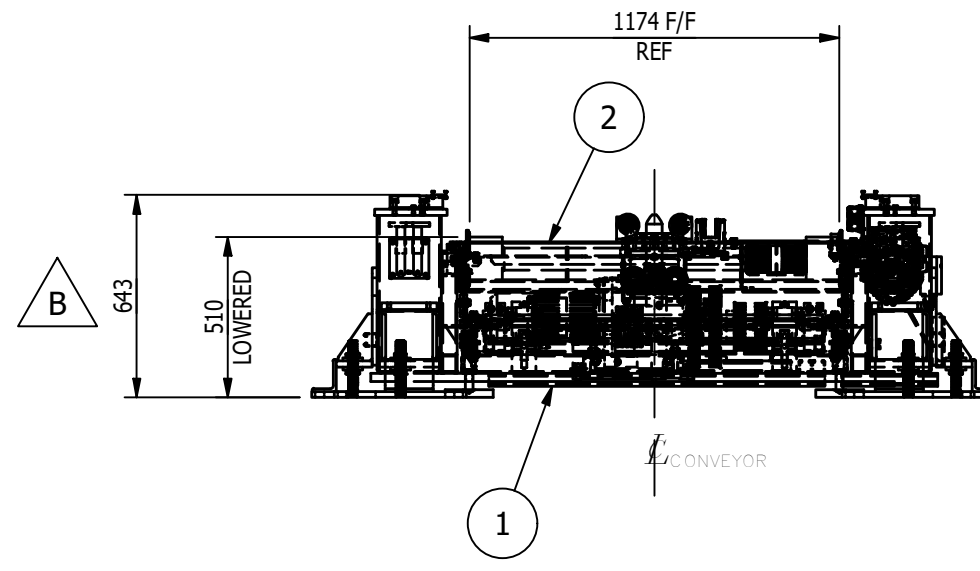
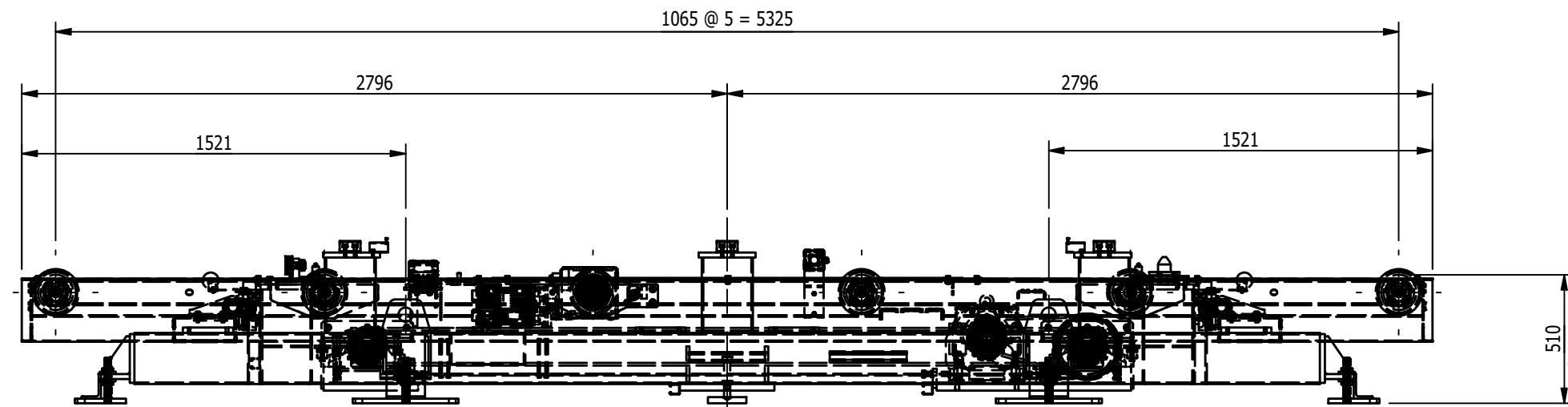
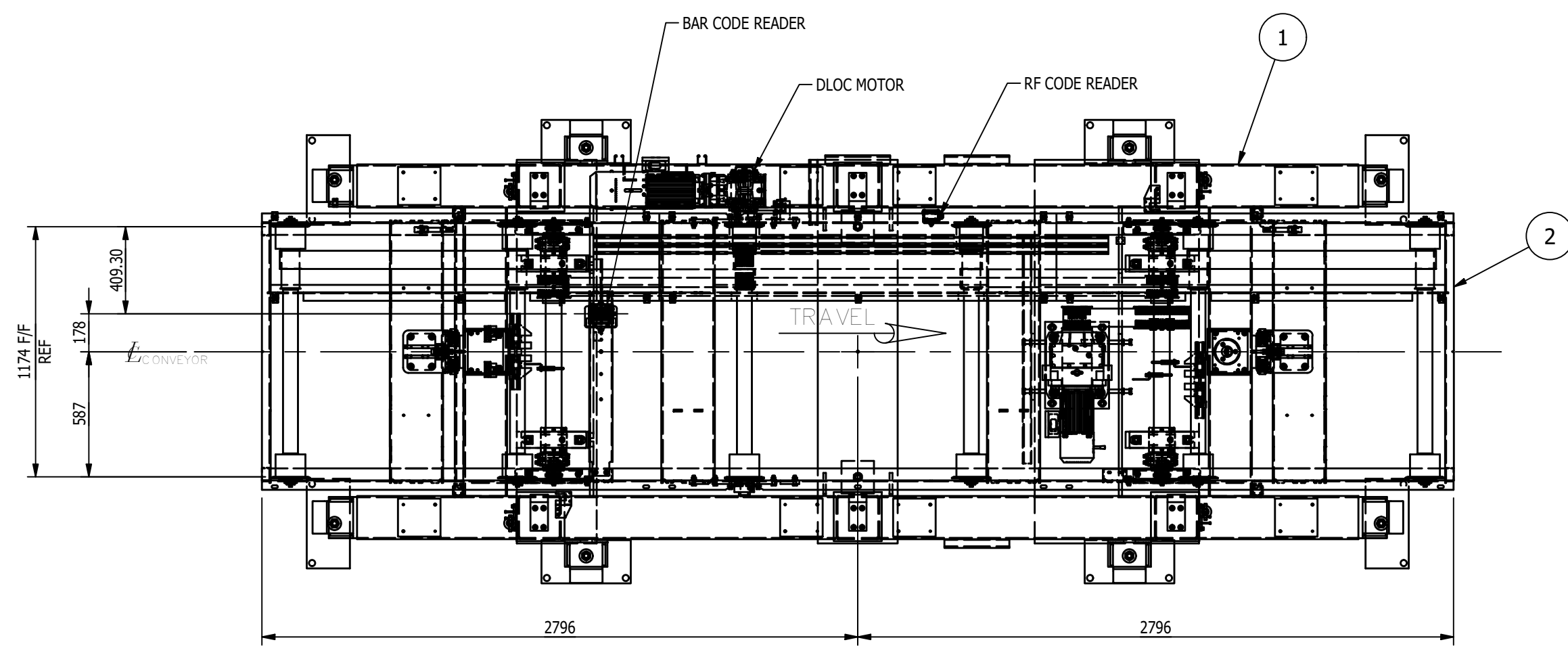


BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D200A			
1	1	MK-D201A ~ LIFTER BASE ASSEMBLY			
2	1	MK-D220A ~ D-LOC PRB6 ASSEMBLY			
TOTAL WEIGHT ~ 5883.5 lbs					



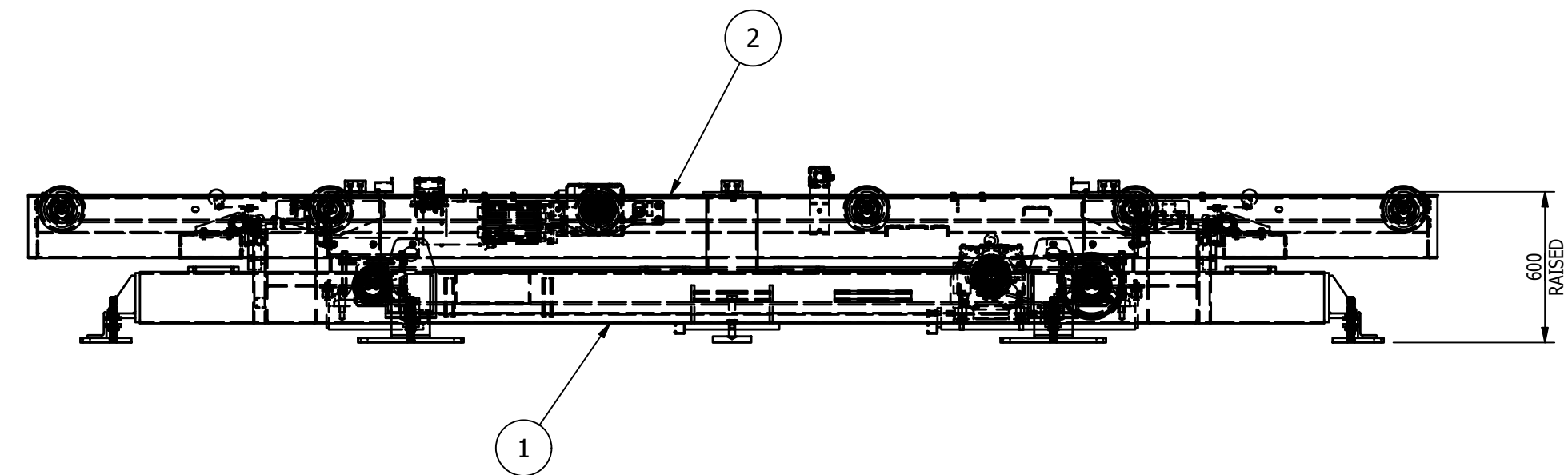
MK-D200A ~ 90mm INBOARD REDUCER LIFTER BASE ASSEMBLY
SCALE 1/2"=1'-0"
DOWN POSITION

SPEED FORMULA ROLL BED (60HZ):

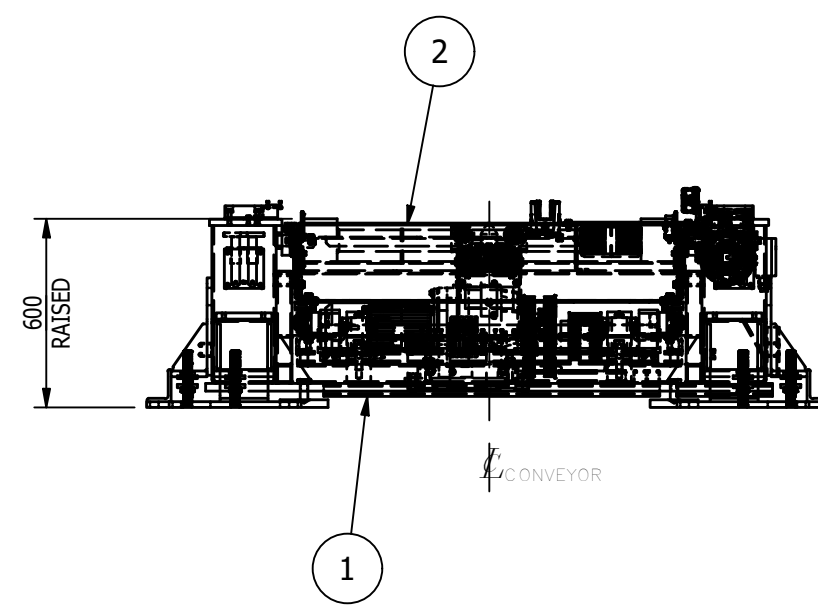
$$\pi \times 1755 \times \frac{1}{13.61} \times \frac{140}{1000} = 56.7 \text{ m/min} = 186.1 \text{ ft/min}$$

SPEED FORMULA ROLL BED (XXX Hz):

- 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.




MK-D200A ~ 90mm INBOARD REDUCER LIFTER BASE ASSEMBLY
SCALE 1/2"=1'-0"
UP POSITION



REV	BY	DATE	DESCRIPTION	APP
B	MC	8/11/2022	643 mm DIM WAS 640 mm	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY	
B	MC 8/11/2022 643 mm DIM WAS 640 mm
A	MC 7/5/2022 FOR FABRICATION

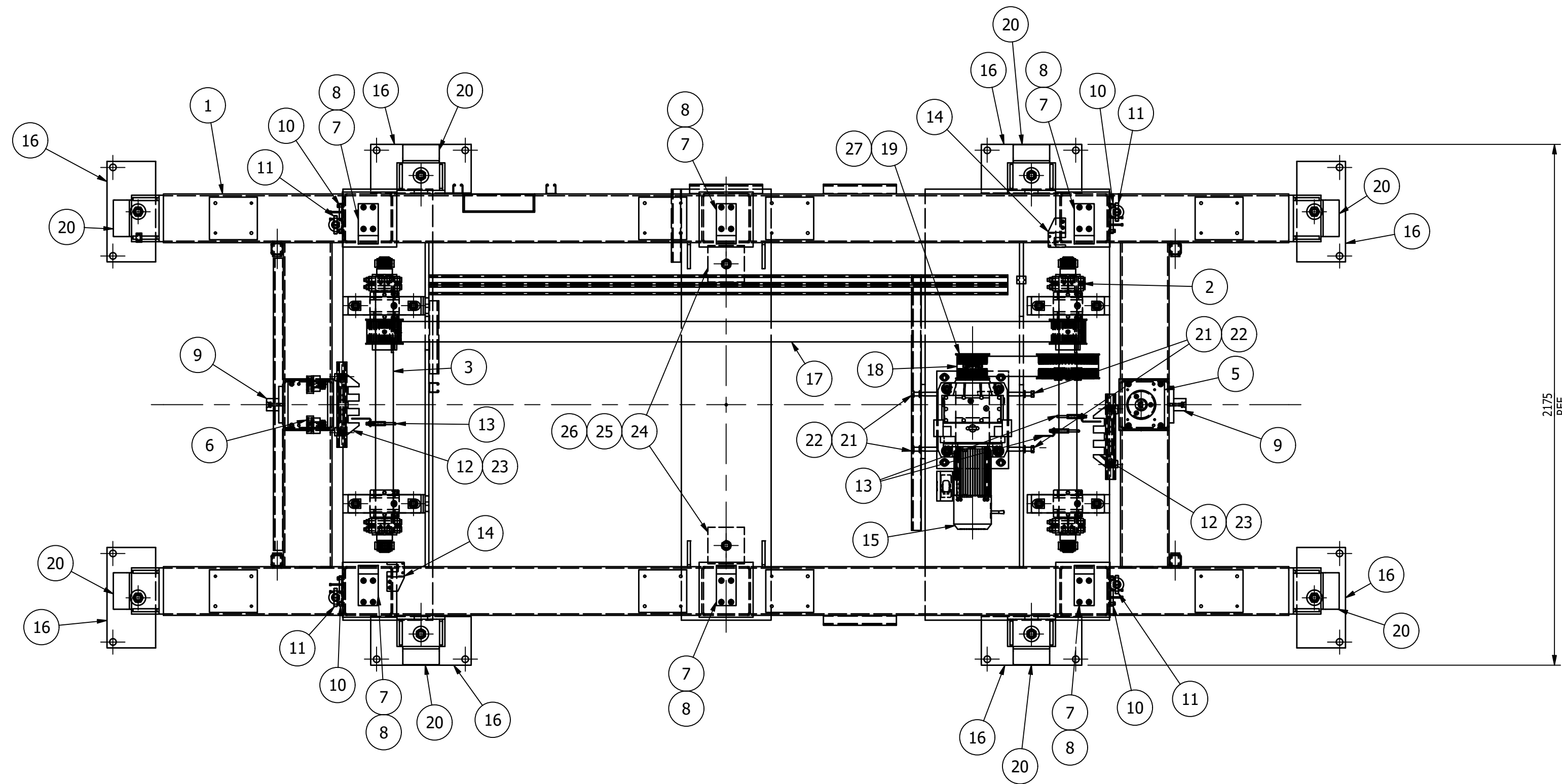
 MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: PWP	
CLIENT: VOLVO	CHECKED BY: CW	
DRAWING No. 1875D200	DWG DATE: 6/21/2022	
	REV: B	JOB No: 22096

MAGNUM CONSULTING
 41100 QuakerRoad Rd.
 Suite 125
 Novi, MI 48235
 Phone: (248) 772-8822
 Fax: (248) 772-8821
 Web: www.mmagnum.com

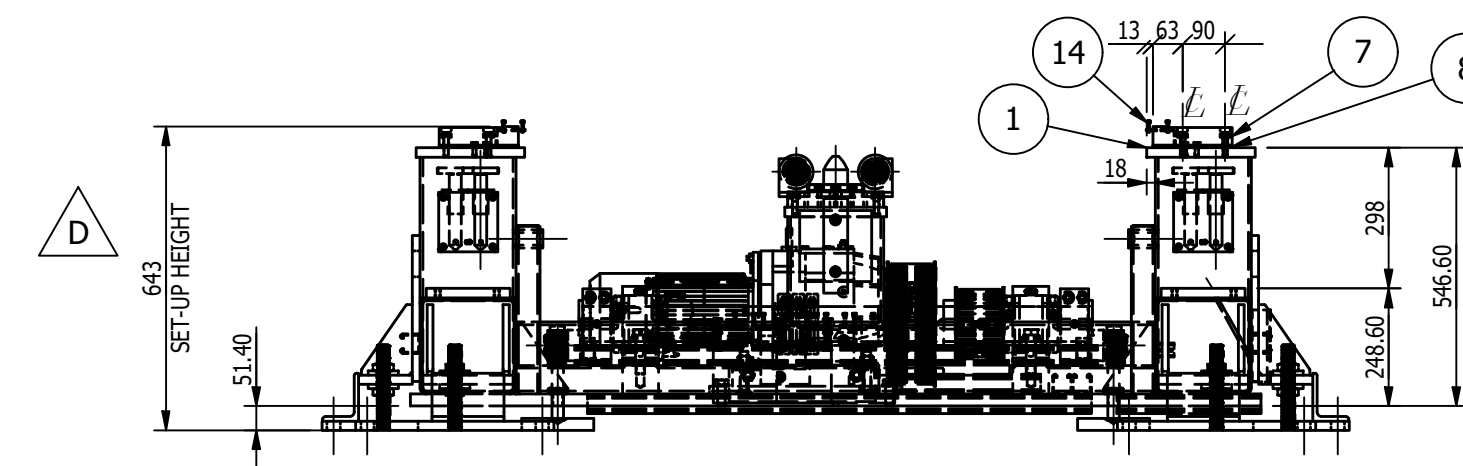
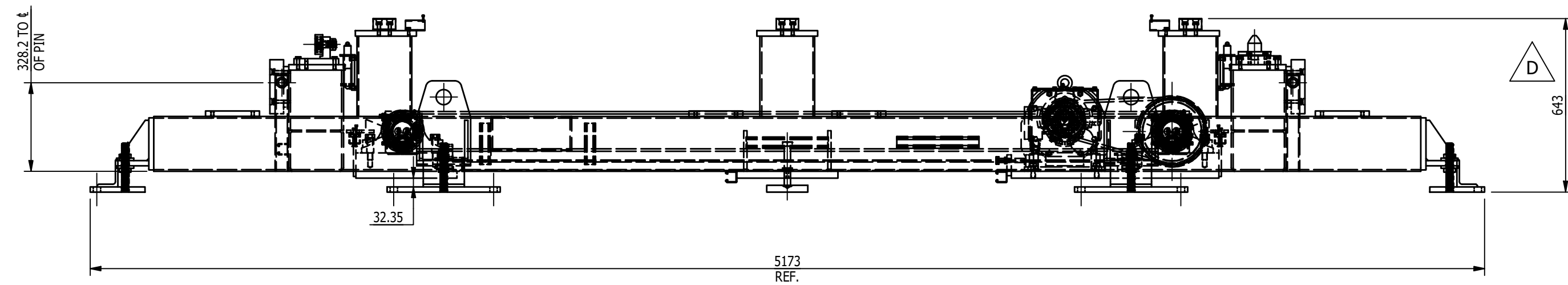
MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D200

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-D201A			
1	1	MK-D245A ~ SAFETY PIN WELDMENT PLACEMENT			
2	1	MK-D204A ~ 90 mm LIFTER SHAFT DRIVER END ASSEMBLY			
3	1	MK-D205A ~ 90 mm LIFTER SHAFT DRIVEN END ASSEMBLY			
5	1	MK-D210A ~ 4 WAY LOCATOR PIN ASSEMBLY			
6	1	MK-D213A ~ 2 WAY LOCATOR ASSEMBLY			
7	6	MK-D216A ~ Z REST PAD			
8	6	MK-D216B ~ Z REST PAD SHIM			
9	2	MK-D216C ~ CAM GUIDE			
10	4	MK-D217A ~ HOLSTER WELDMENT			
11	4	MK-D217B ~ LOCK-OUT PIN			
12	2	MK-D218A ~ SLOTTED SENSOR PLATE			
13	3	MK-D218B ~ SLOT SENSOR LO BRACKET			
14	2	MK-D219A ~ SLOT SENSOR DO BRACKET			
15	1	MK-D234A ~ 90mm LIFTER REDUCER BASE ASSEMBLY			
16	8	MK-D102 ~ FOOT PAD ASSEMBLY			
17	1	GATES GT4 BELT #6160-14MGT-85		2-7	
18	1	GATES GT4 BELT #1400-14MGT-85		2-6	
19	1	SPROCKET W/ BORE FOR B-LOC BUSHING #B301050, GATES POWERGRIP PART-NO. P28-14MGT-85		5-4	
20	8	L 4 x 3 x 3/8 (SHIP LOOSE)	6"		
21	4	M16x2 x 100mm LG. HEX CAP SCREW (FULL THREAD)			
22	4	M16 x 2 HEX JAM NUT			
23	4	McMASTER Strut Channel Nut #3259T53			
24	2	ABP166-NAAMS LEVELING PL 1x6x150mm		10-1	
25	2	M24x3 x 150mm LG. (FULL THREAD)			
26	2	M24 x 3 HEX JAM NUT			
27	1	50 mm DIA. KEYLESS BUSHING, B-LOC PART NO. 02376879		5-6	
		TOTAL WEIGHT ~ 3904.1 lbs			



MK-D201A ~ LIFTER BASE ASSEMBLY
SCALE 3/4"=1'-0"

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

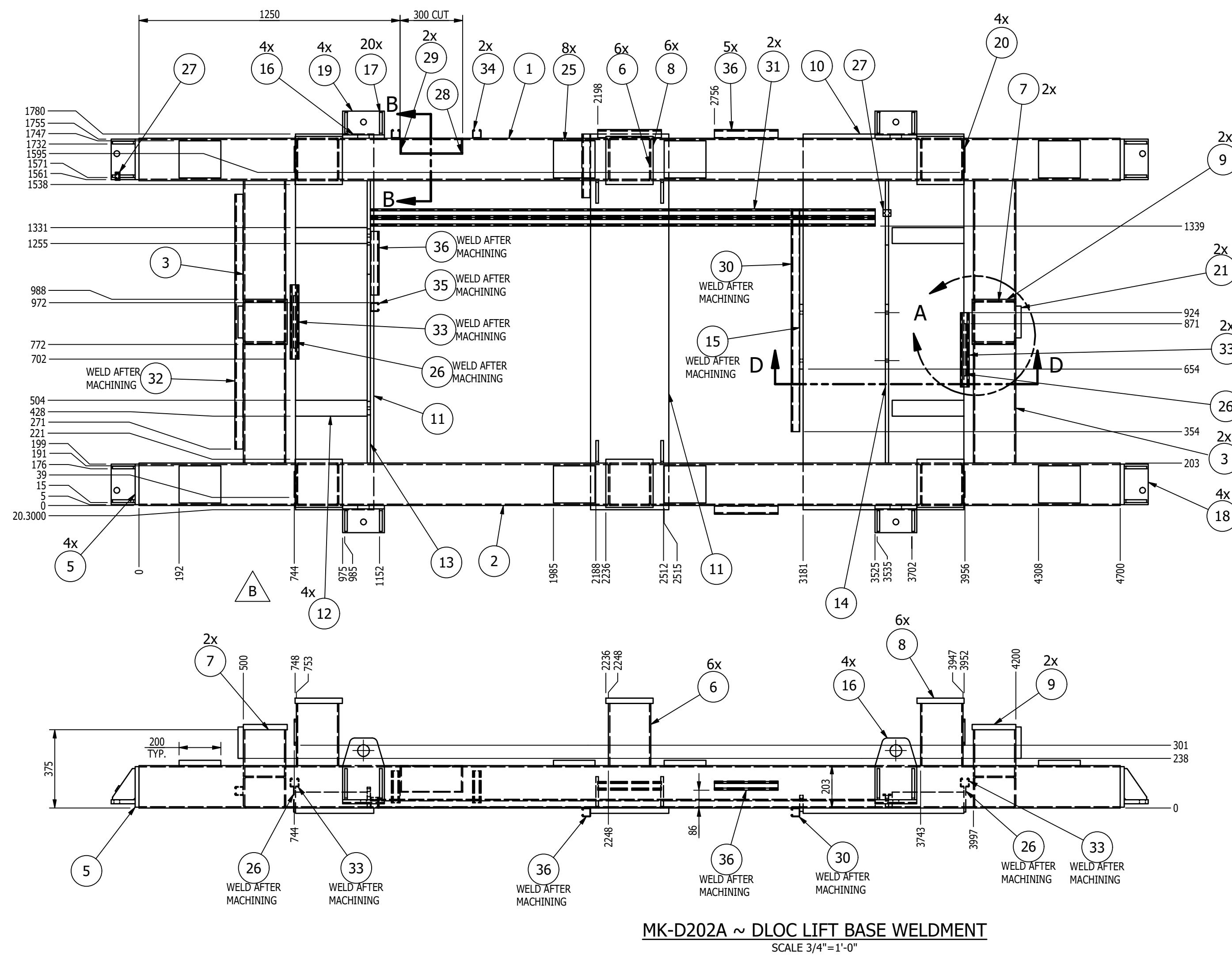
REV	BY	DATE	DESCRIPTION	APP
D	MC	9/2/2022	REVISED DIM	
C	MC	7/29/2022	REVISED CALL-OUT FOR ITEM 1 WAS 203A, NOW 245A	
B	MC	7/14/2022	MK-19 DESC REVISED, MK-27 ADDED	
A	MC	7/5/2022	FOR FABRICATION	

 MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	PWP
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D201	DWG DATE:	6/20/22
		REV:	D
		JOB No.:	22096

