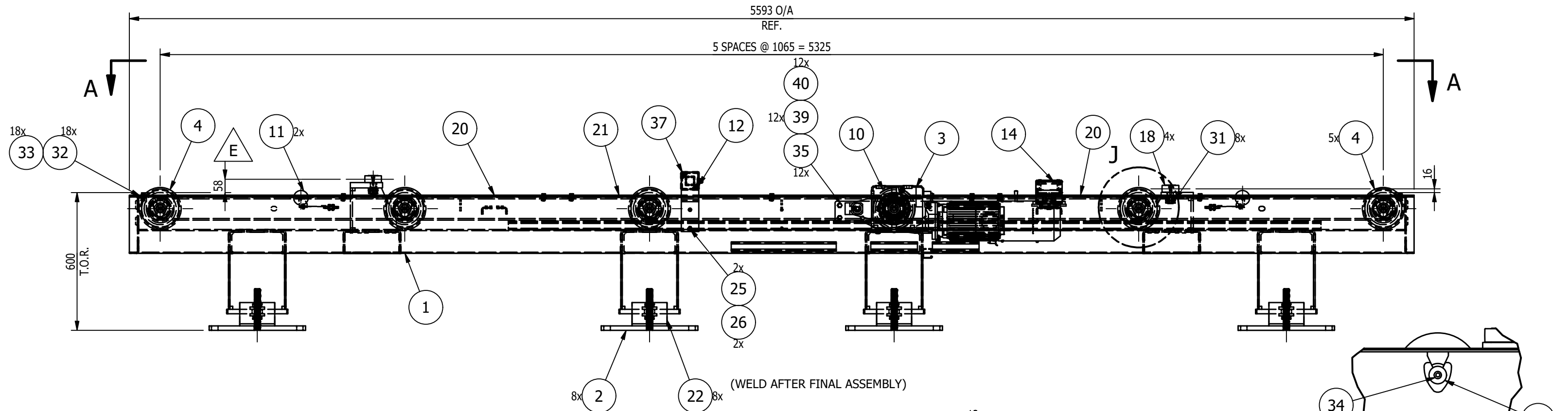


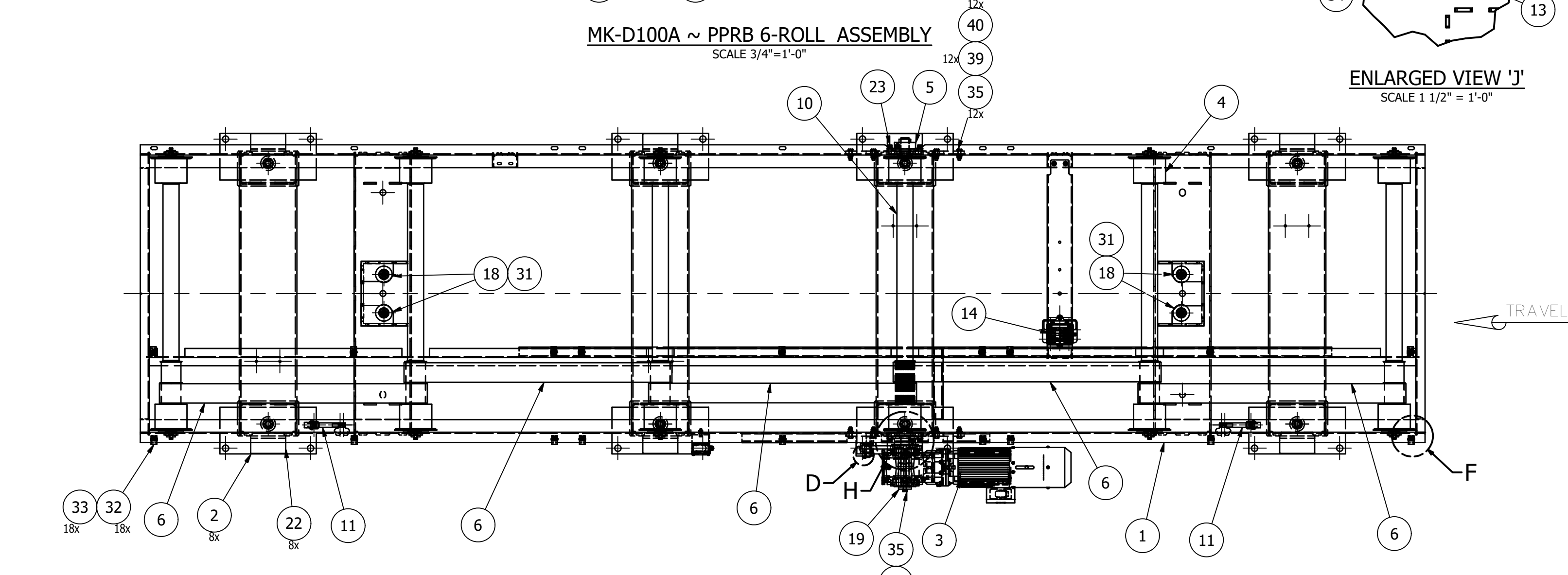
SECTION 'C-C'  
SCALE 1 1/2"=1'-0"

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

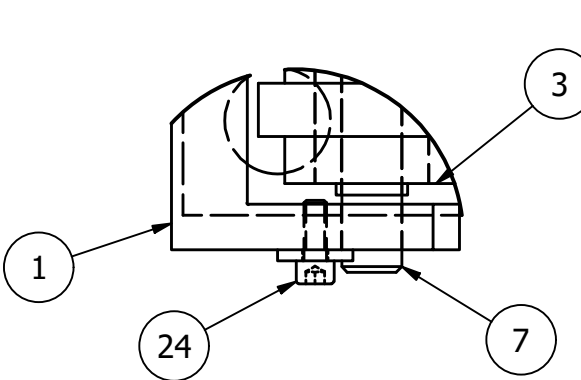


MK-D100A ~ PPRB 6-ROLL ASSEMBLY  
SCALE 3/4"=1'-0"

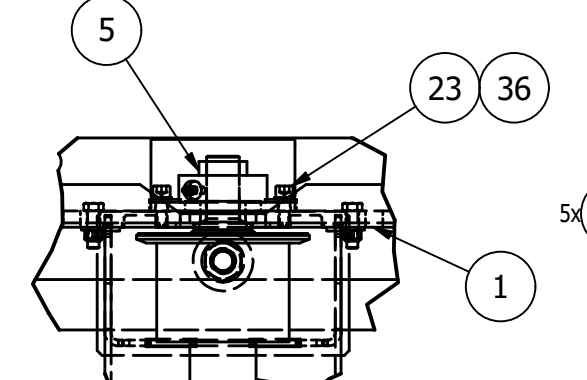
ENLARGED VIEW 'J'  
SCALE 1 1/2"=1'-0"



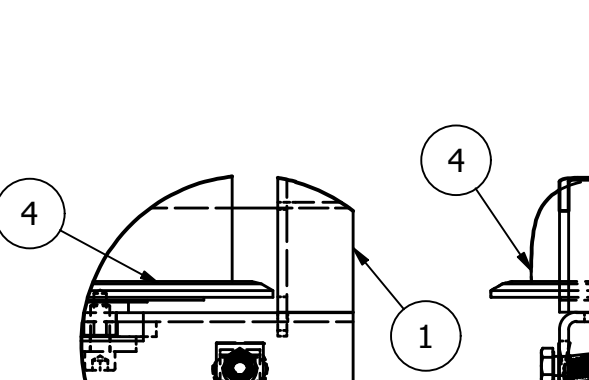
VIEW 'A-A' (BELT COVERS ARE REMOVED FOR CLARITY)  
SCALE 3/4"=1'-0"



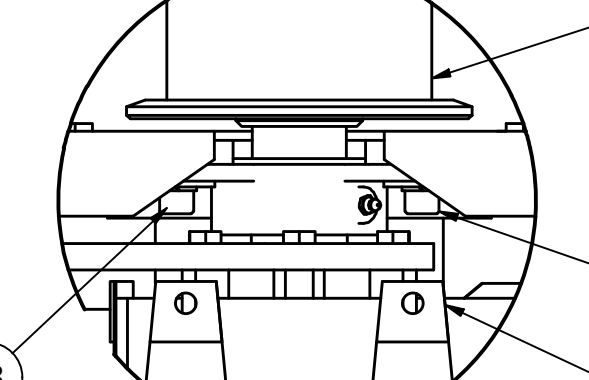
ENLARGED VIEW 'D'  
SCALE 6"=1'-0"



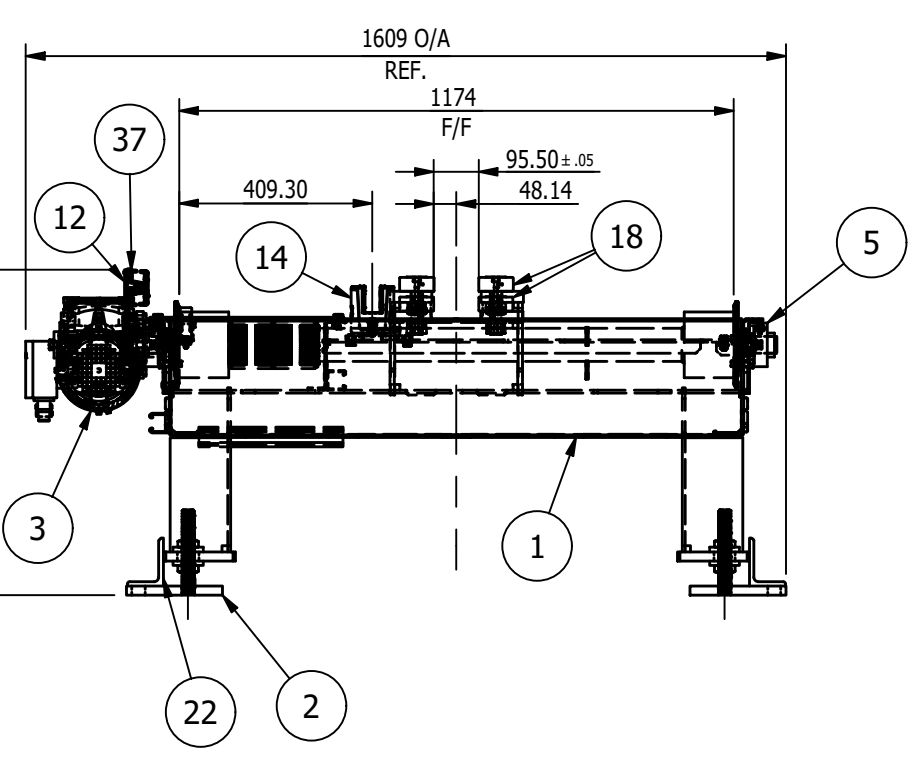
ENLARGED VIEW 'G'  
SCALE 1 1/2"=1'-0"



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



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



SPEED FORMULA (60HZ):

$$\pi \times 1740 \times \frac{1}{13.61} \times \frac{140}{1000} = 56.2 \text{ m/min} = 184.5 \text{ ft/min}$$

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.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D100A			
1	1	MK-D101A ~ PPRB6 WELDMENT			
2	8	MK-D102 ~ FOOT PAD ASSEMBLY			
3	1	SIEMENS RB1 GEARMOTOR (SEE MOTOR DATA LIST)		1-1	
4	5	PALLET DRIVEN ROLLER, DUGOMRULLI PART NO 329638V			
5	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
6	5	GATES POWERGRIP GT4 BELT ~ 2400-8MGT-85		2-1	
7	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
8	1	MK-D116A ~ DRIVE ROLLER SPACER			
9	1	MK-D116B ~ DRIVE ROLLER SPACER			
10	1	PALLET DRIVER ROLLER, DUGOMRULLI PART NO 332192V M12			
11	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
12	1	MK-D240A ~ RF CODE READER BKT			
13	10	MK-D121A ~ ROLLER WASHER			
14	1	WCS3B-LS310D READ HEAD ~ PEPPERL&FUCHS		4-1	
15	1	WCS-MP1 ~ BAR CODE READER MTG PLATE ~ PEPPERL&FUCHS		4-2	
16	1	MK-D119A ~ ENCODER READER MTG PL			
17	1	MK-D119B ~ ENCODER READER HORSESHOE PL			
18	4	SMITH BRG #MCR-72-SB ~ 72 mm OD X 29 mm W, W/24 mm STUD X 49.5 mm L		3-2	
19	1	MK-D121B ~ MOTOR END SPACER			
20	2	MK-D120A ~ END COVER PLATE			
21	1	MK-D120B ~ MID COVER PLATE			
22	8	L 4 x 3 x 3/8 (SHIP LOOSE)	6"		
23	4	M12x1.75 x 30mm LG. HEX SOCKET HEAD CAP SCREW			
24	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
25	2	M8x1.25 x 25mm LG. HEX SOCKET HEAD CAP SCREW			
26	2	M8 x 1.25 STOVER LOCK NUT			
29	4	M3x0.5 x 10mm LG. HEX SOCKET HEAD CAP SCREW			
30	2	M10x1.5 x 16mm LG. HEX CAP SCREW			
31	8	M24 x 1.5 HEX JAM NUT			
32	18	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
33	18	M10x1.5 x 25mm LG. HEX CAP SCREW			
34	10	M10x1.5 x 25mm LG. HEX SOCKET HEAD CAP SCREW			
35	13	M12x1.75 x 40mm LG. HEX CAP SCREW			
36	5	M12 SPRING LOCK WASHER			
37	2	M5x0.8 x 12mm LG. HEX SOCKET HEAD CAP SCREW			
38	2	M10 SPRING LOCK WASHER			
39	12	M12 NARROW FLAT WASHER			
40	12	M12 x 1.75 STOVER LOCK NUT			
41	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	
43	2	M6x1 x 20mm LG. HEX CAP SCREW			
44	2	M6 NARROW FLAT WASHER			
TOTAL WEIGHT = 3152 Lbs					

REV	BY	DATE	DESCRIPTION	APP
F	MC	8/12/2022	DELETED ITEMS 27, 28 ADDED ITEMS 43, 44; SCREWS CHANGED M5 TO M6	
E	MC	7/27/2022	ADDED SPACER, REV. DIMS, REV ITEM 31 ADDED ABM # ITEM 18, ADDED ITEM '41', ADDED LOCTITE ITEM 30	
D	MC	7/12/2022	REVISED MOTOR PLATE, FRAME WELDMENT, SHOP NOTES AND ADDED BOLTS	
C	MC	7/6/2022	GUIDE ROLLER MOVED	
B	MC	7/1/2022	FOR FAB	
A	MC	5/27/2022	FOR APPROVAL	

**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. 1875D100

REV: F

JOB No. 22096

DRAWN BY: SGS  
 CHECKED BY: CW  
 DWG DATE: 5/24/2022

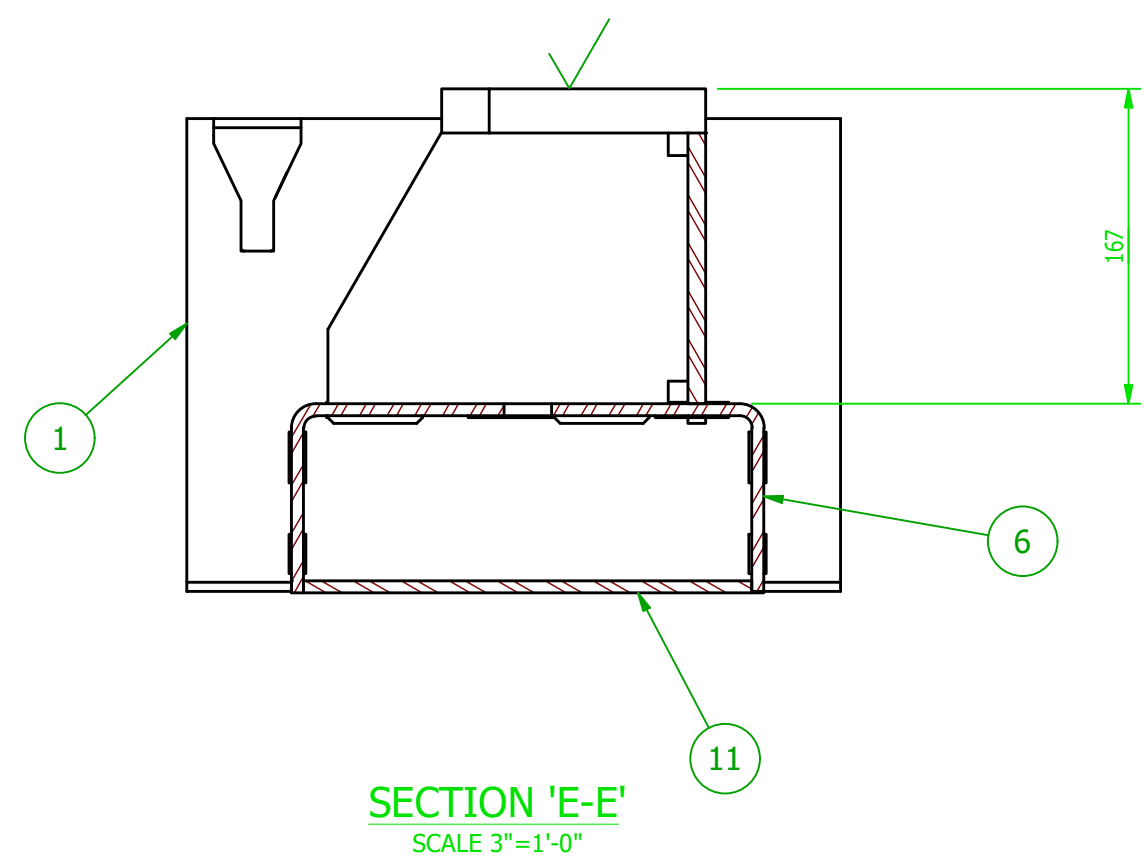
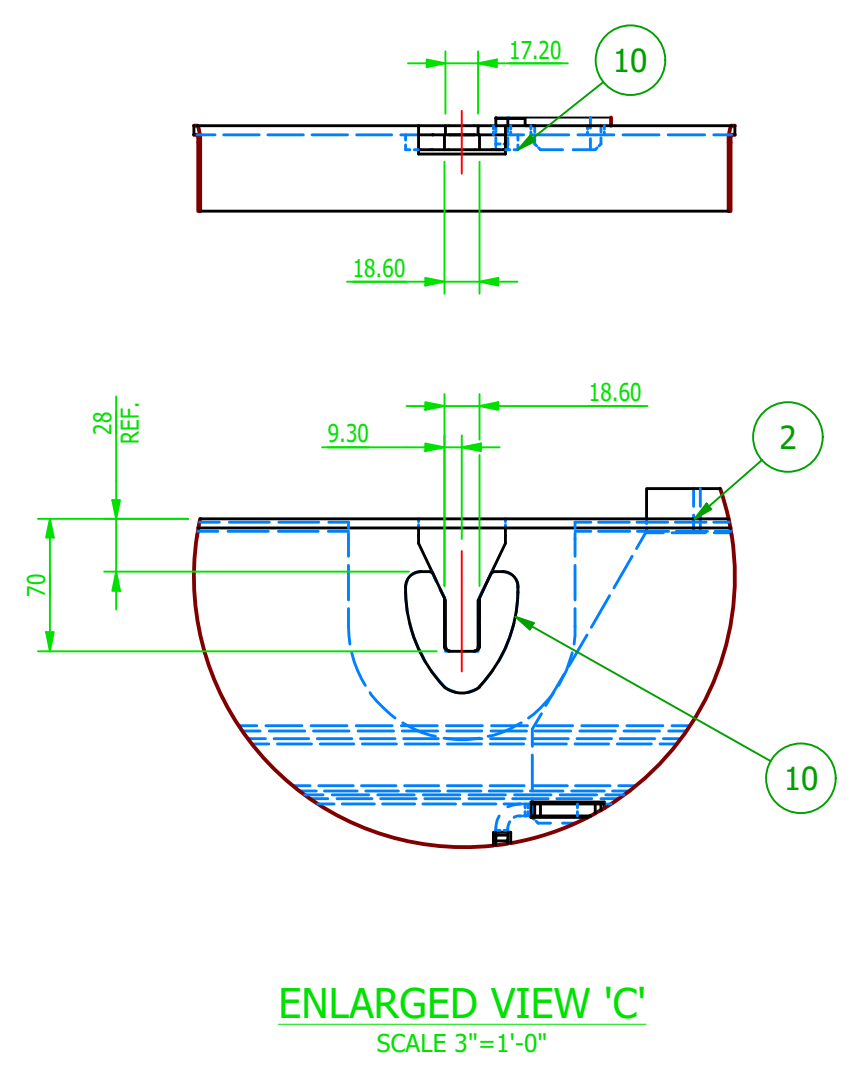
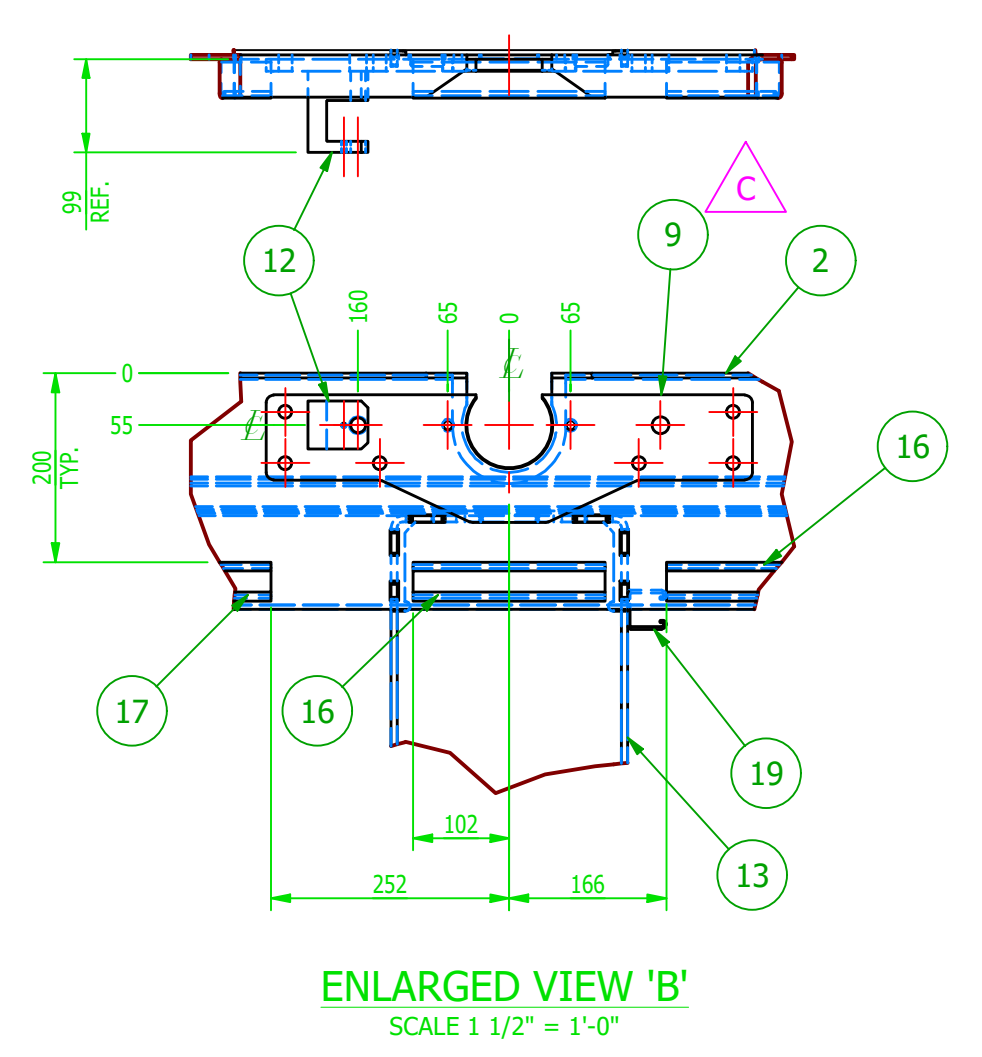
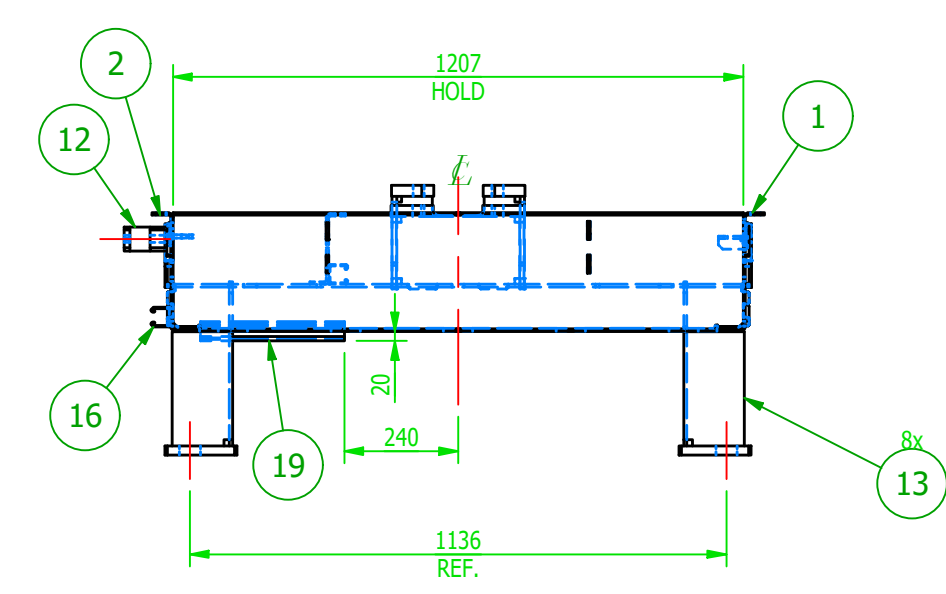
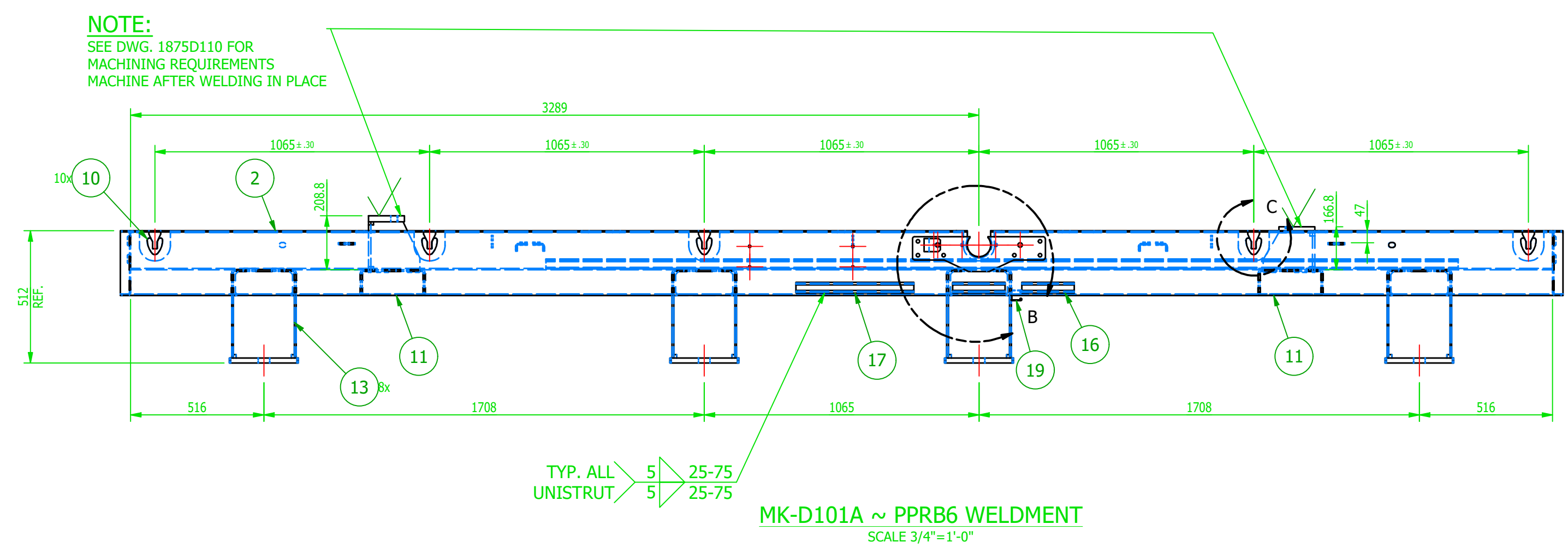
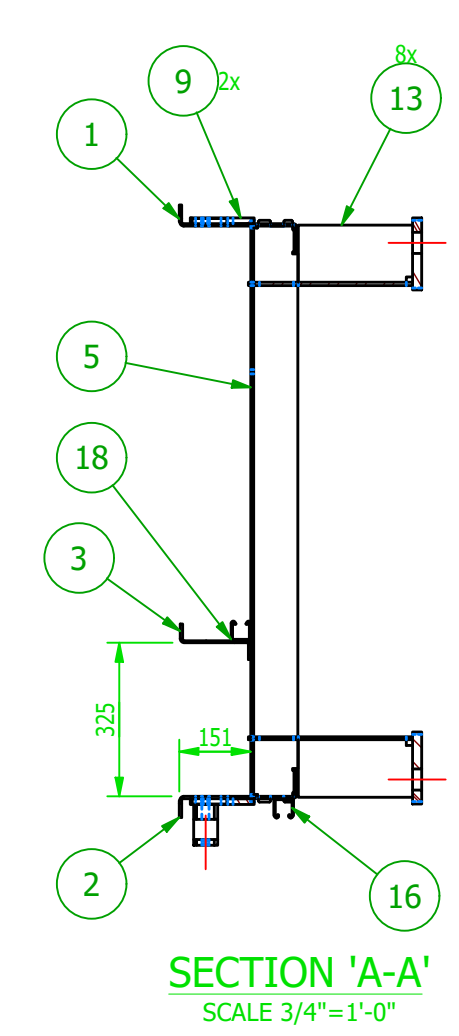
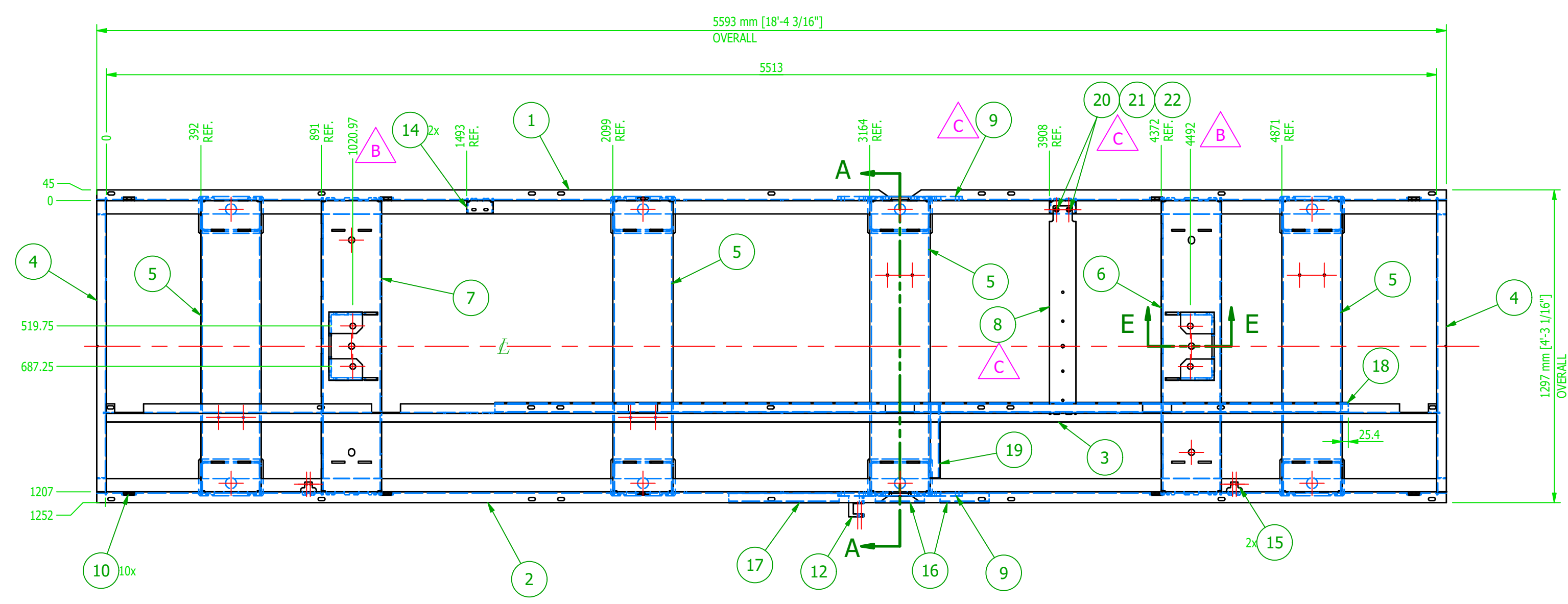
**MAGNUM CONSULTING**  
 41100 Clarkston Rd.  
 Suite 125  
 West, MI 48375  
 Phone: (248) 772-8888  
 Fax: (248) 772-8851  
 Web: www.m4magnum.com

MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 1875D100

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
		MK-D101A			
1	1	MK-D103A ~ SIDE FRAME			
2	1	MK-D104A ~ SIDE FRAME			
3	1	MK-D105A ~ MID FRAME			
4	2	MK-1875D106A ~ END FRAME			
5	4	MK-1875D107A ~ INNER CROSS MEMBER			
6	1	MK-D110B ~ INNER CROSS MEMBER WELDMENT-RH			
7	1	MK-D110A ~ INNER CROSS MEMBER WELDMENT-LH			
8	1	MK-D118A ~ BAR CODE READER BRKT			
9	2	MK-D111A ~ MOTOR MOUNTING PLATE			
10	10	MK-D111B ~ RETAINER			
11	2	MK-D227B ~ STIFFENER PLATE			
12	1	MK-D111D ~ CLEVIS			
13	8	MK-D112A ~ LEG ASSEMBLY			
14	2	MK-D113A ~ BRACKET			
15	2	MK-D113B ~ ENCODER BRACKET			
16	2	P1000 UNISTRUT	8"		
17	1	P1000 UNISTRUT	1'-6"		
18	1	P1000 UNISTRUT	11'-7 1/4"		
19	1	P1000 UNISTRUT	1'-0"		
20	2	M8x1.25 x 25mm LG. HEX CAP SCREW			
21	4	M8 NARROW FLAT WASHER			
22	2	M8 x 1.25 STOVER LOCK NUT			
		TOTAL WEIGHT = 1175.5 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

**MAGNUM CONSULTING**  
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North, MI 48075  
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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	7/12/2022	REVISED MOTOR PLATE, FRAME WELDMENT AND SHOP NOTES	
B	MC	7/06/2022	GUIDE ROLLER MOVED	
A	MC	7/01/2022	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**

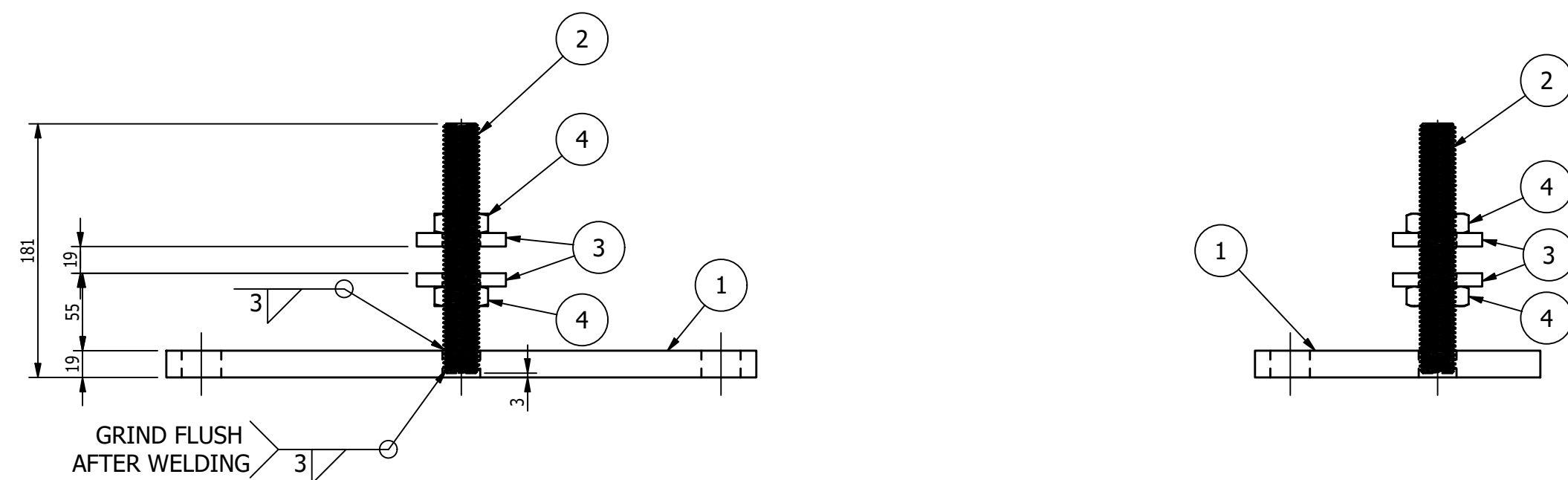
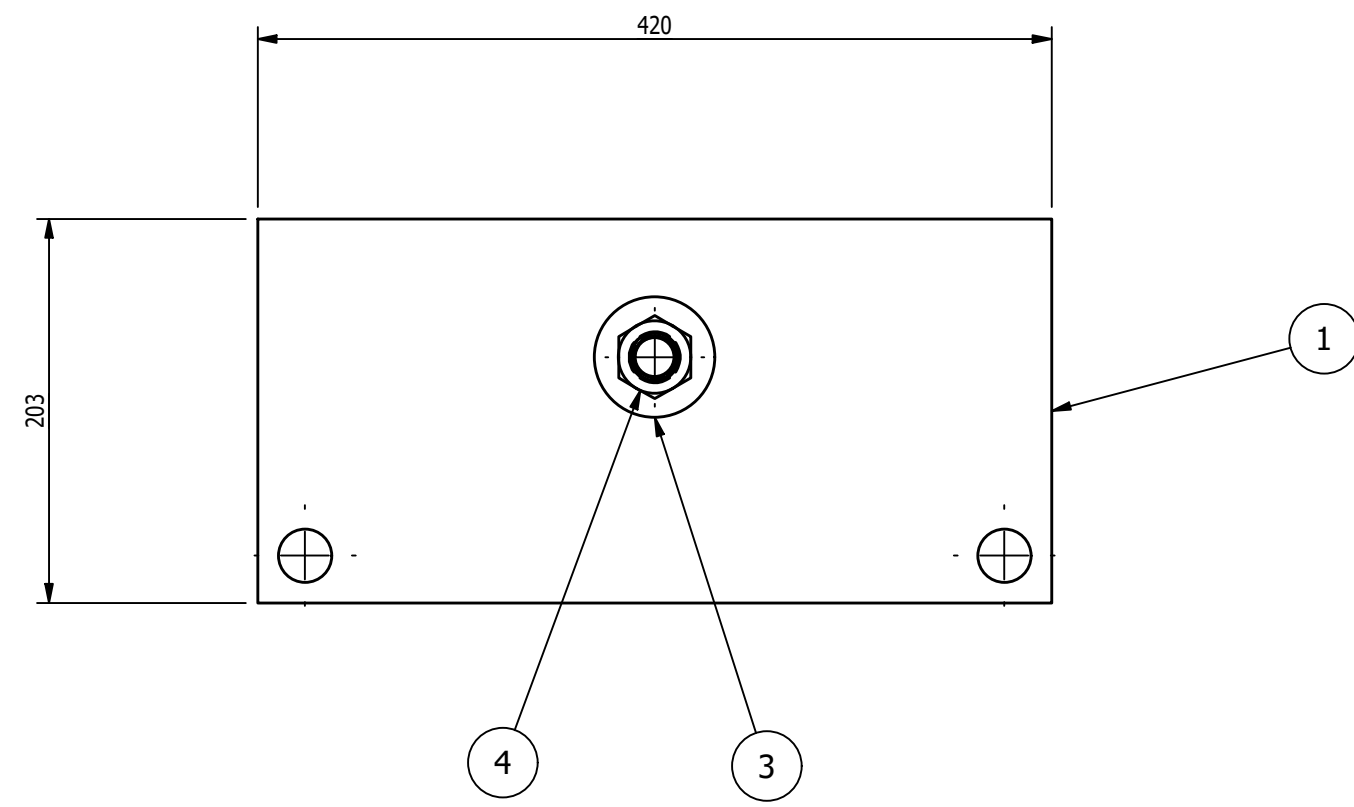
CLIENT: VOLVO

DRAWING No. 1875D101

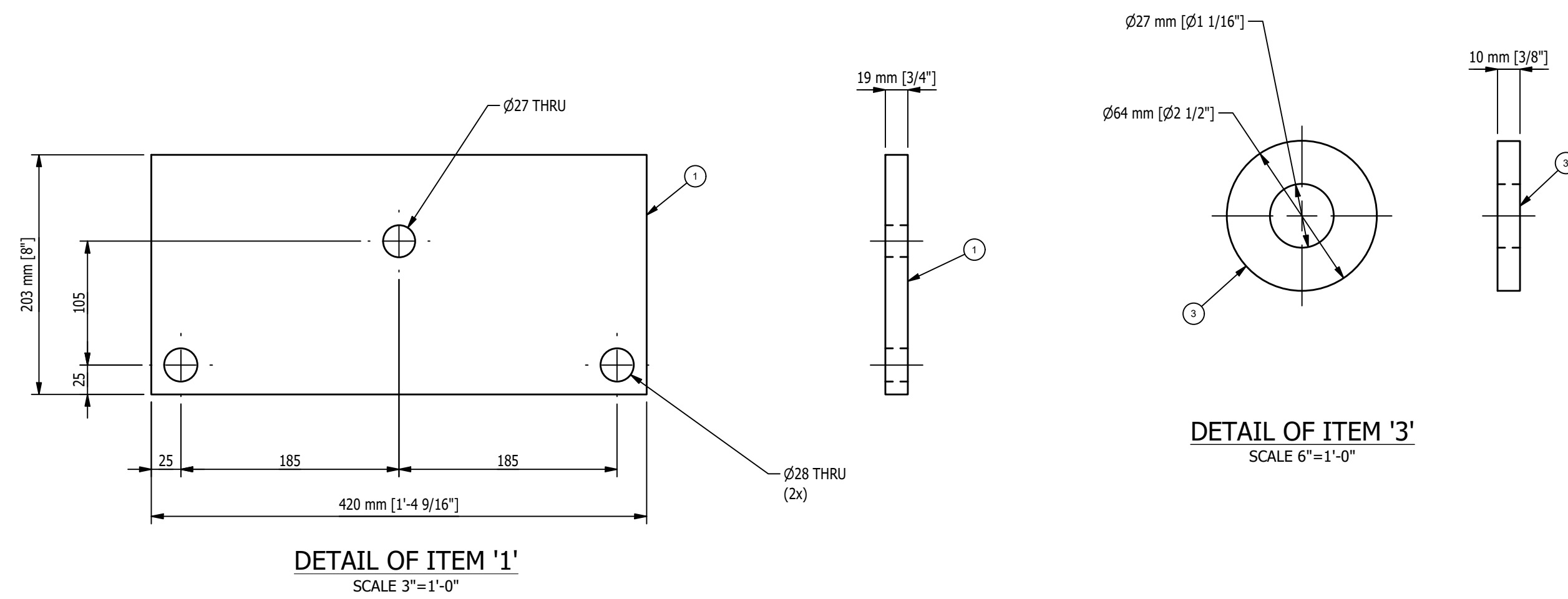
REV: C

JOB No: 22096

DRAWN BY: SGS  
CHECKED BY: CW  
DWG DATE: 6/13/2022



MK-D102A ~ FOOT PAD ASSEMBLY  
SCALE 3"=1'-0"



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

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D102			
1	1	BAR 3/4 x 8	1'-4 9/16"		
2	1	Medium-Strength Steel Threaded Rod 1X8 UNC - 7 In Lg. Grade B7 - McMASTERCARR PART #98750A510			
3	2	FLAT WASHER 1.0625 ID x 2.5 OD x 0.306 THICK			
4	2	1-8UNC HEX JAM NUT			

- 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
  - ONE SHOP COAT OF LIGHT GREY RAL 7035

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/5/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: SGS	
<b>MILLER INDUSTRIES</b> 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		CHECKED BY: CW DWG DATE: 6/13/2022	
<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b> <b>CLIENT: VOLVO</b>		JOB No: 22096	
<b>DRAWING No. 1875D102</b>		<b>REV: A</b>	

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 Novi, MI 48225  
 Phone: (248) 772-8822  
 Fax: (248) 772-8851  
 Web: www.mmagnum.com

MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 1875D102

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:**

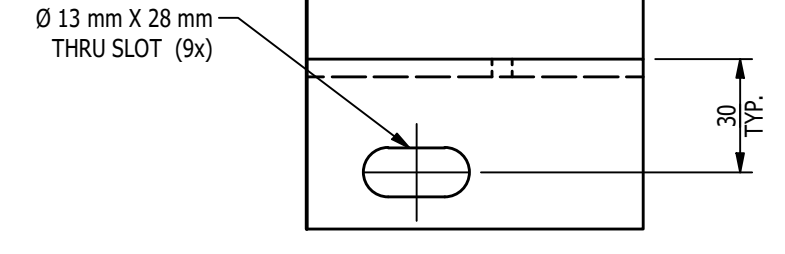
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

**COPIES:**

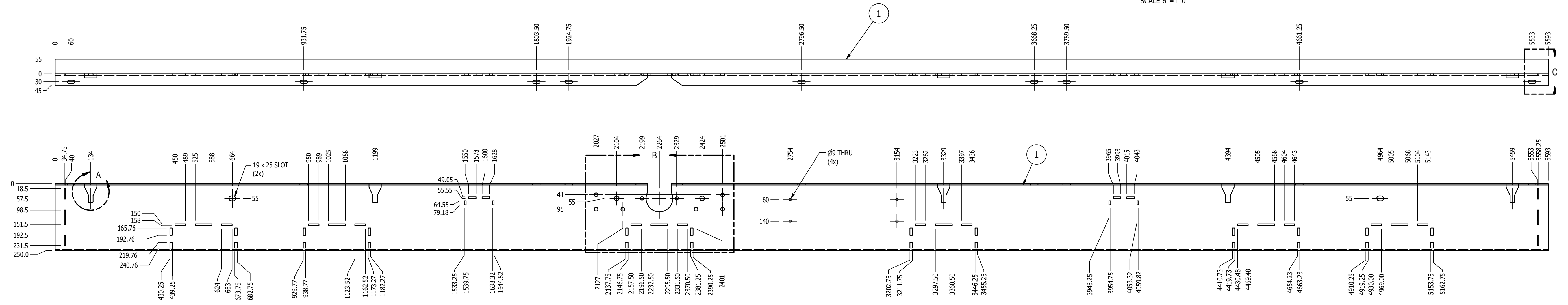
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



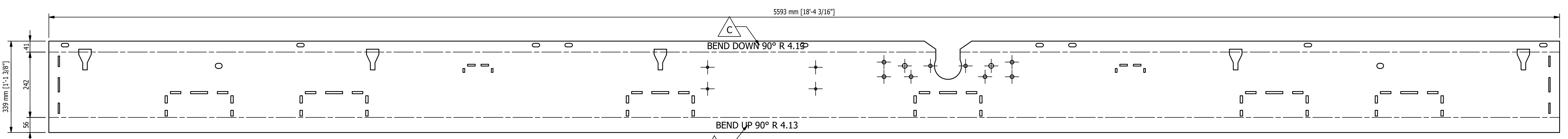
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	PL 3/16 x 1'-1 3/8"	18'-4 3/16"		



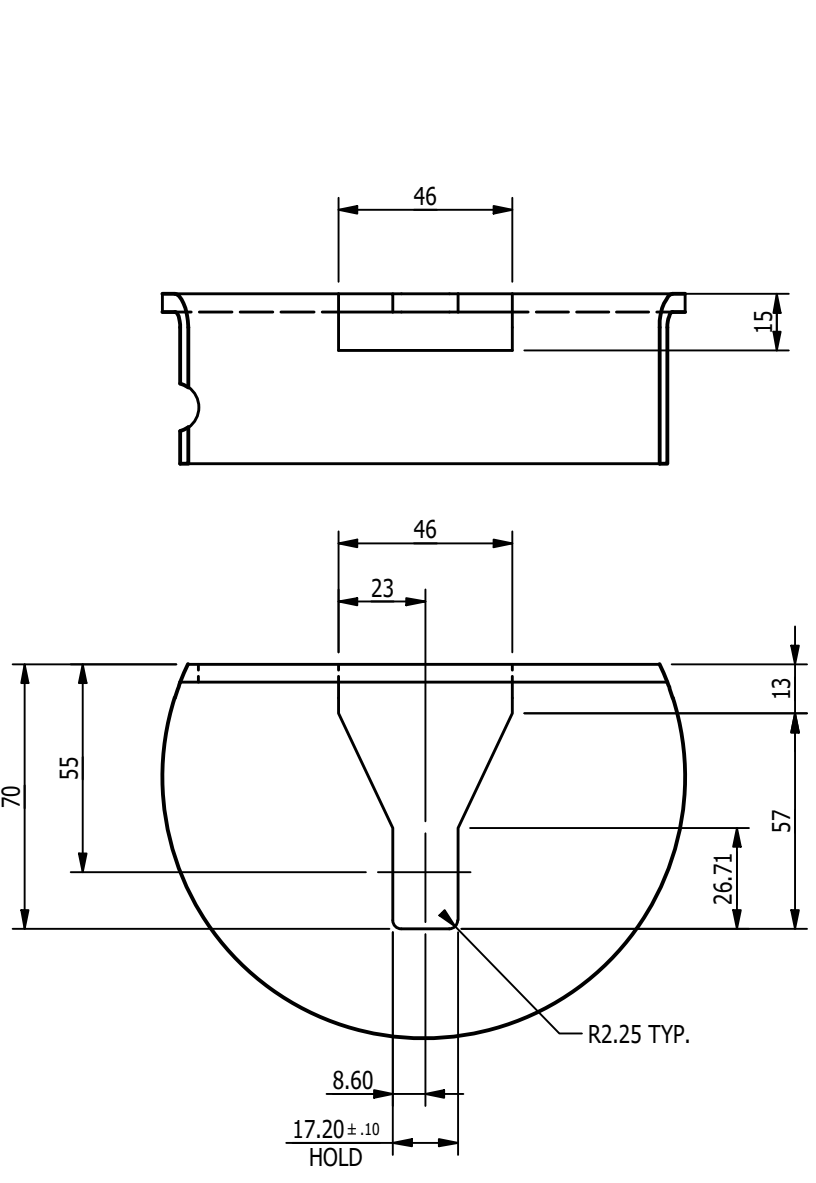
ENLARGED VIEW 'C'  
SCALE 6"=1'-0"



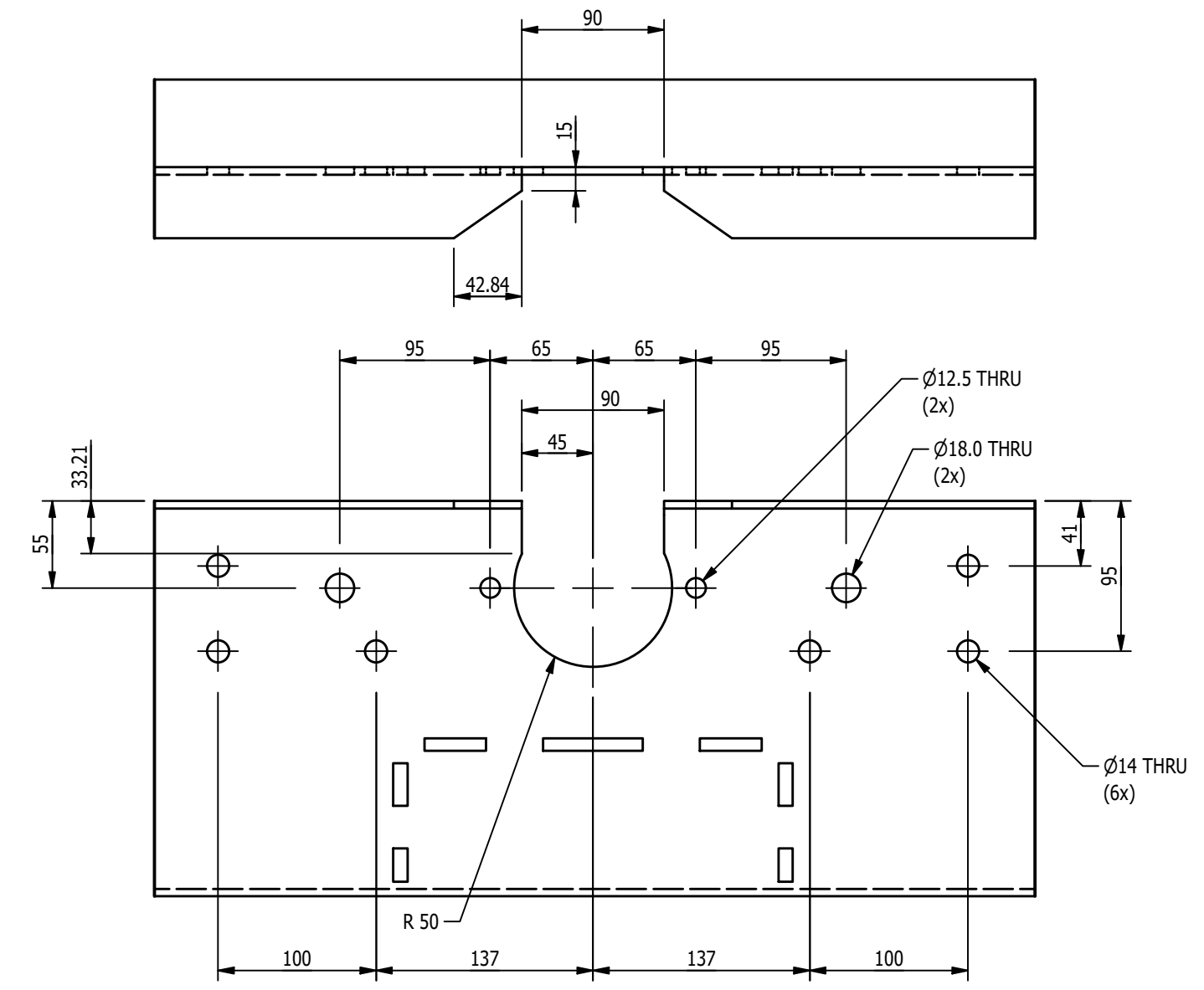
MK-D103A ~ SIDE FRAME  
SCALE 1 1/2"=1'-0"



