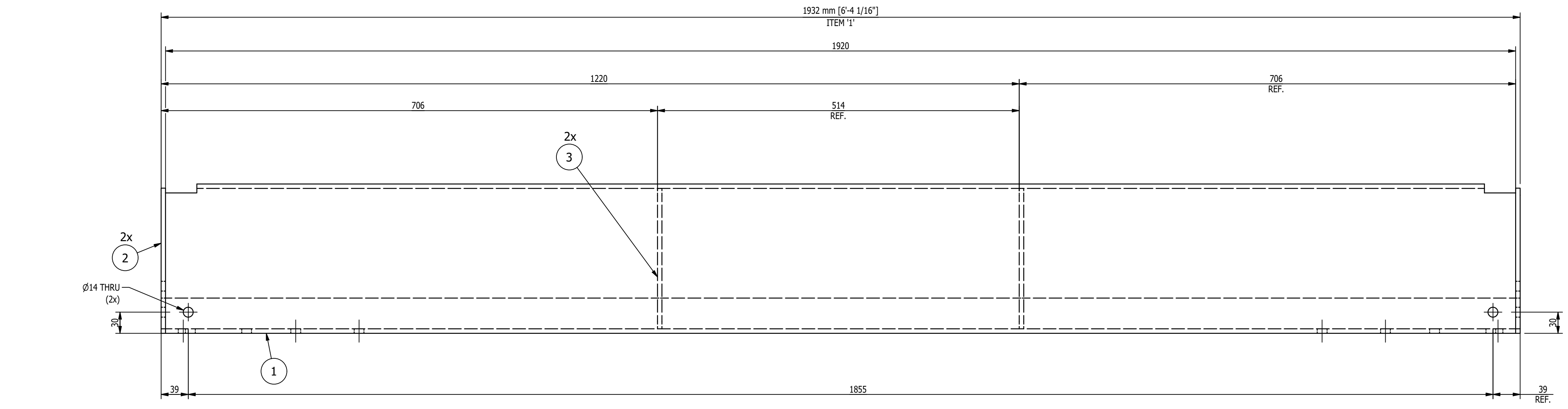
DRAWN BY: RJB

CHECKED BY: CW

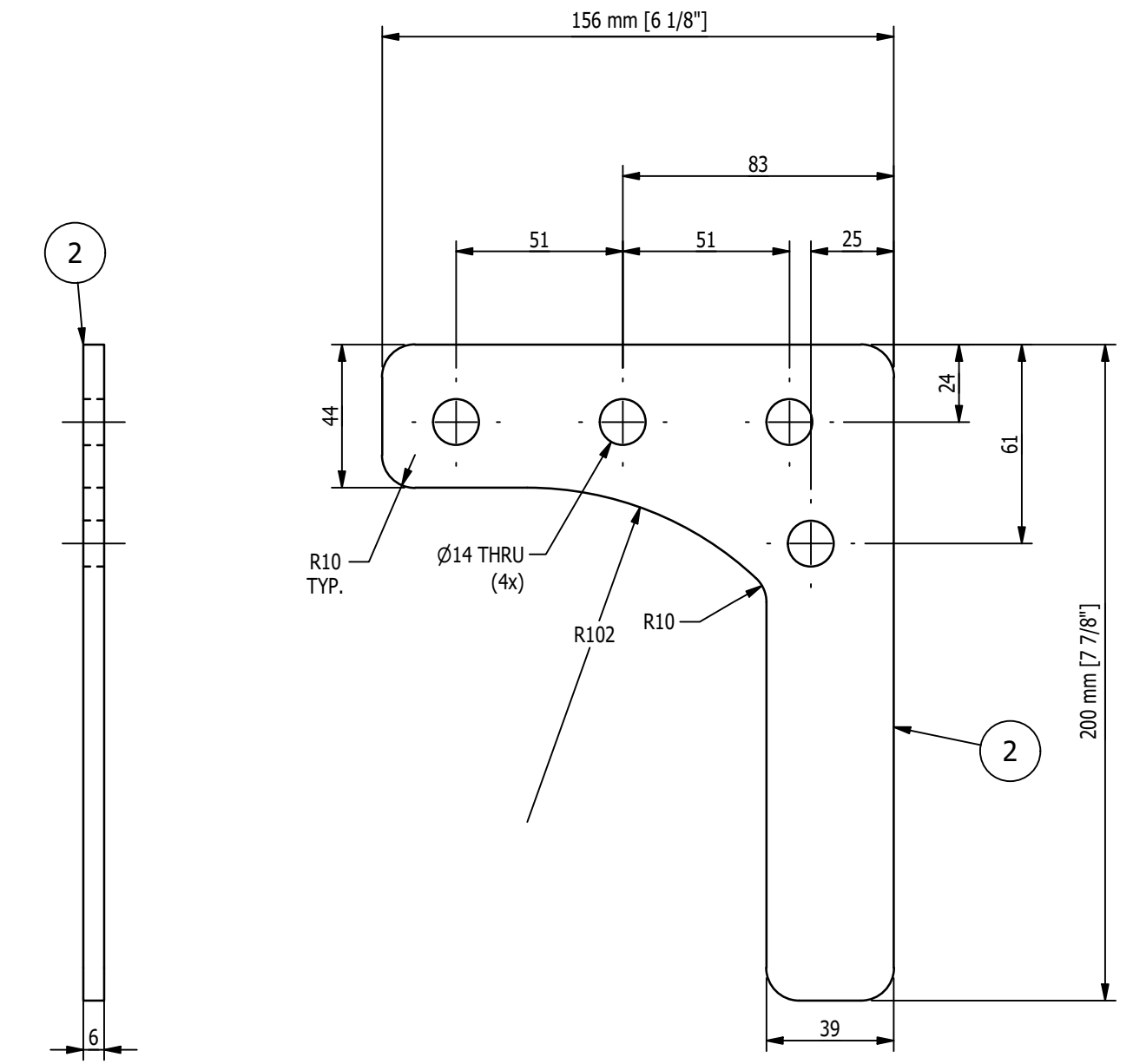
DWG DATE: 6/13/22

JOB No: 22096

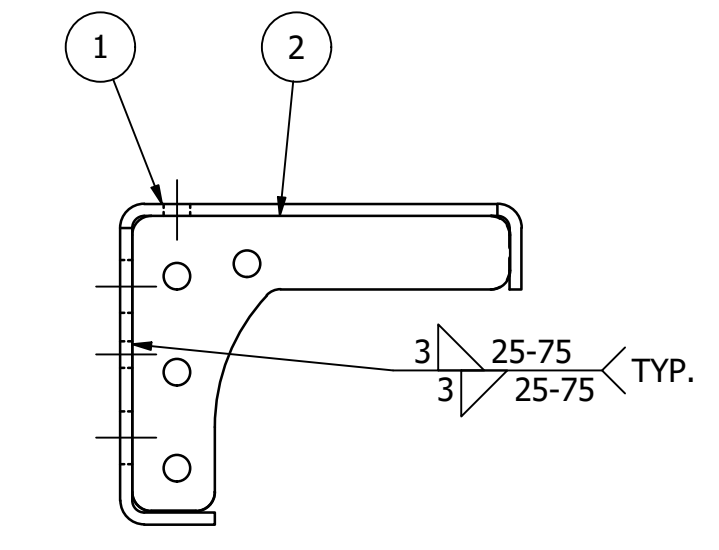
BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D002A		
1	1	PL 1/4 x 17 3/8	6'-4 1/16"	
2	2	PL 1/4 x 6 1/8	7 7/8"	
3	2	PL 1/4 x 6 1/8	7 7/8"	
TOTAL WEIGHT ~ 99.2 lbs				



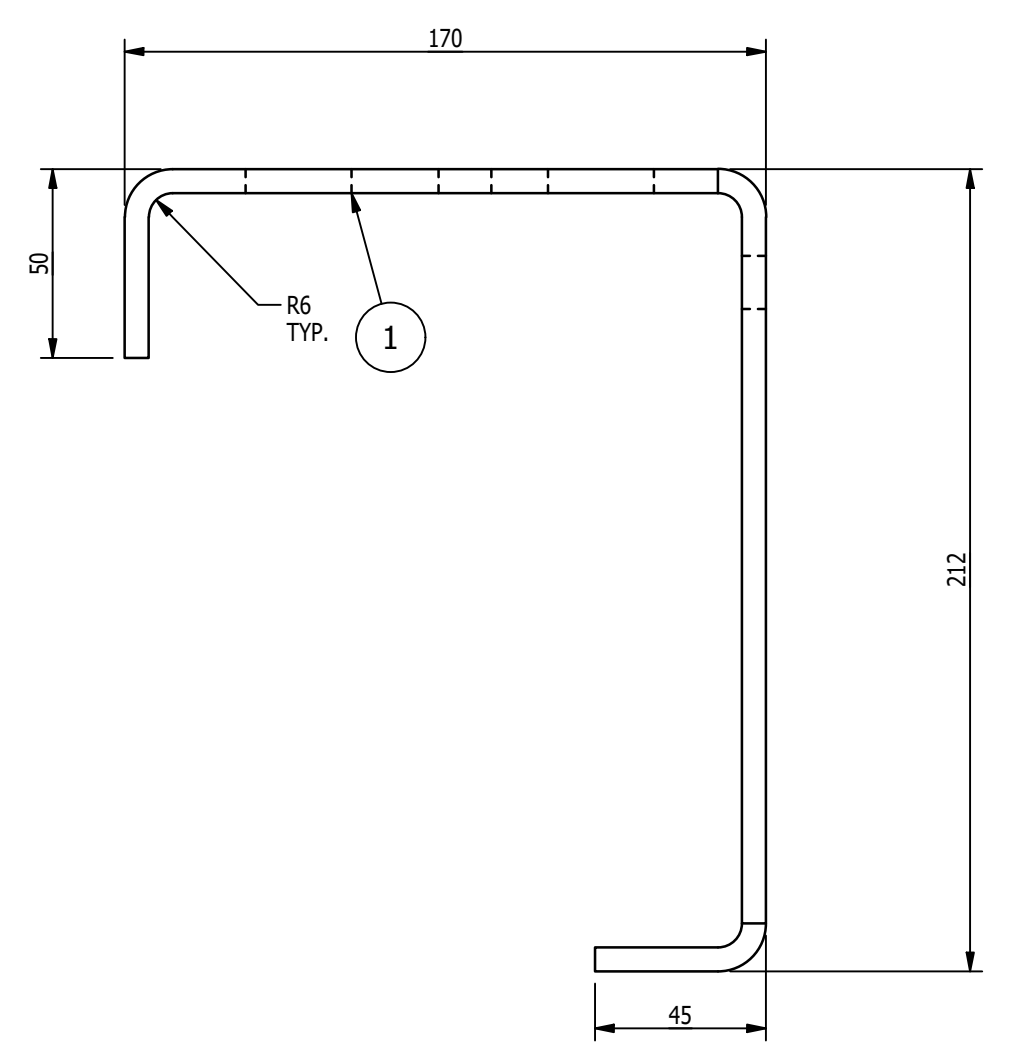
MK-D002 ~ END PLATE ASSY
SCALE 3"=1'-0"



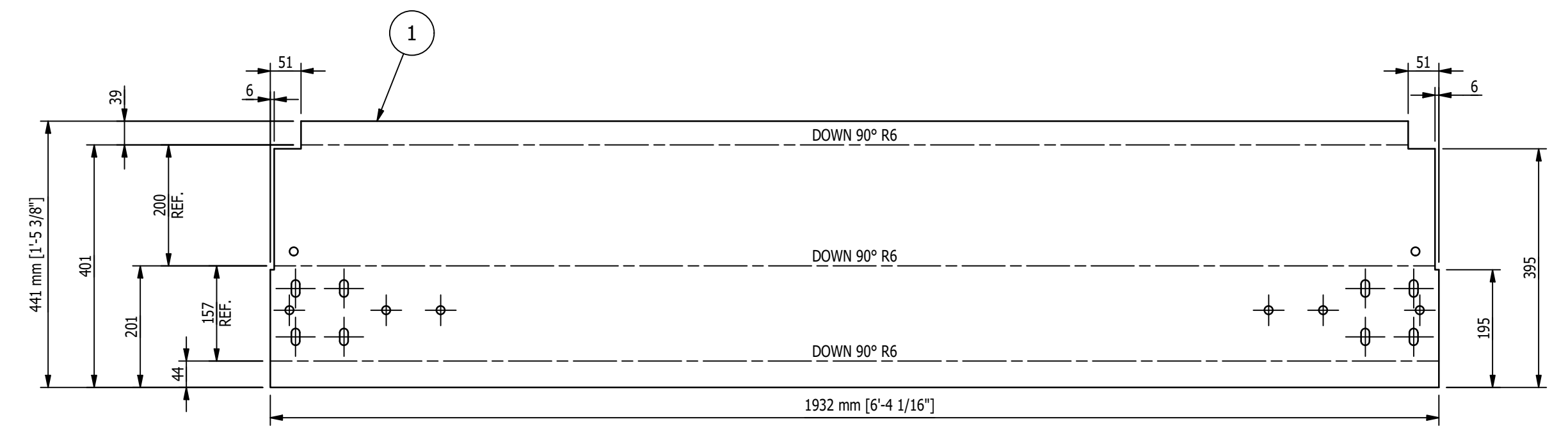
DETAIL OF ITEM '2'
SCALE 6"=1'-0"



DETAIL OF ITEM '3'
SCALE 3"=1'-0"



DETAIL OF ITEM '1'
SCALE 6"=1'-0"



FLAT PATTERN FOR ITEM '1'
SCALE 1 1/2"=1'-0"

- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:
- PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER

- ONE SHOP COAT OF PURE ORANGE RAL 2004
OR
ONE SHOP COAT OF LIGHT GREY RAL 7035

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/4/2022	REVISED BOM DESCRIPTION ITEM 2	
A	MC	7/22/22	FOR FABRICATION	

REVISION HISTORY

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millc.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D002	DWG DATE:	6/6/22
REV:	B	JOB No:	22096

MAGNUM CONSULTING
41100 Dardick Road
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D002

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

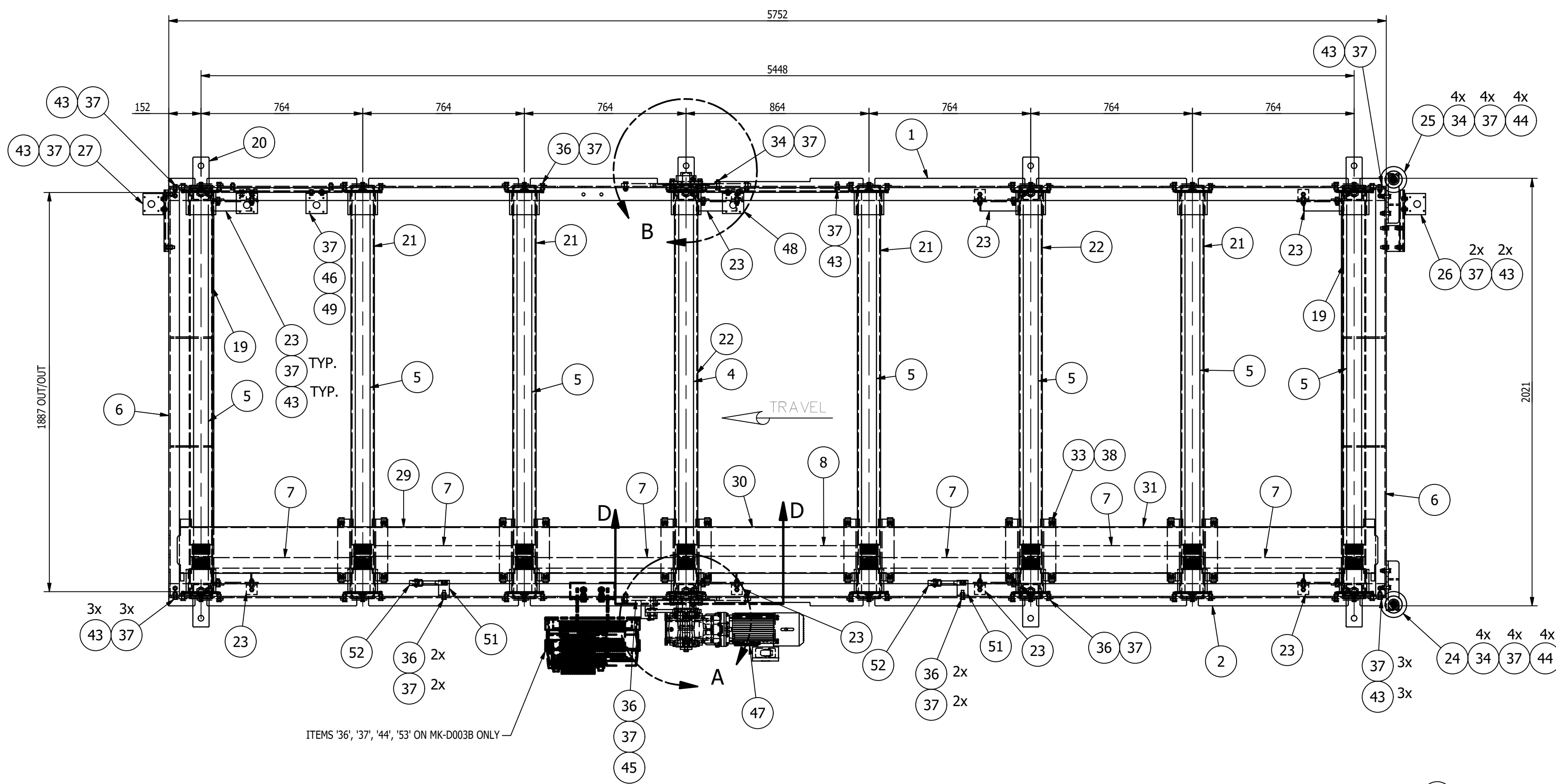
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

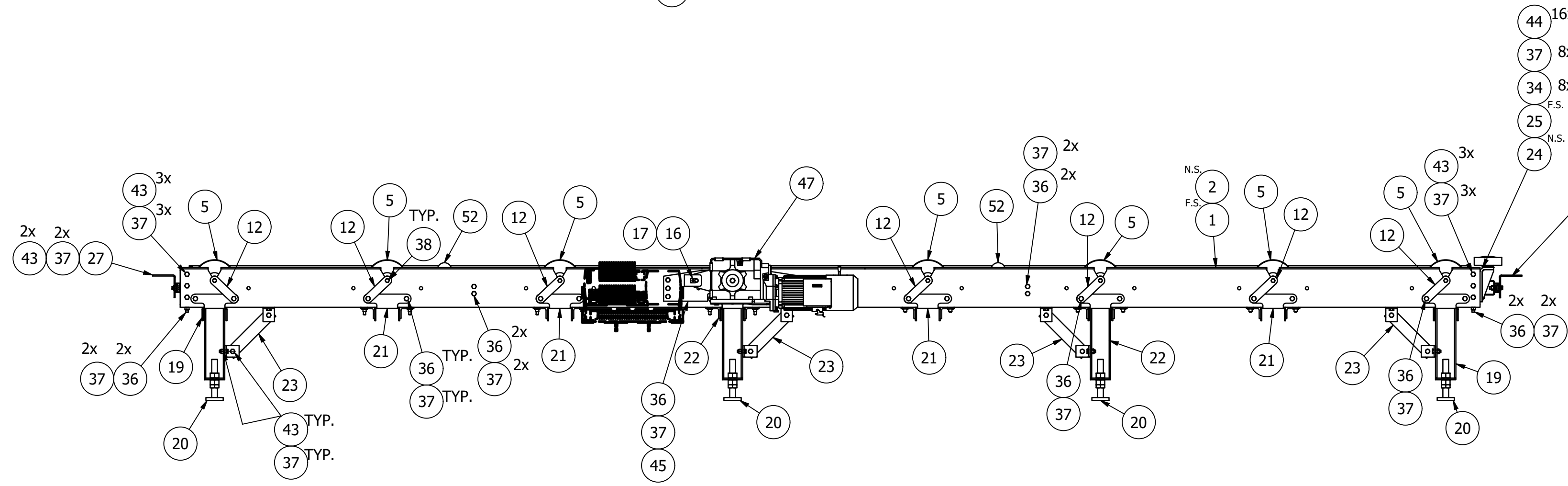
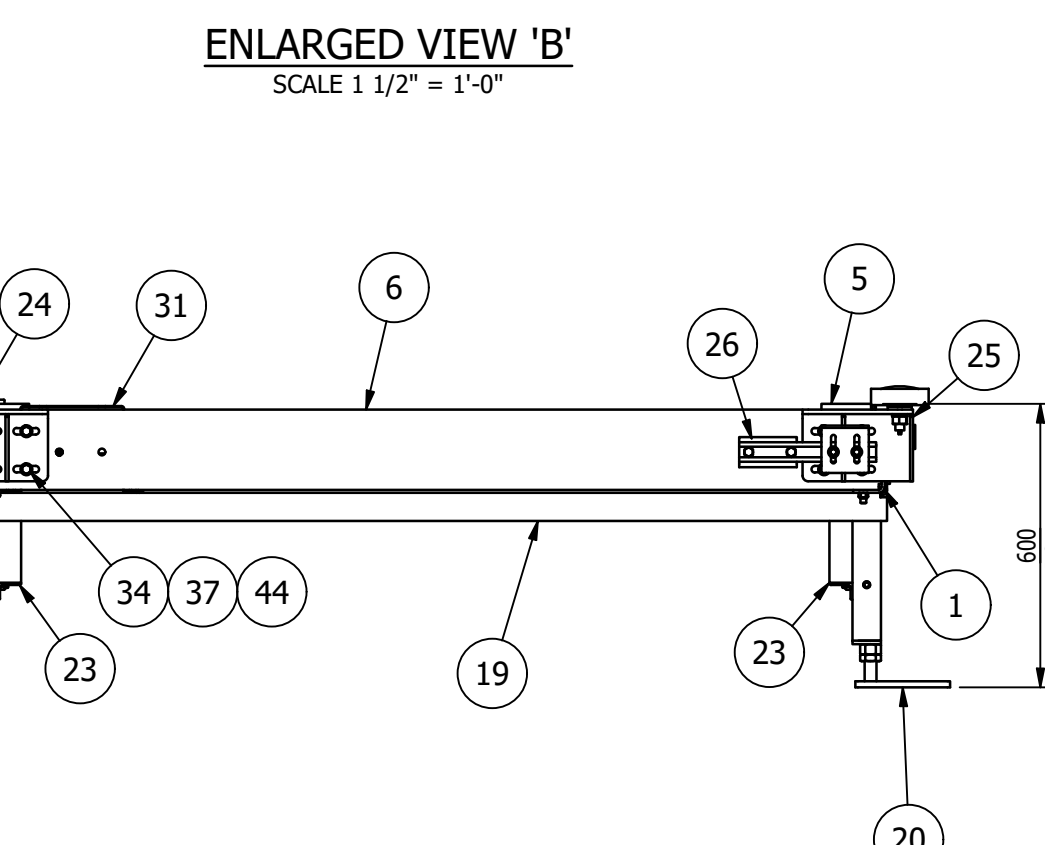
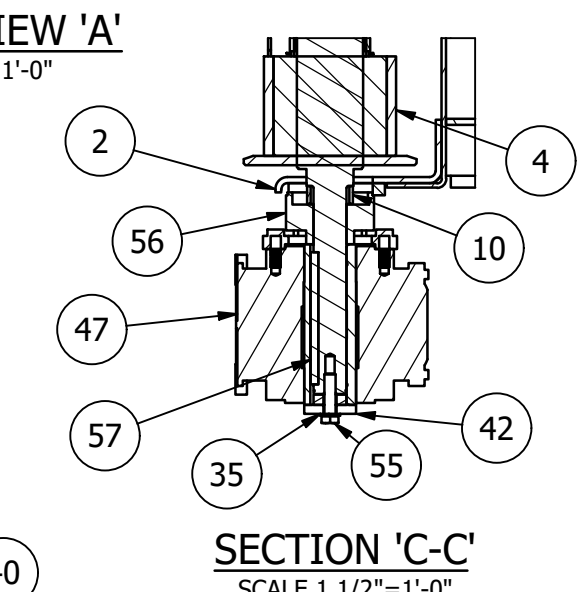
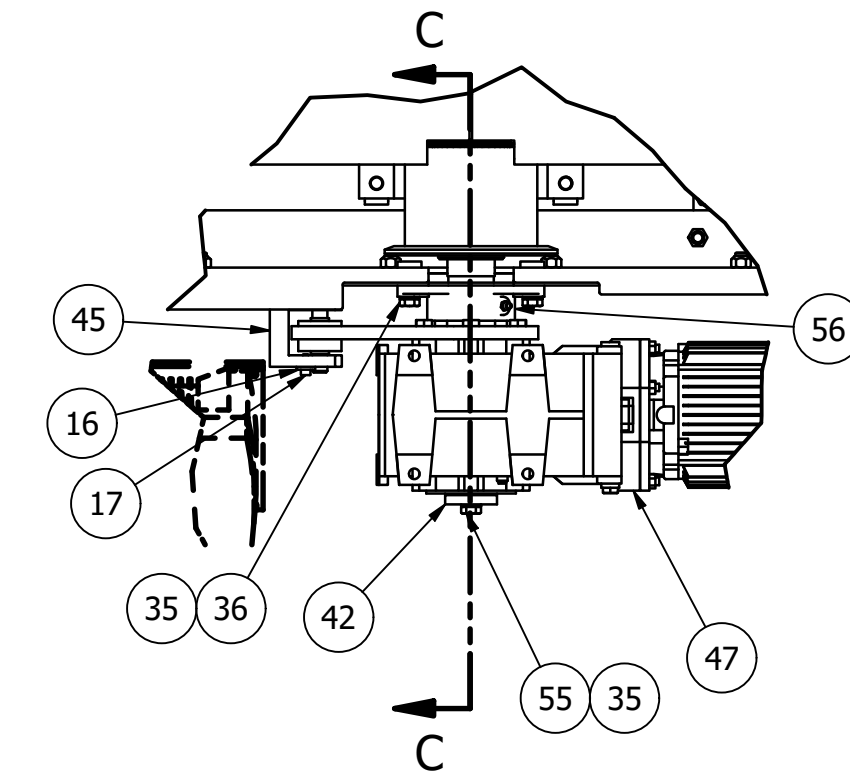
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

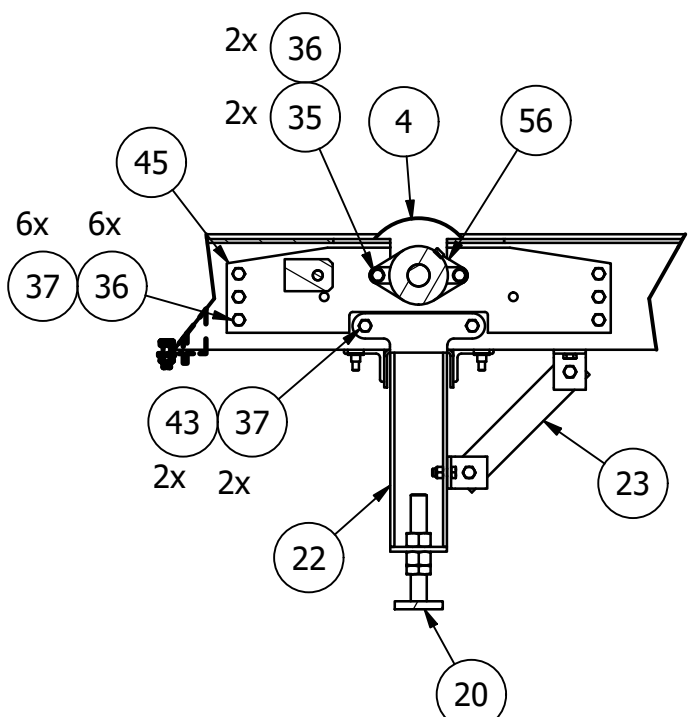


ITEMS '36', '37', '44', '53' ON MK-D003B ONLY



MK-D003A ~ 8 ROLL ASSY (WITHOUT MK-D047A)
MK-D003B ~ 8-ROLL ASSEMBLY (WITH MK-D047A SHOWN)
SCALE 3/4" = 1'-0"

SPEED FORMULA (60HZ):
 $\pi \times 1760 \times \frac{1}{37.18} \times \frac{140}{1000} = 20.8 \text{ m/min} = 68.3 \text{ ft/min}$



- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

MAGNUM CONSULTING
41100 QuakerRoad Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8859
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D003

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D003A			
1	1	MK-D001A ~ 8-ROLL SIDE FRAME ASSY - RH			
2	1	MK-D001B ~ 8 ROLL SIDE FRAME ASSY - LH			
4	1	D140/70x8/35 HTD 8M-55 POWER ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVE ROLL, PART NO. 332306W			
5	7	D140/70/30 Z34 HTD 8M-55 DRIVEN ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVEN ROLL, PART NO. 329A060W			
6	2	MK-D002A ~ END PLATE ASSEMBLY			
7	6	GATES POWERGRIP GT4 BELT, 1800-8M-GT50		2-5	
8	1	GATES POWERGRIP GT4 BELT, 2000-8M-GT50		2-4	
10	1	MK-D005D ~ SHAFT SPACER			
12	14	MK-D005B ~ ROLL KEEPER			
16	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
17	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
18	1	MK-D005C ~ BEARING PLATE			
19	2	MK-D004B ~ LEG ASSEMBLY			
20	8	MK-D007A ~ ADJUSTING SUPPORT			
21	4	MK-D004C ~ CROSS MEMBER WITH GUARD SUPPORT			
22	2	MK-D004D ~ LEG ASSEMBLY WITH GUARD SUPPORT			
23	8	MK-D008A ~ ANGLE BRACE			
24	1	MK-D006C ~ SKID GUIDE ROLLER - LH			
25	1	MK-D006D ~ SKID GUIDE ROLLER - RH			
26	1	MK-D009A ~ PROX BRACKET			
27	1	MK-D009B ~ PROX BRACKET			
29	1	MK-D010A ~ BELT GUARD			
30	1	MK-D010B ~ BELT GUARD			
31	1	MK-D010C ~ BELT GUARD			
33	24	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
34	9	M12x1.75 x 40mm LG. HEX CAP SCREW			
35	5	M12 SPRING LOCK WASHER			
36	51	M12x1.75 x 35mm LG. HEX CAP SCREW			
37	111	M12 x 1.75 STOVER LOCK NUT			
38	38	M10x1.5 x 25mm LG. HEX CAP SCREW			
40	1	MK-D005E ~ SHAFT SPACER			
42	1	MK-D005F ~ MOTOR END PLATE			
43	53	M12x1.75 x 30mm LG. HEX CAP SCREW			
44	16	M12 NARROW FLAT WASHER			
45	1	MK-D005A ~ BEARING PLATE			
46	1	MK-D009D ~ PROX BRACKET			
47	1	SIEMENS RB2 GEARMOTOR (SEE MOTOR DATA LIST)		1-2	
48	1	MK-D009C ~ PROX BRACKET			
49	2	M12x1.75 x 25mm LG. HEX CAP SCREW			
51	2	MK-D005G ~ STATIC WHEEL BRACKET			
52	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
55	1	M12x1.75 x 45mm LG. HEX CAP SCREW			
56	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
57	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	
21		TOTAL WEIGHT ~ 2777.9 lbs			
22					
		MK-D003B			
36	4	M12x1.75 x 35mm LG. HEX CAP SCREW			
37	4	M12 x 1.75 STOVER LOCK NUT			
44	4	M12 NARROW FLAT WASHER			
53	1	MK-D047A ~ CONTROLLER BRACKET			
54	1	MK-D003A ~ 8-ROLL ASSY			
		TOTAL WEIGHT ~ 2823.9 LBS			

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/5/2022	REVISED BALLOONS, DESCRIPTION	
A	MC	8/2/22	FOR FABRICATION	

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

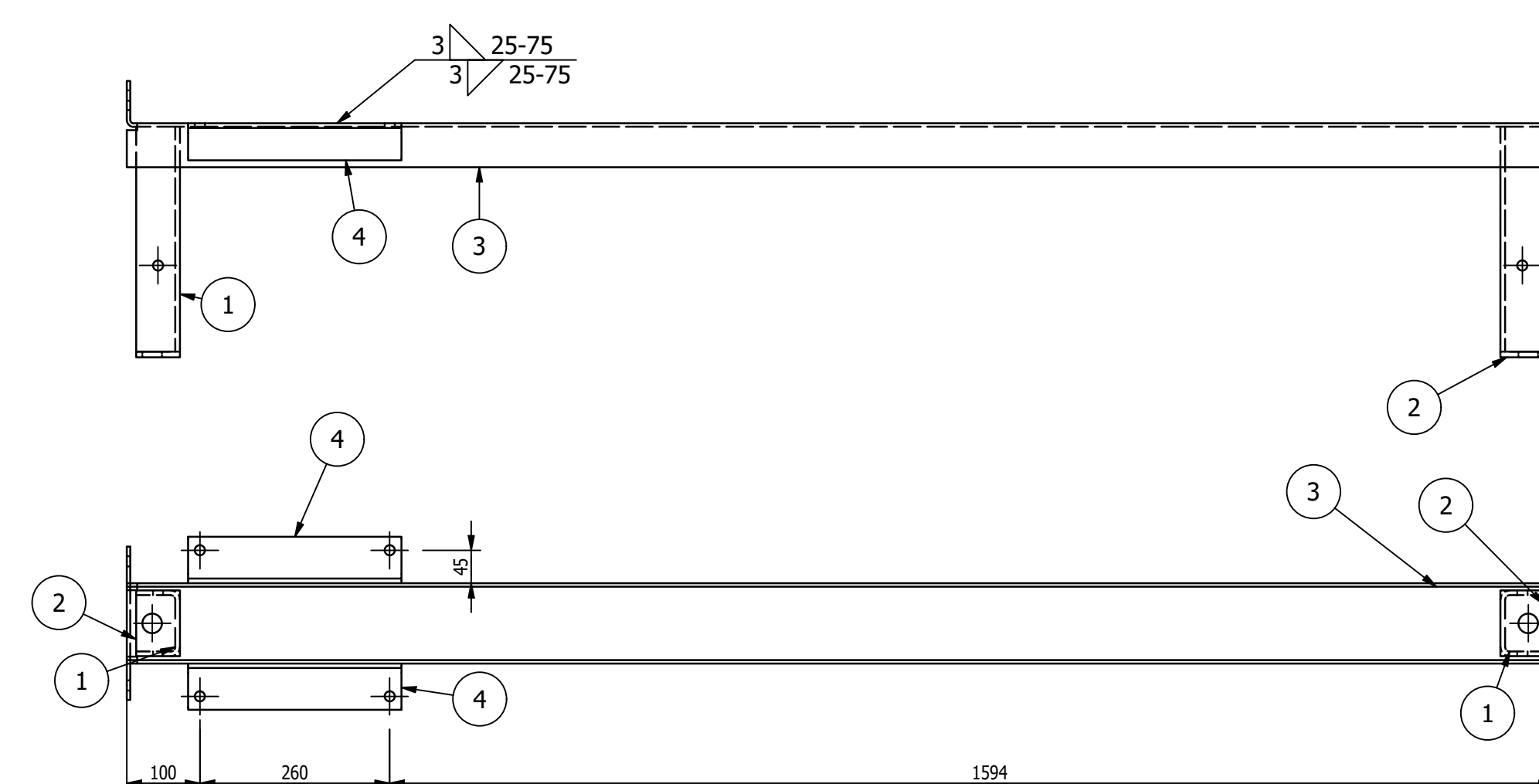
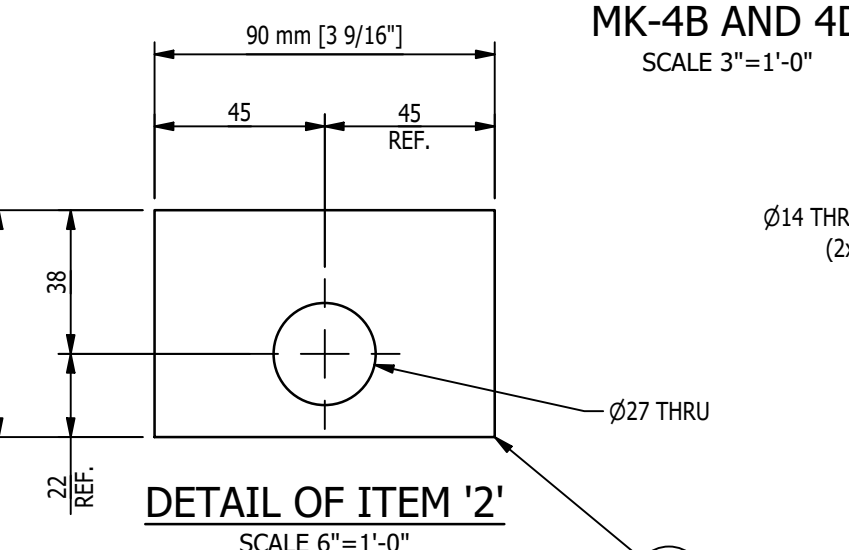
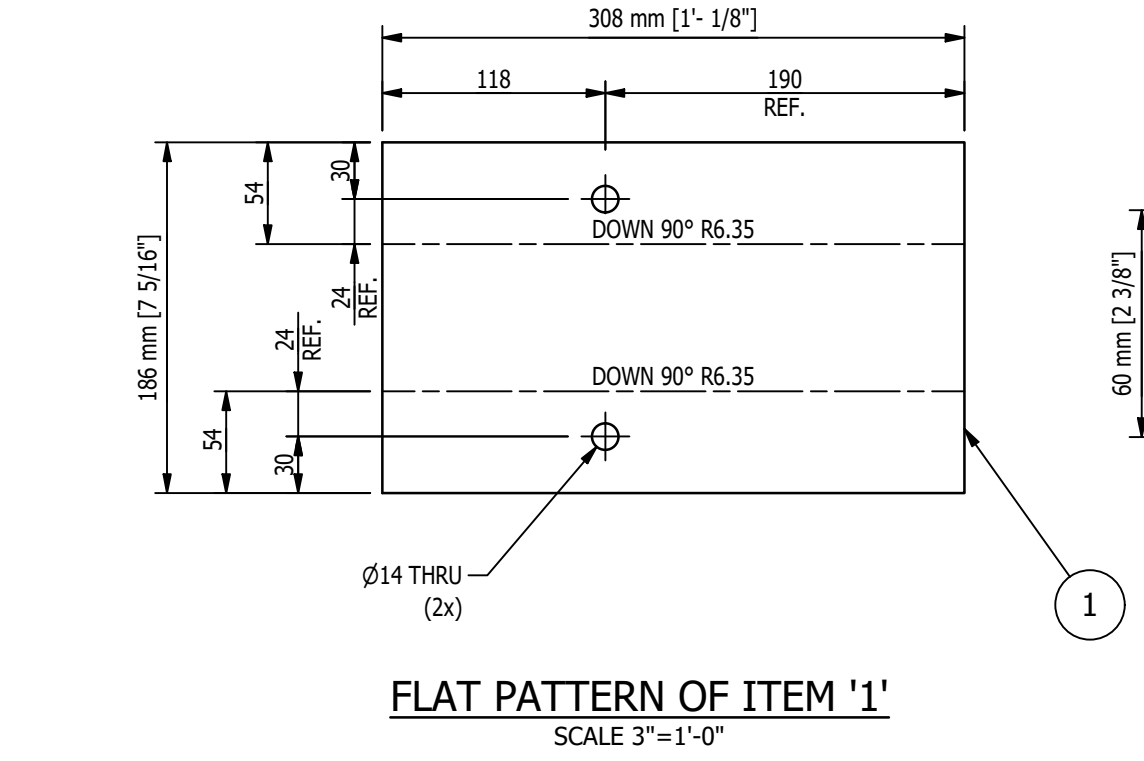
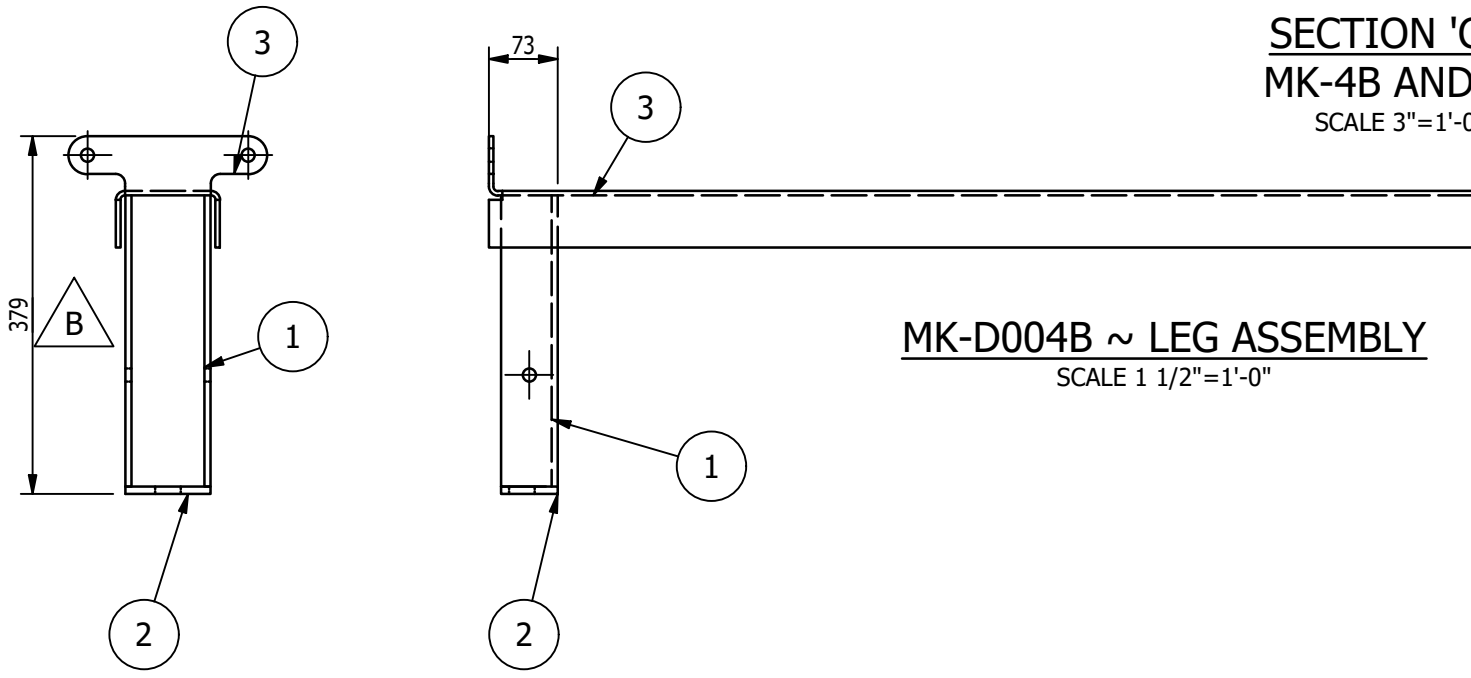
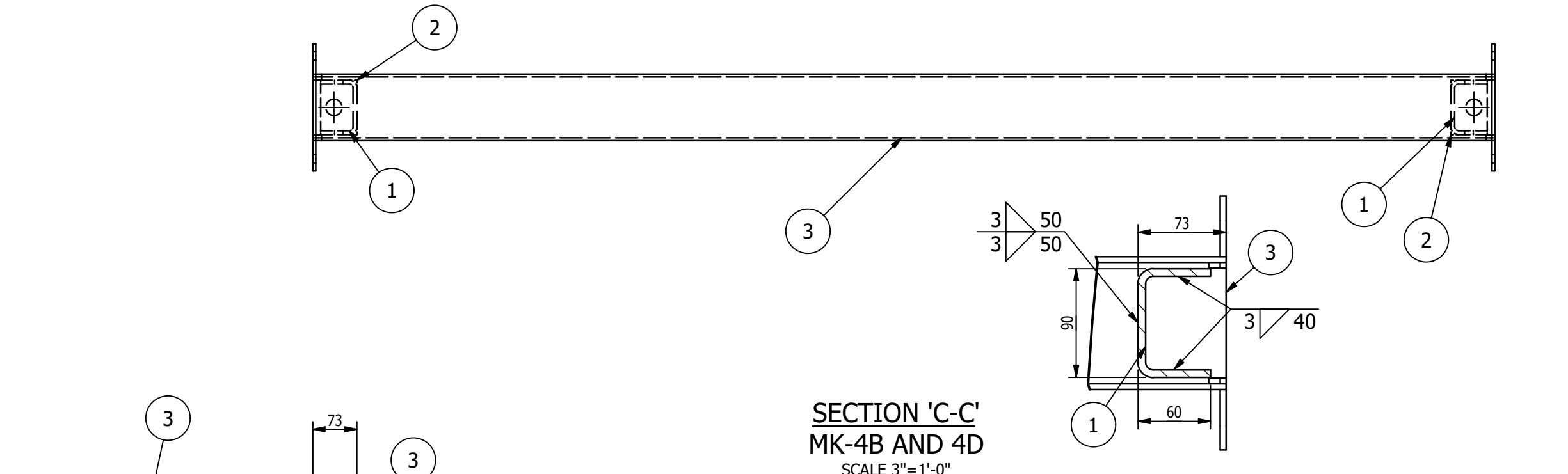
MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.

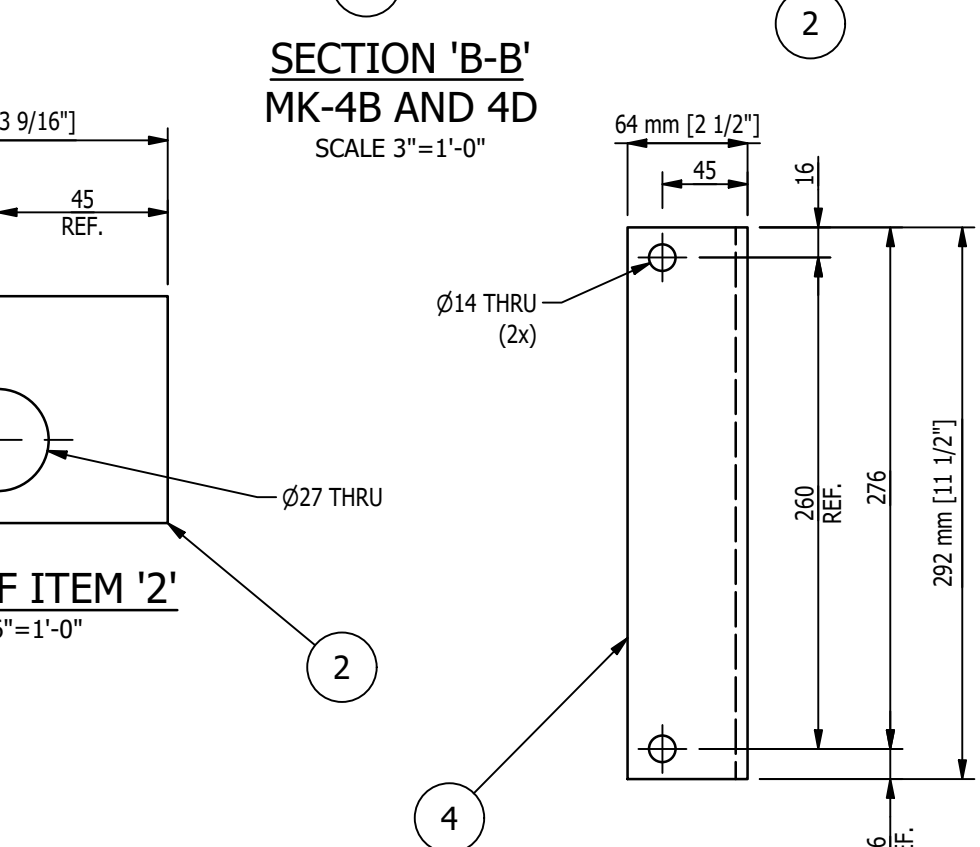
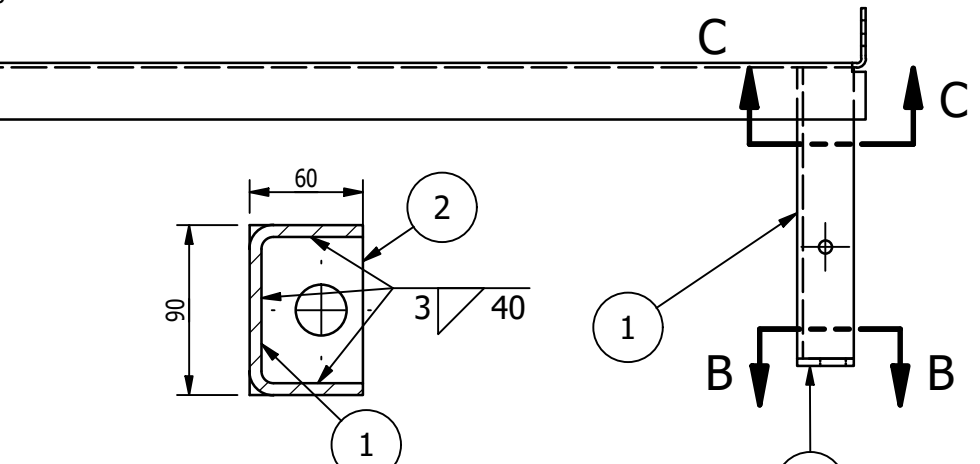
TITLE: P6700 CONVEYORS
CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D003
REV: B
JOB No. 22096

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 5/31/22

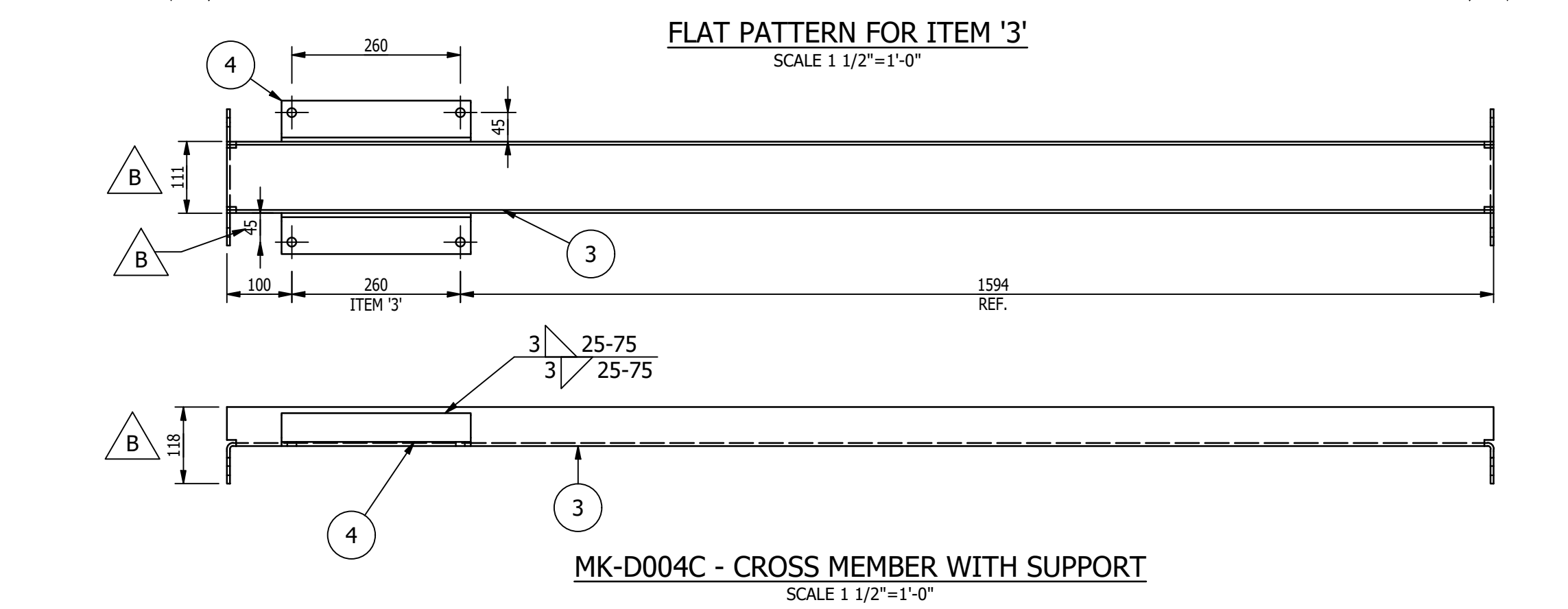
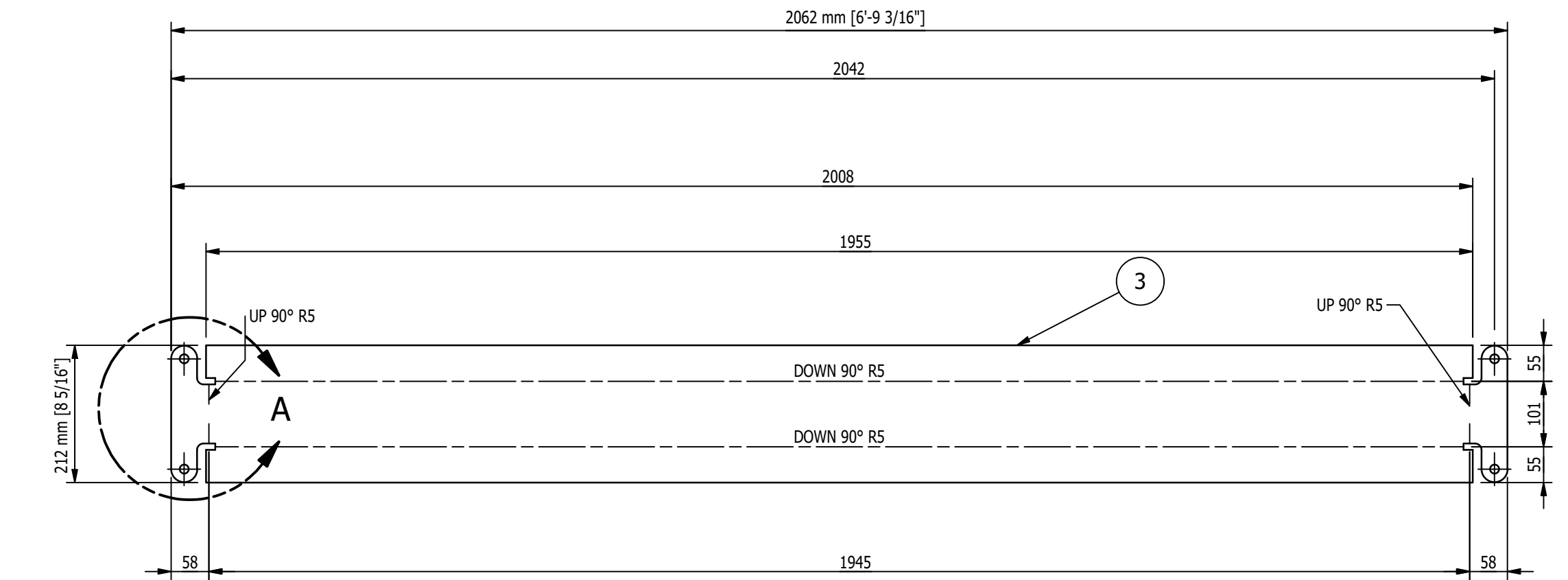
3/20/2022 10:50 AM Drawing/Issues/2022-08-05 Sheet 008 of 04 Rev: 001/1875D003 - REV: B.dwg



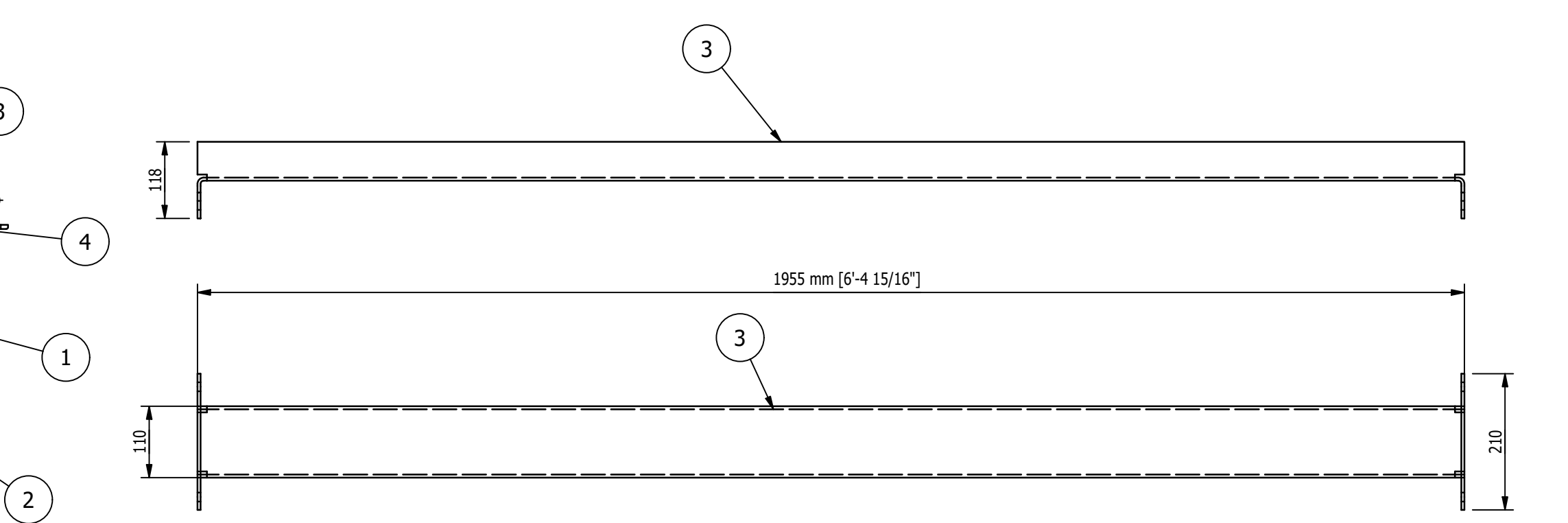
MK-D004D ~ CROSS MEMBER WITH GUARD SUPPORT AND LOCATOR
SCALE 1 1/2"=1'-0"



DETAIL OF ITEM '4'
SCALE 3"=1'-0"

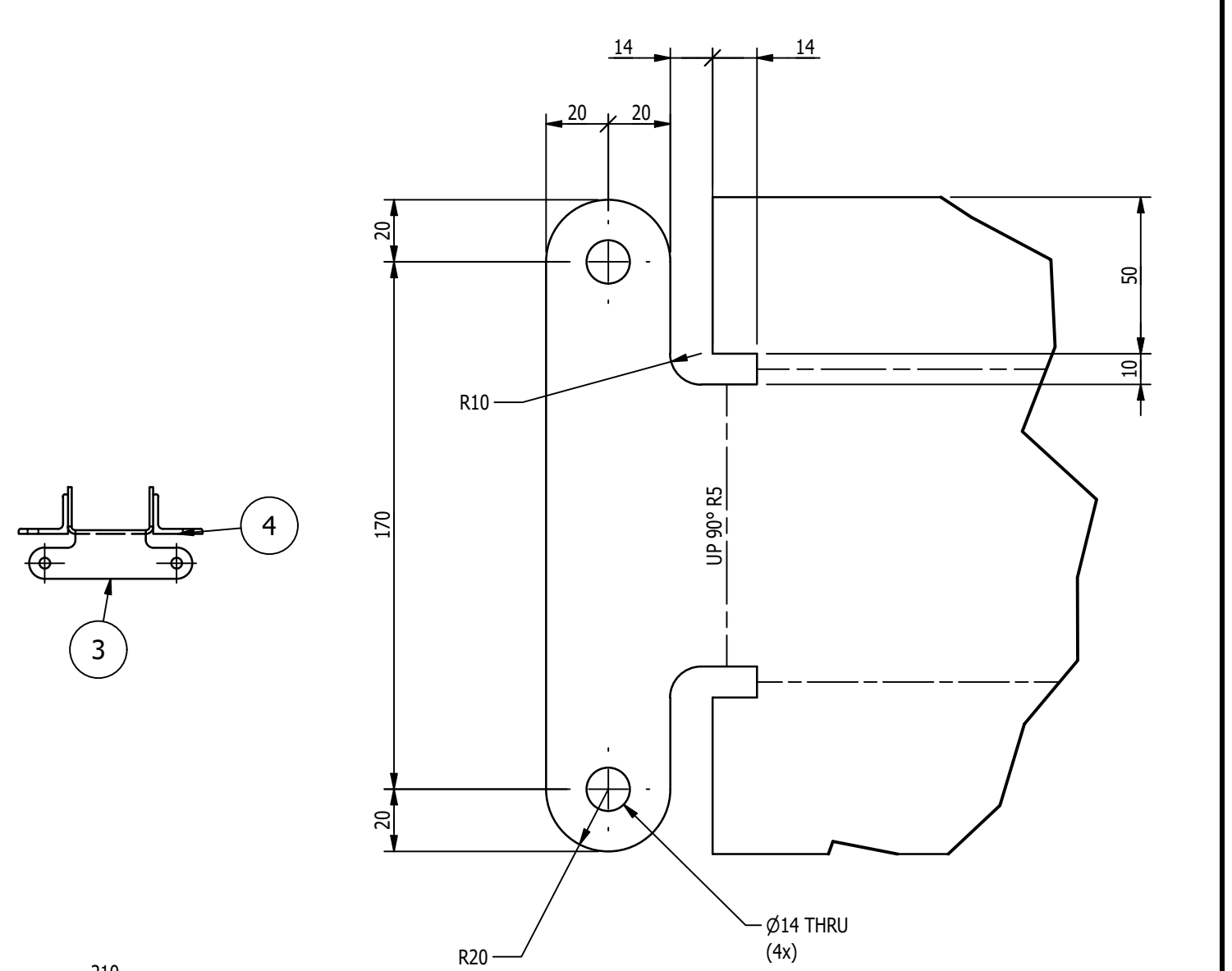


MK-D004C - CROSS MEMBER WITH SUPPORT
SCALE 1 1/2"=1'-0"



MK-D004E ~ CROSS MEMBER
SCALE 1 1/2"=1'-0"

BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D004B		
1	2	BAR 1/4 x 7 5/16	1'- 1/8"	
2	2	BAR 5/16 x 2 3/8	3 9/16"	
3	1	BAR 3/16 x 8 5/16	6'-9 3/16"	
		TOTAL WEIGHT ~ 50 lbs		
		MK-D004C		
3	1	BAR 3/16 x 8 5/16	6'-9 3/16"	
4	2	L 2 1/2 x 2 x 1/4	11 1/2"	
		TOTAL WEIGHT ~ 42.9 lbs		
		MK-D004D		
1	2	BAR 1/4 x 7 5/16	1'- 1/8"	
2	2	BAR 5/16 x 2 3/8	3 9/16"	
3	1	BAR 3/16 x 8 5/16	6'-9 3/16"	
4	2	L 2 1/2 x 2 x 1/4	11 1/2"	
		TOTAL WEIGHT ~ 57 lbs		
		MK-D004E		
3	1	BAR 3/16 x 8 5/16	6'-9 3/16"	
		TOTAL WEIGHT ~ 36 lbs		



ENLARGED VIEW 'A'
SCALE 6"=1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER
- ONE SHOP COAT OF PURE ORANGE RAL 2004
OR
ONE SHOP COAT OF LIGHT GREY RAL 7035

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/4/2022	ADDED DIMS	
A	MC	7/25/022	FOR FABRICATION	

REVISION HISTORY	
	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com
TITLE:	P6700 CONVEYORS CAMPUS BUILDING
CLIENT:	VOLVO
DRAWING No.	1875D004
REV:	B
DRAWN BY:	AH
CHECKED BY:	
DWG DATE:	6/3/22
JOB No.:	22096

MAGNUM Consulting
41100 QuakerRoad Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D004

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

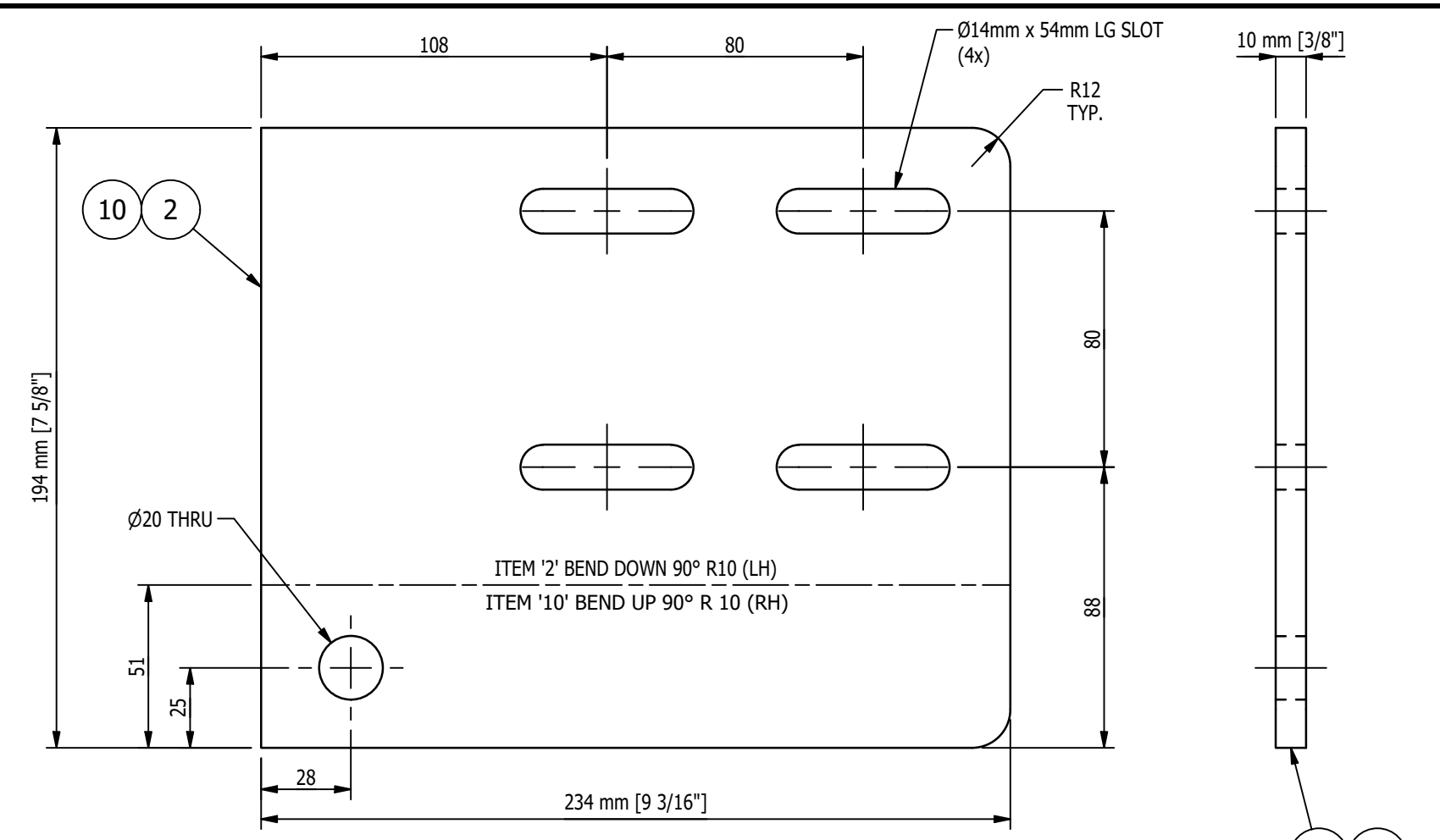
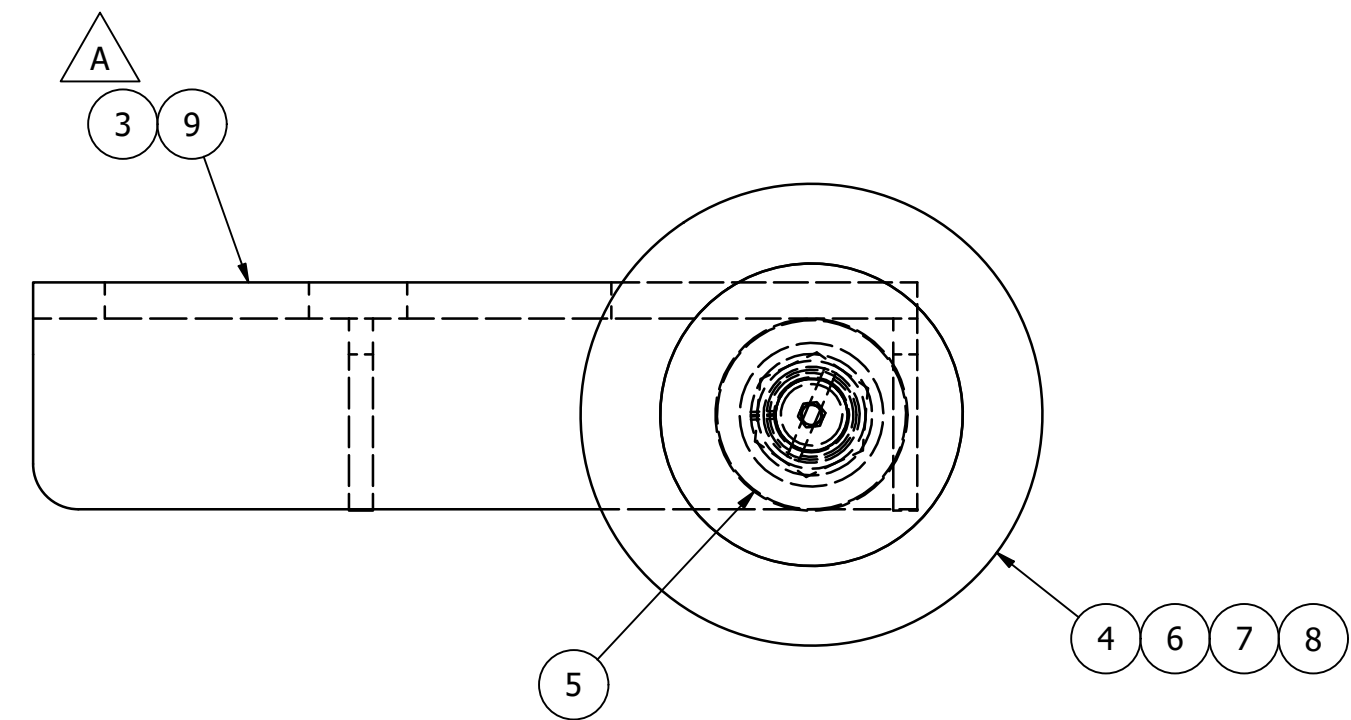
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

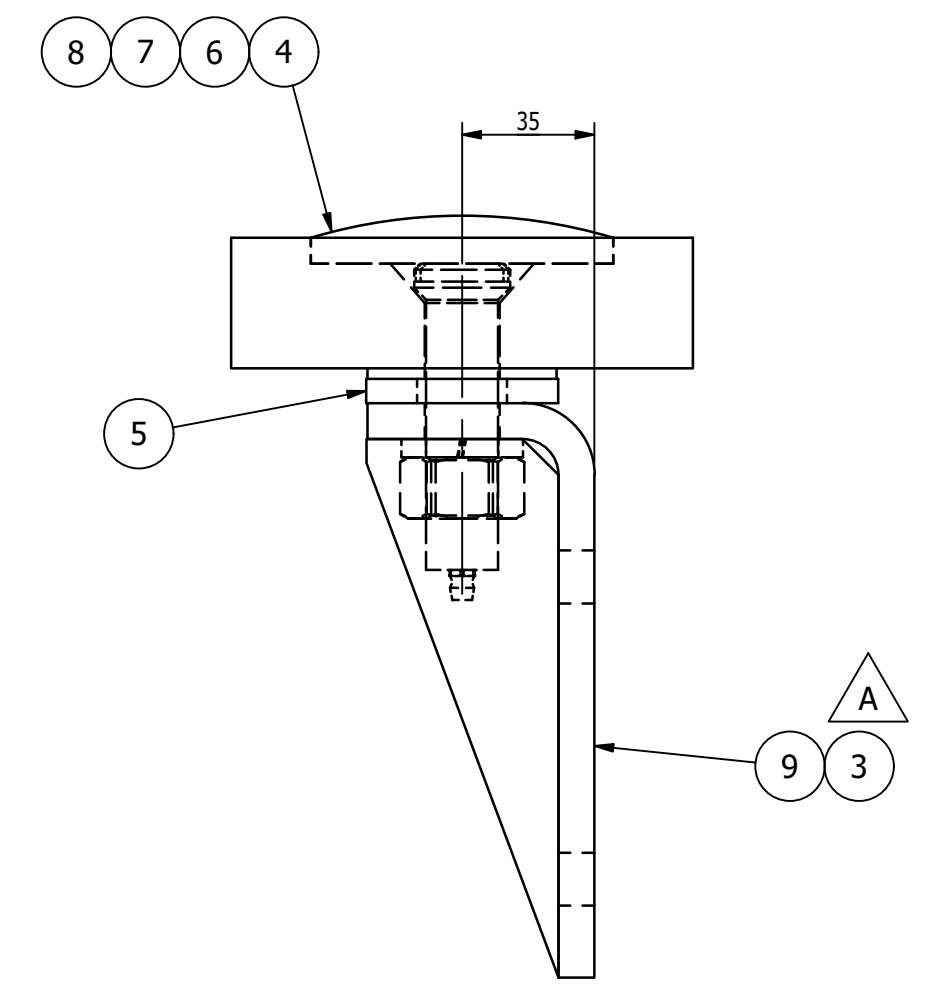
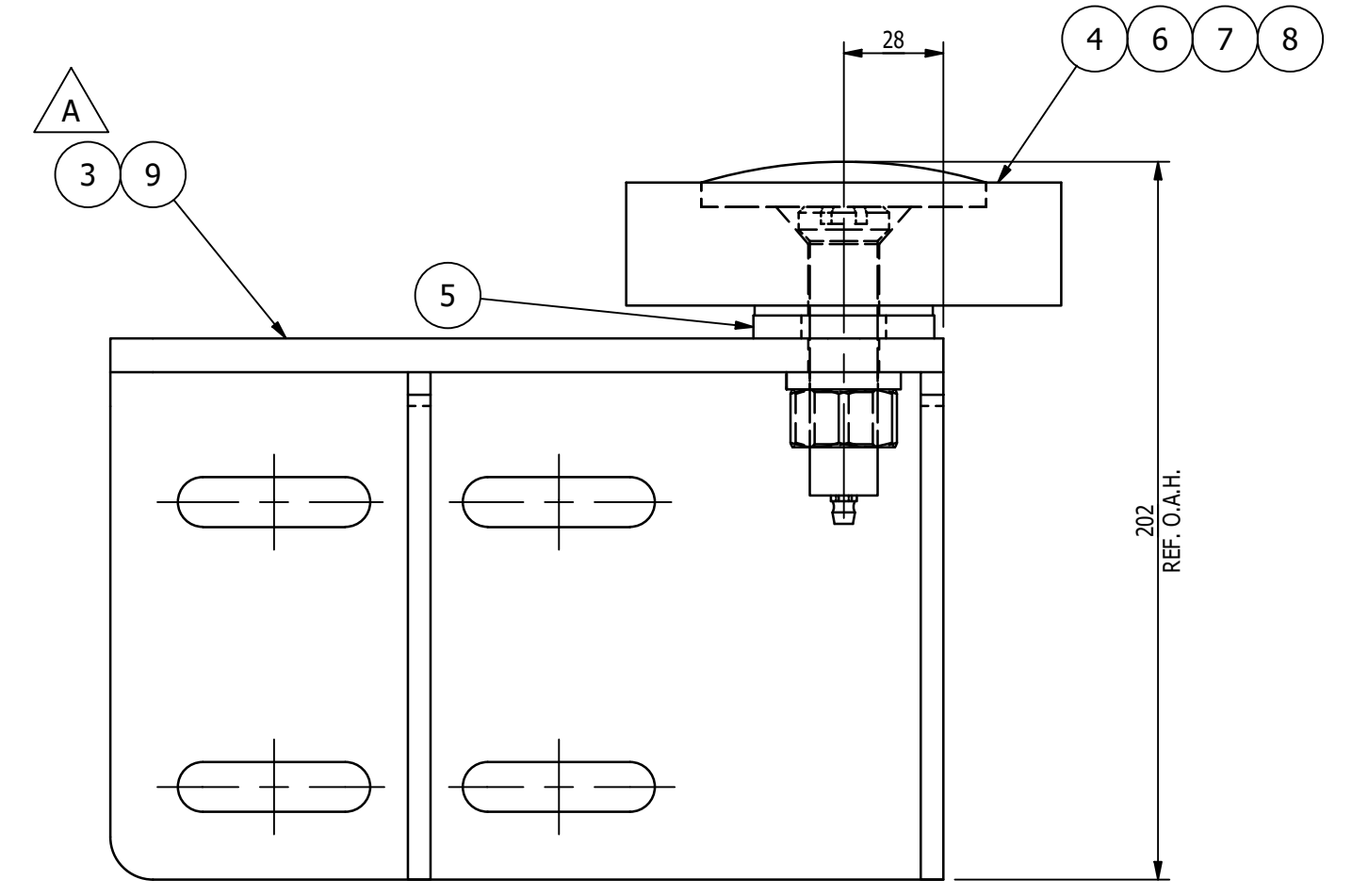
COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

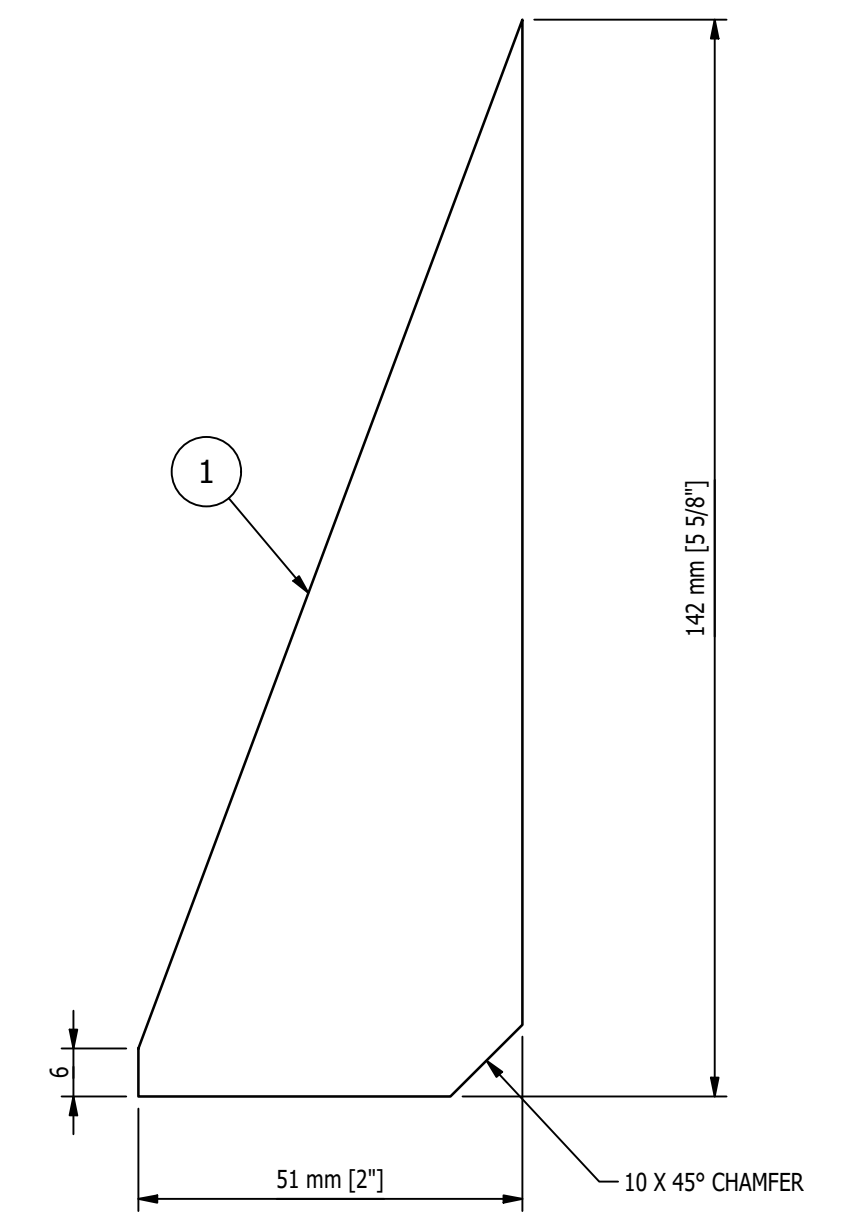
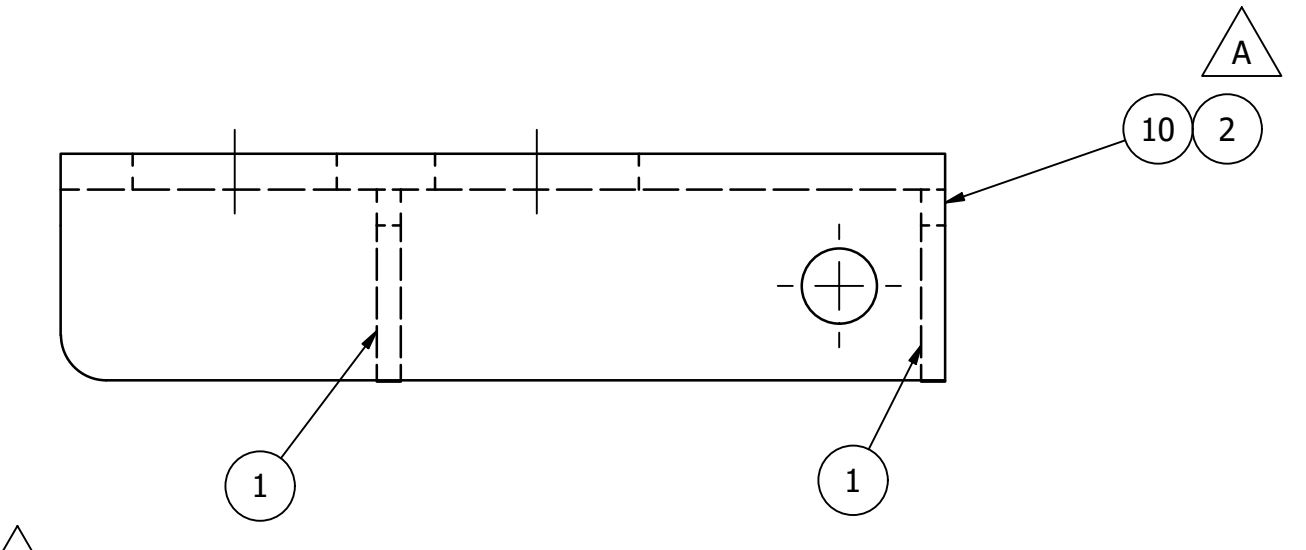
3:00p 1875D004.dwg Drawing/1875D004.dwg 3/22/2022 10:58:44 AM 3/22/2022 10:58:44 AM 3/22/2022 10:58:44 AM 3/22/2022 10:58:44 AM 3/22/2022 10:58:44 AM



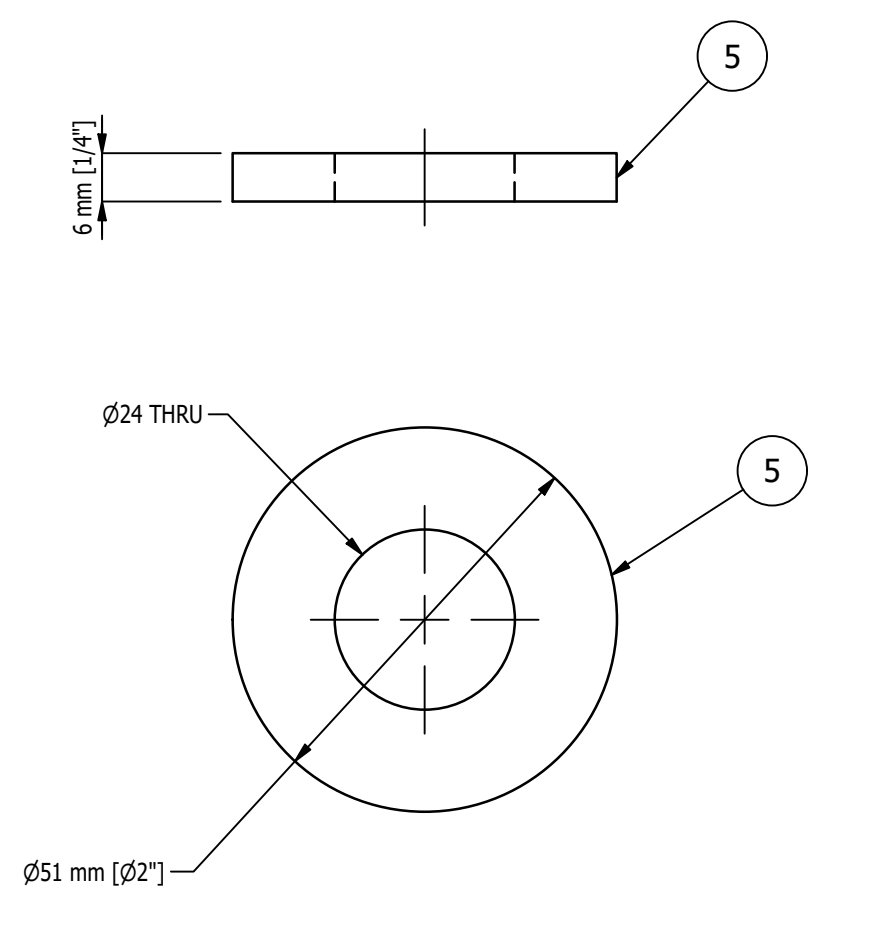
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D006A			
1	2	BAR 1/4 x 2	5 7/8"		
2	1	PL 3/8 x 7 5/8	9 3/16"		
		TOTAL WEIGHT			
		MK-D006B			
1	2	BAR 1/4 x 2	5 5/8"		
10	1	PL 3/8 x 7 5/8	9 3/16"		
		TOTAL WEIGHT ~ 7.9 LBS			
		MK-D006C			
3	1	MK-D006A ~ SKID GUIDE ROLLER BRACKET - LH			
4	1	6" TROLLEY WHEEL W/ WELSH PLUG, FLAT TREAD, FOR 3/4" BOLT, FROST PART NO. 0990300		3-5	
5	1	PL 1/4" X 2"	2"		
6	1	3/4-10UNC HEX NUT			
7	1	3/4 SPRING LOCK WASHER			
8	1	ROLLER TURN BOLT 3/4-16 x 3 3/4" LG, FROST PART NO. 6100405		3-6	
		TOTAL WEIGHT			
		MK-D006D			
4	1	6" TROLLEY WHEEL W/ WELSH PLUG, FLAT TREAD, FOR 3/4" BOLT, FROST PART NO. 0990300		3-5	
5	1	PL 1/4" X 2"	2"		
6	1	3/4-10UNC HEX NUT			
7	1	3/4 SPRING LOCK WASHER			
8	1	ROLLER TURN BOLT 3/4-16 x 3 3/4" LG, FROST PART NO. 6100405		3-6	
9	1	MK-D006B ~ SKID GUIDE ROLLER BRACKET - RH			
		TOTAL WEIGHT ~ 15.8 LBS			



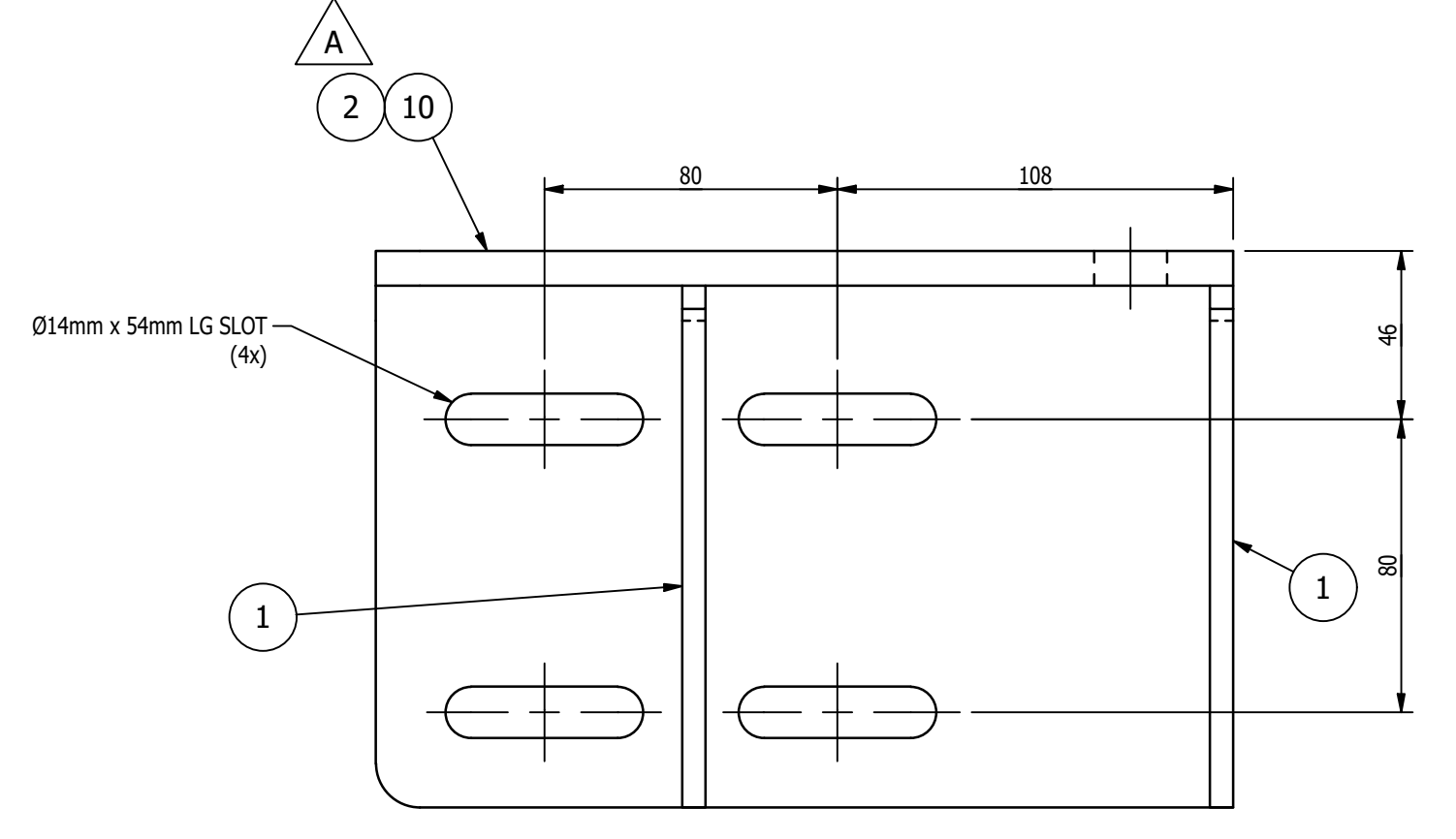
MK-D006D ~ SKID GUIDE ROLLER - RH (SHOWN)
 MK-D006C ~ SKID GUIDE ROLLER - LH (OPPOSITE)
 SCALE 6"=1'-0"



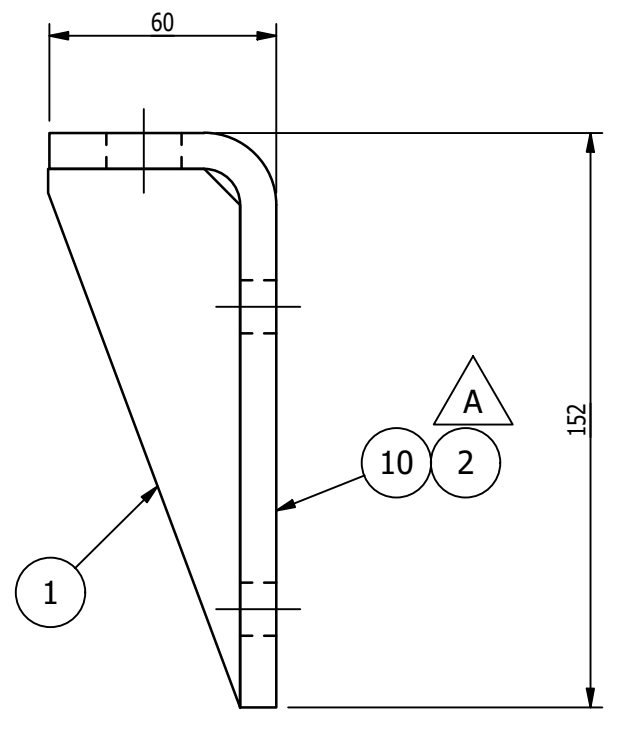
DETAIL OF ITEM '1'
 SCALE 1'-0" = 1'-0"



DETAIL OF ITEM '5'
 SCALE 1'-0" = 1'-0"



MK-D006B ~ SKID GUIDE ROLLER BRACKET - RH (SHOWN)
 MK-D006A ~ SKID GUIDE ROLLER BRACKET - LH (OPPOSITE)
 SCALE 6"=1'-0"



- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
 PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER

ONE SHOP COAT OF PURE ORANGE RAL 2004
 OR
 ONE SHOP COAT OF LIGHT GREY RAL 7035
 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

MAGNUM CONSULTING
 41100 Gardenbrook Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 373-0322
 Fax: (248) 373-0321
 Web: www.millic.com

UNLESS OTHERWISE NOTED:
 X = ±.060
 .XX = ±.030
 .XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
 - ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/3/2022	UPDATED ABM NUMBERS	
A	MC	7/27/2022	UPDATED PAINT NOTES; UPDATED BOM ITEMS	
0	MC	7/19/2022	FOR FABRICATION	

REVISION HISTORY

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D006

REV: B

JOB No: 22096

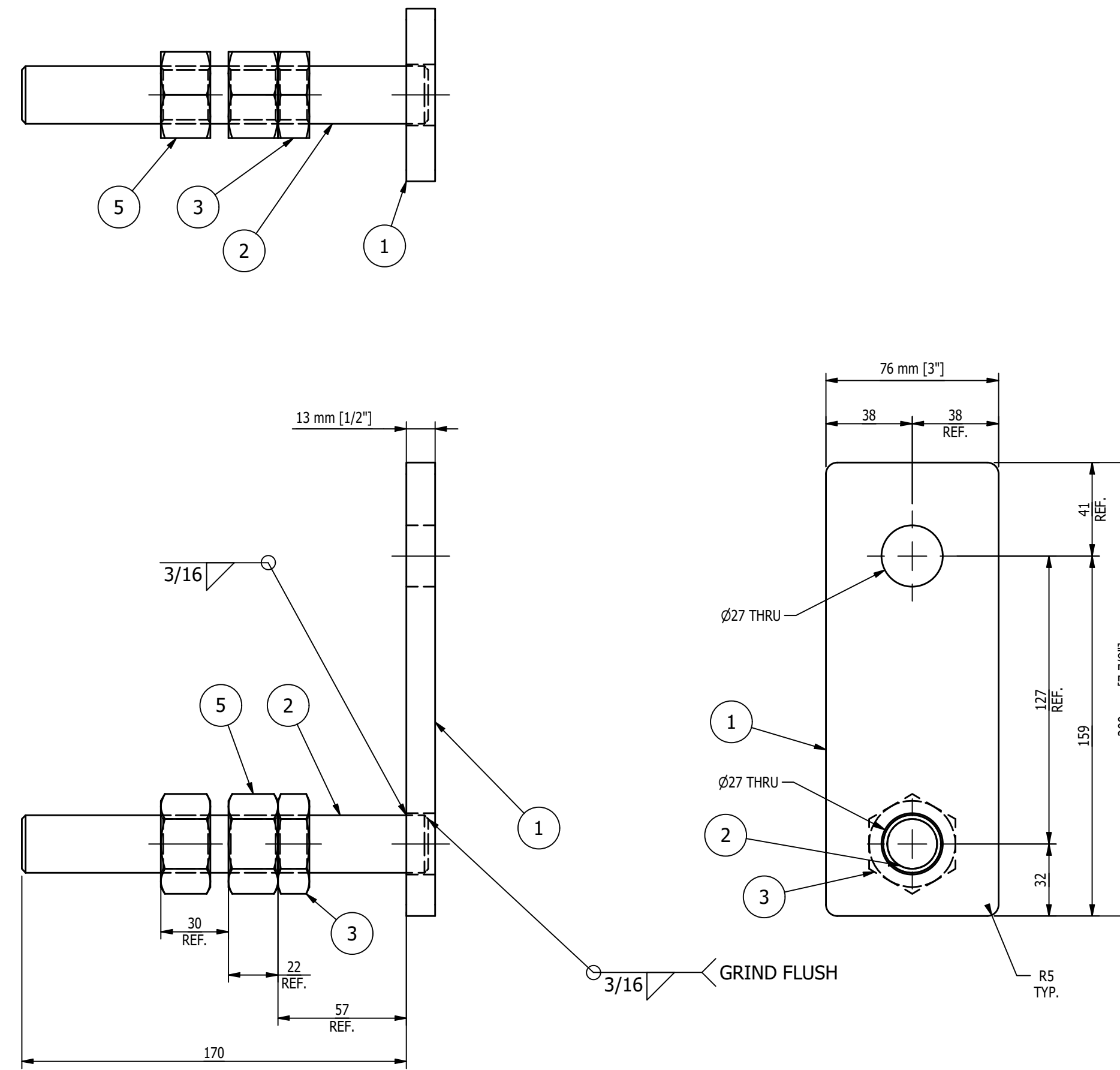
DRAWN BY: RJB

CHECKED BY: CW

DWG DATE: 6/13/22

PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.

BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D007A		
1	1	BAR 1/2 x 3	7 7/8"	
2	1	THD. ROD 1-8UNC	7 1/16"	
3	1	1-8UNC HEX JAM NUT		
5	2	1-8UNC HEX NUT		
TOTAL WEIGHT ~ 5.5 LBS				



MK-D007A ~ ADJUSTING SUPPORT
SCALE 6"=1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- A PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS
OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/27/2022	UPDATED PAINT NOTES	
0	MC	7/19/2022	FOR FABRICATION	

REVISION HISTORY					
TITLE:		P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY:	AH
CLIENT:		VOLVO		CHECKED BY:	CW
DRAWING No.		1875D007		DWG DATE:	6/6/22
REV:		A		JOB No:	22096

MAGNUM CONSULTING
41100 QuakerRoad Rd.
Suite 125
North, MI 48175
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D007

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

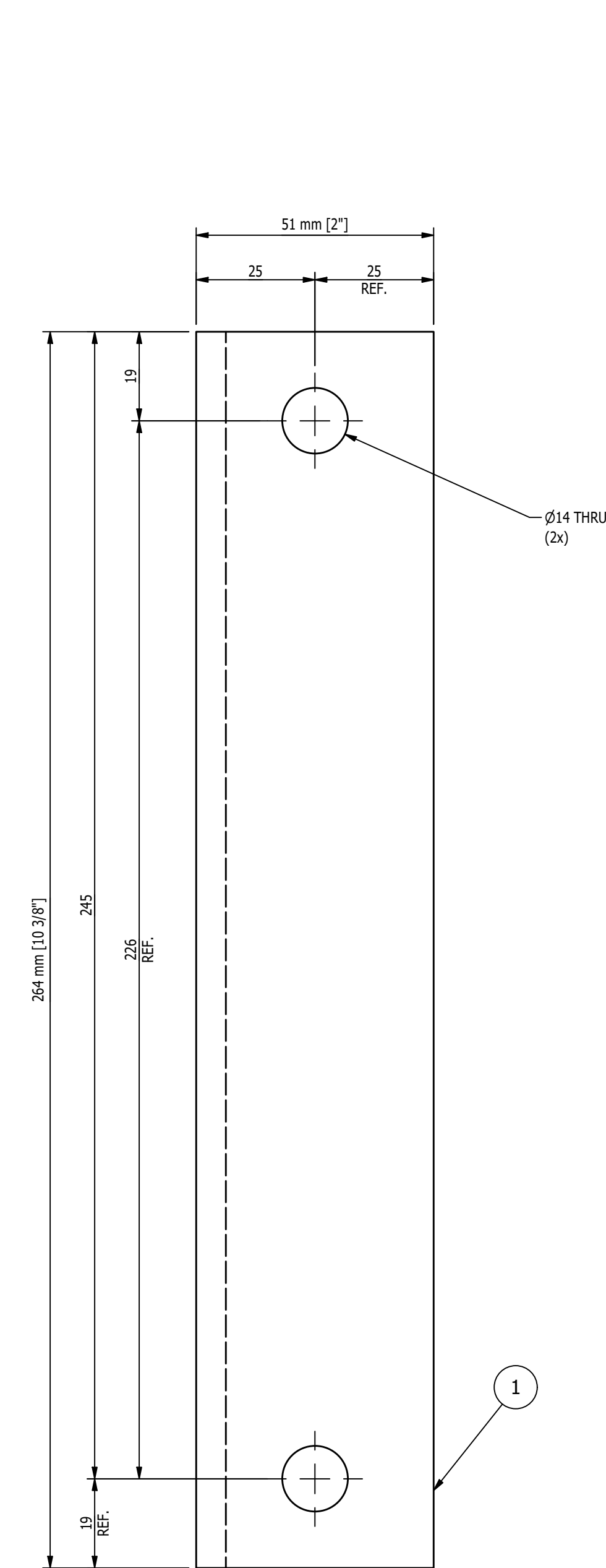
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

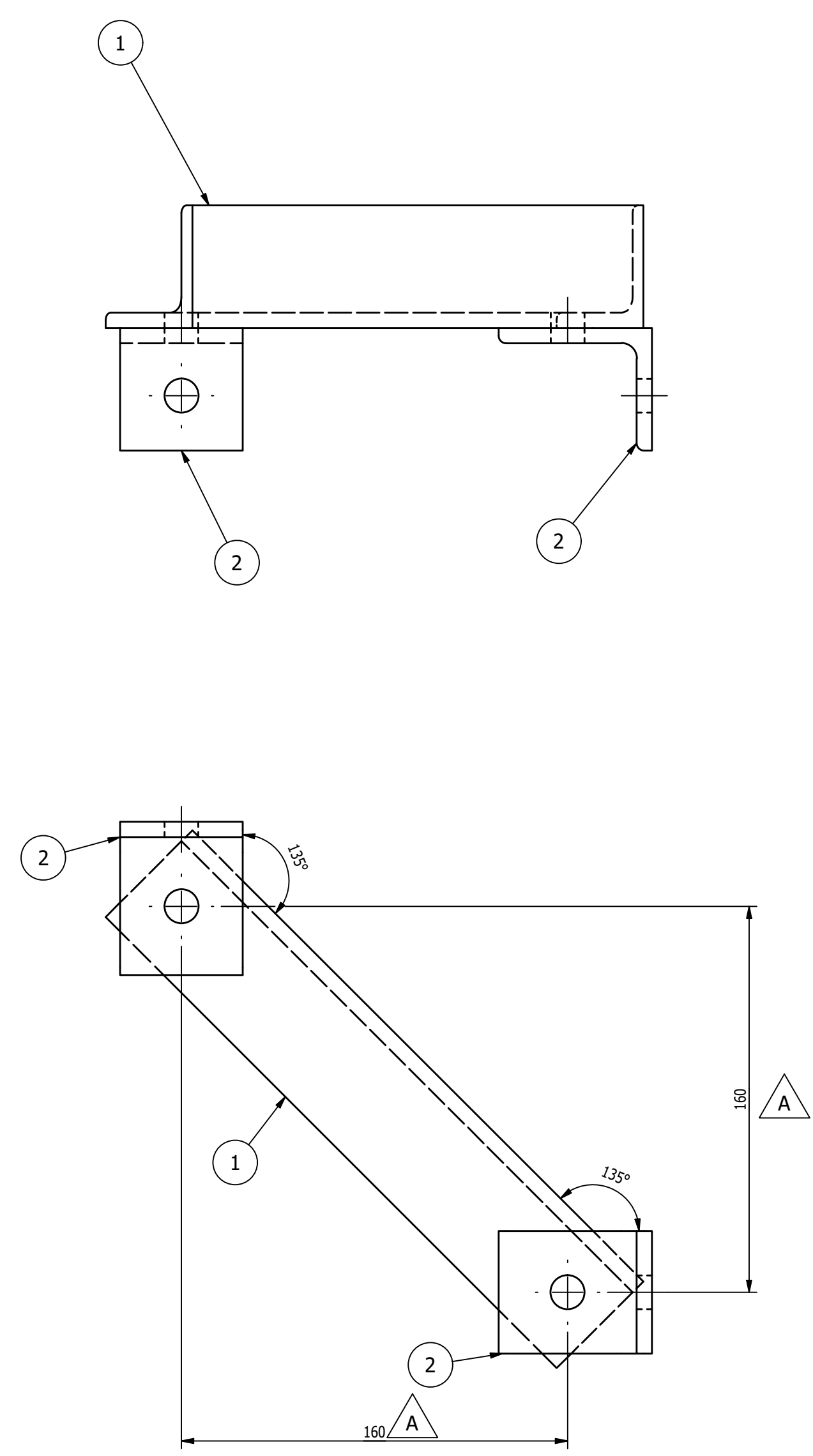
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.

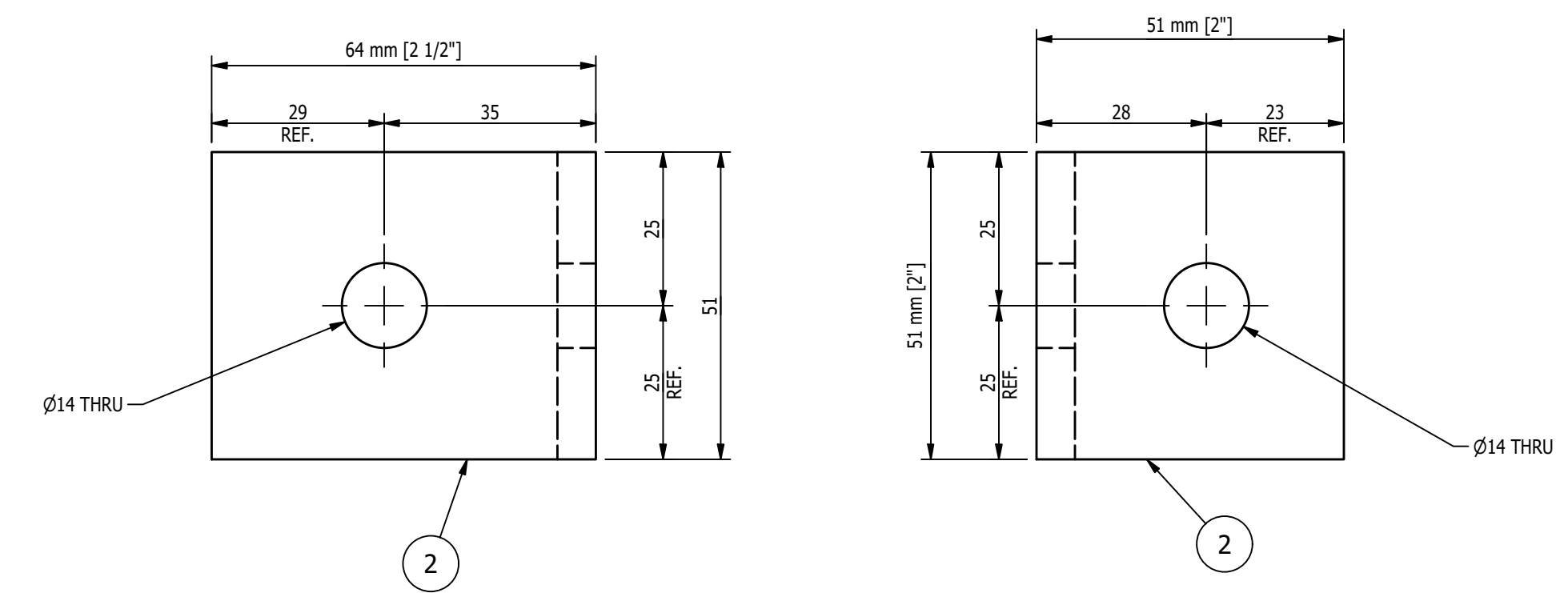
BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D008A		
1	1	L 2 x 2 x 1/4	10 3/8"	
2	2	L 2 1/2 x 2 x 1/4	2"	
TOTAL WEIGHT ~ 3.9 LBS.				



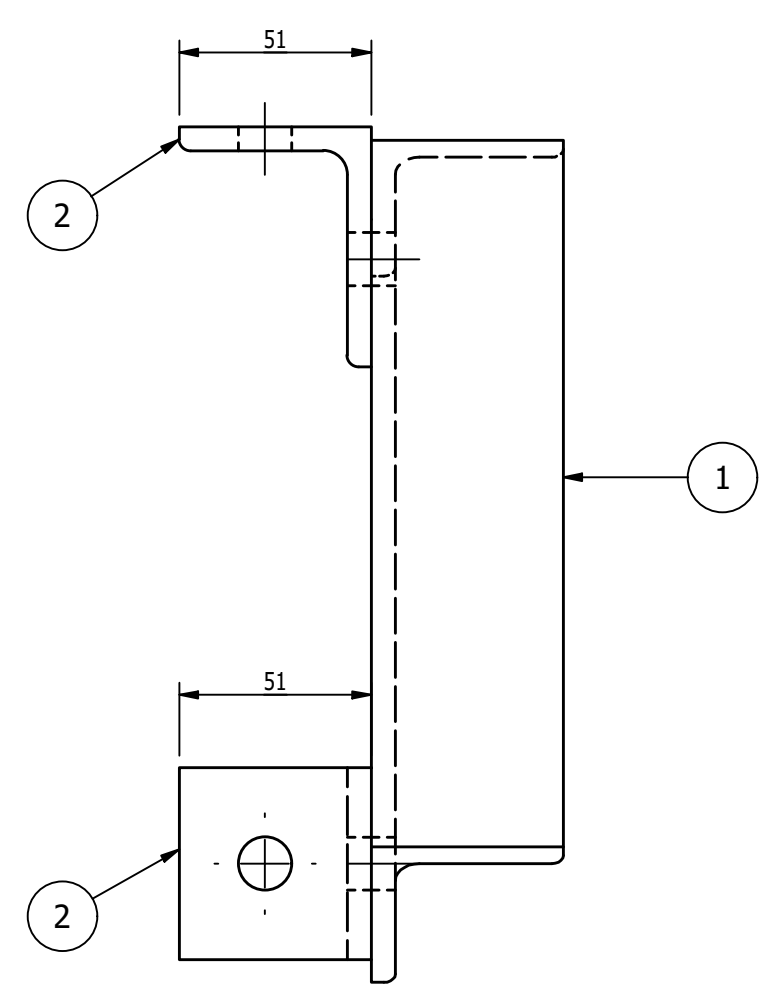
DETAIL OF ITEM '1'
SCALE 1'-0" = 1'-0"



MK-D008A ~ ANGLE BRACE
SCALE 6"=1'-0"



DETAIL OF ITEM '2'
SCALE 1'-0" = 1'-0"



- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER

ONE SHOP COAT OF PURE ORANGE RAL 2004
OR
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/27/2022	REVISED PAINT NOTES; ADDED DIMENSIONS	
0	MC	7/19/2022	FOR FABRICATION	

REVISION HISTORY				
		MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: AH		CHECKED BY: CW
CLIENT: VOLVO		DWG DATE: 6/6/22		JOB No.: 22096
DRAWING No.: 1875D008		REV: A		JOB No.: 22096

MAGNUM CONSULTING
 41700 QuakerRoad Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8821
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D008

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

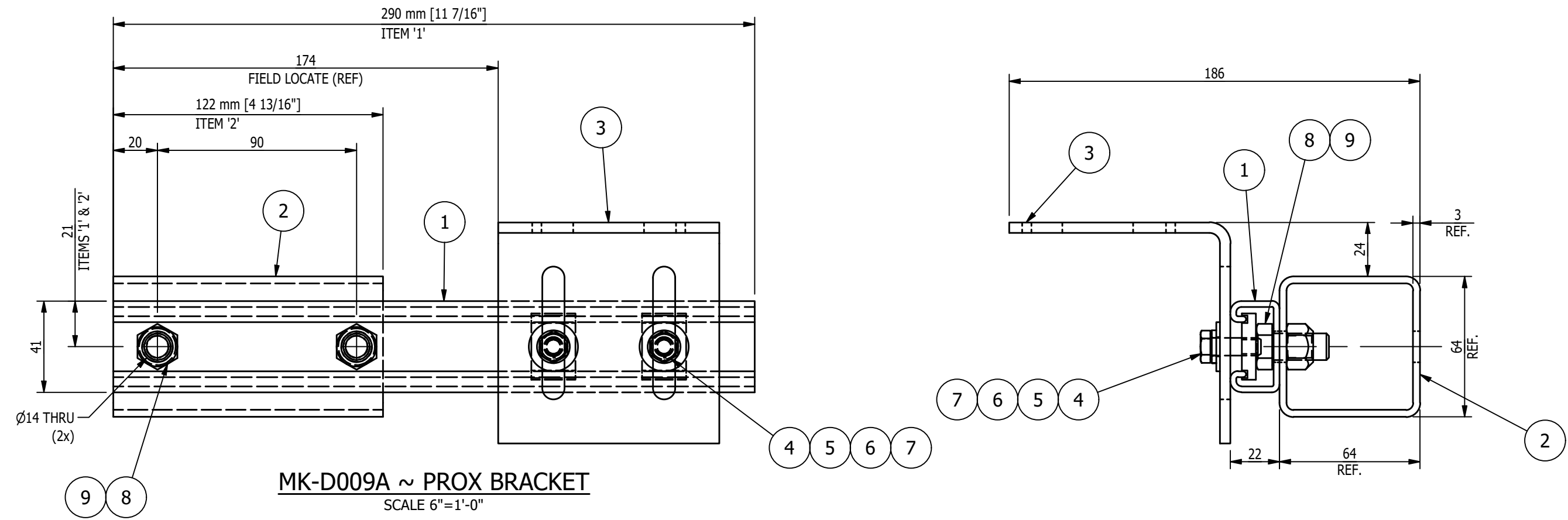
MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

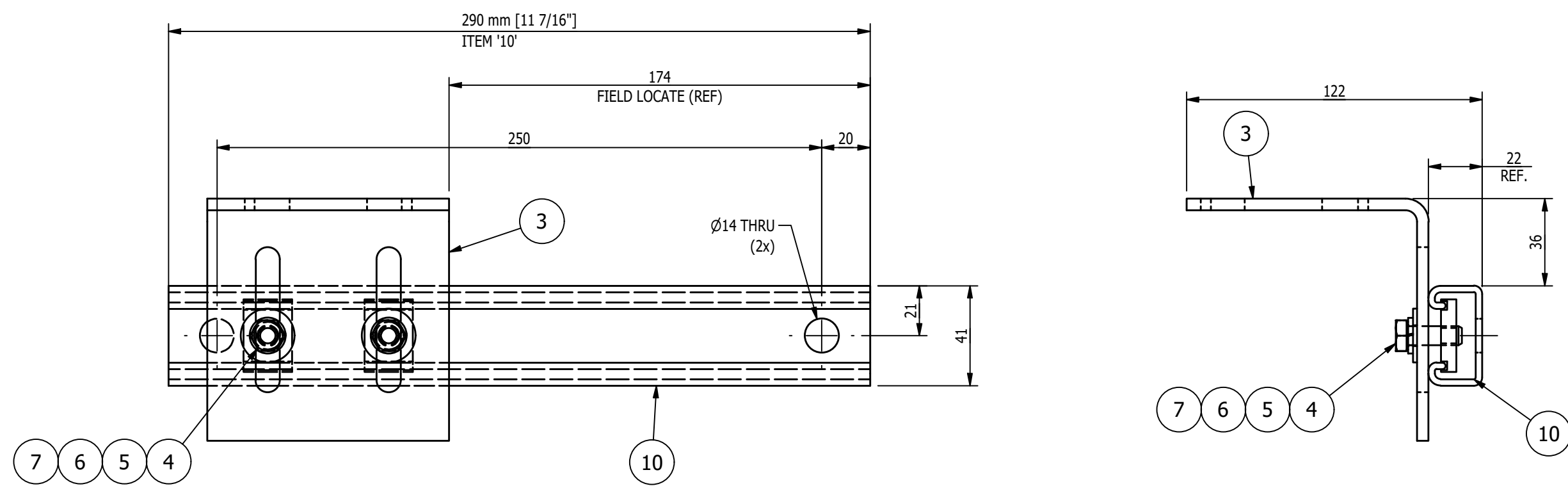
WELDS:
 - ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

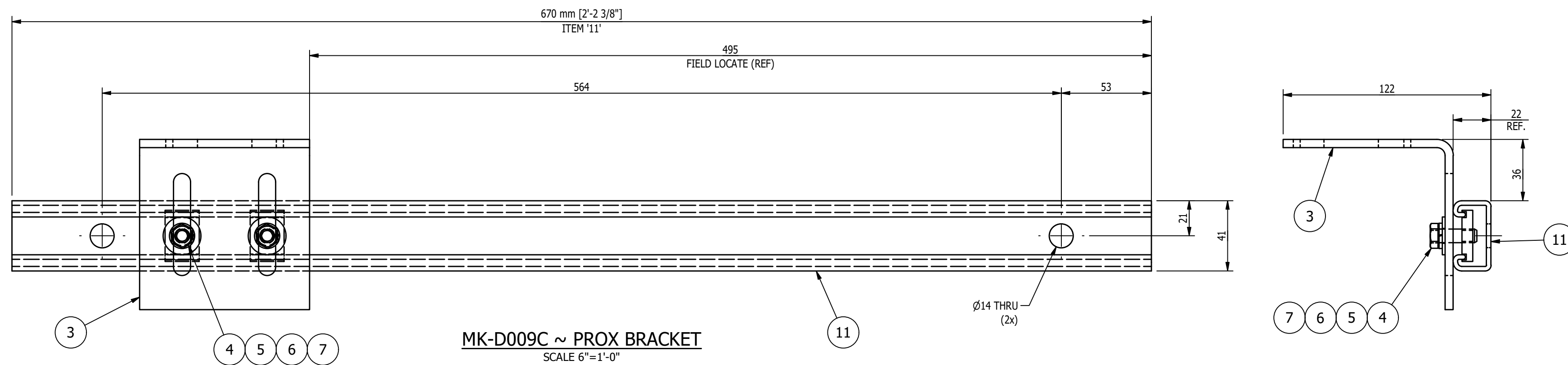
COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



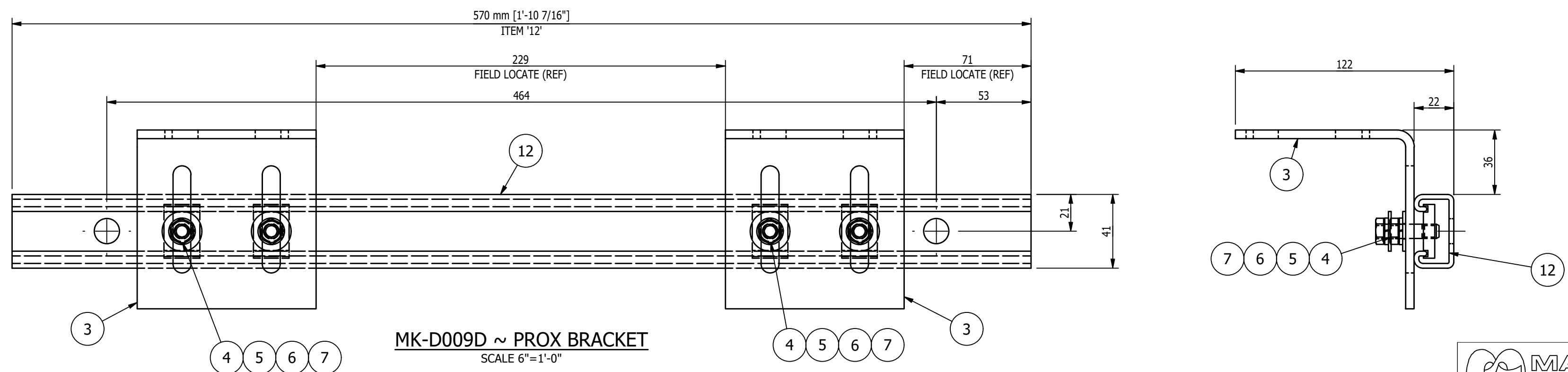
MK-D009A ~ PROX BRACKET
SCALE 6"=1'-0"



MK-D009B ~ PROX BRACKET
SCALE 6"=1'-0"



MK-D009C ~ PROX BRACKET
SCALE 6"=1'-0"



MK-D009D ~ PROX BRACKET
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D009A			
1	1	UNISTRUT P3300 PL	11 7/16"		
2	1	HSS 2 1/2 x 2 1/2 x 1/8	4 13/16"		
3	1	MK-D034A ~ PROX BRACKET			
4	2	5/16-18UNC x 7/8" LG. HEX HEAD CAP SCREW			
5	2	5/16 SPRING LOCK WASHER			
6	2	5/16 TYPE B REGULAR FLAT WASHER			
7	2	CHANNEL NUT FOR 5/16"-18, UNISTRUT P3007			
8	2	M12 x 1.75 STOVER LOCK NUT			
9	2	M12x1.75 x 25mm LG. HEX CAP SCREW			
		TOTAL WEIGHT ~ 4.7 LBS			
		MK-D009B			
3	1	MK-D034A ~ PROX BRACKET			
4	2	5/16-18UNC x 7/8" LG. HEX HEAD CAP SCREW			
5	2	5/16 SPRING LOCK WASHER			
6	2	5/16 TYPE B REGULAR FLAT WASHER			
7	2	CHANNEL NUT FOR 5/16"-18, UNISTRUT P3007			
10	1	UNISTRUT P3300 PL	11 7/16"		
		TOTAL WEIGHT ~ 2.9 LBS			
		MK-D009C			
3	1	MK-D034A ~ PROX BRACKET			
4	2	5/16-18UNC x 7/8" LG. HEX HEAD CAP SCREW			
5	2	5/16 SPRING LOCK WASHER			
6	2	5/16 TYPE B REGULAR FLAT WASHER			
7	2	CHANNEL NUT FOR 5/16"-18, UNISTRUT P3007			
11	1	UNISTRUT P3300 PL	2'-2 3/8"		
		TOTAL WEIGHT ~ 4.6 LBS			
		MK-D009D			
3	2	MK-D034A ~ PROX BRACKET			
4	4	5/16-18UNC x 7/8" LG. HEX HEAD CAP SCREW			
5	4	5/16 SPRING LOCK WASHER			
6	4	5/16 TYPE B REGULAR FLAT WASHER			
7	4	CHANNEL NUT FOR 5/16"-18, UNISTRUT P3007			
12	1	UNISTRUT P3300 PL	1'-10 7/16"		
		TOTAL WEIGHT ~ 5.7 LBS			

SHOP NOTES:
 1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.
PAINT NOTES:
 PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER
 ONE SHOP COAT OF PURE ORANGE RAL 2004
 OR
 ONE SHOP COAT OF LIGHT GREY RAL 7035

GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
 WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)
 PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

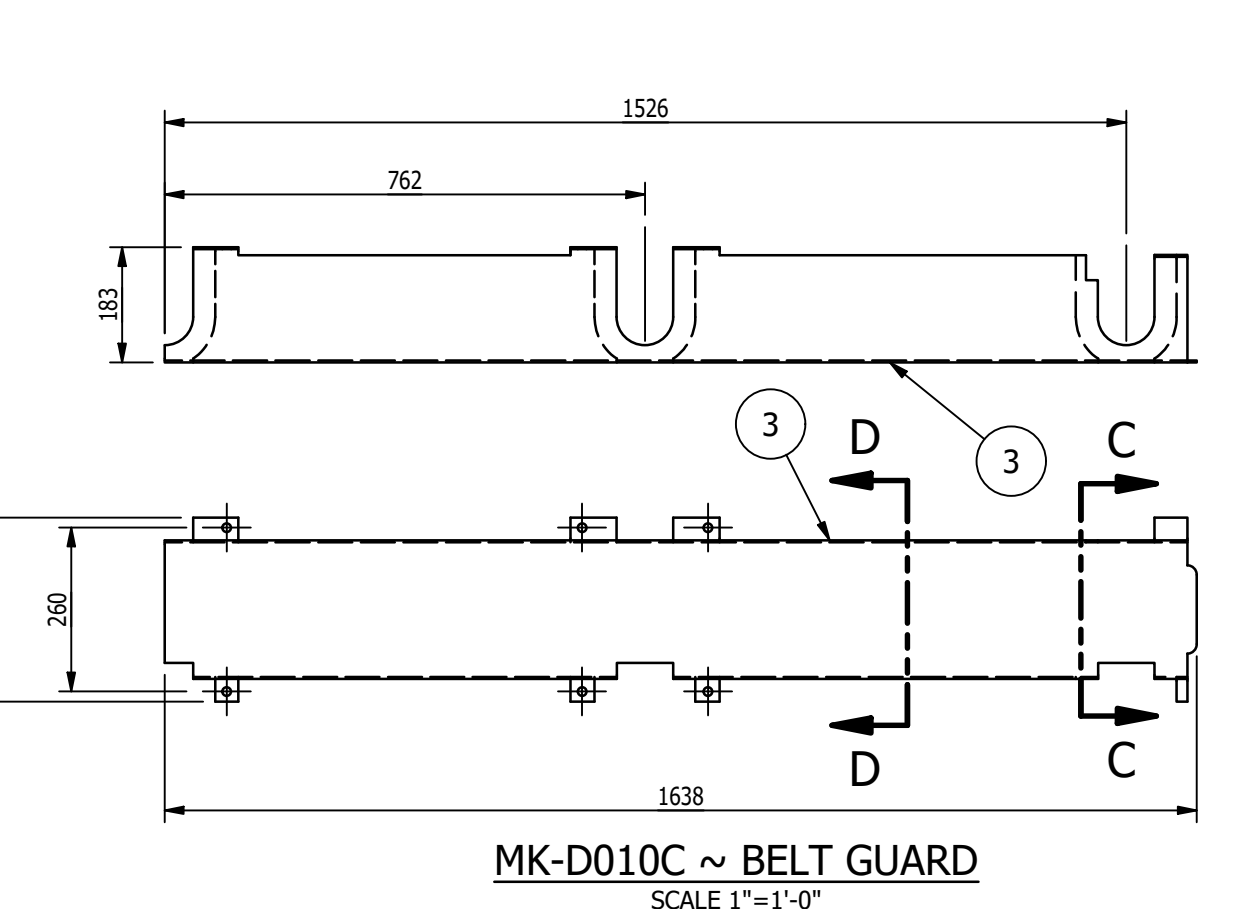
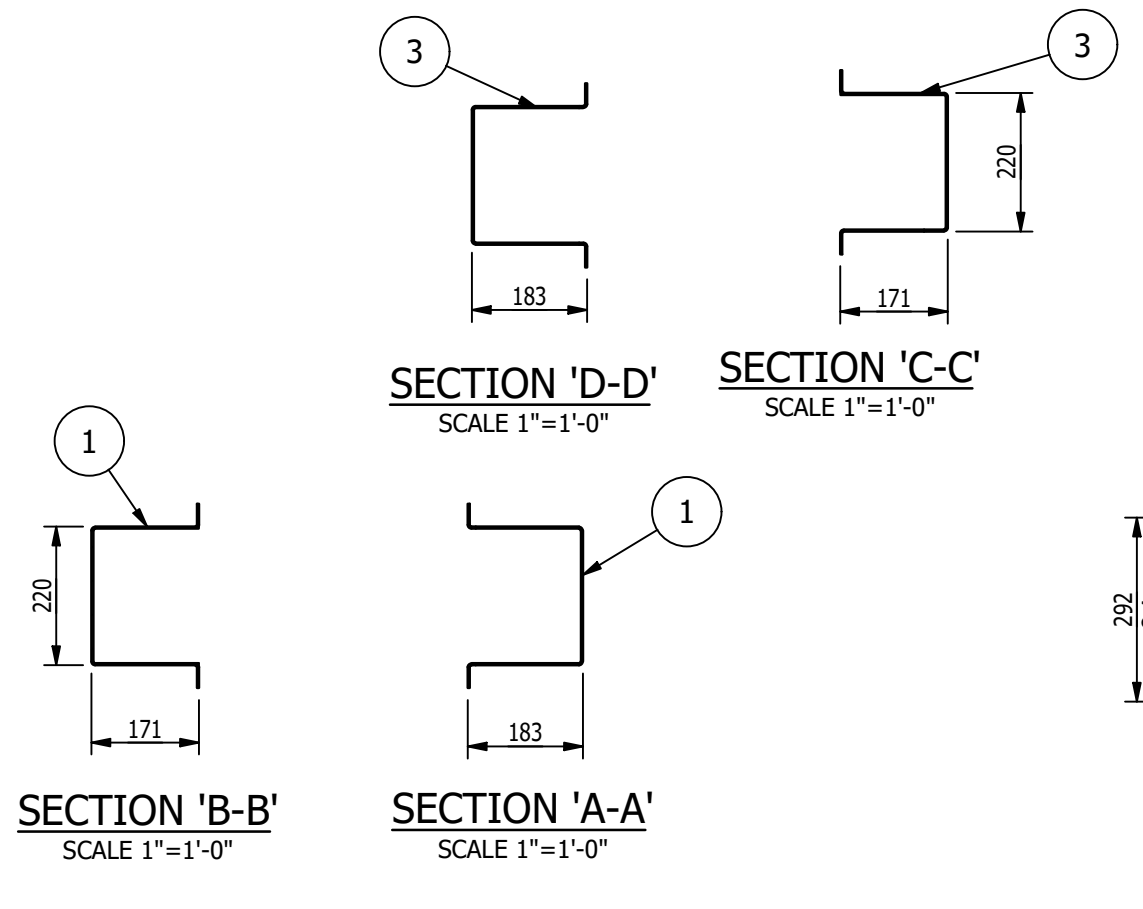
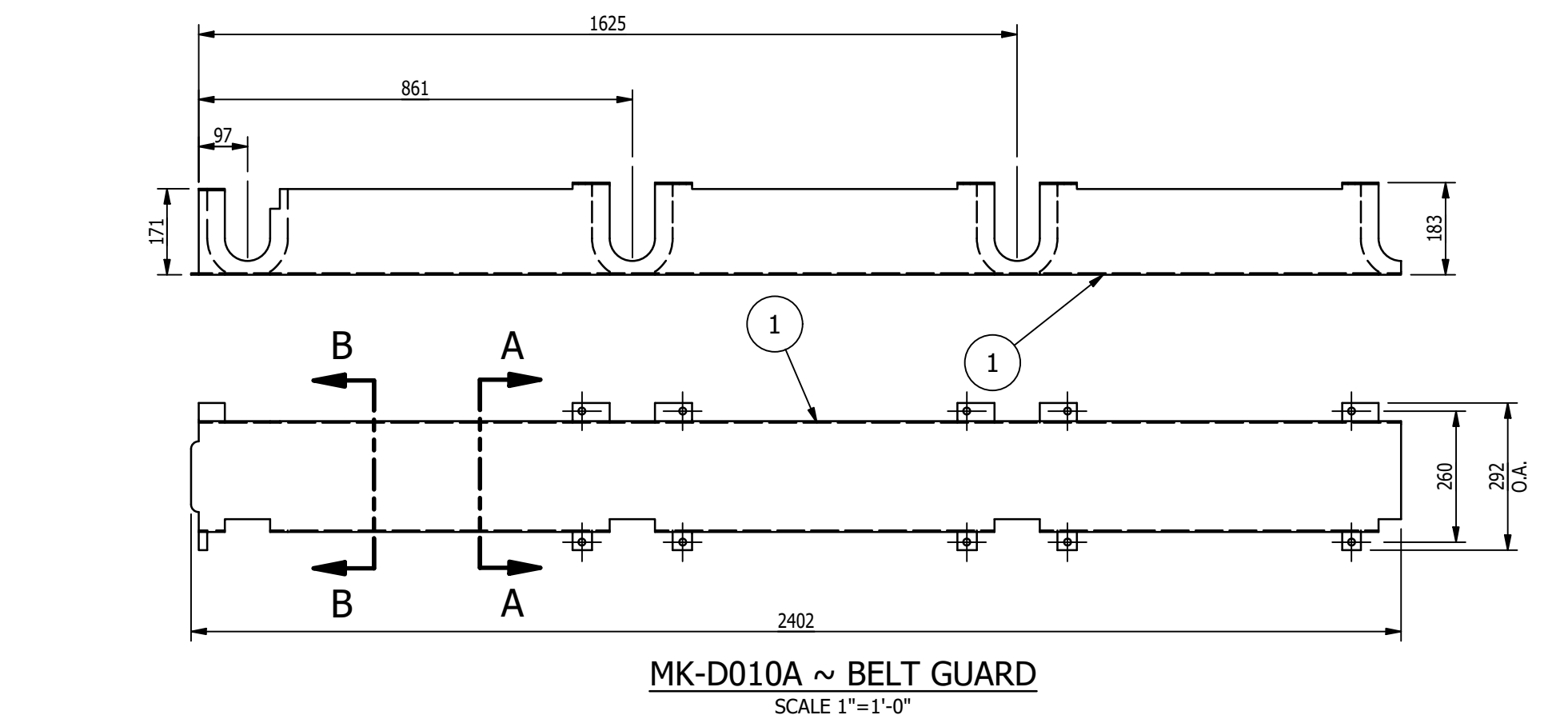
MAGNUM CONSULTING
 41100 Clarkston Rd.
 Suite 125
 Novi, MI 48245
 Phone: (248) 773-8833
 Fax: (248) 773-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D009