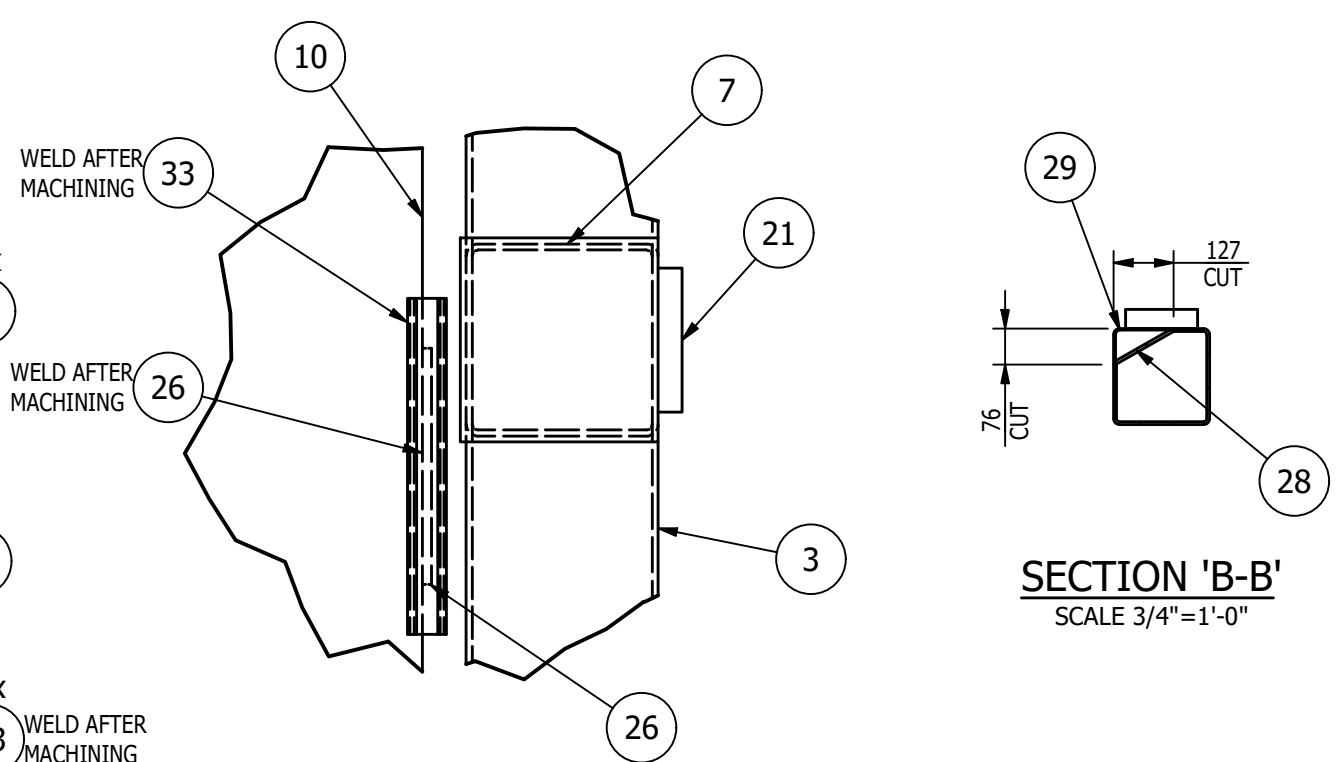
MAGNUM CONSULTING
 41100 Charleston Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D201 - REV D

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

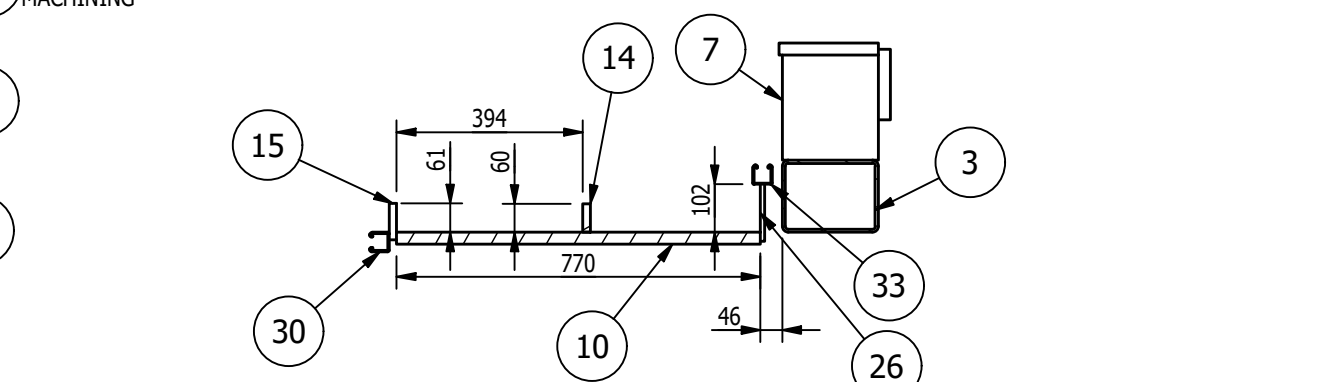
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO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



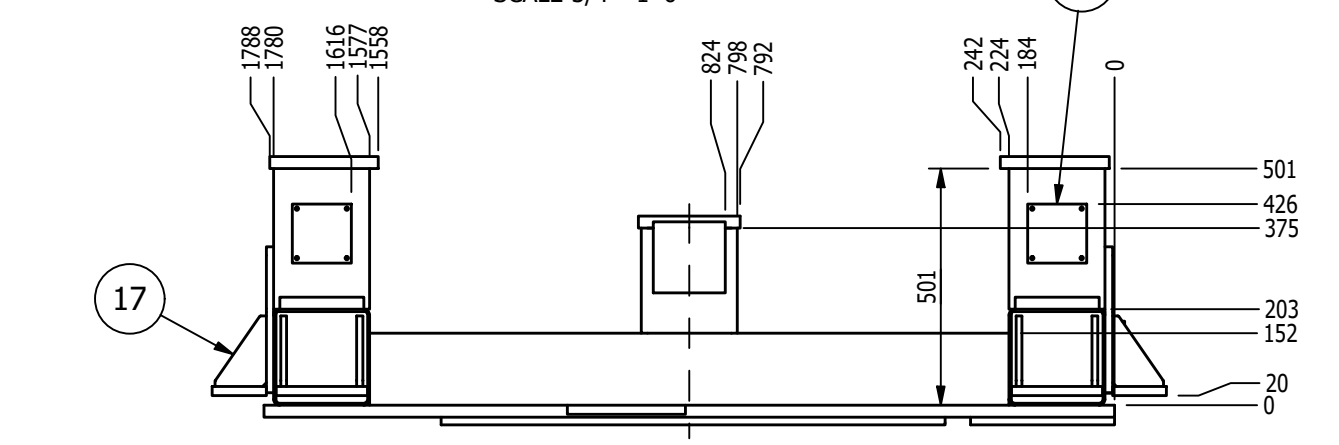
MK-D202A ~ DLOC LIFT BASE WELDMENT
SCALE 3/4"=1'-0"



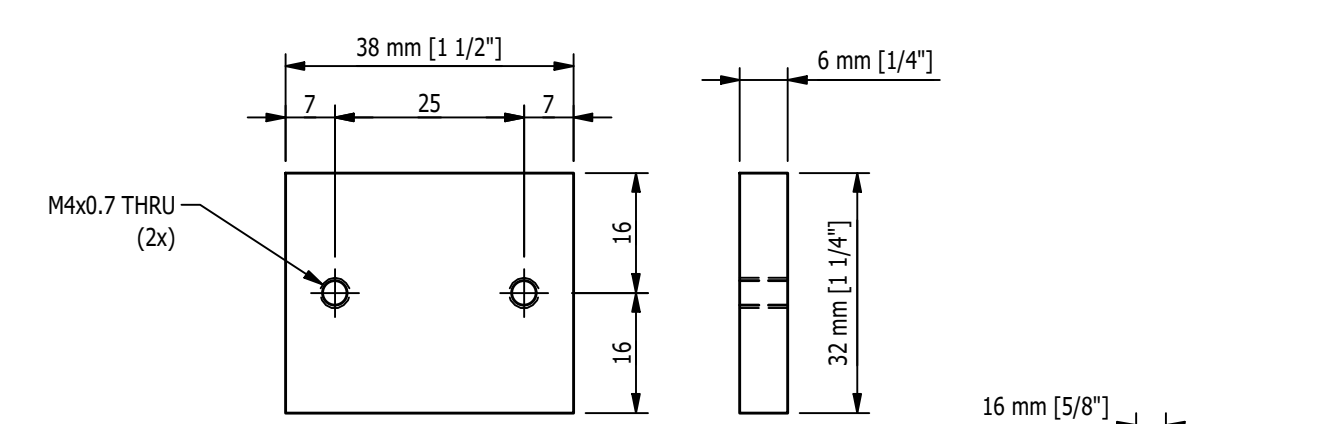
ENLARGED VIEW 'A'
SCALE 1 1/2"=1'-0"



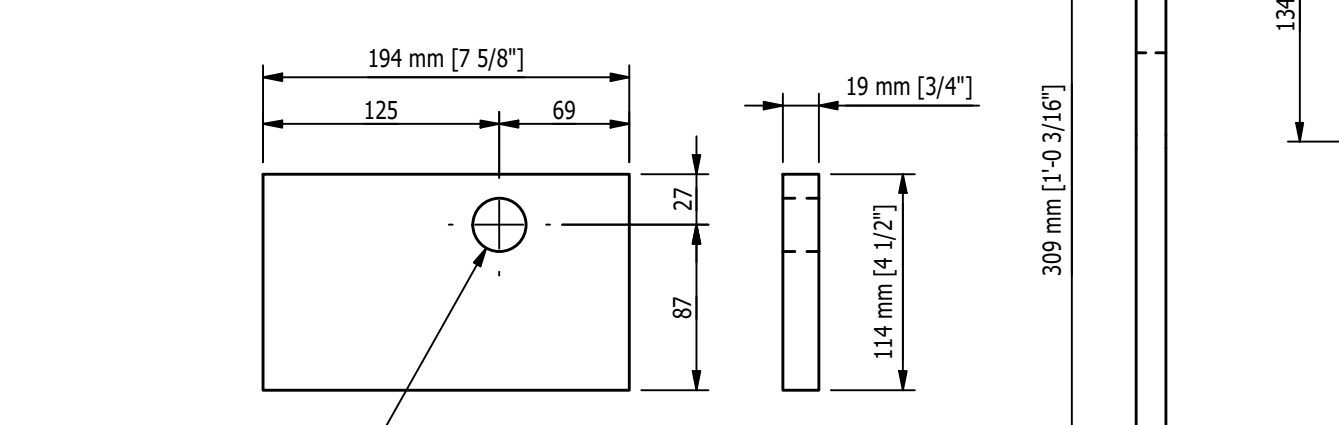
SECTION 'D-D'
SCALE 3/4"=1'-0"



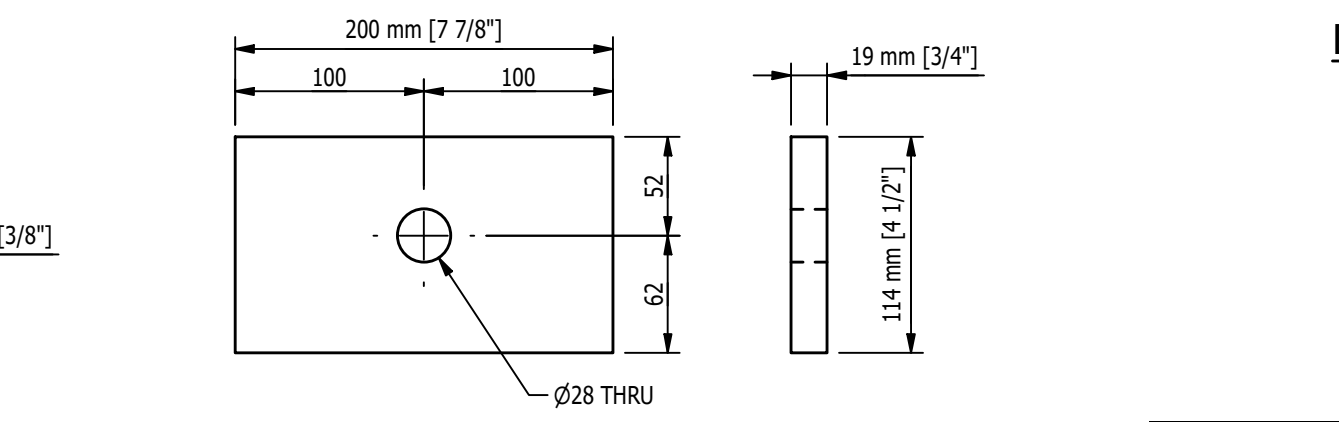
SECTION 'B-B'
SCALE 3/4"=1'-0"



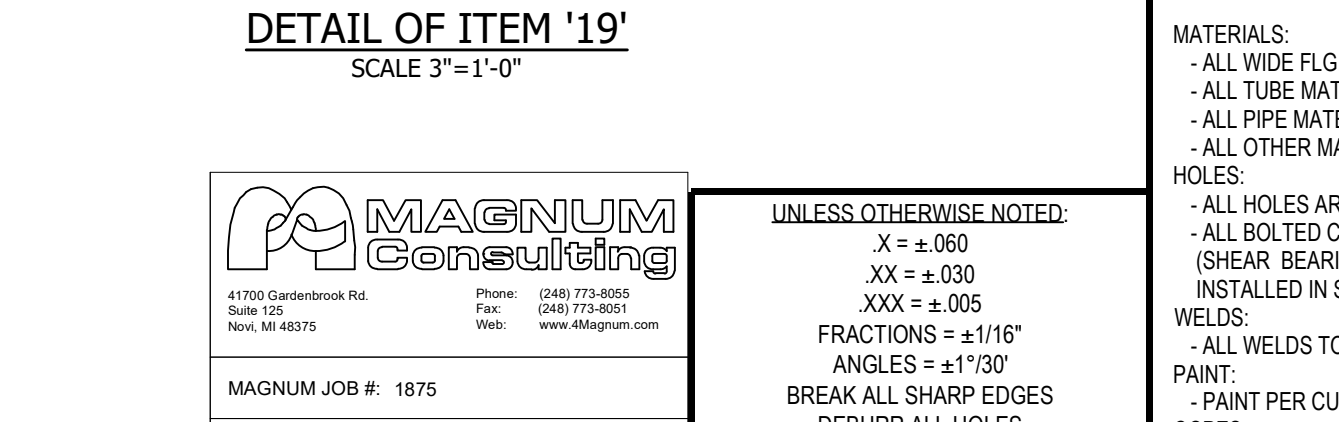
DETAIL OF ITEM '27'
SCALE 1'-0"=1'-0"



DETAIL OF ITEM '18'
SCALE 3"=1'-0"



DETAIL OF ITEM '16'
SCALE 3"=1'-0"



DETAIL OF ITEM '19'
SCALE 3"=1'-0"



DETAIL OF ITEM '15'
SCALE 3"=1'-0"

DETAIL OF ITEM '29'
SCALE 3"=1'-0"

DETAIL OF ITEM '17'
SCALE 3"=1'-0"

DETAIL OF ITEM '20'
SCALE 3"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D202A			
1	1	TS 8 x 8 x 1/4	15'-5 1/16"		
2	1	TS 8 x 8 x 1/4	15'-5 1/16"		
3	2	TS 8 x 6 x 1/4	4'-5 1/4"		
5	4	PL 3/4 x 7 5/8"	7 5/8"		
6	6	TS 8 x 8 x 1/4	11 3/4"		
7	2	TS 8 x 8 x 1/4	8 3/4"		
8	6	PL 1 x 8 7/8"	9 1/16"		
9	2	PL 1 x 8 1/2"	8 1/4"		
10	1	PL 1 x 2'-6 5/16"	5'-10 7/8"		
11	2	PL 1 x 1'-2 3/4"	5'-10 7/8"		
12	4	SQ. BAR 3	1'-1 1/2"		
13	1	PL 5/8 x 3 15/16"	4'-5 1/4"		
14	1	PL 5/8 x 2 3/8"	4'-5 1/4"		
15	1	PL 5/8 x 3 1/16"	1'-3 1/16"		
16	4	PL 5/8 x 7 7/8"	1'-3 1/16"		
17	20	PL 1/2 x 4 1/4"	5 7/8"		
18	4	PL 3/4 x 4 1/2"	7 5/8"		
19	4	PL 3/4 x 4 1/2"	7 7/8"		
20	4	PL 3/8 x 4 15/16"	4 15/16"		
21	2	BAR 1 x 6	5 7/8"		
25	8	BAR 1 x 7	7 7/8"		
26	2	PL 3/8 x 4 3/4"	9 13/16"		
27	2	BAR 1/4 x 1 1/4	1 1/2"		
28	1	PL 3/8 x 5 9/16"	11 13/16"		
29	2	PL 1/4 x 2 5/8"	4 9/16"		
30	1	UNISTRUT 1-5/8 x 1-5/8 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	3'-6"		
31	2	UNISTRUT 1-5/8 x 1-5/8 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	7'-11 3/16"		
32	1	UNISTRUT 1-5/8 x 1-5/8 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	4'-0"		
33	2	UNISTRUT 1-5/8 x 1-5/8 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	1'-2"		
34	2	UNISTRUT 1-5/8 x 1-5/8 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	6"		
35	1	UNISTRUT 1-5/8 x 1-5/8 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	2"		
36	5	UNISTRUT 1-5/8 x 1-5/8 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	1'-0"		
			TOTAL WEIGHT ~ 3146.2 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 AFTER MACHINING AND FINAL WELD DO NOT PAINT MACHINED SURFACES ONE SHOP COAT OF LIGHT GREY RAL 7035

- SHOP NOTE:**
1. WELD ALL UNISTRUT AFTER MACHINING

REV	BY	DATE	DESCRIPTION	APP
D	MC	9/15/2022	ADDED SECTION D-D	
C	MC	7/29/2022	ELIMINATED ITEM 24 MK-D230A	
B	MC	7/15/2022	DIM ADDED	
A	MC	7/5/2022	FOR FABRICATION	

GENERAL NOTES:

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

Holes:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

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

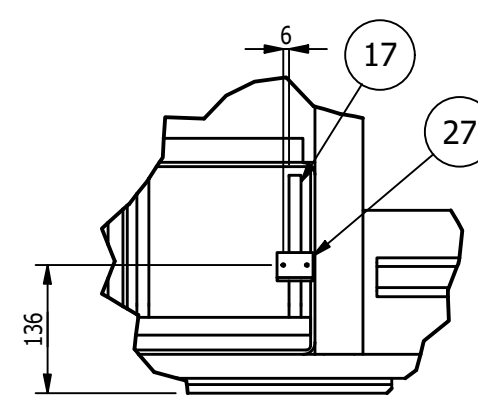
TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No.: 1875D202
REV: C

DRAWN BY: PWP
CHECKED BY: CW
DWG DATE: 6/20/22
JOB No.: 22096

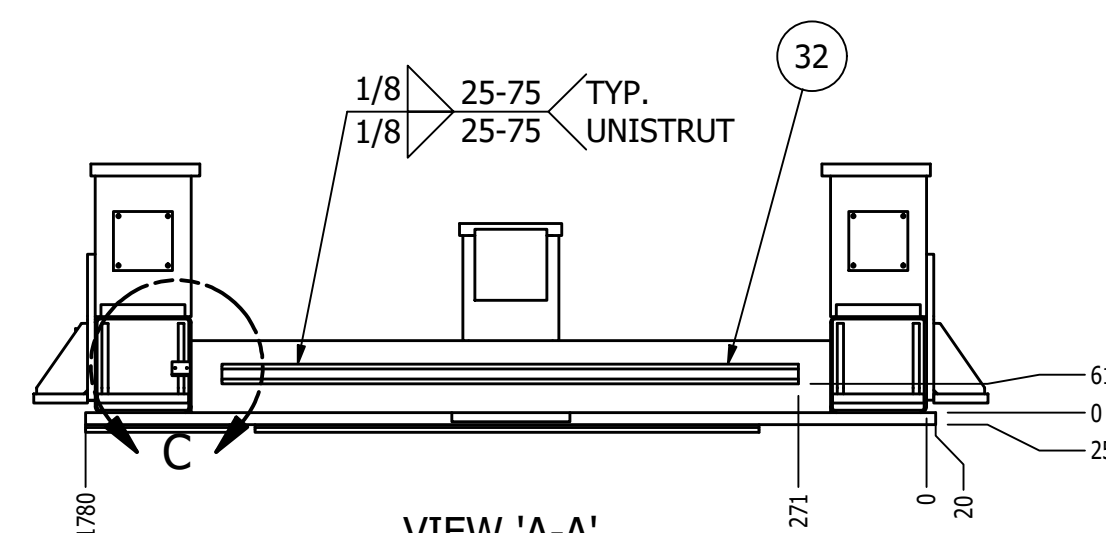
MAGNUM CONSULTING
41100 Charleston Rd.
Suite 125
Wood, MI 48095
Phone: (248) 772-8800
Fax: (248) 772-8801
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D202 - REV D

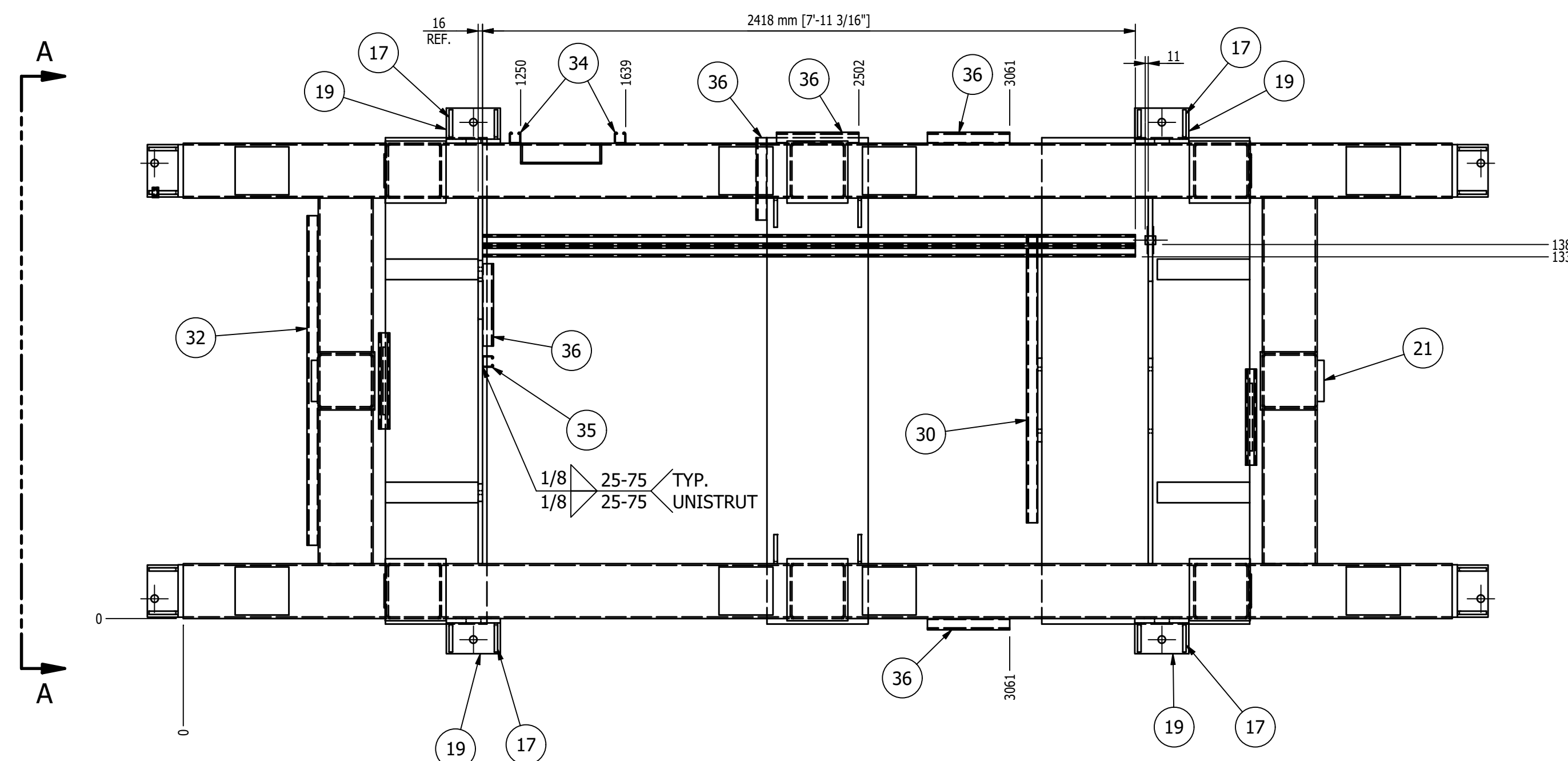
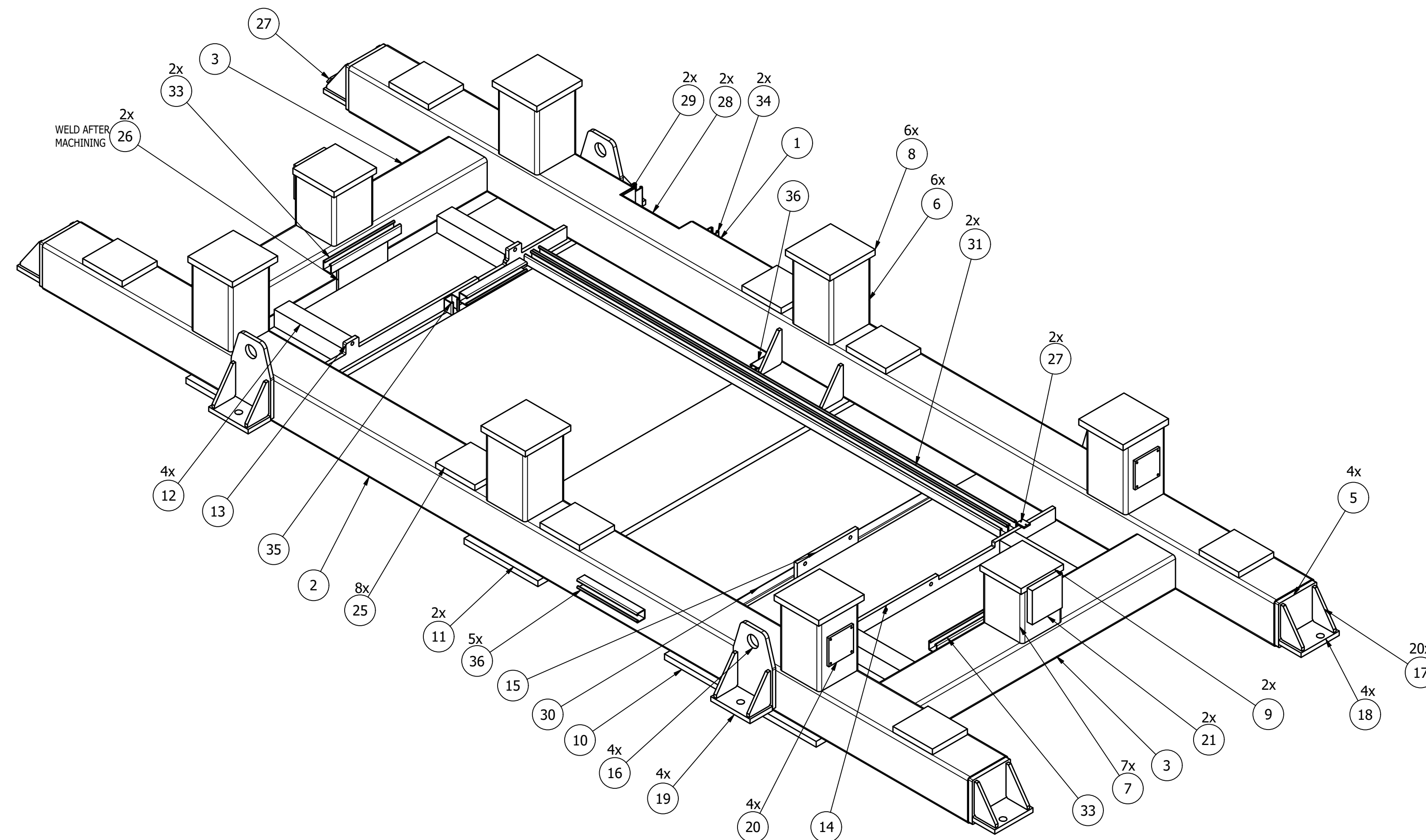
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



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



VIEW 'A-A'
SCALE 3/4" = 1'-0"



SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
D	MC	9/15/2022	ADDED SECTION D-D	
C	MC	7/29/2022	ELIMINATED ITEM 24 MK-D230A	
B	MC	7/15/2022	DIM ADDED	
A	MC	7/5/2022	FOR FABRICATION	