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



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



ENLARGED VIEW 'B'  
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 AFTER WELDING

**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.

**MAGNUM CONSULTING**

41100 Clarkston Rd.  
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North, MI 48715

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Web: www.milc.com

MAGNUM JOB #:  
MAGNUM DRAWING #:

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	9/20/2022	REVISED BEND NOTES	
B	MC	7/13/2022	REVISED & ADDED DIMENSIONS & SHOP NOTE	
A	MC	7-5-22	FOR FABRICATION	

**REVISION HISTORY**

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

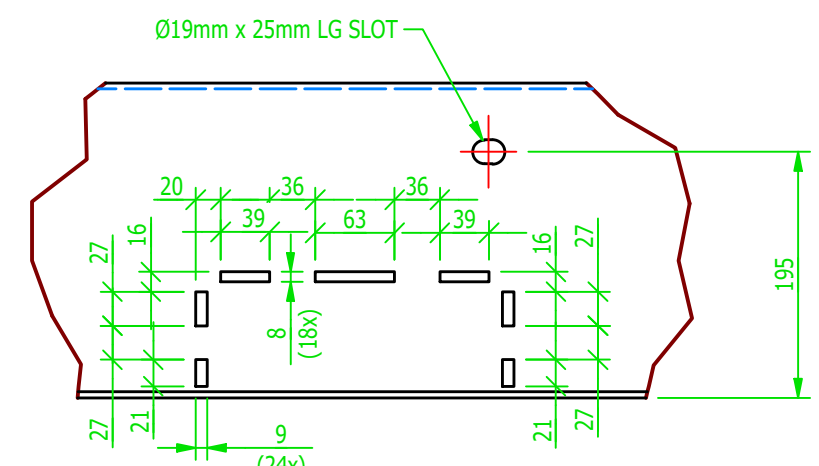
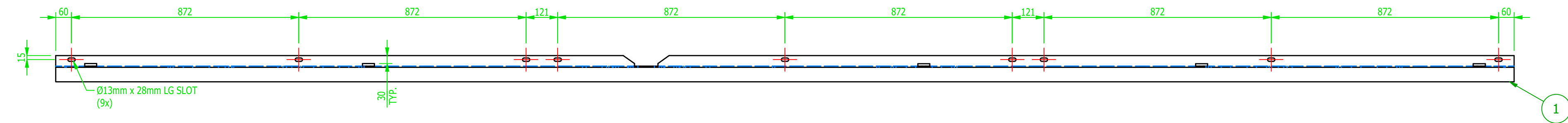
**TITLE:** P6700 CONVEYORS CAMPUS BUILDING  
**CLIENT:** VOLVO  
**DRAWING No.:** 1875D103

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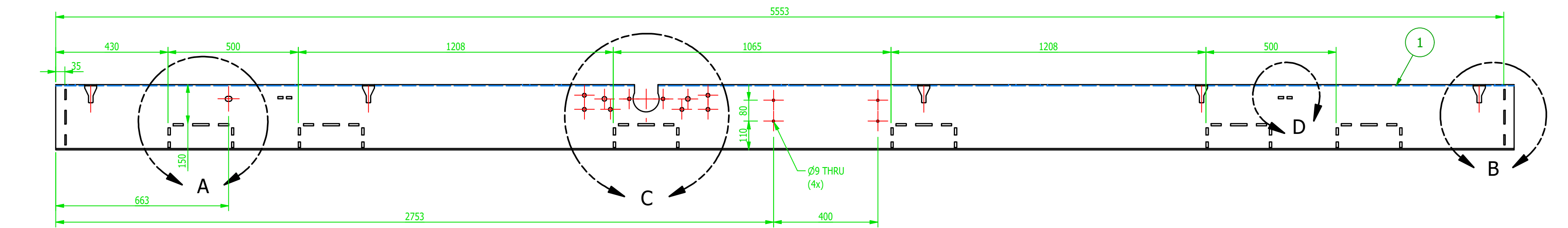
**DRAWN BY:** SGS  
**CHECKED BY:** CW  
**DWG DATE:** 6/13/2022  
**JOB No.:** 22096



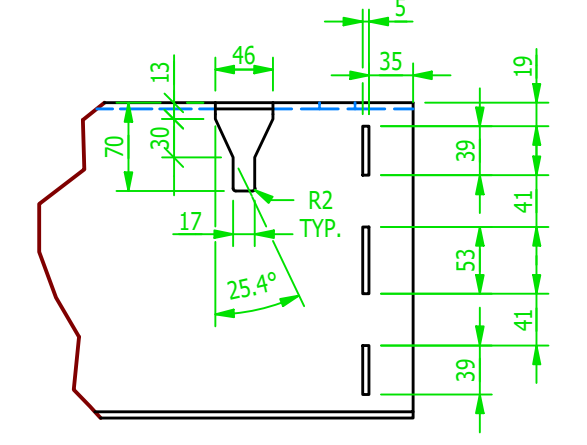
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D104A			
		PL 3/16 x 1'-1 3/8	18'-4 3/16"		



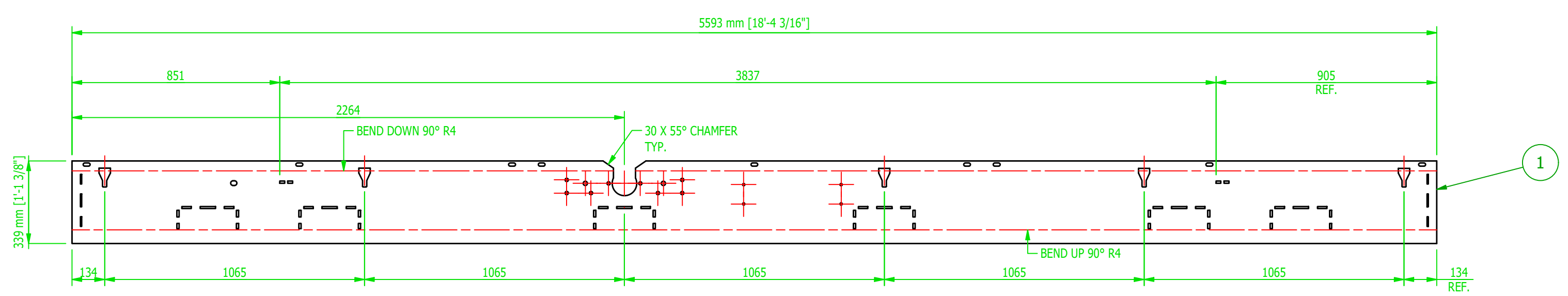
ENLARGED VIEW 'A'  
SCALE 1 / 6



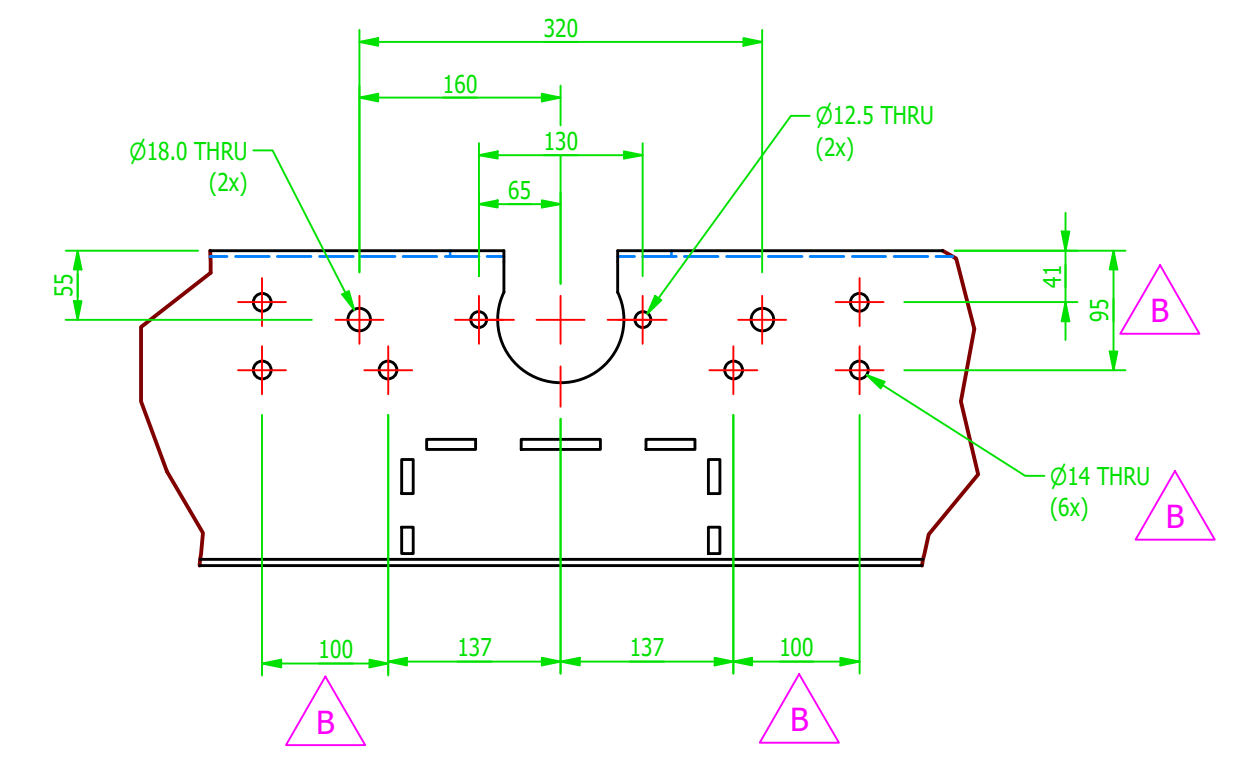
MK-D104A ~ SIDE FRAME  
SCALE 1"=1'-0"



ENLARGED VIEW 'B'  
SCALE 1 / 6

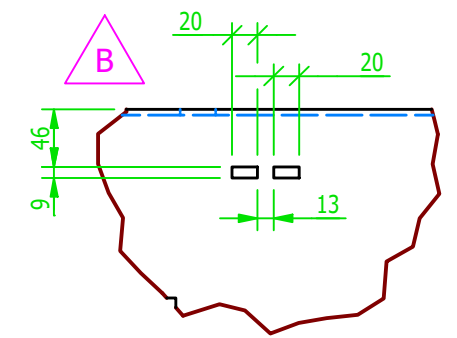


FLAT PATTERN OF ITEM '1'  
SCALE 3/4"=1'-0"



ENLARGED VIEW 'C'  
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.
- PAINT NOTES:**
1. PAINT AFTER WELDING



ENLARGED VIEW 'D'  
SCALE 1 / 6

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/13/2022	REVISED DIMENSIONS & ADDED HOLES AND SHOP NOTE	
A	MC	7/5/22	FOR FABRICATION	

REVISION HISTORY	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING
CLIENT:	VOLVO
DRAWING No.	1875D104
REV:	B
DRAWN BY:	SGS
CHECKED BY:	CW
DWG DATE:	6-13-2022
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 #: 1875D104

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)

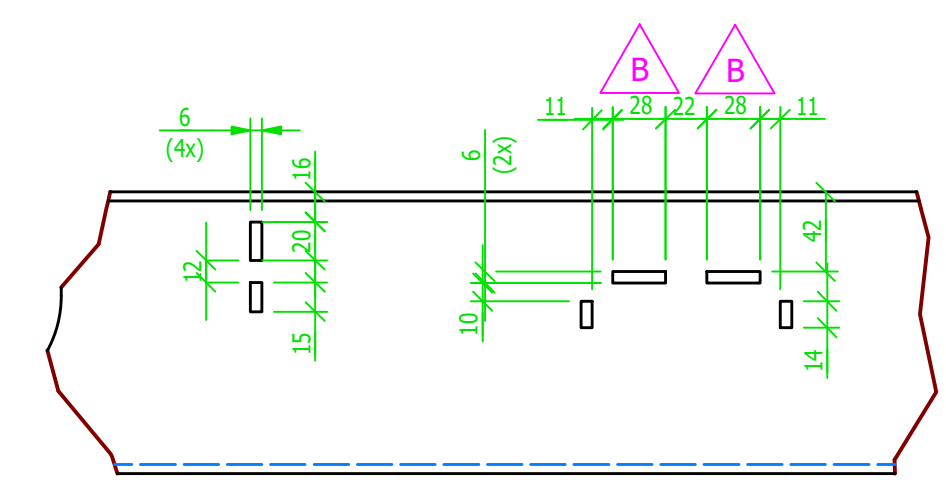
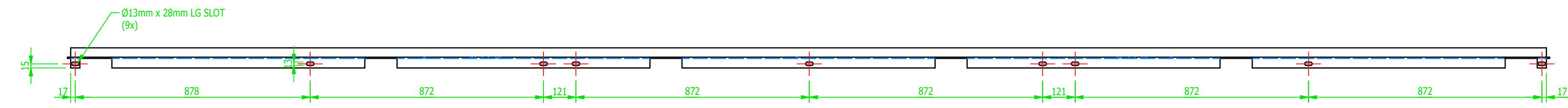
**PAINT:**

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

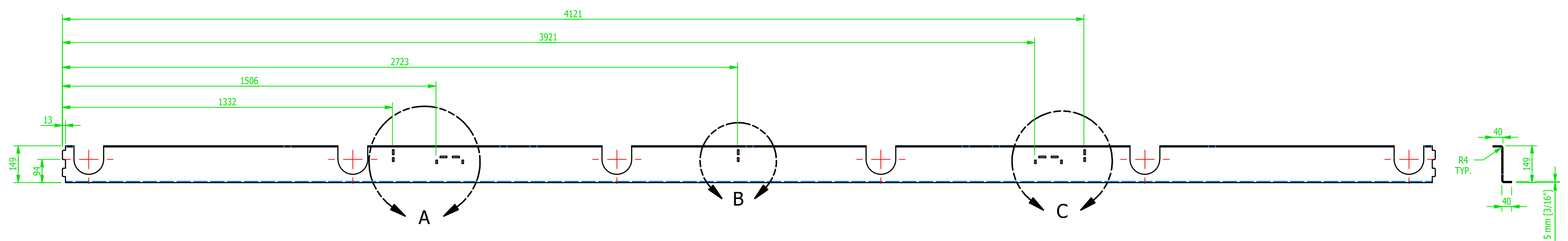
**COPIES:**

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

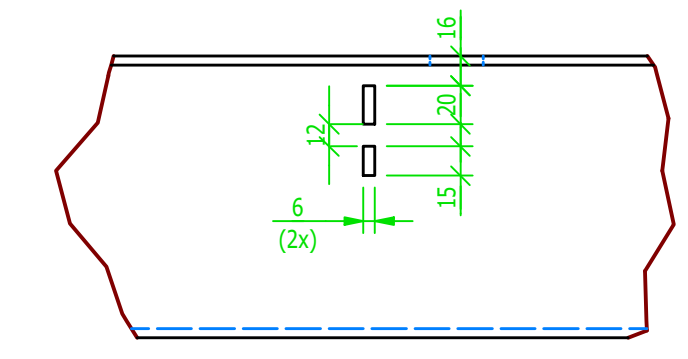
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D105A			
		PL 3/16" X 8 3/8"	18'-2 1/16"		



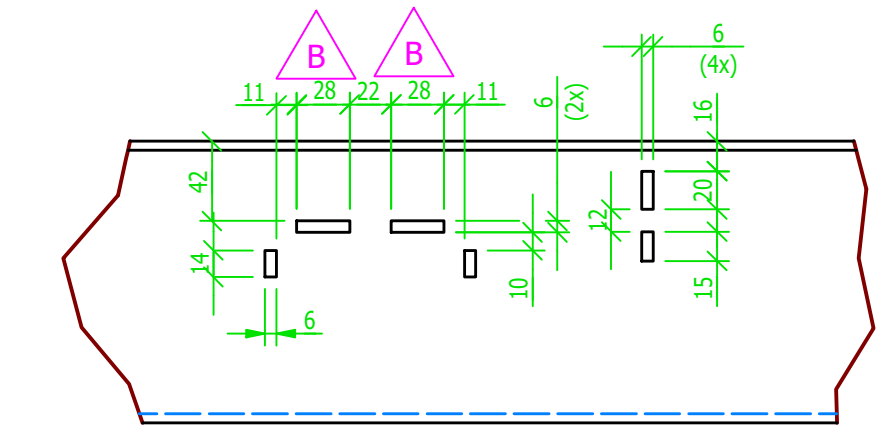
ENLARGED VIEW 'A'  
SCALE 3"=1'-0"



MK-D105A ~ MID FRAME  
SCALE 1"=1'-0"

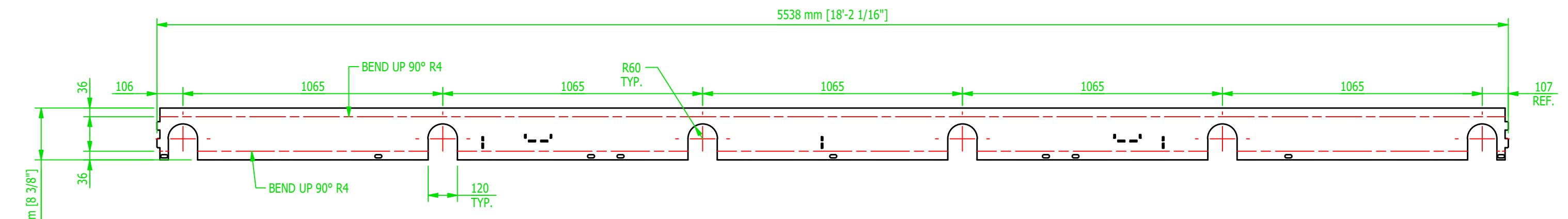


ENLARGED VIEW 'B'  
SCALE 3"=1'-0"



ENLARGED VIEW 'C'  
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 AFTER WELDING



FLAT PATTERN OF ITEM '1'  
SCALE 3/4"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/12/2022	REVISED SLOTS & ADDED SHOP NOTE	
A	MC	7/5/22	FOR FABRICATION	

REVISION HISTORY	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING
CLIENT:	VOLVO
DRAWING No.	1875D105
REV:	B
DRAWN BY:	SGS
CHECKED BY:	CW
DWG DATE:	6-13-2022
JOB No:	22096

**MAGNUM Consulting**  
41100 Charleston Rd  
Suite 125  
Norris, MI 48251  
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:**

**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.

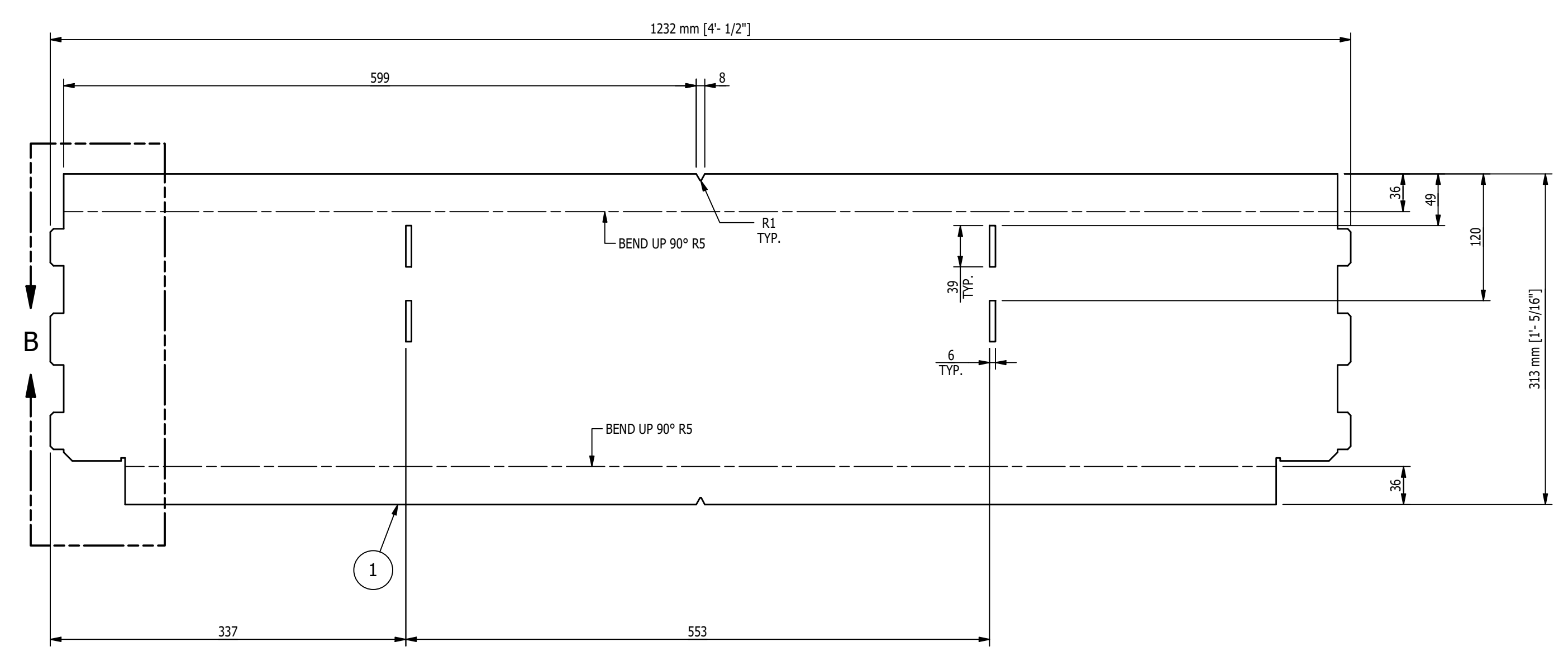
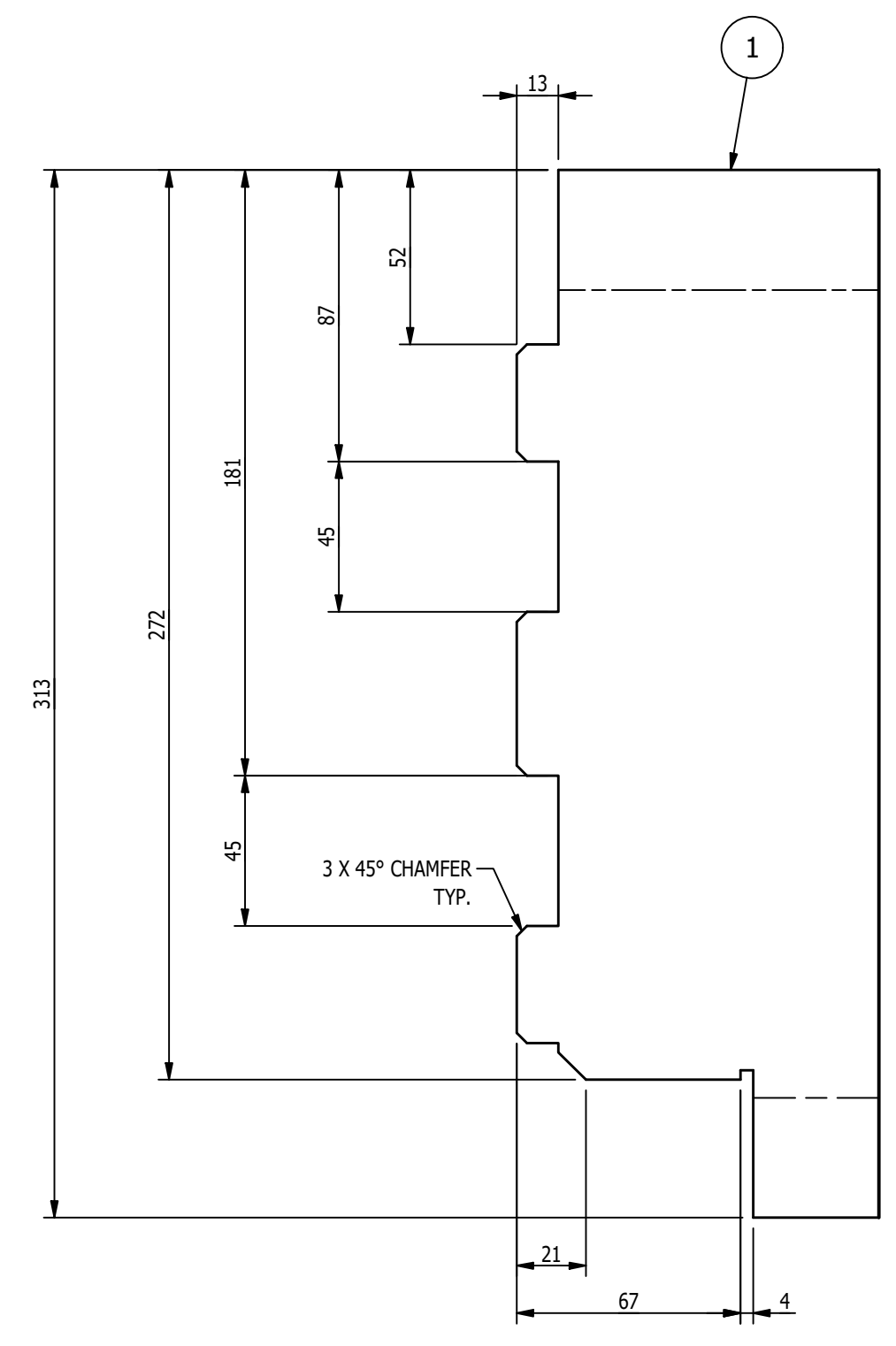
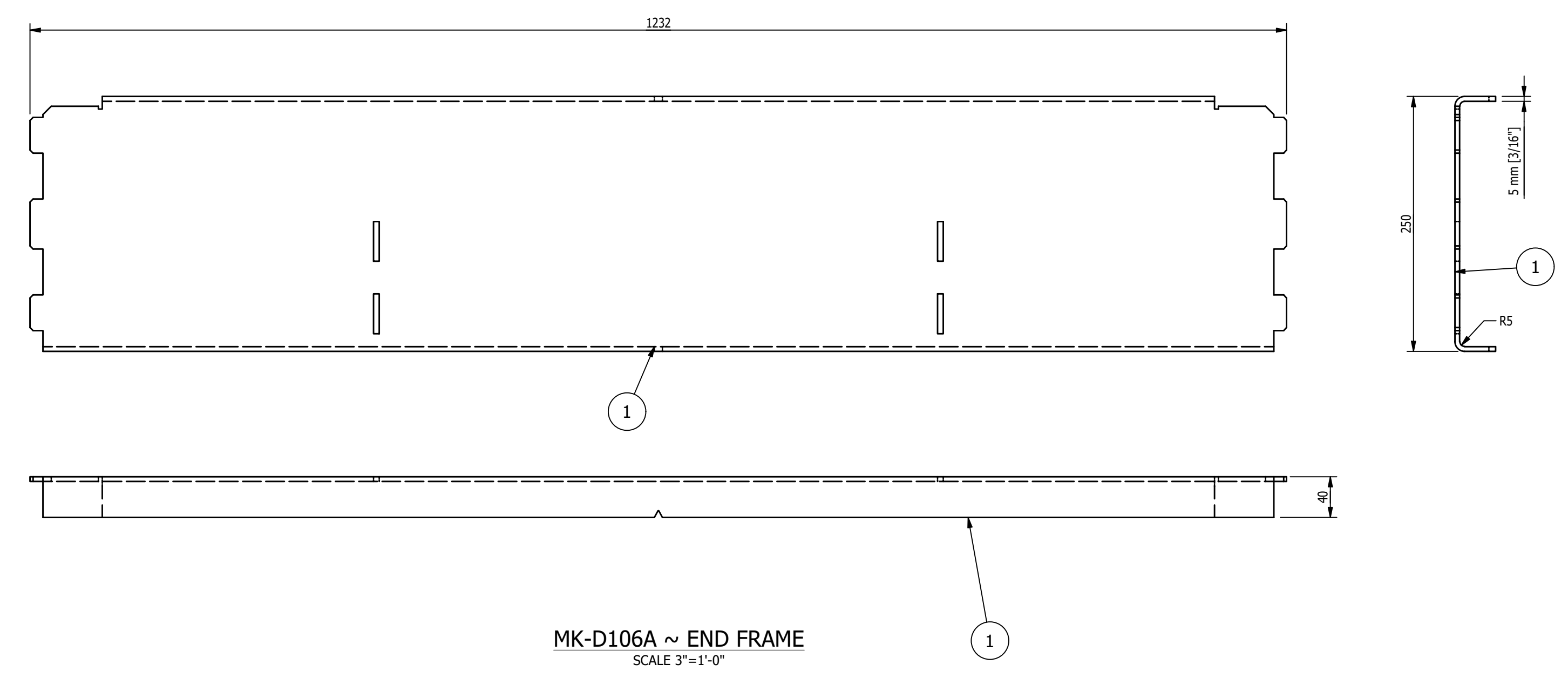
**WELDS:**  
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

**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-D106A			
1	1	PL 3/16 x 1'- 5/16"	4'- 1/2"		



- 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 AFTER WELDING

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/5/22	FOR FABRICATION	

**REVISION HISTORY**

	<b>MILLER INDUSTRIES</b> 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.
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<b>TITLE:</b> P6700 CONVEYORS CAMPUS BUILDING	<b>DRAWN BY:</b> SGS
<b>CLIENT:</b> VOLVO	<b>CHECKED BY:</b> CW
<b>DRAWING No.:</b> 1875D106	<b>DWG DATE:</b> 6-13-2022
<b>REV:</b> A	<b>JOB No.:</b> 22096

**MAGNUM Consulting**  
41100 Quakerbridge Rd.  
Suite 125  
North, MI 48135  
Phone: (248) 772-8822  
Fax: (248) 772-8851  
Web: www.mmagnum.com

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D106

**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.

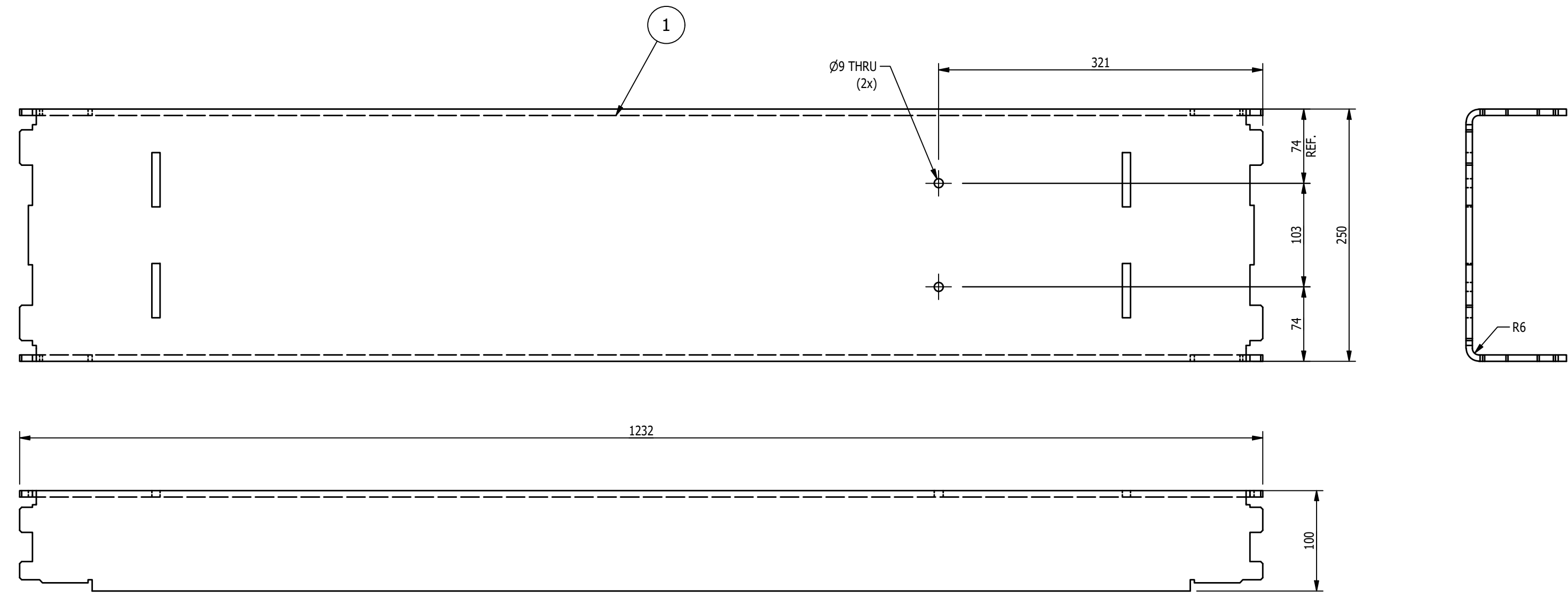
**HOLES:**  
- ALL HOLES ARE 13/16" DIA. U.N.O.  
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

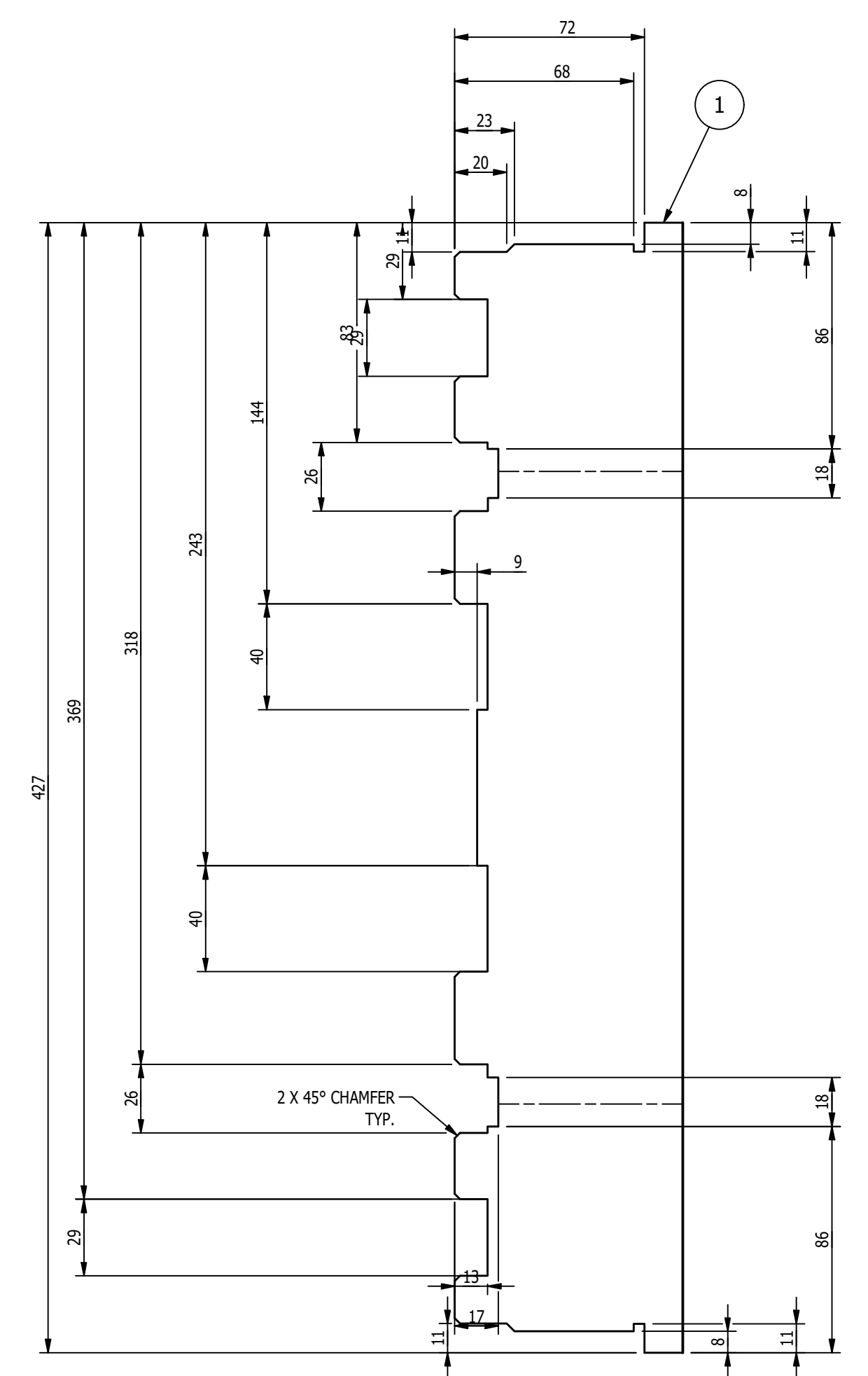
**PAINT:**  
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

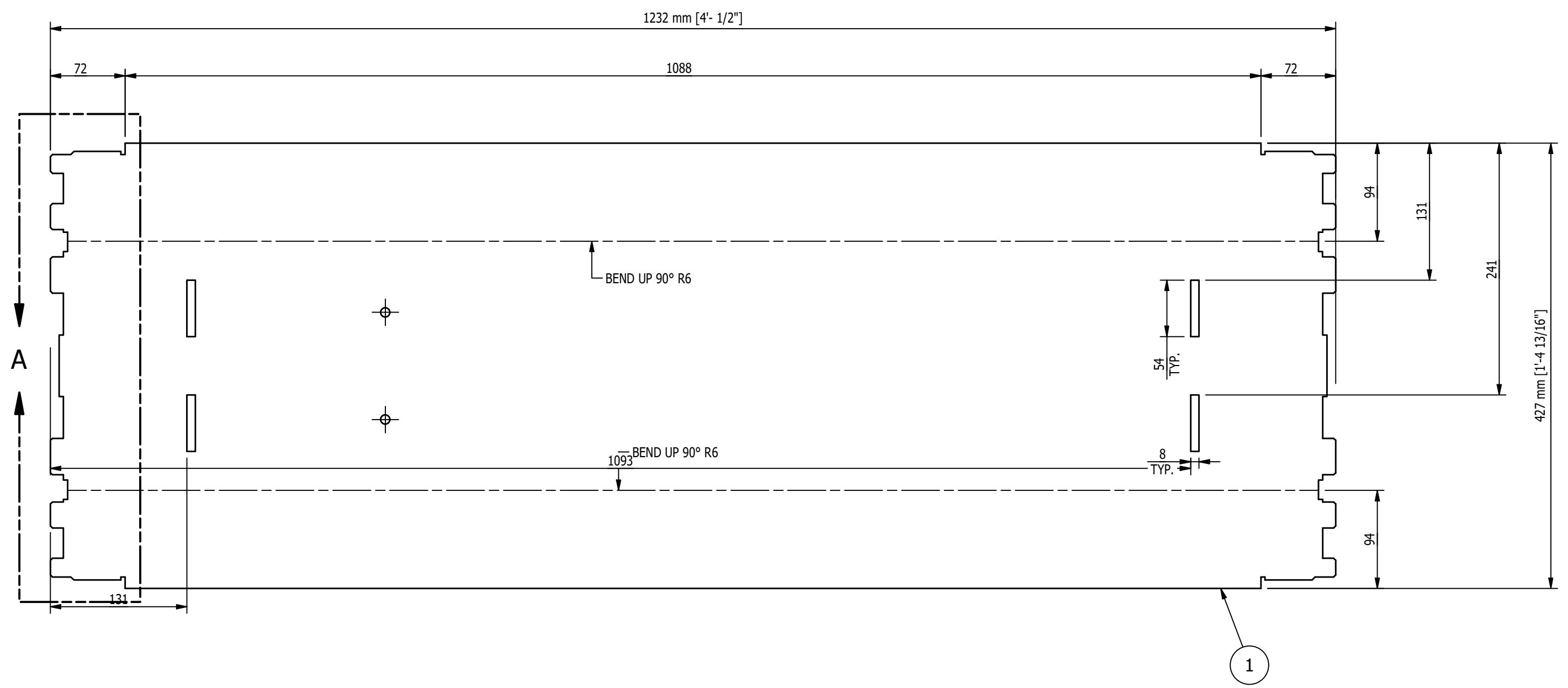
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D107A			
1	1	PL 1/4 x 1'-4 13/16"	4'- 1/2"		



MK-D107A ~ INNER CROSS MEMBER  
SCALE 3"=1'-0"



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



FLAT PATTERN OF MARK '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 AFTER WELDING

**MAGNUM Consulting**  
41100 Charleston Rd.  
Suite 125  
Wood, MI 48095  
Phone: (248) 772-8832  
Fax: (248) 772-8851  
Web: www.mmagnum.com

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D107

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.

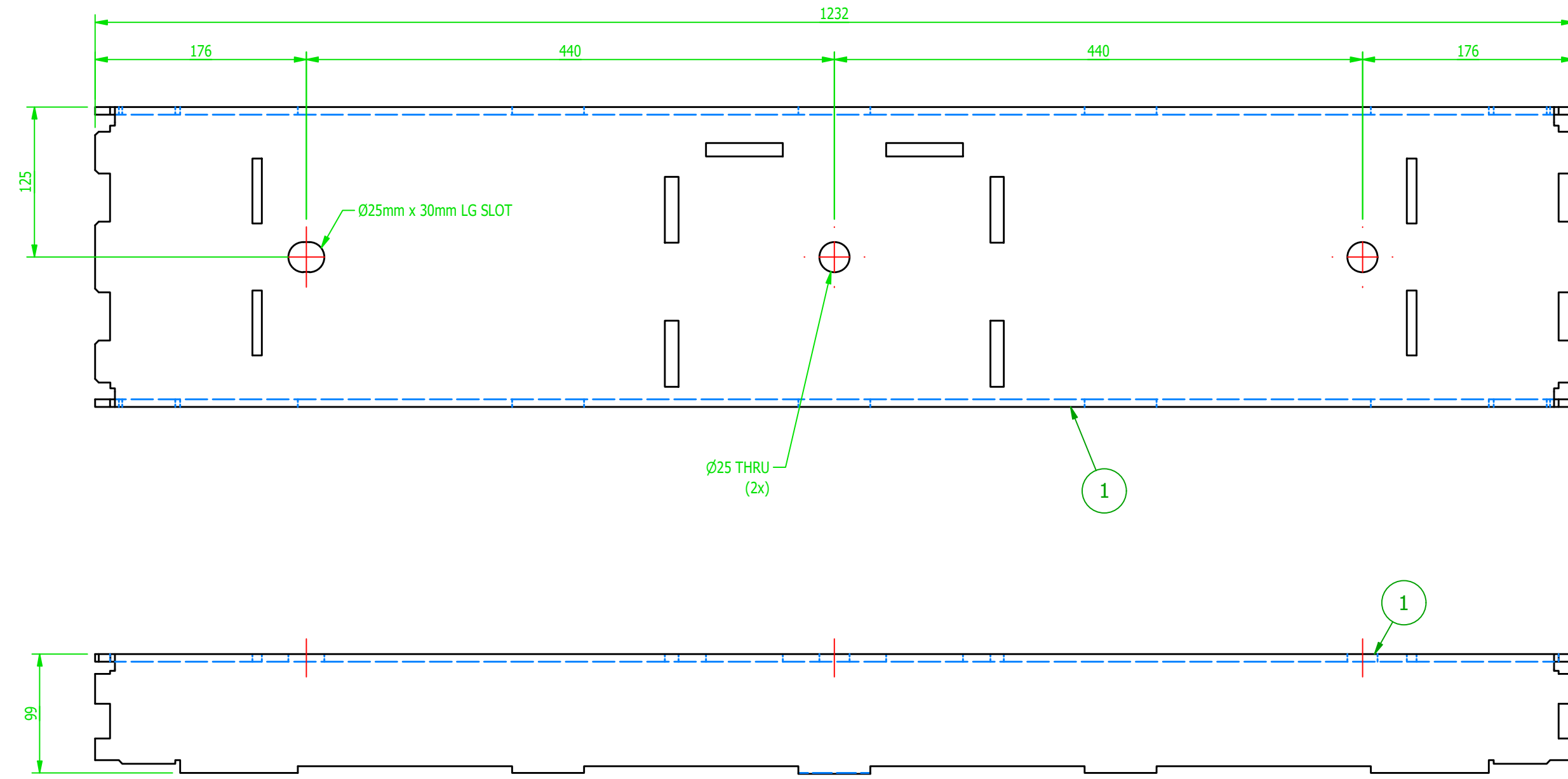
**COPIES:**  
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

A	MC	7/5/22	FOR FABRICATION	
REV	BY	DATE	DESCRIPTION	APP
REVISION HISTORY				

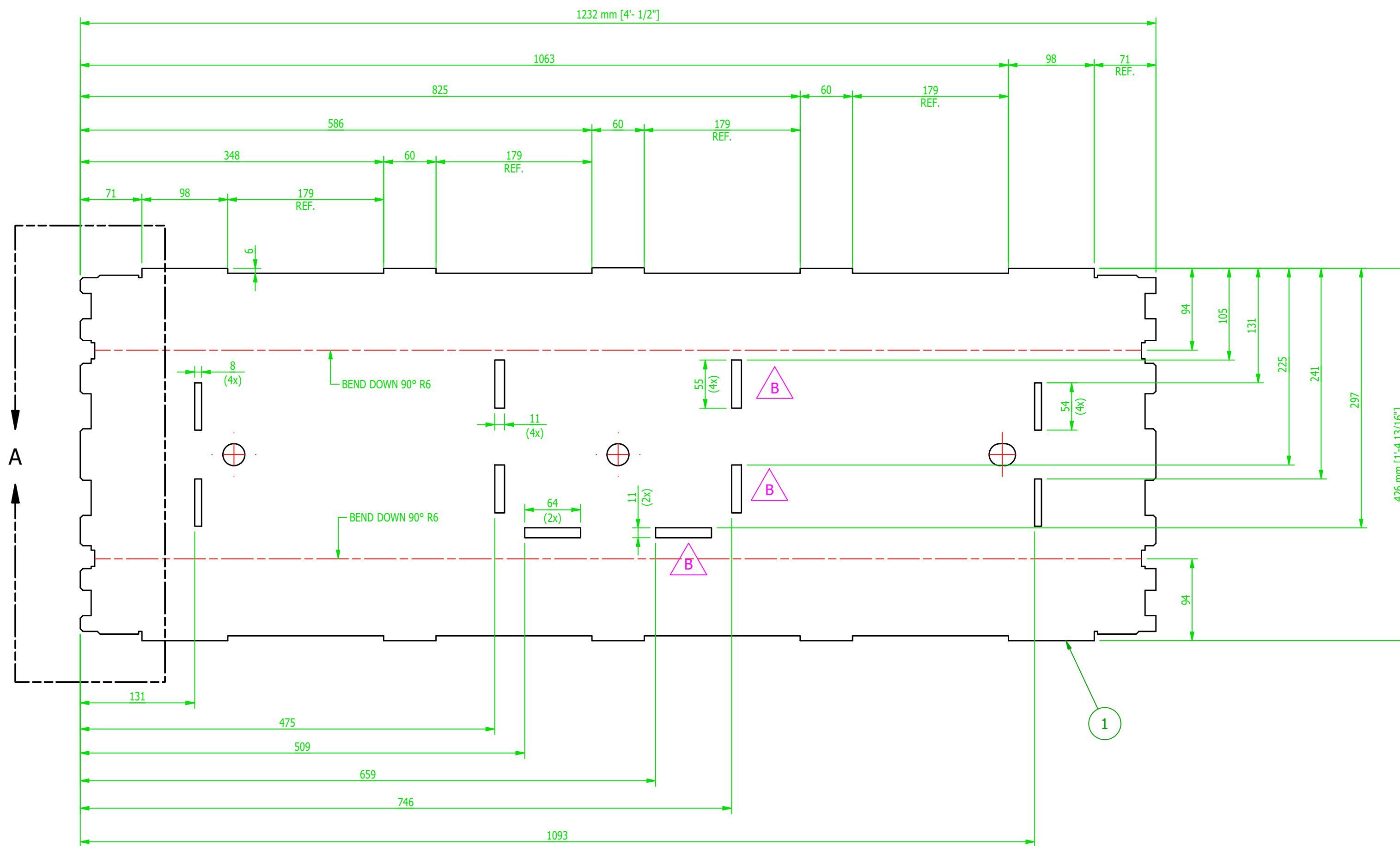
	<b>MILLER INDUSTRIES</b> 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com			PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	<b>TITLE:</b> P6700 CONVEYORS CAMPUS BUILDING	<b>DRAWN BY:</b> SGS	<b>CHECKED BY:</b> CW	<b>DWG DATE:</b> 6-14-2022
<b>CLIENT:</b> VOLVO	<b>DRAWING No.:</b> 1875D107	<b>REV:</b> A	<b>JOB No.:</b> 22096	



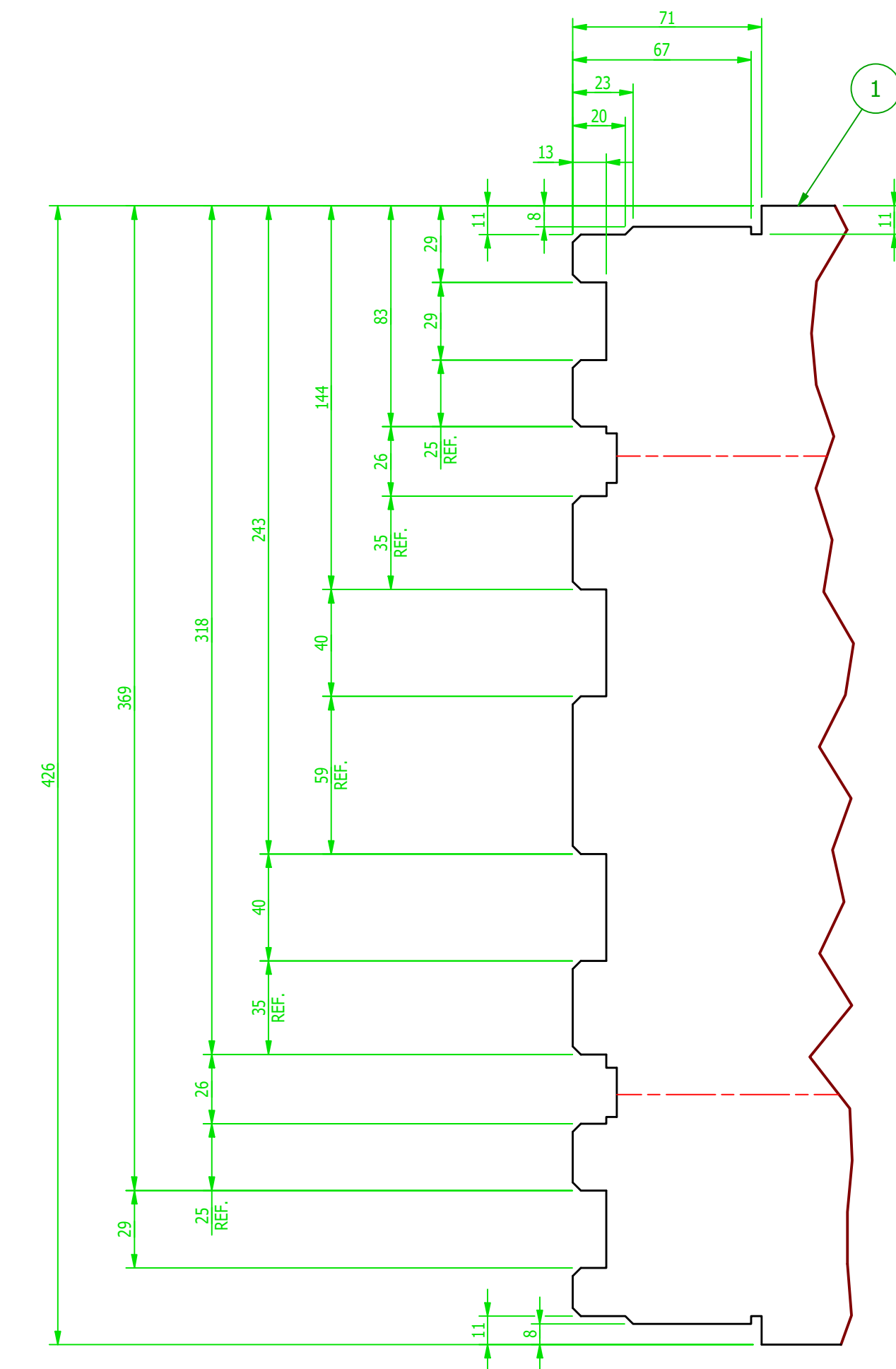
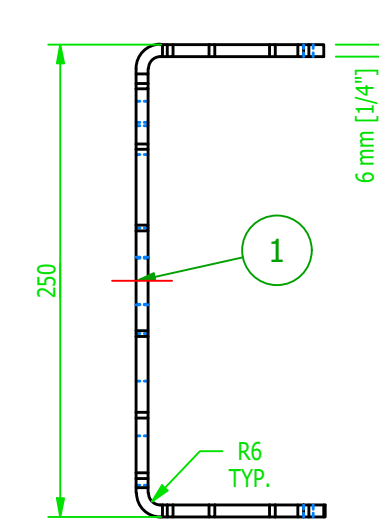
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D108A			
1	1	PL 1/4 x 1'-4 13/16	4'- 1/2"		



MK-D108A ~ INNER CROSS MEMBER  
SCALE 3"=1'-0"



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



ENLARGED VIEW 'A'  
SCALE 6"=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 AFTER WELDING

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	7/06/2022	SLOTS FOR GUIDE ROLLER CHANGED	
A	MC	7/01/2022	FOR FABRICATION	

REVISION HISTORY

**MAGNUM Consulting**  
41100 Charleston Rd.  
Suite 125  
Wood, MI 48095  
Phone: (248) 772-8822  
Fax: (248) 772-8851  
Web: www.milc.com