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

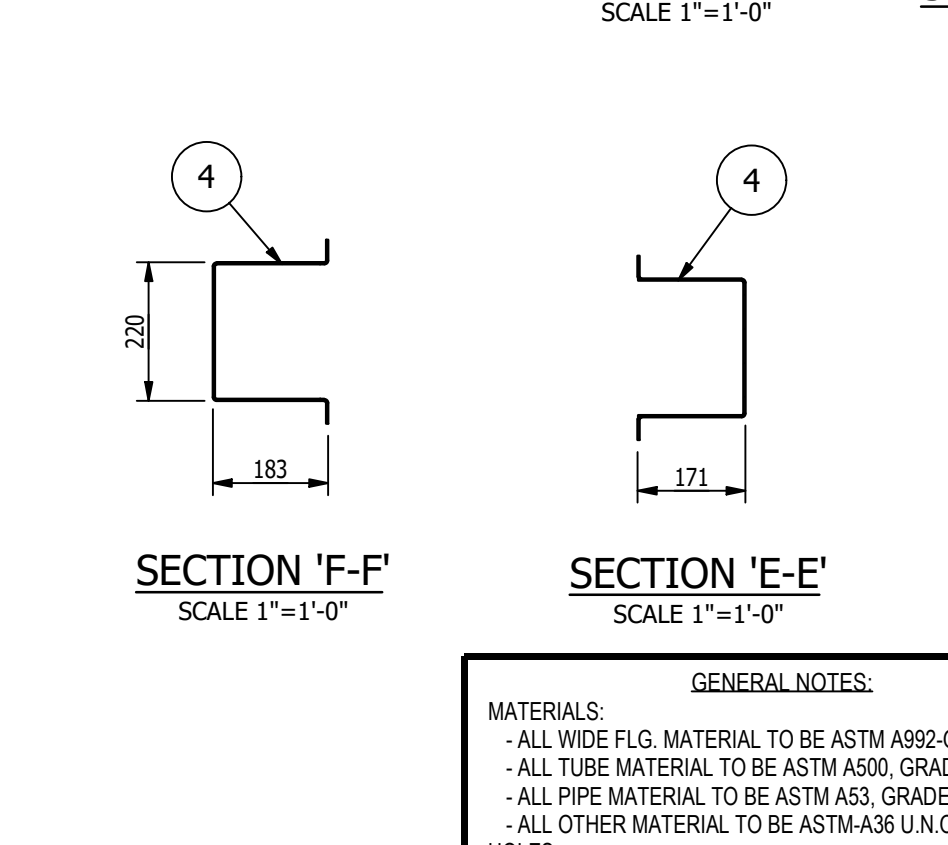
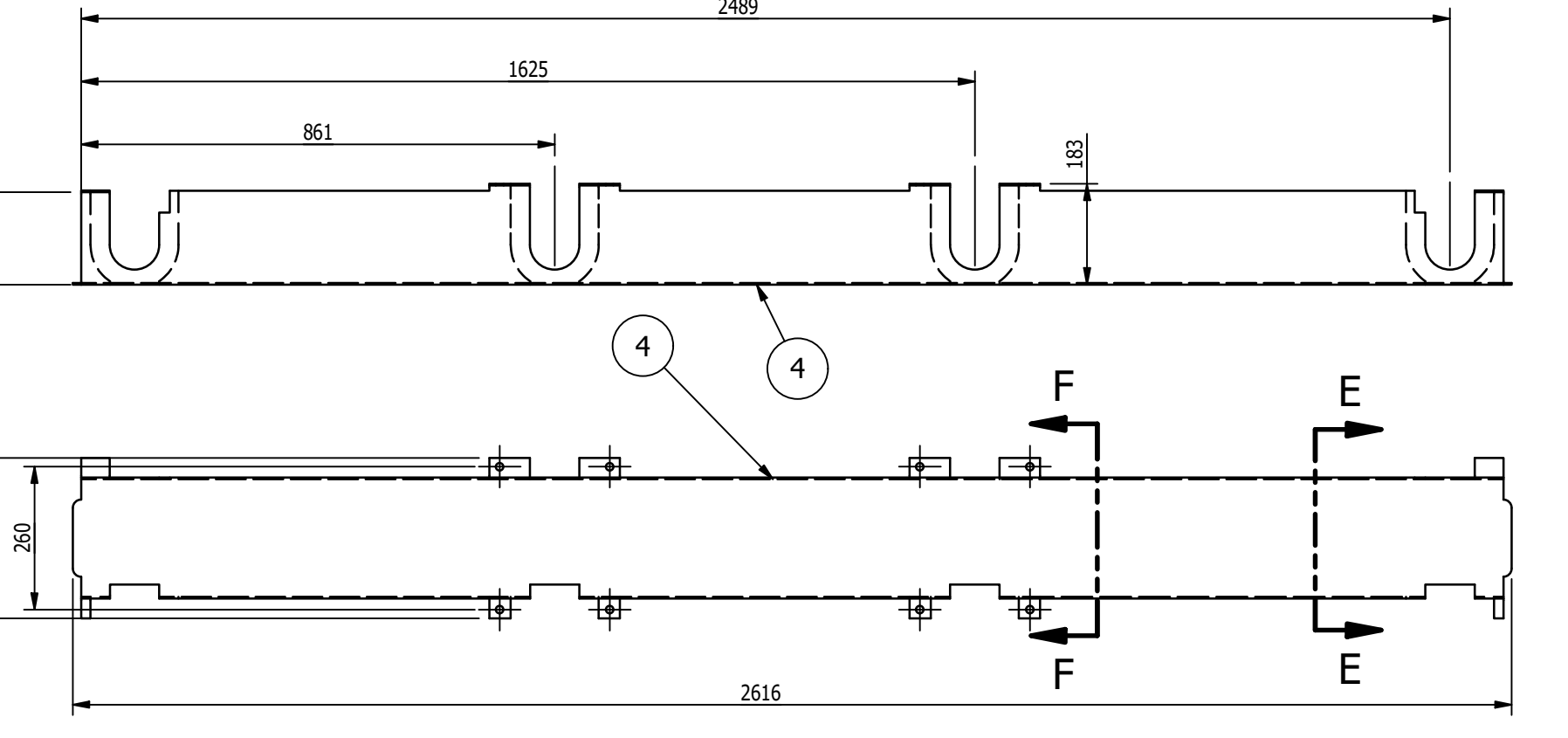
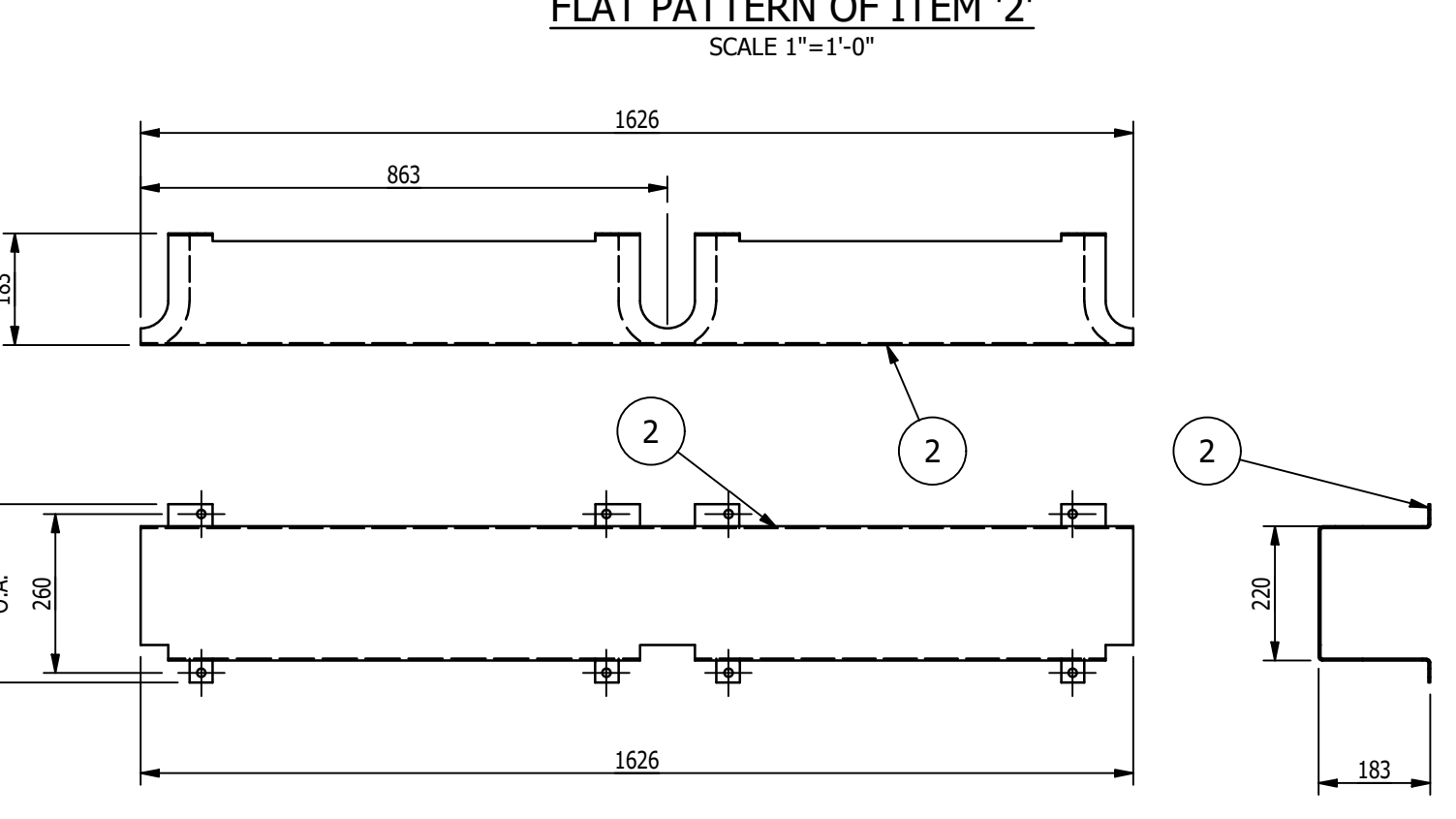
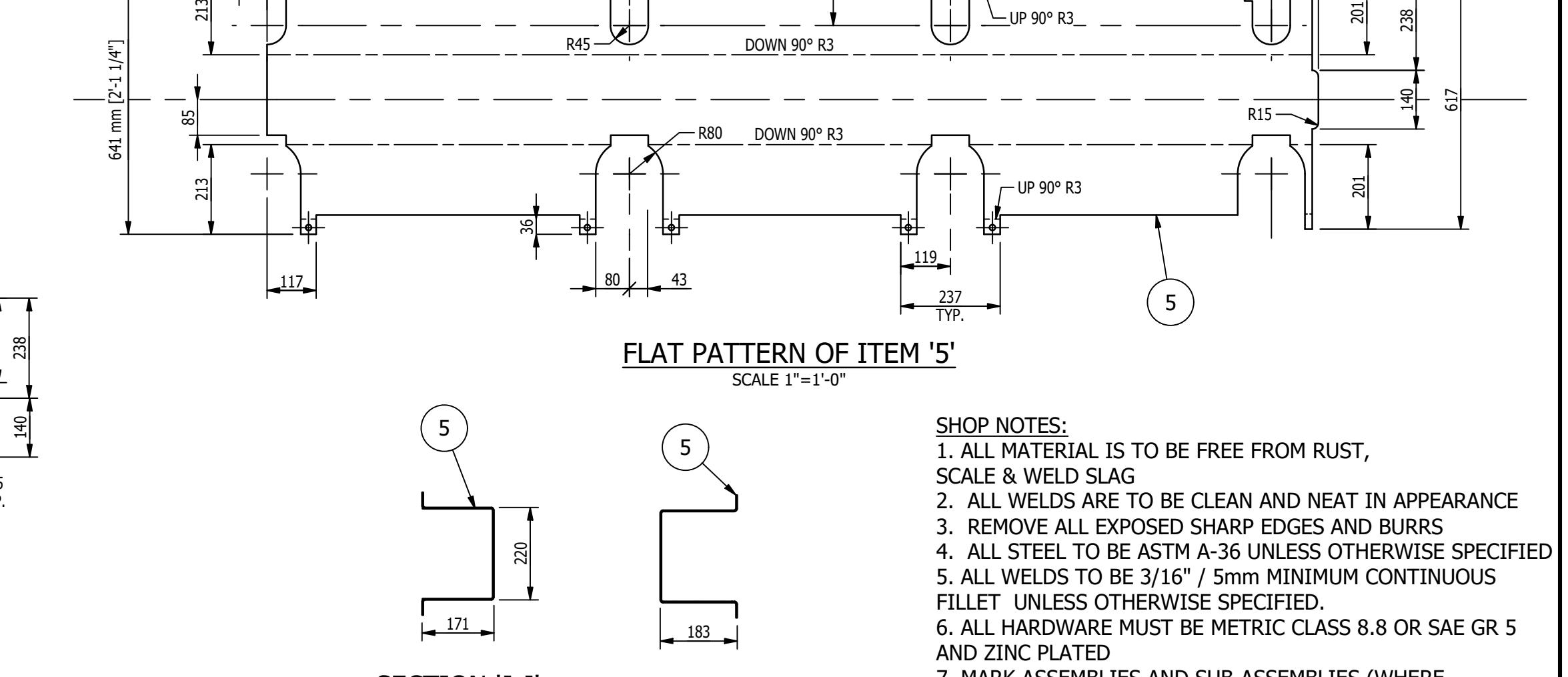
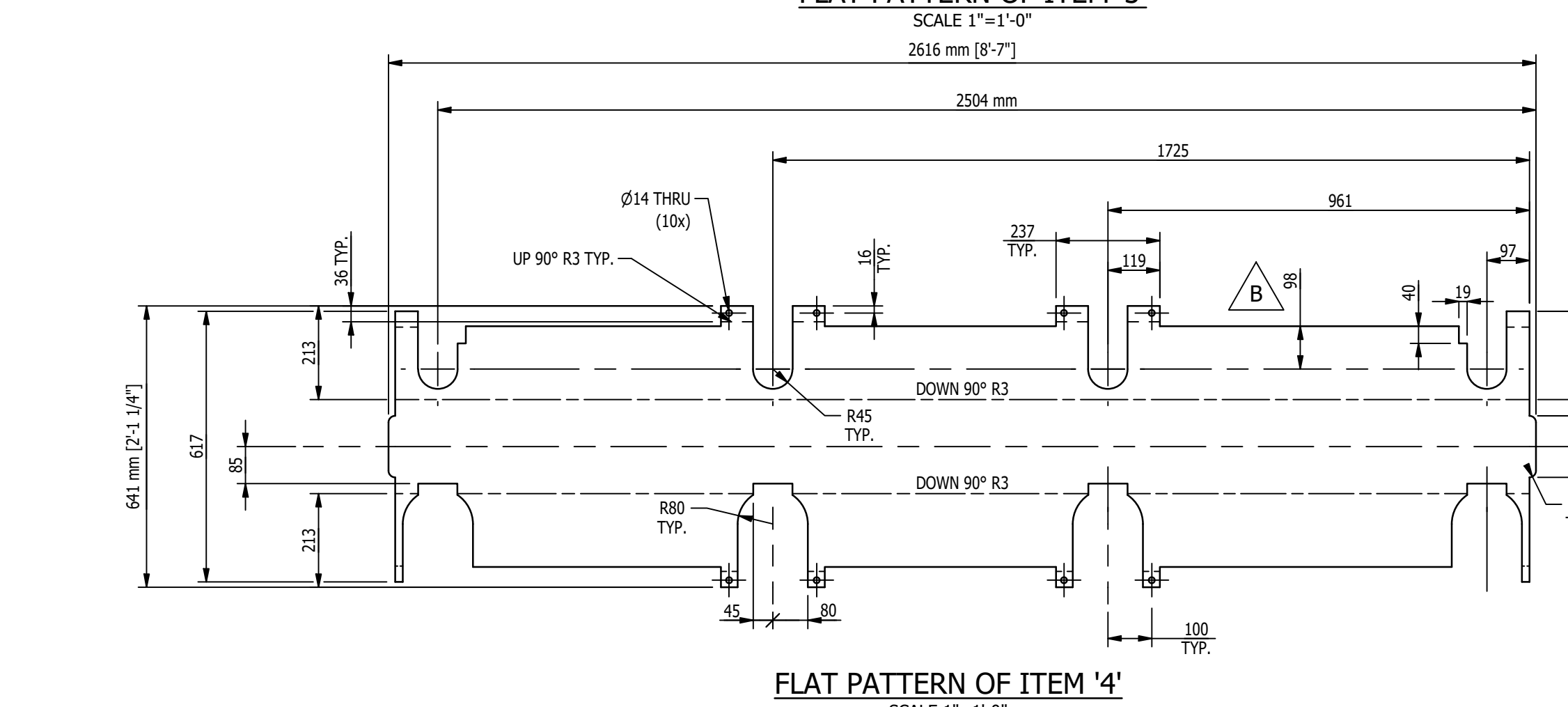
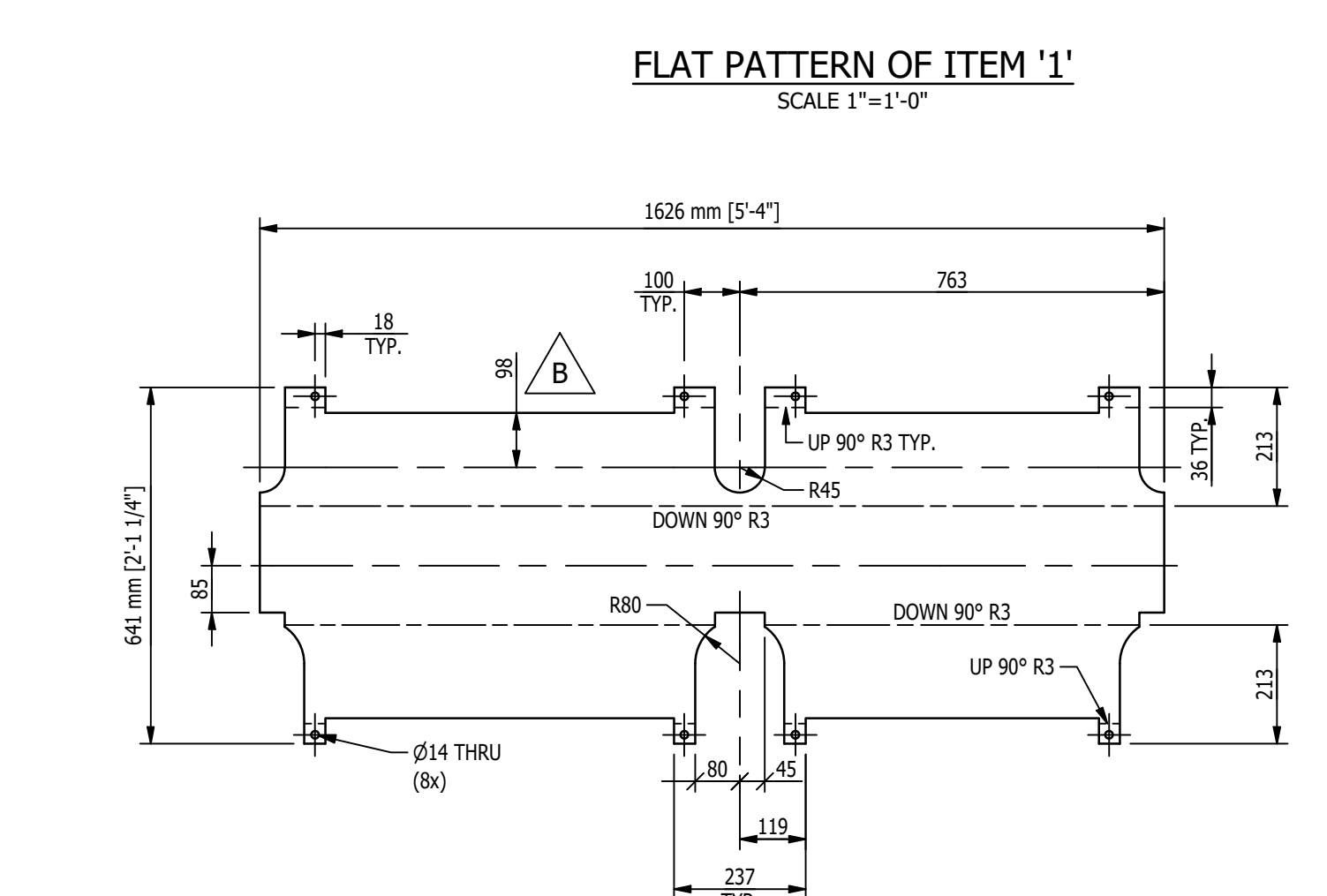
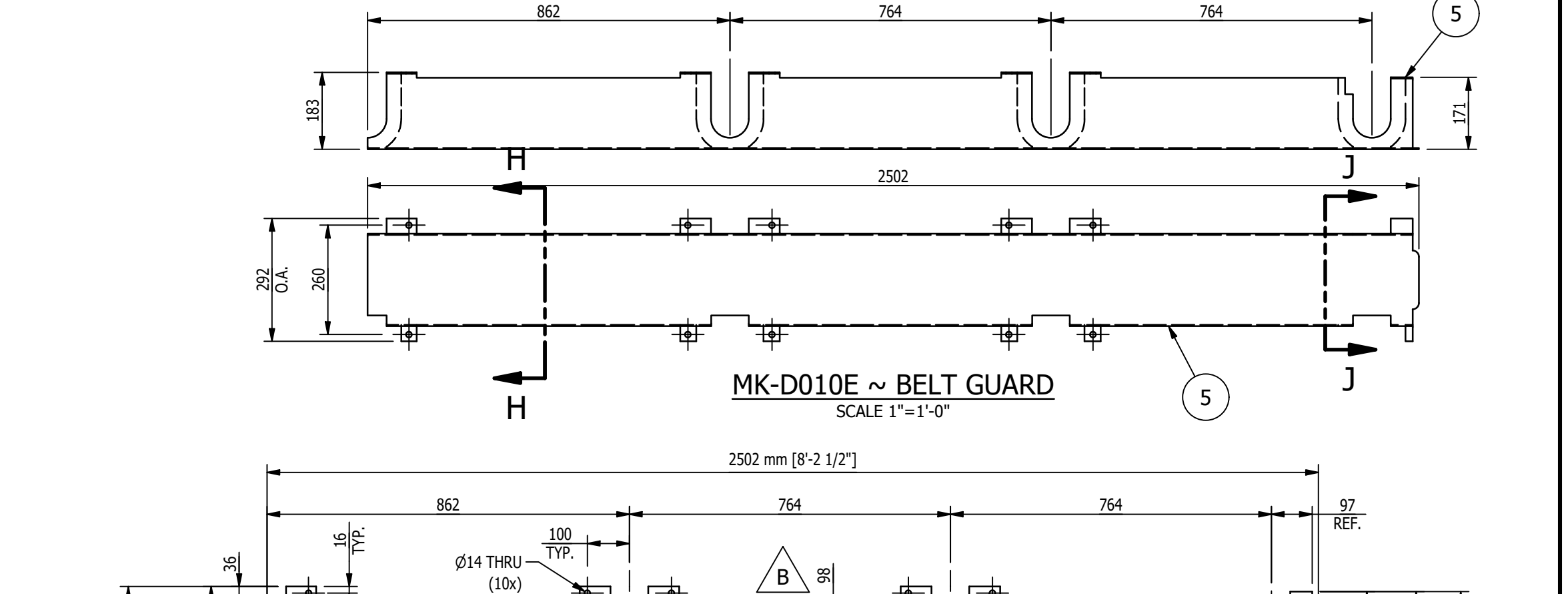
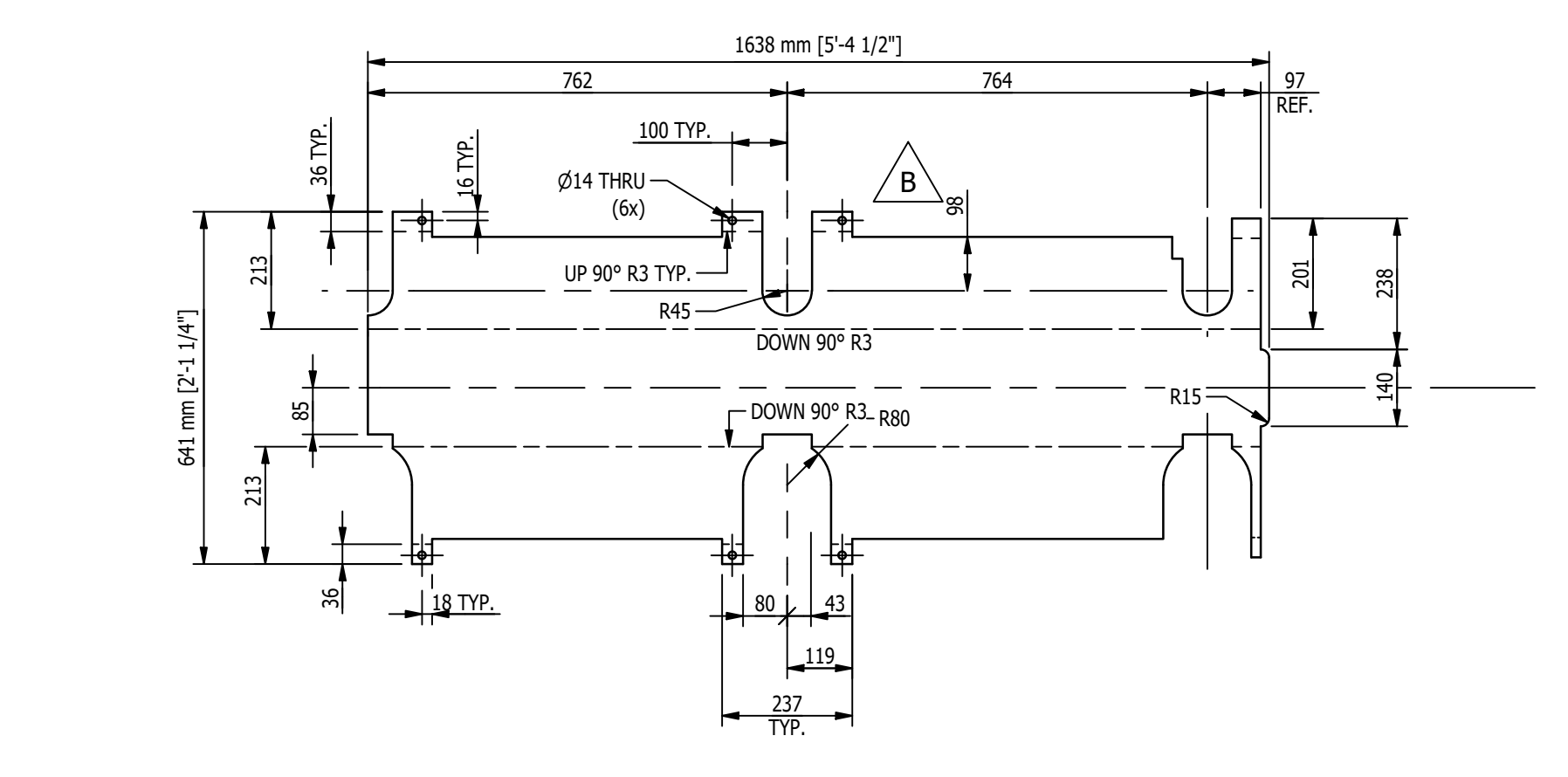
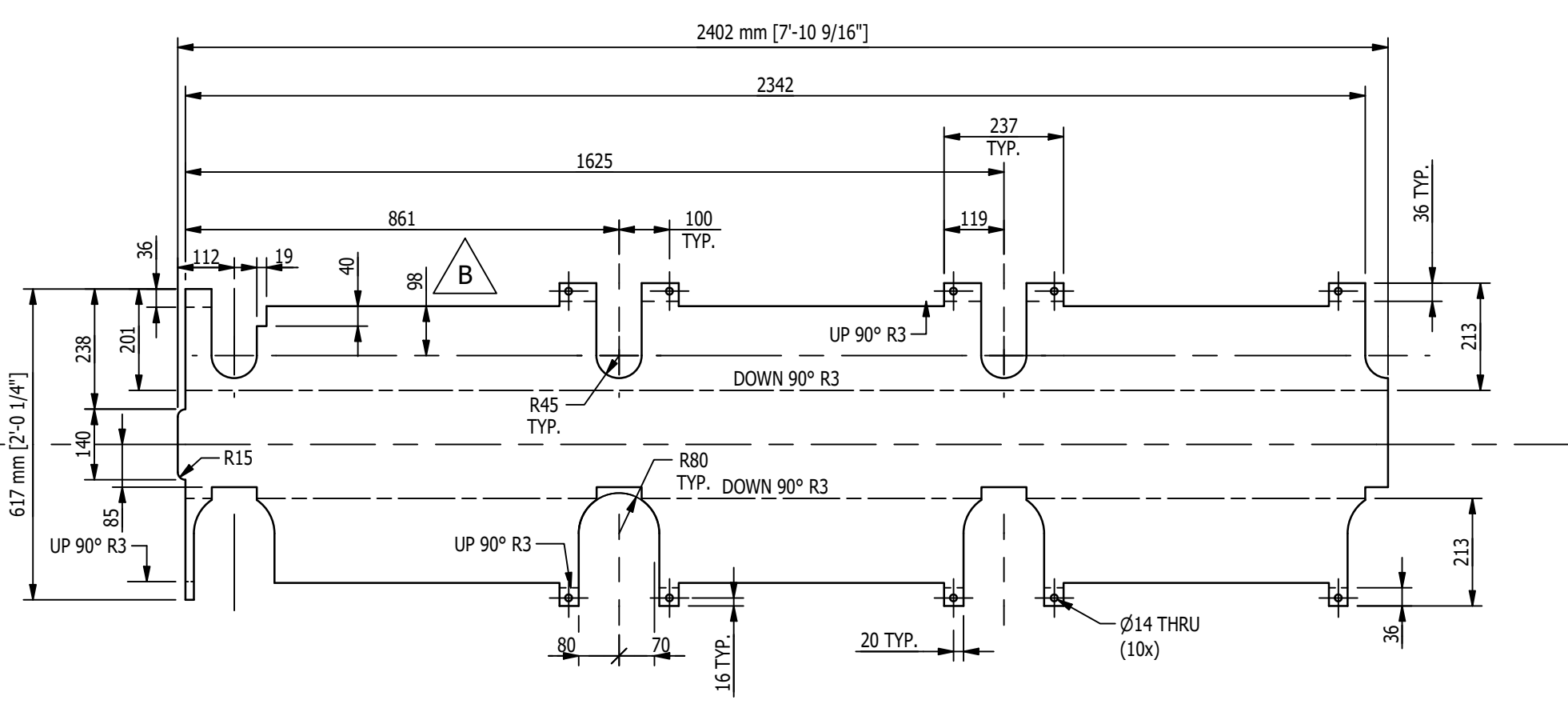
REV	BY	DATE	DESCRIPTION	APP
0	MC	7-19-2022	FOR FABRICATION	

REVISION HISTORY	
0	MC

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING	CLIENT: VOLVO	DRAWN BY: RJB
DRAWING No. 1875D009	REV: 0	CHECKED BY: CW
		DWG DATE: 6/13/22
		JOB No: 22096



BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
1	1	MK-D010A SHT 11 GA x 2' 1/4" TOTAL WEIGHT ~ 63.5 LBS	7'-10 9/16"	
2	1	MK-D010B SHT 11 GA x 2' 1 1/4" TOTAL WEIGHT ~ 44.0 LBS	5'-4"	
3	1	MK-D010C SHT 11 GA x 2'-1 1/4 TOTAL WEIGHT ~ 43.0 LBS	5'-4 1/2"	
4	1	MK-D010D SHT 11 GA x 2'-1 1/4 TOTAL WEIGHT ~ 66.3 LBS	8'-7"	
5	1	MK-D010E SHT 11 GA x 2'-1 1/4 TOTAL WEIGHT ~ 66.3 LBS	8'-2 1/2"	



- SHOP NOTES:**
- ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 - ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 - REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 - ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 - ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 - ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 - MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 - ALL SLOT LENGTHS ARE END TO END U.N.O.
- PAINT NOTES:**
- ONE SHOP COAT OF PURE ORANGE RAL 2004
OR
ONE SHOP COAT OF LIGHT GREY RAL 7035

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/3/2022	ADDED DIMS	
A	MC	6-10-2022	FOR FABRICATION	

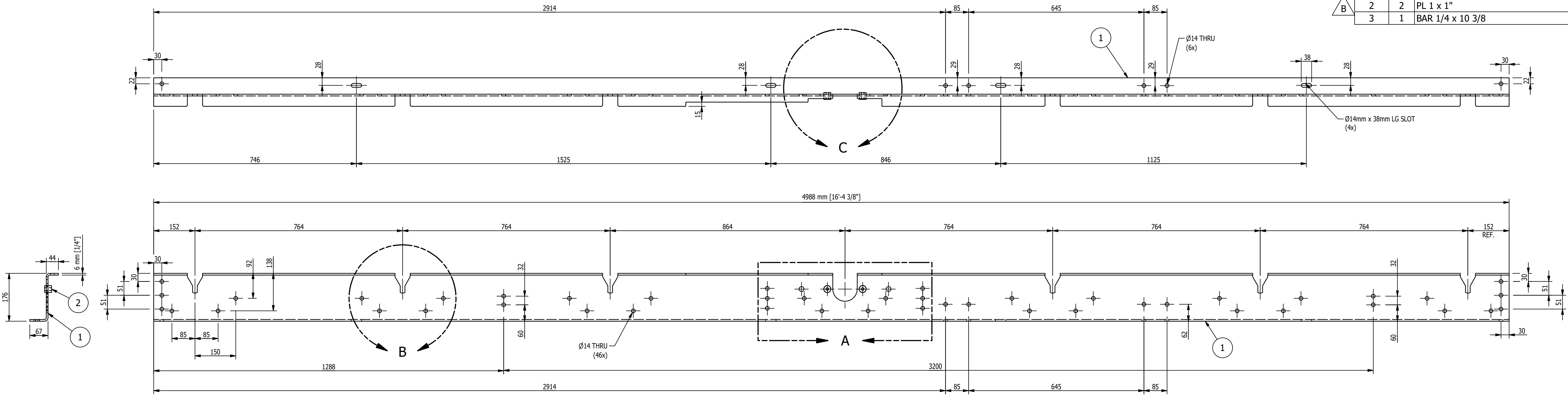
REVISION HISTORY	
B	MC
A	MC

MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: JC CHECKED BY: CW DWG DATE: 6/6/22	CLIENT: VOLVO
DRAWING No. 1875D010	REV: B	JOB No.: 22096

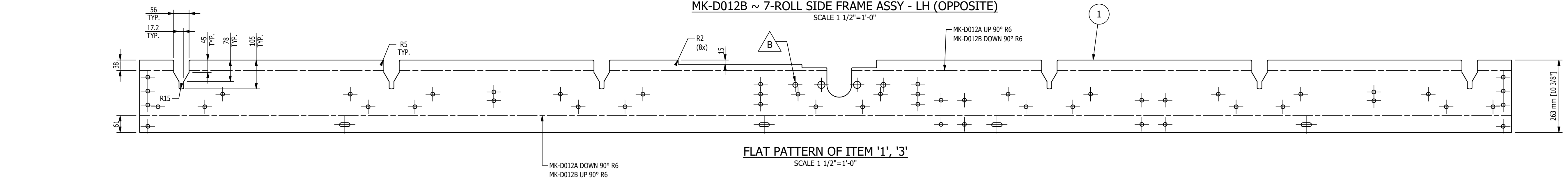
MAGNUM CONSULTING
 41100 Clarkston Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D010

- UNLESS OTHERWISE NOTED:**
- X = ±.060
 - XX = ±.030
 - XXX = ±.005
 - FRACTIONS = ±1/16"
 - ANGLES = ±1°30'
 - BREAK ALL SHARP EDGES
 - DEBURR ALL HOLES
 - DO NOT SCALE DRAWING
- GENERAL NOTES:**
- ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
 - WELDS: ALL WELDS TO BE "E70XX", (PER AWS D1.1)
 - PAINT: PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 - COPIES: ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

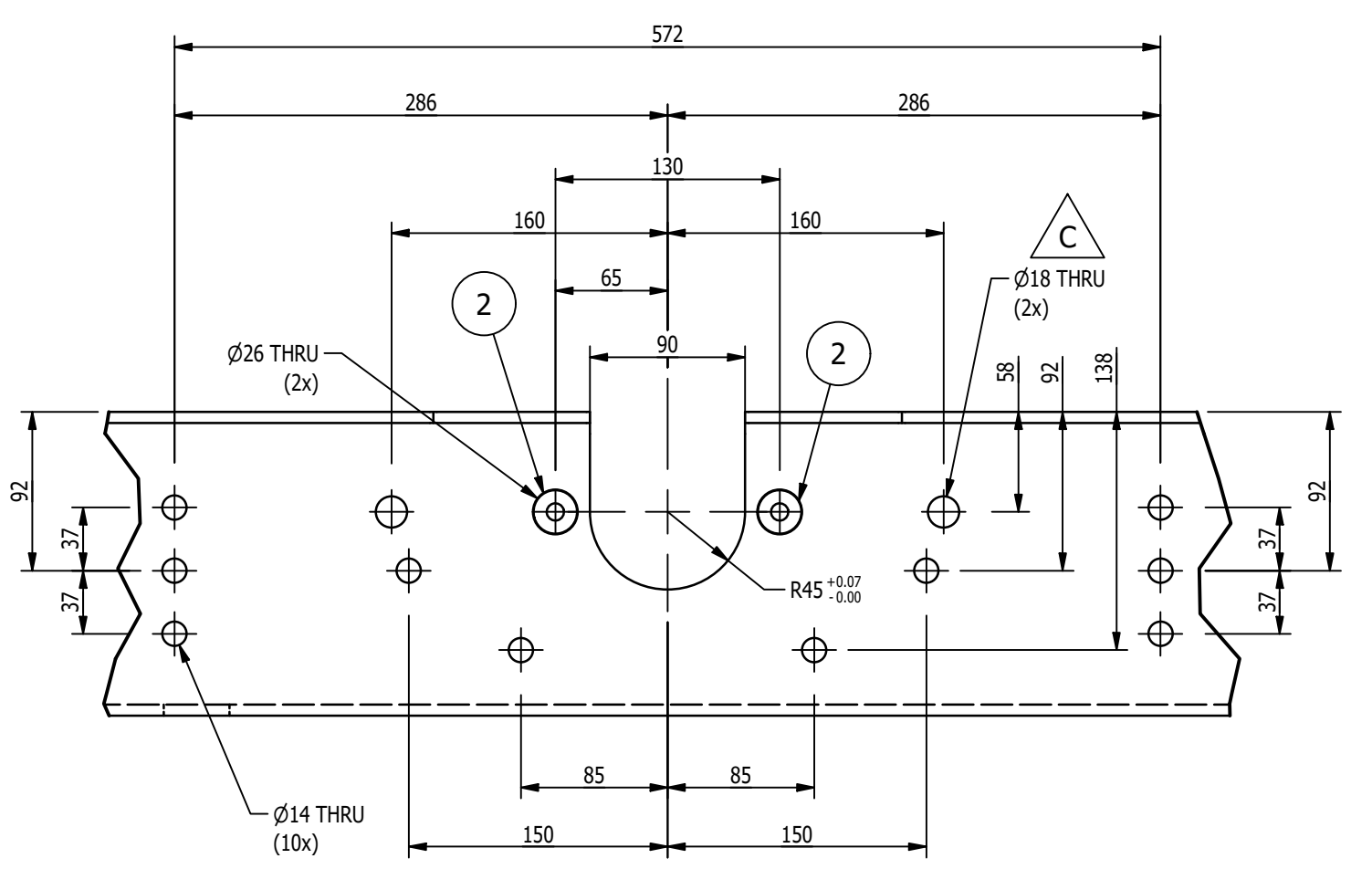
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D012A			
1	1	BAR 1/4 x 10 3/8	16'-4 3/8"		
2	2	PL 1 x 1"	1"		
		MK-D012B			
2	2	PL 1 x 1"	1"		
3	1	BAR 1/4 x 10 3/8	16'-4 3/8"		



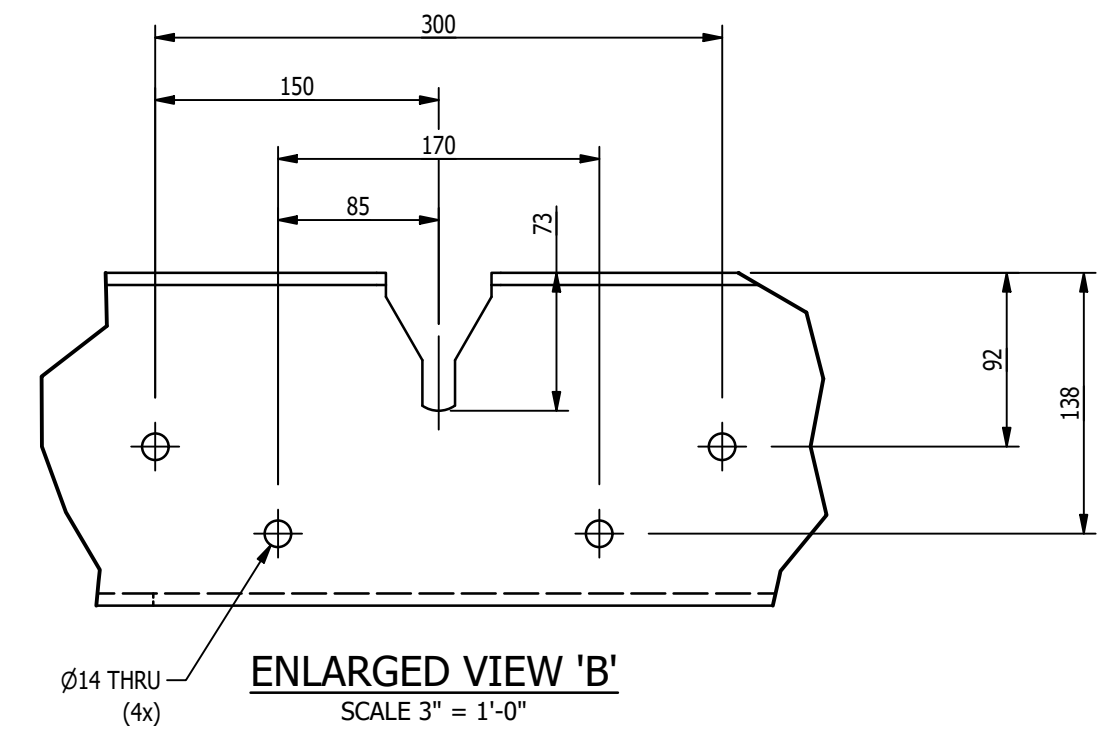
MK-D012A ~ 7-ROLL SIDE FRAME ASSY - RH (SHOWN)
 MK-D012B ~ 7-ROLL SIDE FRAME ASSY - LH (OPPOSITE)
 SCALE 1 1/2\"/>



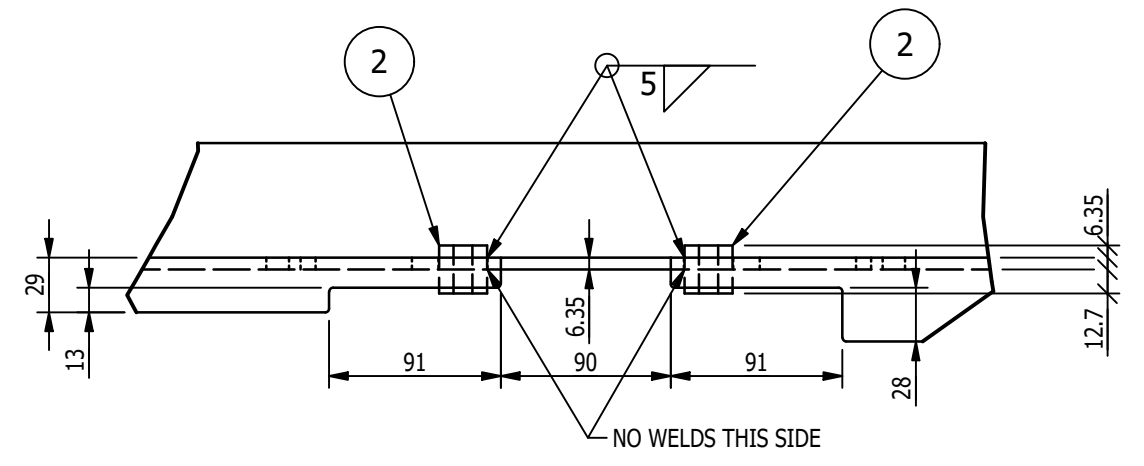
FLAT PATTERN OF ITEM '1', '3'
 SCALE 1 1/2\"/>



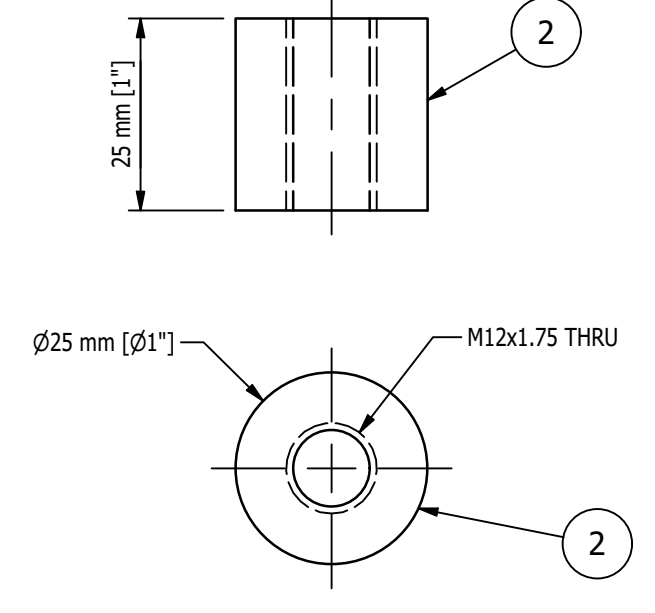
ENLARGED VIEW 'A'
 SCALE 3\"/>



ENLARGED VIEW 'B'
 SCALE 3\"/>



ENLARGED VIEW 'C'
 SCALE 3\"/>



DETAIL OF ITEM '2'
 SCALE 1'-0\"/>

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16\"/>

PAINT NOTES:
 PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

MAGNUM CONSULTING
 41100 Clarkston Road, Suite 125, West, MI 48375
 Phone: (248) 772-8822, Fax: (248) 772-8851, Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D012 - REV C

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16\"/>

- GENERAL NOTES:**
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

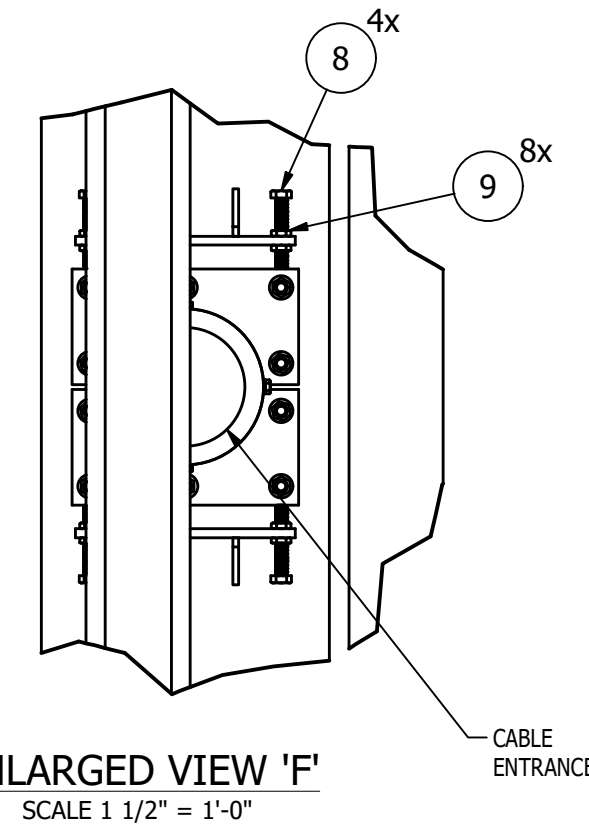
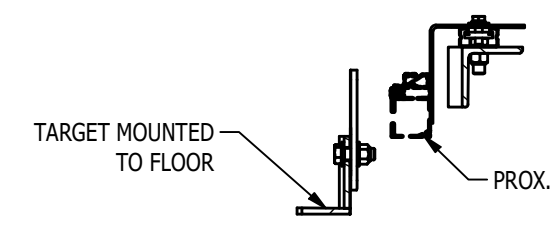
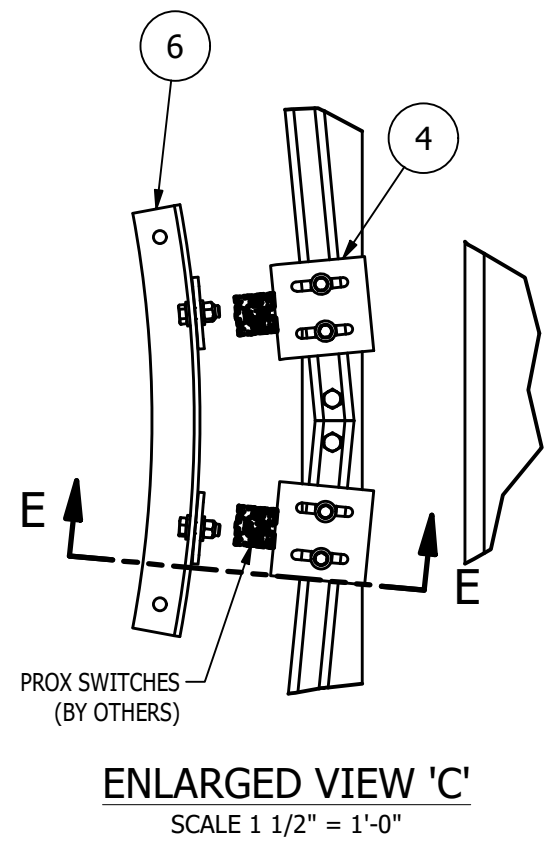
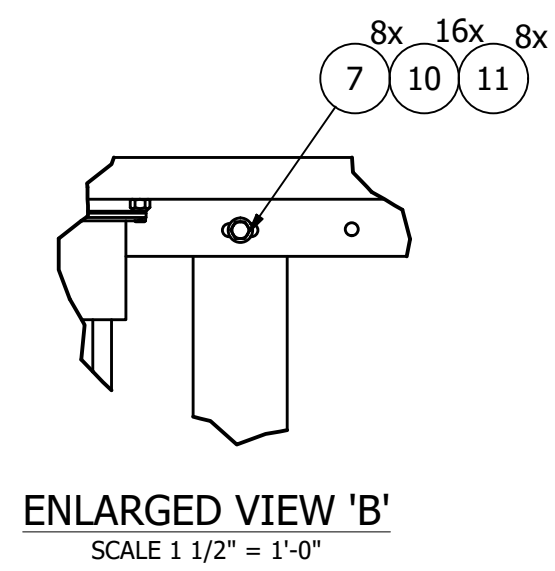
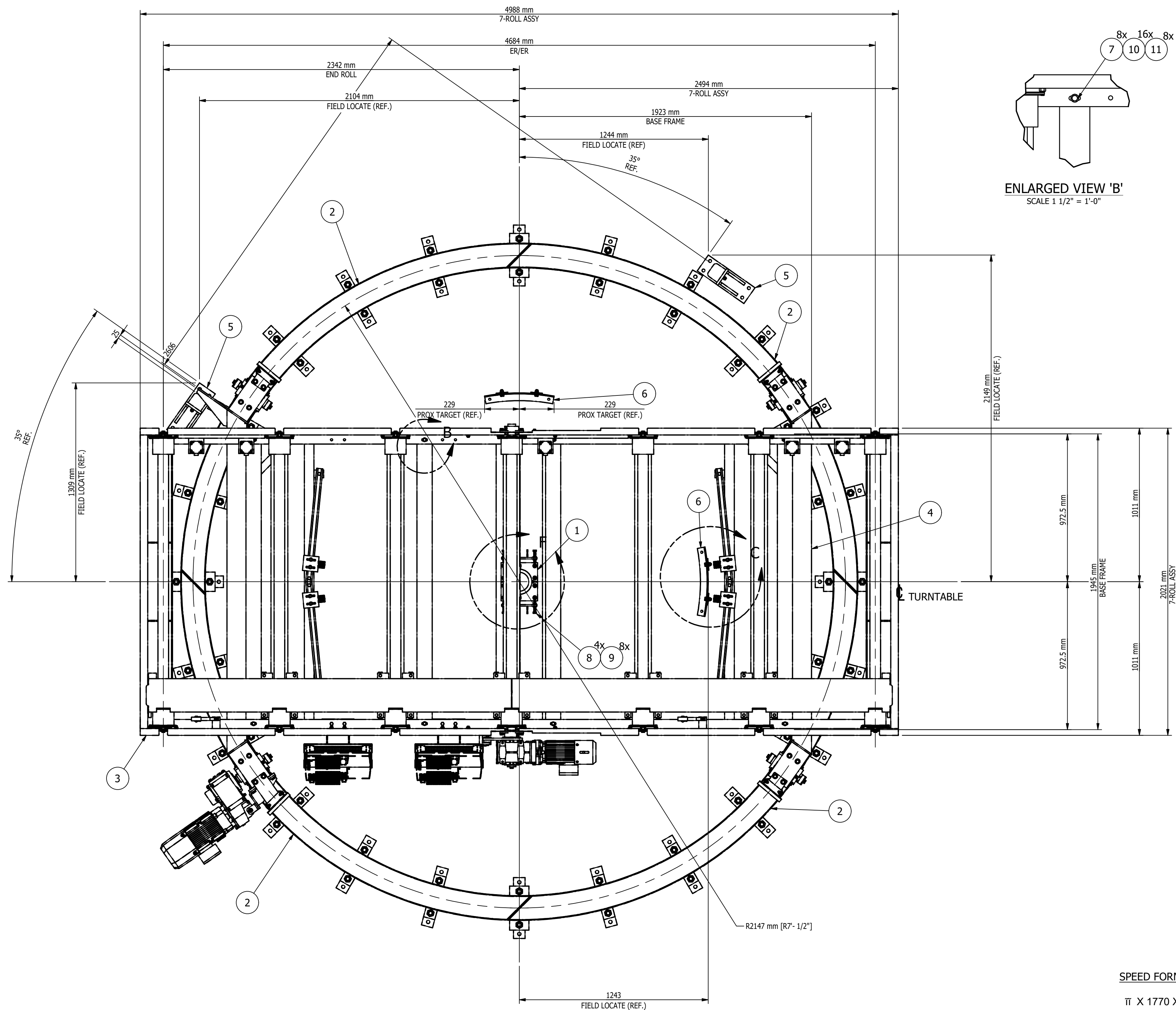
REV	BY	DATE	DESCRIPTION	APP
C	MC	8/24/22	ADDED HOLE SIZE	
B	MC	8/18/22	ADDED HOLE & UPDATED ITEM '2' DESCRIPTION	
A	MC	8/9/22	FOR FABRICATION	

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D012

PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 6/13/22
JOB No: 22096



BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
1	1	MK-D013A ~ CENTER PIVOT POST ASSEMBLY		
2	4	MK-D015A ~ TURNTABLE TRACK SECTION ASSEMBLY		
3	1	MK-D016A ~ 7-ROLL ASSEMBLY FOR TURNTABLE		
4	1	MK-D018A ~ CENTER PIVOT TURNTABLE BASE FRAME ASSEMBLY		
5	2	MK-D026A ~ PIVOT TABLE BUMPER		
6	2	MK-D033A ~ PROX TARGET (SHIP LOOSE)		
7	8	M12x1.75 x 35mm LG. HEX CAP SCREW		
8	4	M12x1.25 x 75mm LG. HEX CAP SCREW (FULLY THREADED)		
9	8	M12 x 1.75 HEX JAM NUT		
10	16	M12 NARROW FLAT WASHER		
11	8	M12 x 1.75 STOVER LOCK NUT		
TOTAL WEIGHT ~ 4850.7 LBS				

- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

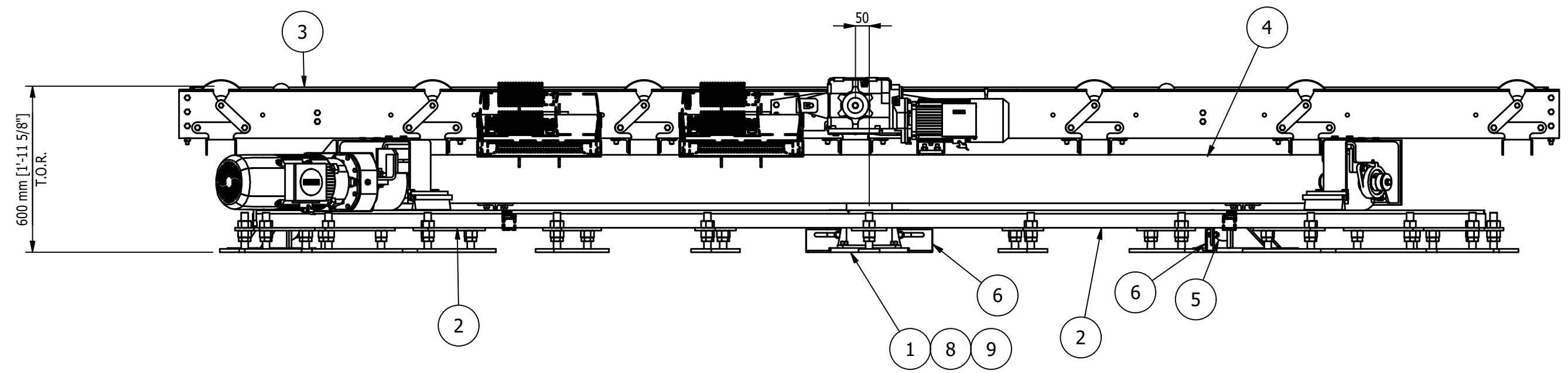
NOTE: WORK THIS WITH INSTALLATION DRAWINGS FOR BUMPER, PROX, GRAVITY STOP LOCATIONS AND GUIDE ROLLERS

SPEED FORMULA ROTATE (60HZ):

$$\pi \times 1770 \times \frac{1}{53.01} \times \frac{203.2}{1000} = 21.3 \text{ m/min} = 69.9 \text{ ft/min}$$

SPEED FORMULA ROLL BED (60HZ):

$$\pi \times 1760 \times \frac{1}{37.18} \times \frac{140}{1000} = 20.8 \text{ m/min} = 68.3 \text{ ft/min}$$



MK-D013A ~ 7-ROLL TURNTABLE ASSEMBLY
SCALE 3/4" = 1'-0"

MAGNUM Consulting
41100 Clarkston Road
Suite 125
North, MI 48075
Phone: (248) 373-8888
Fax: (248) 373-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D013

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/23/22	ITEM '8' IS NOW FULLY THREADED	
B	MC	8/18/22	UPDATED DESCRIPTION OF ITEM '6'	
A	MC	8/5/22	FOR FABRICATION	

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millc.com

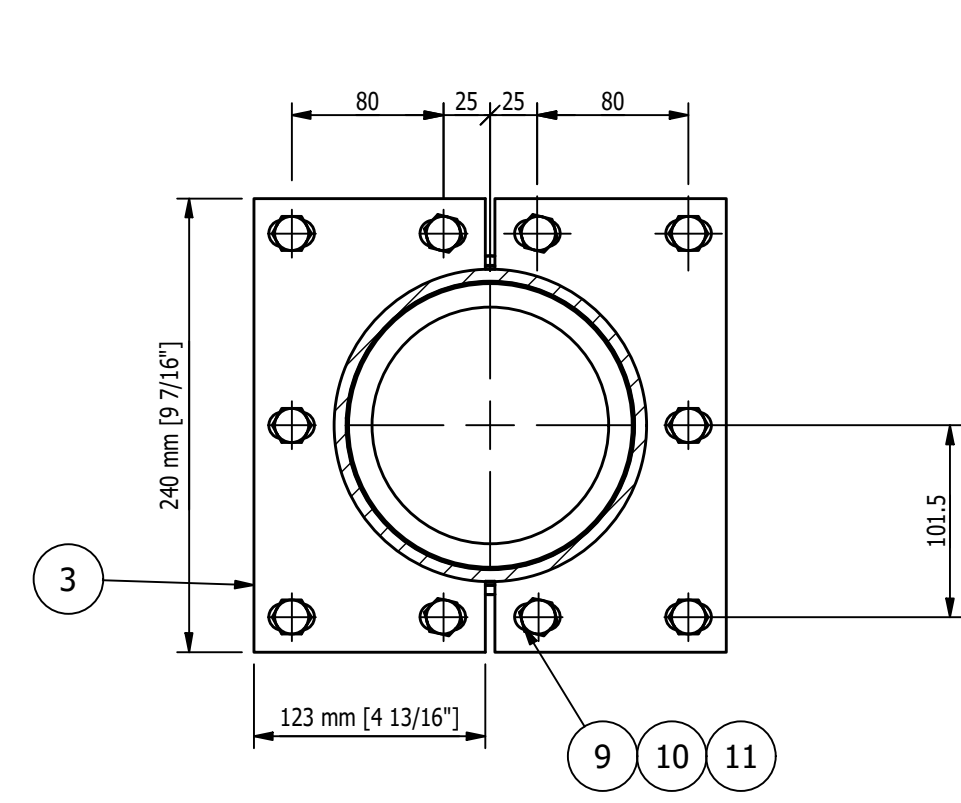
TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

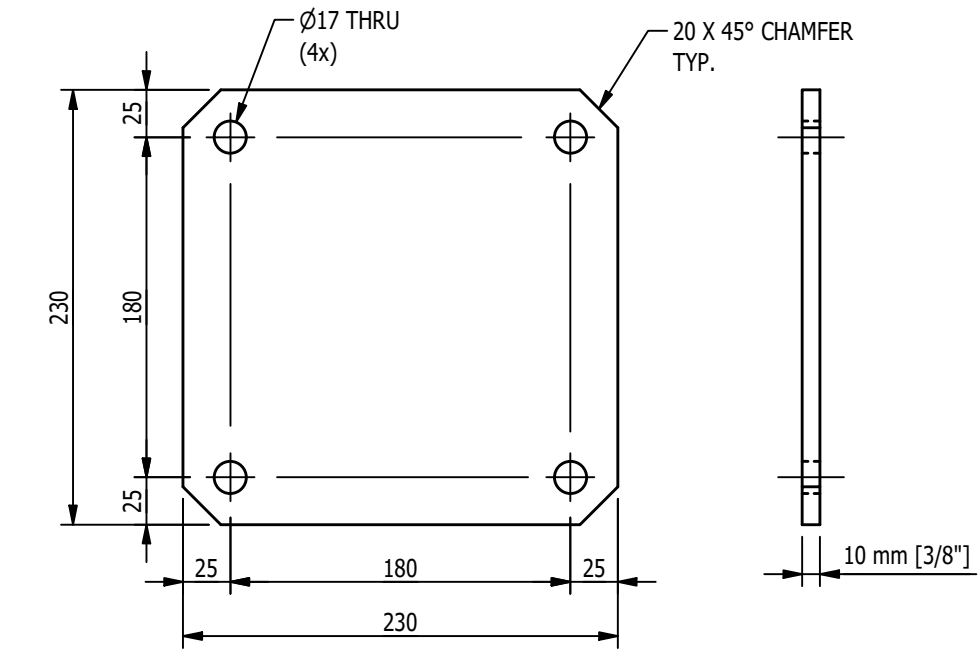
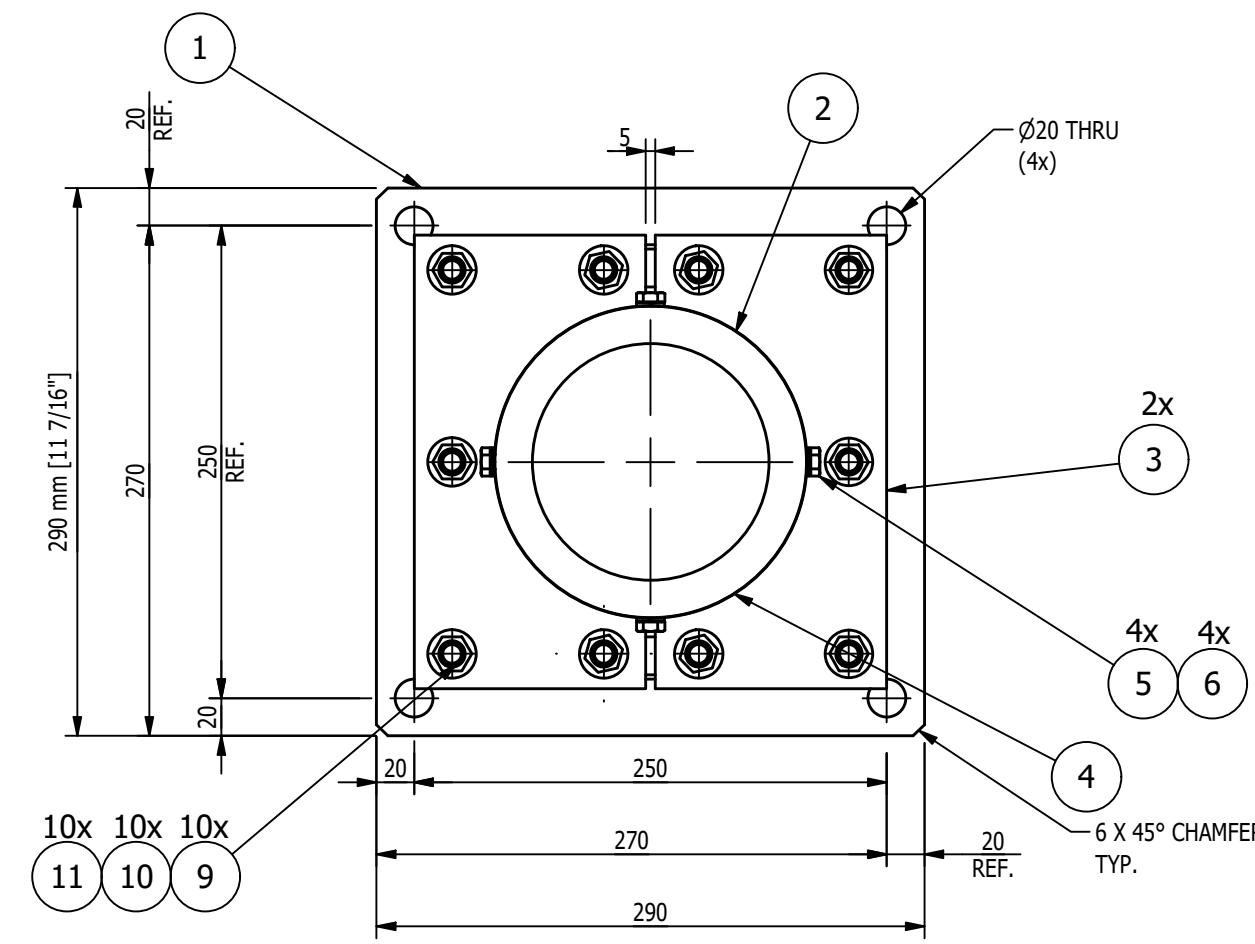
DRAWING No. 1875D013

REV: C

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 6/7/22
JOB No: 22096

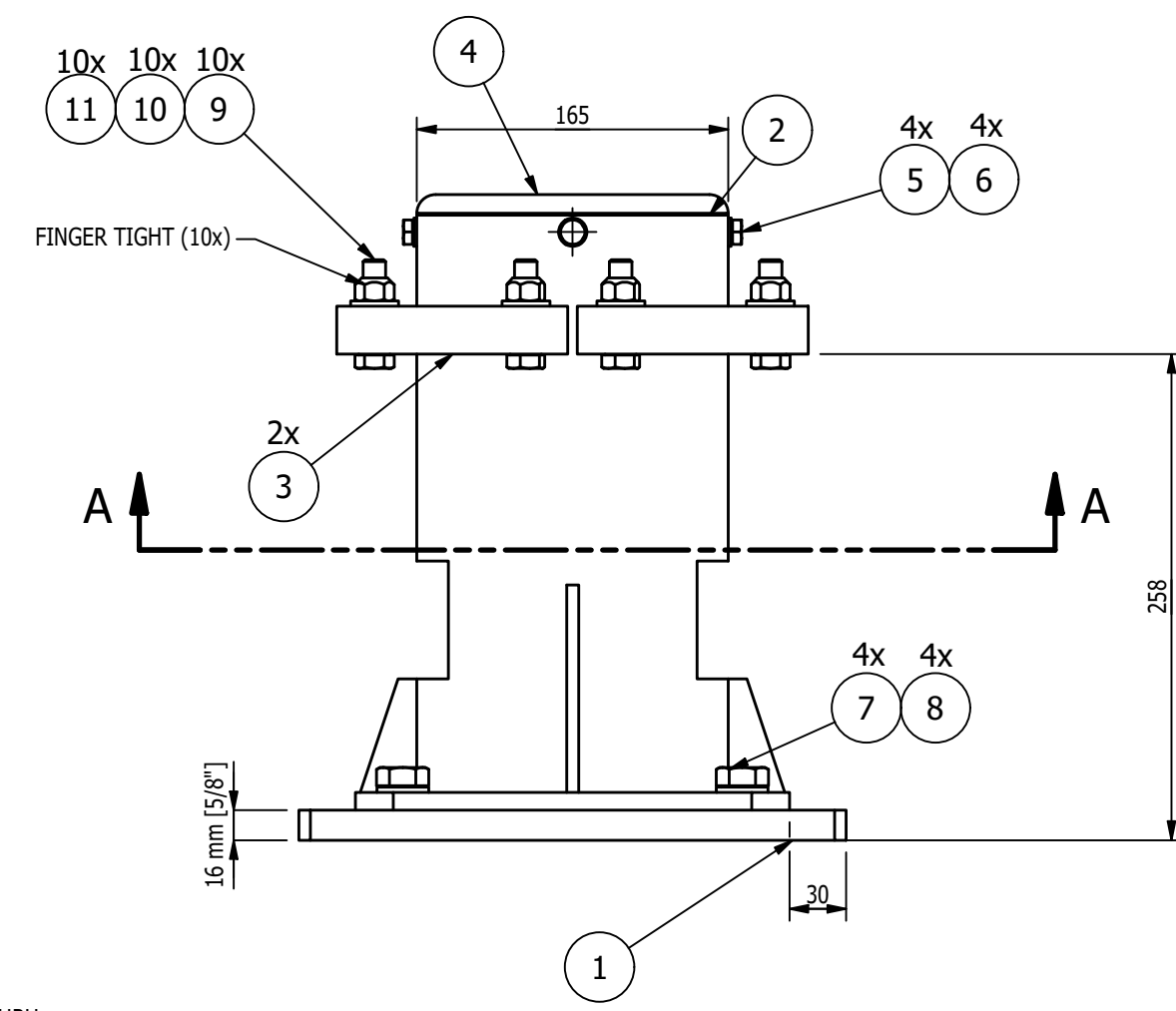


SECTION 'A-A'
SCALE 3"=1'-0"

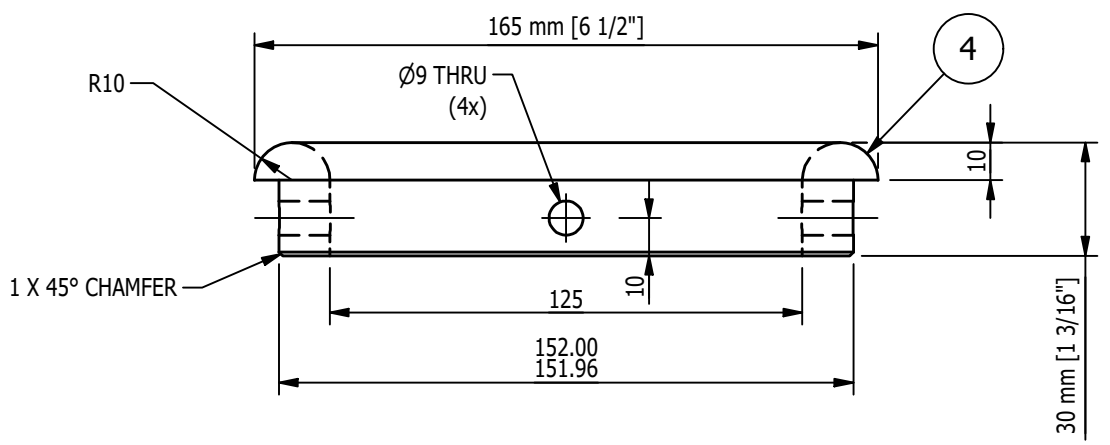
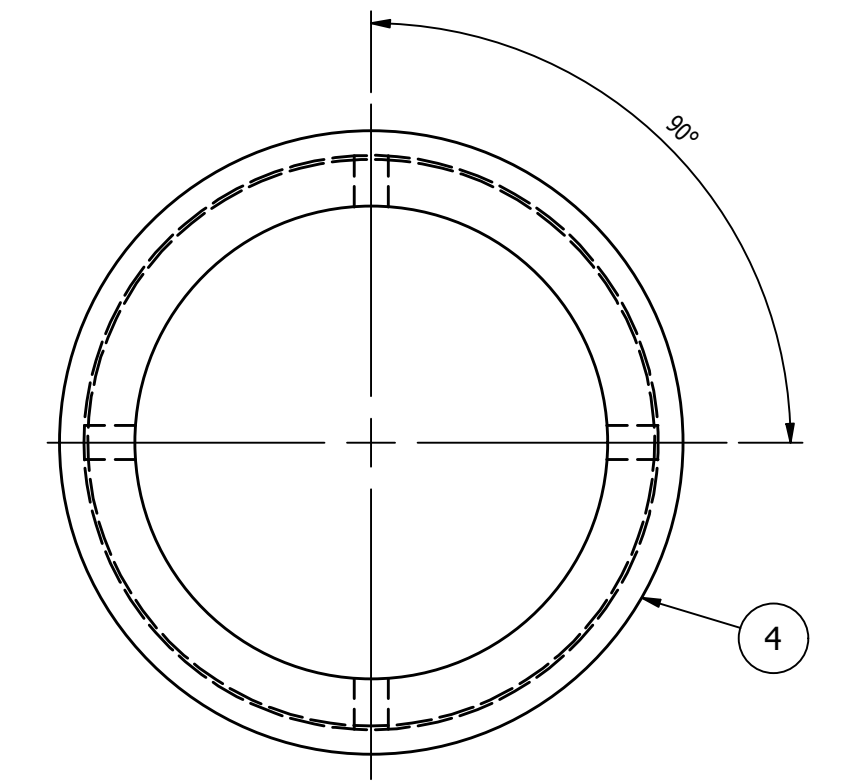
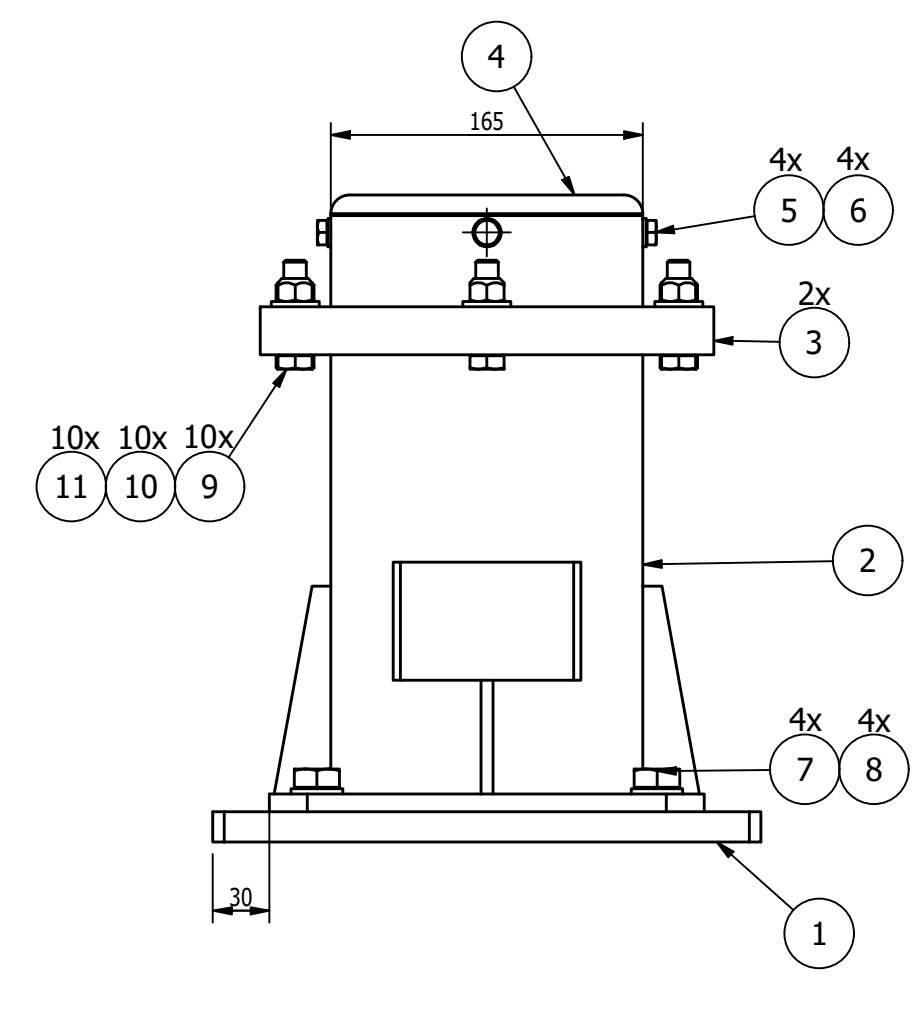


DETAIL OF ITEM '12'
SCALE 3"=1'-0"

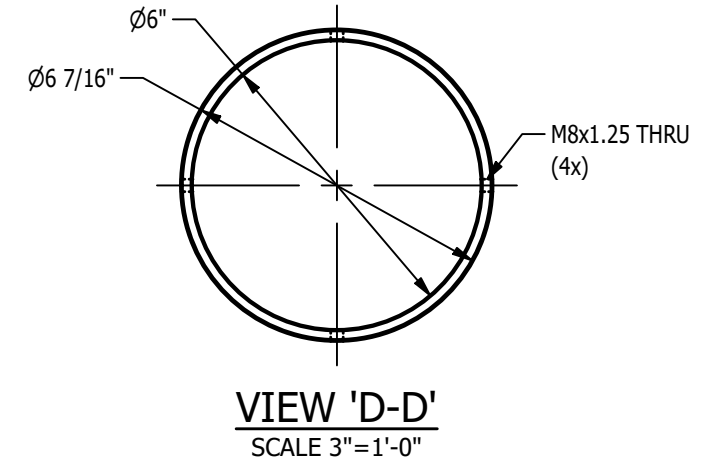
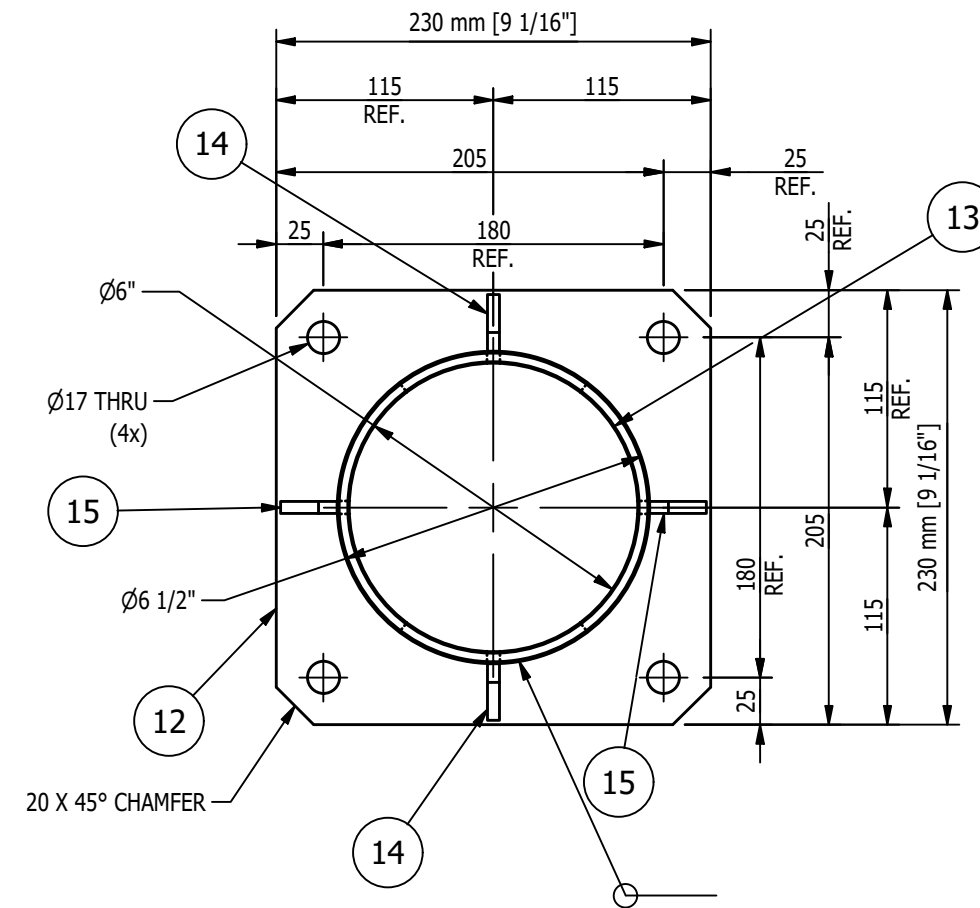
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D014A			
1	1	BAR 5/8 x 11 7/16	11 7/16 in		
2	1	MK-D014B ~ CENTER POST			
3	2	NYLATRON GSM 1 x 4 13/16	9 7/16 in		
4	1	NYLATRON GSM 1 1/4 x 6 1/2	6 1/2 in		
5	4	M8x1.25 x 20mm LG. HEX CAP SCREW			
6	4	M8 SPRING LOCK WASHER			
7	4	M16x2 x 25mm LG. HEX CAP SCREW			
8	4	M16 SPRING LOCK WASHER			
9	10	M12x1.75 x 50mm LG. HEX CAP SCREW			
10	10	M12 NARROW FLAT WASHER			
11	10	M12 x 1.75 STOVER LOCK NUT			
		TOTAL WEIGHT			
		MK-D014B			
12	1	BAR 3/8 x 9 1/16	9 1/16 in		
13	1	DOM TUBING 6 1/2 OD x 6 ID	12 1/16 in		
14	2	BAR 1/4 x 1 3/16	2 3/8 in		
15	2	BAR 1/4 x 1 3/16	4 5/16 in		
		TOTAL WEIGHT			



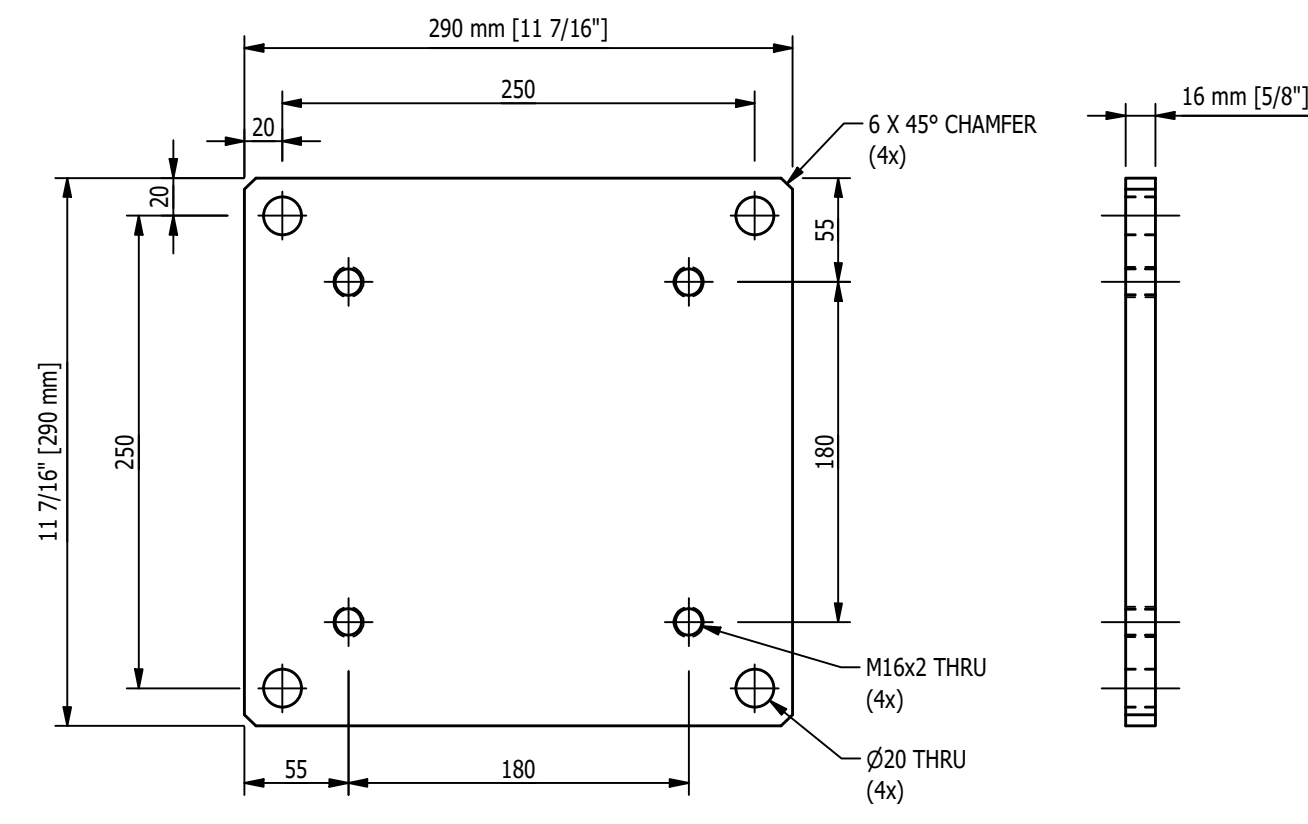
MK-D014A ~ CENTER PIVOT POST ASSEMBLY
SCALE 3"=1'-0"



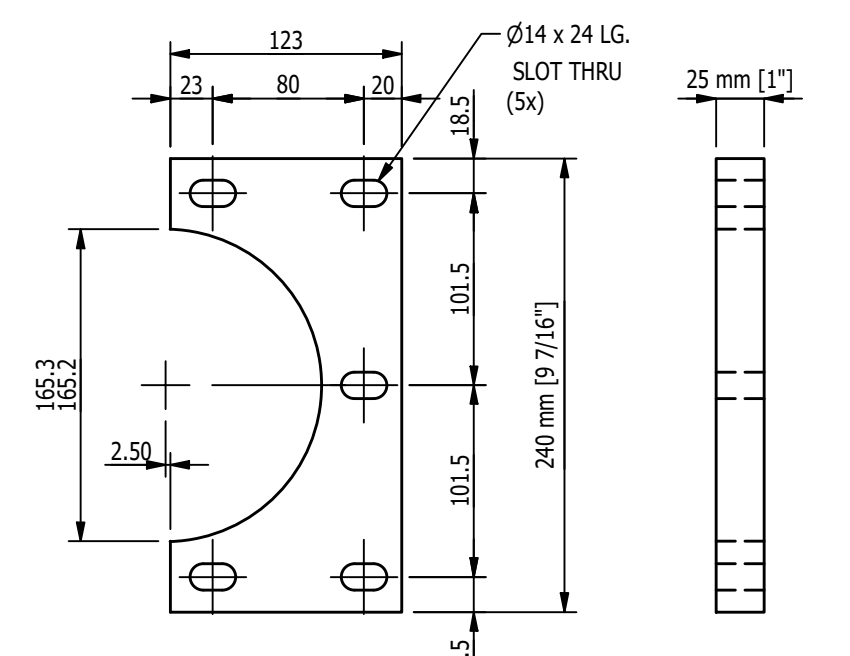
DETAIL OF ITEM '4'
SCALE 6"=1'-0"



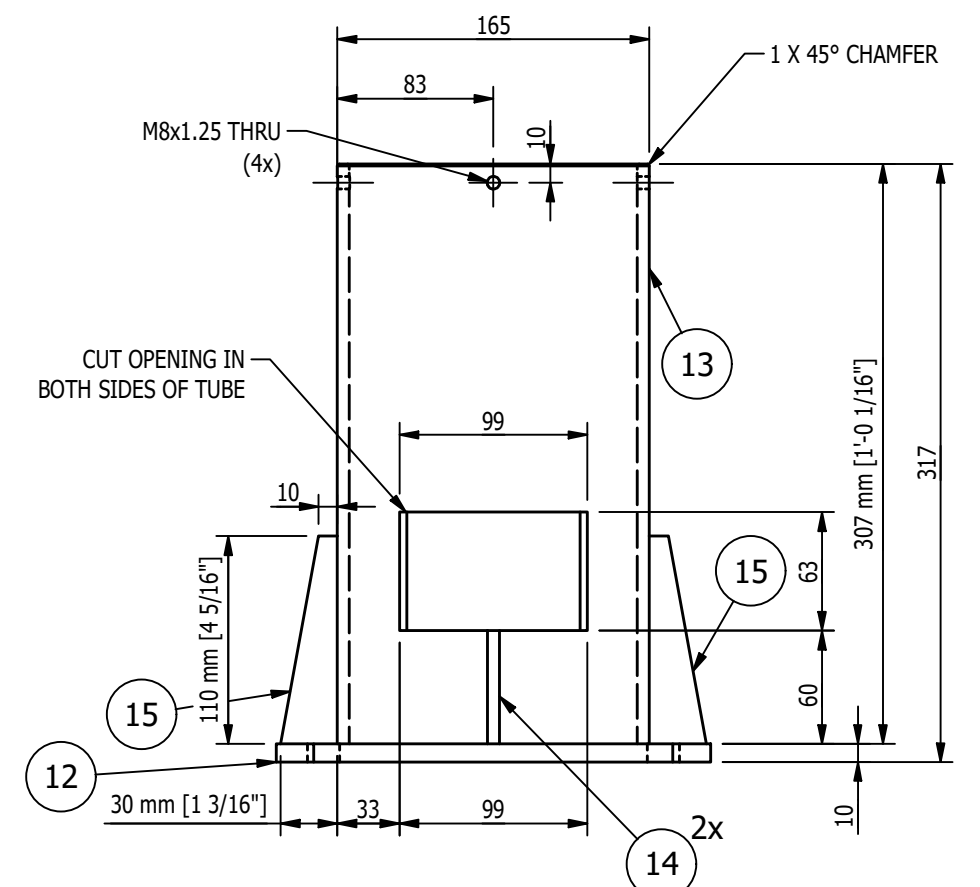
VIEW 'D-D'
SCALE 3"=1'-0"



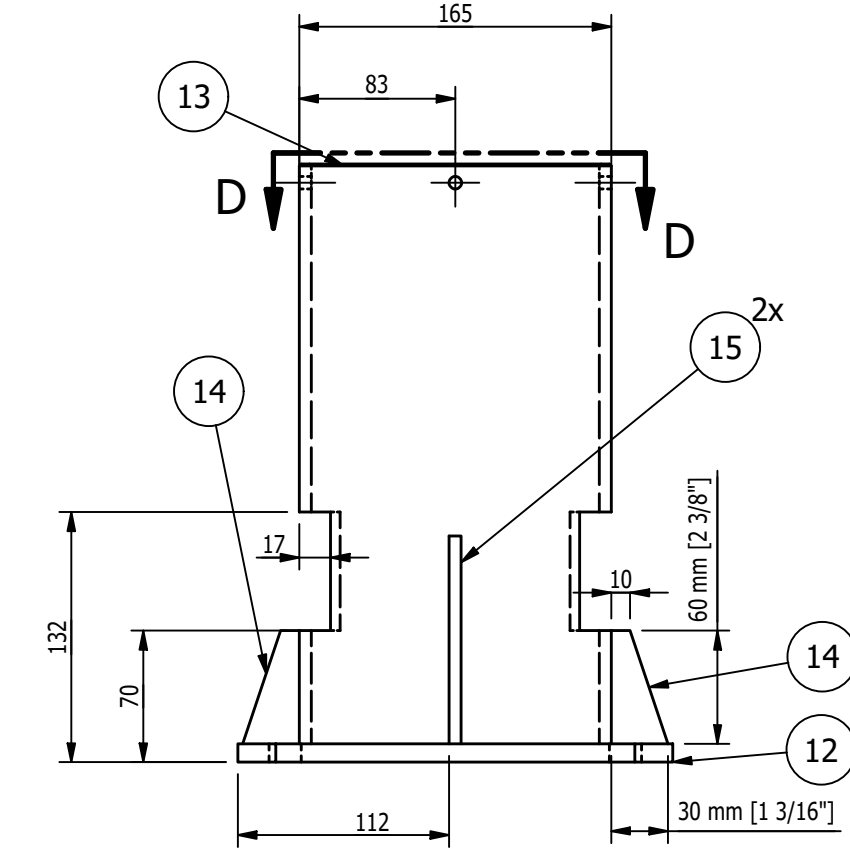
DETAIL ITEM 1
SCALE 3"=1'-0"



DETAIL OF ITEM '3'
SCALE 3"=1'-0"



MK-D014B ~ CENTER POST
SCALE 3"=1'-0"



- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.
DO NOT PAINT ITEMS 3, 4

MAGNUM CONSULTING
41100 Clarkston Road
Suite 125
North, MI 48055
Phone: (248) 373-0322
Fax: (248) 373-0326
Web: www.millic.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D014

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

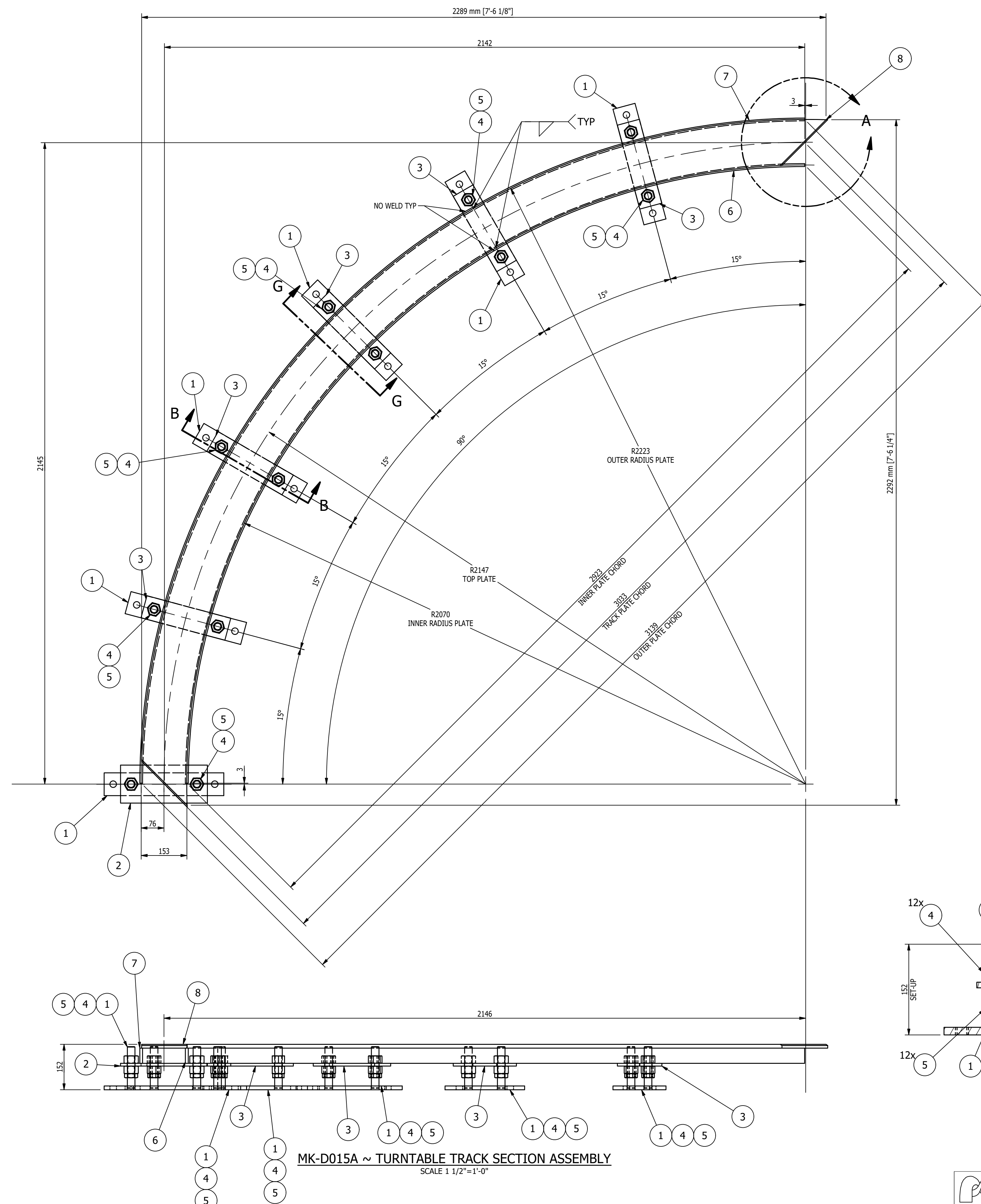
WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

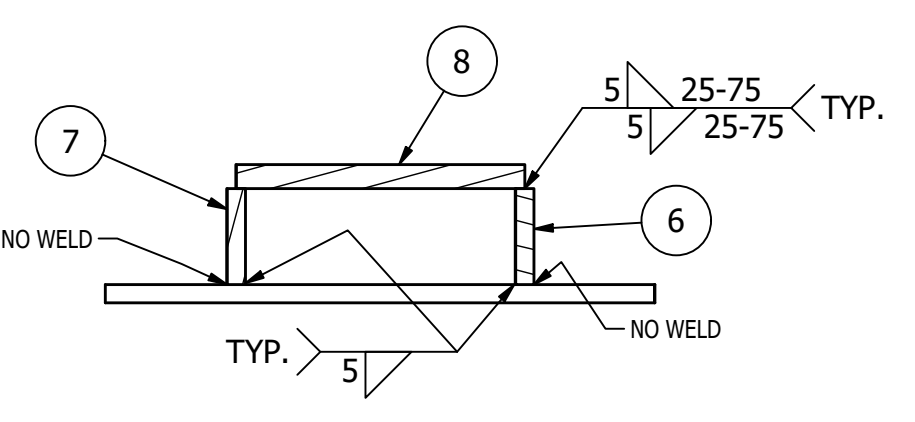
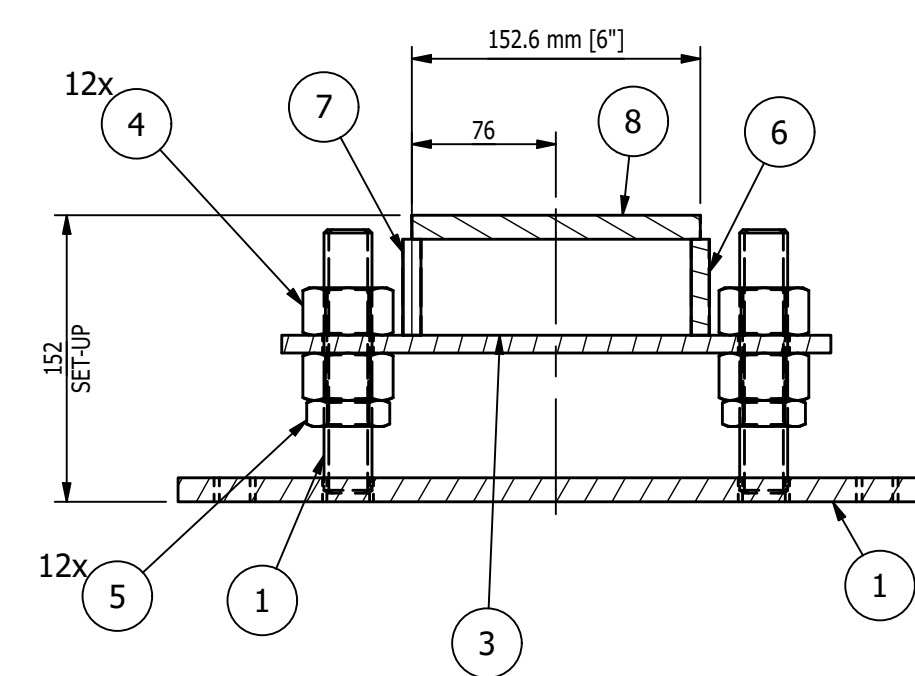
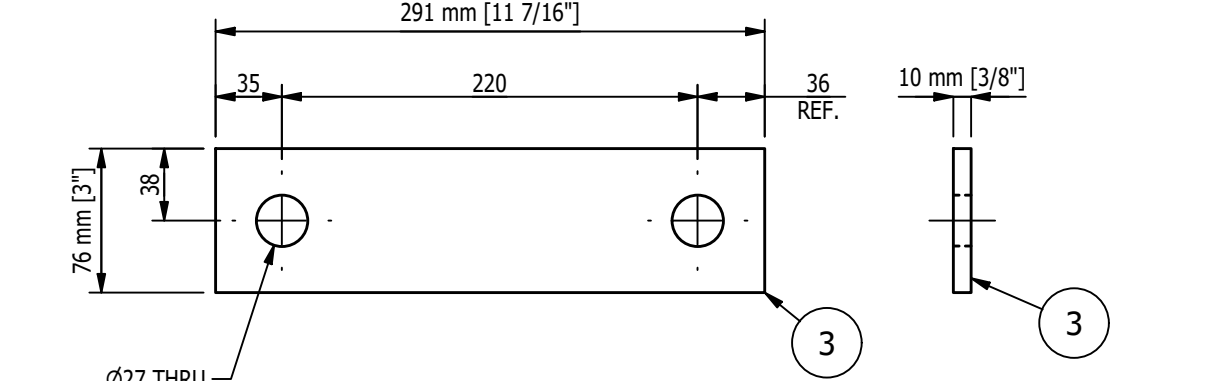
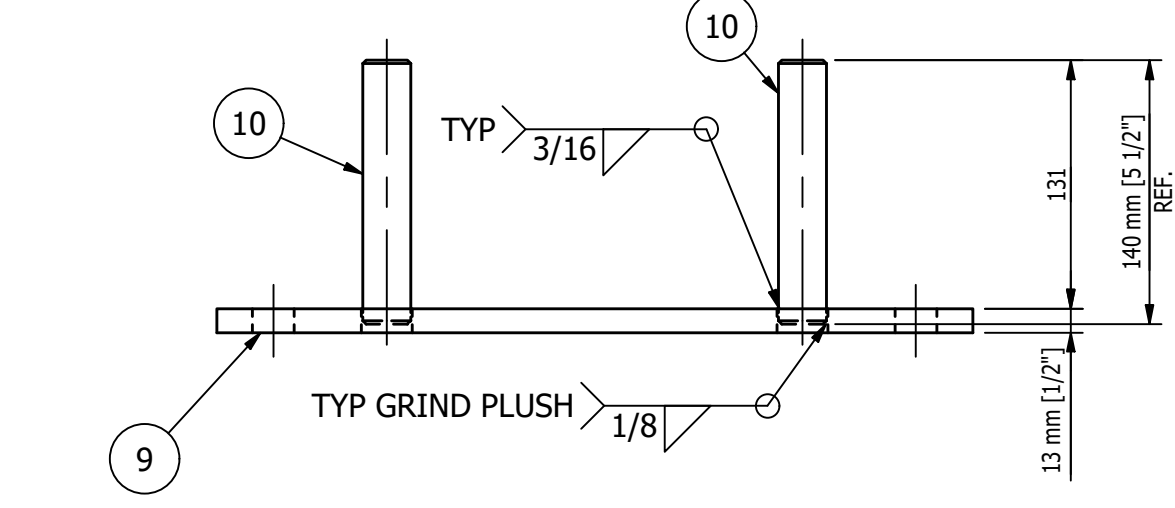
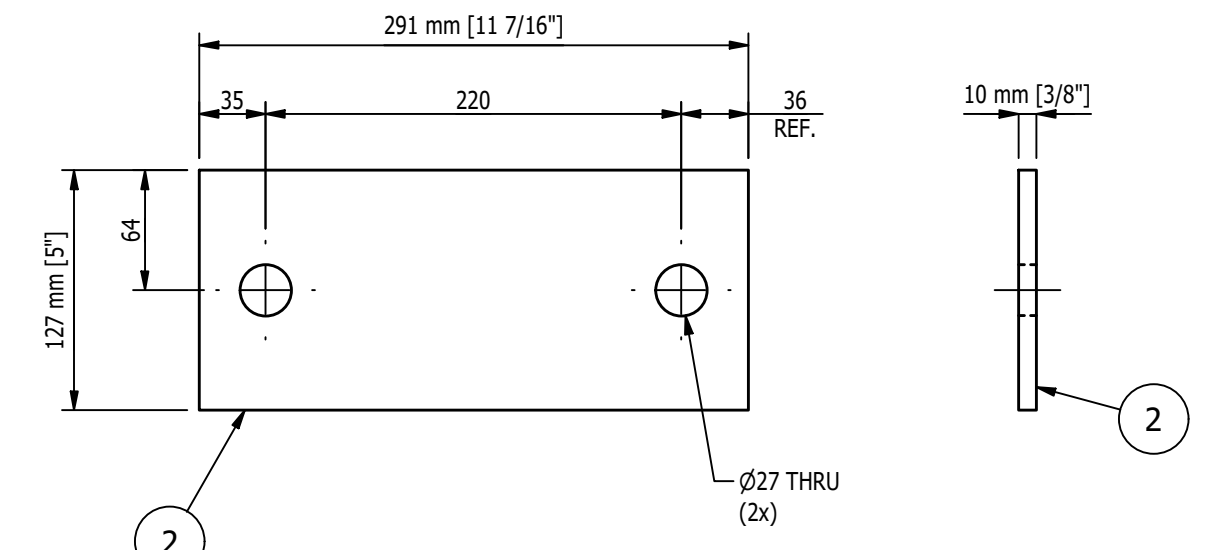
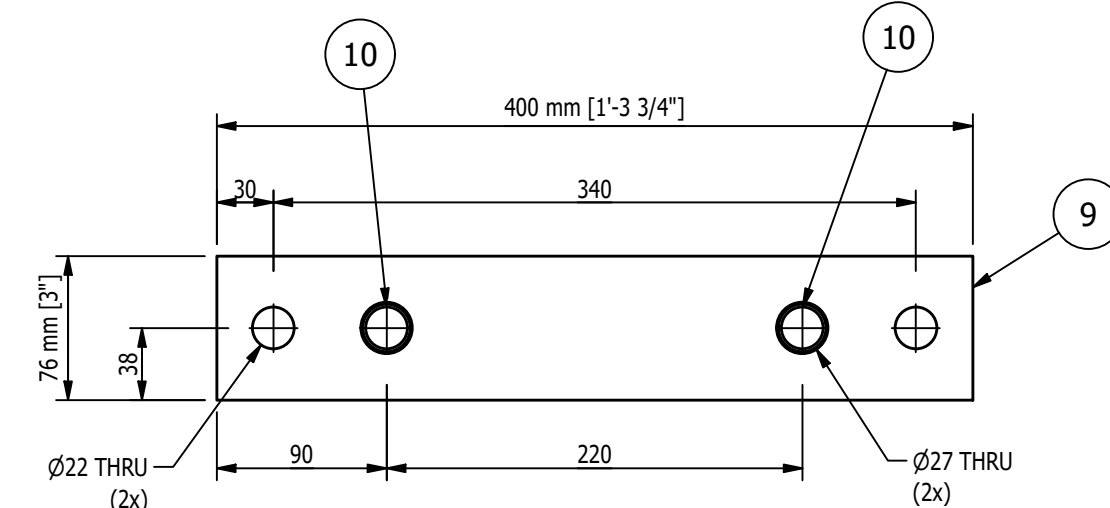
REV	BY	DATE	DESCRIPTION	APP
B	MC	8/18/22	UPDATED ITEM '1' DESCRIPTION, ADDED END VIEW TO ITEM '1', ADJUSTED FASTENERS LOCATIONS, & ADDED DIMS TO ITEM '12'	
A	MC	8/8/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH	
CLIENT:	VOLVO	CHECKED BY:	CW	
DRAWING No.	1875D014	DWG DATE:	6/7/22	
REV:	B	JOB No.:	22096	



ITEM	RADIUS	CHORD	ARC
8 (TOP PLATE)	2147 mm	3033 mm	3372 mm
6 (INNER PLATE)	2070 mm	2923 mm	3255 mm
7 (OUTER PLATE)	2223 mm	3139 mm	3492 mm

BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
1	6	MK-D015A		
2	1	MK-D015B ~ TRACK SUPPORT WELDMENT		
3	5	BAR 3/8 x 5	11 7/16"	
4	24	1-8UNC HEAVY HEX NUT		
5	12	1-8UNC HEX JAM NUT		
6	1	BAR 3/8 x 2	10'-7 3/4"	
7	1	BAR 3/8 x 2	11'-5 3/16"	
8	1	BAR 1/2 x 90 7/16	7'-6 3/8"	
		TOTAL WEIGHT ~ 258.6 lbs		
		MK-D015B		
9	1	BAR 1/2 x 3	1'-3 3/4"	
10	2	THD. ROD 1-8UNC	5 1/2"	
		TOTAL WEIGHT ~ 8.7 lbs		



- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
 ONE SHOP COAT OF LIGHT GREY RAL 7035
 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.
- DO NOT PAINT TOP SURFACE OF ITEM 8

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/18/22	ADDED BEVEL CUTS TO ITEM '8'	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D015	DWG DATE:	6/7/22
REV:	B	JOB No.:	22096

MAGNUM CONSULTING
 41100 QuakerRoad Rd.
 Suite 125
 West, MI 48375

Phone: (248) 773-8822
 Fax: (248) 773-8851
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D015 - REV B

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005

FRACTIONS = ±1/16"
 ANGLES = ±1°30'

BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNIUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

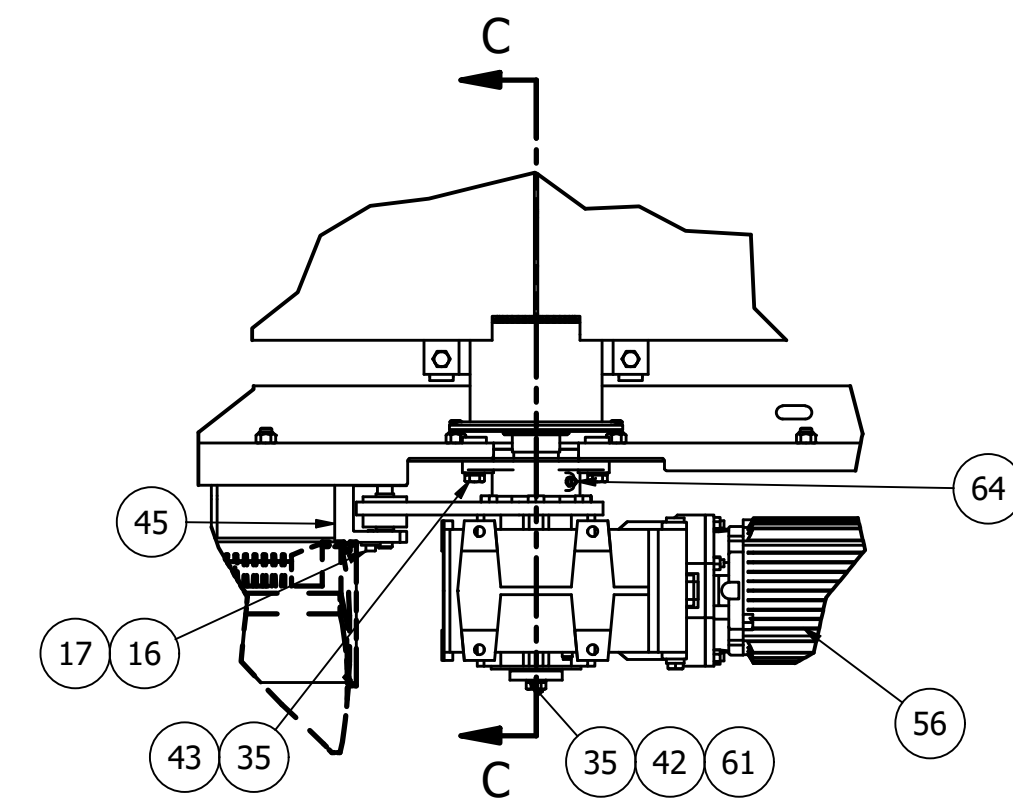
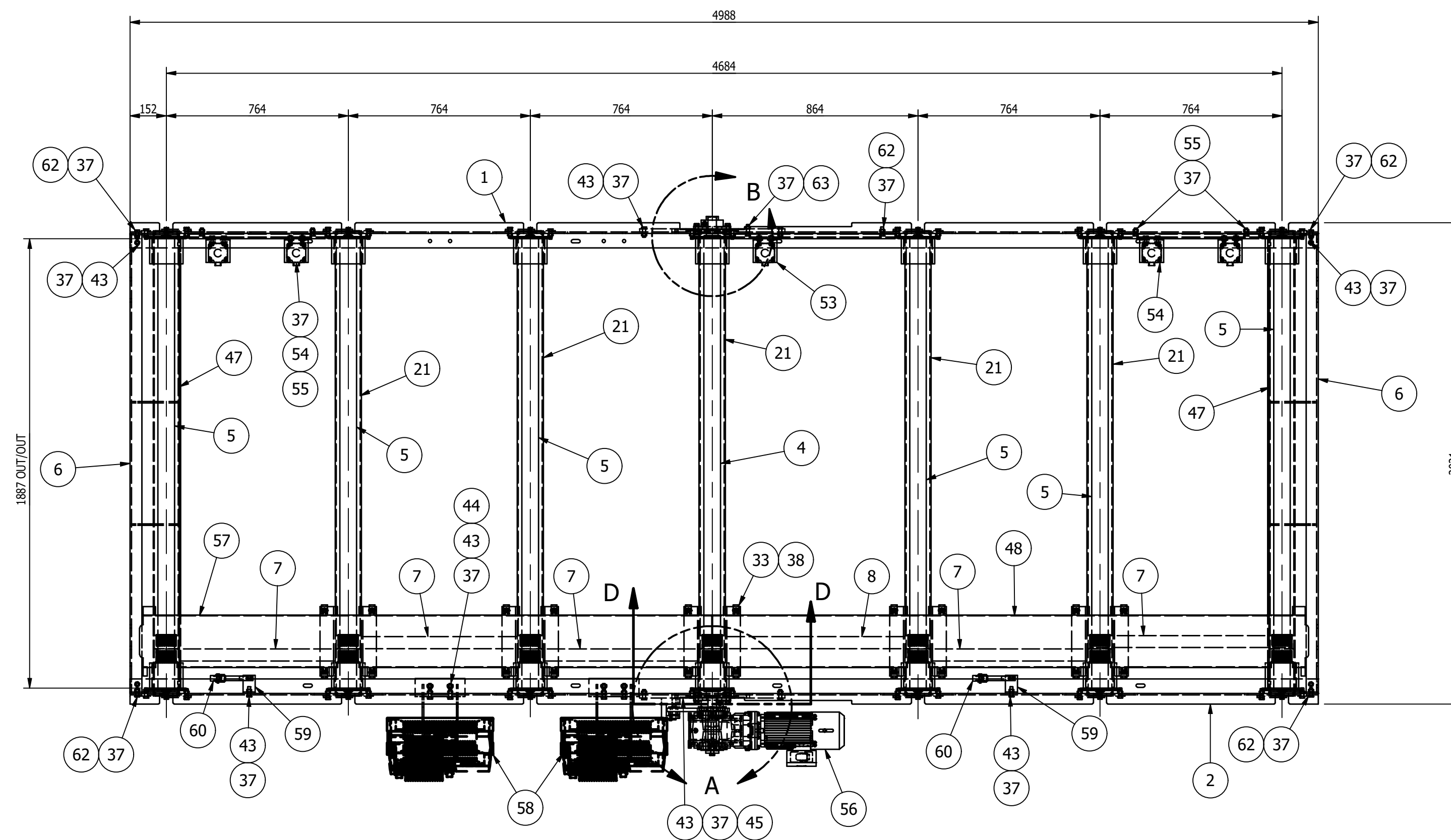
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:

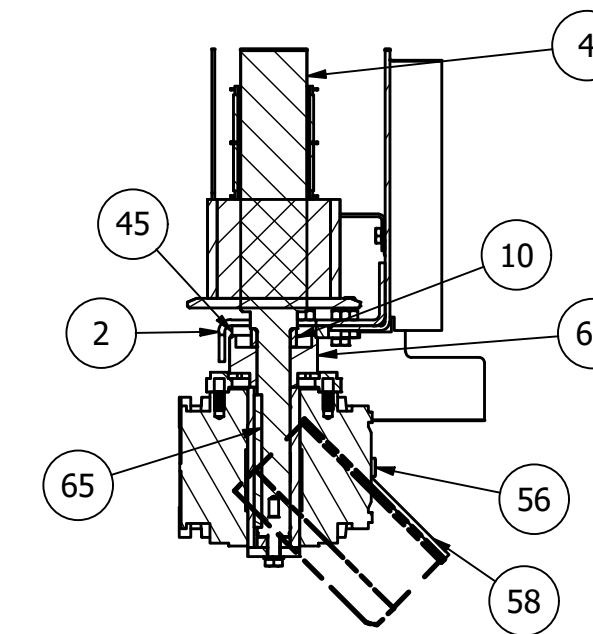
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

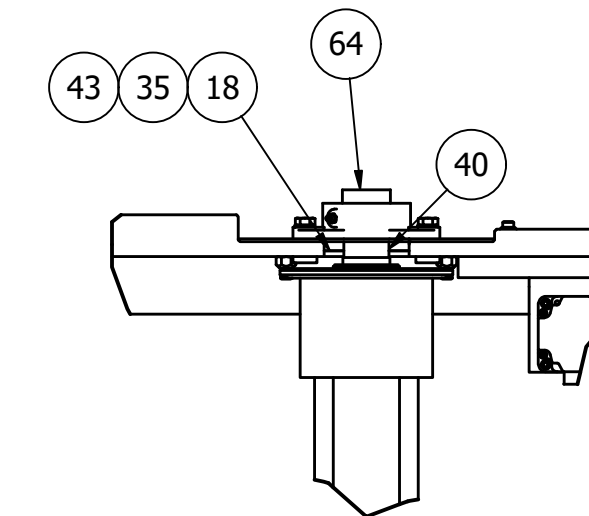
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



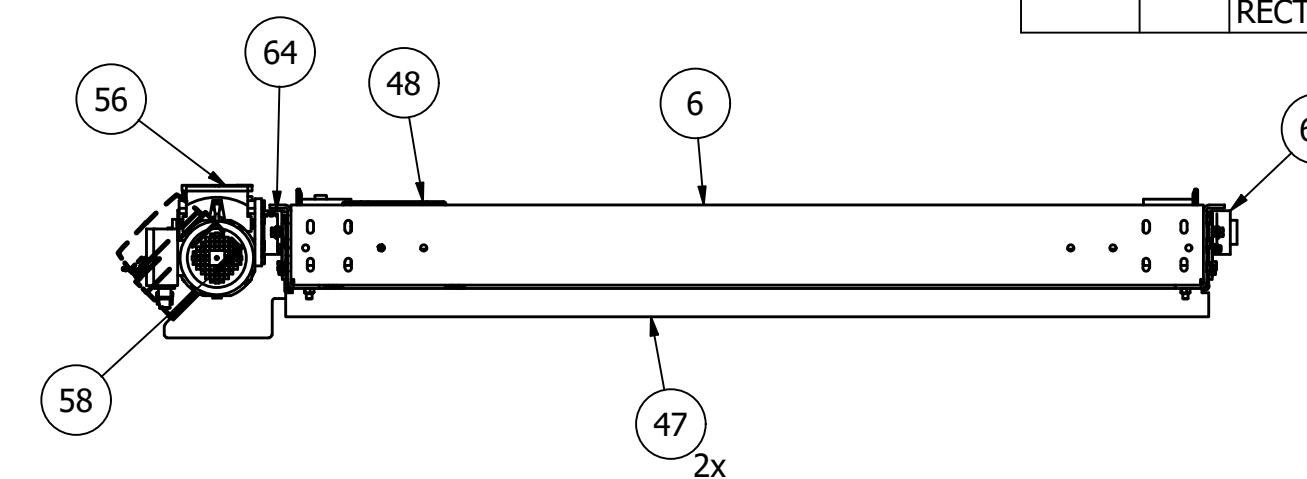
ENLARGED VIEW 'A'
SCALE 1 1/2" = 1'-0"



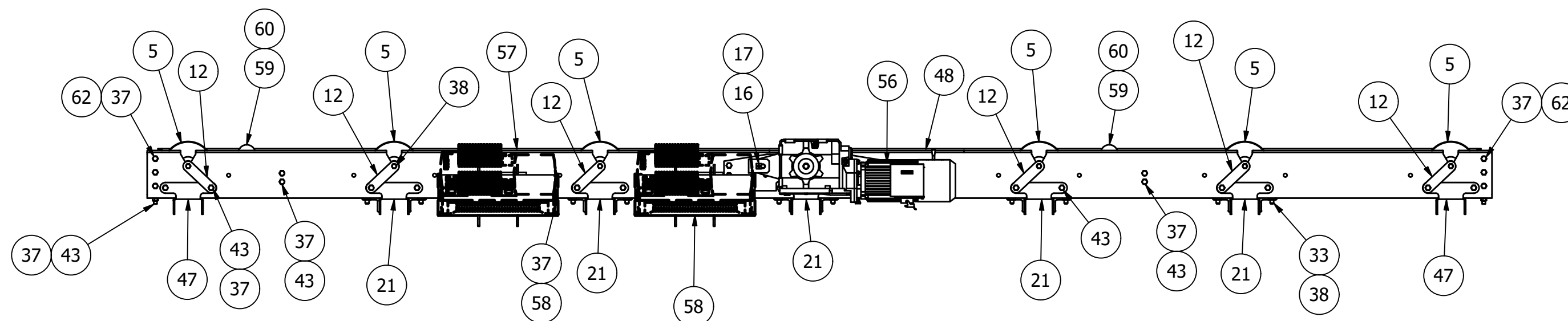
SECTION 'C-C'
SCALE 1 1/2" = 1'-0"



ENLARGED VIEW 'B'
SCALE 1 1/2" = 1'-0"



SECTION 'D-D'
SCALE 1" = 1'-0"



MK-D016A ~ 7-ROLL ASSEMBLY FOR TURNTABLE
SCALE 3/4" = 1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D016A			
1	1	MK-D012A ~ 7-ROLL SIDE FRAME ASSY - RH			
2	1	MK-D012B ~ 7-ROLL SIDE FRAME ASSY - LH			
4	1	D140/70x8/35 HTD 8M-55 POWER ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVE ROLL, PART NO. 332306V			
5	6	D140/70/30 Z34 HTD 8M-55 DRIVEN ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVEN ROLL, PART NO. 329A060W			
6	2	MK-D002A ~ END PLATE ASSEMBLY			
7	5	GATES POWERGRIP GT4 BELT, 1800-8M-GT50		2-5	
8	1	GATES POWERGRIP GT4 BELT, 2000-8M-GT50		2-4	
10	1	MK-D005D ~ SHAFT SPACER			
12	12	MK-D005B ~ ROLL KEEPER			
16	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
17	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
18	1	MK-D005C ~ BEARING PLATE			
21	5	MK-D004C ~ CROSS MEMBER WITH GUARD SUPPORT			
33	20	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
35	5	M12 SPRING LOCK WASHER			
37	73	M12 x 1.75 STOVER LOCK NUT			
38	32	M10x1.5 x 25mm LG. HEX CAP SCREW			
40	1	MK-D005E ~ SHAFT SPACER			
42	1	MK-D005F ~ MOTOR END PLATE			
43	59	M12x1.75 x 35mm LG. HEX CAP SCREW			
44	8	M12 NARROW FLAT WASHER			
45	1	MK-D005A ~ BEARING PLATE			
47	2	MK-D004E ~ CROSS MEMBER			
48	1	MK-D010E ~ BELT GUARD			
53	1	MK-D009C ~ PROX BRACKET			
54	2	MK-D009D ~ PROX BRACKET			
55	4	M12x1.75 x 25mm LG. HEX CAP SCREW			
56	1	SIEMENS RB2 GEARMOTOR (SEE MOTOR DATA LIST)		1-2	
57	1	MK-D010A ~ BELT GUARD			
58	2	MK-D047A ~ CONTROLLER BRACKET			
59	2	MK-D005G ~ STATIC WHEEL BRACKET			
60	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
61	1	M12x1.75 x 45mm LG. HEX CAP SCREW			
62	13	M12x1.75 x 30mm LG. HEX CAP SCREW			
63	1	M12x1.75 x 40mm LG. HEX CAP SCREW			
64	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
65	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	

SPEED FORMULA (60HZ):

$$\pi \times 1760 \times \frac{1}{37.18} \times \frac{140}{1000} = 20.8 \text{ m/min} = 68.3 \text{ ft/min}$$

- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8821
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D016

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/18/22	ADDED BALLOONS TO IDENTIFY ITEMS '10' & '40' FOR FABRICATION	
A	MC	8/8/22		