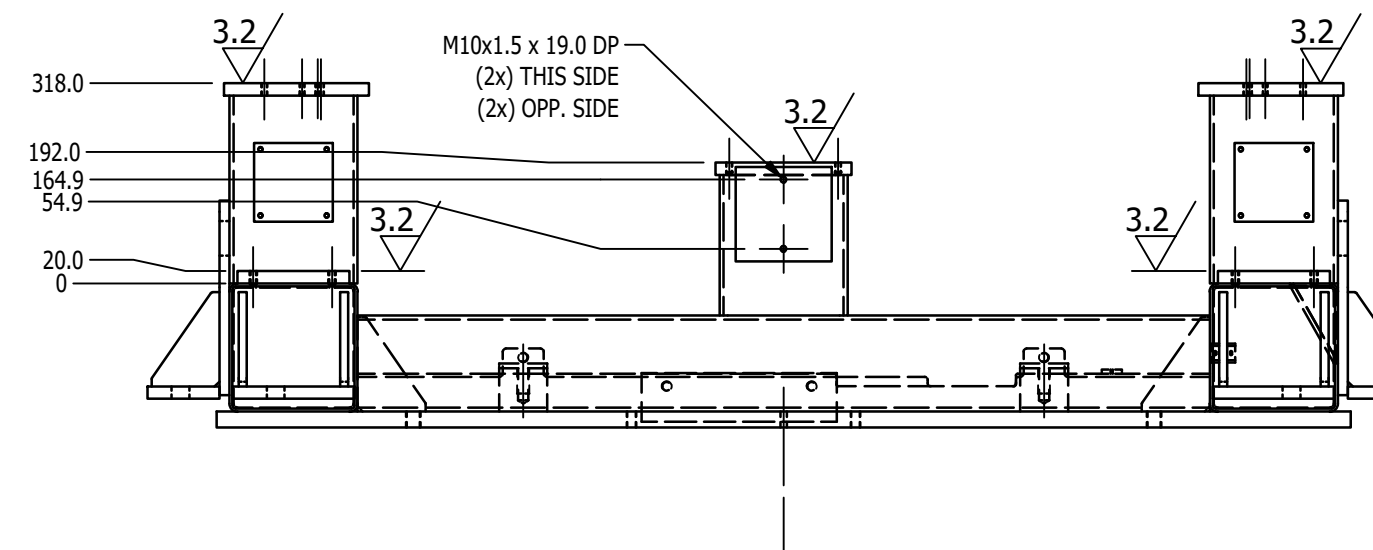
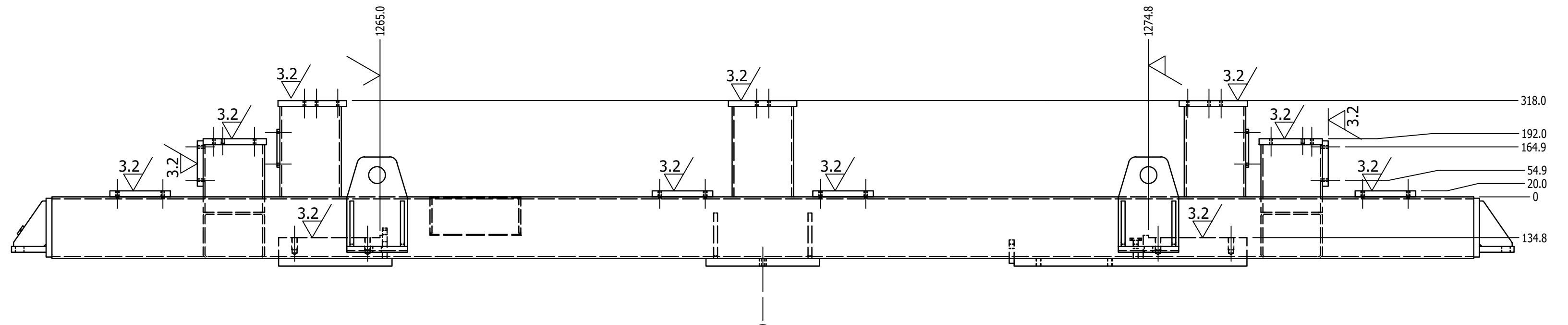
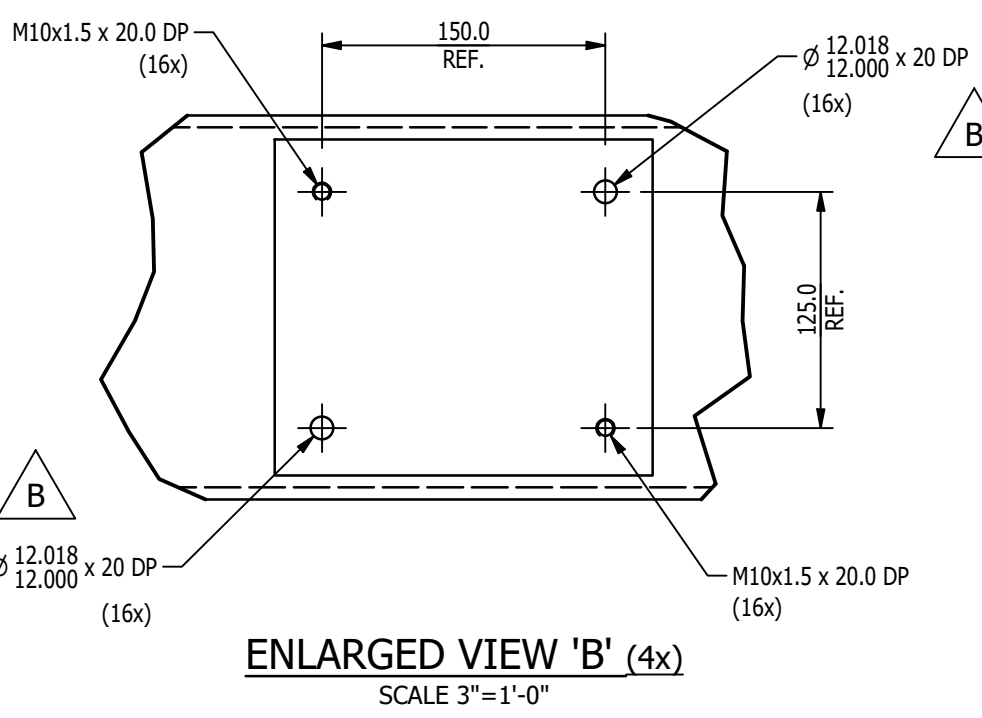
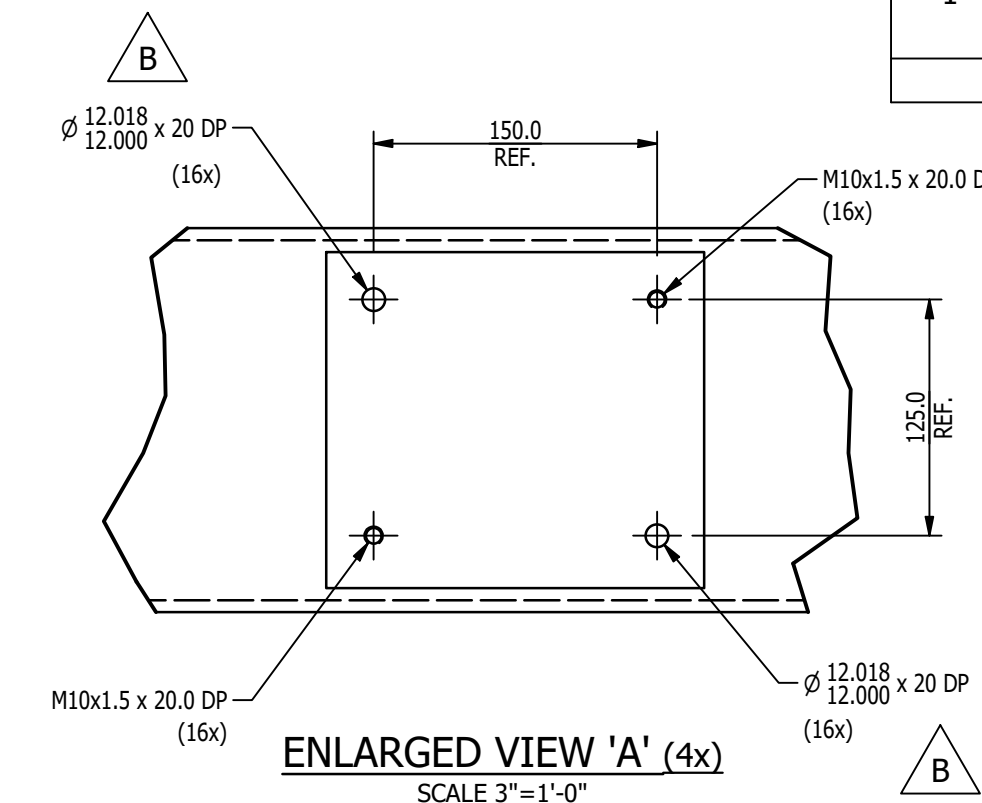
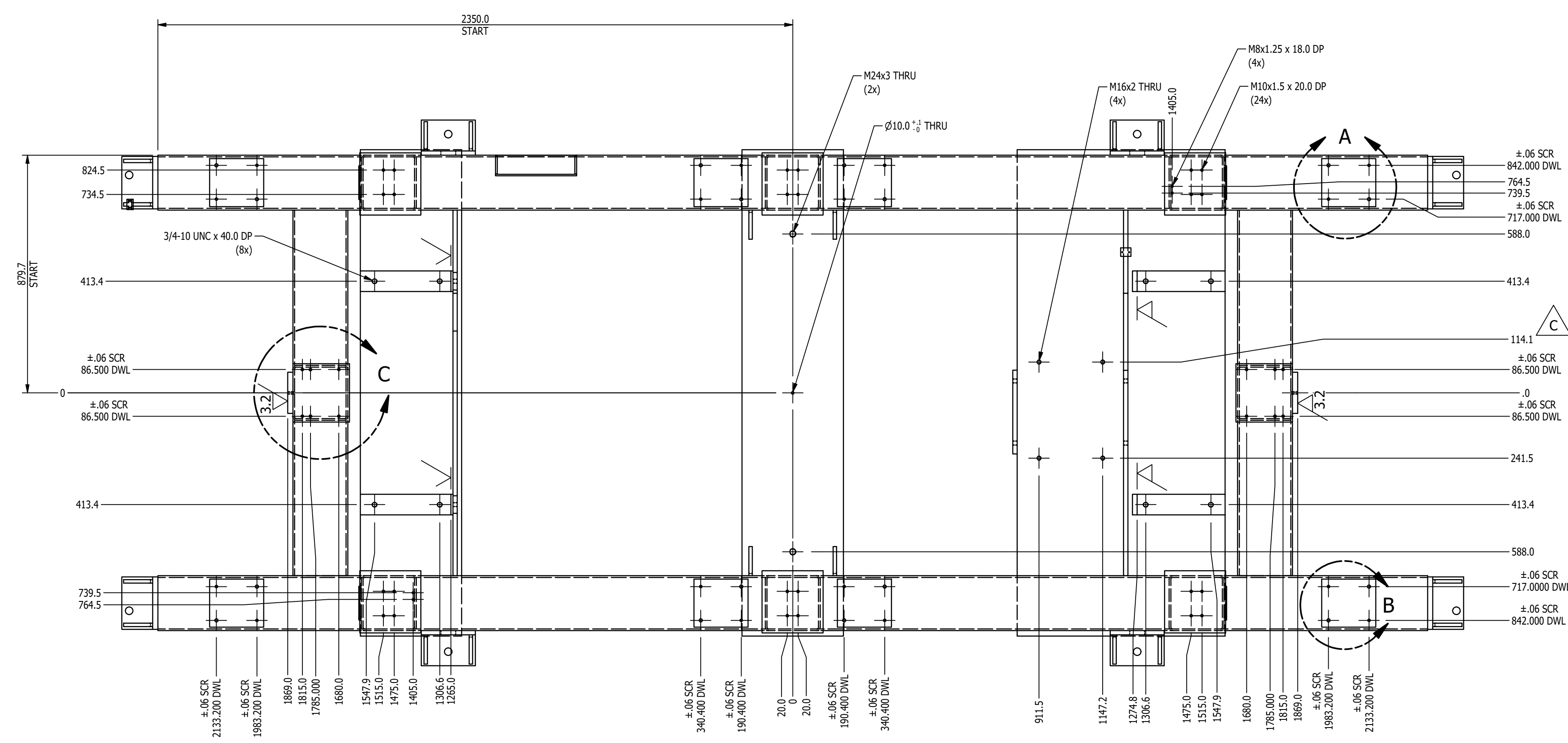
MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: PWP CHECKED BY: CW DWG DATE: 6/20/22
CLIENT: VOLVO	DRAWING No. 1875D202	REV: C JOB No: 22096

MAGNUM Consulting
 41702 Gardenbrook Rd.
 Suite 122
 North, MI 48430
 Phone: (810) 373-0322
 Fax: (810) 373-0321
 Web: www.milic.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D202 - REV D

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

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D203A MK-D202A ~ DLOC LIFT BASE WELDMENT			
TOTAL WEIGHT ~ 3081.1 lbs					



MK-D203A ~ LIFTER BASE MACHINING
SCALE 1"=1'-0"

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

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

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Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D203 - 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	DIM ADDED	
B	MC	7/13/2022	HOLES REVISED	
A	MC	7/5/2022	FOR FABRICATION	

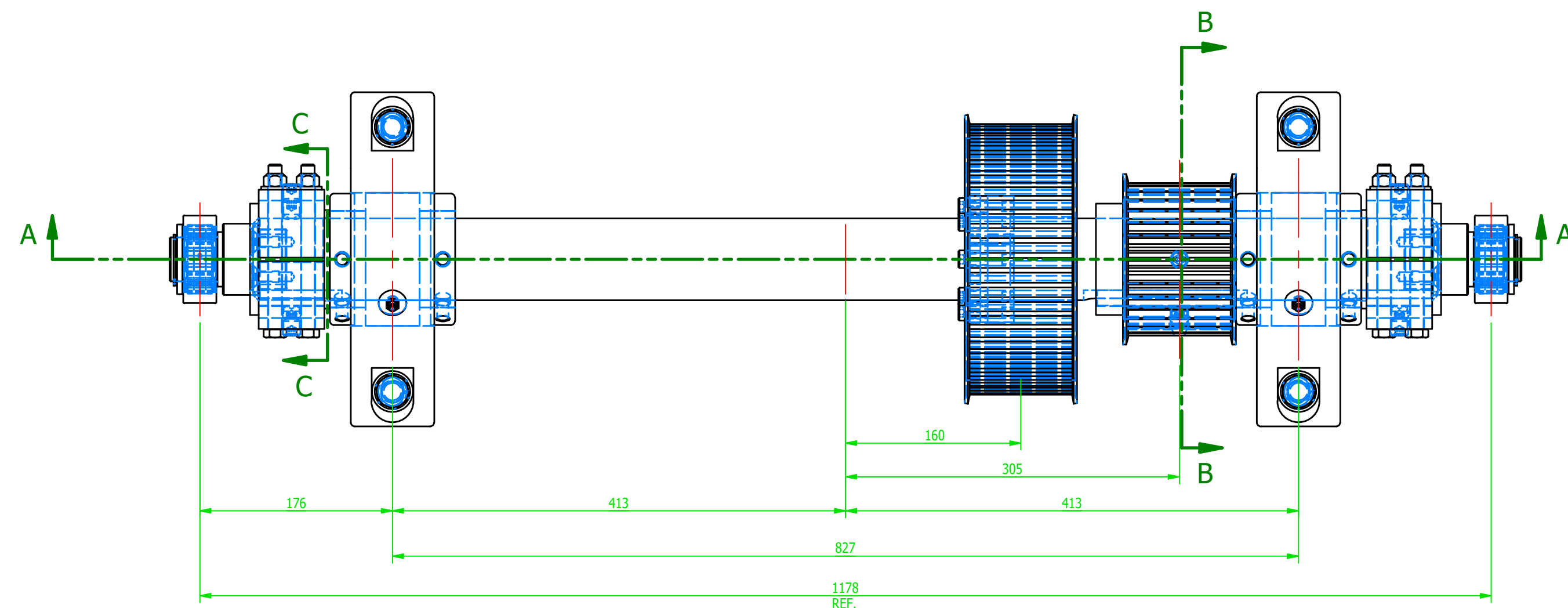
REVISION HISTORY

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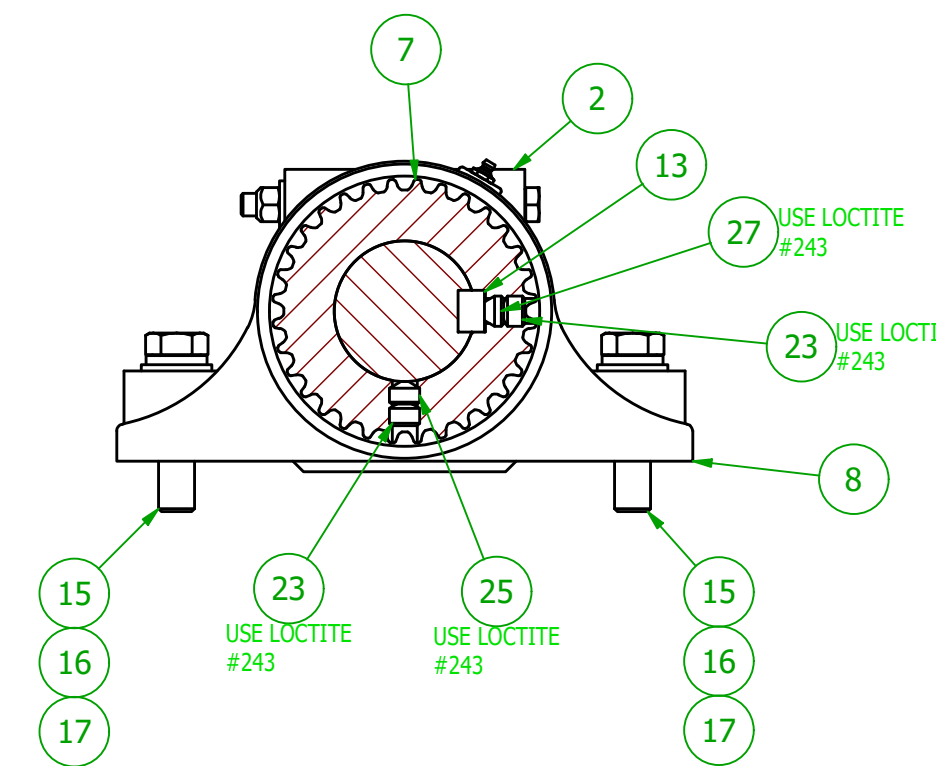
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CLIENT: VOLVO
DRAWING No. 1875D203

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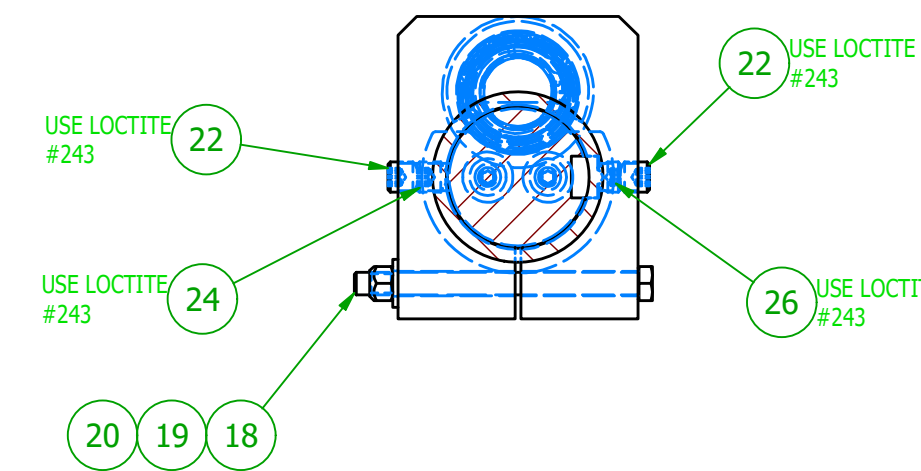
DRAWN BY: PWP
CHECKED BY: CW
DWG DATE: 6/20/22
JOB No: 22096



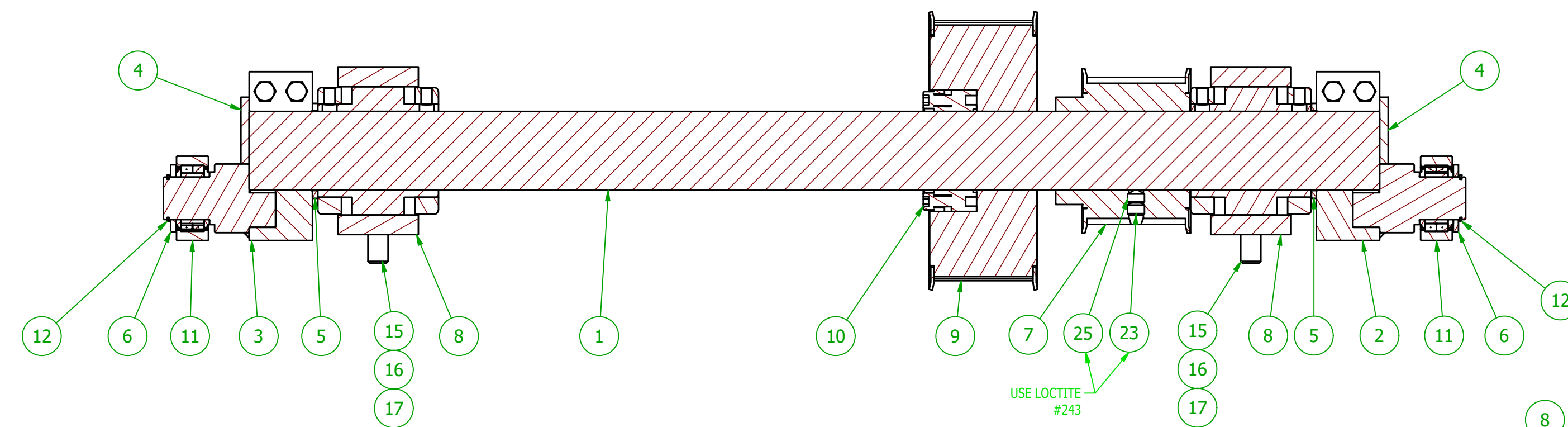
MK-D204A ~ 90 mm LIFTER SHAFT DRIVER END ASSEMBLY
SCALE 3"=1'-0"



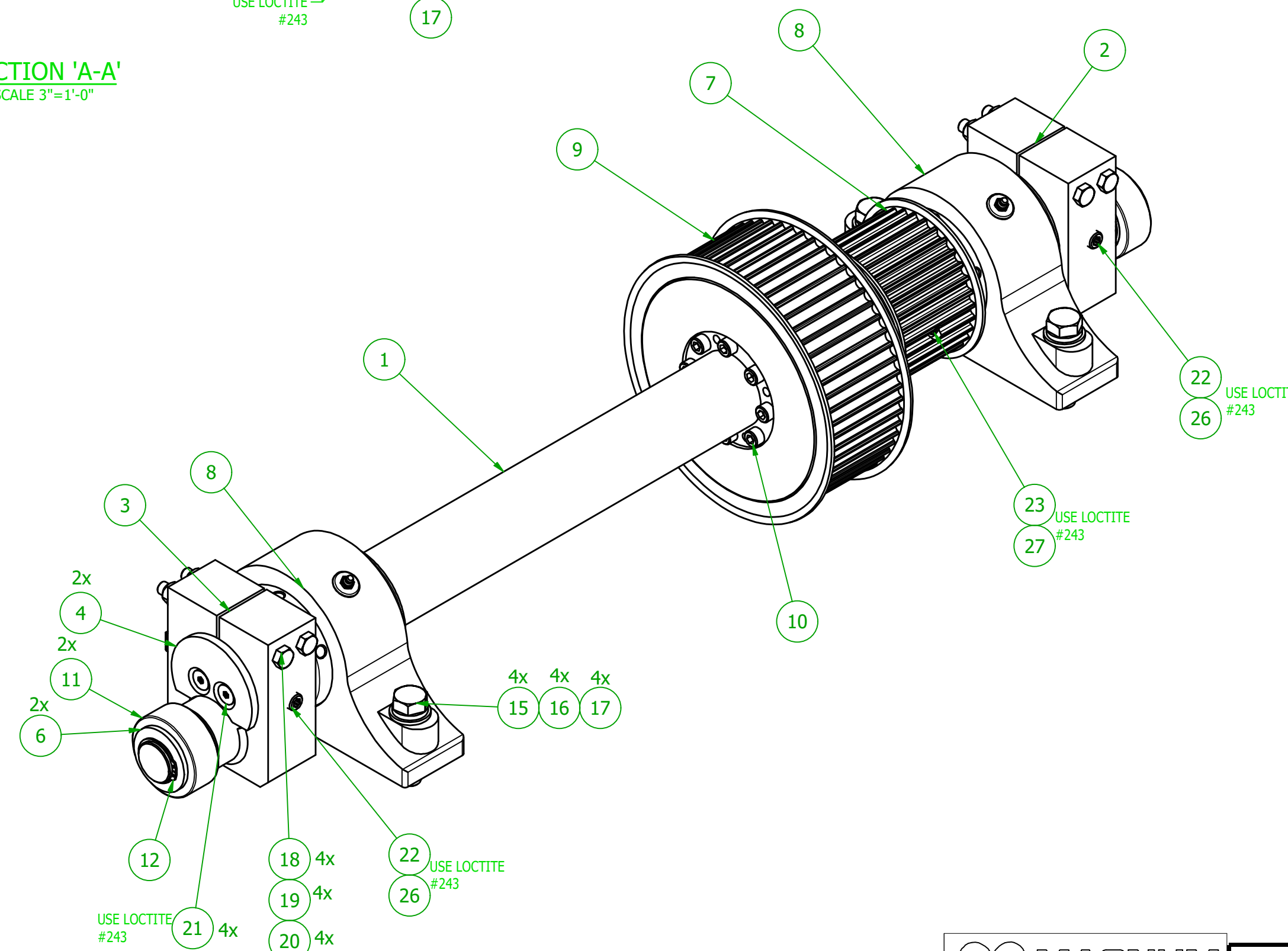
SECTION 'B-B'
SCALE 3"=1'-0"



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



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



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D204A			
1	1	MK-D206A ~ LIFTER SHAFT			
2	1	MK-D208B ~ ECCENTRIC ROLLER CLAMP RIGHT HAND			
3	1	MK-D208A ~ ECCENTRIC ROLLER CLAMP ASSEMBLY - LH			
4	2	MK-D209A ~ LIFTER CAP			
5	2	MK-D209B ~ 90mm LIFTER SHAFT SPACER			
6	2	MK-D209C ~ ECCENTRIC ROLLER SPACER			
7	1	MK-D228A ~ GATES 32 TOOTH SPROCKET		5-2	
8	2	DODGE 2 15/16" TYPE 'E' PILLOW BLOCK #P2B-E-215R		5-1	
9	1	SPROCKET W/ BORE FOR B-LOC BUSHING #B302215, GATES POWERGRIP PART-NO. P56-14MGT-85		5-3	
10	1	2 15/16" DIA. KEYLESS BUSHING, B-LOC PART NO. B302215		5-5	
11	2	YOKE TYPE ROLLER, INA PART-NO NUTR-40		5-7	
12	2	BLACK-FINISH STEEL EXTERNAL RETAINING RING, McMASTER PART-NO 98541A156		5-8	
13	1	22 x 14 x 125 LG. SQ. KEYSTOCK			
14	2	22 x 14 x 63 LG. SQ. KEYSTOCK			
15	4	3/4-10UNC x 3 1/4" LG. HEX HEAD CAP SCREW			
16	4	3/4 TYPE A NARROW FLAT WASHER			
17	4	3/4 SPRING LOCK WASHER			
18	4	M12x1.75 x 150mm LG. HEX CAP SCREW			
19	4	M12 NARROW FLAT WASHER			
20	4	M12 x 1.75 STOVER LOCK NUT			
21	4	M10x1.5 x 25mm LG. FLAT HEX SOCKET HEAD CAP SCREW			
22	4	M16x2 x 16mm LG. HEX SOCKET OVAL POINT SET SCREW			
23	2	M16x2 x 12mm LG. HEX SOCKET OVAL POINT SET SCREW			
24	2	M16x2 x 16mm LG. HEX SOCKET CONE POINT SET SCREW			
25	1	M16x2 x 12mm LG. HEX SOCKET CONE POINT SET SCREW			
26	2	M16x2 x 12mm LG. HEX SOCKET CUP POINT SET SCREW			
27	1	M16x2 x 10mm LG. HEX SOCKET CUP POINT SET SCREW			
		TOTAL WEIGHT ~ 156.6 lbs			

SHAFT/KEYWAY NOTE:
ALL SPROCKETS, CAM ARMS, COUPLINGS & OTHER ITEMS WITH KEYS & SET SCREW ARE TO HAVE (1) CUP POINT SET SCREW OVER KEY & (1) CONE POINT SET SCREW @ 90 DEGREES OVER SHAFT, SPOT DRILL SHAFTS FOR ALL CONE POINT SET SCREWS, BOTH CUP & CONE POINT TO BE BACKED UP BY OVAL POINT SET SCREWS

SHOP NOTES:
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SEE SHEET 2 FOR BLOC INSTALLATION INSTRUCTIONS

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/18/22	ADDED NOTE, SHEET 2 BLOC INSTALLATION	
A	MC	7/5/2022	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.
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MAGNUM DRAWING #: 1875D204

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TITLE: P6700 CONVEYORS
CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D204
REV: B

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DWG DATE: 6/20/22
JOB No.: 22096

INSTALLATION
(Refer to Figure 1)

B-LOC® Series B103 and B106 Keyless Bushings are supplied lightly oiled and ready for installation. They are self-centering and fit straight-thru hub bores. Note that Series B103 units permit axial hub movement during installation. In contrast, the extended flange on Series B106 units results in an axially fixed hub position during assembly. When reinstalling a used unit, make sure that all slits are aligned. The frictional torque capacity of these devices is based on a coefficient of friction of 0.12 for lightly oiled screw, taper, shaft and bore contact areas.