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D108

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.milc.com

**TITLE: P6700 CONVEYORS CAMPUS BUILDING**

CLIENT: VOLVO

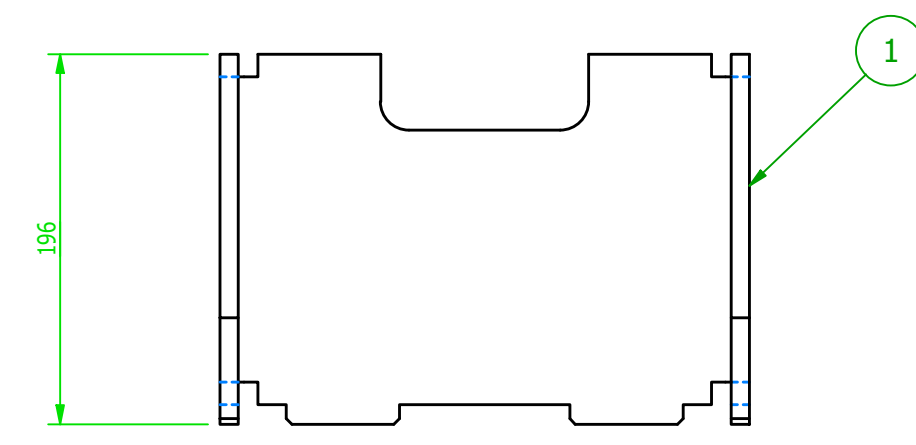
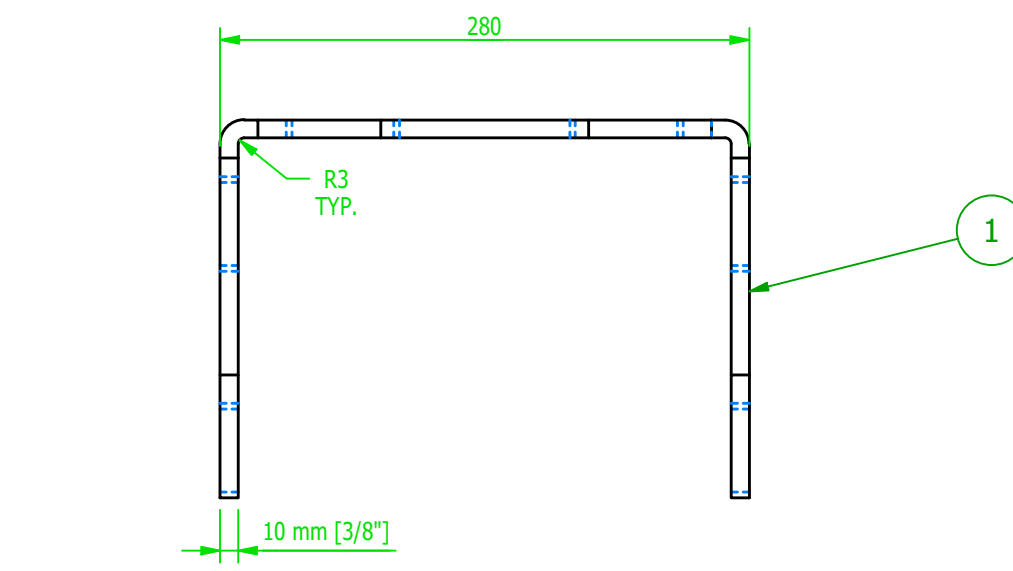
DRAWING No. 1875D108

REV: B

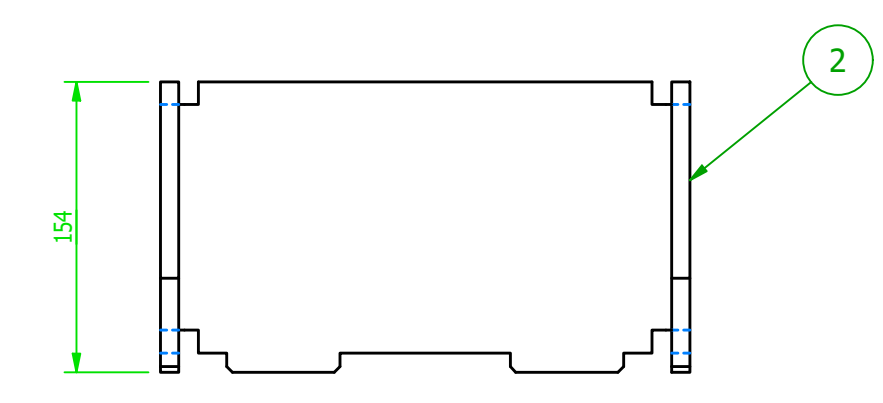
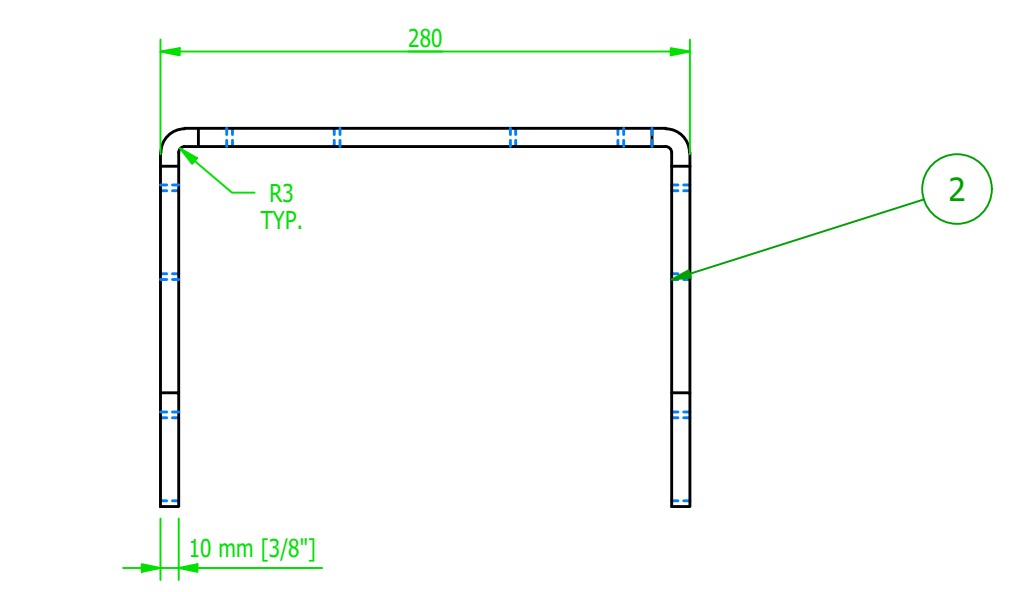
JOB No: 22096

DRAWN BY: SGS  
CHECKED BY: CW  
DWG DATE: 6-14-2022

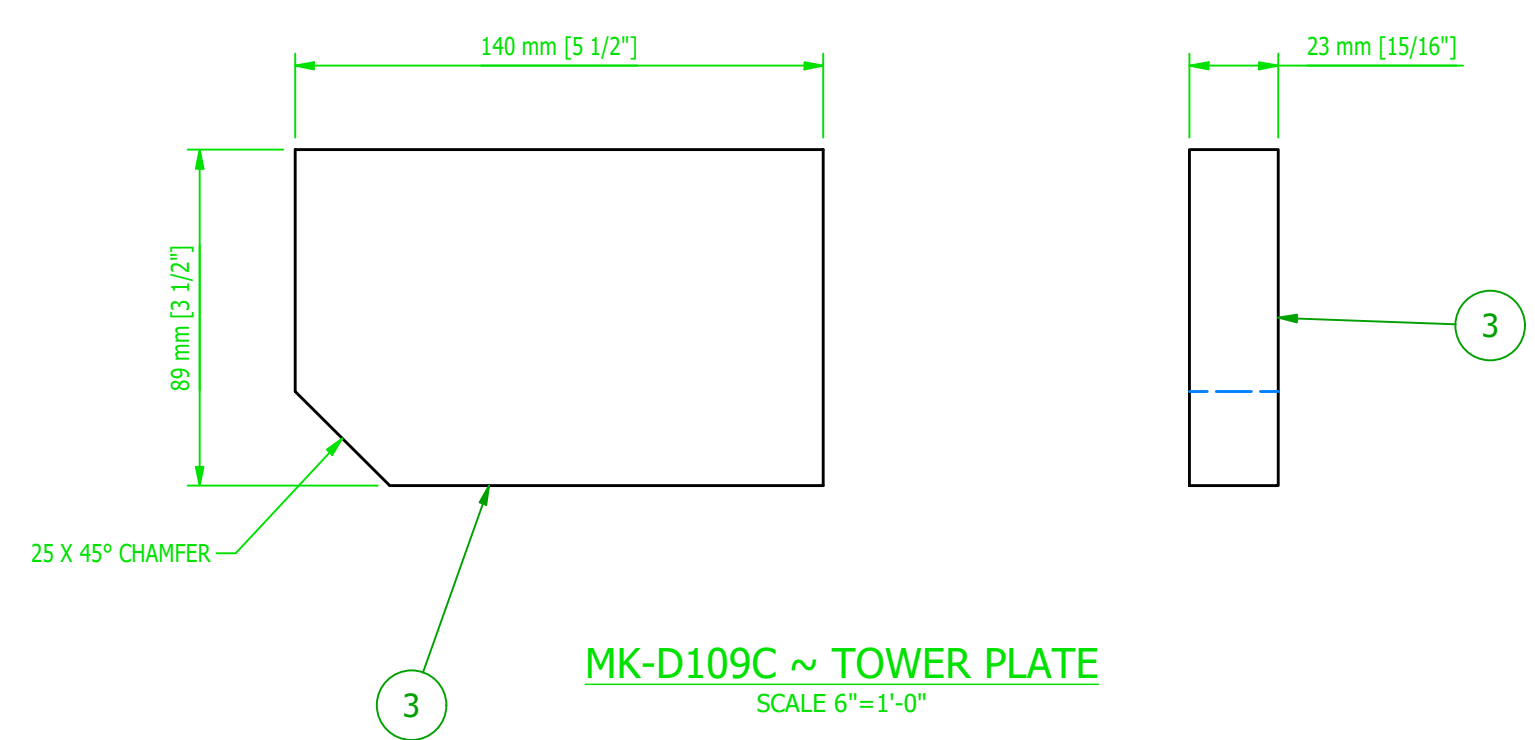
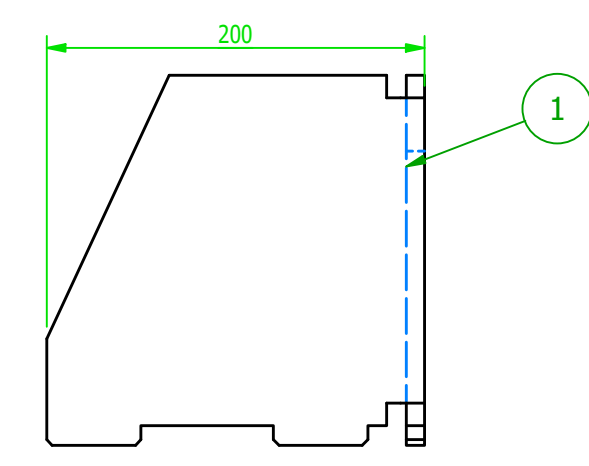
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D109A			
1	1	PL 3/8 x 7 11/16"	2'-1 11/16"		
		MK-D109B			
2	1	PL 3/8 x 6 1/16"	2'-1 11/16"		
		MK-D109C			
3	1	BAR 15/16 x 3 1/2	5 1/2"		



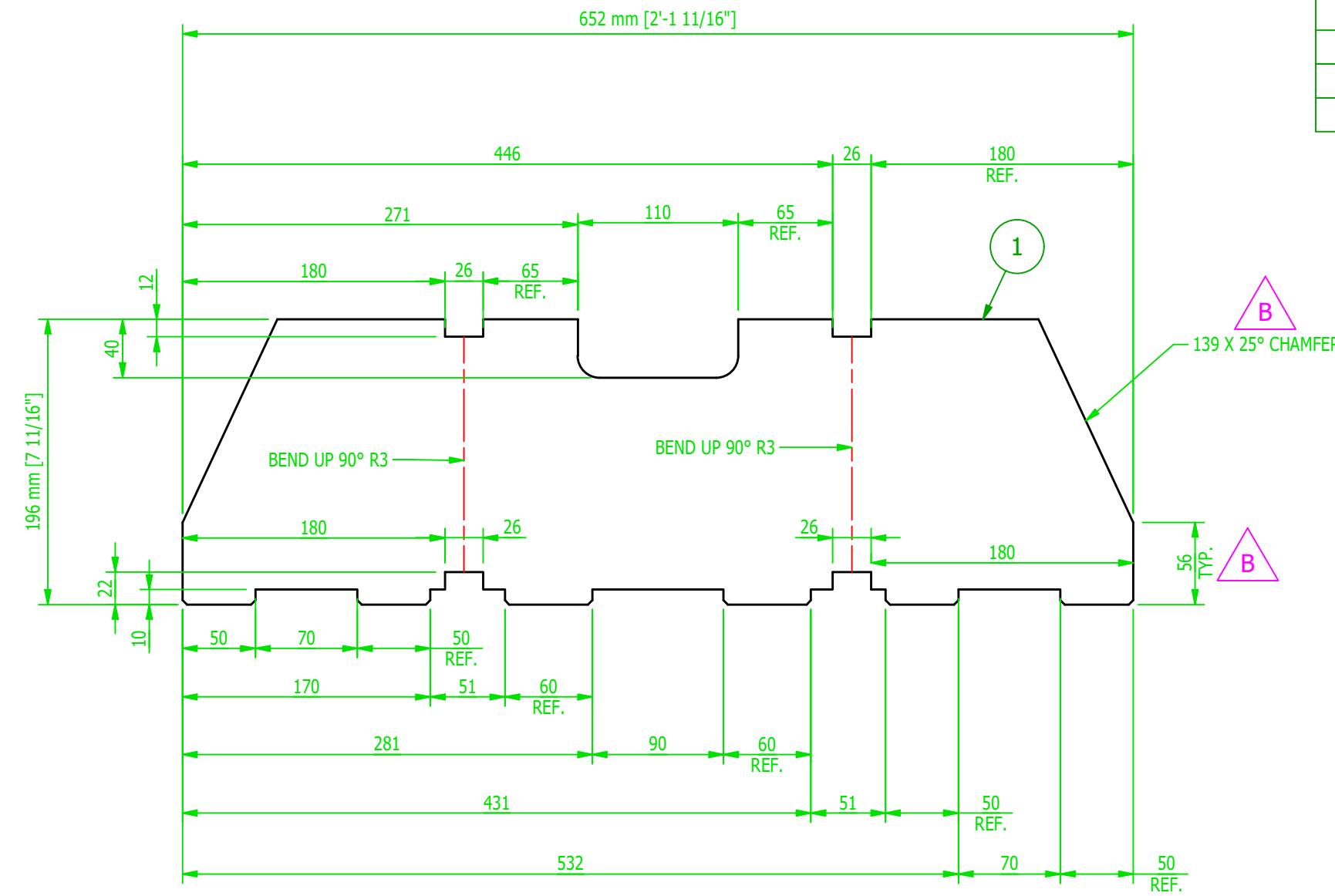
MK-D109A ~ GUIDE ROLLER TOWER-LH  
SCALE 3"=1'-0"



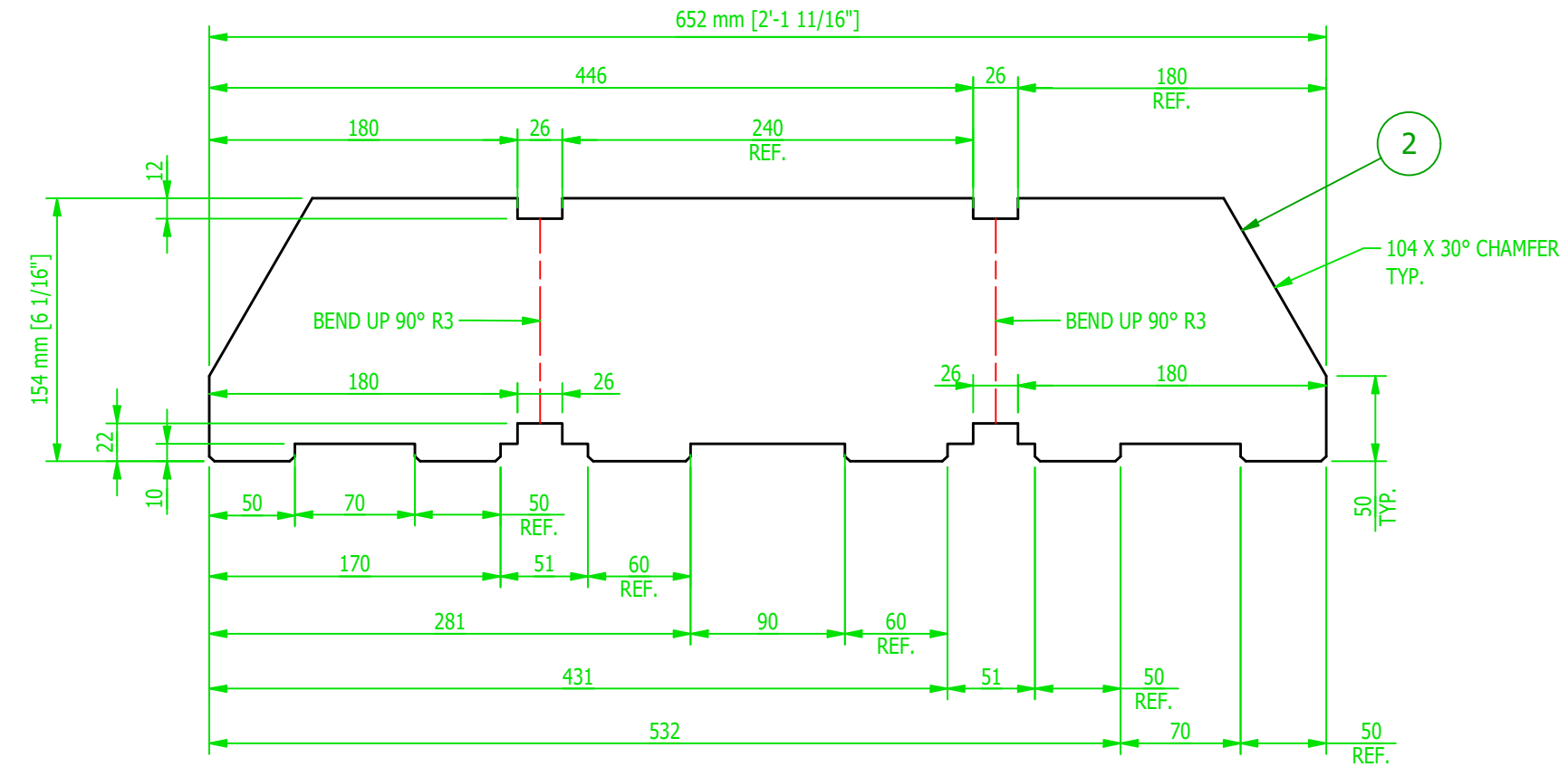
MK-D109B ~ GUIDE ROLLER TOWER-RH  
SCALE 3"=1'-0"



MK-D109C ~ TOWER PLATE  
SCALE 6"=1'-0"



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



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

B

B

B

2

3

- 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 AFTER WELDING

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/06/2022	DIMENSIONAL MODIFICATION ITEM 1	
A	MC	7/01/2022	FOR FABRICATION	

REVISION HISTORY	
REV	APP

**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:	SGS
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D109	DWG DATE:	6-14-2022
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:**

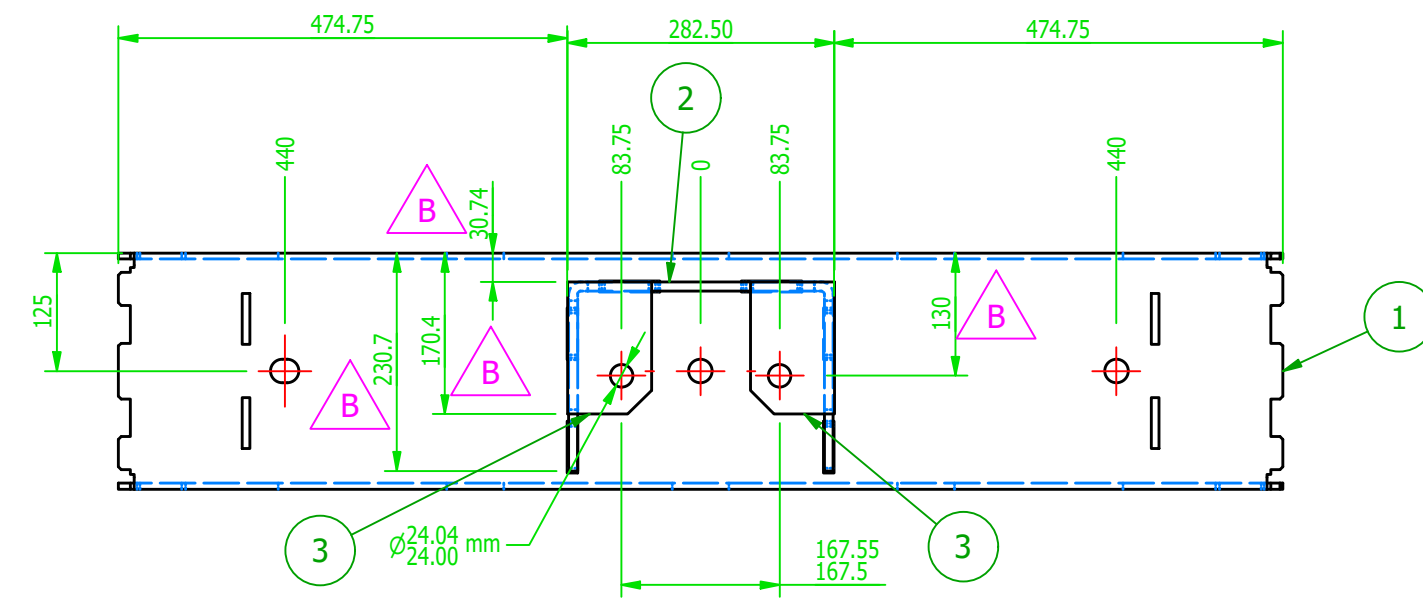
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

**MAGNUM CONSULTING**  
41100 Clarkston Rd.  
Suite 125  
North, MI 48055  
Phone: (248) 772-8822  
Fax: (248) 772-8851  
Web: www.mmagnum.com

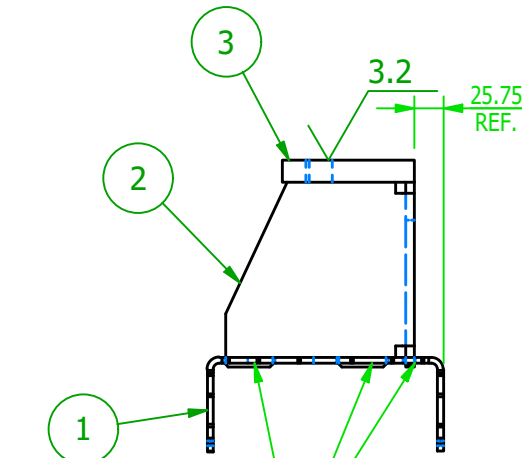
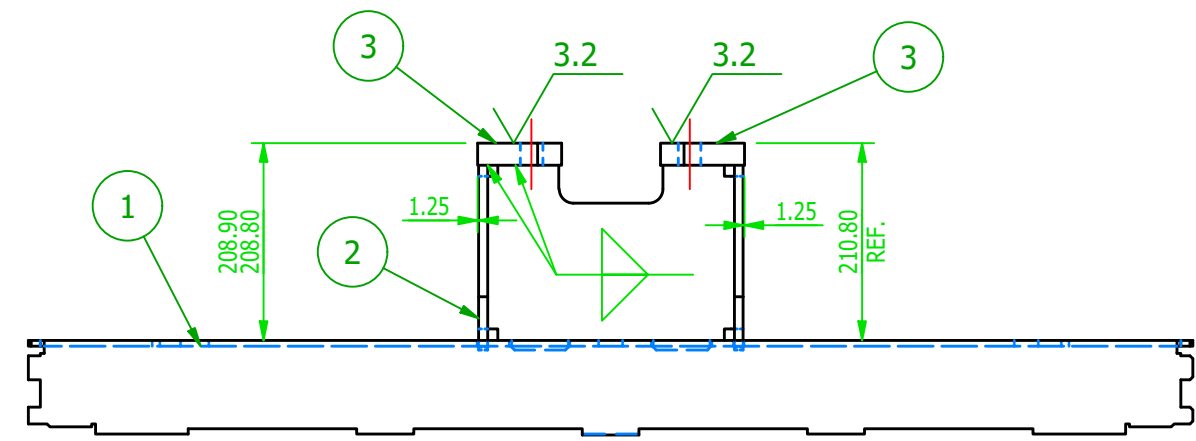
MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D109

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

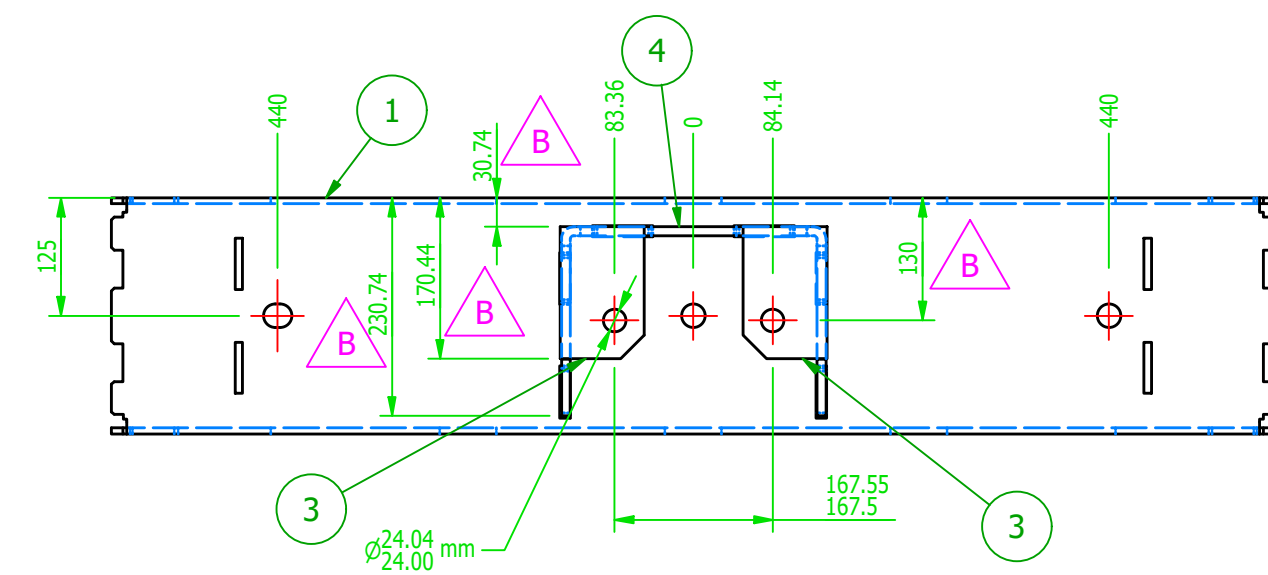
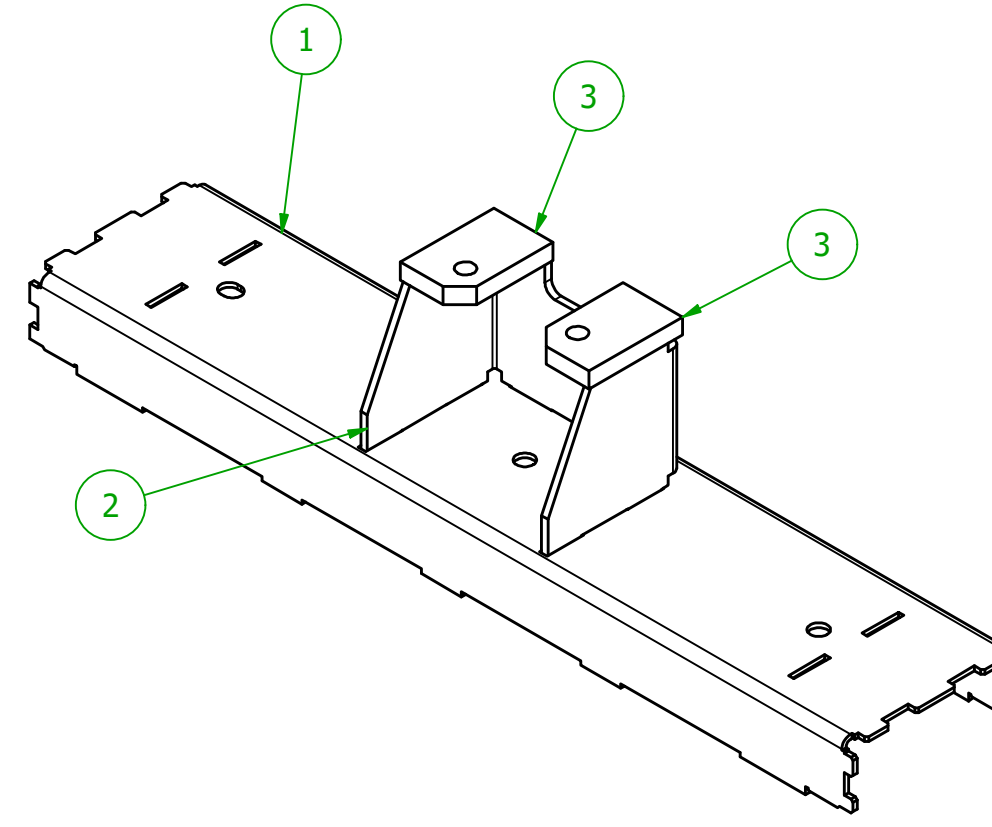




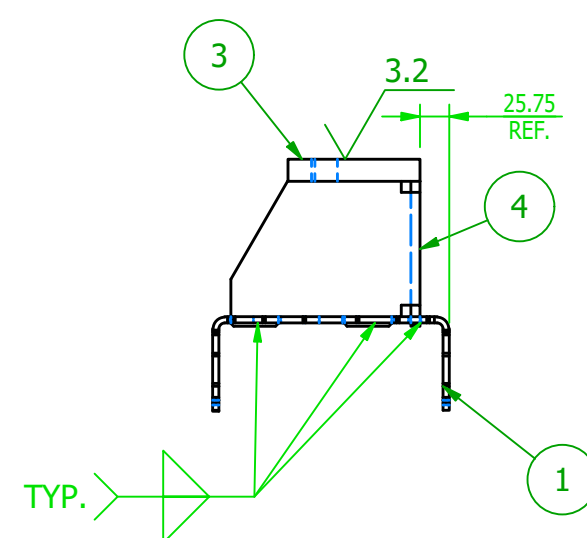
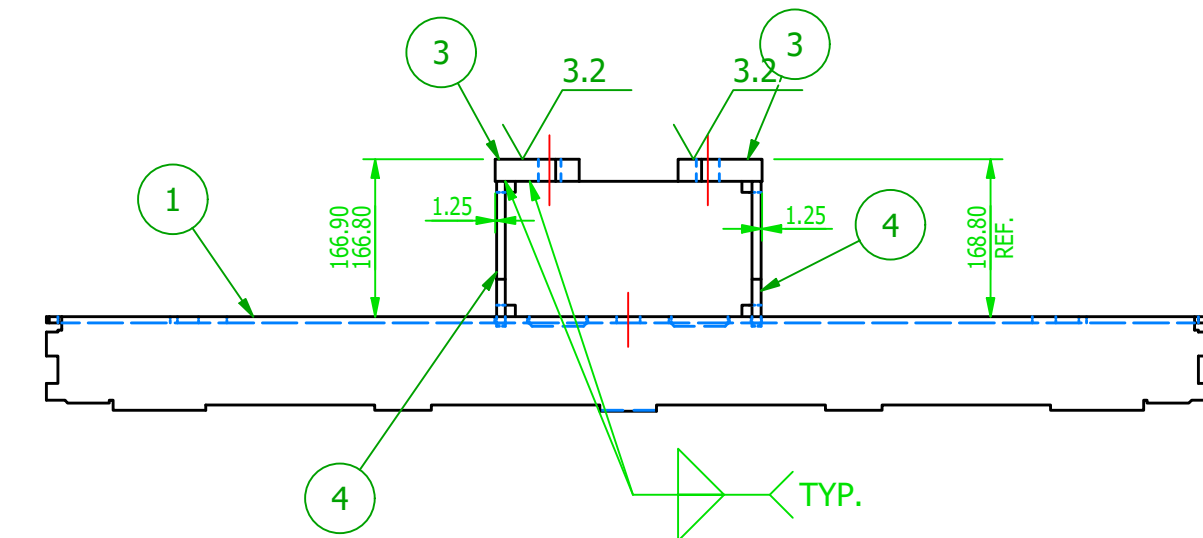
MK-D110A ~ INNER CROSS MEMBER WELDMENT-LH  
SCALE 1 1/2"=1'-0"



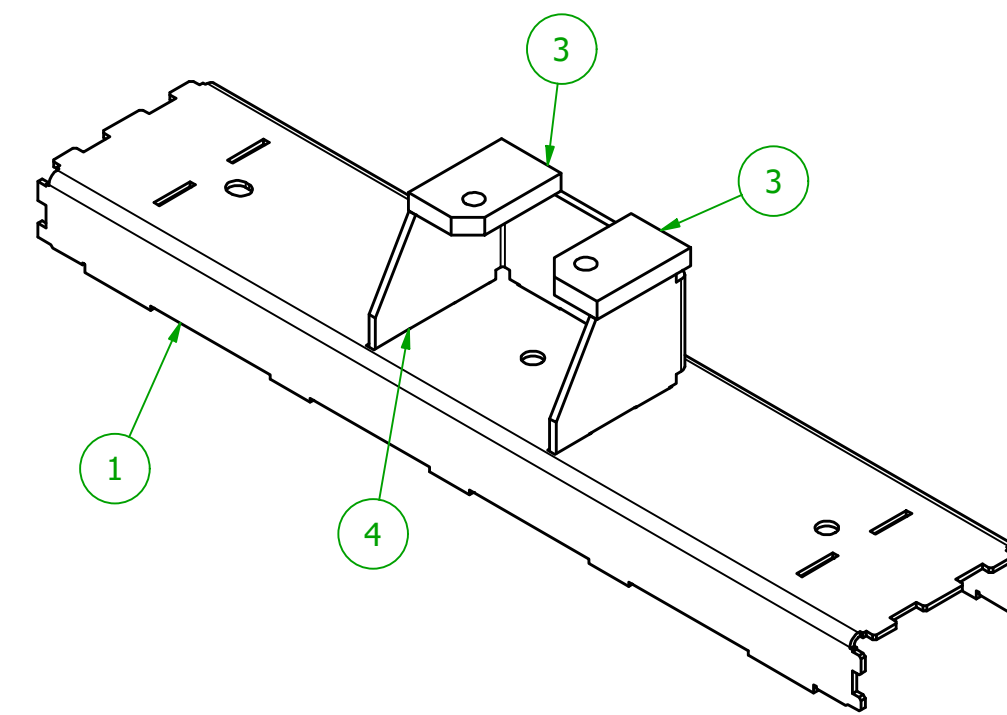
TYP. > REMOVE ALL WELD SPLATTER



MK-D110B ~ INNER CROSS MEMBER WELDMENT-RH  
SCALE 1 1/2"=1'-0"



TYP. >



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D110A			
1	1	MK-D108A ~ INNER CROSS MEMBER			
2	1	MK-D109A ~ GUIDE ROLLER TOWER-LH			
3	2	MK-D109C ~ TOWER PLATE			
zZ					
		MK-D110B			
1	1	MK-D108A ~ INNER CROSS MEMBER			
3	2	MK-D109C ~ TOWER PLATE			
4	1	MK-D109B ~ GUIDE ROLLER TOWER-RH			

- 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 AFTER WELDING

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/06/2022	GUIDE ROLLER MOUNT CHANGED	
A	MC	7/01/2022	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 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.



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

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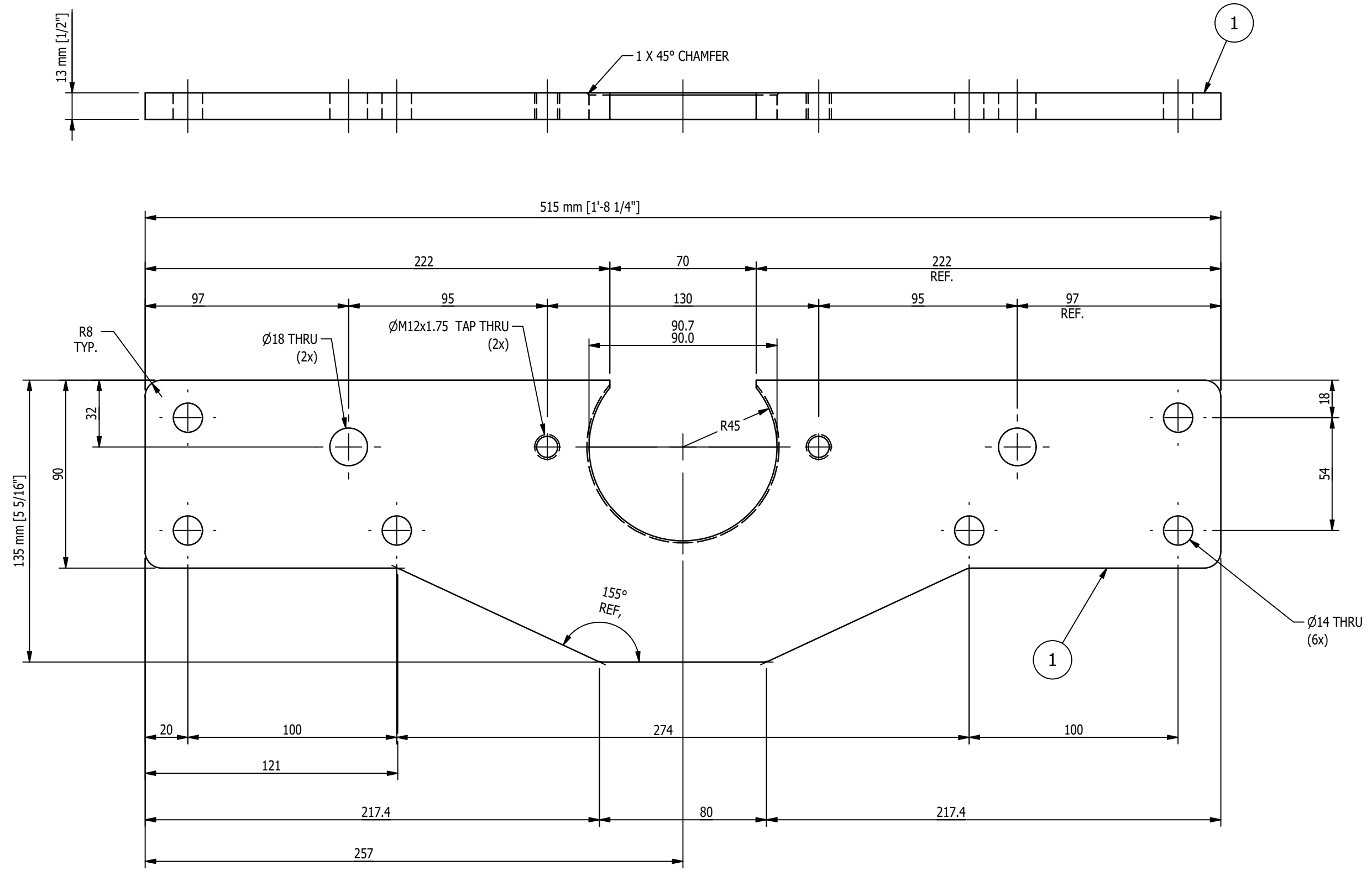
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	SGS
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D110	DWG DATE:	6-14-2022
REV:	B	JOB No.:	22096

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

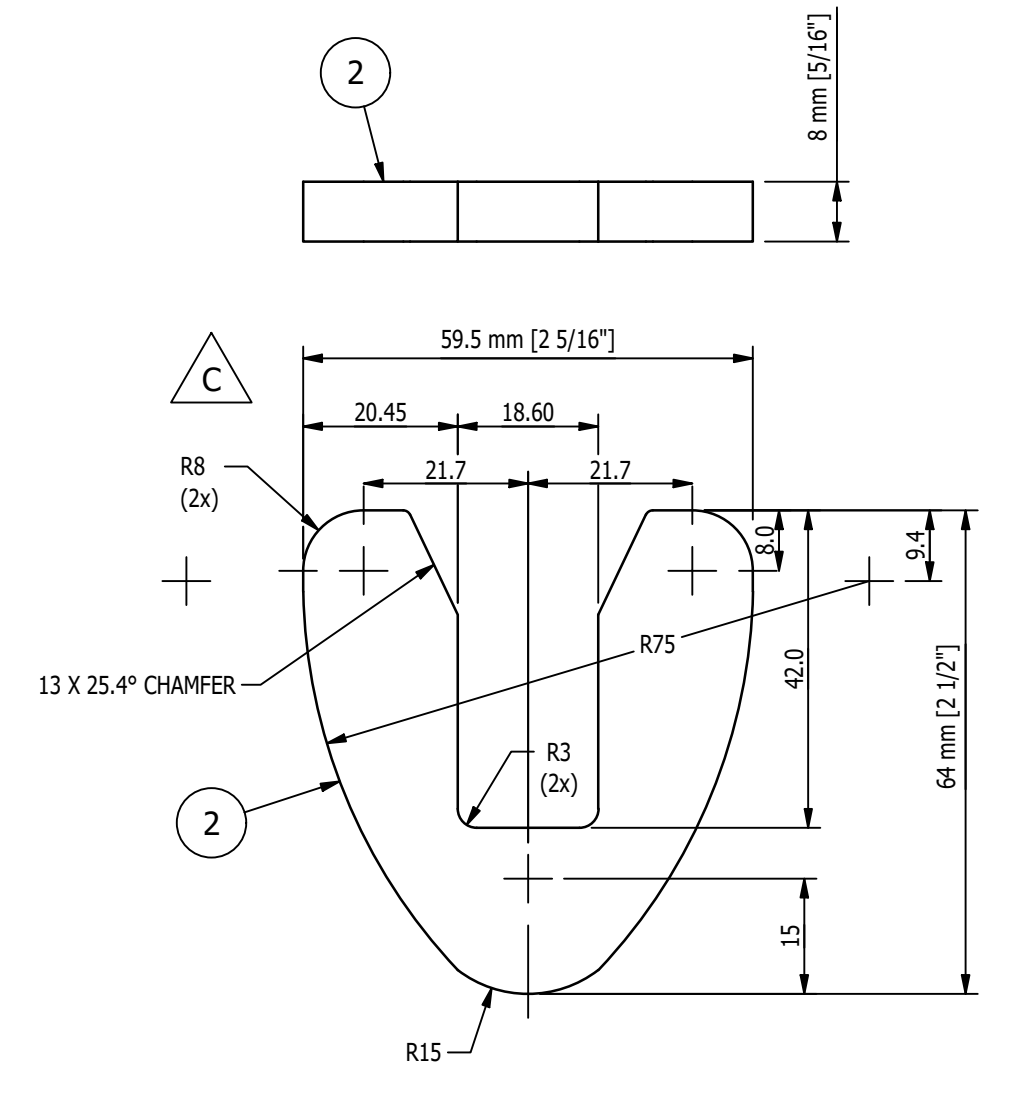
MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D110

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

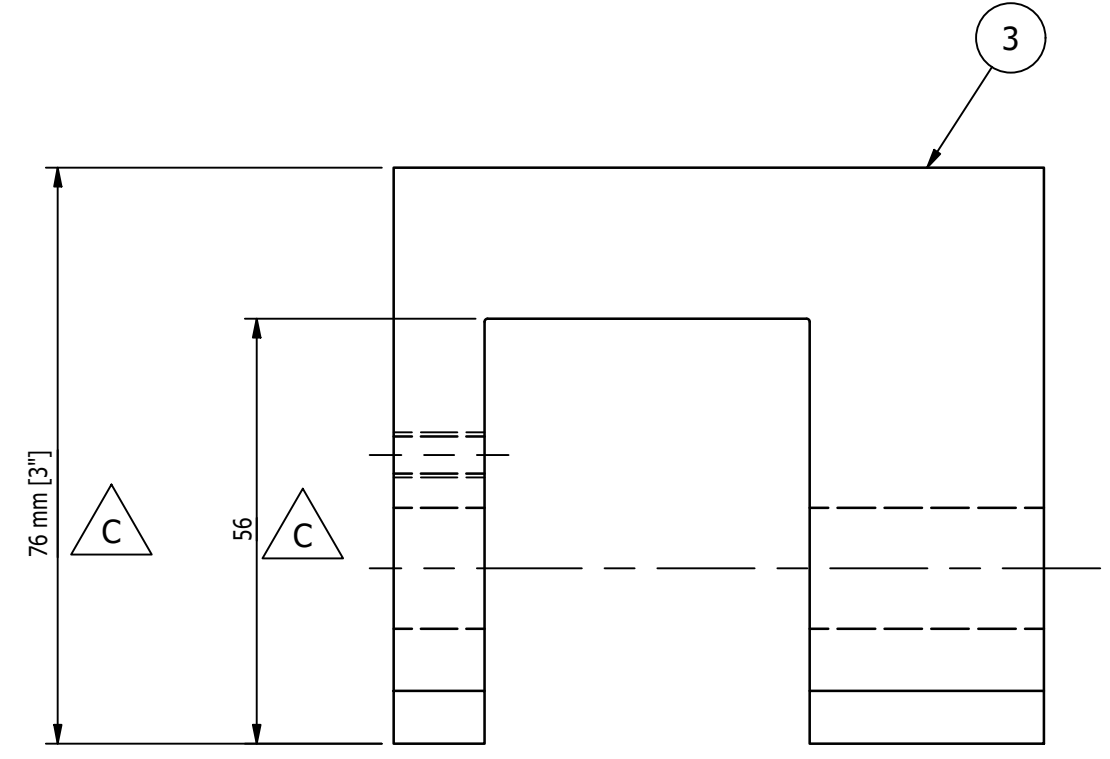
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D111A PL 1/2 x 5 5/16"	1'-8 1/4"		
2	1	MK-D111B PL 5/16 x 2 5/16"	2 1/2"		
3	1	MK-D111D BAR 2 x 3	3 3/8"		



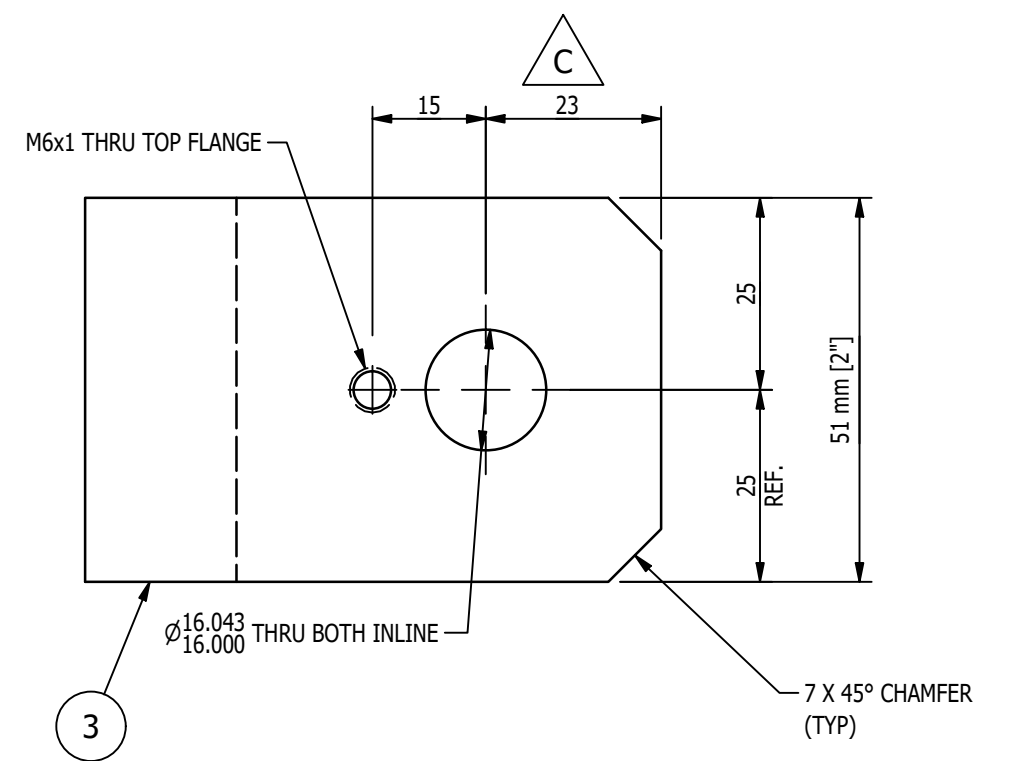
**MK-D111A ~ MOTOR MOUNTING PLATE**  
SCALE 6"=1'-0"



**MK-D111B ~ RETAINER**  
SCALE 1'-0" = 1'-0"



**MK-D111D ~ CLEVIS**  
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 AFTER WELDING

**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.

**MAGNUM Consulting**

41100 Dardickwood Rd.  
Suite 125  
North, MI 48315

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

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D111 - REV C

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	7/27/2022	REVISED ITEM '3', WAS BAR 2 x 2 1/2" NOW BAR 2 x 3; REVISED PAINT NOTE, REMOVED MK-C, ADDED DIMS MK-B, REMOVED MACH/LASER NOTE MK A	
B	MC	7/12/2022	REVISED MOTOR MOUNTING PLATE, SHOP NOTES & ADDED TOLERANCE DIM. TO HOLE	
A	MC	7/5/22	FOR FABRICATION	

**REVISION HISTORY**

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

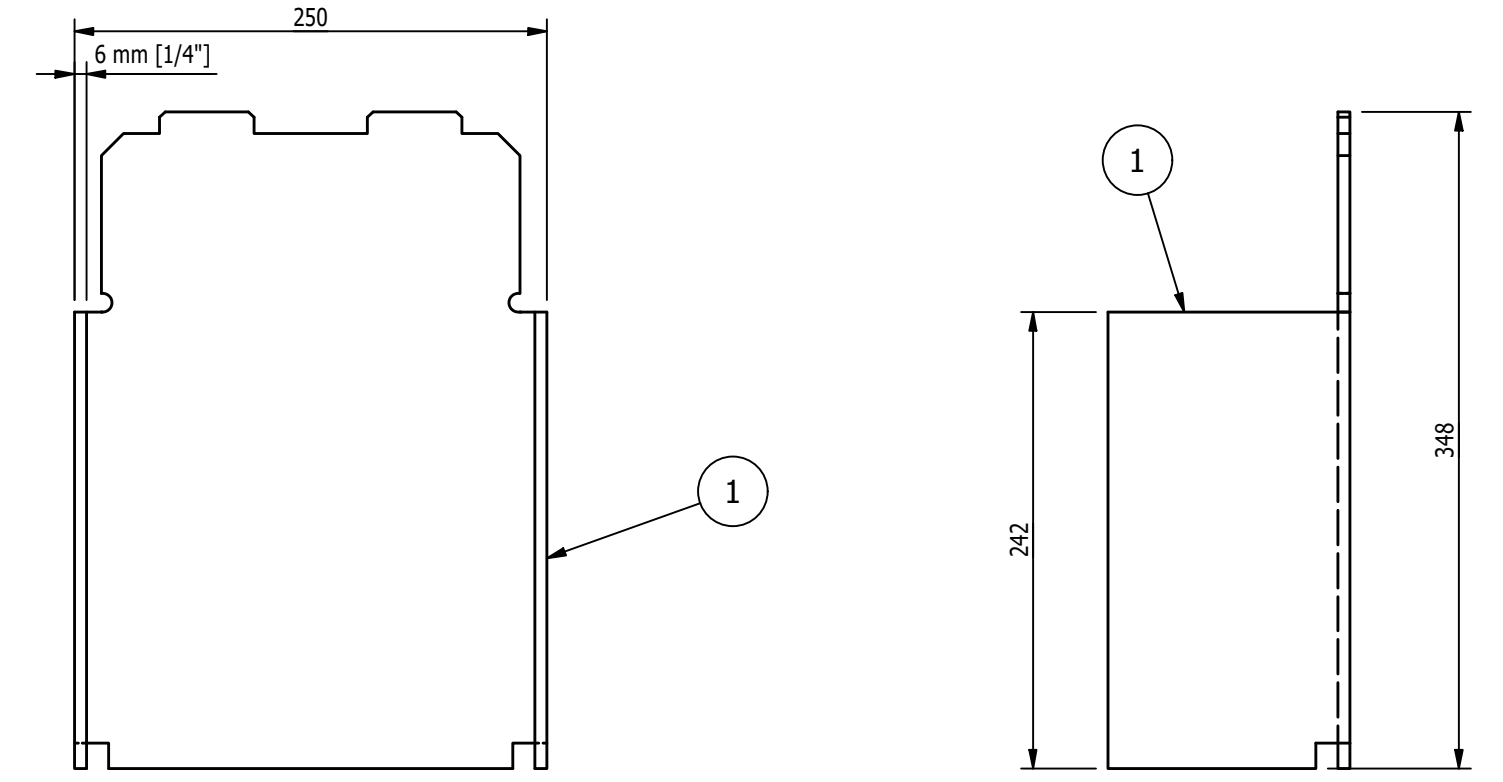
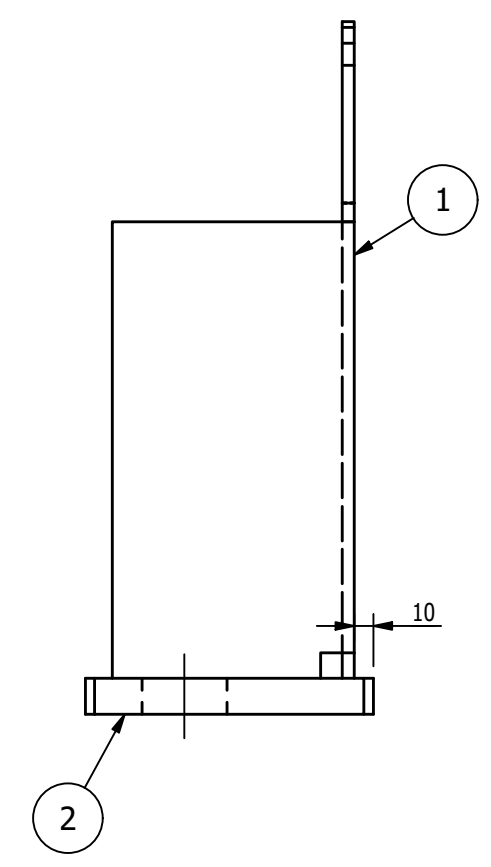
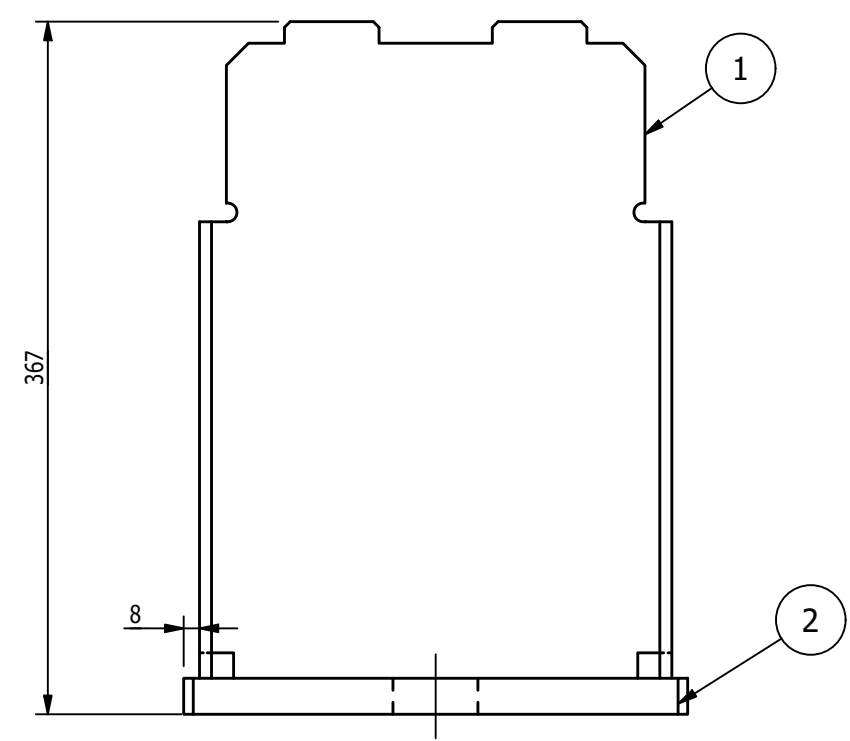
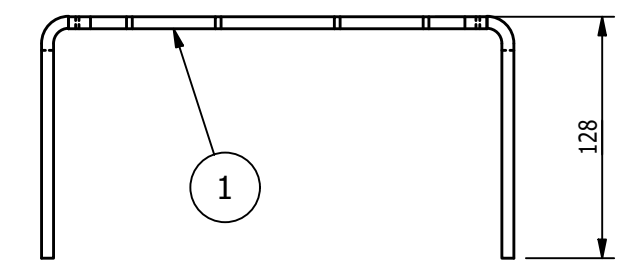
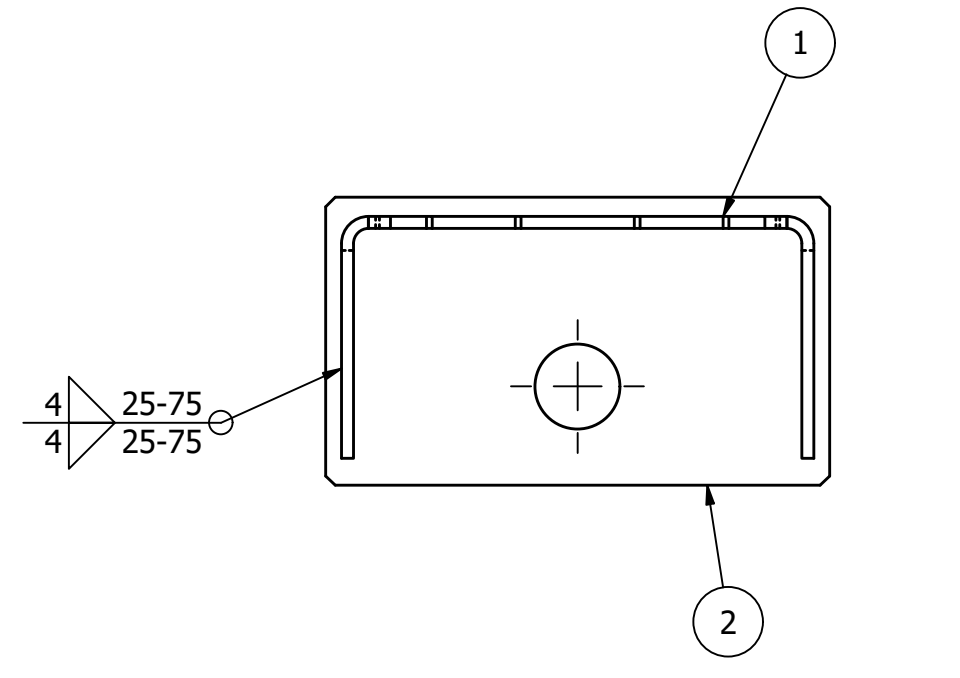
**TITLE:** P6700 CONVEYORS CAMPUS BUILDING  
**CLIENT:** VOLVO  
**DRAWING No.:** 1875D111  
**REV:** C