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING

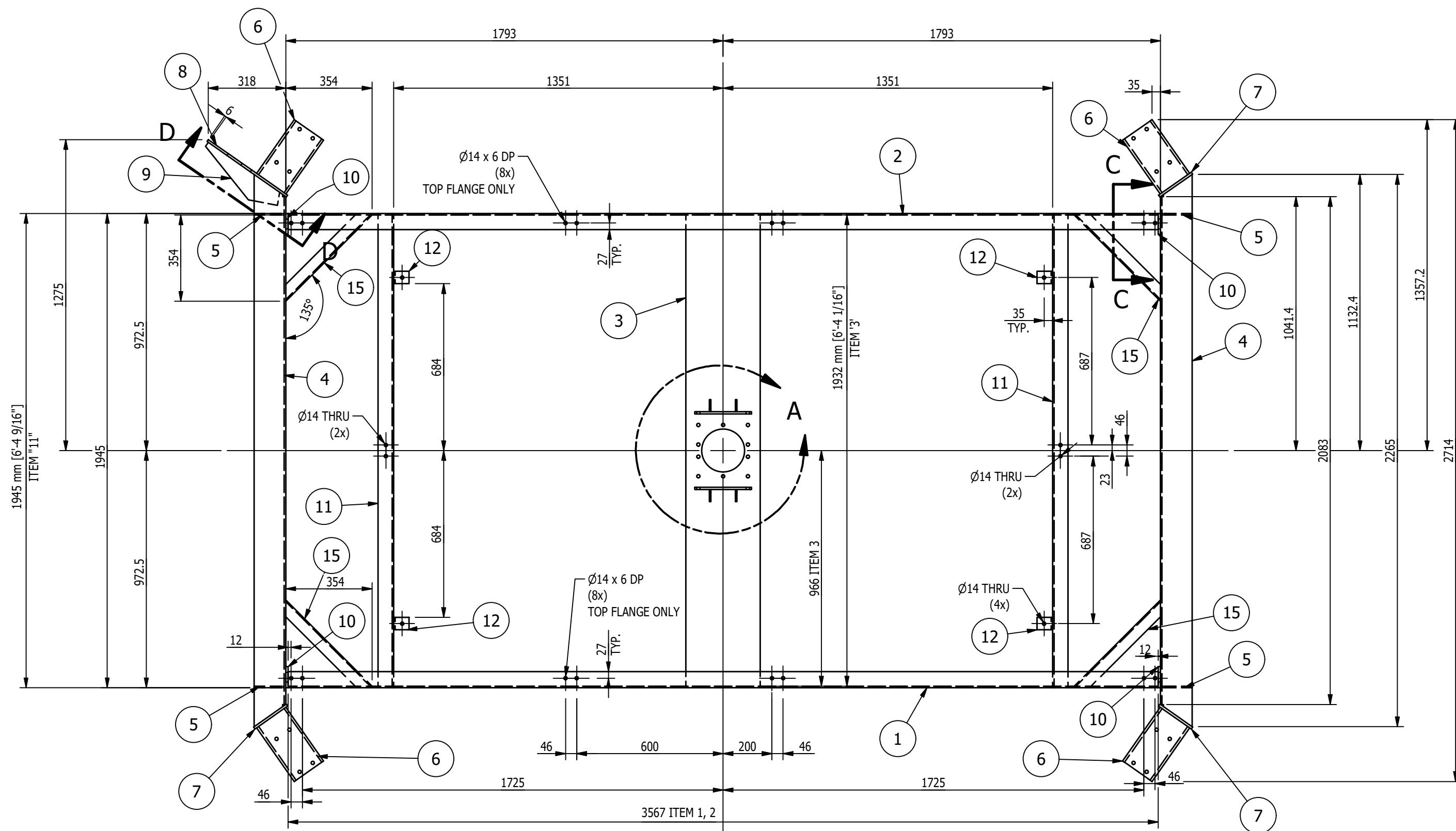
CLIENT: VOLVO

DRAWING No. 1875D016

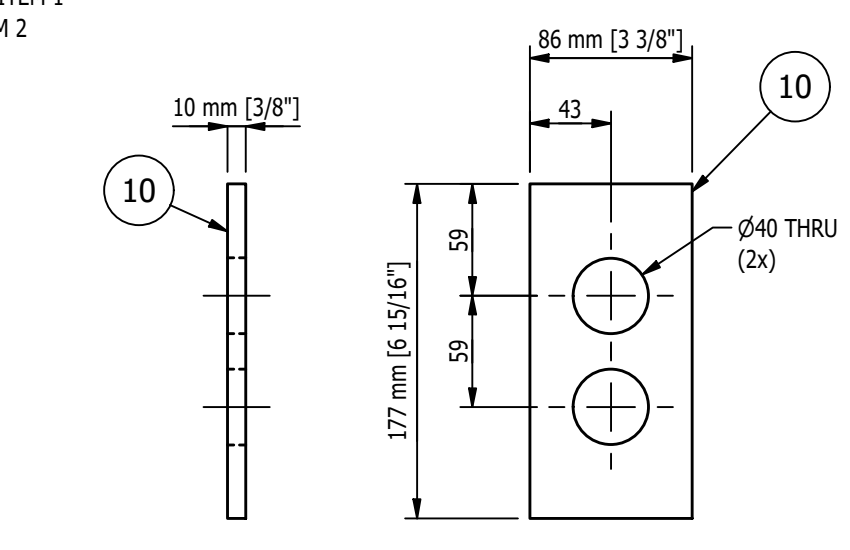
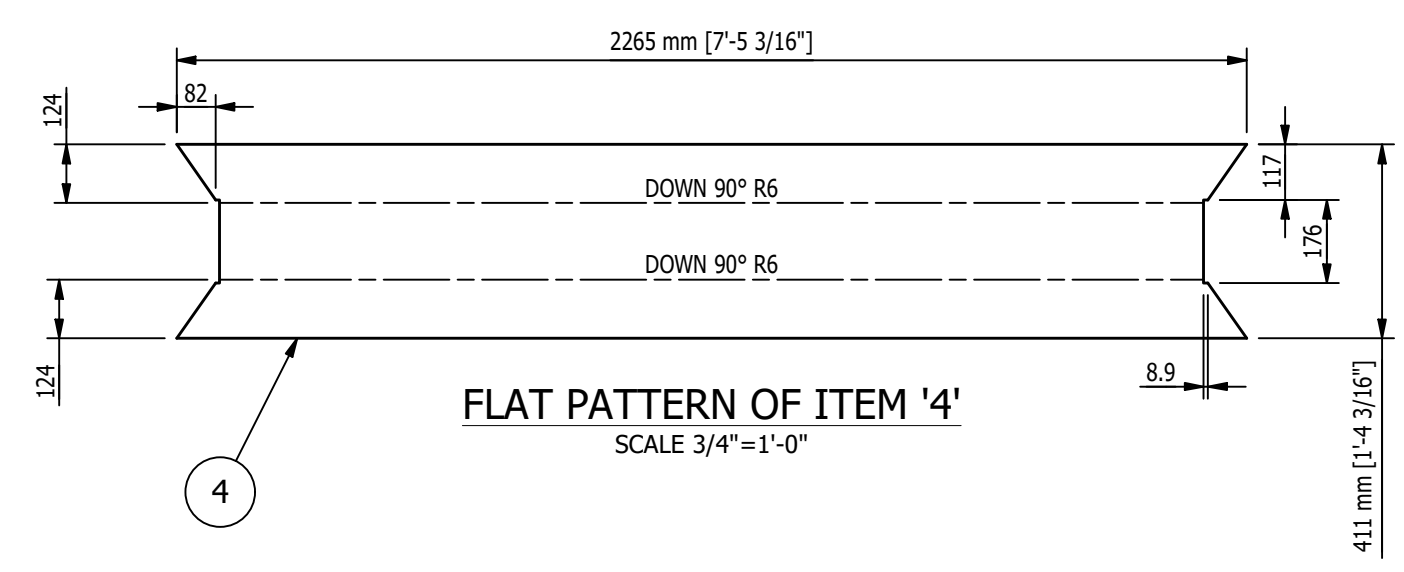
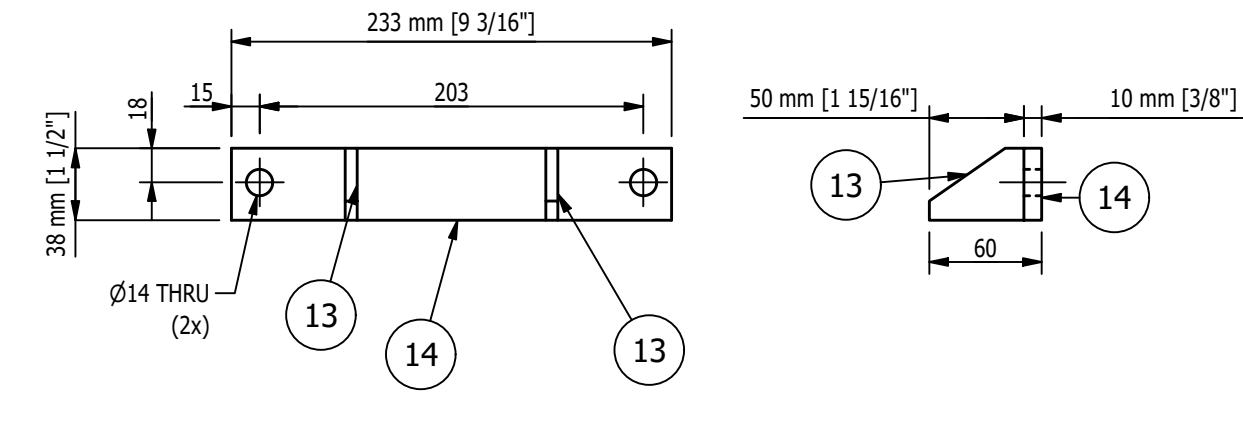
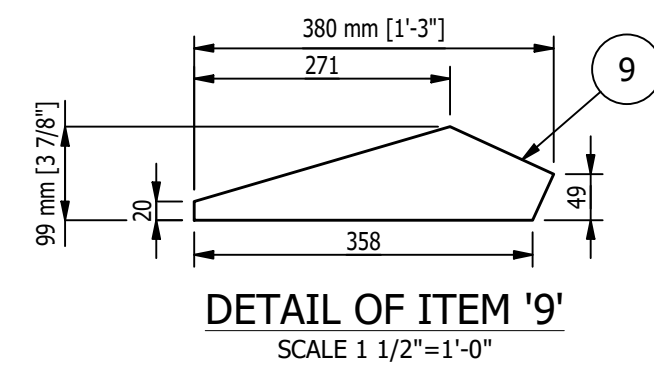
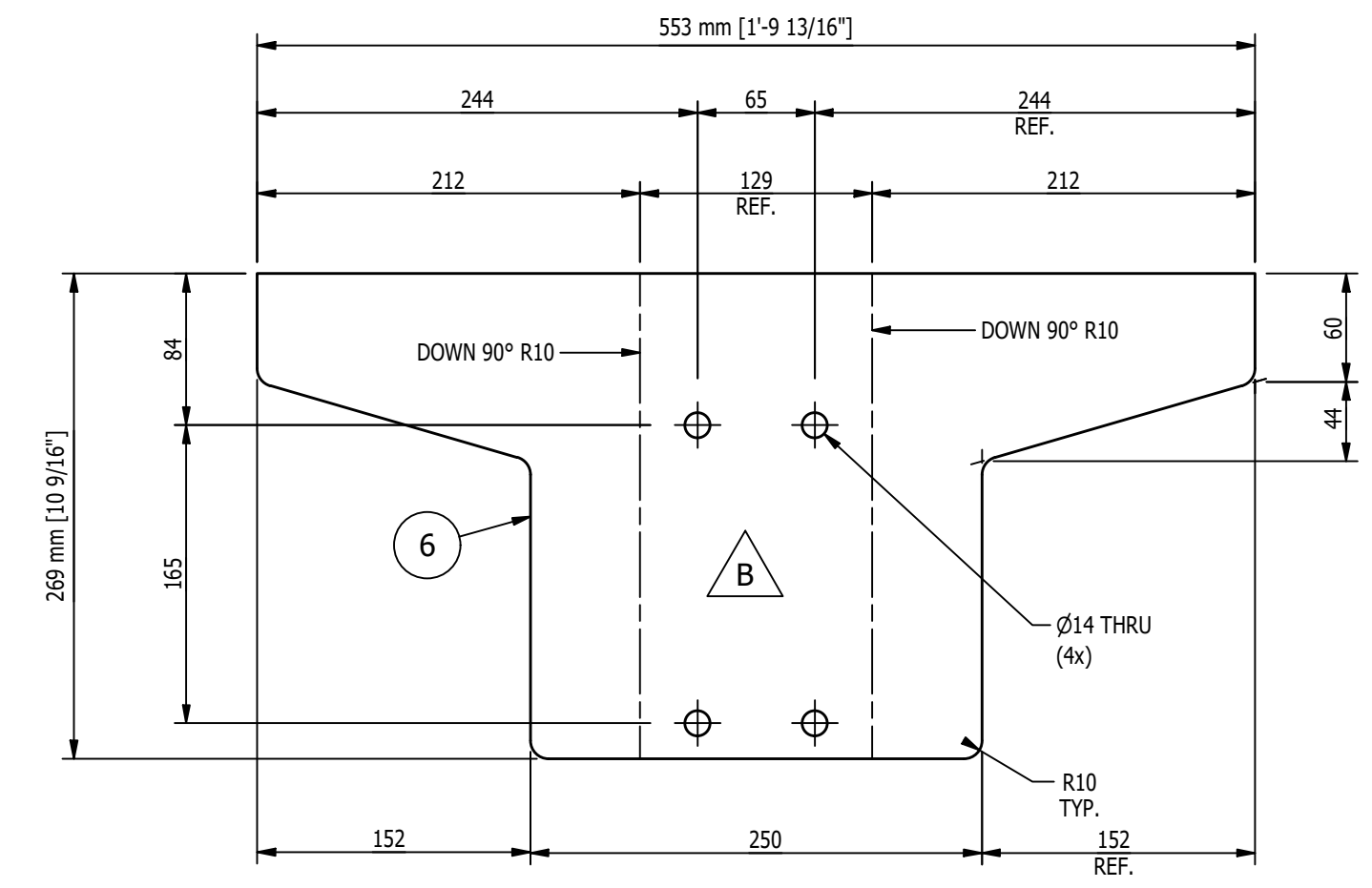
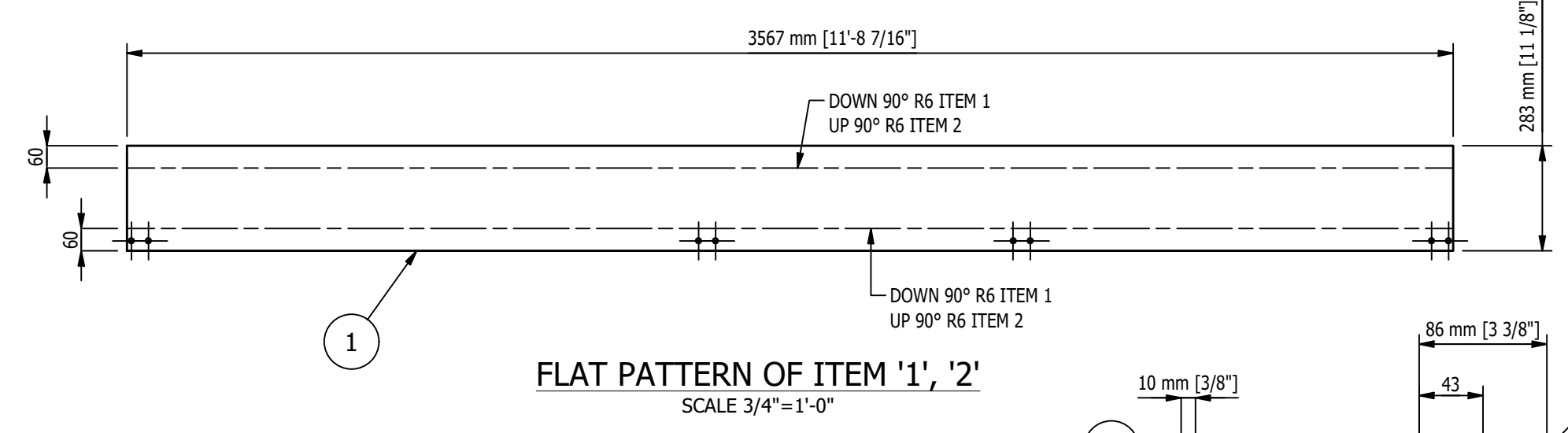
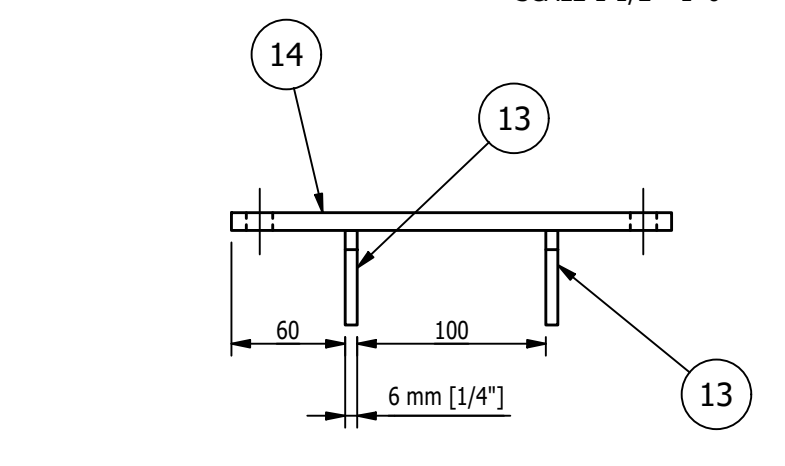
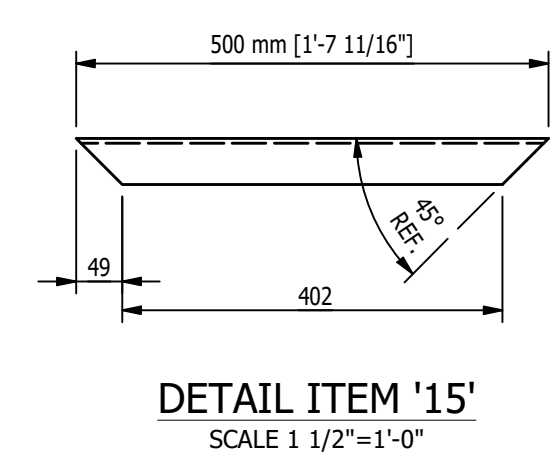
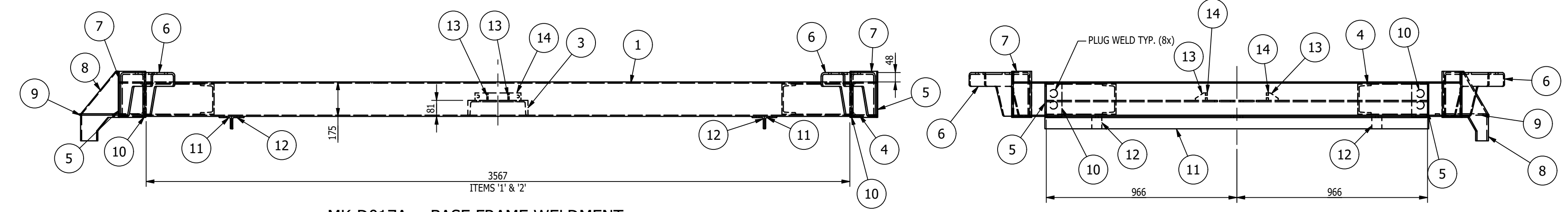
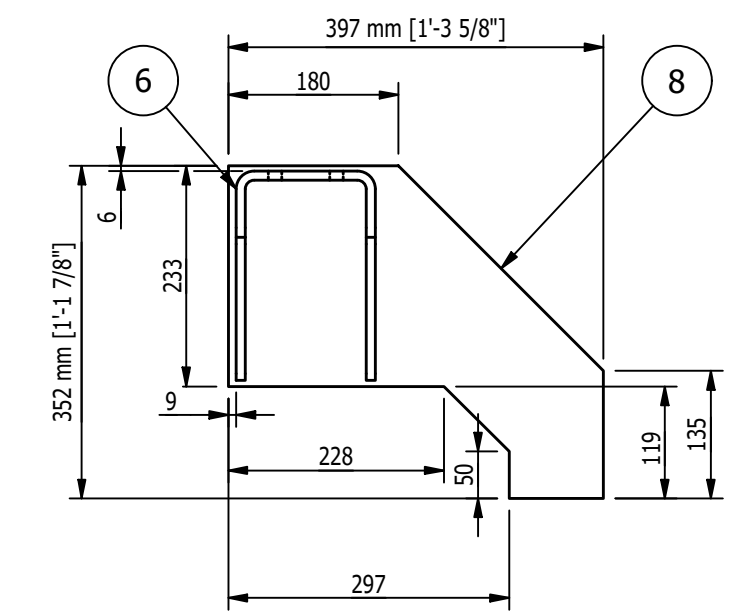
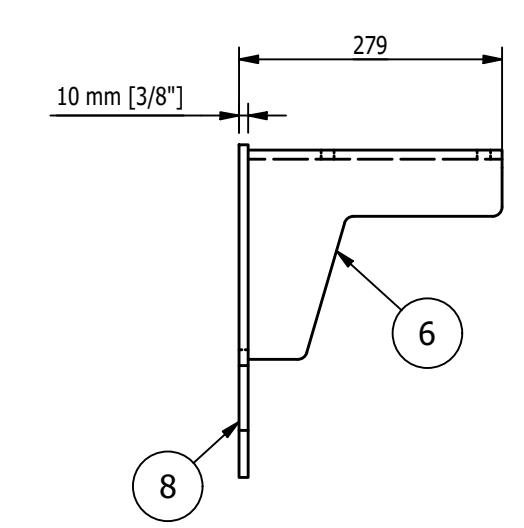
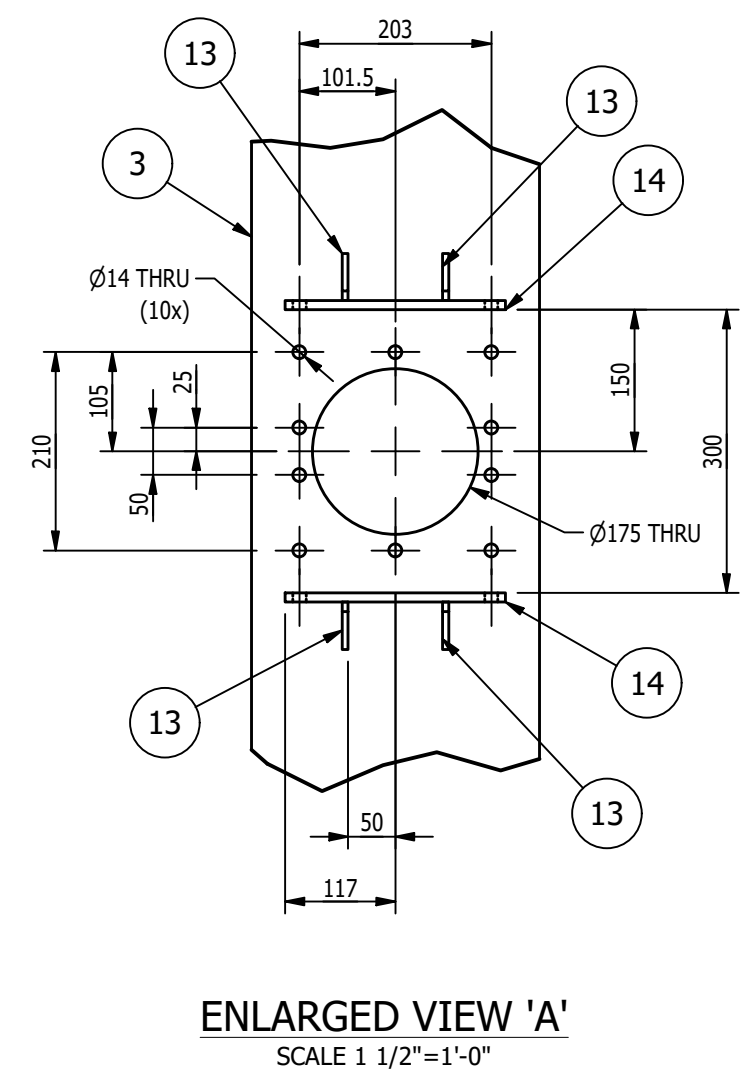
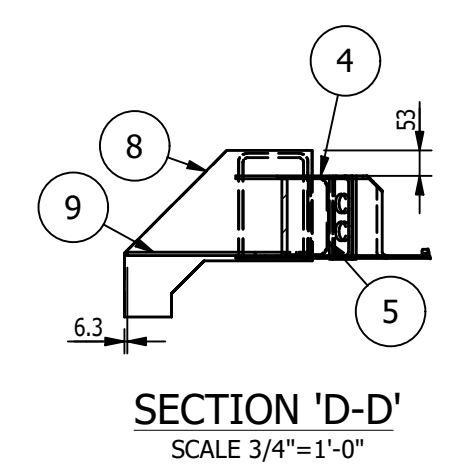
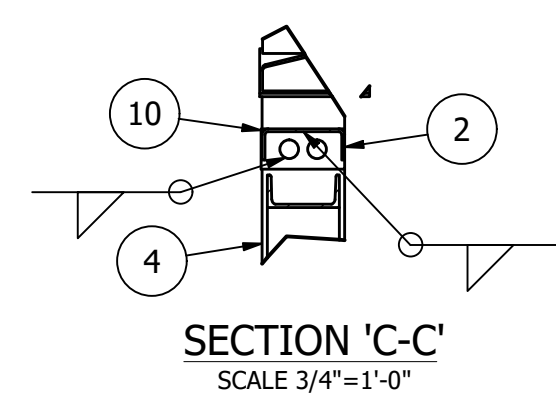
REV: B

JOB No. 22096

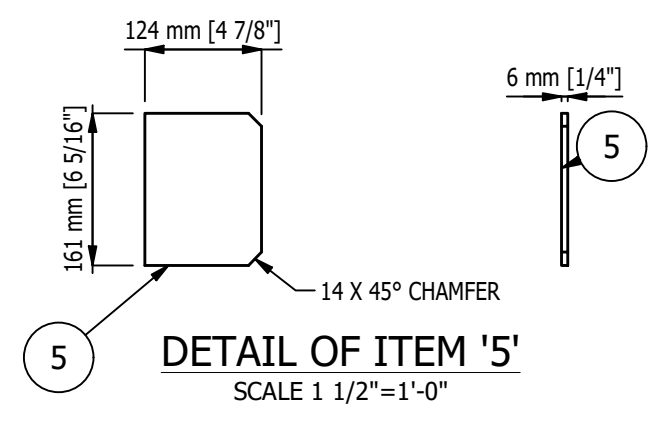
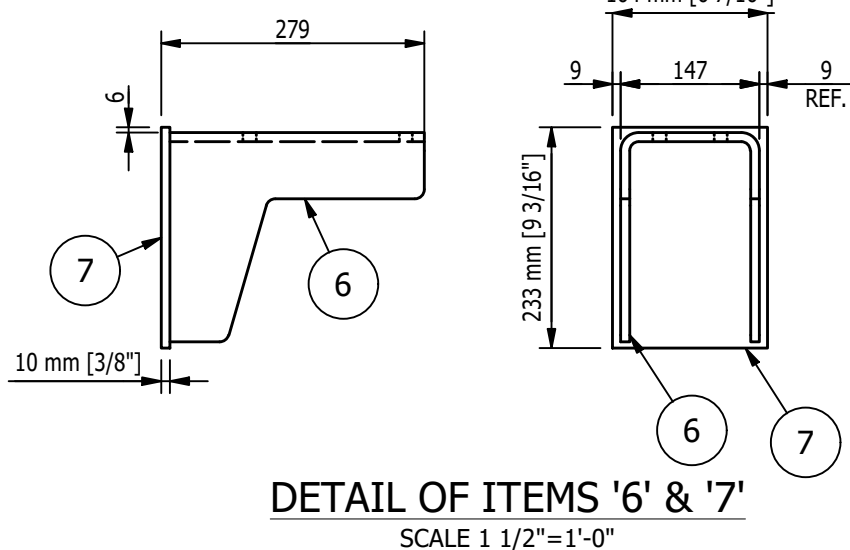
DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 6/7/22



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D017A			
1	1	BAR 1/4 x 11 1/8	11'-8 7/16"		
2	1	BAR 1/4 x 11 1/8	11'-8 7/16"		
3	1	C 12 x 20.7	6'-4 1/16"		
4	2	BAR 1/4 x 16 3/16	7'-5 3/16"		
5	4	PL 1/4 x 4 7/8	6 5/16"		
6	4	PL 3/8 x 10 9/16	1'-9 13/16"		
7	3	PL 3/8 x 6 7/16	9 3/16"		
8	1	PL 3/8 x 13 7/8	1'-3 5/8"		
9	1	PL 1/4 x 3 7/8	1'-3"		
10	4	PL 3/8 x 3 3/8	6 15/16"		
11	2	L 2 1/2 x 2 1/2 x 1/4	6'-4 9/16"		
12	4	L 2 1/2 x 2 1/2 x 1/4	2"		
13	4	PL 1/4 x 1 1/2	1 15/16"		
14	2	PL 3/8 x 1 1/2	9 3/16"		
15	4	C 6 x 8.2	1'-7 11/16"		



SHOP NOTES:
 1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.
 9. VIBRATORY STRESS RELIEVE WELDMENT



MAGNUM CONSULTING
 41100 Clarkston Road
 Suite 125
 Novi, MI 48225
 Phone: (248) 772-8800
 Fax: (248) 772-8801
 Web: www.mmagnum.com

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
 WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)
 PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

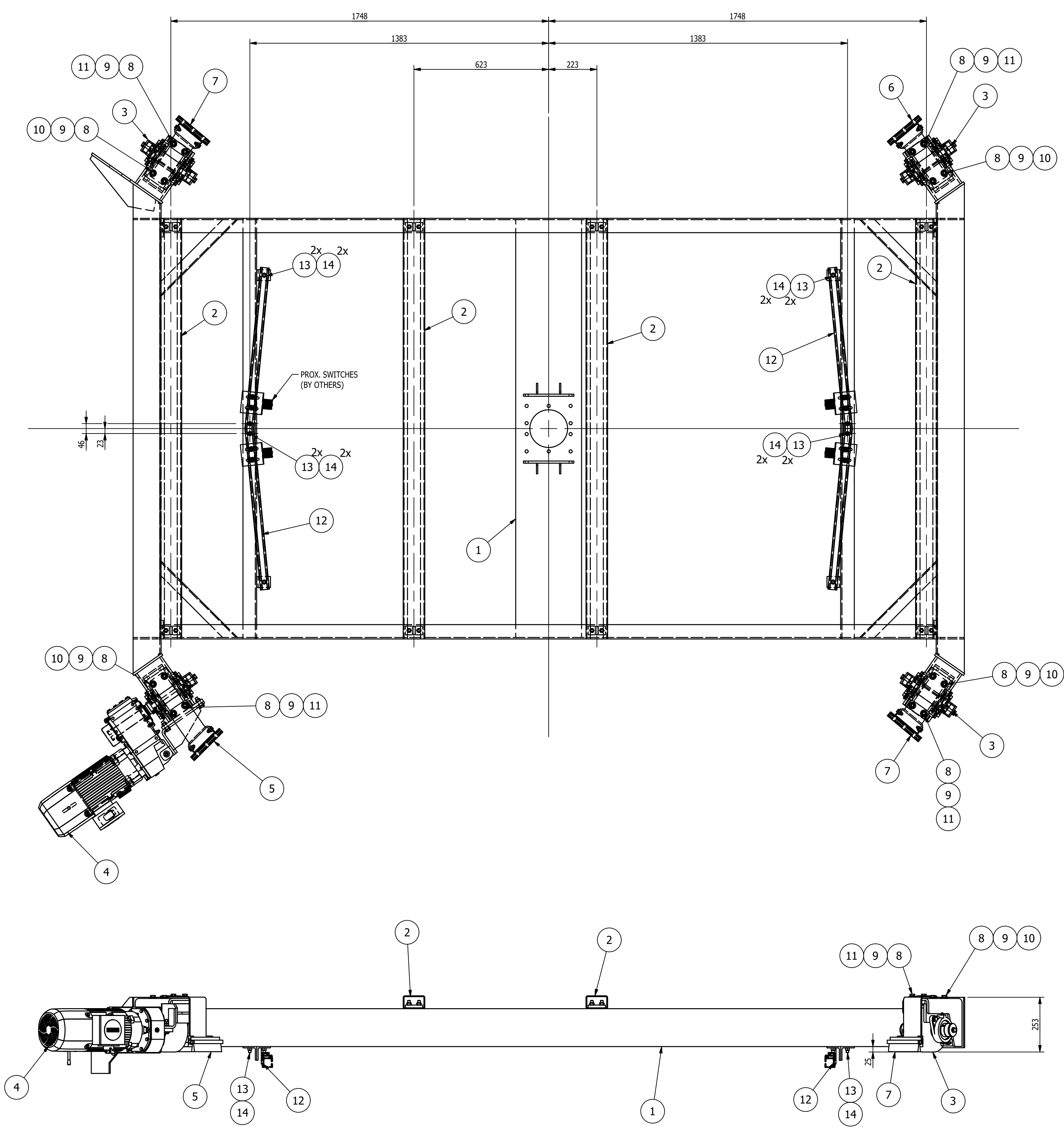
REV	BY	DATE	DESCRIPTION	APP
B	MC	8/26/22	UPDATED CUT OUTS OF ITEM '6'	
A	MC	8/8/22	FOR FABRICATION	

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D017
REV: B

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 6/10/22
JOB No: 22096

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D018A			
1	1	MK-D017A ~ BASE FRAME WELDMENT			
2	4	MK-D019A ~ SUPPORT CHANNEL			
3	3	MK-D020A ~ IDLER WHEEL ASSEMBLY			
4	1	MK-D021A ~ DRIVE WHEEL ASSEMBLY			
5	1	MK-D022A ~ DRIVE WHEEL TRACK BRUSH - LH			
6	1	MK-D022B ~ IDLE WHEEL TRACK BRUSH - LH			
7	2	MK-D022C ~ IDLE WHEEL TRACK BRUSH - RH			
8	16	1/2 SPRING LOCK WASHER			
9	16	1/2 TYPE B REGULAR FLAT WASHER			
10	8	1/2-13UNC x 1 1/2" LG. HEX HEAD CAP SCREW			
11	8	1/2-13UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
12	2	MK-D023A ~ SENSOR STAND			
13	8	M12x1.75 x 30mm LG. HEX CAP SCREW			
14	8	M12 x 1.75 STOVER LOCK NUT			



- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
 PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

MK-D018A ~ CENTER PIVOT TURNTABLE BASE FRAME ASSEMBLY
 SCALE 1"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/6/22	GEOMETRY UPDATED PER ITEM '4'	
B	MC	8/18/22	ADDED BALLOONS SHOWING ITEMS '8', '9', '10', & '11'	
A	MC	08/08/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL
		3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB	
CLIENT:	VOLVO	CHECKED BY:	CW	
DRAWING No.	1875D018	DWG DATE:	6/14/22	
		REV:	C	JOB No: 22096

MAGNUM CONSULTING
 41100 QuakerRoad Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 772-8822
 Fax: (248) 772-8821
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D018

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

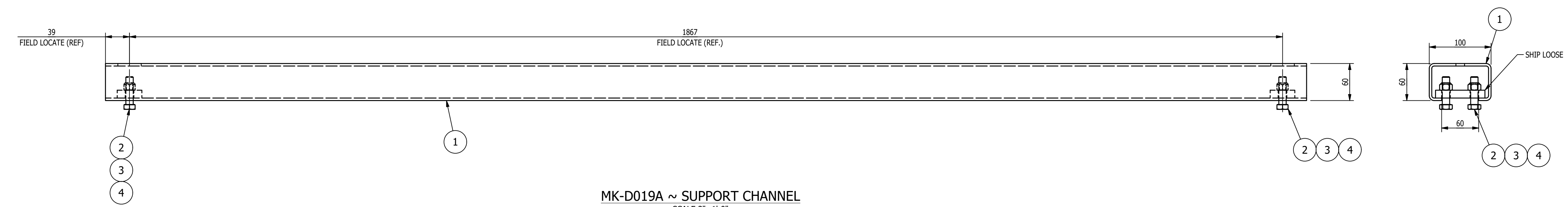
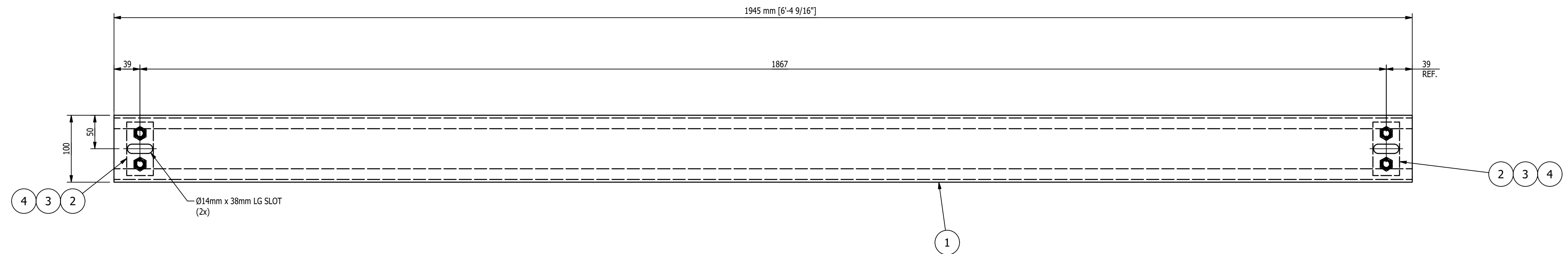
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

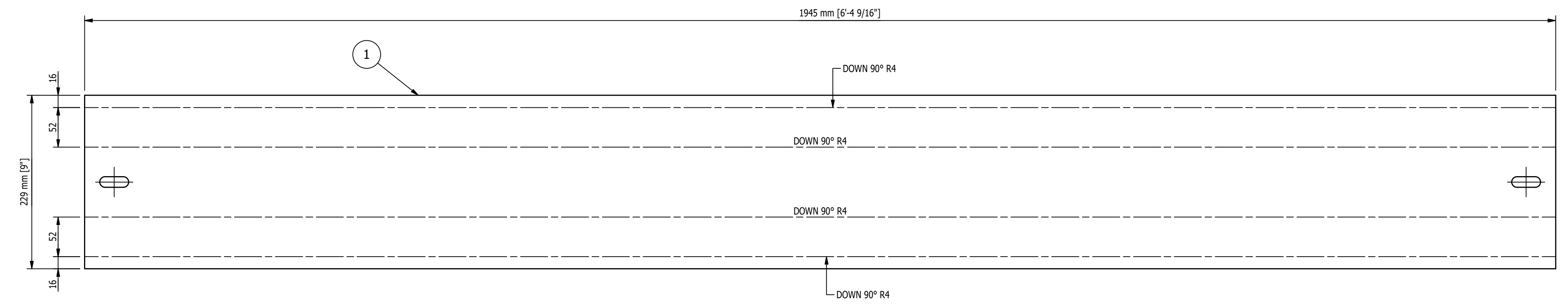
COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

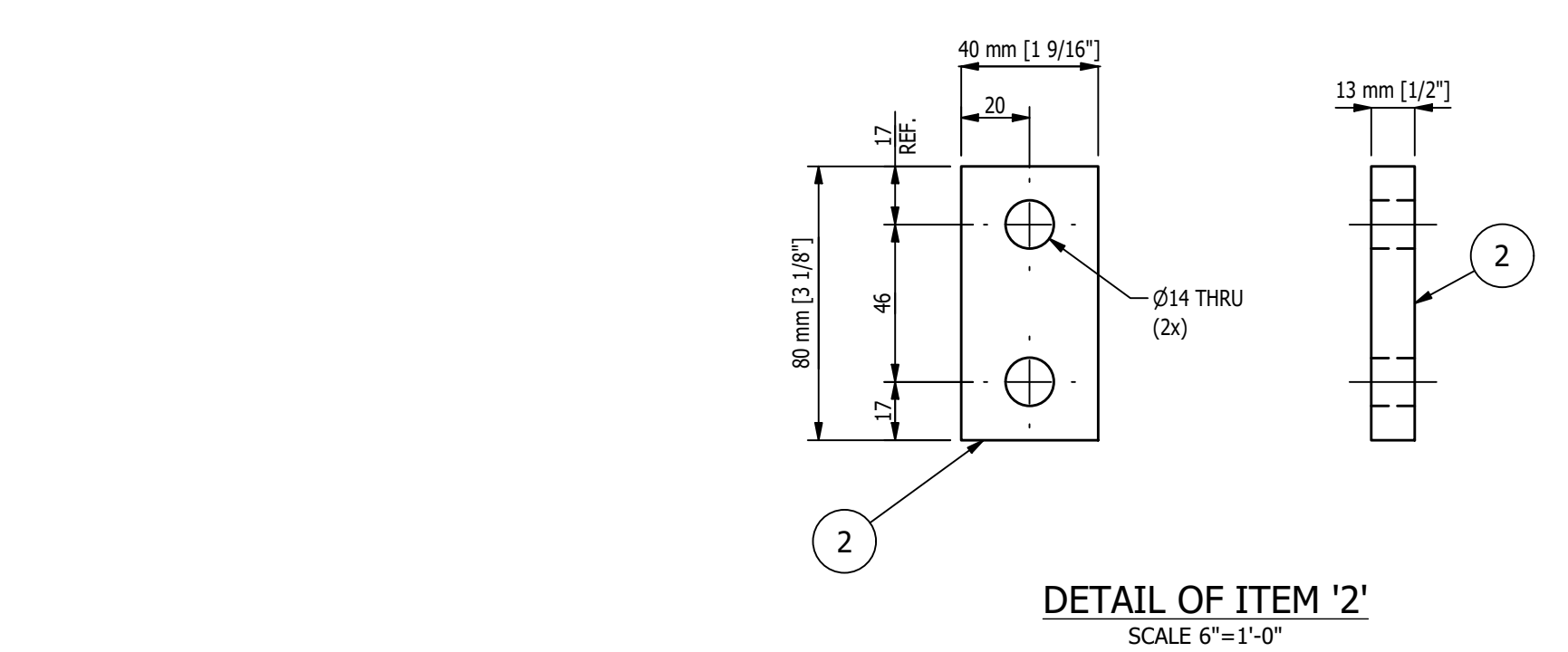
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D019A			
1	1	BAR 3/16 x 9	6'-4 9/16"		
2	2	BAR 1/2 x 1 9/16	3 1/8"		
3	4	M12 x 1.75 STOVER LOCK NUT			
4	4	M12x1.75 x 45mm LG. HEX CAP SCREW			
		TOTAL WEIGHT ~ 34.2 LBS			



MK-D019A ~ SUPPORT CHANNEL
SCALE 3"=1'-0"



FLAT PATTEN OF ITEM '1'
SCALE 3"=1'-0"



DETAIL OF ITEM '2'
SCALE 6"=1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/8/22	FOR FABRICATION	

REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
--	--	---

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D019	DWG DATE:	6/15/22
REV:	A	JOB No.:	22096

MAGNUM CONSULTING

41100 Charleston Rd.
Suite 125
North, MI 48135

Phone: (248) 772-8833
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D019

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

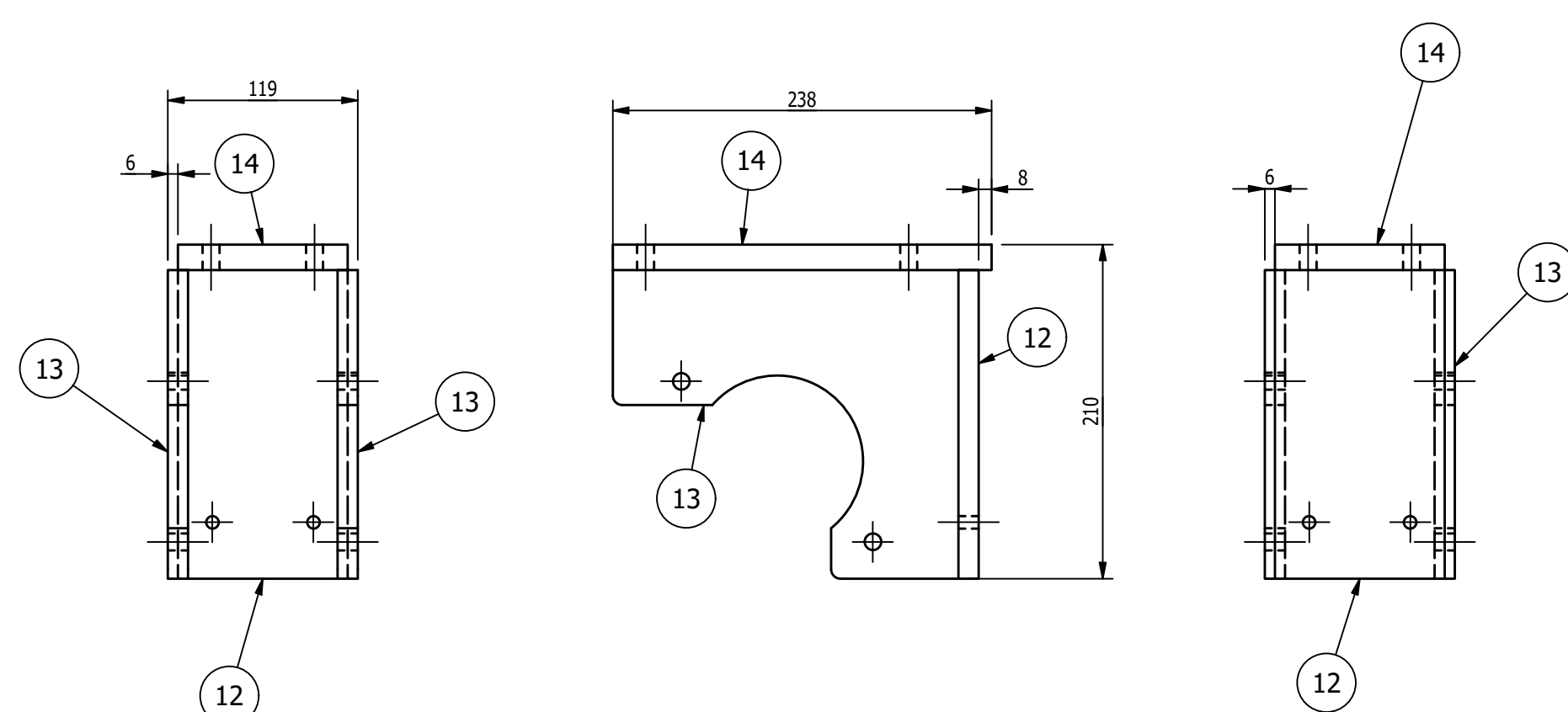
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:

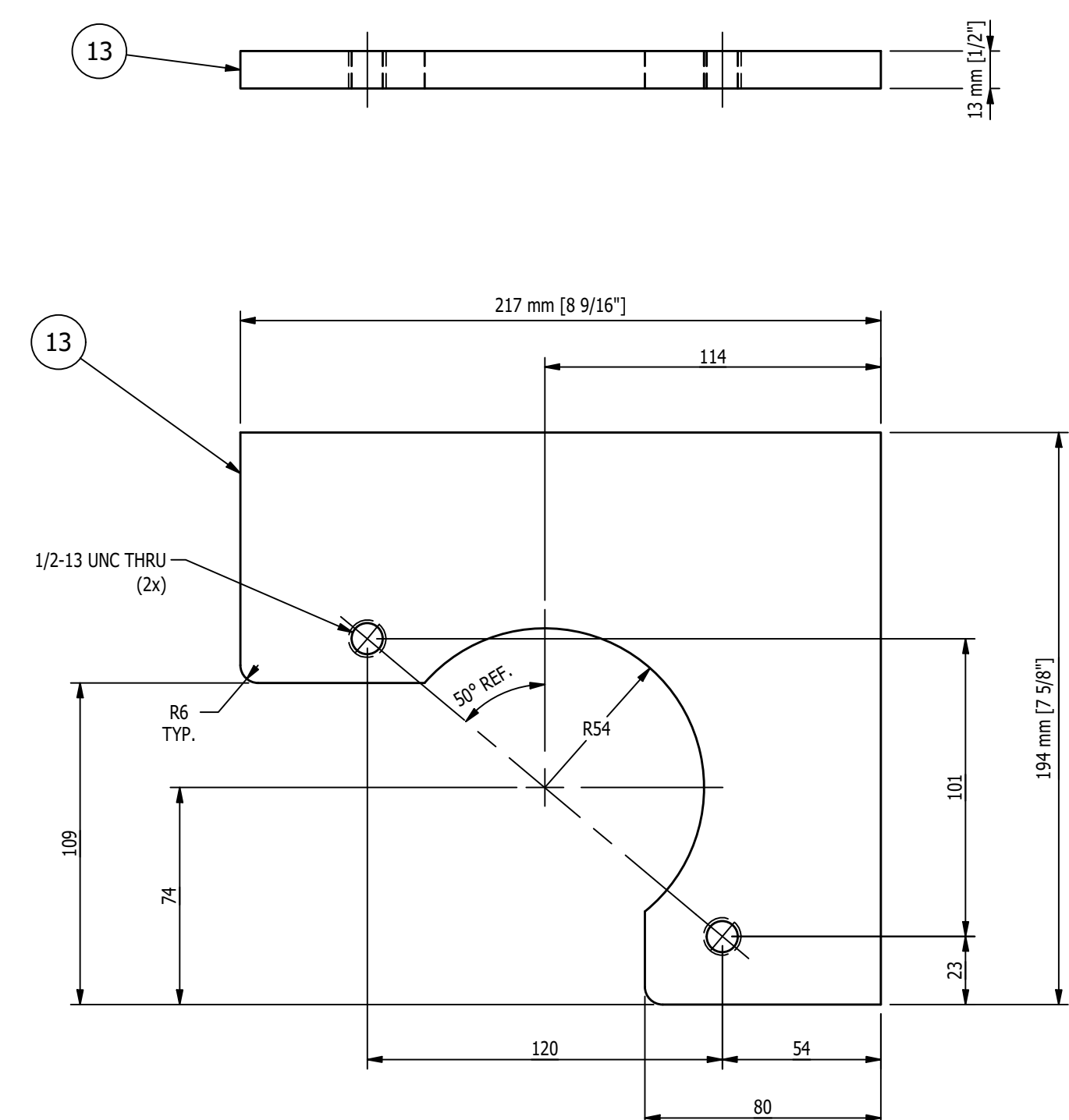
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

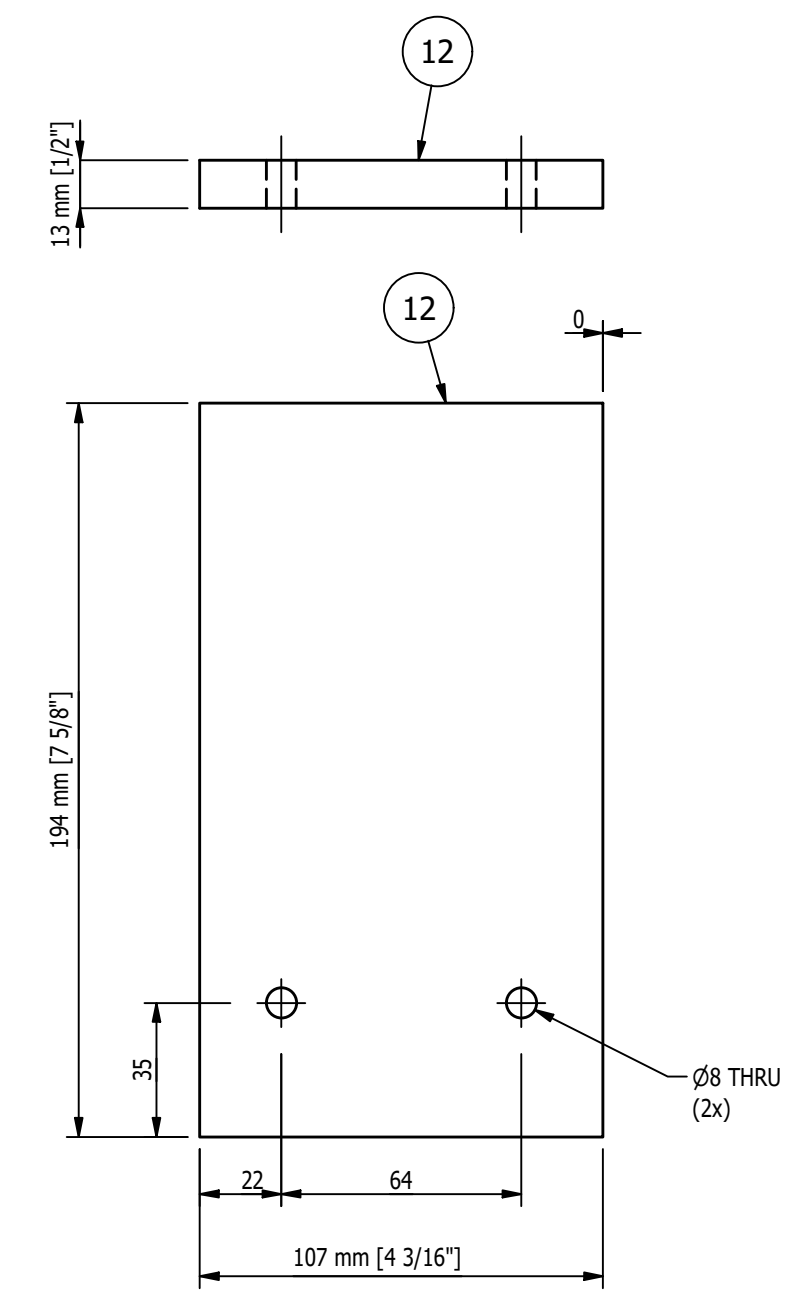
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



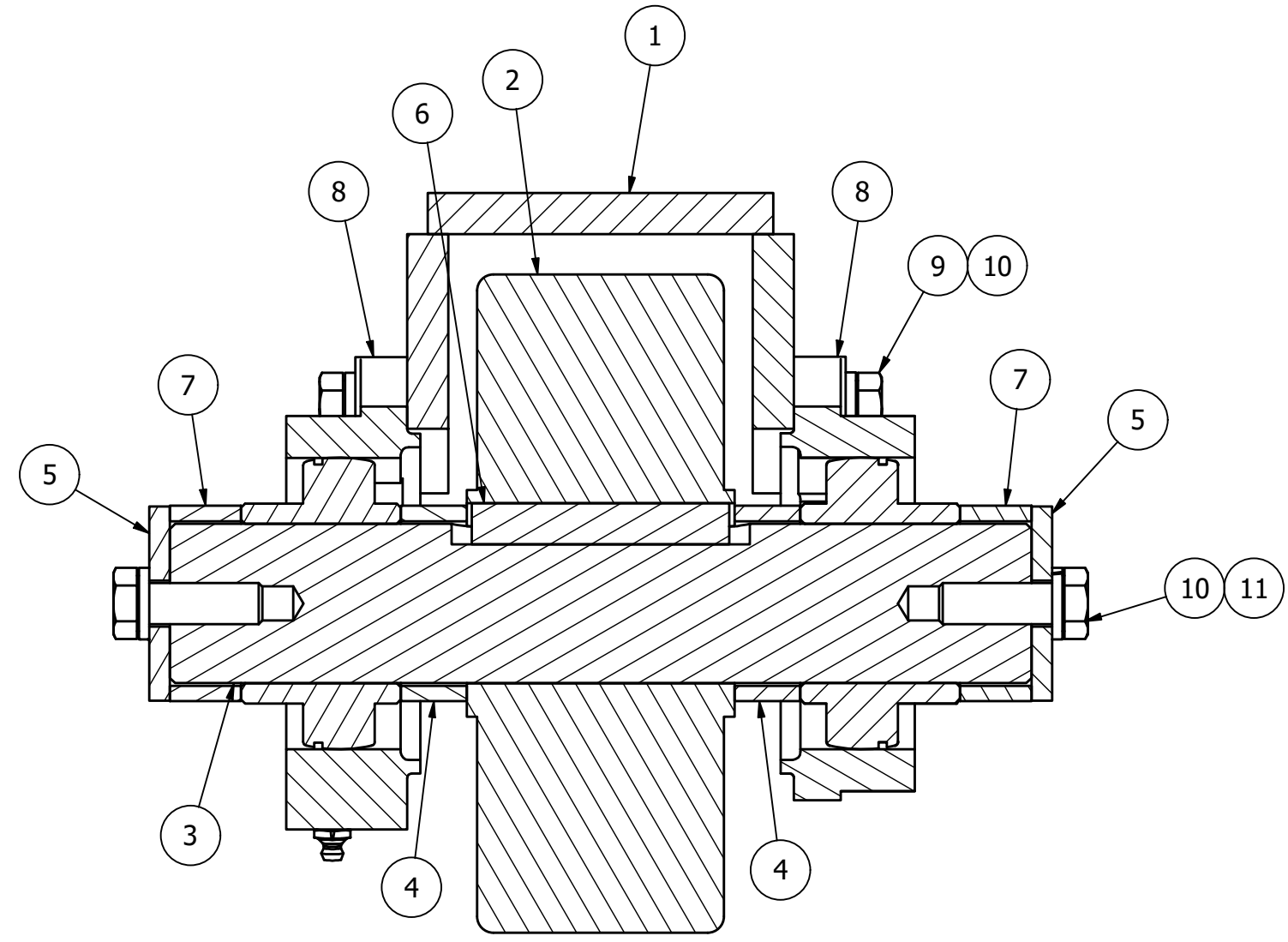
MK-D020B ~ WHEEL HOUSING
SCALE



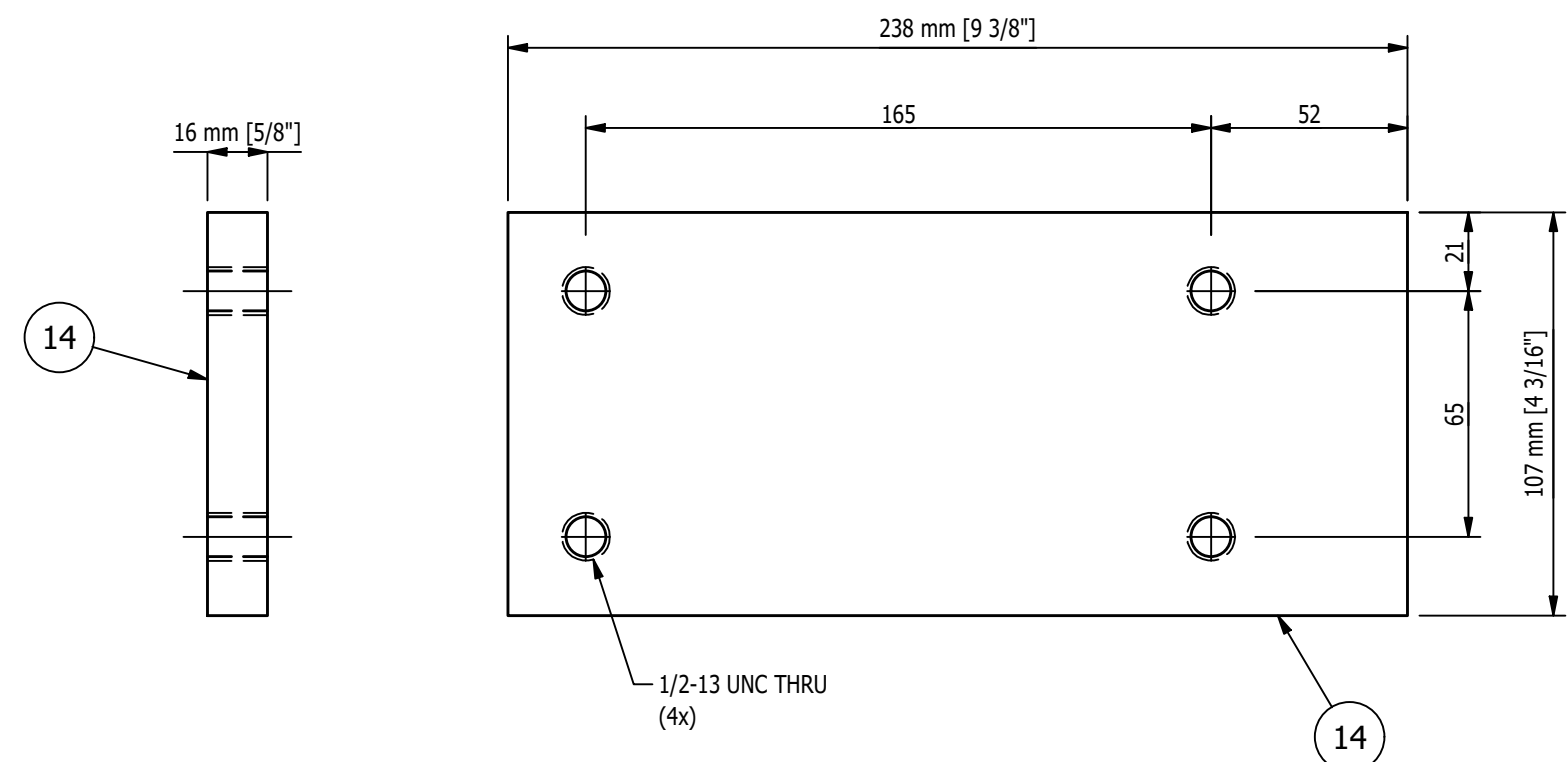
DETAIL OF ITEM '13'
SCALE 6"=1'-0"



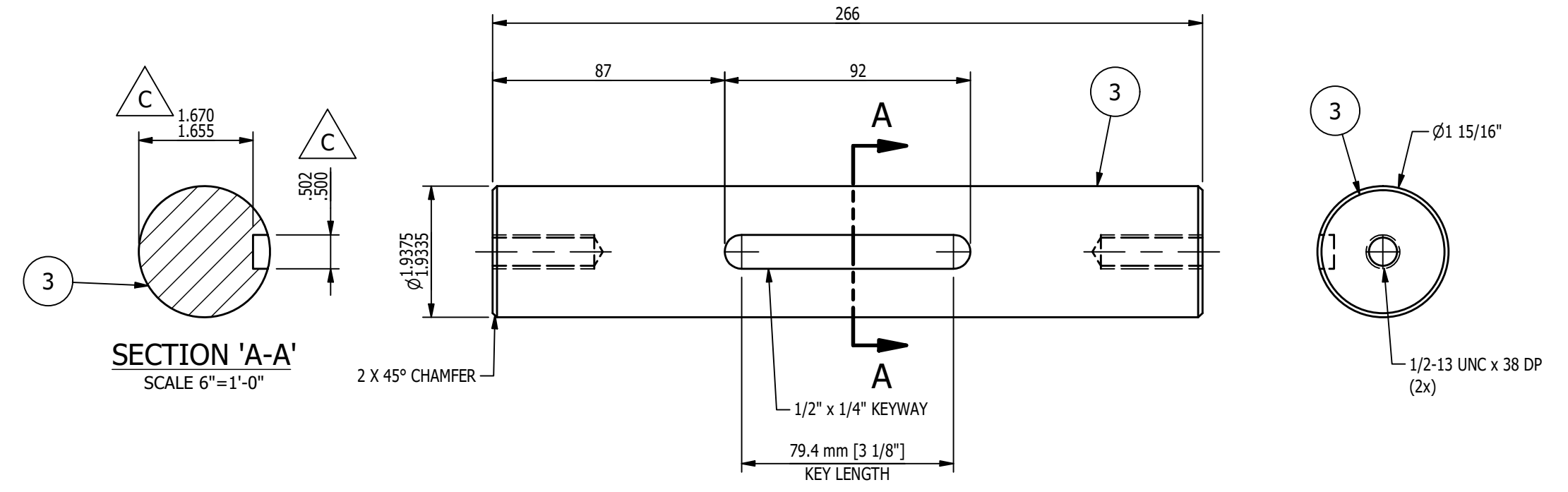
DETAIL OF ITEM '12'
SCALE 6"=1'-0"



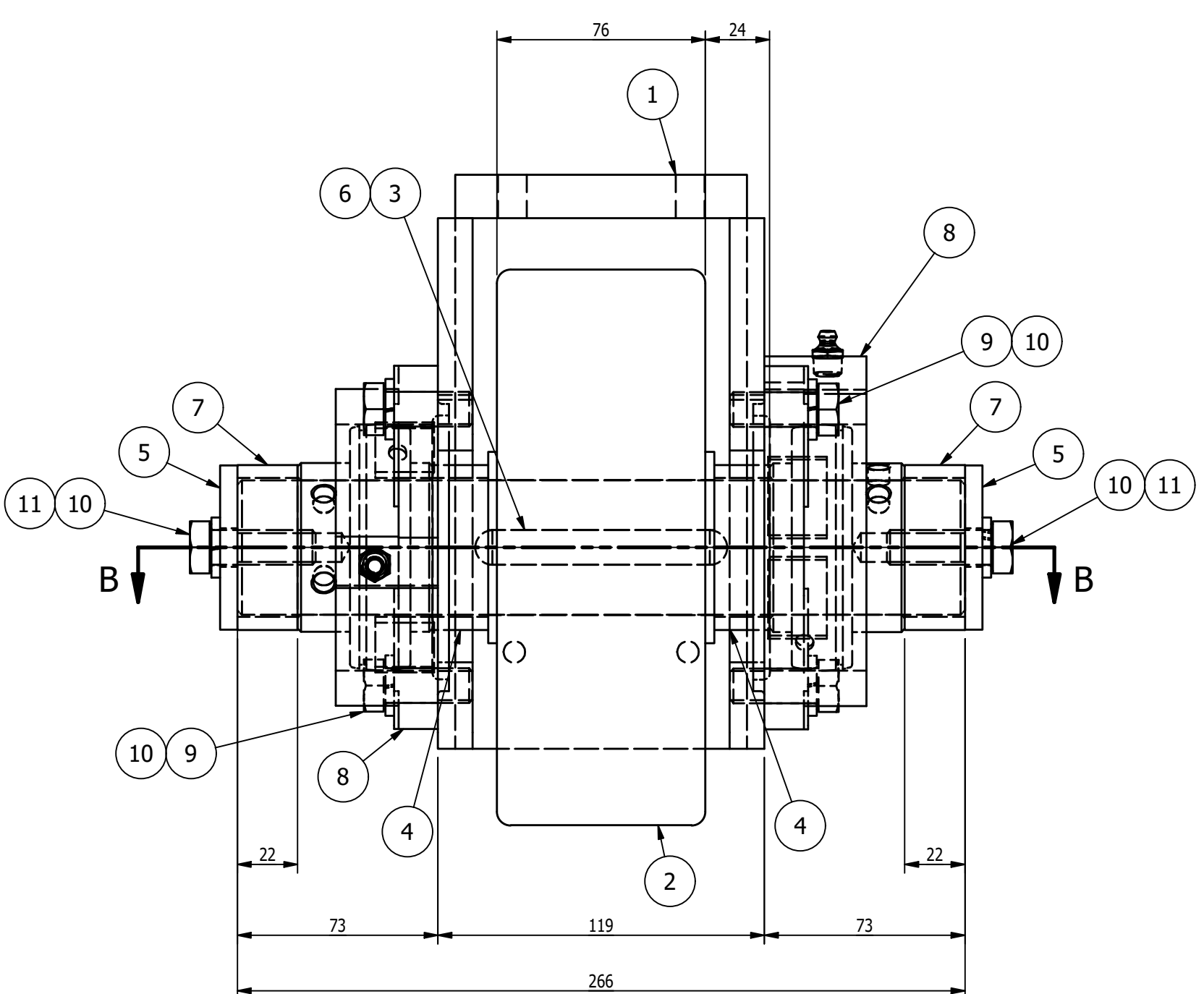
SECTION 'B-B'
SCALE 6"=1'-0"



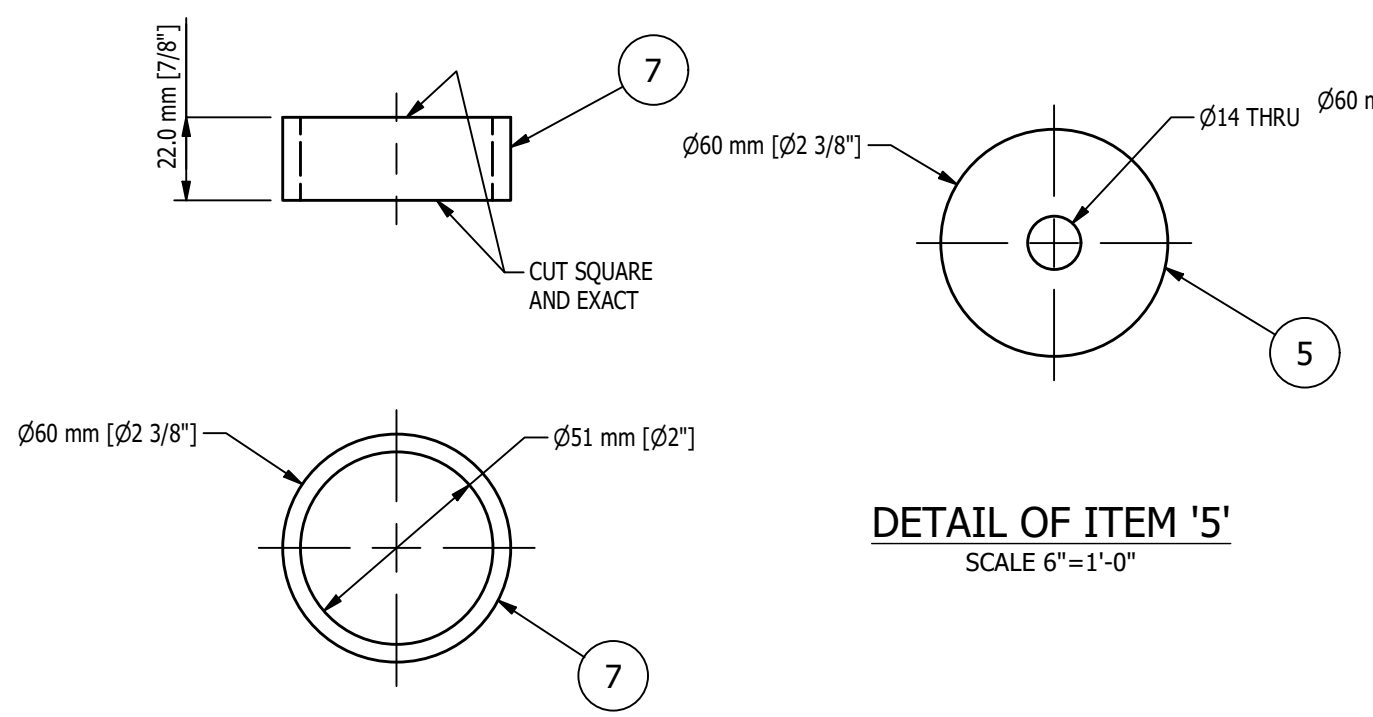
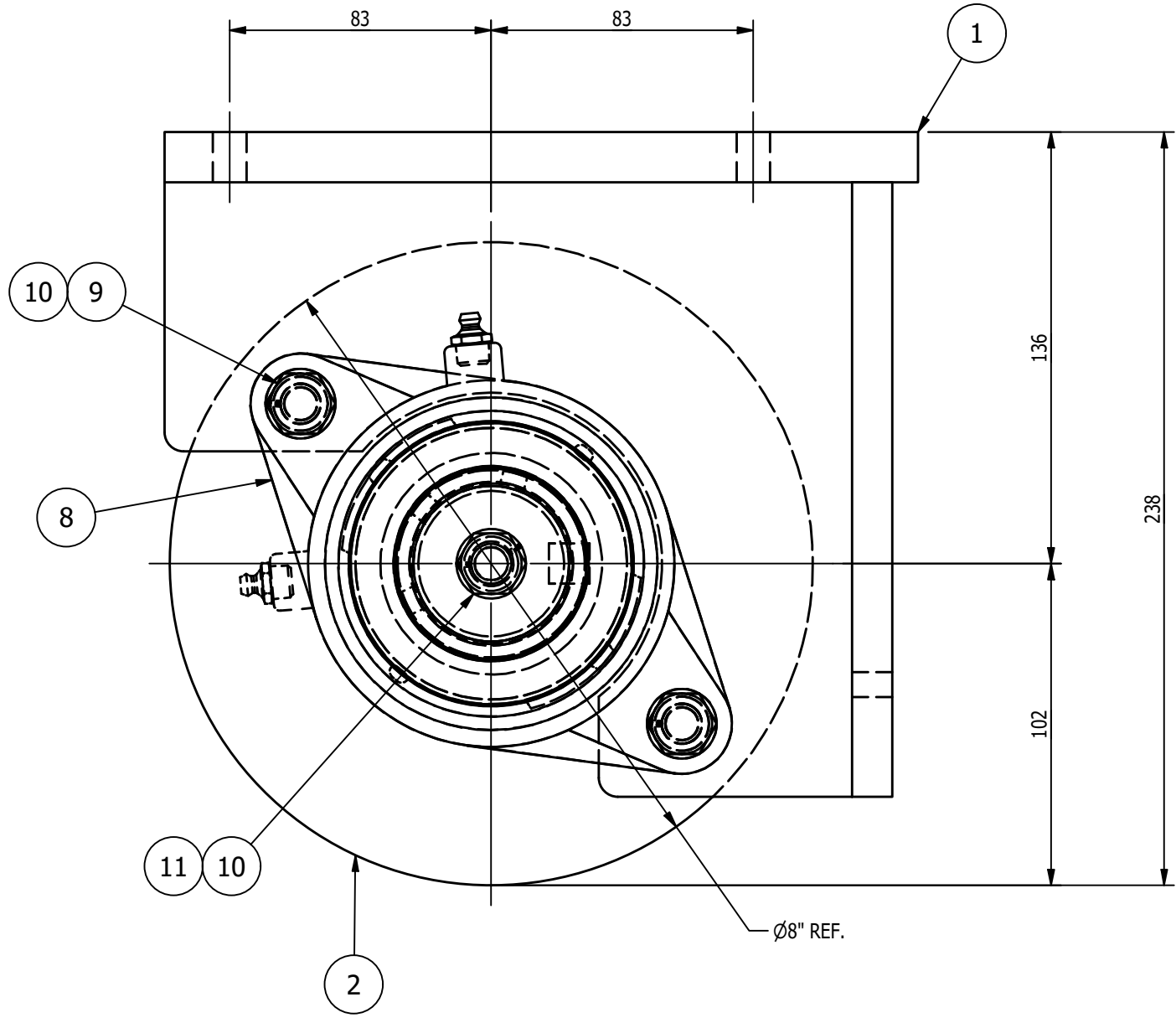
DETAIL OF ITEM '14'
SCALE 6"=1'-0"



DETAIL OF ITEM '3'
SCALE 6"=1'-0"



MK-D020A ~ IDLER WHEEL ASSEMBLY
SCALE 6"=1'-0"



DETAIL OF ITEM '5'
SCALE 6"=1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.
 9. VIBRATORY STRESS RELIEVE WELDMENTS

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
D	MC	8/30/22	FLIPPED ITEM '8'	
C	MC	8/24/2022	REVISED TOLERANCES	
B	MC	8/18/22	UPDATED WIDTH OF ITEMS '12' & '13'	
A	MC	8/8/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
		FENTON, MI 48430		DRAWING IS THE SOLE PROPERTY	
		PH: 810.373.0322 FAX: 810.373.0326		OF MILLER INDUSTRIES. ANY	
		www.millic.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: RJB		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 6/14/22		JOB No: 22096	
DRAWING No. 1875D020		REV: D			

MAGNUM Consulting
41100 Clarkston Road
Suite 125
North, MI 48055
Phone: (248) 772-8800
Fax: (248) 772-8801
Web: www.m4magnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D020

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

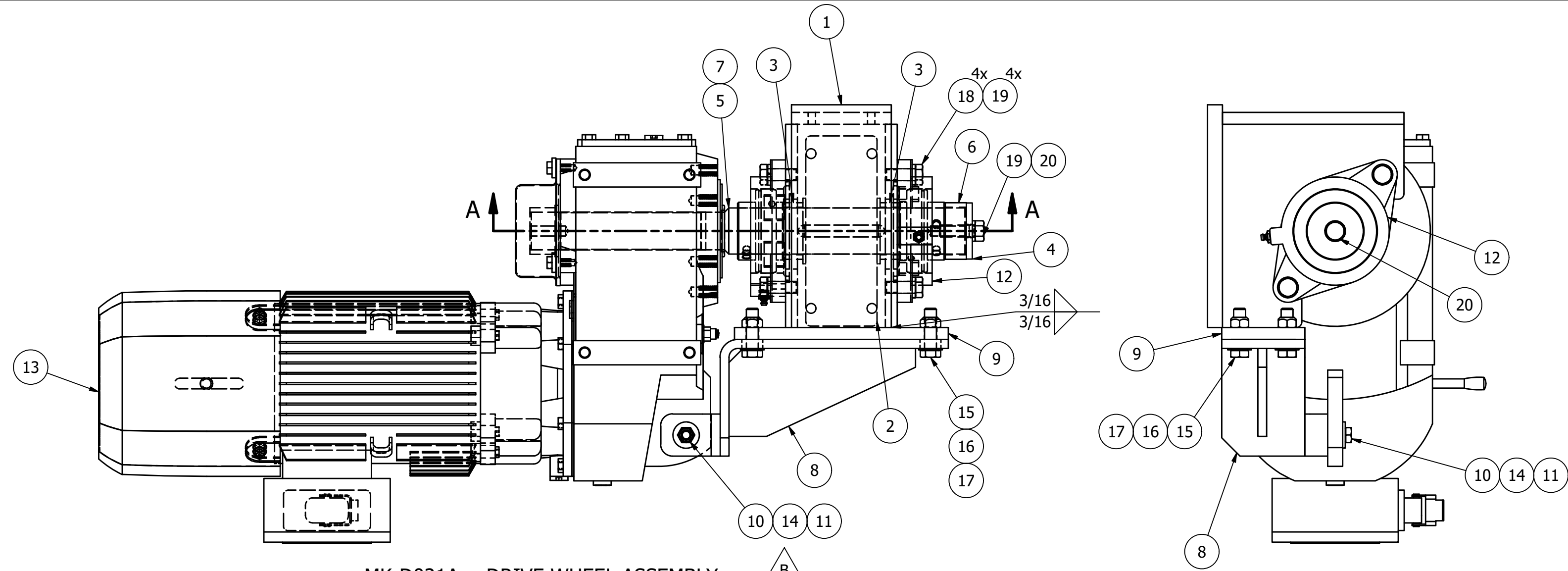
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

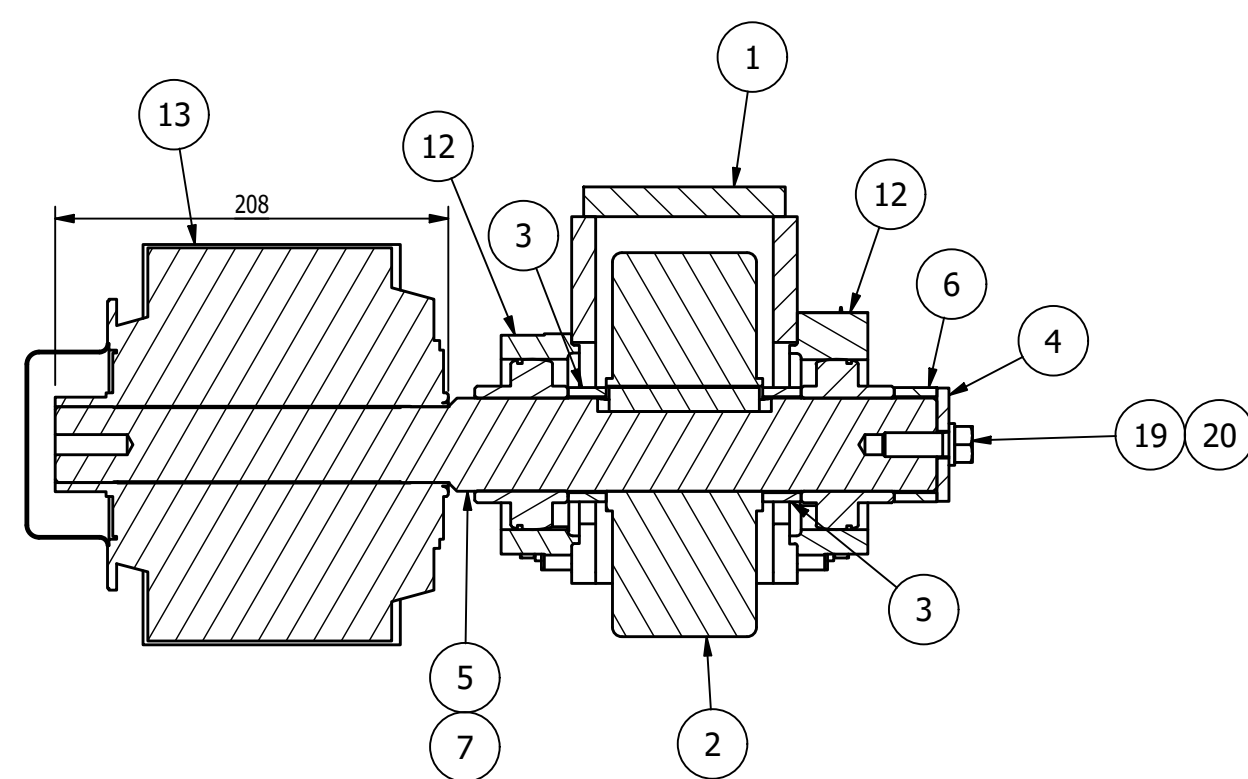
WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

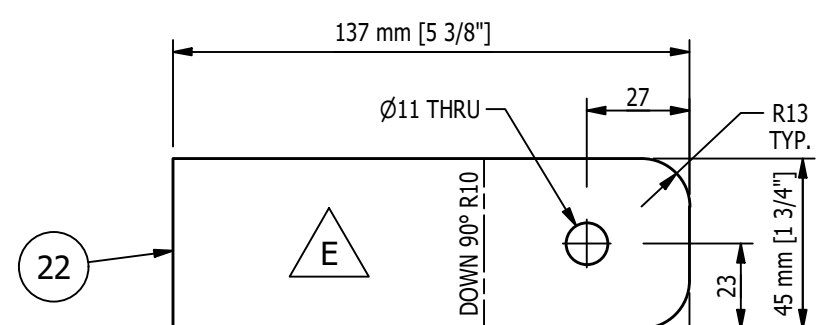
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



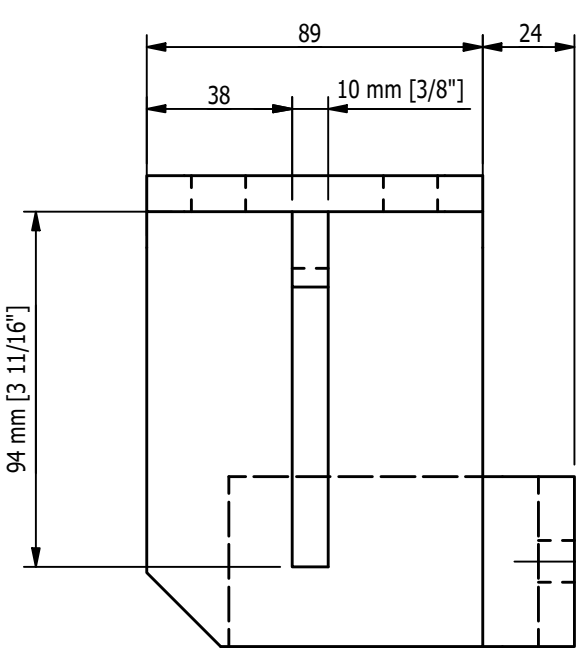
MK-D021A ~ DRIVE WHEEL ASSEMBLY
SCALE 3"=1'-0"



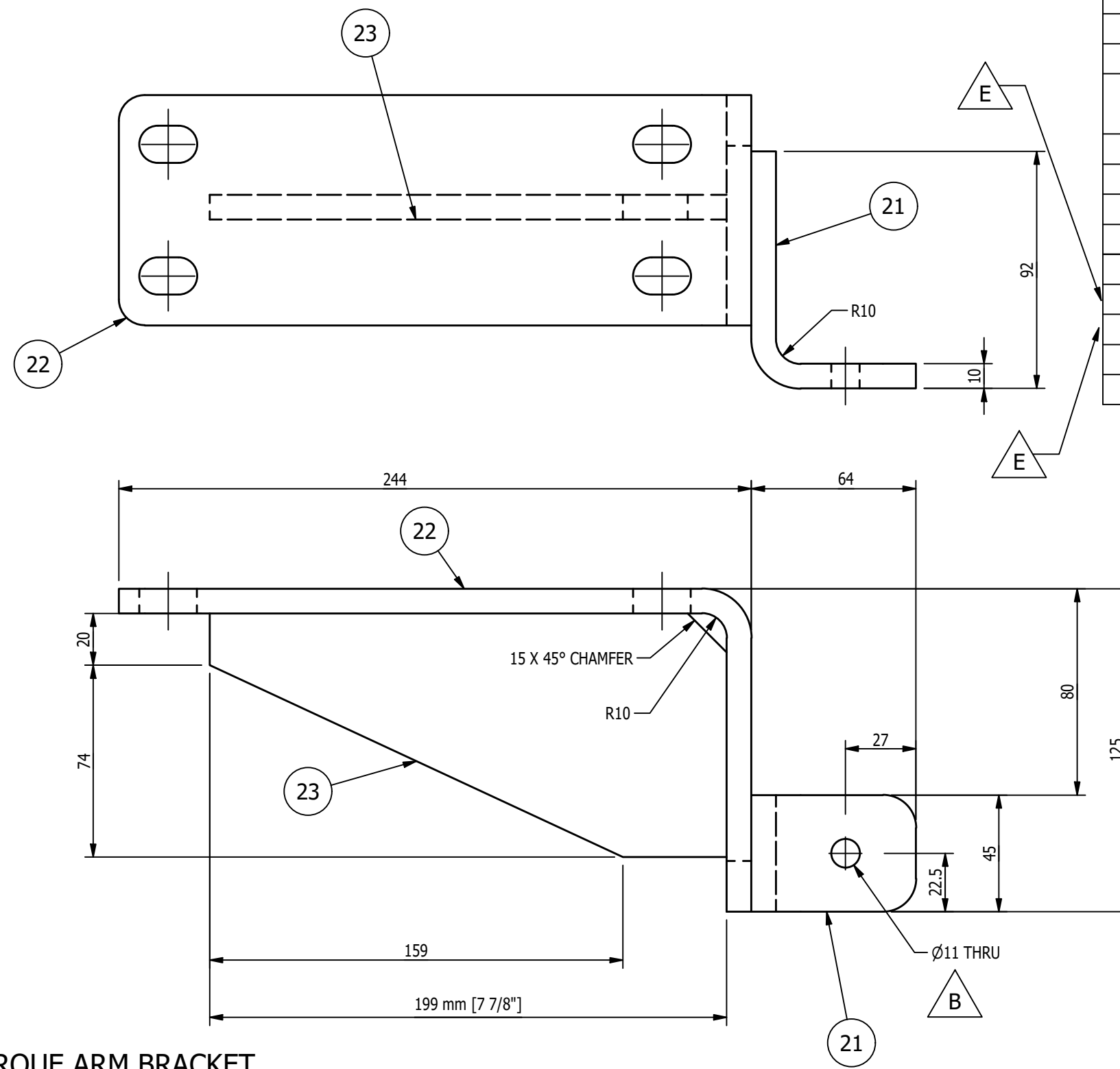
SECTION 'A-A'
SCALE 3"=1'-0"



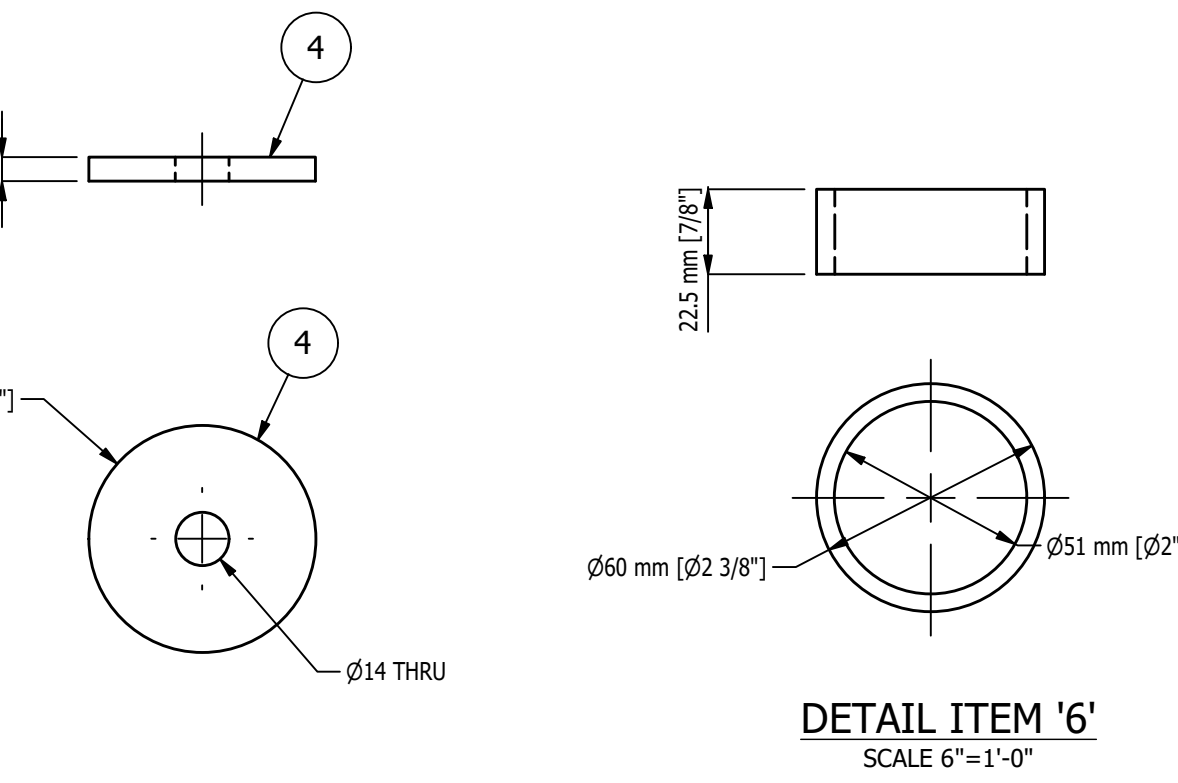
FLAT PATTERN OF ITEM '21'
SCALE 6"=1'-0"



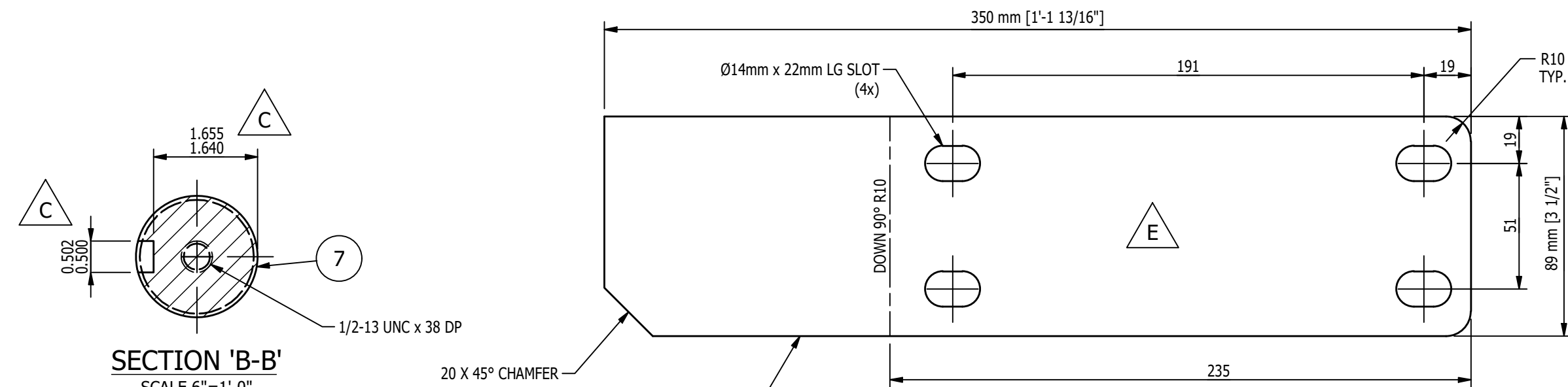
MK-D021B ~ TORQUE ARM BRACKET
SCALE 6"=1'-0"



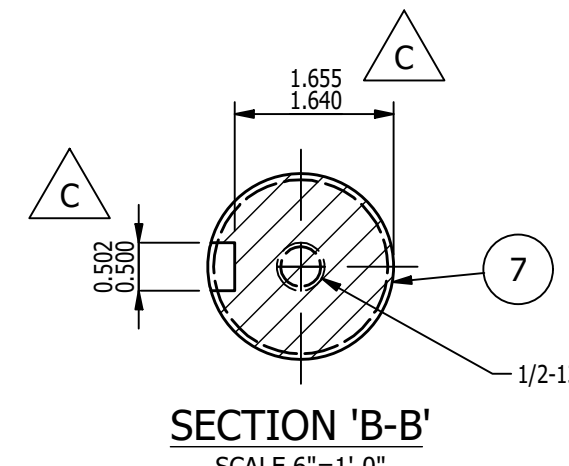
DETAIL OF ITEM '4'
SCALE 6"=1'-0"



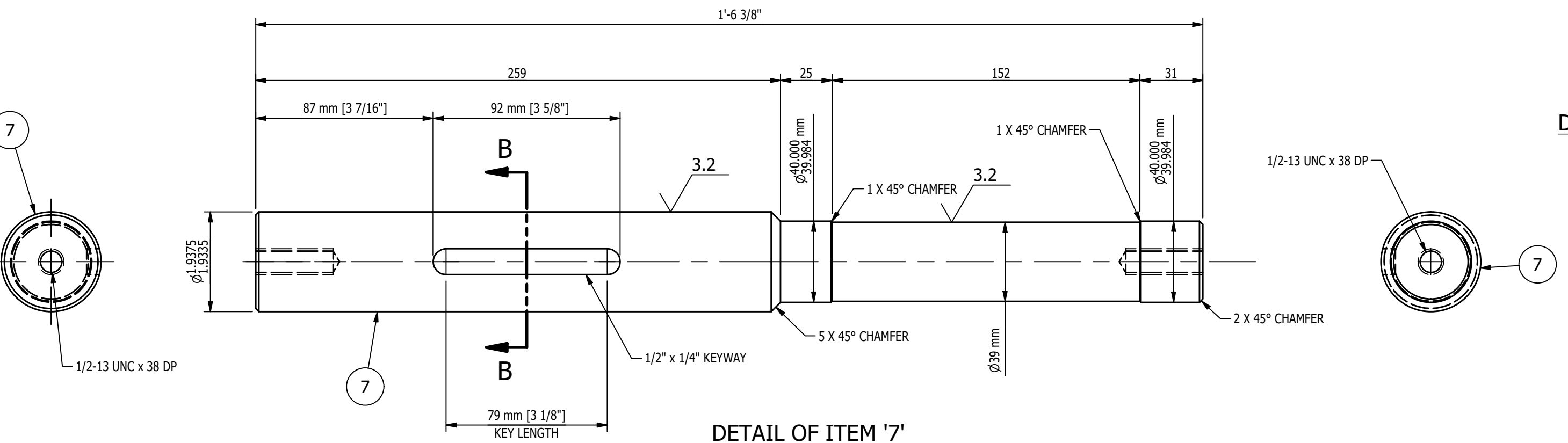
DETAIL ITEM '6'
SCALE 6"=1'-0"



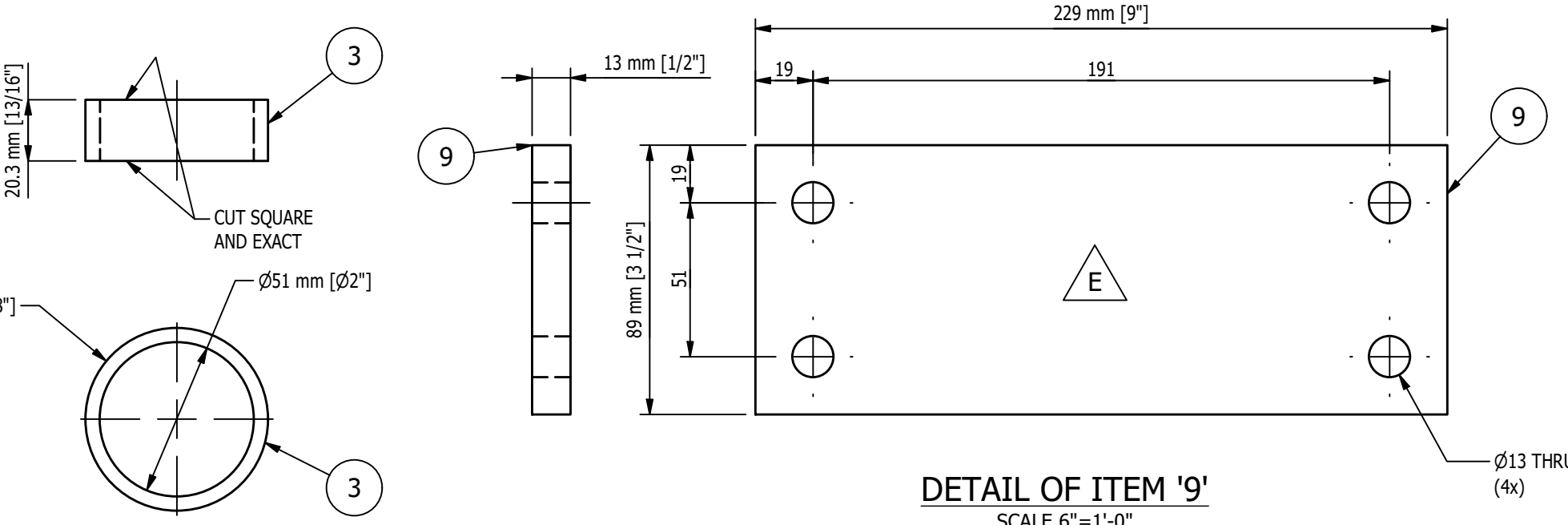
FLAT PATTERN OF ITEM '22'
SCALE 6"=1'-0"



SECTION 'B-B'
SCALE 6"=1'-0"



DETAIL OF ITEM '7'
SCALE 6"=1'-0"



DETAIL OF ITEM '9'
SCALE 6"=1'-0"

DETAIL OF ITEM '3'
SCALE 6"=1'-0"

SHOP NOTES:
 1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
 PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D021A			
1	1	MK-D020B ~ WHEEL HOUSING			
2	1	CASTER CONCEPTS WHEEL, 8" OD POLYURETHANE x 3" WIDE, 3.25" LT, 2500 LB. MAX, PART NO. CNV04070102		6-5	
3	2	TUBE 2 3/8 OD x 3/16 DOM	13/16"		
4	1	BAR 1/4 x 2 3/8	2 3/8"		
5	1	1/2 SQ. KEY STOCK	3 1/8"		
6	1	TUBE 2 3/8 OD x 3/16 DOM	7/8"		
7	1	BAR Ø1 15/16 (CRS 1045)	1'-6 15/16"		
8	1	MK-D021B ~ TORQUE ARM BRACKET			
9	1	BAR 1/2 x 3 1/2	9"		
10	1	M10x1.5 x 60mm LG. HEX CAP SCREW			
11	2	M10 x 1.5 HEX NUT			
12	2	DODGE SET SCREW TWO-BOLT SC FLANGE BEARING 1 15/16" BORE, F2BZ-SC-115 PART NO. 056845		6-7	
13	1	SIEMENS TT1 GEARMOTOR (SEE MOTOR DATA LIST)		1-4	
14	2	M10 REGULAR FLAT WASHER			
15	4	1/2-13UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
16	4	1/2 TYPE B NARROW FLAT WASHER			
17	4	1/2-13UNC STOVER LOCK NUT			
18	4	1/2-13UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
19	5	1/2 SPRING LOCK WASHER			
20	1	1/2-13UNC x 1 1/2" LG. HEX HEAD BOLT			
		TOTAL WEIGHT ~ 145.8 lbs			
		MK-D021B			
21	1	BAR 3/8 x 1 3/4	5 3/8"		
22	1	BAR 3/8 x 3 1/2	1'-1 13/16"		
23	1	BAR 3/8 x 3 11/16	7 7/8"		
		TOTAL WEIGHT ~ 7.5 lbs			

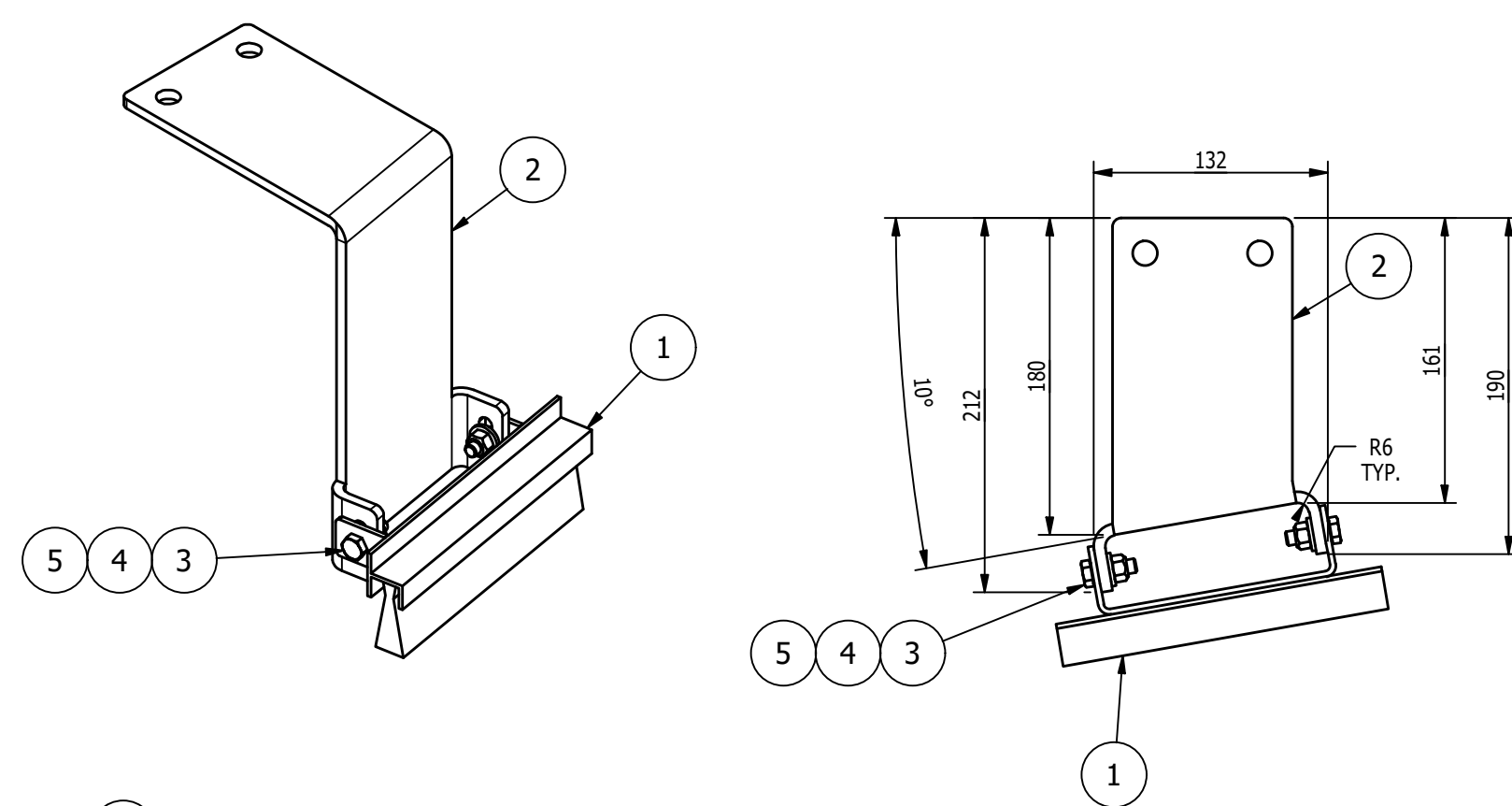
REV	BY	DATE	DESCRIPTION	APP
E	MC	9/6/22	ITEM '9' SIZE & HOLES UPDATED, ITEM '21' SIZE & HOLE UPDATED, ITEM '22' SIZE & SLOTS UPDATED, FLIPPED ITEM '12'	
D	MC	8/30/22		
C	MC	8/24/22	REVISED TOLERANCES	
B	MC	8/18/22	UPDATED HOLE SIZE ON ITEM '21', CHANGED ITEM '10' TO M10 x 60MM HHCS, WAS 1/2-13 UNC x 2 1/2" LG HHCS, CHANGED ITEM '11' TO M10 x 1.5 HEX NUT, WAS 1/2-13 UNC HEX NUT, CHANGED ITEM '14' TO M10 FLAT WASHER, WAS M14 NARROW FLAT WASHER, ADDED VIEW TO ITEM '7'	
A	MC	8/8/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
		FENTON, MI 48430		DRAWING IS THE SOLE PROPERTY	
		PH: 810.373.0322 FAX: 810.373.0326		OF MILLER INDUSTRIES. ANY	
		www.millic.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: RJB		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 6/14/22		JOB No: 22096	
DRAWING No. 1875D021		REV: E			

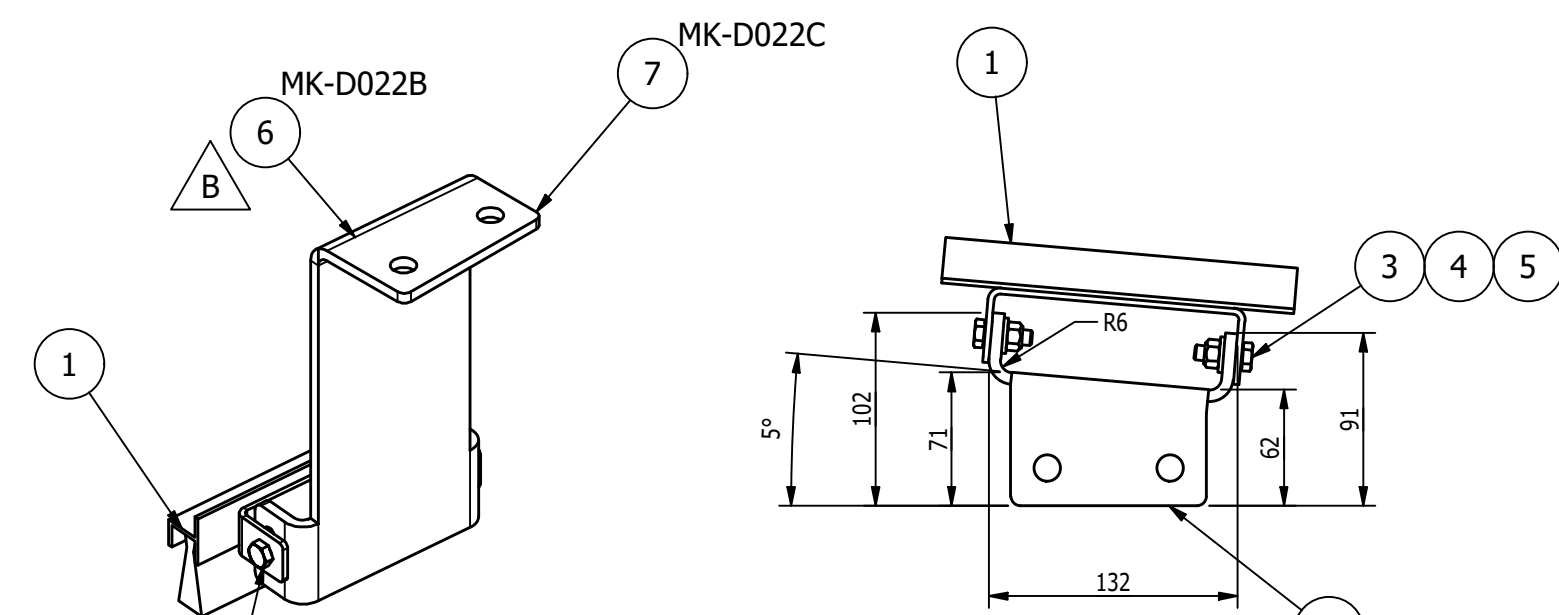
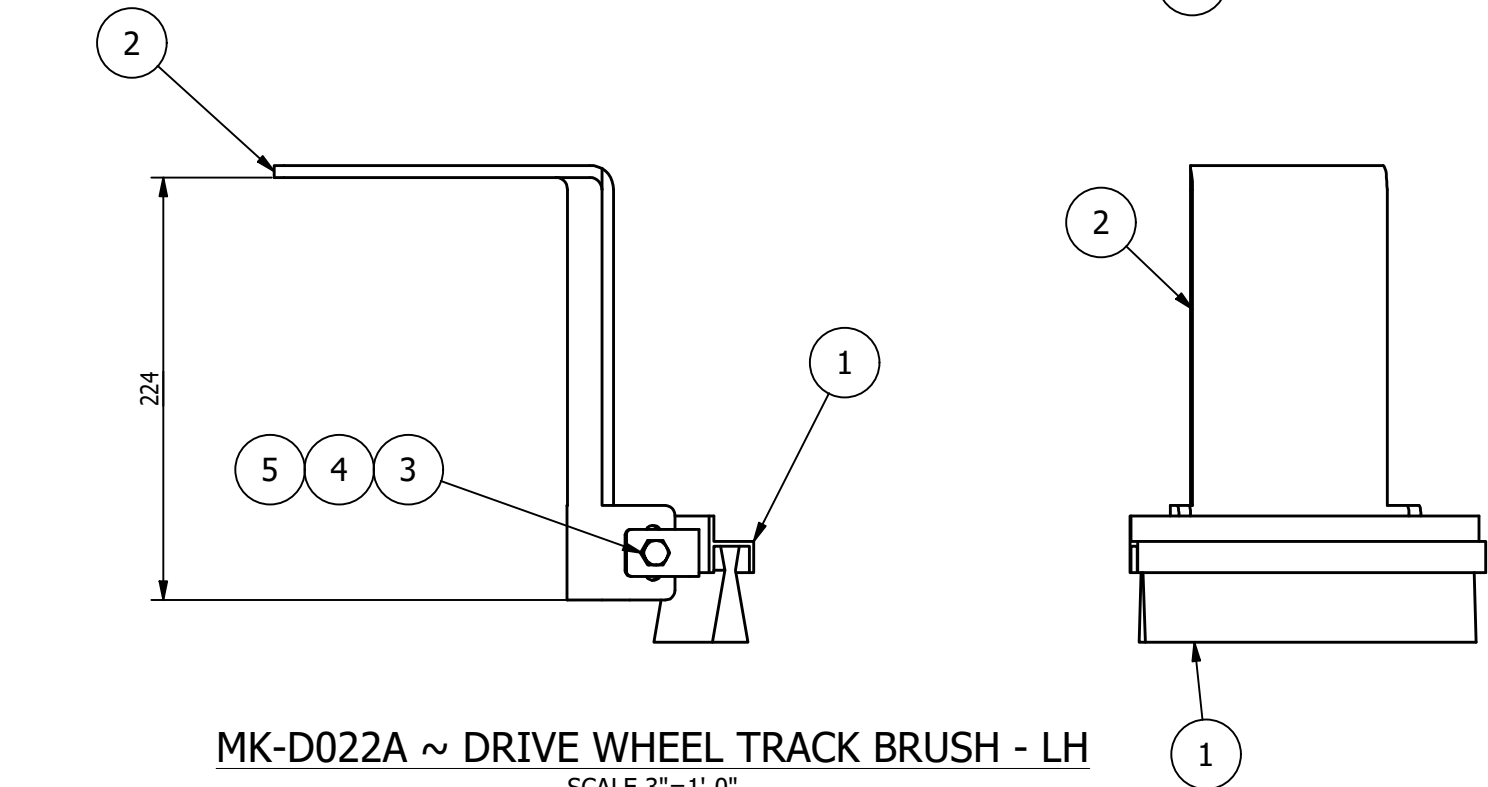
MAGNUM CONSULTING
 4100 Charleston Rd.
 Suite 125
 West, MI 48315
 Phone: (248) 773-8888
 Fax: (248) 773-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D021

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

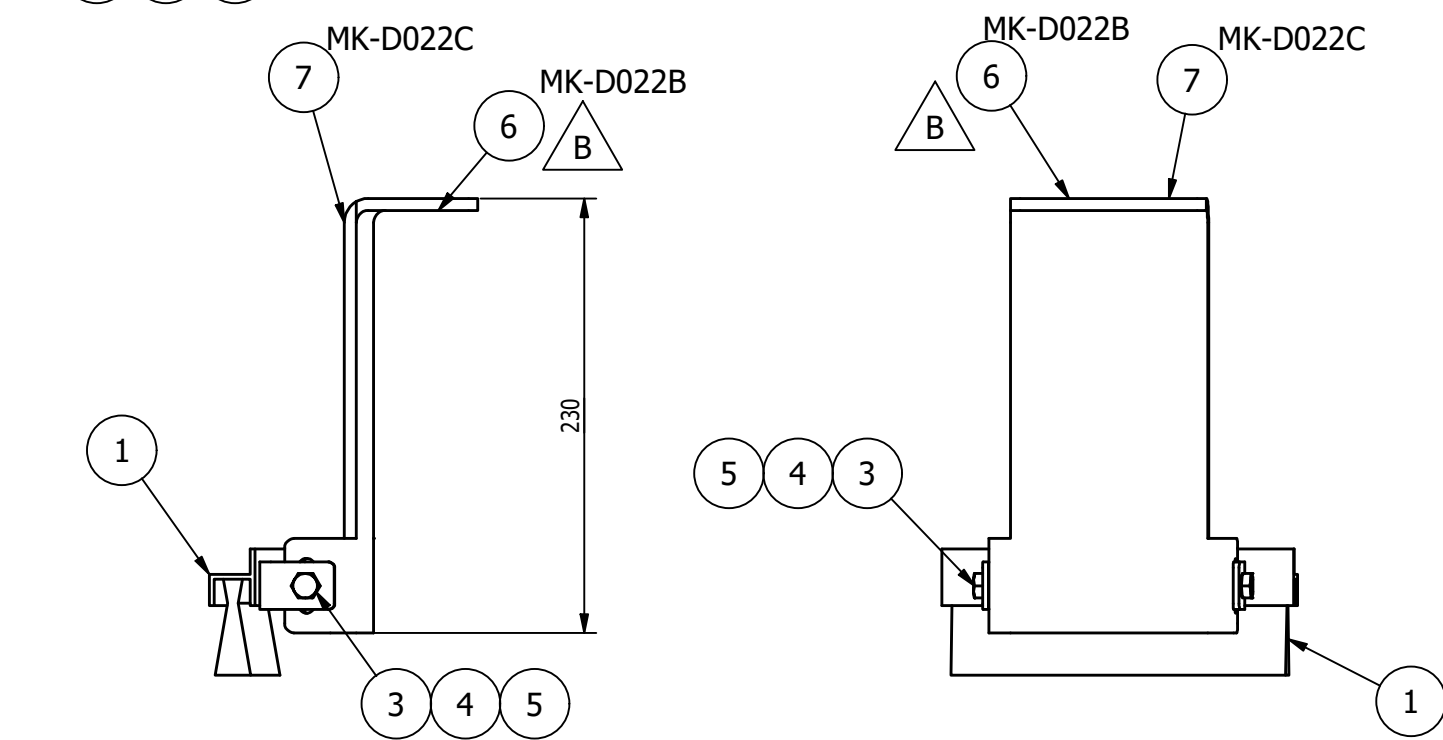
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
 WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)
 PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



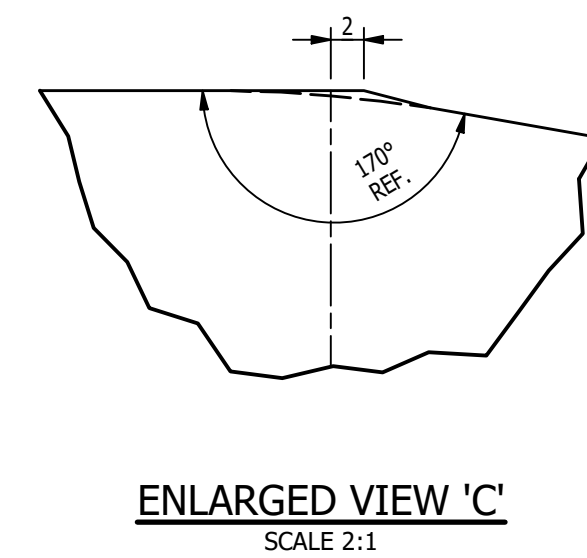
MK-D022A ~ DRIVE WHEEL TRACK BRUSH - LH
SCALE 3"=1'-0"



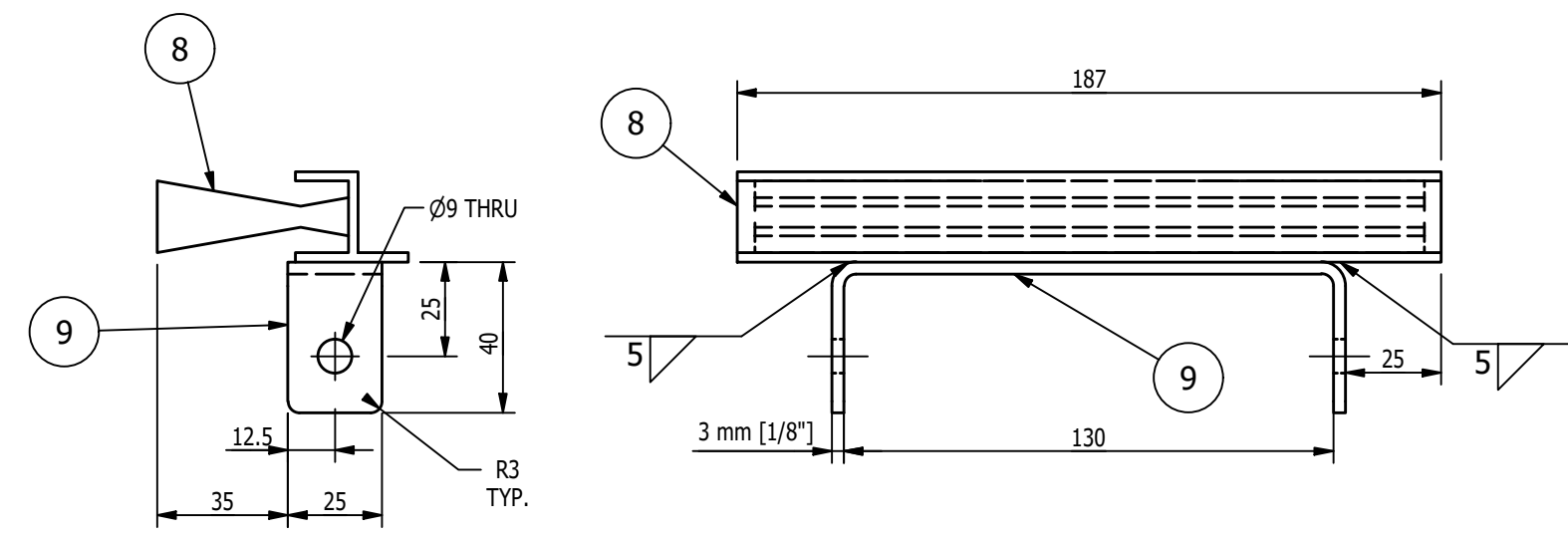
MK-D022B ~ IDLE WHEEL TRACK BRUSH - LH (OPPOSITE)
SCALE 3"=1'-0"



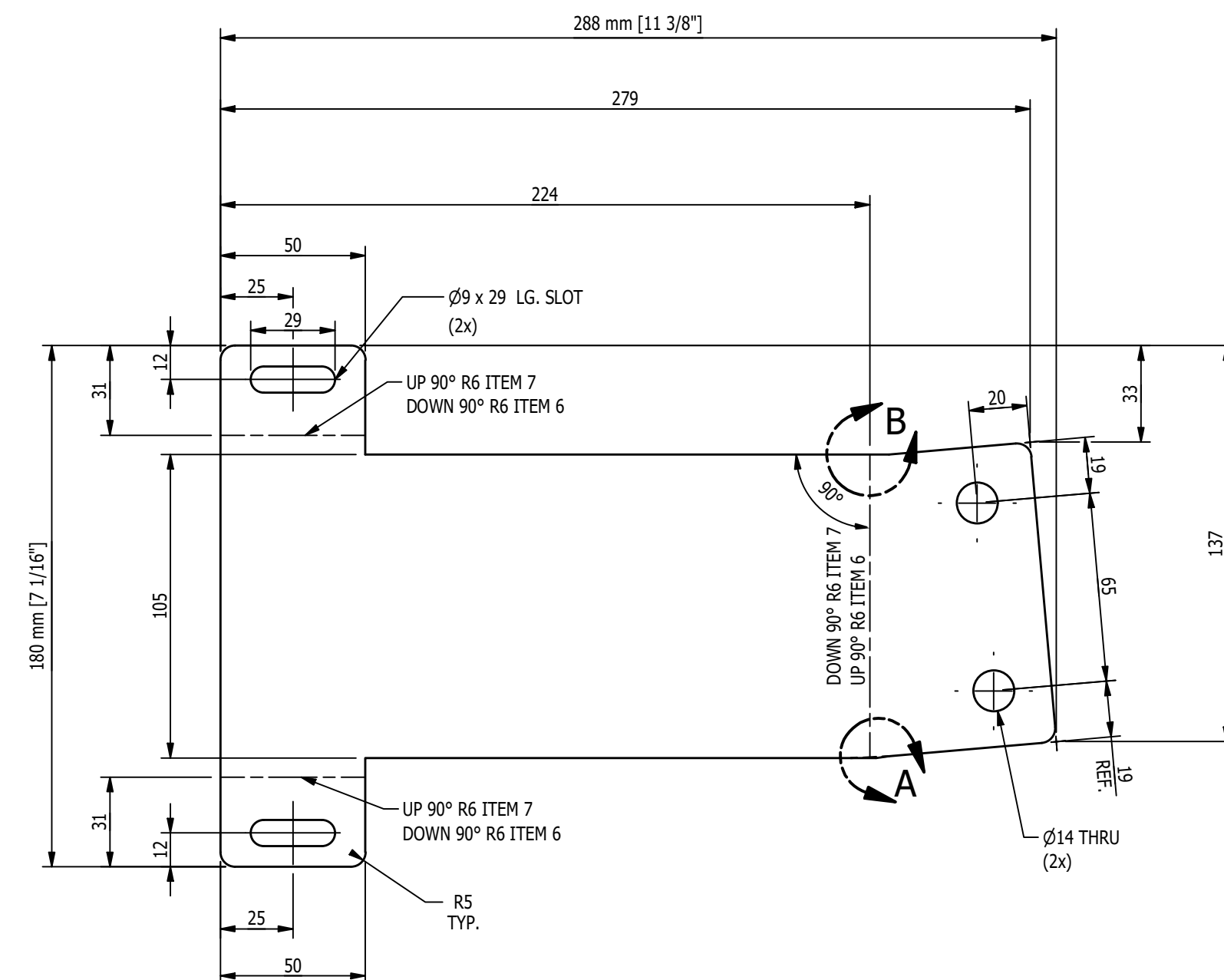
MK-D022C ~ IDLE WHEEL TRACK BRUSH - RH (SHOWN)
SCALE 3"=1'-0"



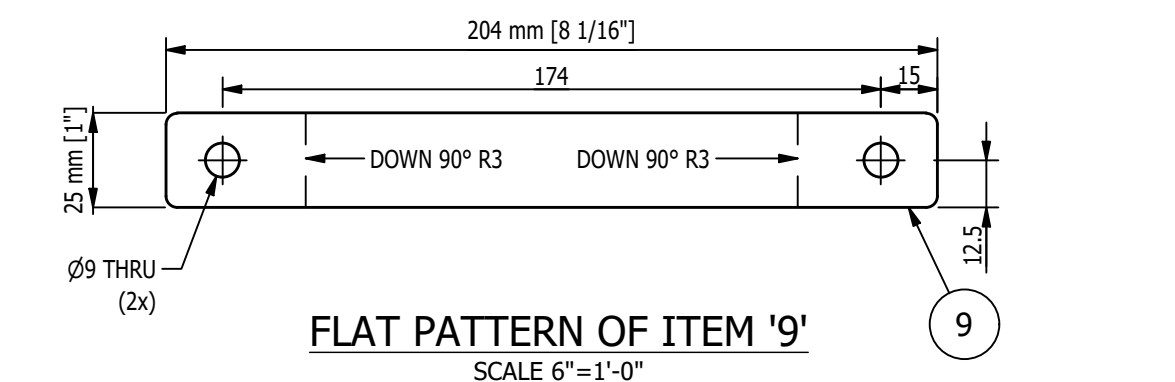
ENLARGED VIEW 'C'
SCALE 2:1



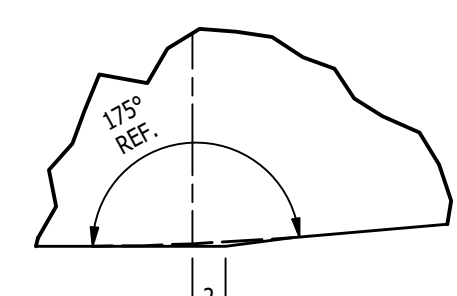
MK-D022D ~ TRACK BRUSH
SCALE 6"=1'-0"



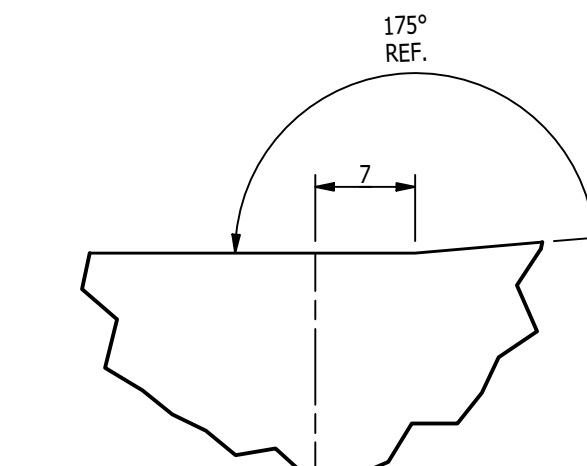
FLAT PATTERN OF ITEM '6', '7'
SCALE 6"=1'-0"



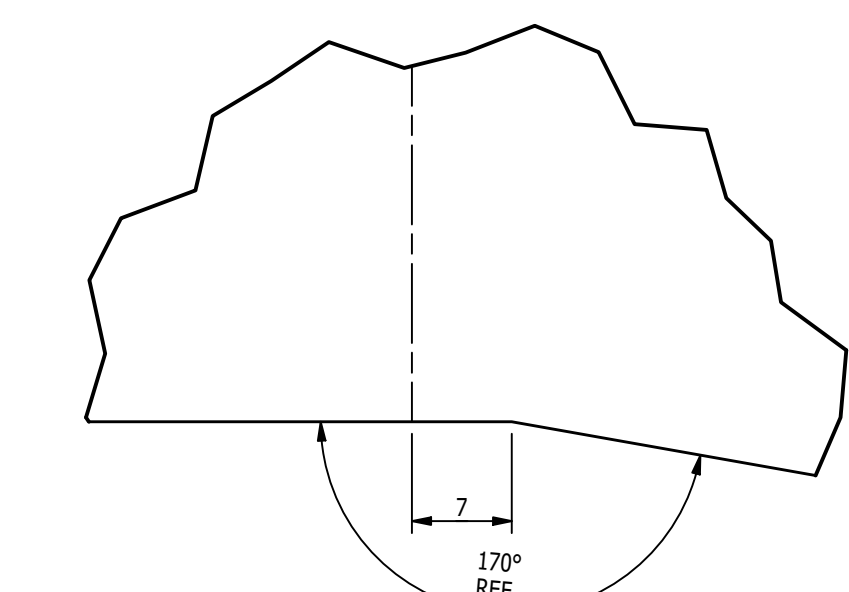
FLAT PATTERN OF ITEM '9'
SCALE 6"=1'-0"



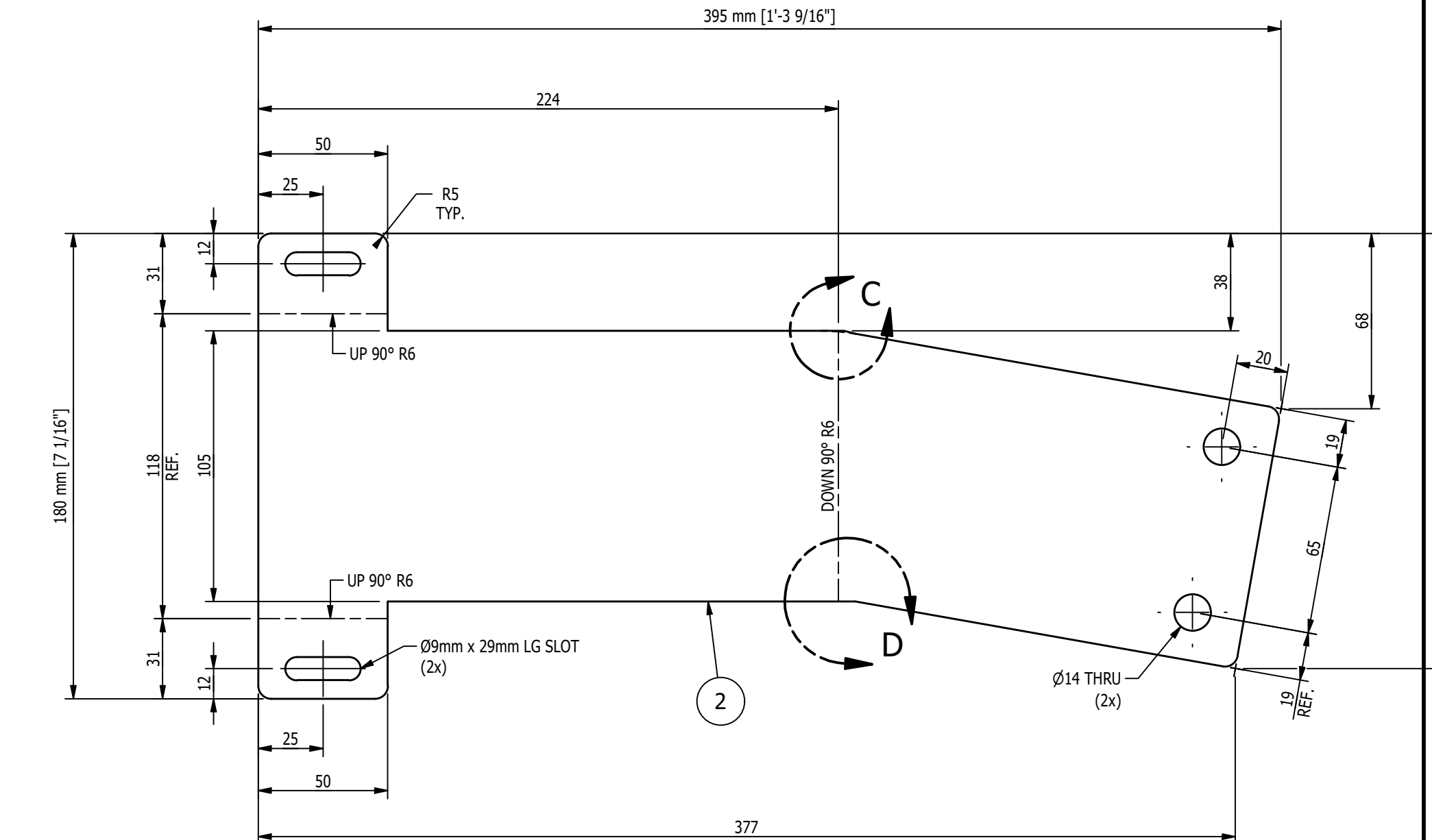
ENLARGED VIEW 'A'
SCALE 2:1



ENLARGED VIEW 'B'
SCALE 2:1



ENLARGED VIEW 'D'
SCALE 2:1



FLAT PATTERN OF ITEM '2'
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D022A			
1	1	MK-D022D ~ TRACK BRUSH			
2	1	BAR 1/4 x 7 1/16	1'-3 9/16"		
3	2	M8 x 1.25 STOVER LOCK NUT			
4	2	M8 NARROW FLAT WASHER			
5	2	M8x1.25 x 25mm LG. HEX CAP SCREW			
		TOTAL WEIGHT ~ 5.7 lbs			
		MK-D022B			
1	1	MK-D022D ~ TRACK BRUSH			
3	2	M8 x 1.25 STOVER LOCK NUT			
4	2	M8 NARROW FLAT WASHER			
5	2	M8x1.25 x 25mm LG. HEX CAP SCREW			
6	1	BAR 1/4 x 7 1/16	11 3/8"		
		TOTAL WEIGHT ~ 4.6 lbs			
		MK-D022C			
1	1	MK-D022D ~ TRACK BRUSH			
3	2	M8 x 1.25 STOVER LOCK NUT			
4	2	M8 NARROW FLAT WASHER			
5	2	M8x1.25 x 25mm LG. HEX CAP SCREW			
7	1	BAR 1/4 x 7 1/16	11 3/8"		
		TOTAL WEIGHT ~ 4.6 lbs			
		MK-D022D			
8	1	BRUSH, MFG POWER BRUSHES INC. (SEE ABM FOR MORE INFO)		6-6	
9	1	BAR 1/8 x 1	8 1/16"		
		TOTAL WEIGHT ~ 0.8 lbs			

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

MAGNUM CONSULTING
41100 Clarkston Rd
Suite 125
North, MI 48075
Phone: (248) 373-0322
Fax: (248) 373-0322
Web: www.millic.com

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

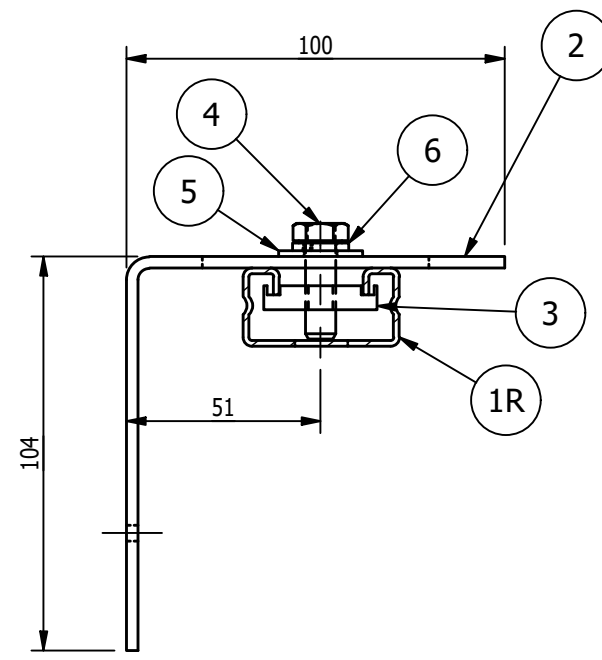
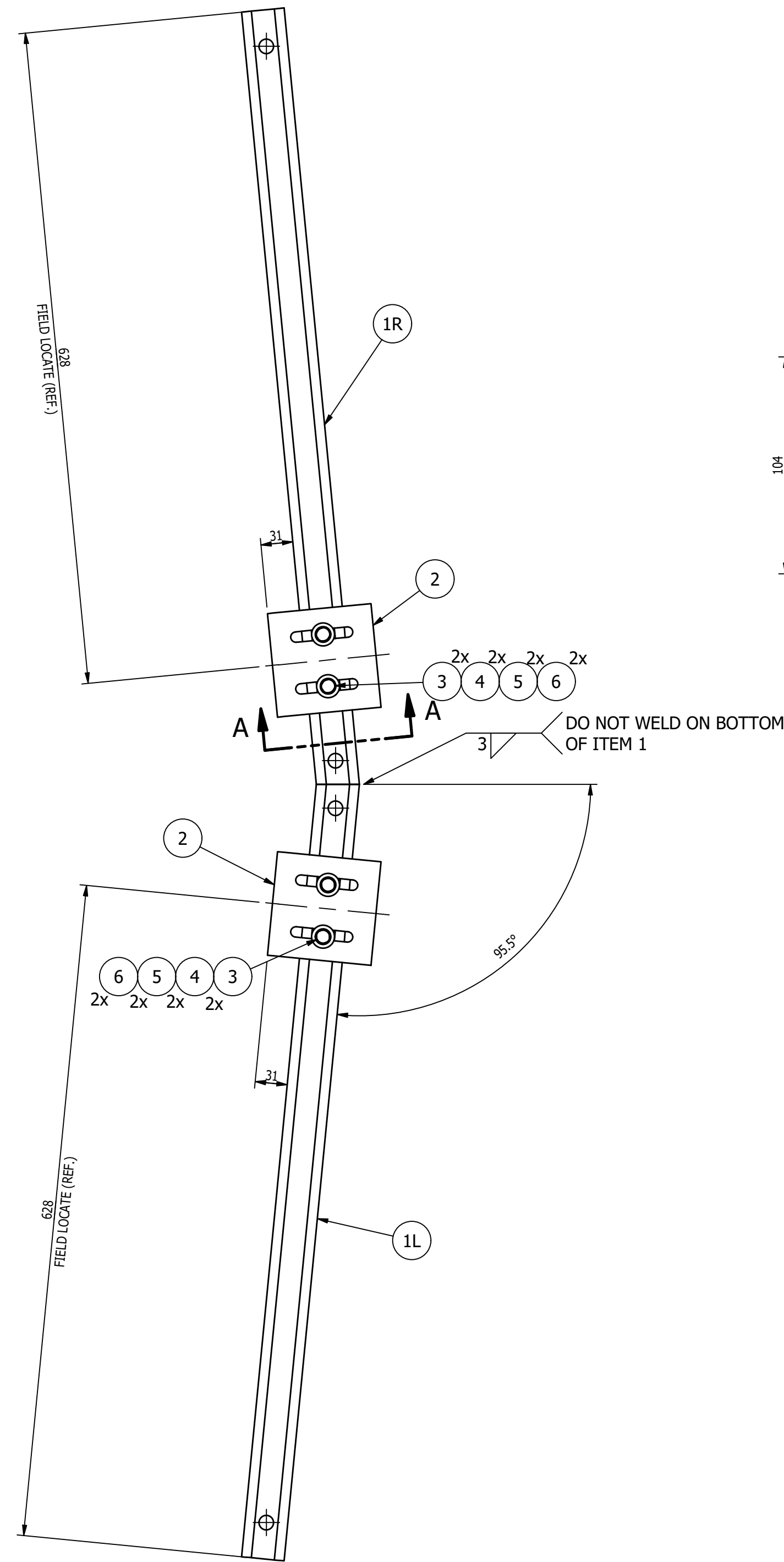
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/18/22	ITEM '6' BALLOONS ADDED	
A	MC	8/8/22	FOR FABRICATION	

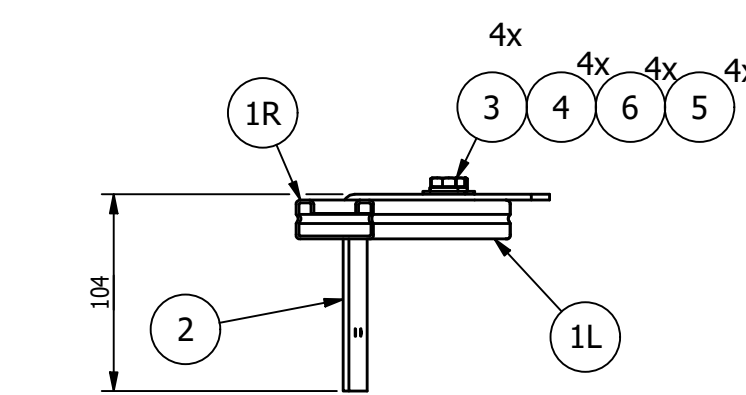
MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No.: 1875D022
REV: B