Therefore, it is important not to use Molybdenum Disulfide (e.g., Molykote, Never-Seeze or similar lubricants) in any Keyless Bushing installation.

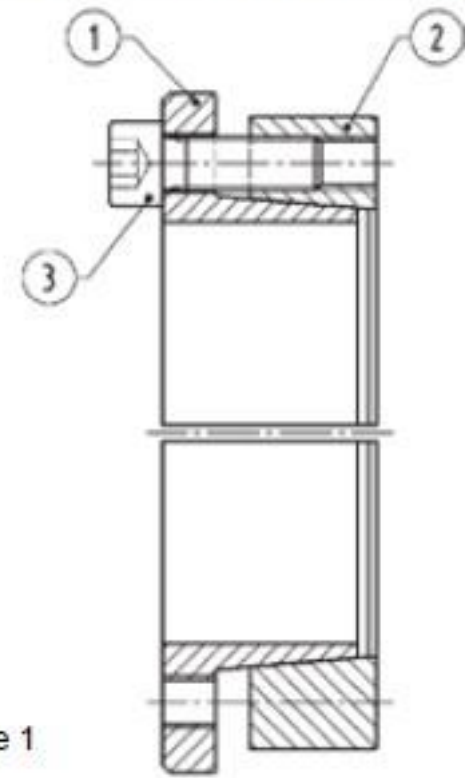


Figure 1

1. Make sure that locking screw, taper, shaft and bore contact areas are clean and lightly oiled with a light machine oil and that all collar slits are aligned.
2. Loosen all locking screws by a minimum of four (4) turns and transfer at least three (3) screws into push-off threads in order to keep Parts 1 and 2 separated during assembly (see Figure 2).
3. After inserting Keyless Bushing into hub bore, relocate locking screws used for separating Parts 1 and 2.
4. Hand tighten locking screws and confirm that collar Item 1 is parallel and in full contact with face of part to be attached to shaft.
5. Use torque wrench and set it approximately 5% higher than specified tightening torque (M_A). Tighten locking screws in either a clockwise or counterclockwise sequence (it is not necessary to tighten in a diametrically opposite pattern), using only 1/4 (i.e., 90°) turns for several passes until 1/4 turns can no longer be achieved.
6. Continue to apply overtorque for 1 to 2 more passes. This is required to compensate for a system-related relaxation of locking screws since tightening of a given screw will always relax adjacent screws. Without overtorquing, an infinite number of passes would be needed to reach specified tightening torque.
7. Reset torque wrench to specified torque (M_A) and check all locking screws. No screw should turn at this point, otherwise repeat Steps 6 and 7.

NOTE: 1. It is not necessary to re-check tightening torque after equipment has been in operation.

2. The torque capacity of these units can be increased by approximately 25% by thoroughly cleaning the shaft and Keyless Bushing bore of any lubricant. In applications subject to extreme corrosion, the slits in all collars should be sealed with a suitable caulking compound or equivalent. Likewise, push-off threads should be protected from corrosion.

INSTALLATION OF B-LOC® KEYLESS BUSHING OVER SHAFT KEYWAYS

The Keyless Bushing should be positioned so that slits in Keyless Bushing collars that contact the shaft are located approximately opposite the keyway. In addition, a locking screw should be centered directly over the keyway.

When tightening locking screws, it is important to follow the installation procedure outlined above, which specifies equal 1/4 turns of each locking screw. Failure to follow these instructions could result in excessive tightening of the screw over the keyway, possibly causing permanent deformation of the Keyless Bushing collars.

REMOVAL
(Refer to Figure 2)

Prior to initiating the following removal procedure, check to ensure that no torque or thrust loads are acting on the Keyless Bushing, shaft or any mounted components.

IMPORTANT! Make sure ends of locking screws used for removal are ground flat and are slightly chamfered to prevent damage to screw and collar threads during push-off.

1. Check to ensure that axial movement of collars - necessary for release of connection - is not restricted. Likewise, ensure that push-off threads are in good condition.
2. Relax all locking screws by approx. four (4) complete turns and transfer screws to all push-off threads located in flange of collar Item 1.
3. Release connection by evenly tightening all push-off screws (not exceeding 1/4 turns) in a diametrically opposite sequence.

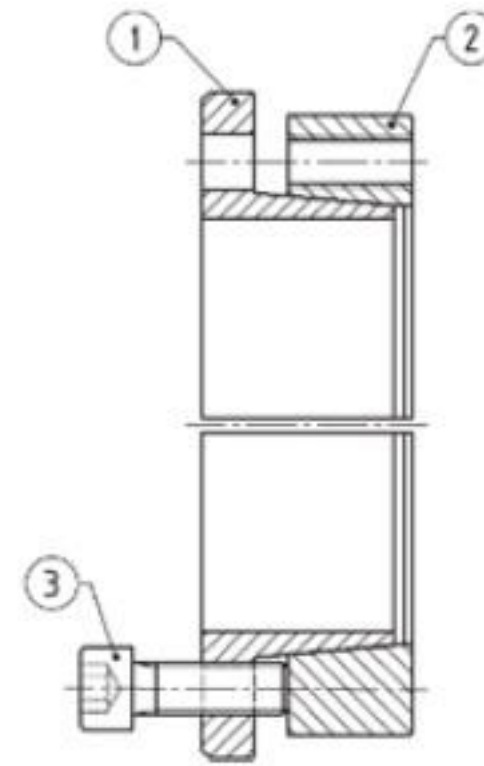


Figure 2

LOCKING SCREW SIZES AND SPECIFIED TIGHTENING TORQUE M_A						
Metric Series	Inch Series	Tightening Torque M_A (ft lb)		Screw Size	Hex Key Size (mm)	
		B106	B103			
20 x 47 to 40 x 65	3/4 to 1-1/2	12	10	M6	5	
45 x 75 to 65 x 95	1-5/8 to 2-9/16	30	25	M8	6	
70 x 110 to 95 x 135	2-11/16 to 3-3/4	60	50	M10	8	
100 x 145 to 120 x 165	3-15/16 to 4-3/4	105	90	M12	10	
130 x 180 to 200 x 260	4-15/16 to 8	166	135	M14	12	
220 x 285 to 260 x 325		257	219	M16	14	
280 x 355 to 300 x 375		350	290	M18	14	
320 x 405 to 340 x 425		500	420	M20	17	
360 x 455 to 400 x 495		675	560	M22	17	



SEE SHEET 1 FOR ASSEMBLY, BOM

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MAGNUM JOB #: 1875

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

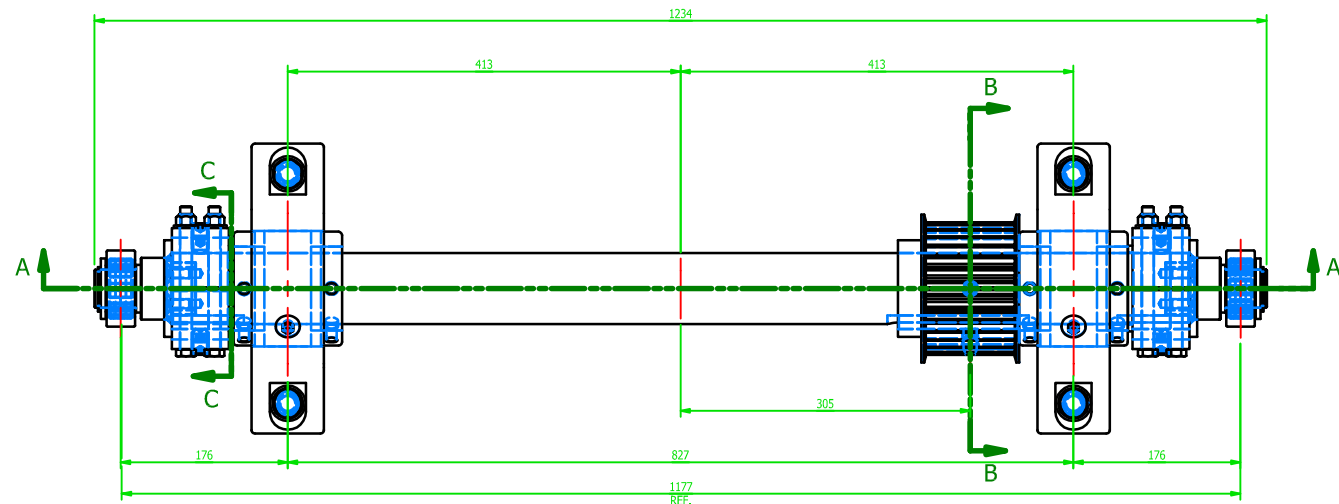
GENERAL NOTES:
MATERIALS:
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- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
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WELDS:
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COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

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CLIENT: VOLVO
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REV: B

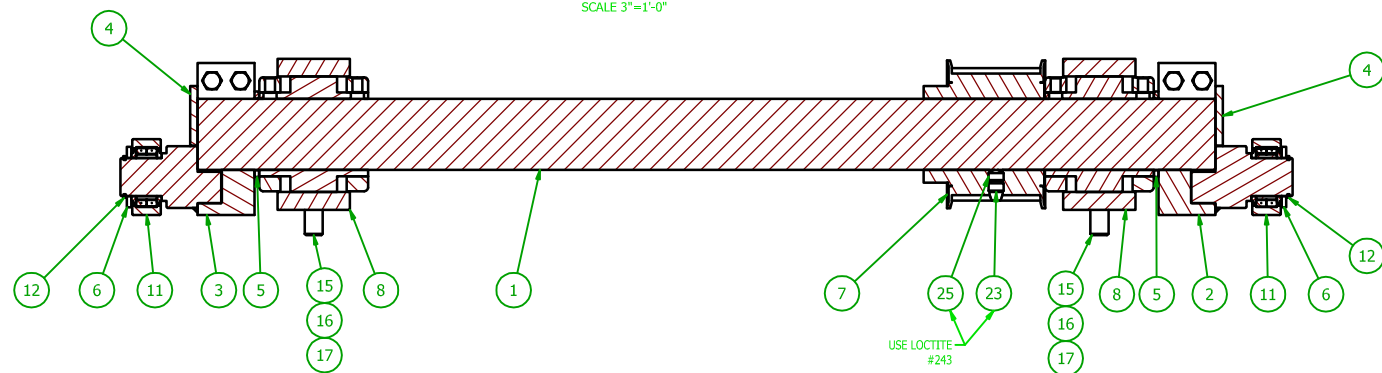
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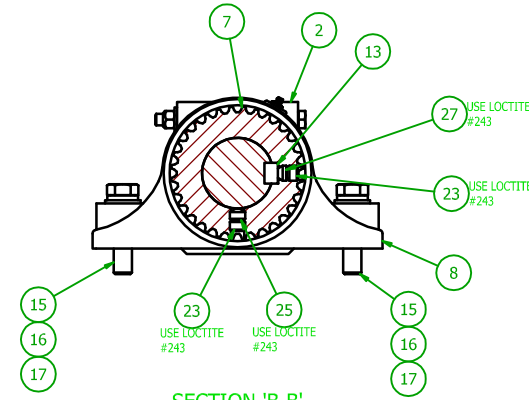
MK-D205A ~ 90 mm LIFTER SHAFT DRIVEN END ASSEMBLY

SCALE 3"=1'-0"



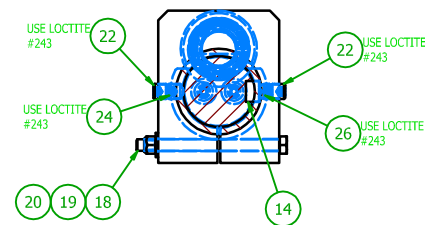
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SCALE 3"=1'-0"



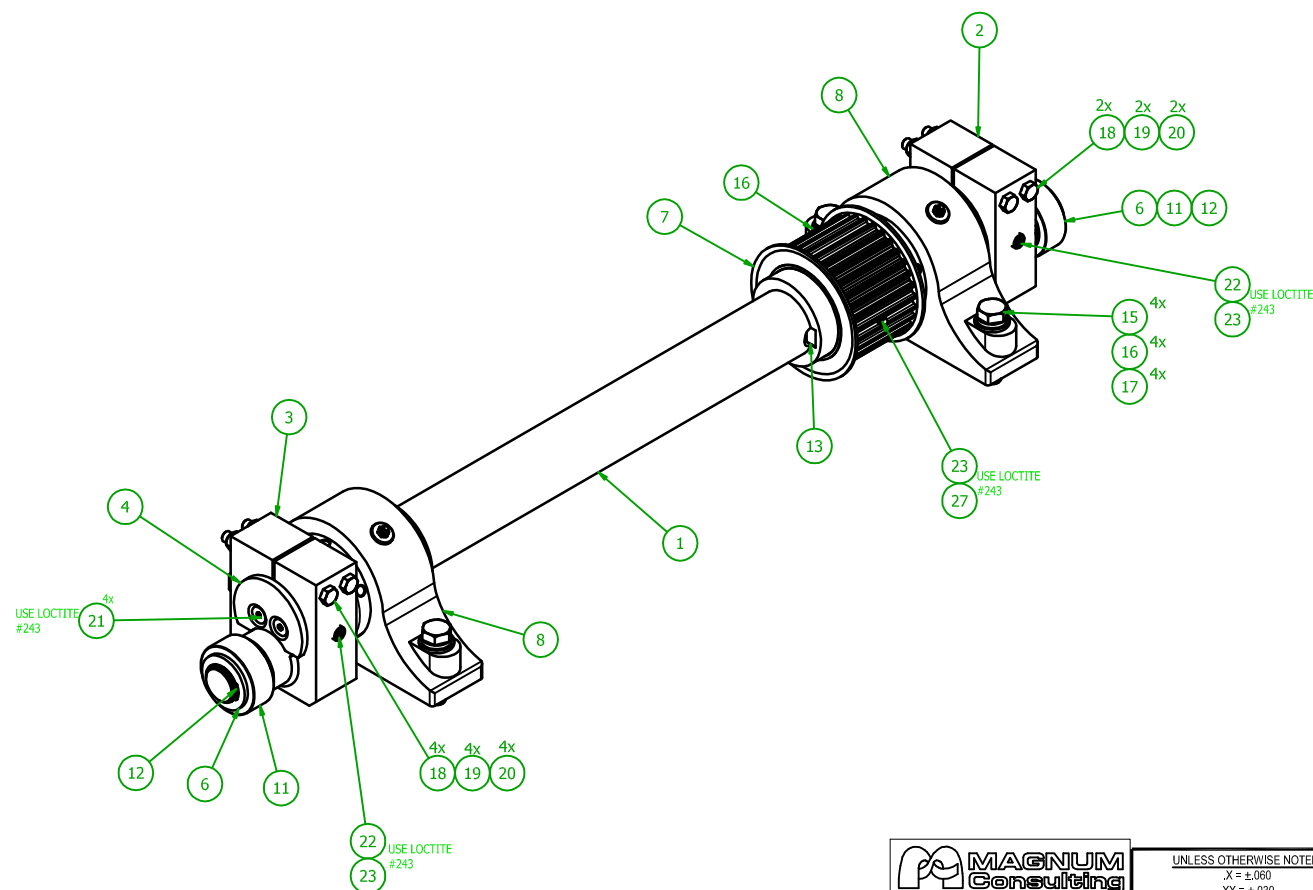
SECTION 'B-B'

SCALE 3"=1'-0"



SECTION 'C-C'

SCALE 3"=1'-0"



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D205A			
1	1	MK-D206A ~ LIFTER SHAFT			
2	1	MK-D208B ~ ECCENTRIC ROLLER CLAMP RIGHT HAND			
3	1	MK-D208A ~ ECCENTRIC ROLLER CLAMP ASSEMBLY - LH			
4	2	MK-D209A ~ LIFTER CAP			
5	2	MK-D209B ~ 90mm LIFTER SHAFT SPACER			
6	2	MK-D209C ~ ECCENTRIC ROLLER SPACER			
7	1	MK-D228A ~ GATES 32 TOOTH SPROCKET		5-2	
8	2	DODGE 2 15/16" TYPE 'E' PILLOW BLOCK #P2B-E-215R		5-1	
11	2	YOKE TYPE ROLLER, INA PART-NO NUTR-40		5-7	
12	2	BLACK-FINISH STEEL EXTERNAL RETAINING RING, McMASTER PART-NO 98541A156		5-8	
13	1	22 x 14 x 125 LG. SQ. KEYSTOCK			
14	2	22 x 14 x 63 LG. SQ. KEYSTOCK			
15	4	3/4-10UNC x 3 1/4" LG. HEX HEAD CAP SCREW			
16	4	3/4 TYPE A NARROW FLAT WASHER			
17	4	3/4 SPRING LOCK WASHER			
18	4	M12x1.75 x 150mm LG. HEX CAP SCREW			
19	4	M12 NARROW FLAT WASHER			
20	4	M12 x 1.75 STOVER LOCK NUT			
21	4	M10x1.5 x 25mm LG. FLAT HEX SOCKET HEAD CAP SCREW			
22	4	M16x2 x 16mm LG. HEX SOCKET OVAL POINT SET SCREW			
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24	2	M16x2 x 16mm LG. HEX SOCKET CONE POINT SET SCREW			
25	1	M16x2 x 12mm LG. HEX SOCKET CONE POINT SET SCREW			
26	2	M16x2 x 12mm LG. HEX SOCKET CUP POINT SET SCREW			
27	1	M16x2 x 10mm LG. HEX SOCKET CUP POINT SET SCREW			
		TOTAL WEIGHT ~ 144.2 lbs			

SHAFT/KEYWAY NOTE:

ALL SPROCKETS, CAM ARMS, COUPLINGS & OTHER ITEMS WITH KEYS & SET SCREW ARE TO HAVE (1) CUP POINT SET SCREW OVER KEY & (1) CONE POINT SET SCREW @ 90 DEGREES OVER SHAFT, SPOT DRILL SHAFTS FOR ALL CONE POINT SET SCREWS, BOTH CUP & CONE POINT TO BE BACKED UP BY OVAL POINT SET SCREWS

SHOP NOTES:

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REV	BY	MC	DATE	DESCRIPTION	APP
A		MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

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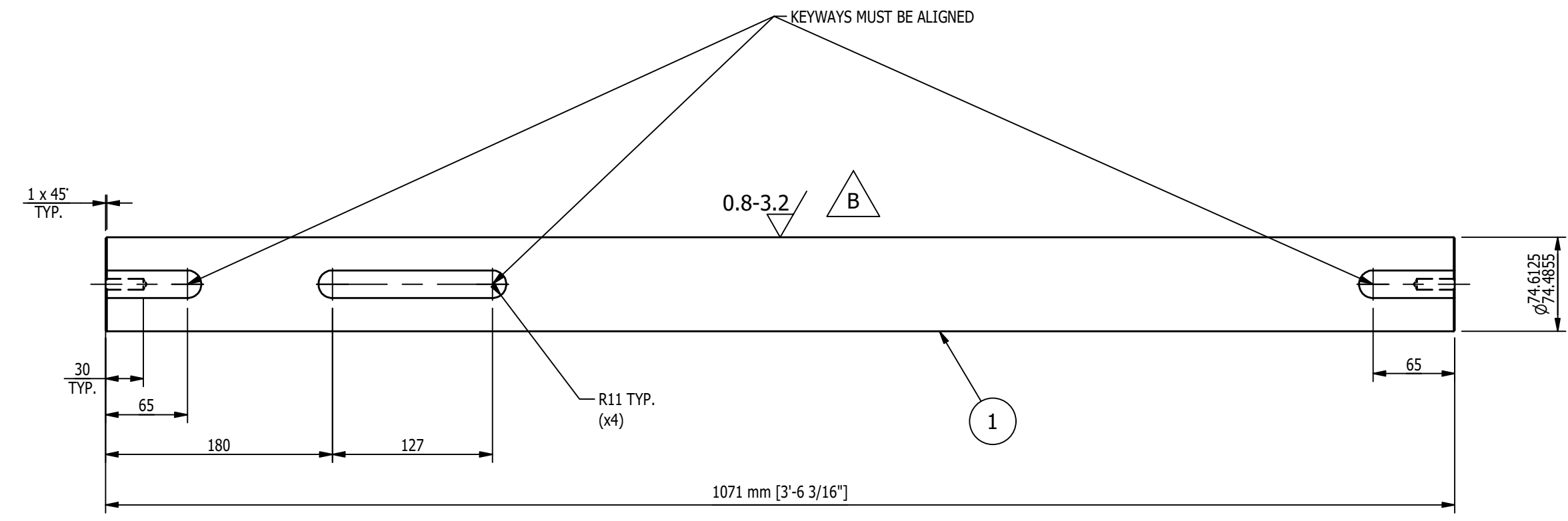
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CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D205	DWG DATE: 6/20/22
REV: A	JOB No: 22096

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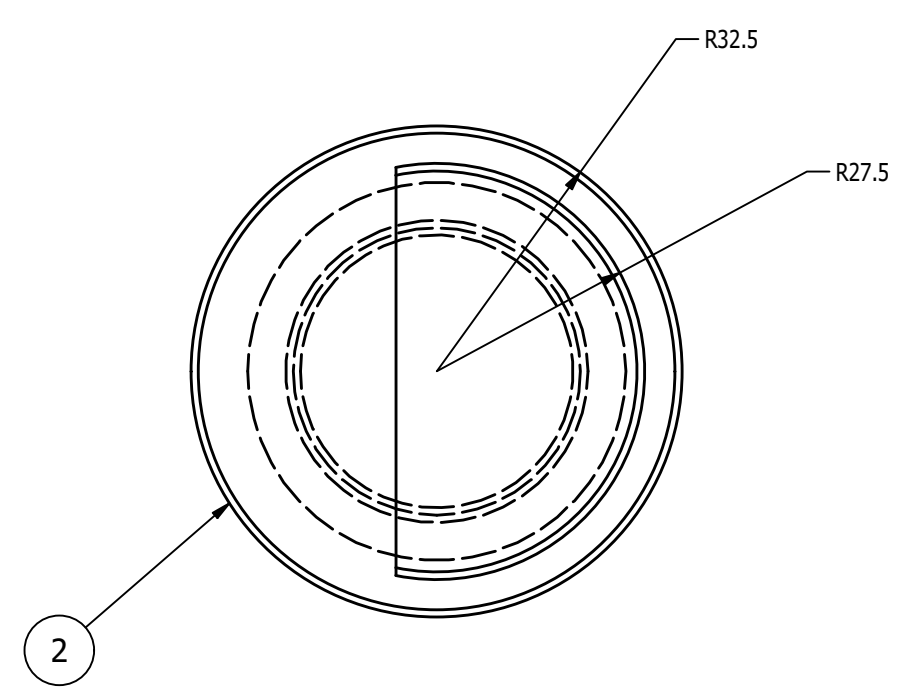
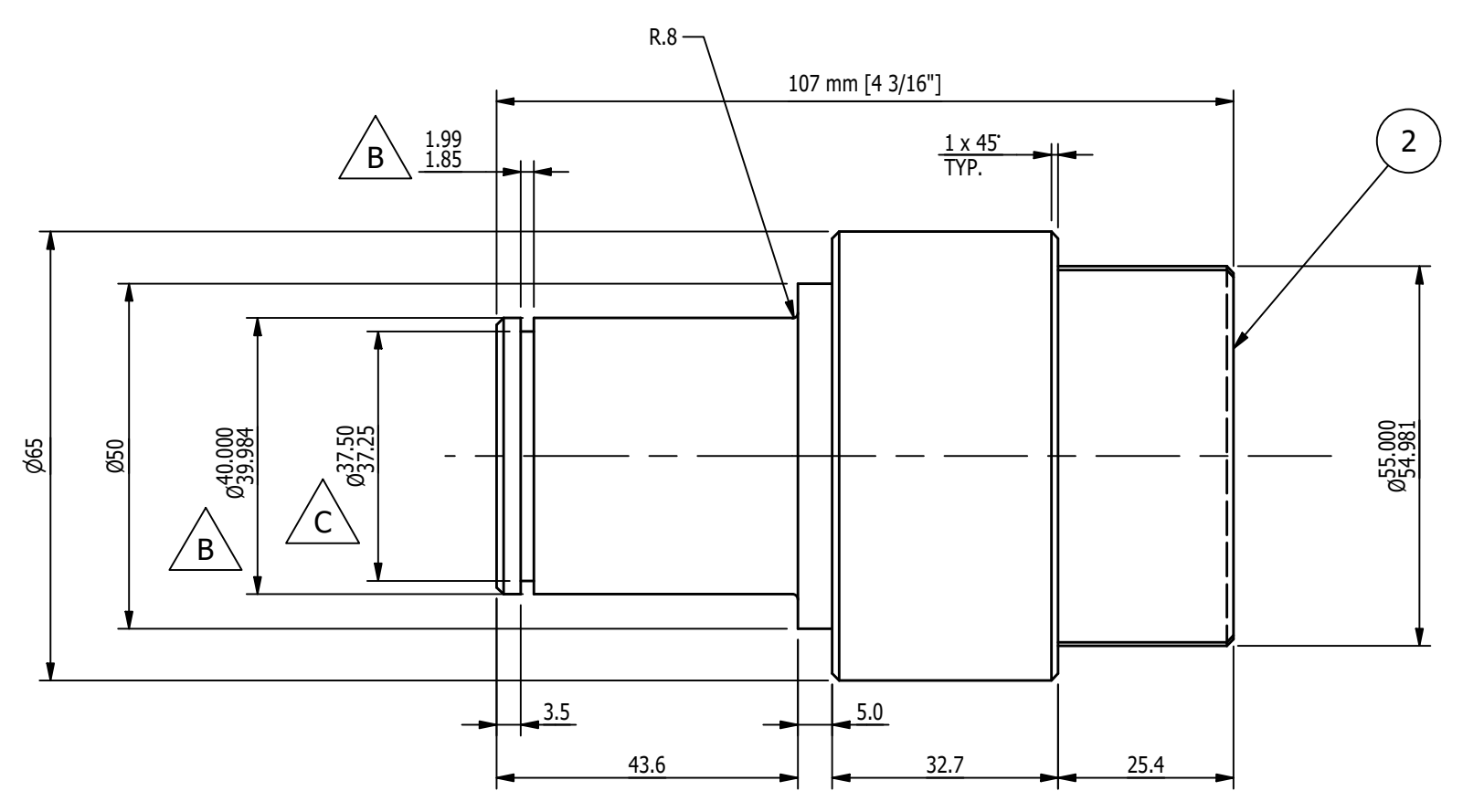
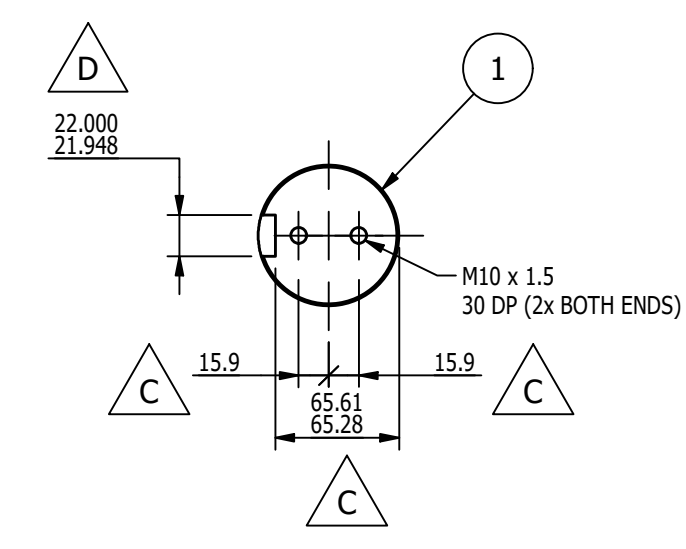
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BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D206A			
1	1	2 15/16" DIA (1045 C.R.S.)	3'-6 3/16"		
		TOTAL WEIGHT ~ 80 lbs			
		MK-DD206B			
2	1	2 3/4" DIA. (1045)	4 3/16"		
		TOTAL WEIGHT ~ 0.5 lbs			