**PROPRIETARY AND CONFIDENTIAL**  
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**DRAWN BY:** SGS  
**CHECKED BY:** CW  
**DWG DATE:** 6-14-2022  
**JOB No.:** 22096

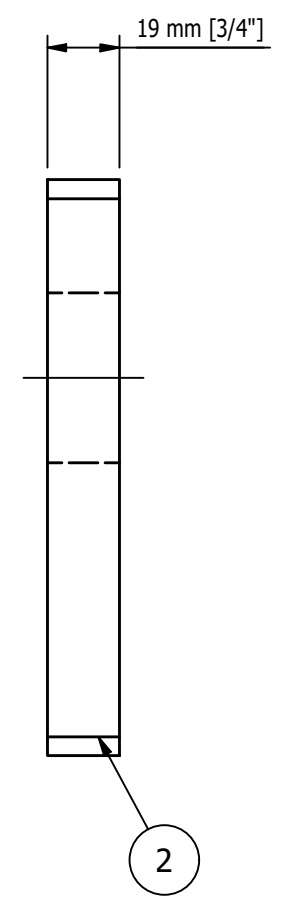
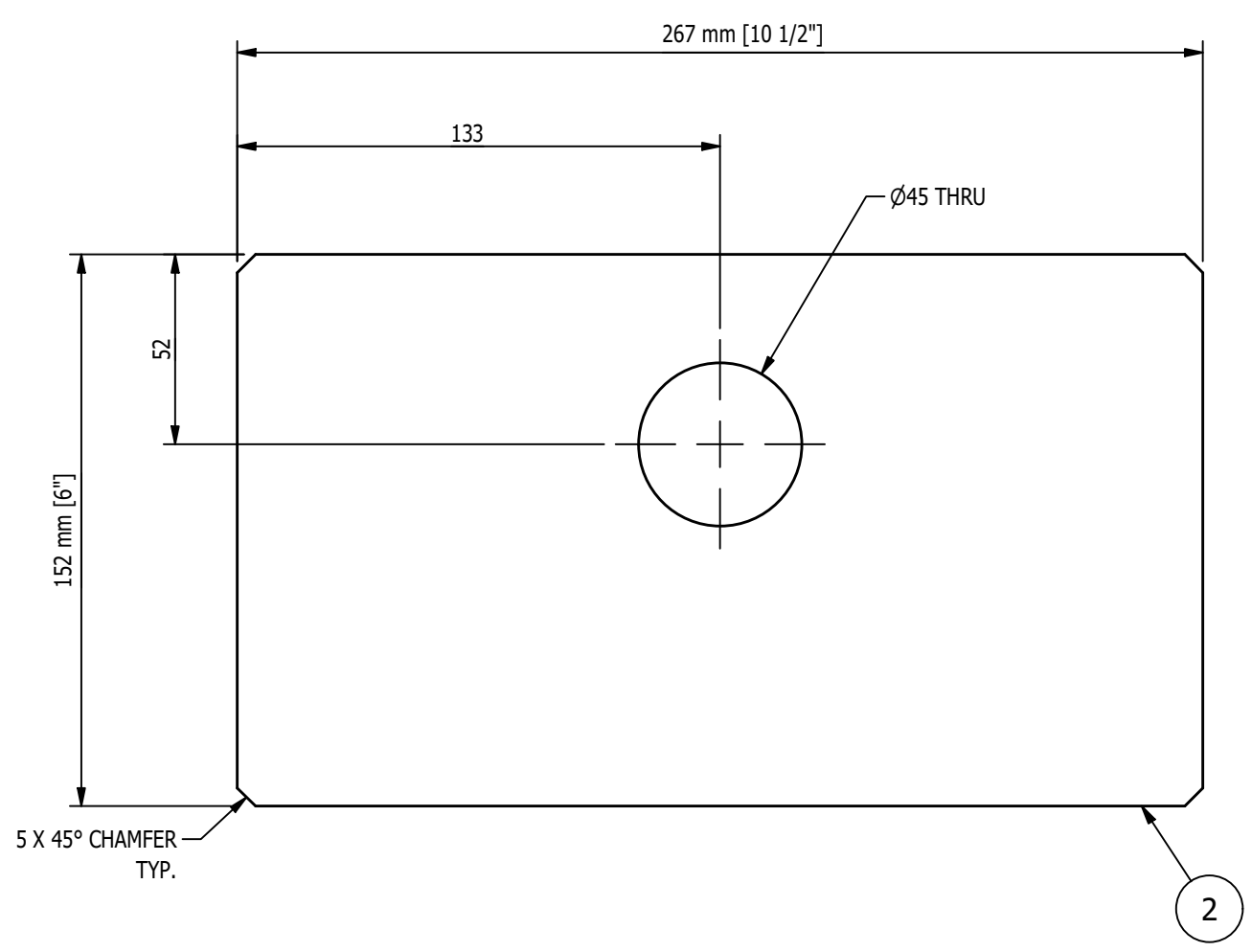


BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D112A			
1	1	PL 1/4 x 1'-1 11/16"	1'-7"		
2	1	BAR 3/4 x 6	10 1/2"		

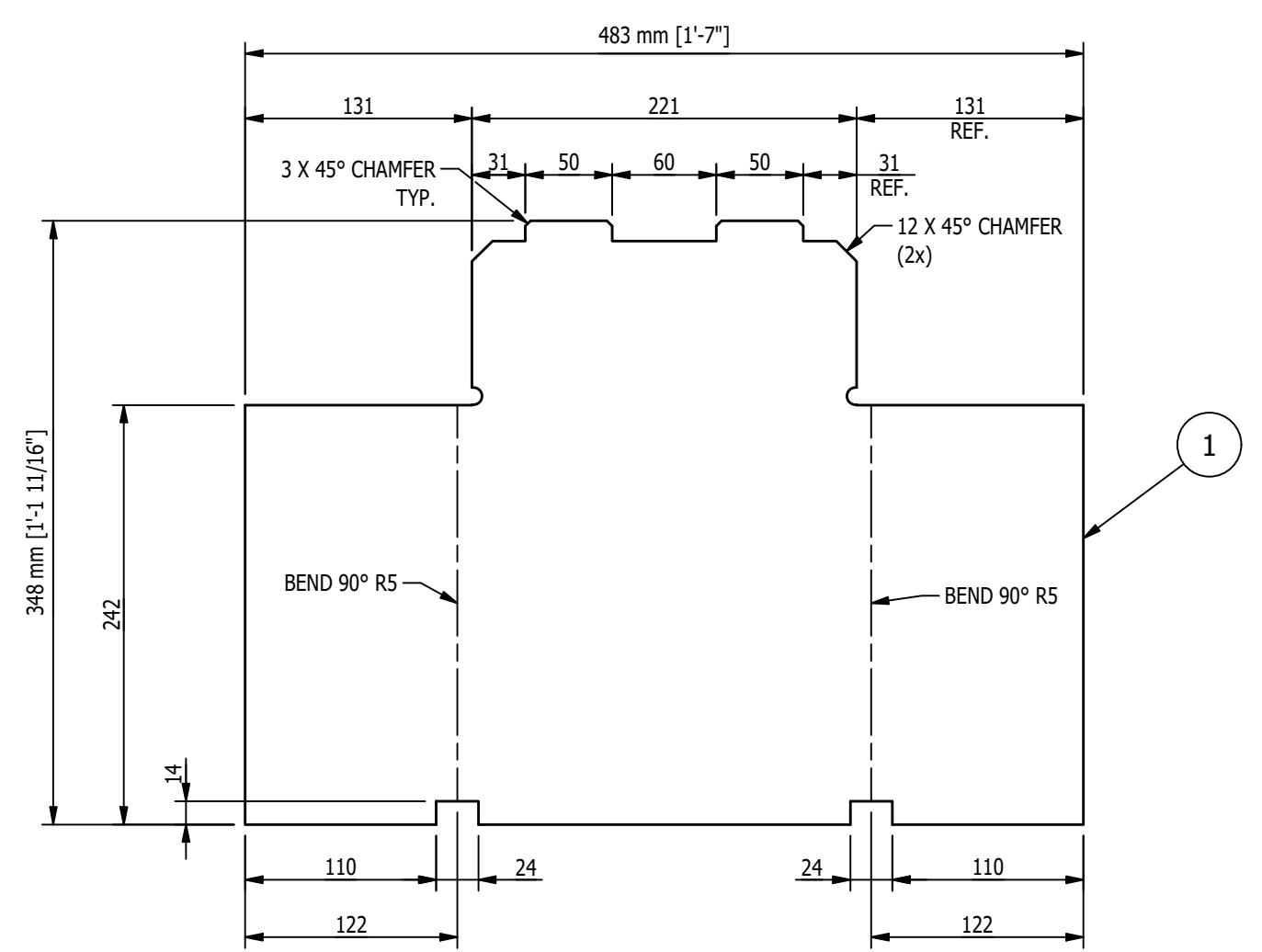


DETAIL OF ITEM '1'  
SCALE 3"=1'-0"

MK-D112A ~ LEG ASSEMBLY  
SCALE 3"=1'-0"



DETAIL OF ITEM '2'  
SCALE 6"=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 AFTER WELDING

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/5/22	FOR FABRICATON	

REVISION HISTORY

	<b>MILLER INDUSTRIES</b> 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: SGS
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D112	DWG DATE: 6-14-2022
REV: A	JOB No: 22096

41100 Charleston Rd.  
Suite 125  
Norfolk, MA 06275

Phone: (248) 372-8822  
Fax: (248) 372-8851  
Web: www.mmagnum.com

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D112

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.

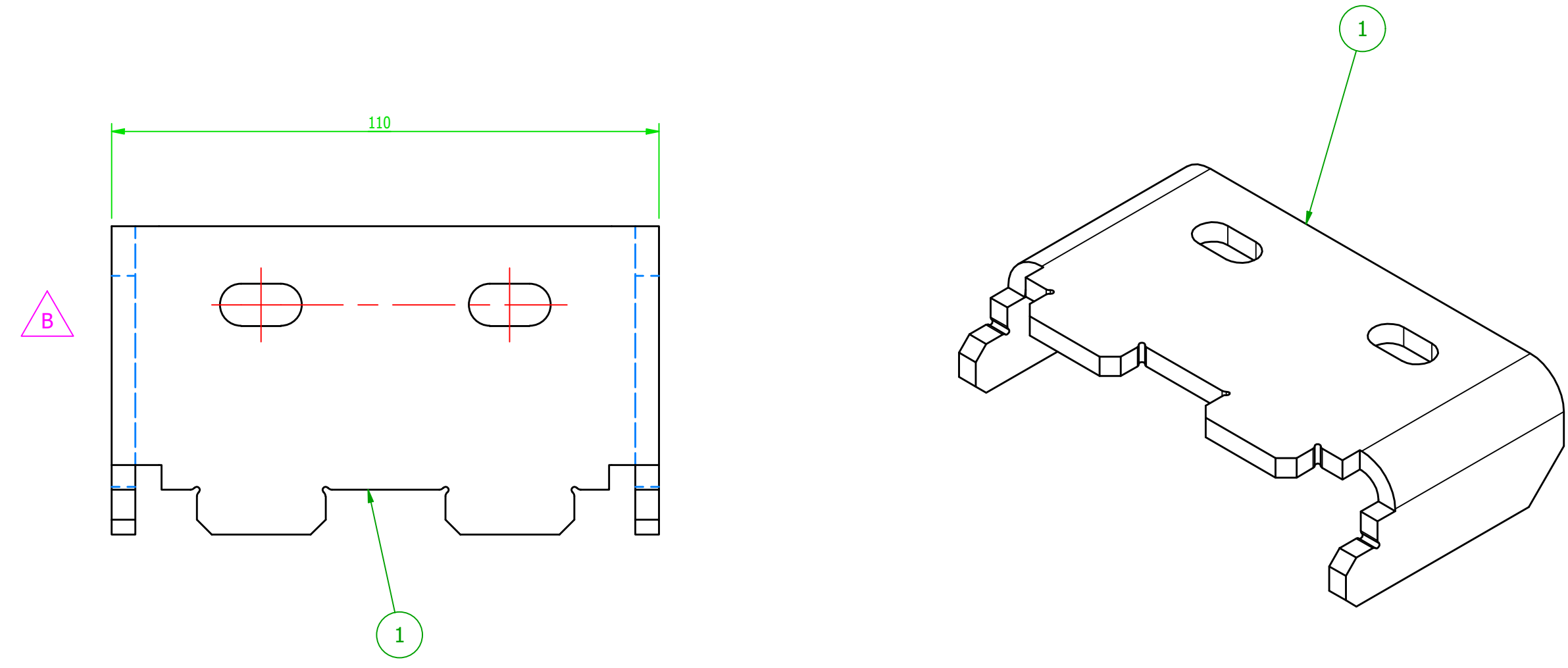
HOLES:  
- ALL HOLES ARE 13/16" DIA. U.N.O.  
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

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

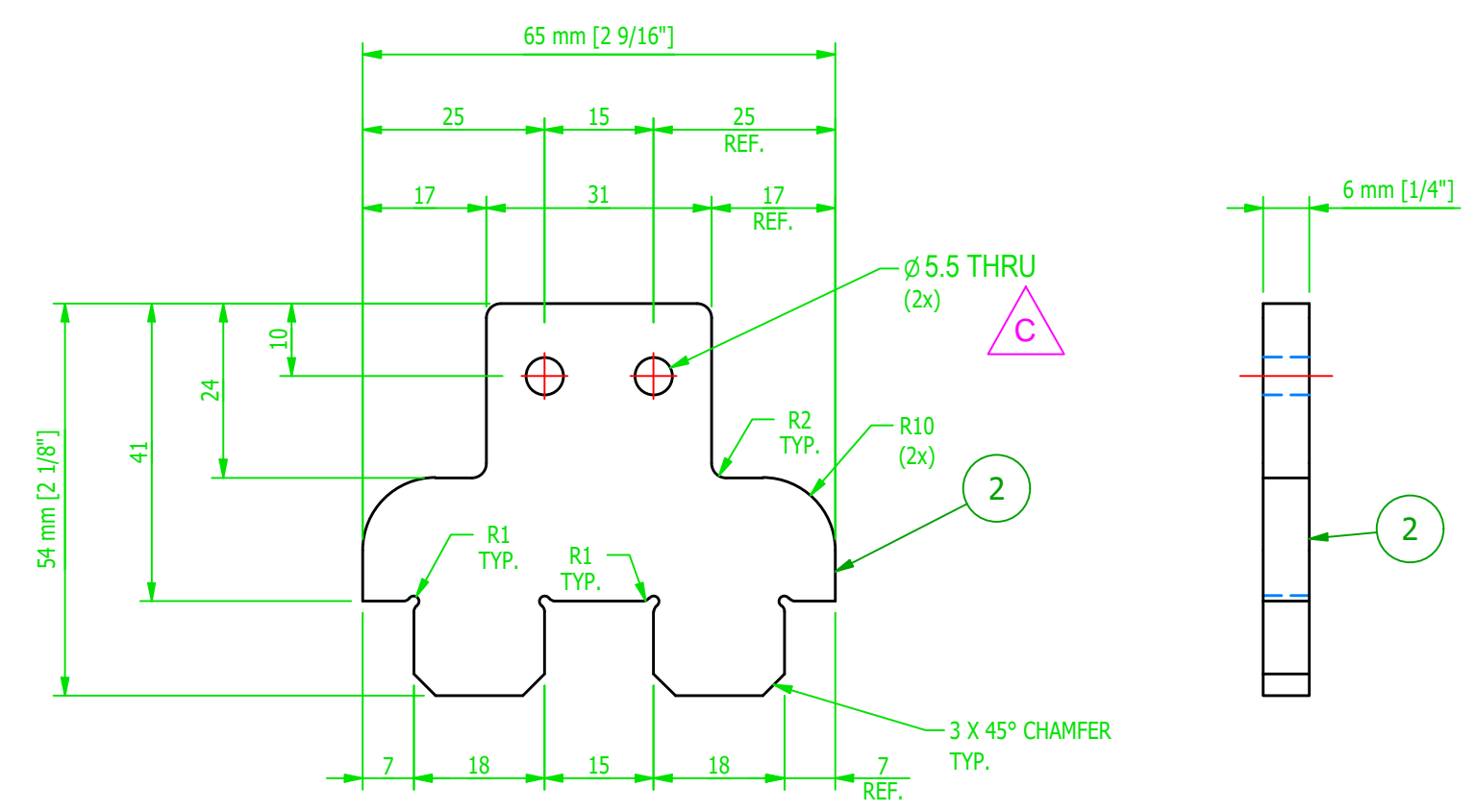
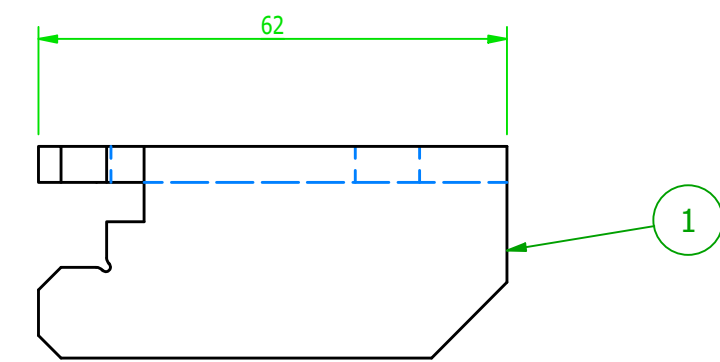
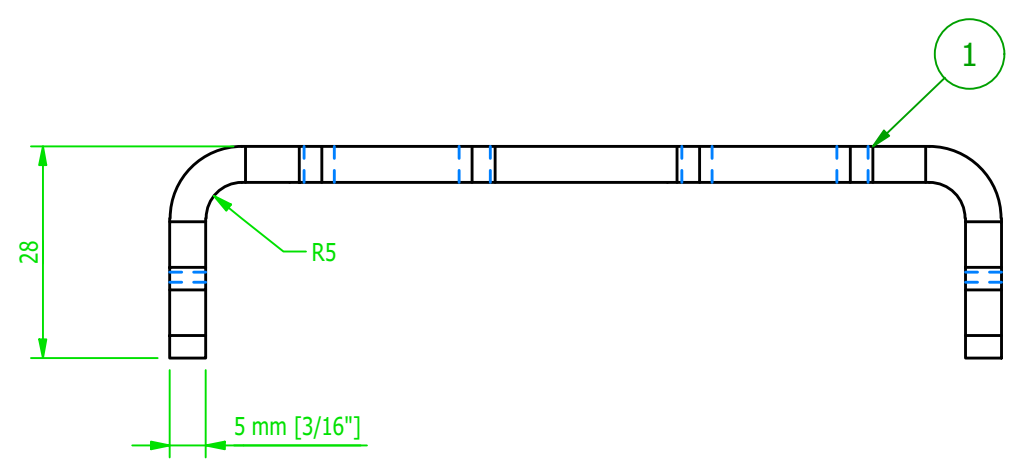
PAINT:  
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

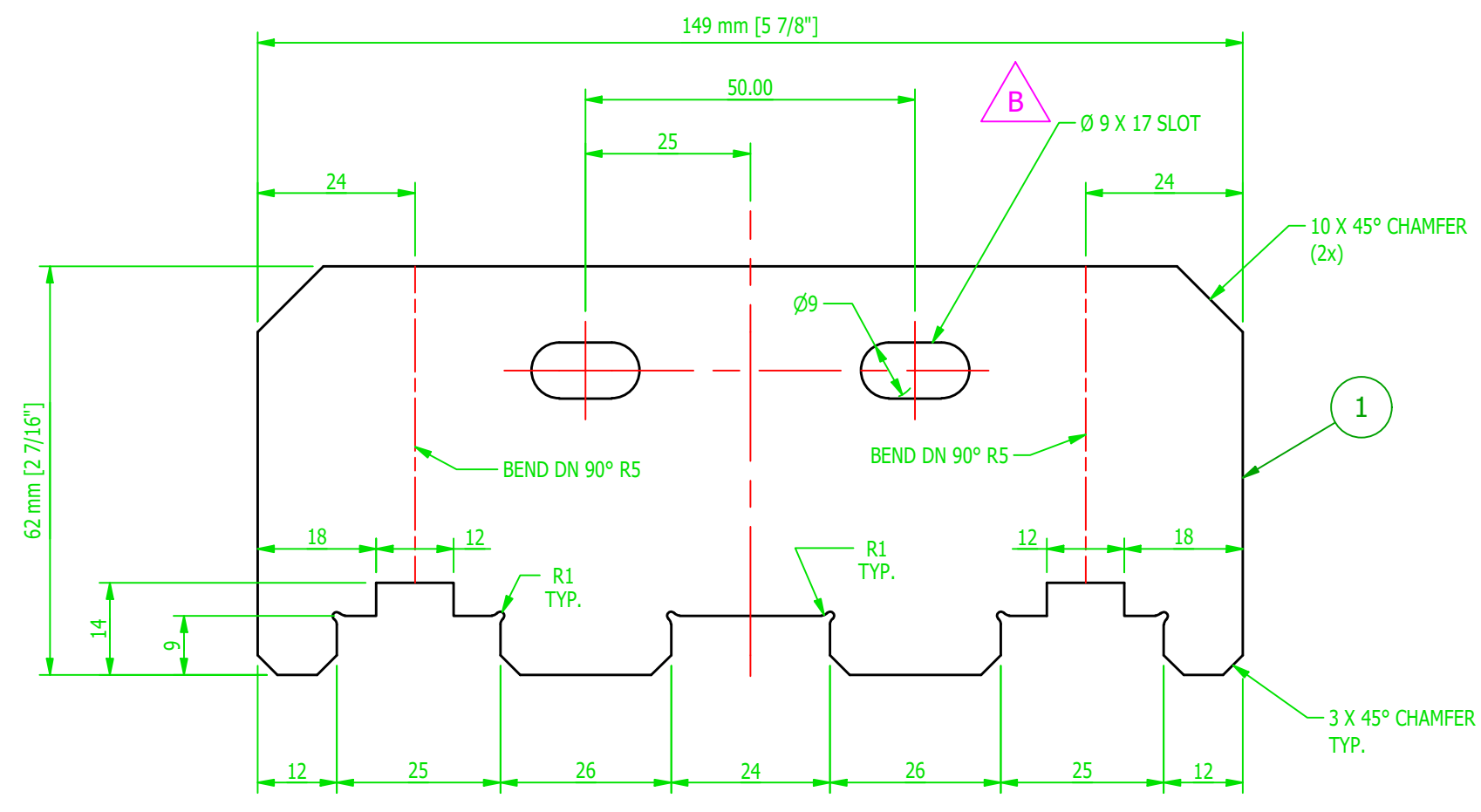
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D113A			
1	1	PL 3/16 x 2 7/16"	5 7/8"		
		MK-D113B			
2	1	PL 1/4 x 2 1/8"	2 9/16"		



**MK-D113A ~ BRACKET**  
SCALE 1'-0" = 1'-0"



**MK-D113B ~ ENCODER BRACKET**  
SCALE 1'-0" = 1'-0"



**DETAIL 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 AFTER WELDING

REV	BY	DATE	DESCRIPTION	APP
C	AC	08/22/22	ITEM 2 - 5 DIA HOLE NOW 5.5	
B	MC	7/13/2022	ADDED SLOT AND SHOP NOTE	
A	MC	7/5/22	FOR FABRICATON	

REVISION HISTORY

**MAGNUM CONSULTING**  
41100 Charleston Rd  
Suite 125  
Norris, MI 48255  
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:**

**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:**

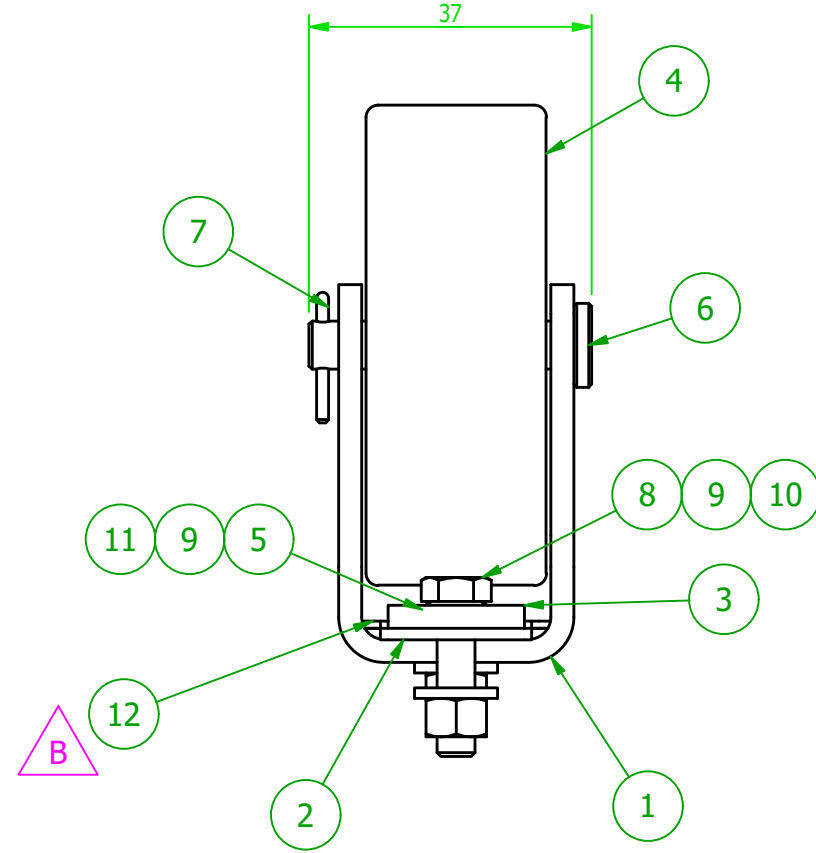
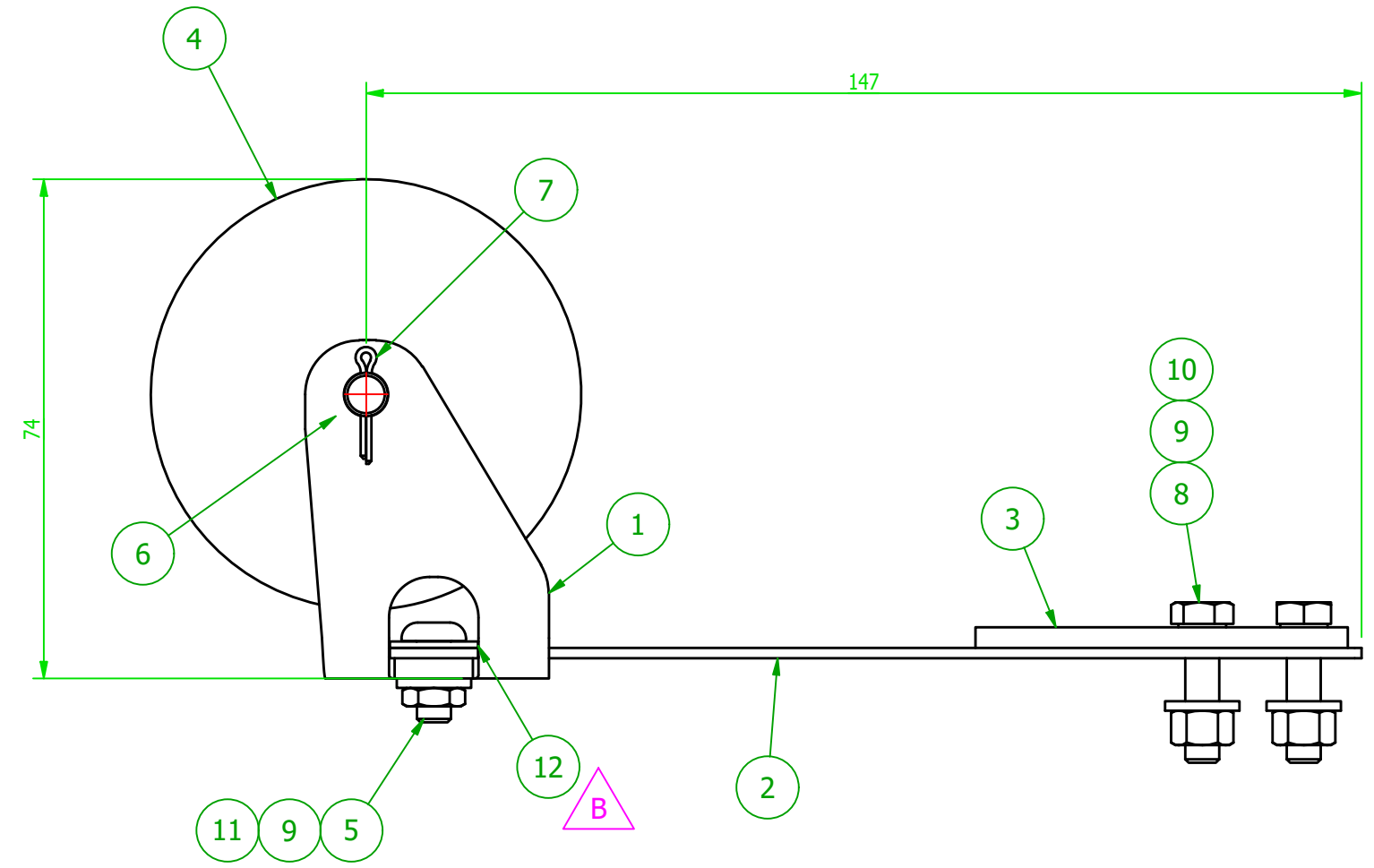
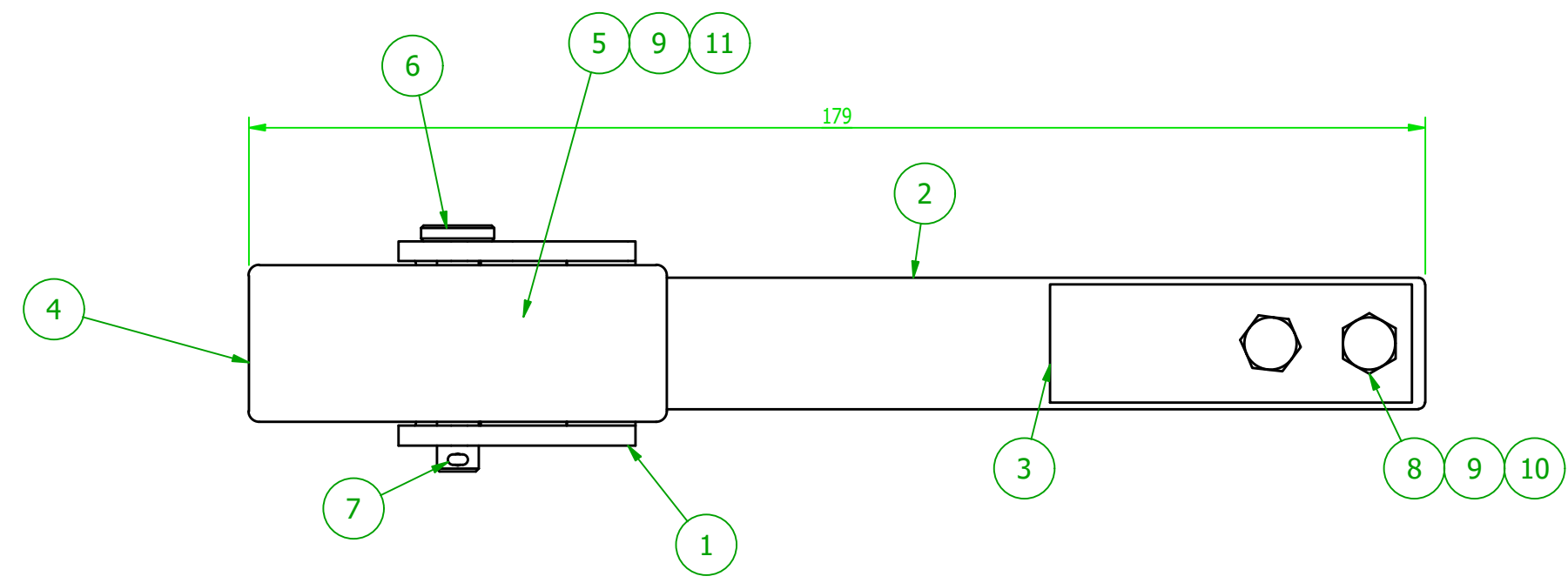
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

**mi MILLER INDUSTRIES**  
3070 W. THOMPSON RD.  
FENTON, MI 48430  
PH: 810.373.0322 FAX: 810.373.0326  
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TITLE: <b>P6700 CONVEYORS CAMPUS BUILDING</b>	DRAWN BY: <b>SGS</b>
CLIENT: <b>VOLVO</b>	CHECKED BY: <b>CW</b>
DRAWING No. <b>1875D113</b>	DWG DATE: <b>6-14-2022</b>
REV: <b>C</b>	JOB No: <b>22096</b>






**MK-D114A ~ STATIC WHEEL ASSEMBLY**  
SCALE 1'-0" = 1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D114A			
1	1	MK-D115A ~ STATIC WHEEL BKT			
2	1	MK-D115B ~ STATIC WHEEL MTG PL			
3	1	MK-D115C ~ STATIC WHEEL WASHER			
4	1	Static-Control Rubber Wheel-2.5 In Dia. X .9375 W - McMASTERCARR #2328T75		8-1	
5	1	M5x0.8 x 12mm LG. BUTTON HEX SOCKET HEAD CAP SCREW			
6	1	MK-D115D ~ STATIC WHEEL PIN- 15 mm Dia. X 40 mm LG A311 STRESSPROOF			
7	1	1004-1045 Carbon Steel Cotter Pins-1-16 In Dia. .5 In Lg ZP - McMASTERCARR #98338A100		8-2	
8	2	M5x0.8 x 20mm LG. HEX CAP SCREW			
9	3	M5 NARROW FLAT WASHER			
10	2	M5 x 0.8 HEX NUT			
11	1	M5 x 0.8 HEX JAM NUT			
12	1	MK-D115E ~ STATIC WASHER			

- 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:**
- DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/12/2022	ADDED ITEM '12', CHANGED ABM NUMBERS	
A	MC	7/5/22	FOR FABRICATON	

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<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b>		<b>DRAWN BY: SGS</b>
<b>CLIENT: VOLVO</b>		<b>CHECKED BY: CW</b>
<b>DRAWING No. 1875D114</b>		<b>DWG DATE: 6-14-2022</b>
<b>REV: B</b>		<b>JOB No: 22096</b>

**MAGNUM CONSULTING**  
 41100 Charleston Rd.  
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 Novi, MI 48275  
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 Fax: (248) 772-8821  
 Web: www.mmagnum.com

MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 1875D114

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)

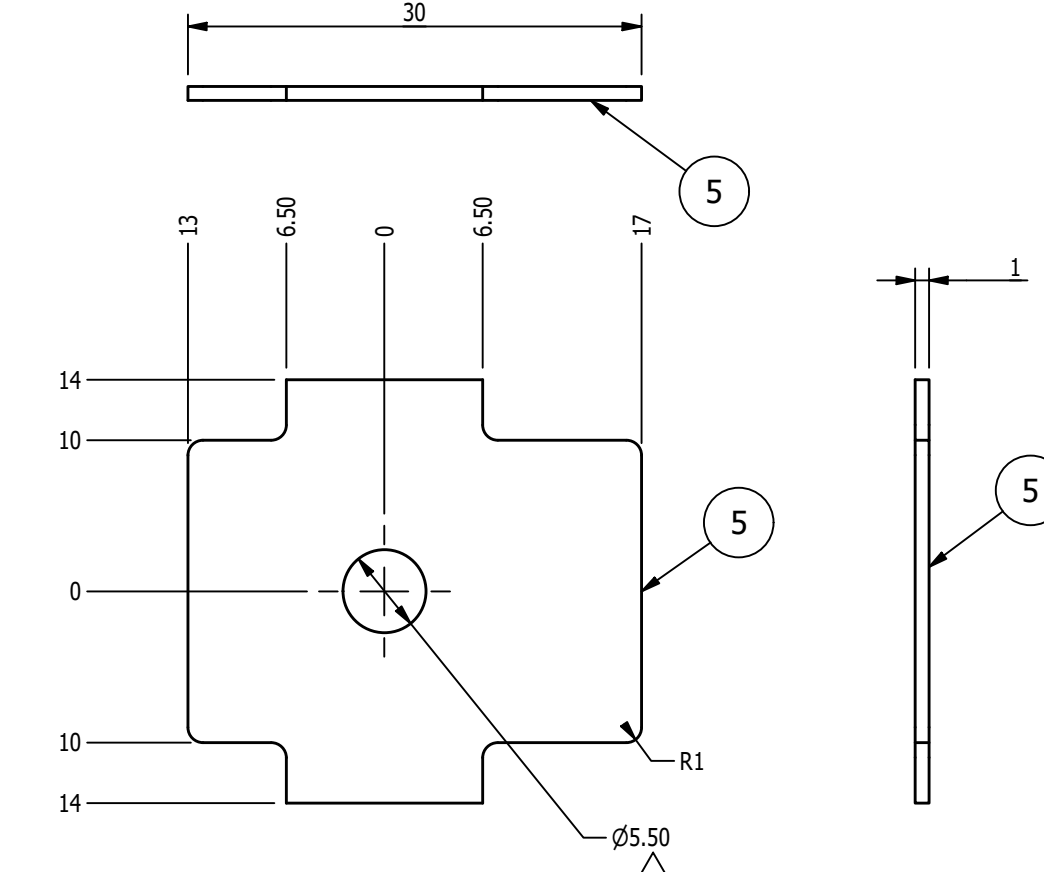
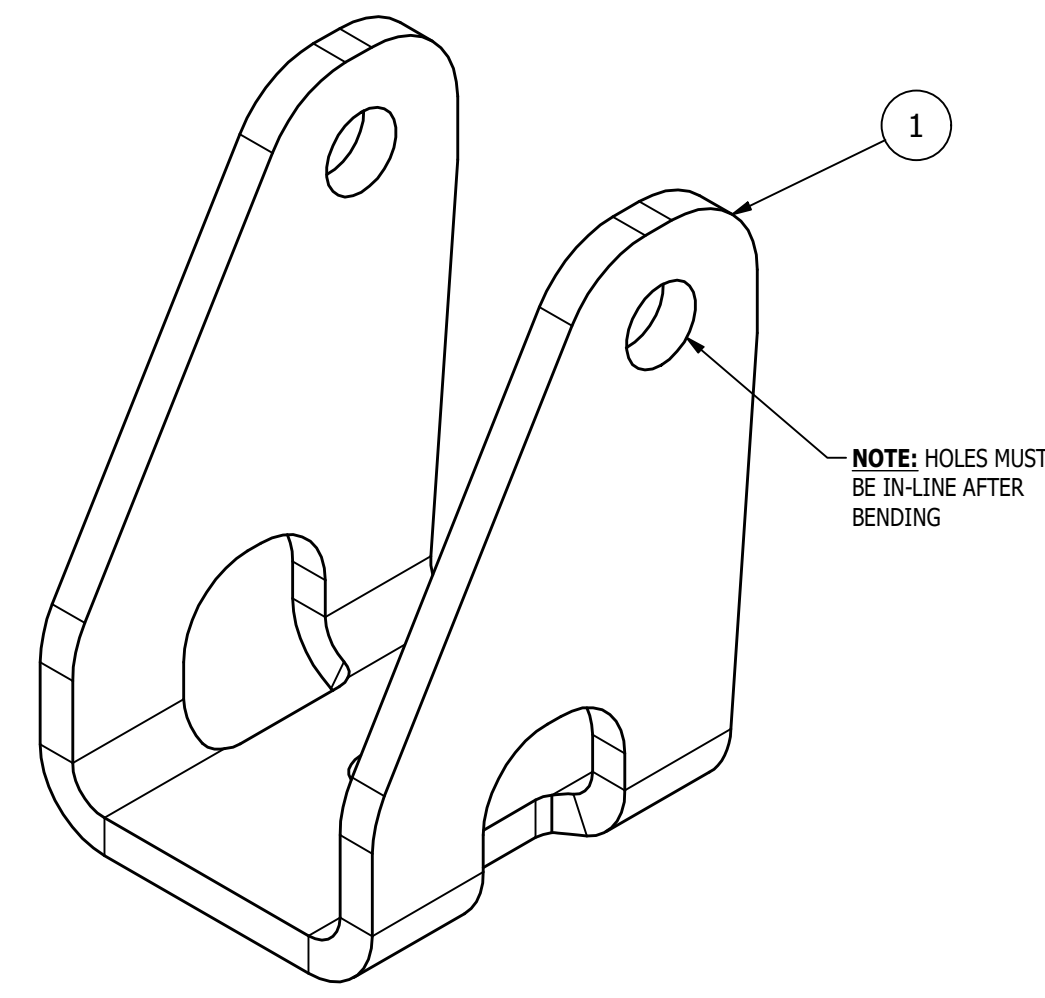
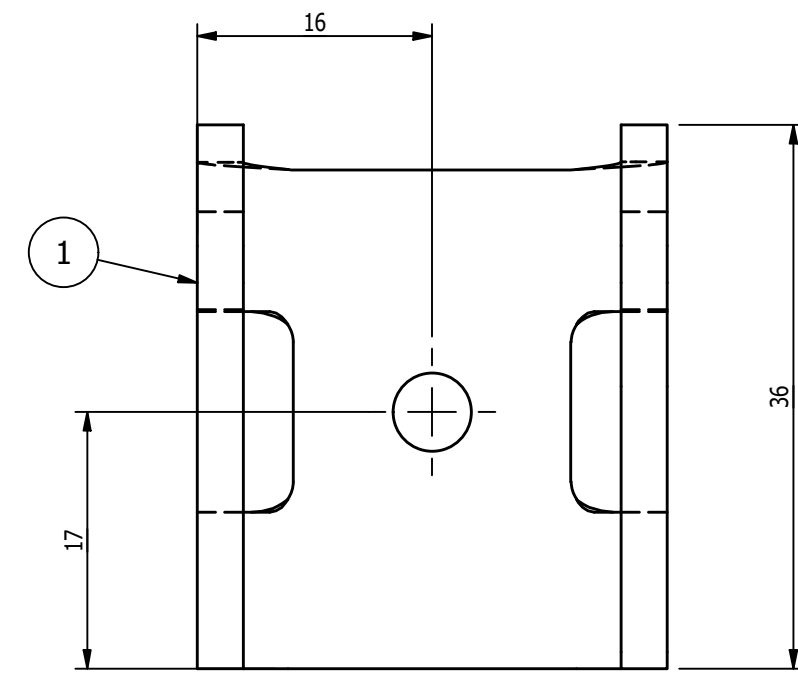
**PAINT:**

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

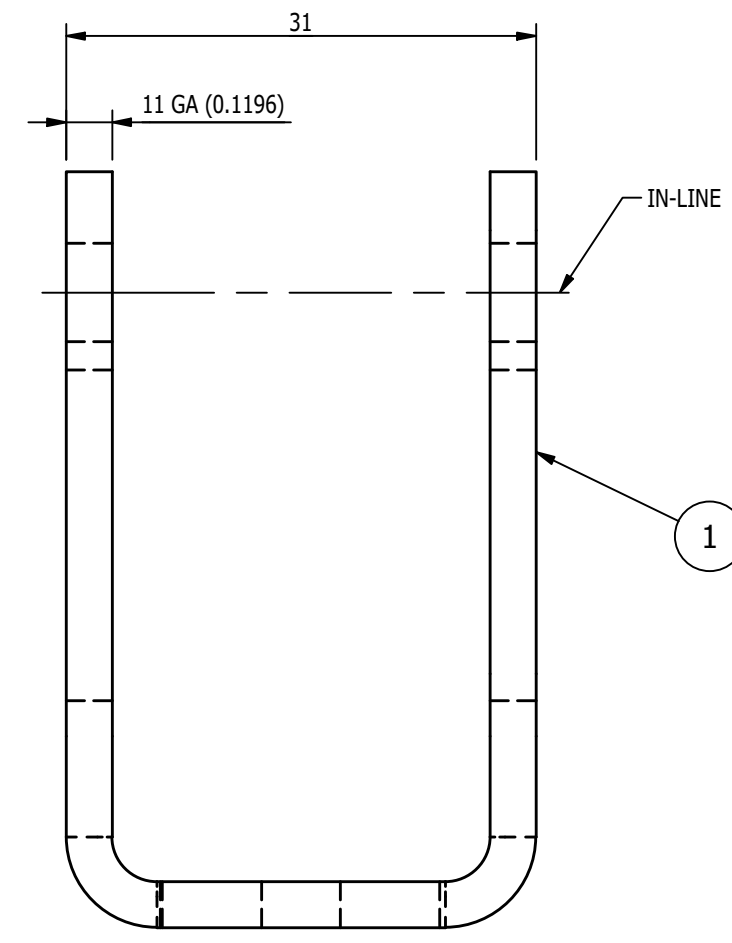
**COPIES:**

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

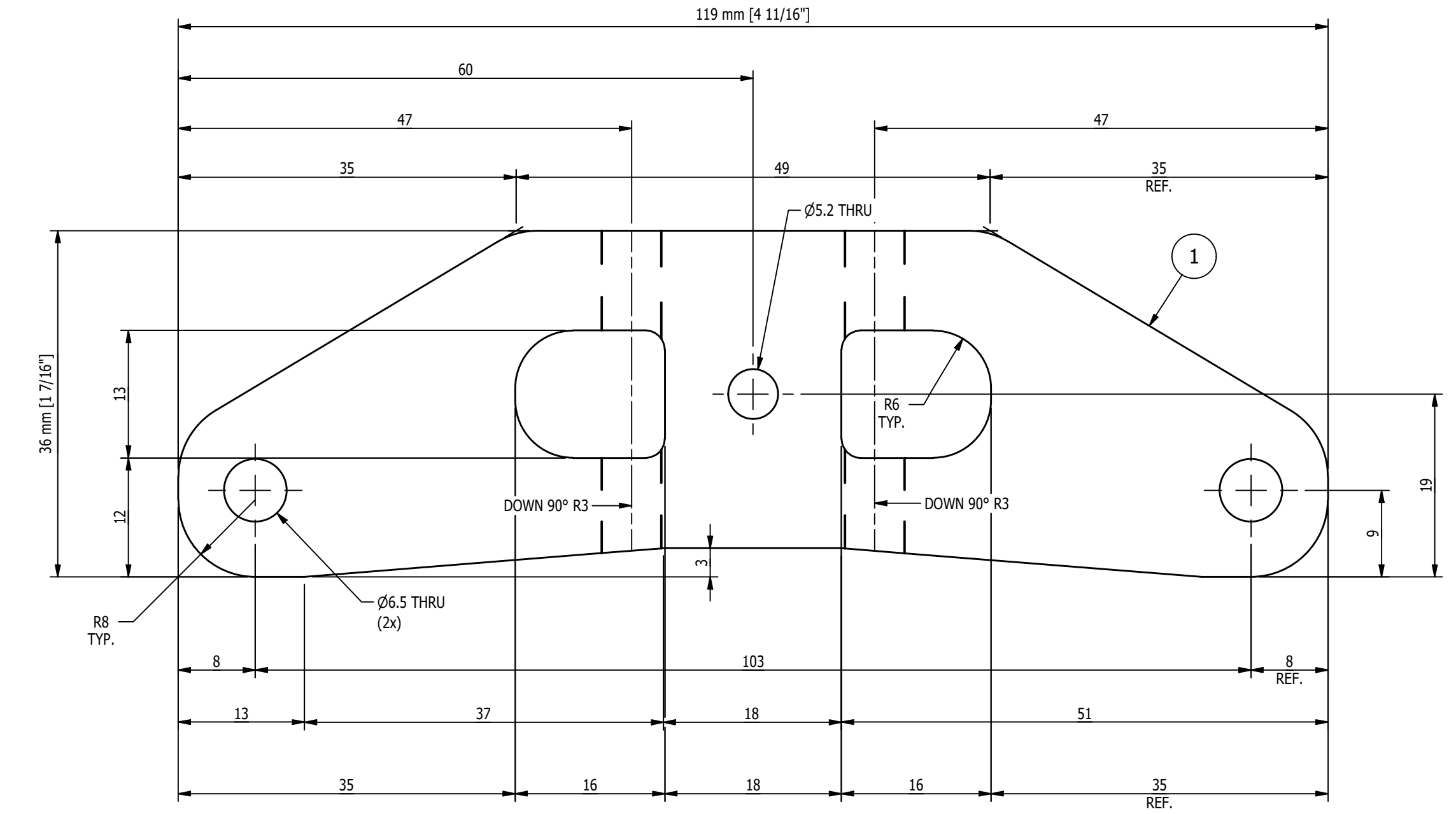
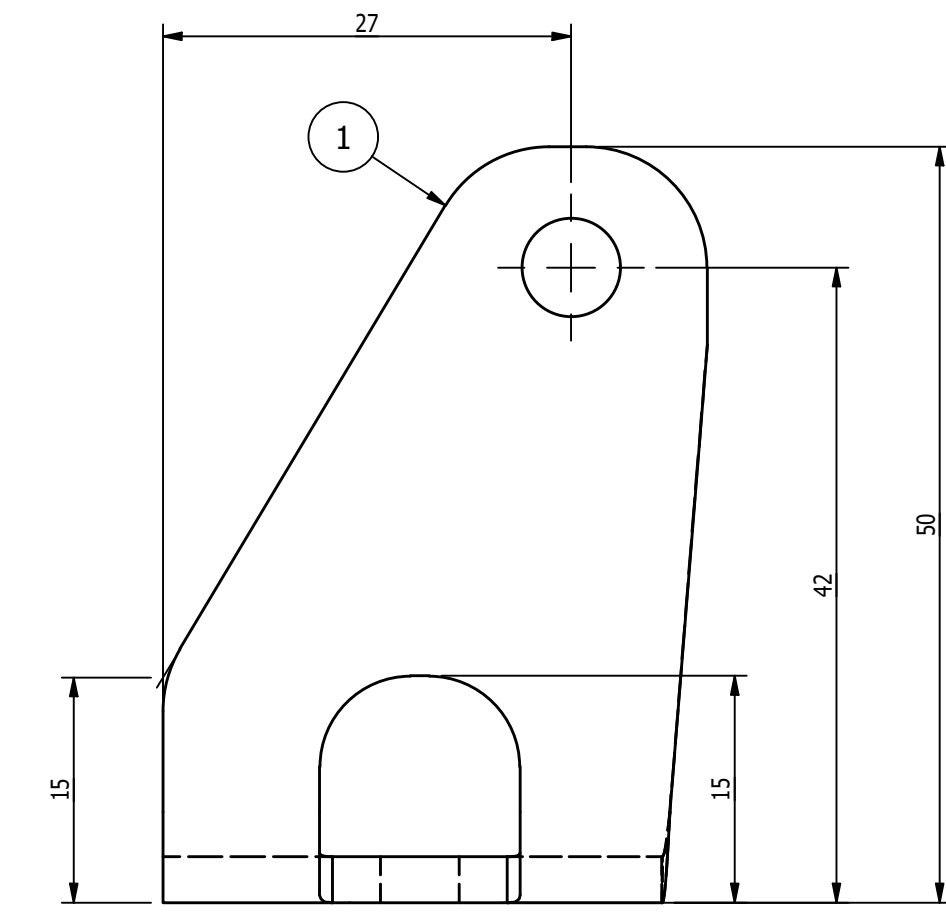
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D115A			
1	1	SHT 11 GA x 1 7/16	4 11/16"		
		MK-D115B			
2	1	SHT 16 GA x 1 1/8 ~ 1095 SPRING STEEL, TEMPERED	5 7/8"		
		MK-D115C			
3	1	SHT 11 GA x 11/16	2 3/16"		
		MK-D115D			
4	1	Ø7/16" A311 STRESSPROOF	1 1/2"		
		MK-D115E			
5	1	SPRING STEEL PL 1mm X 28 mm	30 mm		