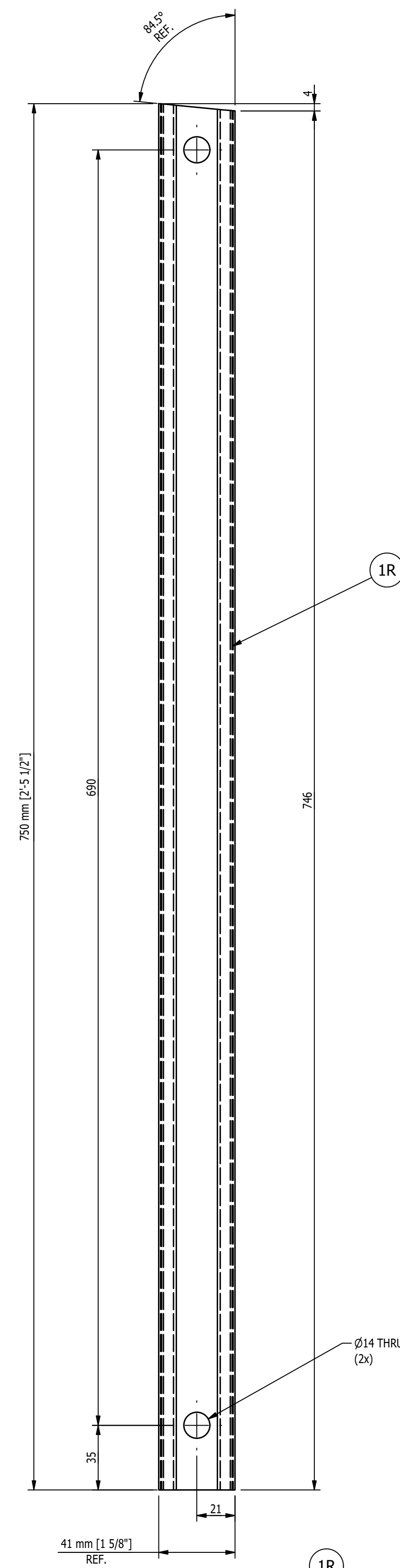
DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 6/15/22
JOB No.: 22096



SECTION 'A-A'
SCALE 6"=1'-0"



MK-D023A ~ SENSOR STAND
SCALE 3"=1'-0"



DETAIL OF ITEM '1R' (SHOWN)
DETAIL OF ITEM '1L' (OPPOSITE)
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D023A			
1R	1	UNISTRUT P4000 ST	2'-5 1/2"		
1L	1	UNISTRUT P4000 ST	2'-5 1/2"		
2	2	MK-D034B ~ PROX BRACKET			
3	4	CHANNEL NUT FOR 5/16"-18, UNISTRUT P3007			
4	4	5/16-18UNC x 1" LG. HEX HEAD CAP SCREW			
5	4	5/16 TYPE B REGULAR FLAT WASHER			
6	4	5/16 SPRING LOCK WASHER			
		TOTAL WEIGHT ~ 6.6 LBS			

- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/18/22	ADDED QUANTITY SYMBOLS, CHANGED ITEM '3' QUANTITY TO 4, WAS 5	
A	MC	8/8/22	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

mi MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.milc.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D023	DWG DATE:	6/15/22
REV:	B	JOB No:	22096

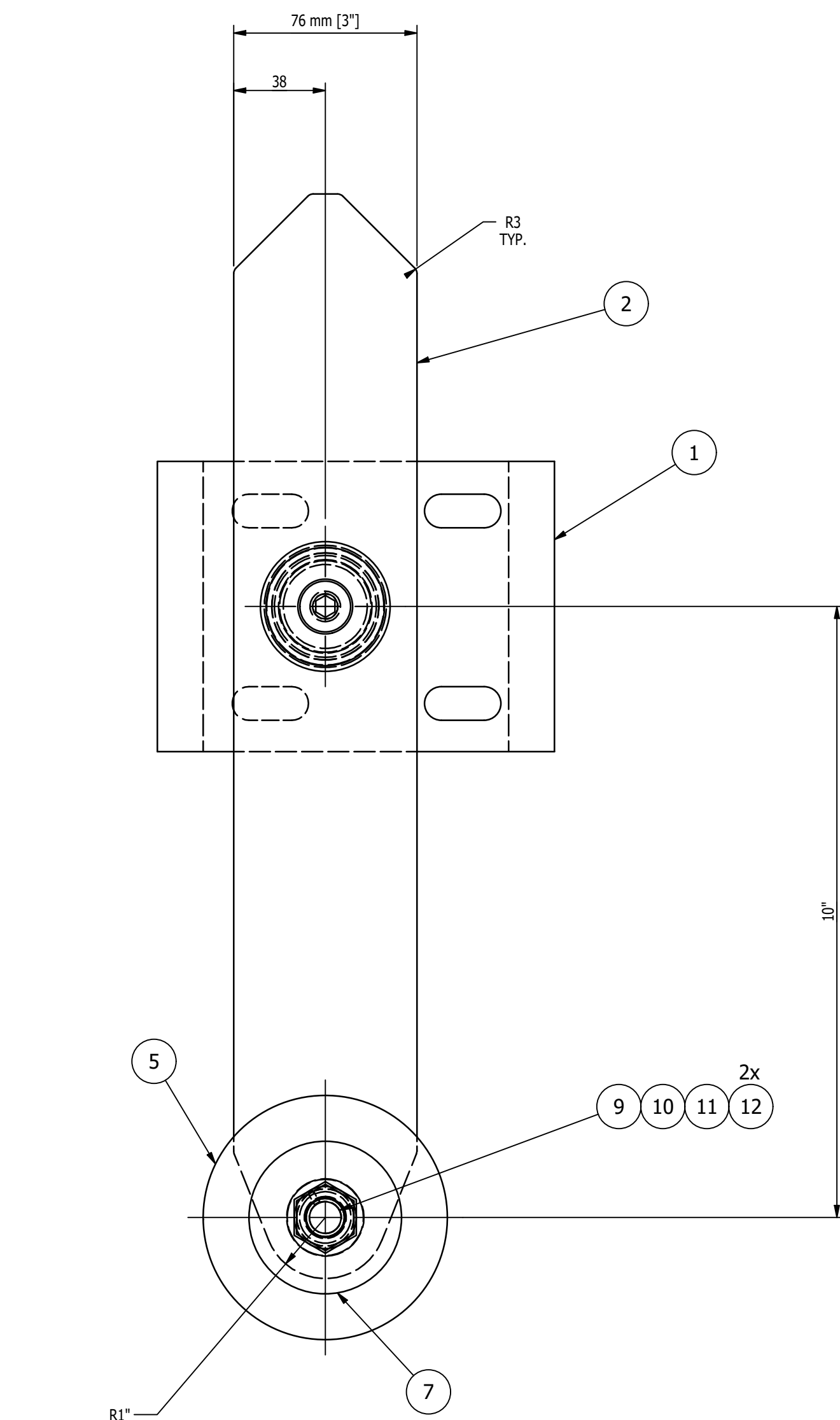
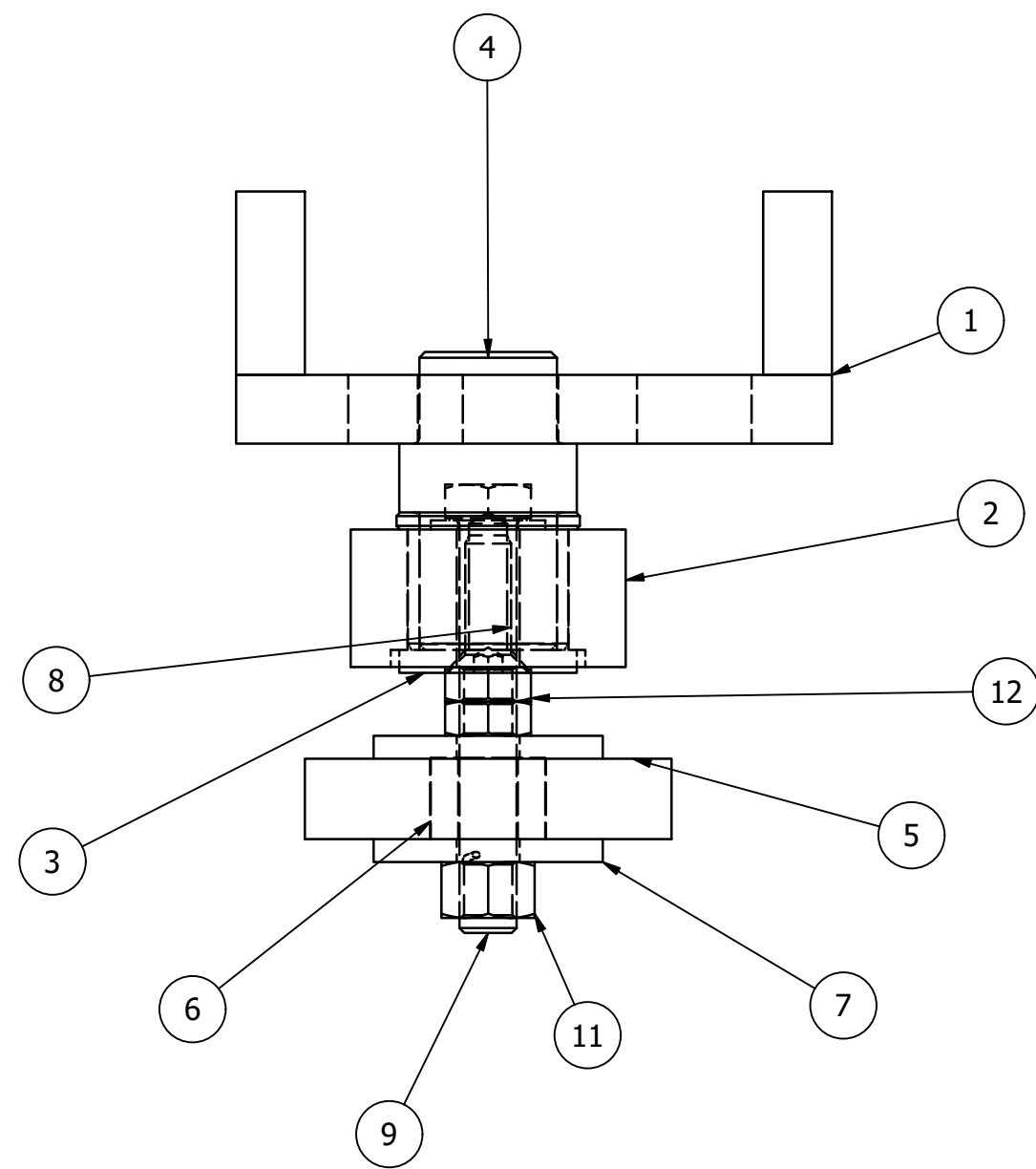
MAGNUM CONSULTING

41100 QuakerRoad Rd.
Suite 125
North, MI 48175

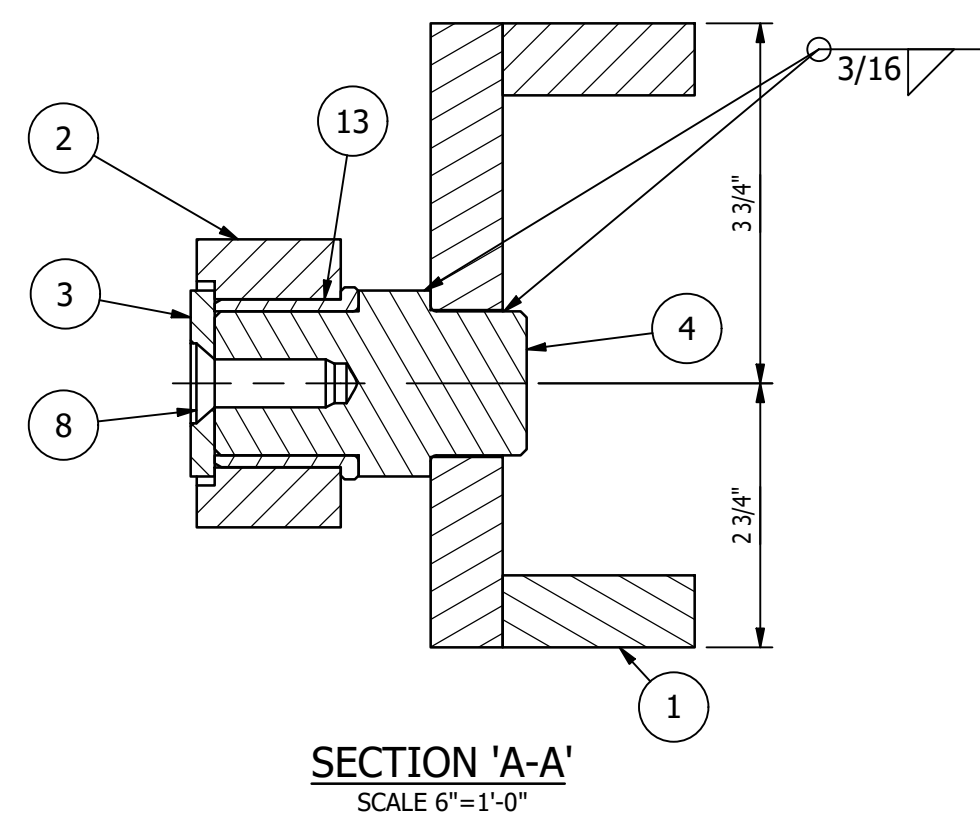
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D023

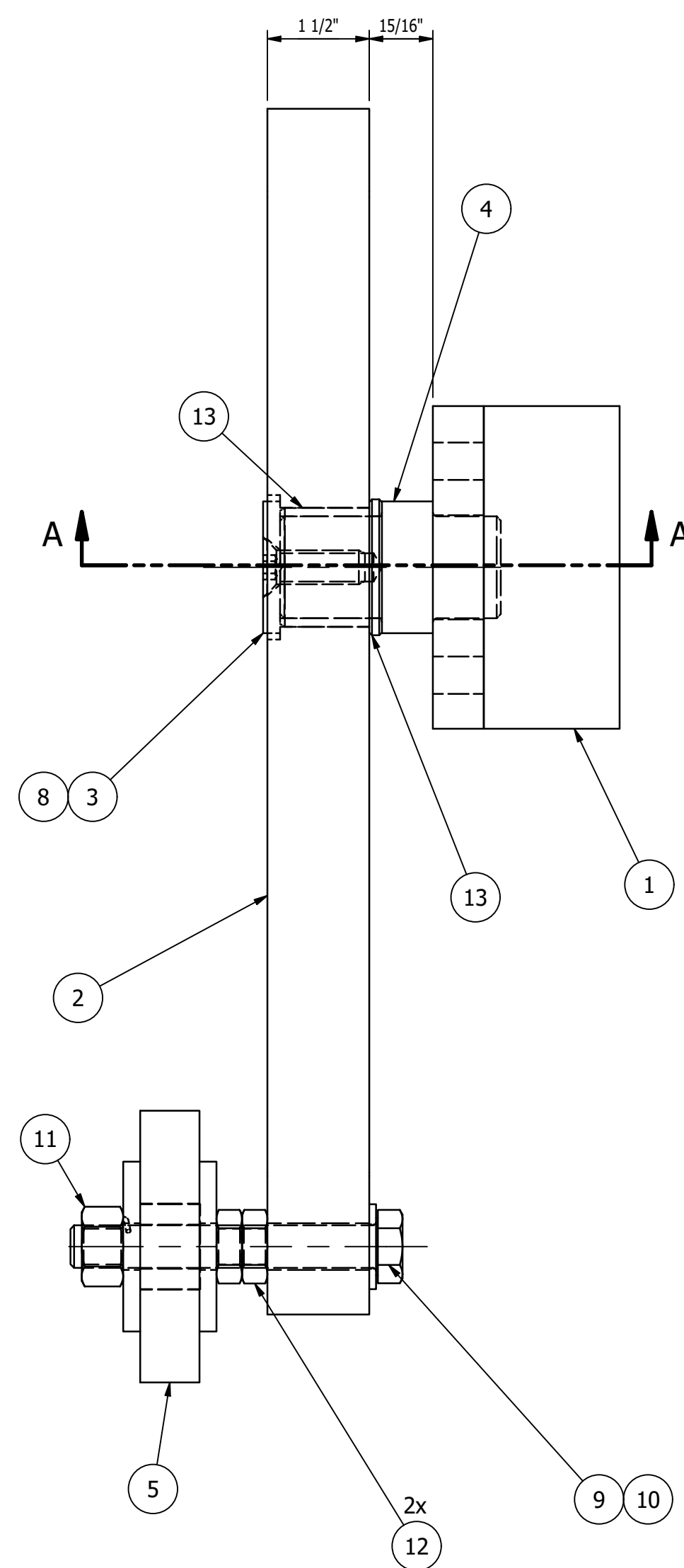
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



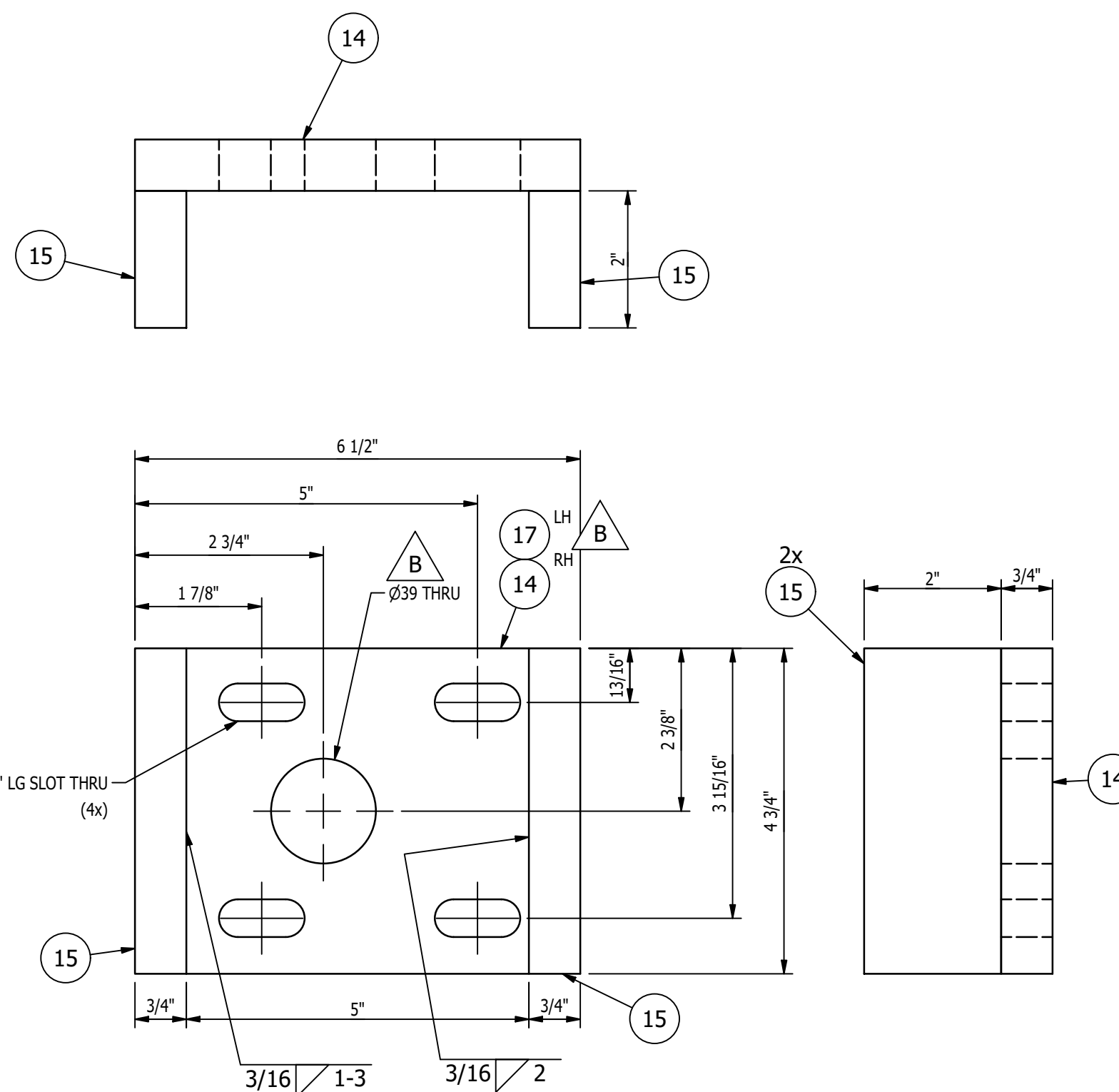
MK-D024A ~ GRAVITY STOP ASSEMBLY - RH (SHOWN)
 MK-D024C ~ GRAVITY STOP ASSEMBLY - LH (OPPOSITE)
 SCALE 6"=1'-0"



SECTION 'A-A'
 SCALE 6"=1'-0"



MK-D024B ~ GRAVITY STOP WELDMENT - RH (SHOWN)
 MK-D024D ~ GRAVITY STOP WELDMENT - LH (OPPOSITE)
 SCALE 6"=1'-0"



MK-D024B ~ GRAVITY STOP WELDMENT - RH (SHOWN)
 MK-D024D ~ GRAVITY STOP WELDMENT - LH (OPPOSITE)
 SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D024A			
1	1	MK-D024B ~ GRAVITY STOP WELDMENT - RH			
2	1	MK-D055A ~ GRAVITY STOP ARM			
3	1	MK-D056A ~ KEEPER PLATE			
4	1	MK-D056B ~ PIVOT SHAFT DETAIL			
5	1	MK-D056C ~ PIVOT WHEEL			
6	1	MK-D056D ~ PIVOT SHAFT			
7	2	MK-D056E ~ WHEEL PLATE			
8	1	1/2-13UNC x 1 1/2" LG. FLAT HEX SOCKET HEAD CAP SCREW			
9	1	5/8-11UNC x 4 1/2" LG. HEX HEAD CAP SCREW			
10	1	5/8 TYPE B NARROW FLAT WASHER			
11	1	ANCO LOCK NUT, 5/8-11, A194 -2H, PLAIN			
12	2	5/8-11UNC HEX JAM NUT			
13	1	BRONZE FLANGED BEARING, 1 3/4 OD x 1 3/4 ID x 1 1/2 LG, BUNTING PART NO. EBCF242812		6-8	
		MK-D024B			
14	1	BAR 3/4 x 6 1/2	4 3/4"		
15	2	BAR 3/4 x 2	4 3/4"		
		MK-D024C			
2	1	MK-D055A ~ GRAVITY STOP ARM			
3	1	MK-D056A ~ KEEPER PLATE			
4	1	MK-D056B ~ PIVOT SHAFT DETAIL			
5	1	MK-D056C ~ PIVOT WHEEL			
6	1	MK-D056D ~ PIVOT SHAFT			
7	2	MK-D056E ~ WHEEL PLATE			
8	1	1/2-13UNC x 1 1/2" LG. FLAT HEX SOCKET HEAD CAP SCREW			
9	1	5/8-11UNC x 4 1/2" LG. HEX HEAD CAP SCREW			
10	1	5/8 TYPE B NARROW FLAT WASHER			
12	2	5/8-11UNC HEX JAM NUT			
13	1	BRONZE FLANGED BEARING, 1 3/4 OD x 1 3/4 ID x 1 1/2 LG, BUNTING PART NO. EBCF242812		6-8	
16	1	MK-D024D ~ GRAVITY STOP WELDMENT - LH			
17	1	ANCO LOCK NUT, 5/8-11, A194 -2H, PLAIN			
		MK-D024D			
15	2	BAR 3/4 x 2	4 3/4"		
17	1	BAR 3/4 x 6 1/2	4 3/4"		

- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	REVISED HOLE SIZE, BALLOONS	
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY

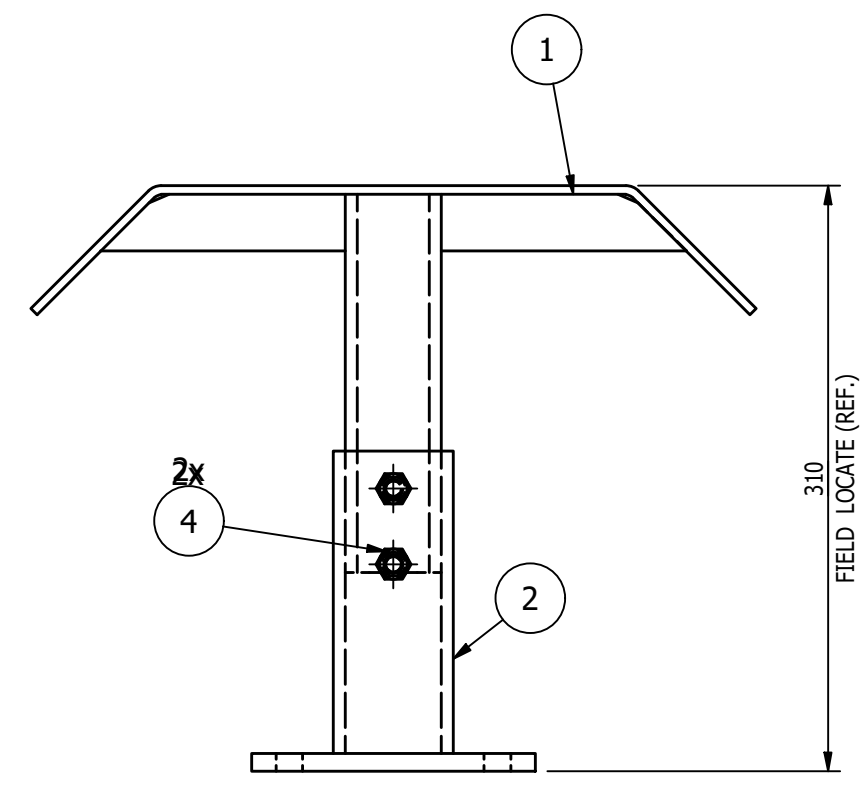
MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D024	DWG DATE:	6/7/22
REV:	B	JOB No:	22096

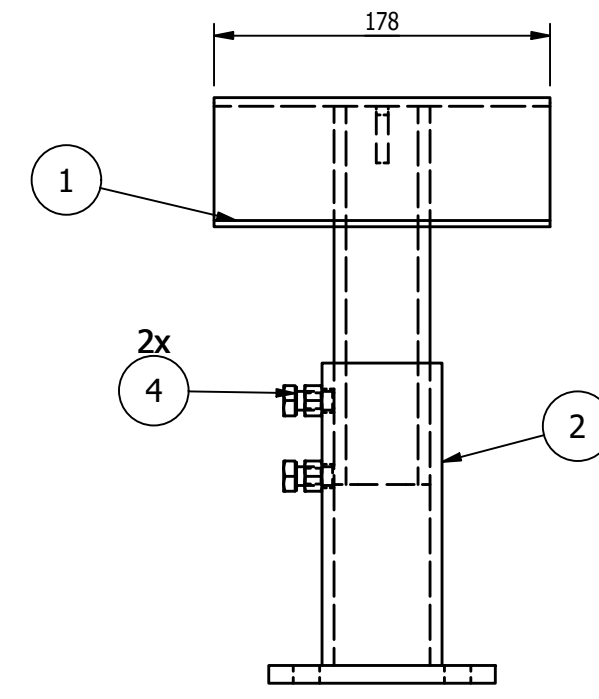
MAGNUM CONSULTING
 41100 QuakerRoad Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

- UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

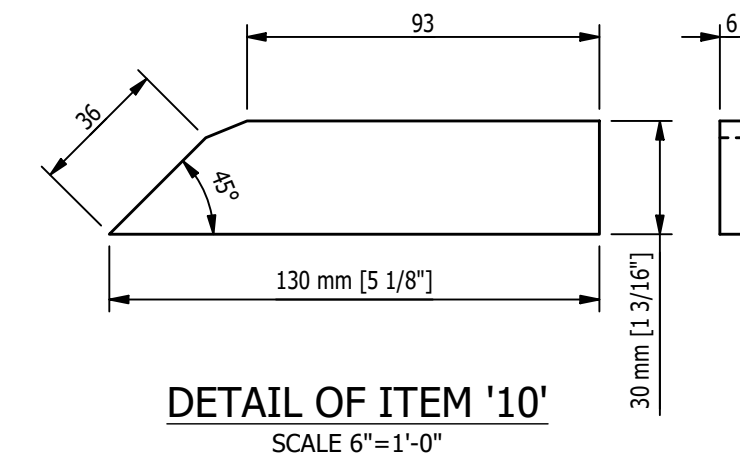
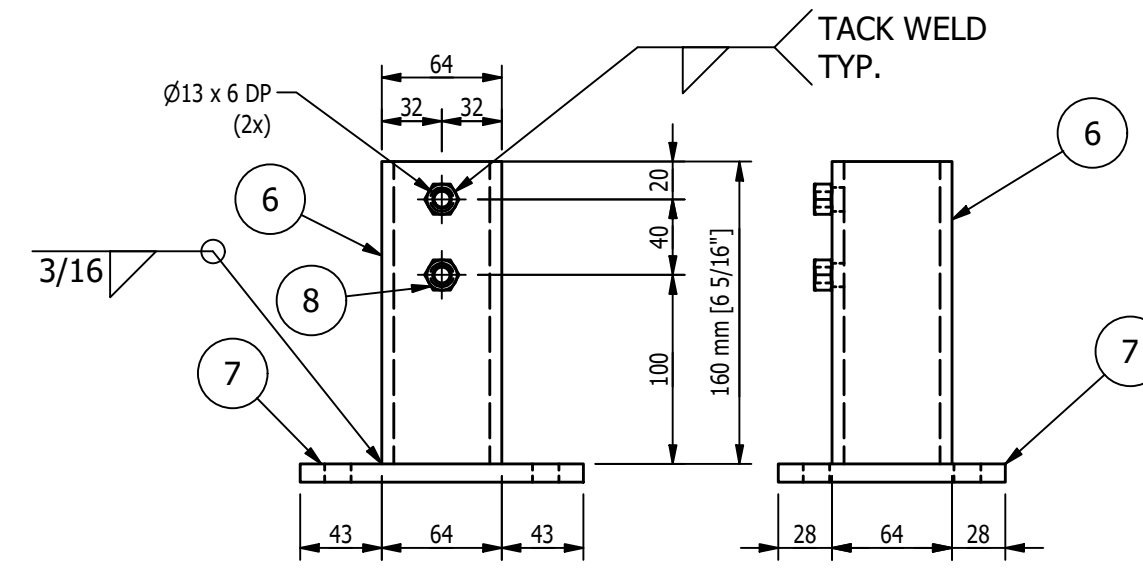
- GENERAL NOTES:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
- Holes:
- ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.
- WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)
- PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
- COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



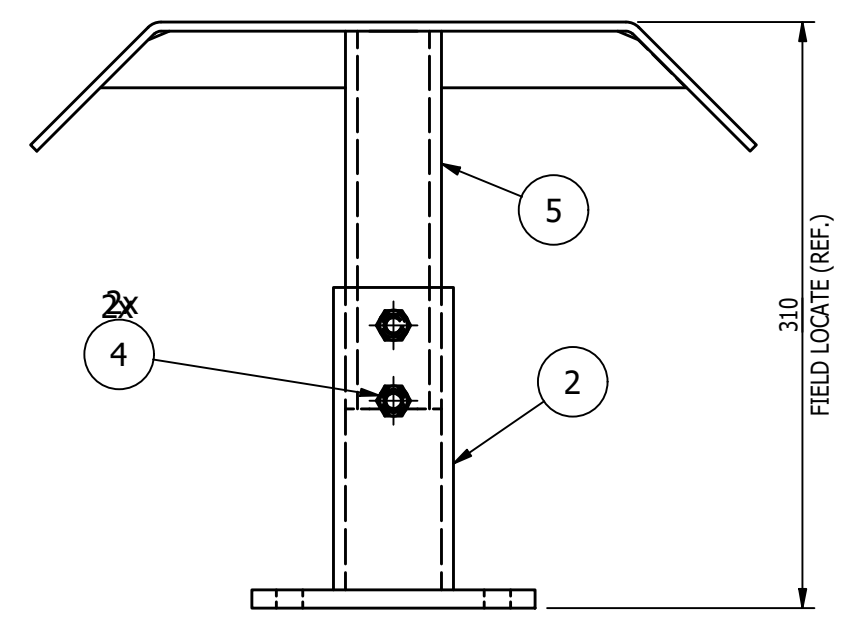
MK-D025A ~ STOP POST
SCALE 3"=1'-0"



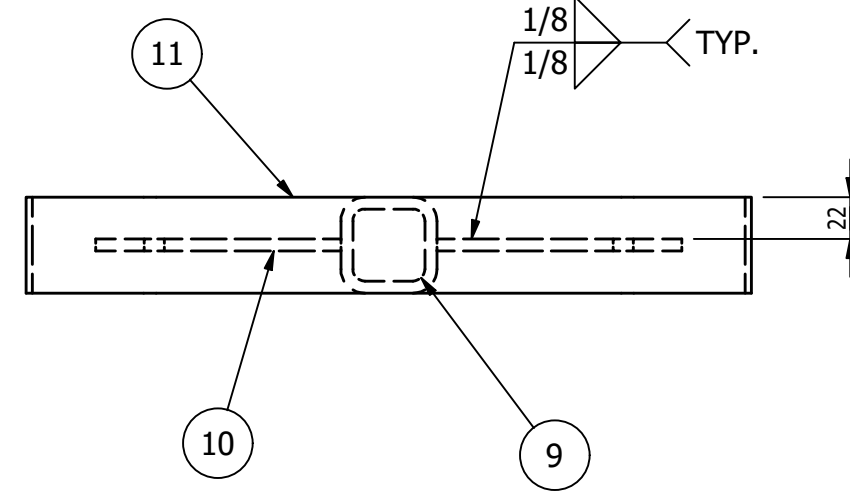
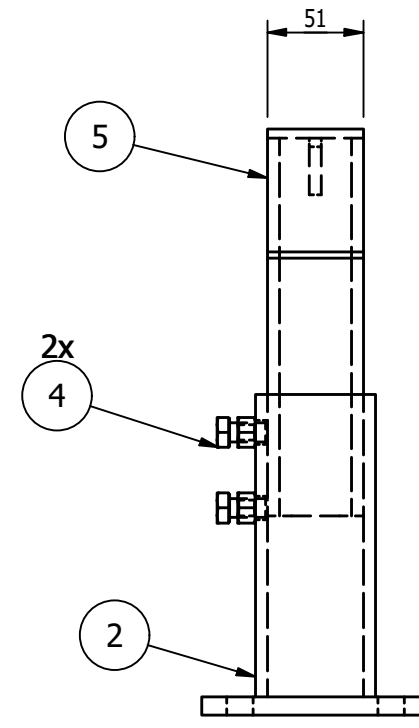
MK-D025C ~ LOWER STOP POST
SCALE 3"=1'-0"



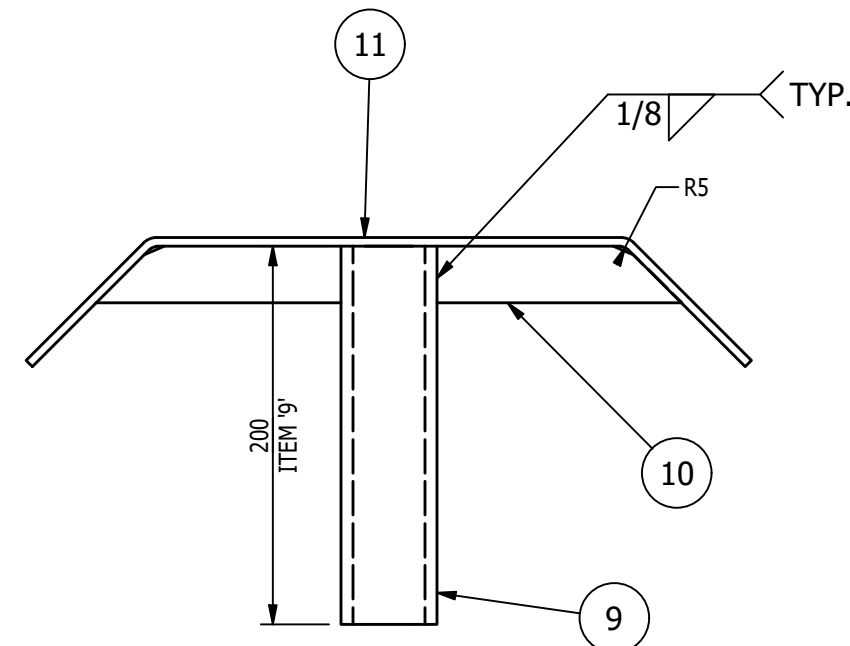
DETAIL OF ITEM '10'
SCALE 6"=1'-0"



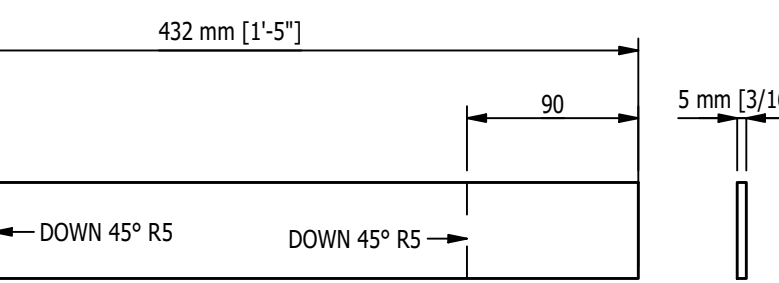
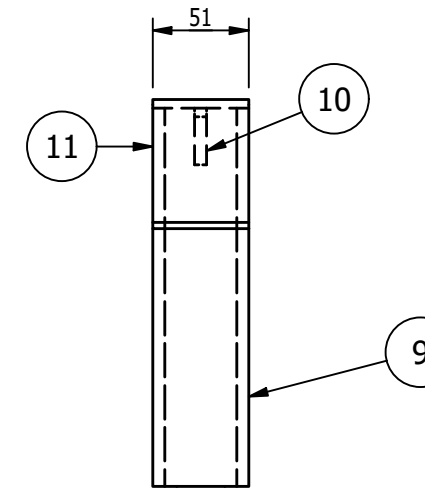
MK-D025B ~ STOP POST
SCALE 3"=1'-0"



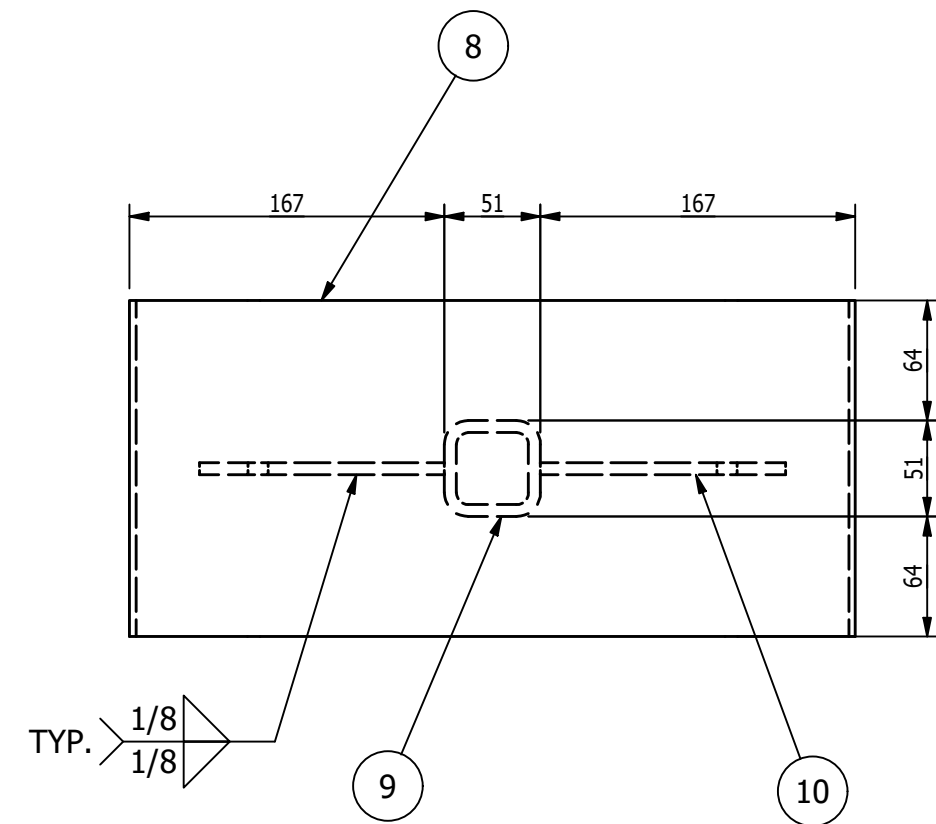
DETAIL OF ITEM '7'
SCALE 3"=1'-0"



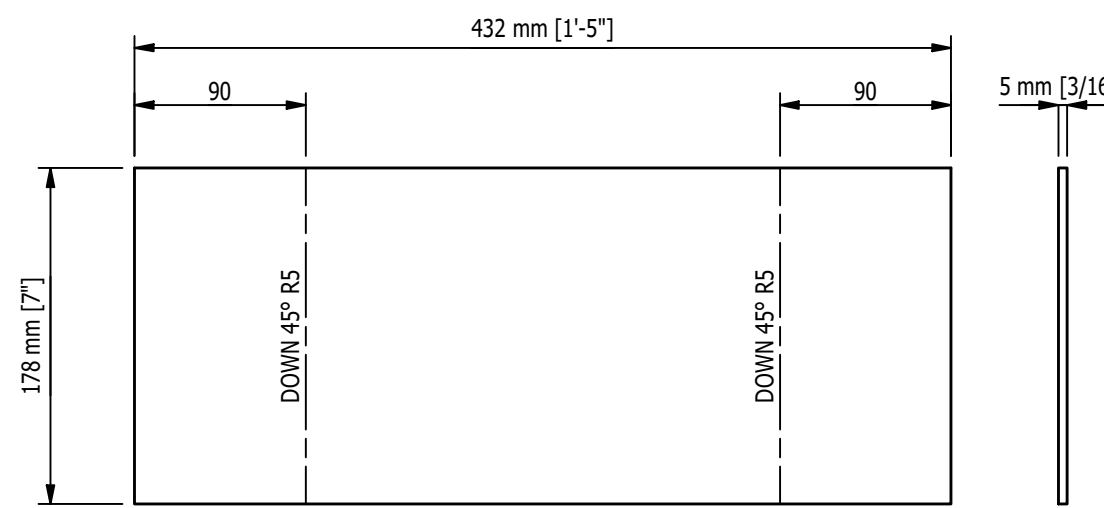
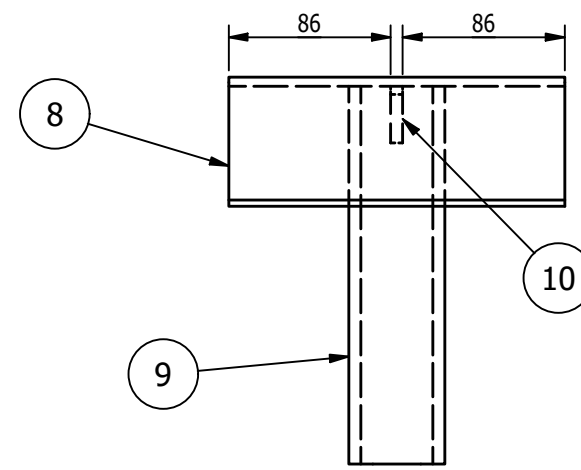
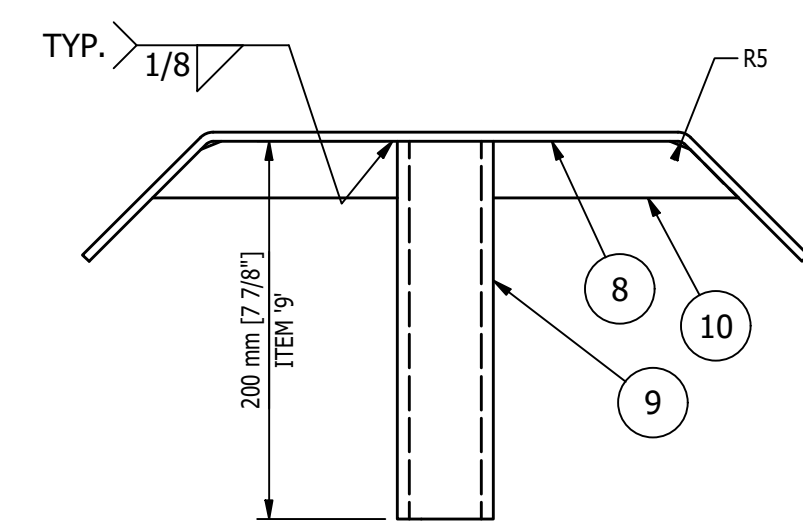
MK-D025E ~ UPPER STOP POST
SCALE 3"=1'-0"



DETAIL OF ITEM '11'
SCALE 3"=1'-0"



MK-D025D ~ UPPER STOP POST
SCALE 3"=1'-0"



DETAIL OF ITEM '8'
SCALE 3"=1'-0"

BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D025A		
1	1	MK-D025D ~ UPPER STOP POST		
2	1	MK-D025C ~ LOWER STOP POST		
4	2	M10x1.5 x 20mm LG. HEX CAP SCREW		
		MK-D025B		
2	1	MK-D025C ~ LOWER STOP POST		
4	2	M10x1.5 x 20mm LG. HEX CAP SCREW		
5	1	MK-D025E ~ UPPER STOP POST		
		MK-D025C		
6	1	TS 2 1/2 x 2 1/2 x 7 GA.	6 5/16"	
7	1	PL 3/8 x 4 3/4"	5 7/8"	
8	2	M10 x 1.5 HEX NUT		
		MK-D025D		
8	1	BAR 3/16 x 7	1'-5"	
9	1	TS 2 x 2 x 3/16"	7 7/8"	
10	2	PL 1/4 x 1 3/16"	6 5/16"	
		MK-D025E		
9	1	TS 2 x 2 x 3/16"	7 7/8"	
10	2	PL 1/4 x 1 3/16"	6 5/16"	
11	1	BAR 1/4 x 2	1'-5"	

NOTE:
FOR EXACT HEIGHTS OF MK-D025A & MK-D025B,
REFER TO LAYOUTS

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D025	DRAWN BY: AH CHECKED BY: CW DWG DATE: 7/12/22

DRAWING No. 1875D025	REV: A	JOB No: 22096
----------------------	--------	---------------

MAGNUM CONSULTING
 4100 Clarkston Road
 Suite 125
 Novi, MI 48275
 Phone: (248) 773-8833
 Fax: (248) 773-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D025

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

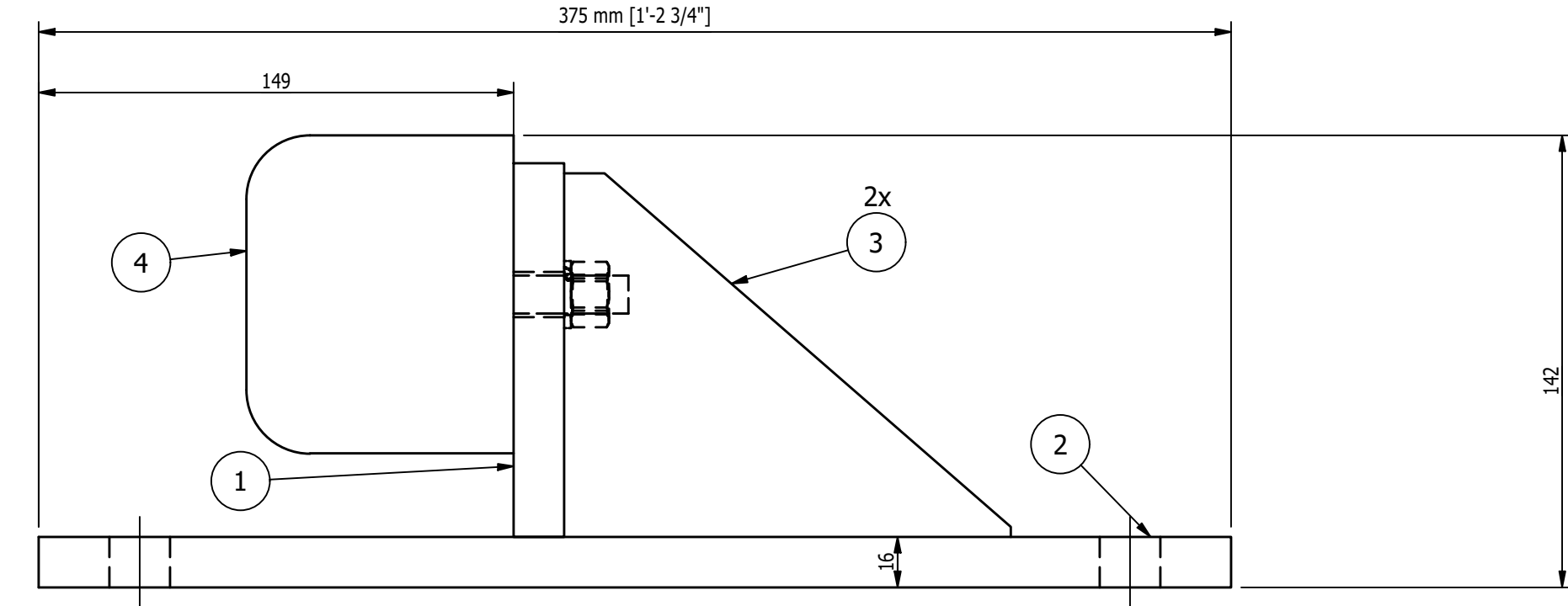
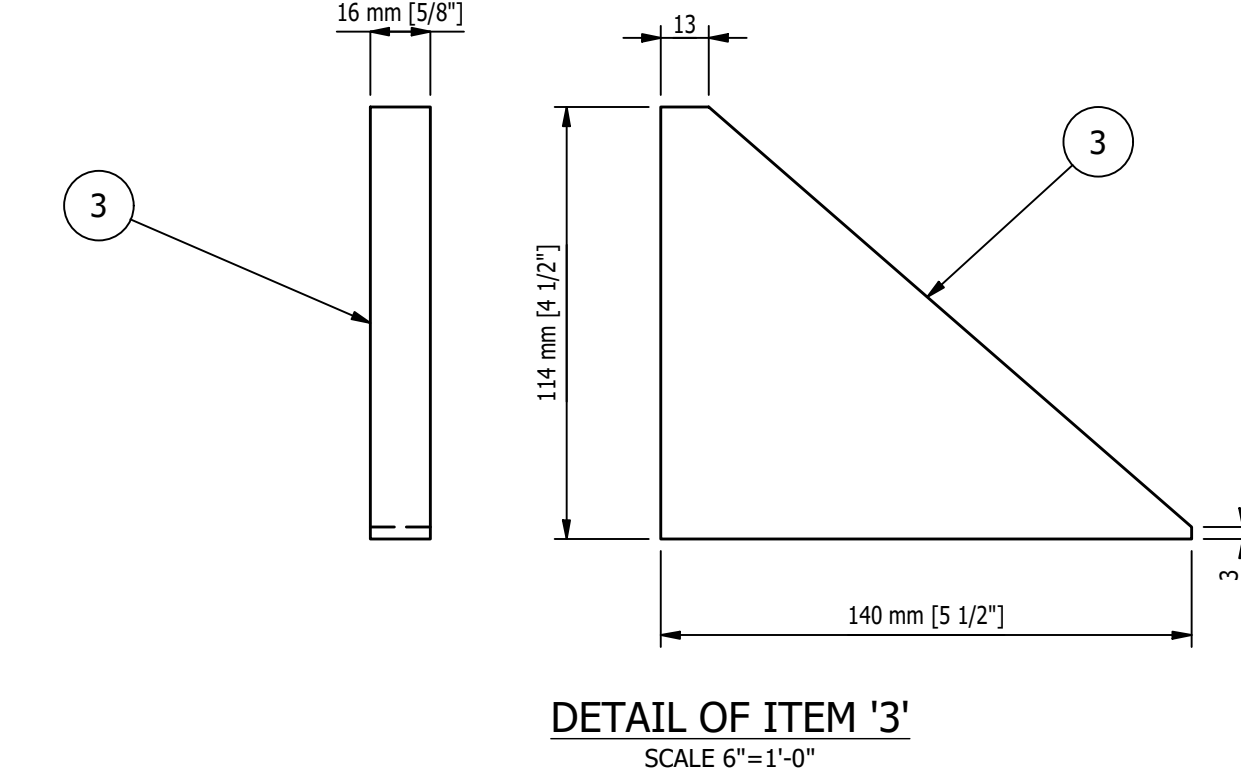
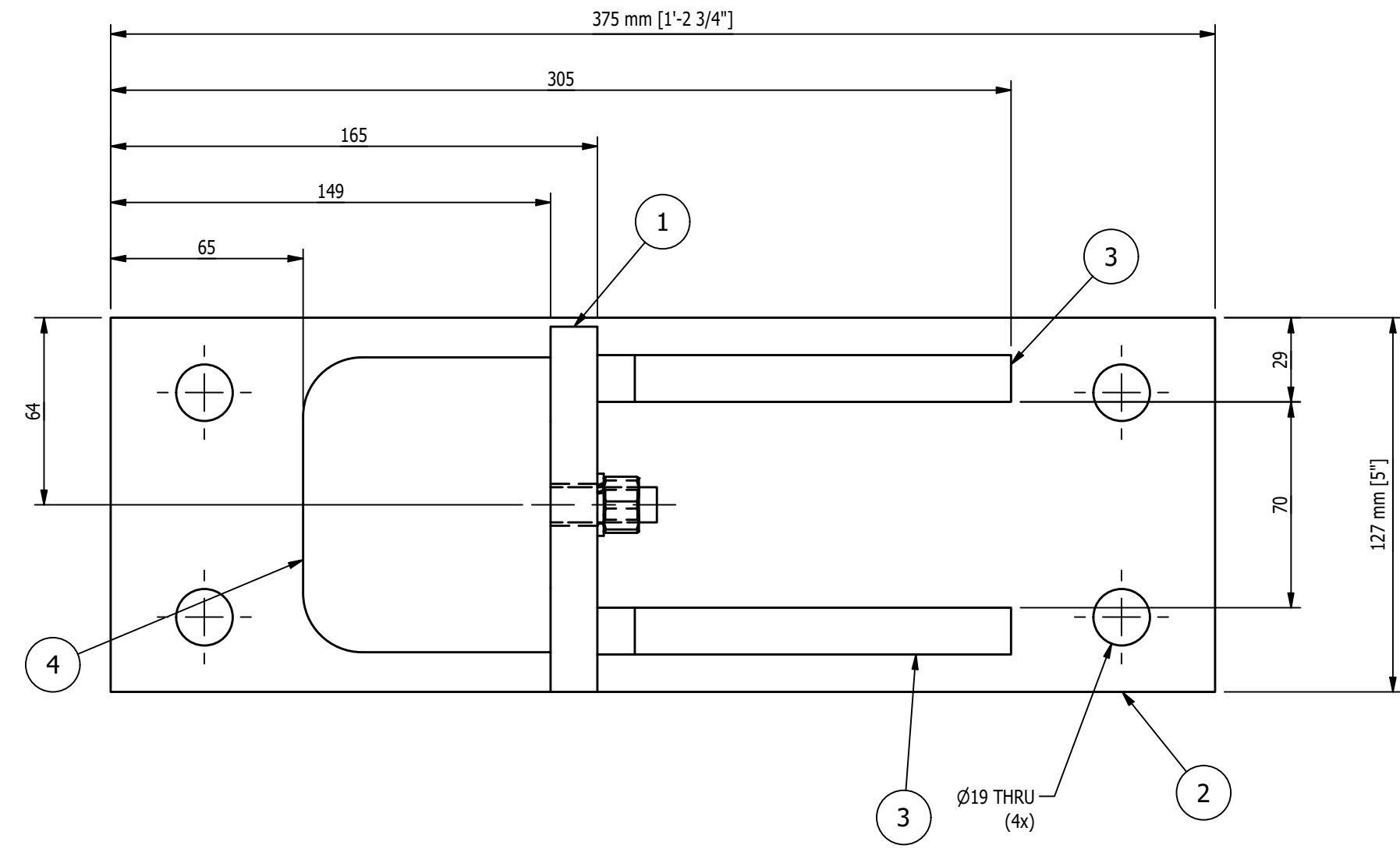
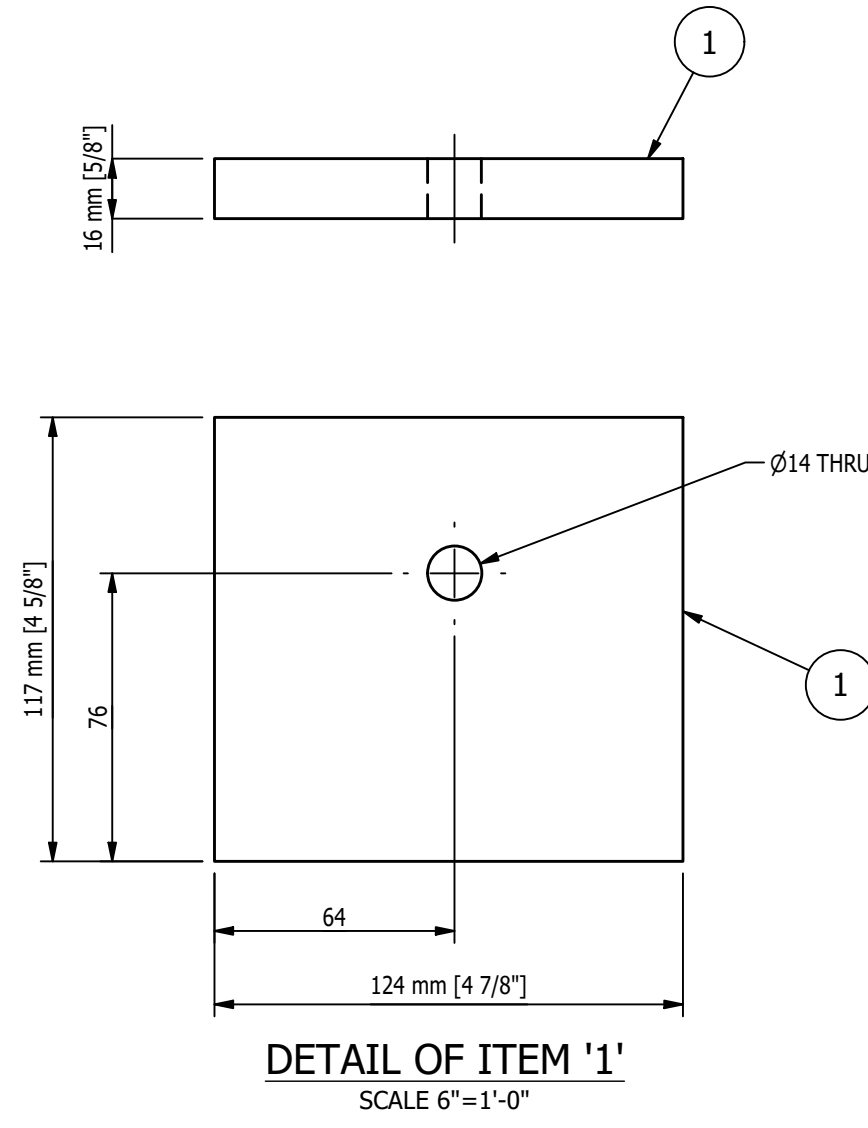
HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

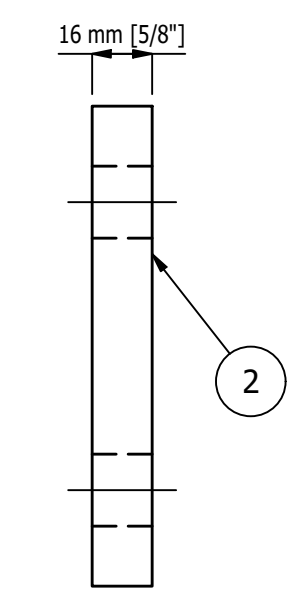
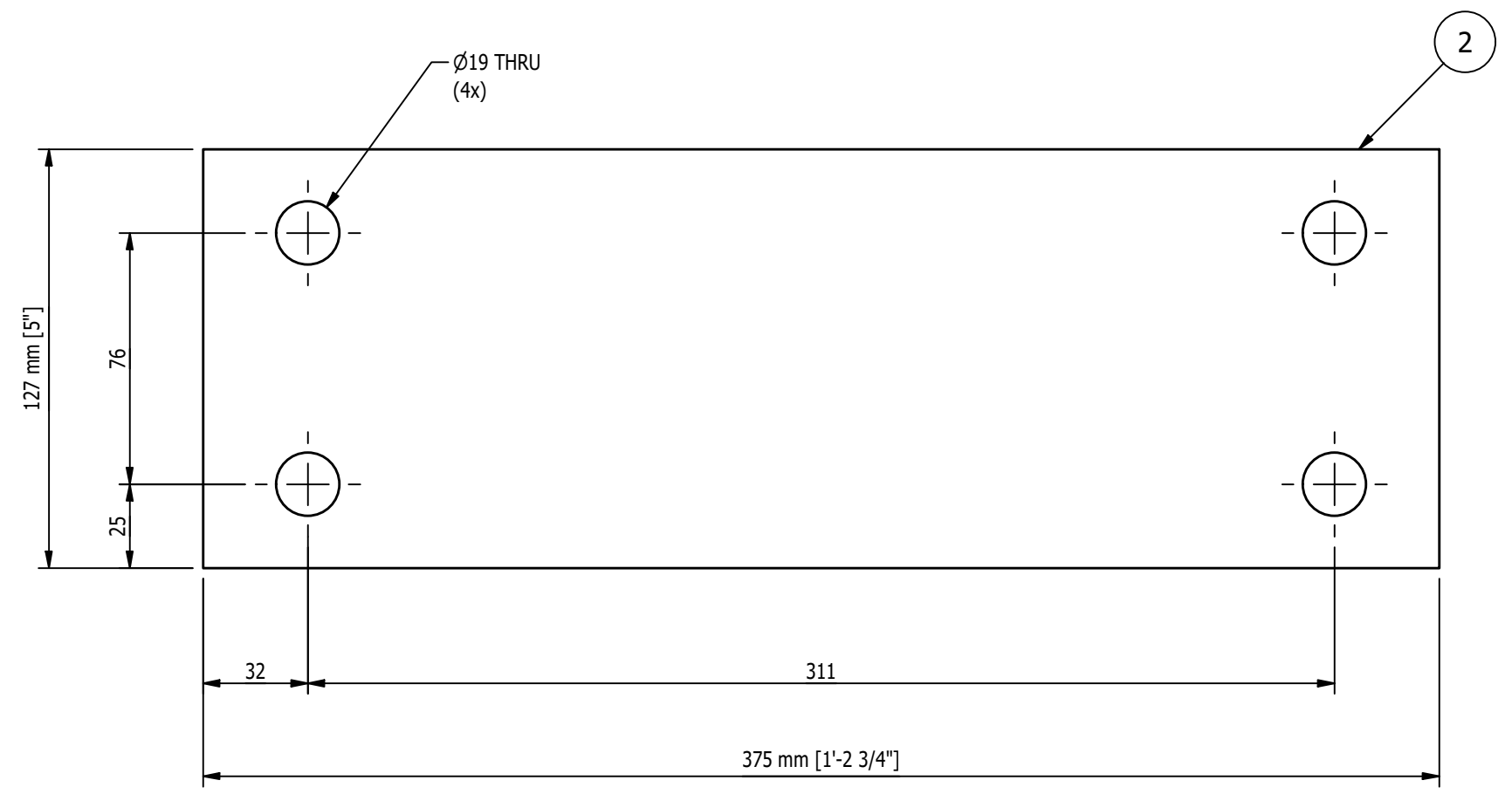
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D026A			
1	1	BAR 5/8 x 4 5/8	4 7/8"		
2	1	BAR 5/8 x 5	1'-2 3/4"		
3	2	BAR 5/8 x 4 1/2	5 1/2"		
4	1	BUMPER WITH FASTENERS, 100mm OD x 84mm LG BUMPER, 120 TOTAL LENGTH, M12 THREAD, CONDUCTIX-WAMPFLER PART NO. XA-017120-100N-1		6-1	INCLUDES M12 WASHER AND NUT
TOTAL WEIGHT ~ 32.5 LBS					



MK-D026A ~ PIVOT TABLE BUMPER
SCALE 6"=1'-0"



DETAIL OF ITEM '2'
SCALE 6"=1'-0"

- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/18/22	ADDED REMARKS TO ITEM '4'	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	
CLIENT: VOLVO	DRAWING No. 1875D026	REV: B	JOB No: 22096
DRAWN BY: AH	CHECKED BY: CW	DWG DATE: 6/7/22	

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REFRANT CUTS TO BE A MIN 1/2" RADIUS U.N.O.

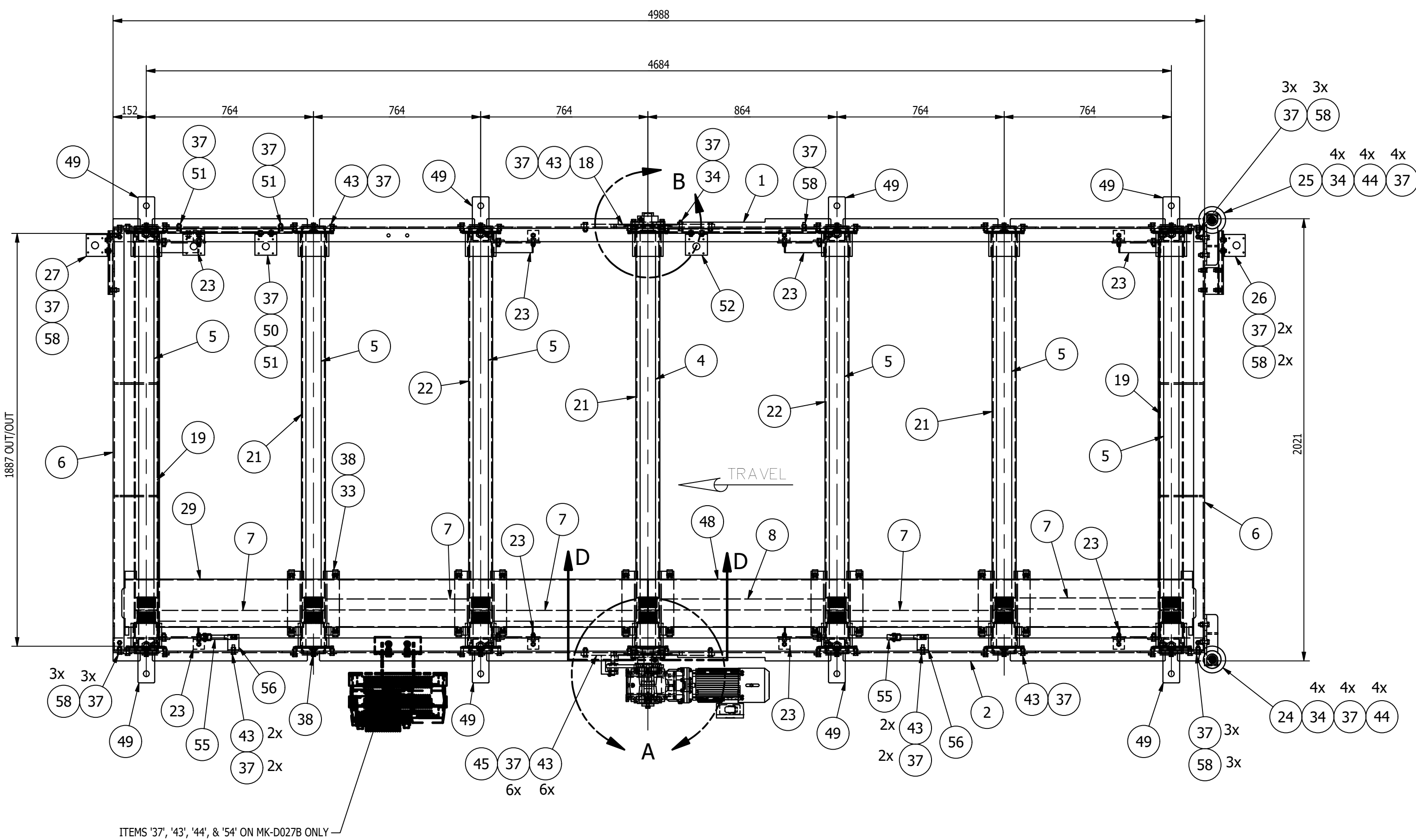
MAGNUM CONSULTING

41100 Charleston Rd.
Suite 125
Newport, MI 48255

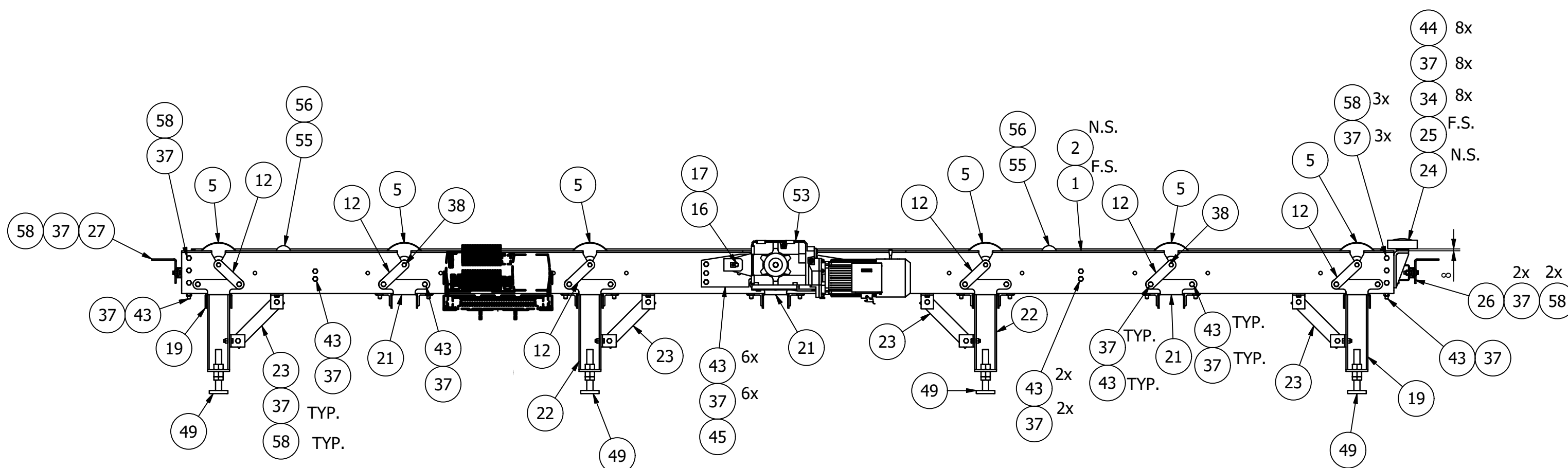
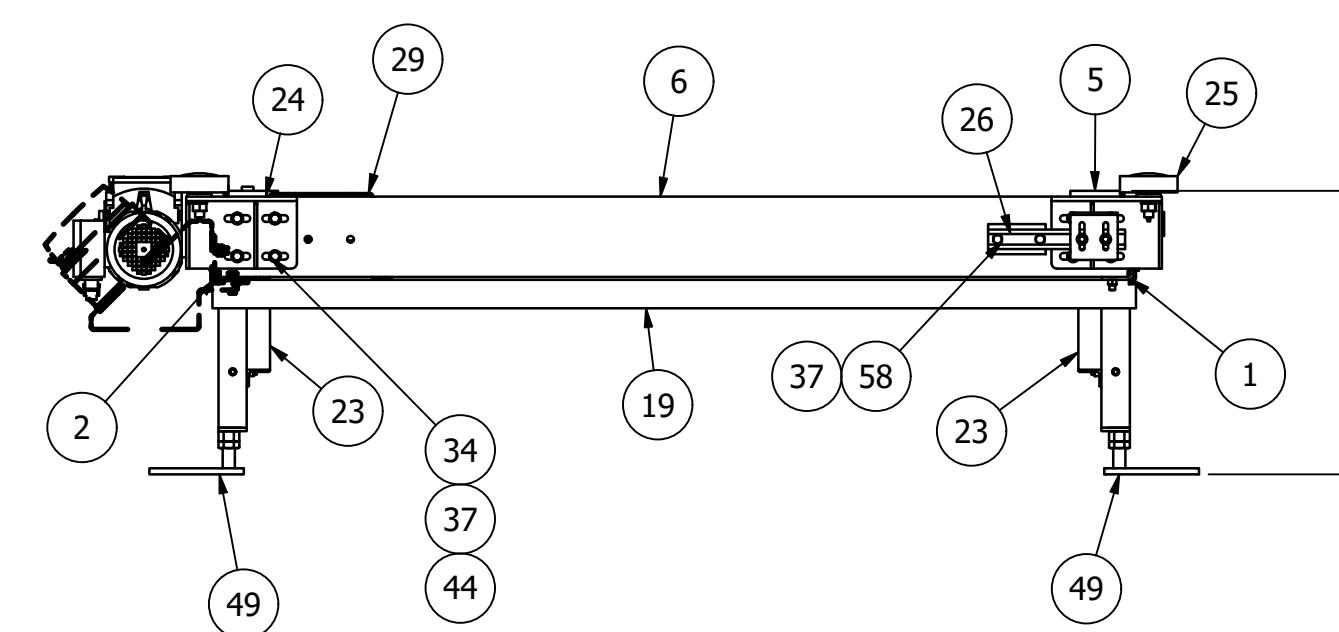
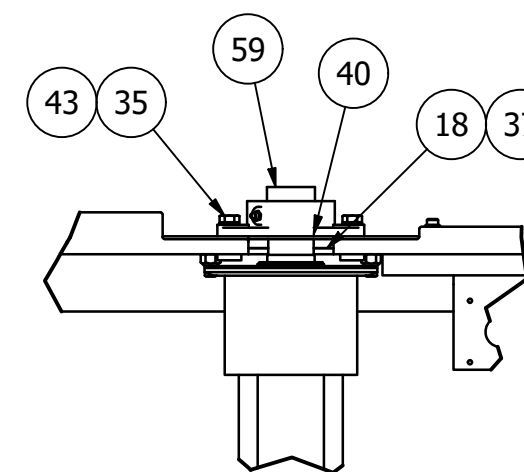
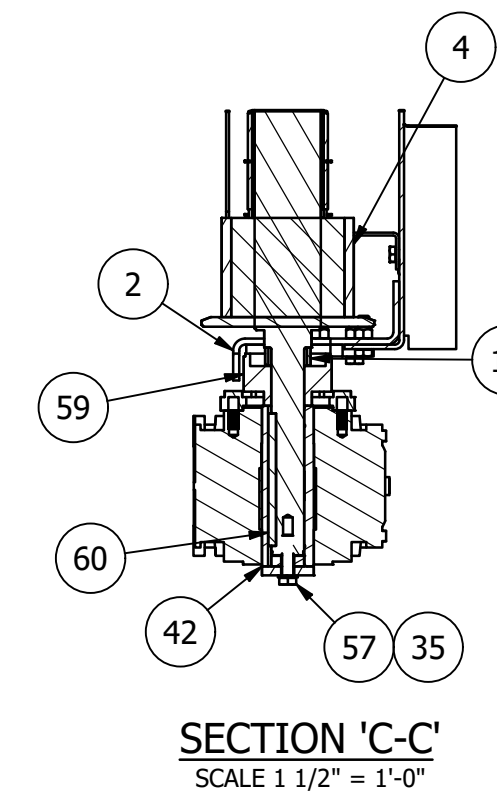
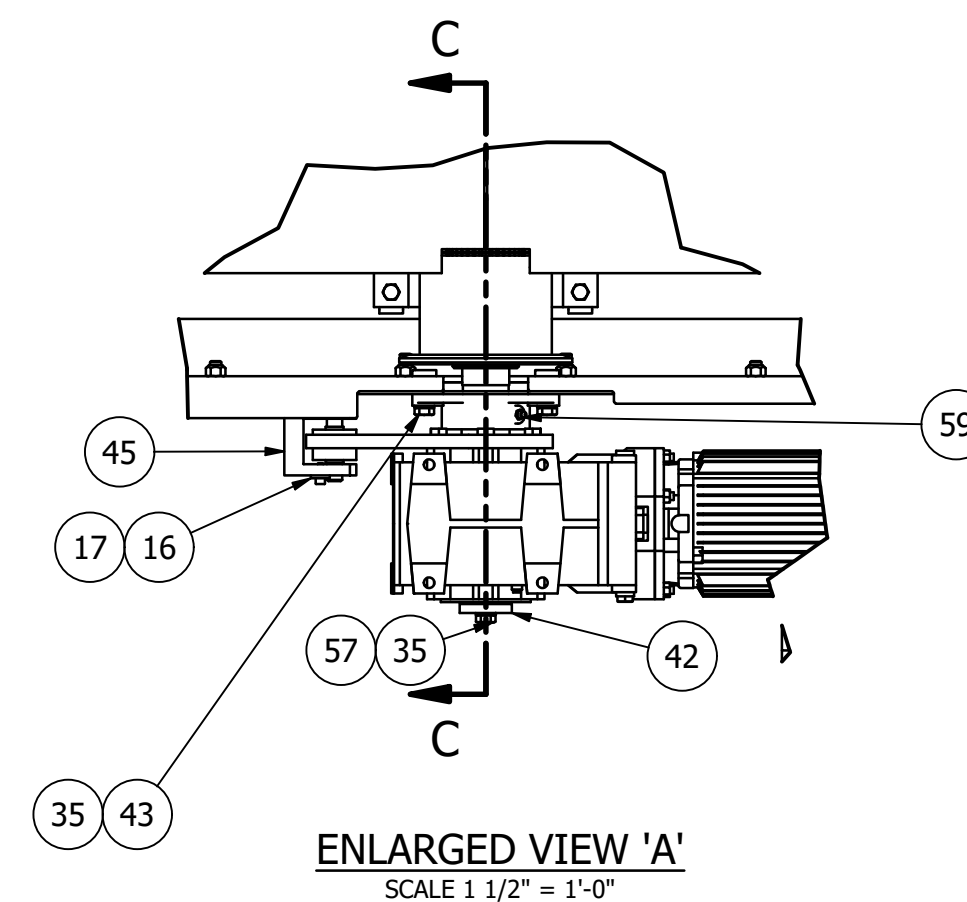
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D026

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

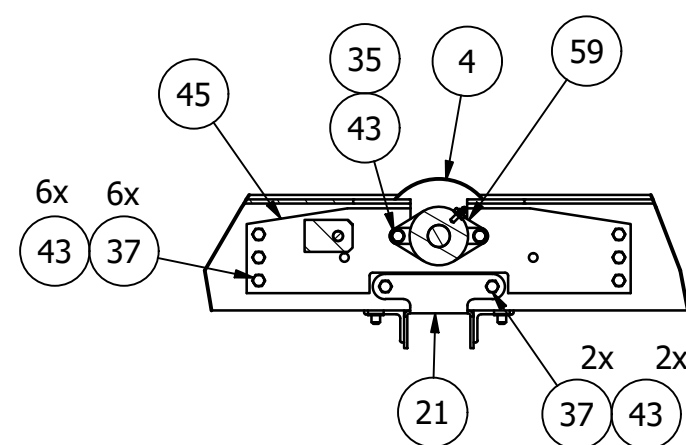


ITEMS '37', '43', '44', & '54' ON MK-D027B ONLY



MK-D027A ~ 7-ROLL ASSEMBLY (WITHOUT MK-D047A; SHOWN)
MK-D027B ~ 7-ROLL ASSEMBLY (WITH MK-D047A)

SCALE 3/4" = 1'-0"



- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

SPEED FORMULA (60HZ):

$$\pi \times 1760 \times \frac{1}{37.18} \times \frac{140}{1000} = 20.8 \text{ m/min} = 68.3 \text{ ft/min}$$

MAGNUM CONSULTING
4110 Quindaro Rd. Suite 125 West, MI 48375
Phone: (248) 772-8859 Fax: (248) 772-8851 Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D027 - REV B

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

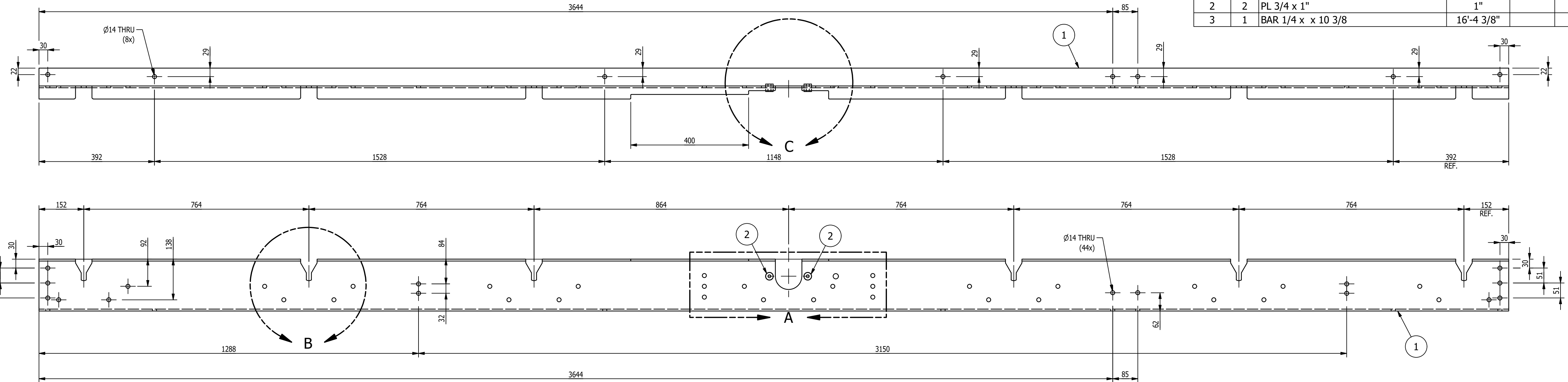
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

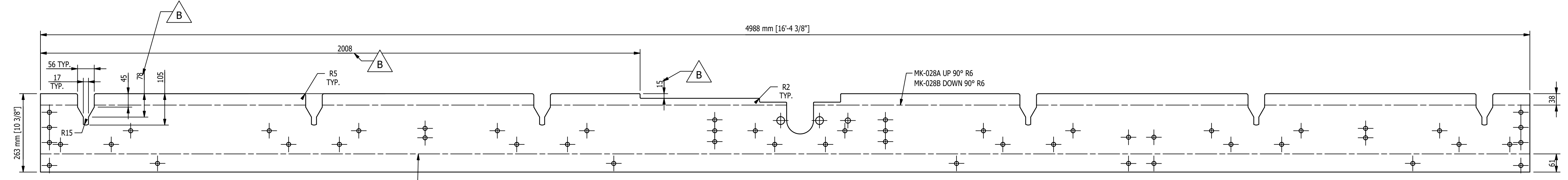
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D027A & MK-D027B			
1	1	MK-D028A ~ 7-ROLL SIDE FRAME ASSY - RH			
2	1	MK-D028B ~ 7-ROLL SIDE FRAME ASSY - LH			
4	1	D140/70x8/35 HTD 8M-55 POWER ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVE ROLL, PART NO. 332306V			
5	6	D140/70/30 Z34 HTD 8M-55 DRIVEN ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVEN ROLL, PART NO. 329A060W			
6	2	MK-D002A ~ END PLATE ASSEMBLY			
7	5	GATES POWERGRIP GT4 BELT, 1800-8M-GT50		2-5	
8	1	GATES POWERGRIP GT4 BELT, 2000-8M-GT50		2-4	
10	1	MK-D005D ~ SHAFT SPACER			
12	12	MK-D005B ~ ROLL KEEPER			
16	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
17	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
18	1	MK-D005C ~ BEARING PLATE			
19	2	MK-D004B ~ LEG ASSEMBLY			
21	3	MK-D004C ~ CROSS MEMBER WITH GUARD SUPPORT			
22	2	MK-D004D ~ LEG ASSEMBLY WITH GUARD SUPPORT			
23	8	MK-D008A ~ ANGLE BRACE			
24	1	MK-D006C ~ SKID GUIDE ROLLER - LH			
25	1	MK-D006D ~ SKID GUIDE ROLLER - RH			
26	1	MK-D009A ~ PROX BRACKET			
27	1	MK-D009B ~ PROX BRACKET			
29	1	MK-D010A ~ BELT GUARD			
33	20	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
34	9	M12x1.75 x 40mm LG. HEX CAP SCREW			
35	5	M12 SPRING LOCK WASHER			
37	105	M12 x 1.75 STOVER LOCK NUT			
38	32	M10x1.5 x 25mm LG. HEX CAP SCREW			
40	1	MK-D005E ~ SHAFT SPACER			
42	1	MK-D005F ~ MOTOR END PLATE			
43	51	M12x1.75 x 35mm LG. HEX CAP SCREW			
44	16	M12 NARROW FLAT WASHER			
45	1	MK-D005A ~ BEARING PLATE			
48	1	MK-D010E ~ BELT GUARD			
49	8	MK-D007A ~ ADJUSTING SUPPORT			
50	1	MK-D009D ~ PROX BRACKET			
51	2	M12x1.75 x 25mm LG. HEX CAP SCREW			
52	1	MK-D009C ~ PROX BRACKET			
53	1	SIEMENS RB2 GEARMOTOR (SEE MOTOR DATA LIST)		1-2	
55	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
56	2	MK-D005G ~ STATIC WHEEL BRACKET			
57	1	M12x1.75 x 45mm LG. HEX CAP SCREW			
58	49	M12x1.75 x 30mm LG. HEX CAP SCREW			
59	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
60	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	
TOTAL WEIGHT ~ 2508.3 lbs					
MK-D027B					
37	4	M12 x 1.75 STOVER LOCK NUT			
43	4	M12x1.75 x 35mm LG. HEX CAP SCREW			
44	4	M12 NARROW FLAT WASHER			
54	1	MK-D047A ~ CONTROLLER BRACKET			
61	1	MK-D027A ~ 7-ROLL ASSEMBLY			
TOTAL WEIGHT ~ 2531.9 lbs					

B	MC	8/4/2022	REVISED BALLOONS MULTIPLE ITEMS	
A	MC	7/22/22	FOR FABRICATION	
REV	BY	DATE	DESCRIPTION	APP
REVISION HISTORY				
			MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	
TITLE: P6700 CONVEYORS CAMPUS BUILDING			PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
CLIENT: VOLVO			DRAWN BY: RJB CHECKED BY: CW DWG DATE: 6/7/22	
DRAWING No. 1875D027			REV: B JOB No: 22096	

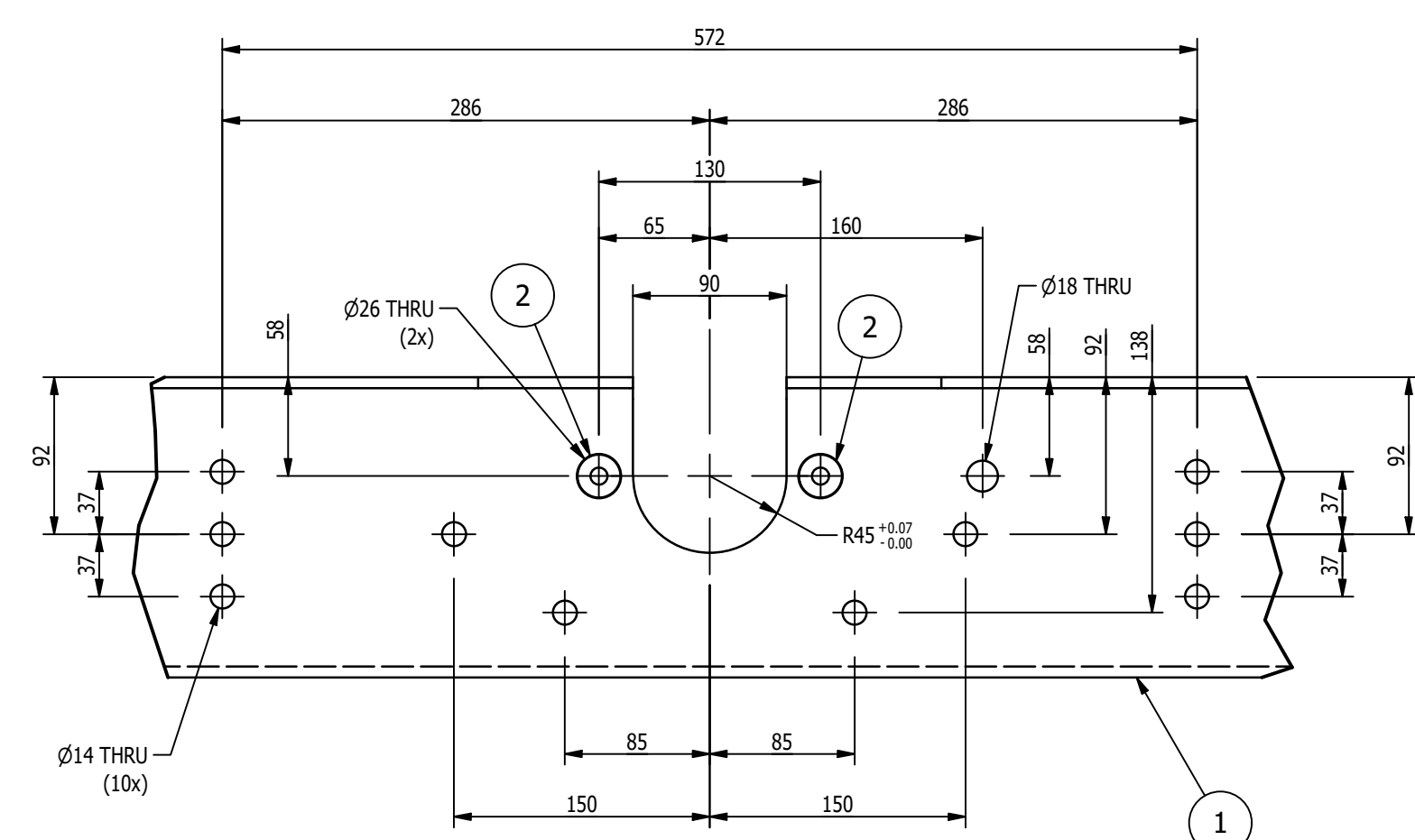
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D028A			
1	1	BAR 1/4 x 10 3/8"	16'-4 3/8"		
2	2	PL 1 x 1"	1"		
		MK-D028B			
2	2	PL 3/4 x 1"	1"		
3	1	BAR 1/4 x x 10 3/8	16'-4 3/8"		



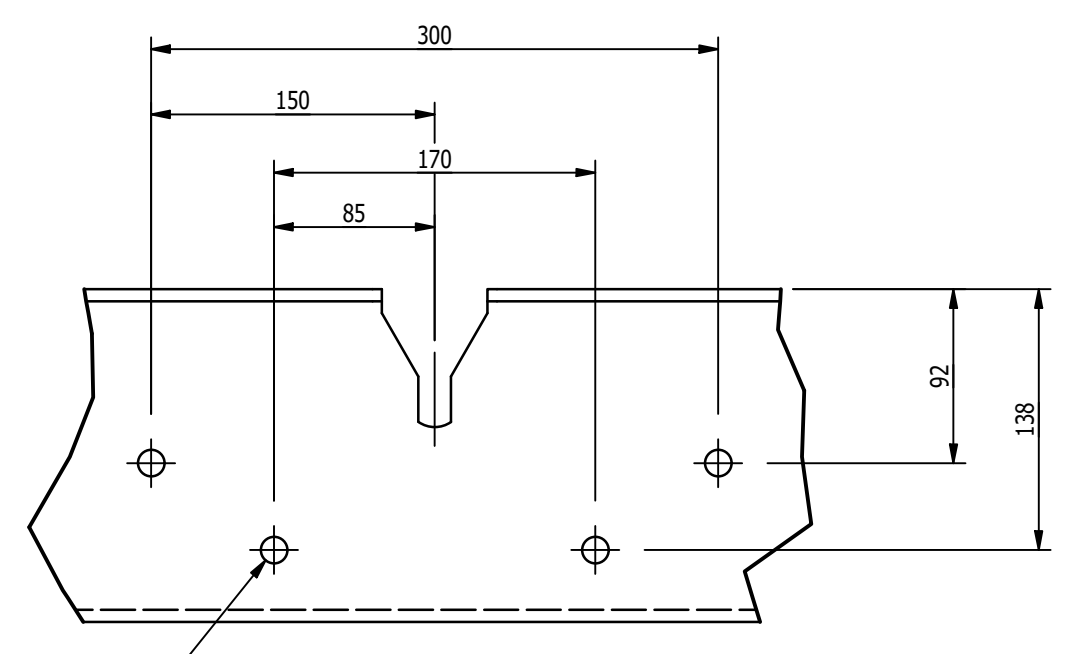
MK-D028A ~ 7-ROLL SIDE FRAME ASSY - RH (SHOWN)
 MK-D028B ~ 7-ROLL SIDE FRAME ASSY - LH (OPPOSITE)
 SCALE 1 1/2"=1'-0"



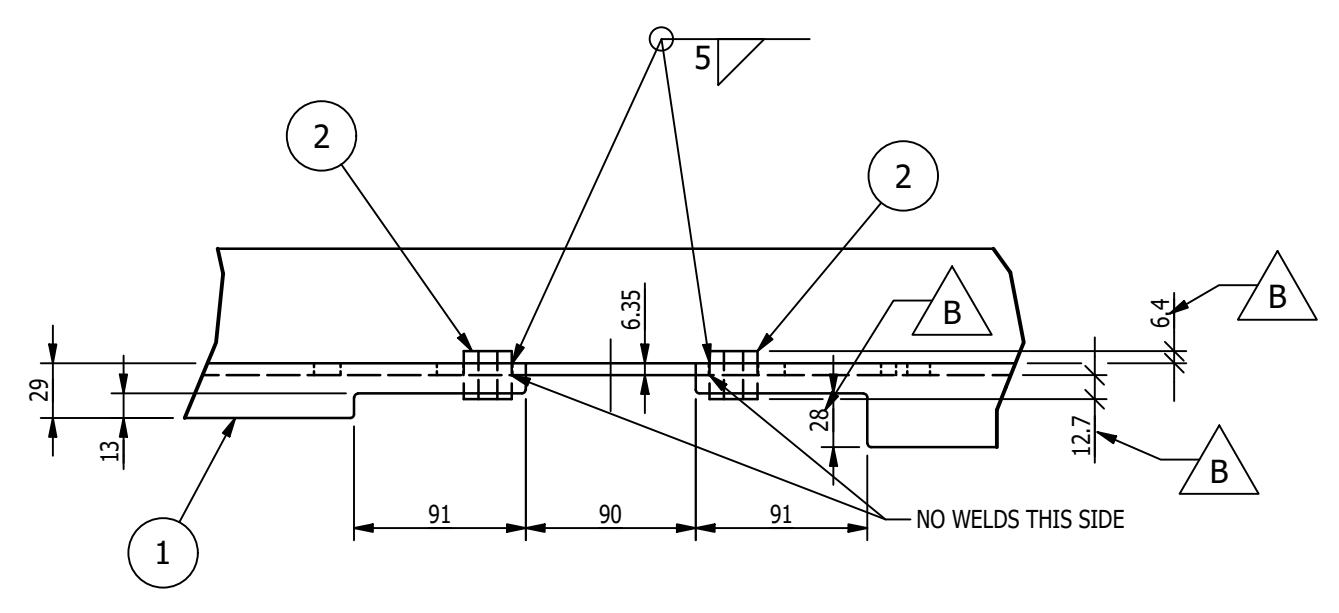
FLAT PATTERN OF ITEM '1'
 FLAT PATTERN OF ITEM '3'
 SCALE 1 1/2"=1'-0"



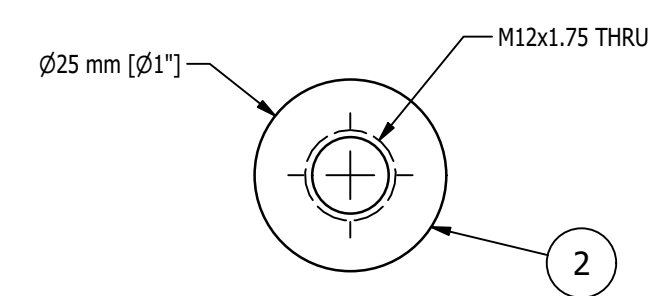
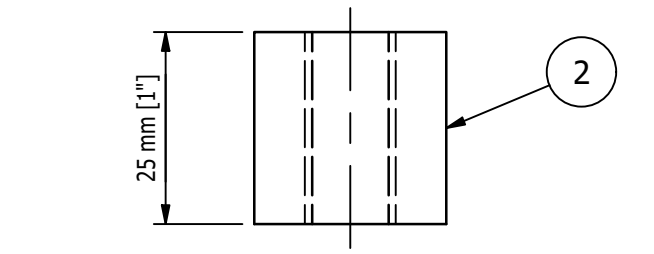
ENLARGED VIEW 'A'
 SCALE 3" = 1'-0"



ENLARGED VIEW 'B'
 SCALE 3" = 1'-0"



ENLARGED VIEW 'C'
 SCALE 3" = 1'-0"



DETAIL OF ITEM '2'
 SCALE 1'-0" = 1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
 PAINT ALL FABRICATED STEEL
 ONE SHOP COAT OF LIGHT GREY RAL 7035

MAGNUM Consulting
 41100 Clarkston Rd.
 Suite 125
 Novi, MI 48235
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D028 - REV B

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/4/2022	ADDED, REVISED DIMS	
A	MC	7/25/22	FOR FABRICATION	

REVISION HISTORY

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE: P6700 CONVEYORS
CAMPUS BUILDING

CLIENT: VOLVO

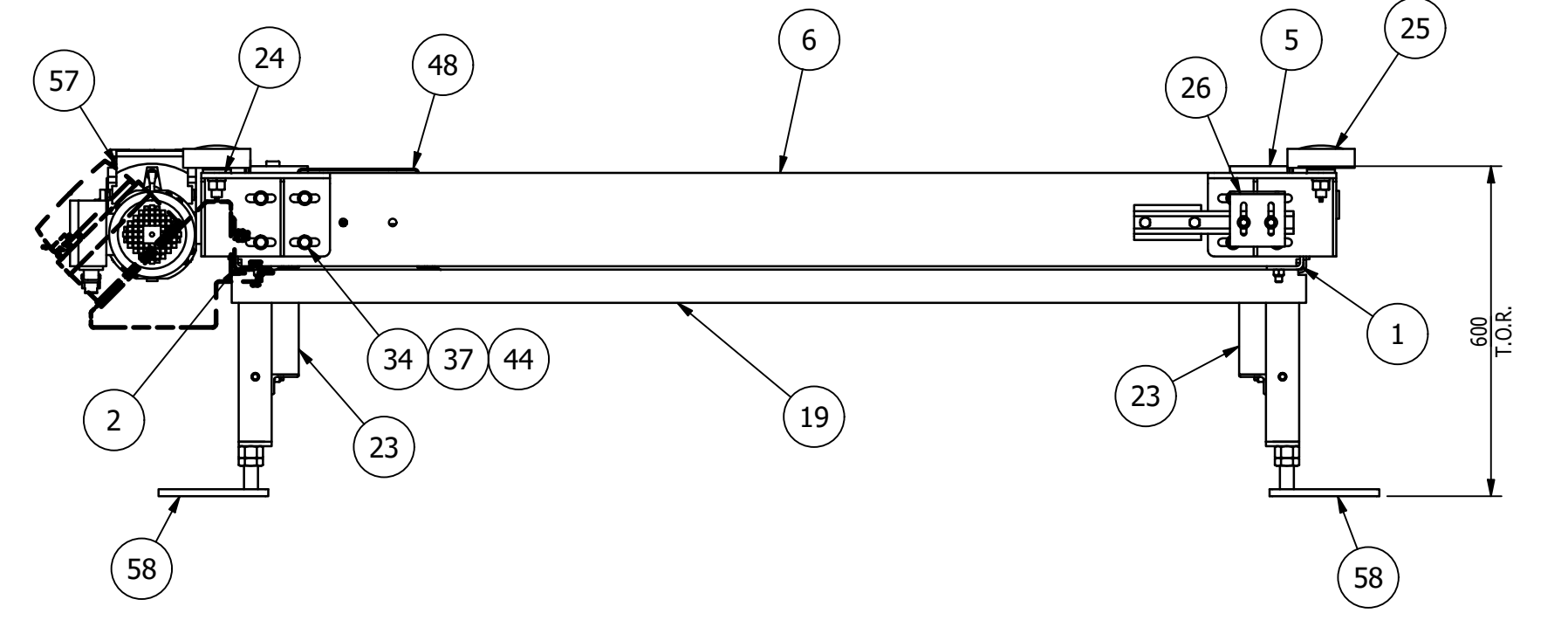
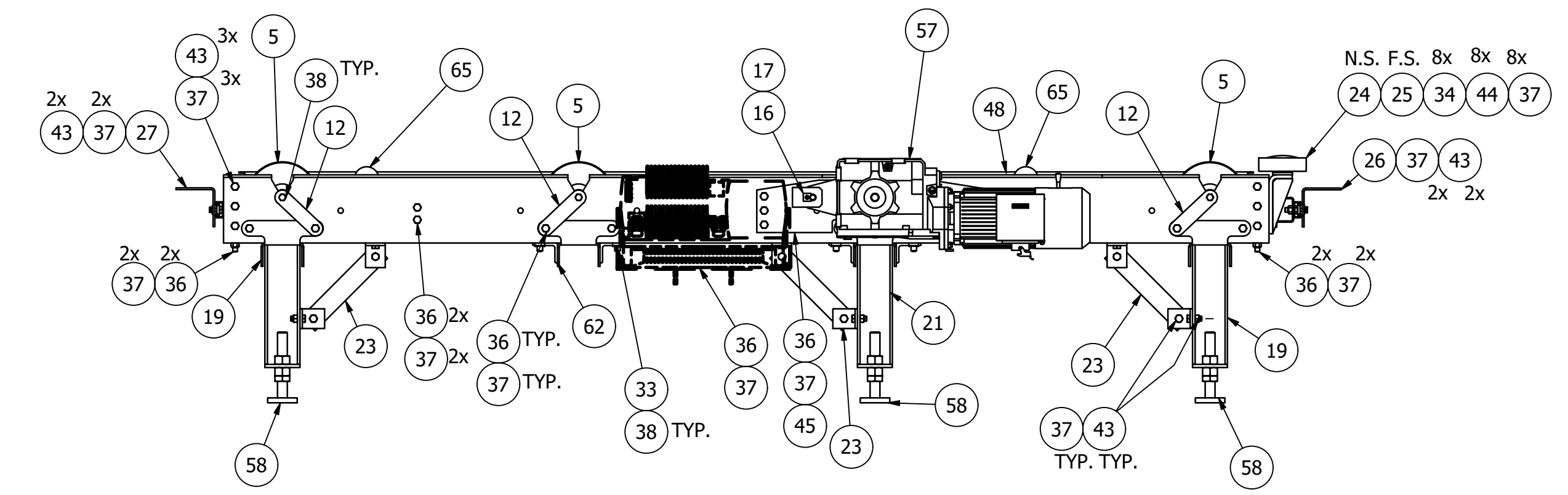
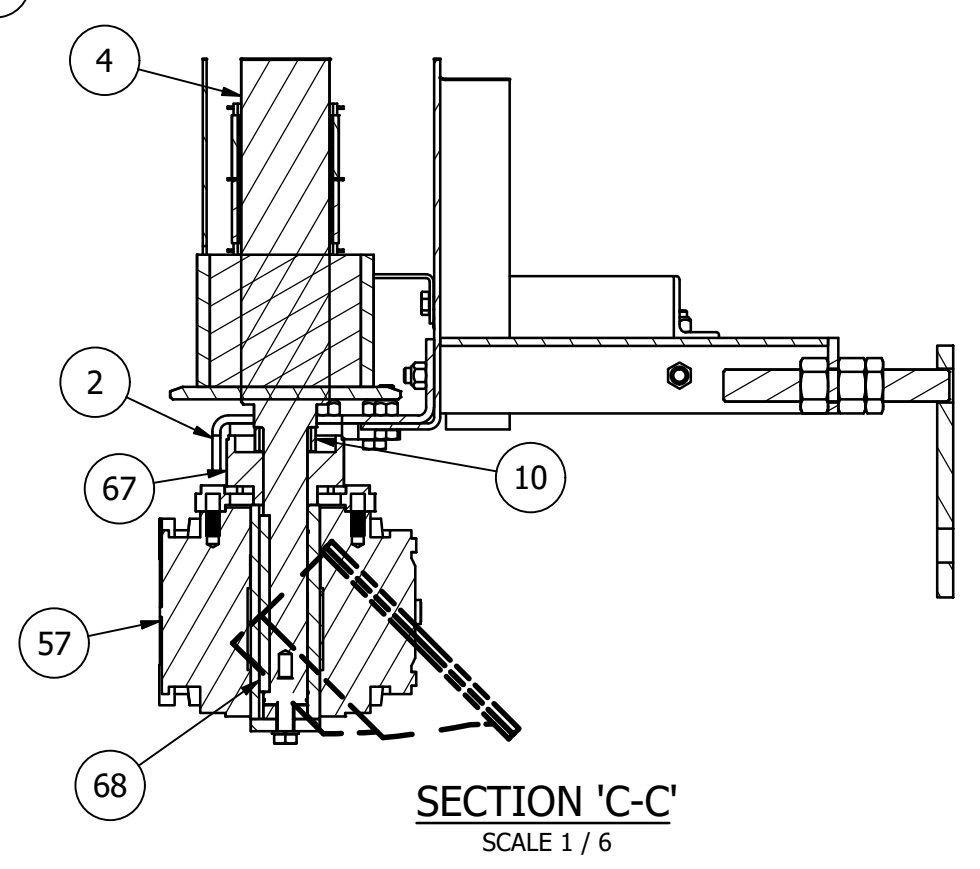
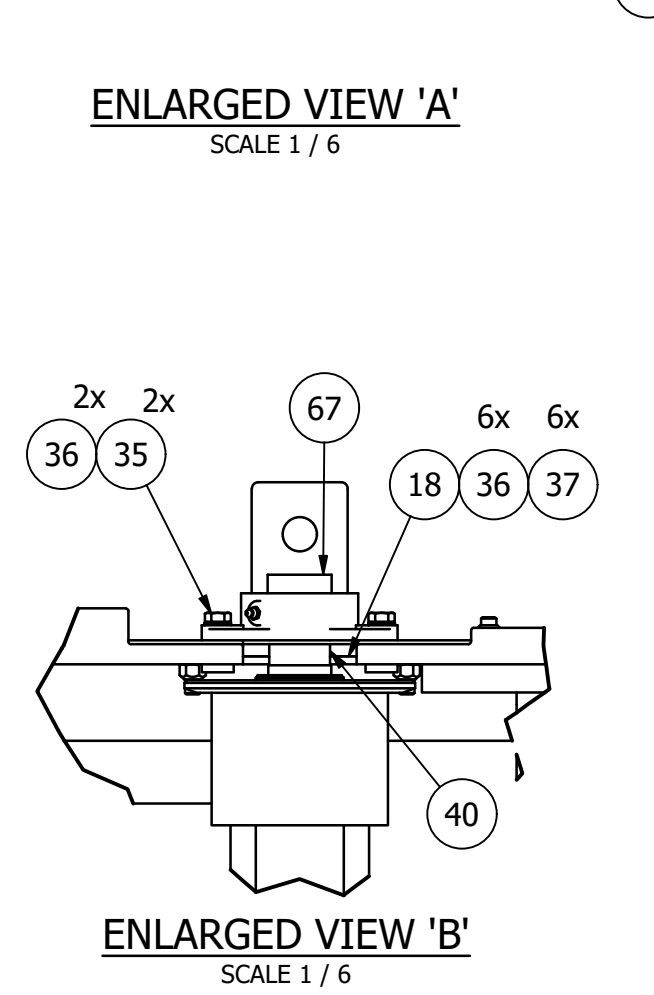
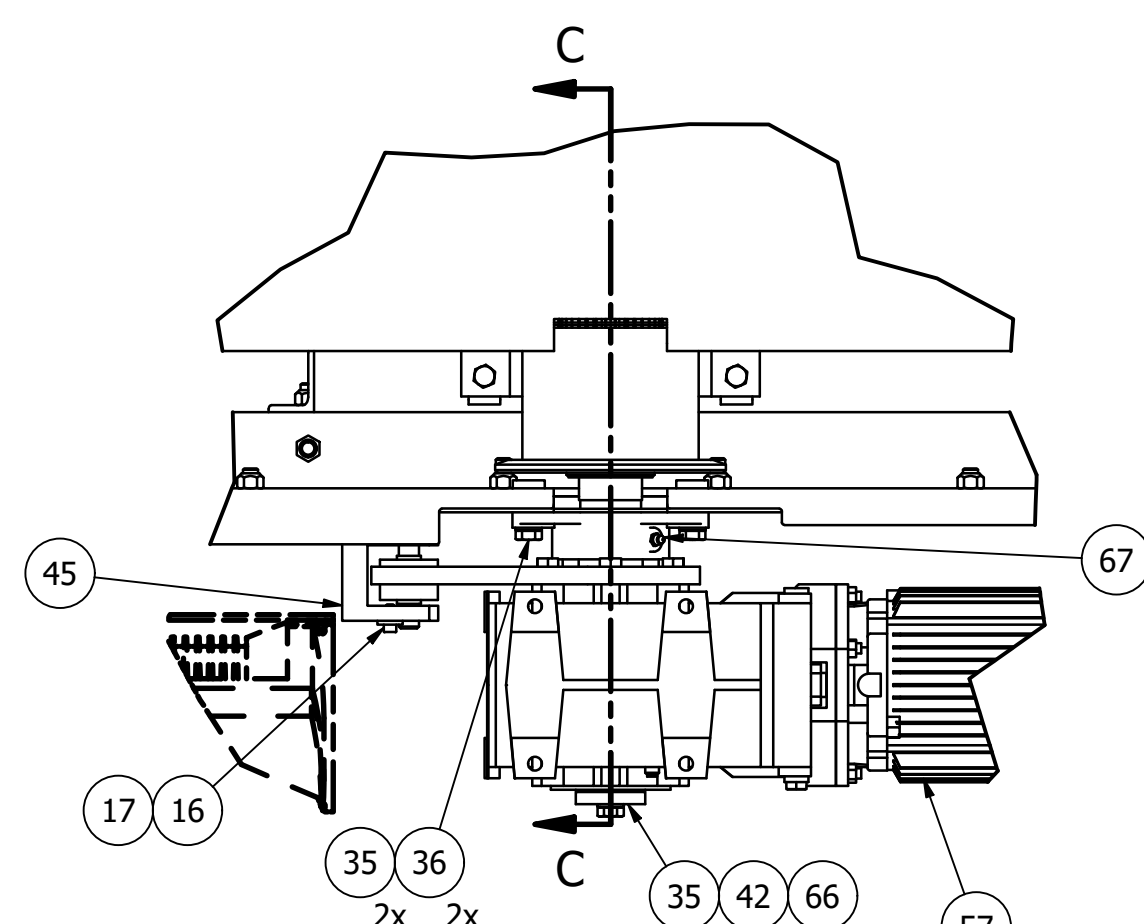
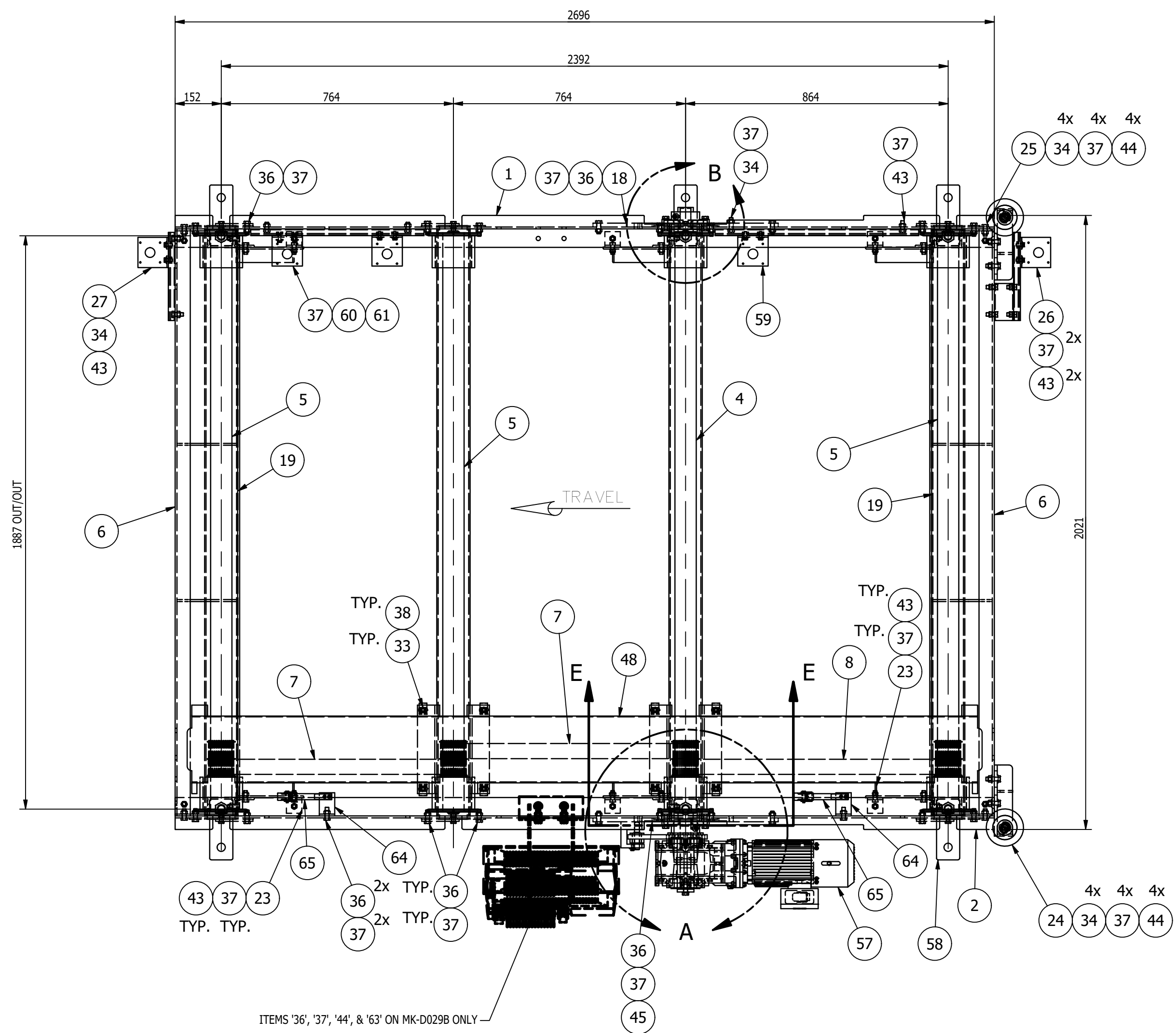
DRAWING No.: 1875D028

REV: B

JOB No.: 22096

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 6/15/22

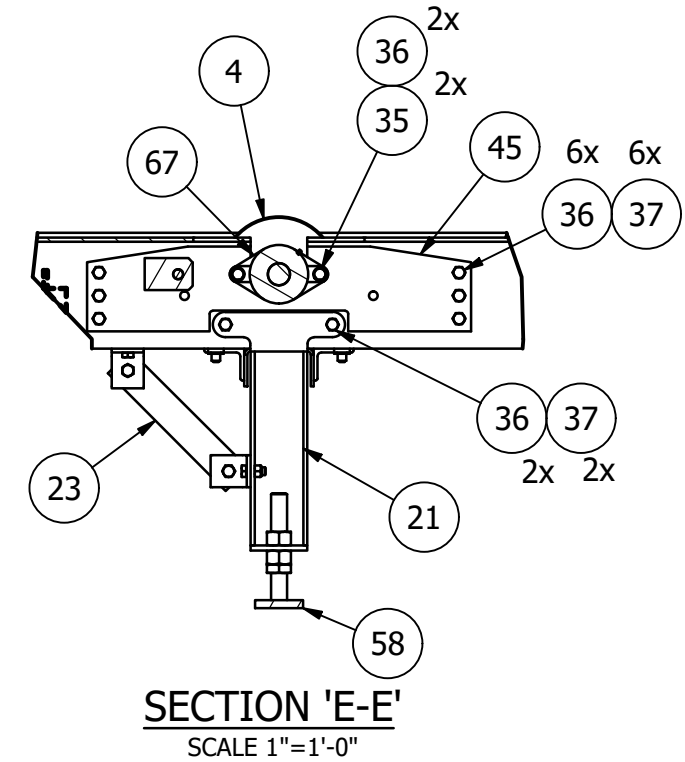
PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.



MK-D029A ~ 4-ROLL ASSEMBLY (WITHOUT MK-D047A; SHOWN)
 MK-D029B ~ 4-ROLL ASSEMBLY (WITH MK-D047A)
 SCALE 1"=1'-0"

SPEED FORMULA (60HZ):

$$\pi \times 1760 \times \frac{1}{37.18} \times \frac{140}{1000} = 20.8 \text{ m/min} = 68.3 \text{ ft/min}$$



- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

MAGNUM Consulting
 41100 Clarkston Rd. Suite 125 West, MI 48375
 Phone: (248) 772-8859 Fax: (248) 772-8851 Web: www.mmagnum.com
 MAGNUM JOB #: 1875 MAGNUM DRAWING #: 1875D029

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
 WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)
 PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
	1	MK-D029A			
1	1	MK-D030A ~ 4-ROLL SIDE FRAME ASSY - RH			
2	1	MK-D030B ~ 4-ROLL SIDE FRAME ASSEMBLY - LH			
4	1	D140/70x8/35 HTD 8M-55 POWER ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVE ROLL, PART NO. 332306W			
5	3	D140/70/30 Z34 HTD 8M-55 DRIVEN ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVEN ROLL, PART NO. 329A060W			
6	2	MK-D002A ~ END PLATE ASSEMBLY			
7	2	GATES POWERGRIP GT4 BELT, 1800-8M-GT50		2-5	
8	1	GATES POWERGRIP GT4 BELT, 2000-8M-GT50		2-4	
10	1	MK-D005D ~ SHAFT SPACER			
12	6	MK-D005B ~ ROLL KEEPER			
16	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
17	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
18	1	MK-D005C ~ BEARING PLATE			
19	2	MK-D004B ~ LEG ASSEMBLY			
21	1	MK-D004D ~ LEG ASSEMBLY WITH GUARD SUPPORT			
23	6	MK-D008A ~ ANGLE BRACE			
24	1	MK-D006C ~ SKID GUIDE ROLLER - LH			
25	1	MK-D006D ~ SKID GUIDE ROLLER - RH			
26	1	MK-D009A ~ PROX BRACKET			
27	1	MK-D009B ~ PROX BRACKET			
33	8	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
34	9	M12x1.75 x 40mm LG. HEX CAP SCREW			
35	5	M12 SPRING LOCK WASHER			
36	39	M12x1.75 x 35mm LG. HEX CAP SCREW			
37	87	M12 x 1.75 STOVER LOCK NUT			
38	15	M10x1.5 x 25mm LG. HEX CAP SCREW			
40	1	MK-D005E ~ SHAFT SPACER			
42	1	MK-D005F ~ MOTOR END PLATE			
43	41	M12x1.75 x 30mm LG. HEX CAP SCREW			
44	16	M12 NARROW FLAT WASHER			
45	1	MK-D005A ~ BEARING PLATE			
48	1	MK-D010D ~ BELT GUARD			
57	1	SIEMENS RB2 GEARMOTOR (SEE MOTOR DATA LIST)		1-2	
58	6	MK-D007A ~ ADJUSTING SUPPORT			
59	1	MK-D009C ~ PROX BRACKET			
60	1	MK-D009D ~ PROX BRACKET			
61	2	M12x1.75 x 25mm LG. HEX CAP SCREW			
62	1	MK-D004C ~ CROSS MEMBER WITH GUARD SUPPORT			
64	2	MK-D005G ~ STATIC WHEEL BRACKET			
65	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
66	1	M12x1.75 x 45mm LG. HEX CAP SCREW			
67	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
68	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	
		TOTAL WEIGHT ~ 1597.3 LBS			
		MK-D029B			
36	4	M12x1.75 x 35mm LG. HEX CAP SCREW			
37	4	M12 x 1.75 STOVER LOCK NUT			
44	4	M12 NARROW FLAT WASHER			
63	1	MK-D047A ~ CONTROLLER BRACKET			
69	1	MK-D029A ~ 4-ROLL ASSEMBLY			
		TOTAL WEIGHT 1620.9 LBS			

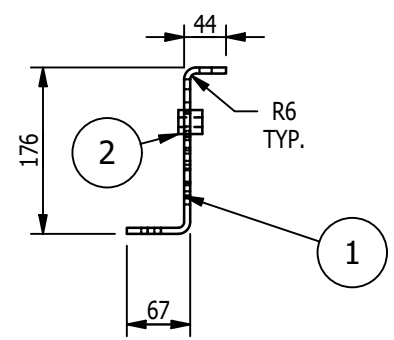
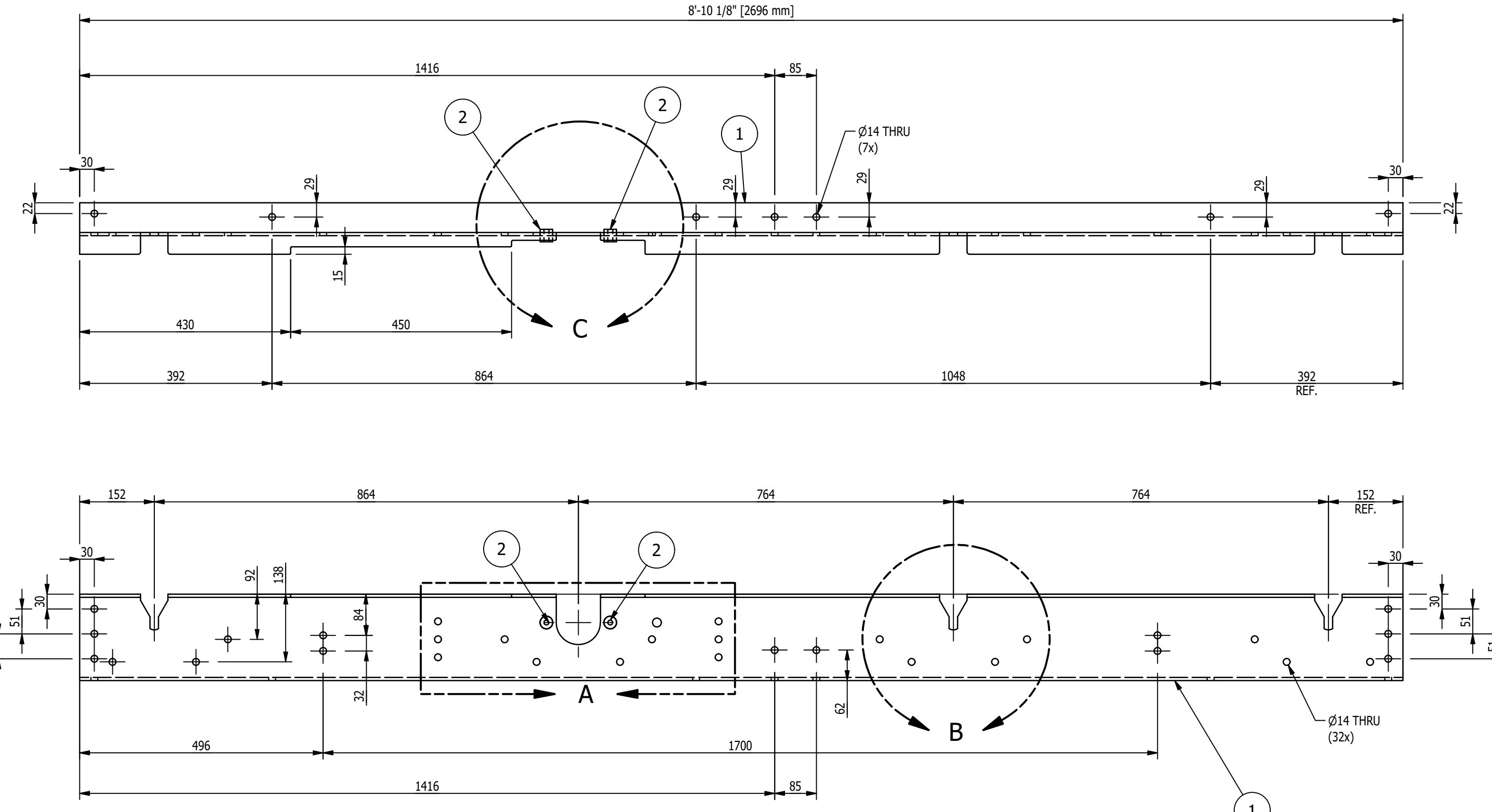
REV	BY	DATE	DESCRIPTION	APP
B	MC	8/5/2022	REVISED BALLOONS	
A	MC	8/2/22	FOR FABRICATION	

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

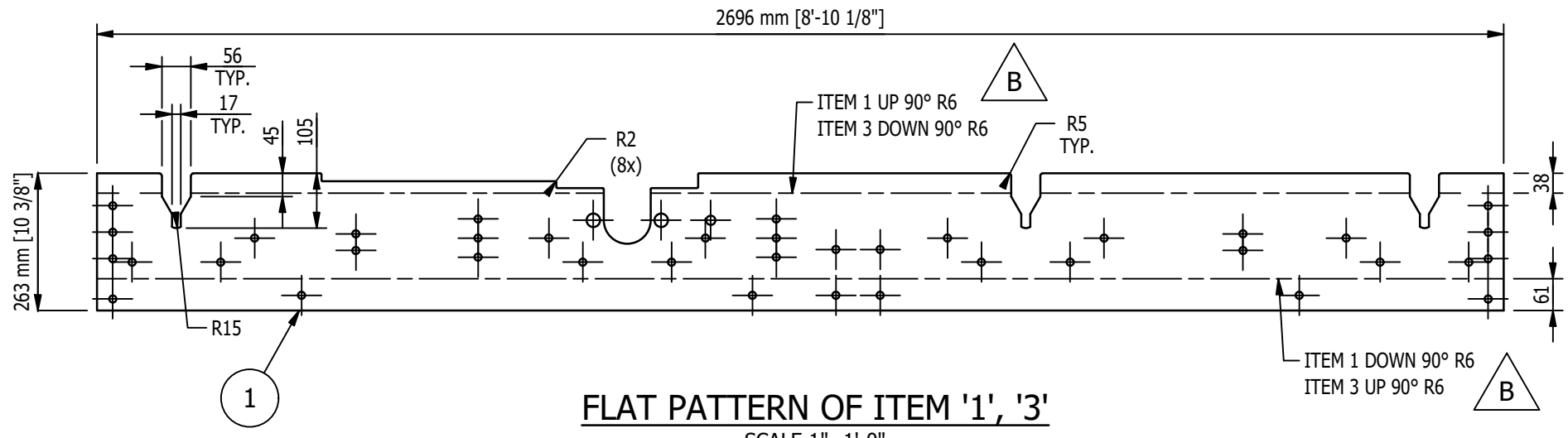
PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.