MK-D206A ~ LIFTER SHAFT
SCALE 3"=1'-0"



MK-DD206B ~ ECCENTRIC ROLLER SHAFT
SCALE 1'-0" = 1'-0"

- SHOP NOTES:**
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 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
D	MC	7/28/2022	REVISED TOL	
C	MC	7/27/2022	DIM TOL'S REVISED	
B	MC	7/13/2022	TOLERANCES ADDED	
A	MC	7/5/2022	FOR FABRICATION	

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D206	DRAWN BY: PWP CHECKED BY: CW DWG DATE: 6/20/22 REV: D JOB No: 22096

MAGNUM CONSULTING
 41100 Charleston Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D206 - REV D

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

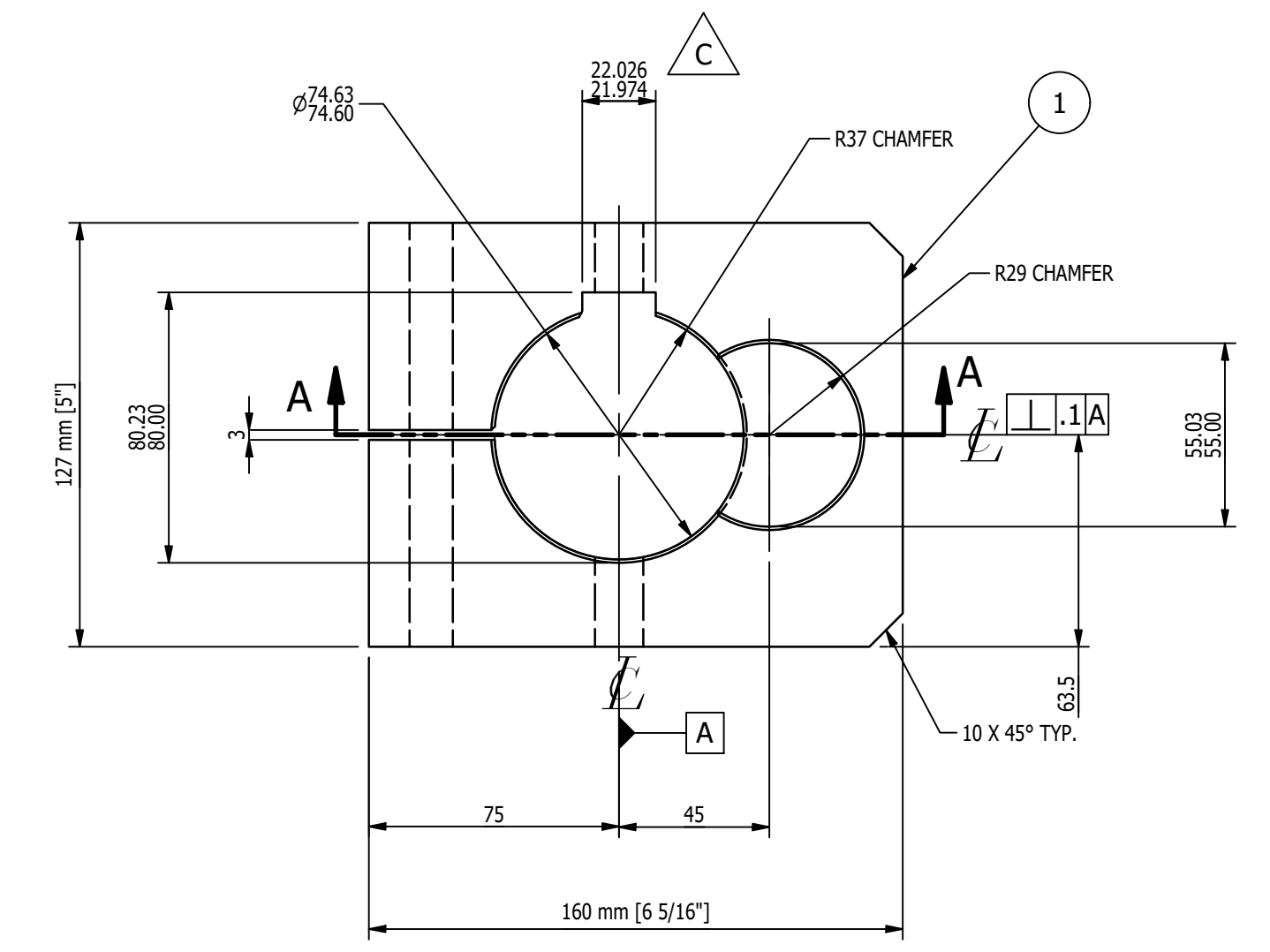
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

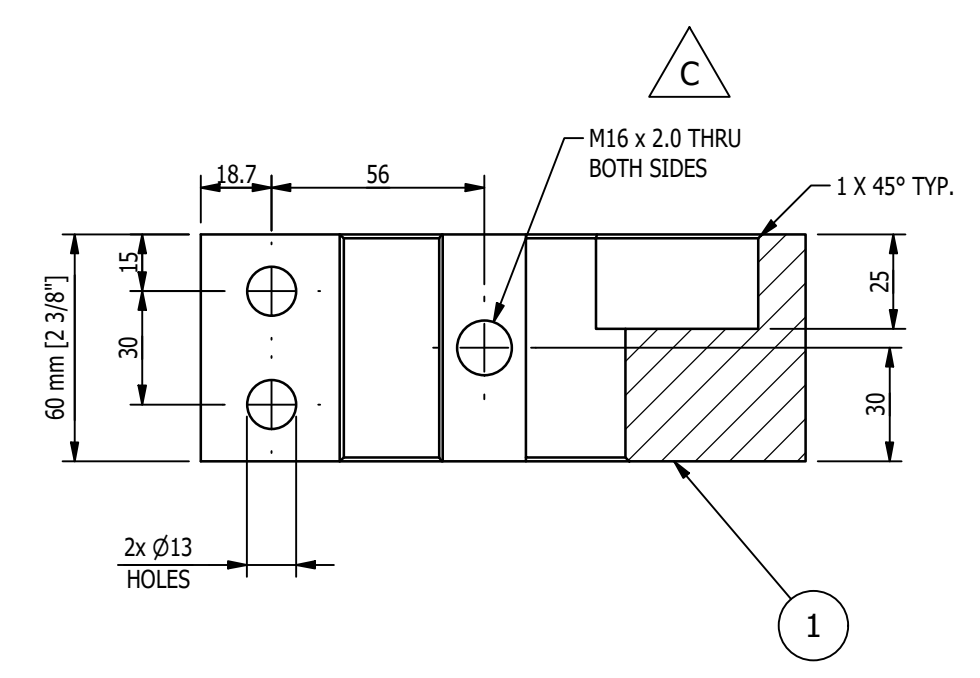
COPIES:

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

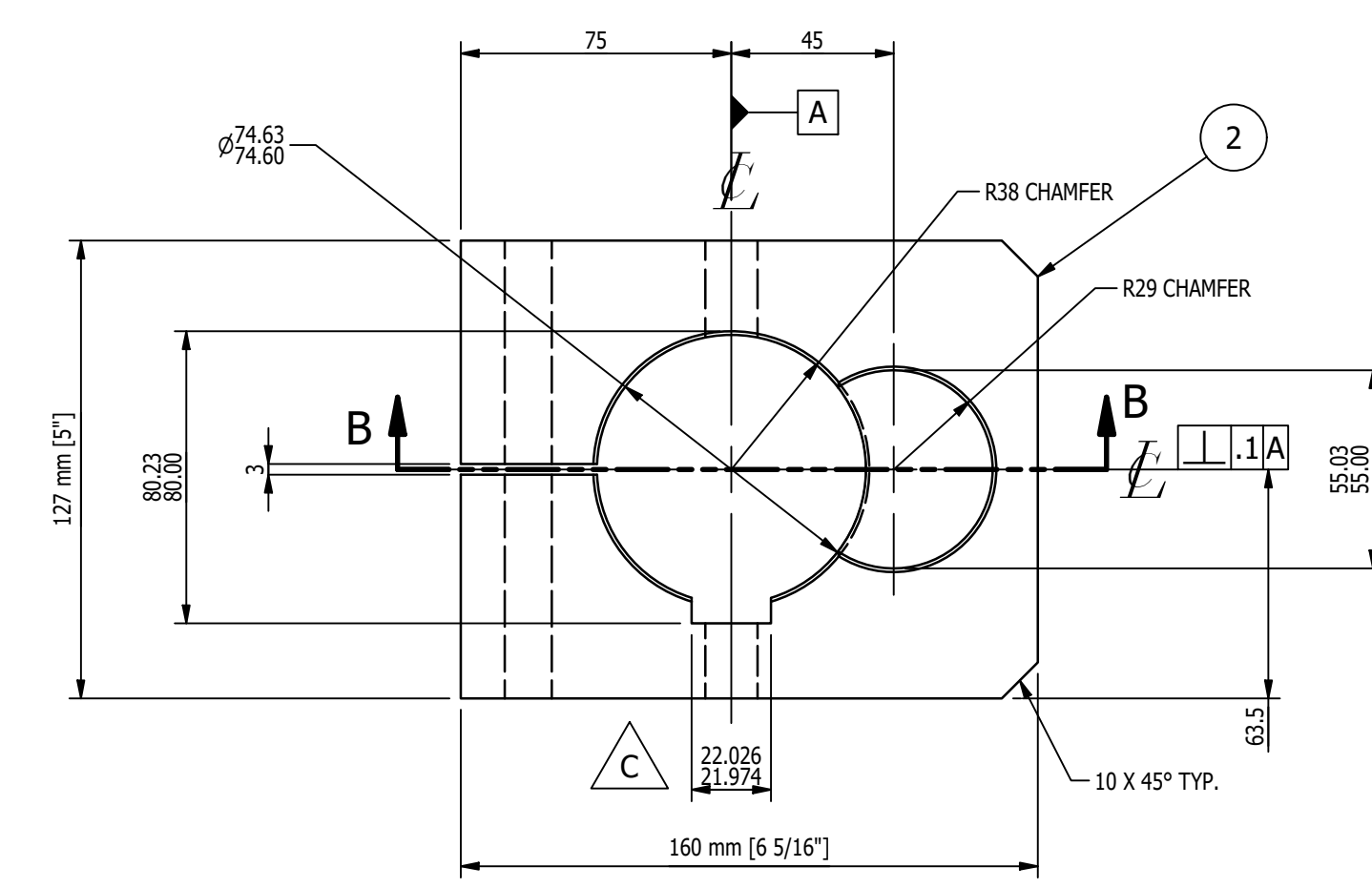
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D207A			
1	1	BAR 2 1/2" x 5" (1045)	6 5/16"		
		TOTAL WEIGHT ~ 14.7 lbs			
		MK-D207B			
2	1	BAR 2 1/2" x 5" (1045)	6 5/16"		
		TOTAL WEIGHT ~ 14.7 lbs			



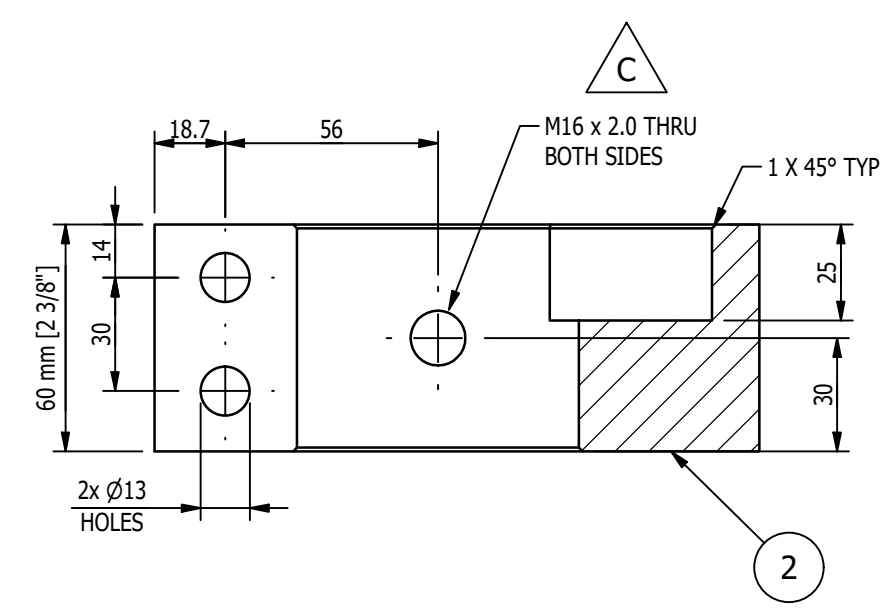
MK-D207A ~ ECCENTRIC ROLLER CLAMP LEFT HAND
SCALE 6"=1'-0"



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



MK-D207B ~ ECCENTRIC ROLLER CLAMP RIGHT HAND
SCALE 6"=1'-0"



SECTION 'B-B'
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:
 B BLACK OXIDE
 DO NOT COAT MACHINED SURFACES

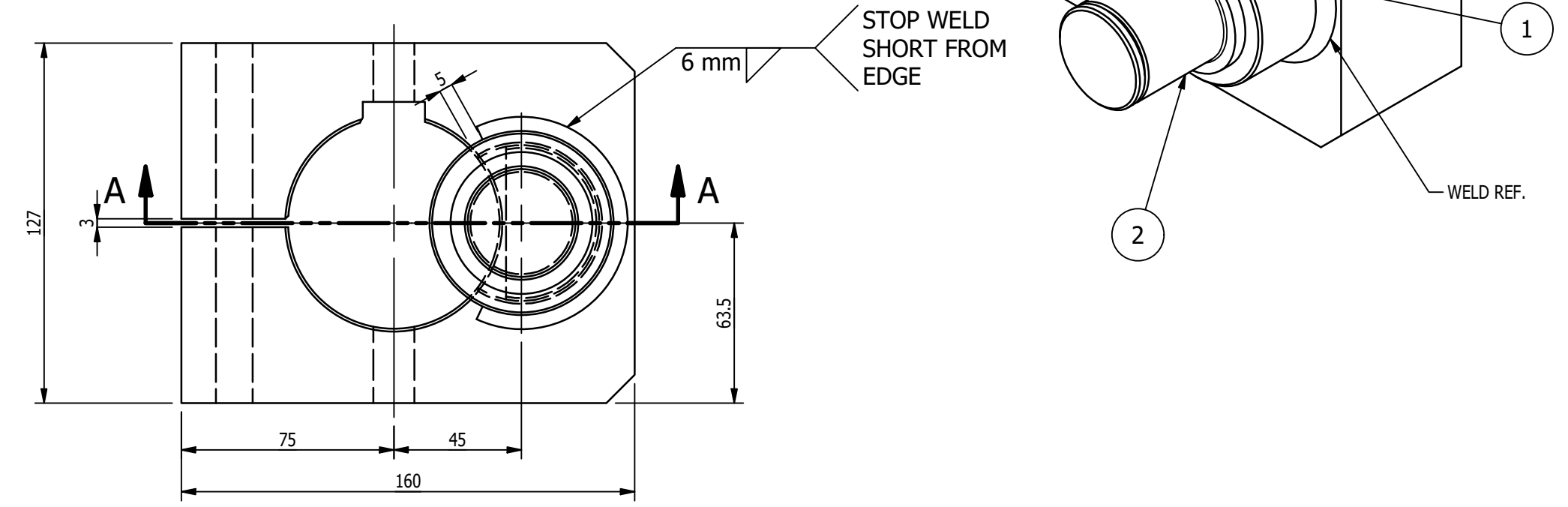
REV	BY	DATE	DESCRIPTION	APP
C	MC	7/27/2022	DIM TOL'S REVISED, HOLE NOTE REVISED	
B	MC	7/14/2022	PAINT NOTE REVISED, DIM TOL'S REVISED	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
		FENTON, MI 48430		DRAWING IS THE SOLE PROPERTY	
		PH: 810.373.0322 FAX: 810.373.0326		OF MILLER INDUSTRIES. ANY	
		www.millic.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: PWP		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 6/20/22		JOB No: 22096	
DRAWING No. 1875D207		REV: C			

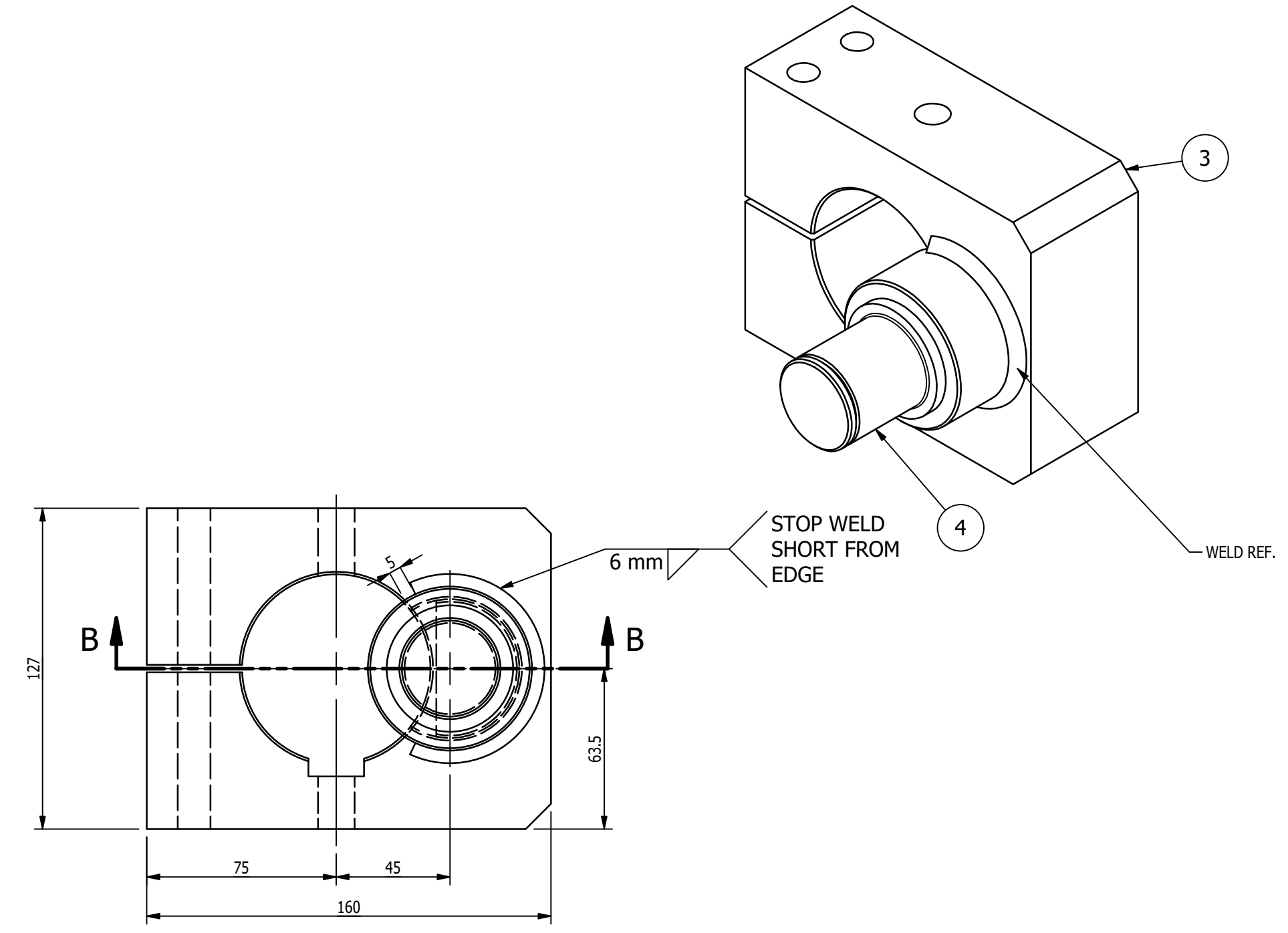
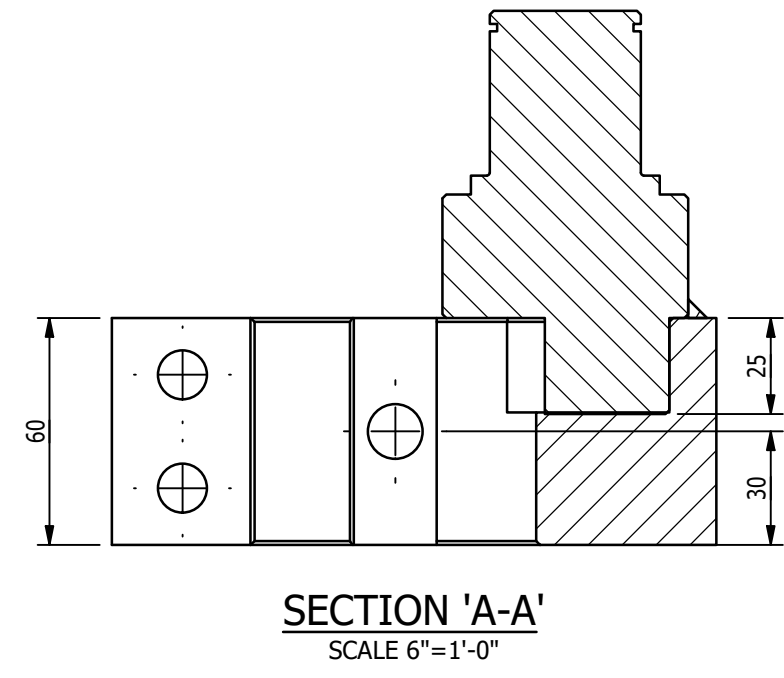
MAGNUM CONSULTING
 41100 Dardickwood Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D207 - REV C

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

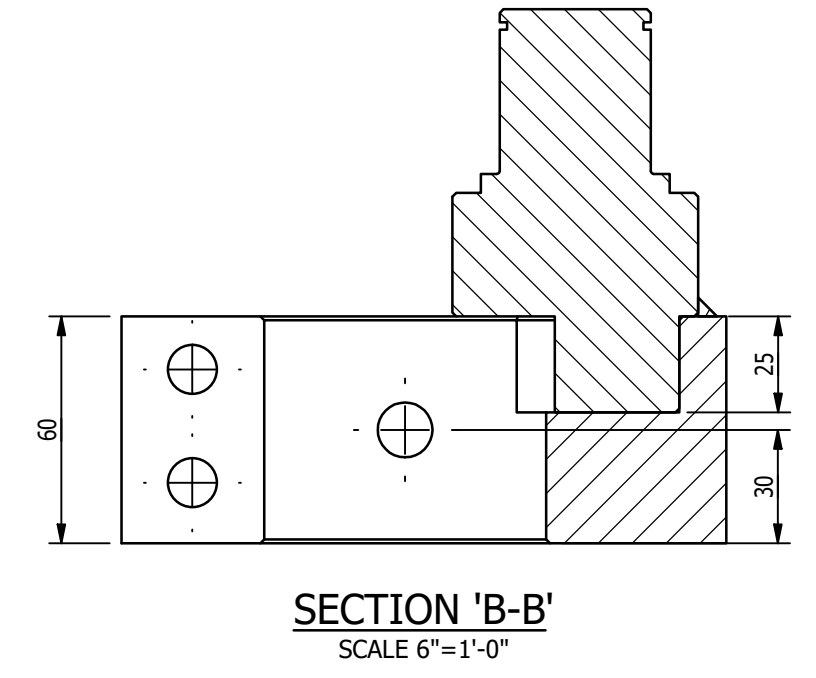
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO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



MK-D208A ~ ECCENTRIC ROLLER CLAMP ASSEMBLY - LH
SCALE 6"=1'-0"



MK-D208B ~ ECCENTRIC ROLLER CLAMP RIGHT HAND
SCALE 6"=1'-0"



BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
1	1	MK-D208A MK-D207A ~ ECCENTRIC ROLLER CLAMP LEFT HAND		
2	1	MK-DD206B ~ ECCENTRIC ROLLER SHAFT		
TOTAL WEIGHT ~ 15.2 lbs				
3	1	MK-D208B MK-D207B ~ ECCENTRIC ROLLER CLAMP RIGHT HAND		
4	1	MK-DD206B ~ ECCENTRIC ROLLER SHAFT		
TOTAL WEIGHT ~ 15.2 lbs				

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

PAINT NOTES:
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

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

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: PWP
CLIENT: VOLVO	CHECKED BY: XXX
DRAWING No. 1875D208	DWG DATE:
REV: A	JOB No: 22096

MAGNUM CONSULTING

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D208

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:

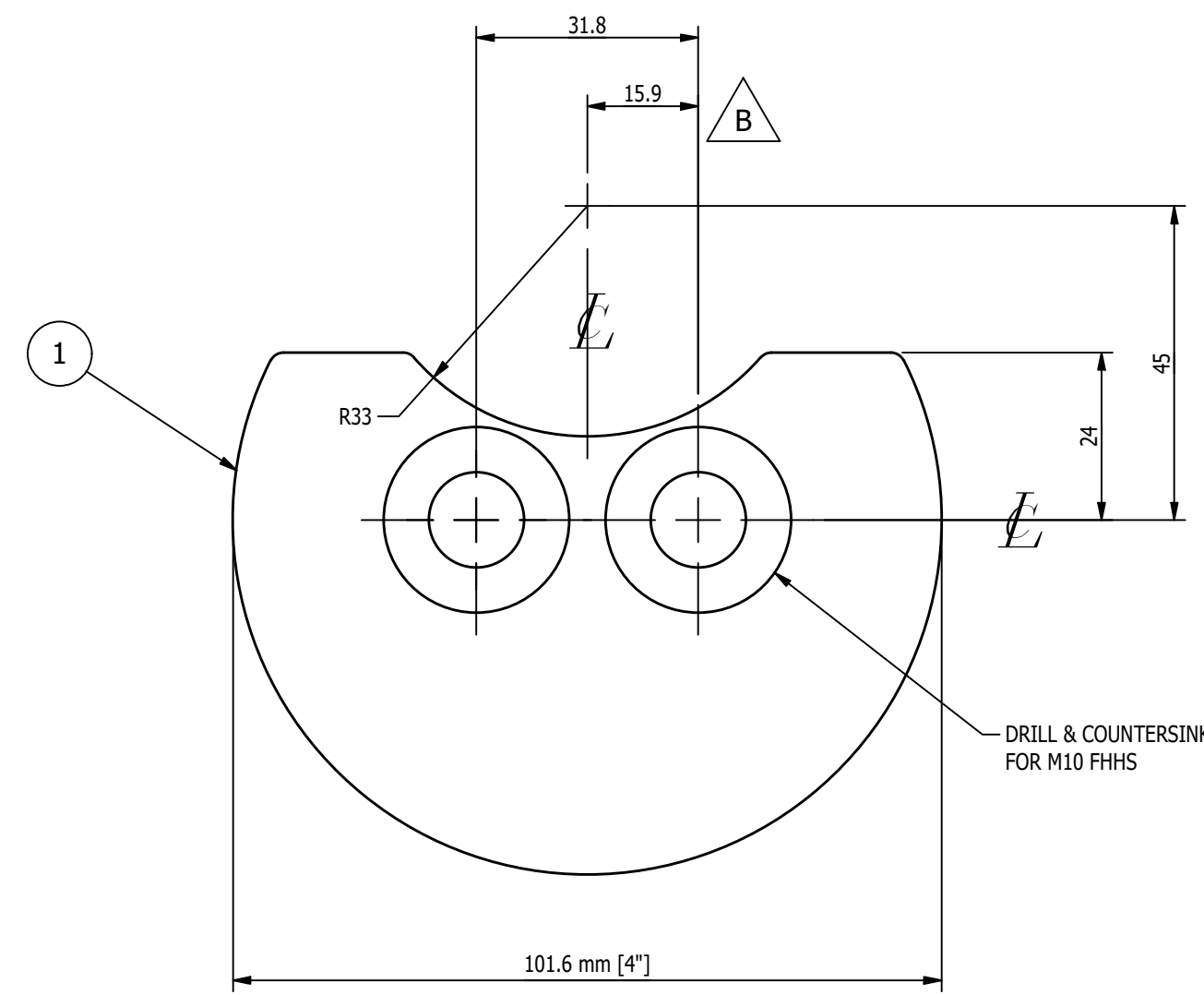
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

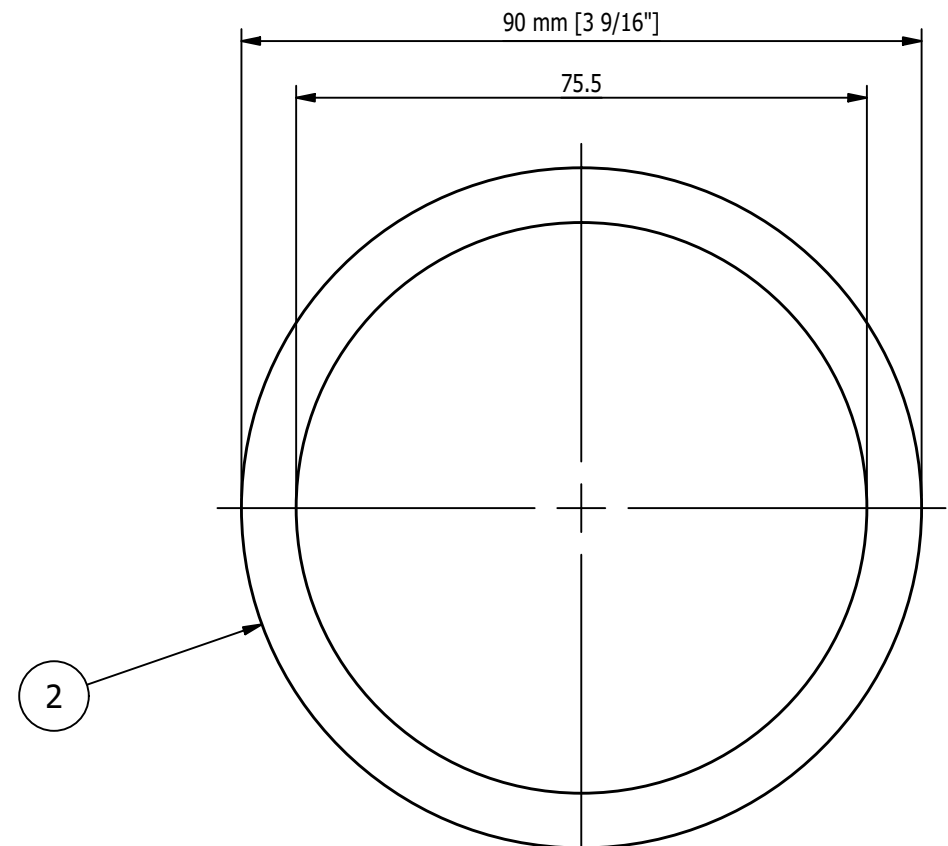
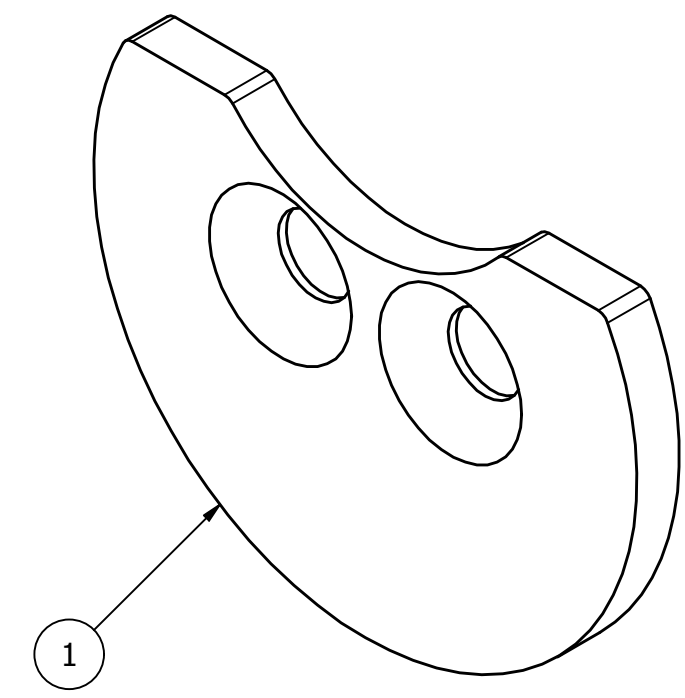
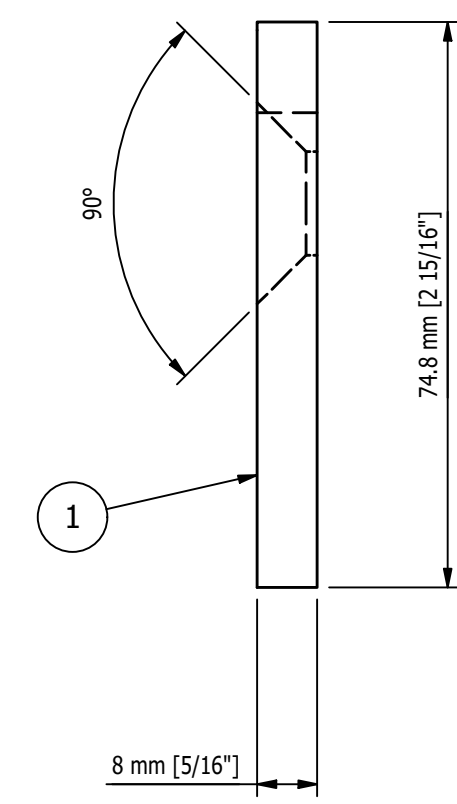
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

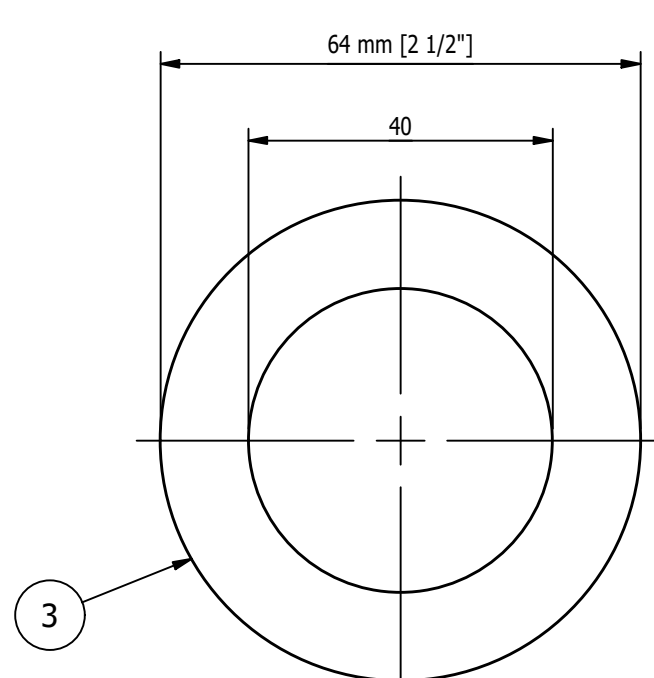
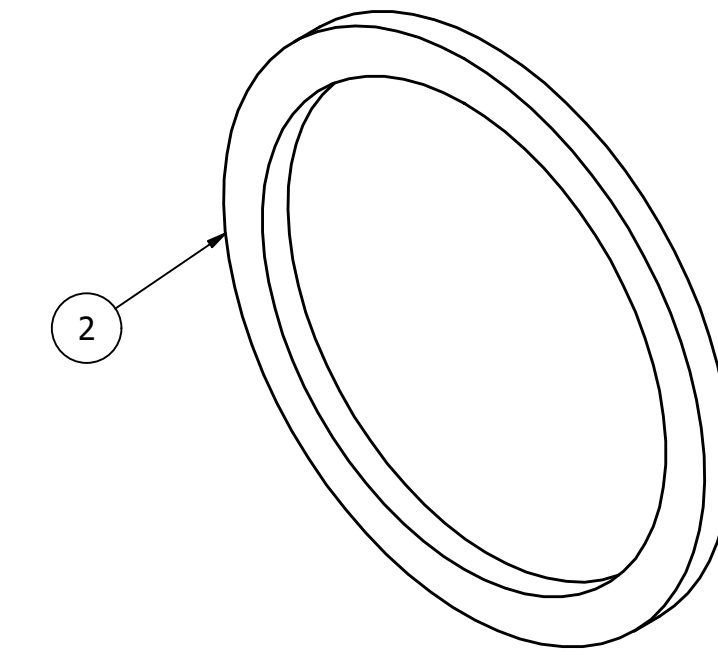
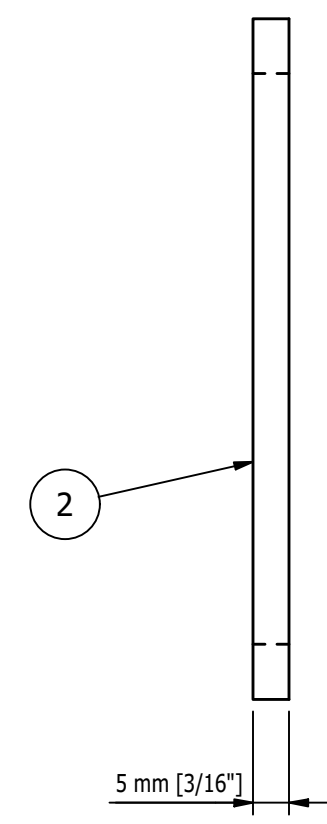
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



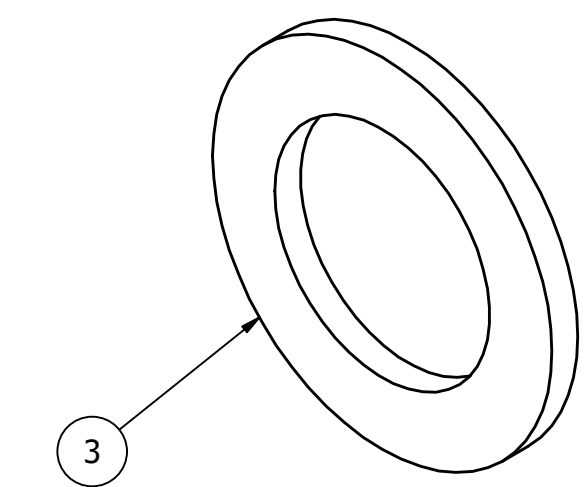
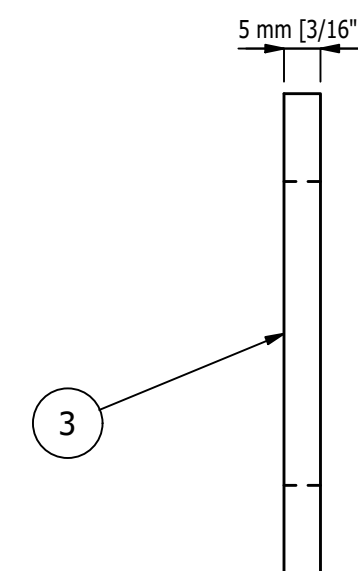
MK-D209A ~ LIFTER CAP
SCALE 1'-0" = 1'-0"



MK-D209B ~ 90mm LIFTER SHAFT SPACER
SCALE 1'-0" = 1'-0"



MK-D209C ~ ECCENTRIC ROLLER SPACER
SCALE 1'-0" = 1'-0"



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D209A			
1	1	BAR 5/16" x 4"	2 15/16"		
		TOTAL WEIGHT ~ 0.1 lbs			
		MK-D209B			
2	1	BAR 3 5/8" DIA	3/16"		
		TOTAL WEIGHT ~ 0 lbs			
		MK-D209C			
3	1	BAR 2 5/8" DIA	3/16"		
		TOTAL WEIGHT ~ 0 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:
B BLACK OXIDE

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/13/2022	PAINT NOTE REVISED, DIM ADDED	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: PWP	
MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		CHECKED BY: CW DWG DATE: 6/20/22	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		JOB No: 22096	
CLIENT: VOLVO		REV: B	
DRAWING No. 1875D209		JOB No: 22096	

MAGNUM CONSULTING
 41100 Charleston Rd.
 Suite 125
 Noris, MI 48235
 Phone: (248) 772-8822
 Fax: (248) 772-8821
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D209

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)

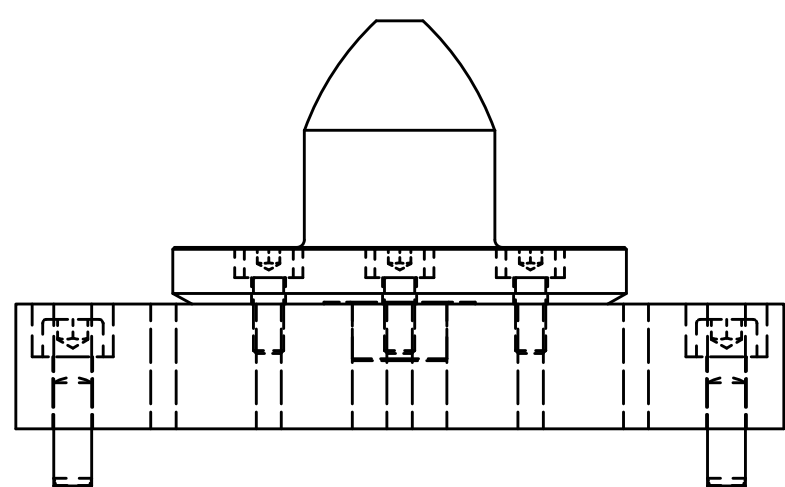
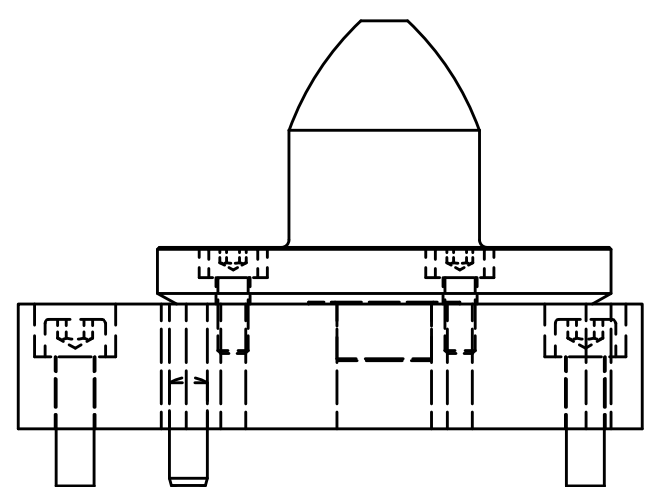
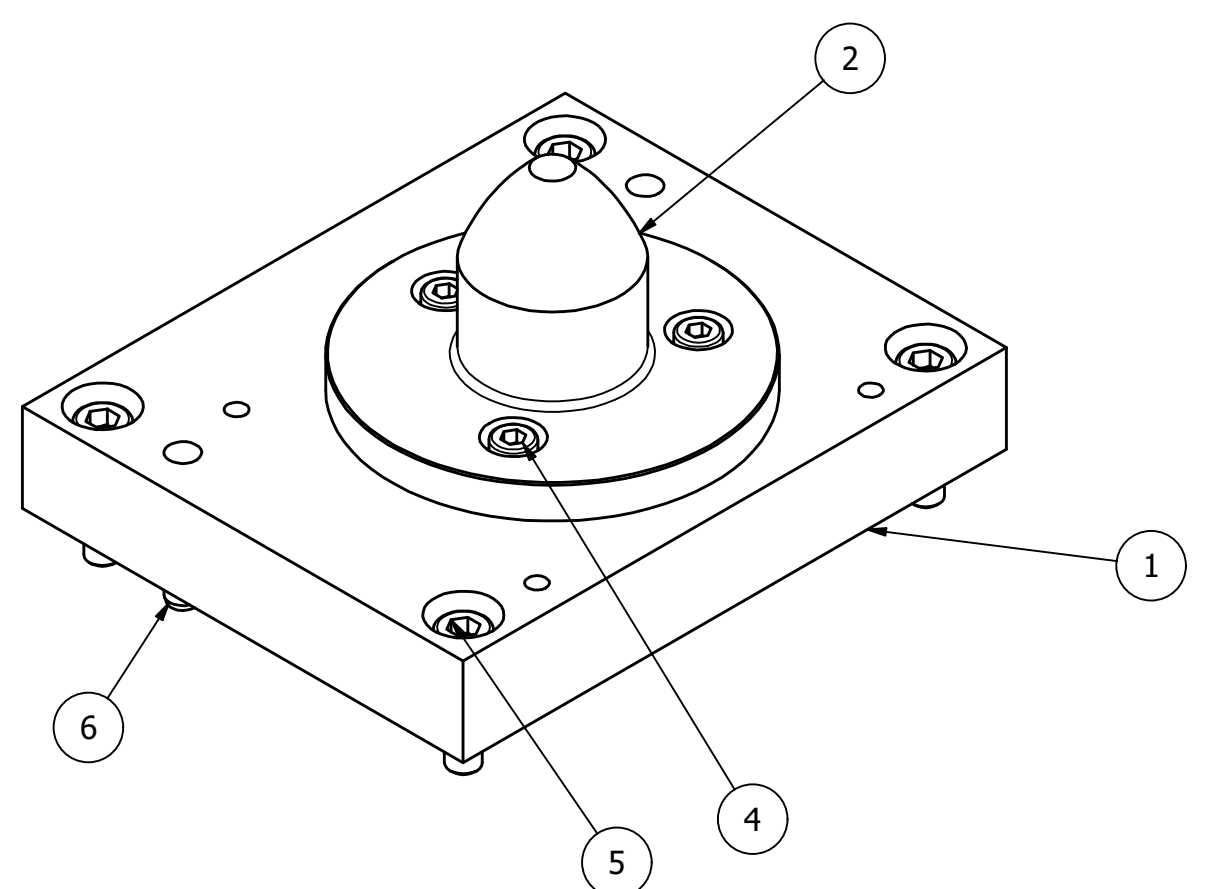
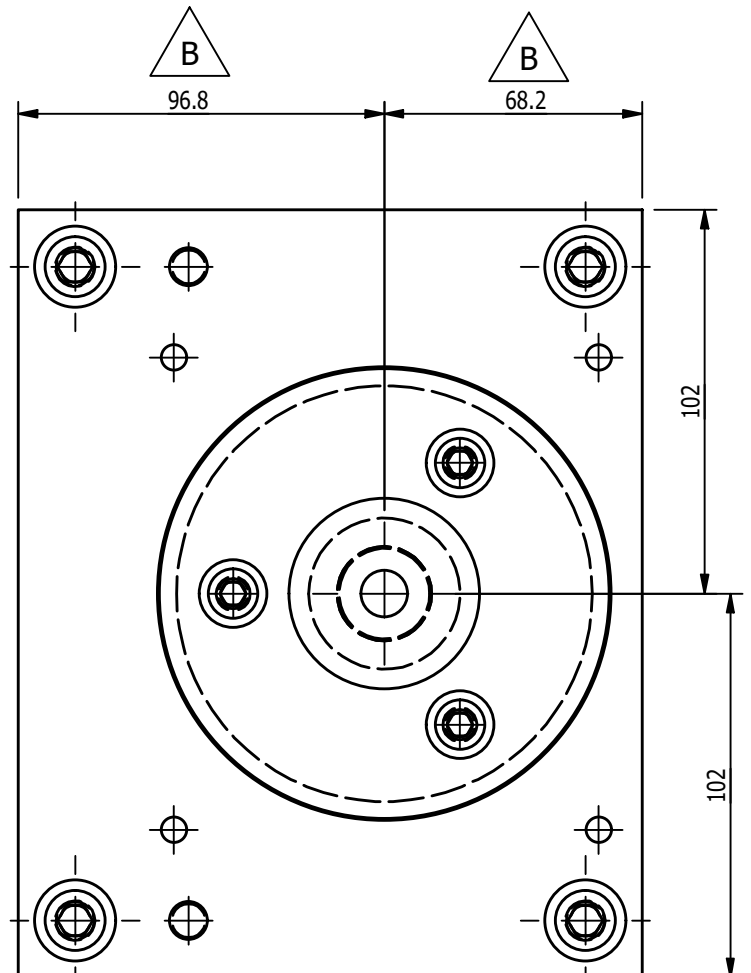
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D210A			
1	1	MK-D211A ~ 4 WAY PLATE			
2	1	MK-D212A ~ 4-WAY LOCATOR PIN			
4	3	M8x1.25 x 20mm LG. HEX SOCKET HEAD CAP SCREW			
5	4	M10x1.5 x 35mm LG. HEX SOCKET HEAD CAP SCREW			
6	2	10mm DIA x 30mm LG. DOWEL			
TOTAL WEIGHT ~ 23.1 lbs					



MK-D210A ~ 4 WAY LOCATOR PIN ASSEMBLY
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
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/5/2022	DIM 96.8 WAS 90, DIM 68.2 WAS 75	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

 MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
		TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D210

MAGNUM CONSULTING
 41100 QuakerRoad Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8821
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D210

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.

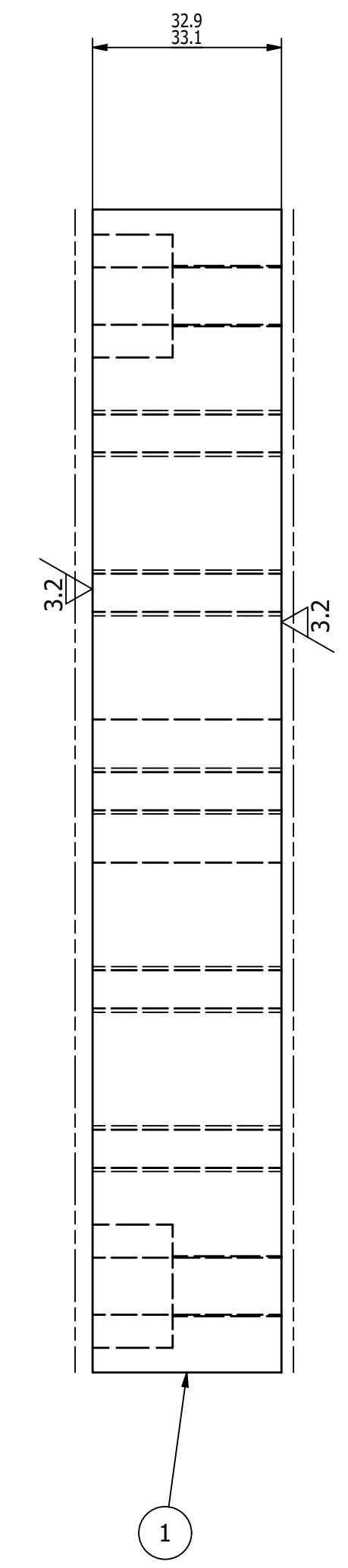
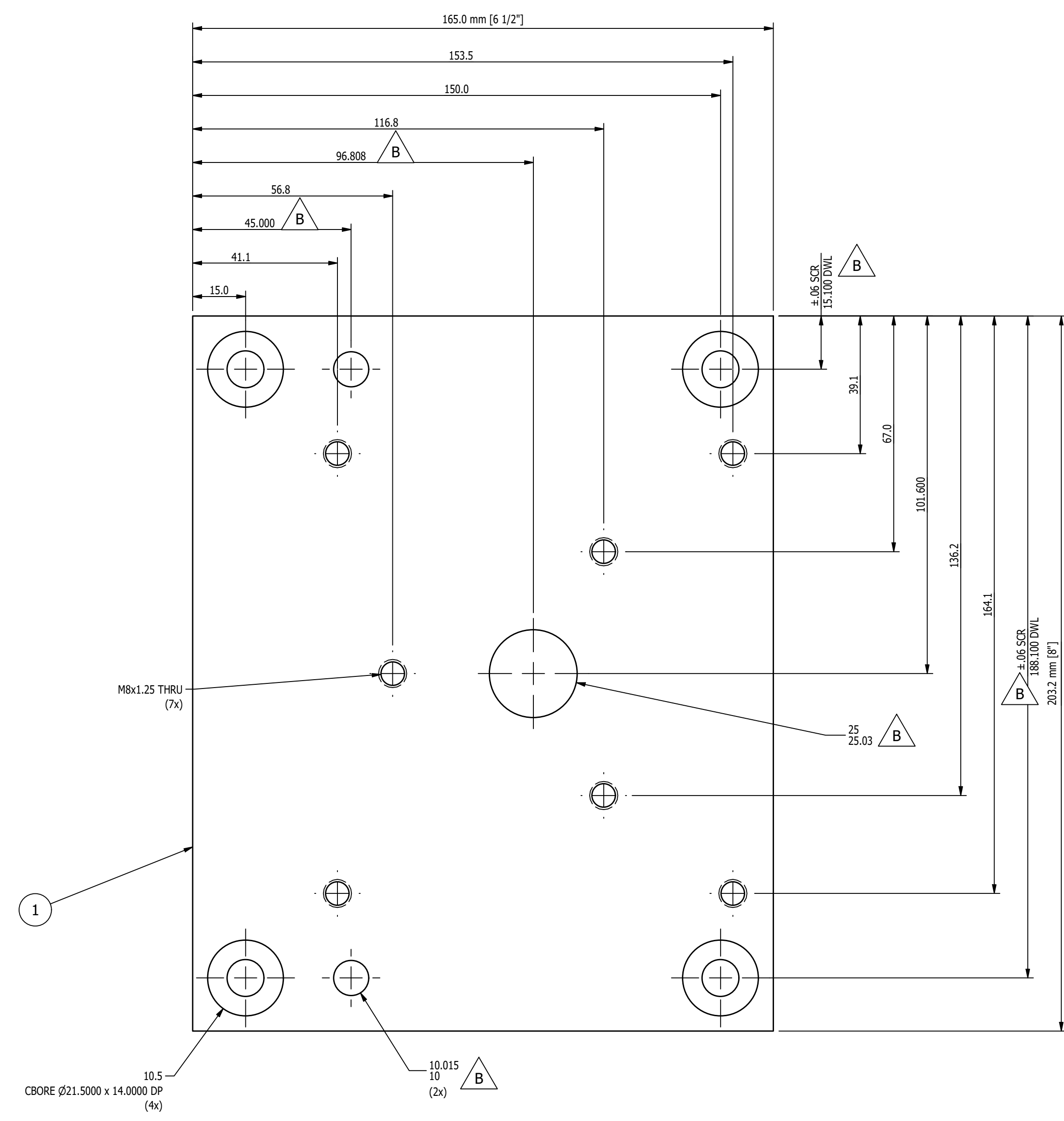
WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

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

DRAWN BY: PWP	CHECKED BY: CW	DWG DATE: 6/20/22
REV: B	JOB No: 22096	

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D211A			
1	1	BAR 1 1/2 x 8	6 1/2"		
TOTAL WEIGHT ~ 18.2 lbs					



MK-D211A ~ 4 WAY PLATE
SCALE 1'-0" = 1'-0"

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

PAINT NOTES:
BLACK OXIDE

REV	BY	DATE	DESCRIPTION	APP
C	MC	7/15/2022	PAINT NOTE REVISED	
B	MC	7/5/2022	DIM 45.000 WAS 38.1, DIM 96.808 WAS 90.0, SCR/DWL NOTE ADDED, HOLE TOL'S REVISED	
A	MC	7/5/2022	FOR FABRICATION	

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.