MK-D115E ~ STATIC WASHER  
SCALE 2:1



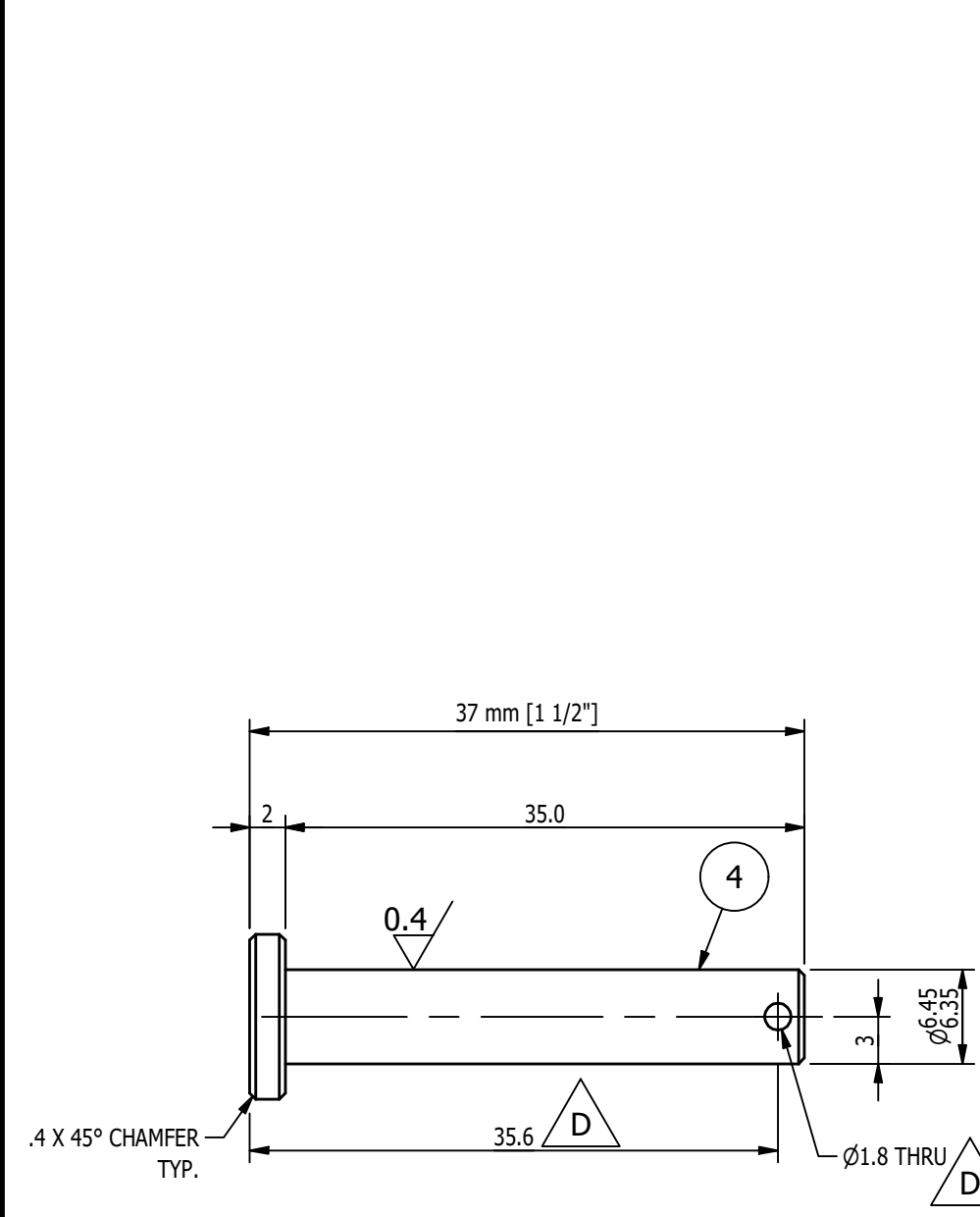
MK-D115A ~ STATIC WHEEL BKT  
SCALE 2:1



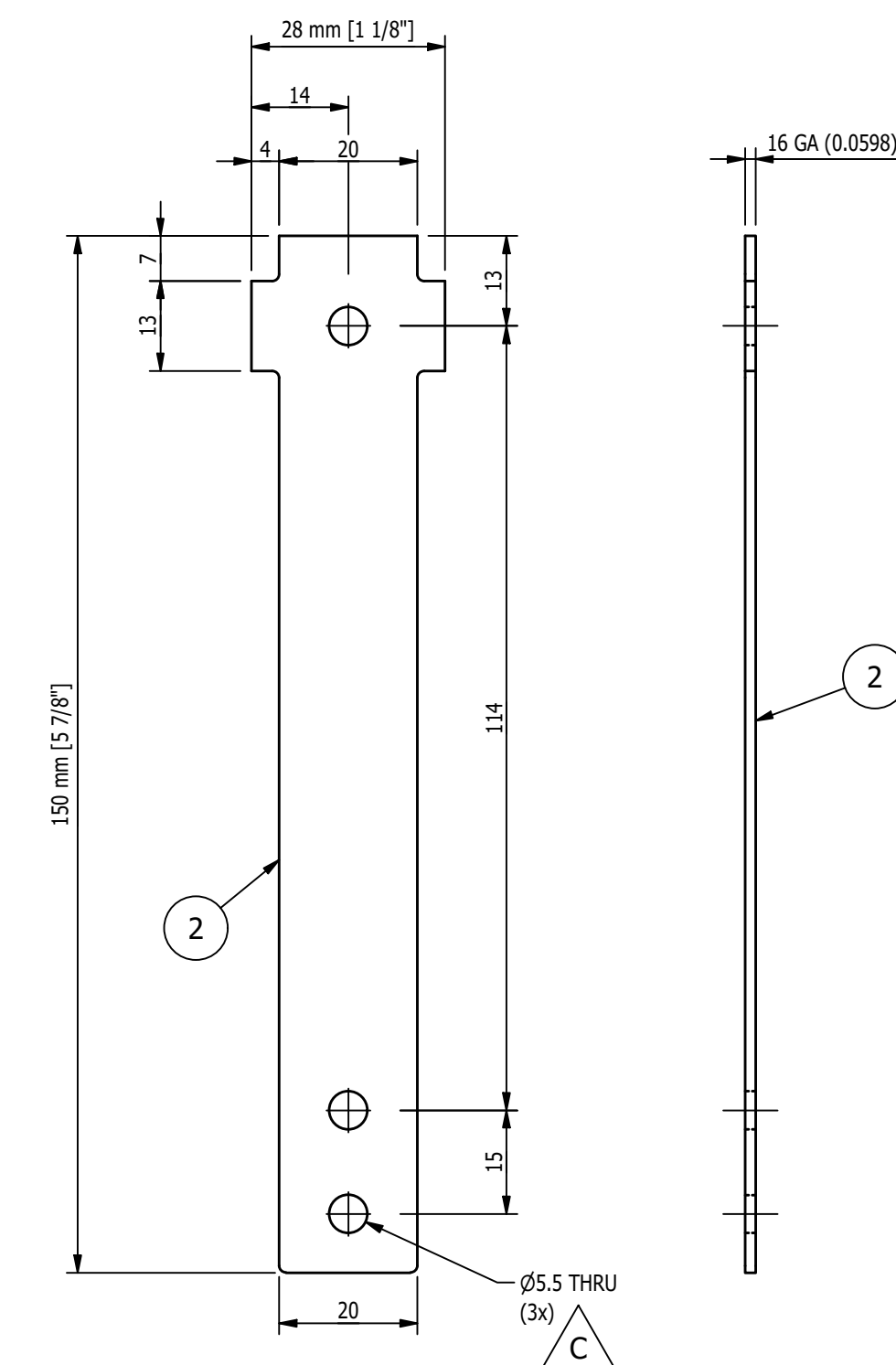
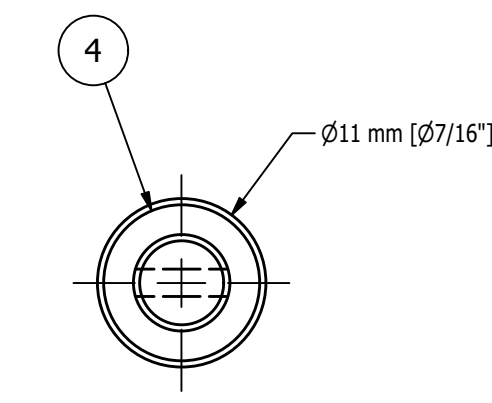
FLAT PATTERN OF ITEM '1'  
SCALE 2:1

- 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" / 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.

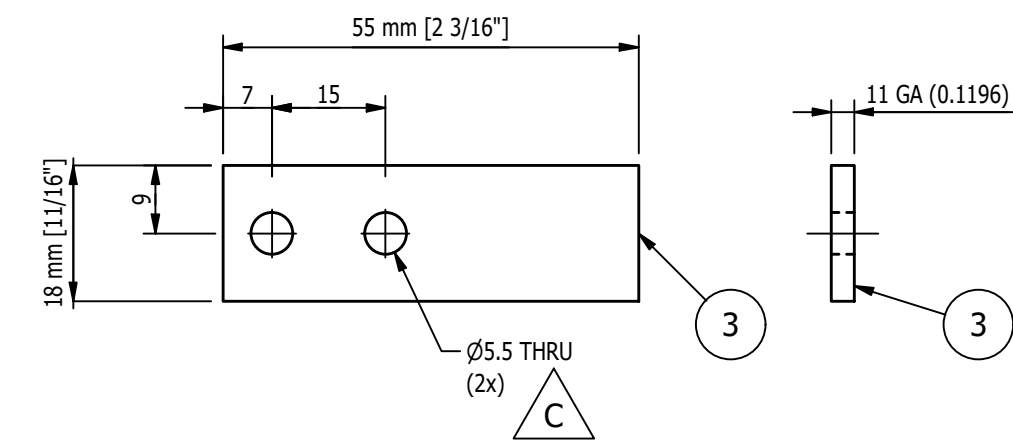
- PAINT NOTES:**
1. DO NOT PAINT MK-D115D
  2. PAINT BLACK OXIDE MK-D115A, MK-D115B, & MK-D115C



MK-D115D ~ STATIC WHEEL PIN  
SCALE 2:1  
(NO PAINT)



MK-D115B ~ STATIC WHEEL MTG PL  
SCALE 1'-0" = 1'-0"  
(NO PAINT)



MK-D115C ~ STATIC WHEEL WASHER  
SCALE 1'-0" = 1'-0"

**MAGNUM CONSULTING**  
41100 QuakerRoad Rd.  
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North, MI 48135  
Phone: (248) 773-8822  
Fax: (248) 773-8851  
Web: www.mmagnum.com  
MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D115

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.

REV	BY	DATE	DESCRIPTION	APP
E	MC	9/6/22	UPDATED LENGTH OF ITEM '4'	
D	MC	8/25/2022	REVISED DIMS	
C	AC	8/22/2022	ITEMS '2', '3', '5' - 5/5.2 DIA HOLES NOW 5.5	
B	MC	7/13/2022	ADDED STATIC WASHER & REVISED SHOP NOTE	
A	MC	7/5/22	FOR FABRICATON	

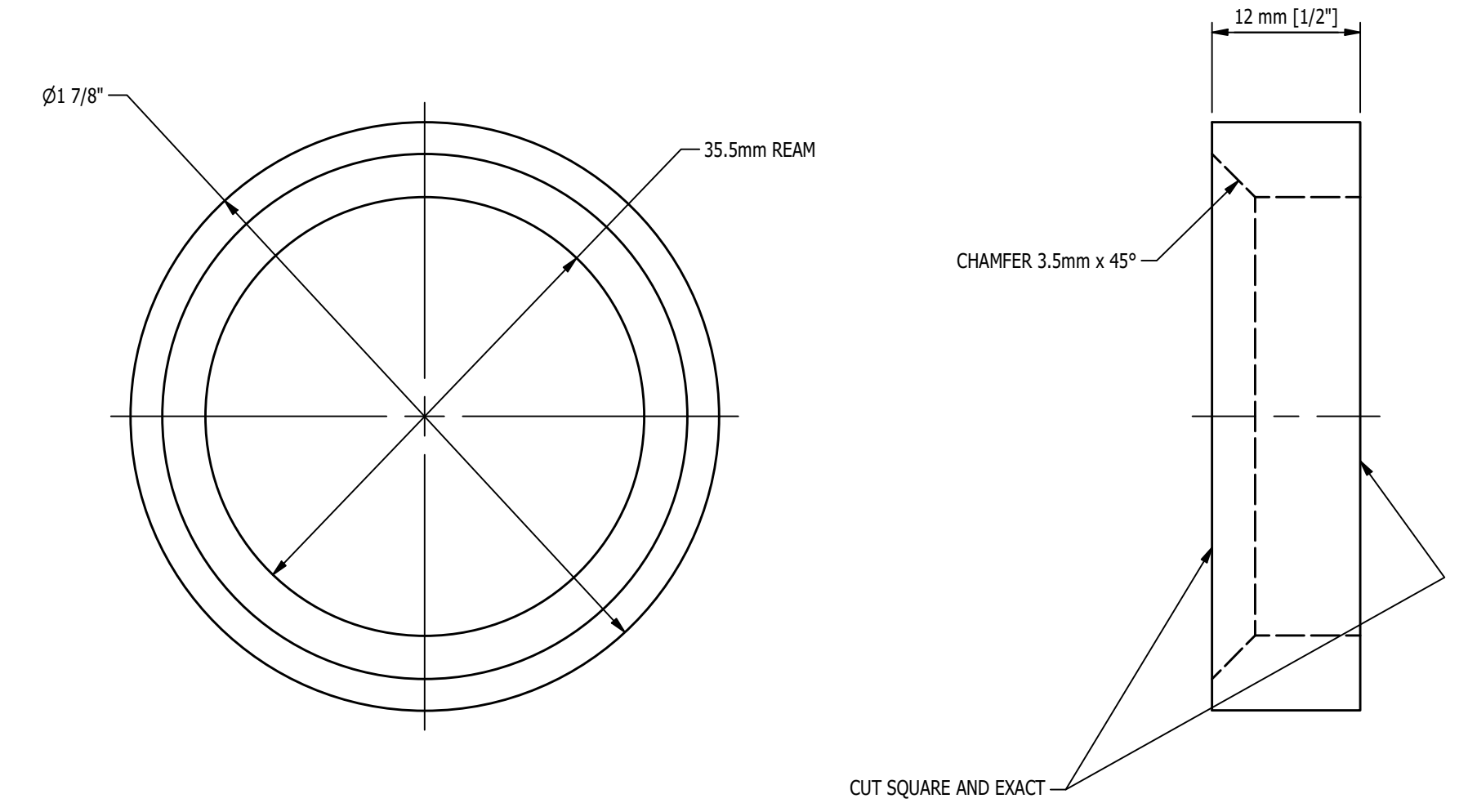
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3070 W. THOMPSON RD.  
FENTON, MI 48430  
PH: 810.373.0322 FAX: 810.373.0326  
www.millc.com

**TITLE:** P6700 CONVEYORS CAMPUS BUILDING  
**CLIENT:** VOLVO  
**DRAWING No.:** 1875D115  
**REV:** E

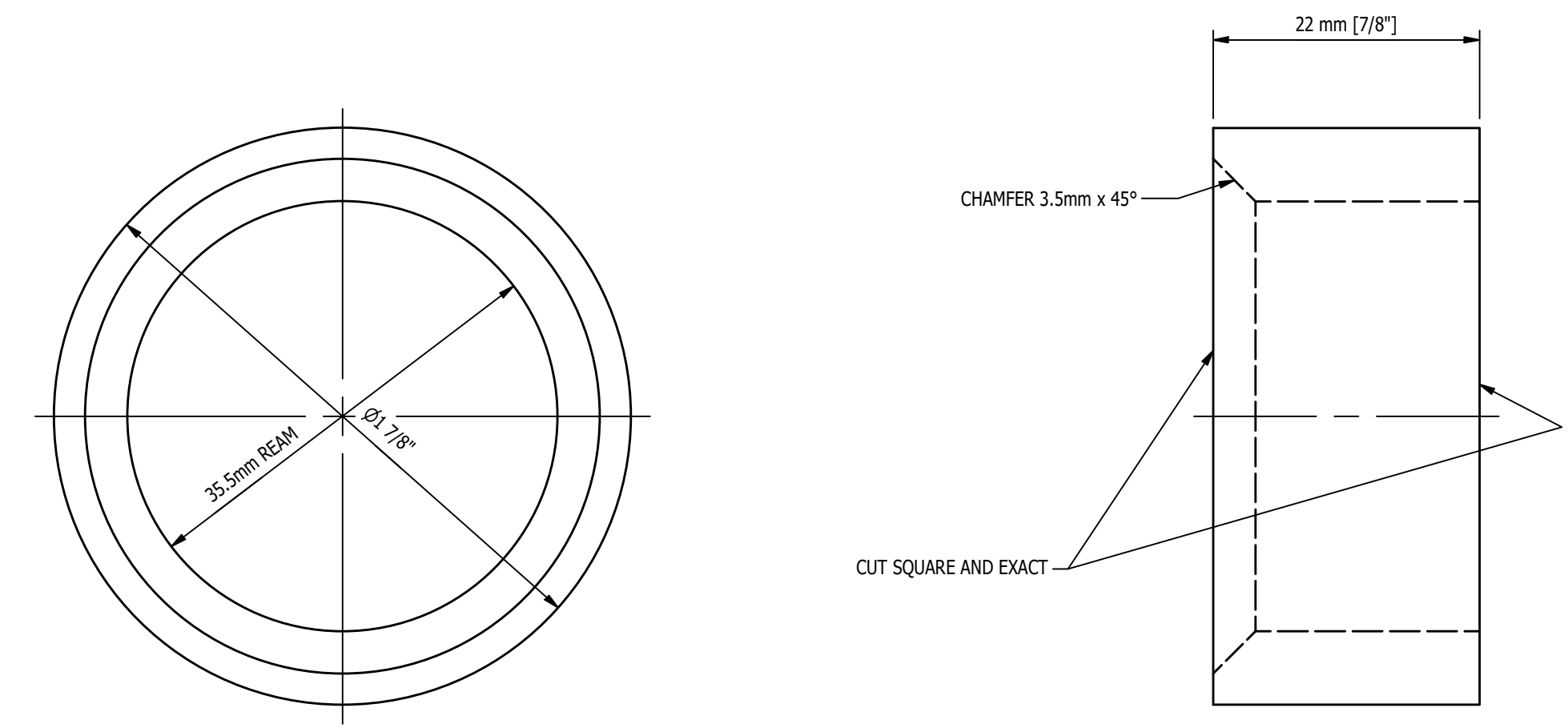
**DRAWN BY:** SGS  
**CHECKED BY:** CW  
**DWG DATE:** 6-14-2022  
**JOB No.:** 22096



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D116A			
2	1	TS 1 7/8 OD x 1/4 DOM	1/2"		
		MK-D116B			
3	1	TS 1 7/8 OD x 1/4 DOM	7/8"		



**MK-D116A ~ DRIVE ROLLER SPACER**  
SCALE 2:1




**MK-D116B ~ DRIVE ROLLER SPACER2**  
SCALE 2:1

- 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" / 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

PAINT OUTSIDE SURFACES ONLY

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/8/2022	CHANGED MATERIAL FROM PIPE TO DOM TUBING, BOTH MK'S	
B	MC	7/27/2022	ADDED SPACER, REV DIMS	
A	MC	7/21/2022	REVISED SPACER	

REVISION HISTORY			
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<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b>		<b>DRAWN BY: SGS</b>	
<b>CLIENT: VOLVO</b>		<b>CHECKED BY: CW</b>	
<b>DRAWING No. 1875D116</b>		<b>DWG DATE: 6-14-2022</b>	
<b>REV: C</b>		<b>JOB No: 22096</b>	

**MAGNUM CONSULTING**  
 41100 Charleston Rd.  
 Suite 125  
 Novi, MI 48275  
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 Fax: (248) 772-8821  
 Web: www.mmagnum.com

MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 1875D116 - REV C

**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.

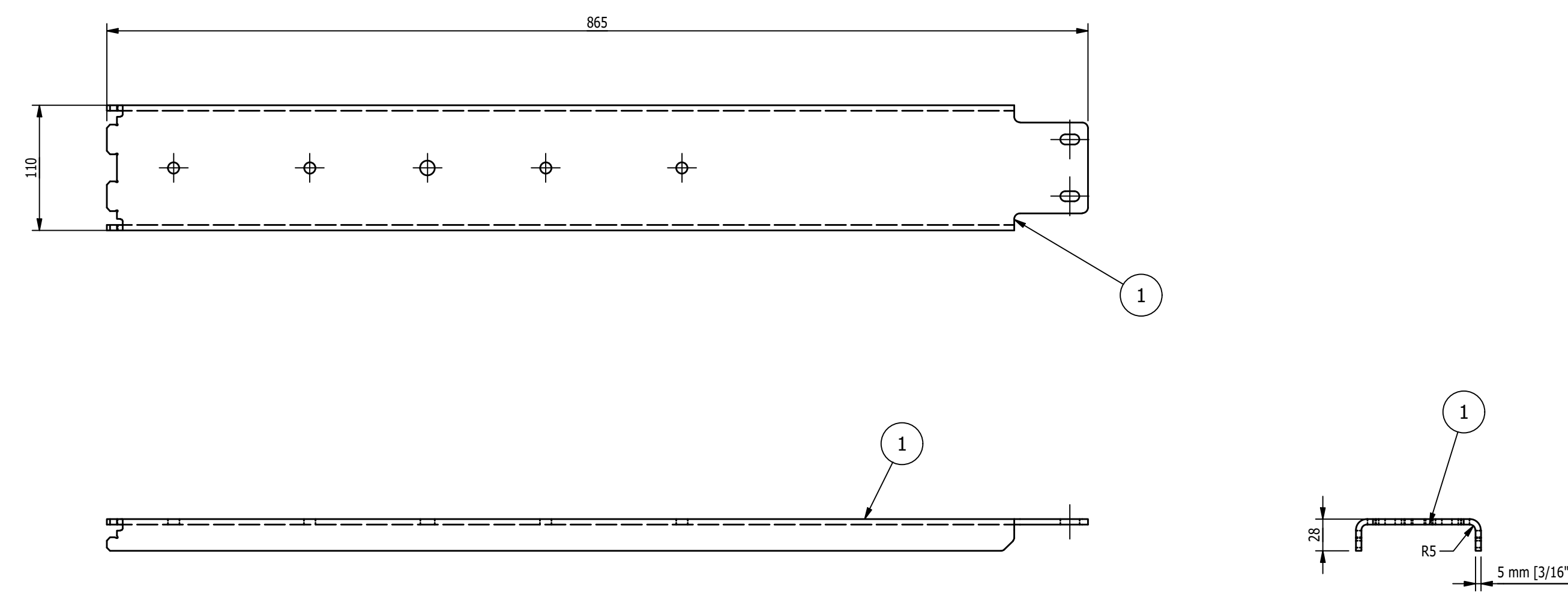
**HOLES:**  
 - ALL HOLES ARE 13/16" DIA. U.N.O.  
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

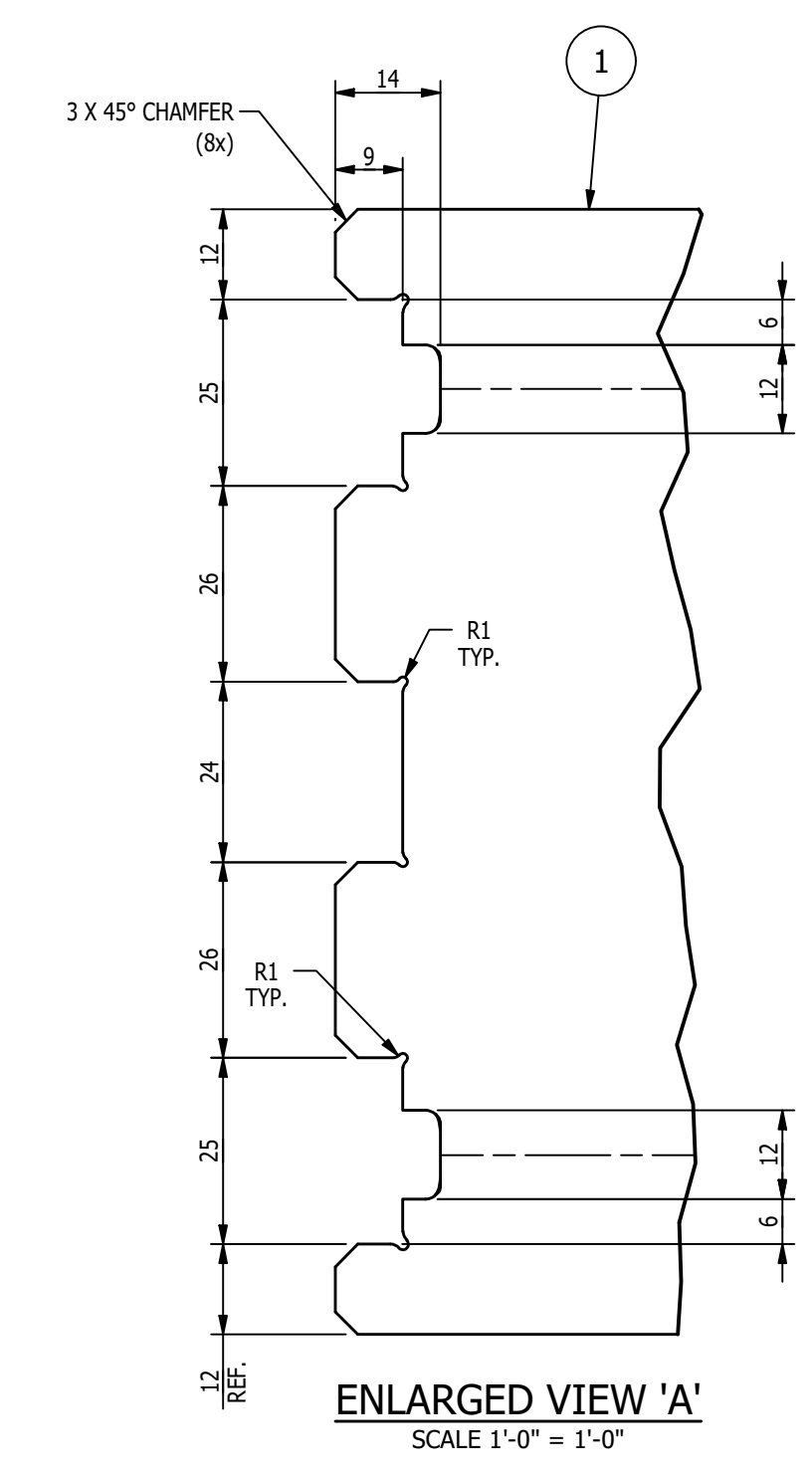
**PAINT:**  
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

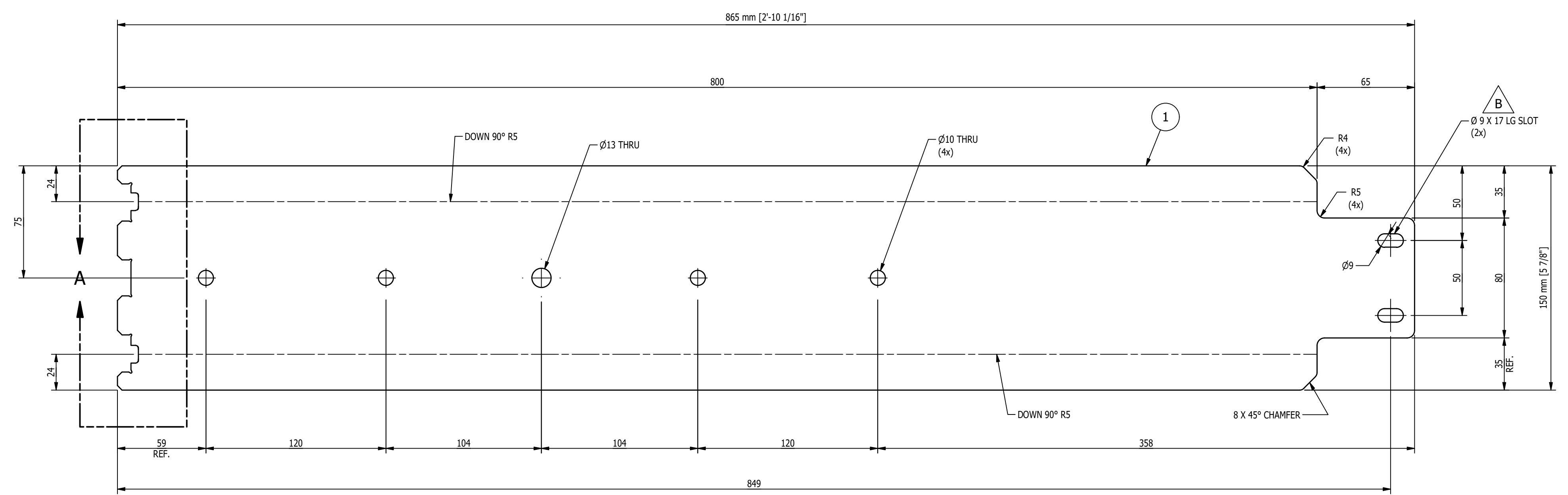
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D118A	2'-10 1/16"		
		PL 3/16 x 5 7/8			



MK-D118A ~ BAR CODE READER BRKT  
SCALE 3"=1'-0"




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




FLAT PATTERN OF ITEM '1'  
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 AFTER WELDING

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/13/2022	ADDED SLOT AND REVISED SHOP NOTE	
A	MC	7/5/22	FOR FABRICATON	

 <b>MILLER INDUSTRIES</b> 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>
<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b> <b>CLIENT: VOLVO</b>		DRAWN BY: SGS CHECKED BY: CW DWG DATE: 6-14-2022
DRAWING No. 1875D118		REV: B JOB No: 22096



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 41100 Quakerstown Rd.  
 Suite 125  
 West, MI 48375  
 Phone: (248) 772-8833  
 Fax: (248) 772-8851  
 Web: www.mmagnum.com  
 MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 1875D118 - 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.

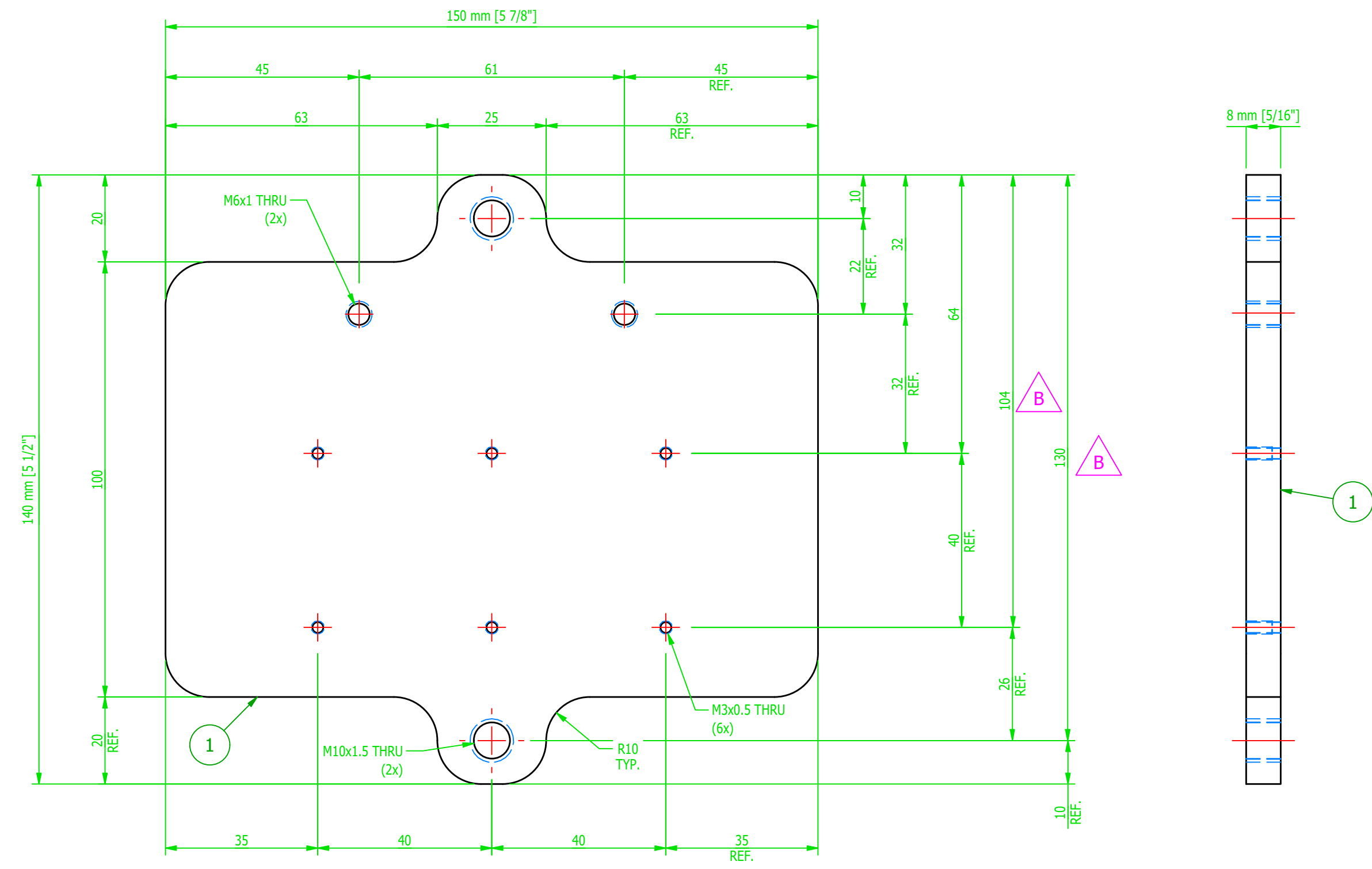
**WELDS:**  
 - ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

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

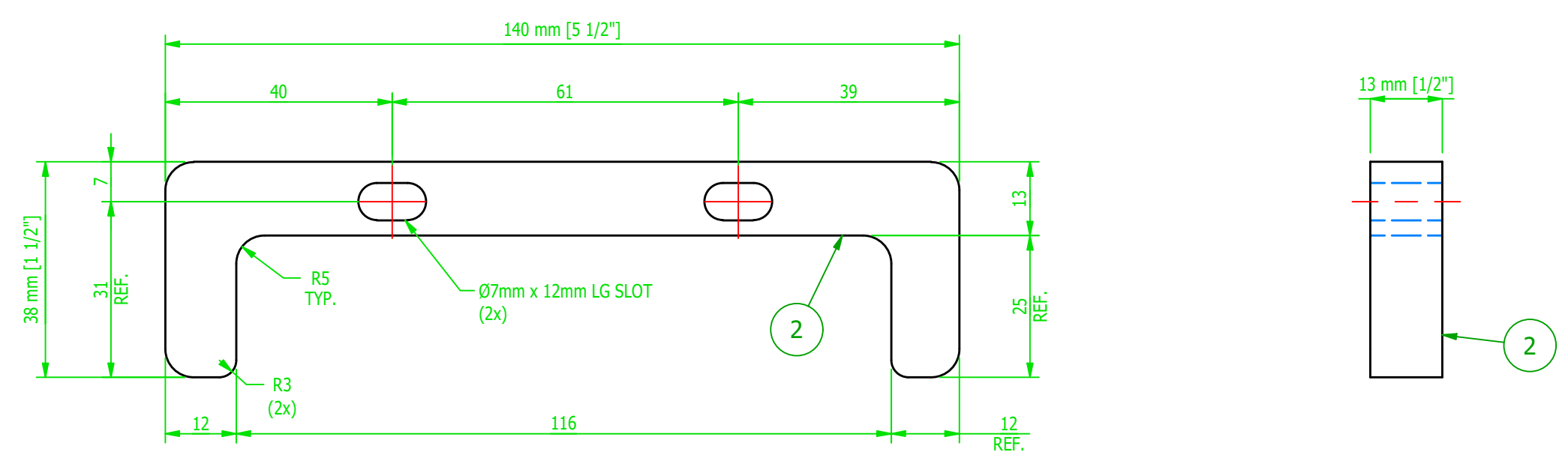
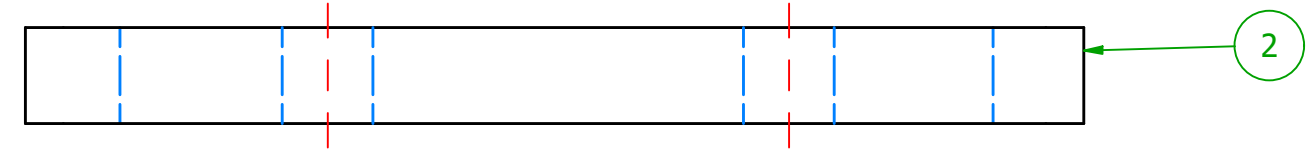
**COPIES:**  
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



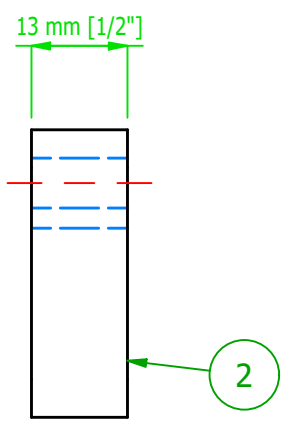
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D119A			
1	1	PL 5/16 x 5 1/2	5 7/8"		
		MK-D119B			
2	1	PL 1/2 x 1 1/2	5 1/2"		



**MK-D119A ~ ENCODER READER MTG PL**  
SCALE 1'-0" = 1'-0"



**MK-D119B ~ ENCODER READER HORSESHOE PL**  
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

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/14/2022	ADDED DIMENSIONS & REVISED SHOP NOTE	
A	MC	7/5/22	FOR FABRICATON	

<b>MILLER INDUSTRIES</b> 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.
<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b>		<b>DRAWN BY: SGS</b>
<b>CLIENT: VOLVO</b>		<b>CHECKED BY: CW</b>
<b>DRAWING No. 1875D119</b>		<b>DWG DATE: 6-14-2022</b>
<b>REV: B</b>		<b>JOB No: 22096</b>

**MAGNUM CONSULTING**  
 41100 Charleston Rd.  
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 Novi, MI 48275  
 Phone: (248) 772-8833  
 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:**

**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.

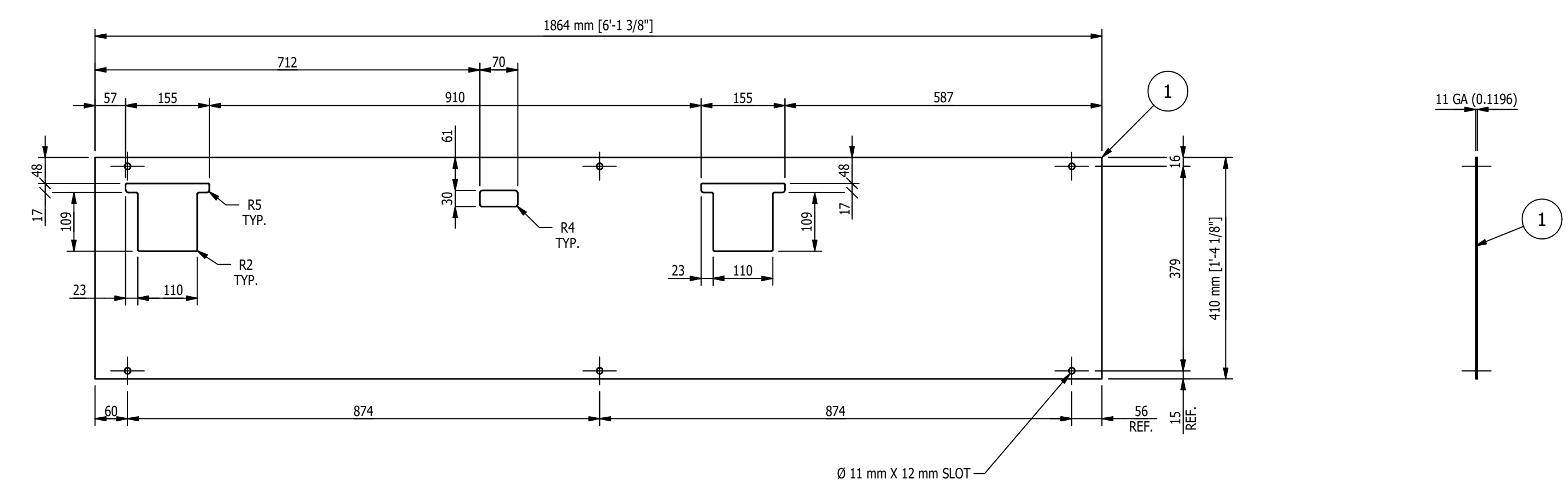
**HOLES:**  
 - ALL HOLES ARE 13/16" DIA. U.N.O.  
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

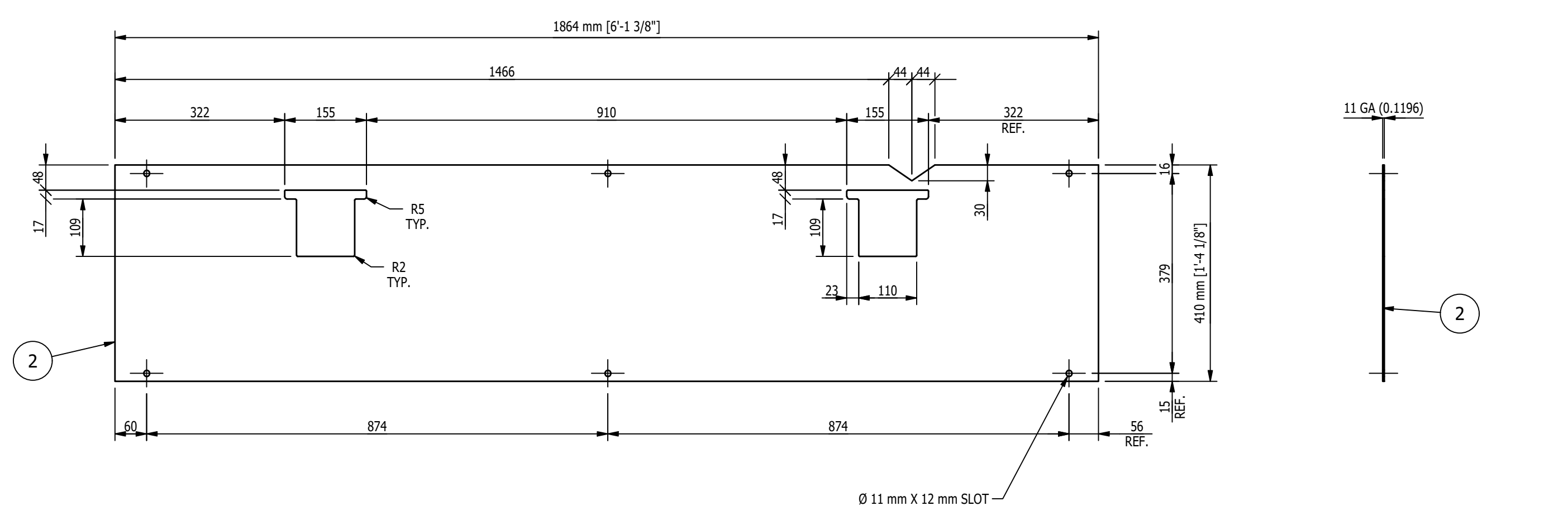
**PAINT:**  
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D120A			
1	1	SHT 11 GA x 16 1/8	6'-1 3/8"		
Z2					
		MK-D120B			
2	1	SHT 11 GA x 16 1/8	6'-1 3/8"		



**MK-D120A ~ END COVER PLATE**  
SCALE 1 1/2"=1'-0"



**MK-D120B ~ MID COVER PLATE**  
SCALE 1 1/2"=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:**
1. PAINT (ONE) SHOP COAT PRIMER.
  2. PAINT (2) FINISH COATS LIGHT GREY RAL 7035

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/5/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: SGS	
<b>MILLER INDUSTRIES</b> 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		CHECKED BY: CW DWG DATE: 6-15-2022 JOB No: 22096	
<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b> <b>CLIENT: VOLVO</b>		<b>DRAWING No. 1875D120</b> <b>REV: A</b>	

**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 #: 1875D120

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.

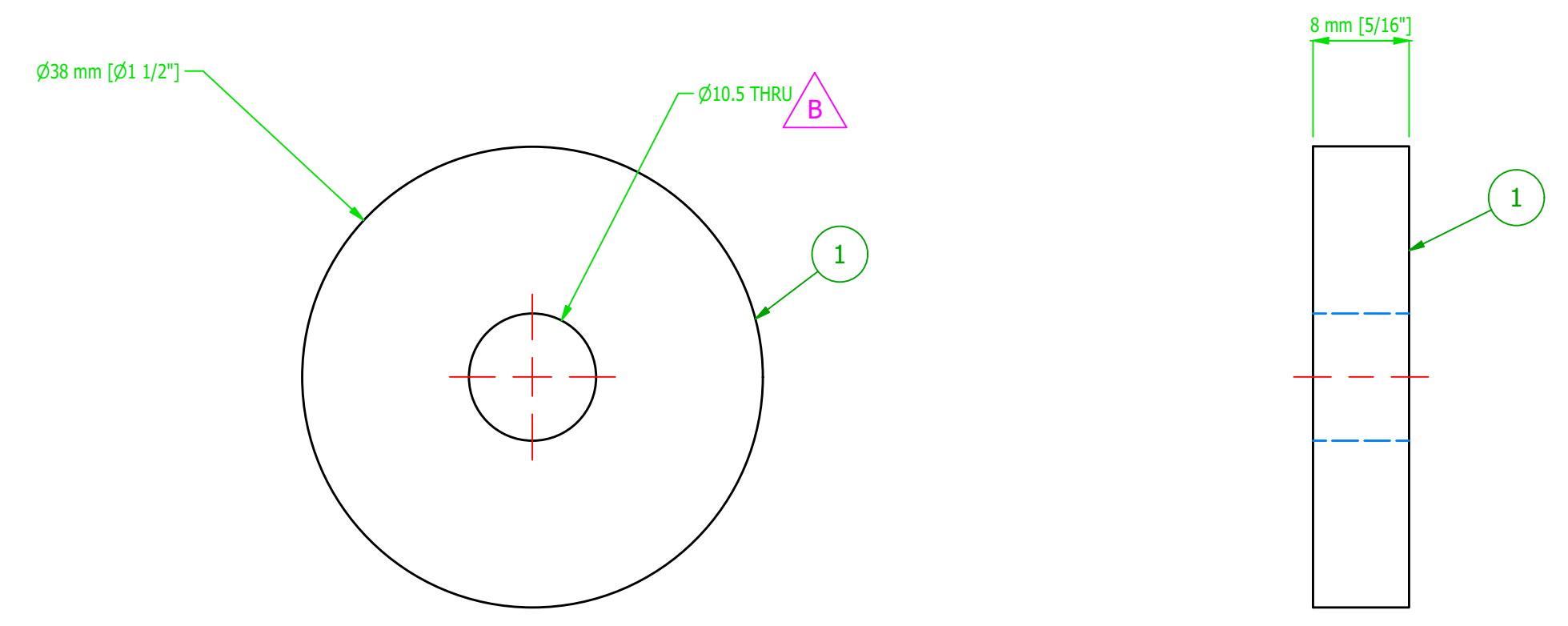
**WELDS:**  
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

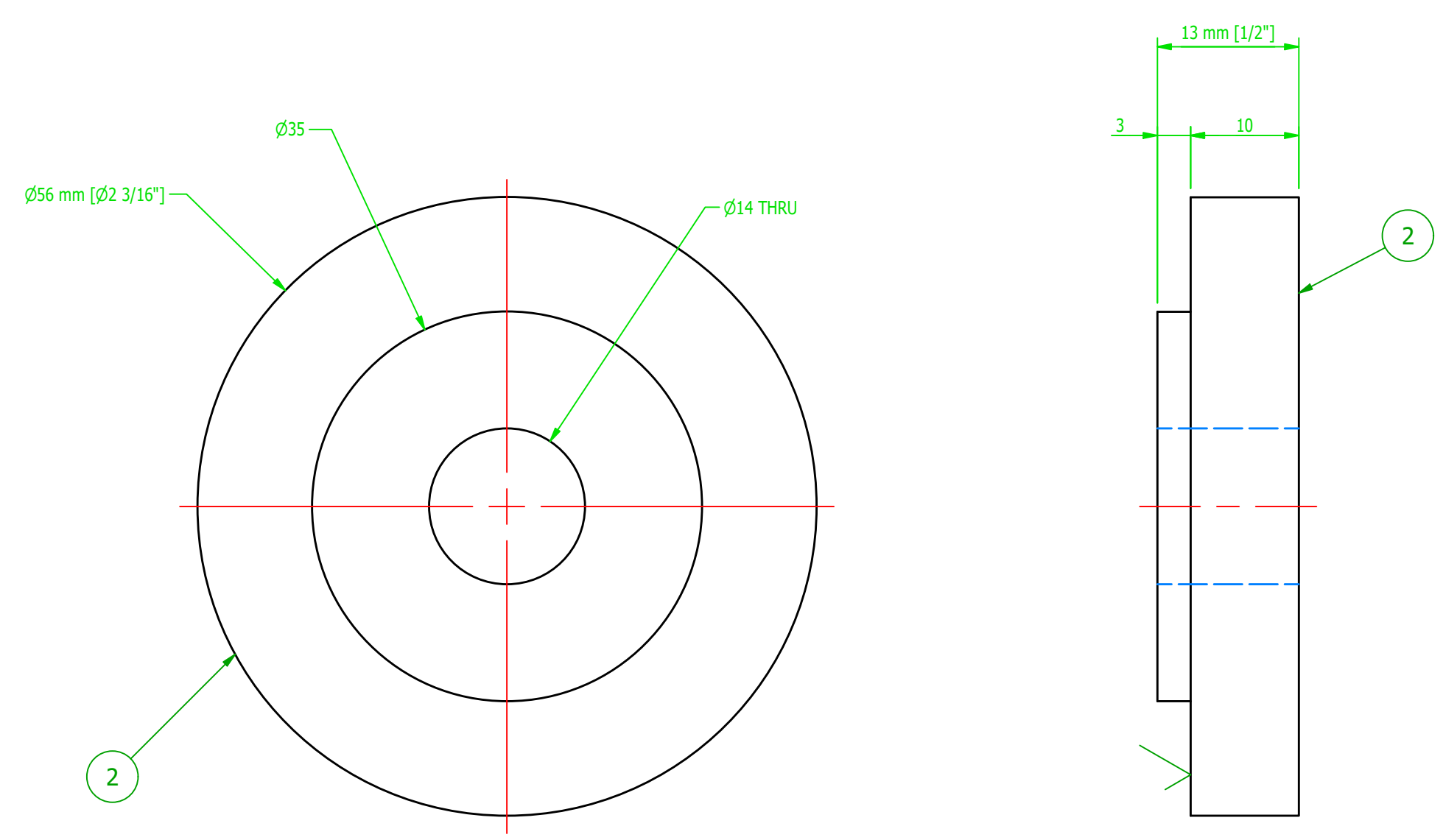
**COPIES:**  
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D121A			
1	1	BAR 5/16 X 1 1/2	5/16"		
		MK-D121B			
2	1	BAR Ø2 3/16	1/2"		



**MK-D121A ~ ROLLER WASHER**  
SCALE 2:1



**MK-D121B ~ MOTOR END SPACER**  
SCALE 2:1

NO DXF FILE FOR MARK 2

- 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:**  
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/13/2022	REVISED HOLE DIM AND SHOP NOTE	
A	MC	7/5/21	FOR FABRICATION	

<b>MILLER INDUSTRIES</b> 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.
<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b>		<b>DRAWN BY: SGS</b>
<b>CLIENT: VOLVO</b>		<b>CHECKED BY: CW</b>
<b>DRAWING No. 1875D121</b>		<b>DWG DATE: 6-15-2022</b>
<b>REV: B</b>		<b>JOB No: 22096</b>

**MAGNUM CONSULTING**  
 41100 Charleston Rd.  
 Suite 125  
 Novi, MI 48275  
 Phone: (248) 772-8822  
 Fax: (248) 772-8821  
 Web: www.mmagnum.com

MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 1875D121

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:**

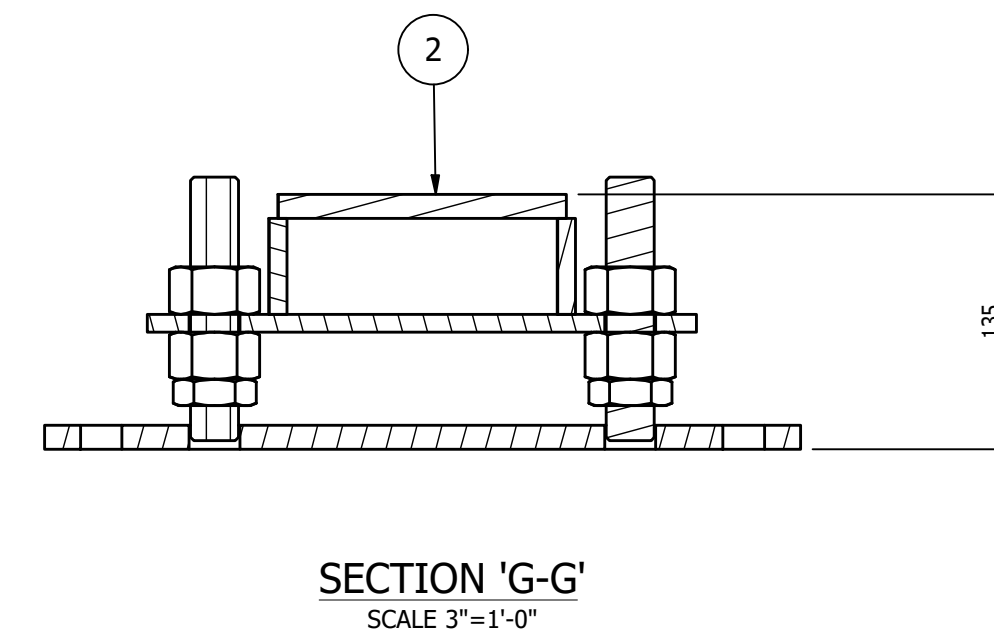
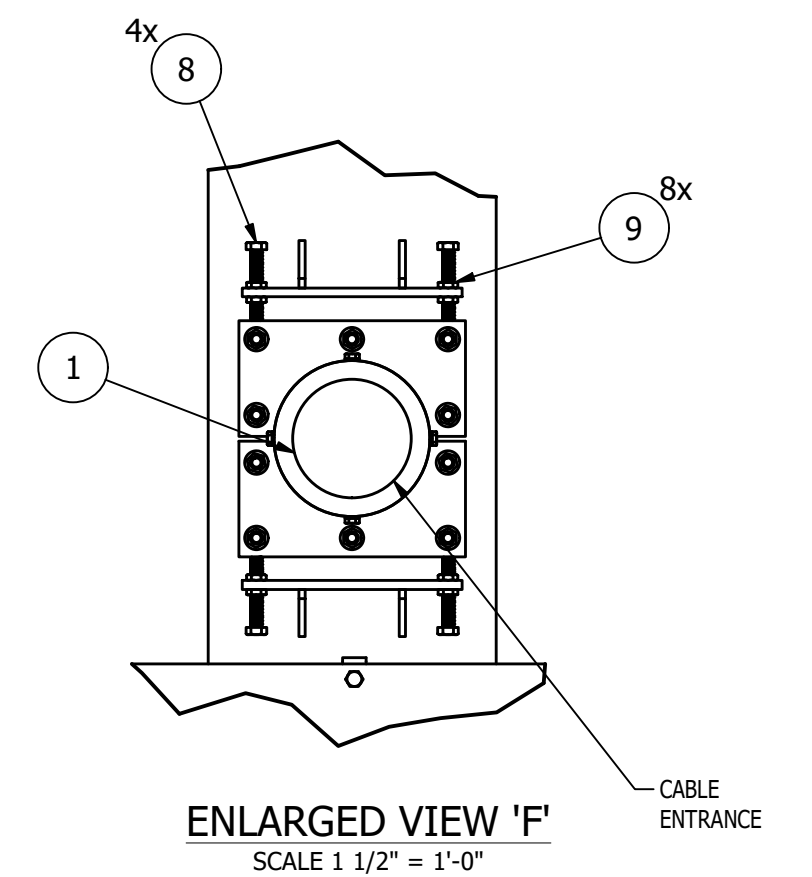
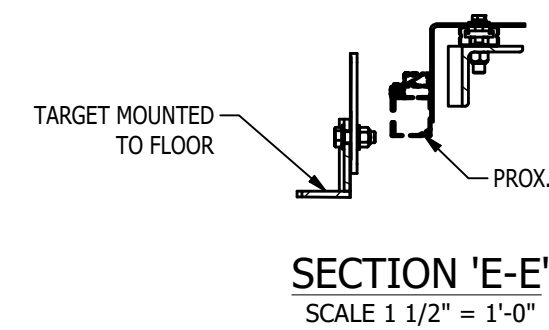
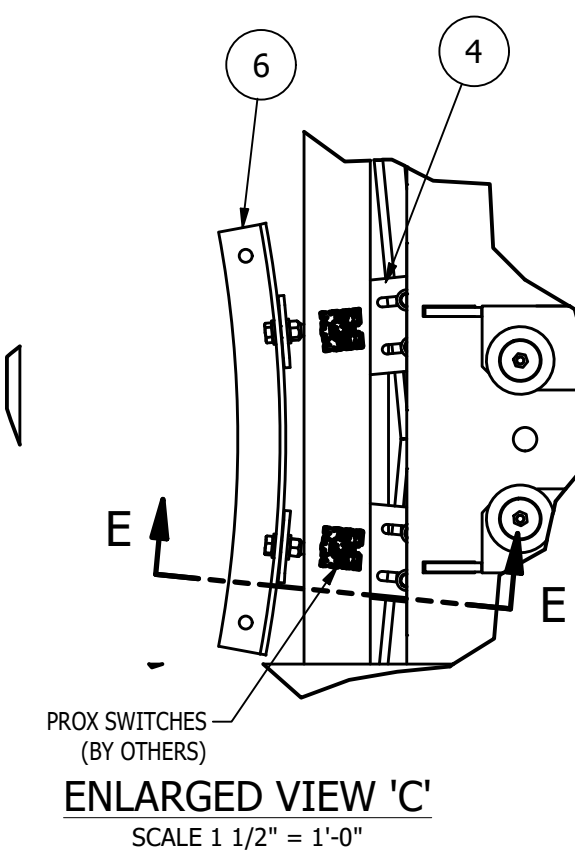
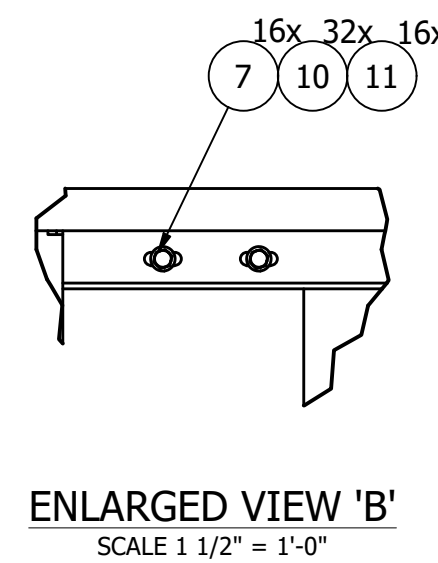
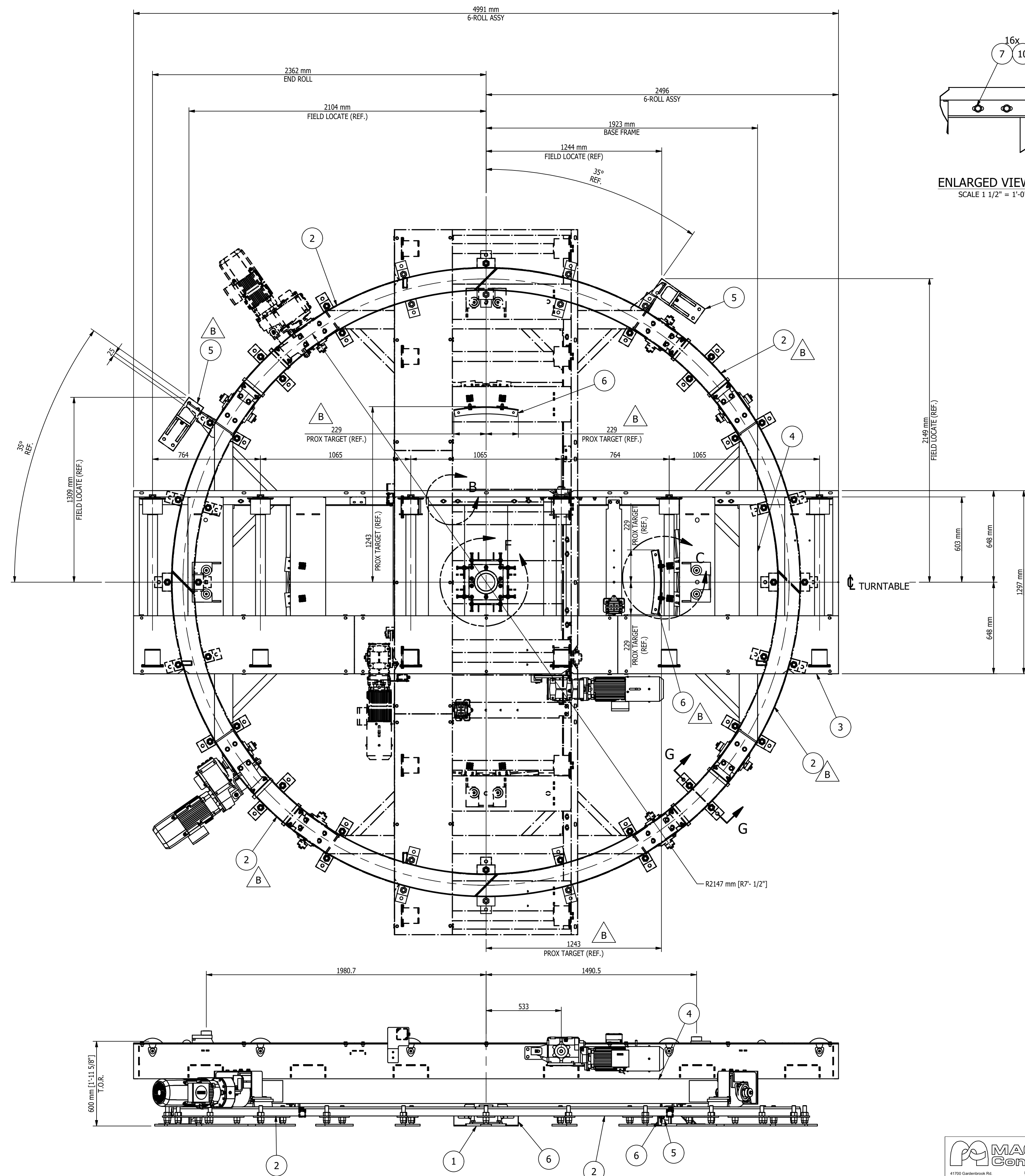
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

**PAINT:**

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

**COPIES:**

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



MK-D122A ~ PPRB 6-ROLL TURNTABLE ASSEMBLY  
SCALE 3/4" = 1'-0"

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):

$$\pi \times 1760 \times \frac{1}{13.61} \times \frac{140}{1000} = 56.2 \text{ m/min} = 184.5 \text{ ft/min}$$

BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
	1	MK-D122A		
1	1	MK-D014A ~ CENTER PIVOT POST ASSEMBLY		
2	4	MK-D015A ~ TURNTABLE TRACK SECTION ASSEMBLY		
3	1	MK-D123A ~ PPRB 6-ROLL TURNTABLE BED		
4	1	MK-D127A ~ CENTER PIVOT TURNTABLE BASE FRAME ASSEMBLY		
5	2	MK-D026A ~ PIVOT TABLE BUMPER		
6	2	MK-D033A ~ PROX TARGET		
7	16	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	32	M12 NARROW FLAT WASHER		
11	16	M12 x 1.75 STOVER LOCK NUT		
	1	TOTAL WEIGHT		

- 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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/6/22	ADDED BALLOONS & PROX TARGET LOCATION DIMENSIONS	
A	MC	8/26/22	FOR FABRICATION	

REVISION HISTORY

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

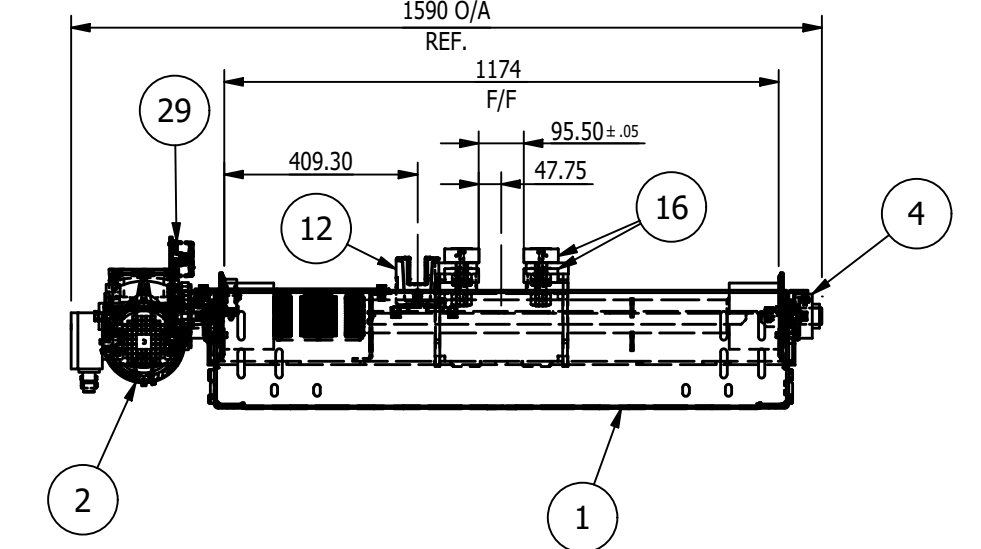
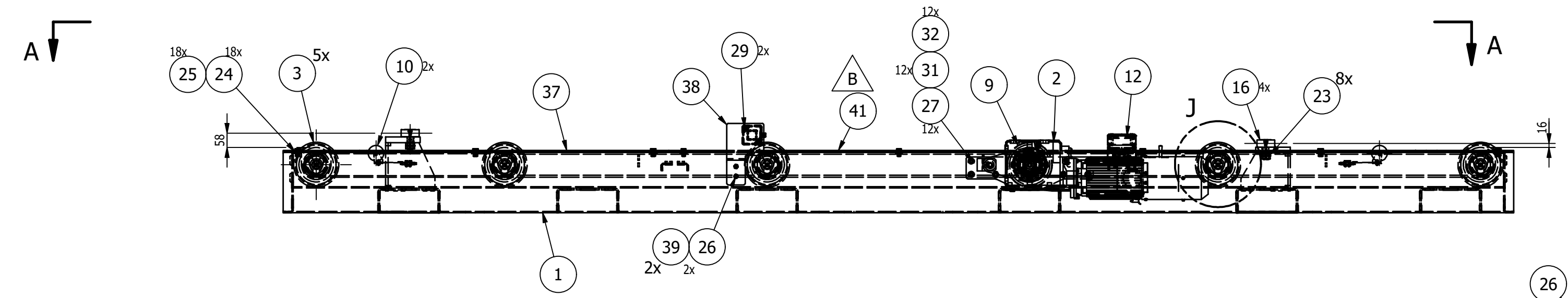
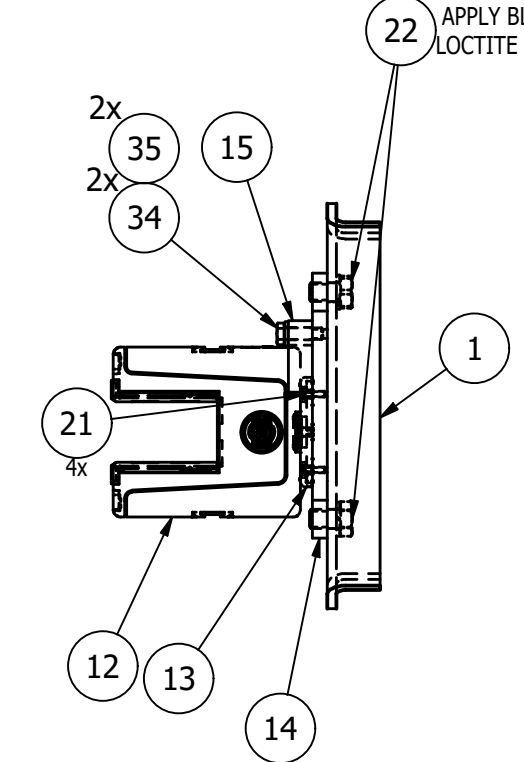
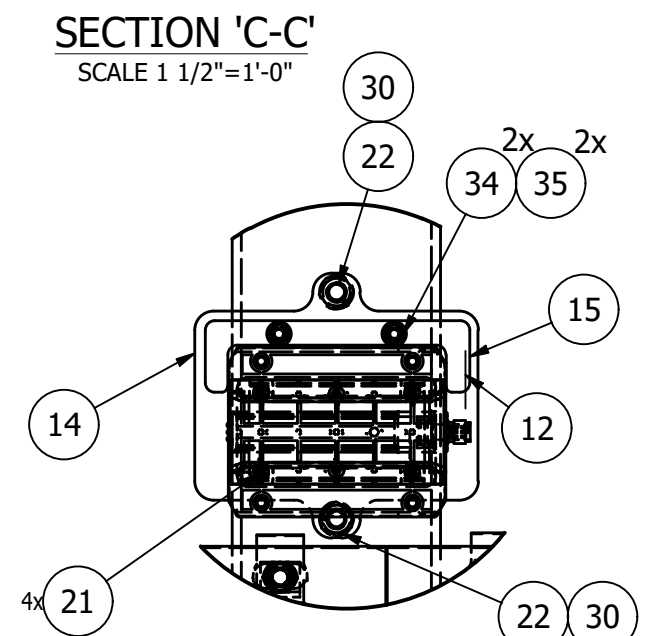
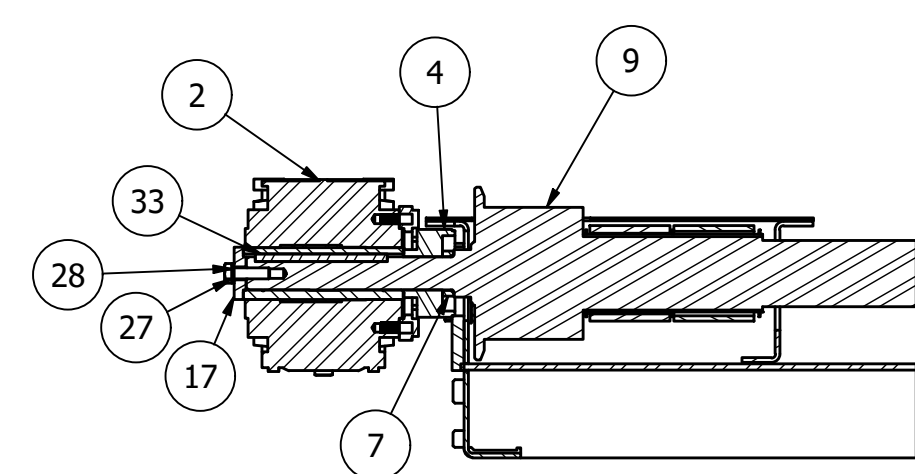
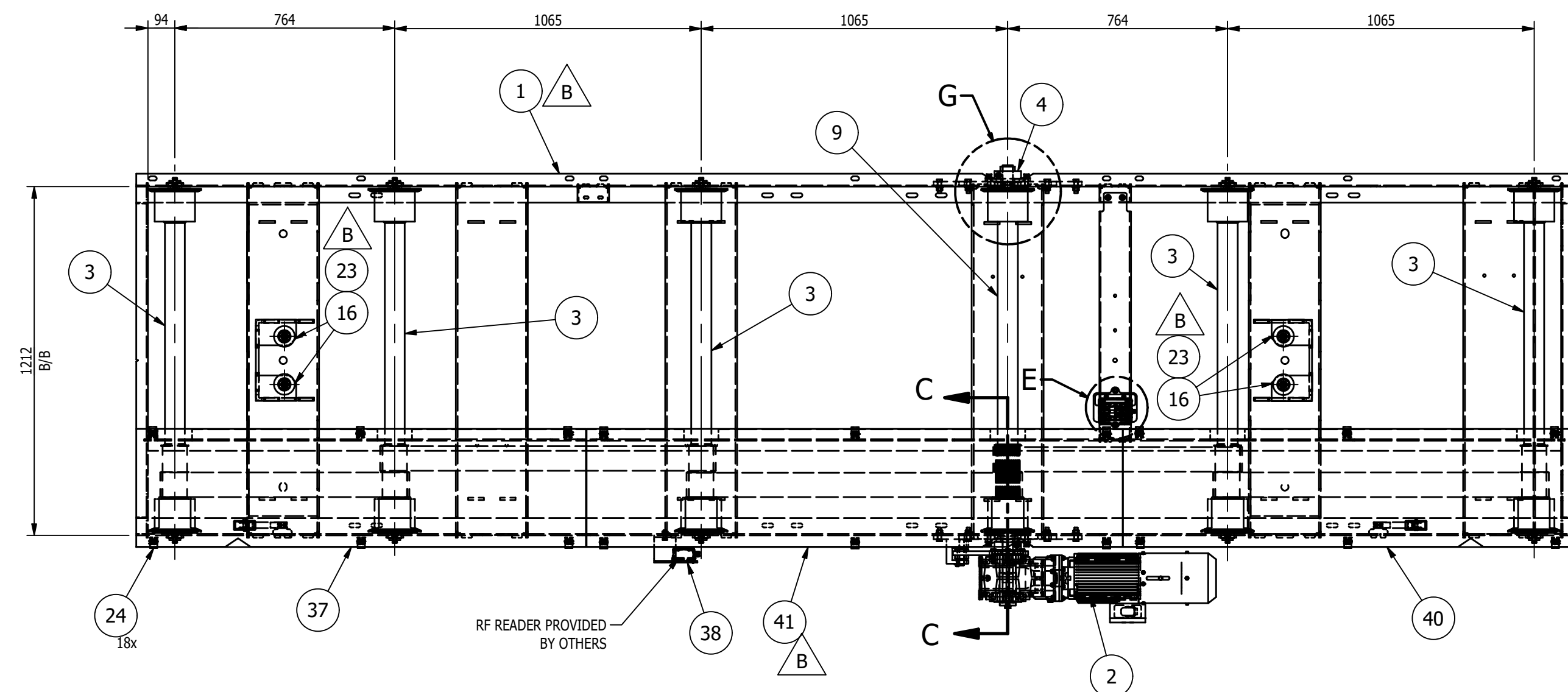
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D122	DWG DATE:	8/18/22
REV:	B	JOB No.:	22096

**MAGNUM Consulting**  
41100 Clarkston Rd.  
Suite 125  
West, MI 48375  
Phone: (248) 772-8889  
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

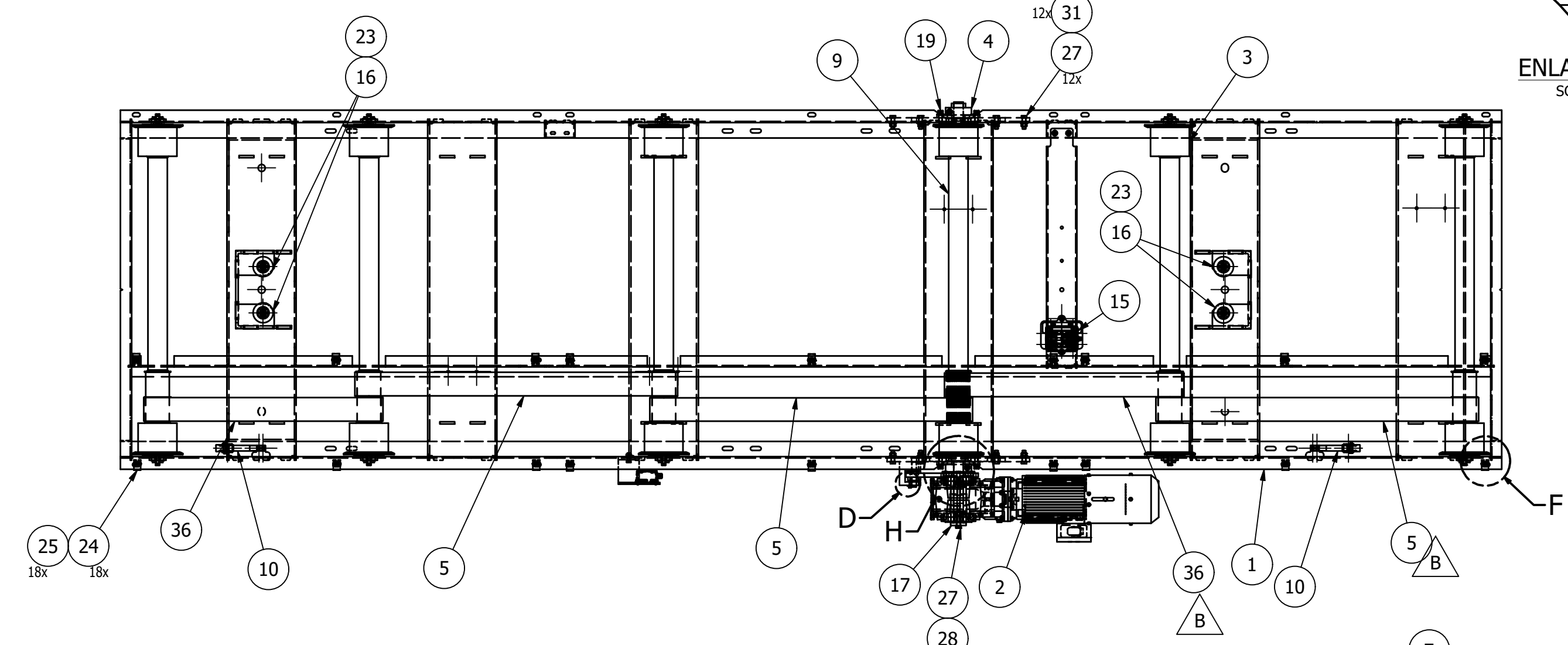
GENERAL NOTES:  
MATERIALS:  
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.  
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.  
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.  
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.  
HOLES:  
- ALL HOLES ARE 13/16" DIA. U.N.O.  
- ALL BOLTED CONNECTIONS 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.



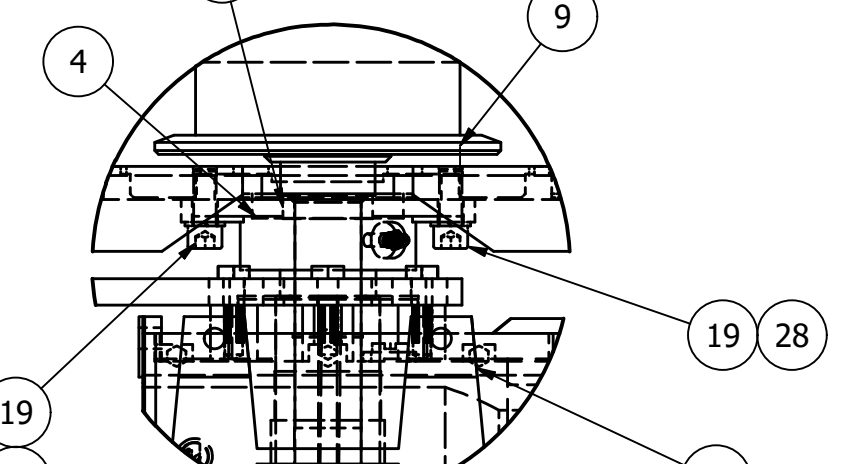
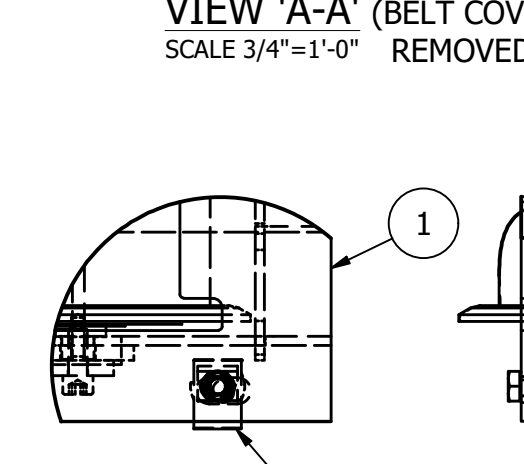
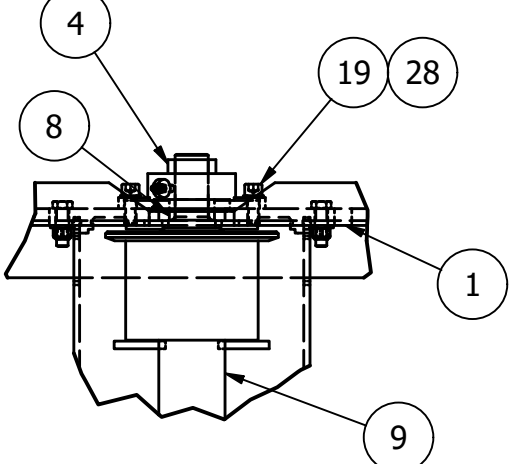
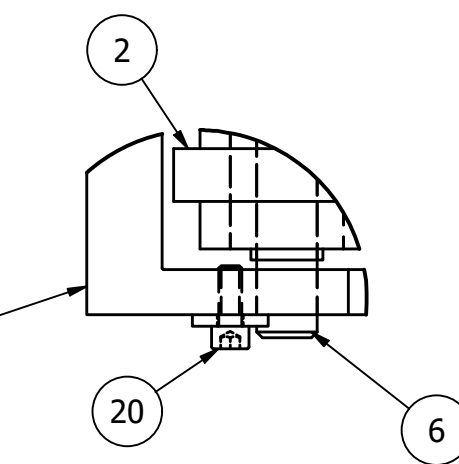


MK-D123A ~ PPRB 6-ROLL TURNTABLE BED  
SCALE 3/4"=1'-0"

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



VIEW 'A-A' (BELT COVERS ARE REMOVED FOR CLARITY)  
SCALE 3/4"=1'-0"



SPEED FORMULA (60HZ):

$$\pi \times 1740 \times \frac{1}{13.61} \times \frac{140}{1000} = 56.2 \text{ m/min} = 184.5 \text{ ft/min}$$

- 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.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D123A			
1	1	MK-D124A ~ PPRB 6-ROLL TURNTABLE WELDMENT			
2	1	SIEMENS RB1 GEARMOTOR (SEE MOTOR DATA LIST)		1-1	
3	5	PALLET DRIVEN ROLLER, DUGOMRULLI PART NO 329638V			
4	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
5	3	GATES POWERGRIP GT4 BELT ~ 2400-8MGT-85		2-1	
6	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
7	1	MK-D116A ~ DRIVE ROLLER SPACER			
8	1	MK-D116B ~ DRIVE ROLLER SPACER			
9	1	PALLET DRIVER ROLLER, DUGOMRULLI PART NO 332192V M12			
10	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
11	10	MK-D121A ~ ROLLER WASHER			
12	1	WCS3B-LS310D READ HEAD ~ PEPPERL&FUCHS		4-1	
13	1	WCS-MP1 ~ BAR CODE READER MTG PLATE ~ PEPPERL&FUCHS		4-2	
14	1	MK-D119A ~ ENCODER READER MTG PL			
15	1	MK-D119B ~ ENCODER READER HORSESHOE PL			
16	4	SMITH BRG #MCR-72-SB ~ 72 mm OD X 29 mm W, W/24 mm STUD X 49.5 mm L		3-2	
17	1	MK-D121B ~ MOTOR END SPACER			
19	4	M12x1.75 x 30mm LG. HEX SOCKET HEAD CAP SCREW			
20	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
21	4	M3x0.5 x 10mm LG. HEX SOCKET HEAD CAP SCREW			
22	2	M10x1.5 x 16mm LG. HEX CAP SCREW			
23	8	M24 x 1.5 HEX JAM NUT			
24	18	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
25	18	M10x1.5 x 25mm LG. HEX CAP SCREW			
26	12	M10x1.5 x 25mm LG. HEX SOCKET HEAD CAP SCREW			
27	13	M12x1.75 x 40mm LG. HEX CAP SCREW			
28	5	M12 SPRING LOCK WASHER			
29	2	M5x0.8 x 12mm LG. HEX SOCKET HEAD CAP SCREW			
30	2	M10 SPRING LOCK WASHER			
31	12	M12 NARROW FLAT WASHER			
32	12	M12 x 1.75 STOVER LOCK NUT			
33	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	
34	2	M6x1 x 20mm LG. HEX CAP SCREW			
35	2	M6 NARROW FLAT WASHER			
36	2	GATES POWERGRIP GT4 BELT, 1800-8M-GT85		2-3	
37	1	MK-D133A ~ END COVER PLATE			
38	1	MK-D134A ~ RF CODE READER BRACET			
39	2	M10 x 1.5 STOVER LOCK NUT			
40	1	MK-D133B ~ END COVER PLATE			
41	1	MK-D133C ~ MID COVER PLATE			

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/6/22	ADDED BALLOONS, SWITCHED LOCATION OF ITEMS '36' & '5', REPLACED ITEM '18' WITH ITEM '41'	
A	MC	8/26/22	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.:** 1875D123  
**REV:** B

**DRAWN BY:** RJB  
**CHECKED BY:** CW  
**DWG DATE:** 8/18/2022  
**JOB No.:** 22096

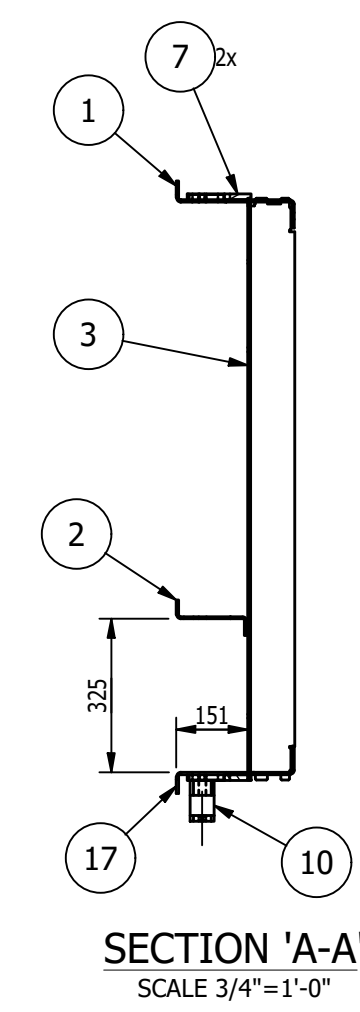
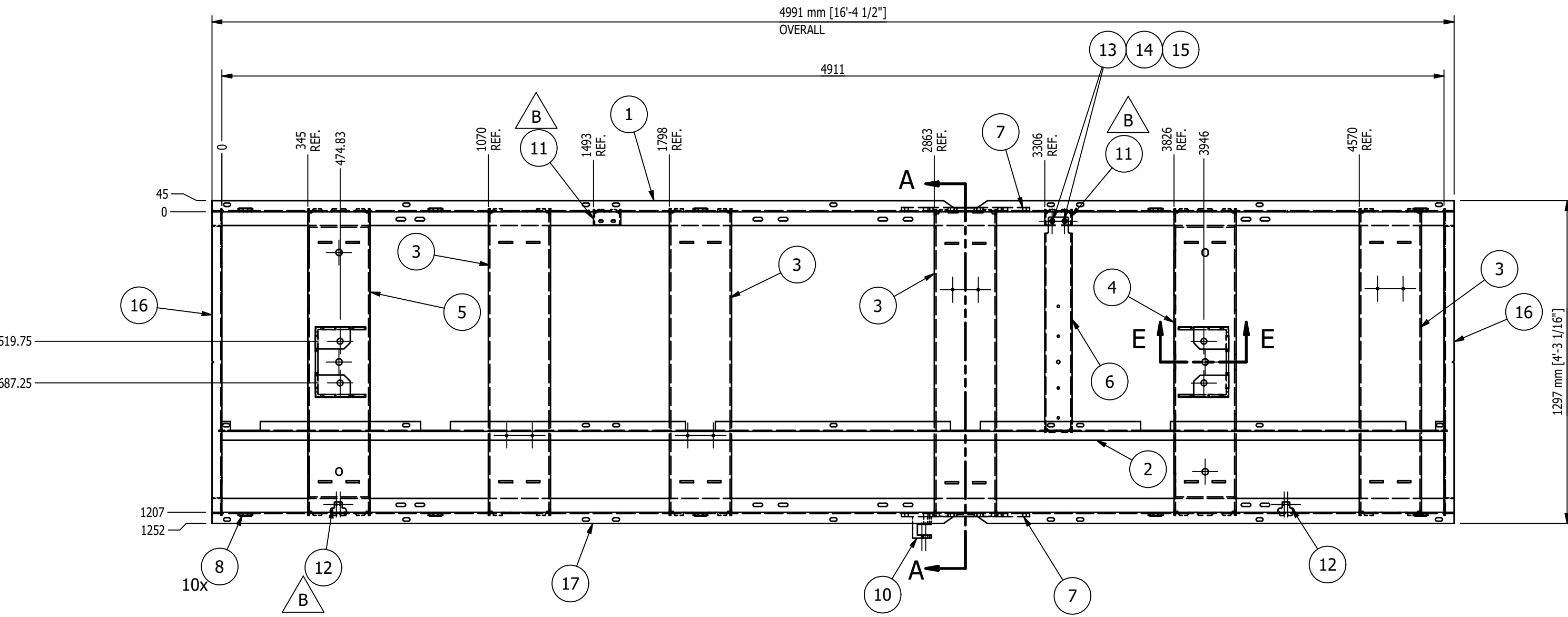
**MAGNUM CONSULTING**  
4100 Clarkston Rd  
Suite 125  
West, MI 48375  
Phone: (248) 772-8889  
Fax: (248) 772-8851  
Web: www.mmagnum.com

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D100

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

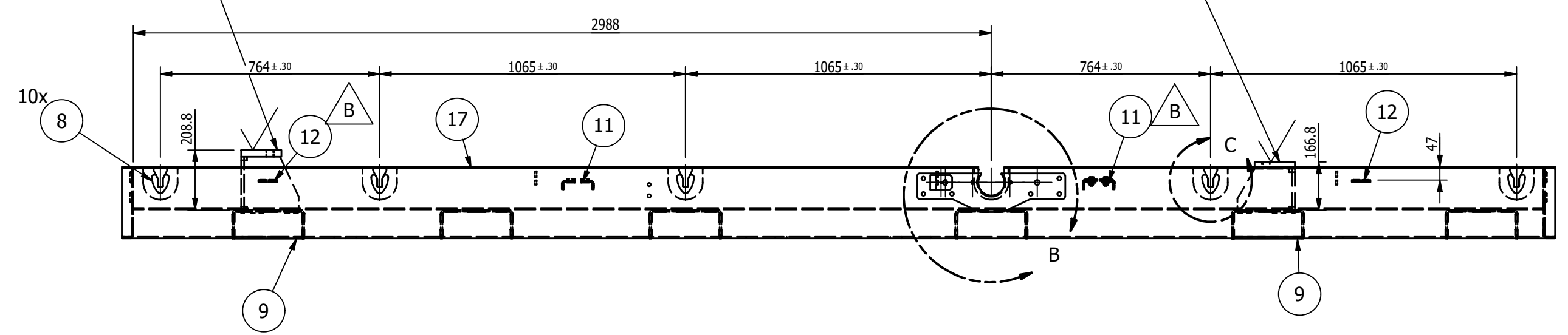
GENERAL NOTES:  
MATERIALS:  
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.  
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.  
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.  
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.  
HOLES:  
- ALL HOLES ARE 13/16" DIA. U.N.O.  
- ALL BOLTED CONNECTIONS 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.



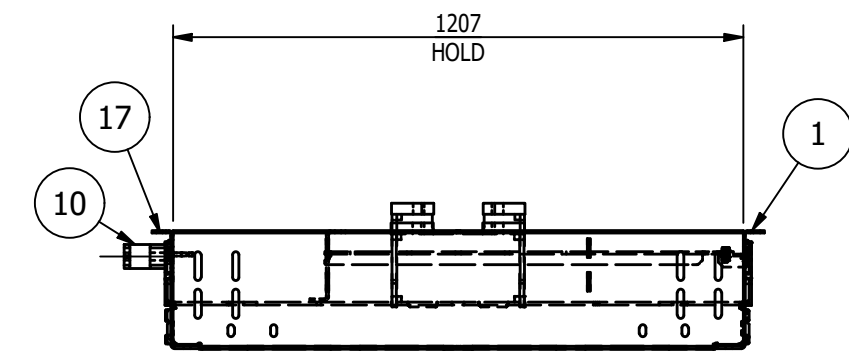


BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D124A			
1	1	MK-D125A ~ PPRB 6-ROLL TURNTABLE SIDE FRAME			
2	1	MK-D132A ~ MID FRAME			
3	4	MK-D107A ~ INNER CROSS MEMBER			
4	1	MK-D110B ~ INNER CROSS MEMBER WELDMENT-RH			
5	1	MK-D110A ~ INNER CROSS MEMBER WELDMENT-LH			
6	1	MK-D118A ~ BAR CODE READER BRKT			
7	2	MK-D111A ~ MOTOR MOUNTING PLATE			
8	10	MK-D111B ~ RETAINER			
9	2	MK-D227B ~ STIFFENER PLATE			
10	1	MK-D111D ~ CLEVIS			
11	2	MK-D113A ~ BRACKET			
12	2	MK-D113B ~ ENCODER BRACKET			
13	2	M8x1.25 x 25mm LG. HEX CAP SCREW			
14	4	M8 NARROW FLAT WASHER			
15	2	M8 x 1.25 STOVER LOCK NUT			
16	2	MK-D130A ~ END FRAME			
17	1	MK-D125B ~ SIDE FRAME			
		TOTAL WEIGHT = 1175.5 Lbs			

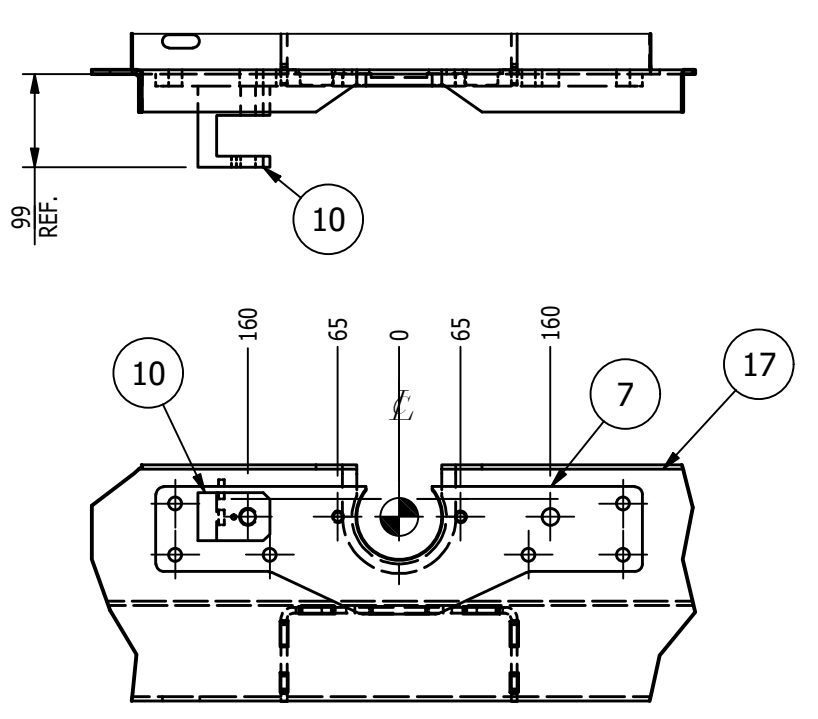
**NOTE:**  
SEE DWG. 1875D110 FOR MACHINING REQUIREMENTS MACHINE AFTER WELDING IN PLACE



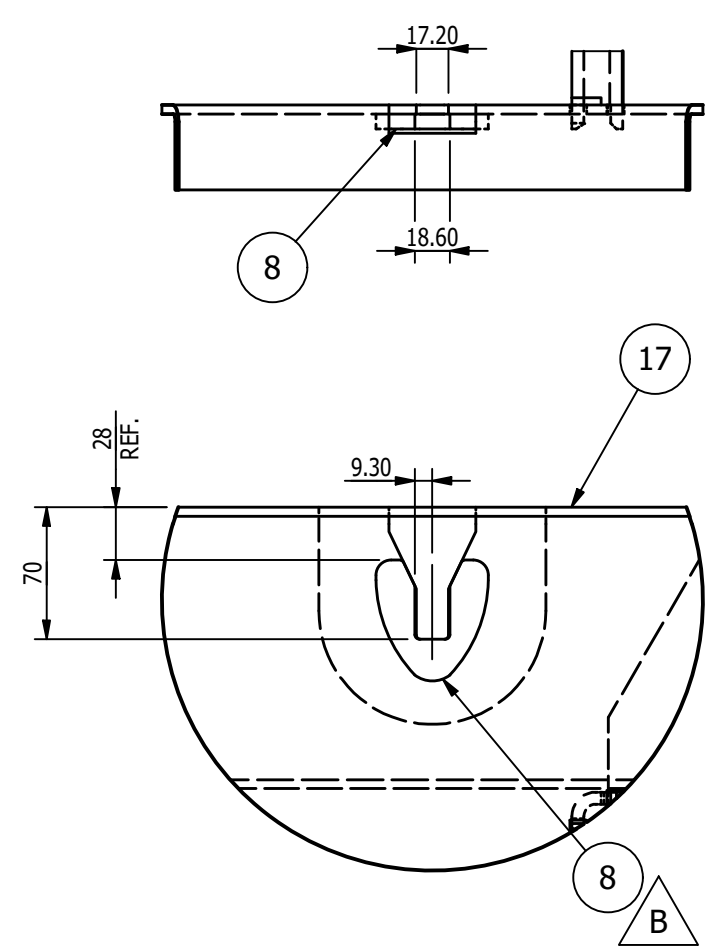
MK-D124A ~ PPRB 6-ROLL TURNTABLE WELDMENT  
SCALE 3/4" = 1'-0"



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



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



ENLARGED VIEW 'C'  
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.
  9. 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.

**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  
North, MI 48075

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

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D101

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
B	MC	9/6/22	ADDED BALLONS, UPDATED DESCRIPTION OF ITEM '3'	
A	MC	8/26/22	FOR FABRICATION	
REVISION HISTORY				

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

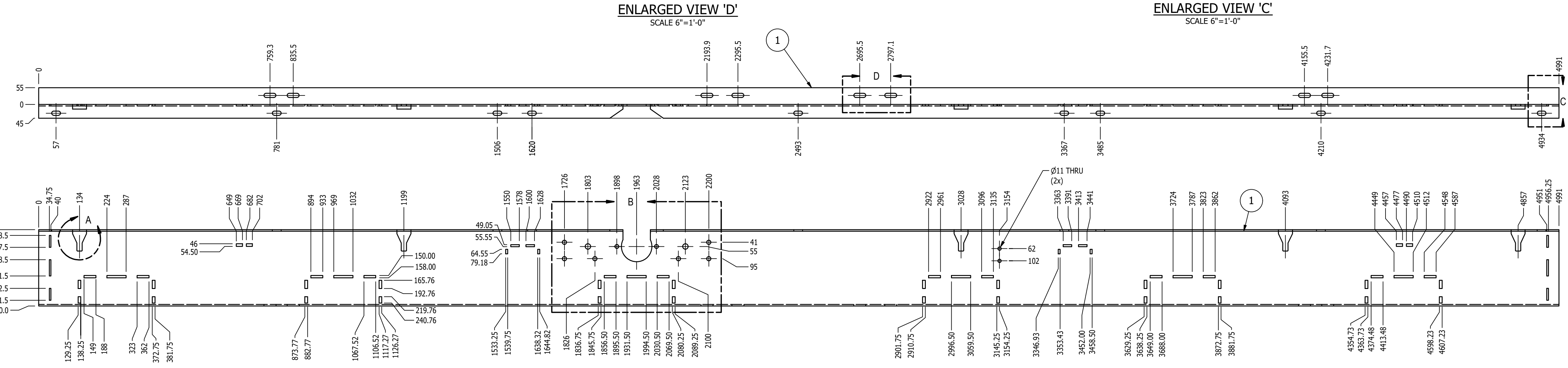
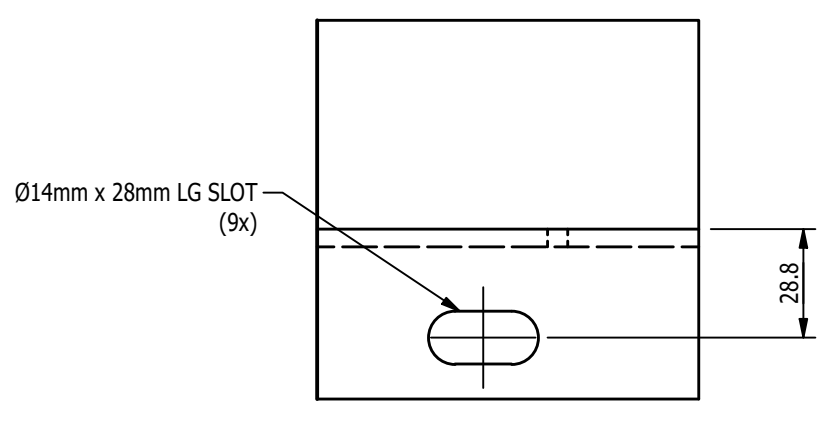
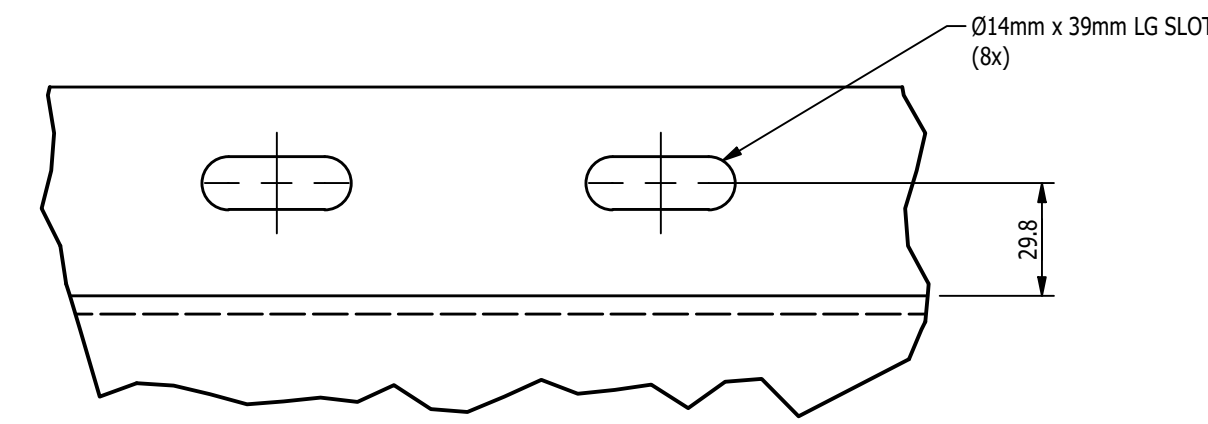
**TITLE:** P6700 CONVEYORS CAMPUS BUILDING  
**CLIENT:** VOLVO  
**DRAWING No.:** 1875D124

**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.

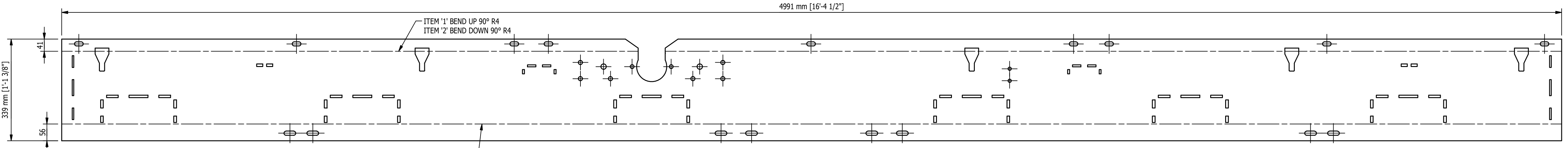
**DRAWN BY:** RJB  
**CHECKED BY:** CW  
**DWG DATE:** 8/18/22  
**JOB No.:** 22096

**REV:** B

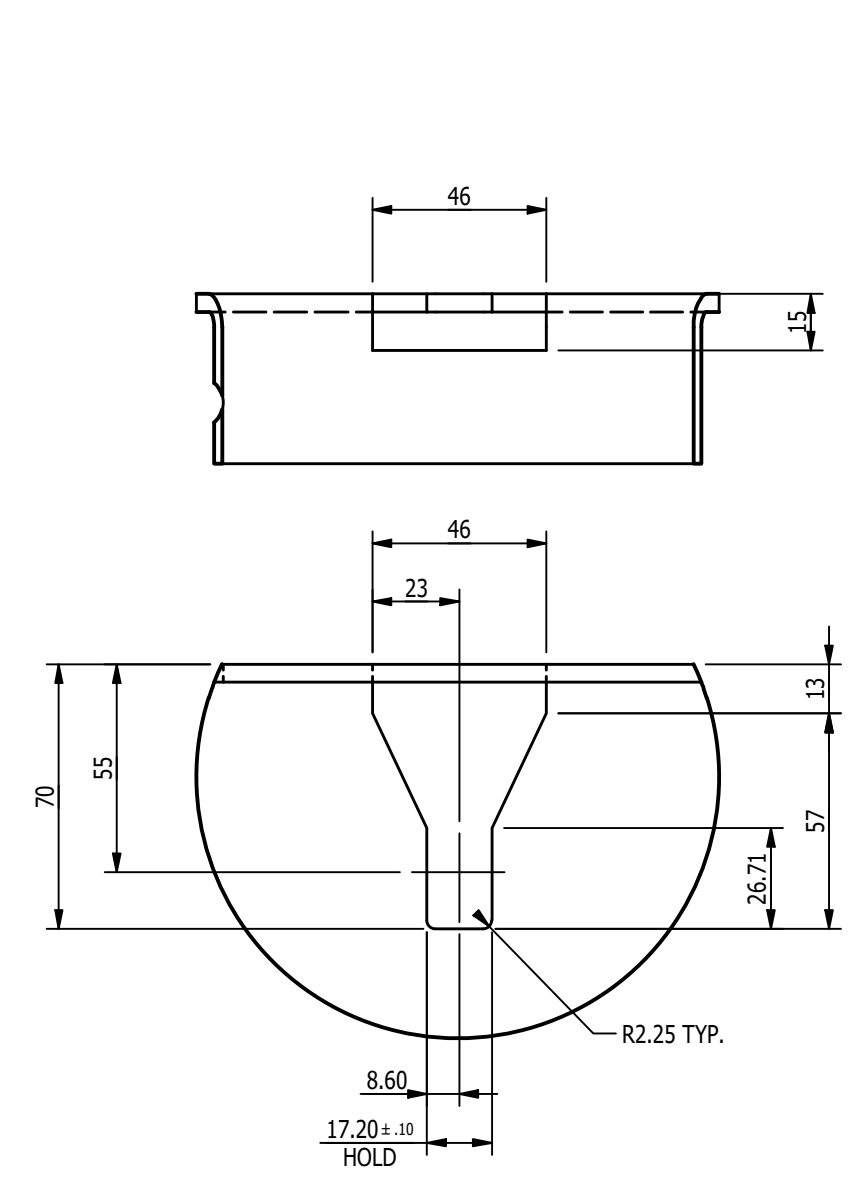
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D125A PL 3/16 x 1'-1 3/8"	16'-4 1/2"		
2	1	MK-D125B PL 3/16 x 1'-1 3/8"	16'-4 1/2"		