TITLE: P6700 CONVEYORS CAMPUS BUILDING
 CLIENT: VOLVO
 DRAWING No. 1875D029
 REV: A
 DRAWN BY: RJB
 CHECKED BY: CW
 DWG DATE: 6/10/22
 JOB No: 22096

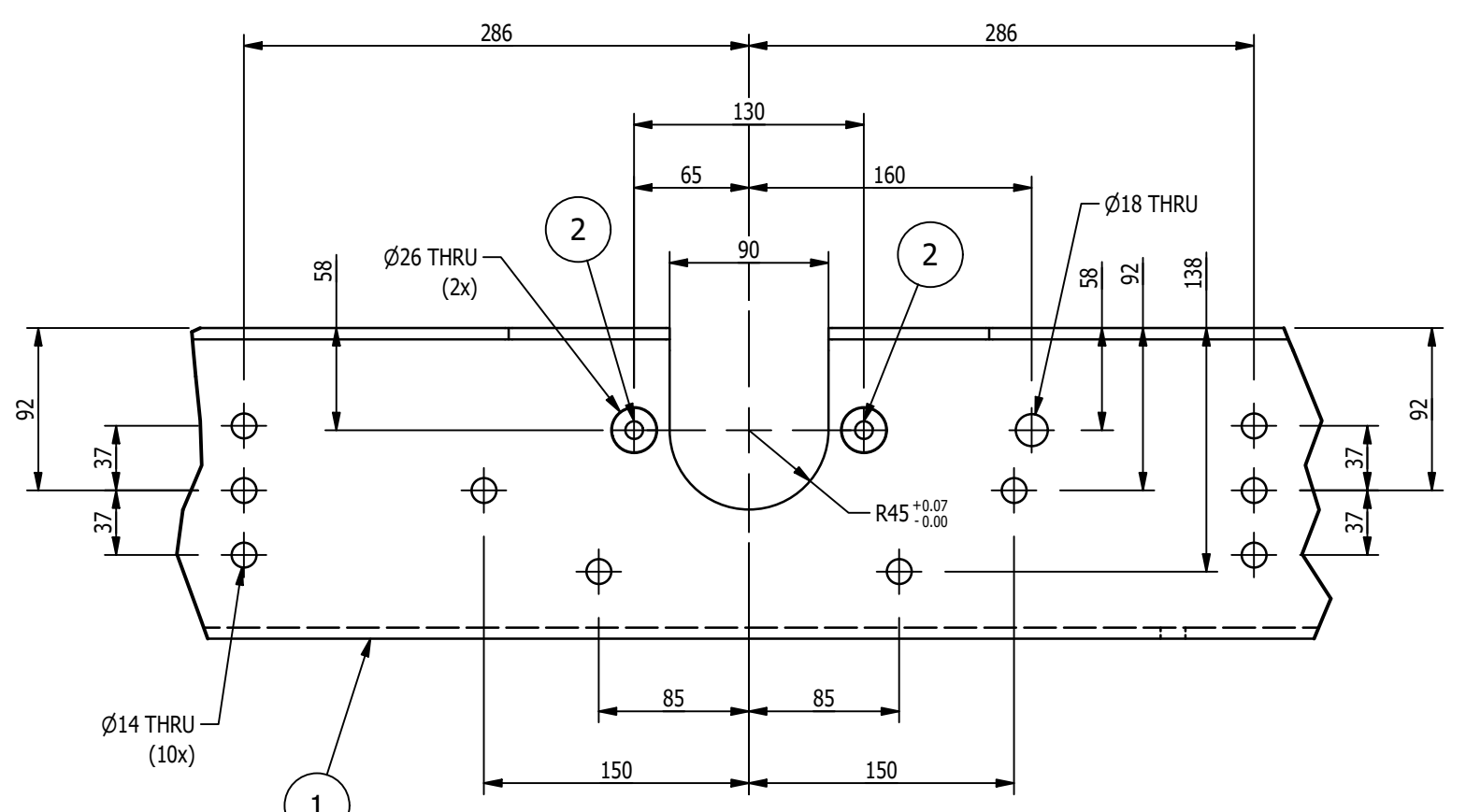
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D030A			
1	1	BAR 1/4 x 10 3/8	8'-10 1/8"		
2	2	PL 1 x 1"	1"		
		MK-D030B			
2	2	PL 1 x 1"	1"		
3	1	BAR 1/4 x 10 3/8	8'-10 1/8"		



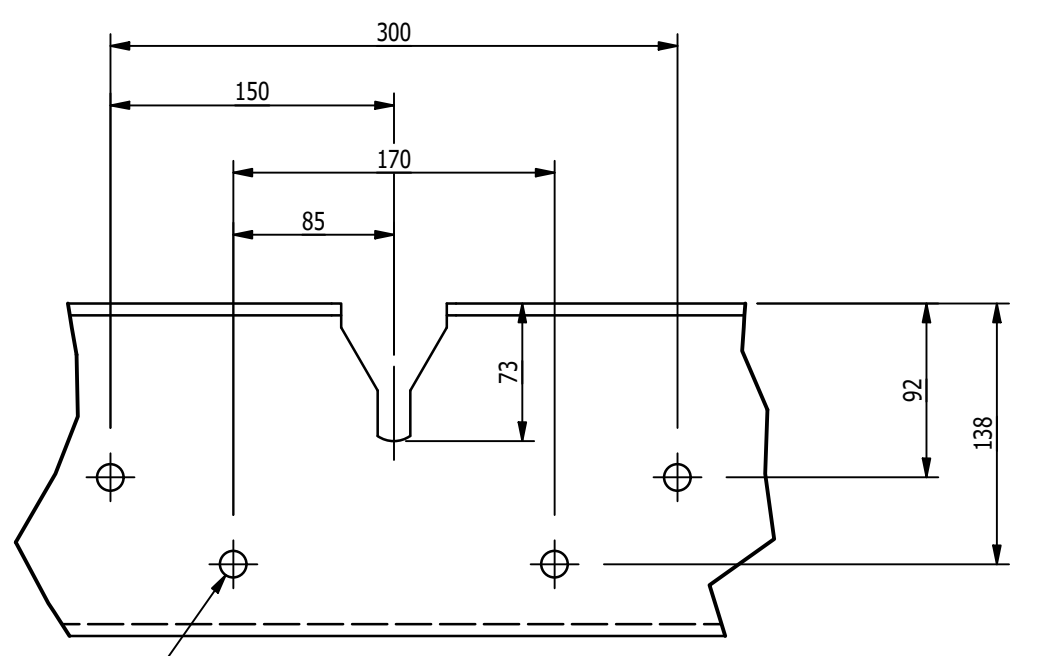
MK-D030A ~ 4-ROLL SIDE FRAME ASSY - RH (SHOWN)
 MK-D030B ~ 4-ROLL SIDE FRAME ASSY - LH (OPPOSITE)
 SCALE 1/2\"/>



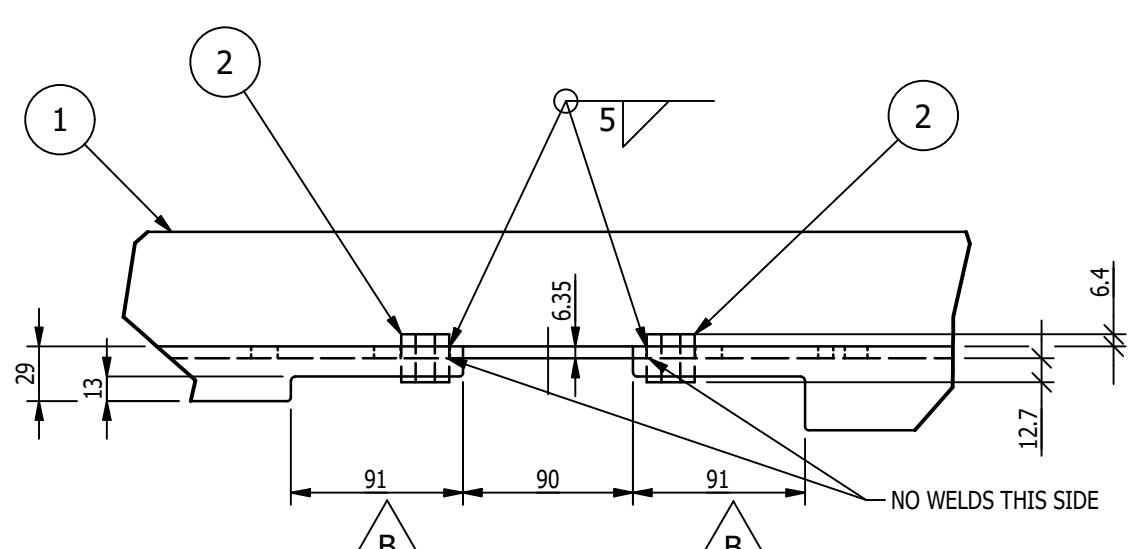
FLAT PATTERN OF ITEM '1', '3'
 SCALE 1\"/>



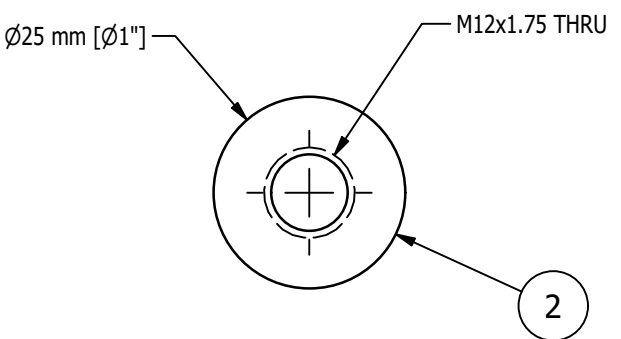
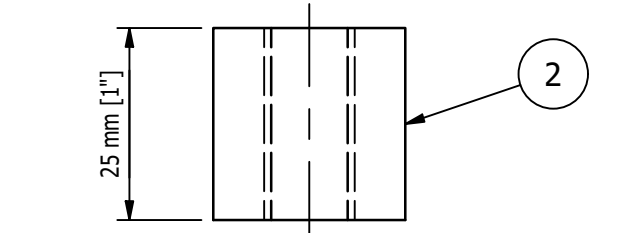
ENLARGED VIEW 'A'
 SCALE 3\"/>



ENLARGED VIEW 'B'
 SCALE 3\"/>



ENLARGED VIEW 'C'
 SCALE 3\"/>



DETAIL OF ITEM '2'
 SCALE 1\"/>

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16\"/>

PAINT NOTES:
 PAINT ALL FABRICATED STEEL
 ONE SHOP COAT OF LIGHT GREY RAL 7035

MAGNUM CONSULTING
 41100 Quakertown Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D030 - REV B

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
 - ALL HOLES ARE 13/16\"/>

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/5/2022	REVISED DIM, ADDED DIM, CHANGED DXF FILE	
A	MC	8/2/22	FOR FABRICATION	

REVISION HISTORY

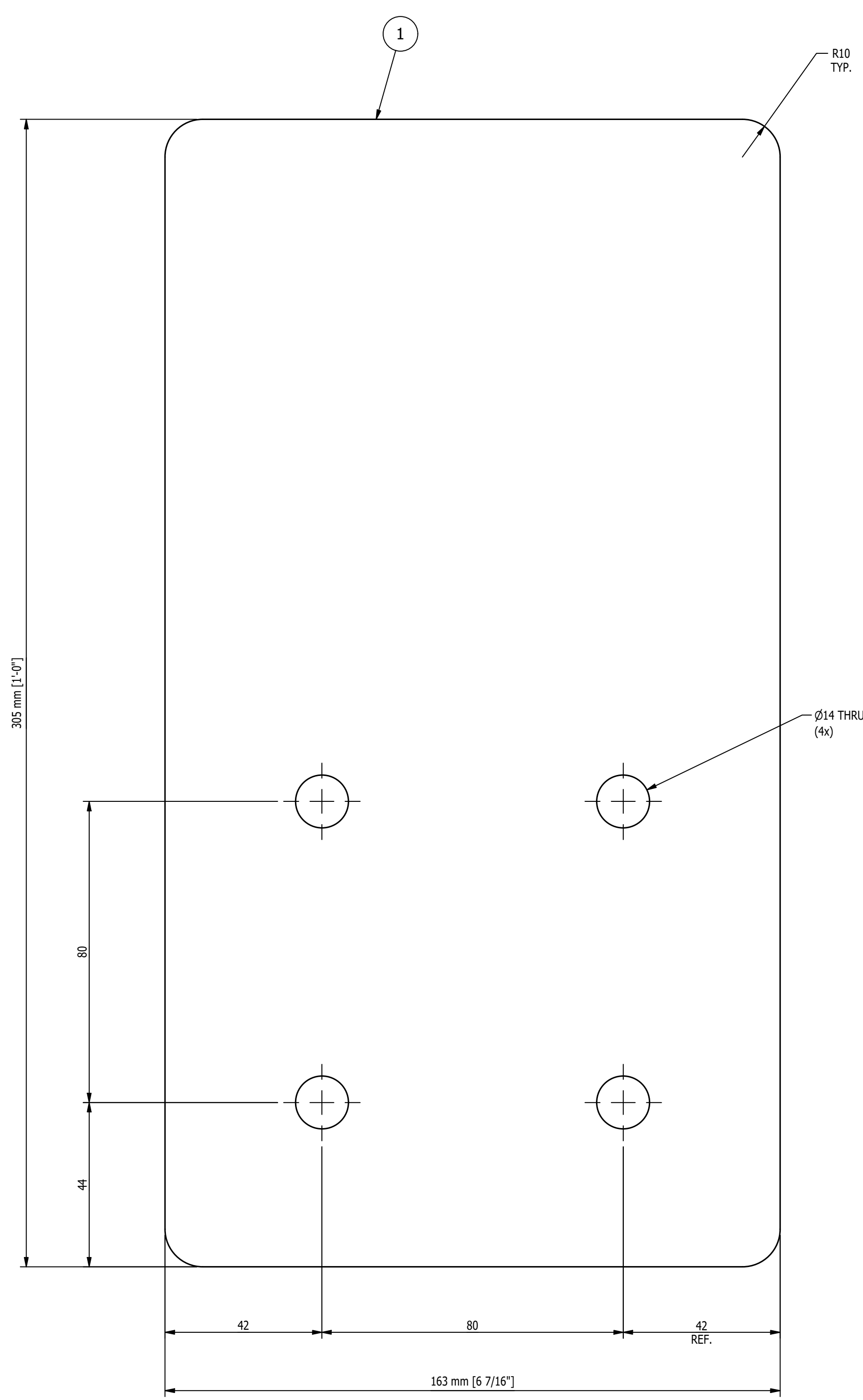
MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D030

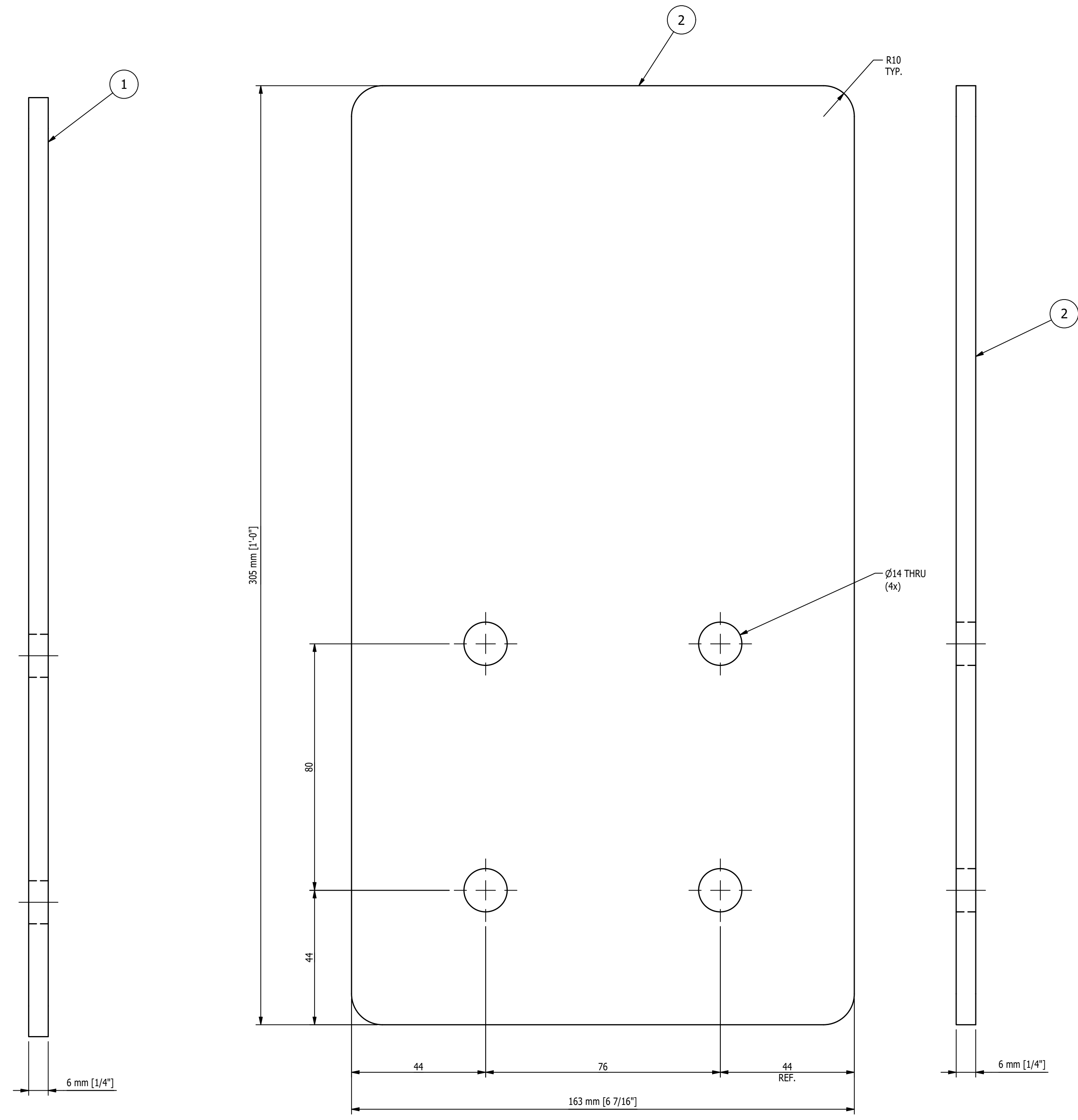
PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 6/15/22
REV: B
JOB No: 22096

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D031A			
1	1	BAR 1/4 x 6 7/16	1'-0"		
		MK-D031B			
2	1	BAR 1/4 x 6 7/16	1'-0"		



MK-D031A ~ DEAD END PLATE
SCALE 1'-0" = 1'-0"



MK-D031B ~ DEAD END PLATE
SCALE 1'-0" = 1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
--	---	---

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No.: 1875D031	DWG DATE: 6/15/22
REV: A	JOB No.: 22096

MAGNUM CONSULTING
41100 Charleston Rd.
Suite 125
Novi, MI 48165
Phone: (248) 772-8822
Fax: (248) 772-8821
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D031

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

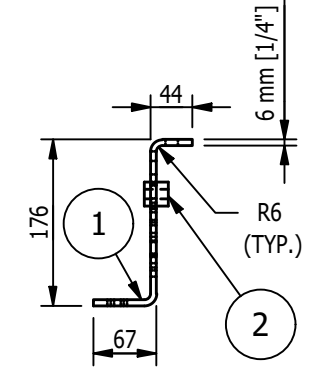
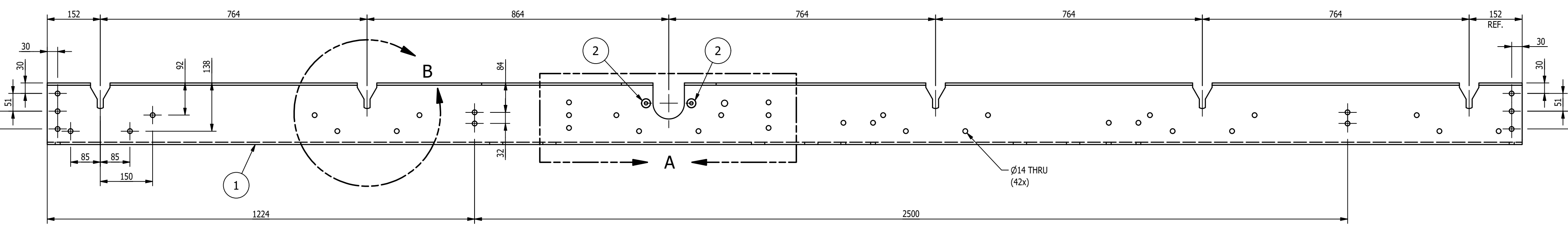
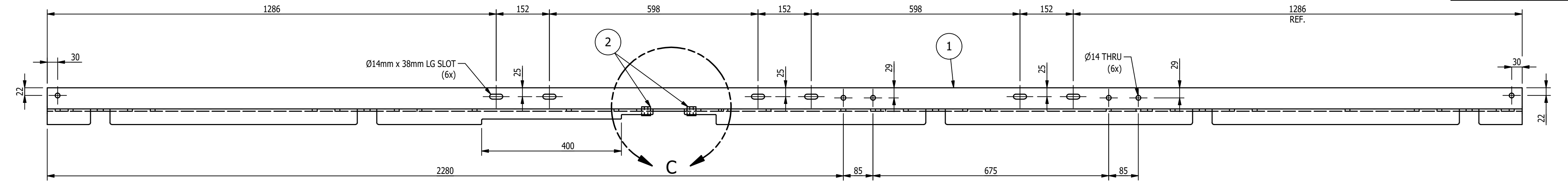
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

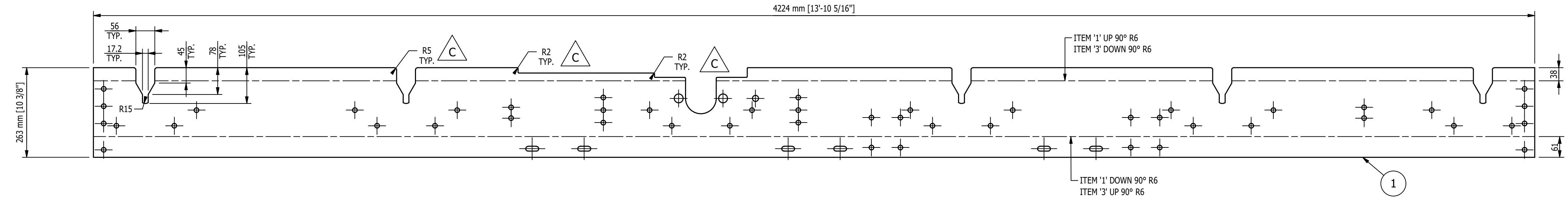
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

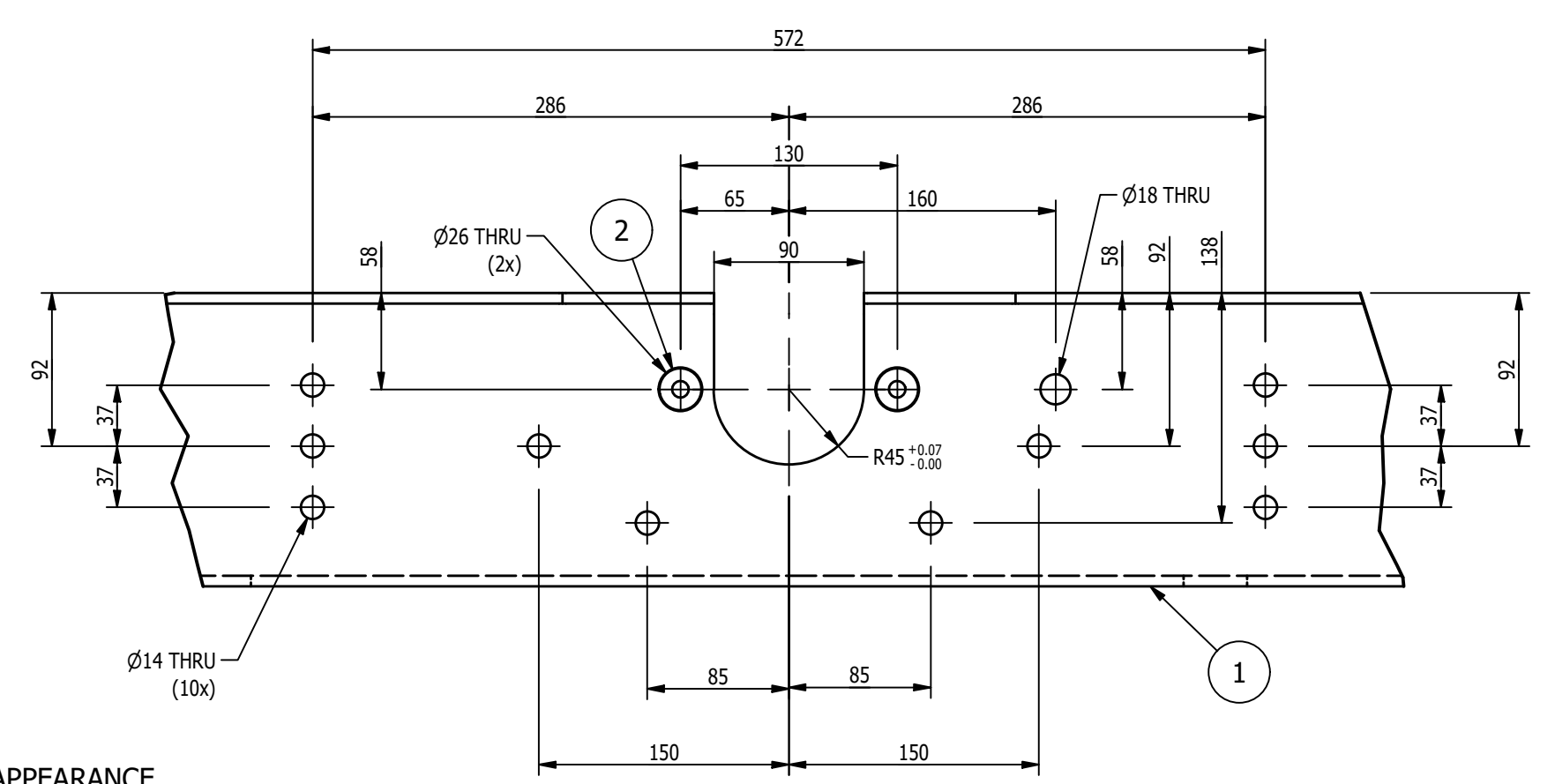
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D032A			
1	1	BAR 1/4 x 10 3/8	13'-10 5/16"		
2	2	PL 1 x 1"	1"		
		MK-D032B			
2	2	PL 1 x 1"	1"		
3	1	BAR 1/4 x 10 3/8	13'-10 5/16"		



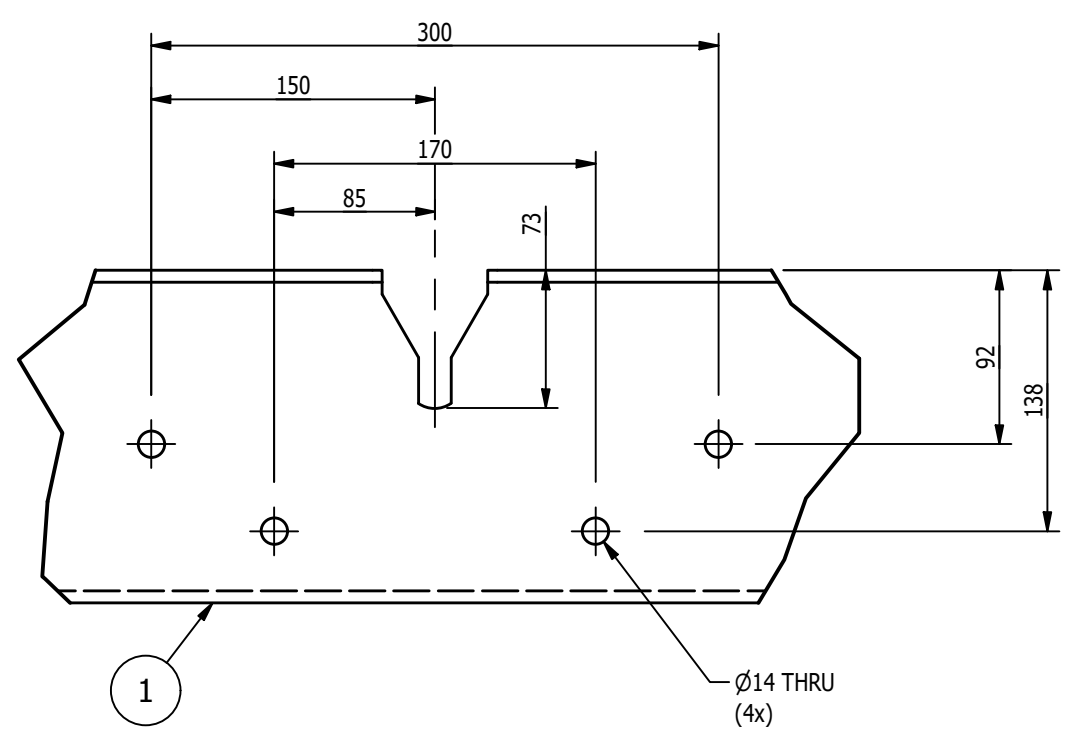
MK-D032A ~ 6-ROLL SIDE FRAME ASSY - RH (SHOWN)
 MK-D032B ~ 6-ROLL SIDE FRAME ASSY - LH (OPPOSITE)
 SCALE 1 1/2" = 1'-0"



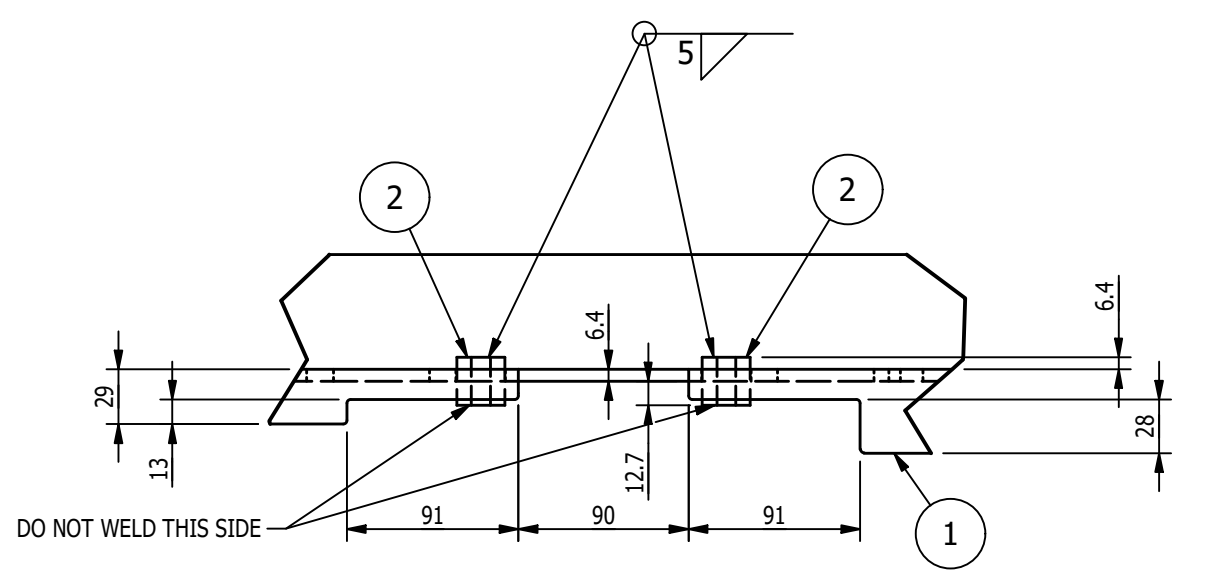
FLAT PATTERN OF ITEM '1'
 FLAT PATTERN OF ITEM '3'
 SCALE 1 1/2" = 1'-0"



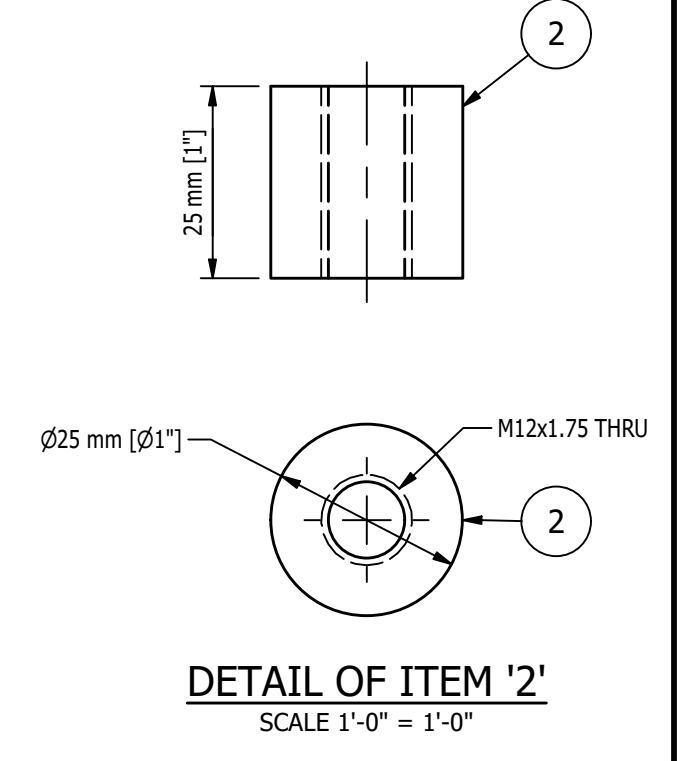
ENLARGED VIEW 'A' TYP.
 SCALE 3" = 1'-0"



ENLARGED VIEW 'B' TYP.
 SCALE 3" = 1'-0"



ENLARGED VIEW 'C'
 SCALE 3" = 1'-0"



DETAIL OF ITEM '2'
 SCALE 1'-0" = 1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
 PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER

ONE SHOP COAT OF PURE ORANGE RAL 2004 OR
 ONE SHOP COAT OF LIGHT GREY RAL 7035
 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

GENERAL NOTES:

MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
 - ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MAGNUM CONSULTING
 41100 Charleston Rd.
 Suite 125
 Norcross, GA 30052

Phone: (770) 447-8822
 Fax: (770) 447-8821
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D032

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005

FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	UPDATED PAINT NOTES, ADDED RADII DIMENSIONS	
B	MC	8/26/22	ADDED DIMENSION, ITEM '4' CHANGED TO ITEM '2' ON MK-D032B	
A	MC	8/11/22	FOR FABRICATION	

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millc.com

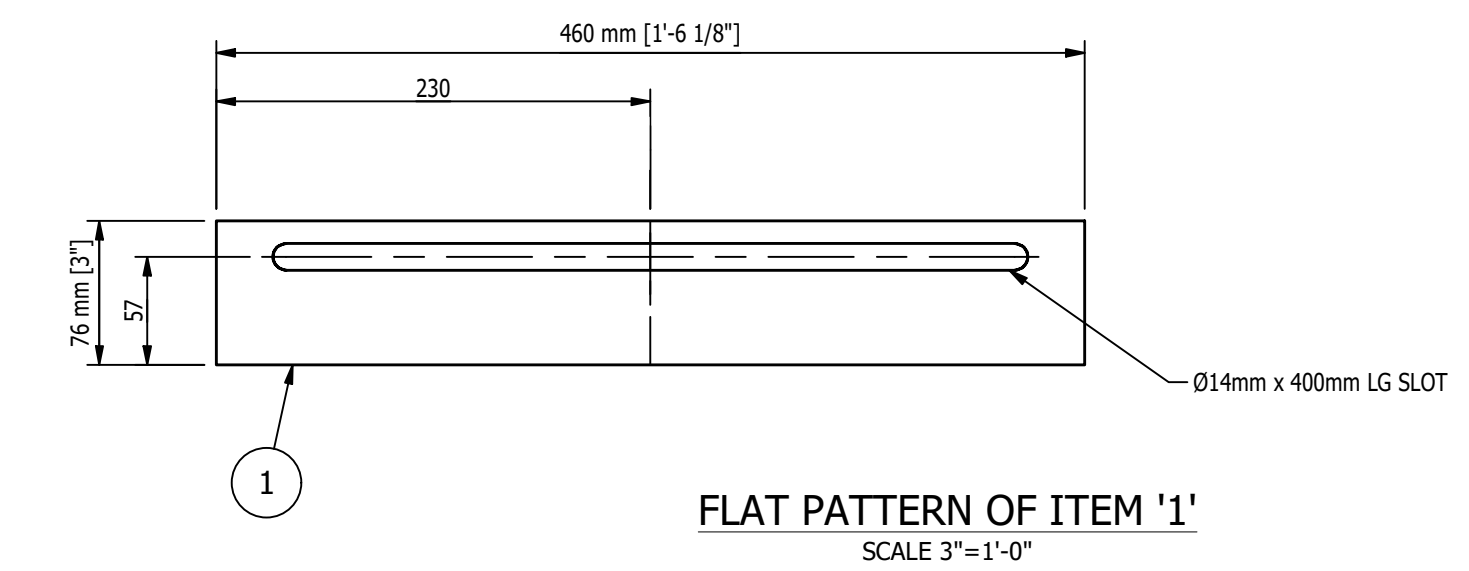
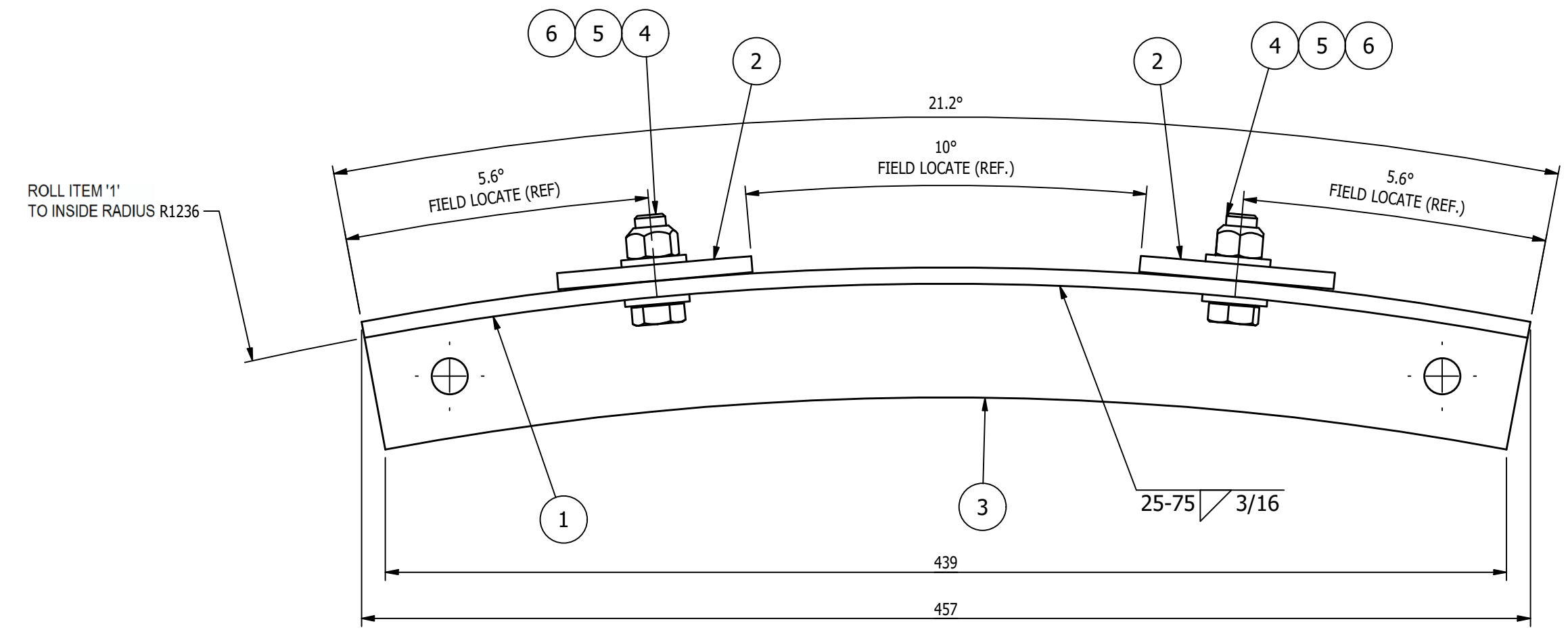
TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO

DRAWING No. 1875D032

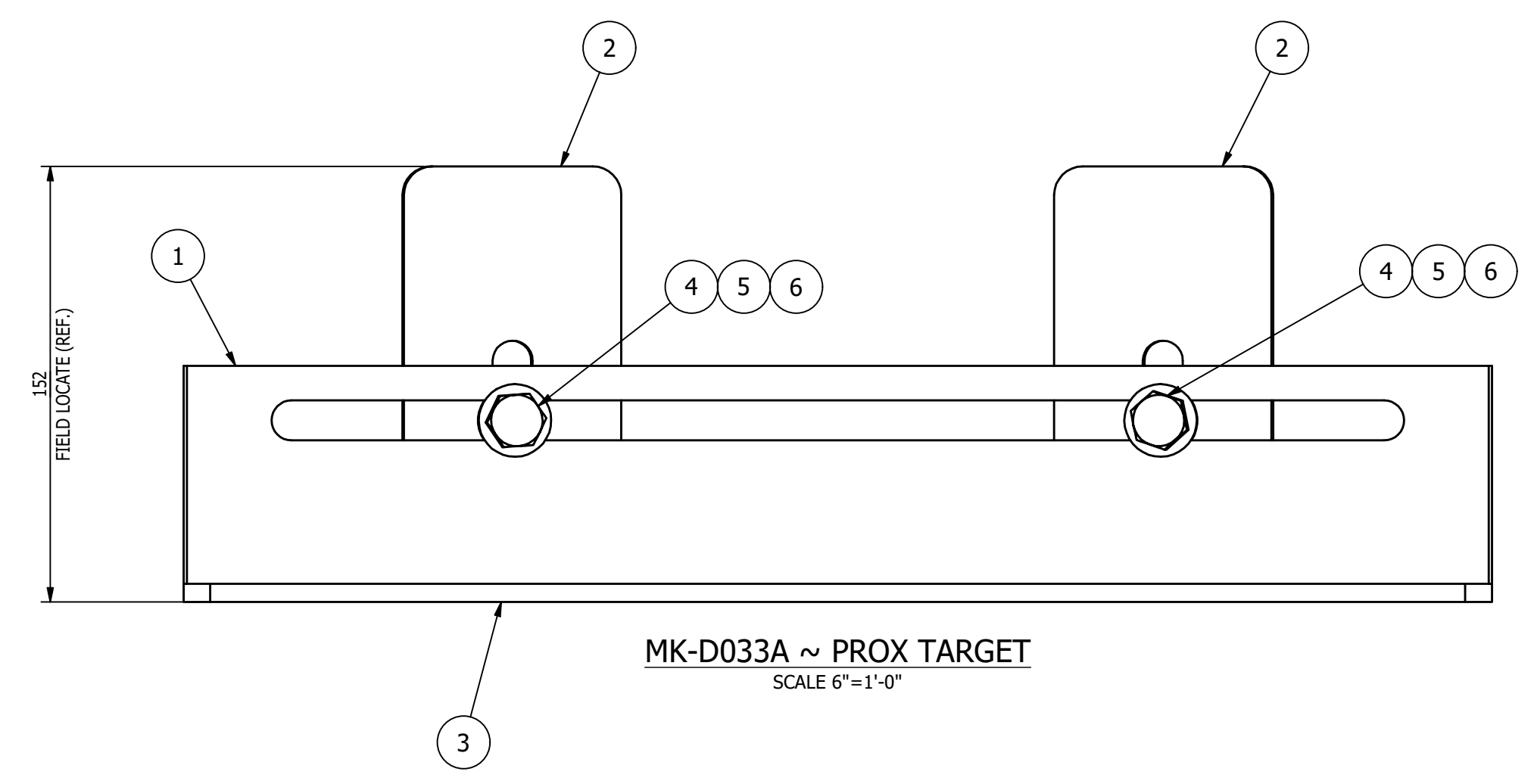
REV: C

DRAWN BY: JC
CHECKED BY: CW
DWG DATE: 6/27/22
JOB No: 22096

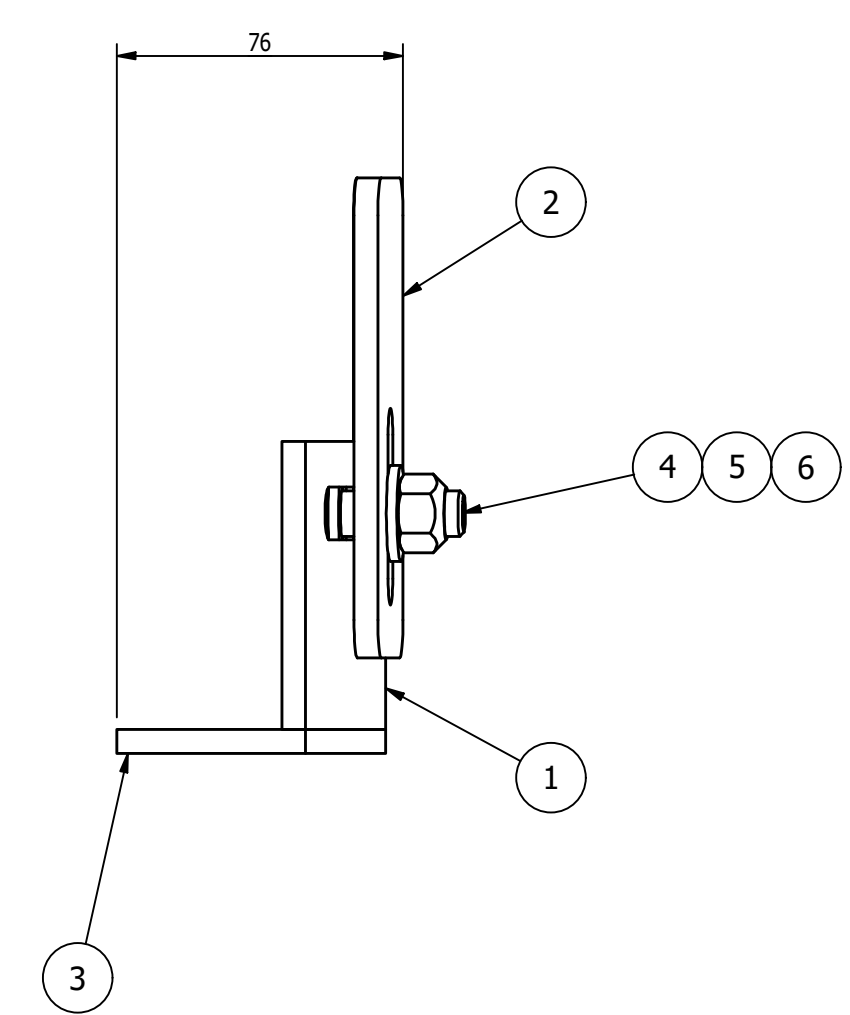
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
	6	MK-D033A			
1	1	BAR 1/4 x 3	1'-6 1/8"		
2	2	BAR 1/4 x 3	5"		
3	1	BAR 1/4 x 2 13/16	1'-6"		
4	2	M12x1.75 x 35mm LG. HEX CAP SCREW			
5	4	M12 NARROW FLAT WASHER			
6	2	M12 x 1.75 STOVER LOCK NUT			
		TOTAL WEIGHT ~ 8.0 LBS			



FLAT PATTERN OF ITEM '1'
SCALE 3"=1'-0"

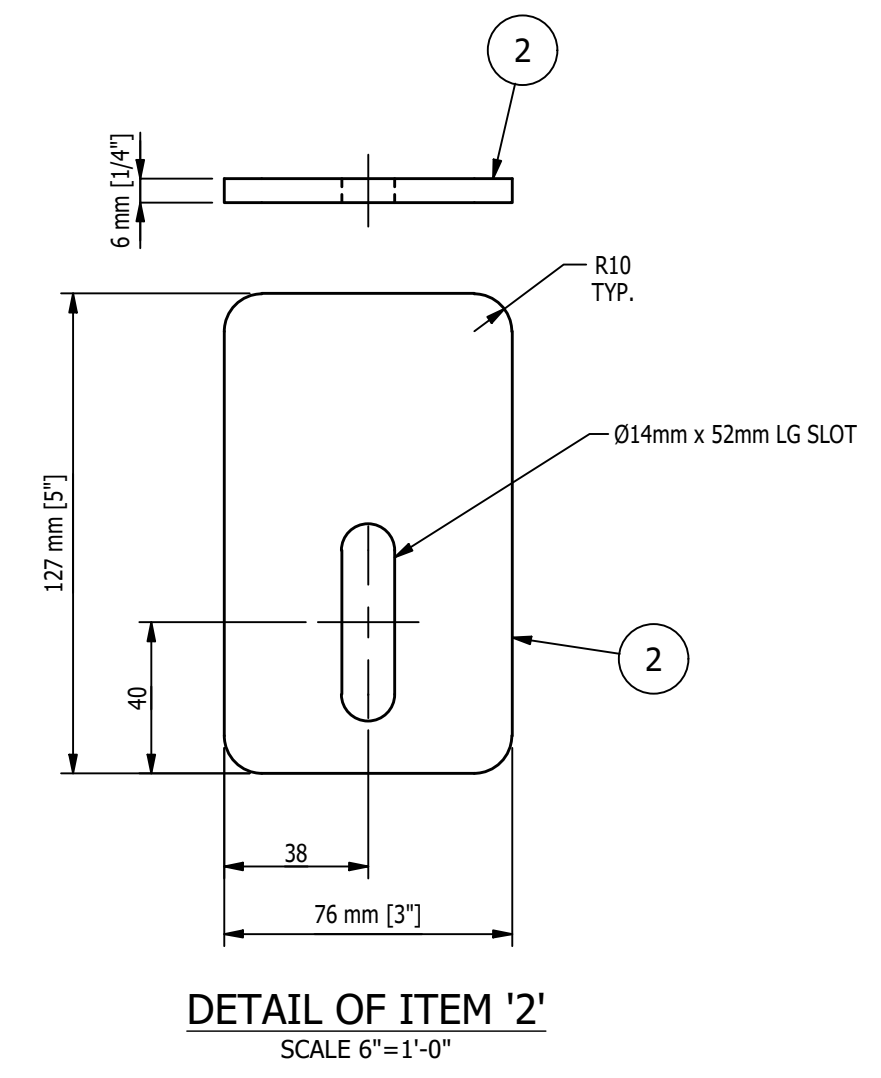


MK-D033A ~ PROX TARGET
SCALE 6"=1'-0"

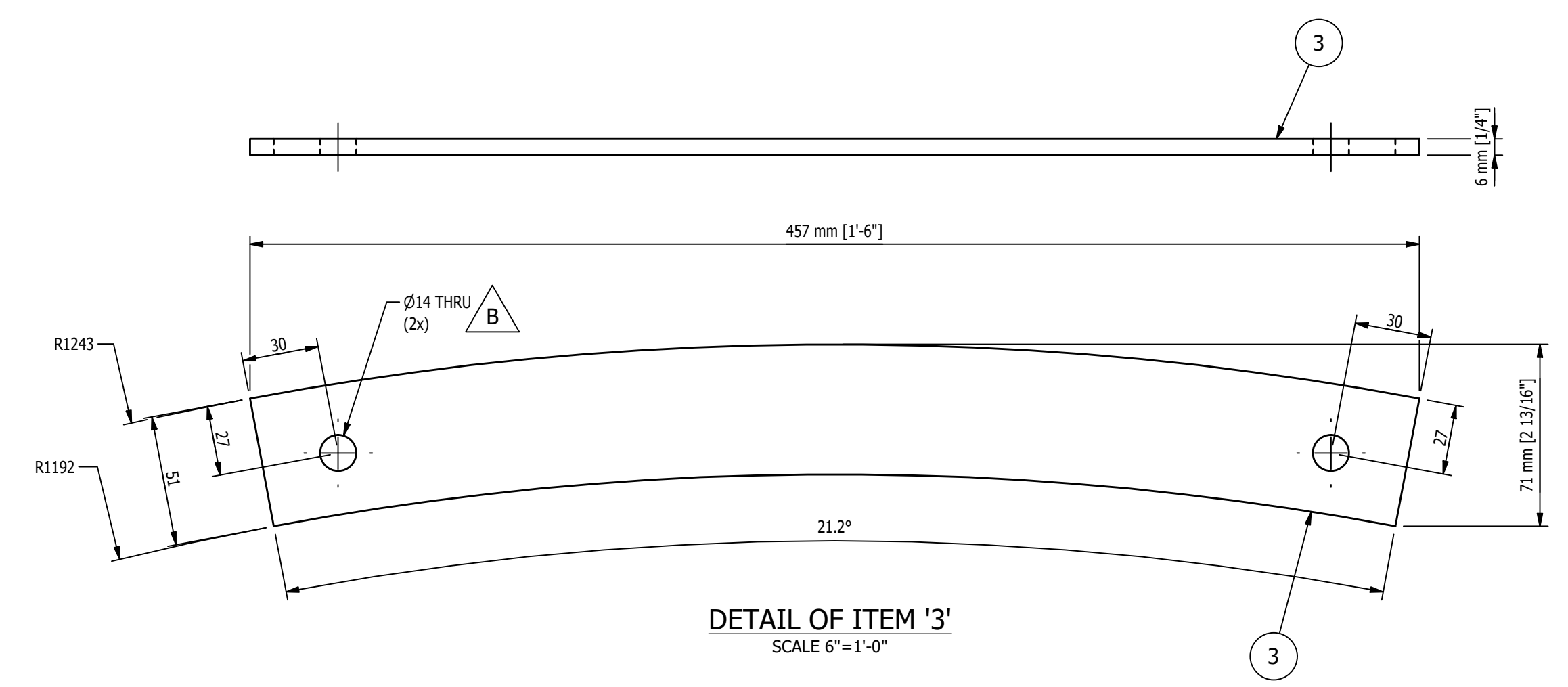


- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
 - ONE SHOP COAT OF LIGHT GREY RAL 7035
 - DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.



DETAIL OF ITEM '2'
SCALE 6"=1'-0"



DETAIL OF ITEM '3'
SCALE 6"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/18/22	ADDED DIAMETER DIMENSION	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
		FENTON, MI 48430		DRAWING IS THE SOLE PROPERTY	
		PH: 810.373.0322 FAX: 810.373.0326		OF MILLER INDUSTRIES. ANY	
		www.millic.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: RJB		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 6/15/22		JOB No: 22096	
DRAWING No. 1875D033		REV: B			

MAGNUM CONSULTING
4110 QuakerRoad Rd.
Suite 125
North, MI 48175
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D033

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

Holes:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

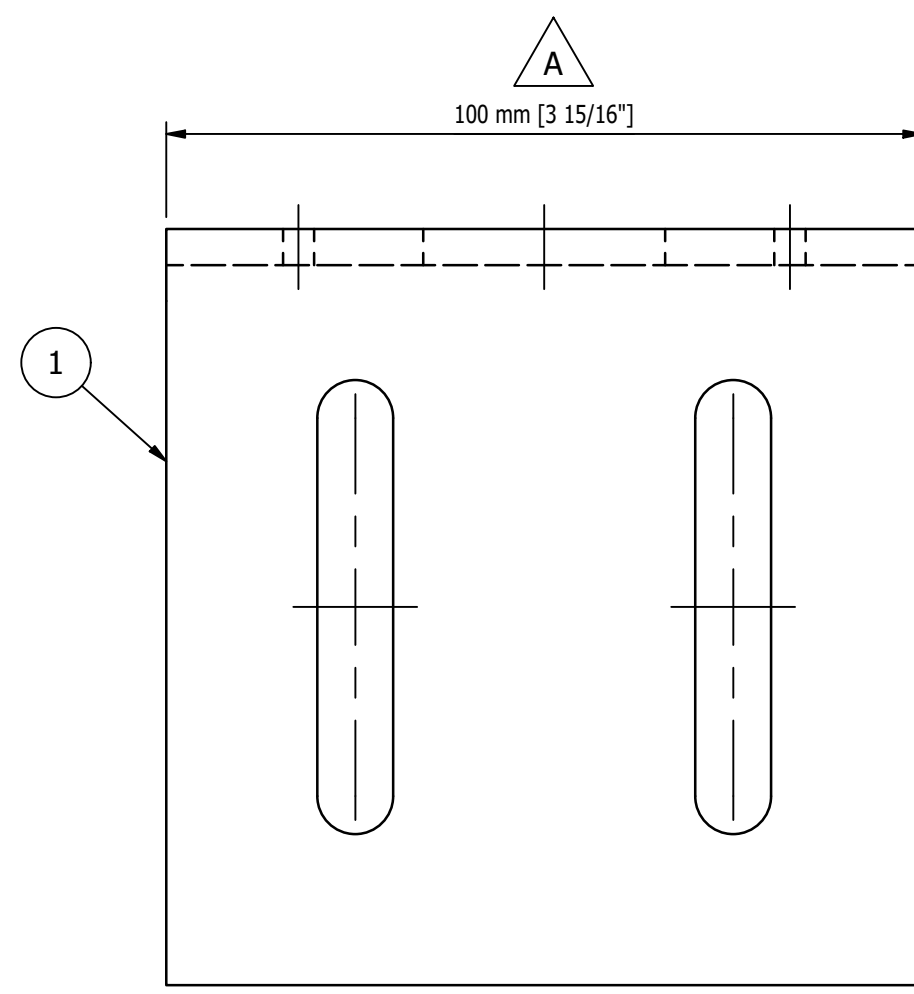
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

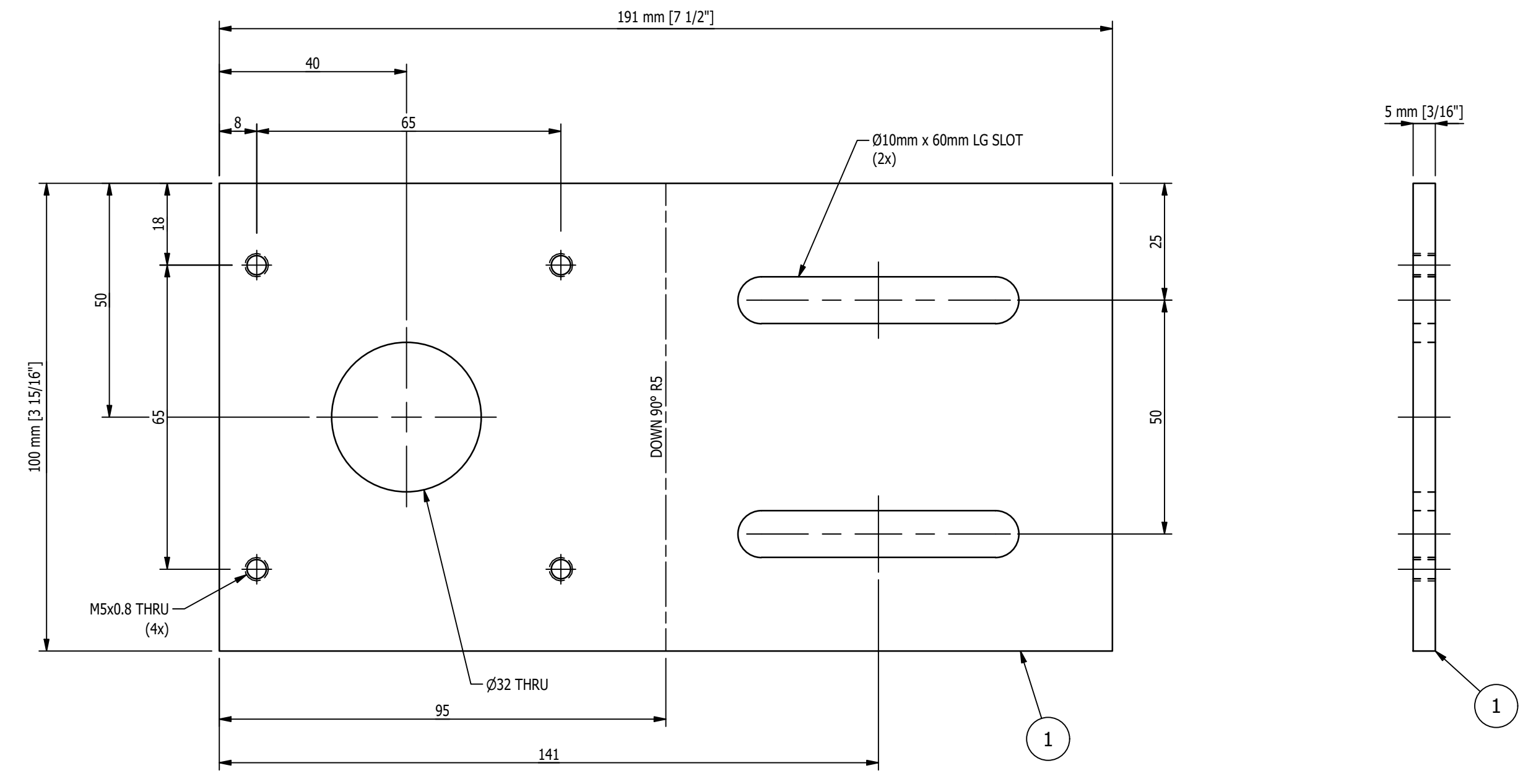
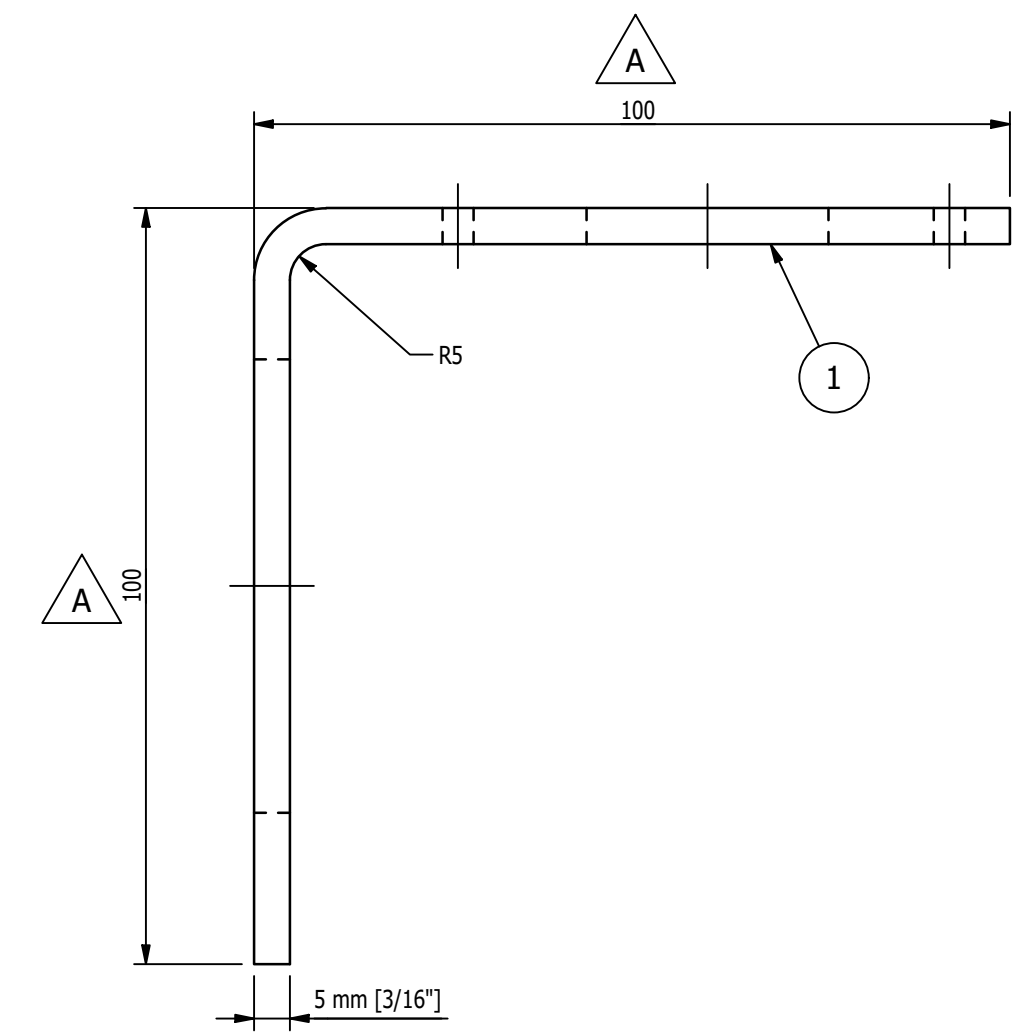
COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

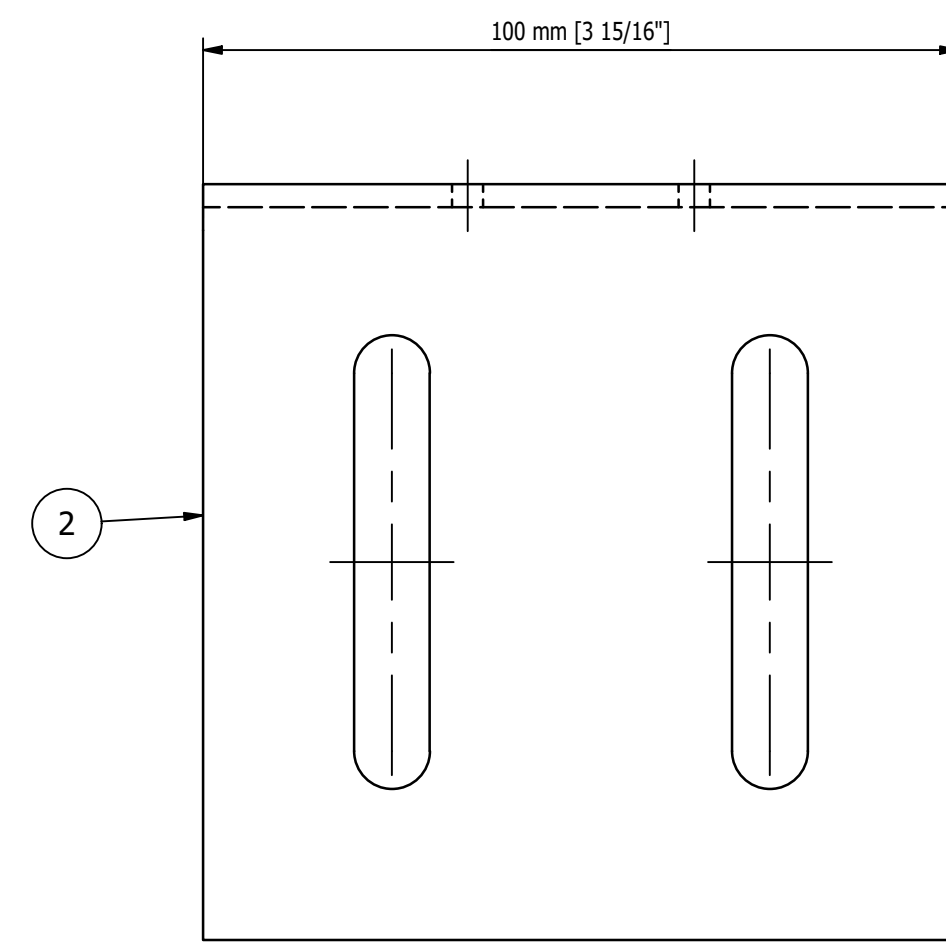
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D034A			
1	1	BAR 3/16 x 3 15/16	7 1/2"		
		TOTAL WEIGHT ~ 1.5 LBS			
		MK-D034B			
2	1	BAR 1/8 x 3 15/16	7 13/16"		
		TOTAL WEIGHT ~ 1.0 LBS			



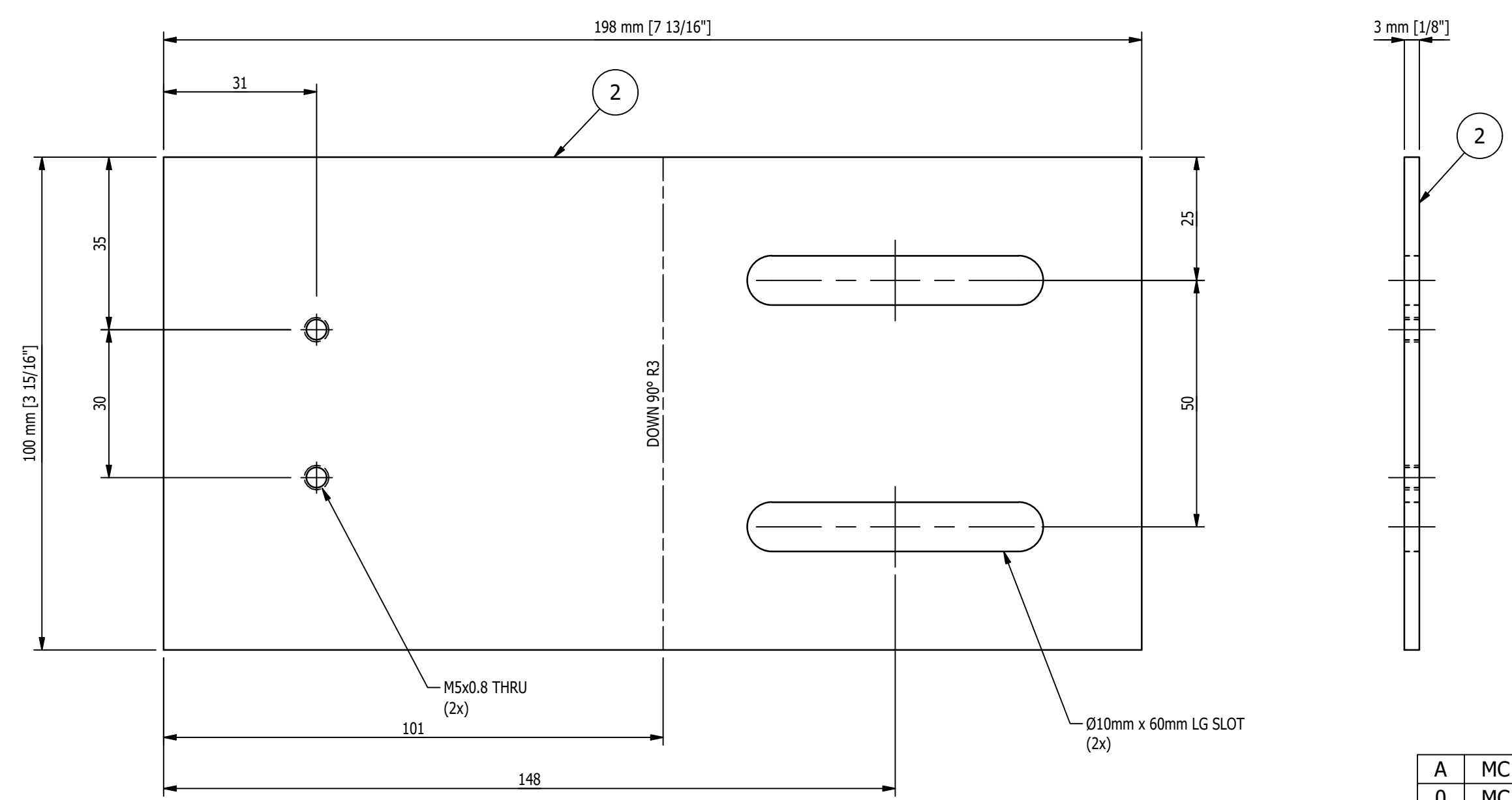
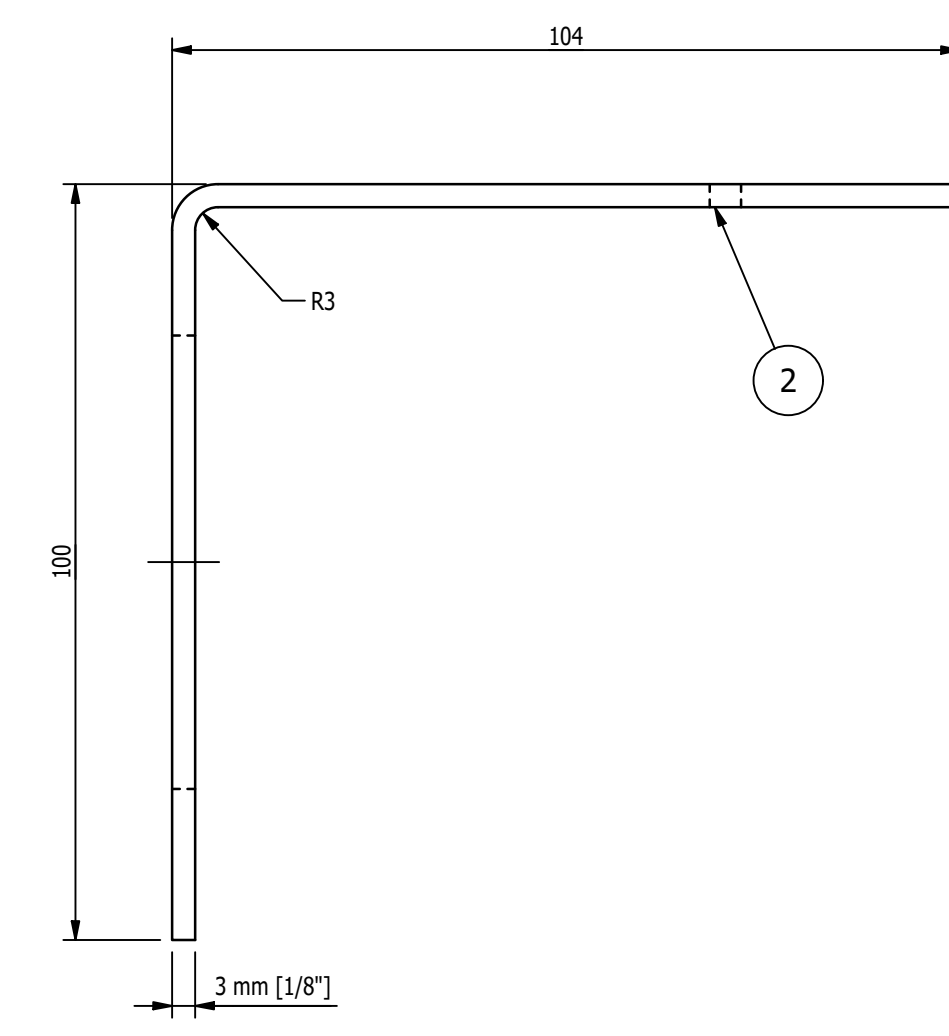
MK-D034A ~ PROX BRACKET
SCALE 1'-0" = 1'-0"



FLAT PATTERN OF ITEM '1'
SCALE 1'-0" = 1'-0"



MK-D034B ~ PROX BRACKET
SCALE 1'-0" = 1'-0"



FLAT PATTERN OF ITEM '2'
SCALE 1'-0" = 1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/27/2022	REVISED PAINT NOTES; ADDED DIMENSIONS	
0	MC	7/19/2022	FOR FABRICATION	

REVISION HISTORY

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/27/2022	REVISED PAINT NOTES; ADDED DIMENSIONS	
0	MC	7/19/2022	FOR FABRICATION	

MAGNUM CONSULTING
41100 Dardickwood Rd.
Suite 125
North, MI 48315

Phone: (248) 772-8888
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D034 - REV A

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

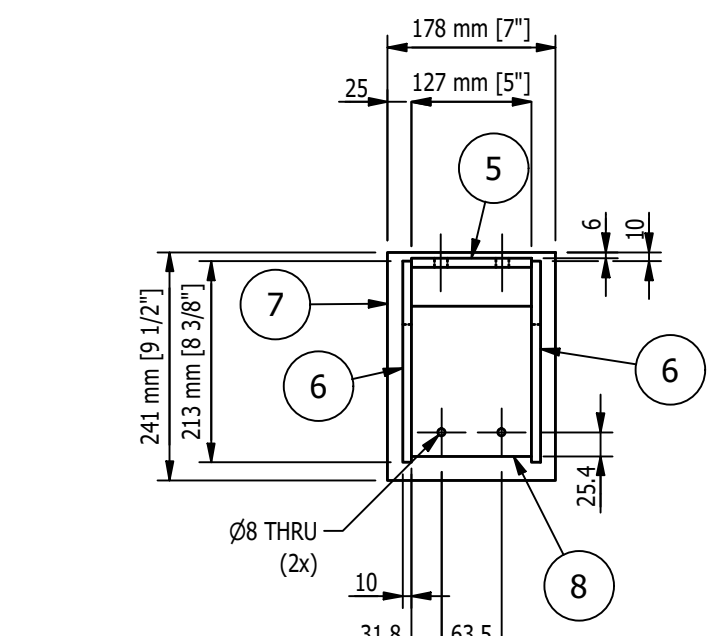
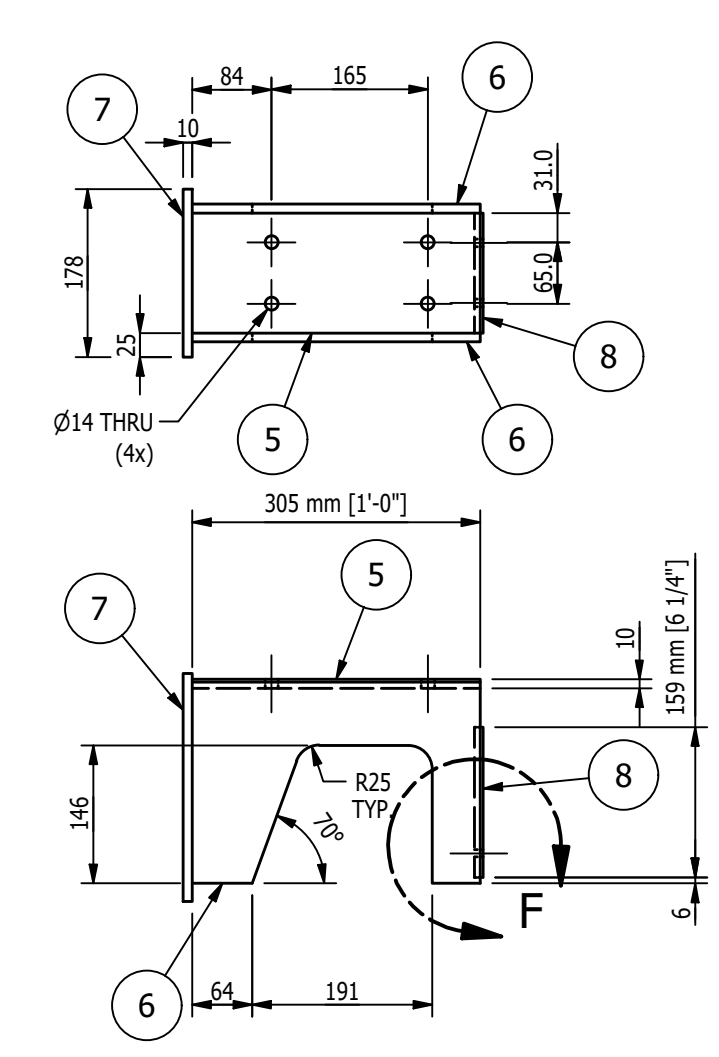
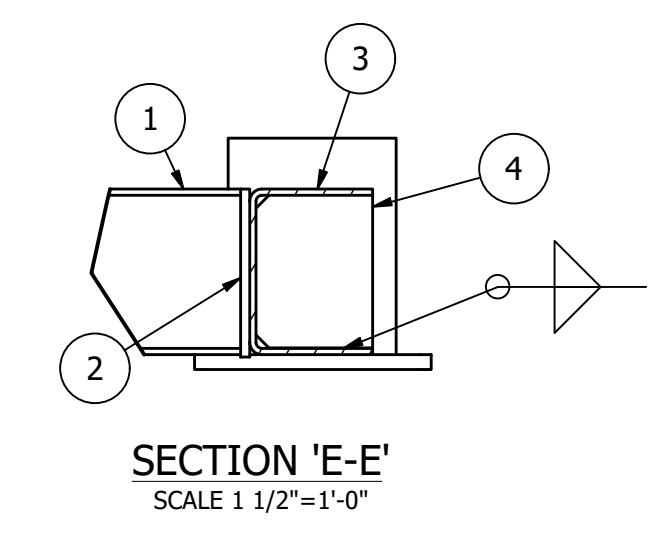
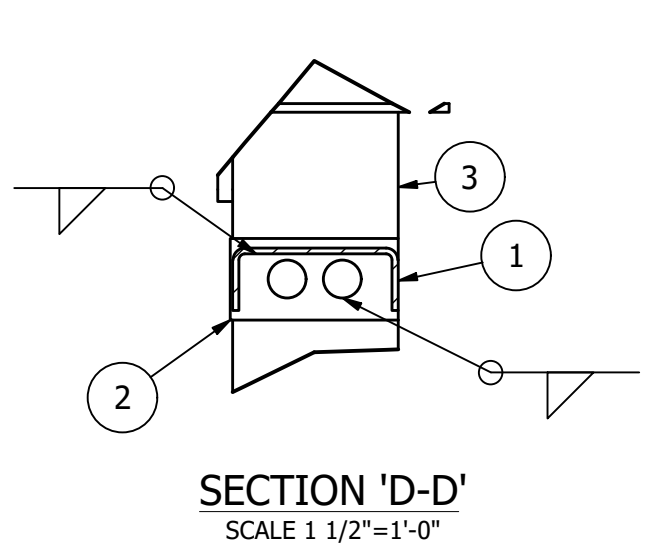
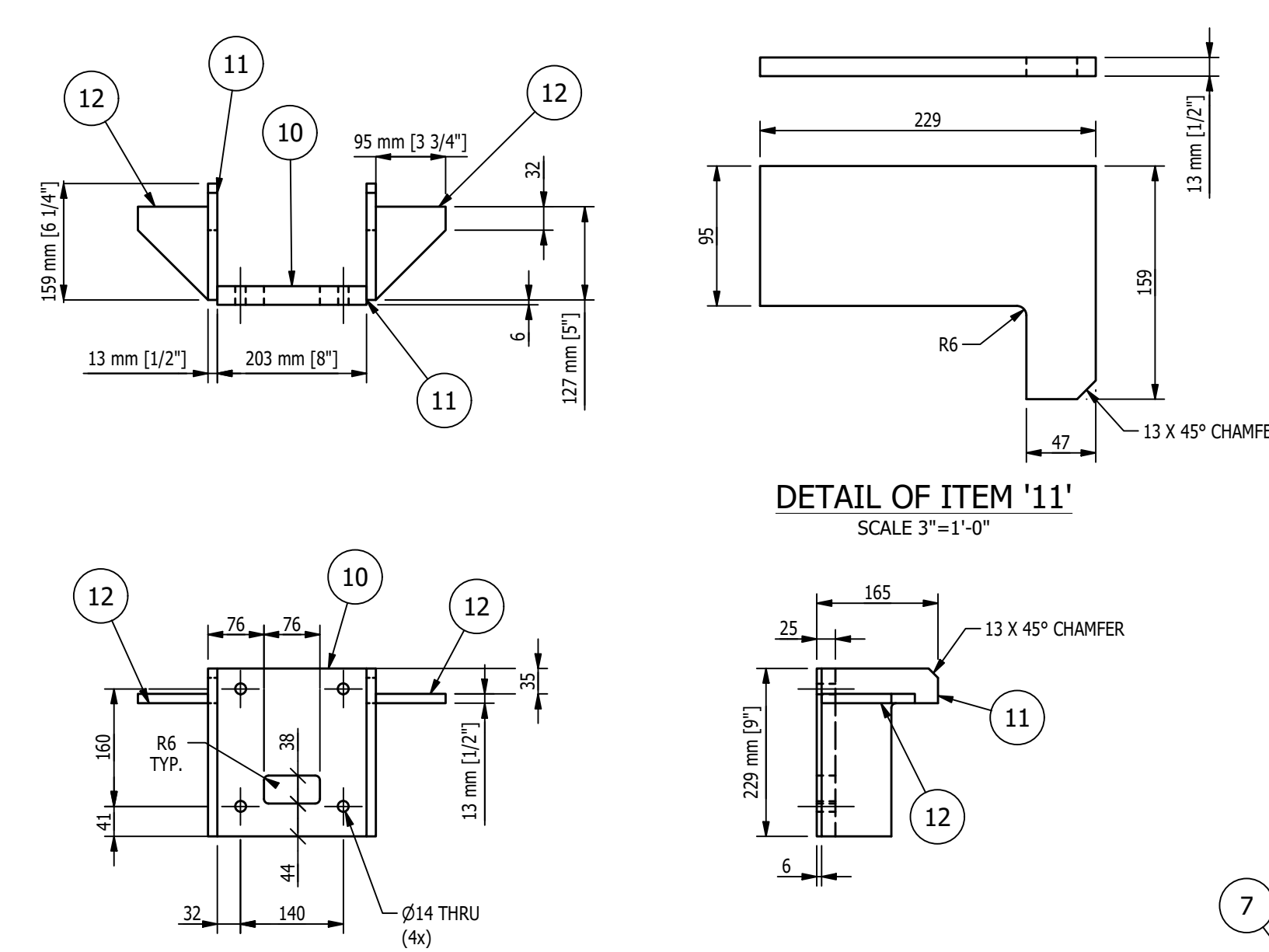
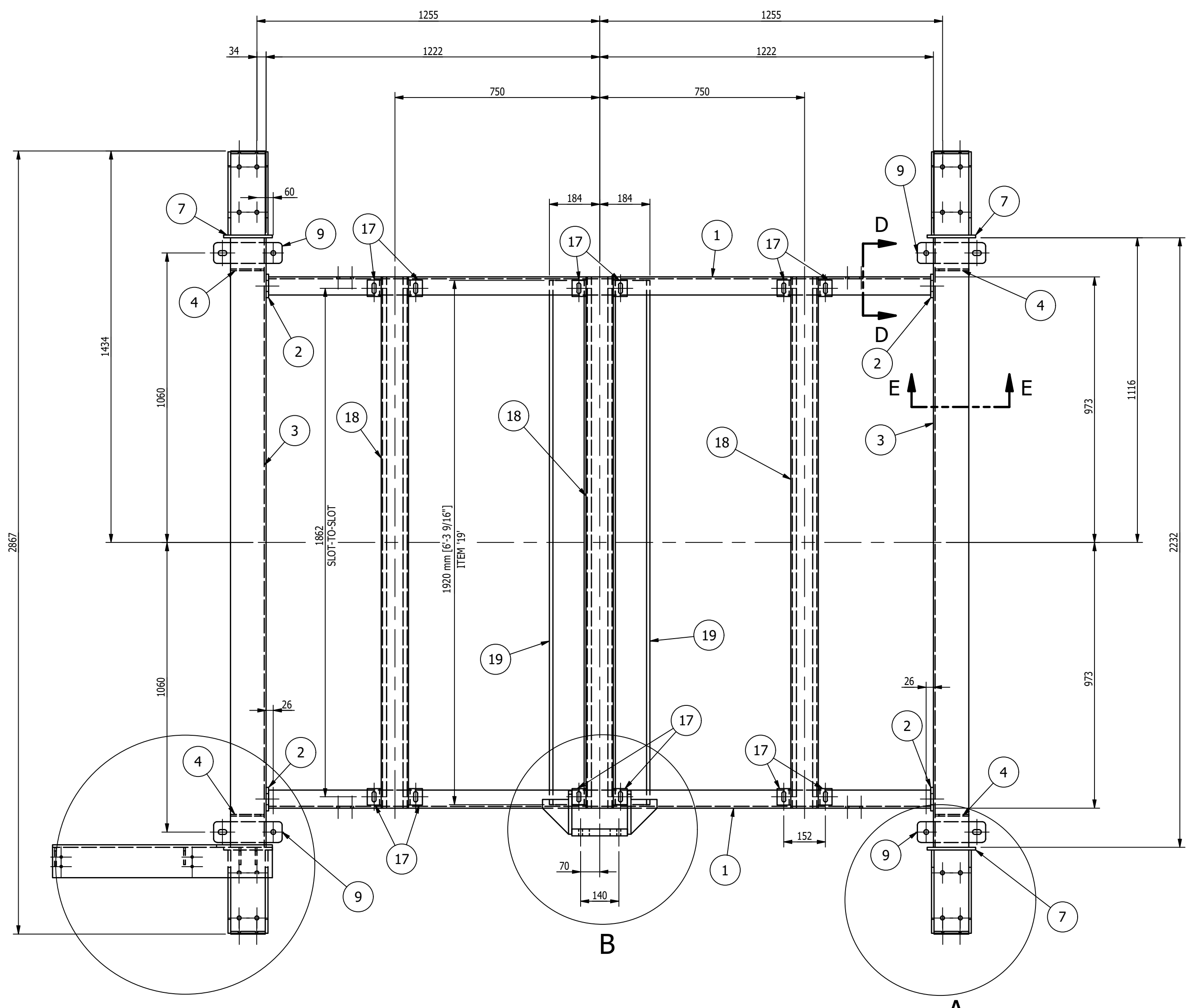
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

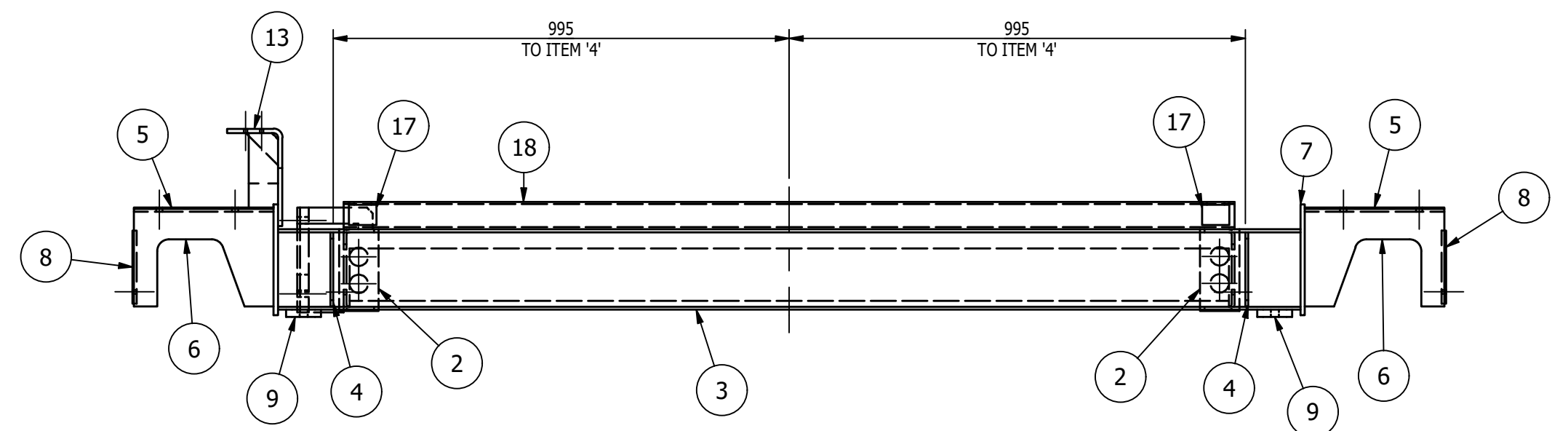
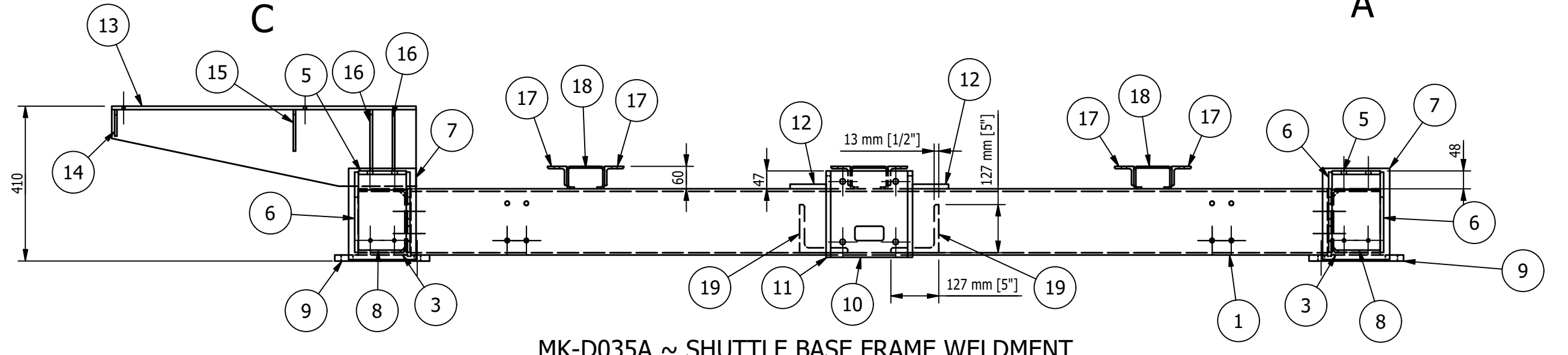
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D034	DWG DATE: 6/15/22
REV: A	JOB No: 22096



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D035A			
1	2	BAR 1/4 x 11 1/8	7'-11 7/16"		
2	4	PL 3/8 x 3 3/8	7"		
3	2	BAR 1/4 x 16 3/16	7'-3 7/8"		
4	4	PL 1/4 x 4 7/8	6 3/8"		
5	4	BAR 3/8 x 5	1'-0"		
6	8	BAR 3/8 x 12	8 3/8"		
7	4	BAR 3/8 x 7	9 1/2"		
8	4	BAR 3/8 x 5	6 1/4"		
9	4	BAR 5/8 x 3	9 7/8"		
10	1	BAR 1 x 8	9"		
11	2	BAR 1/2 x 9	6 1/4"		
12	2	BAR 1/2 x 3 3/4	5"		
13	1	BAR 3/8 x 12 3/8	2'-7 11/16"		
14	1	PL 1/4 x 1 9/16	3 7/8"		
15	1	PL 1/4 x 2 1/2	4 5/16"		
16	2	PL 1/4 x 2 1/2	6 3/8"		
17	12	L 2 x 2 x 1/4	2 3/8"		
18	3	BAR 3/16 x 8 15/16	6'-4 9/16"		
19	2	L 5 x 5 x 1/2	6'-3 9/16"		



- SHOP NOTES:**
- ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 - ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 - REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 - ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 - ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 - ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 - MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 - ALL SLOT LENGTHS ARE END TO END U.N.O.
 - VIBRATORY STRESS RELIEVE WELDMENT
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

SHEET 1 OF 3

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	ADDED 4 HOLES AND DIMENSION TO ITEM '1', CORRECTED NAME OF ENLARGED VIEW 'F'	
B	MC	8/26/22	CORRECTED LENGTH OF ITEM '13' IN BOM	
A	MC	8/9/22	FOR FABRICATION	

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

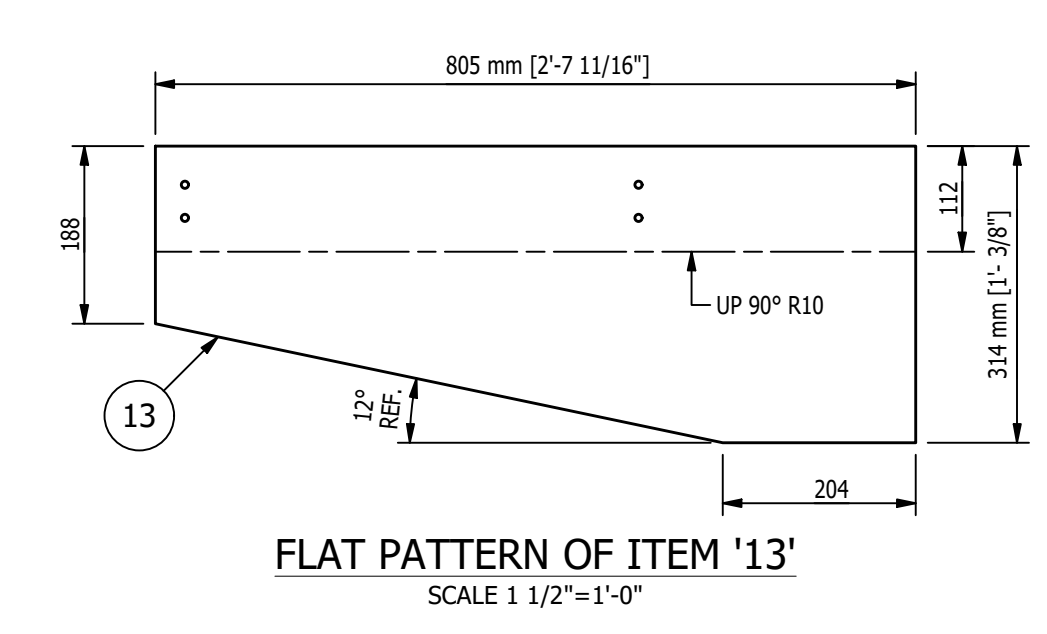
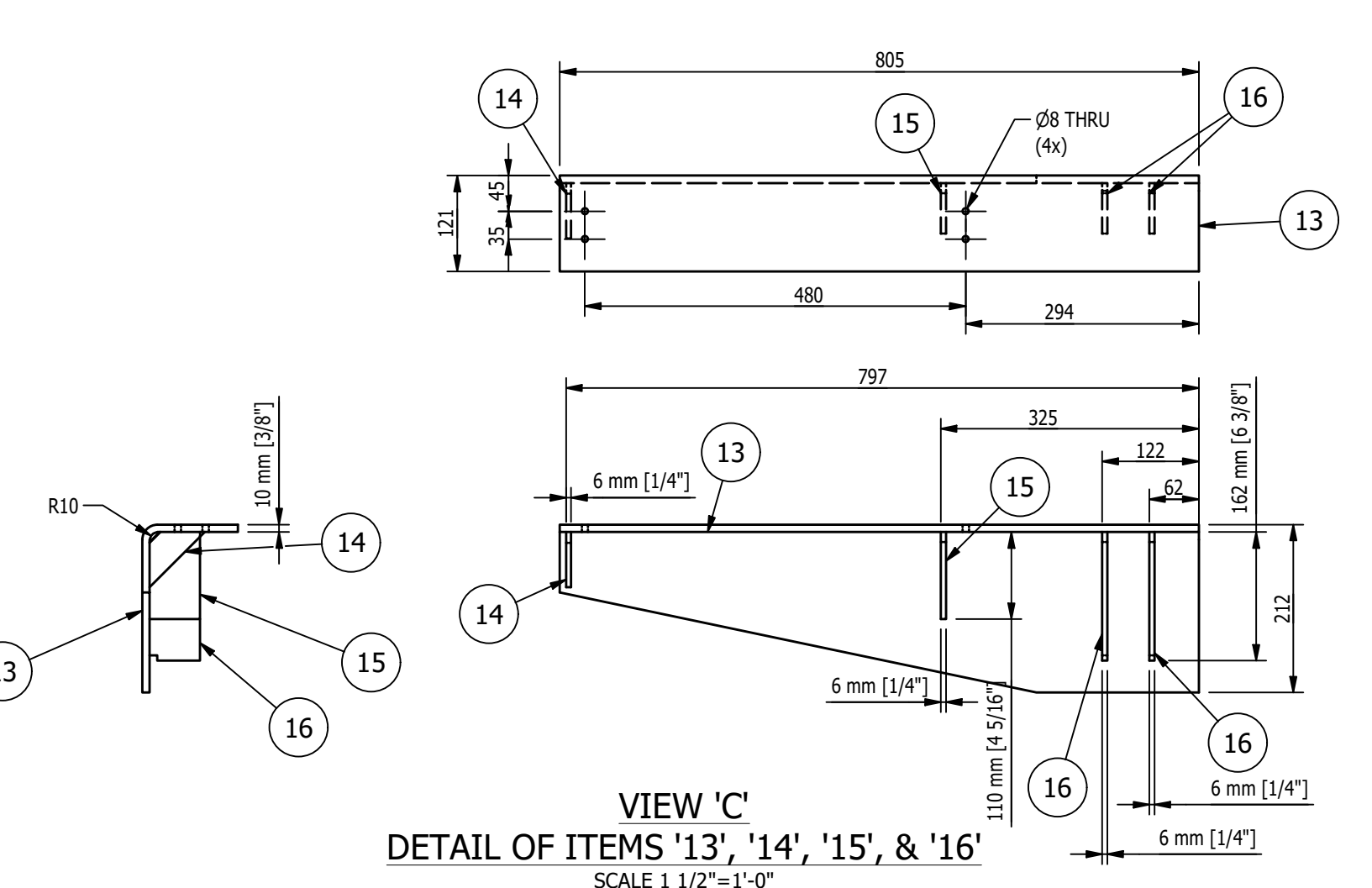
COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No.: 1875D035
REV: C
JOB No.: 22096

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 6/28/22

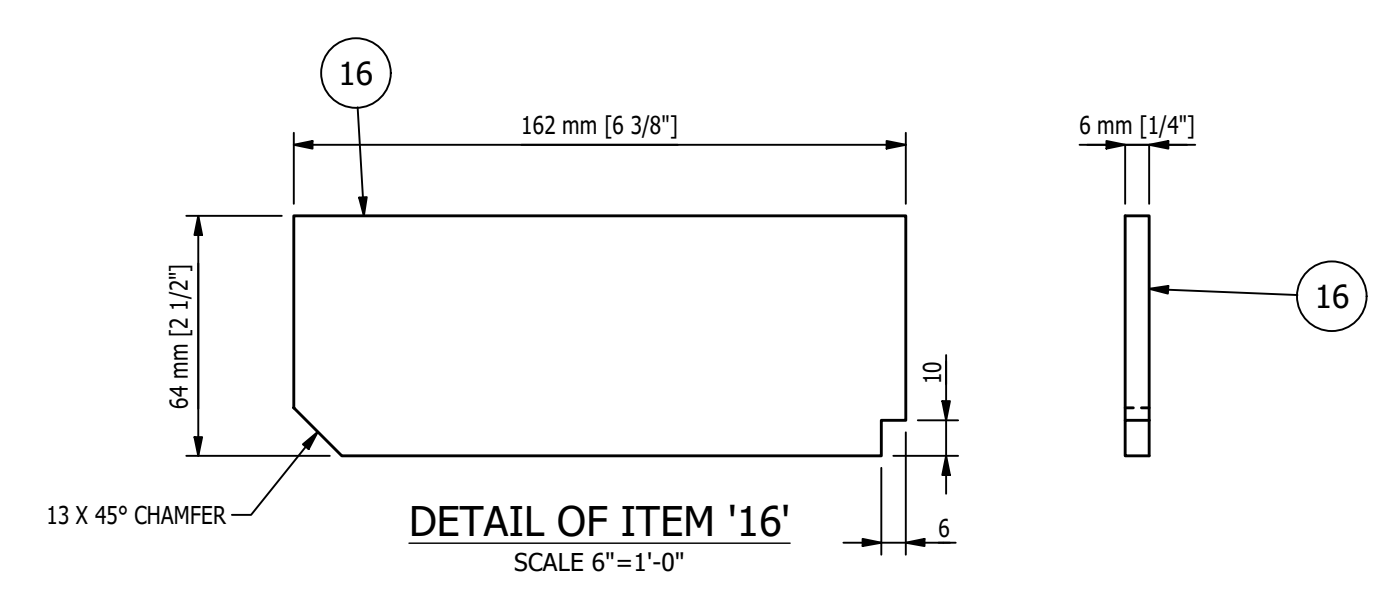
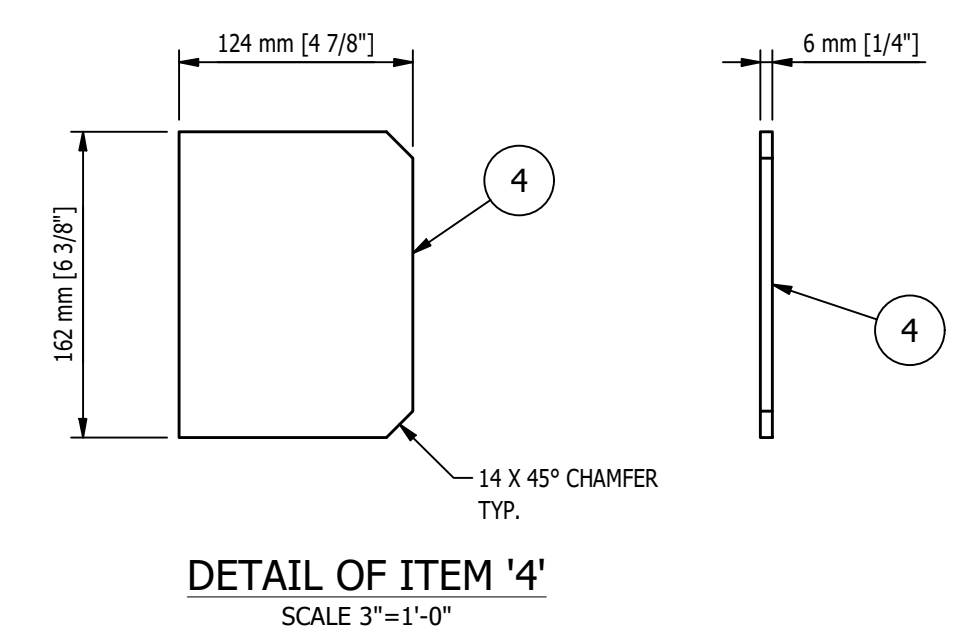
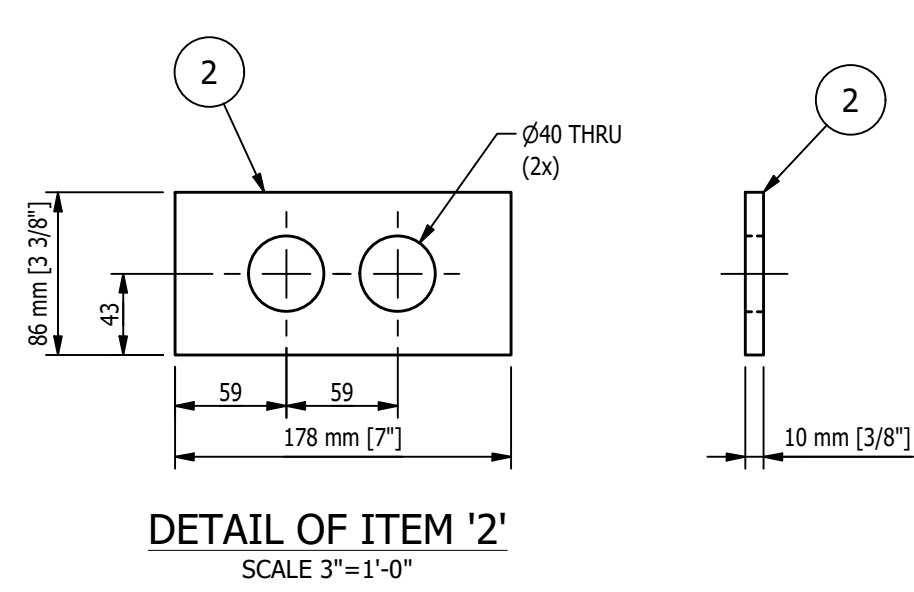
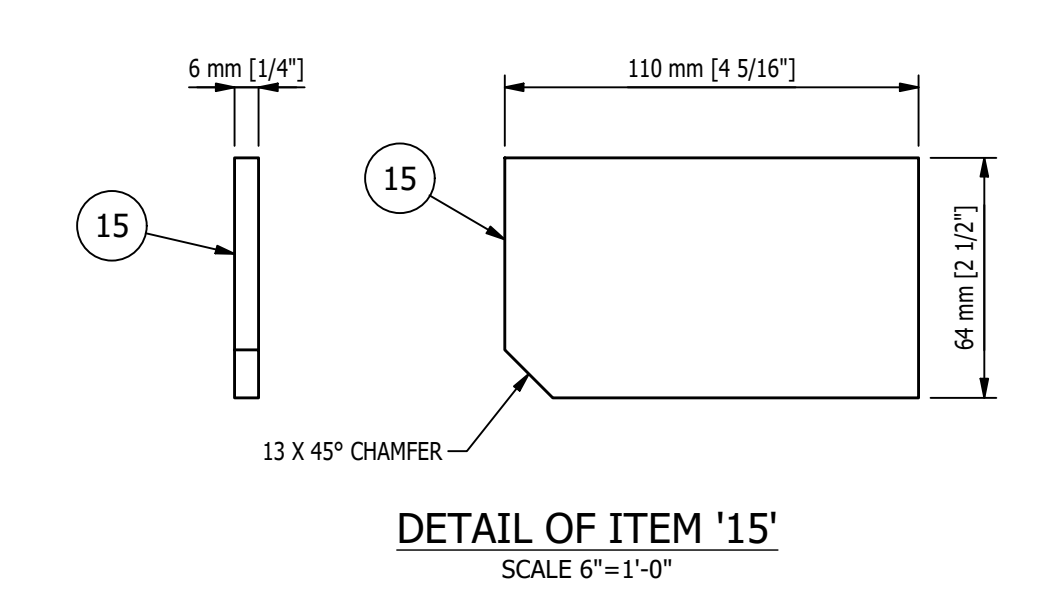
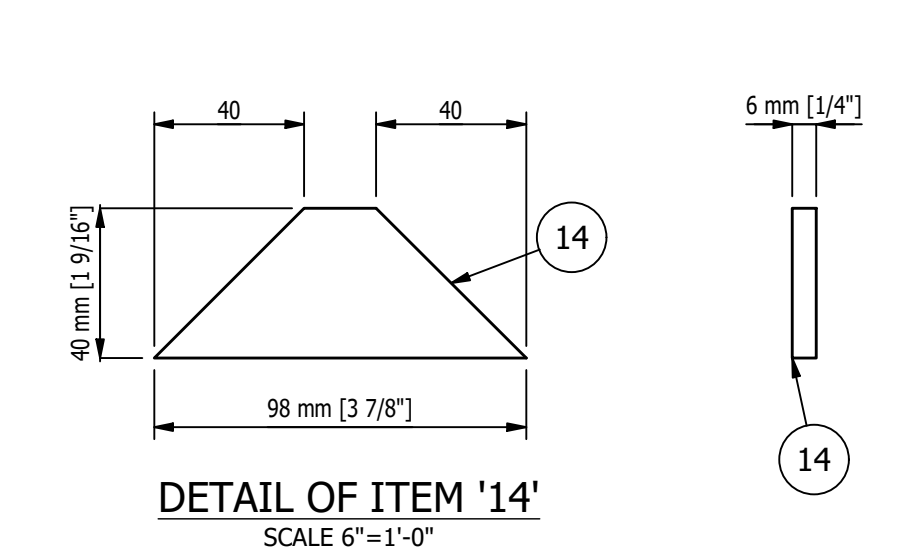
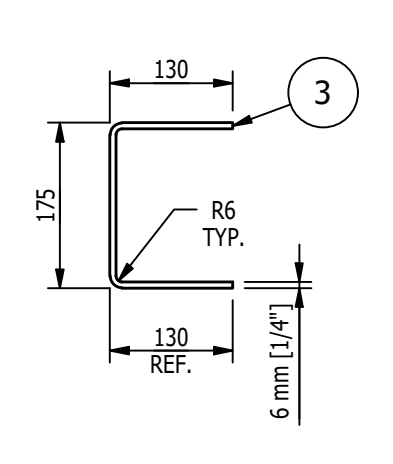
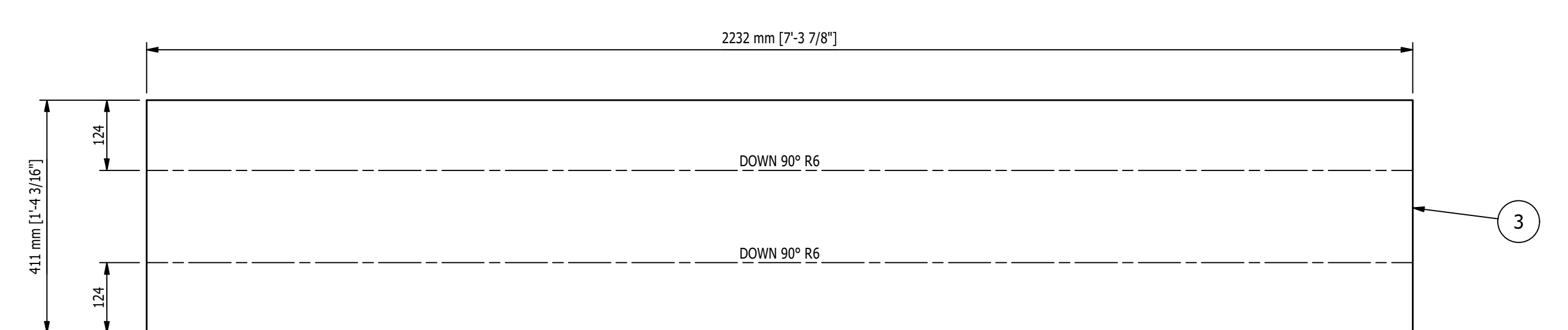
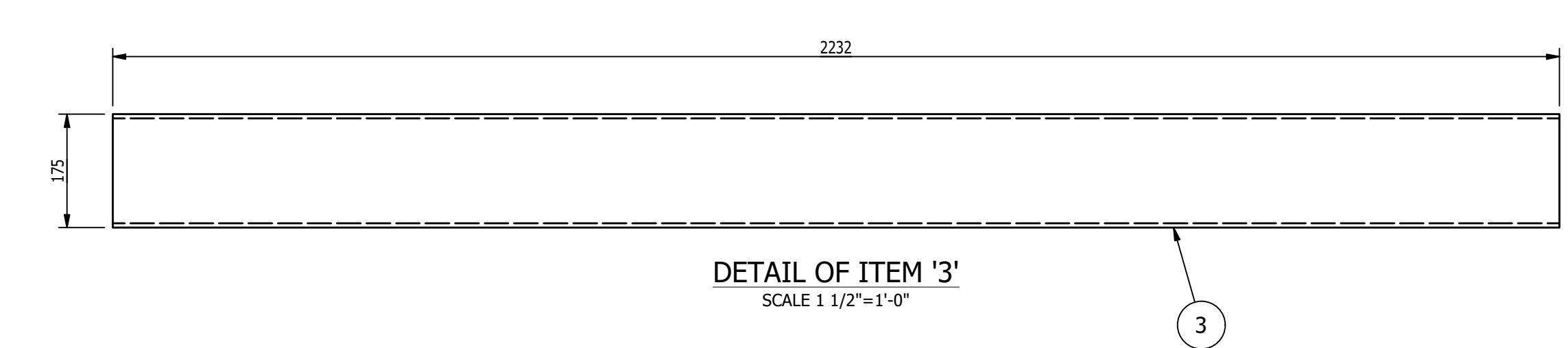
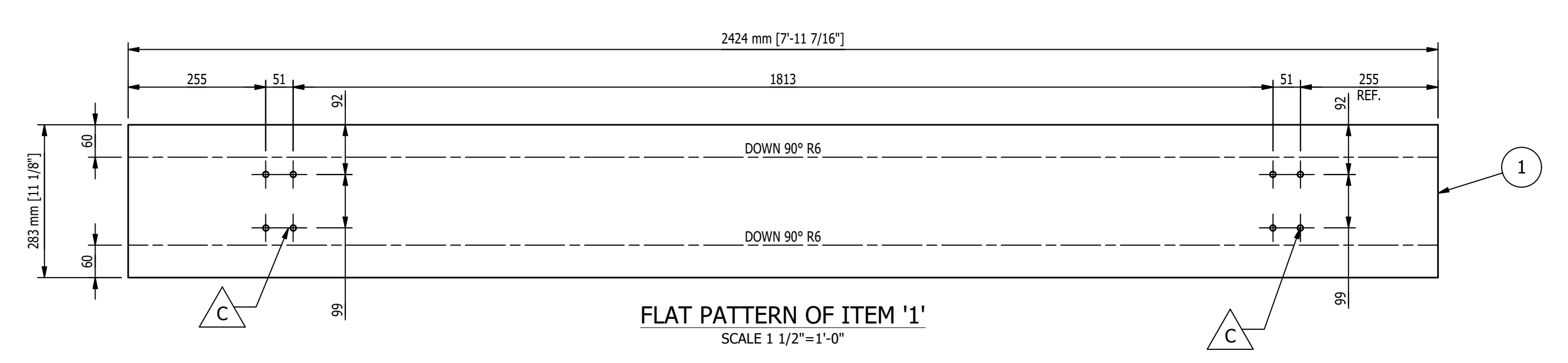
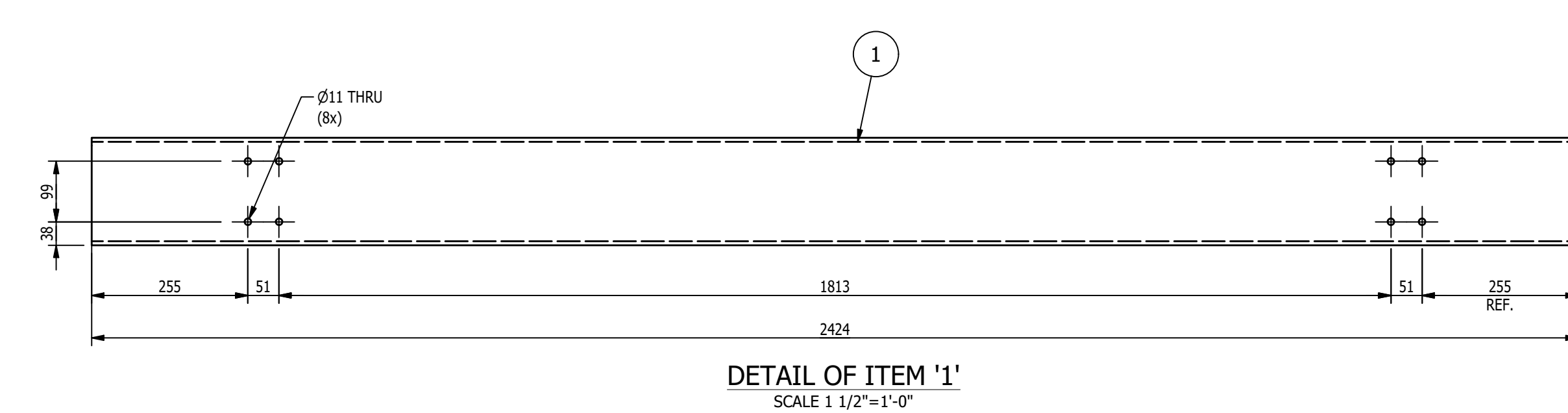
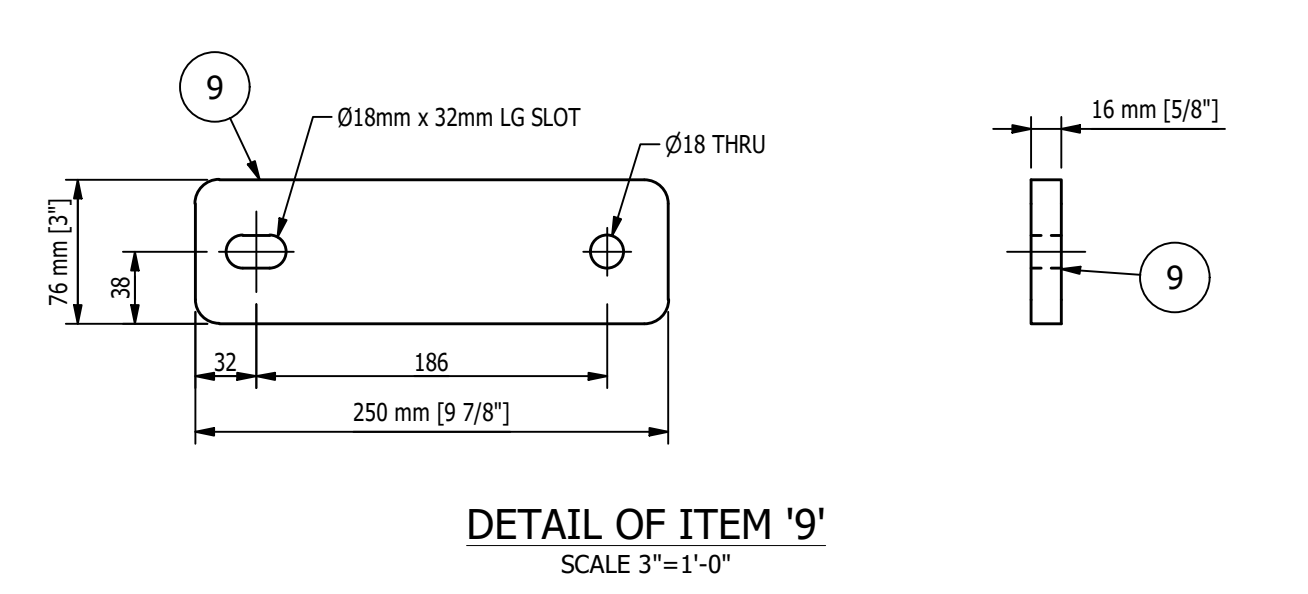
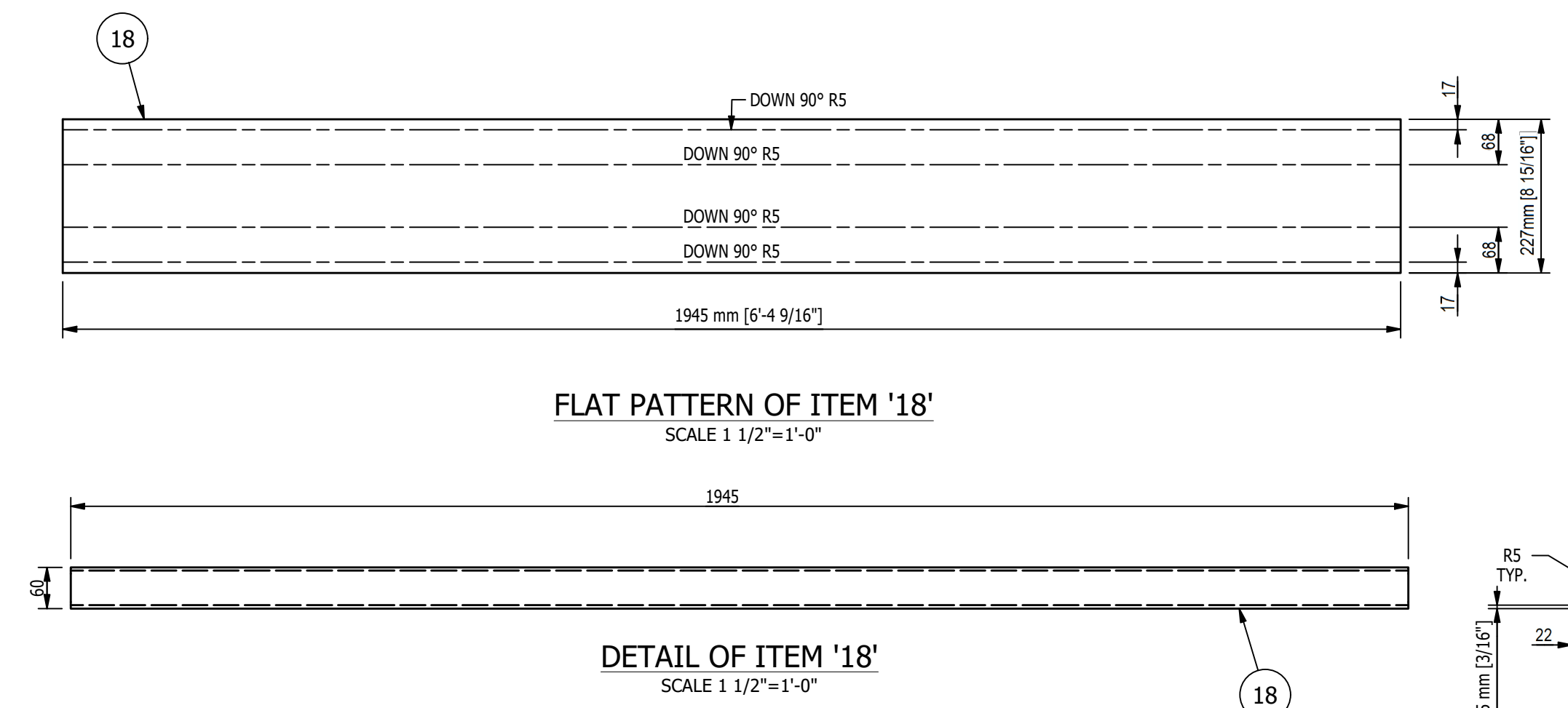
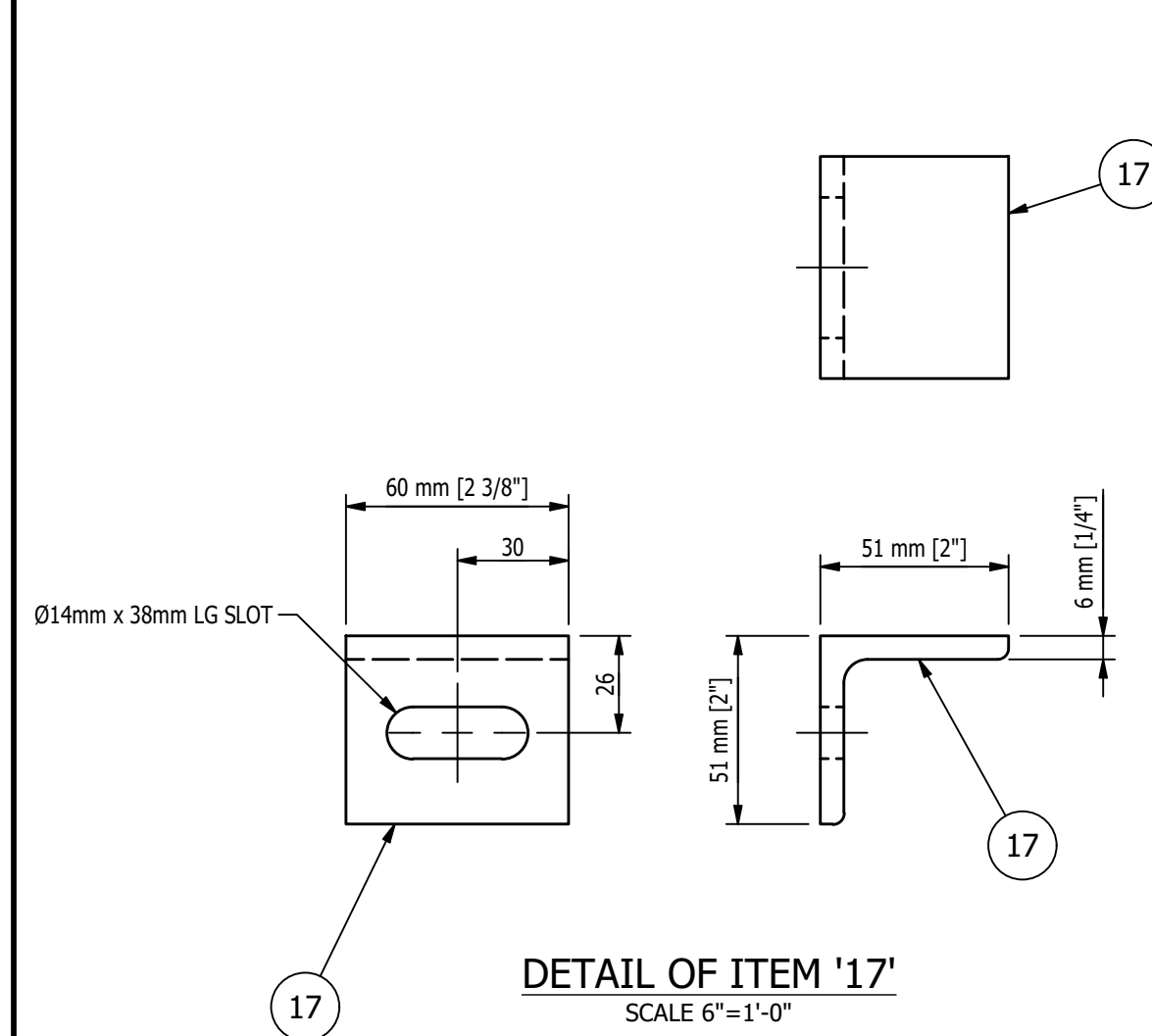


MAGNUM Consulting
 4100 Clarkston Rd.
 Suite 125
 Novi, MI 48225
 Phone: (248) 772-8889
 Fax: (248) 772-8851
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D035

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

3:00 PM 11/25/2022 1875D035.dwg



SHEET 2 OF 3

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	ADDED 4 HOLES AND DIMENSION TO ITEM '1', CORRECTED NAME OF ENLARGED VIEW 'F'	
B	MC	8/26/22	CORRECTED LENGTH OF ITEM '13' IN BOM	
A	MC	8/9/22	FOR FABRICATION	

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
 WELDS:
 - ALL WELDS TO BE "E70XX". (PER AWS D1.1)
 PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 COPES:
 - ALL REINTRANT CUTS TO BE A MIN 1/2" RADIUS U.N.O.