<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com</p>	<p>TITLE: P6700 CONVEYORS CAMPUS BUILDING</p>		<p>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</p>
	<p>CLIENT: VOLVO</p>	<p>DRAWN BY: PWP</p>	<p>CHECKED BY: CW</p>
<p>DRAWING No. 1875D211</p>	<p>REV: C</p>	<p>DWG DATE: 6/20/22</p>	<p>JOB No: 22096</p>

MAGNUM CONSULTING

41100 Charleston Rd.
Suite 125
Newport, MI 48751

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Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D211

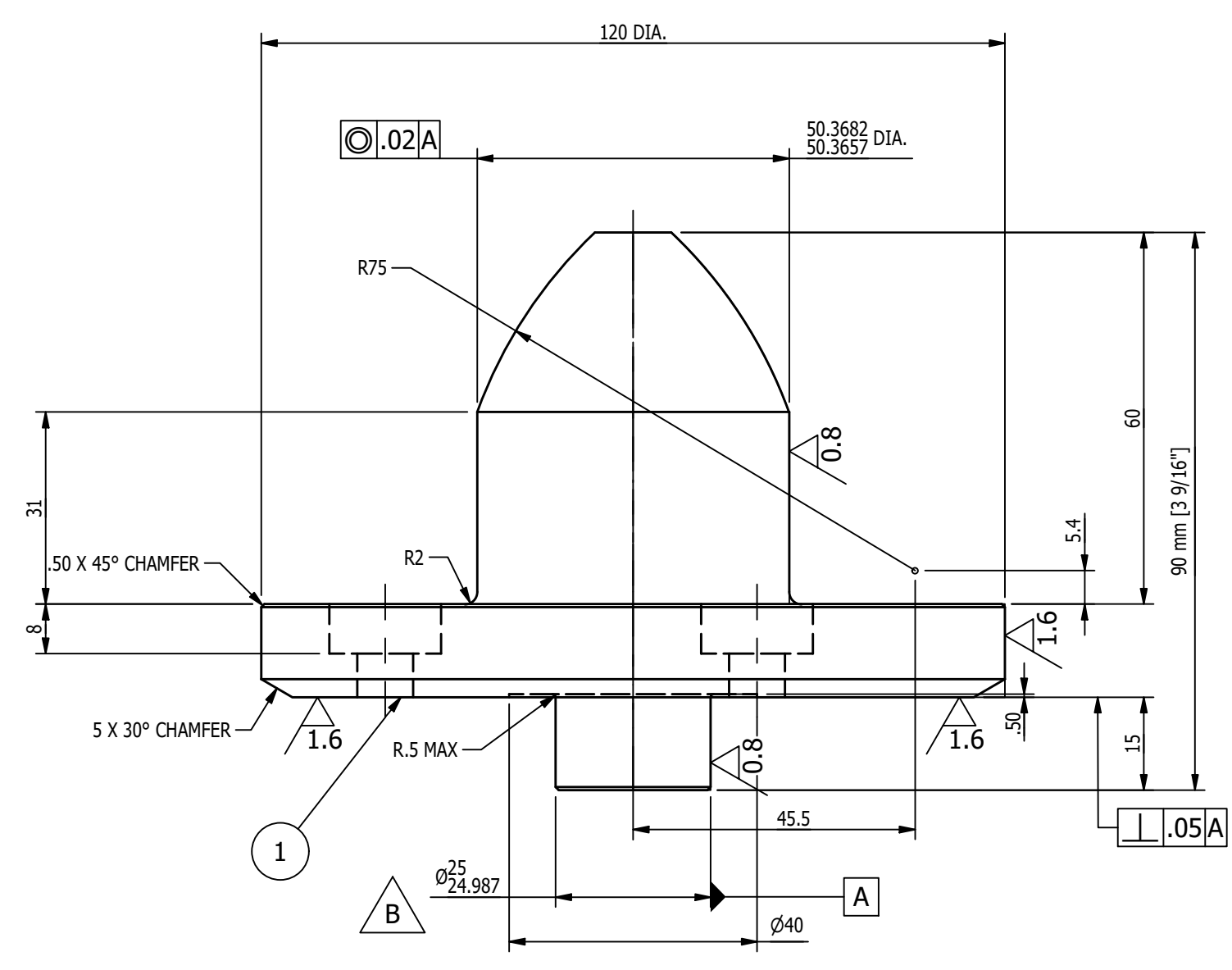
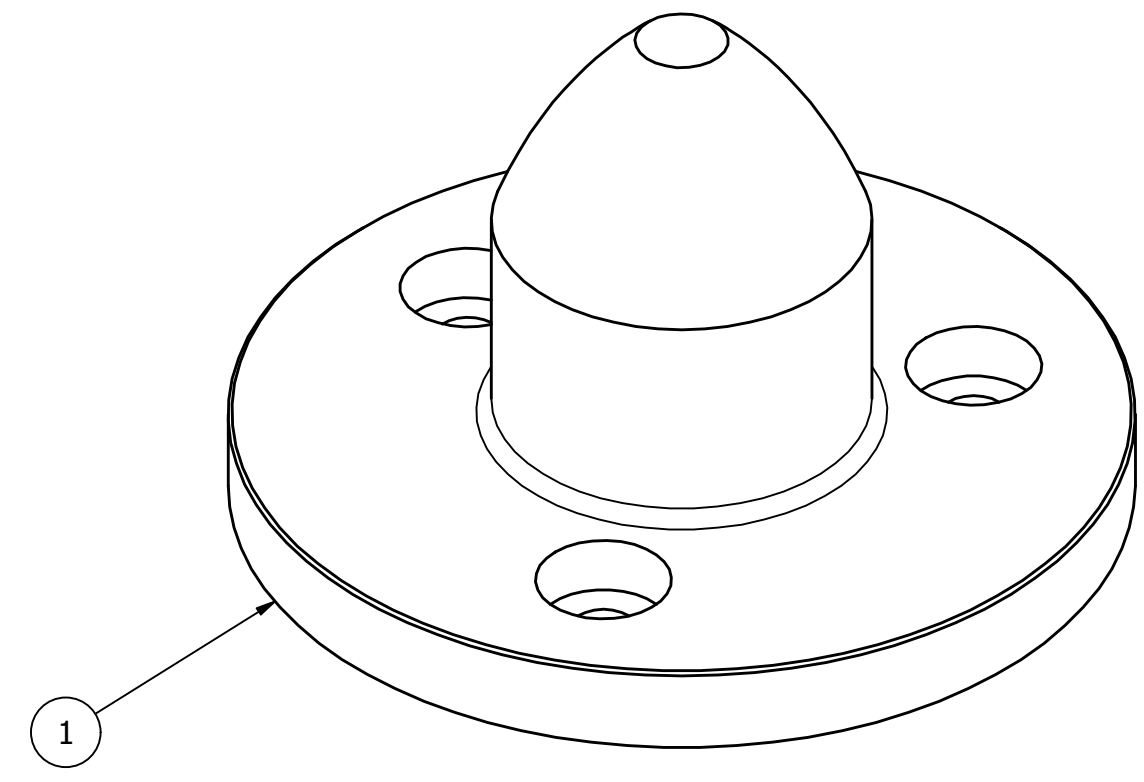
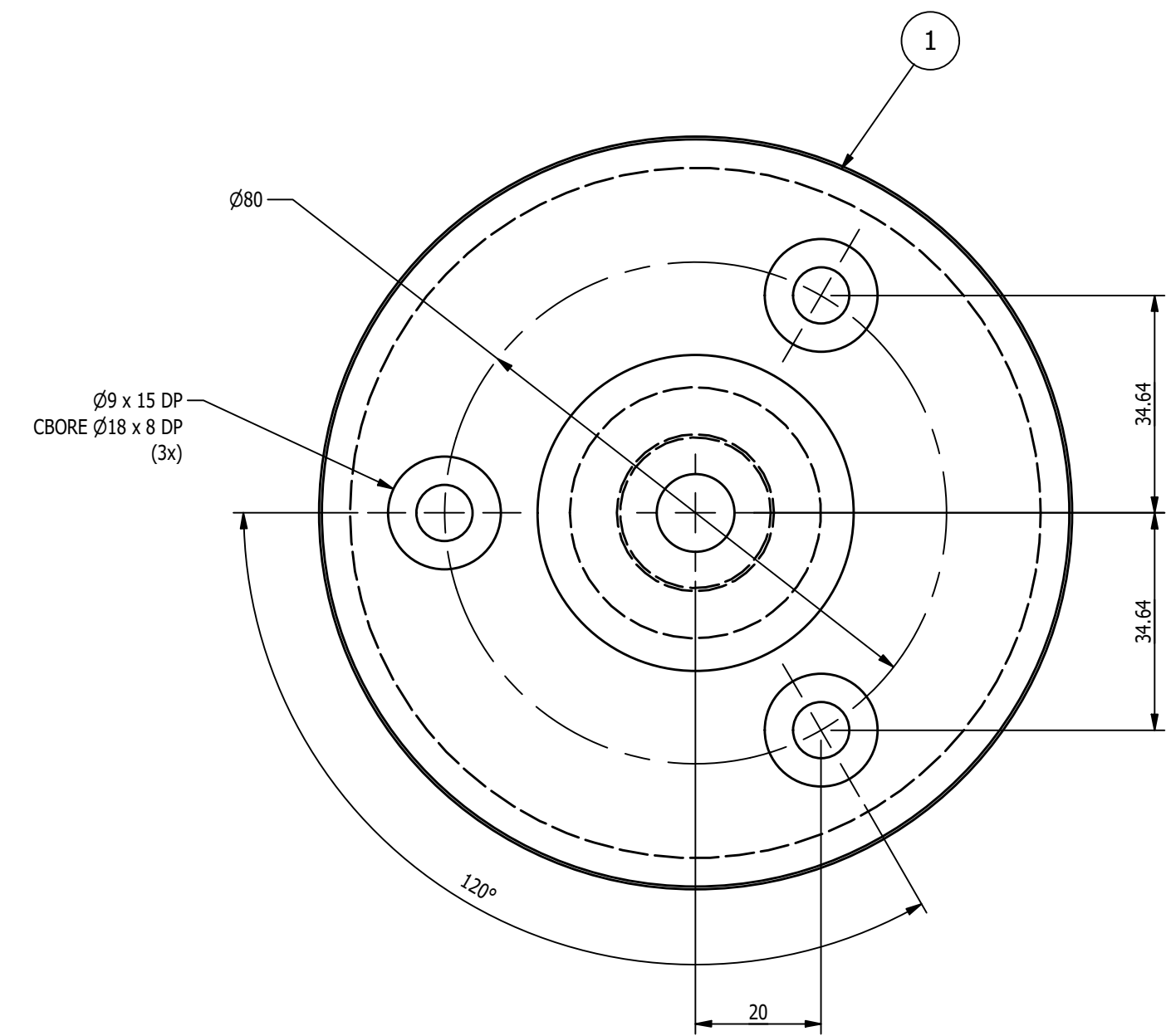
UNLESS OTHERWISE NOTED:

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-D212A			
1	1	BAR 4 3/4" DIA (A-2 TOOL STEEL CARB TO 54-58 RC)	3 9/16"		
TOTAL WEIGHT ~ 4.5 lbs					



MK-D212A ~ 4-WAY LOCATOR PIN
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:
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/14/2022	DIM TOL. REVISED	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

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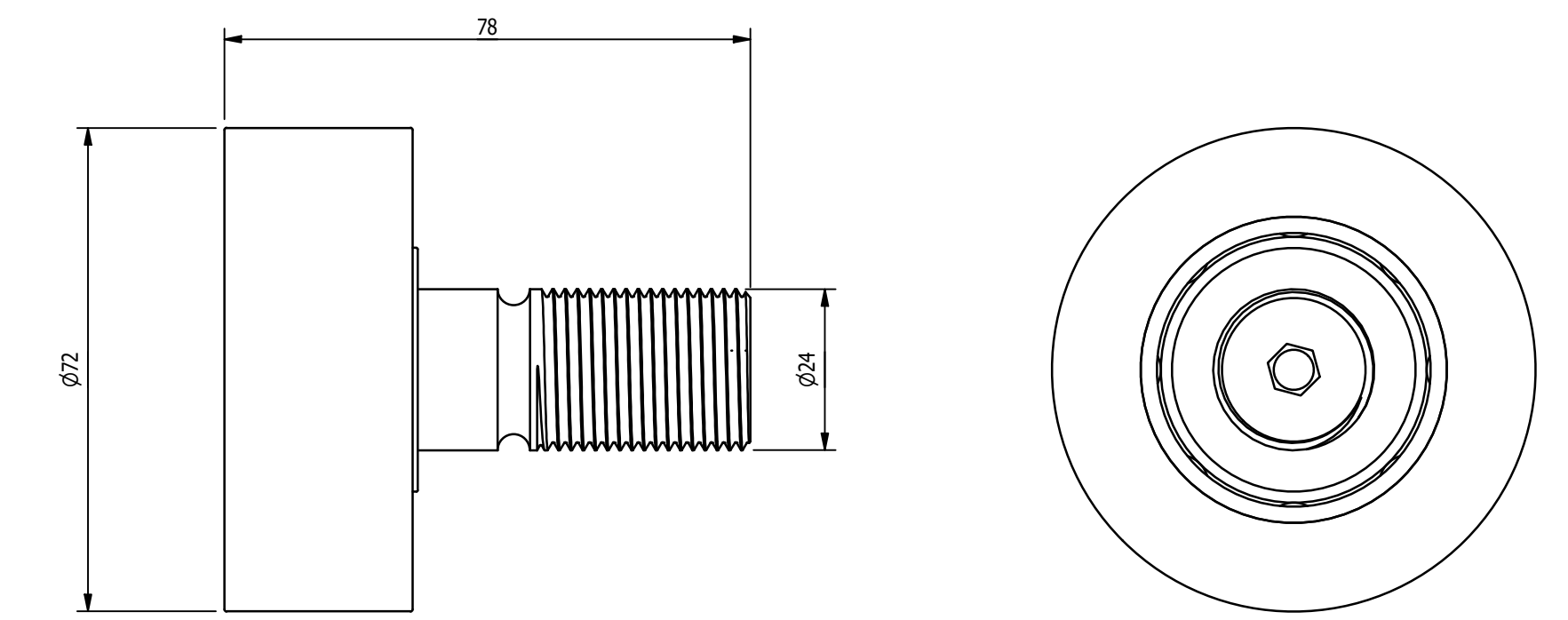
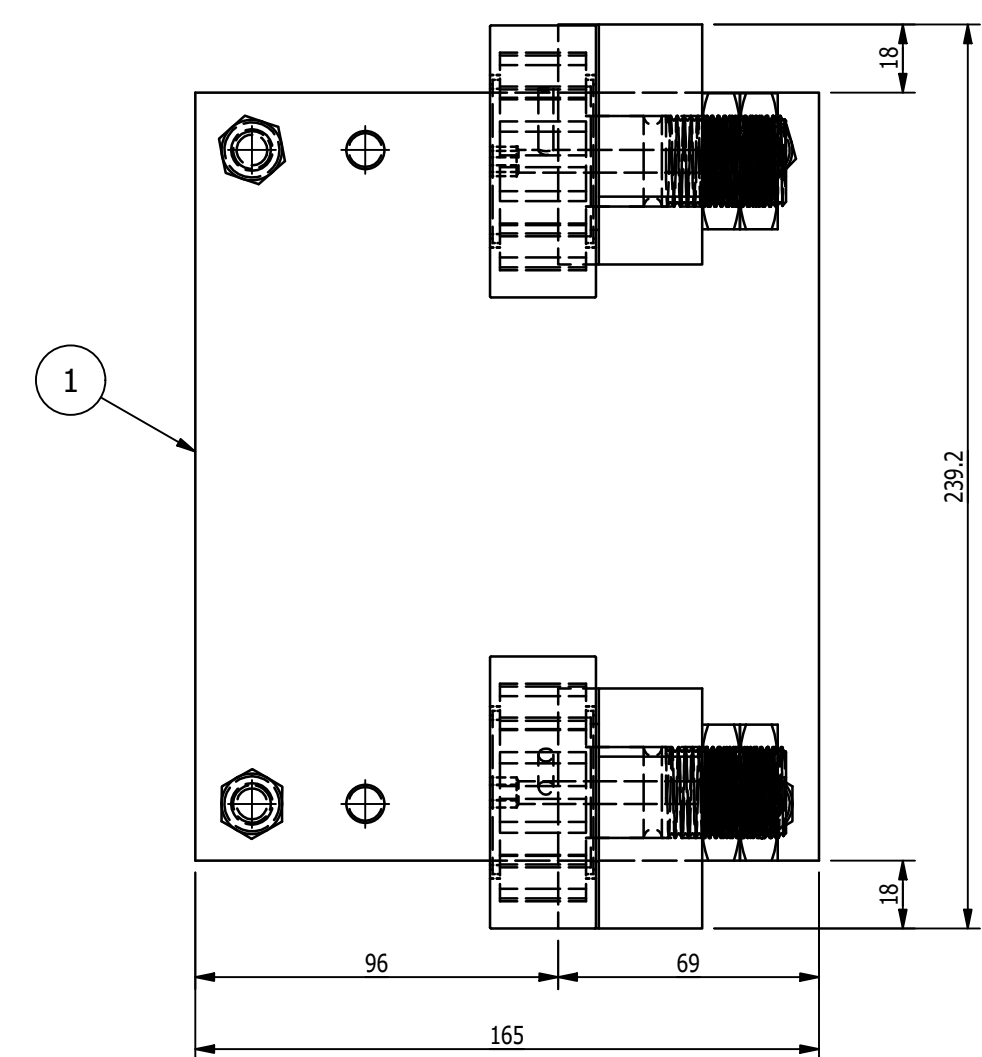
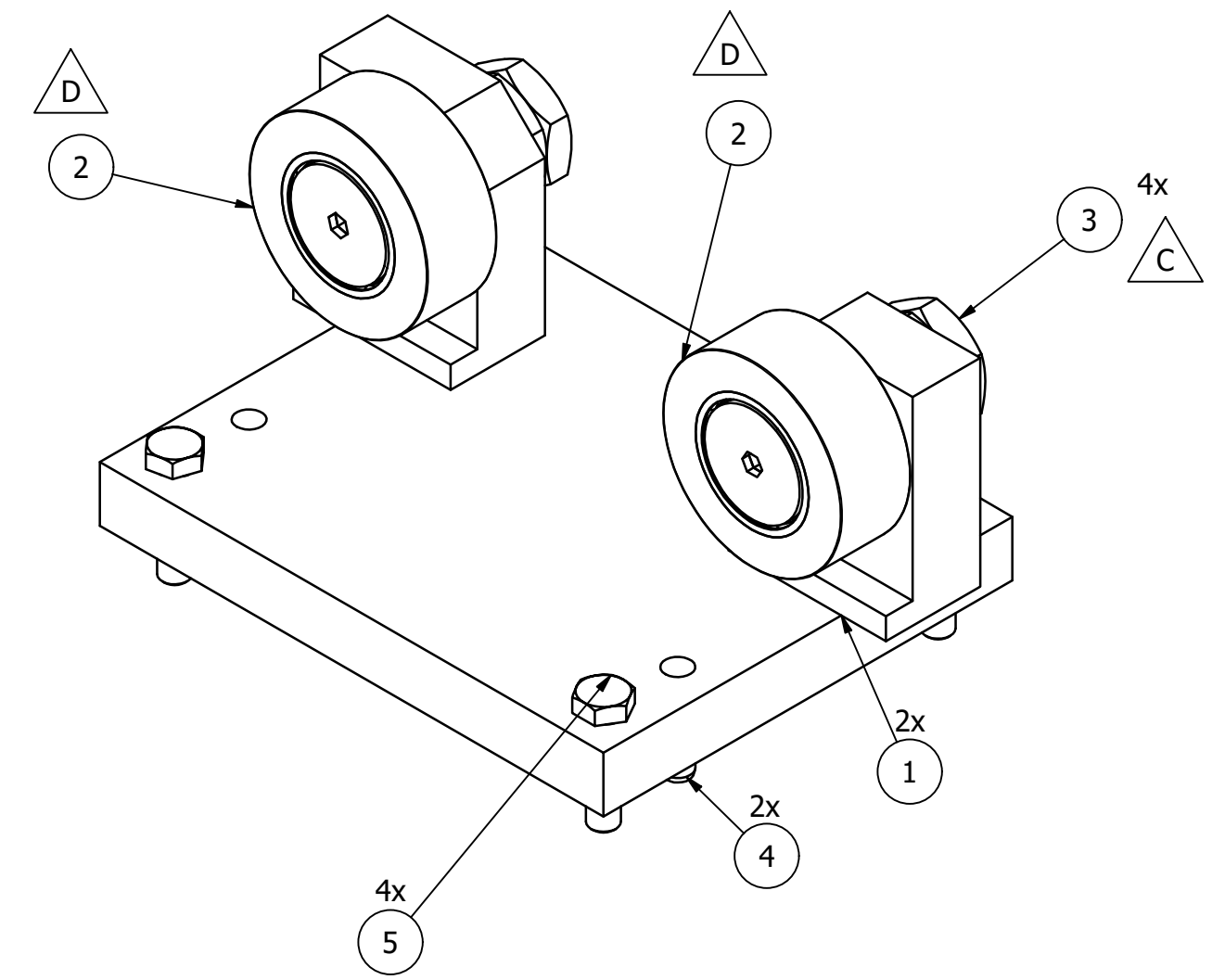
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	PWP
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D212	DWG DATE:	6/20/22
REV:	B	JOB No:	22096

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41100 Charleston Rd.
Suite 125
North, MI 48175
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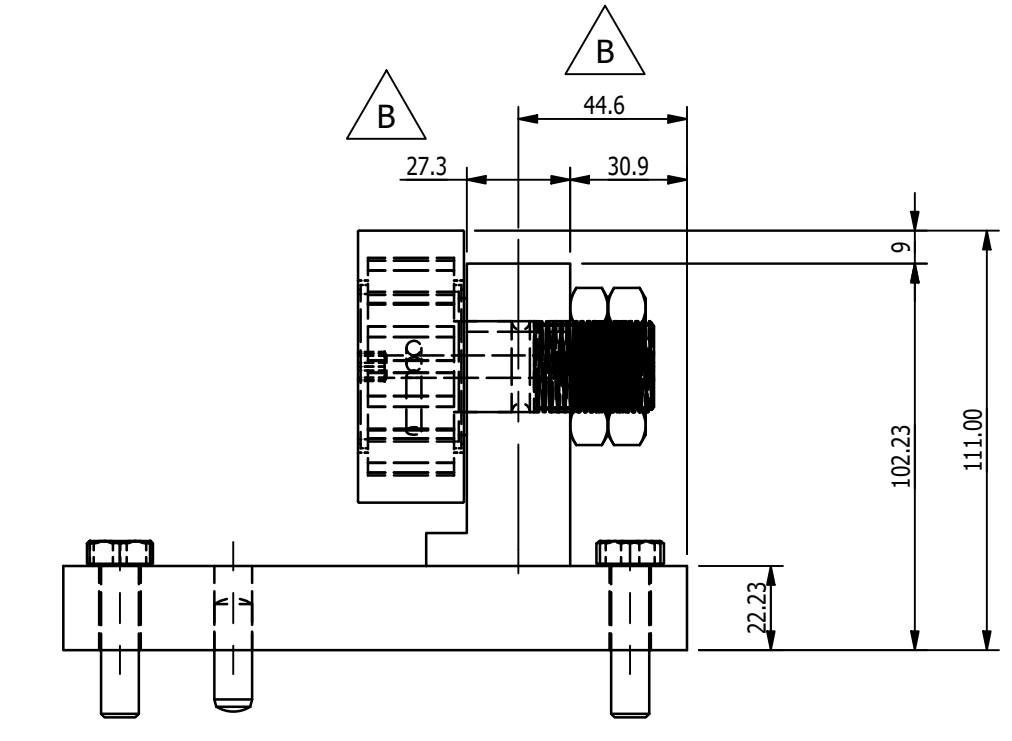
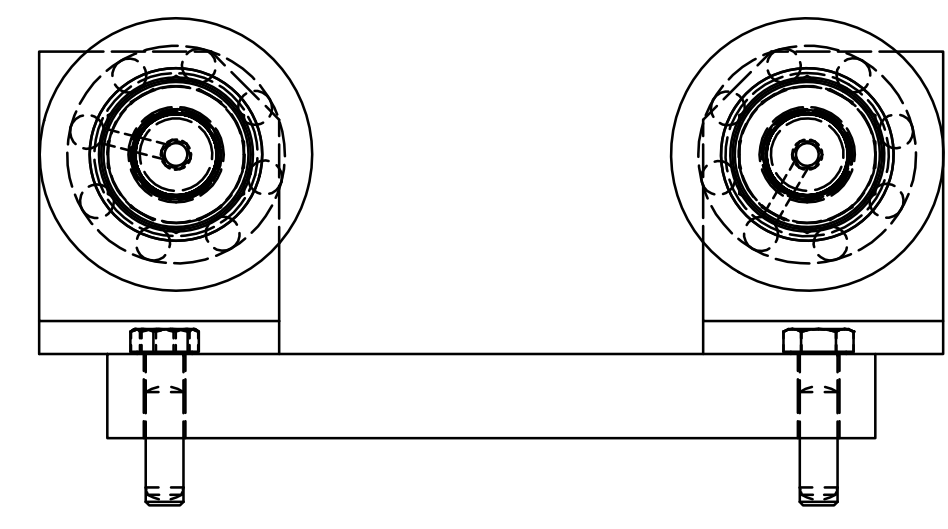
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D213A			
1	1	MK-D215A ~ 2 WAY LOCATOR MACHINE			
2	2	CAM ROLLER, INA PART-NO KR-72PP		5-9	
3	4	M24 x 1.5 HEX JAM NUT			
4	2	10mm DIA x 30mm LG. DOWEL			
5	4	M10x1.5 x 40mm LG. HEX CAP SCREW			
		TOTAL WEIGHT ~ 18 lbs			



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



MK-D213A ~ 2 WAY LOCATOR ASSEMBLY
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:
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
D	MC	7/27/2022	2x NOTE REMOVED	
C	MC	7/15/2022	ITEM '3' WAS QTY 2, GEO REVISED	
B	MC	7/5/2022	DIM 27.3 WAS 29.1, DIM 44.6 WAS 45.5	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

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Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D213 - REV D

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.