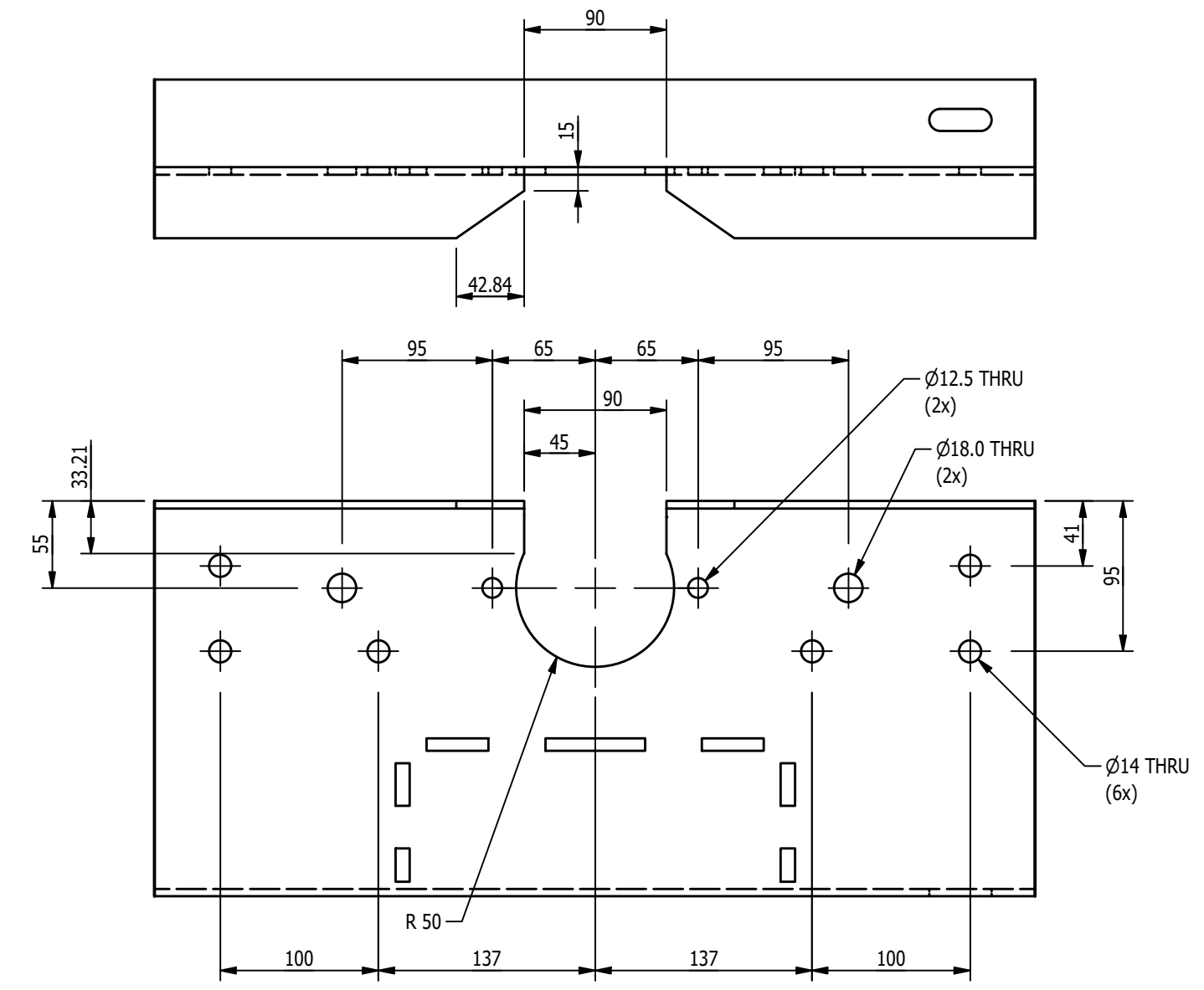
MK-D125A ~ SIDE FRAME (SHOWN)  
MK-D125B ~ SIDE FRAME (OPPOSITE)  
SCALE 1 1/2"=1'-0"



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



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



ENLARGED VIEW 'B'  
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 AFTER WELDING

**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.

**MAGNUM CONSULTING**  
41100 Dardick Road  
Suite 125  
North, MI 48315  
Phone: (248) 772-8822  
Fax: (248) 772-8851  
Web: www.mmagnum.com

MAGNUM JOB #:  
MAGNUM DRAWING #:

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	9/20/2022	FLIPPED FLAT PATTERN END TO END	
B	MC	9/6/22	ADJUSTED SLOT SPACING, CORRECTED PART DESCRIPTION	
A	MC	8/26/22	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**

**CLIENT:** VOLVO

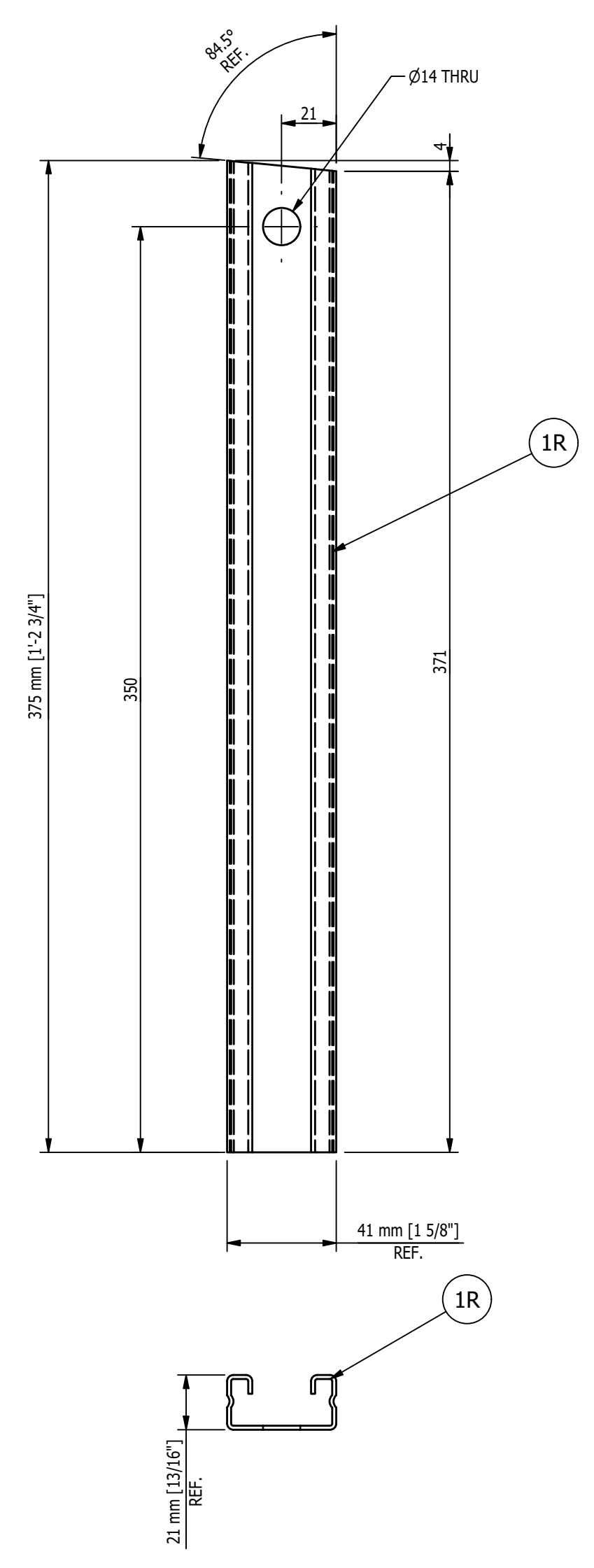
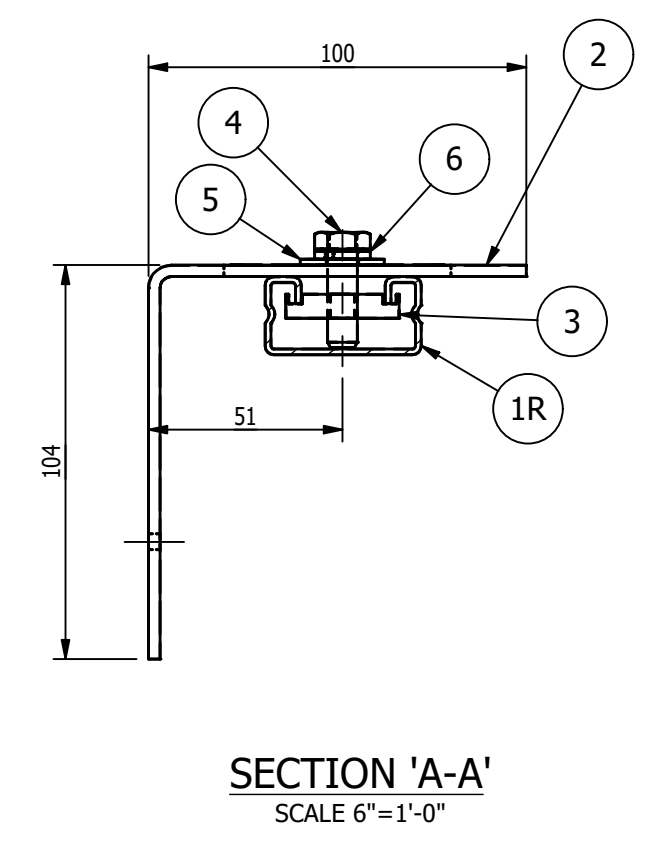
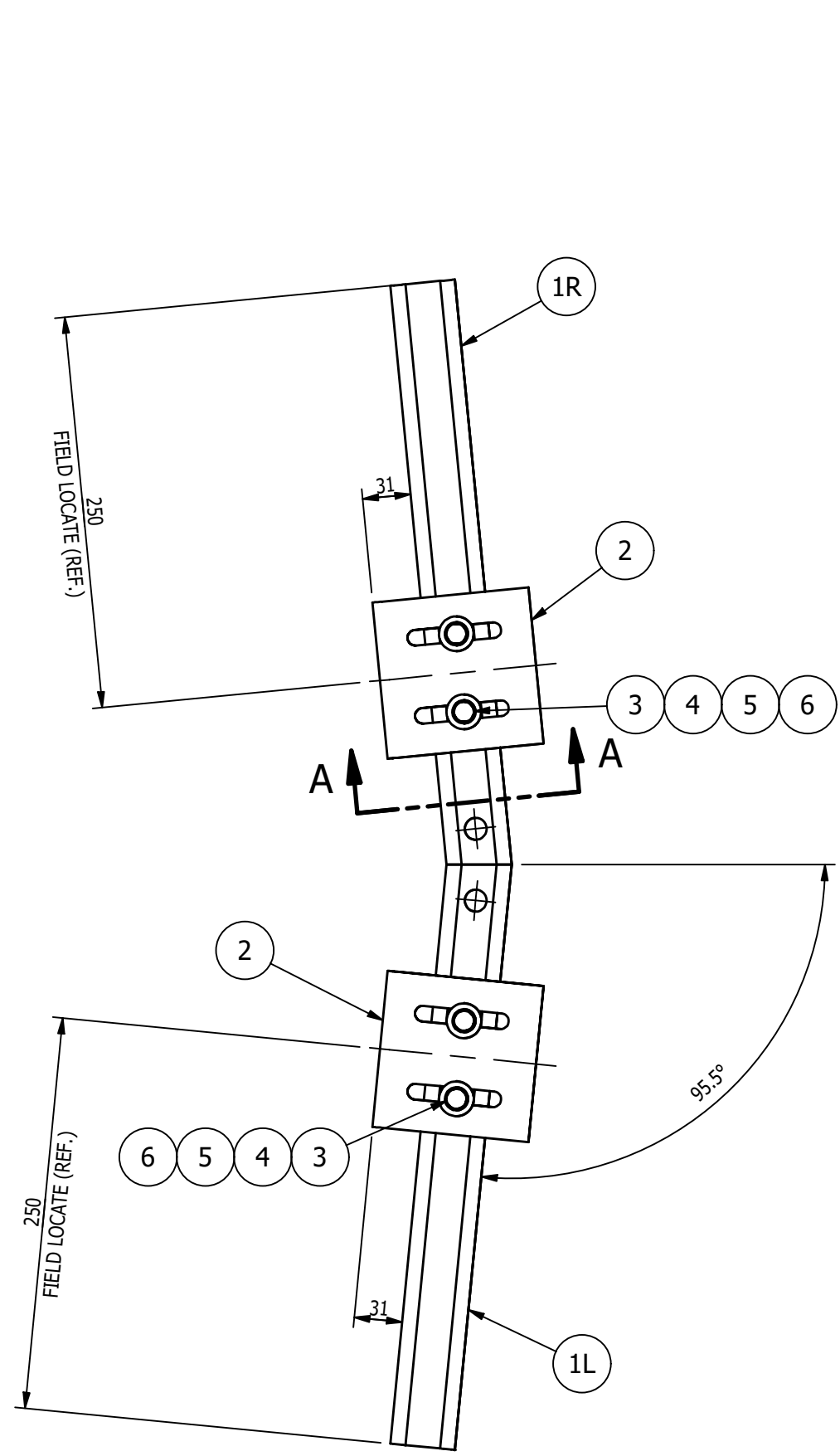
**DRAWING No.:** 1875D125

**REV:** C

**DRAWN BY:** RJB  
**CHECKED BY:** CW  
**DWG DATE:** 8/18/2022  
**JOB No.:** 22096

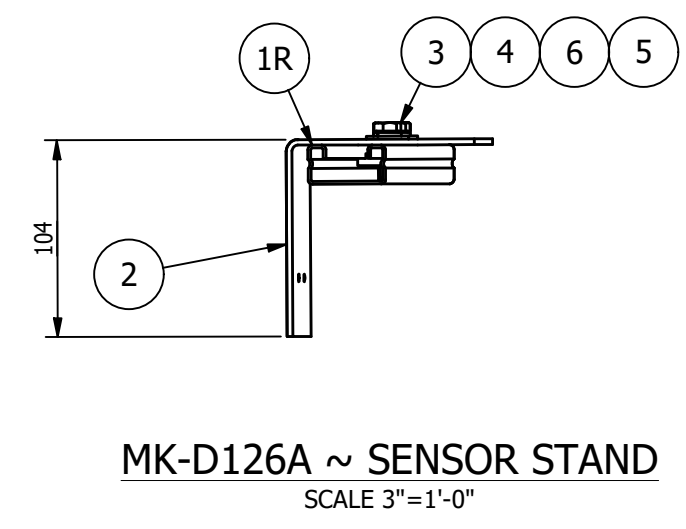


BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D126A			
1R	1	UNISTRUT P4000 ST	1'-2 3/4"		
1L	1	UNISTRUT P4000 ST	1'-2 3/4"		
2	2	MK-D034B ~ PROX BRACKET			
3	4	CHANNEL NUT FOR 5/16"-18, UNISTRUT P3007			
4	4	5/16-18UNC x 1" LG. HEX HEAD CAP SCREW			
5	4	5/16 TYPE B REGULAR FLAT WASHER			
6	4	5/16 SPRING LOCK WASHER			



- 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	8/26/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: RJB	
<b>MILLER INDUSTRIES</b> 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		CHECKED BY: CW DWG DATE: 8/18/22	
TITLE: <b>P6700 CONVEYORS CAMPUS BUILDING</b> CLIENT: <b>VOLVO</b>		JOB No: 22096	
DRAWING No. 1875D126		REV: A	

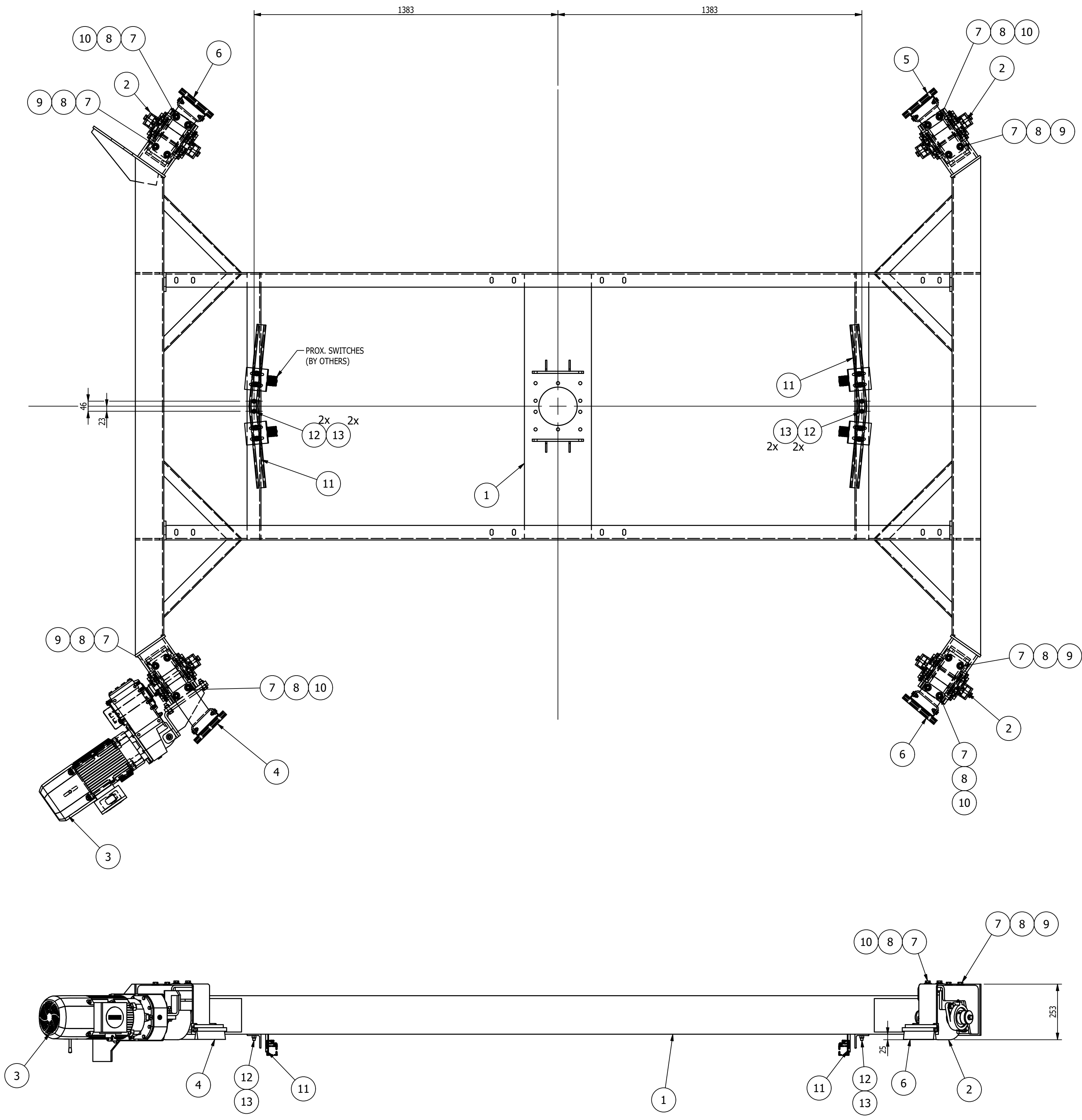
**MAGNUM Consulting**  
 41700 QuakerRoad Rd.  
 Suite 125  
 Novi, MI 48275  
 Phone: (248) 772-8822  
 Fax: (248) 772-8821  
 Web: www.mmagnum.com

MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 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

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-D127A			
1	1	MK-D128A ~ BASE FRAME WELDMENT			
2	3	MK-D020A ~ IDLER WHEEL ASSEMBLY			
3	1	MK-D021A ~ DRIVE WHEEL ASSEMBLY			
4	1	MK-D022A ~ DRIVE WHEEL TRACK BRUSH - LH			
5	1	MK-D022B ~ IDLE WHEEL TRACK BRUSH - LH			
6	2	MK-D022C ~ IDLE WHEEL TRACK BRUSH - RH			
7	16	1/2 SPRING LOCK WASHER			
8	16	1/2 TYPE B REGULAR FLAT WASHER			
9	8	1/2-13UNC x 1 1/2" LG. HEX HEAD CAP SCREW			
10	8	1/2-13UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
11	2	MK-D126A ~ SENSOR STAND			
12	4	M12x1.75 x 30mm LG. HEX CAP SCREW			
13	4	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-D127A ~ CENTER PIVOT TURNTABLE BASE FRAME ASSEMBLY  
 SCALE 1"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/6/22	GEOMETRY UPDATED PER ITEM '3'	
A	MC	8/26/22	FOR FABRICATION	

	<b>MILLER INDUSTRIES</b> 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>
	<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b> <b>CLIENT: VOLVO</b>	<b>DRAWN BY: RJB</b> <b>CHECKED BY: CW</b> <b>DWG DATE: 8/22/22</b>

**MAGNUM CONSULTING**  
 41100 Charleston Rd.  
 Suite 125  
 Novi, MI 48275  
 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.

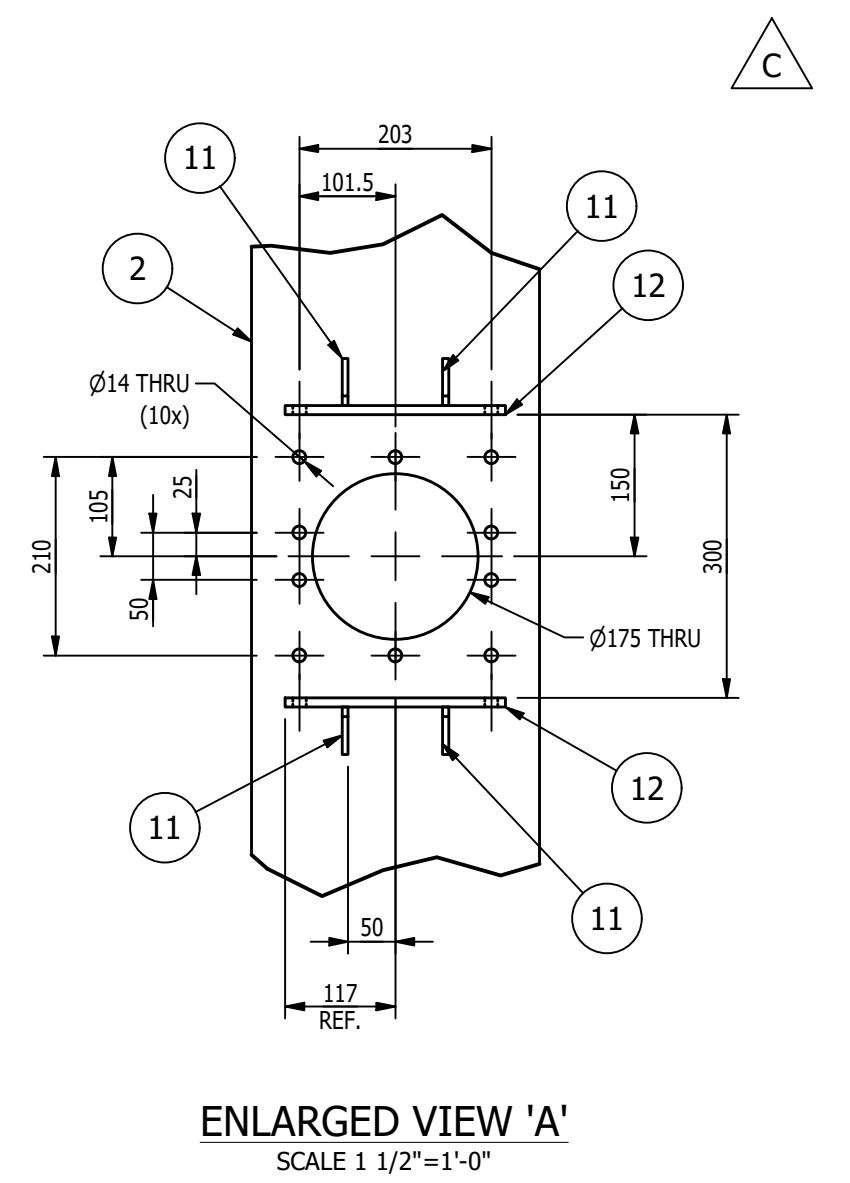
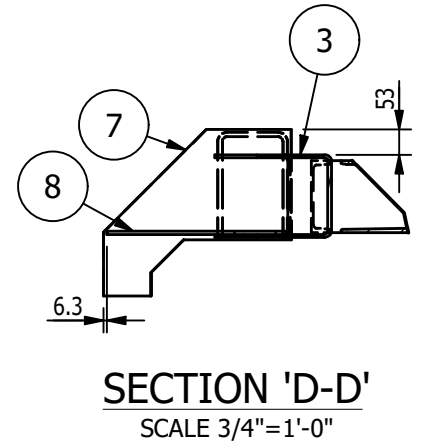
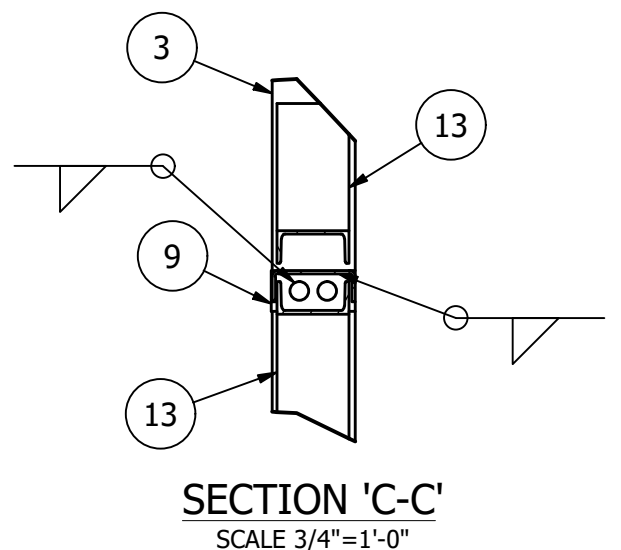
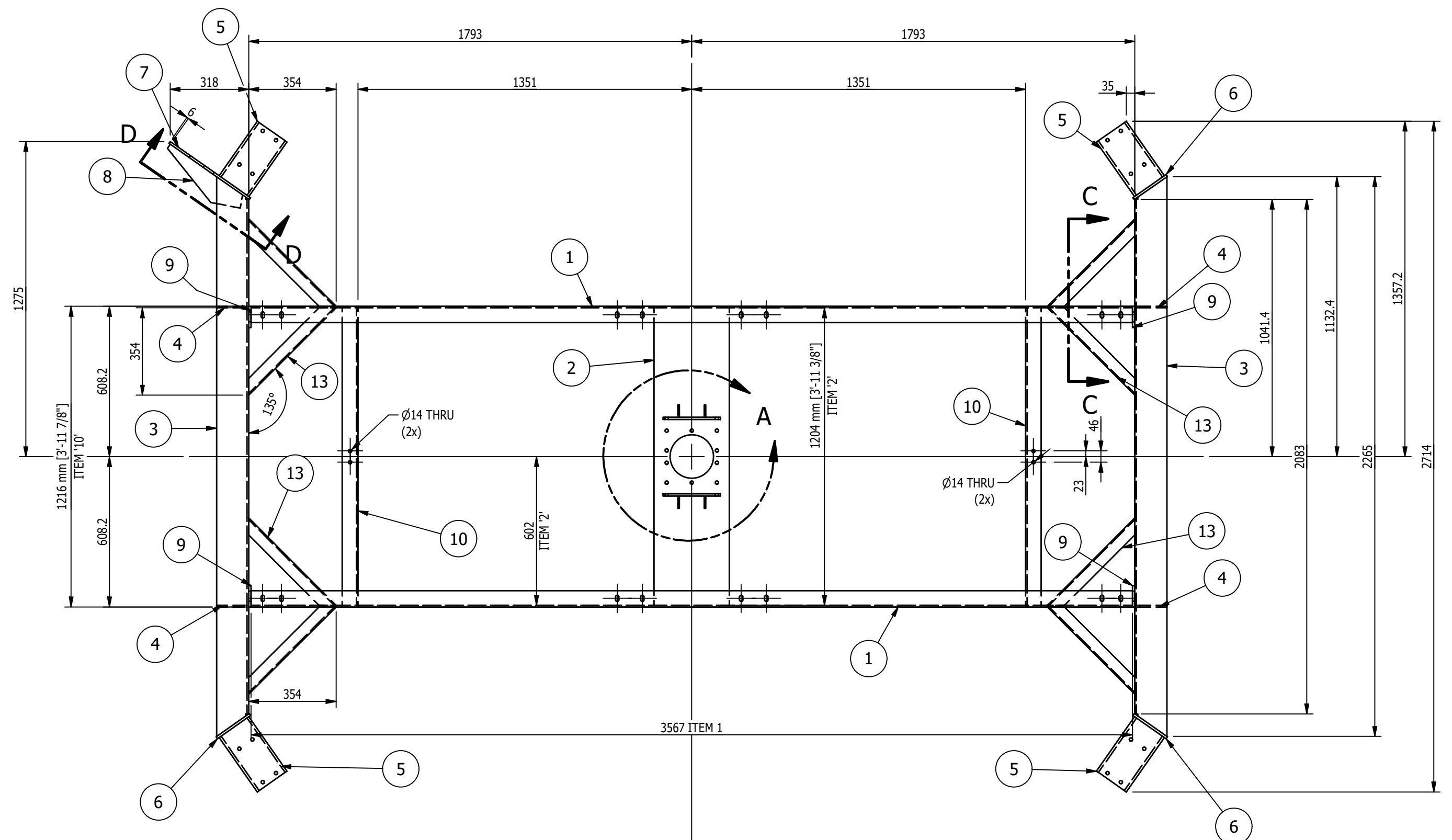
**WELDS:**  
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

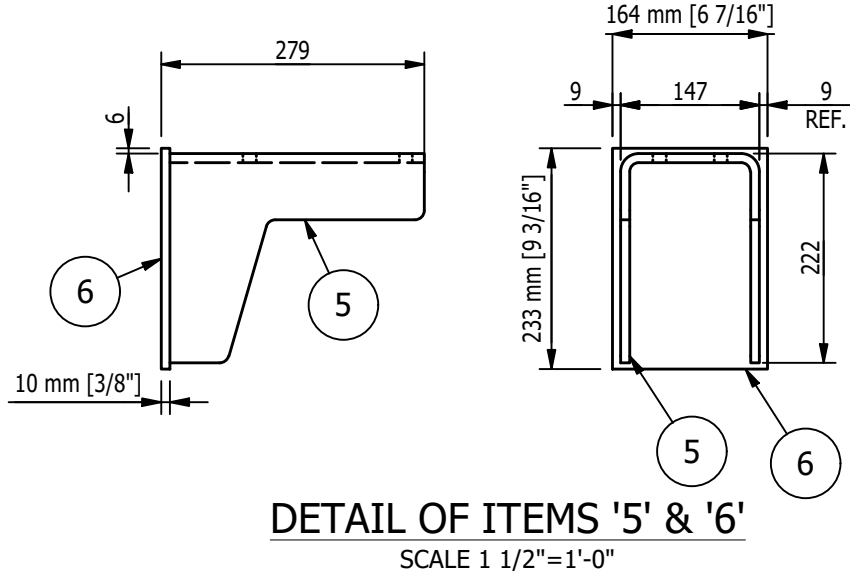
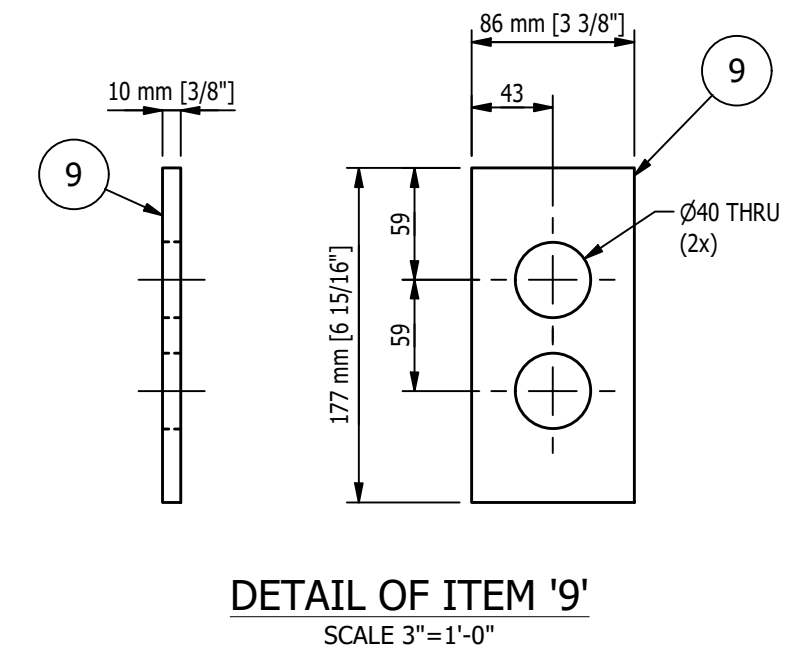
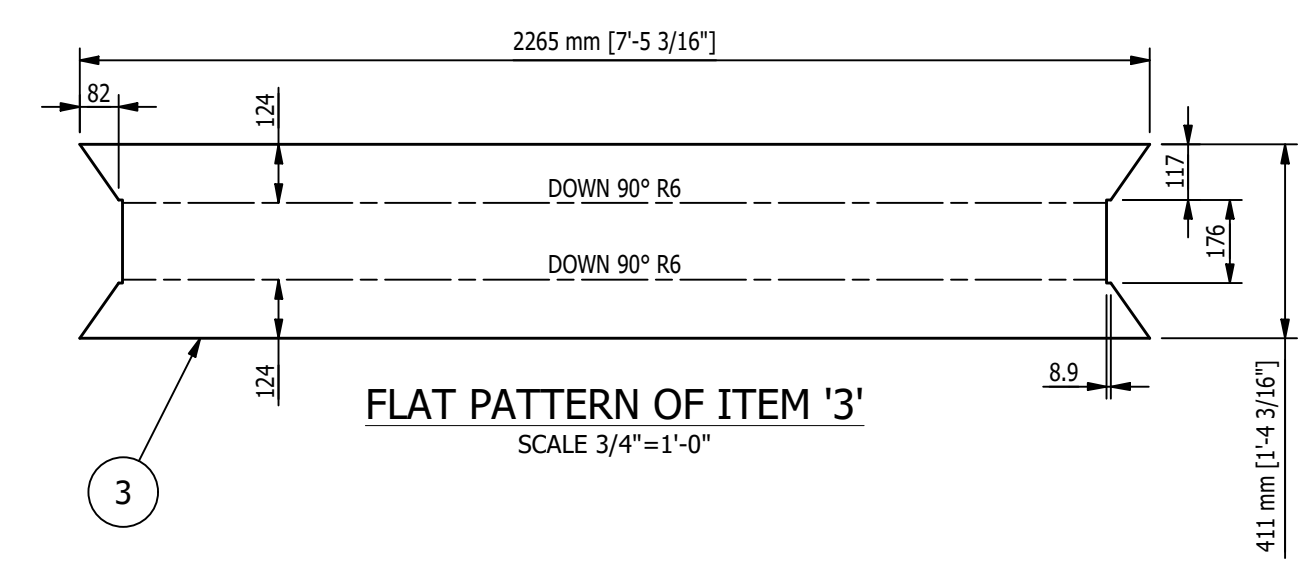
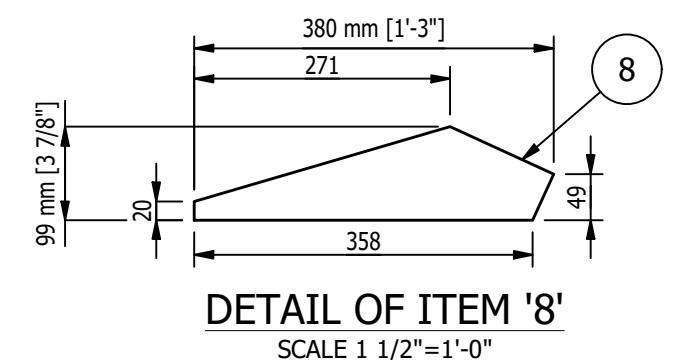
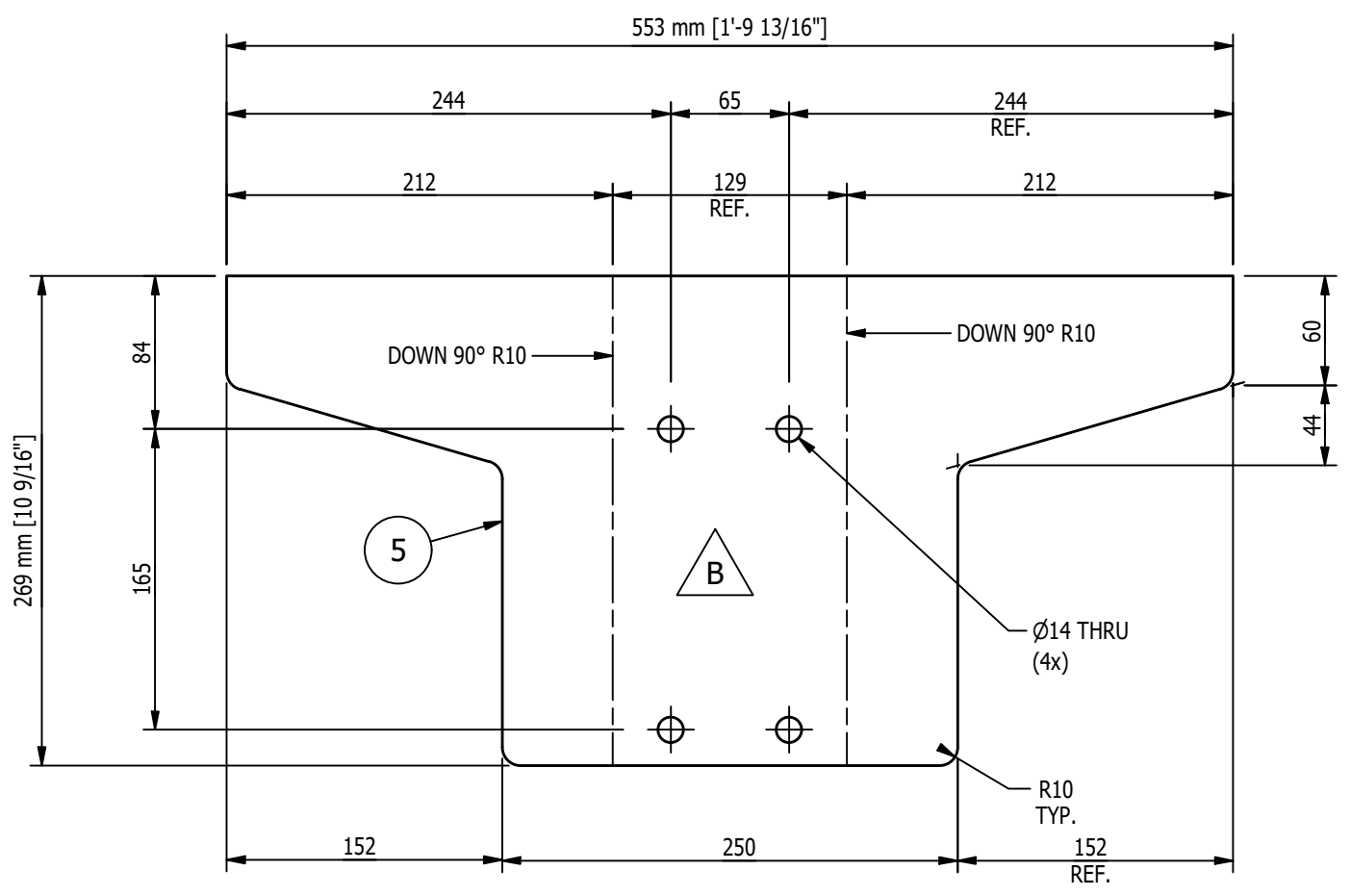
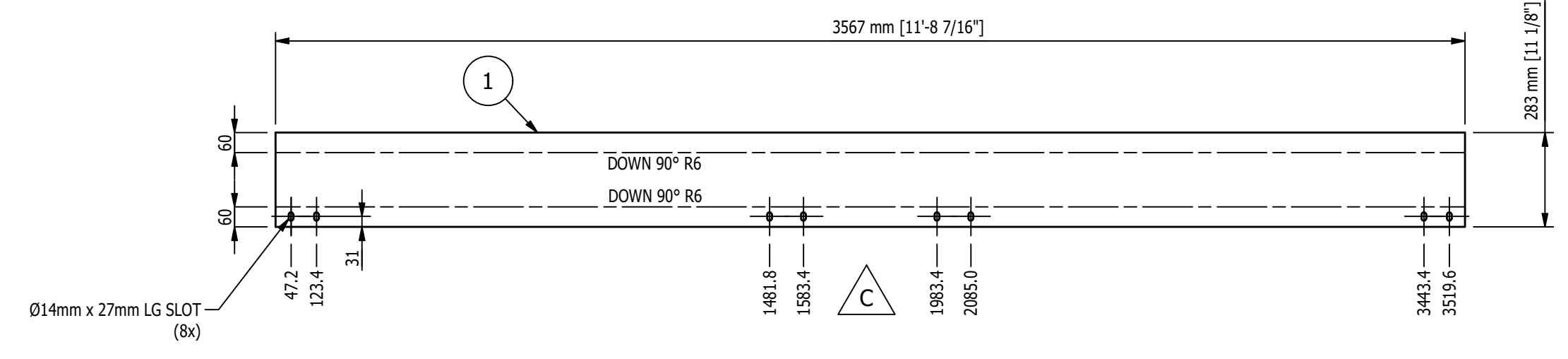
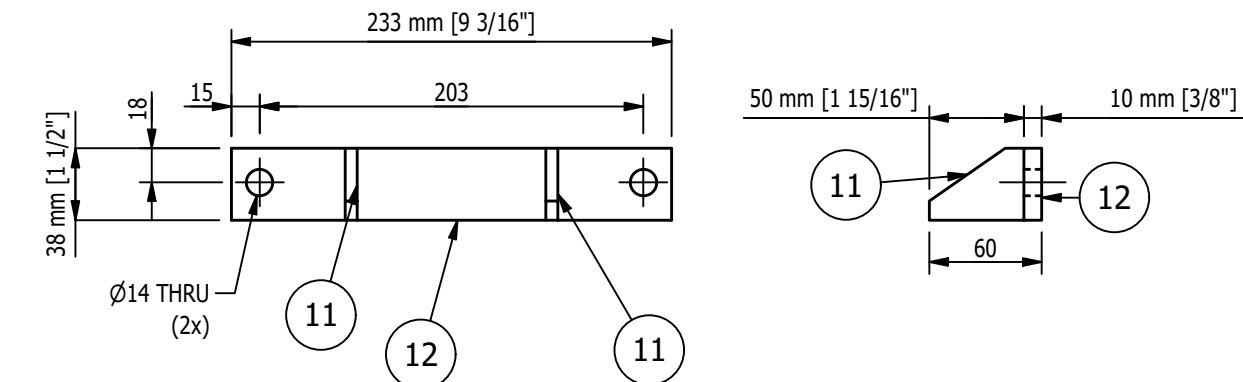
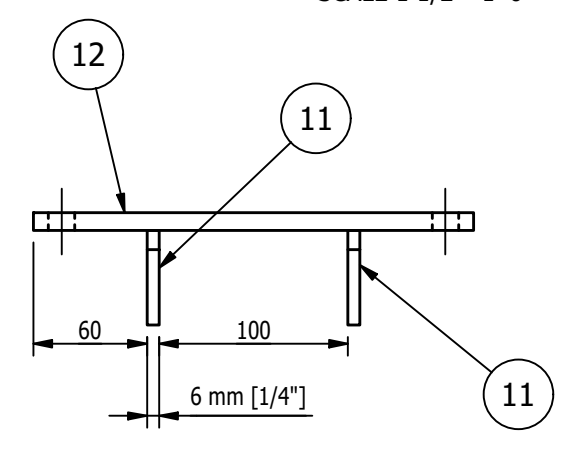
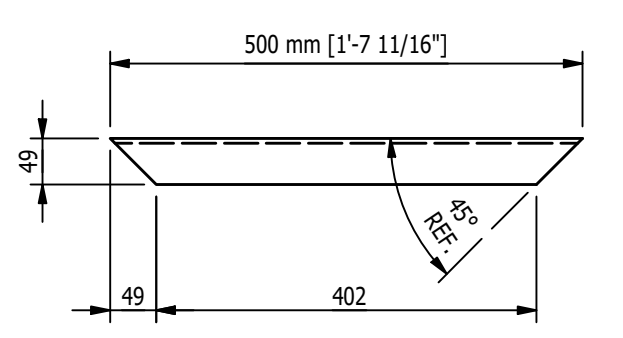
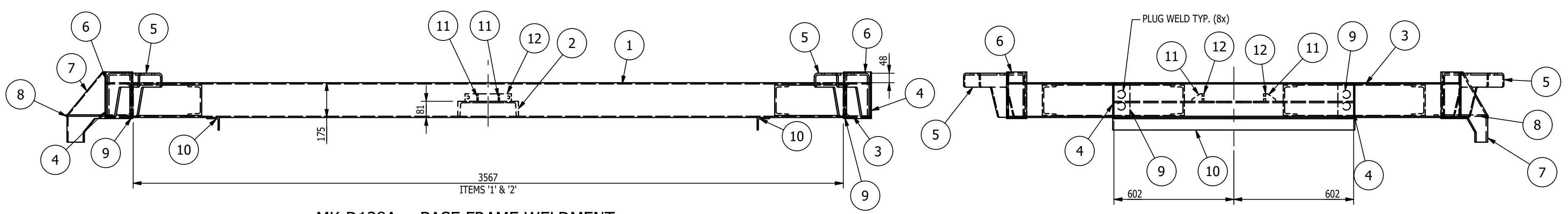
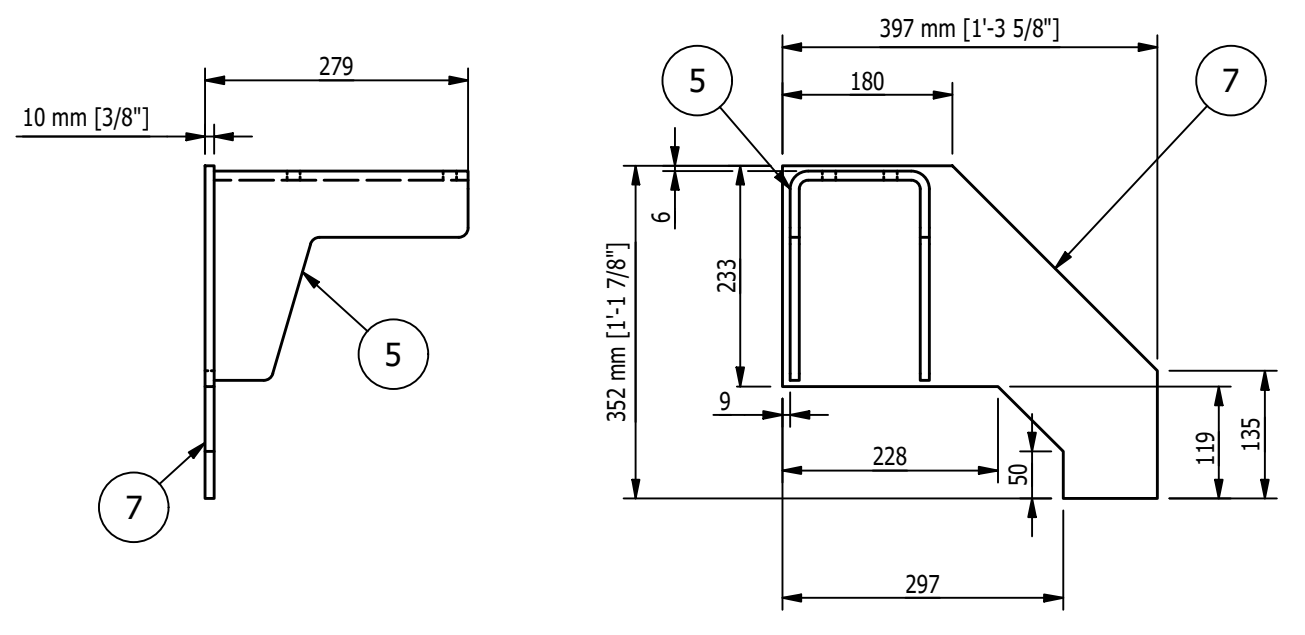
**COPIES:**  
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MAGNUM JOB #: 1875	MAGNUM DRAWING #: 1875D127	DRAWING No. 1875D127	REV: B	JOB No: 22096
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BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D128A			
1	2	PL 1/4 x 11 1/8	11'-8 7/16"		
2	1	C 12 x 20.7	3'-11 3/8"		
3	2	PL 1/4 x 16 3/16	7'-5 3/16"		
4	4	PL 1/4 x 4 7/8	6 5/16"		
5	4	PL 3/8 x 10 9/16	1'-9 13/16"		
6	3	PL 3/8 x 6 7/16	9 3/16"		
7	1	PL 3/8 x 13 7/8	1'-3 5/8"		
8	1	PL 1/4 x 3 7/8	1'-3"		
9	4	PL 3/8 x 3 3/8	6 15/16"		
10	2	L 2 1/2 x 2 1/2 x 1/4	3'-11 7/8"		
11	4	PL 1/4 x 1 1/2	1 15/16"		
12	2	PL 3/8 x 1 1/2	9 3/16"		
13	8	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

**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 Charleston Rd.  
 Suite 125  
 West, MI 48375  
 Phone: (248) 773-8888  
 Fax: (248) 773-8851  
 Web: www.mmagnum.com  
 MAGNUM JOB #: 1885  
 MAGNUM DRAWING #: 1875D128

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.