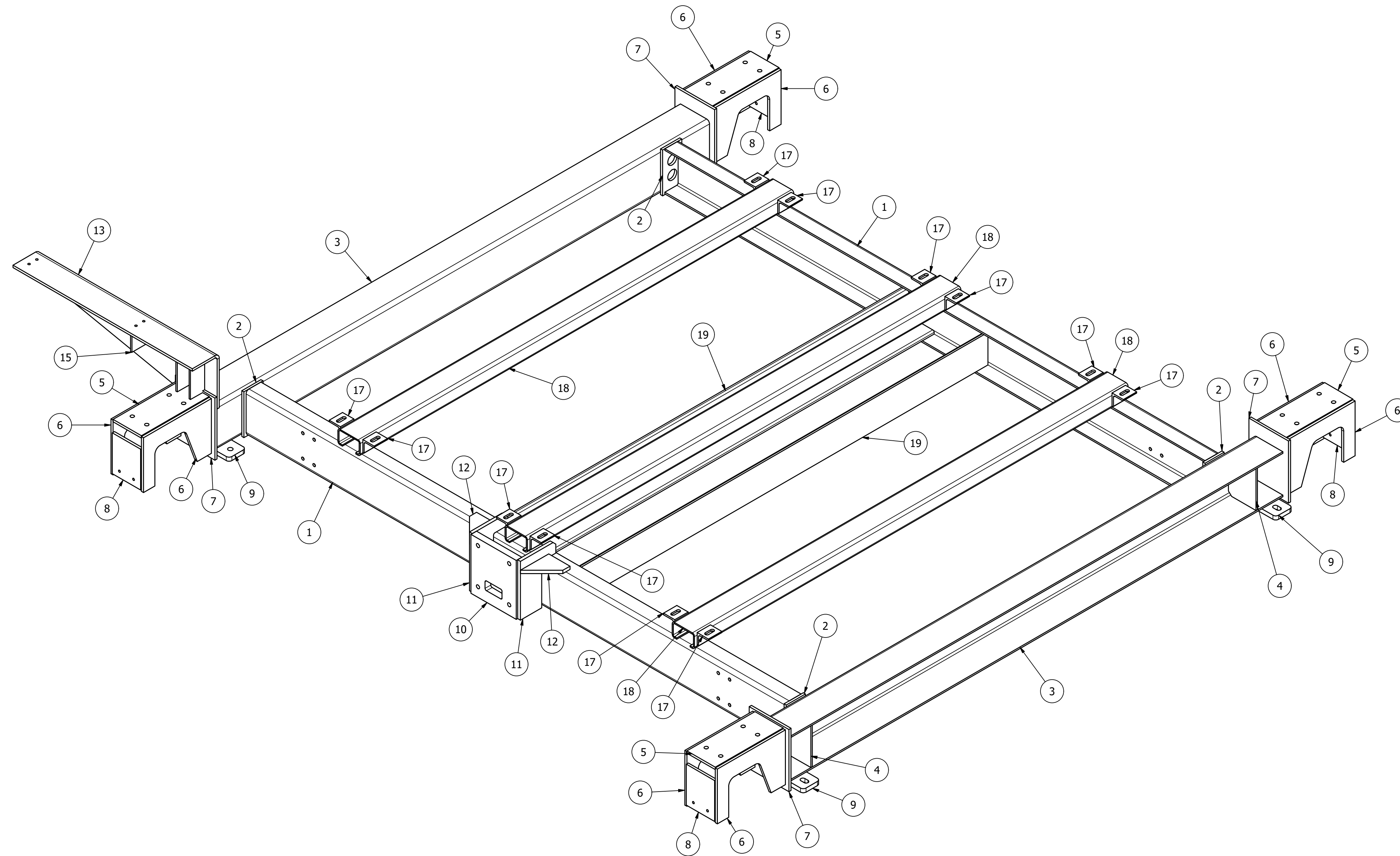
MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millc.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D035

PROPRIETARY AND CONFIDENTIAL
 INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 6/28/22
JOB No: 22096

3:20:43 PM New Job Drawings/Details/1875D035.dwg



SHEET 3 OF 3

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	ADDED 4 HOLES AND DIMENSION TO ITEM '1', CORRECTED NAME OF ENLARGED VIEW 'F'	
B	MC	8/26/22	CORRECTED LENGTH OF ITEM '13' IN BOM	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

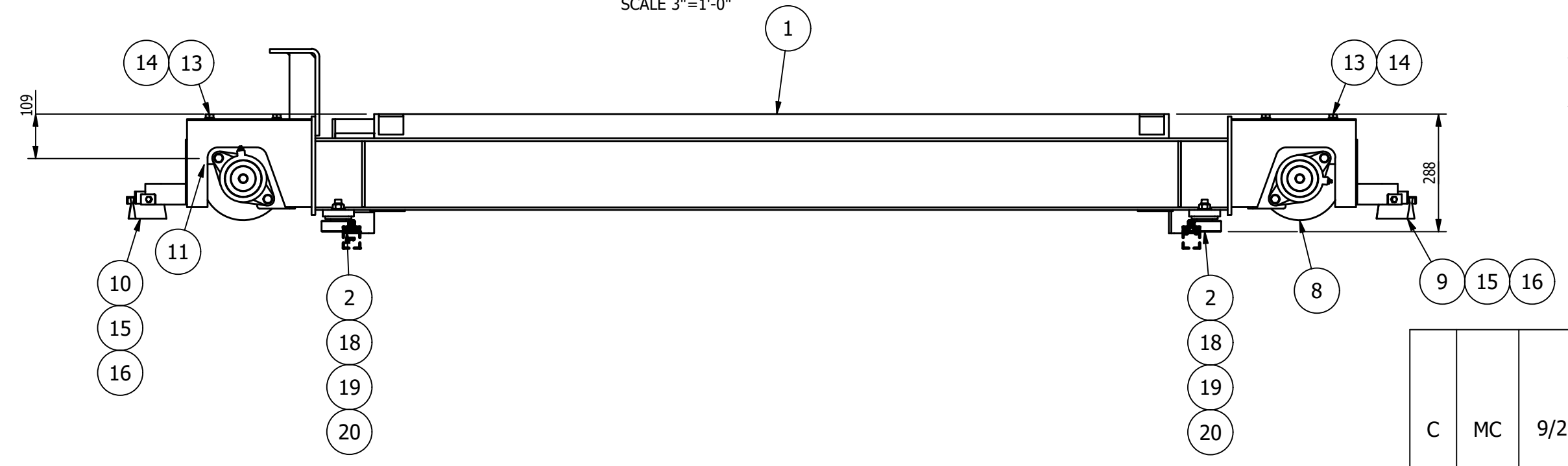
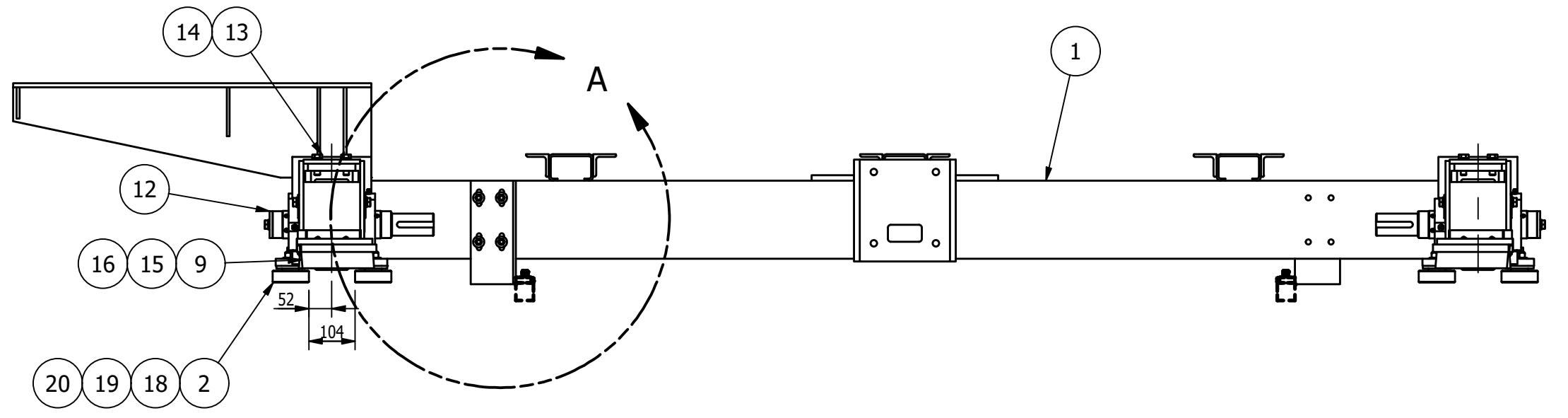
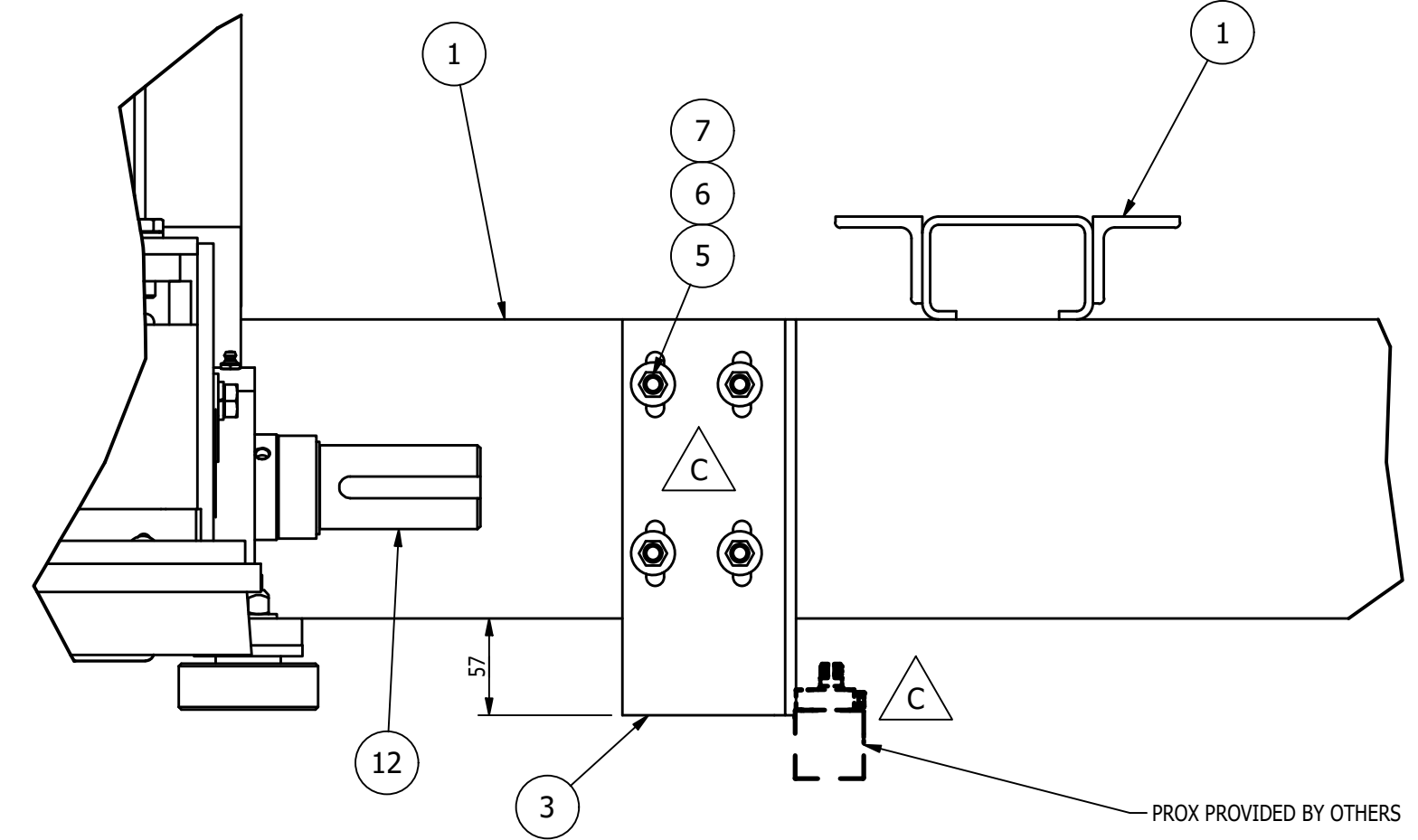
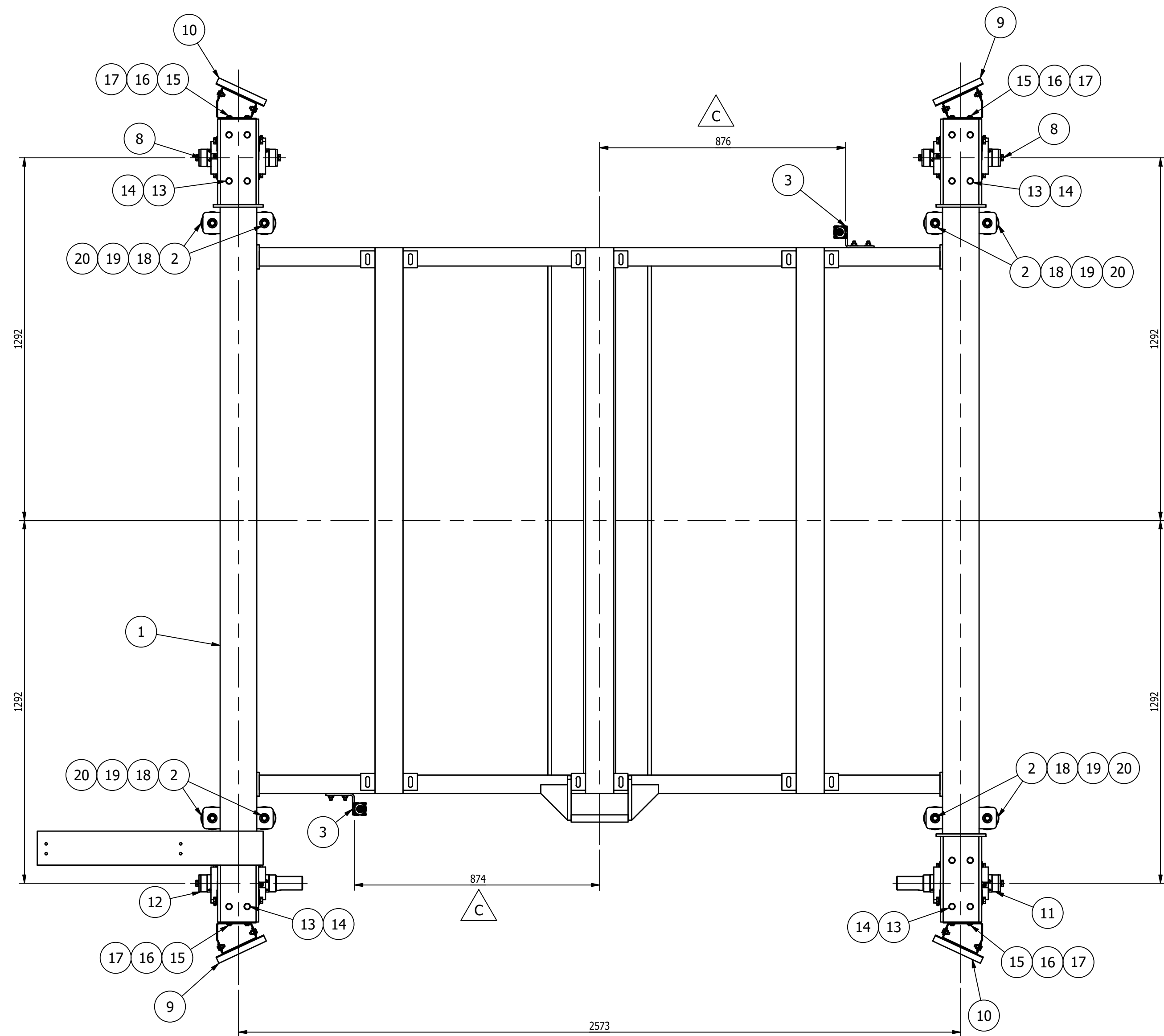
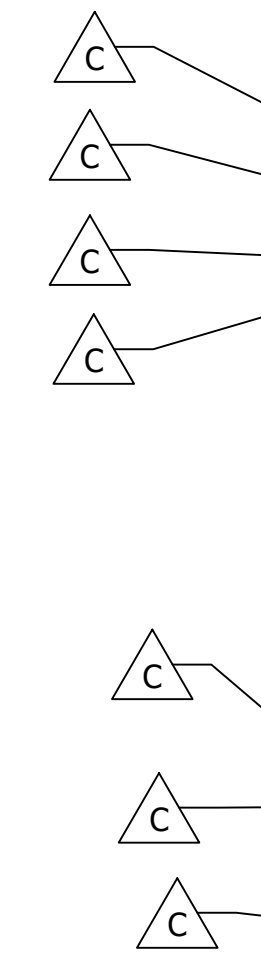
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

 MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: RJB
	CLIENT: VOLVO		CHECKED BY: CW
DRAWING No. 1875D035	REV: C	JOB No: 22096	DWG DATE: 6/28/22

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D035A ~ SHUTTLE BASE FRAME WELDMNT			
2	8	MK-D037A ~ GUIDE ROLLER SPACER			
3	2	MK-D037B ~ PROX BRACKET ANGLE			
5	8	3/8-16UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
6	16	3/8 TYPE B REGULAR FLAT WASHER			
7	8	3/8-16UNC STOVER LOCK NUT			
8	2	MK-D020A ~ IDLER WHEEL ASSEMBLY			
9	2	MK-D038A ~ SHUTTLE BRUSH ASSEMBLY - RH			
10	2	MK-D038B ~ SHUTTLE BRUSH ASSEMBLY - LH			
11	1	MK-D042A ~ SHUTTLE DRIVE WHEEL ASSEMBLY - RH			
12	1	MK-D042B ~ SHUTTLE DRIVE WHEEL ASSEMBLY - LH			
13	16	1/2 SPRING LOCK WASHER			
14	16	1/2-13UNC x 1 1/2" LG. HEX HEAD CAP SCREW			
15	8	M6 x 1 STOVER LOCK NUT			
16	8	M6 REGULAR FLAT WASHER			
17	8	M6x1 x 25mm LG. HEX CAP SCREW			
18	8	FROST STUD - TYPE GUIDED ROLLER, 3.25" DIA x 1.06" WIDE 5/8-11 THREAD, SEAL FOR LIFE, P/N: 4290000		11-1	
19	8	5/8 TYPE A NARROW FLAT WASHER			
20	8	5/8-11UNC STOVER LOCK NUT			



MK-D036A ~ SHUTTLE BASE FRAME ASSEMBLY
SCALE 1"=1'-0"

SHOP NOTES:
 1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
 PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	ITEM '3' LOCATION UPDATED, ADDED PROX NOTE, & QUANTITIES UPDATED: ITEM '5' WAS 4 NOW 8, ITEM '6' WAS 8 NOW 16, & ITEM '7' WAS 4 NOW 8. DESCRIPTION OF ITEM '3' UPDATED, ITEM 17 NOW M6x1 x 25mm LG HEX CAP SCREW. ITEM '13' NOW 1/2 SPRING LOCK WASHER, ITEM '14' NOW 1/2-13 UNC x 1 1/2" LG HEX HEAD CAP SCREW	
B	MC	8/26/22	REMOVED ITEM '4'. QUANTITIES UPDATED: ITEM '5' WAS 8, NOW 4. ITEM '6' WAS 16, NOW 8. ITEM '7' WAS 8, NOW 4.	
A	MC	8/9/22	FOR FABRICATION	

GENERAL NOTES:

MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

REVISION HISTORY

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE: P6700 CONVEYORS
CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D036

REV: C

JOB No: 22096

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 6/29/22

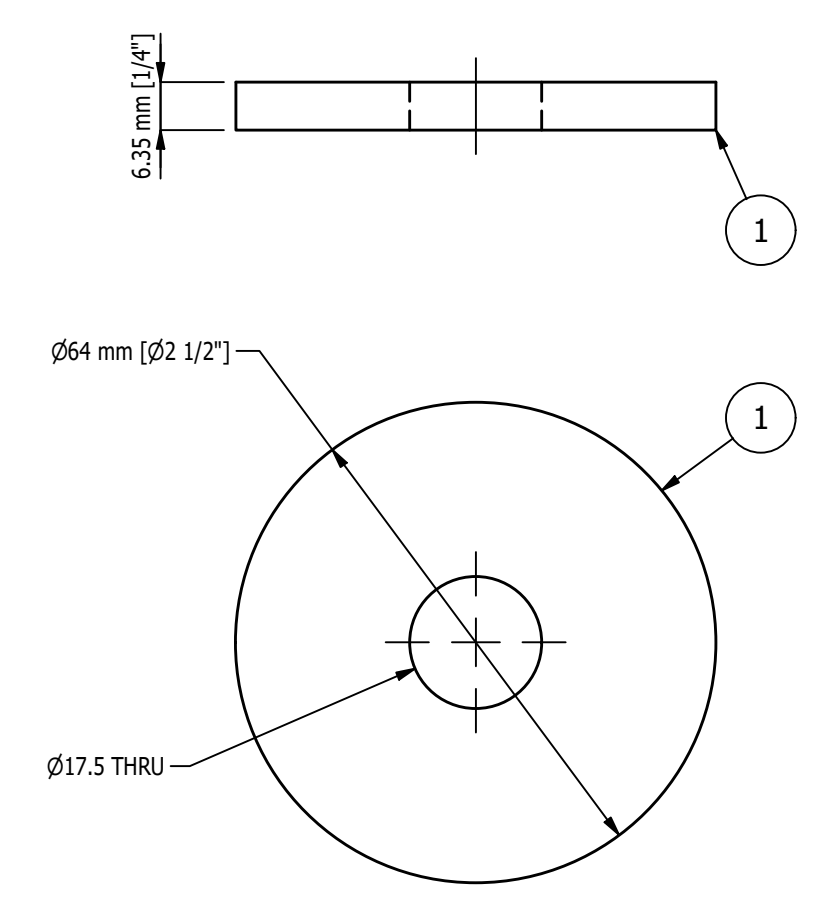
MAGNUM CONSULTING
 41100 Clarkston Rd.
 Suite 125
 Novi, MI 48275

Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

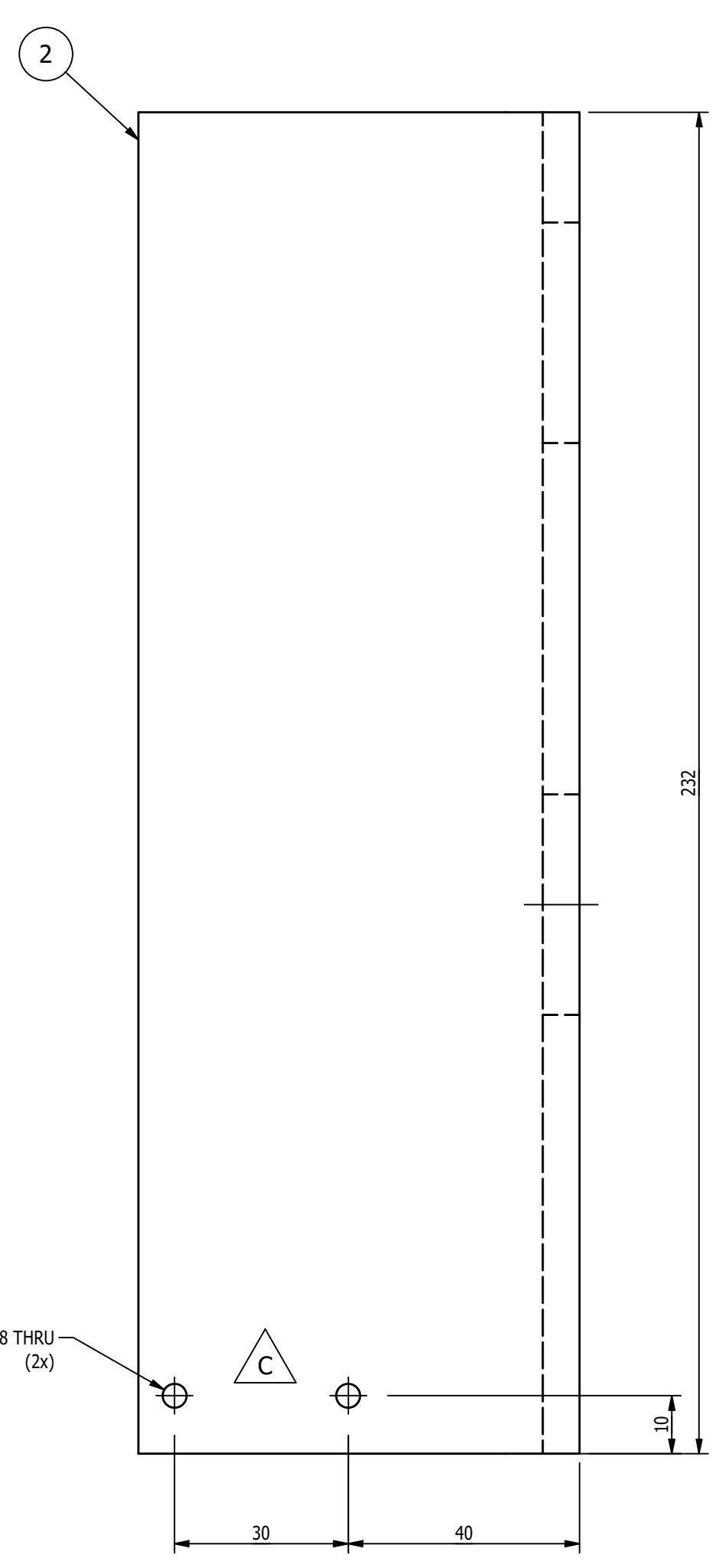
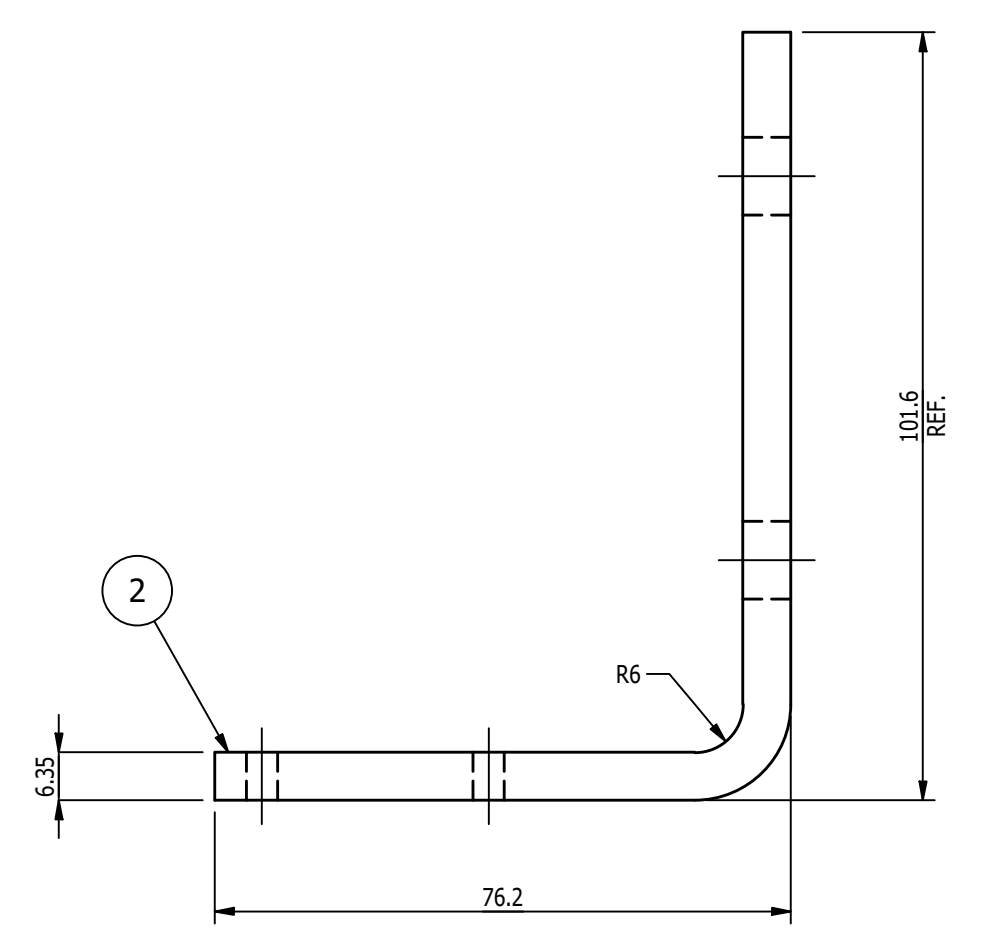
MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D036

3:00p 11/25/2022 New Job Drawing/Details/1875D036.dwg

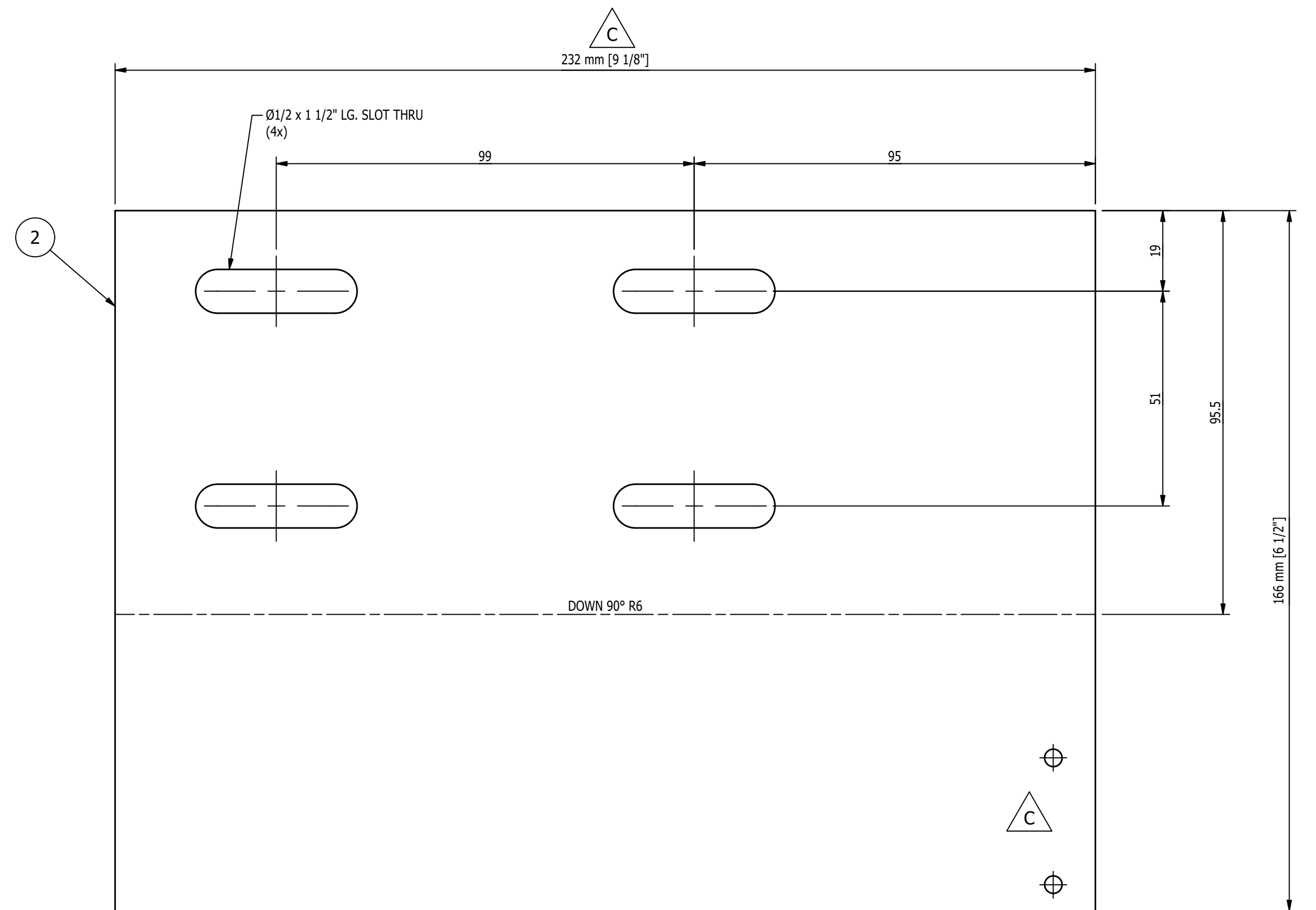
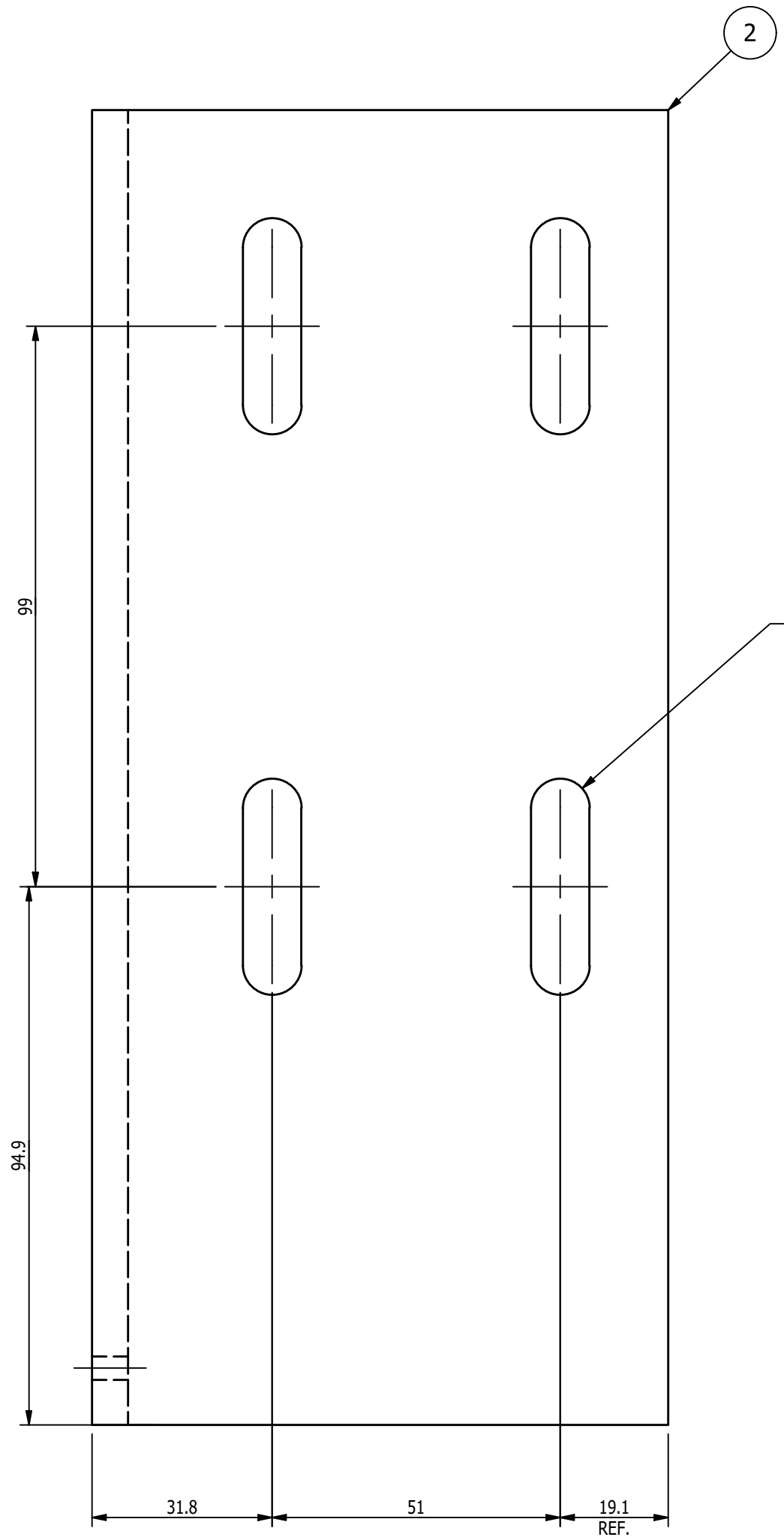
BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D037A		
1	1	PL 1/4 x 2 1/2"	2 1/2"	
		TOTAL WEIGHT ~ 0.3 LBS		
		MK-D037B		
2	1	BAR 1/4" x 6 1/2"	9 1/8"	
		TOTAL WEIGHT ~ 1.3 LBS		



MK-D037A ~ GUIDE ROLLER SPACER
SCALE 1'-0" = 1'-0"



MK-D037B ~ PROX BRACKET ANGLE
SCALE 1'-0" = 1'-0"



DETAIL OF ITEM '2'
SCALE 1'-0" = 1'-0"

- SHOP NOTES:**
1. USE E70XX LOW HYD. RODS FOR ALL WELDING U.N.O.
 2. ALL WELDS TO BE 3/16" CONTINUOUS FILLET U.N.O.
 3. ALL STEEL ANGLES, CHANNELS, MC, PLATES, FLATS, ROUNDS & S-SHAPES TO BE ASTM A-36 U.N.O.
 4. ALL STRUCTURAL STEEL WIDE FLANGES AND WIDE FLANGE TEES TO BE ASTM A-992/A-572 GR. 50
 5. ALL FASTENERS TO BE ZINC PLATED U.N.O.
 6. ALL BOLTS TO BE ASTM A-325 U.N.O.
 7. ALL NUTS ARE TO BE ASTM A-194 GR. 2 ANCO LOCK NUTS U.N.O.
 8. ALL WASHERS ARE TO BE ASTM F436 U.N.O.
 9. ALL STEEL TO BE CLEAN OF DIRT, RUST, MILL SCALE, WELD SPLATTER AND DEBURR ALL EDGES PRIOR TO PAINTING.
 10. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 11. ALL SLOT LENGTHS ARE END TO END U.N.O.
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	UPDATED PLATE SIZE, HOLE LOCATION, & QUANTITY AND SLOT SIZE & LOCATIONS OF ITEM '2', REMOVED MK-D037C, AND UPDATED DESCRIPTION OF MK-D037B	
B	MC	8/26/22	UPDATED ITEMS '2' & '3'; ADDED HOLES AND SIZE OF BAR	
A	MC	8/11/22	FOR FABRICATION	

REVISION HISTORY

MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
North, MI 48135
Phone: (248) 772-8822
Fax: (248) 772-8821
Web: www.mmagnum.com

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D037

REV: C

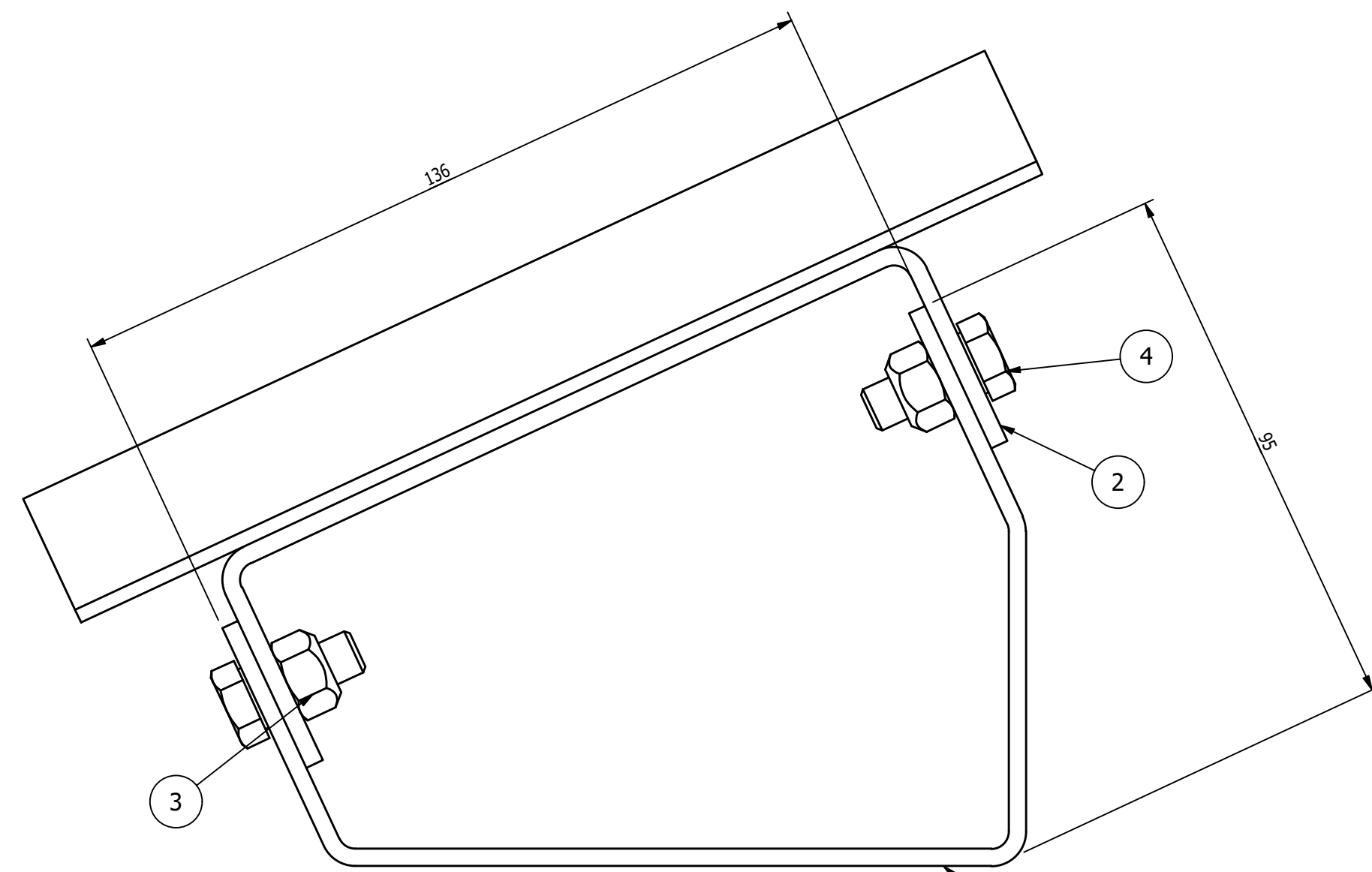
JOB No: 22096

DRAWN BY: JC

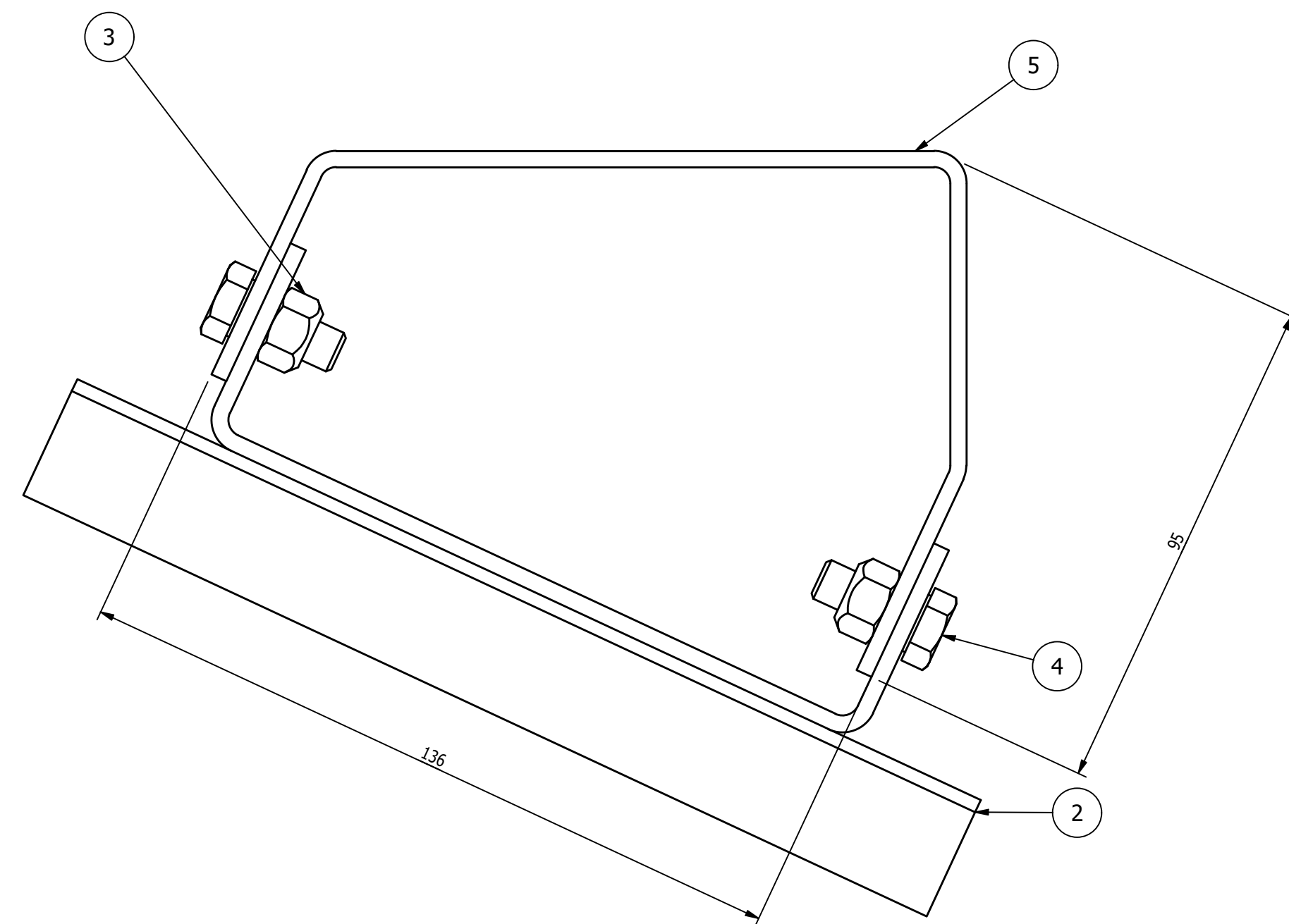
CHECKED BY: CW

DWG DATE: 6/29/22

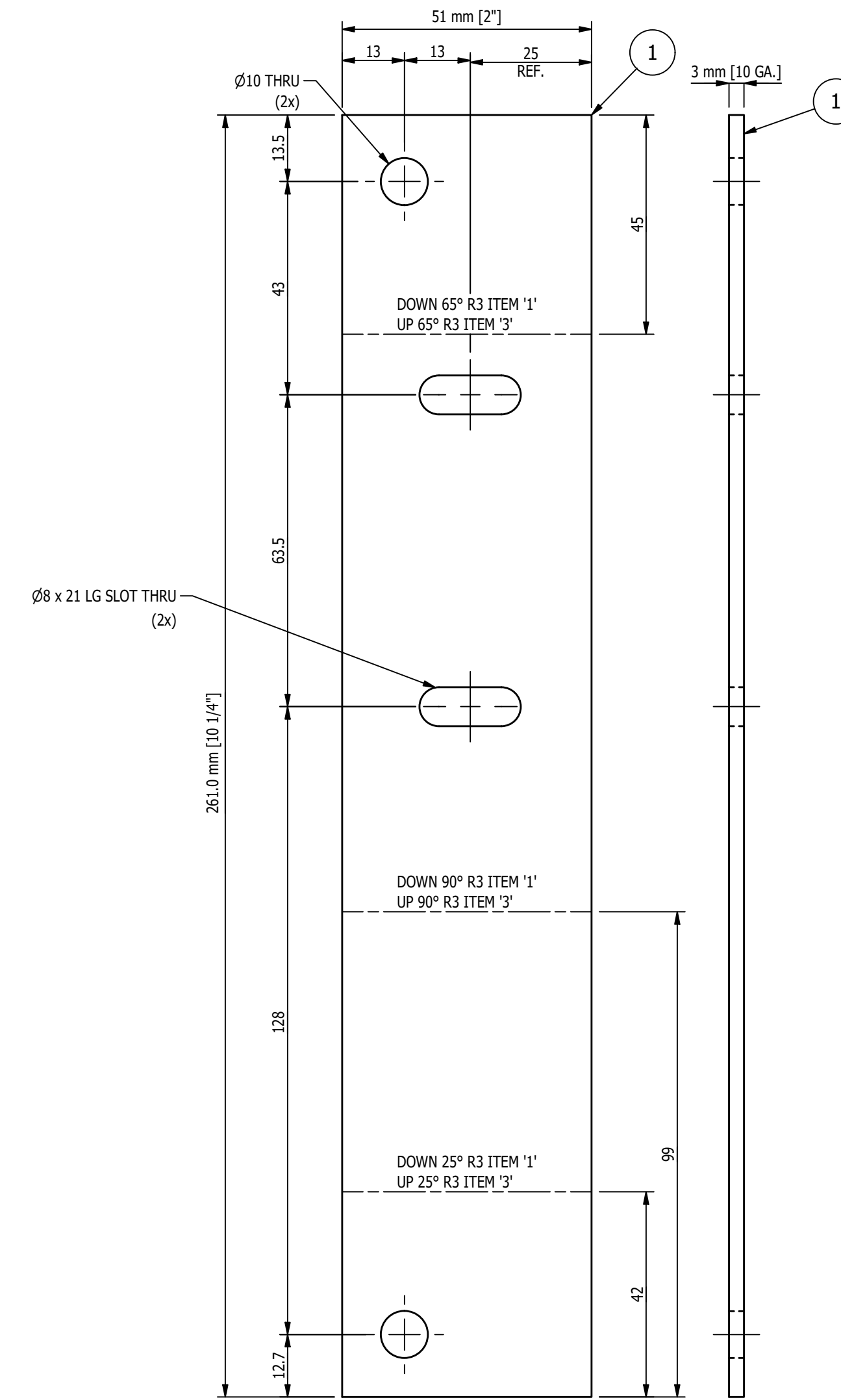
3:00p 1875D037.dwg 11/29/2022 11:29:37 AM



MK-D038A ~ SHUTTLE BRUSH ASSEMBLY - RH
SCALE 1'-0" = 1'-0"



MK-D038B ~ SHUTTLE BRUSH ASSEMBLY - LH
SCALE 1'-0" = 1'-0"



FLAT PATTERN OF ITEM '1' & '5'
SCALE 1'-0" = 1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D038A			
1	1	SHT 10 GA x 2"	10 1/4"		
2	1	MK-D022D ~ TRACK BRUSH			
3	2	M8 x 1.25 STOVER LOCK NUT			
4	2	M8x1.25 x 20mm LG. HEX CAP SCREW			
		TOTAL WEIGHT ~ 1.7 lbs			
		MK-D038B			
2	1	MK-D022D ~ TRACK BRUSH			
3	2	M8 x 1.25 STOVER LOCK NUT			
4	2	M8x1.25 x 20mm LG. HEX CAP SCREW			
5	1	SHT 10 GA x 2"	10 1/4"		
		TOTAL WEIGHT ~ 1.7 lbs			

SHOP NOTES:

1. USE E70XX LOW HYD. RODS FOR ALL WELDING U.N.O.
2. ALL WELDS TO BE 3/16" CONTINUOUS FILLET U.N.O.
3. ALL STEEL ANGLES, CHANNELS, MC, PLATES, FLATS, ROUNDS & S-SHAPES TO BE ASTM A-36 U.N.O.
4. ALL STRUCTURAL STEEL WIDE FLANGES AND WIDE FLANGE TEES TO BE ASTM A-992/A-572 GR. 50
5. ALL FASTENERS TO BE ZINC PLATED U.N.O.
6. ALL BOLTS TO BE ASTM A-325 U.N.O.
7. ALL NUTS ARE TO BE ASTM A-194 GR. 2 ANCO LOCK NUTS U.N.O.
8. ALL WASHERS ARE TO BE ASTM F436 U.N.O.
9. ALL STEEL TO BE CLEAN OF DIRT, RUST, MILL SCALE, WELD SPLATTER AND DEBURR ALL EDGES PRIOR TO PAINTING.
10. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
11. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:

PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/11/2022	FOR FABRICATION	

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	TITLE: P6700 CONVEYORS CAMPUS BUILDING	

CLIENT: VOLVO	DRAWN BY: AH
DRAWING No. 1875D038	CHECKED BY: CW
REV: A	DWG DATE: 6/29/22
JOB No: 22096	

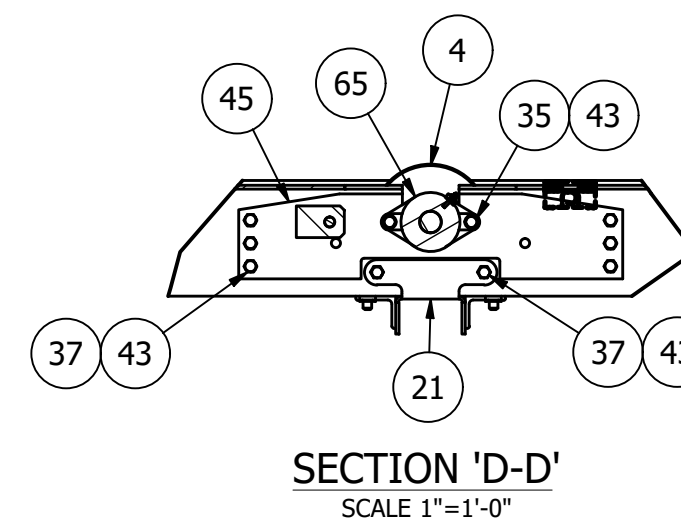
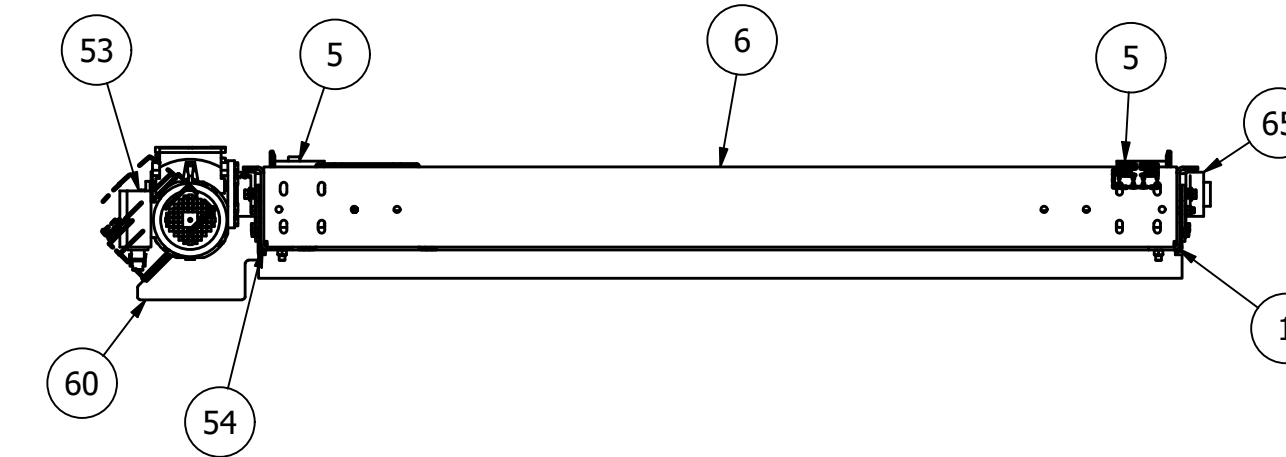
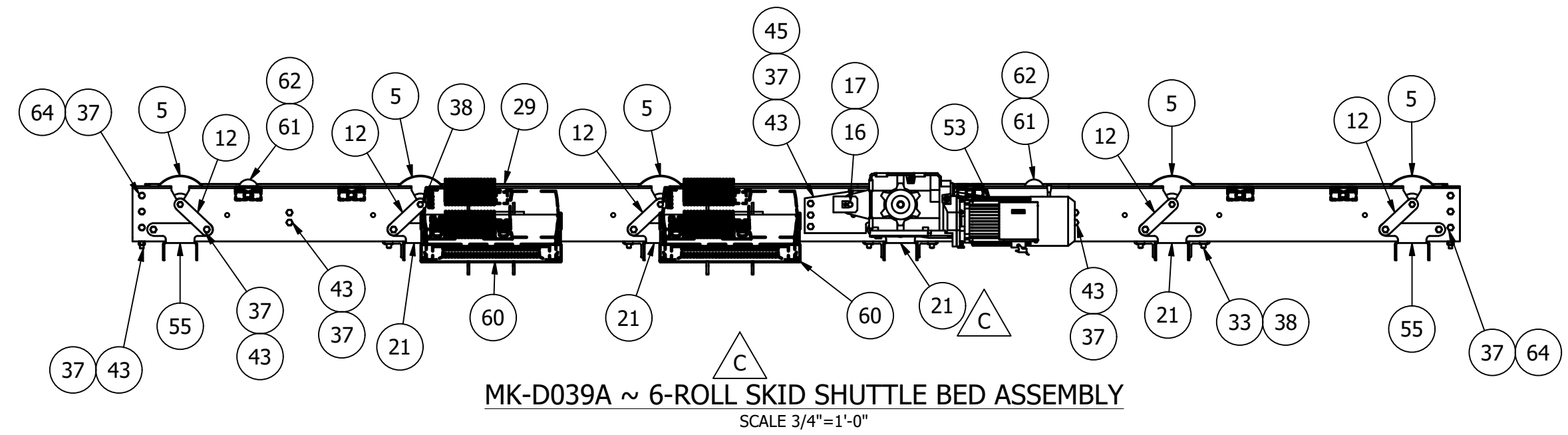
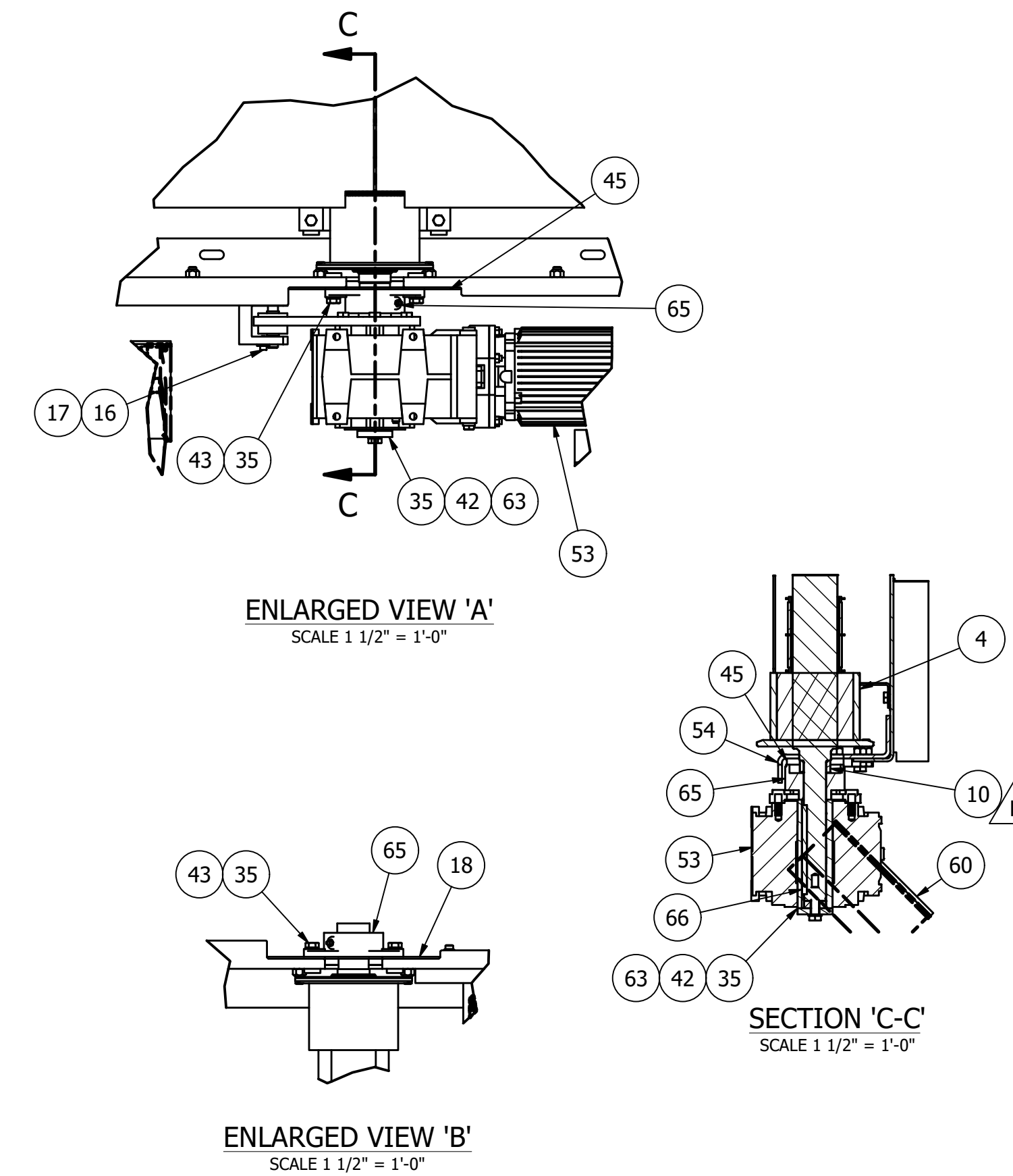
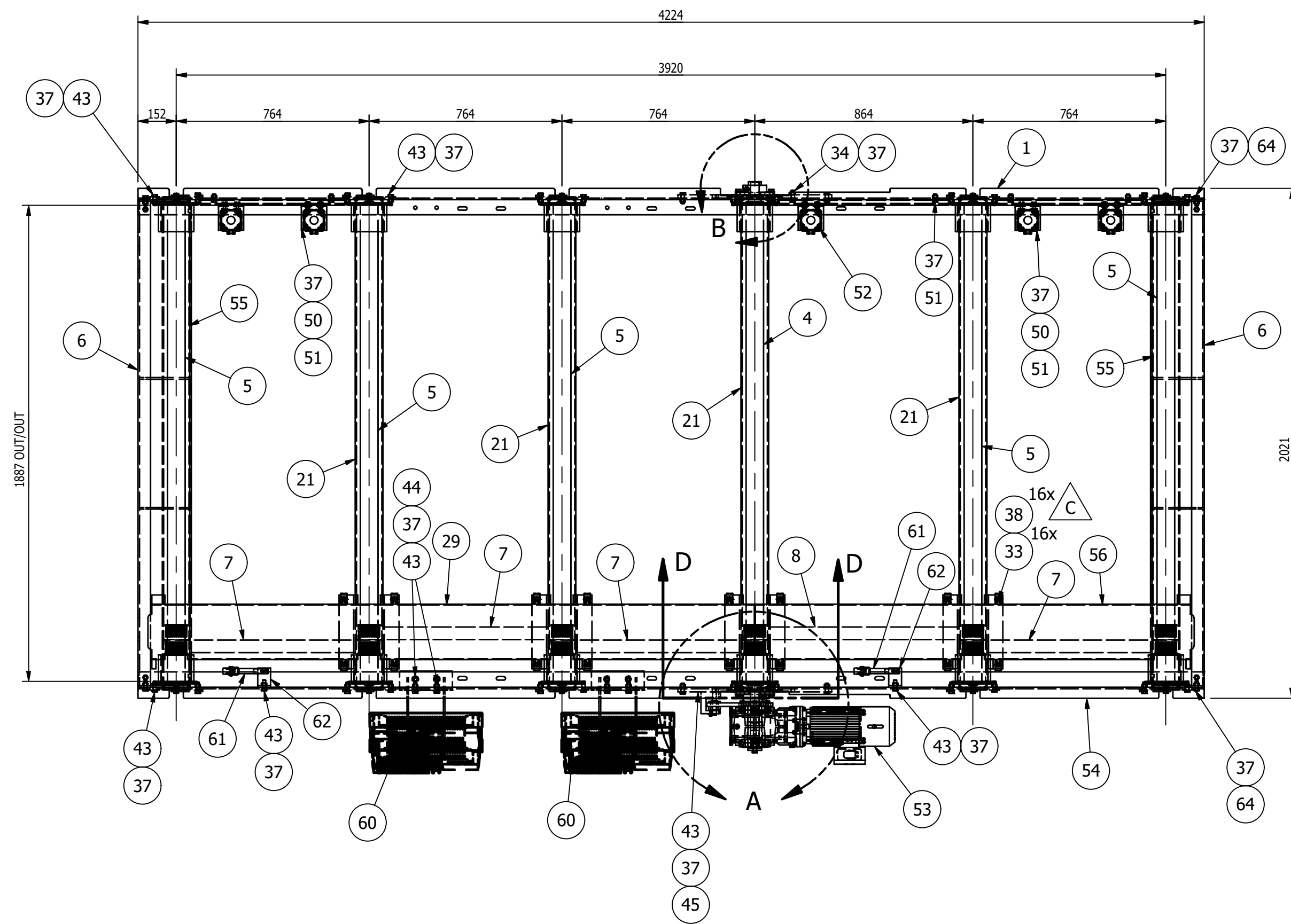
41100 QuakerRoad Rd.
 Suite 125
 West, MI 48375

Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D038

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
 WELDS:
 - ALL WELDS TO BE 'E70XX', (PER AWS D1.1)
 PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D039A			
1	1	MK-D032A ~ 6-ROLL SIDE FRAME ASSY - RH			
4	1	D140/70x8/35 HTD 8M-55 POWER ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVE ROLL, PART NO. 332306W			
5	5	D140/70/30 Z34 HTD 8M-55 DRIVEN ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVE ROLL, PART NO. 329A060W			
6	2	MK-D002A ~ END PLATE ASSEMBLY			
7	4	GATES POWERGRIP GT4 BELT, 1800-8M-GT50		2-5	
8	1	GATES POWERGRIP GT4 BELT, 2000-8M-GT50		2-4	
10	1	MK-D005D ~ SHAFT SPACER			
12	10	MK-D005B ~ ROLL KEEPER			
16	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
17	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
18	1	MK-D005C ~ BEARING PLATE			
21	4	MK-D004C ~ CROSS MEMBER WITH GUARD SUPPORT			
29	1	MK-D010A ~ BELT GUARD			
33	16	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
34	1	M12x1.75 x 40mm LG. HEX CAP SCREW			
35	5	M12 SPRING LOCK WASHER			
37	68	M12 x 1.75 STOVER LOCK NUT			
38	26	M10x1.5 x 25mm LG. HEX CAP SCREW			
40	1	MK-D005E ~ SHAFT SPACER			
42	1	MK-D005F ~ MOTOR END PLATE			
43	55	M12x1.75 x 35mm LG. HEX CAP SCREW			
44	8	M12 NARROW FLAT WASHER			
45	1	MK-D005A ~ BEARING PLATE			
50	2	MK-D009D ~ PROX BRACKET			
51	5	M12x1.75 x 25mm LG. HEX CAP SCREW			
52	1	MK-D009C ~ PROX BRACKET			
53	1	SIEMENS RB2 GEARMOTOR (SEE MOTOR DATA LIST)		1-2	
54	1	MK-D032B ~ 6-ROLL SIDE FRAME ASSY - LH			
55	2	MK-D004E ~ CROSS MEMBER			
56	1	MK-D040A ~ 6-ROLL BELT GUARD			
60	2	MK-D047A ~ CONTROLLER BRACKET			
61	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
62	2	MK-D005G ~ STATIC WHEEL BRACKET			
63	1	M12x1.75 x 45mm LG. HEX CAP SCREW			
64	12	M12x1.75 x 30mm LG. HEX CAP SCREW			
65	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
66	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	

SPEED FORMULA ROLL BED (60HZ):

$$\pi \times 1760 \times \frac{1}{37.18} \times \frac{140}{1000} = 20.8 \text{ m/min} = 68.3 \text{ ft/min}$$

SHOP NOTES:

1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
8. ALL SLOT LENGTHS ARE END TO END U.N.O.

MAGNUM Consulting
 41100 Clarkston Rd.
 Suite 125
 Novi, MI 48225
 Phone: (248) 772-8822
 Fax: (248) 772-8821
 Web: www.mmagnum.com

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
 WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)
 PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	UPDATED DESCRIPTION OF MK-D039A, ADDED BALLOONS	
B	MC	8/30/22	ADDED BALLOON FOR ITEM '10'	
A	MC	8/9/22	FOR FABRICATION	

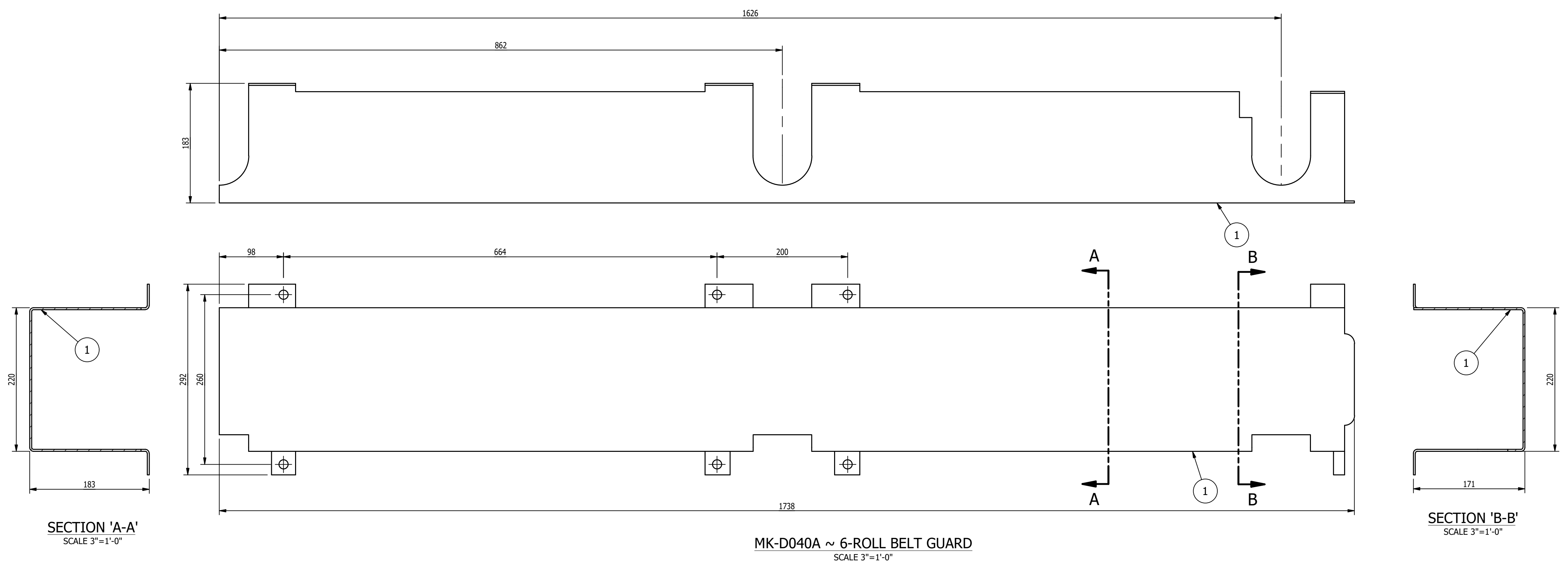
MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millc.com

MILLER INDUSTRIES
 PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.

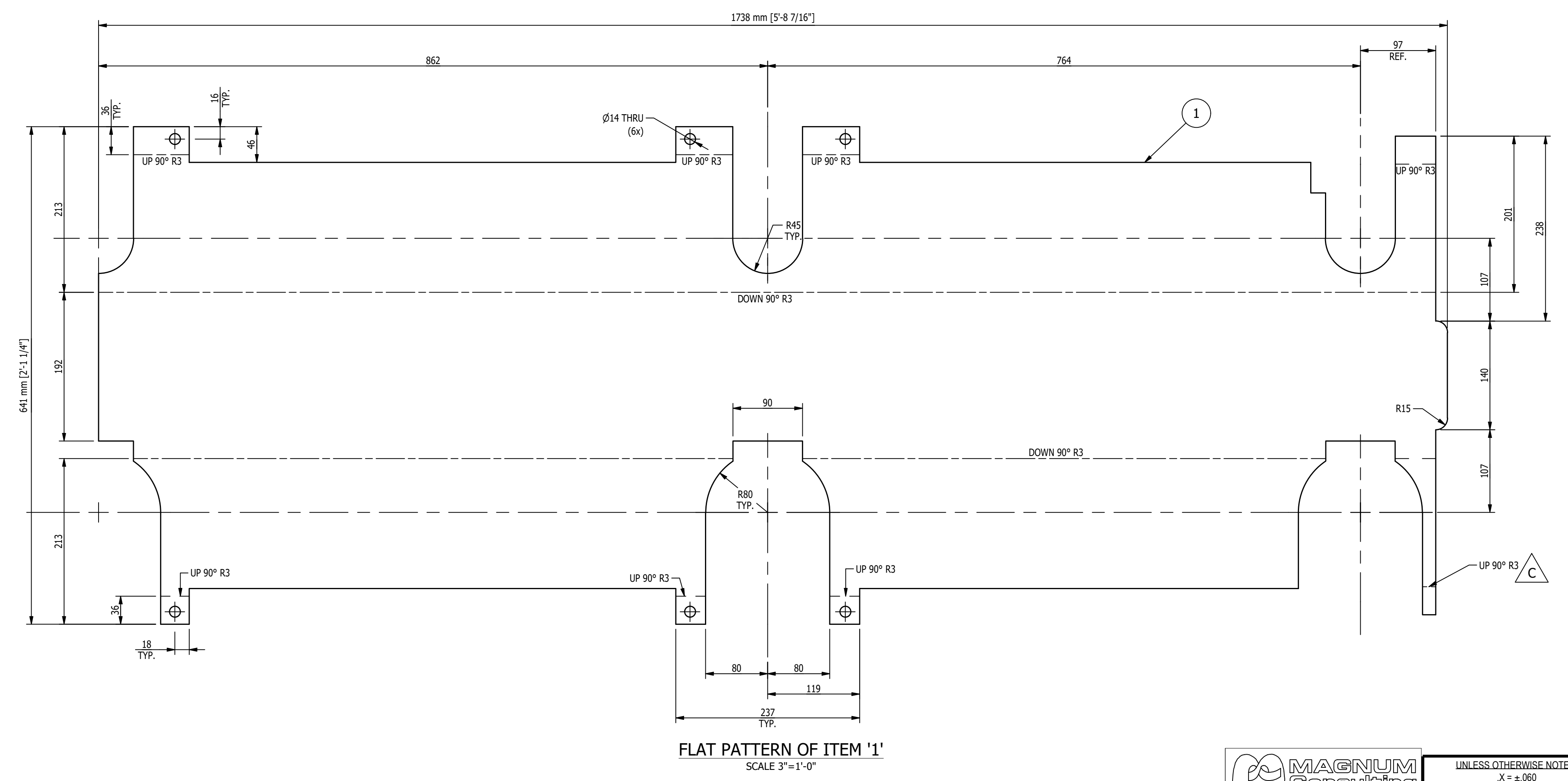
TITLE: **P6700 CONVEYORS CAMPUS BUILDING**
 CLIENT: **VOLVO**
 DRAWING No. **1875D039**
 REV: **C**

DRAWN BY: **RJB**
 CHECKED BY: **CW**
 DWG DATE: **6/27/22**
 JOB No: **22096**

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D040A			
1	1	SHT 11 GA x 2'-1 1/4"	5'-8 7/16"		
TOTAL WEIGHT ~ 45.9 lbs					



MK-D040A ~ 6-ROLL BELT GUARD
SCALE 3"=1'-0"



FLAT PATTERN OF ITEM '1'
SCALE 3"=1'-0"

- SHOP NOTES:**
1. USE E70XX LOW HYD. RODS FOR ALL WELDING U.N.O.
 2. ALL WELDS TO BE 3/16" CONTINUOUS FILLET U.N.O.
 3. ALL STEEL ANGLES, CHANNELS, MC, PLATES, FLATS, ROUNDS & S-SHAPES TO BE ASTM A-36 U.N.O.
 4. ALL STRUCTURAL STEEL WIDE FLANGES AND WIDE FLANGE TEES TO BE ASTM A-992/A-572 GR. 50
 5. ALL FASTENERS TO BE ZINC PLATED U.N.O.
 6. ALL BOLTS TO BE ASTM A-325 U.N.O.
 7. ALL NUTS ARE TO BE ASTM A-194 GR. 2 ANCO LOCK NUTS U.N.O.
 8. ALL WASHERS ARE TO BE ASTM F436 U.N.O.
 9. ALL STEEL TO BE CLEAN OF DIRT, RUST, MILL SCALE, WELD SPLATTER AND DEBURR ALL EDGES PRIOR TO PAINTING.
 10. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 11. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER

ONE SHOP COAT OF PURE ORANGE RAL 2004
OR
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	UPDATED PAINT NOTES & ADDED BEND NOTES	
B	MC	8/30/22	ADDED DIMS TO FLAT PATTERN OF ITEM '1'	
A	MC	8/11/2022	FOR FABRICATION	

REVISION HISTORY

MAGNUM CONSULTING
41100 QuakerRoad Rd.
Suite 125
North, MI 48175
Phone: (248) 773-8822
Fax: (248) 773-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D040

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D040

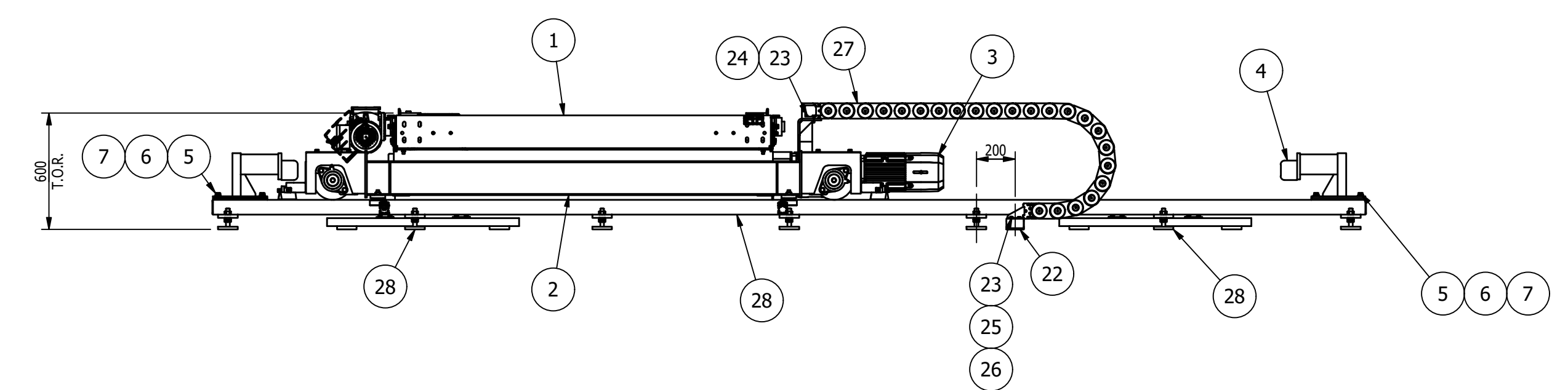
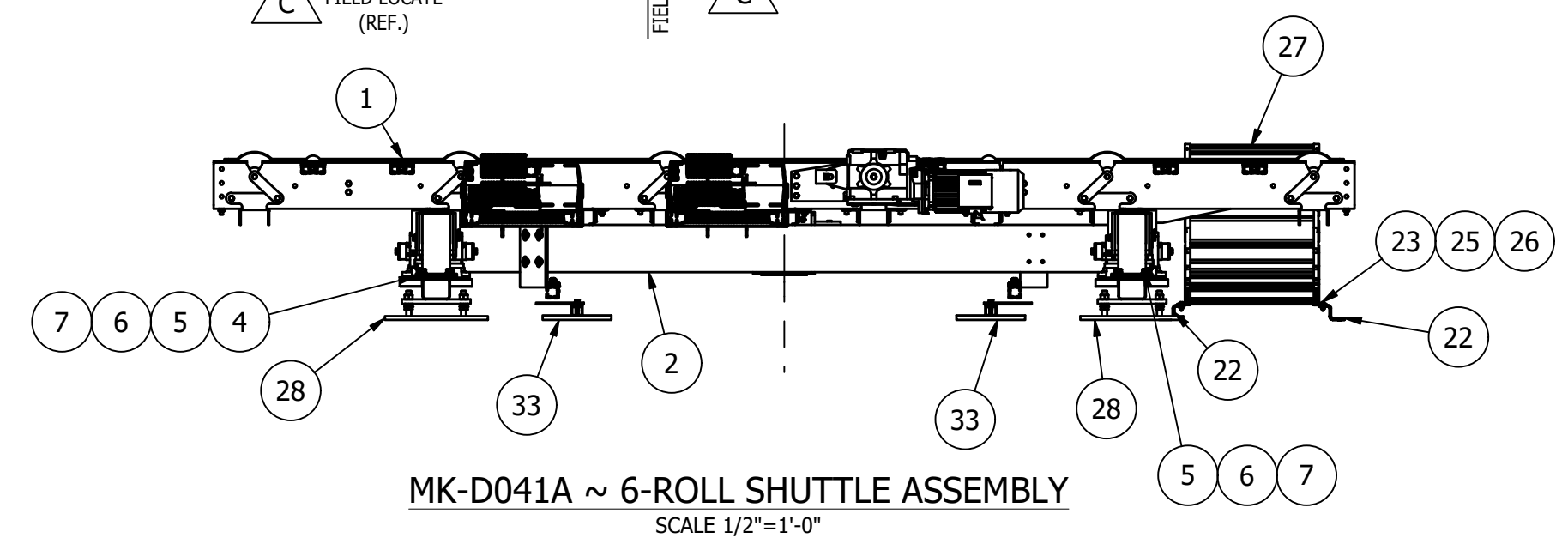
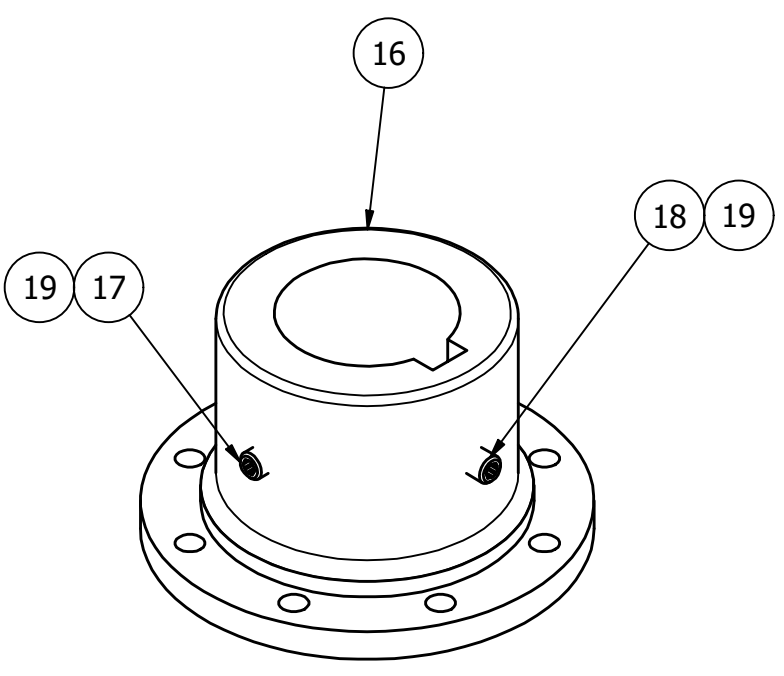
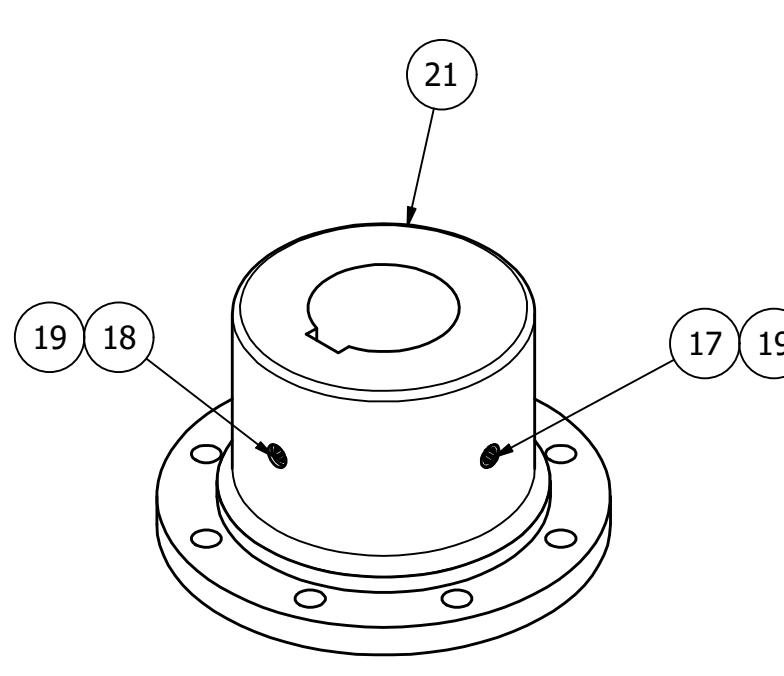
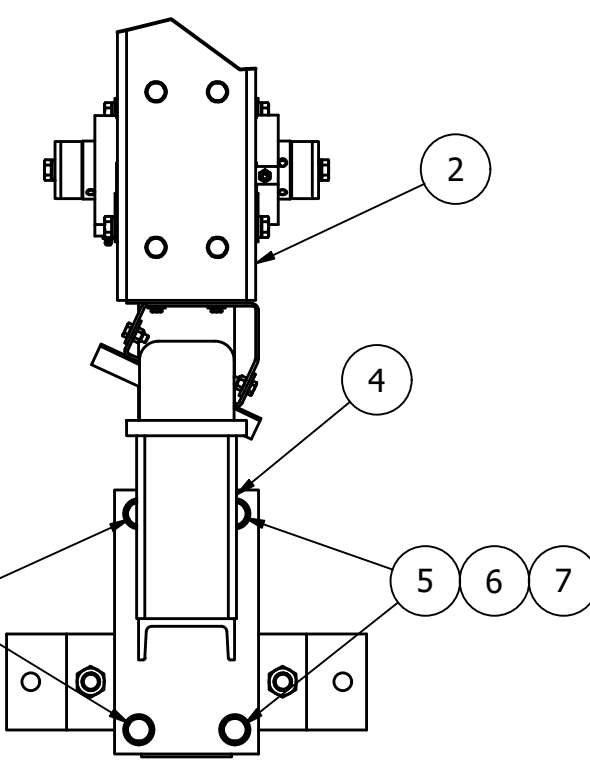
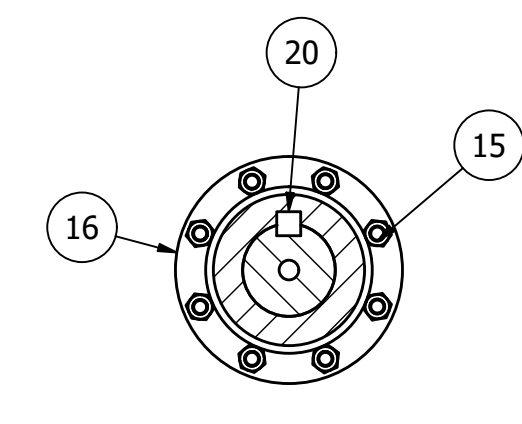
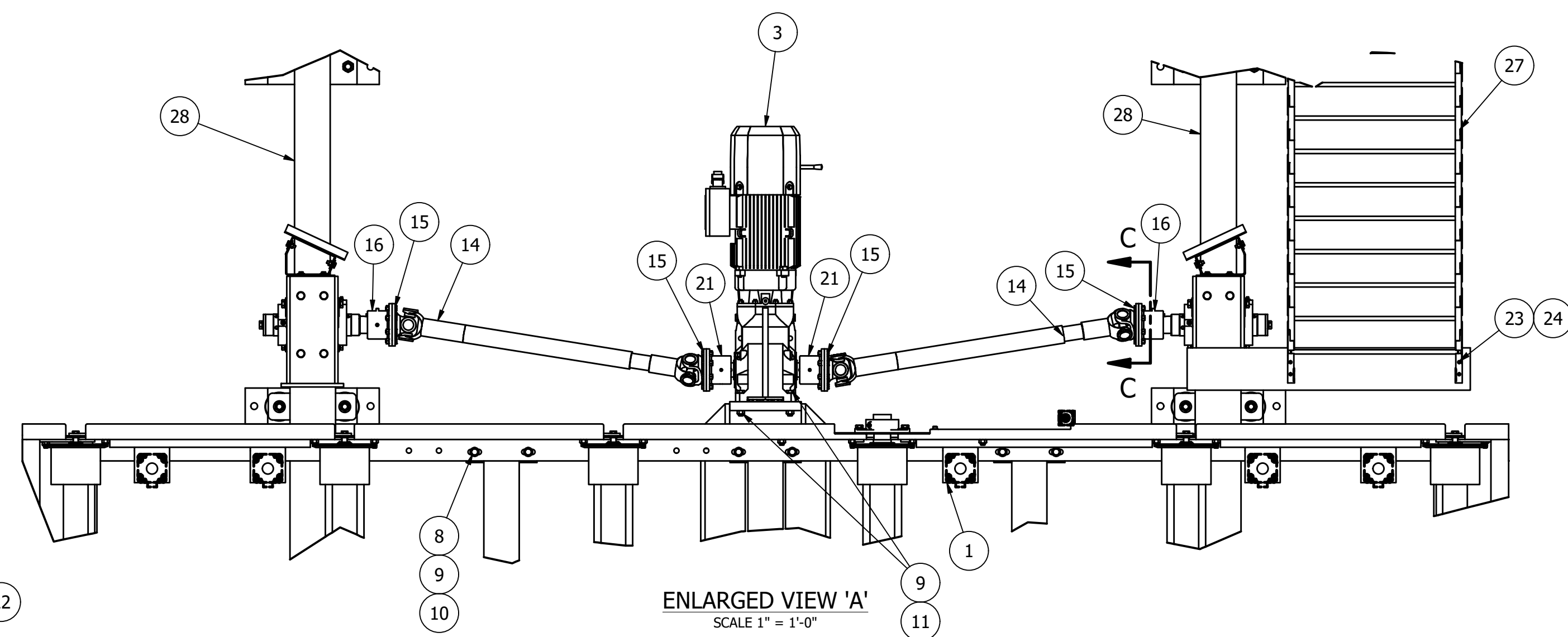
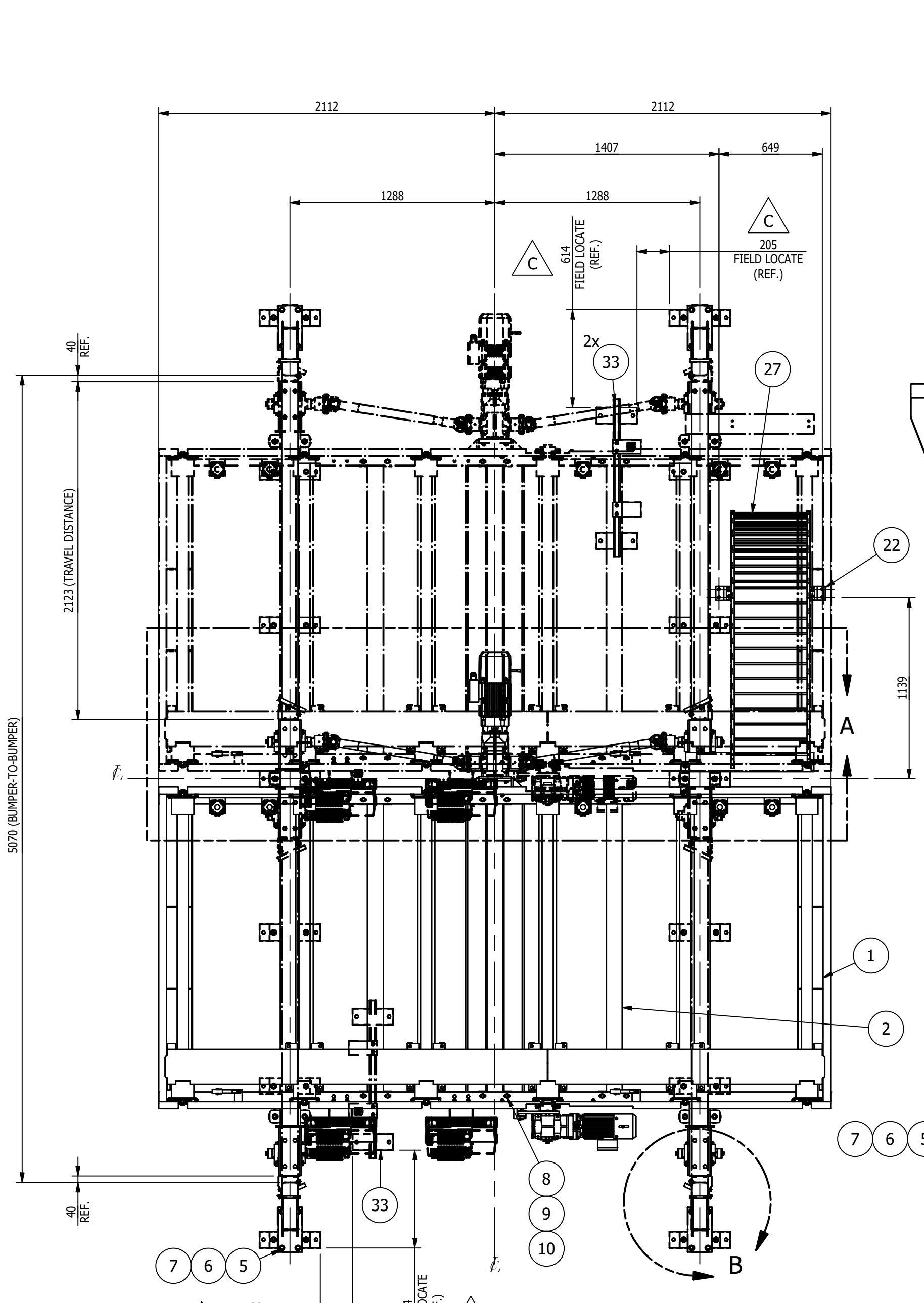
REV: C

JOB No. 22096

DRAWN BY: AH

CHECKED BY: CW

DWG DATE: 6/24/22



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D041A			
1	1	MK-D039A ~ 6-ROLL SKID SHUTTLE BED ASSEMBLY			
2	1	MK-D036A ~ SHUTTLE BASE FRAME ASSEMBLY			
3	1	SH1 GEARMOTOR PER MOTOR DATA SHEET		1-3	
4	4	MK-D044A ~ SHUTTLE BUMPER			
5	16	5/8-11UNC x 1" LG. HEX HEAD CAP SCREW			
6	16	5/8 SPRING LOCK WASHER			
7	16	5/8 TYPE B NARROW FLAT WASHER			
8	24	M12 NARROW FLAT WASHER			
9	16	M12 x 1.75 STOVER LOCK NUT			
10	12	M12x1.75 x 35mm LG. HEX CAP SCREW			
11	4	M12x1.75 x 65mm LG. HEX CAP SCREW			
14	2	ELBE UJOINT TUBE TYPE STD EXT N=36, S=869, X=40, FL=120 8X8MM CNT, PART NO. 0.110.101.6147		15-1	
15	32	M8x1.25x26MM, ELBE BOLT KIT (16 EA), 120 8X8 FLANGE, PART NO. 0.112.192.001		15-3	
16	2	ELBE, 120 8X8 SLF COMPANION FLANGE, BORE 1.937", KEYWAY 0.50 OAL=3", (2) M8 SET SCREWS, PART NO. 1.112.240.6031		15-8	
17	4	ELBE CONE POINT M8x1.25x10MM #90194, PART NO. 1.000.925.6011		15-5	
18	4	ELBE CUP POINT M8x1.25x5MM			
19	8	ELBE OVAL POINT M8x1.25x10MM		15-6	
20	2	1/2 x 1/2 x 3 LG. SQ. KEYSTOCK			
21	2	ELBE, 120 8X8 SLF COMPANION FLANGE, BORE 40H7, KEYWAY 12P9 2SS M8, (2) M8 SET SCREWS, PART NO. 1.112.240.6001		15-7	
22	2	MK-D054A ~ CATRACK SUPPORT BRACKET			
23	8	M6 x 1 STOVER LOCK NUT			
24	4	M6x1 x 30mm LG. HEX SOCKET HEAD CAP SCREW			
25	8	M6 REGULAR FLAT WASHER			
26	4	M6x1 x 25mm LG. HEX CAP SCREW			
27	1	2123 mm TRAVEL KABELSCHLEPP Katrak, MC0950-18.00"-RMS-260 X 22 LINKS + FAA-MU		18-1	
28	2	MK-D043A ~ SHUTTLE TRACK			
33	2	MK-D057A ~ SHUTTLE PROX TARGET			
		TOTAL WEIGHT ~ 4313.7 LBS			

SHOP NOTES:

- ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
- ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
- REMOVE ALL EXPOSED SHARP EDGES AND BURRS
- ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
- ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
- ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
- MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
- ALL SLOT LENGTHS ARE END TO END U.N.O.

NOTE: WORK THIS WITH INSTALLATION DRAWINGS FOR BUMPER, PROX, STOP TRIGGER AND GRAVITY STOP LOCATIONS

SPEED FORMULA SHUTTLE (60HZ):

$$\pi \times 1770 \times \frac{1}{49.31} \times \frac{203.2}{1000} = 22.9 \text{ m/min} = 75.2 \text{ ft/min}$$

SPEED FORMULA ROLL BED (60HZ):

$$\pi \times 1760 \times \frac{1}{37.18} \times \frac{140}{1000} = 20.8 \text{ m/min} = 68.3 \text{ ft/min}$$

SHEET 1 OF 3

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	BALLOON UPDATES, ADDED REVISION HISTORY CHART TO SHEETS 2 AND 3, & FIELD LOCATE DIMENSIONS ADDED TO ITEM '33'	
B	MC	8/30/22	ADDED ITEM '33', UPDATED GEOMETRY PER ITEMS '2', '28', '30', & '32'	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
		FENTON, MI 48430		DRAWING IS THE SOLE PROPERTY	
		PH: 810.373.0322 FAX: 810.373.0326		OF MILLER INDUSTRIES. ANY	
		www.millc.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: RJB		JOB No: 22096	
CLIENT: VOLVO		CHECKED BY: CW			
DRAWING No. 1875D041		DWG DATE: 7/26/22			
REV: C		JOB No: 22096			

MAGNUM CONSULTING
 41100 Clarkston Rd.
 Suite 125
 Novi, MI 48225
 Phone: (248) 772-8822
 Fax: (248) 772-8821
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D041

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

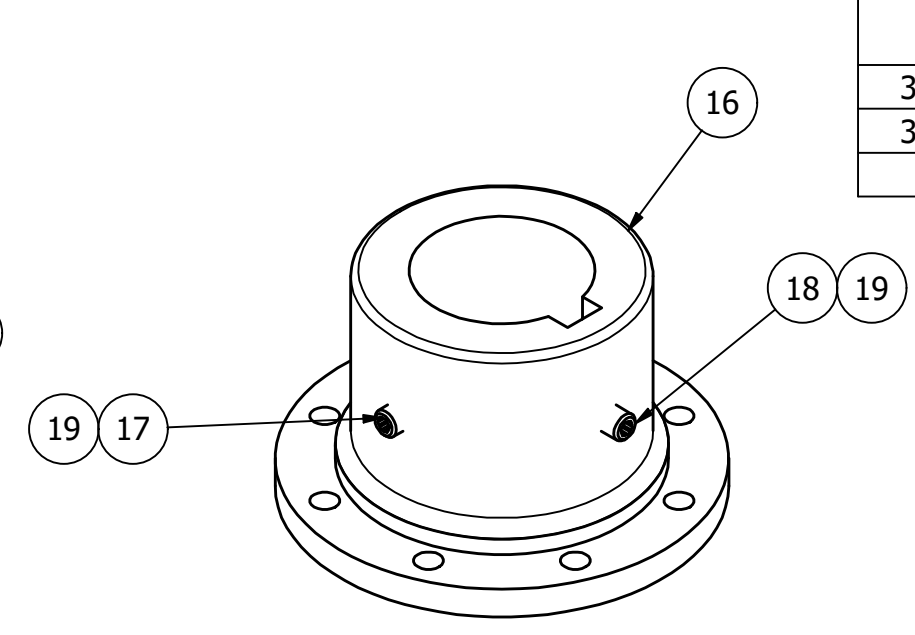
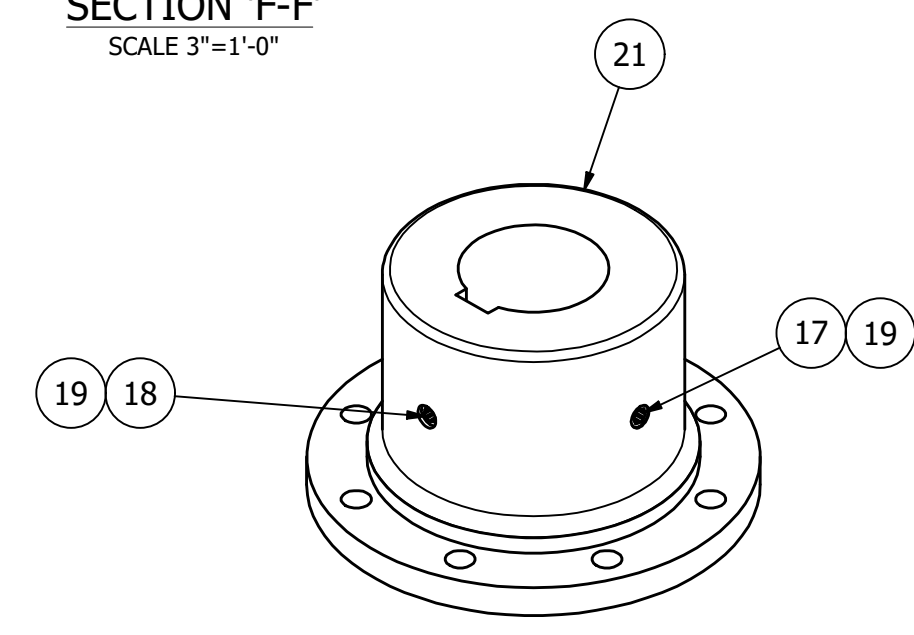
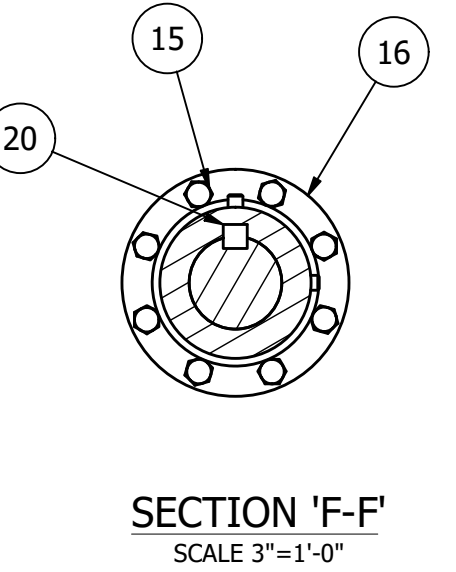
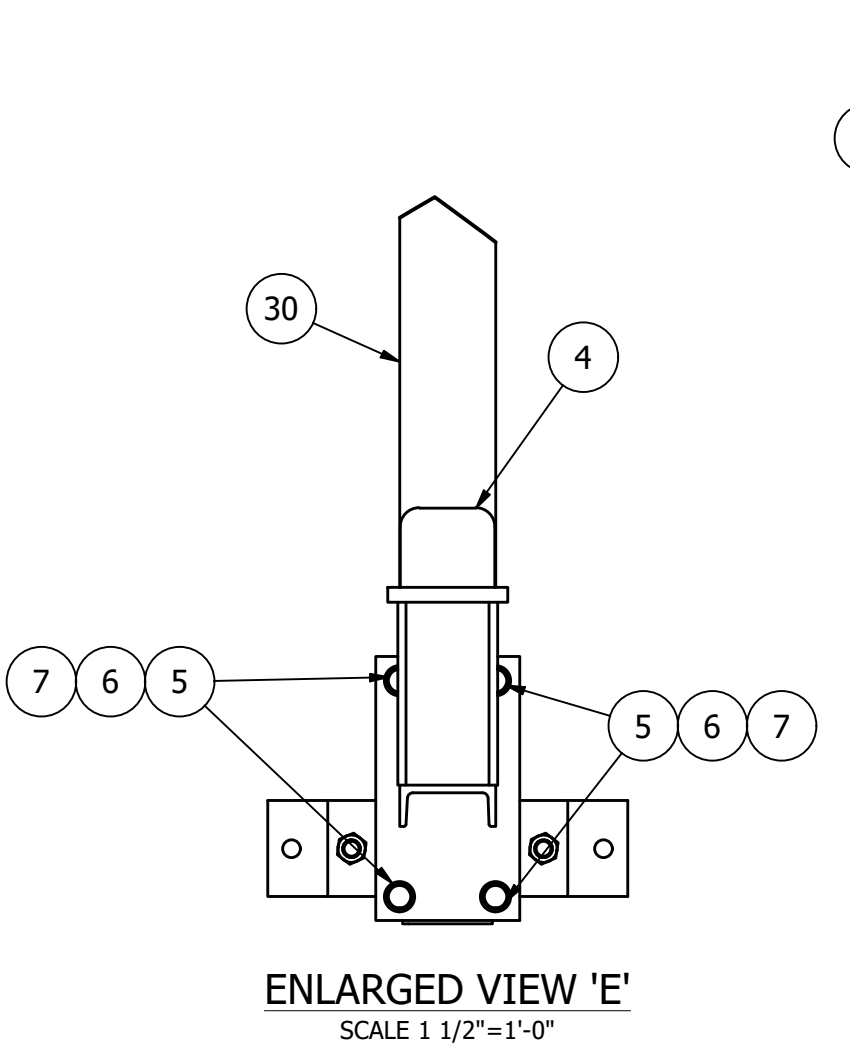
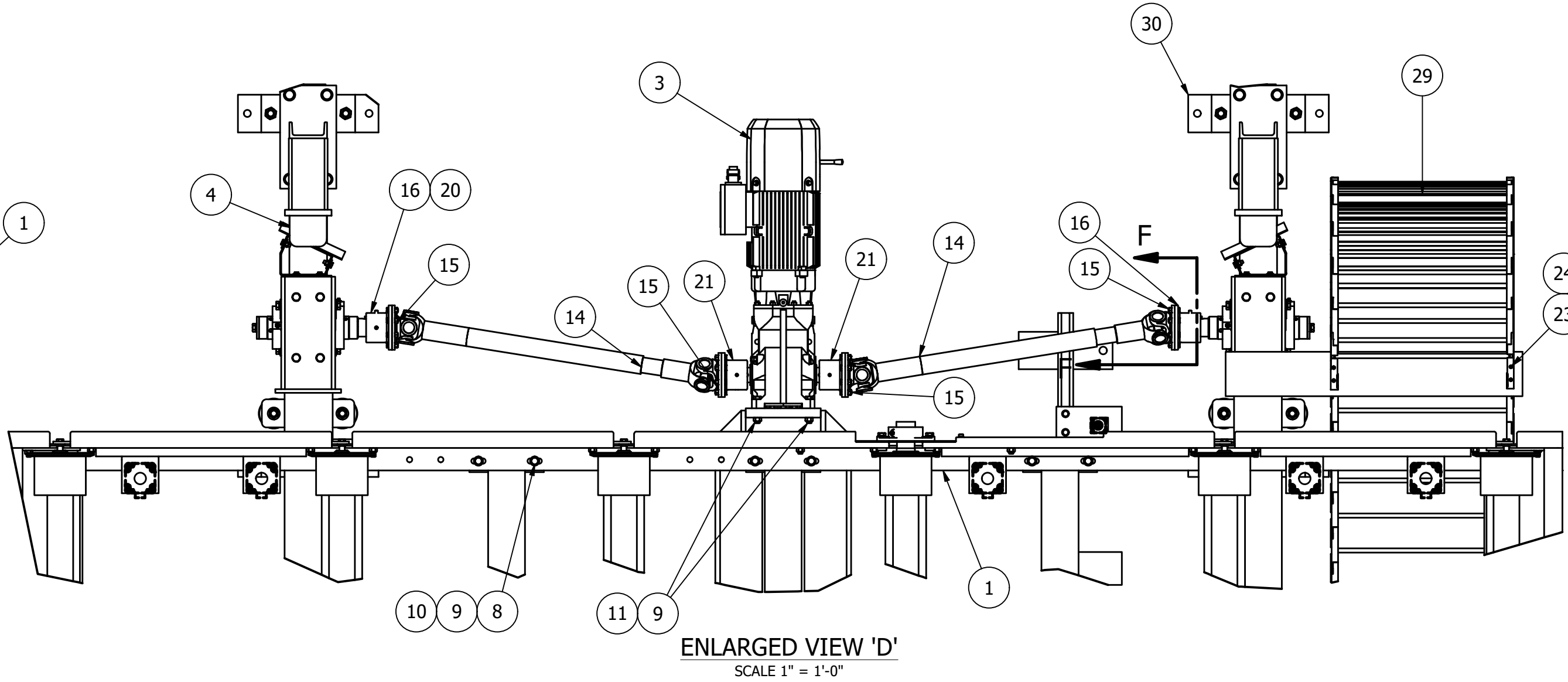
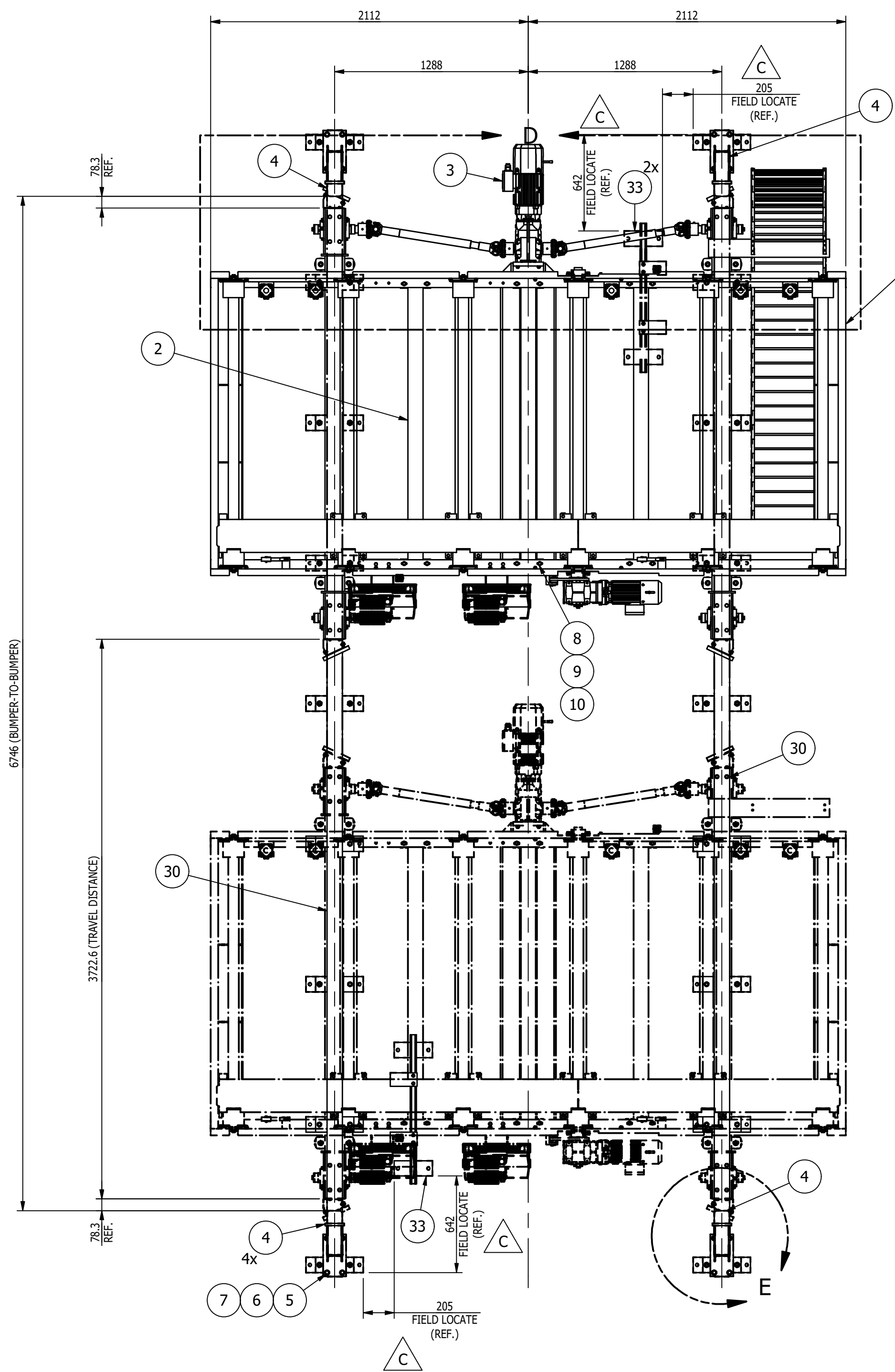
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

3:200 - P6700 New - Add Drawing Details 1875D041



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D041B			
2	1	MK-D039A ~ 6-ROLL SKID SHUTTLE BED ASSEMBLY			
3	1	MK-D036A ~ SHUTTLE BASE FRAME ASSEMBLY			
3	1	SH1 GEARMOTER PER MOTOR DATA SHEET		1-3	
4	4	MK-D044A ~ SHUTTLE BUMPER			
5	16	5/8-11UNC x 1" LG. HEX HEAD CAP SCREW			
6	16	5/8 SPRING LOCK WASHER			
7	16	5/8 TYPE B NARROW FLAT WASHER			
8	24	M12 NARROW FLAT WASHER			
9	16	M12 x 1.75 STOVER LOCK NUT			
10	12	M12x1.75 x 35mm LG. HEX CAP SCREW			
11	4	M12x1.75 x 65mm LG. HEX CAP SCREW			
14	2	ELBE UJOINT TUBE TYPE STD EXT N=36, S=869, X=40, FL=120 8X8MM CNT, PART NO. 0.110.101.6147		15-1	
15	32	M8x1.25x26MM, ELBE BOLT KIT (16 EA), 120 8X8 FLANGE, PART NO. 0.112.192.001		15-3	
16	2	ELBE, 120 8X8 SLF COMPANION FLANGE, BORE 1.937", KEYWAY 0.50 OAL=3", (2) M8 SET SCREWS, PART NO. 1.112.240.6031		15-8	
17	4	ELBE CONE POINT M8x1.25x10MM #90194, PART NO. 1.000.925.6011		15-5	
18	4	ELBE CUP POINT M8x1.25x5MM			
19	8	ELBE OVAL POINT M8x1.25x10MM		15-6	
20	2	1/2 x 1/2 x 3 LG. SQ. KEYSTOCK			
21	2	ELBE, 120 8X8 SLF COMPANION FLANGE, BORE 40H7, KEYWAY 12P9 2SS M8, (2) M8 SET SCREWS, PART NO. 1.112.240.6001		15-7	
22	2	MK-D054A ~ CATRACK SUPPORT BRACKET			
23	8	M6 x 1 STOVER LOCK NUT			
24	4	M6x1 x 30mm LG. HEX SOCKET HEAD CAP SCREW			
25	8	M6 REGULAR FLAT WASHER			
26	4	M6x1 x 25mm LG. HEX CAP SCREW			
29	1	3723 mm TRAVEL KABELSCHLEPP Katrak, MC0950-18.00"-RMS-260 X 32 LINKS + FAA-MU		18-2	
30	2	MK-D045A ~ SHUTTLE TRACK			
33	2	MK-D057A ~ SHUTTLE PROX TARGET			
		TOTAL WEIGHT ~ 4498.7 LBS			

SHOP NOTES:

- ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
- ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
- REMOVE ALL EXPOSED SHARP EDGES AND BURRS
- ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
- ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
- ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
- MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
- ALL SLOT LENGTHS ARE END TO END U.N.O.

NOTE: WORK THIS WITH INSTALLATION DRAWINGS FOR BUMPER, PROX, STOP TRIGGER AND GRAVITY STOP LOCATIONS SPEED FORMULA SHUTTLE (60HZ):

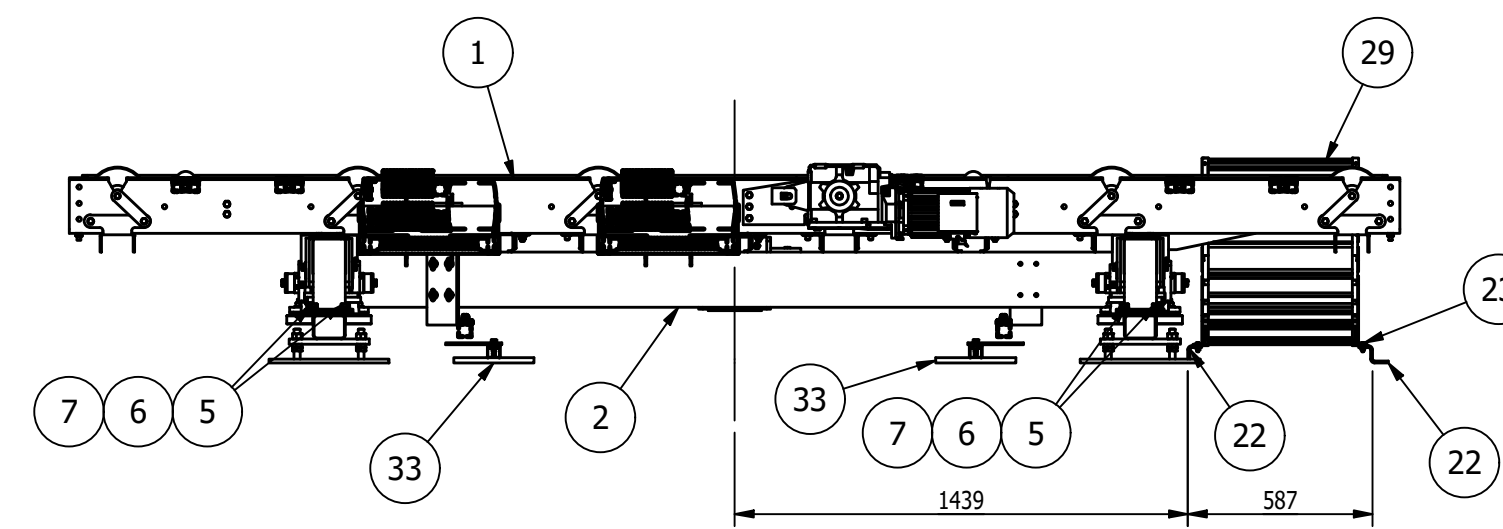
$$\pi \times 1770 \times \frac{1}{49.31} \times \frac{203.2}{1000} = 22.9 \text{ m/min} = 75.2 \text{ ft/min}$$

SPEED FORMULA ROLL BED (60HZ):

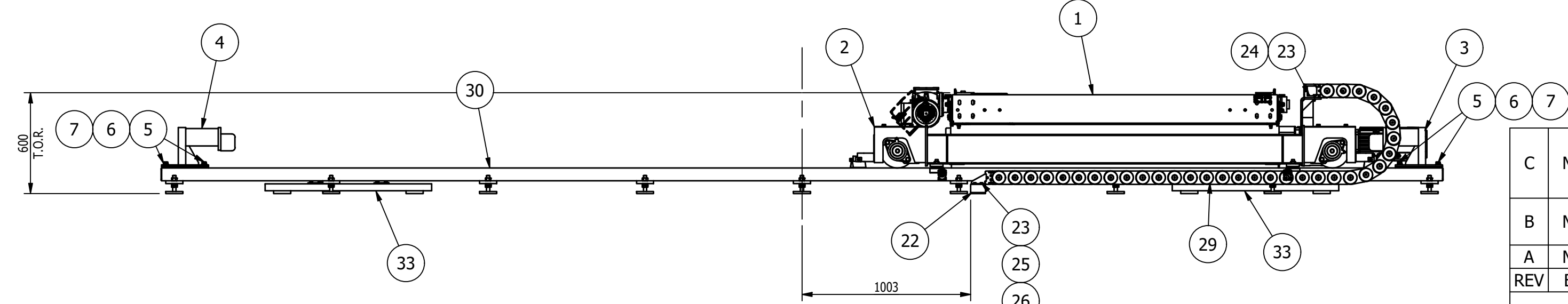
$$\pi \times 1760 \times \frac{1}{37.18} \times \frac{140}{1000} = 20.8 \text{ m/min} = 68.3 \text{ ft/min}$$

SHEET 2 OF 3

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	BALLOON UPDATES, ADDED REVISION HISTORY CHART TO SHEETS 2 AND 3, & FIELD LOCATE DIMENSIONS ADDED TO ITEM '33'	
B	MC	8/30/22	ADDED ITEM '33', UPDATED GEOMETRY PER ITEMS '2', '28', '30', & '32'	
A	MC	8/9/22	FOR FABRICATION	



MK-D041B ~ 6-ROLL SHUTTLE ASSEMBLY
SCALE 1/2"=1'-0"



MAGNUM Consulting
41100 Clarkston Rd.
Suite 125
North, MI 48315
Phone: (248) 773-8800
Fax: (248) 773-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D041

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX". (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REINTRANT CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS
CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No.: 1875D041

REV: C

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 7/26/22
JOB No.: 22096

3/200 - R1875D041.dwg Drawing created 11/25/2021

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D041C			
1	1	MK-D039A ~ 6-ROLL SKID SHUTTLE BED ASSEMBLY			
2	1	MK-D036A ~ SHUTTLE BASE FRAME ASSEMBLY			
3	1	SH1 GEARMOTER PER MOTOR DATA SHEET		1-3	
4	4	MK-D044A ~ SHUTTLE BUMPER			
5	16	5/8-11UNC x 1" LG. HEX HEAD CAP SCREW			
6	16	5/8 SPRING LOCK WASHER			
7	16	5/8 TYPE B NARROW FLAT WASHER			
8	24	M12 NARROW FLAT WASHER			
9	16	M12 x 1.75 STOVER LOCK NUT			
10	12	M12x1.75 x 30mm LG. HEX CAP SCREW			
11	4	M12x1.75 x 65mm LG. HEX CAP SCREW			
14	2	ELBE UJOINT TUBE TYPE STD EXT N=36, S=869, X=40, FL=120 8X8MM CNT, PART NO. 0.110.101.6147		15-1	
15	32	M8x1.25x26MM, ELBE BOLT KIT (16 EA), 120 8X8 FLANGE, PART NO. 0.112.192.001		15-3	
16	2	ELBE, 120 8X8 SLF COMPANION FLANGE, BORE 1.937", KEYWAY 0.50 OAL=3", (2) M8 SET SCREWS, PART NO. 1.112.240.6031		15-8	
17	4	ELBE CONE POINT M8x1.25x10MM #90194, PART NO. 1.000.925.6011		15-5	
18	4	ELBE CUP POINT M8x1.25x5MM			
19	8	ELBE OVAL POINT M8x1.25x10MM		15-6	
20	2	1/2 x 1/2 x 3 LG. SQ. KEYSTOCK			
21	2	ELBE, 120 8X8 SLF COMPANION FLANGE, BORE 40H7, KEYWAY 12P9 2SS M8, (2) M8 SET SCREWS, PART NO. 1.112.240.6001		15-7	
22	2	MK-D054A ~ CATRACK SUPPORT BRACKET			
23	8	M6 x 1 STOVER LOCK NUT			
24	4	M6x1 x 30mm LG. HEX SOCKET HEAD CAP SCREW			
25	8	M6 REGULAR FLAT WASHER			
26	4	M6x1 x 25mm LG. HEX CAP SCREW			
31	1	5744 mm TRAVEL KABELSCHLEPP Katrak, MC0950-18.00"-RMS-260 X 42 LINKS + FAA-MU		18-3	
32	2	MK-D046A ~ SHUTTLE TRACK			
33	2	MK-D057A ~ SHUTTLE PROX TARGET			
		TOTAL WEIGHT ~ 4849.1 LBS			

SHOP NOTES:

- ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
- ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
- REMOVE ALL EXPOSED SHARP EDGES AND BURRS
- ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
- ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
- ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
- MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
- ALL SLOT LENGTHS ARE END TO END U.N.O. NOTE: WORK THIS WITH INSTALLATION DRAWINGS FOR BUMPER, PROX, STOP TRIGGER AND GRAVITY STOP LOCATIONS

SPEED FORMULA SHUTTLE (60HZ):

$$\pi \times 1770 \times \frac{1}{49.31} \times \frac{203.2}{1000} = 22.9 \text{ m/min} = 75.2 \text{ ft/min}$$

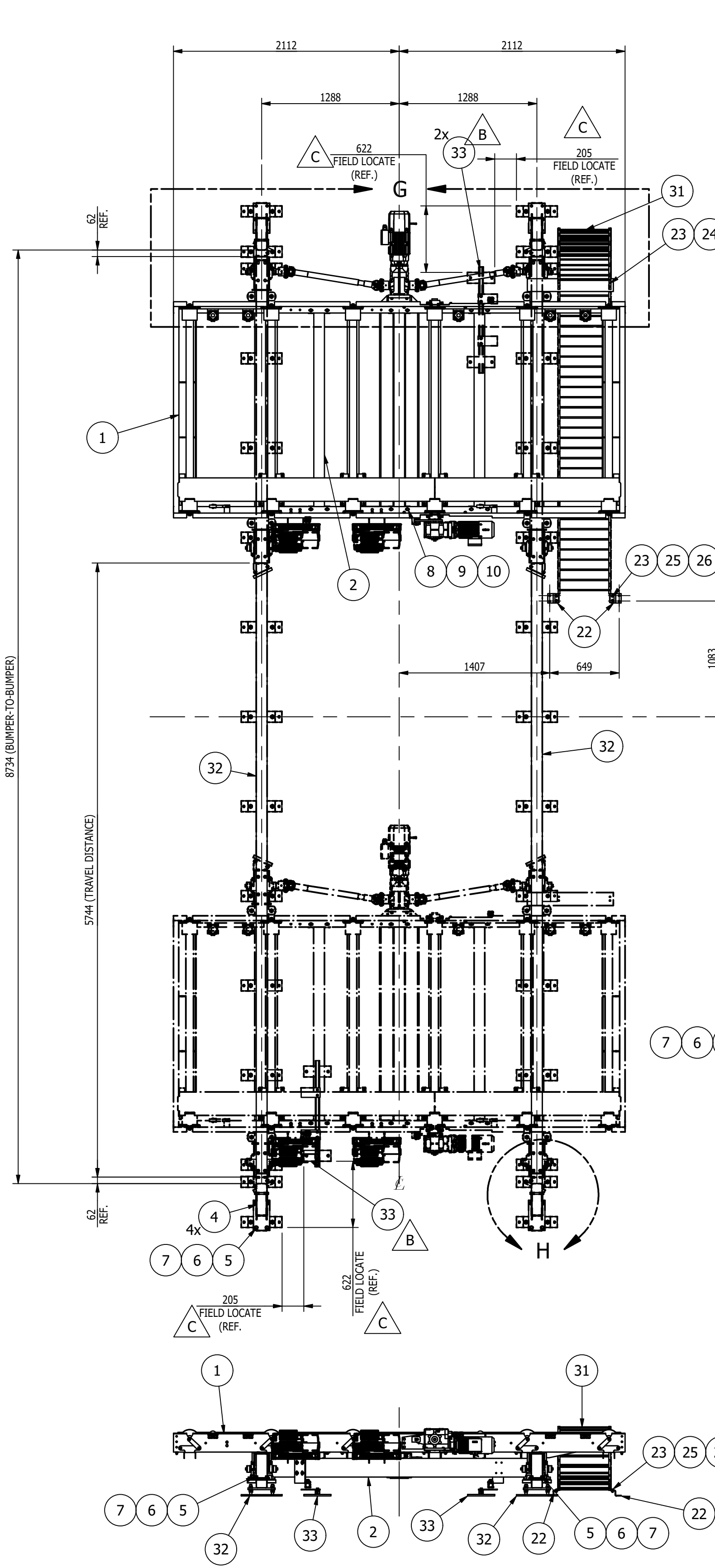
SPEED FORMULA ROLL BED (60HZ):

$$\pi \times 1760 \times \frac{1}{37.18} \times \frac{140}{1000} = 20.8 \text{ m/min} = 68.3 \text{ ft/min}$$

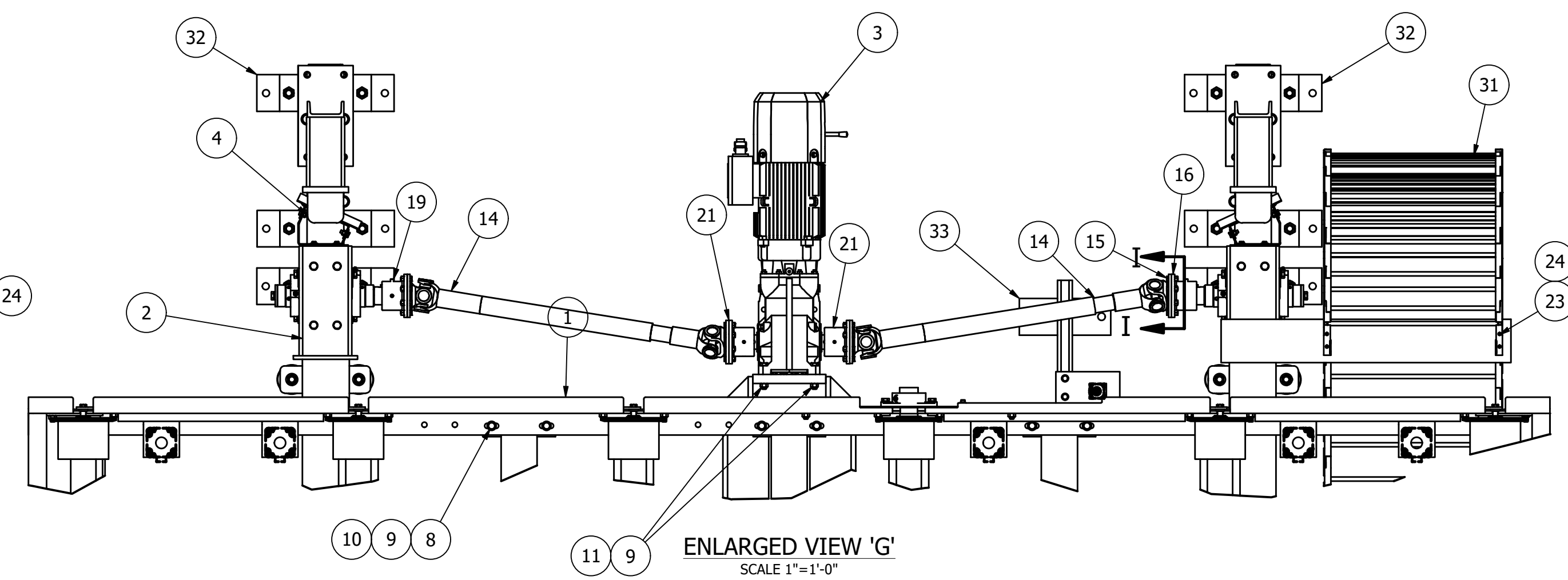
SHEET 3 OF 3

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	BALLOON UPDATES, ADDED REVISION HISTORY CHART TO SHEETS 2 AND 3, & FIELD LOCATE DIMENSIONS ADDED TO ITEM '33'	
B	MC	8/30/22	ADDED ITEM '33', UPDATED GEOMETRY PER ITEMS '2', '28', '30', & '32'	
A	MC	8/9/22	FOR FABRICATION	

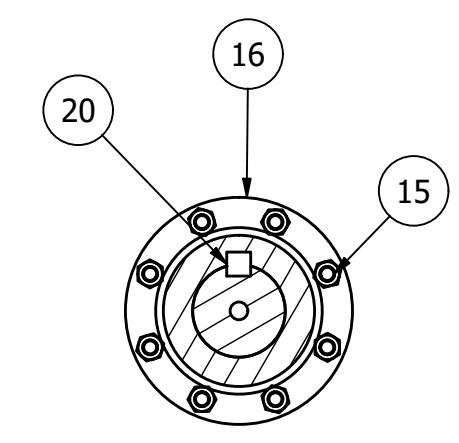
REVISION HISTORY	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING
CLIENT:	VOLVO
DRAWING No.	1875D041
REV:	C
DRAWN BY:	RJB
CHECKED BY:	CW
DWG DATE:	7/26/22
JOB No.:	22096



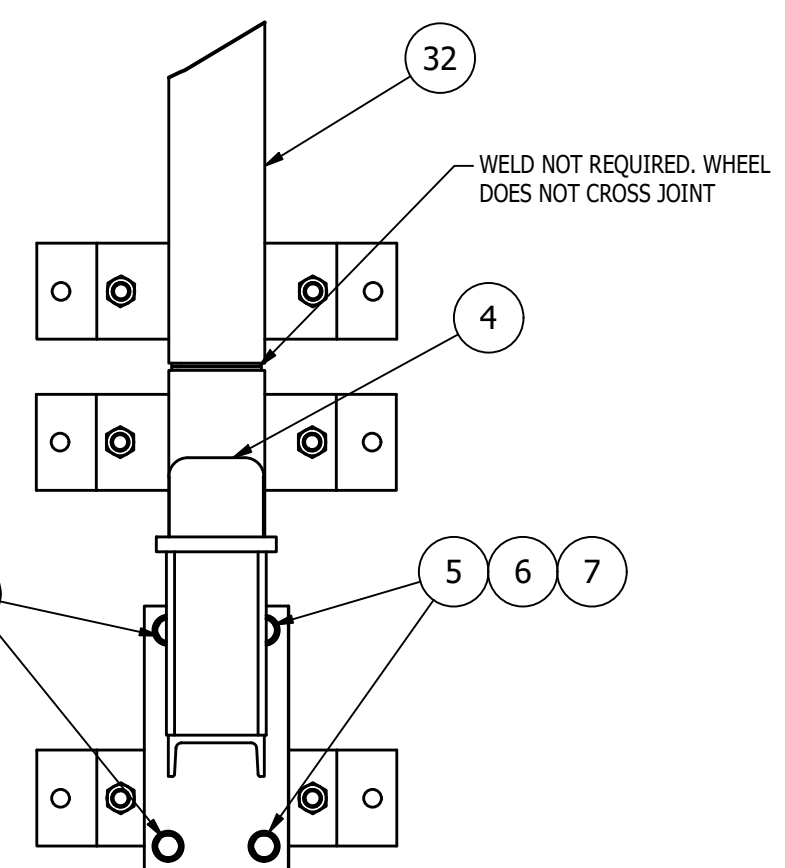
MK-D041C ~ 6-ROLL SHUTTLE ASSEMBLY
SCALE 3/8"=1'-0"



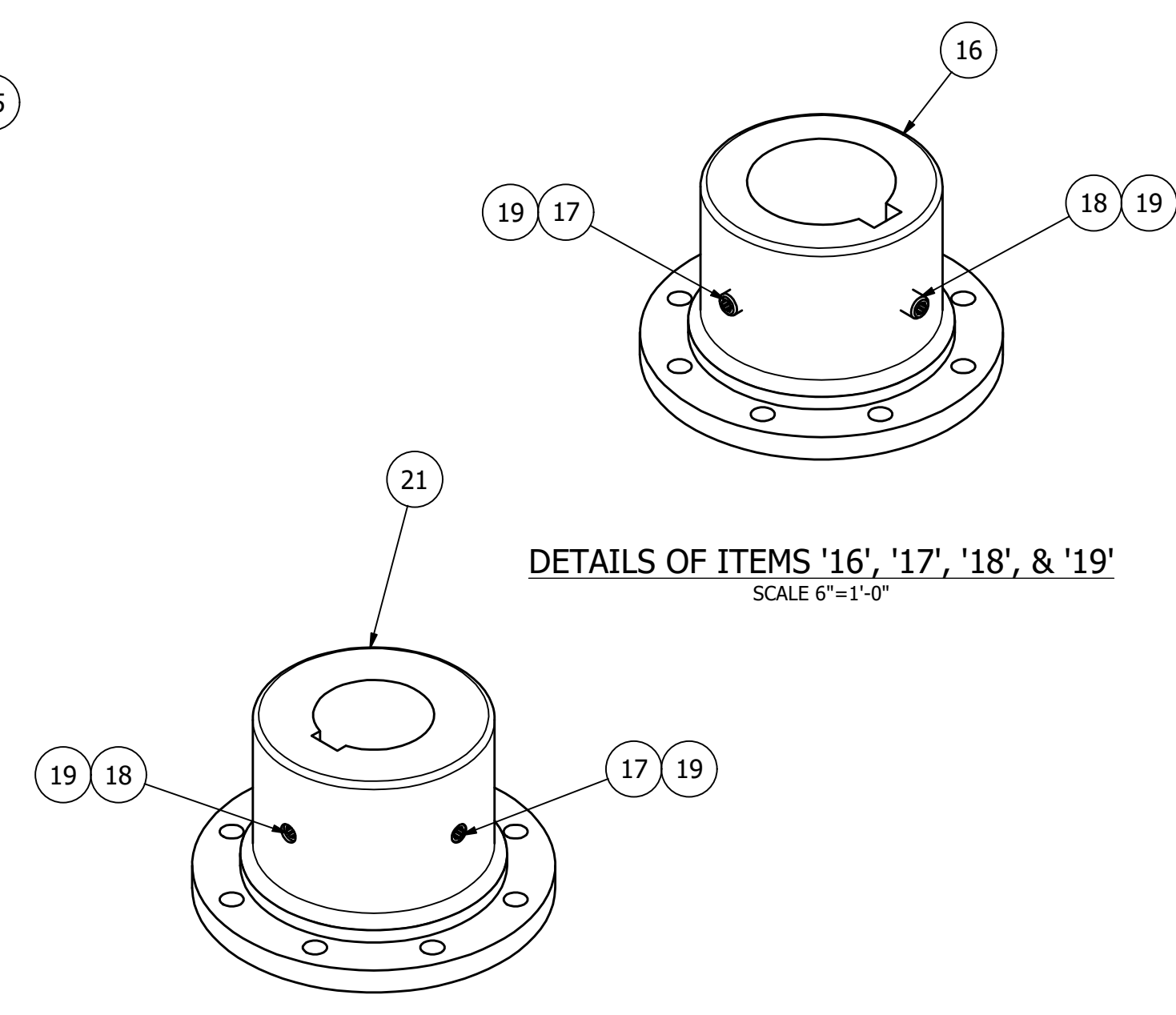
ENLARGED VIEW 'G'
SCALE 1"=1'-0"



SECTION 'I-I'
SCALE 3"=1'-0"

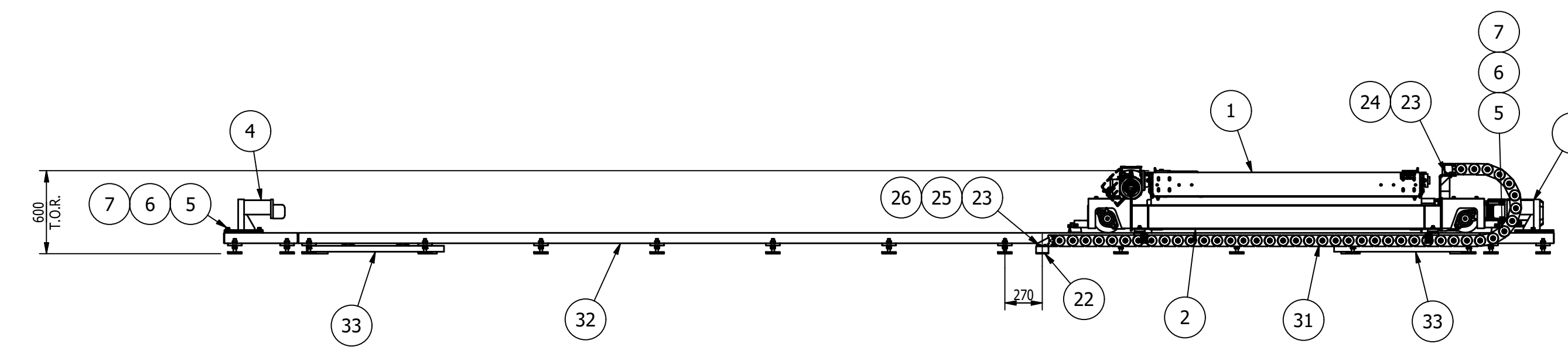


ENLARGED VIEW 'H'
SCALE 1 1/2"=1'-0"



DETAILS OF ITEMS '16', '17', '18', & '19'
SCALE 6"=1'-0"

DETAILS OF ITEMS '17', '18', '19', & '21'
SCALE 6"=1'-0"



GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX". (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REINTRANT CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MAGNUM Consulting

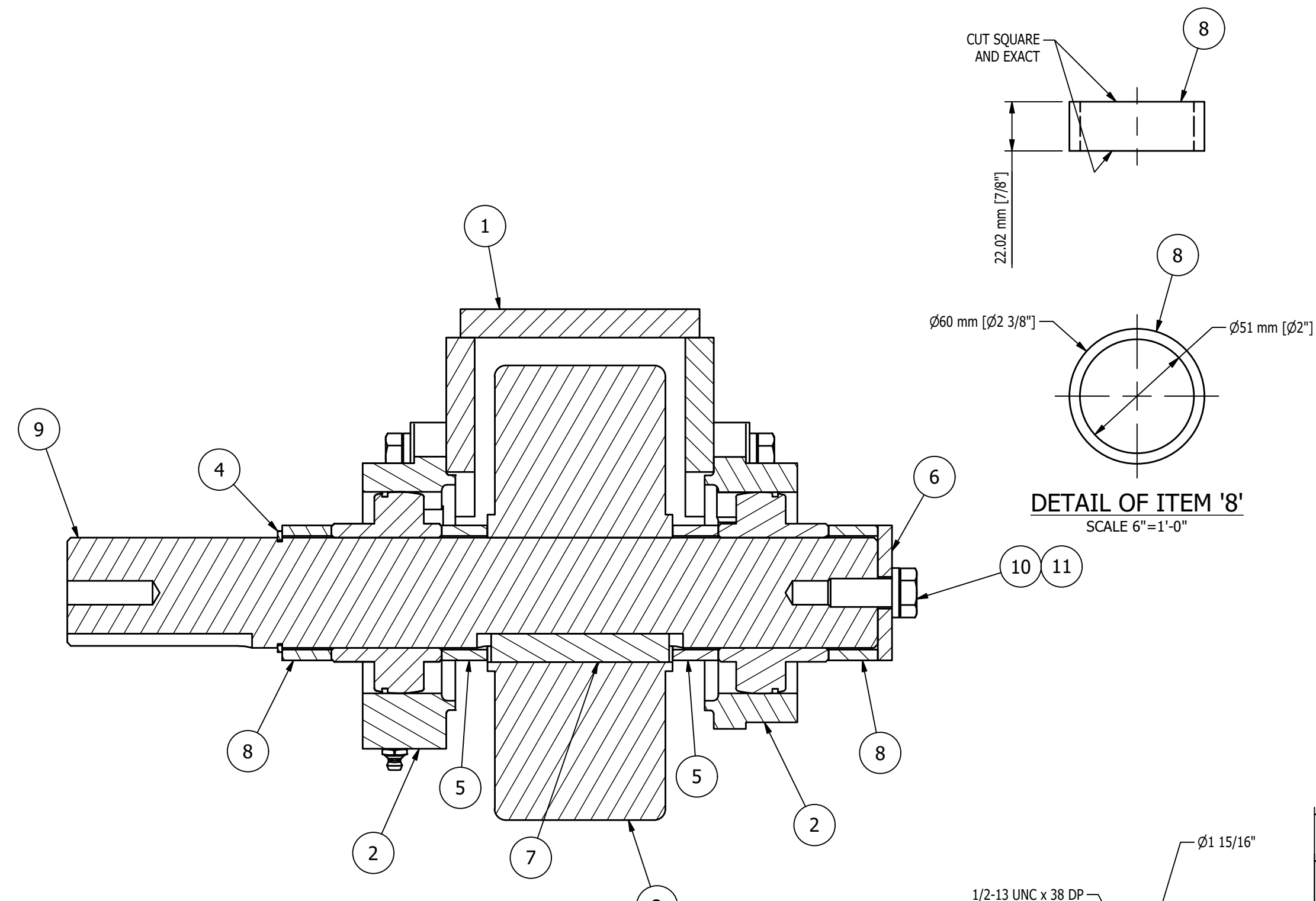
4170 Gardenbrook Rd.
Suite 125
North, MI 48135

Phone: (248) 773-8000
Fax: (248) 773-8001
Web: www.48magnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D041

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

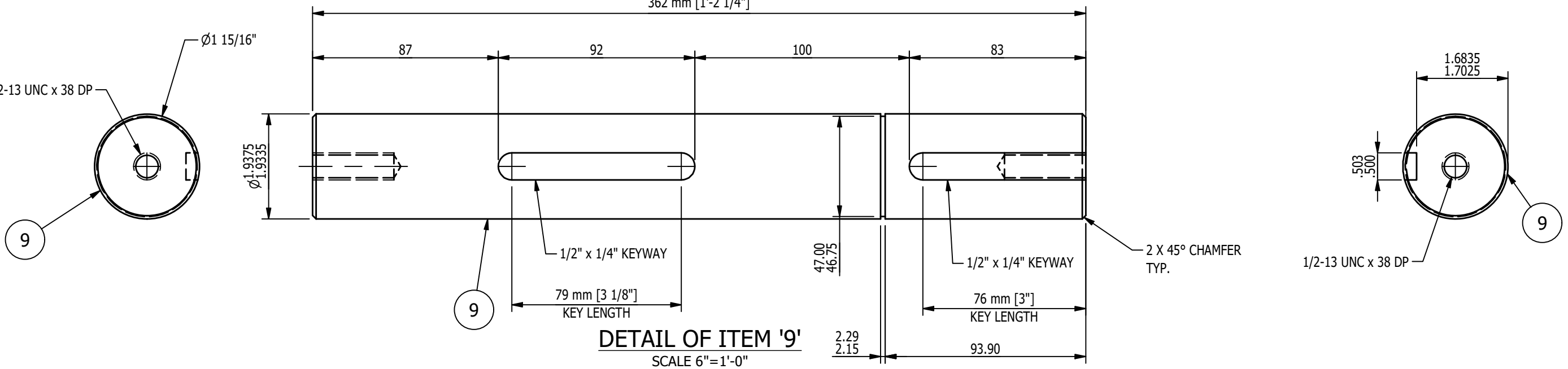
3:00p 1875D041 Rev. 08/26/22



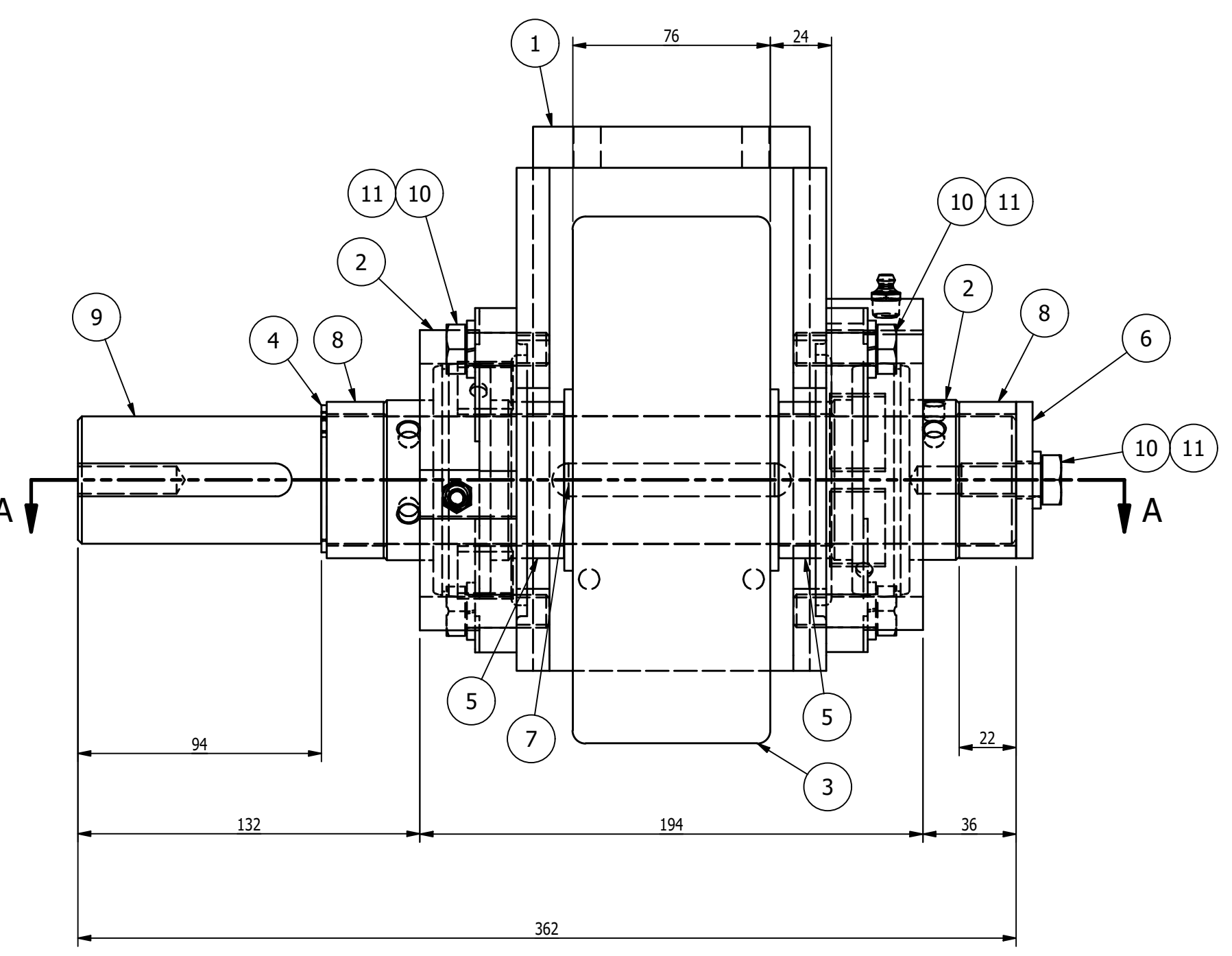
MK-D042A ~ SHUTTLE DRIVE WHEEL ASSEMBLY - RH
SCALE 3"=1'-0"

MK-D042B ~ SHUTTLE DRIVE WHEEL ASSEMBLY - LH
SCALE 3"=1'-0"

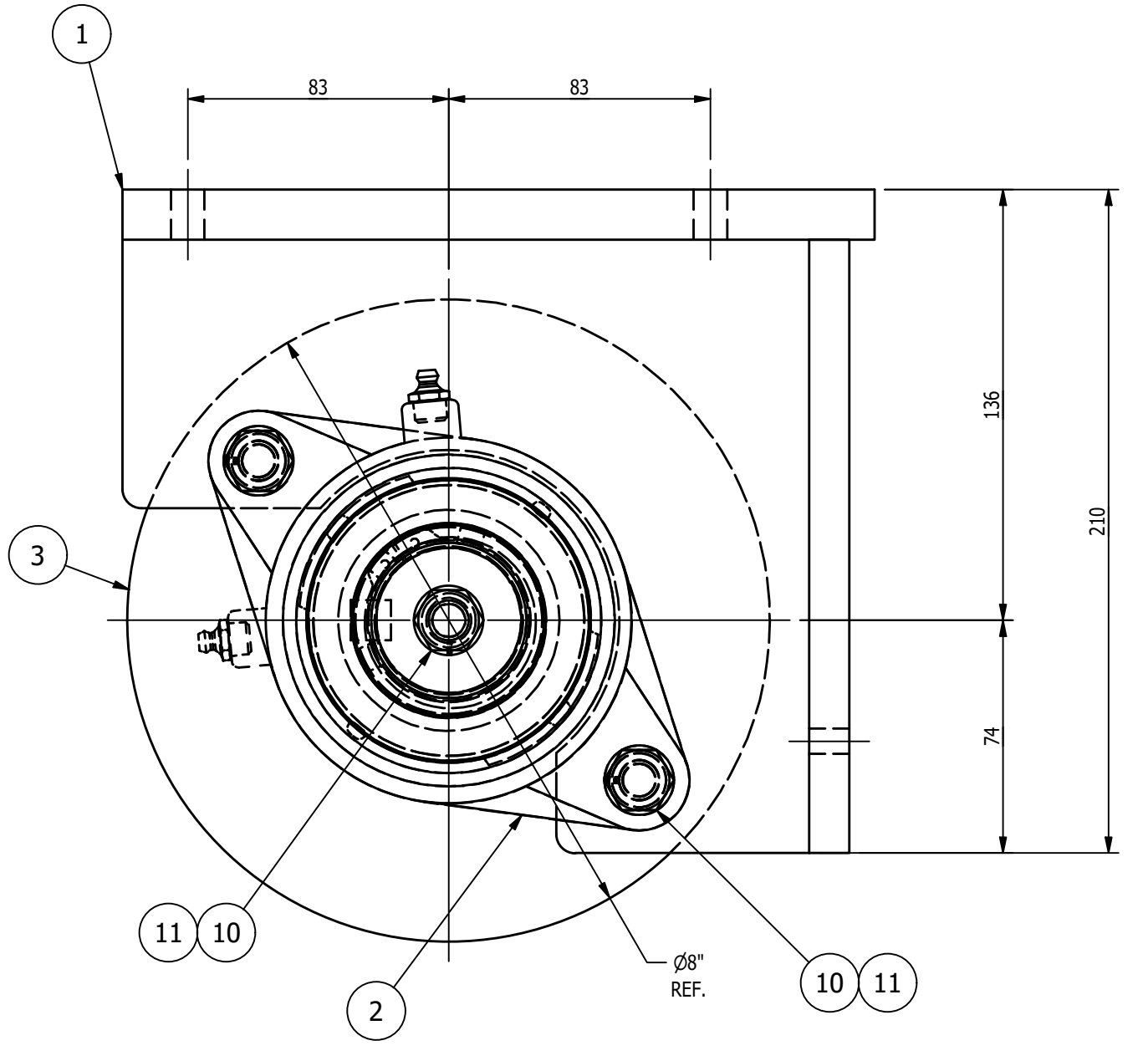
SECTION 'A-A'
SCALE 6"=1'-0"



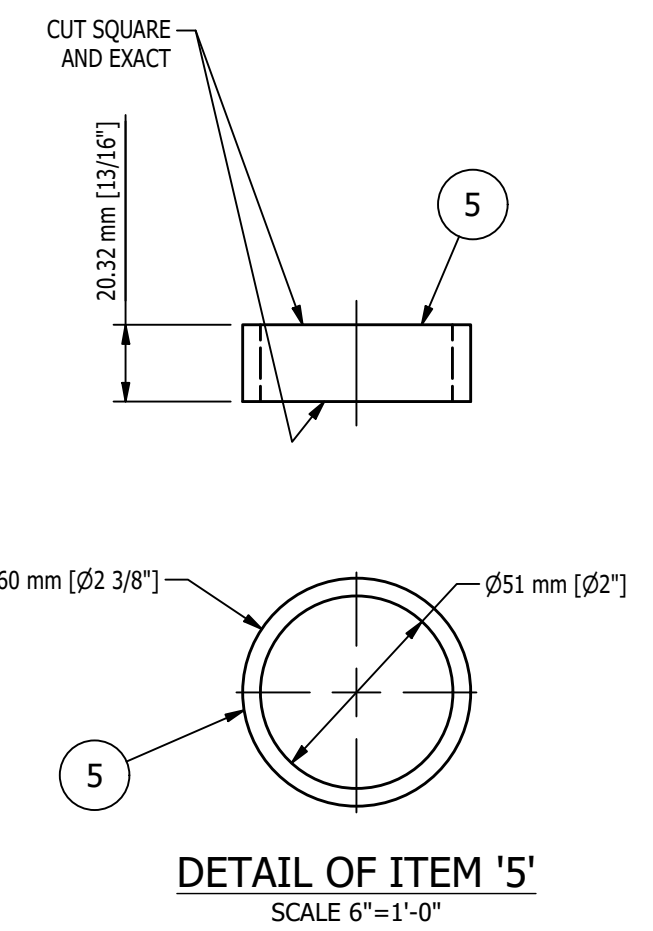
DETAIL OF ITEM '9'
SCALE 6"=1'-0"



MK-D042A ~ SHUTTLE DRIVE WHEEL ASSEMBLY - RH (SHOWN)
MK-D042B ~ SHUTTLE DRIVE WHEEL ASSEMBLY - LH (OPPOSITE)
SCALE 6"=1'-0"



DETAIL OF ITEM '6'
SCALE 6"=1'-0"



DETAIL OF ITEM '5'
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D042A			
1	1	MK-D020B ~ WHEEL HOUSING			
2	2	DODGE SET SCREW TWO-BOLT SC FLANGE BEARING 1 15/16" BORE, F2BZ-SC-115 PART NO. 056845		6-7	
3	1	CASTER CONCEPTS WHEEL, 8" OD POLYURETHANE x 3" WIDE, 3.25" LTB, 2500 LB. MAX, PART NO. CNV04070102		6-5	
4	1	EXTERNAL RETAINING RING FOR 50MM OD, MCMaster CARR PART NO. 98541A167		11-2	
5	2	TS 2 3/8 OD x 3/16 DOM	13/16"		
6	1	PL 1/4 x 2 3/8"	2 3/8"		
7	1	1/2 SQ. KEY STOCK	3 1/8"		
8	2	TS 2 3/8 OD x 3/16 DOM	7/8"		
9	1	BAR Ø1 15/16 (1045 CRS)	1'-2 1/4"		
10	5	1/2 SPRING LOCK WASHER			
11	5	1/2-13UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
		MK-D042B			
1	1	MK-D020B ~ WHEEL HOUSING			
2	2	DODGE SET SCREW TWO-BOLT SC FLANGE BEARING 1 15/16" BORE, F2BZ-SC-115 PART NO. 056845		6-7	
3	1	CASTER CONCEPTS WHEEL, 8" OD POLYURETHANE x 3" WIDE, 3.25" LTB, 2500 LB. MAX, PART NO. CNV04070102		6-5	
4	1	EXTERNAL RETAINING RING FOR 50MM OD, MCMaster CARR PART NO. 98541A167		11-2	
5	2	TS 2 3/8 OD x 3/16 DOM	13/16"		
6	1	PL 1/4 x 2 3/8"	2 3/8"		
7	1	1/2 SQ. KEY STOCK	3 1/8"		
8	2	TS 2 3/8 OD x 3/16 DOM	7/8"		
9	1	BAR Ø1 15/16 (1045 CRS)	1'-2 1/4"		
10	5	1/2 SPRING LOCK WASHER			
11	5	1/2-13UNC x 1 1/4" LG. HEX HEAD CAP SCREW			

- SHOP NOTES:**
- ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 - ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 - REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 - ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 - ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 - ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 - MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 - ALL SLOT LENGTHS ARE END TO END U.N.O.
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/30/22	FLIPPED ITEM '2'	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY

B	MC	8/30/22	FLIPPED ITEM '2'	
A	MC	8/9/22	FOR FABRICATION	

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D042

REV: B

JOB No. 22096

DRAWN BY: RJB

CHECKED BY: CW

DWG DATE: 6/29/22

MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
Northville, MI 48165

Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D042

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

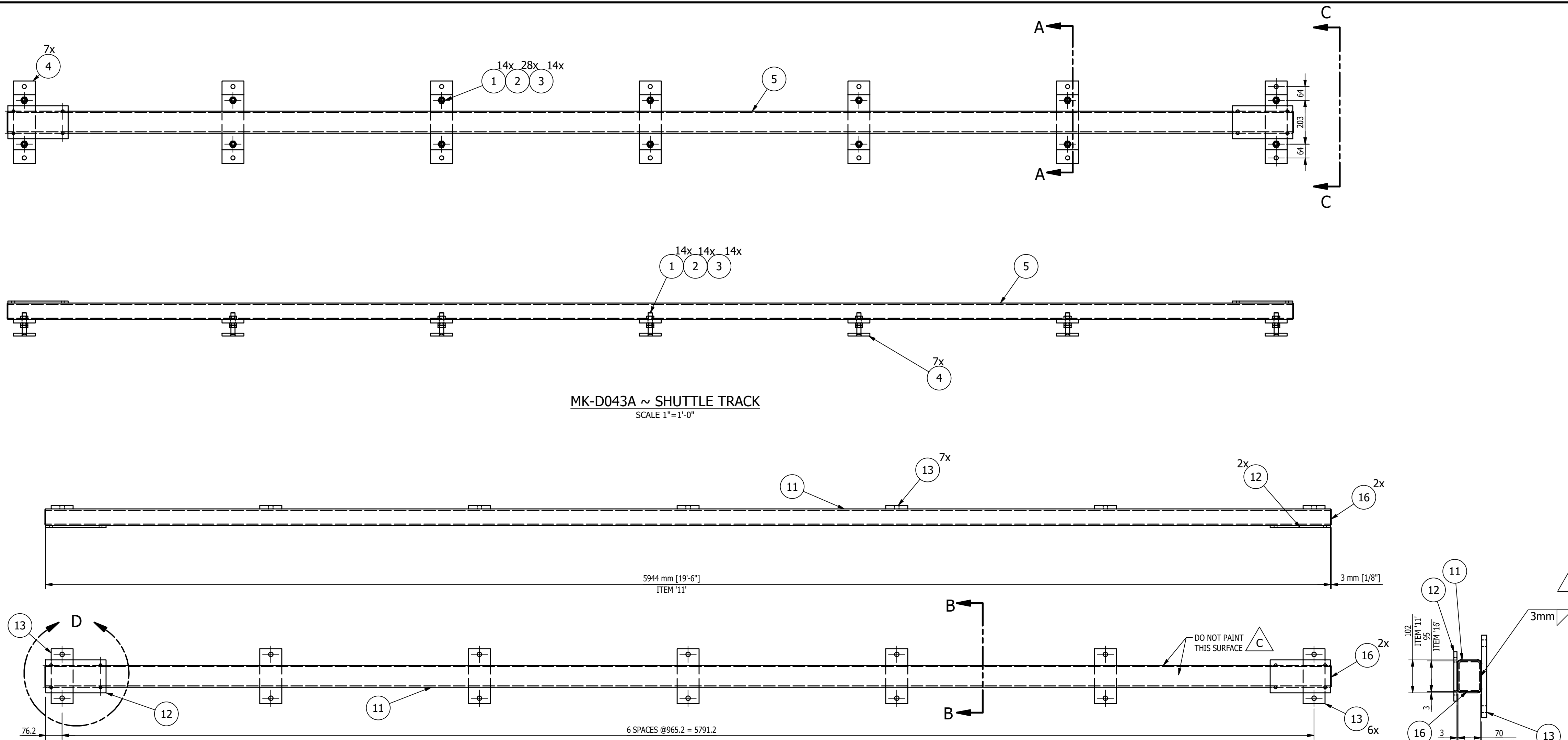
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

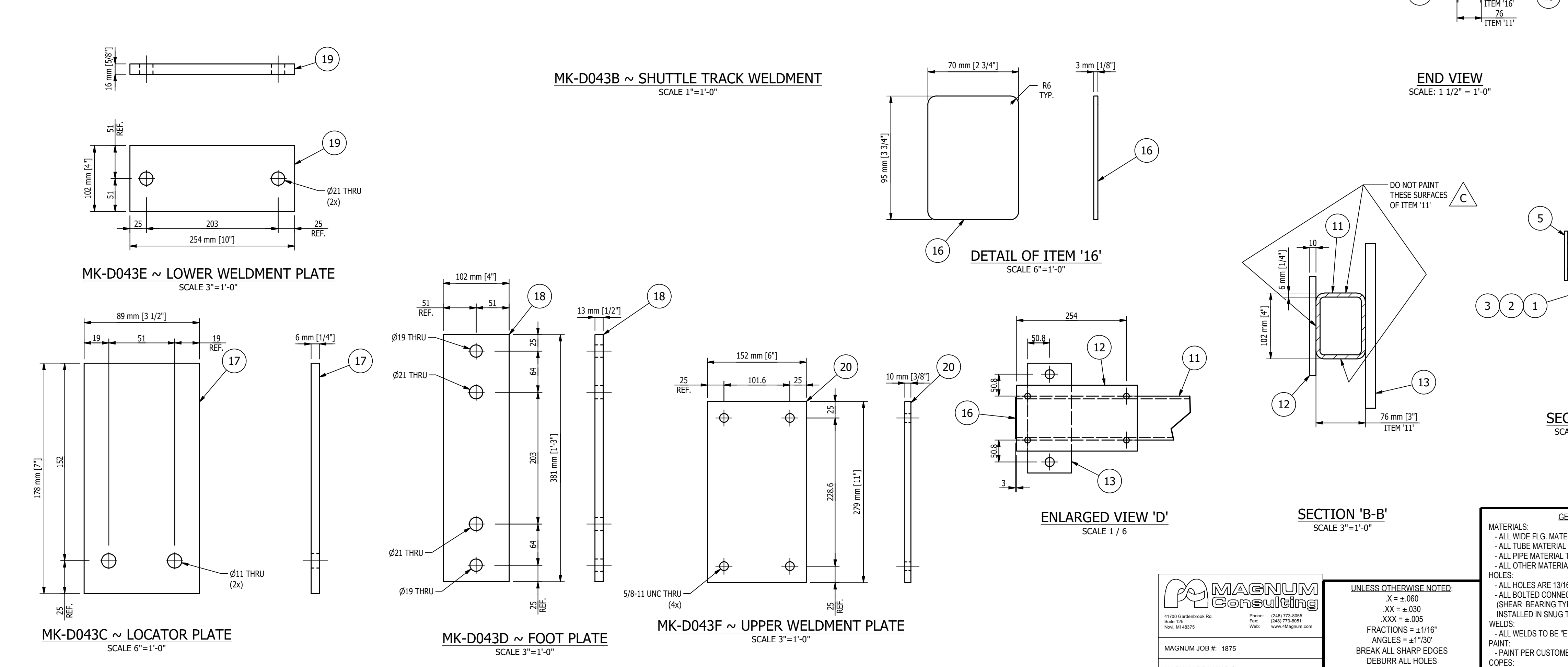
COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



MK-D043A ~ SHUTTLE TRACK
SCALE 1"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D043A			
1	14	THD. ROD 3/4-10UNC	4"		
2	28	3/4-10UNC HEX JAM NUT			
3	14	3/4-10UNC HEX NUT			
4	7	MK-D043D ~ FOOT PLATE			
5	1	MK-D043B ~ SHUTTLE TRACK WELDMENT			
		TOTAL WEIGHT ~ 360.3 lbs			
		MK-D043B			
11	1	TS 4 x 3 x 1/4	19'-6"		
12	2	MK-D043F ~ UPPER WELDMENT PLATE			
13	7	MK-D043E ~ LOWER WELDMENT PLATE			
16	2	PL 1/8 x 2 3/4"	3 3/4"		
		TOTAL WEIGHT ~ 283.2 lbs			
		MK-D043C			
17	1	PL 1/4 x 3 1/2"	7"		
		TOTAL WEIGHT ~ 1.7 lbs			
		MK-D043D			
18	1	PL 1/2 x 4"	1'-3"		
		TOTAL WEIGHT ~ 8.3 LBS			
		MK-D043E			
19	1	PL 5/8 x 4"	10"		
		TOTAL WEIGHT ~ 6.9 LBS			
		MK-D043F			
20	1	PL 3/8 x 6"	11"		
		TOTAL WEIGHT ~ 6.9 LBS			



MK-D043B ~ SHUTTLE TRACK WELDMENT
SCALE 1"=1'-0"

MK-D043E ~ LOWER WELDMENT PLATE
SCALE 3"=1'-0"

MK-D043C ~ LOCATOR PLATE
SCALE 6"=1'-0"

MK-D043D ~ FOOT PLATE
SCALE 3"=1'-0"

MK-D043F ~ UPPER WELDMENT PLATE
SCALE 3"=1'-0"

DETAIL OF ITEM '16'
SCALE 6"=1'-0"

ENLARGED VIEW 'D'
SCALE 1 / 6

SECTION 'B-B'
SCALE 3"=1'-0"

END VIEW
SCALE: 1 1/2"=1'-0"

SECTION 'A-A'
SCALE 1 1/2"=1'-0"

VIEW 'C-C'
SCALE 1 1/2"=1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.
DO NOT PAINT TOP OR SIDES OF TRACK

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	ADJUSTED PAINT NOTES AND WELD NOTES, ADDED DIMENSIONS	
B	MC	8/26/22	REMOVED ITEMS '6', '7', '8', '9', '10', '14', & '15'	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY

mi	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH
CLIENT:	VOLVO	CHECKED BY: CW
DRAWING No.	1875D043	DWG DATE: 6/27/22
REV:	C	JOB No: 22096

MAGNUM Consulting
41100 Clarkston Rd
Suite 125
North, MI 48075
Phone: (248) 773-8882
Fax: (248) 773-8851
Web: www.mmagnum.com

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°00'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

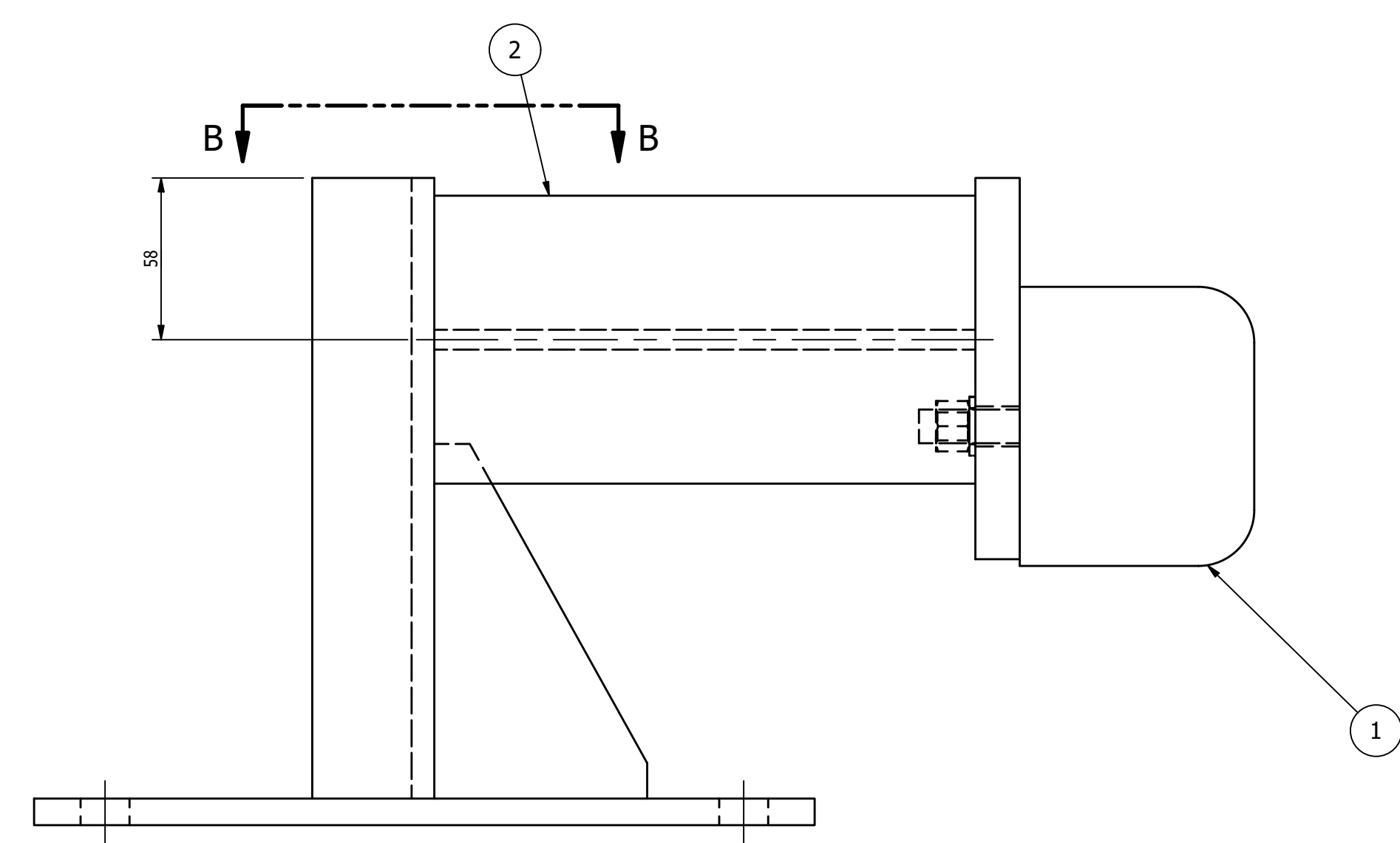
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

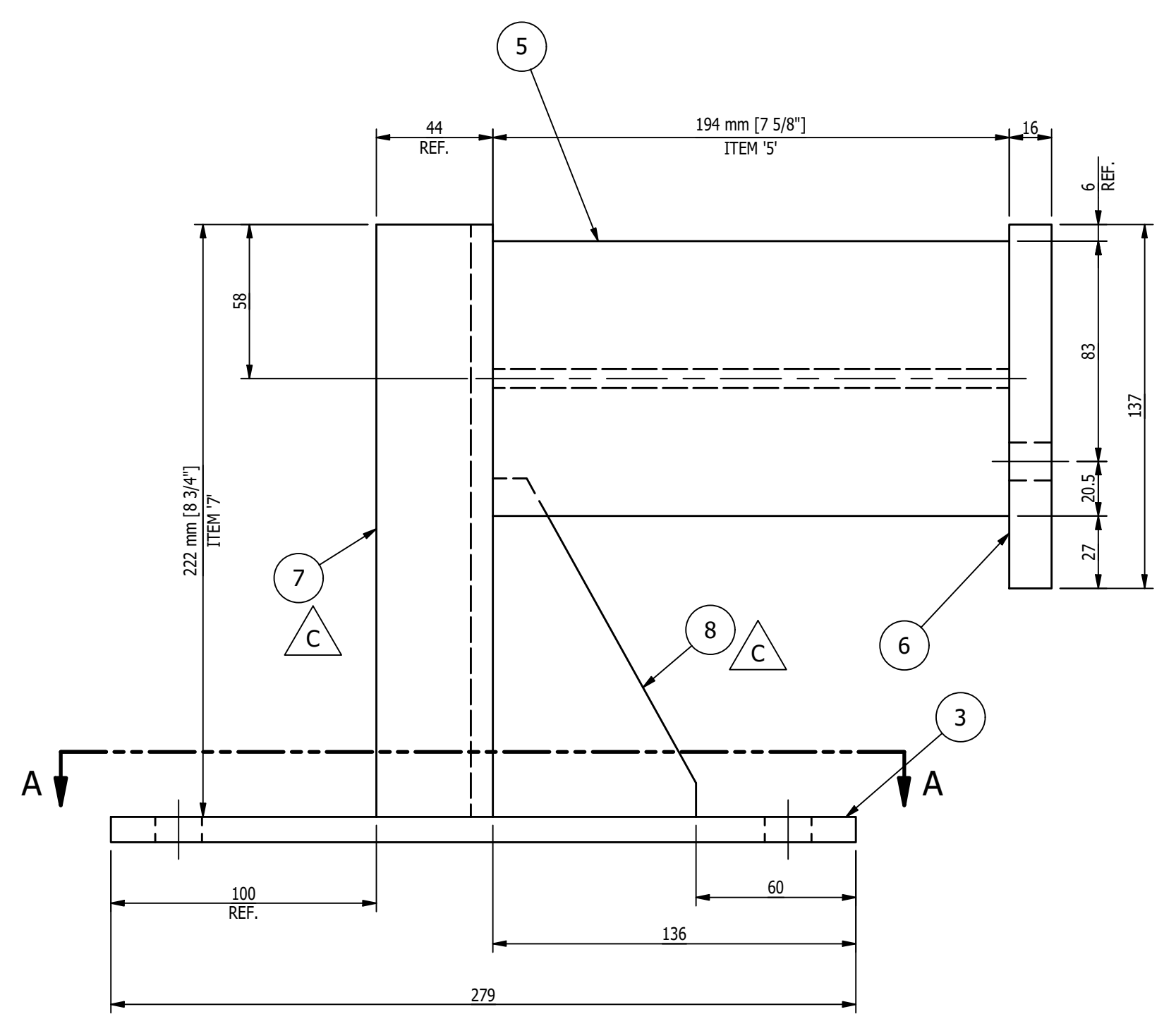
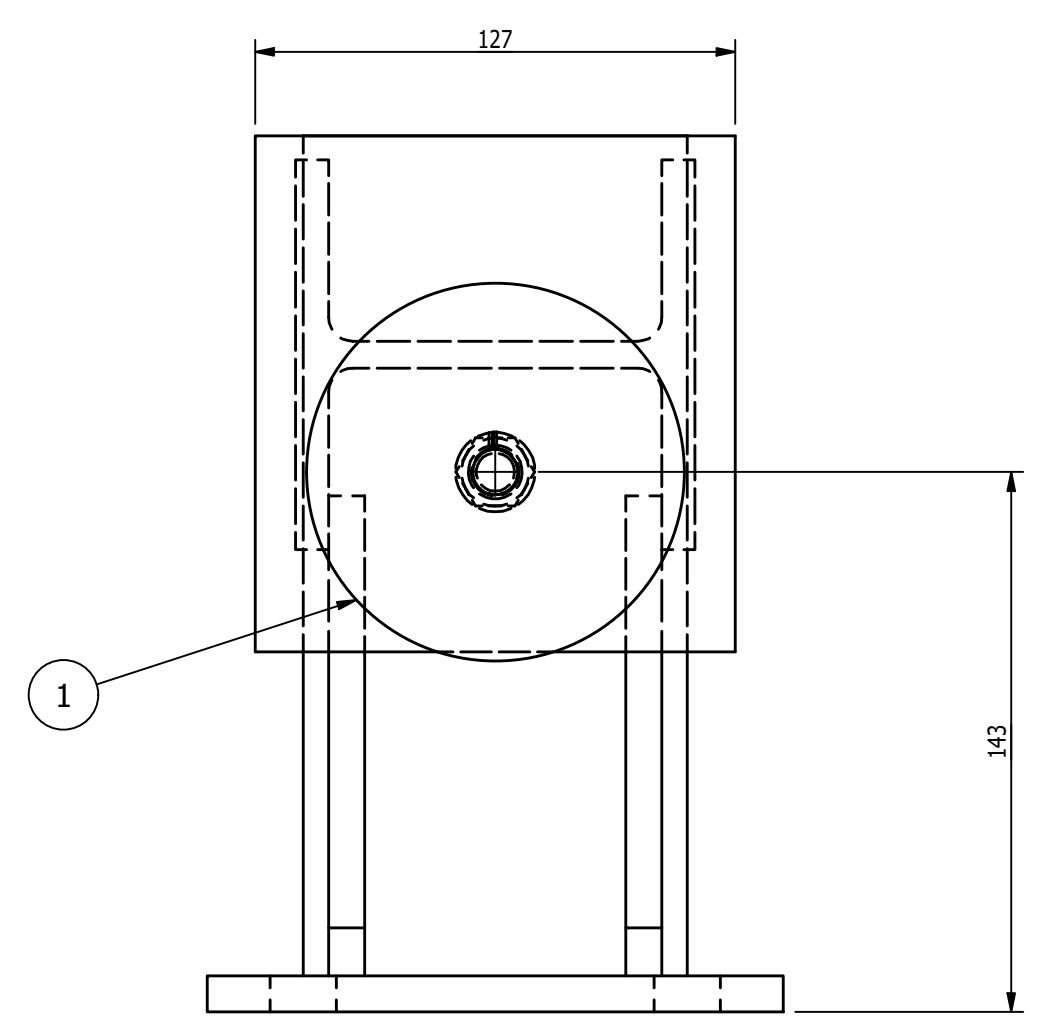
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

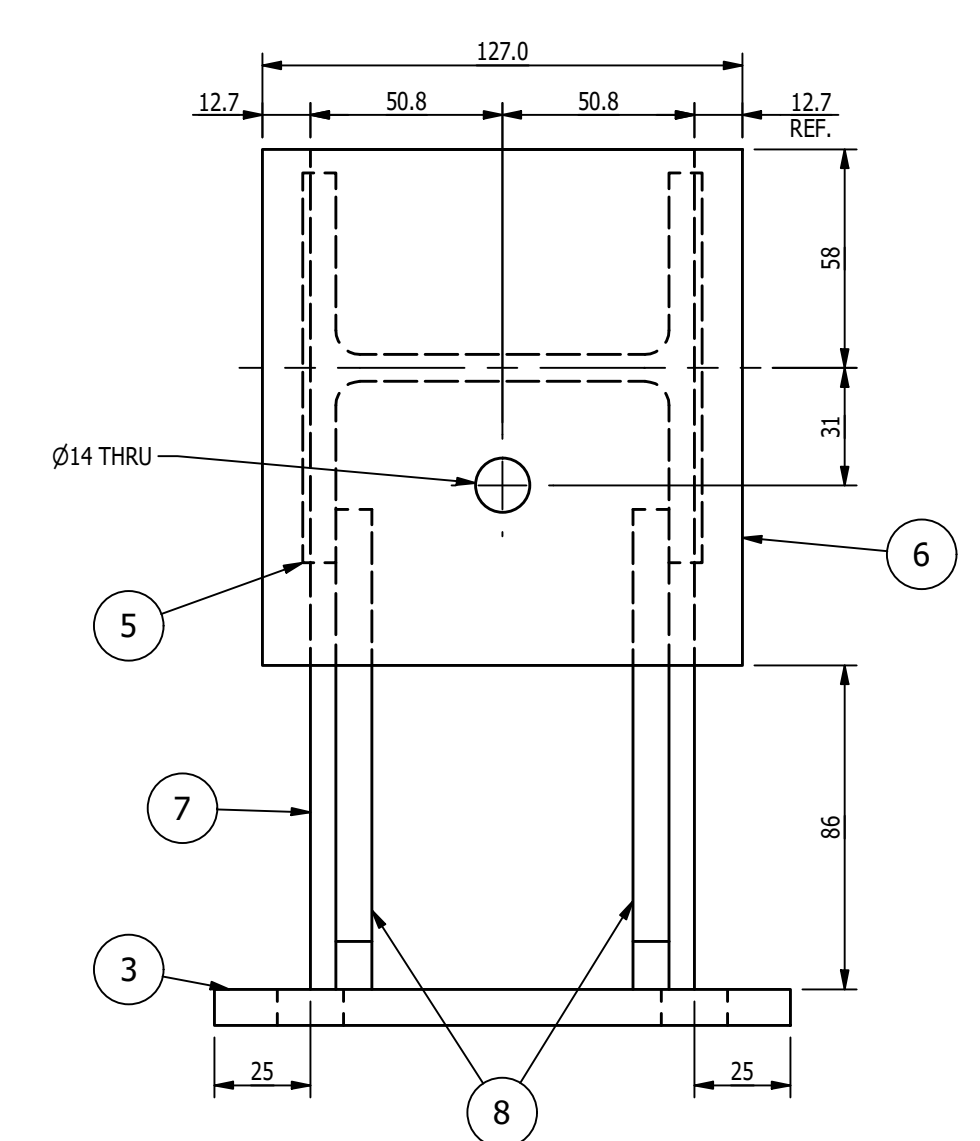
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D044A BUMPER WITH FASTENERS, 100mm OD x 84mm LG BUMPER, 120 TOTAL LENGTH, M12 THREAD, CONDUCTIX-WAMPFLER PART NO. XA-017120-100N-1		6-1	INCLUDES M12 WASHER AND NUT
2	1	MK-D044B ~ SHUTTLE BUMPER WELDMENT TOTAL WEIGHT ~ 38.8 lbs			
MK-D044B					
3	1	PL 3/8 x 6"	11"		
5	1	W 4 x 13	7 5/8"		
6	1	PL 5/8 x 5"	5 3/8"		
7	1	C 4 x 7.25	8 3/4"		
8	2	PL 3/8 x 3"	5"		
TOTAL WEIGHT ~ 27.7 lbs					



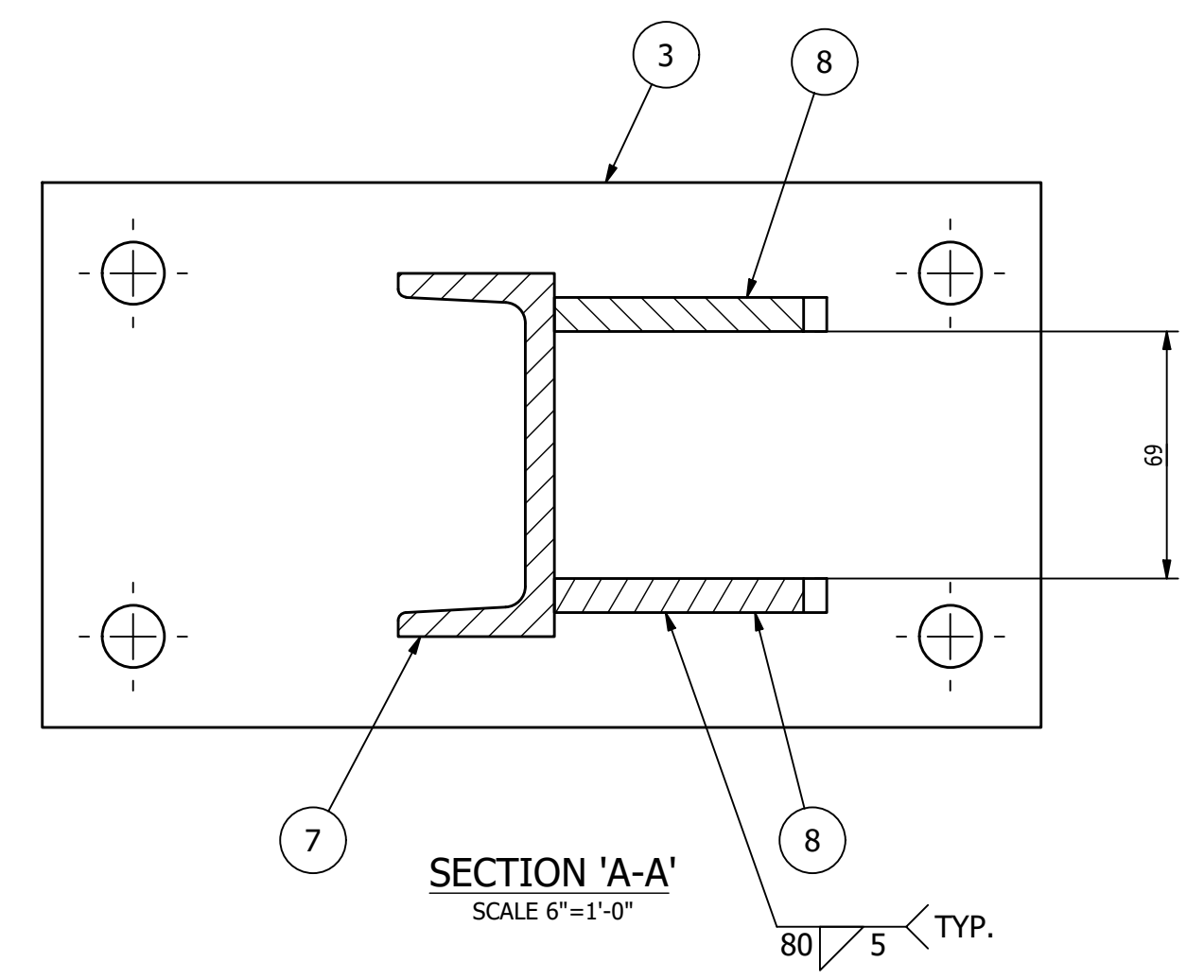
MK-D044A ~ SHUTTLE BUMPER ASSEMBLY
SCALE 6"=1'-0"



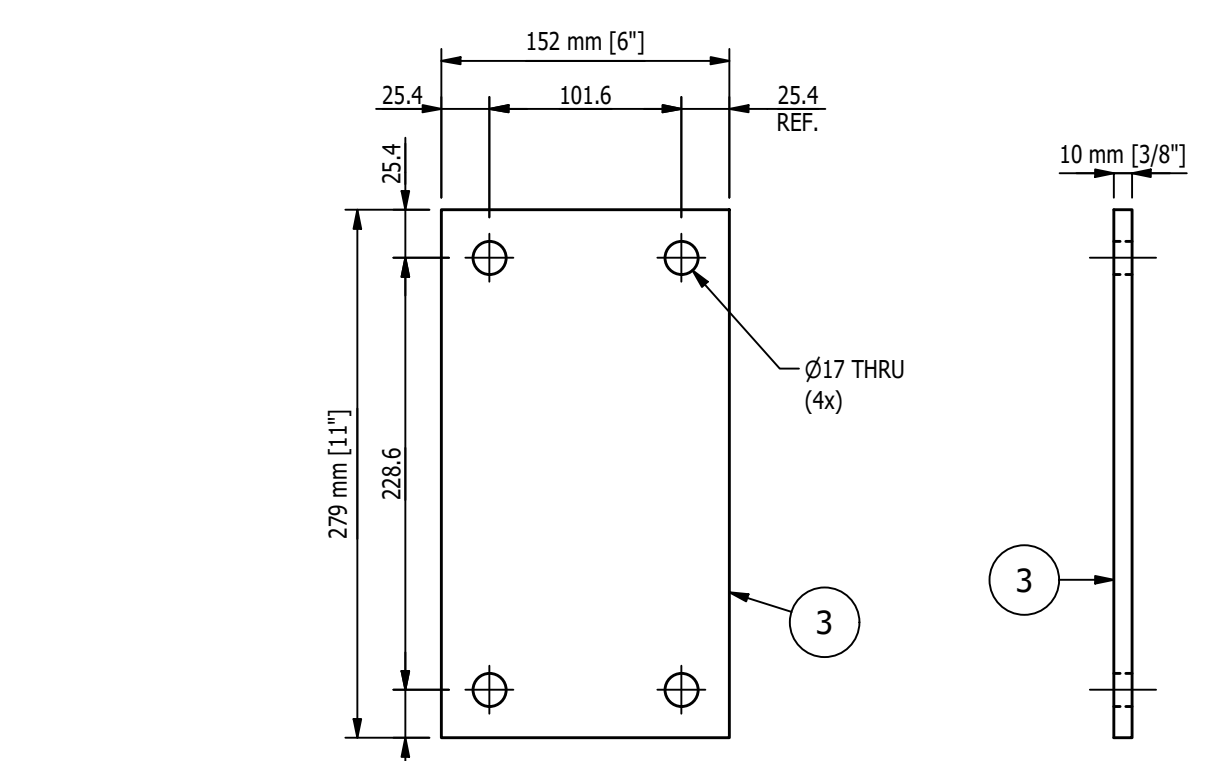
MK-D044B ~ SHUTTLE BUMPER WELDMENT
SCALE 6"=1'-0"



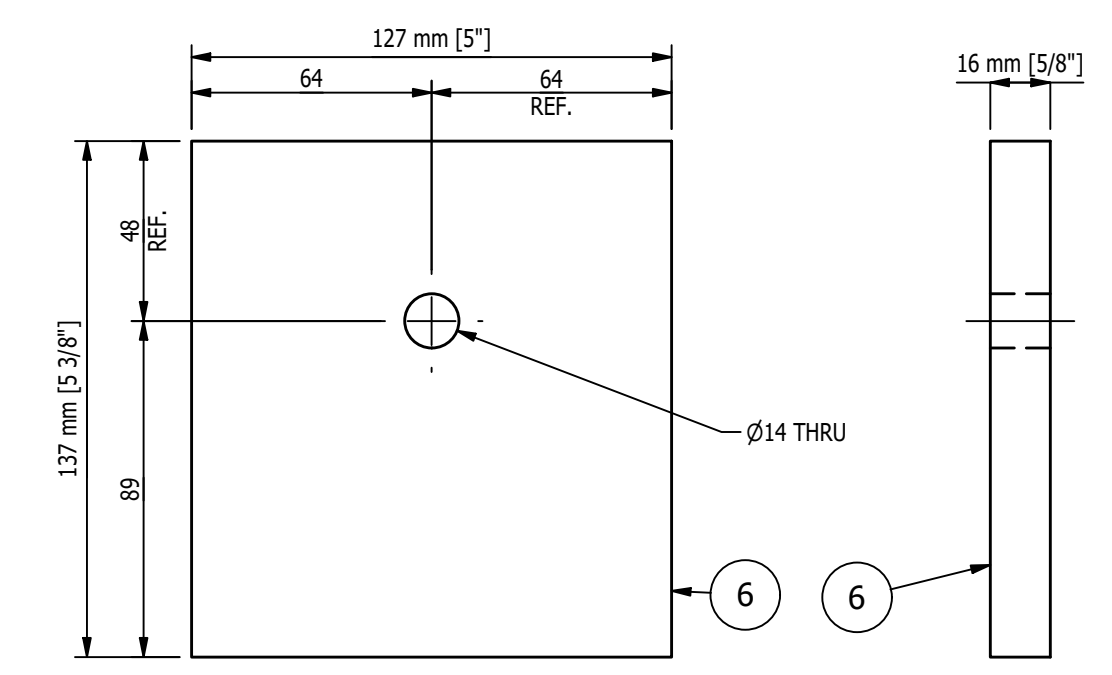
VIEW 'B-B'
SCALE 6"=1'-0"



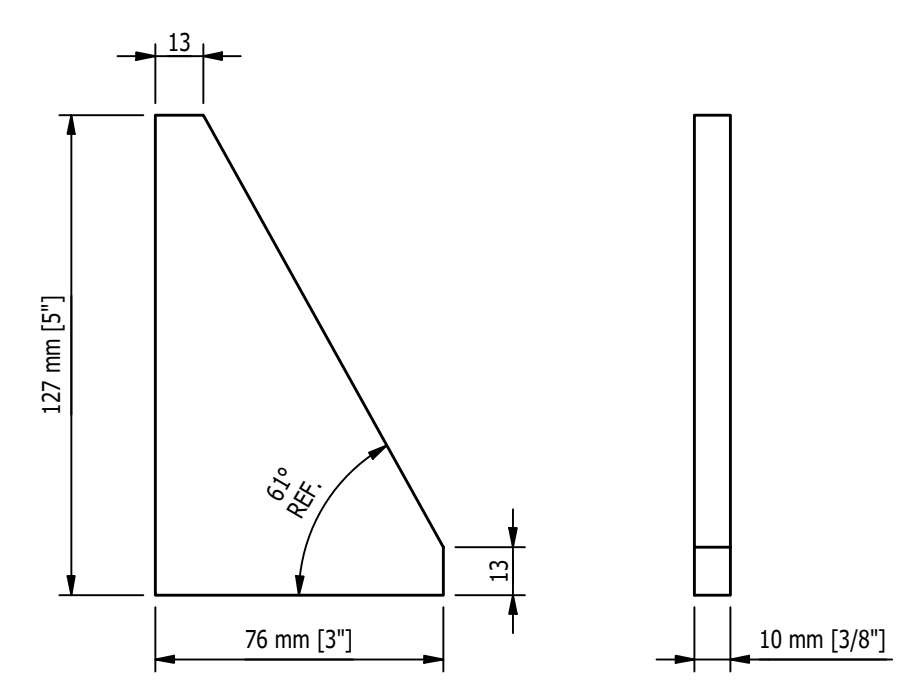
SECTION 'A-A'
SCALE 6"=1'-0"



DETAIL OF ITEM '3'
SCALE 3"=1'-0"



DETAIL OF ITEM '6'
SCALE 6"=1'-0"



DETAIL OF ITEM '8'
SCALE 6"=1'-0"

- SHOP NOTES:**
- USE E70XX LOW HYD. RODS FOR ALL WELDING U.N.O.
 - ALL WELDS TO BE 3/16" CONTINUOUS FILLET U.N.O.
 - ALL STEEL ANGLES, CHANNELS, MC, PLATES, FLATS, ROUNDS & S-SHAPES TO BE ASTM A-36 U.N.O.
 - ALL STRUCTURAL STEEL WIDE FLANGES AND WIDE FLANGE TEES TO BE ASTM A-992/A-572 GR. 50
 - ALL FASTENERS TO BE ZINC PLATED U.N.O.
 - ALL BOLTS TO BE ASTM A-325 U.N.O.
 - ALL NUTS ARE TO BE ASTM A-194 GR. 2 ANCO LOCK NUTS U.N.O.
 - ALL WASHERS ARE TO BE ASTM F436 U.N.O.
 - ALL STEEL TO BE CLEAN OF DIRT, RUST, MILL SCALE, WELD SPLATTER AND DEBURR ALL EDGES PRIOR TO PAINTING.
 - MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 - ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
 - ONE SHOP COAT OF LIGHT GREY RAL 7035
 - DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	REMOVED ITEM '4', ADDED ITEMS '7' & '8'	
B	MC	8/30/22	ADDED DIMENSIONS	
A	MC	8/11/2022	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millc.com

TITLE: P6700 CONVEYORS
CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No.: 1875D044

REV: C

JOB No.: 22096

DRAWN BY: AH

CHECKED BY: CW

DWG DATE: 6/24/22

MAGNUM Consulting

41100 Charleston Rd.
Suite 125
Noris, MI 48255

Phone: (248) 772-8822
Fax: (248) 772-8821
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D044

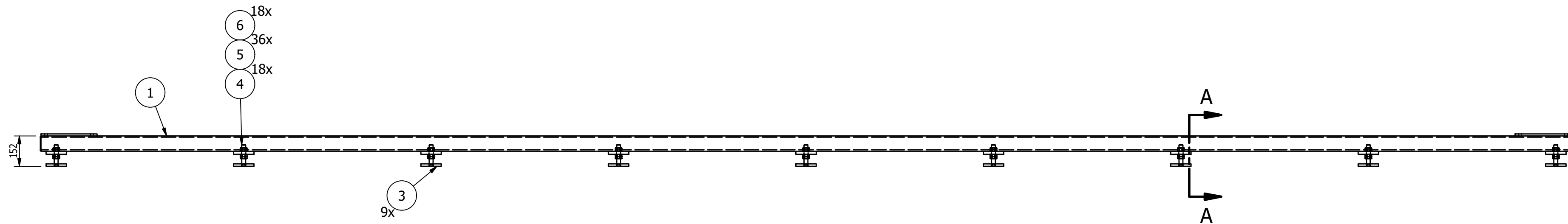
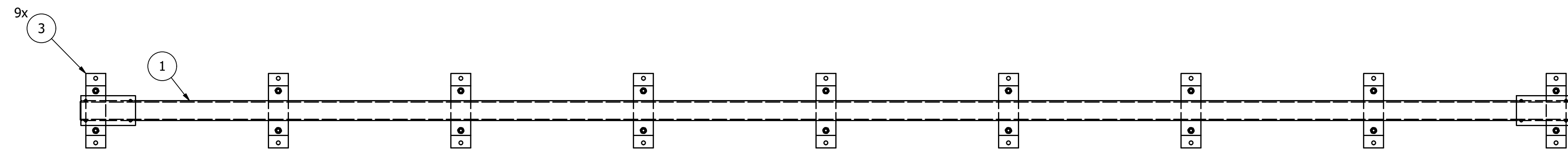
UNLESS OTHERWISE NOTED:

X = ±.060
XX = ±.030
XXX = ±.005

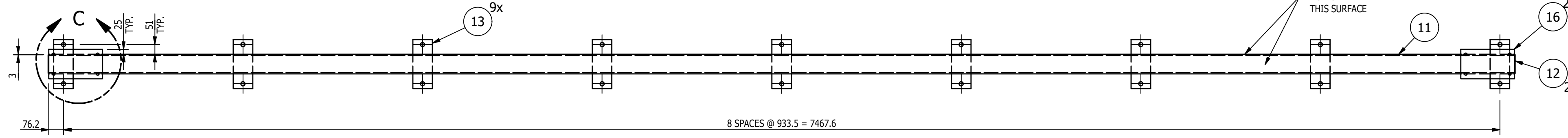
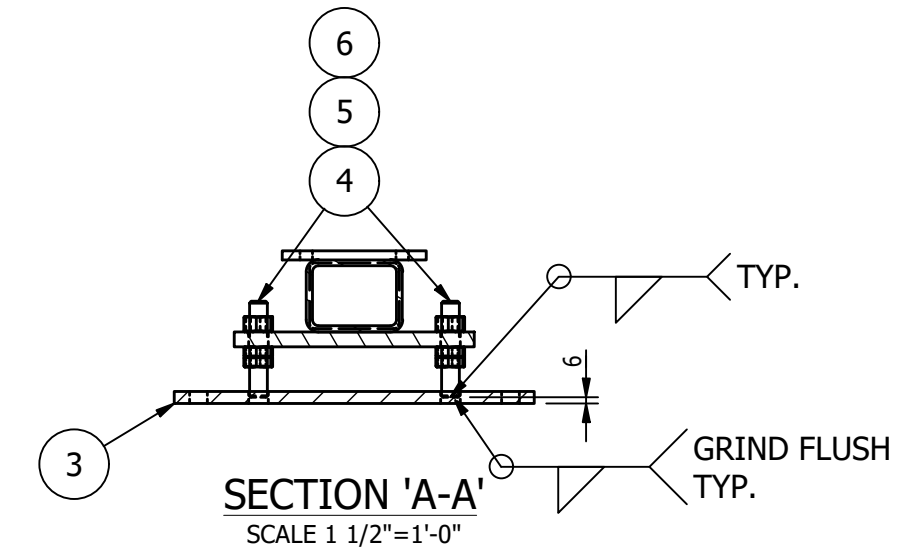
FRACTIONS = ±1/16"
ANGLES = ±1°30'

BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

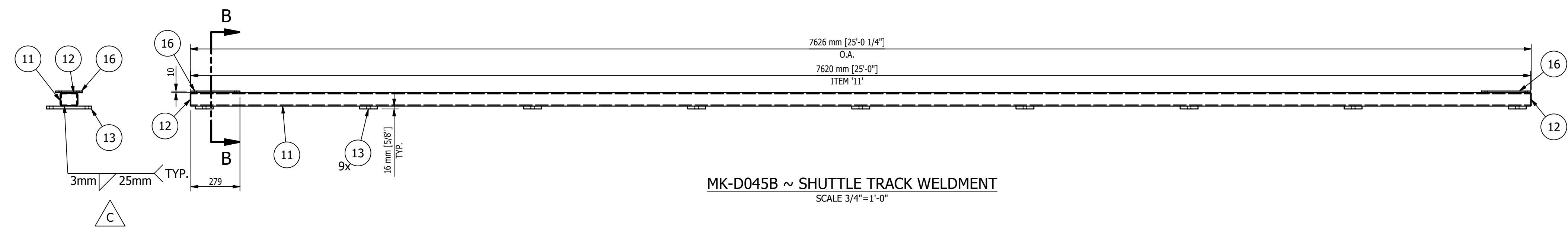
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D045A			
3	9	MK-D043D ~ SHUTTLE TRACK WELDMENT			
4	18	THD. ROD 3/4-10UNC	4"		
5	36	3/4-10UNC HEX JAM NUT			
6	18	3/4-10UNC HEX NUT			
		TOTAL WEIGHT ~ 451.7 LBS			
		MK-D045B			
11	1	TS 4 x 3 x 1/4	25'-0"		
12	2	PL 1/8 x 2 3/4"	3 3/4"		
13	9	MK-D043E ~ LOWER WELDMENT PLATE			
16	2	MK-D043F ~ UPPER WELDMENT PLATE			
		TOTAL WEIGHT ~ 354.6 LBS			



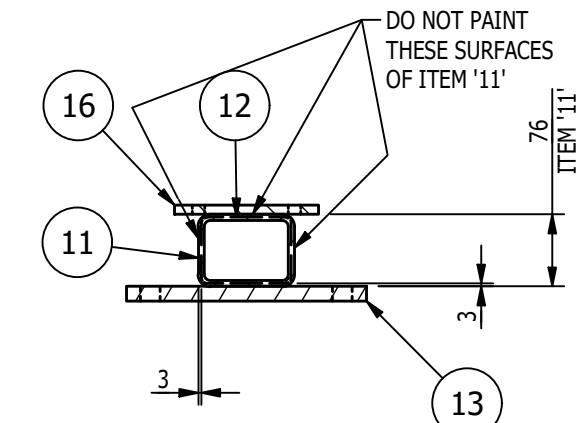
MK-D045A ~ SHUTTLE TRACK
SCALE 3/4"=1'-0"



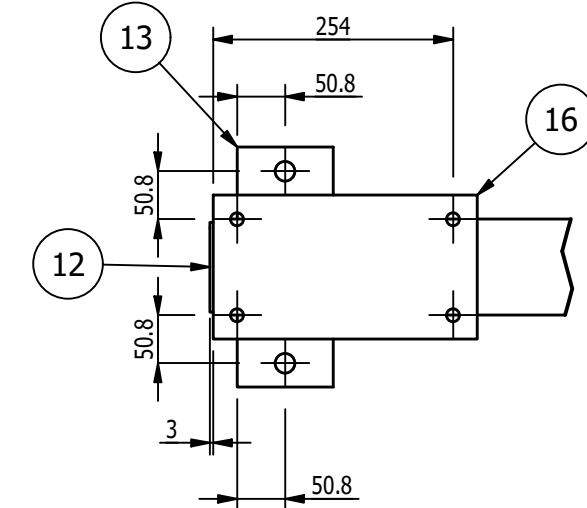
MK-D045B ~ SHUTTLE TRACK WELDMENT
SCALE 3/4"=1'-0"



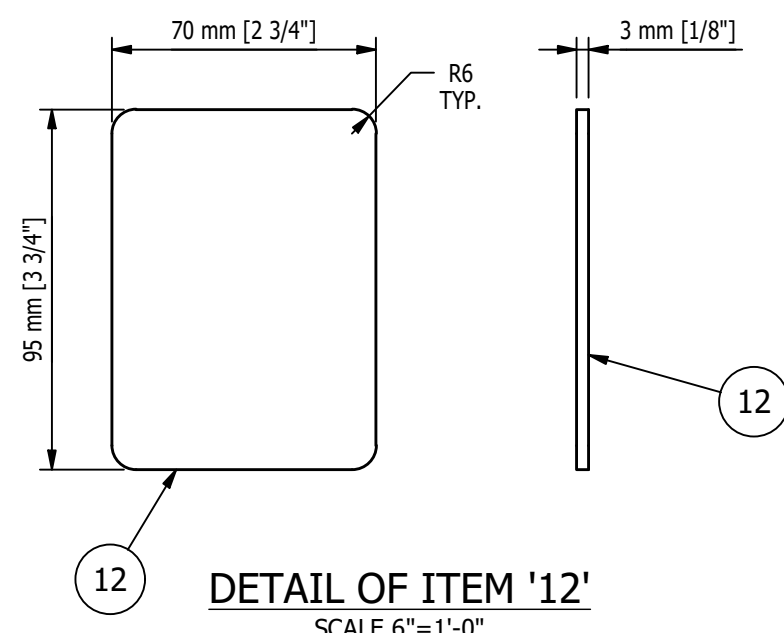
- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.
DO NOT PAINT TOP OR SIDE OF TRACK



SECTION 'B-B'
SCALE 1 1/2"=1'-0"



ENLARGED VIEW 'C'
SCALE 1 1/2"=1'-0"



DETAIL OF ITEM '12'
SCALE 6"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	ADJUSTED PAINT NOTES WELD NOTES	
B	MC	8/26/22	REMOVED ITEMS '2', '7', '8', '9', '10', '14', & '15'	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MAGNUM CONSULTING

41100 Clarkston Rd
Suite 125
Novi, MI 48225

Phone: (248) 772-8822
Fax: (248) 772-8821
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D045

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS
CAMPUS BUILDING

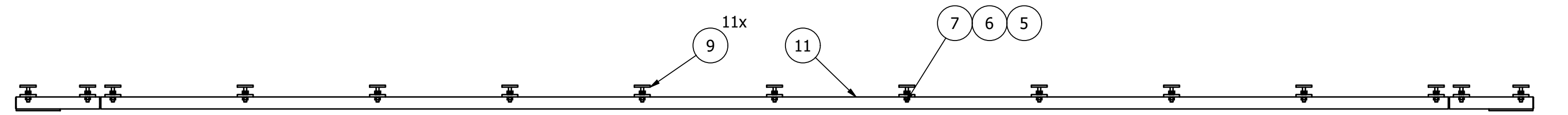
CLIENT: VOLVO

DRAWING No.: 1875D045

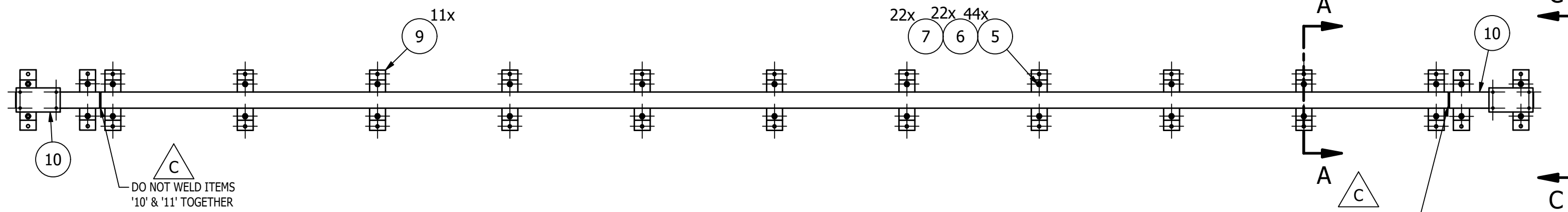
REV: C

JOB No.: 22096

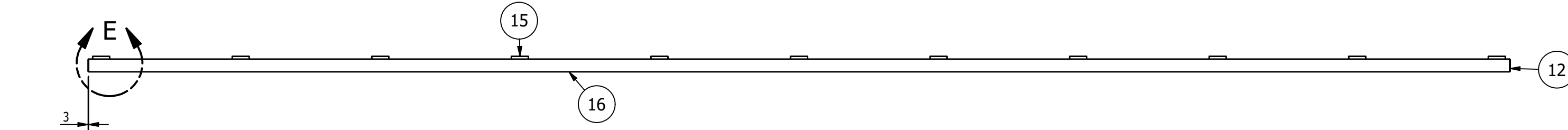
DRAWN BY: JC
CHECKED BY: CW
DWG DATE: 6/27/22



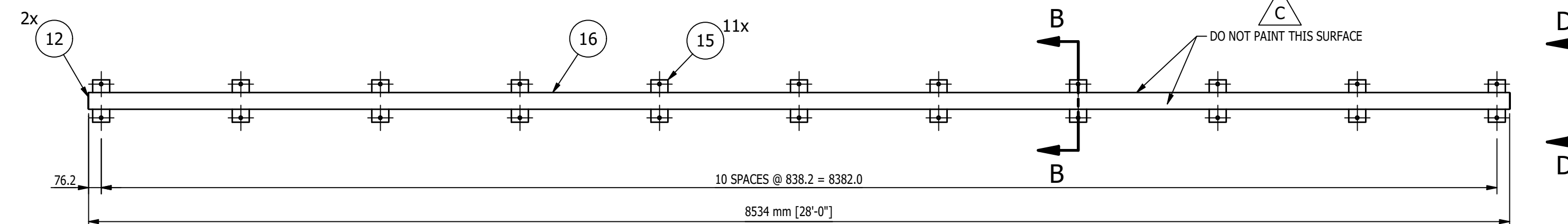
MK-D046A ~ SHUTTLE TRACK
SCALE 1/2"=1'-0"



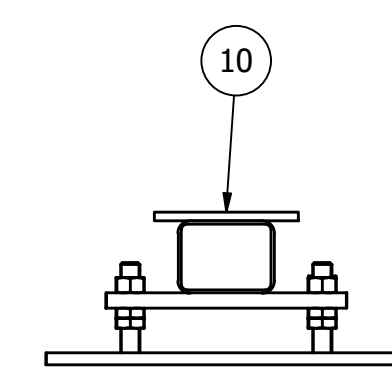
MK-D046B ~ SHUTTLE TRACK WELDMENT
SCALE 1/2"=1'-0"



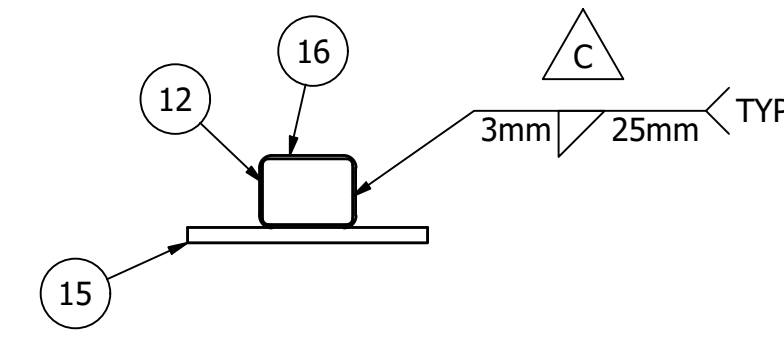
MK - D046C ~ SHUTTLE TRACK ENDS
SCALE 1 1/2"=1'-0"



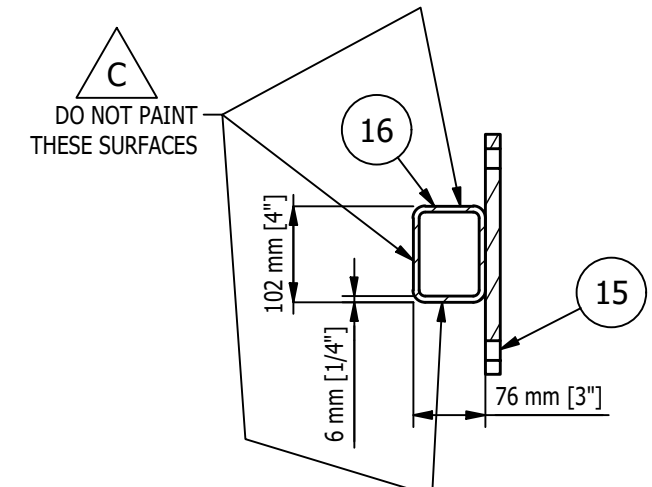
MK-D046D ~ SHUTTLE TRACK BUMPER ENDS WELDMENT
SCALE 1 1/2"=1'-0"



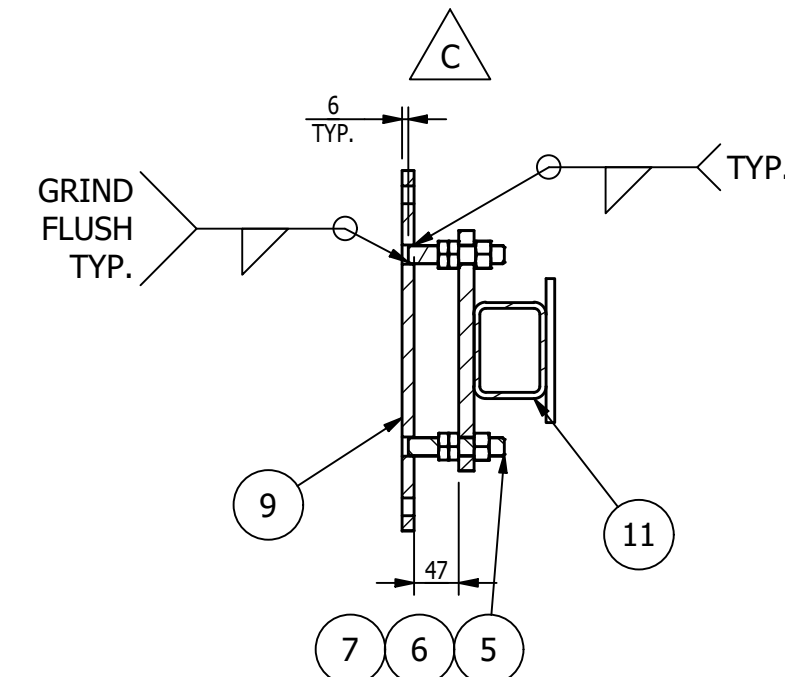
VIEW 'C-C'
SCALE 1 1/2"=1'-0"



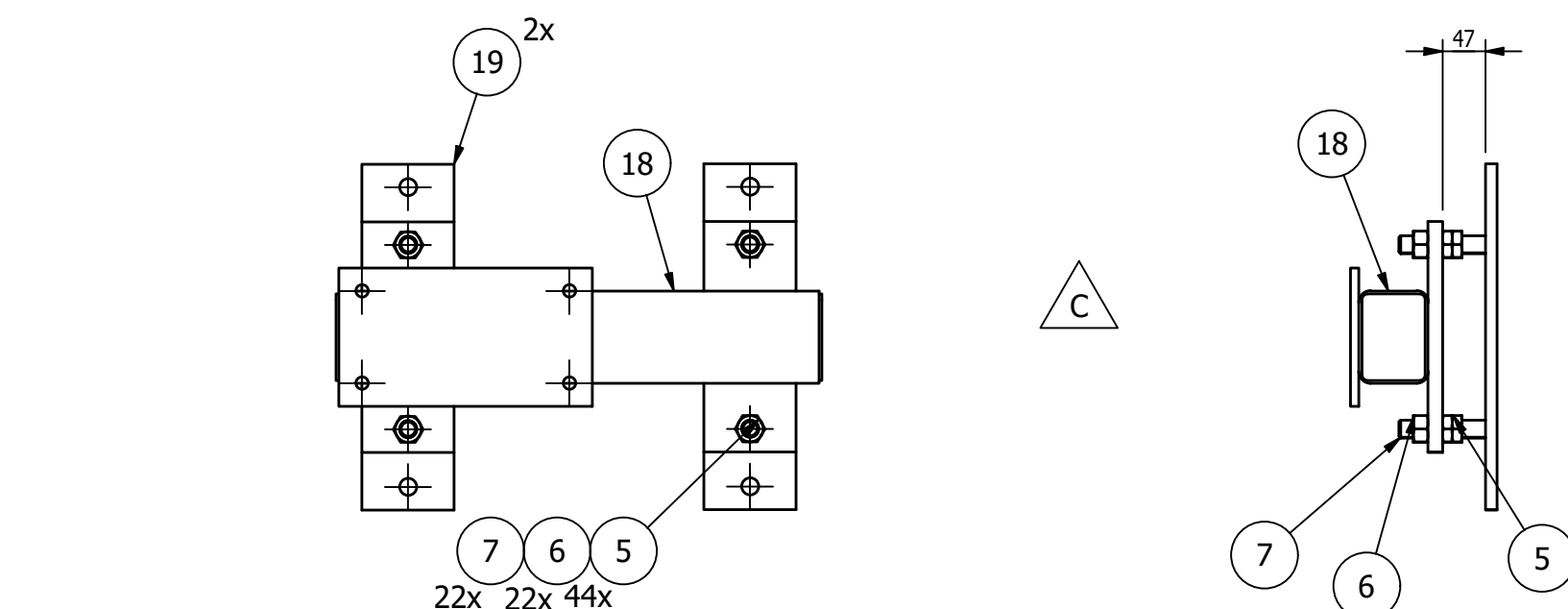
VIEW 'D-D'
SCALE 1 1/2"=1'-0"



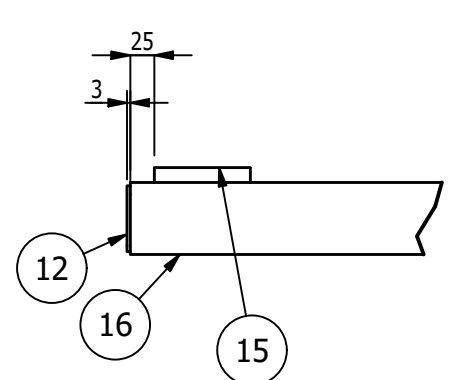
SECTION 'B-B'
SCALE 1 1/2"=1'-0"



SECTION 'A-A'
SCALE 1 1/2"=1'-0"



DETAIL OF ITEM '12'
SCALE 6"=1'-0"



ENLARGED VIEW 'E'
SCALE 1 1/2"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D046A			
5	44	3/4-10UNC HEX JAM NUT			
6	22	3/4-10UNC HEX NUT			
7	22	THD. ROD 3/4-10UNC	4"		
9	11	MK-D043D ~ FOOT PLATE			
10	2	MK-D046C ~ SHUTTLE TRACK ENDS			
11	1	MK-D046B ~ SHUTTLE TRACK WELDMENT			
		MK-D046B			
12	2	PL 1/8 x 2 3/4"	3 3/4"		
15	11	MK-D043E ~ LOWER WELDMENT PLATE			
16	1	TS 4 x 3 x 1/4	28'-0"		
		MK-D046C			
5	8	3/4-10UNC HEX JAM NUT			
6	4	3/4-10UNC HEX NUT			
7	4	THD. ROD 3/4-10UNC	4"		
18	1	MK-D046D ~ SHUTTLE TRACK BUMPER ENDS WELDMENT			
19	2	MK-D043D ~ FOOT PLATE			
		MK-D046D			
12	2	PL 1/8 x 2 3/4"	3 3/4"		
19	2	MK-D043E ~ LOWER WELDMENT PLATE			
20	1	MK-D043F ~ UPPER WELDMENT PLATE			
21	1	TS 4 x 3 x 1/4	1'-8 13/16"		

- SHOP NOTES:
- ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 - ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 - REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 - ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 - ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 - ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 - MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 - ALL SLOT LENGTHS ARE END TO END U.N.O.
- PAINT NOTES:
- PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.
DO NOT PAINT TOP OR SIDES OF TRACK

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	UPDATED WELD NOTES, PAINT NOTES, & DIMENSIONS	
B	MC	8/26/22	REMOVED ITEMS '1', '2', '3', '4', '8', '13', & '14'	
A	MC	8/9/22	FOR FABRICATION	

<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com</p>	<p>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</p>

MAGNUM Consulting
41100 Clarkston Rd.
Suite 125
North, MI 48075
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D046

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

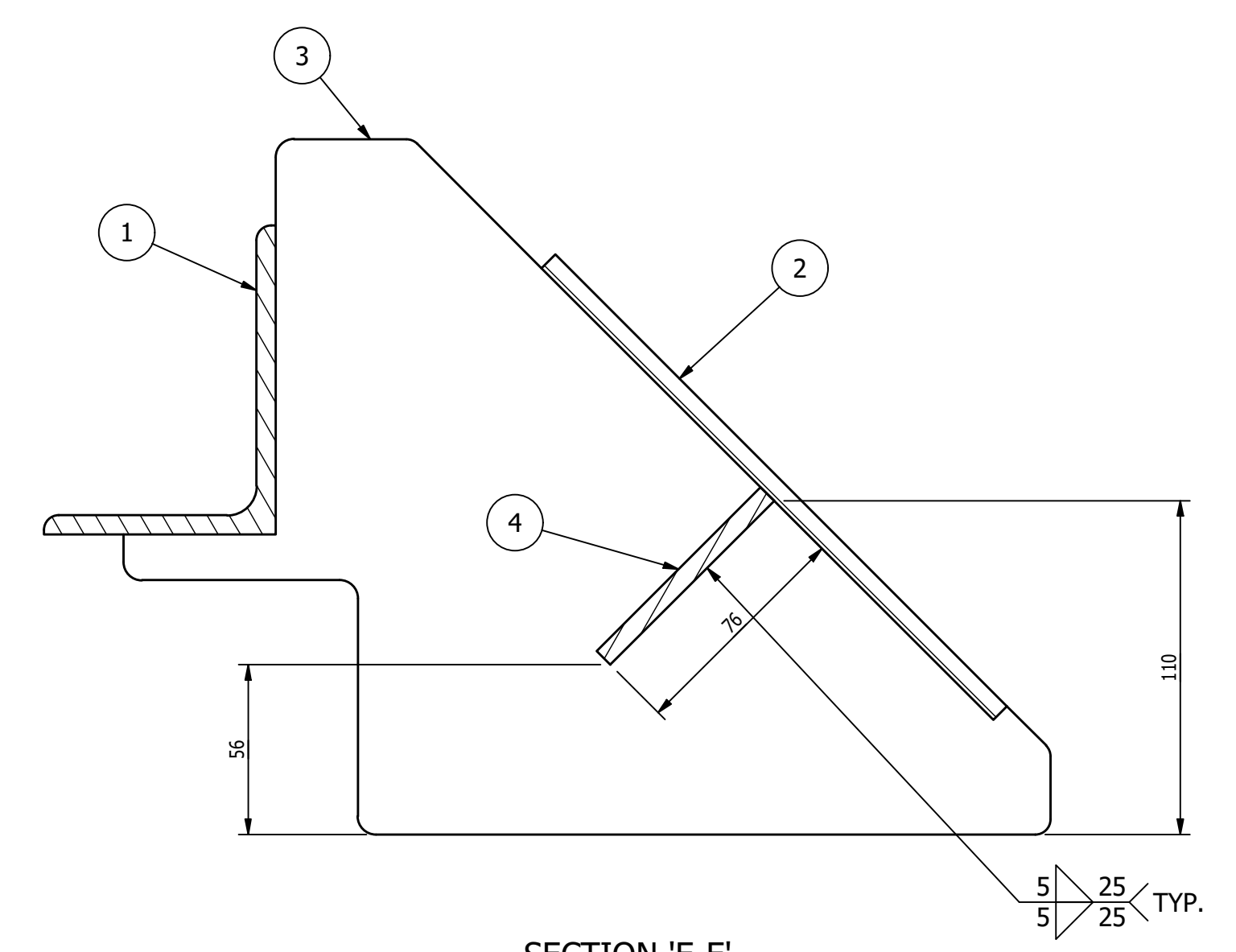
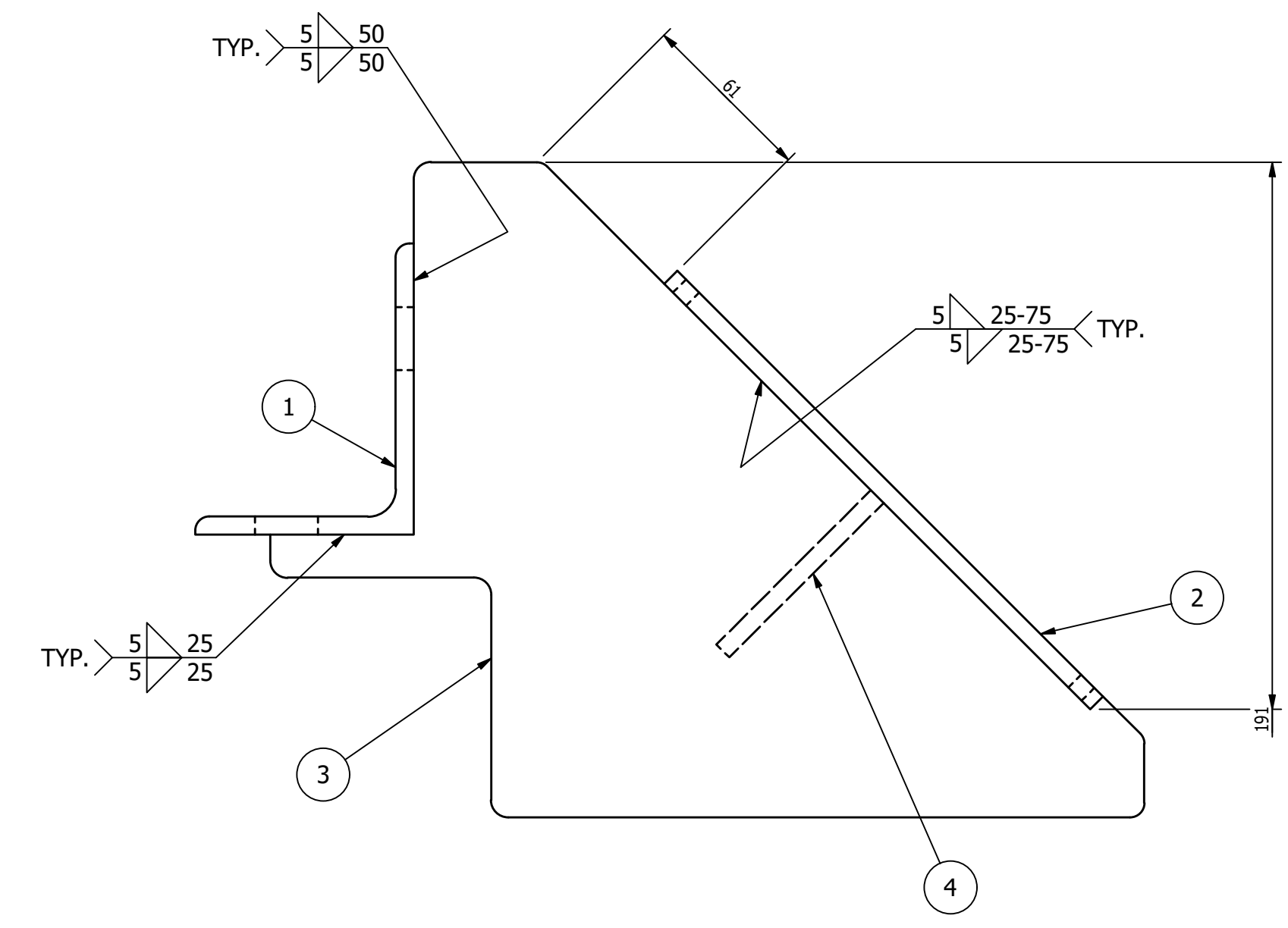
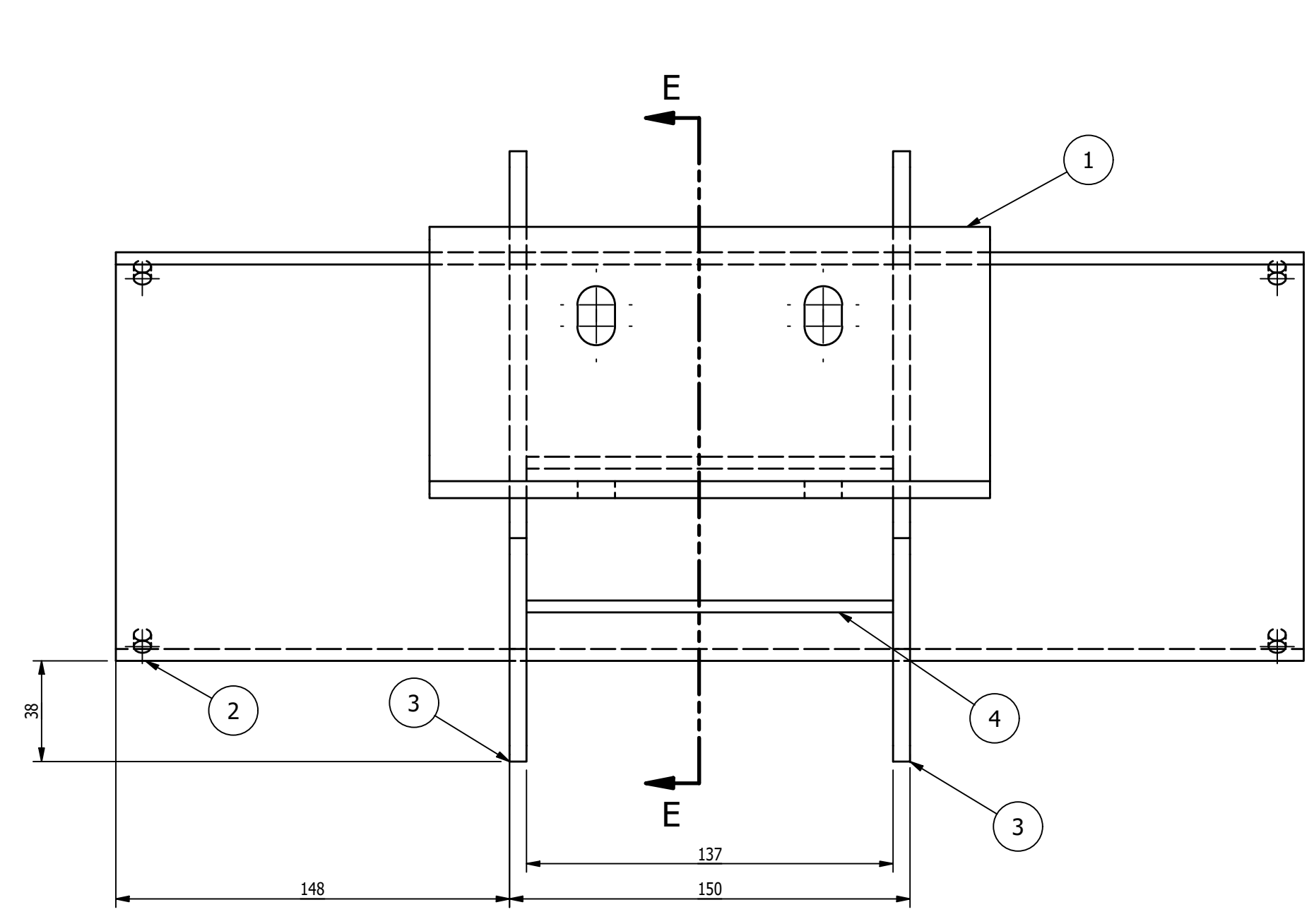
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

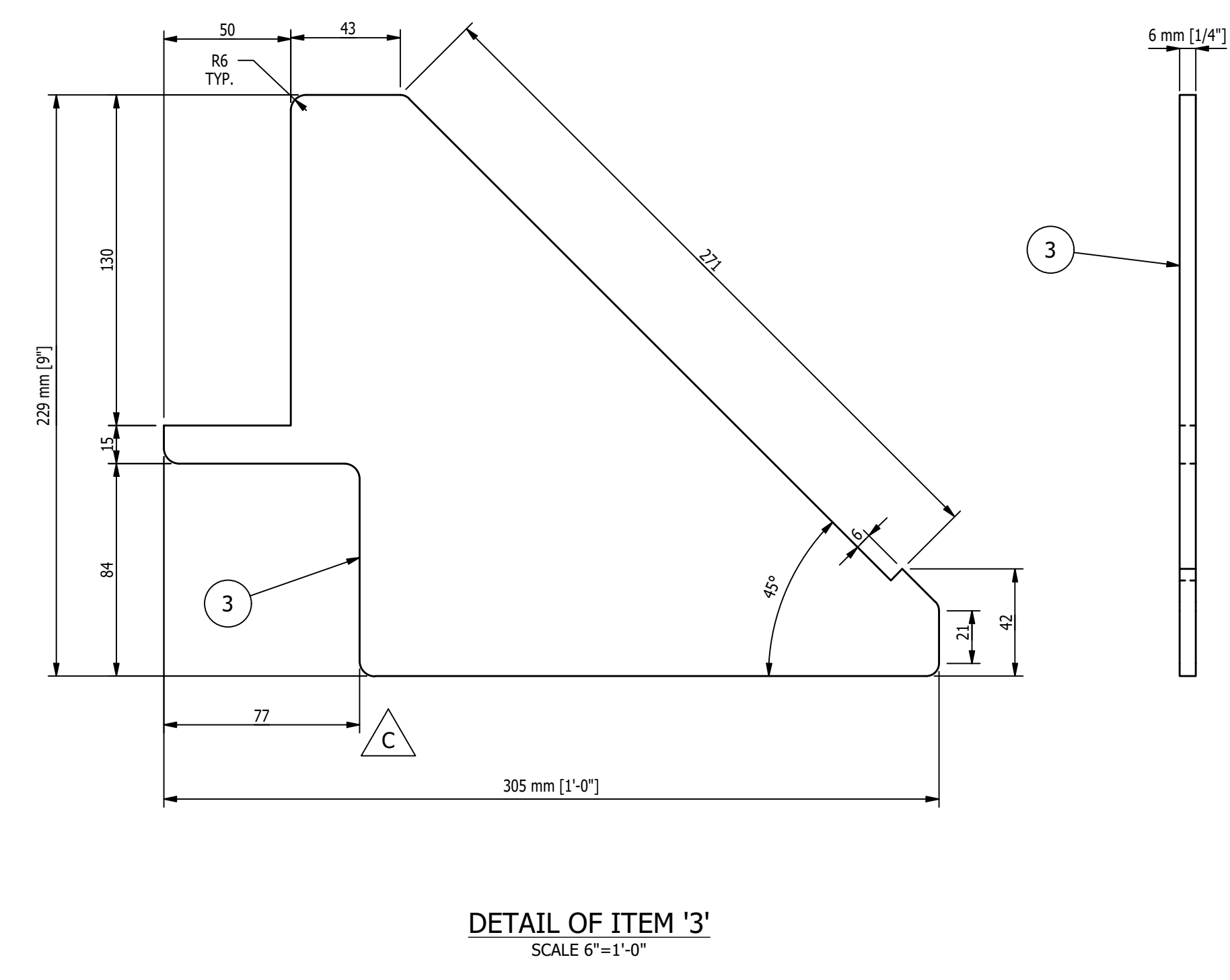
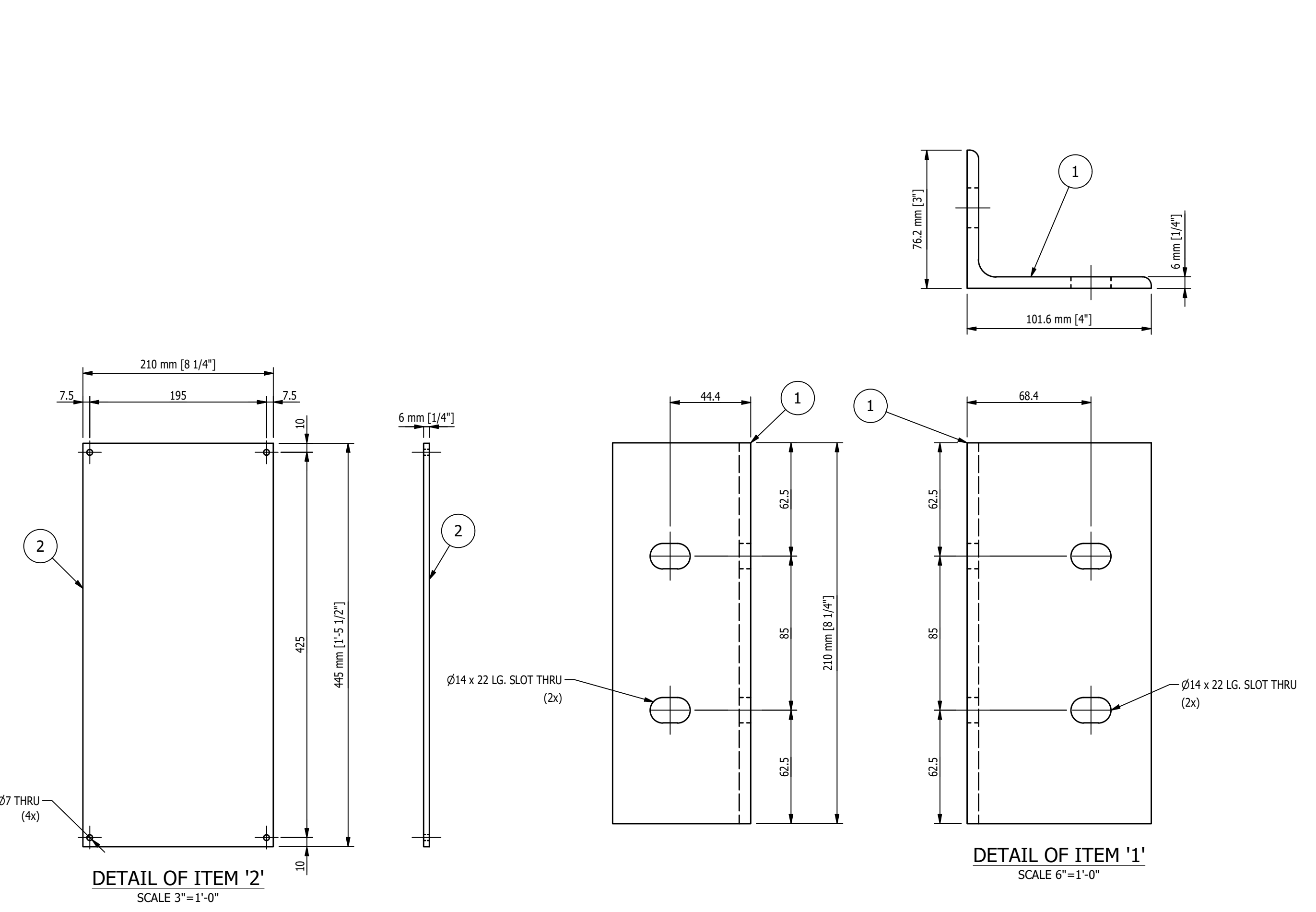
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D047A			
1	1	L 4 x 3 x 1/4	8 1/4"		
2	1	PL 1/4 x 8 1/4"	1'-5 1/2"		
3	2	PL 1/4 x 9"	1'-0"		
4	1	PL 1/4 x 3"	5 3/8"		
TOTAL WEIGHT ~ 23 lbs					



SECTION 'E-E'
SCALE 6"=1'-0"

MK-D047A ~ CONTROLLER BRACKET
SCALE 6"=1'-0"



DETAIL OF ITEM '3'
SCALE 6"=1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER
- ONE SHOP COAT OF PURE ORANGE RAL 2004
OR
ONE SHOP COAT OF LIGHT GREY RAL 7035

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/9/2022	UPDATED LENGTH OF CUT ON ITEM '3' TO ORIGINAL LENGTH	
B	MC	8/8/22	UPDATED LENGTH OF CUT ON ITEM '3'	
A	MC	07/20/22	FOR FABRICATION	

MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: AH
CLIENT: VOLVO		CHECKED BY: CW
DRAWING No. 1875D047		DWG DATE: 6/28/22
REV: C		JOB No: 22096

MAGNUM Consulting
 41100 QuakerRoad Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.m4magnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D047

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

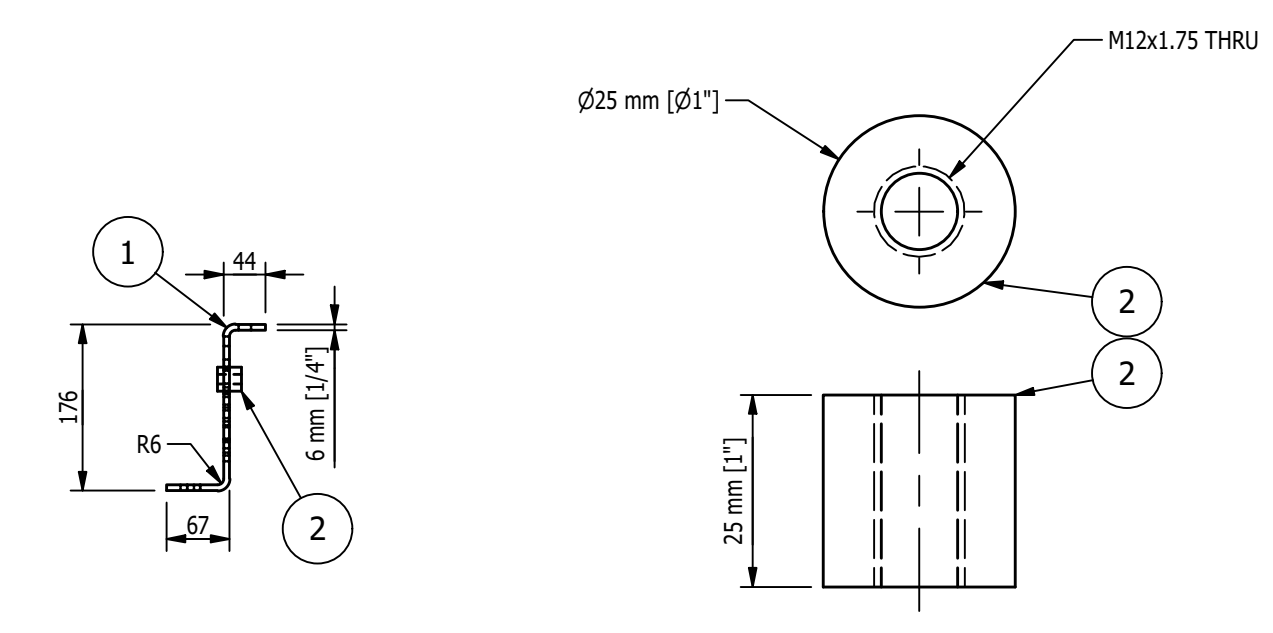
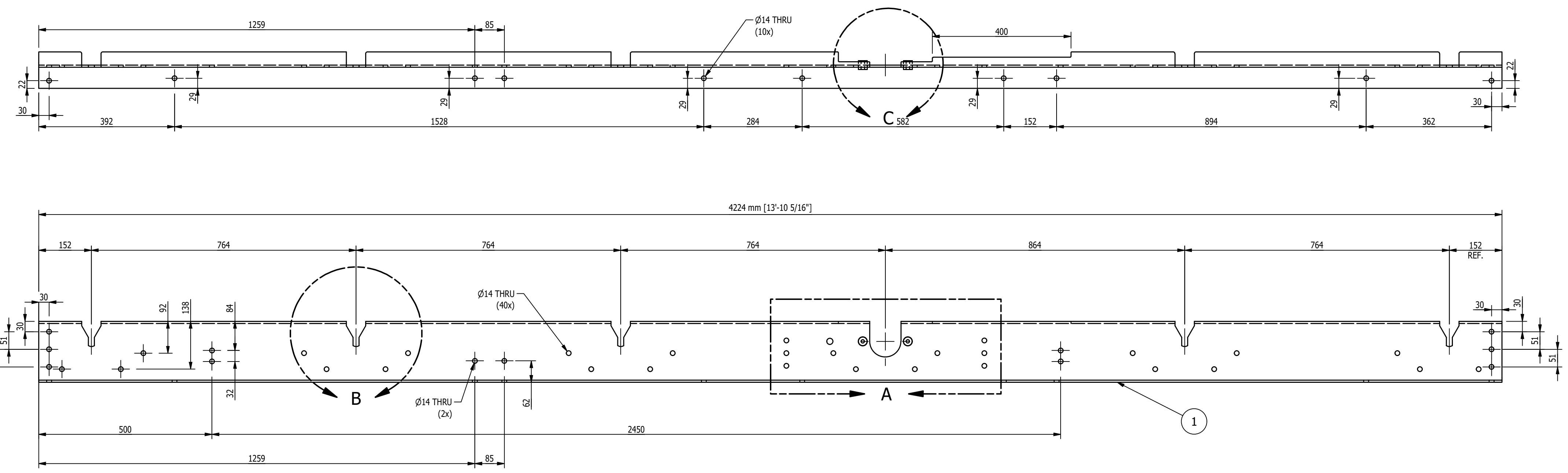
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

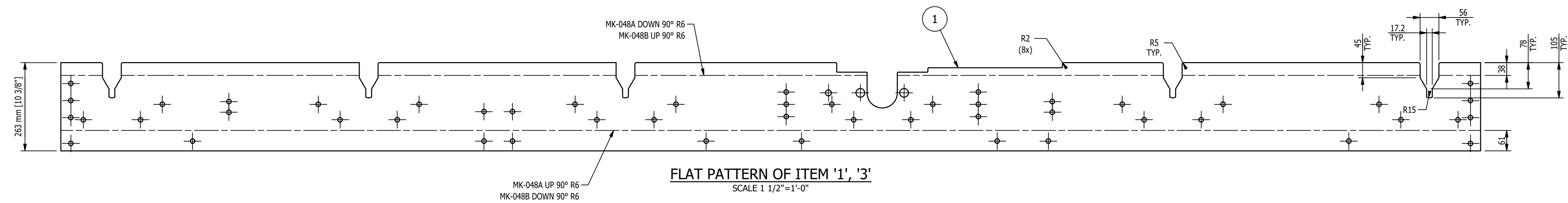
COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D048A			
1	1	BAR 1/4 x 10 3/8	13'-10 5/16"		
2	2	PL 1 x 1"	1"		
		MK-D048B			
2	2	PL 1 x 1"	1"		
3	1	BAR 1/4 x 10 3/8	13'-10 5/16"		



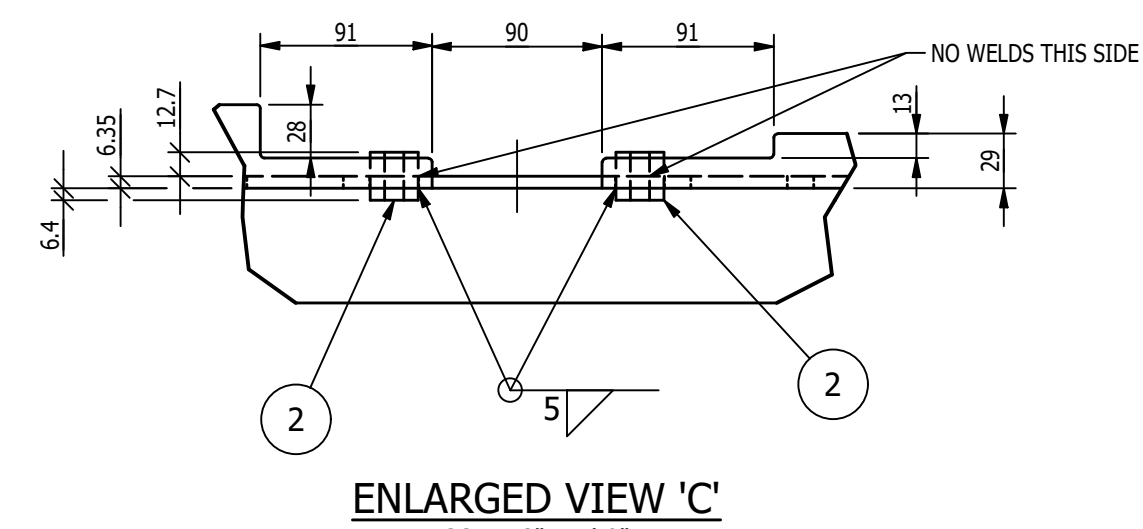
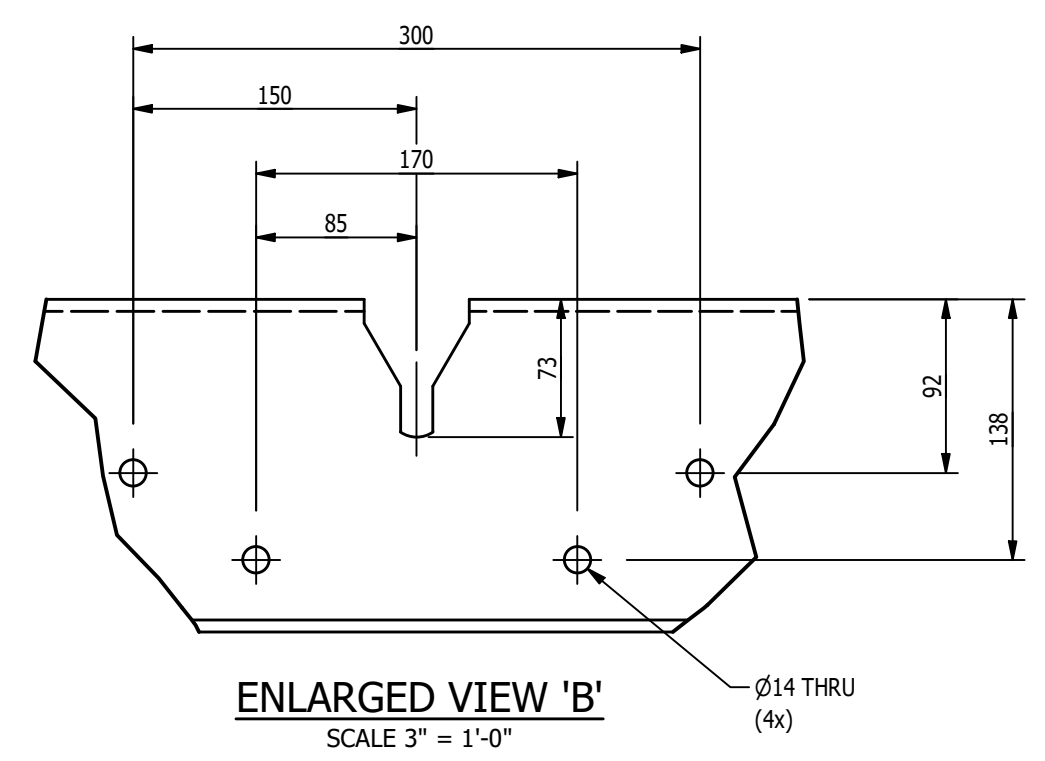
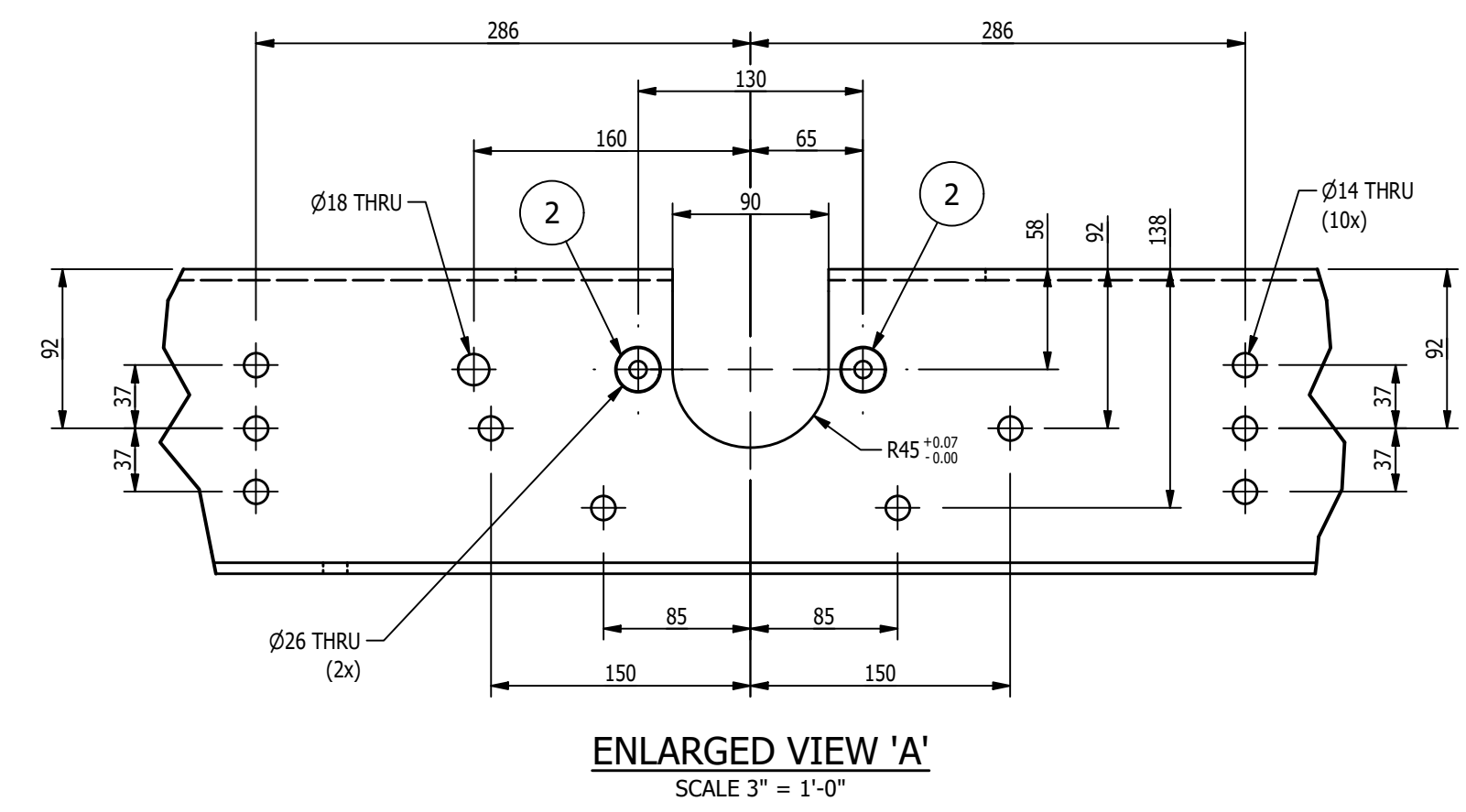
MK-D048A ~ 6-ROLL SIDE FRAME ASSY - RH (SHOWN)
MK-D048B ~ 6-ROLL SIDE FRAME ASSY - LH (OPPOSITE)
SCALE 1 1/2"=1'-0"



- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER

ONE SHOP COAT OF PURE ORANGE RAL 2004
OR
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.



GENERAL NOTES:

MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNIUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

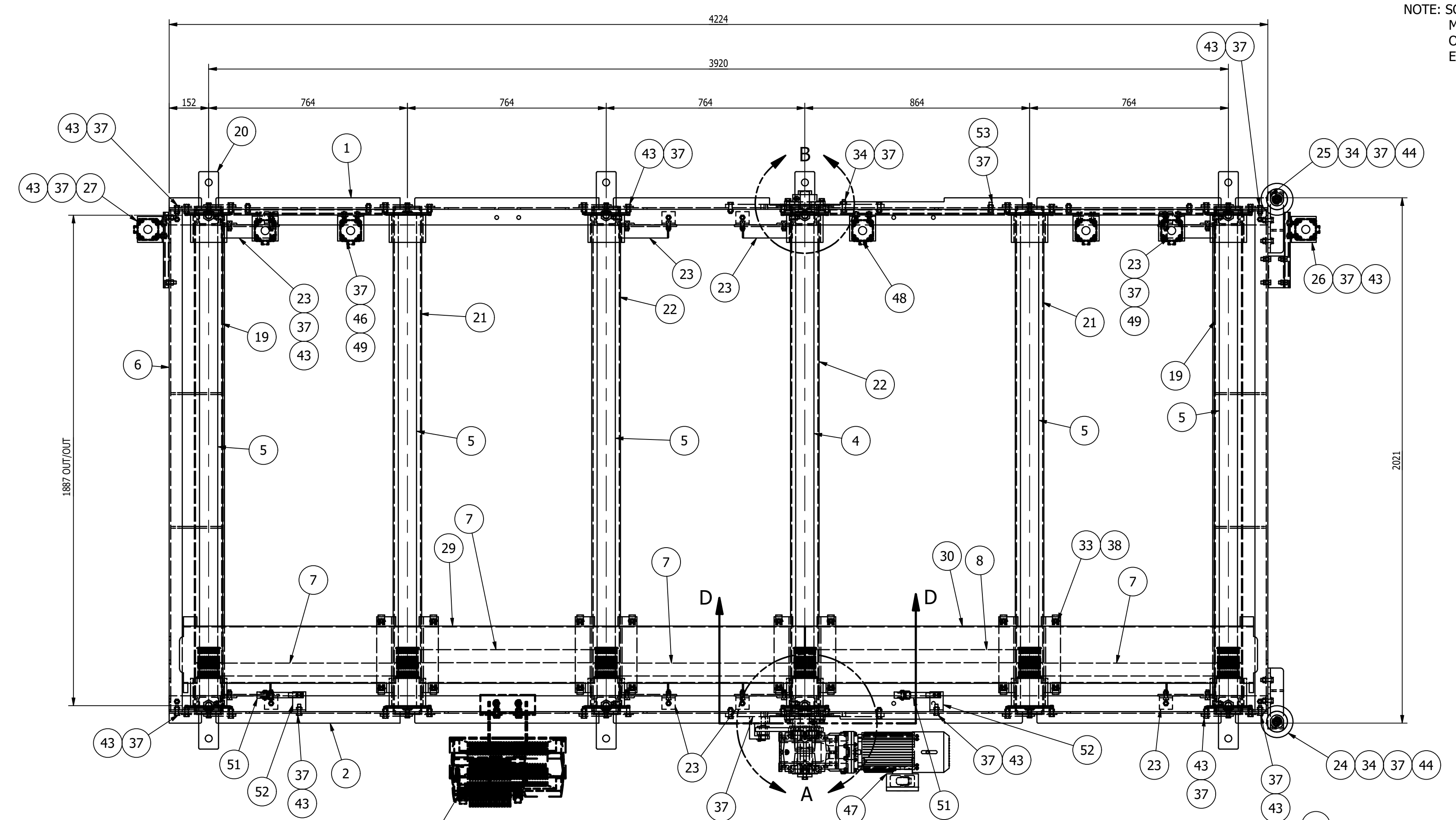
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

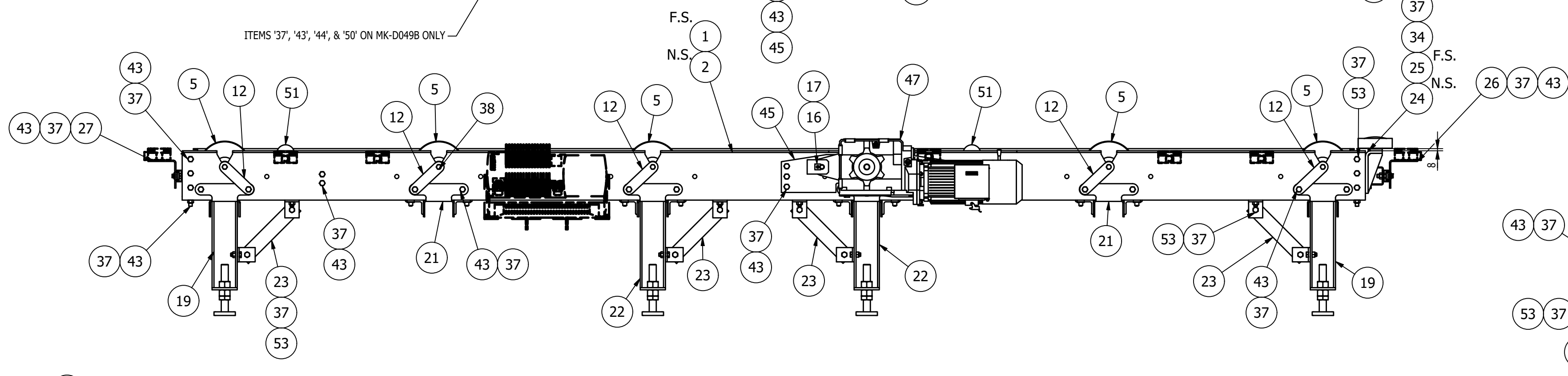
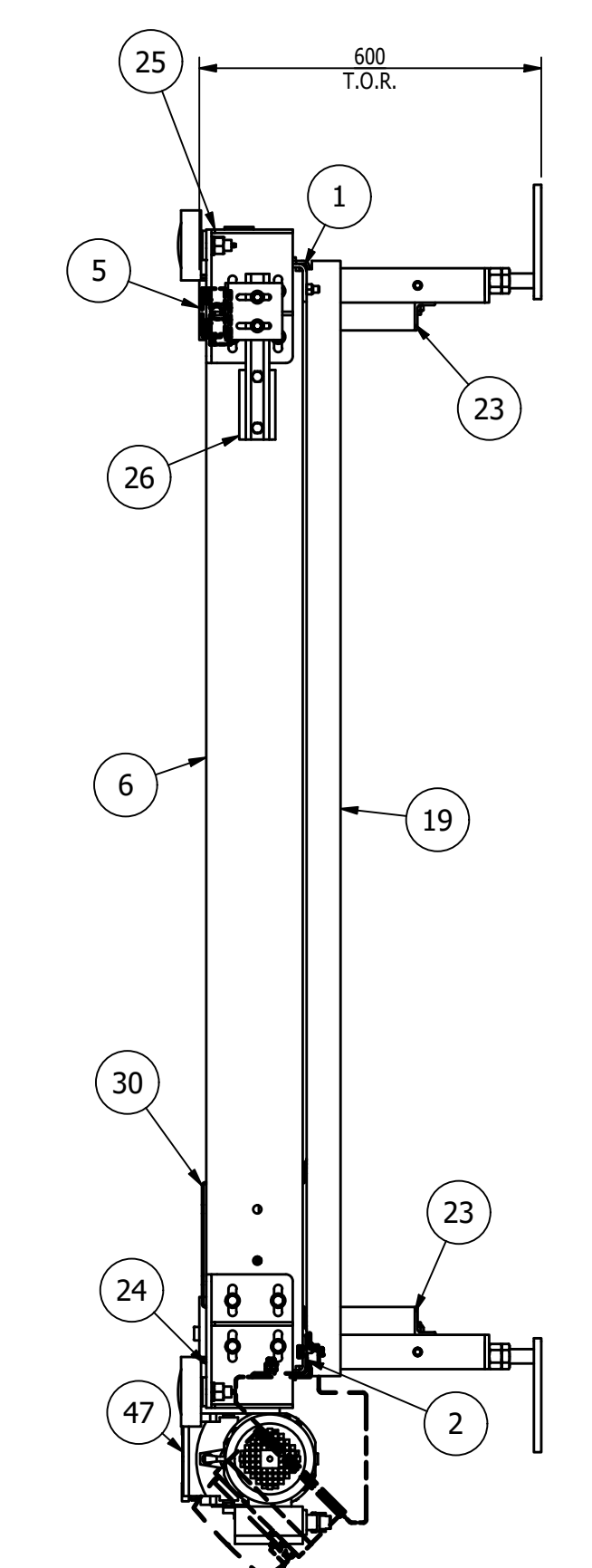
MAGNUM CONSULTING
41100 Clarkston Road
Suite 125
North, MI 48135
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D048

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

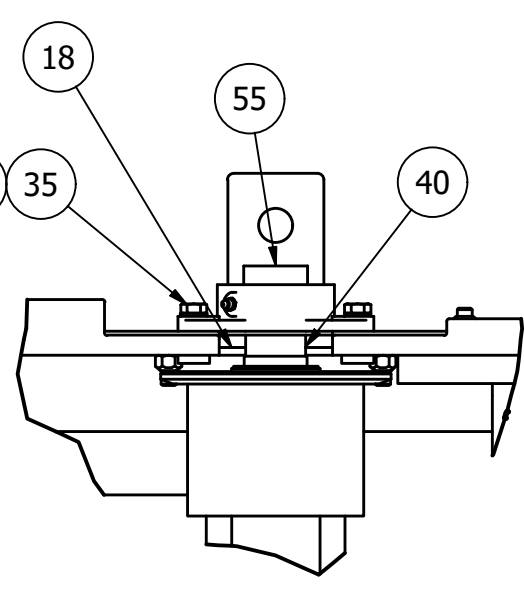
REV	BY	MC	DATE	DESCRIPTION	APP
A		MC	10/5/22	FOR FABRICATION	
REVISION HISTORY					
MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com					
TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D048				PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED. DRAWN BY: AH CHECKED BY: CW DWG DATE: 7/6/22 JOB No: 22096	



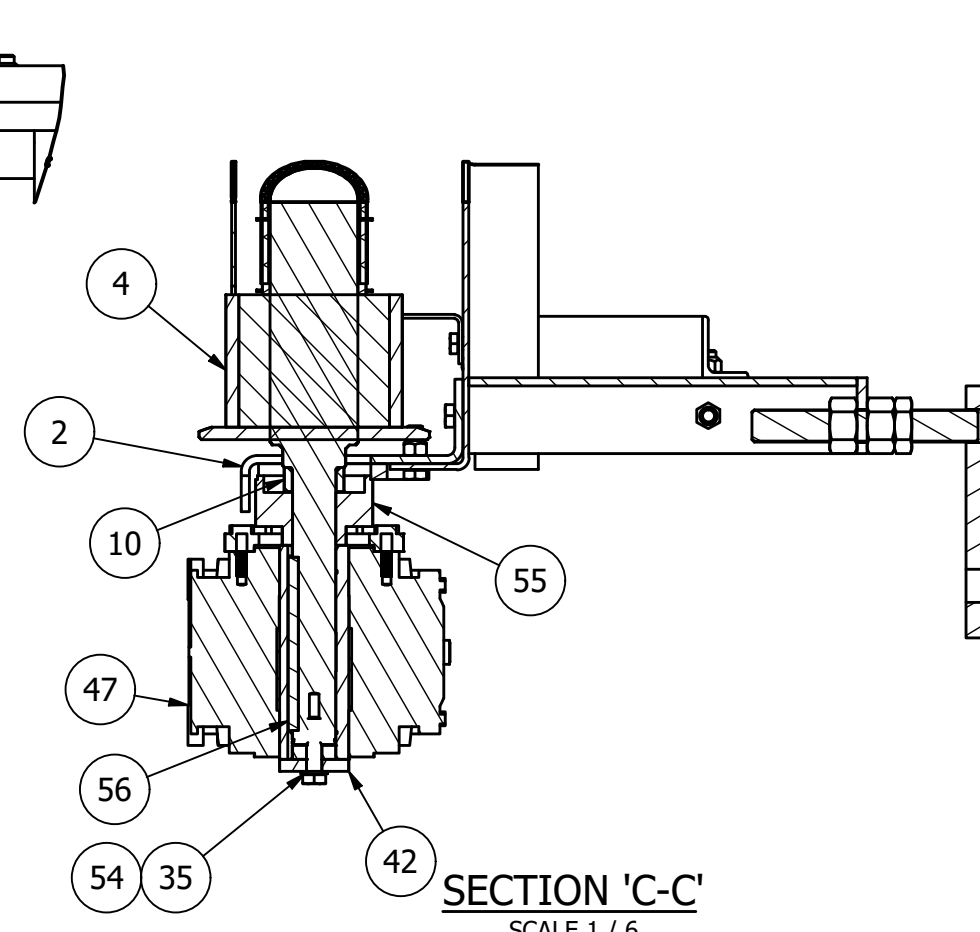
NOTE: SOME LOCATIONS REQUIRE MK-D006C, MK-D006D, MK-D009A, & MK-D009B TO BE ON OPPOSITE SIDE OF ROLL BED. REFER TO LAYOUT DRAWINGS FOR EXACT LOCATIONS OF THESE ITEMS.