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/6/22	MATERIALS IN B.O.M. WERE BAR NOW PLATES. ADJUSTED DIMENSIONS ON FLAT PATTERN OF ITEM '1'	
B	MC	8/26/22	UPDATED CUT OUTS TO ITEM '5'	
A	MC	8/26/22	FOR FABRICATION	
REVISION HISTORY				

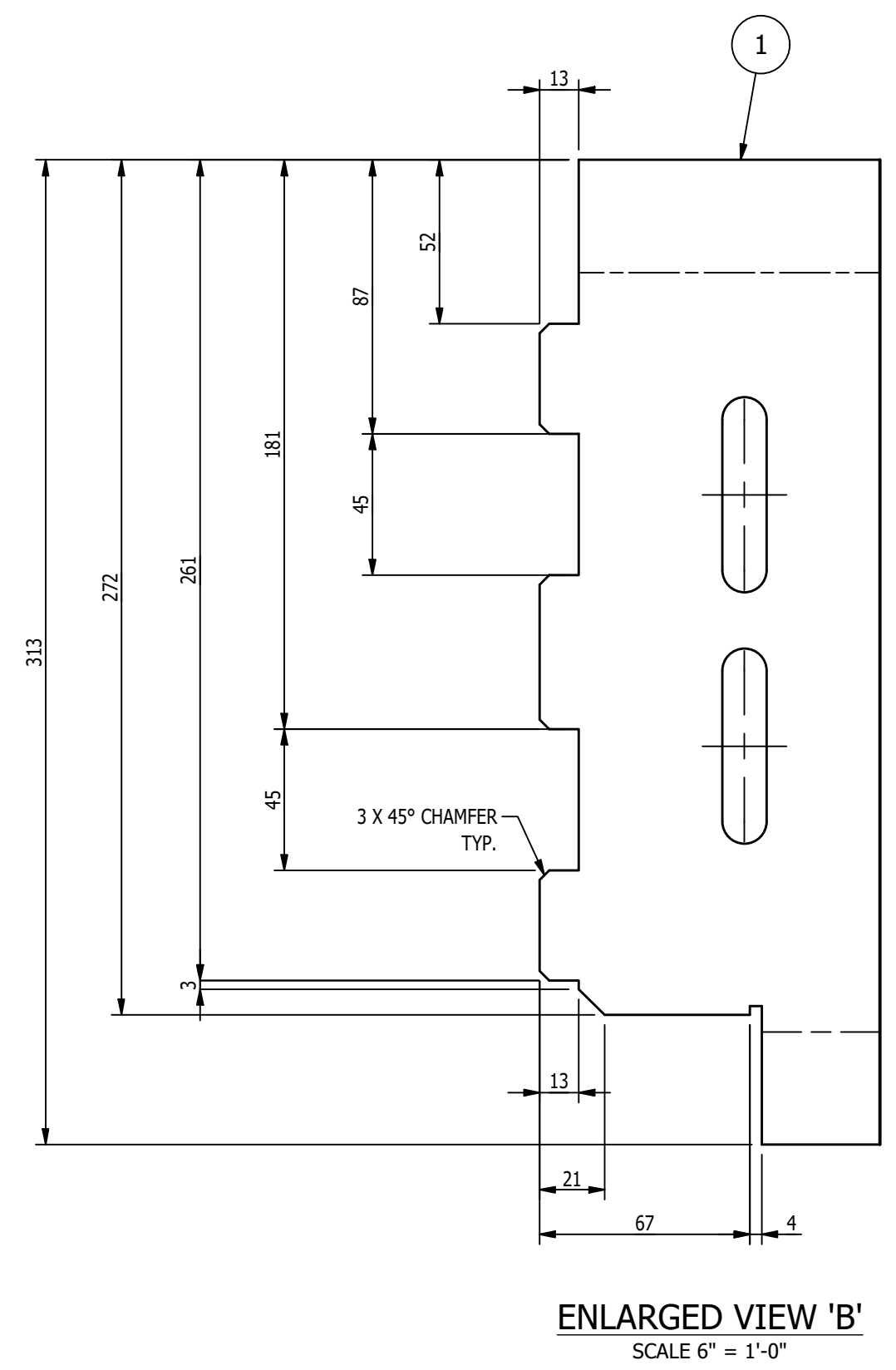
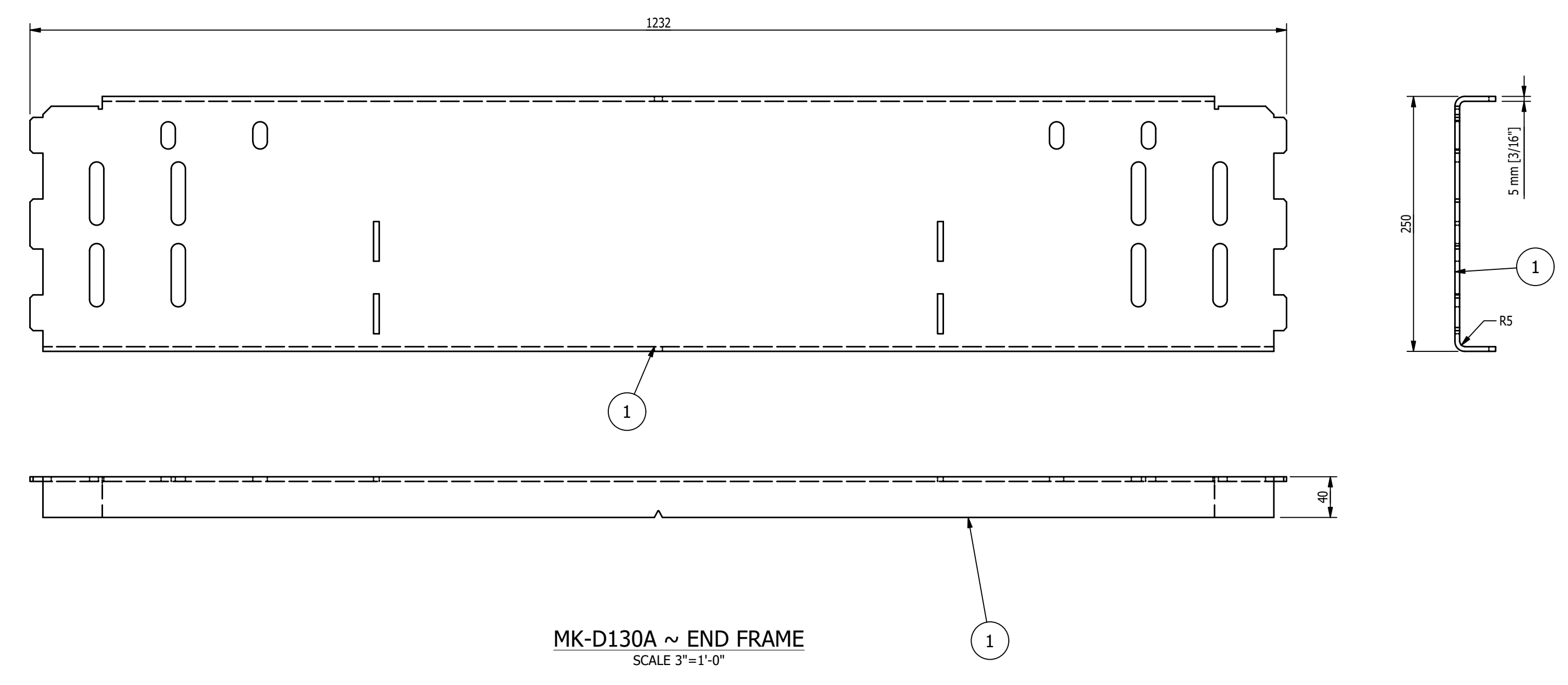
**MILLER INDUSTRIES**  
 3070 W. THOMPSON RD.  
 FENTON, MI 48430  
 PH: 810.373.0322 FAX: 810.373.0326  
 www.millic.com

**TITLE:** P6700 CONVEYORS CAMPUS BUILDING  
**CLIENT:** VOLVO  
**DRAWING No.:** 1875D128  
**REV:** C

**DRAWN BY:** RJB  
**CHECKED BY:** CW  
**DWG DATE:** 8/22/22  
**JOB No.:** 22096

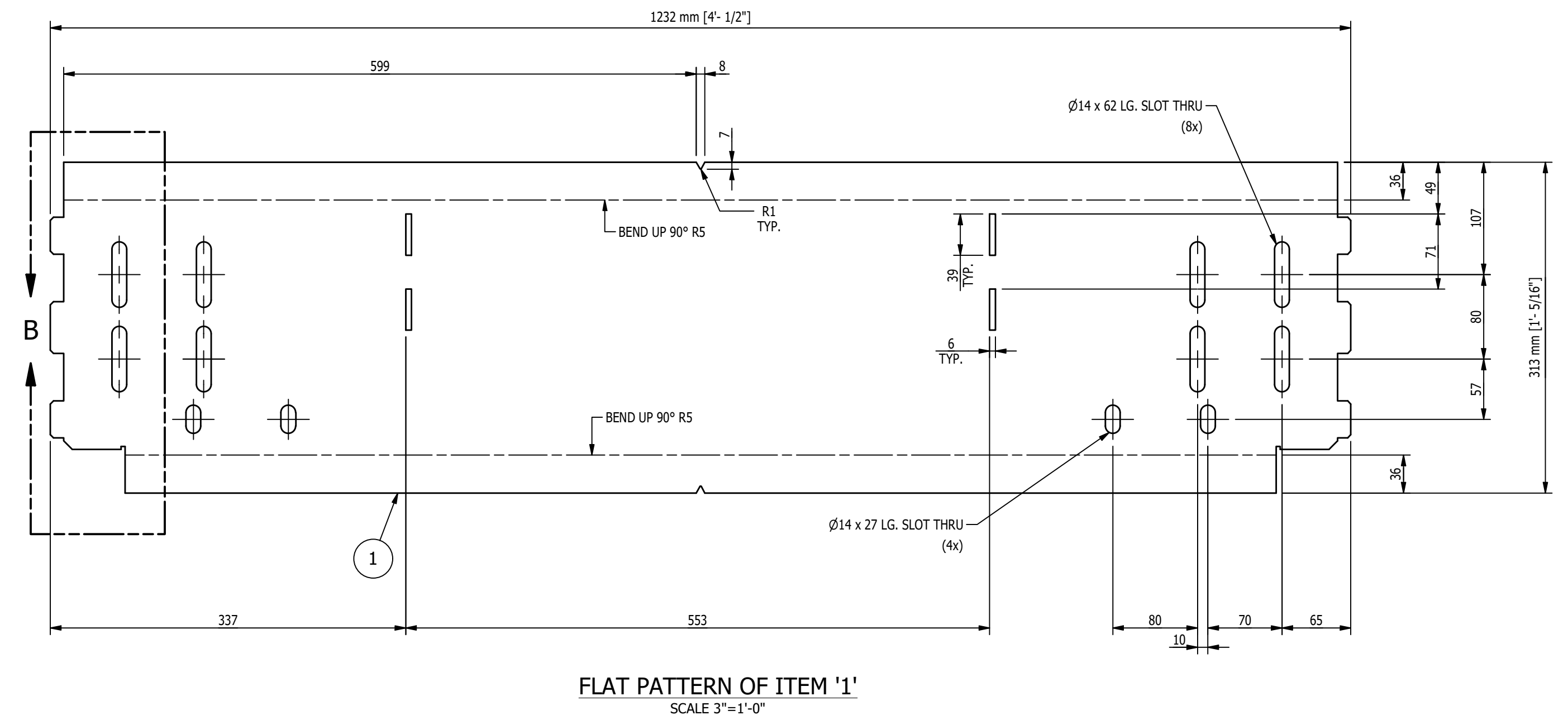


BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D130A			
1	1	PL 3/16 x 1'- 5/16"	4'- 1/2"		



- 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 AFTER WELDING



**MAGNUM CONSULTING**  
41100 Charleston Rd.  
Suite 125  
North, MI 48435  
Phone: (248) 772-8832  
Fax: (248) 772-8851  
Web: www.mmagnum.com  
MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D130

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

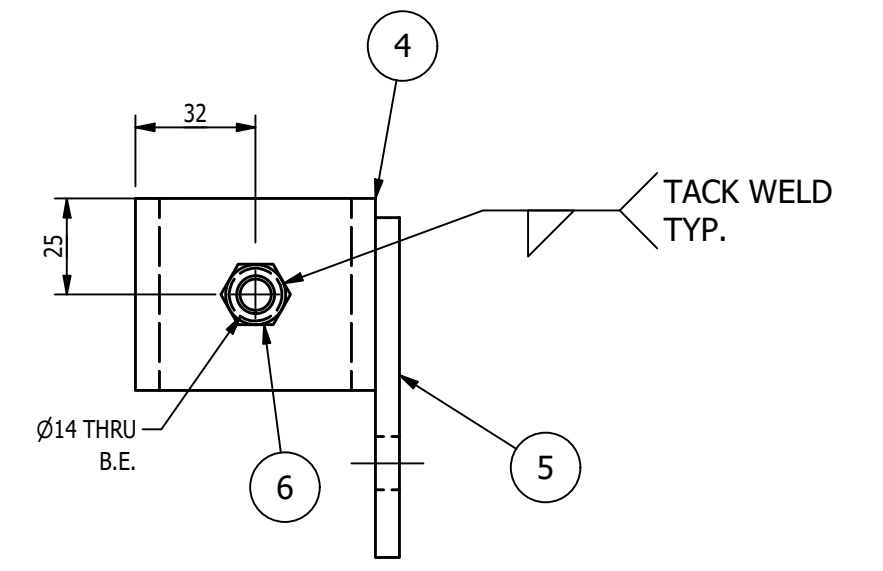
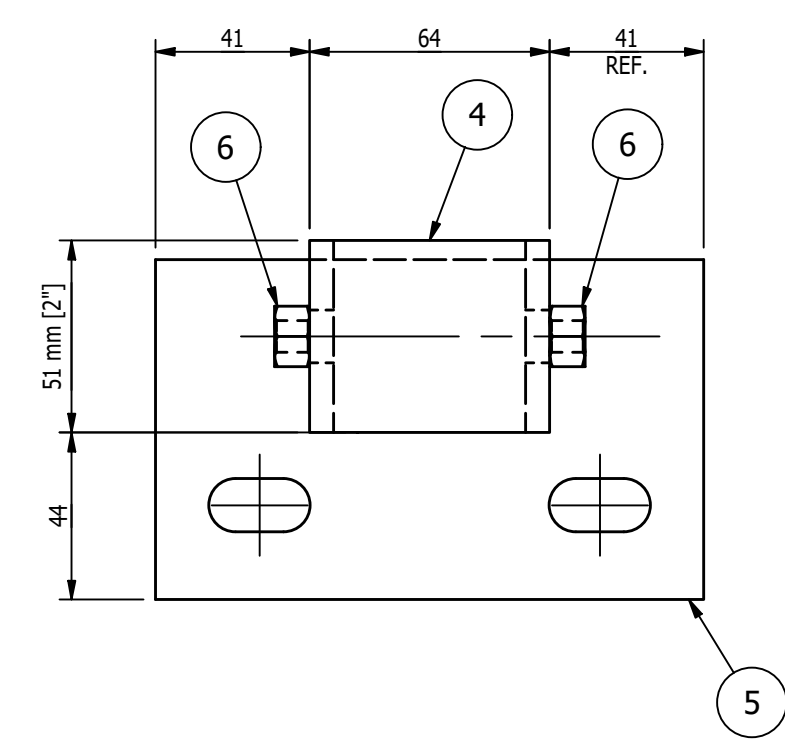
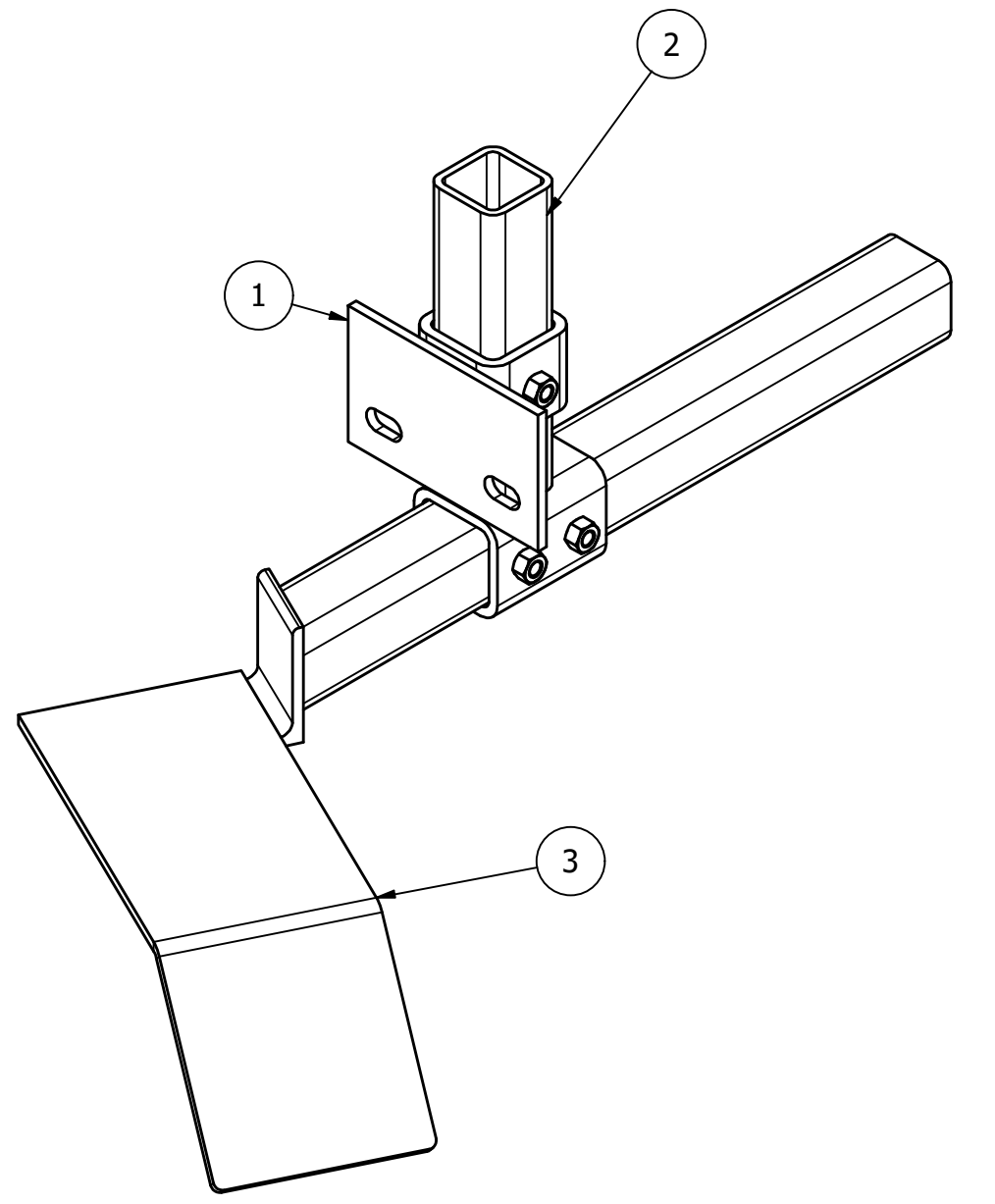
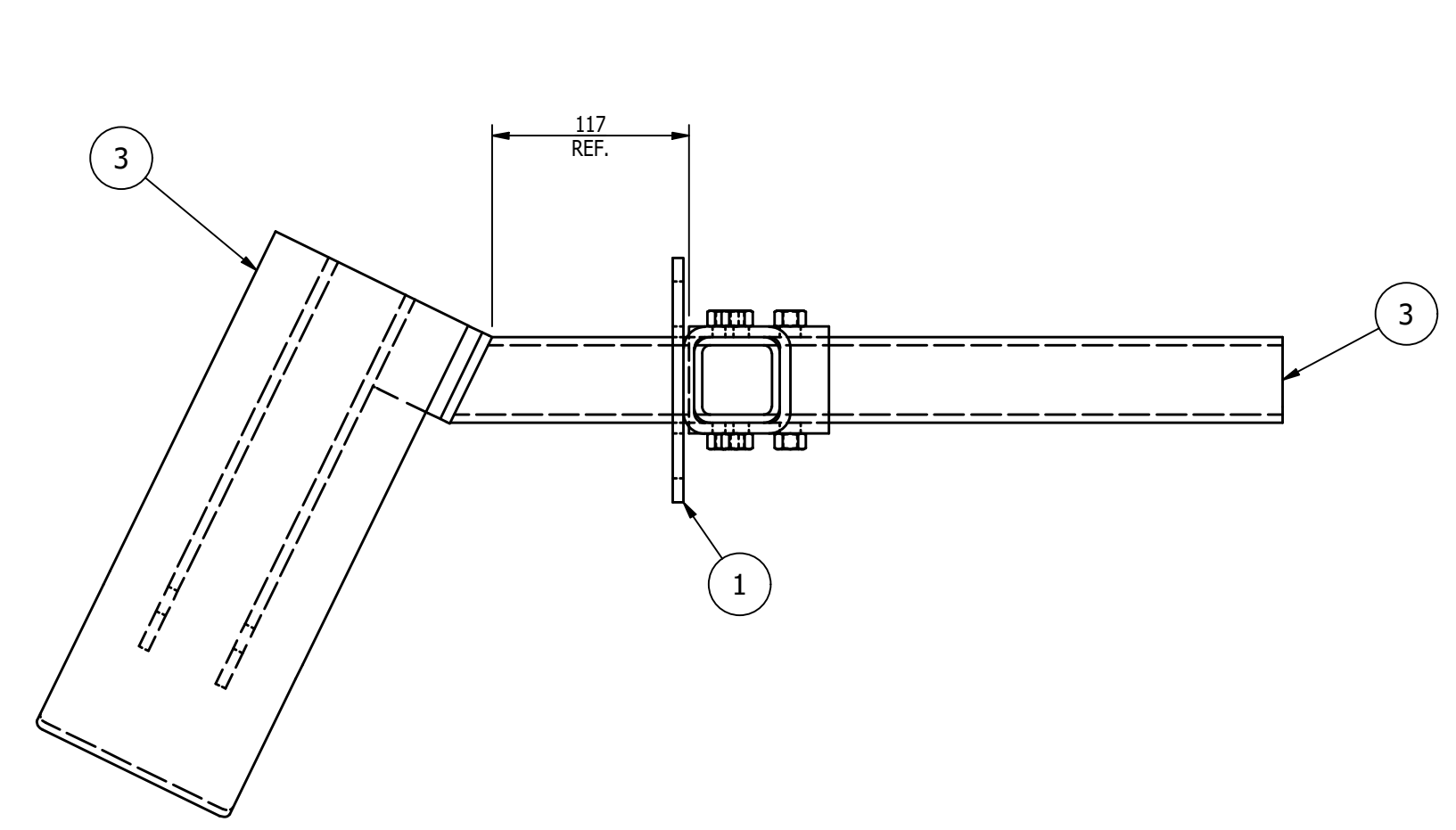
**GENERAL NOTES:**  
MATERIALS:  
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.  
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.  
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.  
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.  
HOLES:  
- ALL HOLES ARE 13/16" DIA. U.N.O.  
- ALL BOLTED CONNECTIONS 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
A	MC	8/26/22	FOR FABRICATION	
REVISION HISTORY				

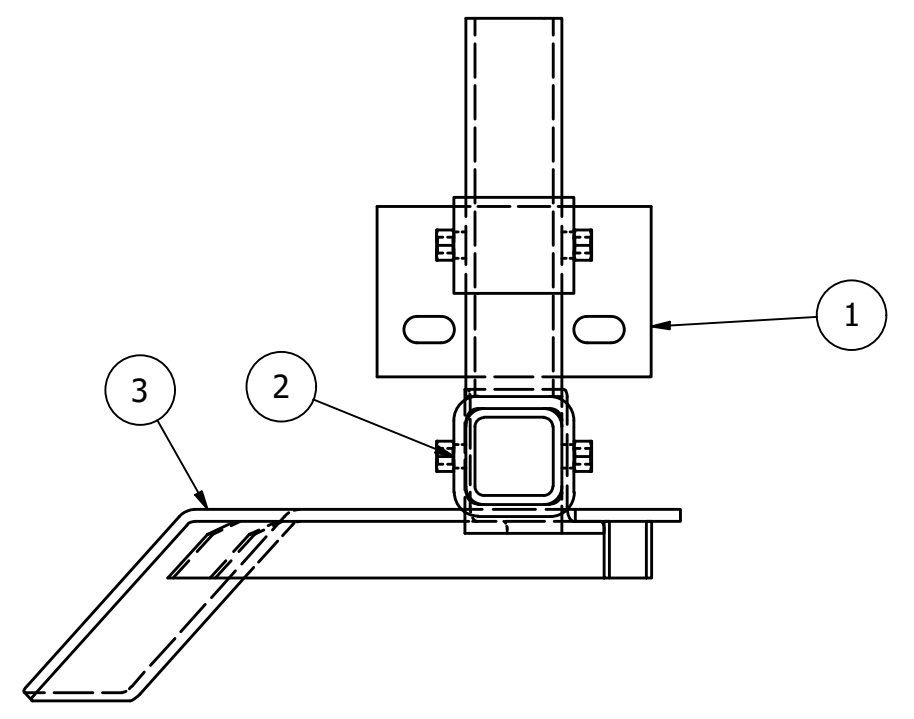
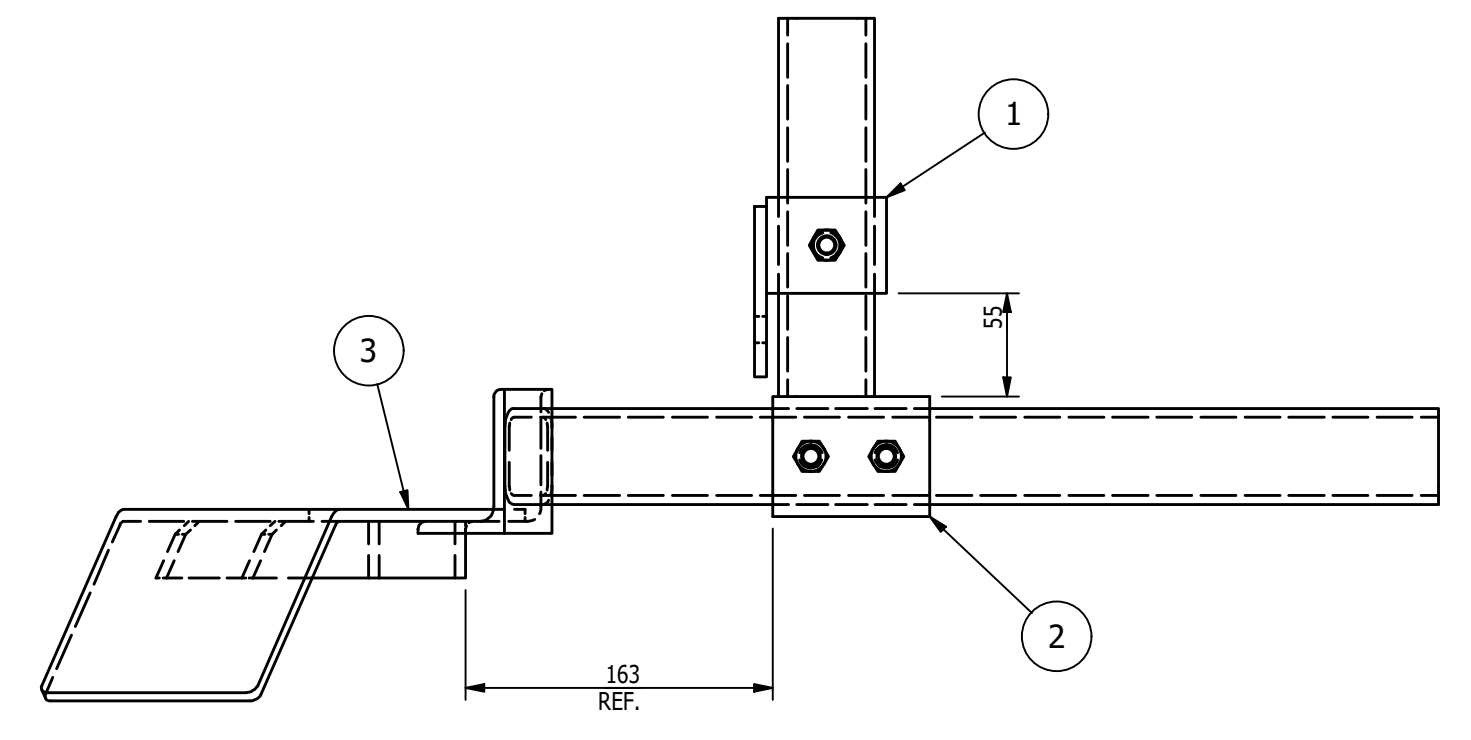
<p><b>MILLER INDUSTRIES</b> 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com</p>	<p><b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b></p> <p><b>CLIENT: VOLVO</b></p> <p><b>DRAWING No. 1875D130</b></p>	<p><b>DRAWN BY: RJB</b></p> <p><b>CHECKED BY: CW</b></p> <p><b>DWG DATE: 8/22/22</b></p>

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D131A			
1	1	MK-D131B ~ ATTACHMENT BASE			
2	1	MK-D050B ~ UPPER ADJUSTMENT			
3	1	MK-D050D ~ LOWER ADJUSTMENT			
		MK-D131B			
4	1	TS 2 1/2 x 2 1/2 x 7 GA.	2"		
5	1	PL 1/4 x 3 9/16"	5 11/16"		
6	2	M10 x 1.5 HEX NUT			

**NOTE:**  
FOR EXACT POSITION OF MK-D052A,  
REFER TO LAYOUTS



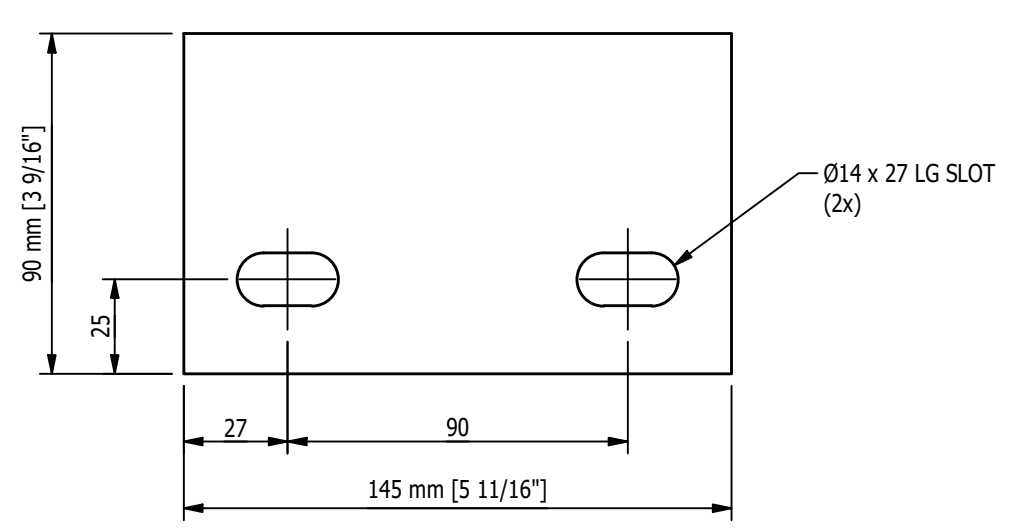
**MK-D131B ~ ATTACHMENT BASE**  
SCALE 6"=1'-0"



**MK-D131A ~ STOP TRIGGER**  
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 WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.



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

REV	BY	DATE	DESCRIPTION	APP
A	MC	9/14/22	FOR FABRICATION	

	<b>MILLER INDUSTRIES</b> 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.
	<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b> <b>CLIENT: VOLVO</b>	<b>DRAWN BY: RJB</b> <b>CHECKED BY: CW</b> <b>DWG DATE: 8/22/22</b>

<b>DRAWING No. 1875D131</b>	<b>REV: A</b>	<b>JOB No: 22096</b>
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**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 #: 1875D131

**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)

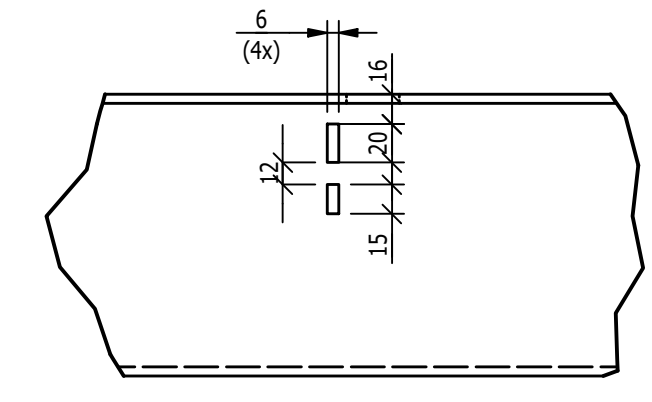
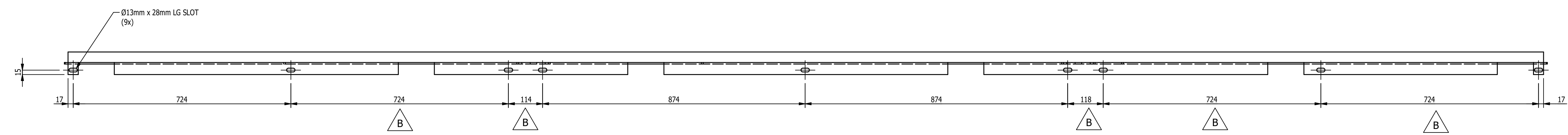
**PAINT:**

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

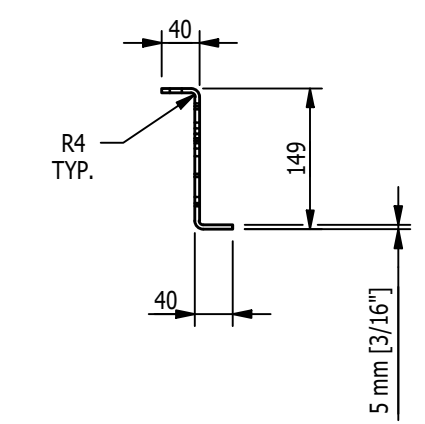
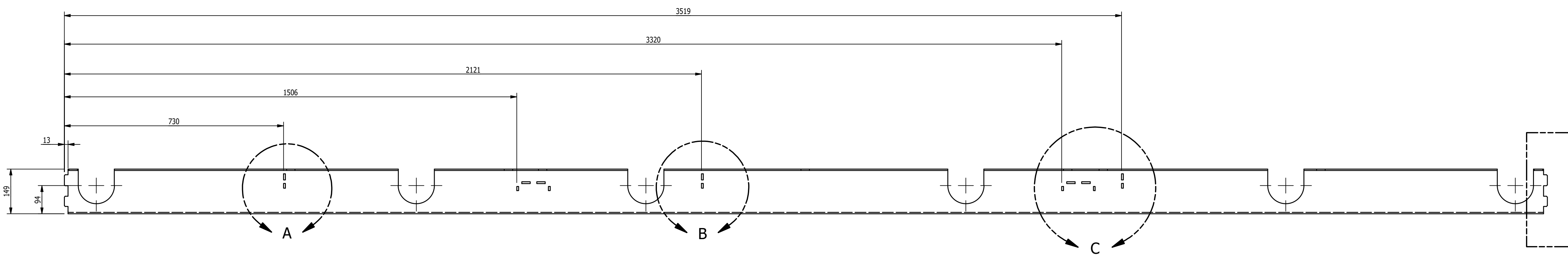
**COPIES:**

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

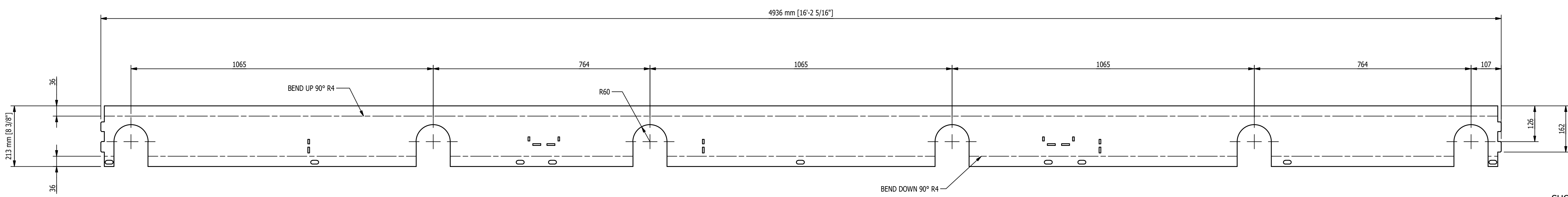
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D132A			
		PL 3/16 x 8 3/8"	16'-2 5/16"		



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



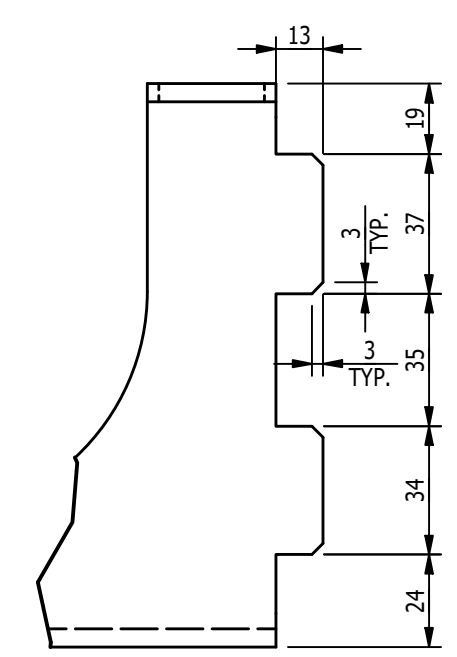
MK-D132A ~ MID FRAME  
SCALE 1 1/2"=1'-0"



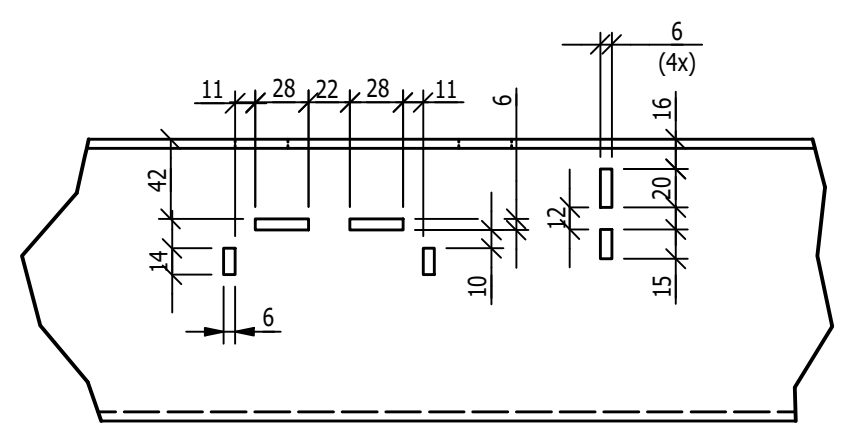
FLAT PATTERN OF ITEM '1'  
SCALE 1 1/2"=1'-0"

- 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.

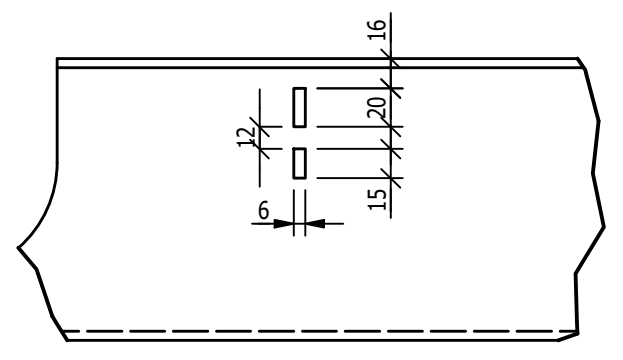
- PAINT NOTES:**  
PAINT AFTER WELDING



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



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



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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/6/22	DIMENSIONS AND SLOT LOCATIONS UPDATED	
A	MC	8/26/22	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.

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

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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D132	DWG DATE:	8/19/22
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.m4magnum.com

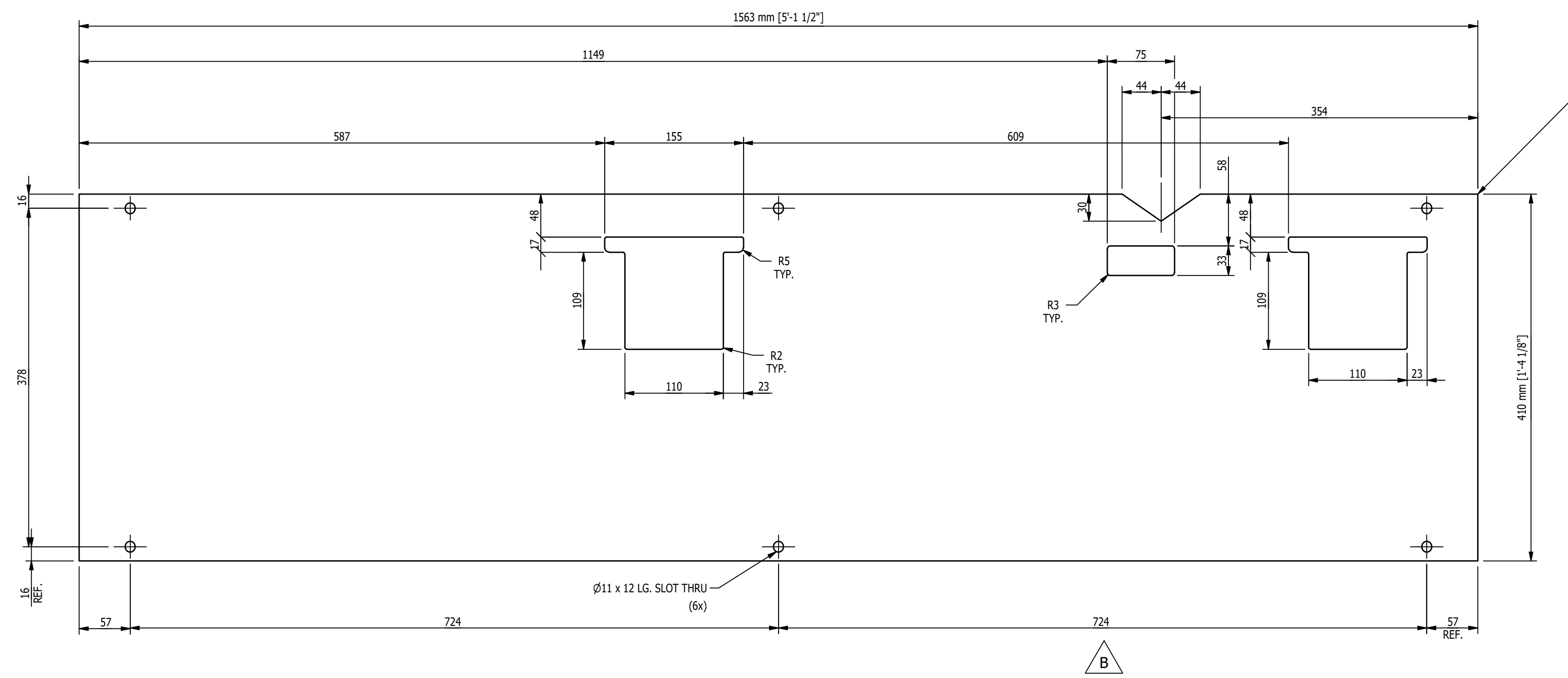
MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D132

**UNLESS OTHERWISE NOTED:**

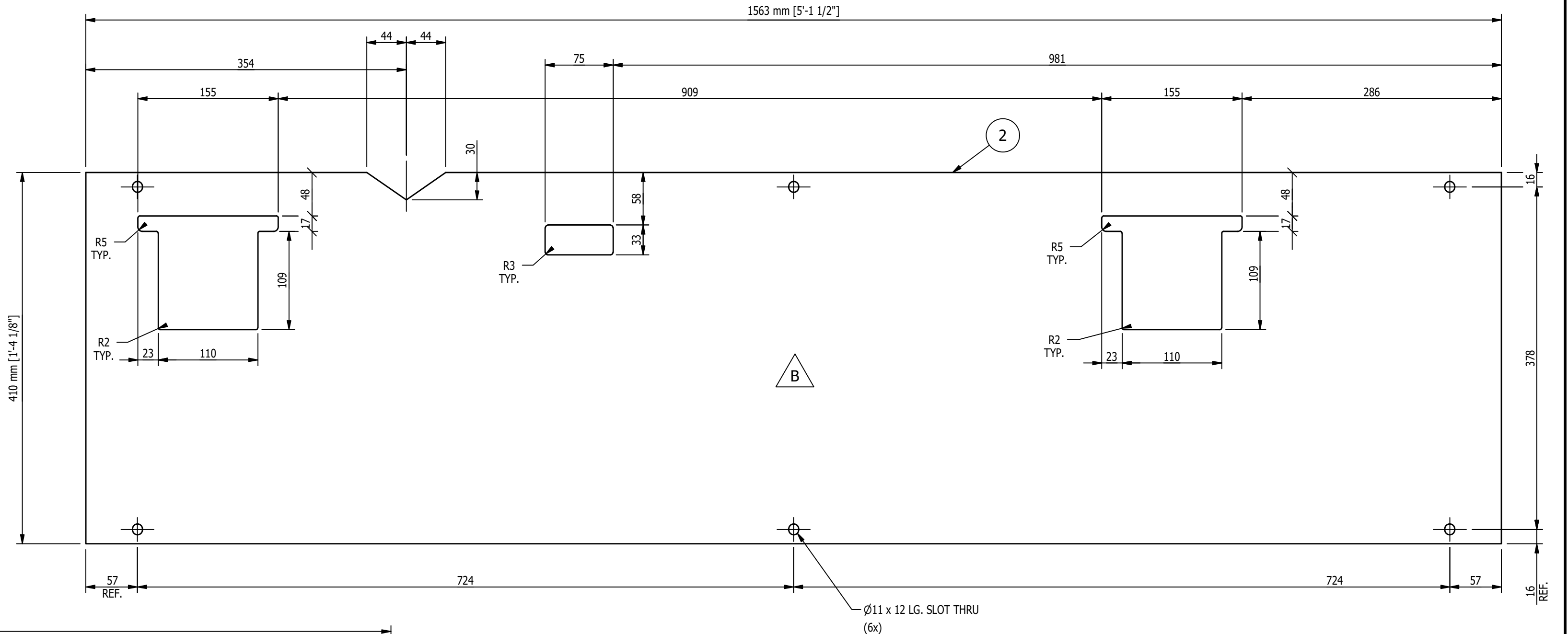
- X = ±.060
- XX = ±.030
- XXX = ±.005

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

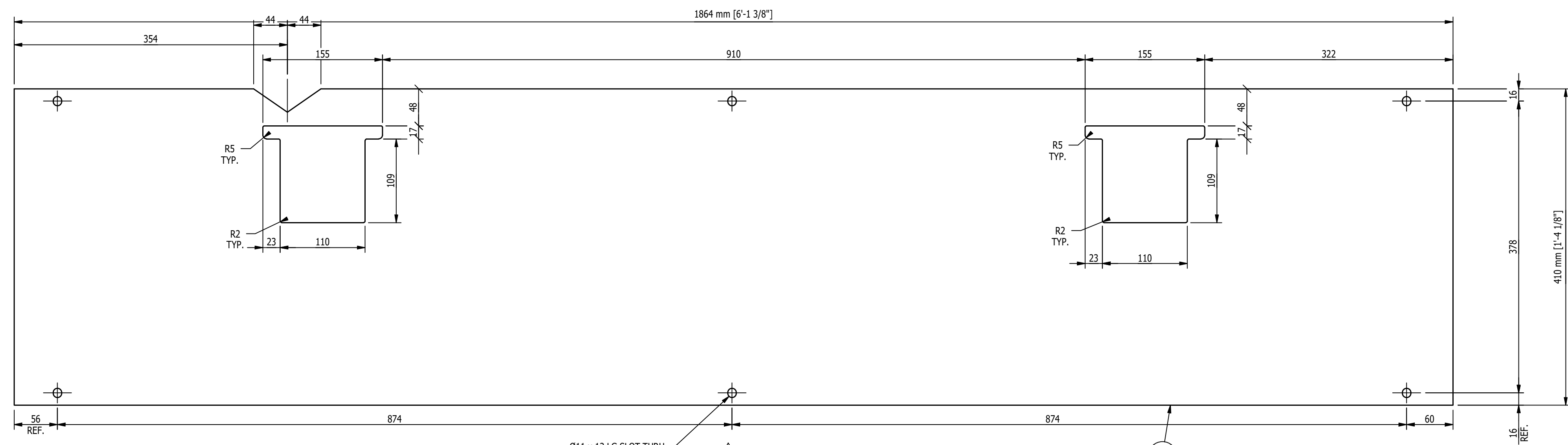




MK-D133A ~ END COVER PLATE  
SCALE 3"=1'-0"



MK-D133B ~ END COVER PLATE  
SCALE 3"=1'-0"



MK-D133C ~ MID COVER PLATE  
SCALE 3"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D133A			
1	1	SHT 11 GA x 1'-4 1/8"	5'-1 1/2"		
		MK-D133B			
2	1	SHT 11 GA x 1'-4 1/8"	5'-1 1/2"		
		MK-D133C			
3	1	SHT 11 GA x 1'-4 1/8"	6'-1 3/8"		

- 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	9/6/22	ADDED ITEM MK-D133C, FLIPPED MK-D133B, & ADJUSTED SLOT LOCATIONS ON ALL END COVER PLATES	
A	MC	8/26/22	FOR FABRICATION	

REVISION HISTORY



**MILLER INDUSTRIES**  
3070 W. THOMPSON RD.  
FENTON, MI 48430  
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TITLE: <b>P6700 CONVEYORS CAMPUS BUILDING</b>	DRAWN BY: <b>RJB</b>
CLIENT: <b>VOLVO</b>	CHECKED BY: <b>CW</b>
DRAWING No. <b>1875D133</b>	DWG DATE: <b>8/19/22</b>
REV: <b>B</b>	JOB No: <b>22096</b>

**MAGNUM CONSULTING**  
41100 Charleston Rd.  
Suite 125  
West, MI 48375  
Phone: (248) 373-8833  
Fax: (248) 373-8831  
Web: www.m4magnum.com  
MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D133

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.

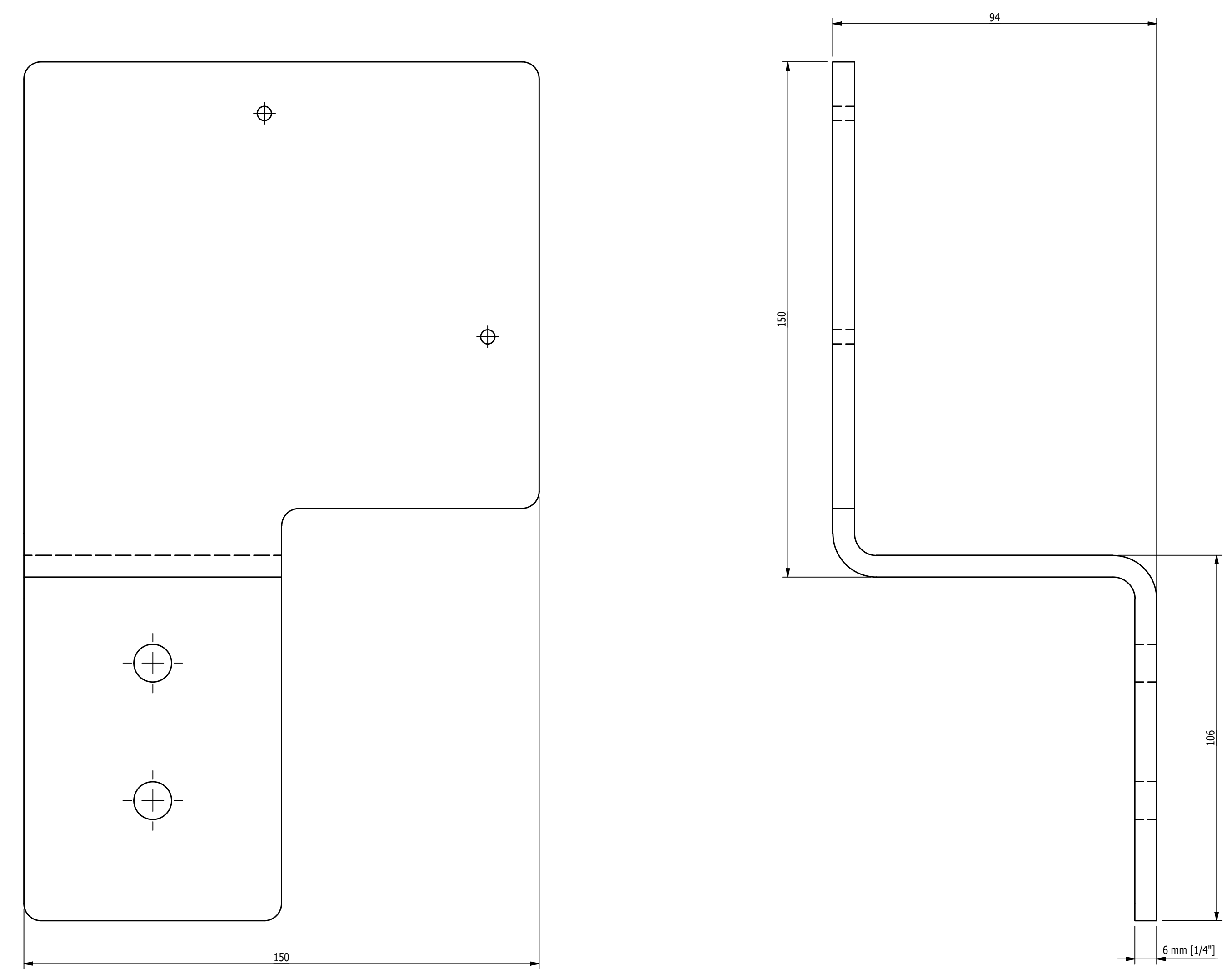
**HOLES:**  
- ALL HOLES ARE 13/16" DIA. U.N.O.  
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

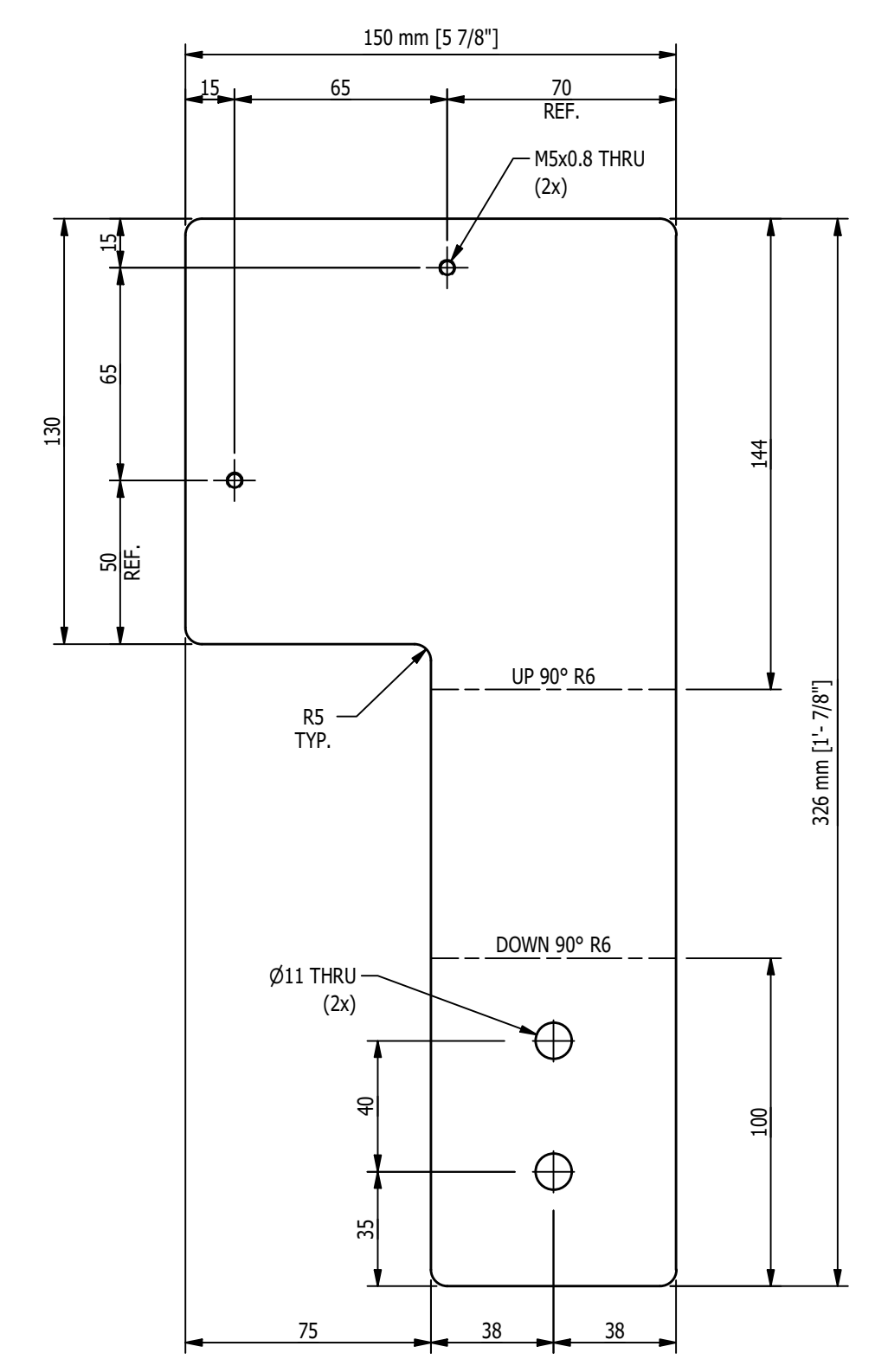
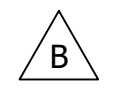
**PAINT:**  
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	PL 1/4 x 5 7/8	1'- 7/8"		



MK-D134A ~ RF CODE READER BRACKET  
SCALE 1'-0" = 1'-0"



FLAT PATTERN OF ITEM '1'  
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	9/6/22	DESCRIPTION UPDATED	
A	MC	8/26/22	FOR FABRICATION	

REVISION HISTORY

**MAGNUM CONSULTING**  
41100 Charleston Rd  
Suite 125  
North, MI 48315  
Phone: (248) 773-8833  
Fax: (248) 773-8851  
Web: www.mmagnum.com

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D134

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.

**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.:** 1875D134  
**REV:** B

**DRAWN BY:** AH  
**CHECKED BY:** CW  
**DWG DATE:** 8/19/22  
**JOB No.:** 22096