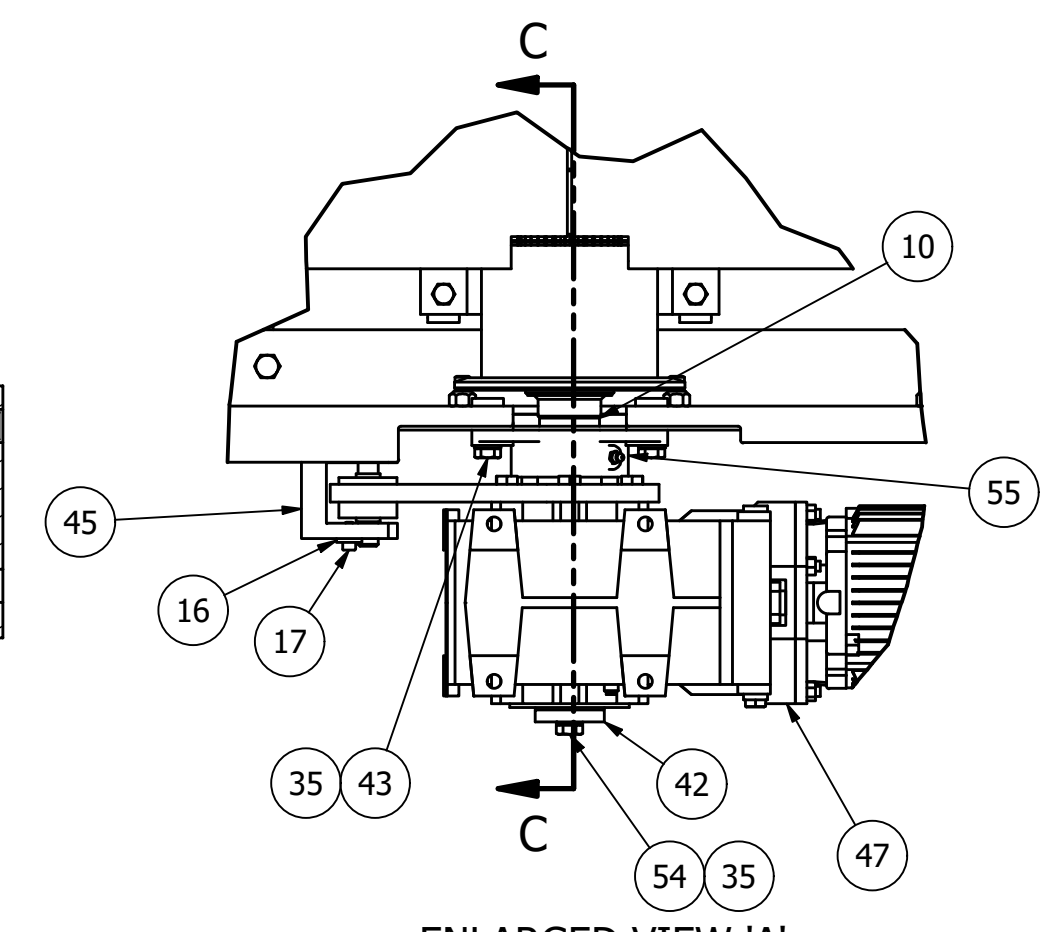
MK-D049A ~ 6 ROLL ASSY (WITHOUT MK-D047A)
 MK-D049B ~ 6-ROLL ASSEMBLY (WITH MK-D047A)
 SCALE 1"=1'-0"



ENLARGED VIEW 'B'
 SCALE 1 / 6



SECTION 'C-C'
 SCALE 1 / 6



ENLARGED VIEW 'A'
 SCALE 1 / 6

- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

MAGNUM CONSULTING
 41100 Clarkston Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D049

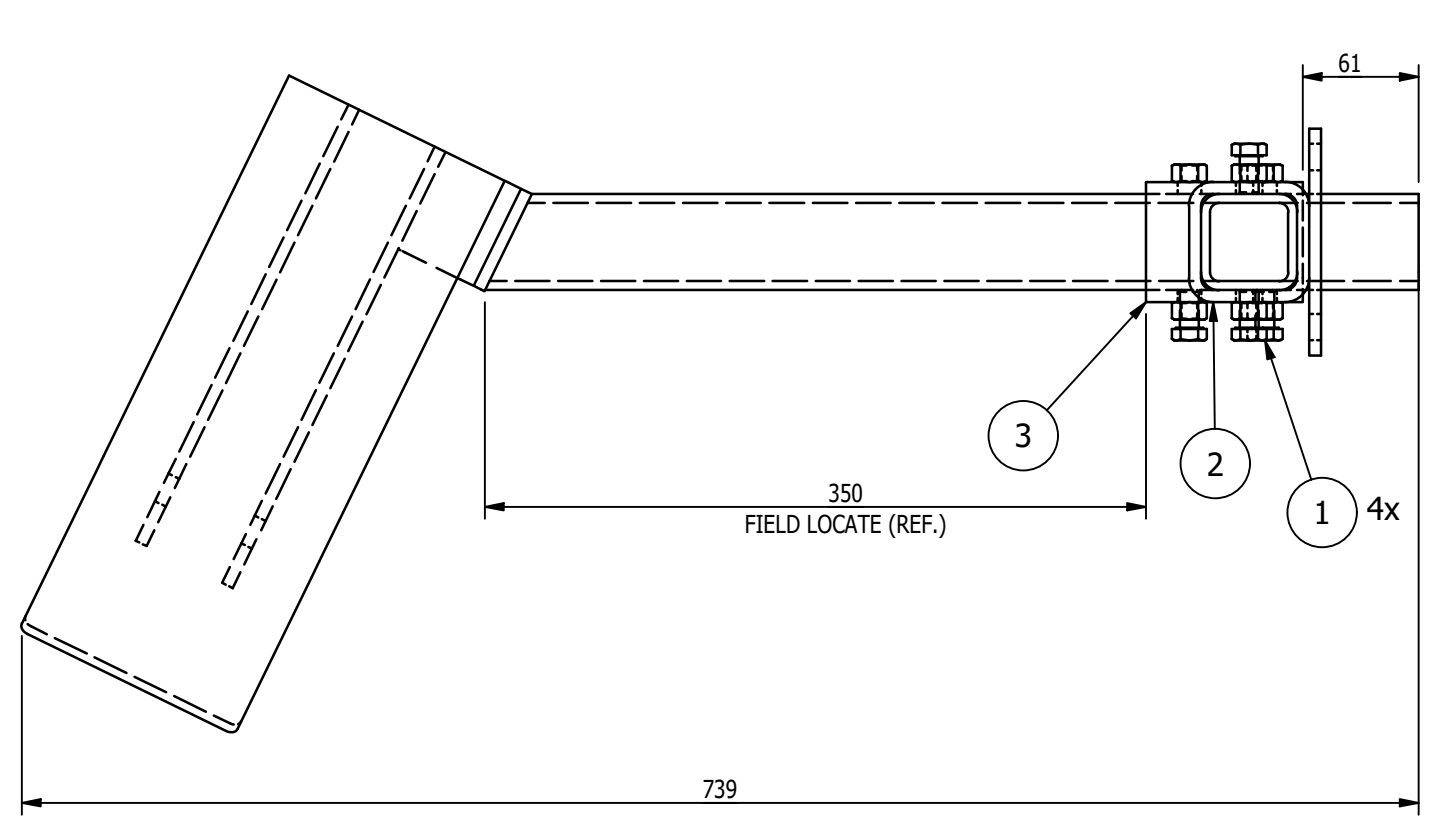
UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
 WELDS:
 - ALL WELDS TO BE 'E70XX' (PER AWS D1.1)
 PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

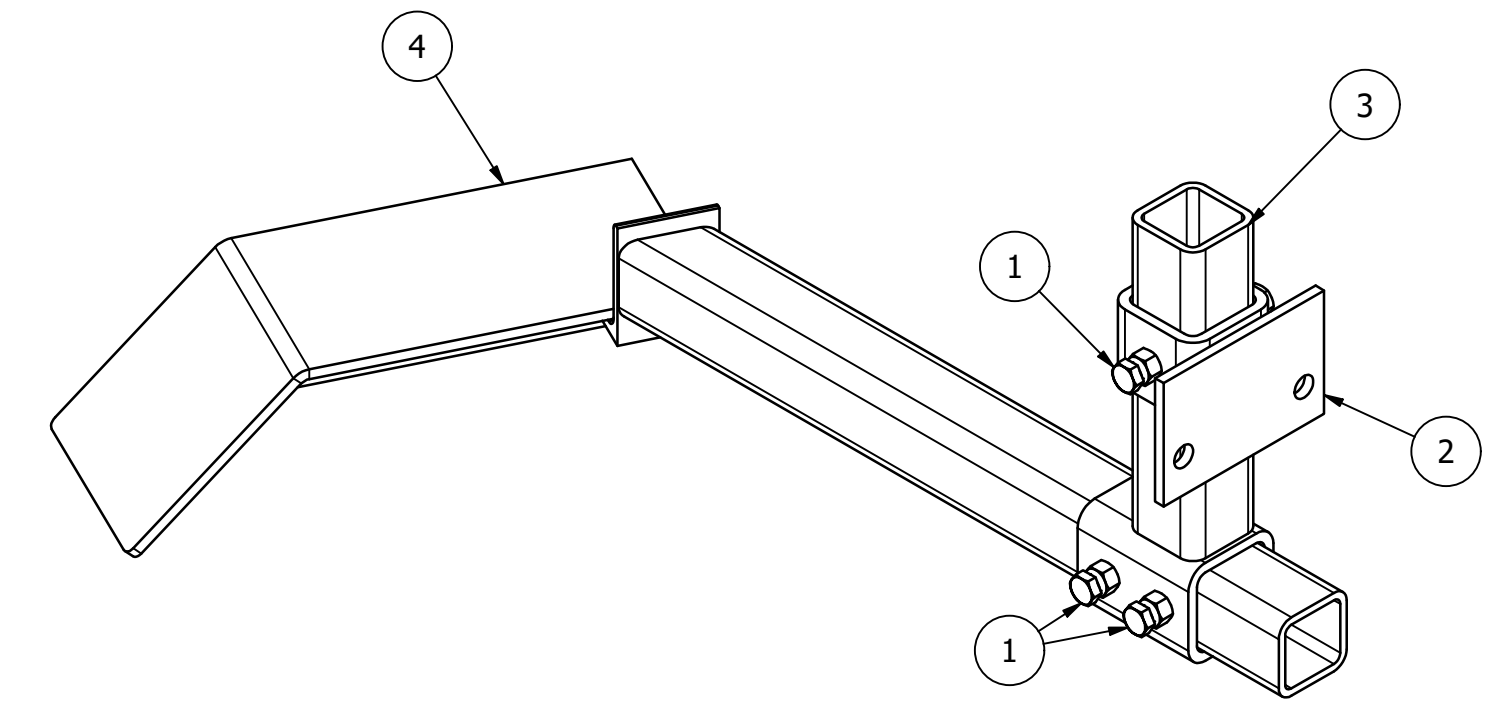
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D049A			
1	1	MK-D048A ~ 6-ROLL SIDE FRAME ASSY - RH			
2	1	MK-D048B ~ 6-ROLL SIDE FRAME ASSY - LH			
4	1	D140/70x8/35 HTD 8M-55 POWER ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVE ROLL, PART NO. 332306V			
5	5	D140/70/30 Z34 HTD 8M-55 DRIVEN ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVEN ROLL, PART NO. 329A060W			
6	2	MK-D002A ~ END PLATE ASSEMBLY			
7	4	GATES POWERGRIP GT4 BELT, 1800-8M-GT50		2-5	
8	1	GATES POWERGRIP GT4 BELT, 2000-8M-GT50		2-4	
10	1	MK-D005D ~ SHAFT SPACER			
12	10	MK-D005B ~ ROLL KEEPER			
16	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
17	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
18	1	MK-D005C ~ BEARING PLATE			
19	2	MK-D004B ~ LEG ASSEMBLY			
20	8	MK-D007A ~ ADJUSTING SUPPORT			
21	2	MK-D004C ~ CROSS MEMBER WITH GUARD SUPPORT			
22	2	MK-D004D ~ CROSS MEMBER WITH GUARD SUPPORT AND LOCATOR			
23	8	MK-D008A ~ ANGLE BRACE			
24	1	MK-D006C ~ SKID GUIDE ROLLER - LH			
25	1	MK-D006D ~ SKID GUIDE ROLLER - RH			
26	1	MK-D009A ~ PROX BRACKET			
27	1	MK-D009B ~ PROX BRACKET			
29	1	MK-D010A ~ BELT GUARD			
30	1	MK-D040A ~ 6-ROLL BELT GUARD			
33	16	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
34	9	M12x1.75 x 40mm LG. HEX CAP SCREW			
35	5	M12 SPRING LOCK WASHER			
37	104	M12 x 1.75 STOVER LOCK NUT			
38	26	M10x1.5 x 25mm LG. HEX CAP SCREW			
40	1	MK-D005E ~ SHAFT SPACER			
42	1	MK-D005F ~ MOTOR END PLATE			
43	47	M12x1.75 x 35mm LG. HEX CAP SCREW			
44	16	M12 NARROW FLAT WASHER			
45	1	MK-D005A ~ BEARING PLATE			
46	2	MK-D009D ~ PROX BRACKET			
47	1	SIEMENS RB2 GEARMOTOR (SEE MOTOR DATA LIST)		1-2	
48	1	MK-D009C ~ PROX BRACKET			
49	4	M12x1.75 x 25mm LG. HEX CAP SCREW			
51	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
52	2	MK-D005G ~ STATIC WHEEL BRACKET			
53	49	M12x1.75 x 30mm LG. HEX CAP SCREW			
54	1	M12x1.75 x 45mm LG. HEX CAP SCREW			
55	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
56	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	
		TOTAL WEIGHT ~ 2221.8 lbs			
		MK-D049B			
37	4	M12 x 1.75 STOVER LOCK NUT			
43	4	M12x1.75 x 35mm LG. HEX CAP SCREW			
44	4	M12 NARROW FLAT WASHER			
50	1	MK-D047A ~ CONTROLLER BRACKET			
57	1	MK-D049A ~ 6-ROLL SHUTTLE ASSEMBLY			
		TOTAL WEIGHT ~ 2245.4 LBS			

REV	BY	DATE	DESCRIPTION	APP
A	MC	10/5/22	FOR FABRICATION	
REVISION HISTORY				

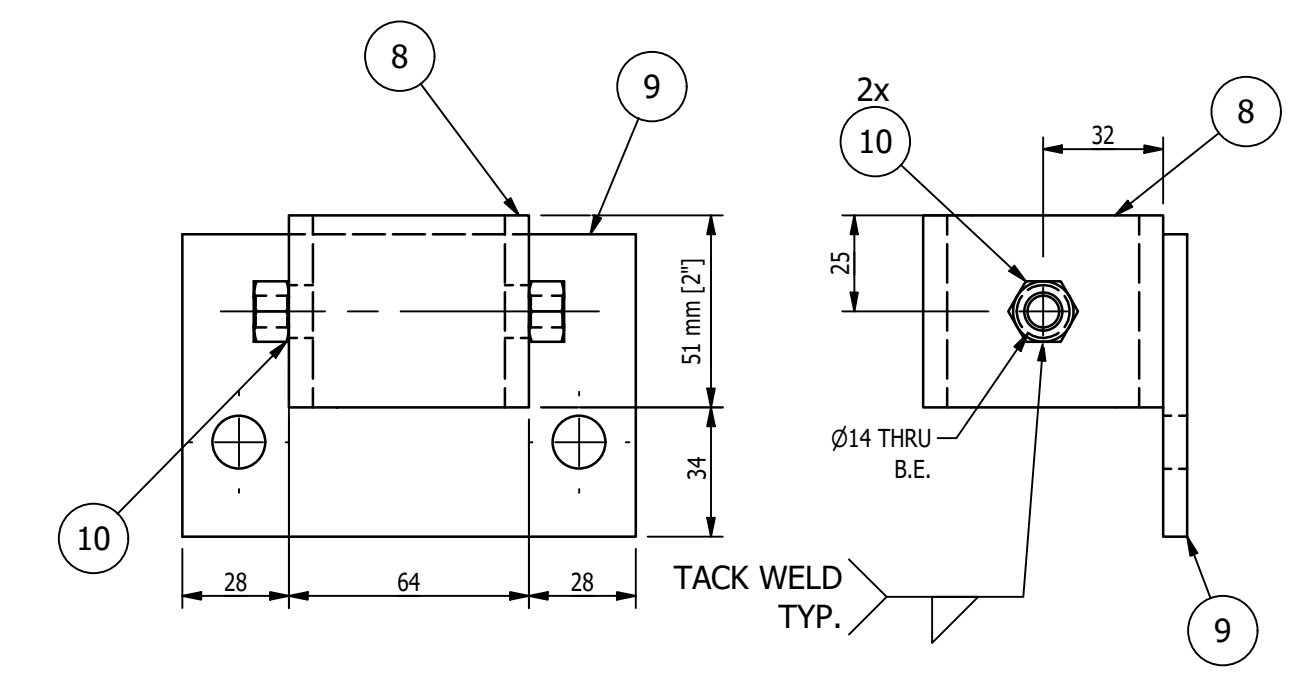
<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com</p>		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D049	DWG DATE:	7/6/22
REV:	A	JOB No.:	22096



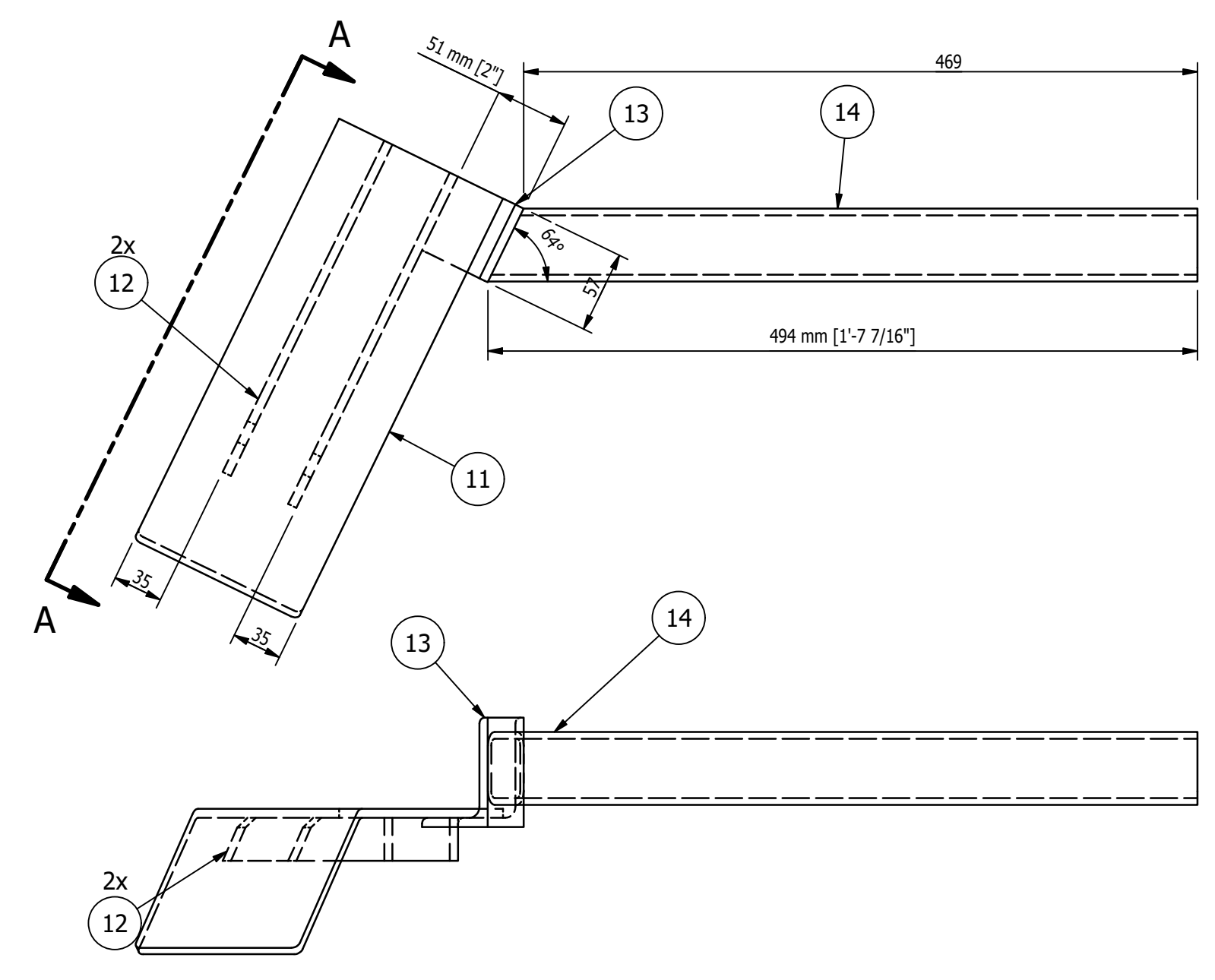
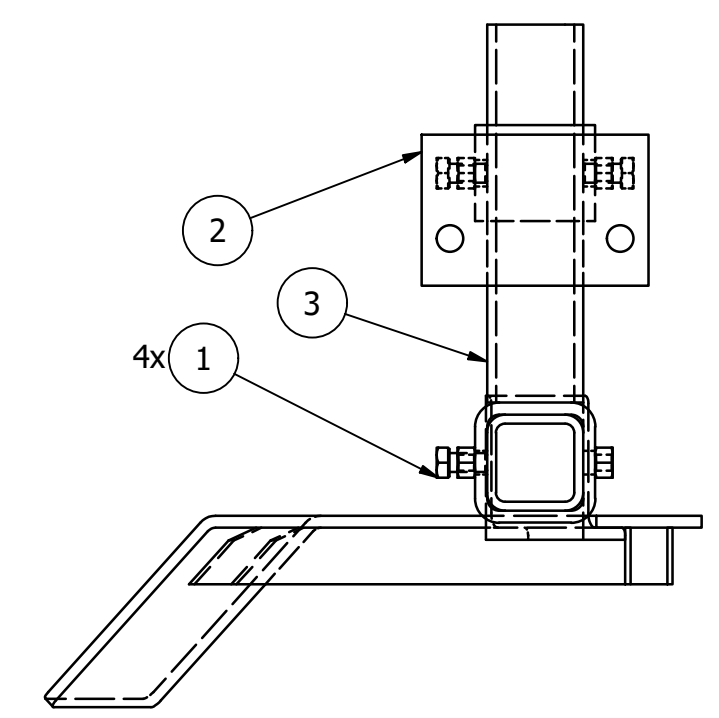
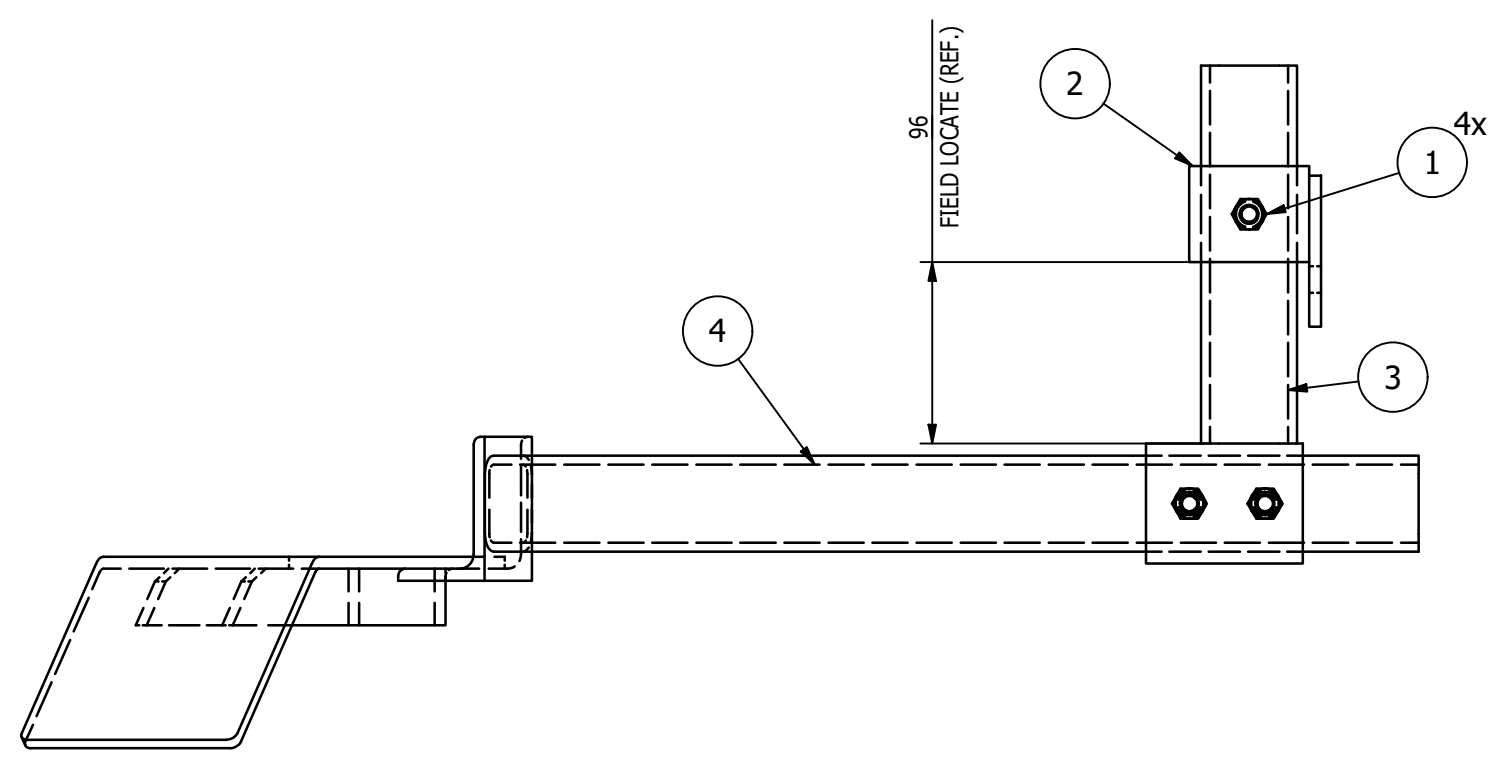
MK-D050A ~ STOP TRIGGER
SCALE 3"=1'-0"



MK-D050C ~ ATTACHMENT BASE
SCALE 6"=1'-0"

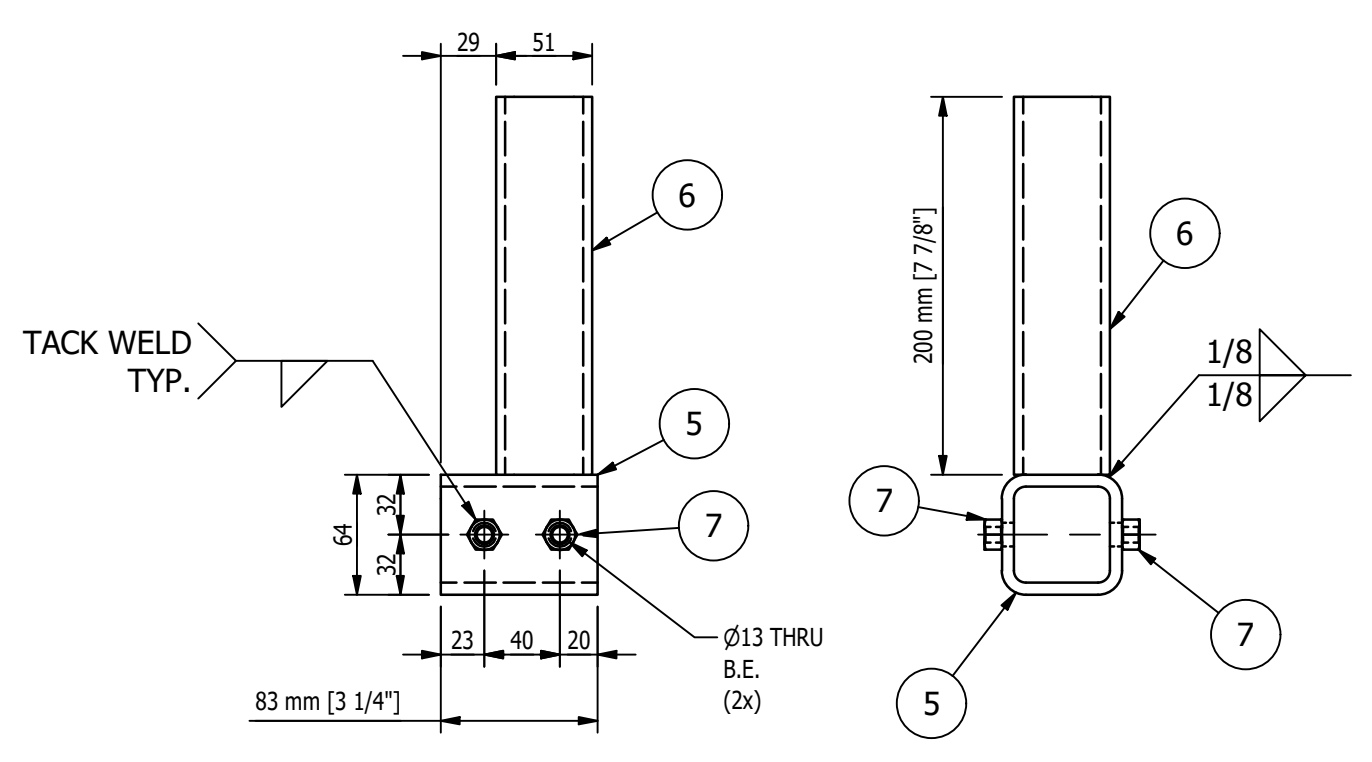


BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D050A			
1	4	M10x1.5 x 20mm LG. HEX CAP SCREW			
2	1	MK-D050C ~ ATTACHMENT BASE			
3	1	MK-D050B ~ UPPER ADJUSTMENT			
4	1	MK-D050D ~ LOWER ADJUSTMENT			
		MK-D050B			
5	1	TS 2 1/2 x 2 1/2 x 7 GA.	3 1/4"		
6	1	TS 2 x 2 x 3/16	7 7/8"		
7	4	M10 x 1.5 HEX NUT			
		MK-D050C			
8	1	TS 2 1/2 x 2 1/2 x 7 GA.	2"		
9	1	PL 1/4 x 3 1/8"	4 3/4"		
10	2	M10 x 1.5 HEX NUT			
		MK-D050D			
11	1	BAR 1/4 x 5	1'-2 1/4"		
12	2	PL 1/4 x 1 3/16"	10 1/8"	B	
13	1	L 3 x 2 x 1/4	2 1/4"		
14	1	TS 2 x 2 x 3/16	1'-7 7/16"		

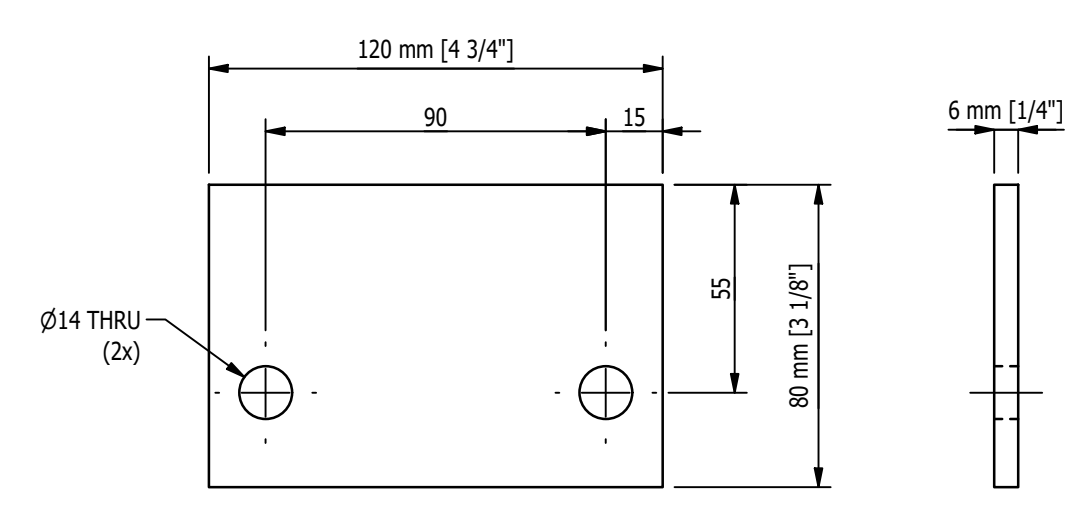


MK-D050D ~ LOWER ADJUSTMENT
SCALE 3"=1'-0"

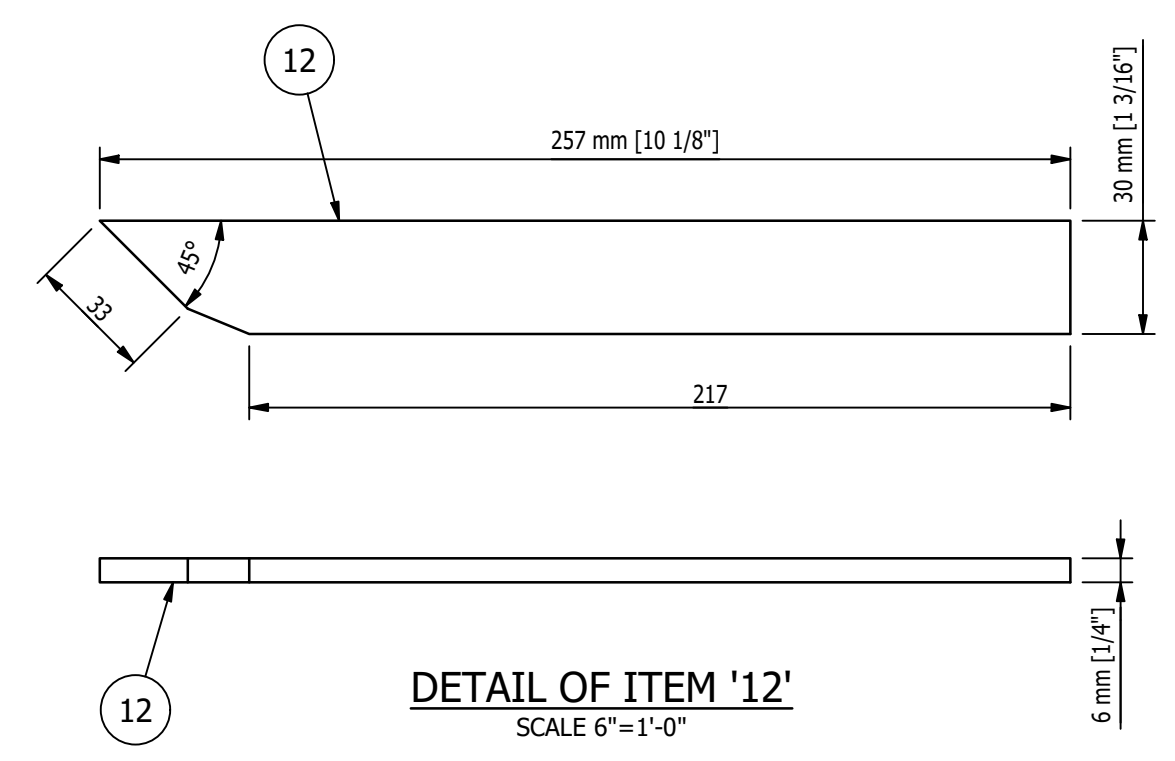
NOTE:
FOR EXACT POSITIONS ON MK-D050A,
SEE LAYOUTS



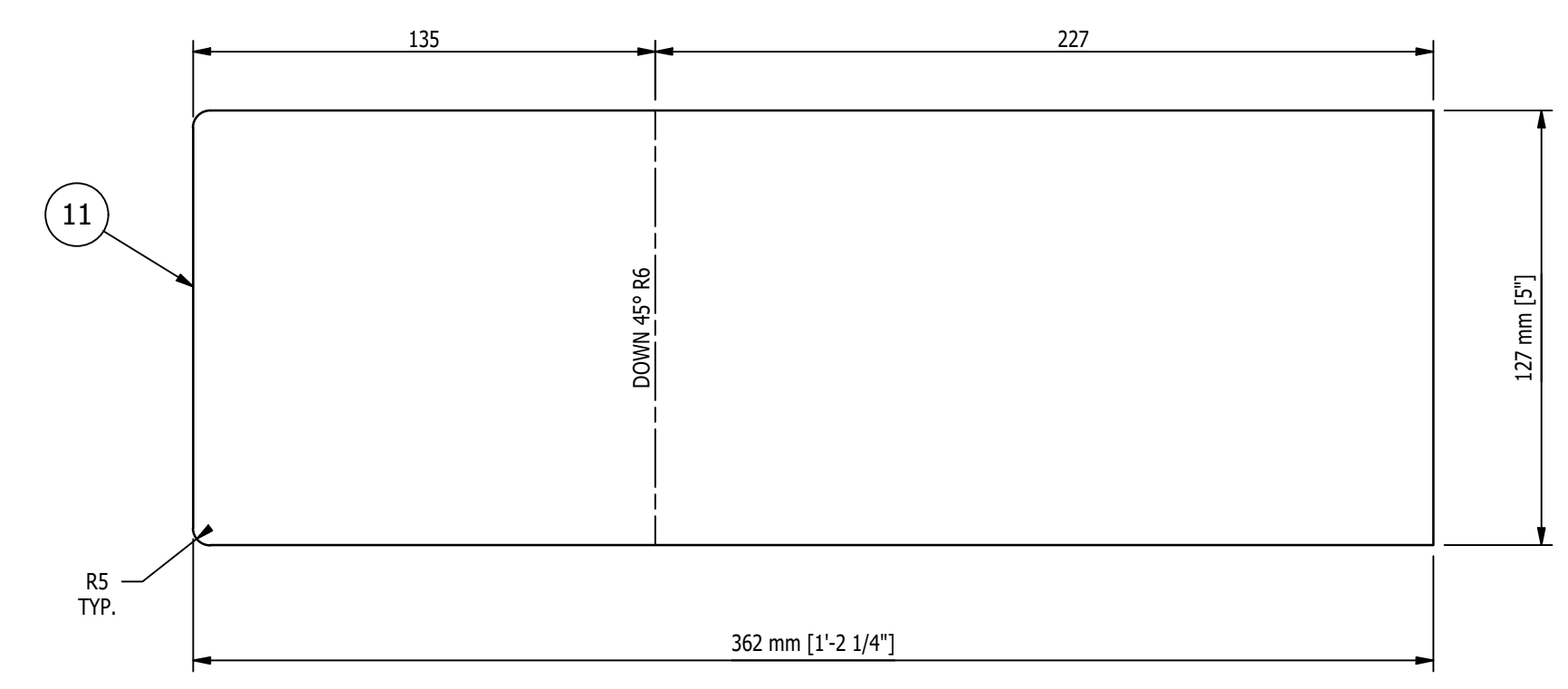
MK-D050B ~ UPPER ADJUSTMENT
SCALE 3"=1'-0"



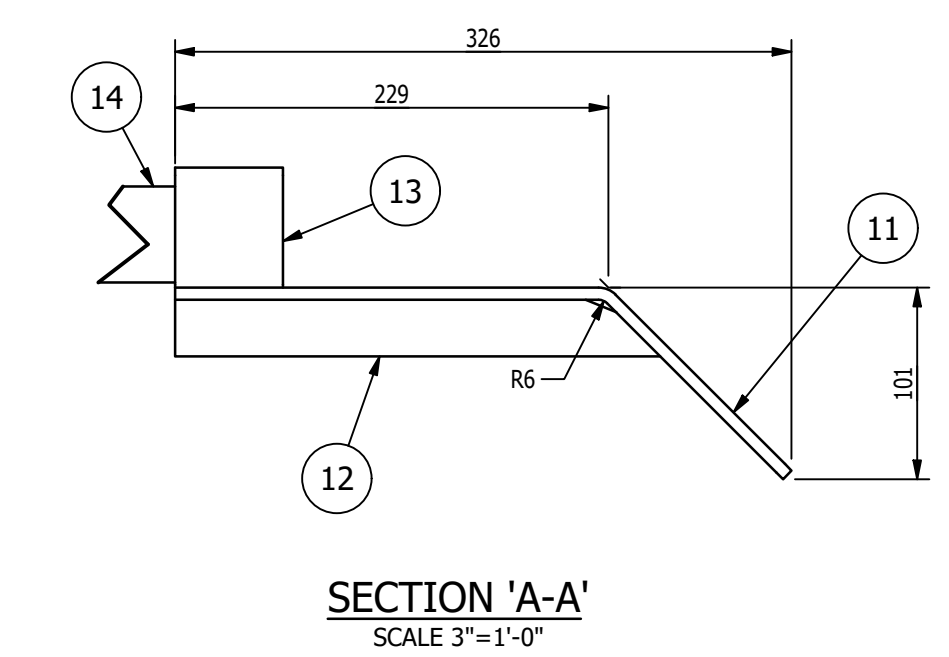
DETAIL OF ITEM '9'
SCALE 6"=1'-0"



DETAIL OF ITEM '12'
SCALE 6"=1'-0"



FLAT PATTERN OF ITEM '11'
SCALE 6"=1'-0"



SECTION 'A-A'
SCALE 3"=1'-0"

PAINT NOTES:
PAINT ALL FABRICATED STEEL WITH ONE
SHOP COAT OF PURE ORANGE RAL 2004
DO NOT PAINT MACHINED ITEMS, FASTENERS
OF PURCHASED ITEMS.

SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST,
SCALE & WELD SLAG
2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS
FILLET UNLESS OTHERWISE SPECIFIED.
6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5
AND ZINC PLATED
7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE
APPLICABLE) WITH MK IDENTIFIERS.
8. ALL SLOT LENGTHS ARE END TO END U.N.O.

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	REVISED LENGTH ITEM 12 IN BOM	
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY	
B	MC 10/10/22 REVISED LENGTH ITEM 12 IN BOM
A	MC 9/16/22 FOR FABRICATION

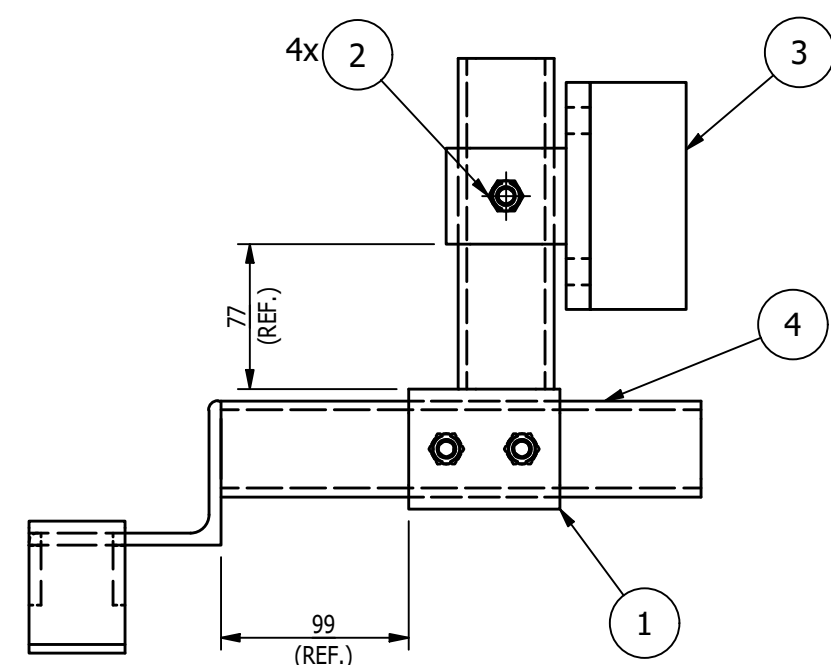
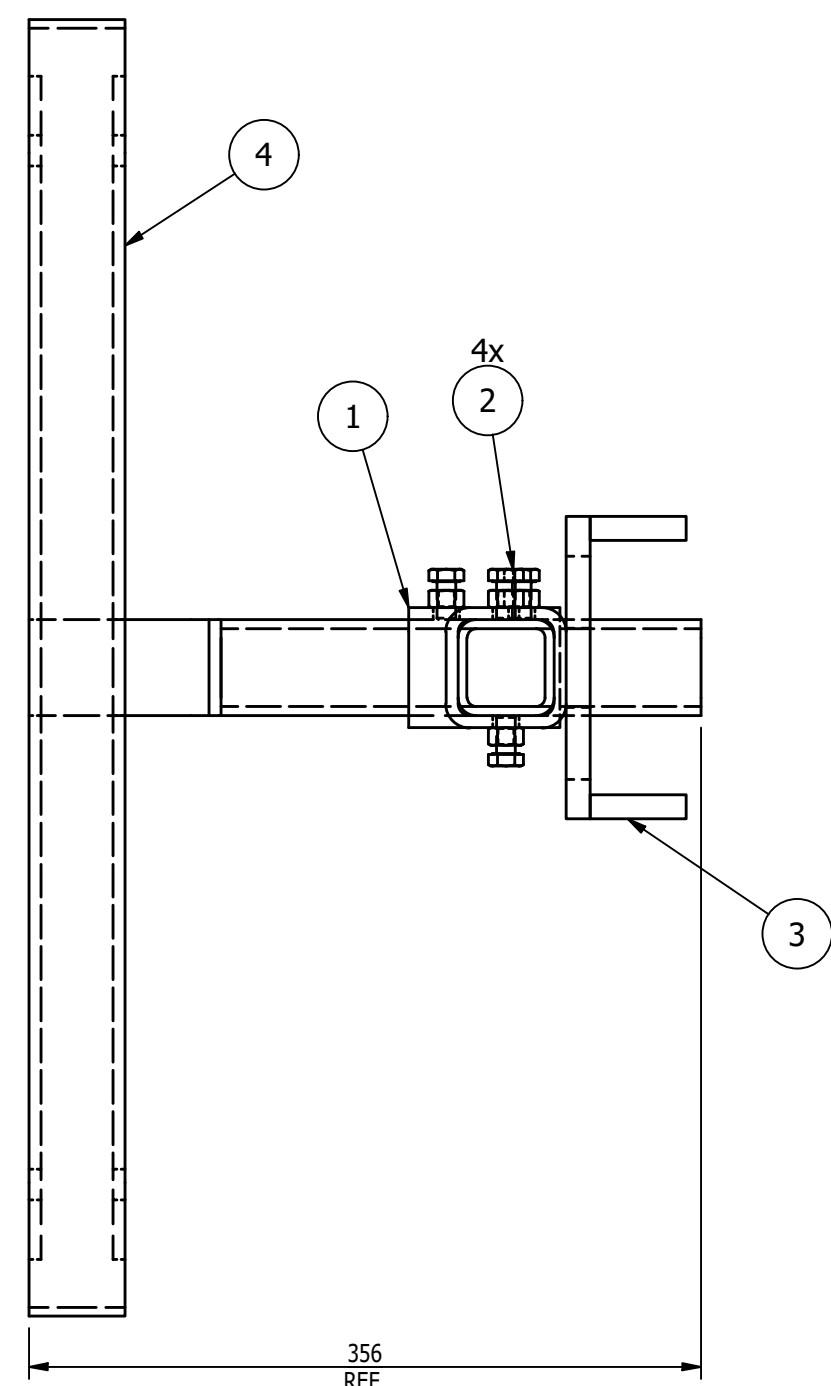
mi	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH
CLIENT:	VOLVO	CHECKED BY: CW
DRAWING No.	1875D050	DWG DATE: 7/12/22
REV:	B	JOB No: 22096

MAGNUM Consulting
4110 QuakerRoad Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D050 - REV B

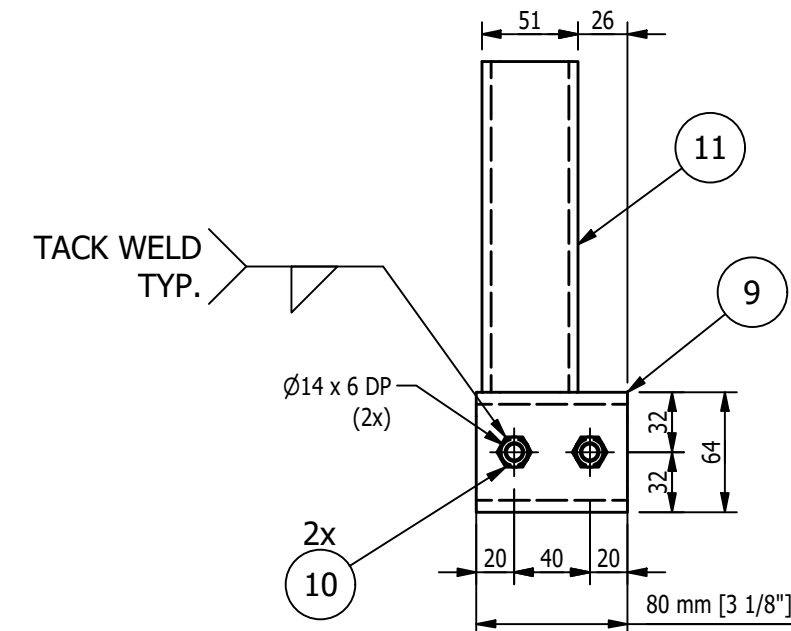
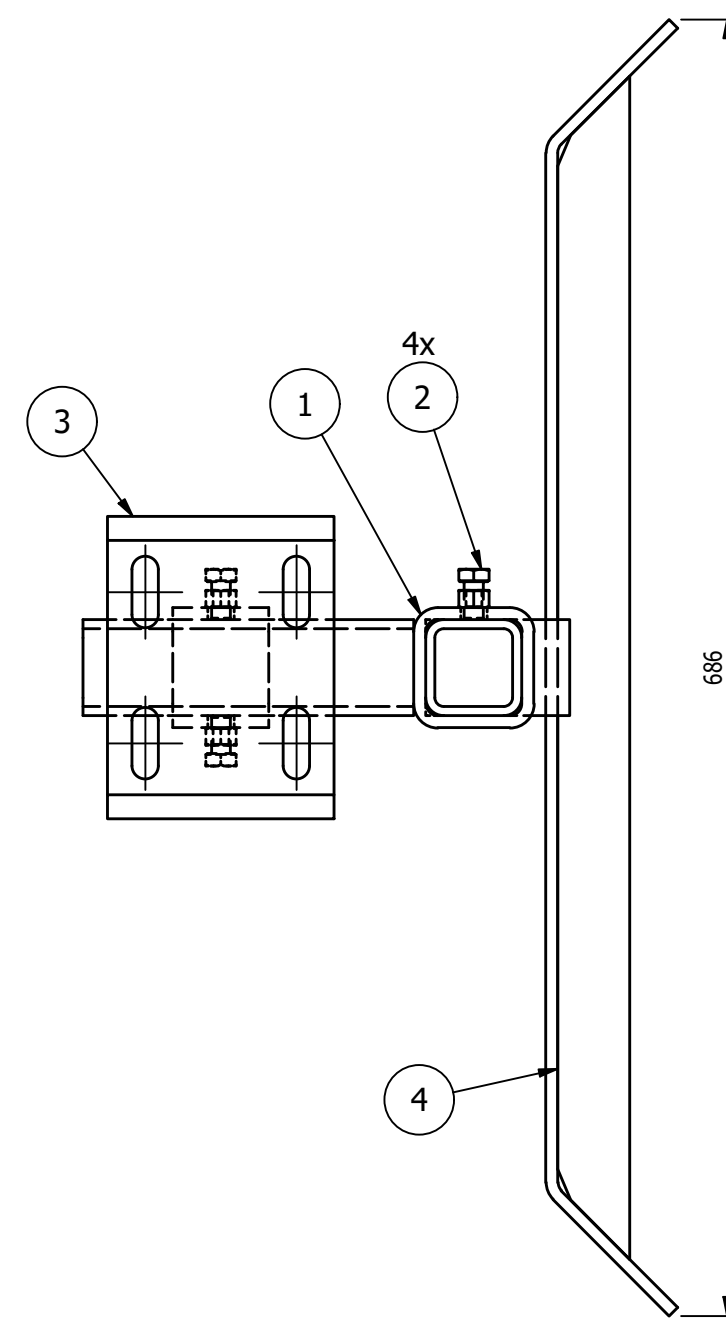
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N
(SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS
INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

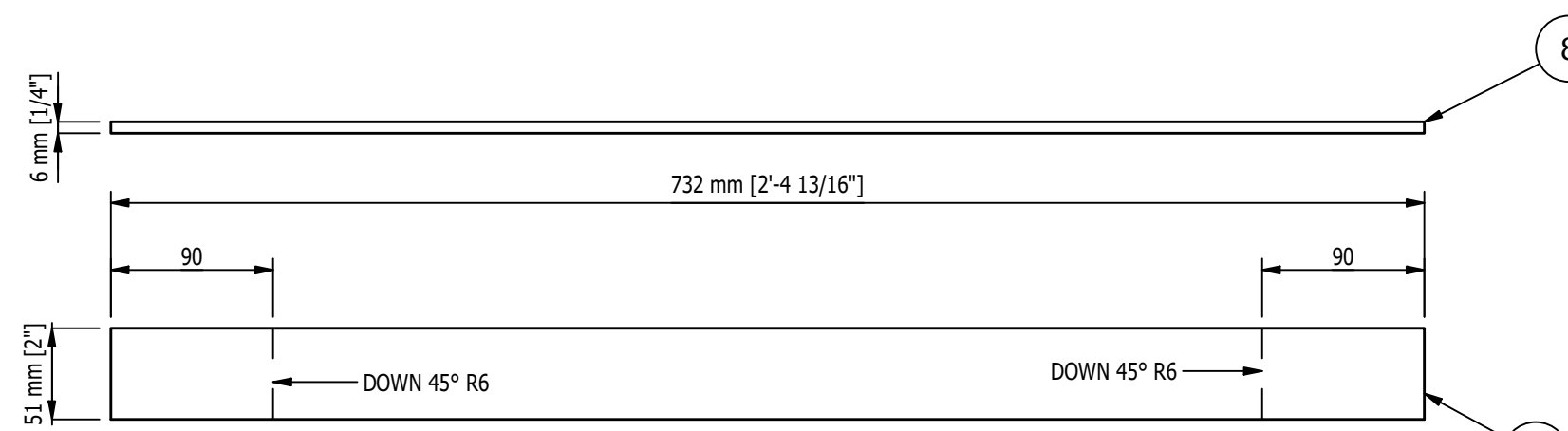


MK-D051A ~ STOP TRIGGER
SCALE 3"=1'-0"

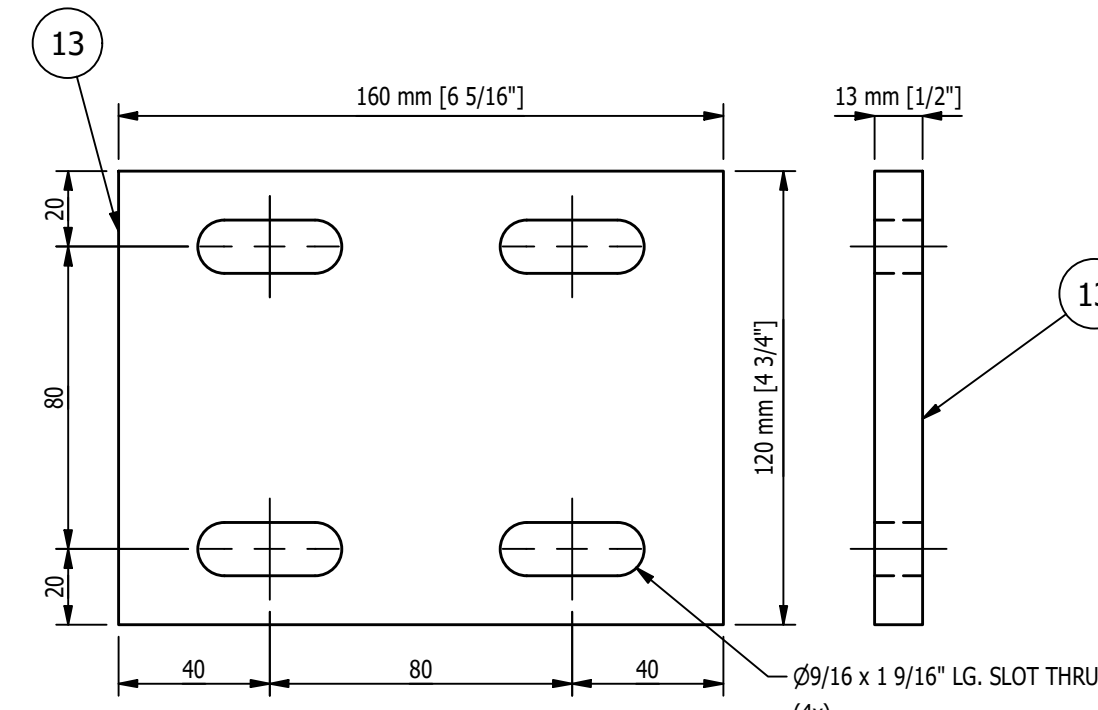
NOTE:
FOR EXACT POSITIONS ON MK-D051A,
SEE LAYOUTS



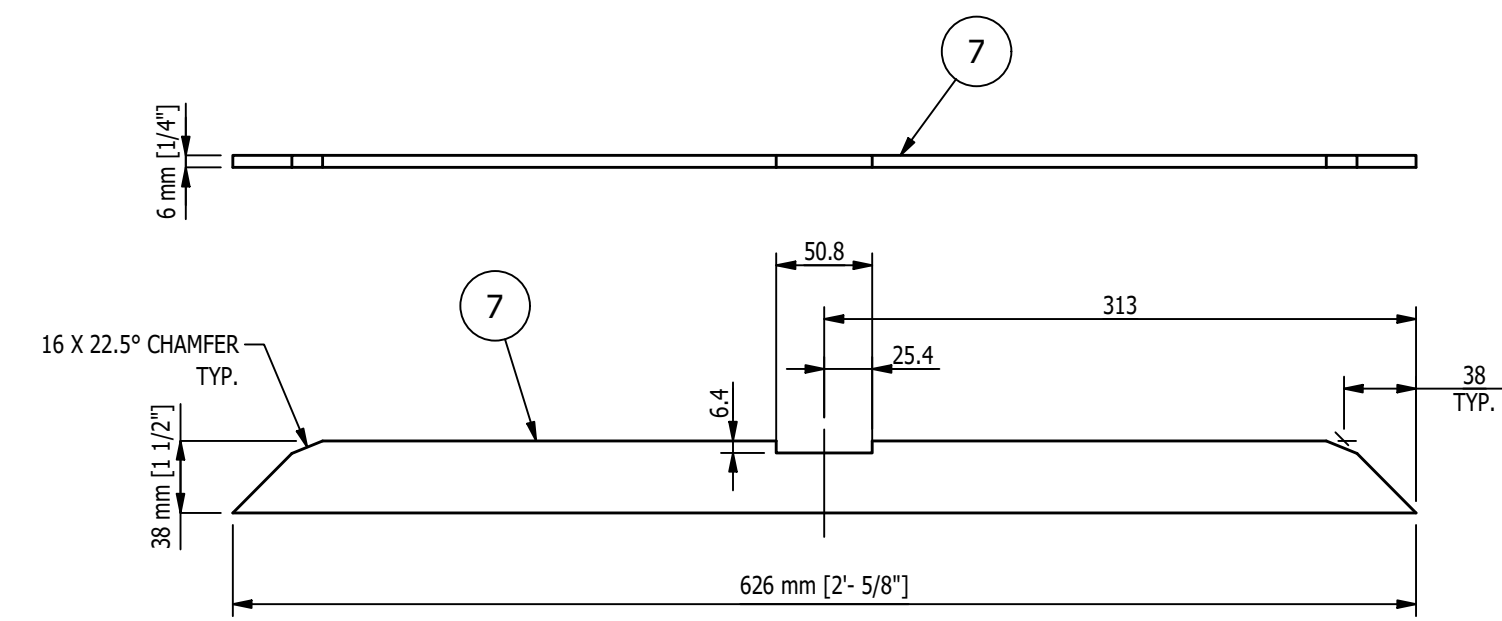
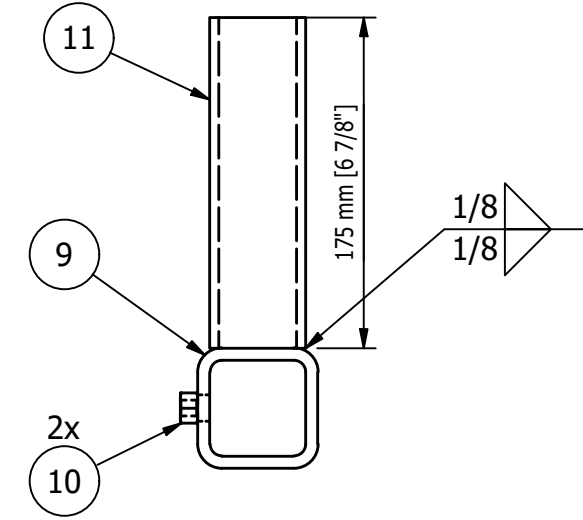
MK-D051C ~ UPPER ADJUSTMENT
SCALE 3"=1'-0"



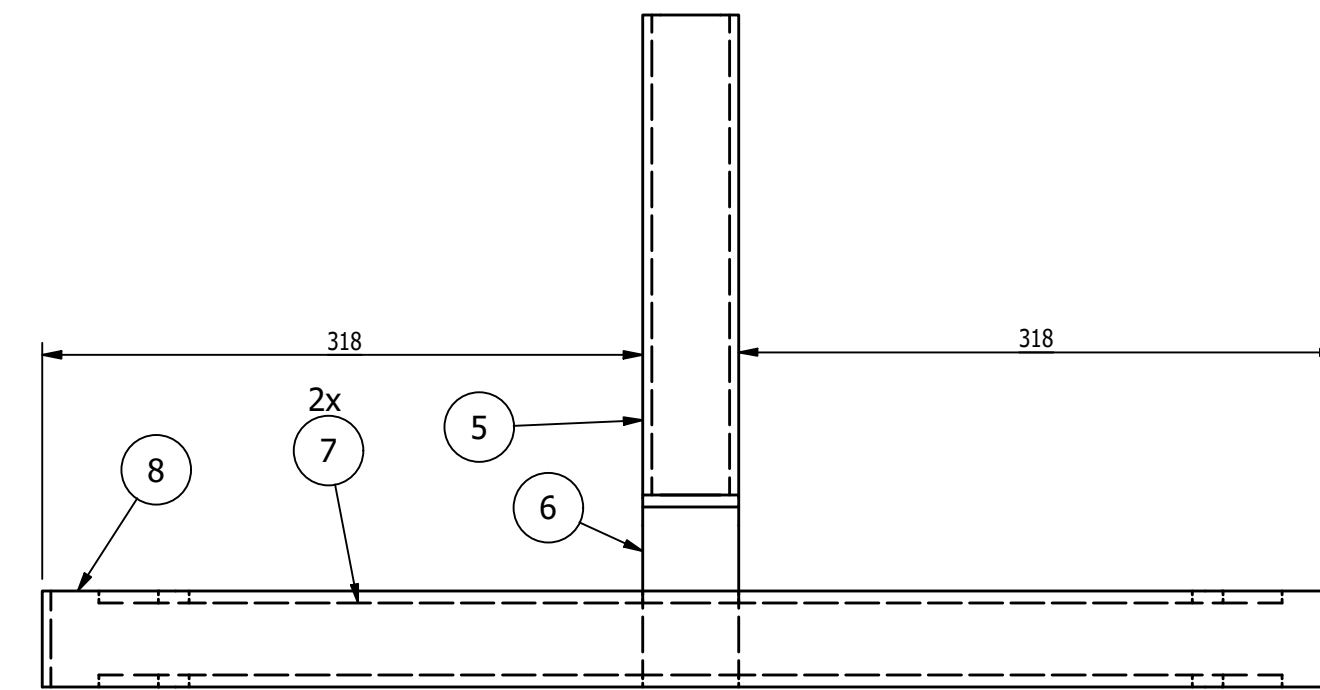
FLAT PATTERN OF ITEM '8'
SCALE 3"=1'-0"



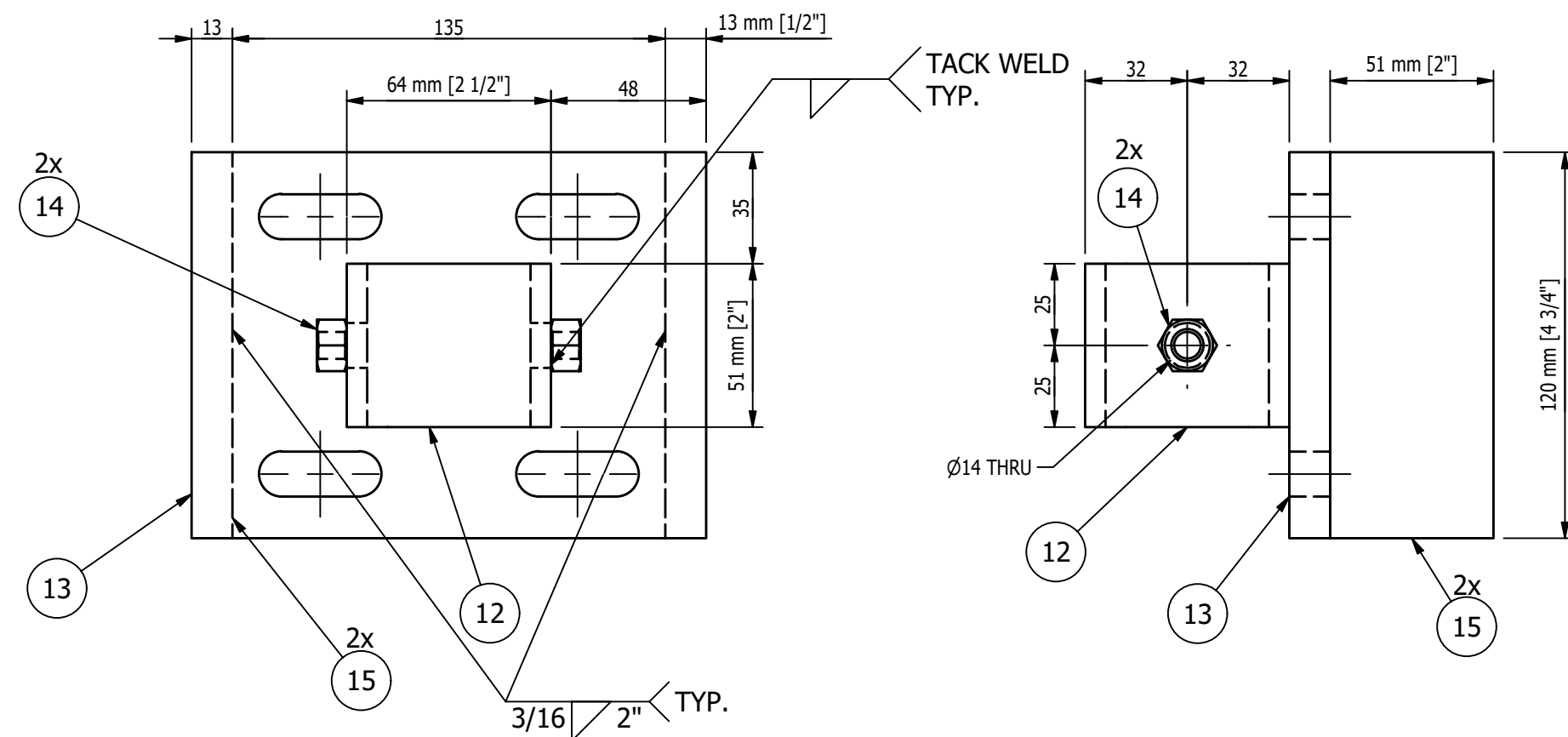
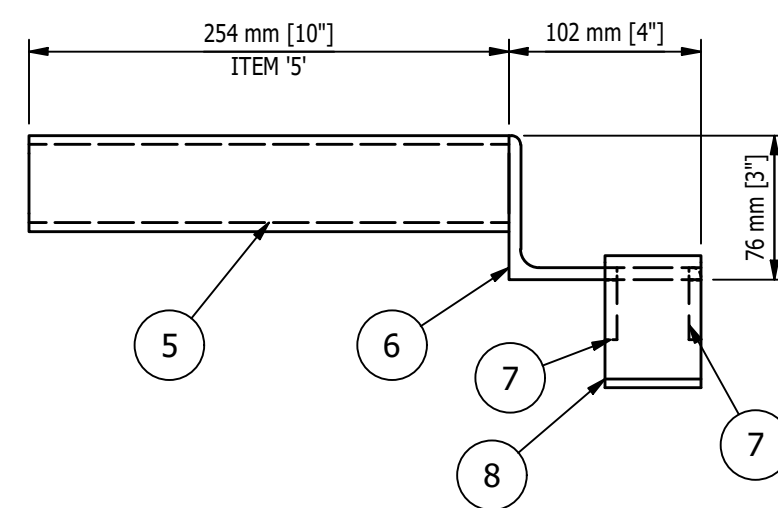
DETAIL OF ITEM '13'
SCALE 6"=1'-0"



DETAIL OF ITEM '7'
SCALE 3"=1'-0"



MK-D051B ~ LOWER ADJUSTMENTS
SCALE 3"=1'-0"



MK-D051D ~ ATTACHMENT BASE
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D051A			
1	1	MK-D051C ~ UPPER ADJUSTMENT			
2	4	M10x1.5 x 20mm LG. HEX CAP SCREW			
3	1	MK-D051D ~ ATTACHMENT BASE			
4	1	MK-D051B ~ LOWER ADJUSTMENTS			
		MK-D051B			
5	1	TS 2 x 2 x 3/16	10"		
6	1	L 4 x 3 x 1/4	2"		
7	2	PL 1/4 x 1 1/2"	2'- 5/8"		
8	1	PL 1/4 x 2"	2'-4 13/16"		
		MK-D051C			
9	1	TS 2 1/2 x 2 1/2 x 7 GA.	3 1/8"		
10	2	M10 x 1.5 HEX NUT			
11	1	TS 2 x 2 x 3/16	6 7/8"		
		MK-D051D			
12	1	TS 2 1/2 x 2 1/2 x 7 GA.	2"		
13	1	PL 1/2 x 4 3/4"	6 5/16"		
14	2	M10 x 1.5 HEX NUT			
15	2	PL 1/2 x 2"	4 3/4"		

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	MC	DATE	DESCRIPTION	APP
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
--	---	---

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D051	DWG DATE: 7/12/22
REV: A	JOB No: 22096

MAGNUM CONSULTING
41100 Charleston Rd.
Suite 125
Wood, MI 48095
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D051

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

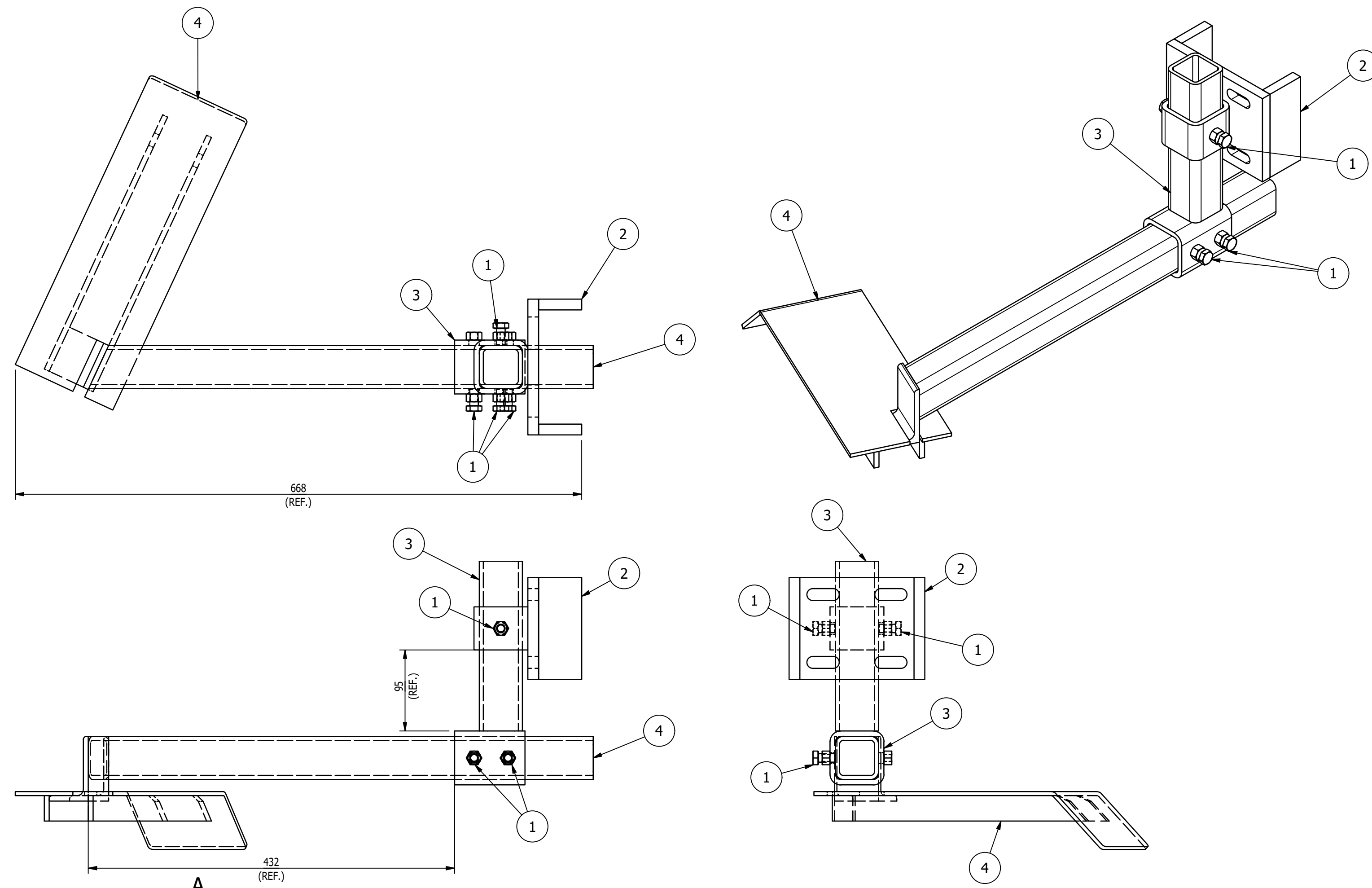
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

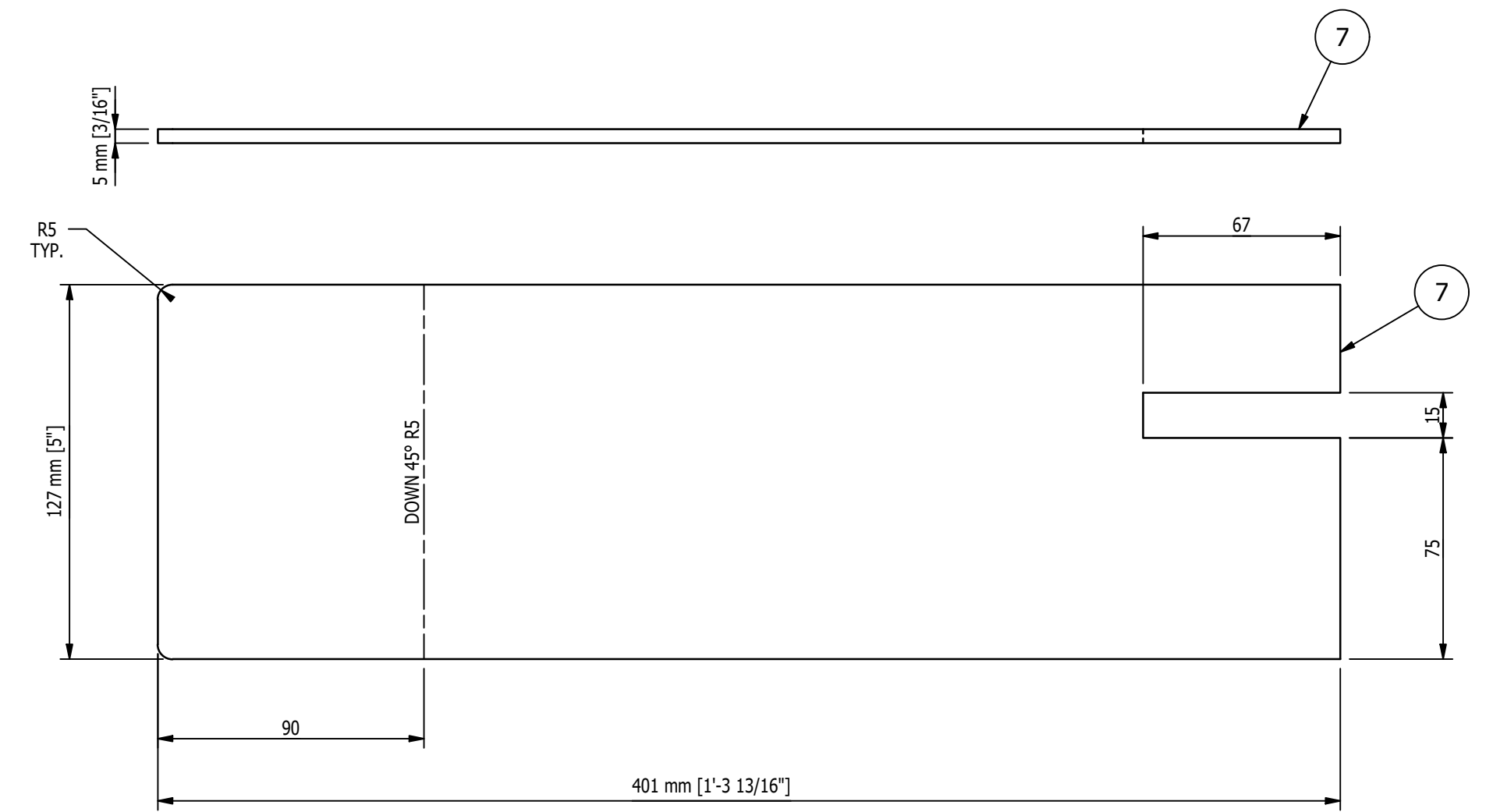
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D052A			
1	4	M10x1.5 x 20mm LG. HEX CAP SCREW			
2	1	MK-D051D ~ ATTACHMENT BASE			
3	1	MK-D050B ~ UPPER ADJUSTMENT			
4	1	MK-D052B ~ LOWER ADJUSTMENT			
		MK-D052B			
5	2	PL 1/4 x 1 3/16"	1'-1" \triangle B		
6	1	L 3 x 2 x 1/4	2 1/4"		
7	1	BAR 3/16 x 5	1'-3 13/16"		
8	1	TS 2 x 2 x 3/16	1'-11 7/16"		

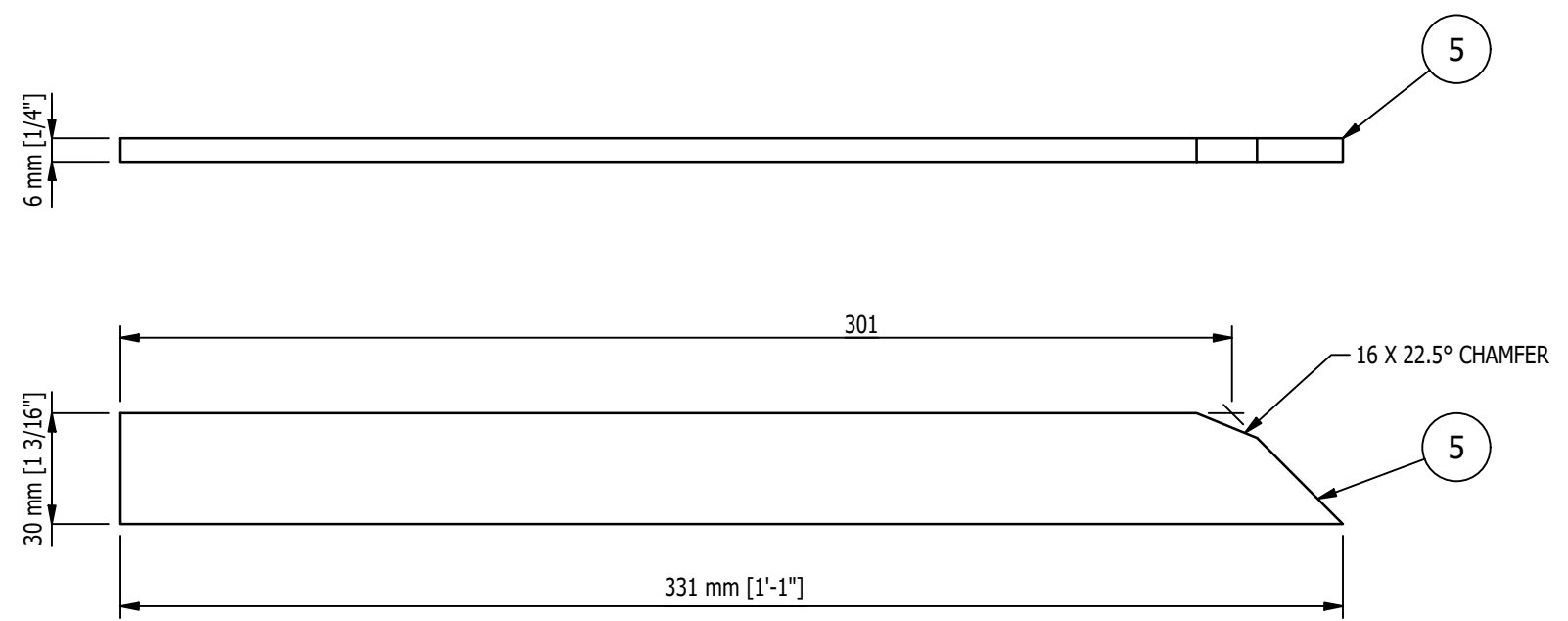
NOTE:
FOR EXACT POSITION OF MK-D052A,
REFER TO LAYOUTS



MK-D052A ~ STOP TRIGGER
SCALE 3"=1'-0"



DETAIL OF ITEM '7'
SCALE 6"=1'-0"



DETAIL OF ITEM '5'
SCALE 6"=1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	REVISED LENGTH ITEM 5 IN BOM	
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
--	---	---

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No.: 1875D052	DWG DATE: 7/21/22
REV: B	JOB No.: 22096

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MAGNUM CONSULTING

41100 Dardickwood Rd.
Suite 125
West, MI 48375

Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

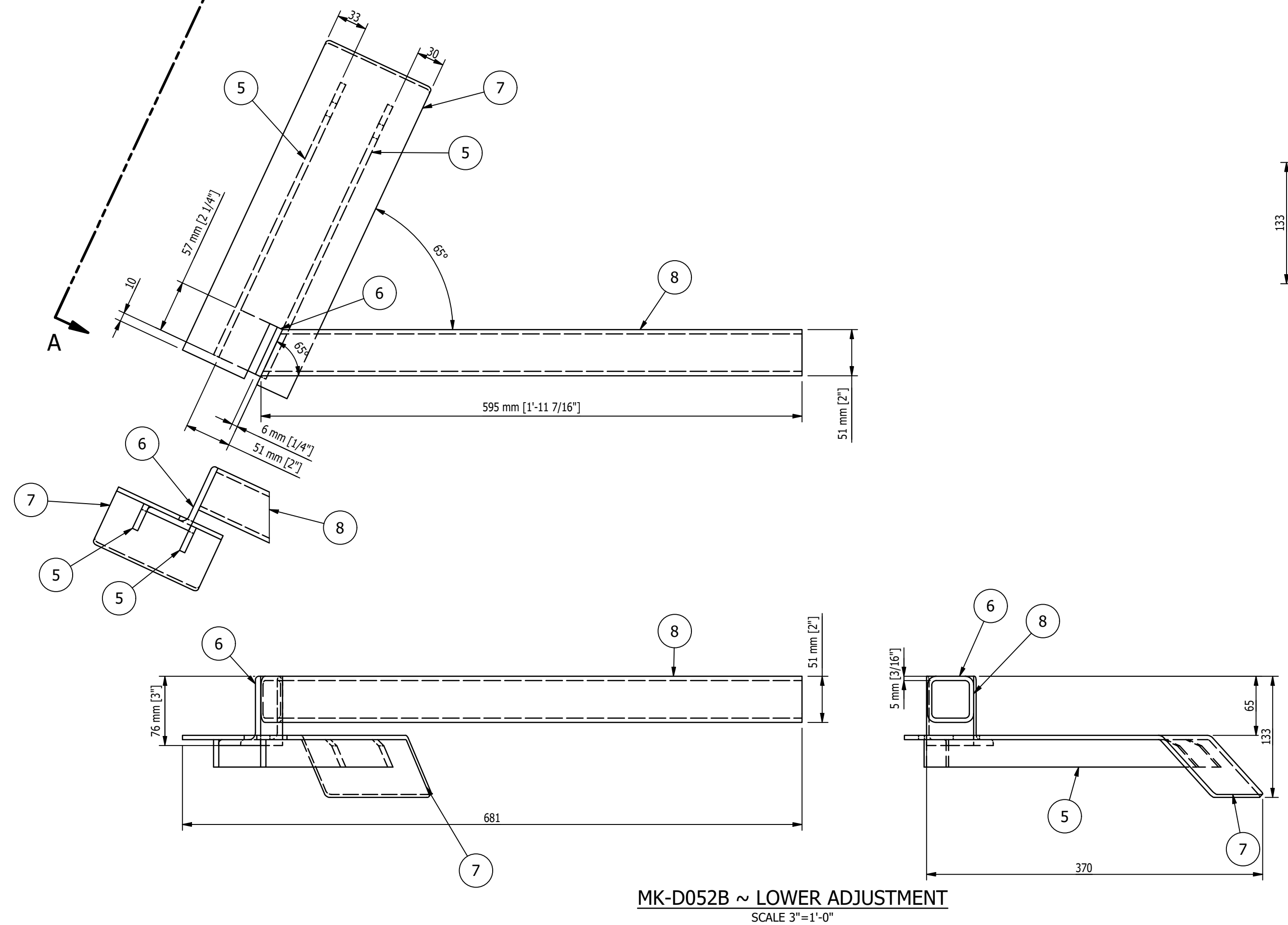
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D052 - REV B

UNLESS OTHERWISE NOTED:

X = ±.060
XX = ±.030
XXX = ±.005

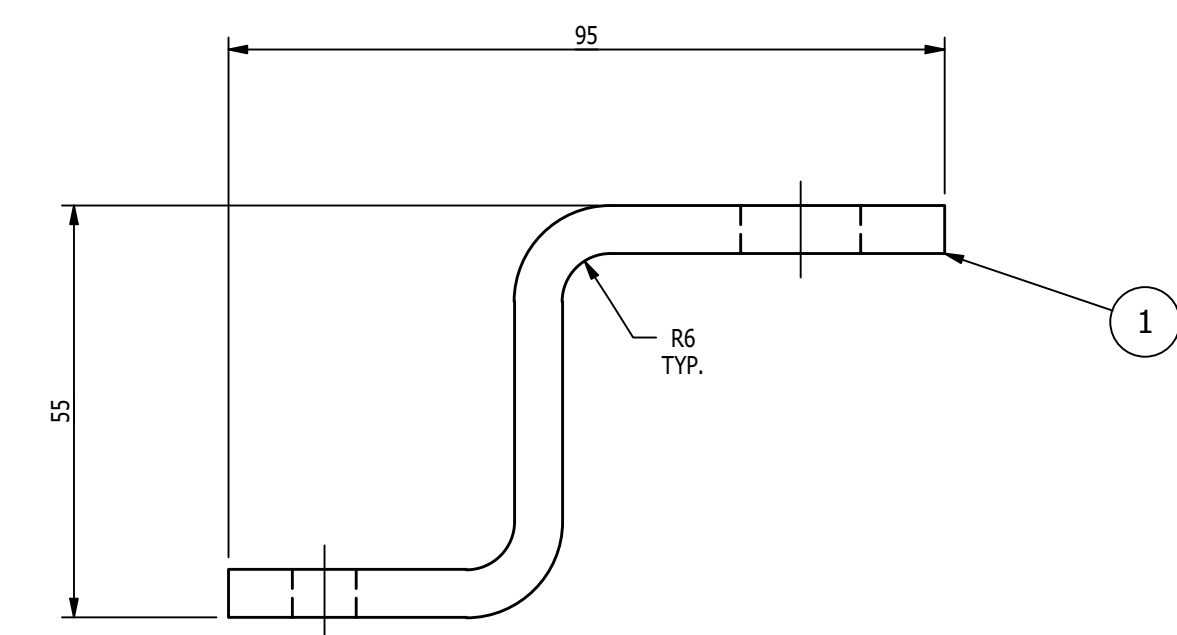
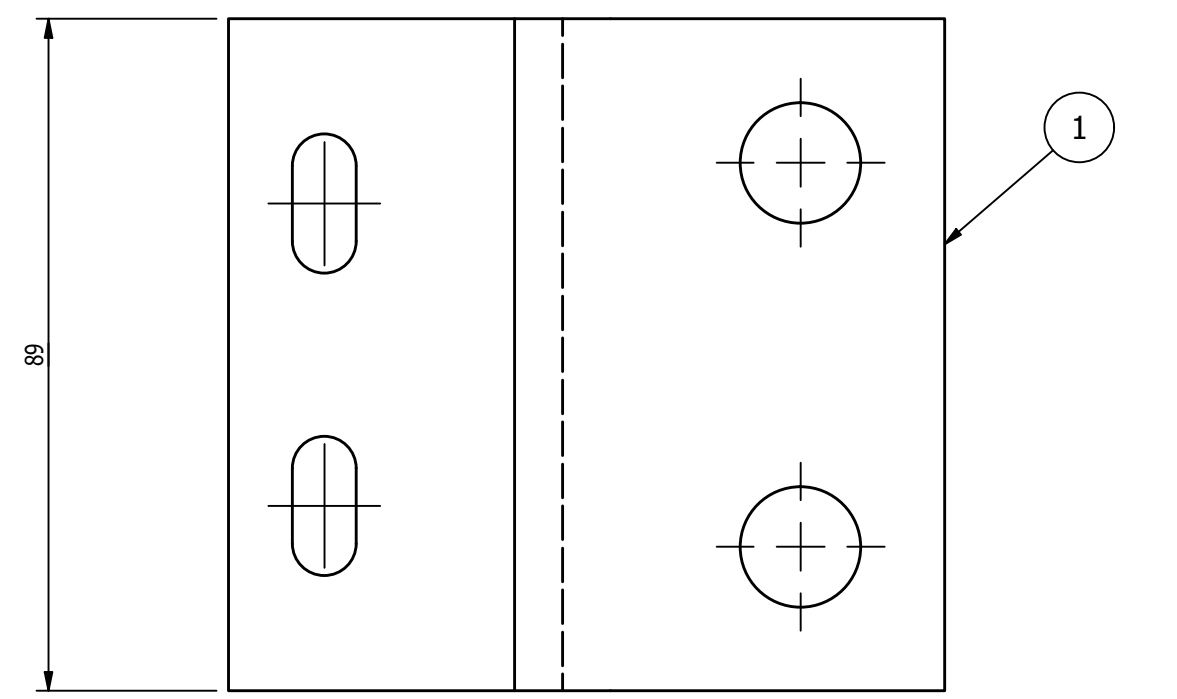
FRACTIONS = ±1/16"
ANGLES = ±1°30'

BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

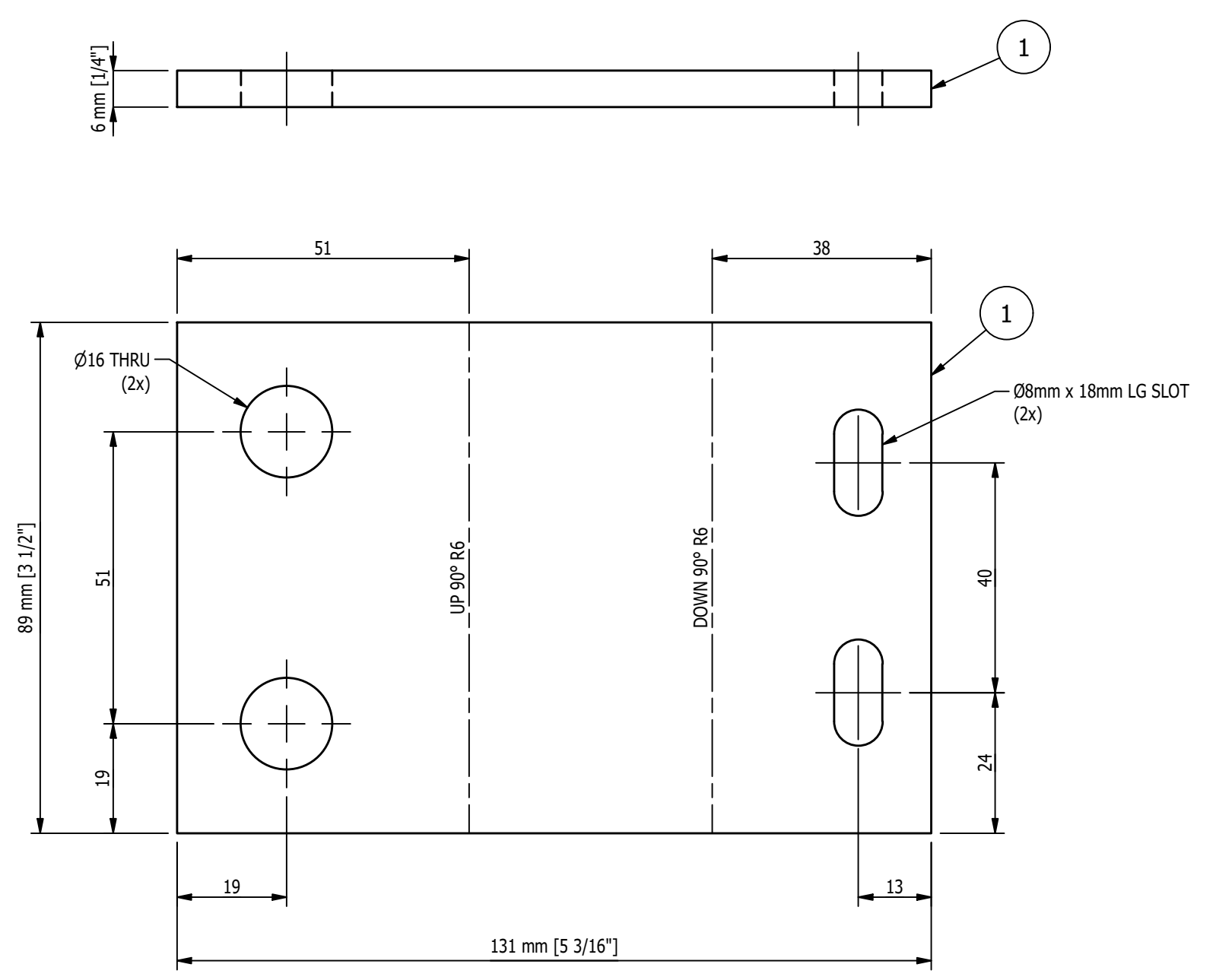


MK-D052B ~ LOWER ADJUSTMENT
SCALE 3"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D054A			
1	1	BAR 1/4 x 3 1/2	5 3/16"		



MK-D054A ~ CATRACK SUPPORT BRACKET
SCALE 1'-0" = 1'-0"



FLAT PATTERN OF ITEM '1'
SCALE 1'-0" = 1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
 - ONE SHOP COAT OF LIGHT GREY RAL 7035
 - DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/9/22	FOR FABRICATION	

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	<small>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</small>
	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D054 REV: A	DRAWN BY: RJB CHECKED BY: CW DWG DATE: 7/29/22 JOB No: 22096

MAGNUM Consulting
 41100 QuakerRoad Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D054

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

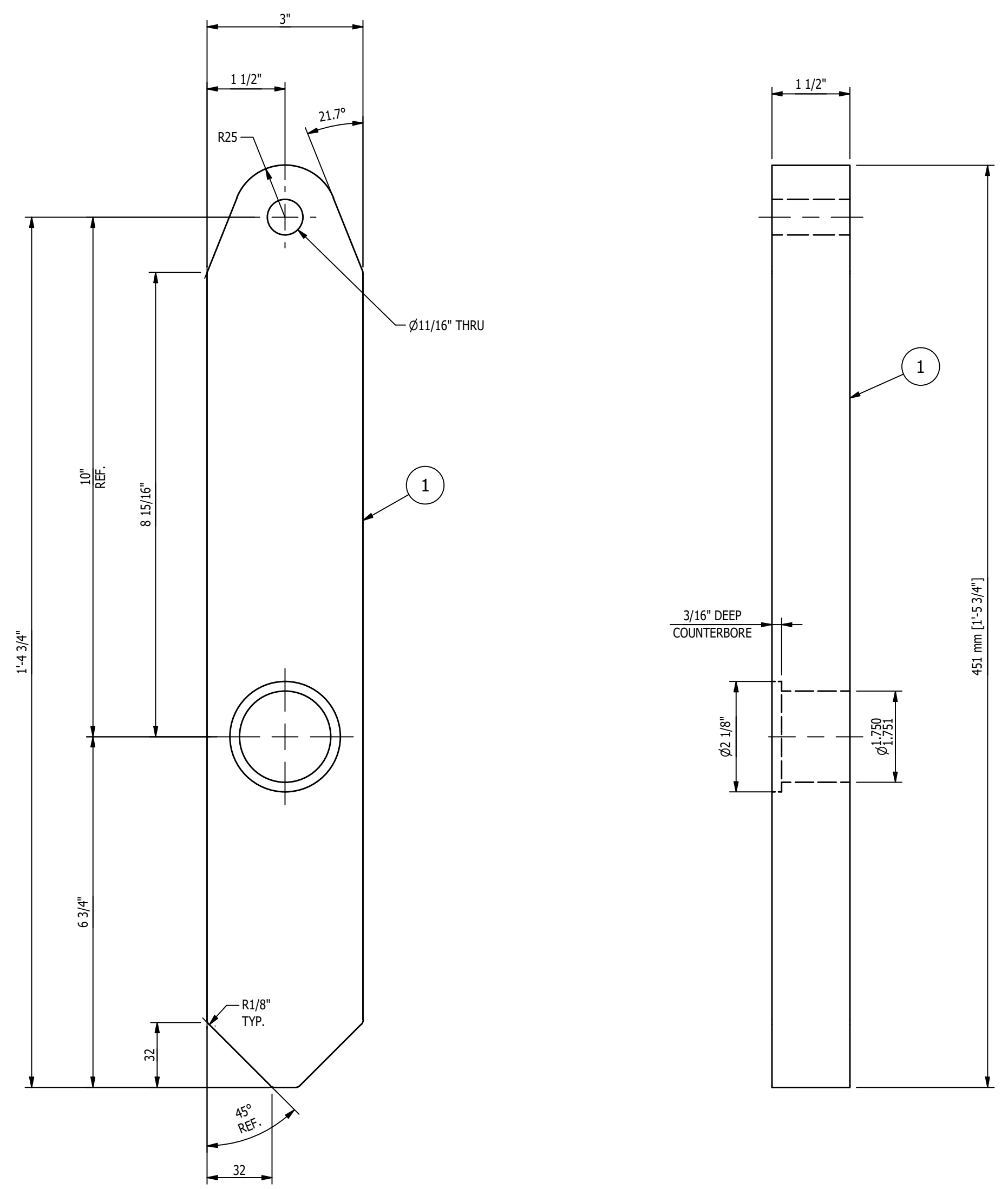
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D055A			
1	1	BAR 1 1/2 x 3	1'-5 3/4"		



MK-D055A ~ GRAVITY STOP ARM
SCALE 6"=1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

PAINT NOTES:
 PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
A	MC	9/16/22	FOR FABRICATION	

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO	DRAWN BY: RJB CHECKED BY: CW DWG DATE: 8/15/22

DRAWING No. 1875D055	REV: A	JOB No: 22096
-----------------------------	---------------	----------------------

MAGNUM Consulting
 41100 Clarkston Road, Suite 125, Novi, MI 48275
 Phone: (248) 772-8822 Fax: (248) 772-8851 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D055

UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

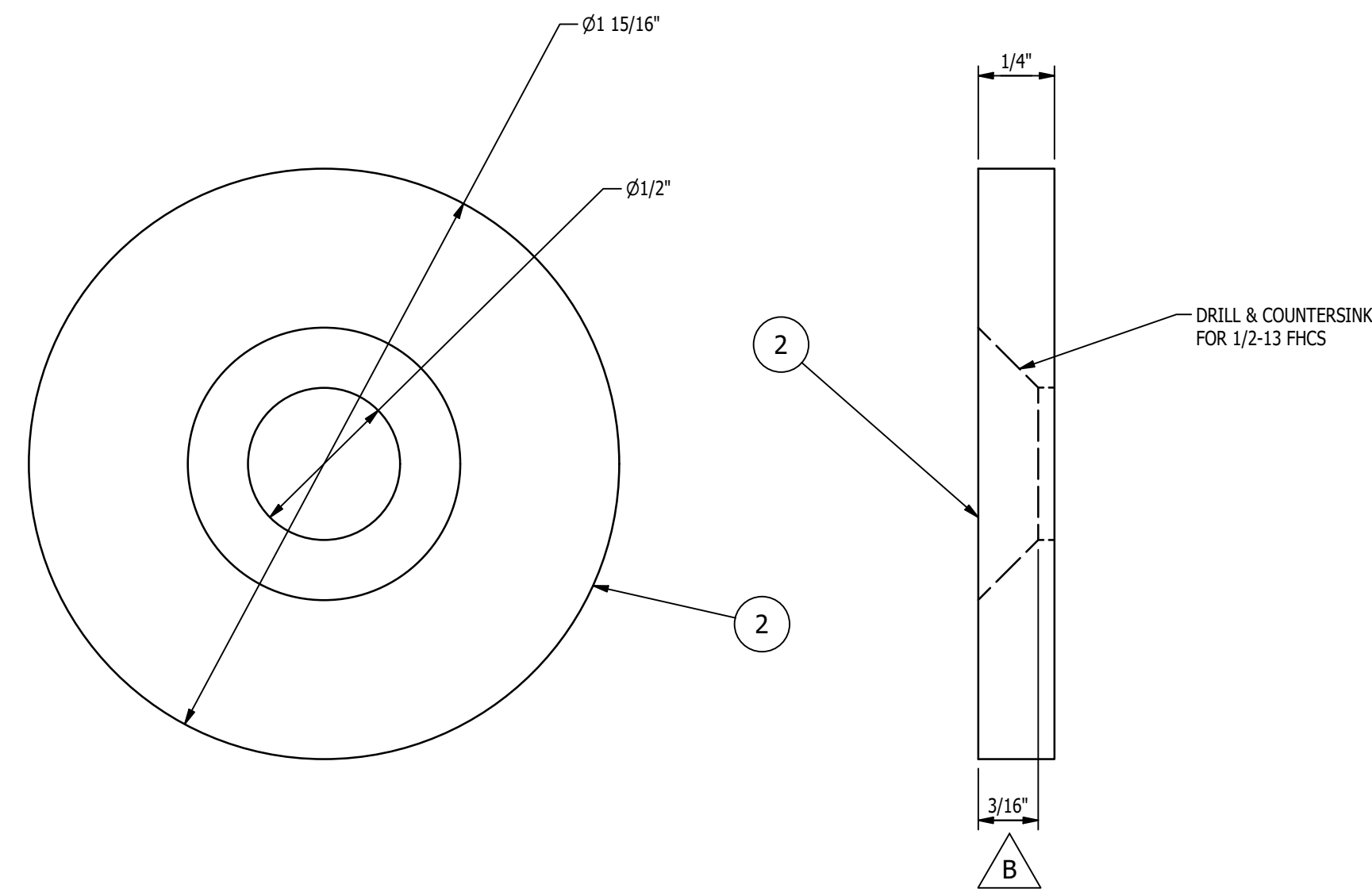
HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

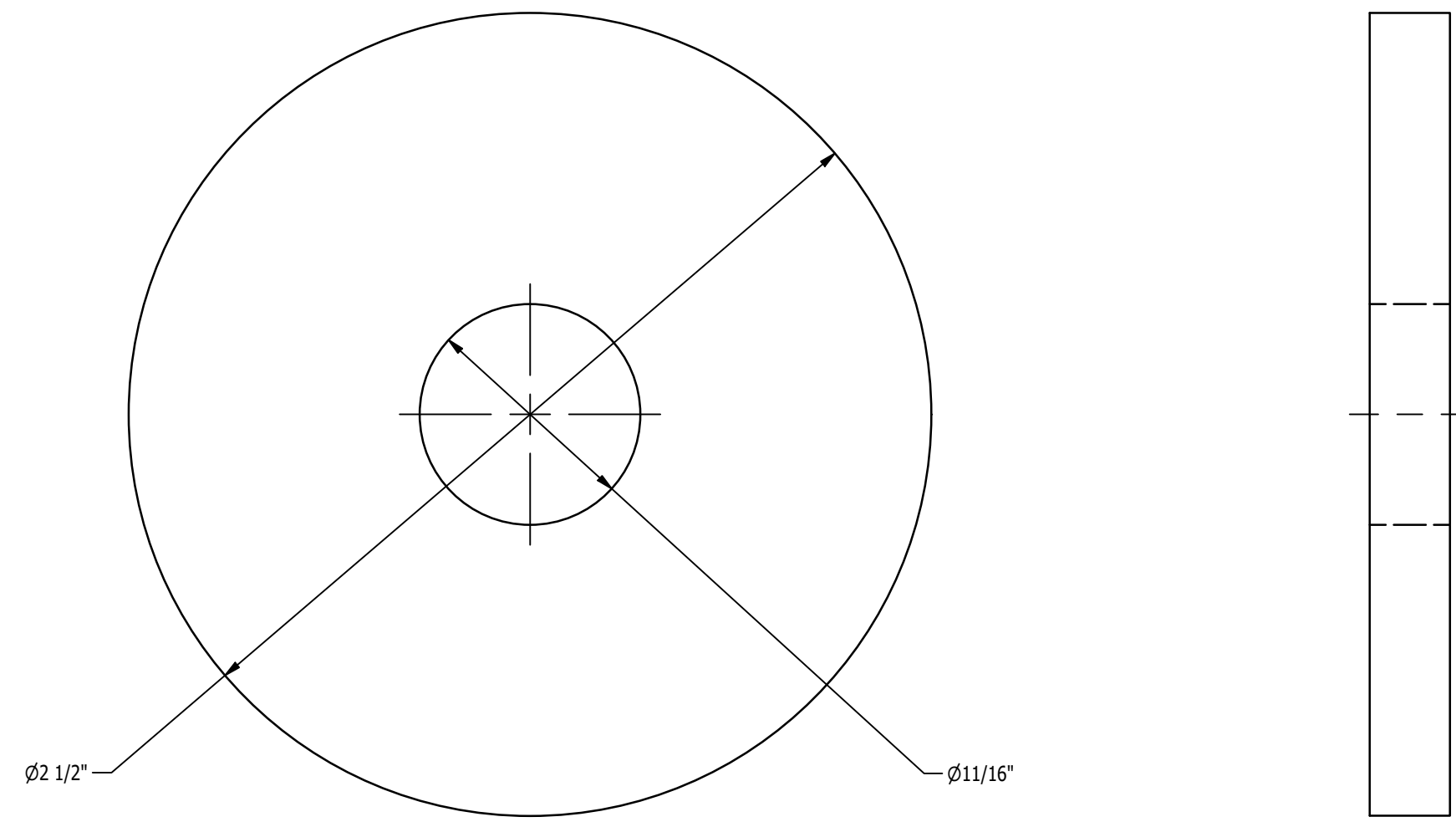
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

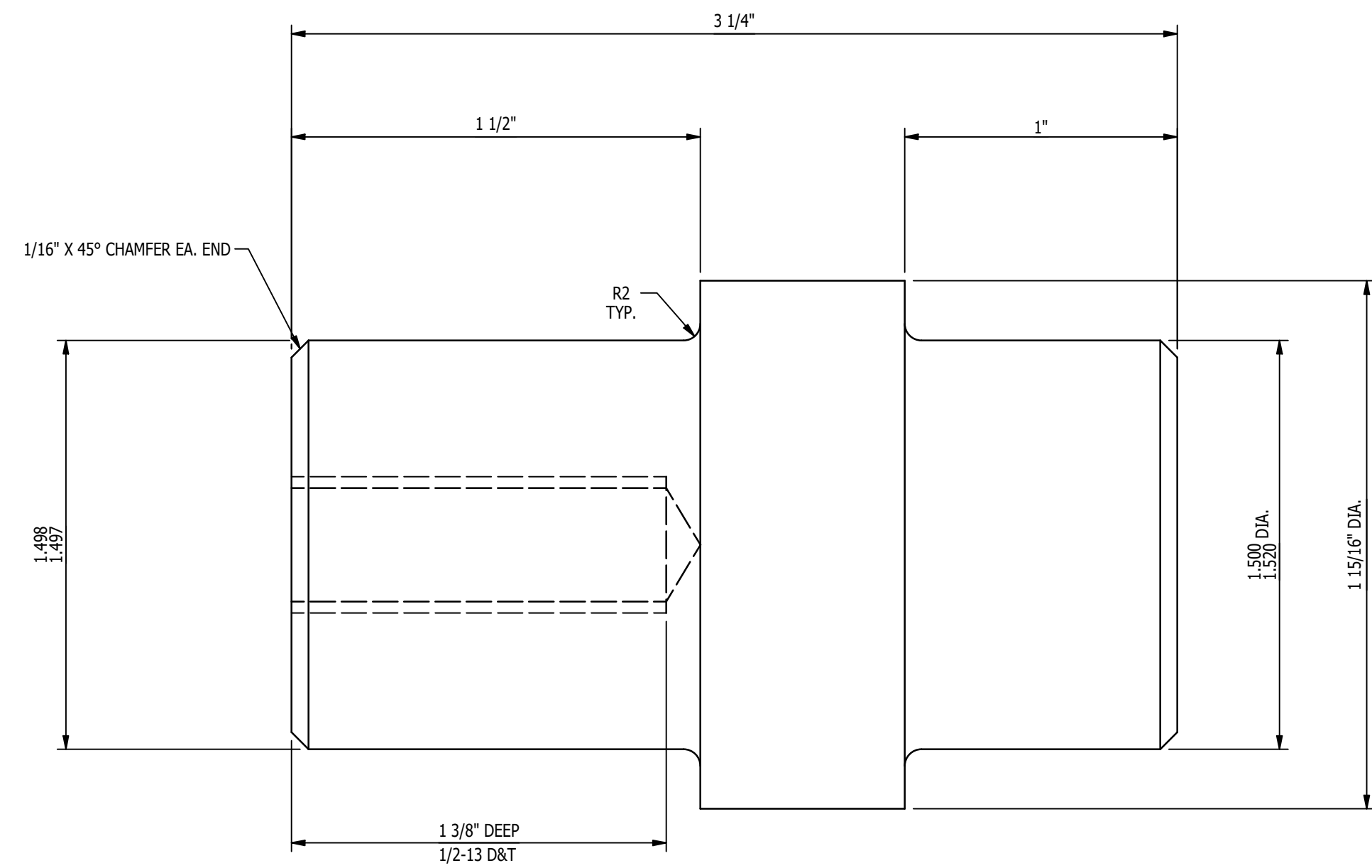
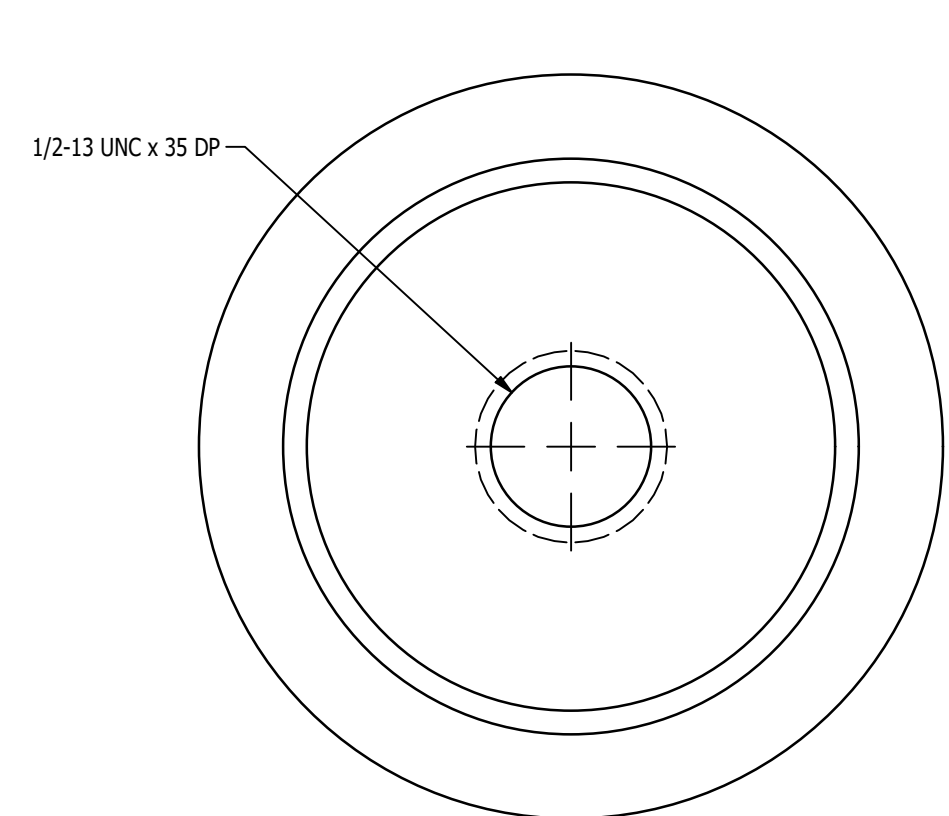
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D056A			
1	1	PL 1/4 x 1 15/16"	1 15/16"		
		MK-D056B			
2	1	BAR Ø1 15/16 (1045)	3 1/4"		
		MK-D056C			
3	1	BAR Ø4 (UHMW)	7/8"		
		MK-D056D			
4	1	BAR Ø1 1/4 (1045) (CRS)	7/8"		
		MK-D056E			
5	1	PL 1/4 x 2 1/2"	2 1/2"		



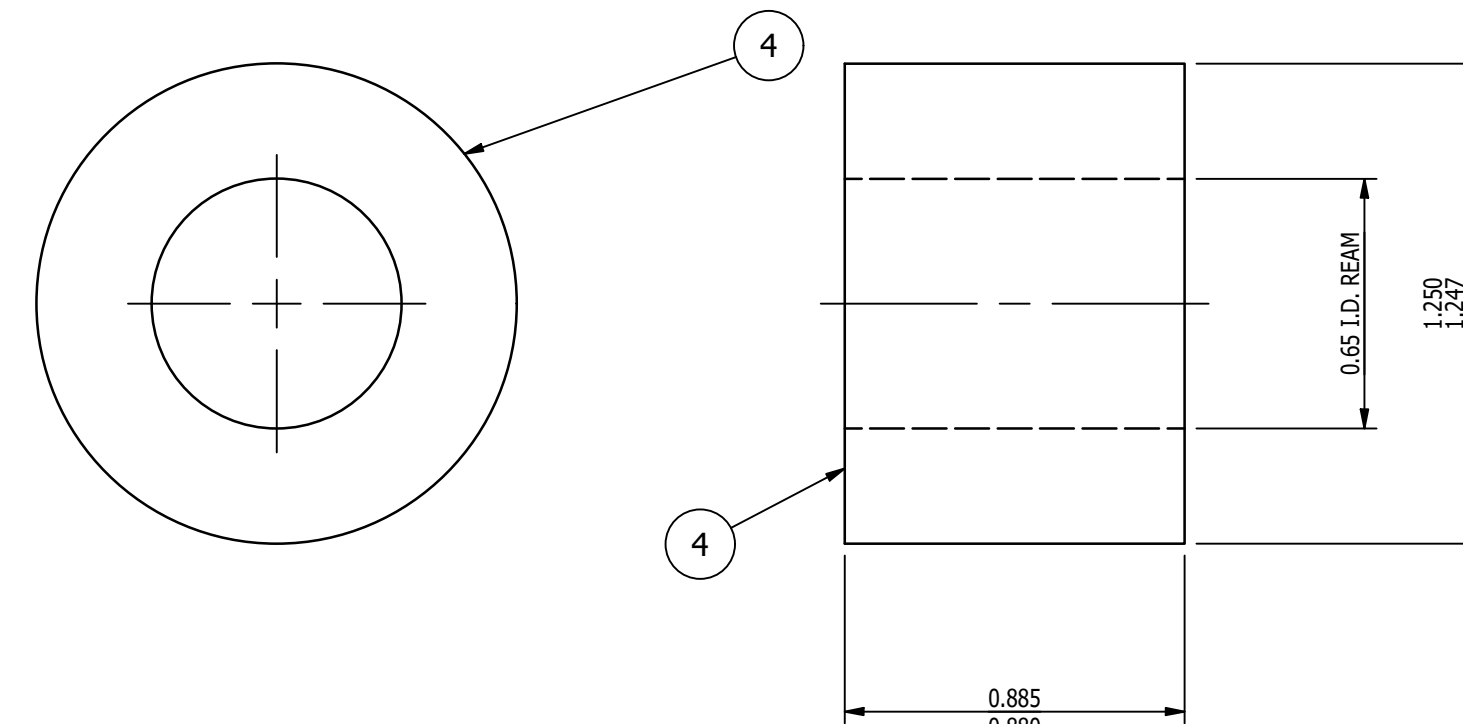
MK-D056A ~ KEEPER PLATE
SCALE 2:1



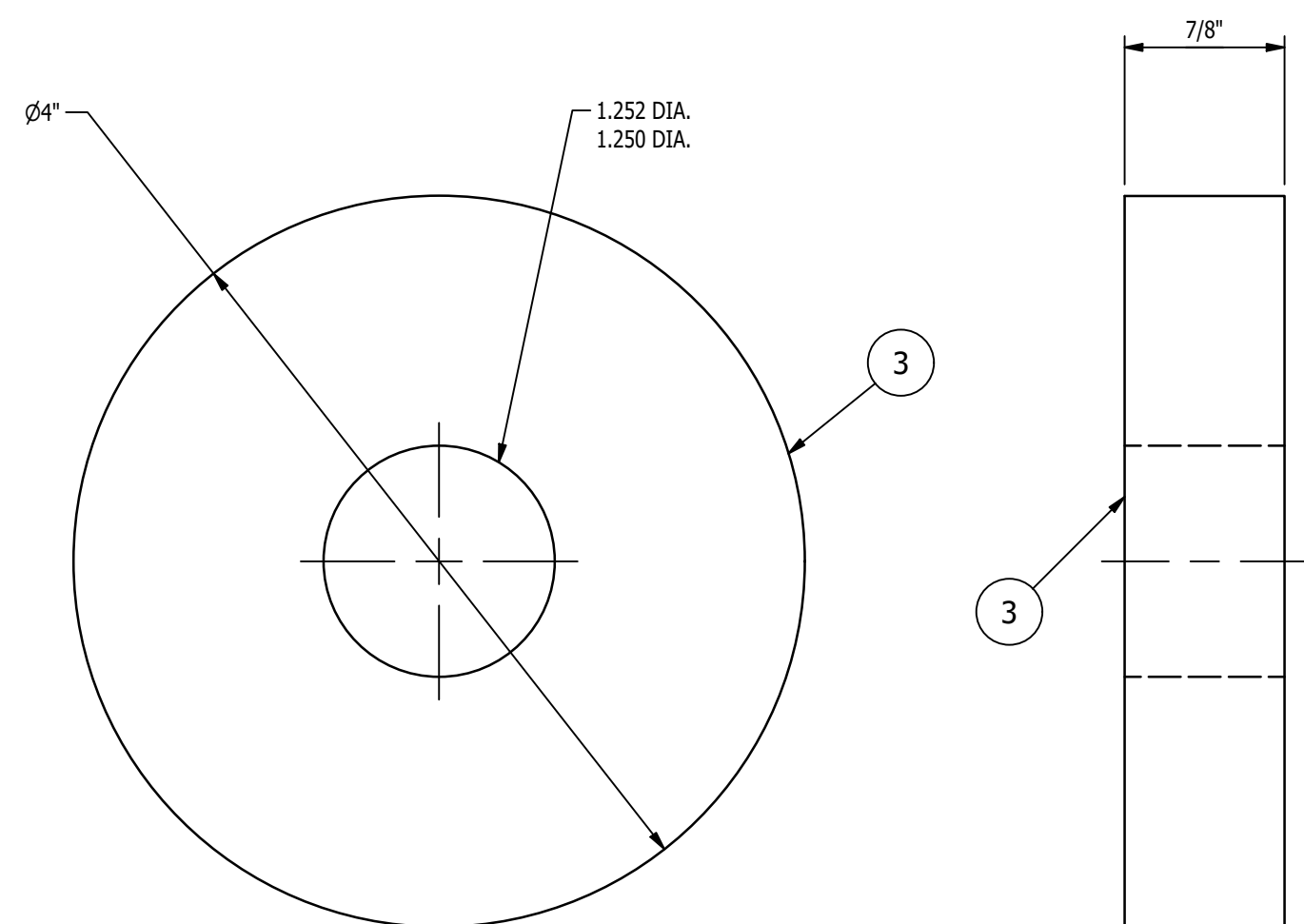
MK-D056E ~ WHEEL PLATE
SCALE 2:1



MK-D056B ~ PIVOT SHAFT DETAIL
SCALE 2:1



MK-D056D ~ PIVOT SHAFT
SCALE 2:1



MK-D056C ~ PIVOT WHEEL
SCALE 1'-0" = 1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.
DO NOT PAINT ITEM '3'

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	ADDED DIM	
A	MC	9/16/22	FOR FABRICATION	

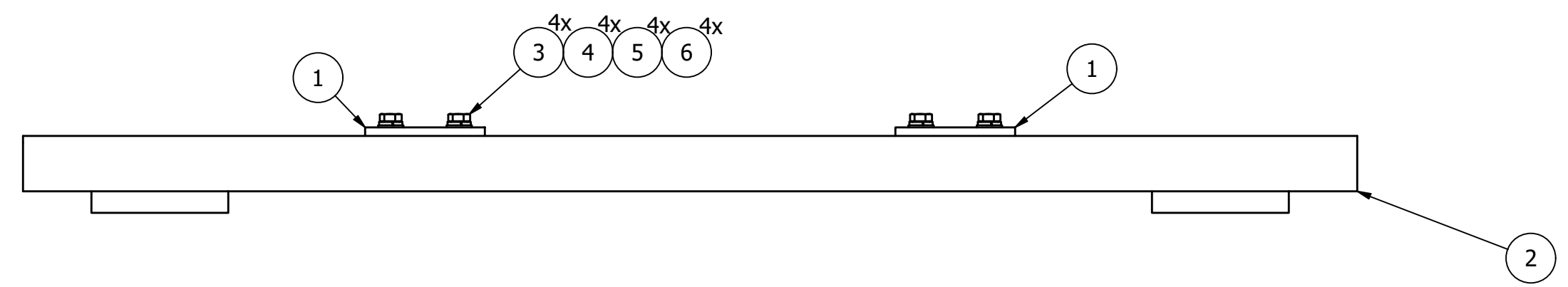
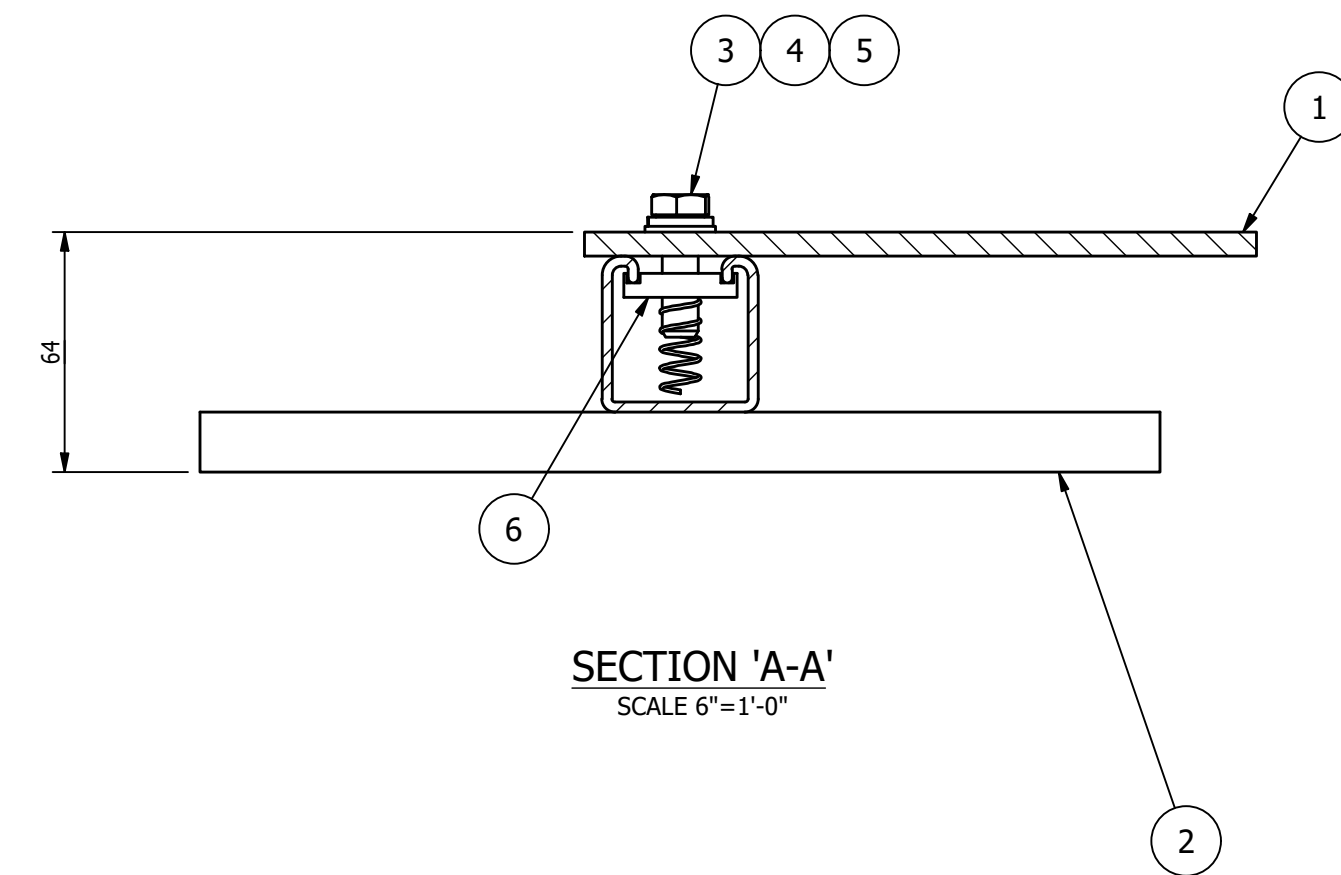
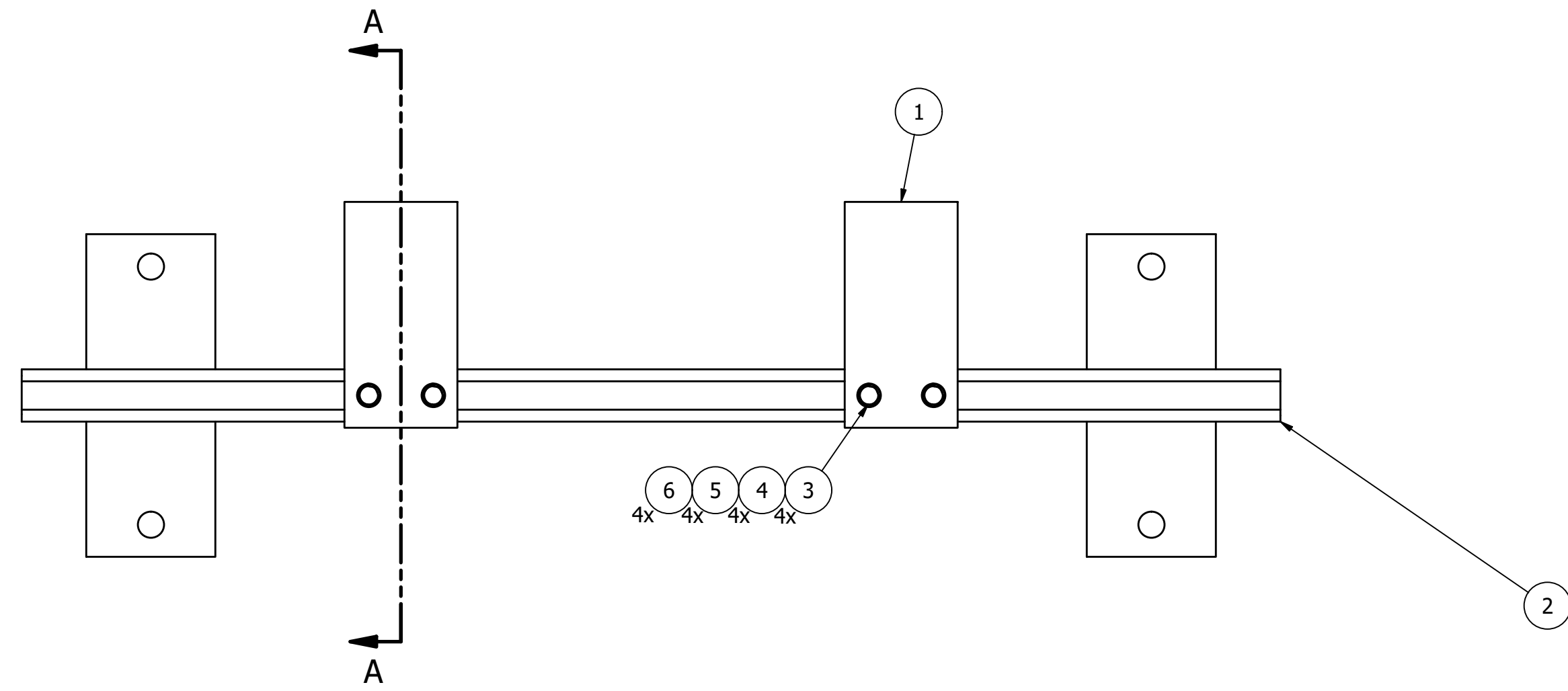
REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D056	DRAWN BY: RJB CHECKED BY: CW DWG DATE: 8/15/22

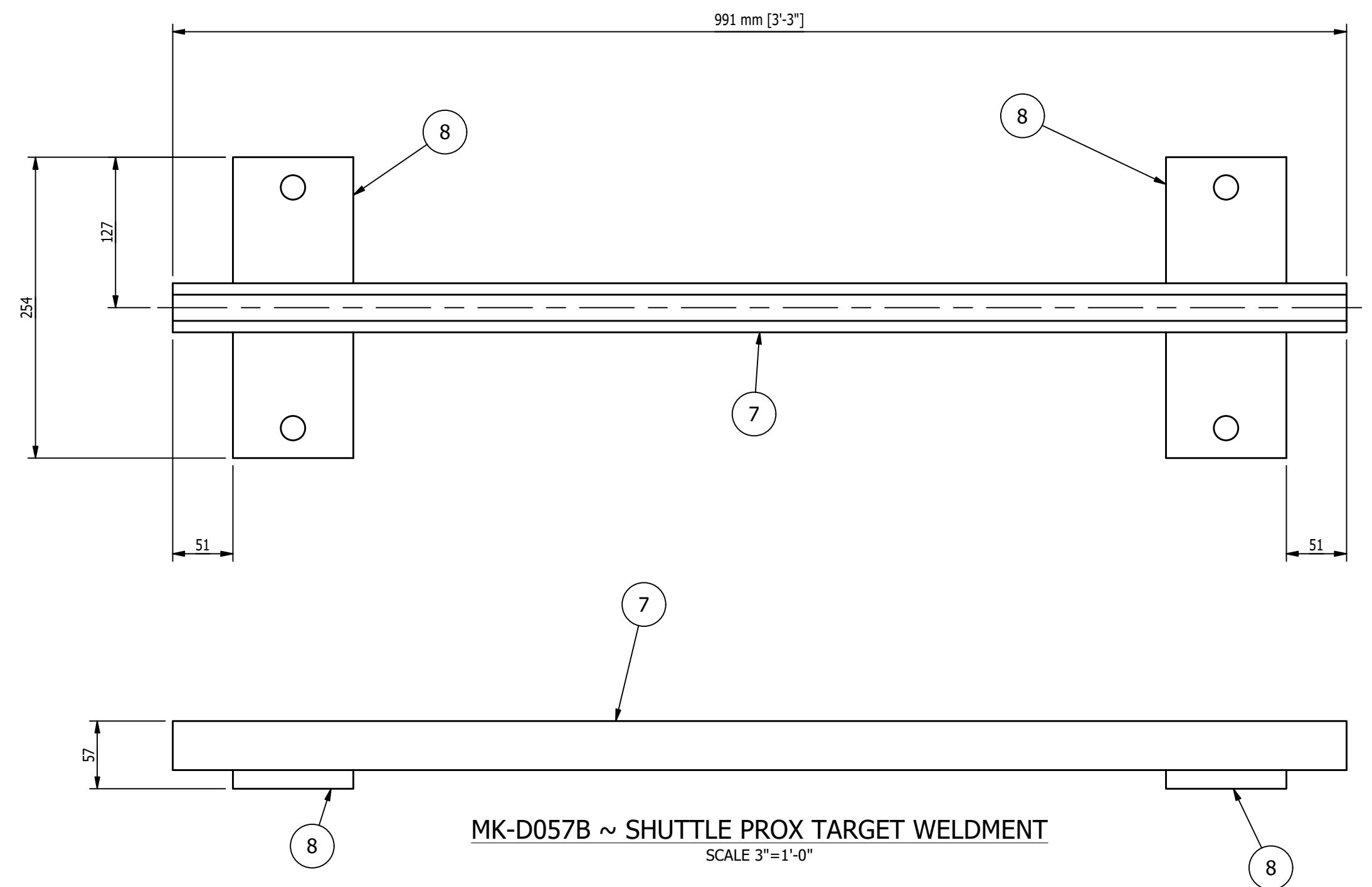
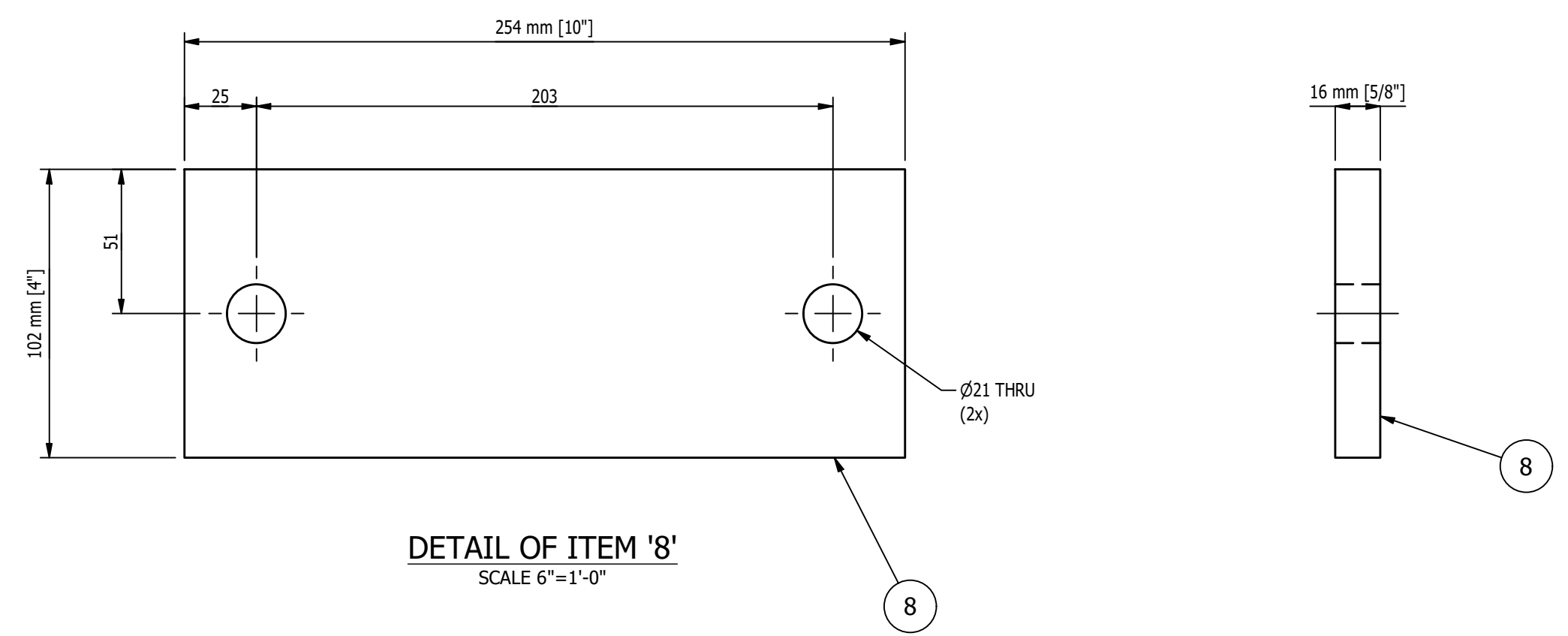
MAGNUM JOB #: 1875 MAGNUM DRAWING #: 1875D056 - REV B	UNLESS OTHERWISE NOTED: X = ±.060 XX = ±.030 XXX = ±.005 FRACTIONS = ±1/16" ANGLES = ±1°30' BREAK ALL SHARP EDGES DEBURR ALL HOLES DO NOT SCALE DRAWING	GENERAL NOTES: MATERIALS: - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O. - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O. - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O. - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O. HOLES: - ALL HOLES ARE 13/16" DIA. U.N.O. - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED. WELDS: - ALL WELDS TO BE "E70XX", (PER AWS D1.1) PAINT: - PAINT PER CUSTOMER SPECIFICATIONS U.N.O. COPE: - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.
--	--	--

41700 Dardickwood Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D056 - REV B

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
	1	MK-D057A			
1	2	MK-D043C ~ LOCATOR PLATE			
2	1	MK-D057B ~ SHUTTLE PROX TARGET WELDMENT			
3	4	3/8 TYPE B NARROW FLAT WASHER			
4	4	3/8 SPRING LOCK WASHER			
5	4	3/8-16UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
6	4	CHANNEL NUT FOR 3/8"-16 WITH SPRING, UNISTRUT P1008			
	1	MK-D057B			
7	1	UNISTRUT 1-5/8" x 1-5/8" 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	3'-3"		
8	2	PL 5/8 x 4"	10"		



MK-D057A ~ SHUTTLE PROX TARGET
SCALE 3"=1'-0"



MK-D057B ~ SHUTTLE PROX TARGET WELDMENT
SCALE 3"=1'-0"

- SHOP NOTES:**
- ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 - ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 - REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 - ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 - ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 - ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 - MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 - ALL SLOT LENGTHS ARE END TO END U.N.O.
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/31/22	FOR FABRICATION	

<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com</p>	<p>TITLE: P6700 CONVEYORS CAMPUS BUILDING</p>		<p>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</p>
	<p>CLIENT: VOLVO</p>	<p>DRAWN BY: RJB</p>	<p>CHECKED BY: CW</p>
<p>DRAWING No. 1875D057</p>	<p>REV: A</p>	<p>JOB No: 22096</p>	

MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
Novi, MI 48165
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.m4magnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D057

UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.