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

**P6700 CONVEYORS
CAMPUS BUILDING**

CLIENT: VOLVO

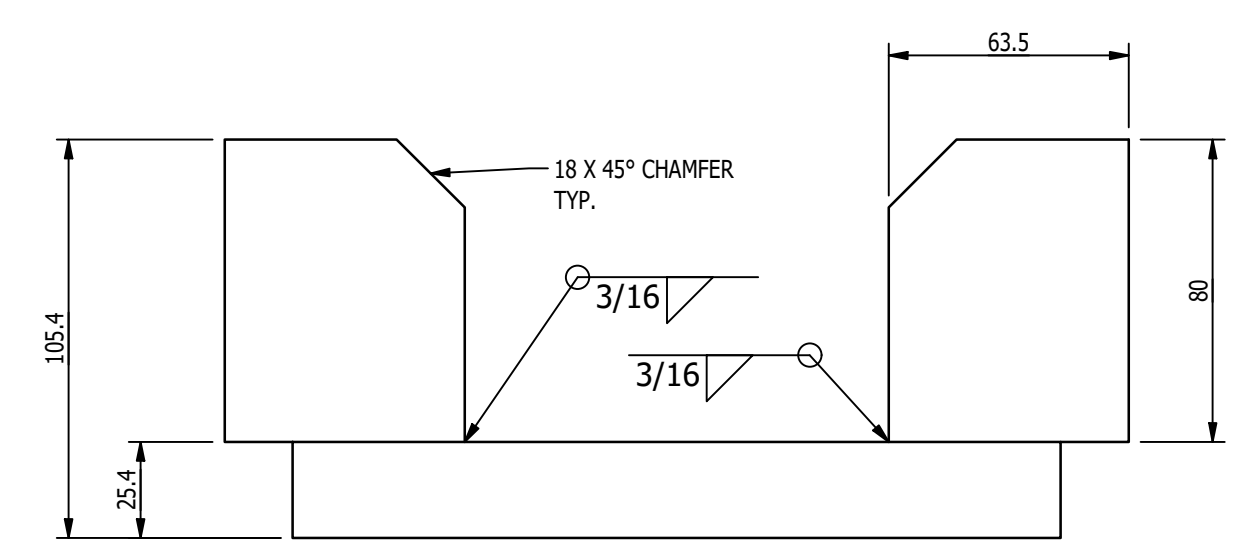
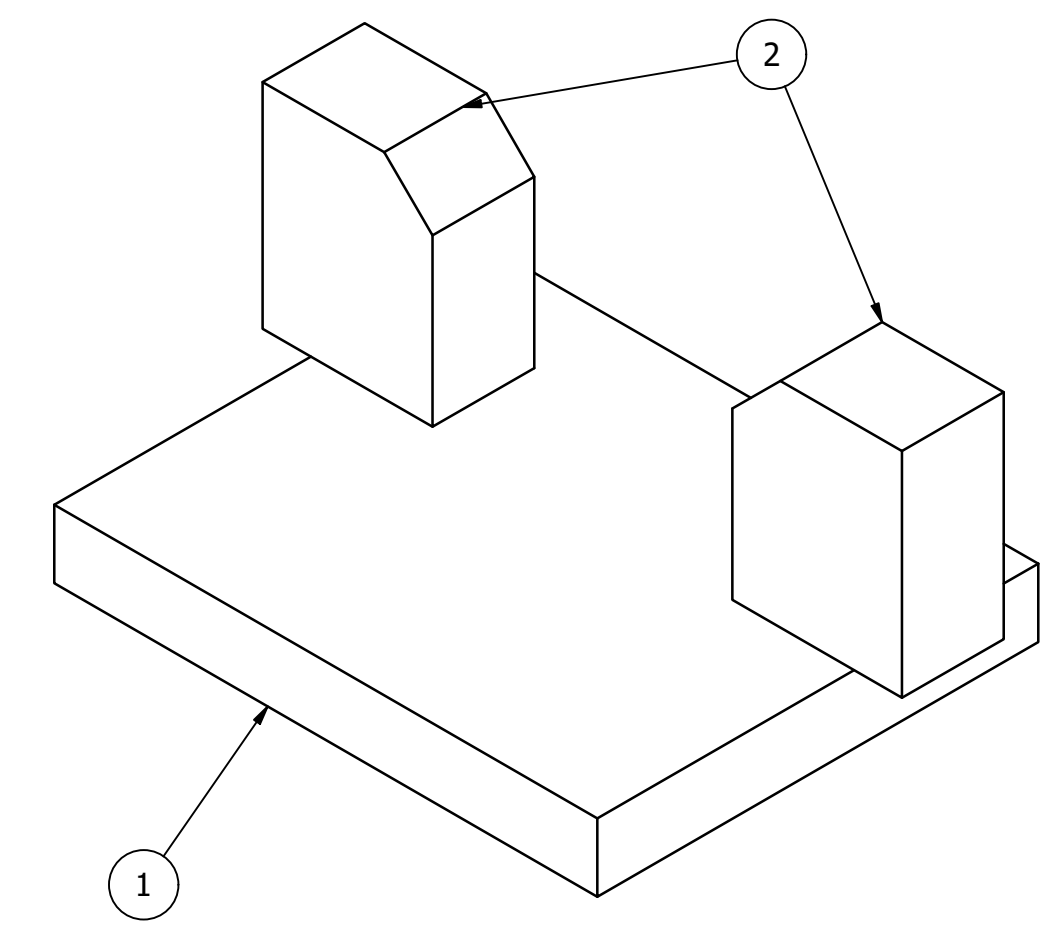
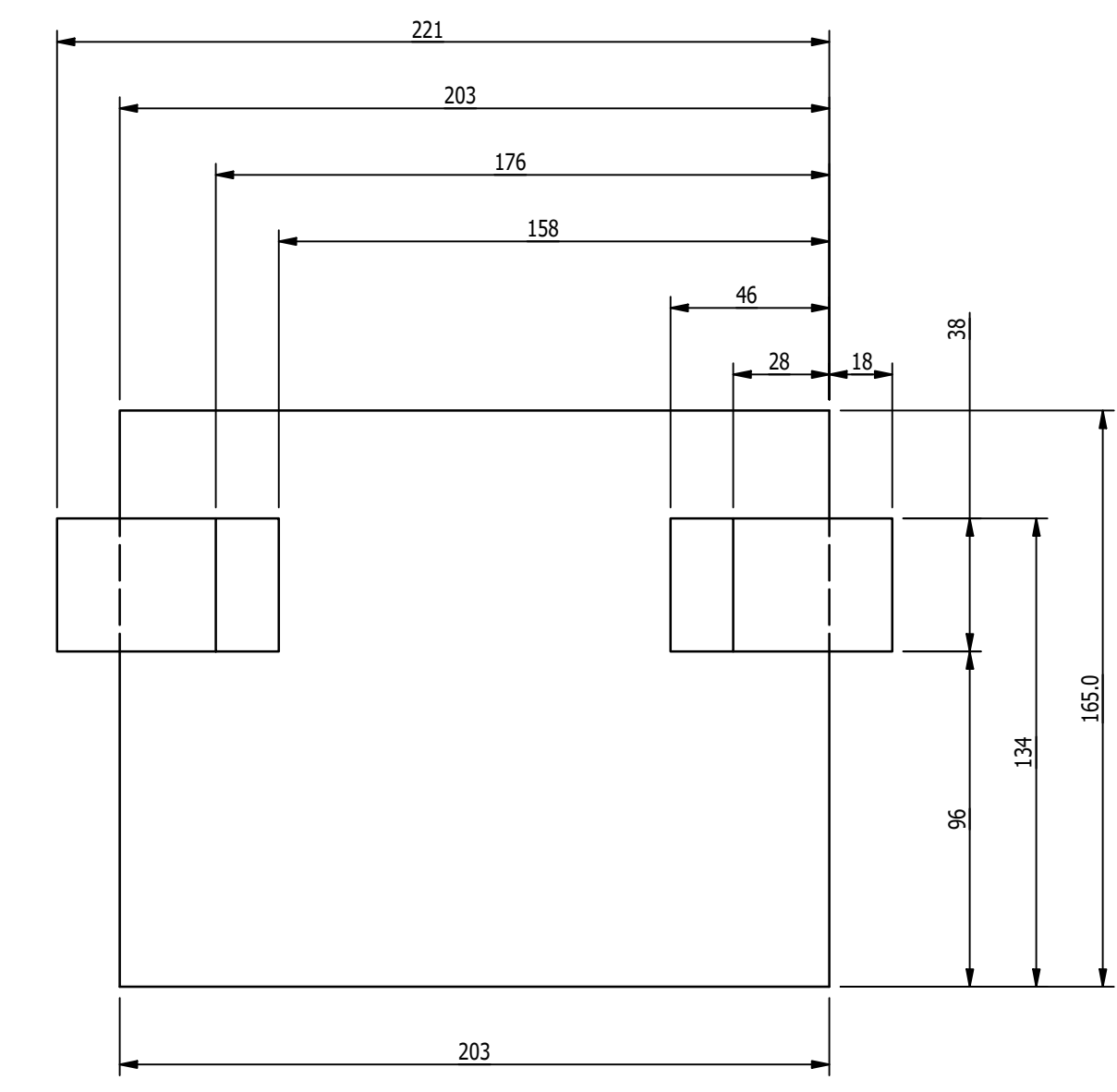
DRAWING No. 1875D213

REV: D

JOB No: 22096

DRAWN BY: PWP
CHECKED BY: CW
DWG DATE: 6/20/22

BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D214A		
1	1	BAR 1 x 8	6 1/2"	
2	2	BAR 1 1/2 x 2 1/2	3 1/8"	
TOTAL WEIGHT ~ 21.3 lbs				



MK-D214A ~ 2 WAY LOCATOR WELDMENT
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 ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035

A	MC	7/5/2022	FOR FABRICATION	
REV	BY	DATE	DESCRIPTION	APP
REVISION HISTORY				

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

MAGNUM CONSULTING

41100 QuakerRoad Rd
Suite 125
North, MI 48315

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D214

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.millc.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D214

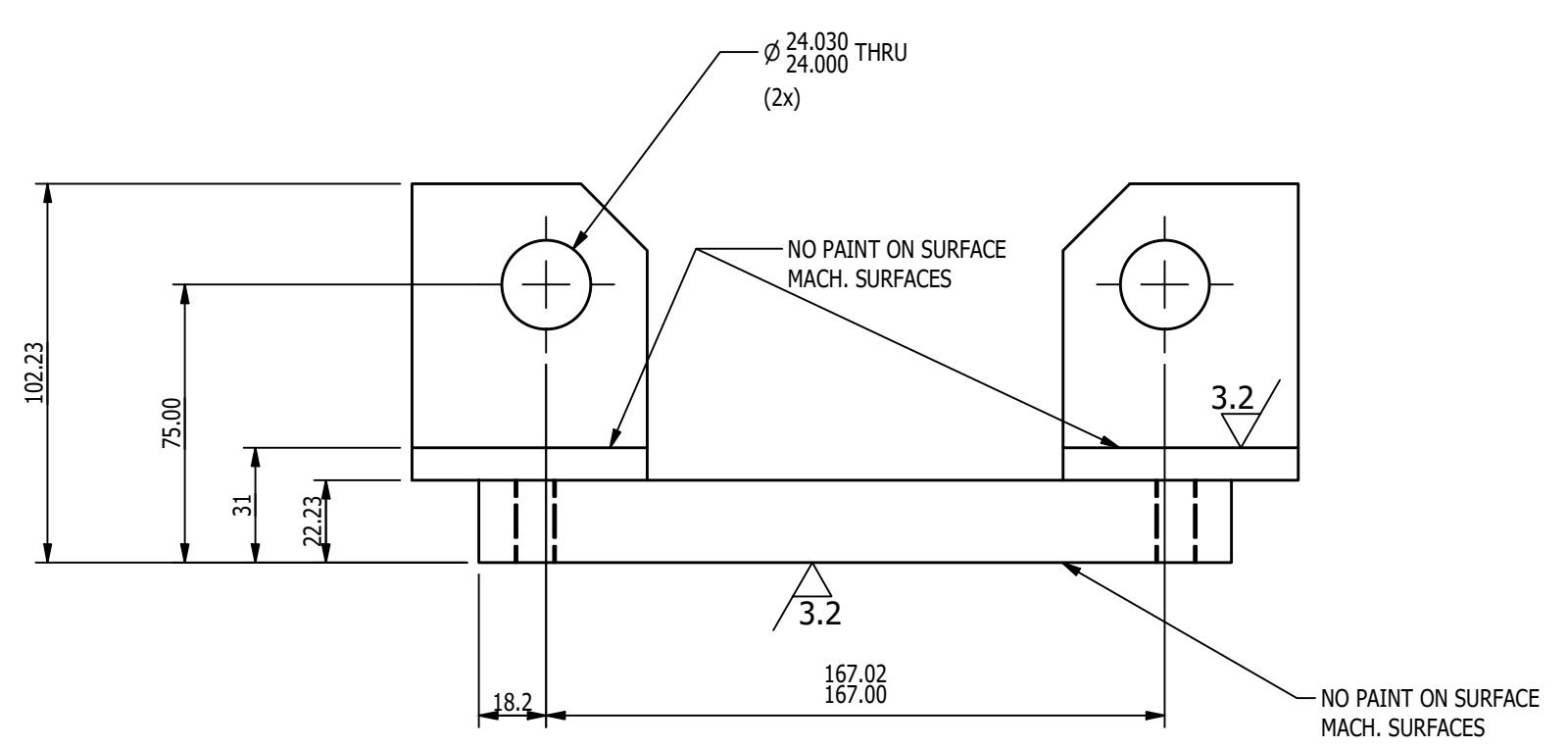
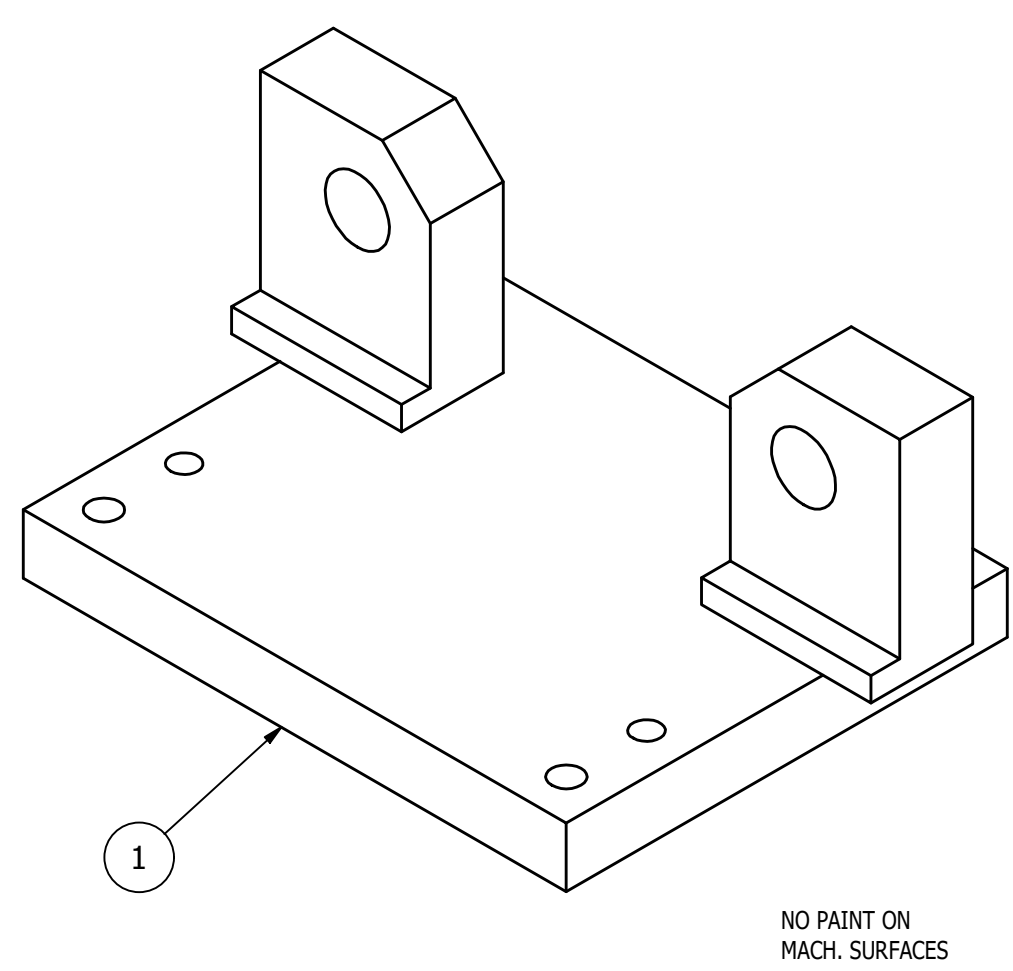
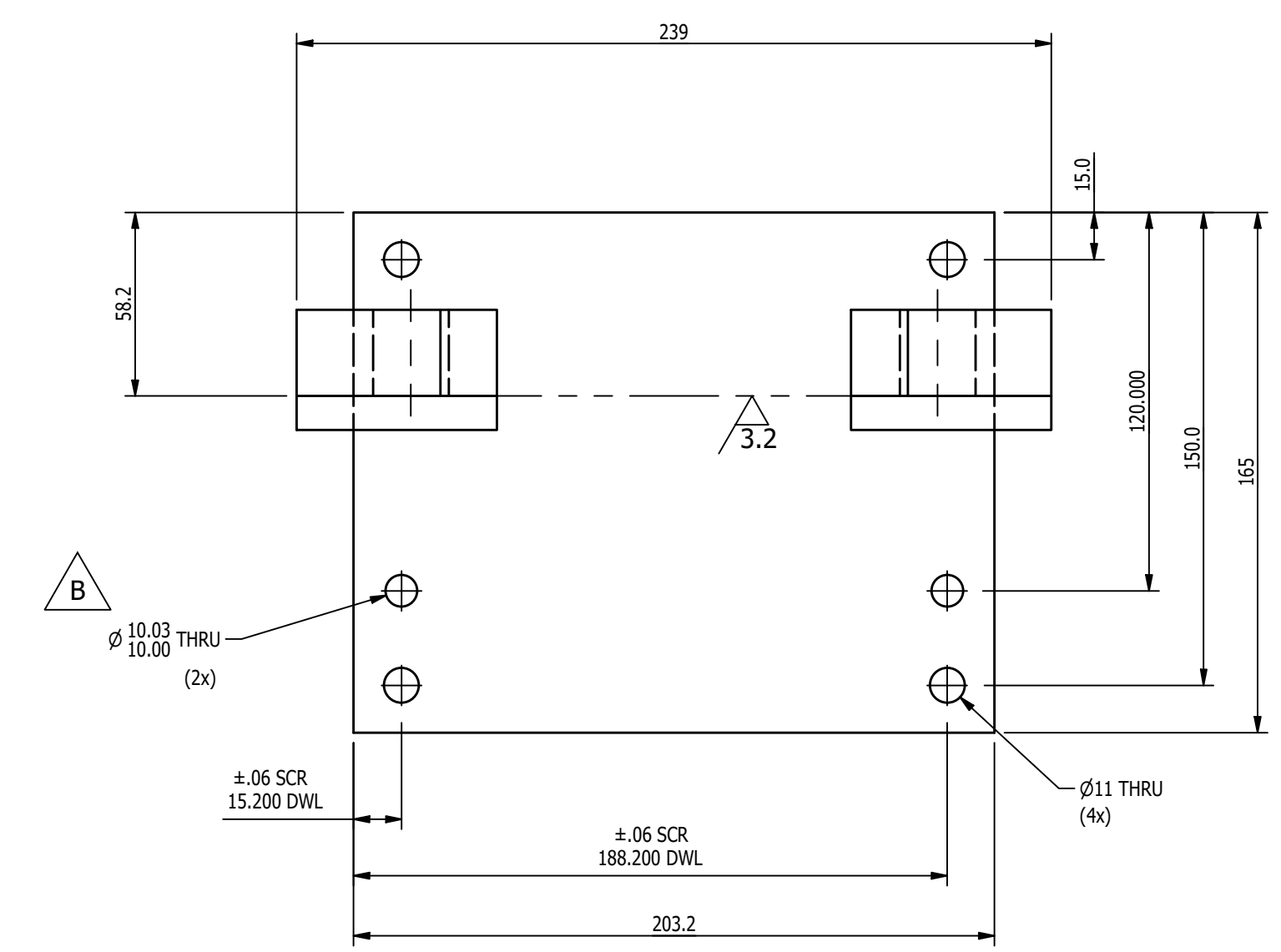
REV: A

JOB No: 22096

DRAWN BY: PWP
CHECKED BY: XXX
DWG DATE:

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BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D215A			
1	1	MK-D214A ~ 2 WAY LOCATOR WELDMENT			
		TOTAL WEIGHT ~ 17.2 lbs			



MK-D215A ~ 2 WAY LOCATOR MACHINE
SCALE 6"=1'-0"

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

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

DO NOT PAINT MACHINED SURFACES

REV	BY	DATE	DESCRIPTION	APP
C	MC	7/27/2022	TOL. REV	
B	MC	7/21/2022	HOLE TOL. REVISED	
A	MC	7/15/2022	REVISED DIM	

REVISION HISTORY

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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	PWP
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D215	DWG DATE:	6/20/22
REV:	C	JOB No.:	22096

MAGNUM CONSULTING

41100 QuakerRoad Rd.
Suite 125
North, MI 48175

Phone: (248) 772-8822
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MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D215 - 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:

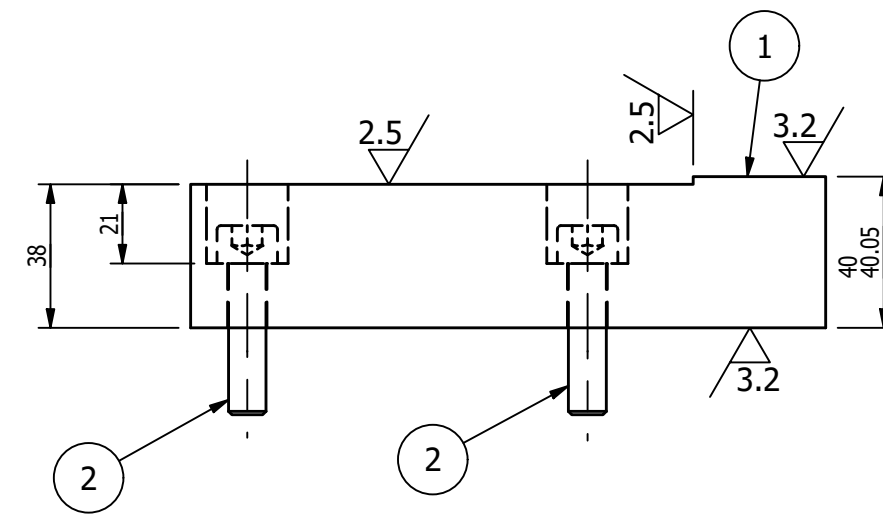
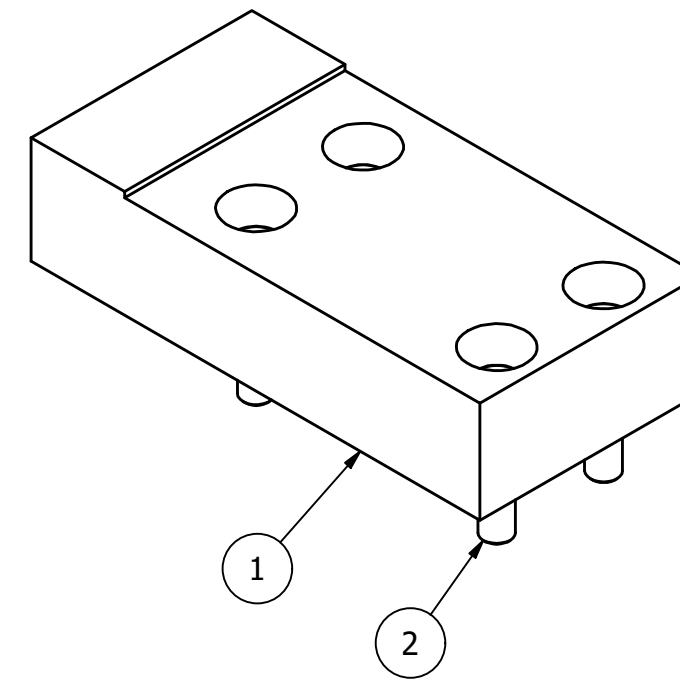
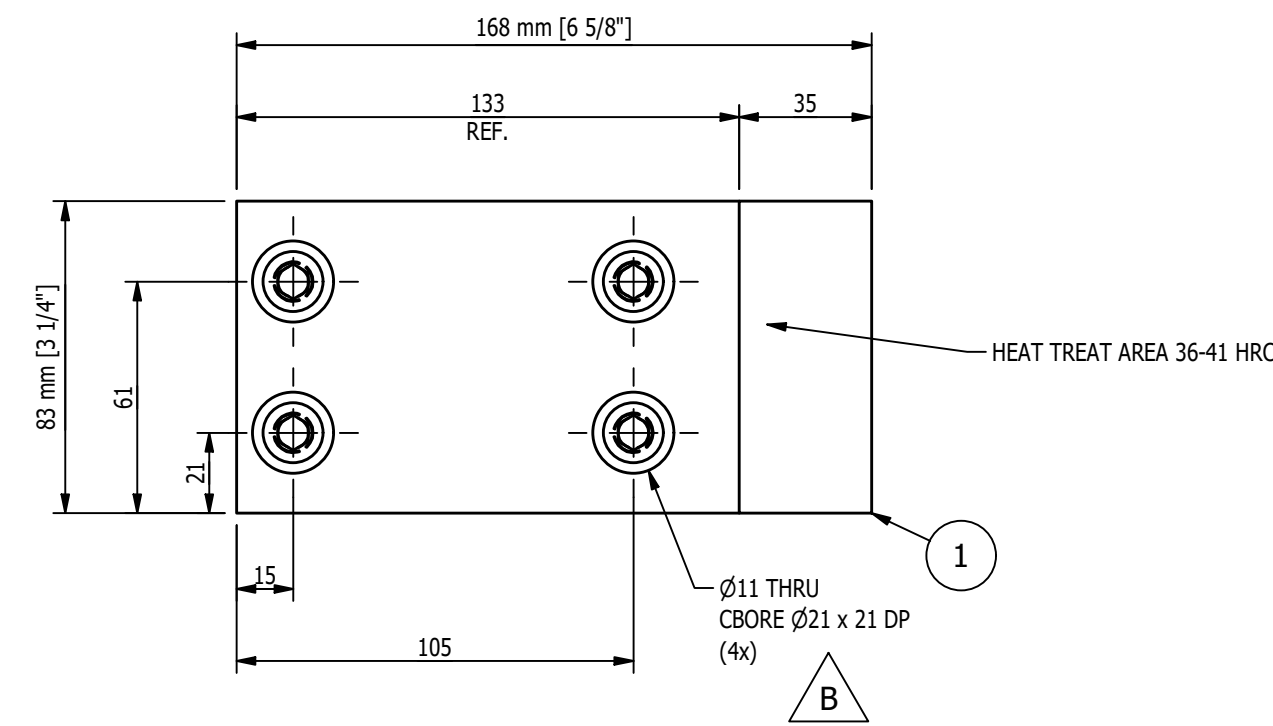
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

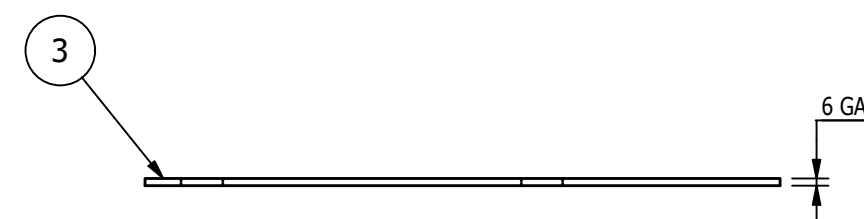
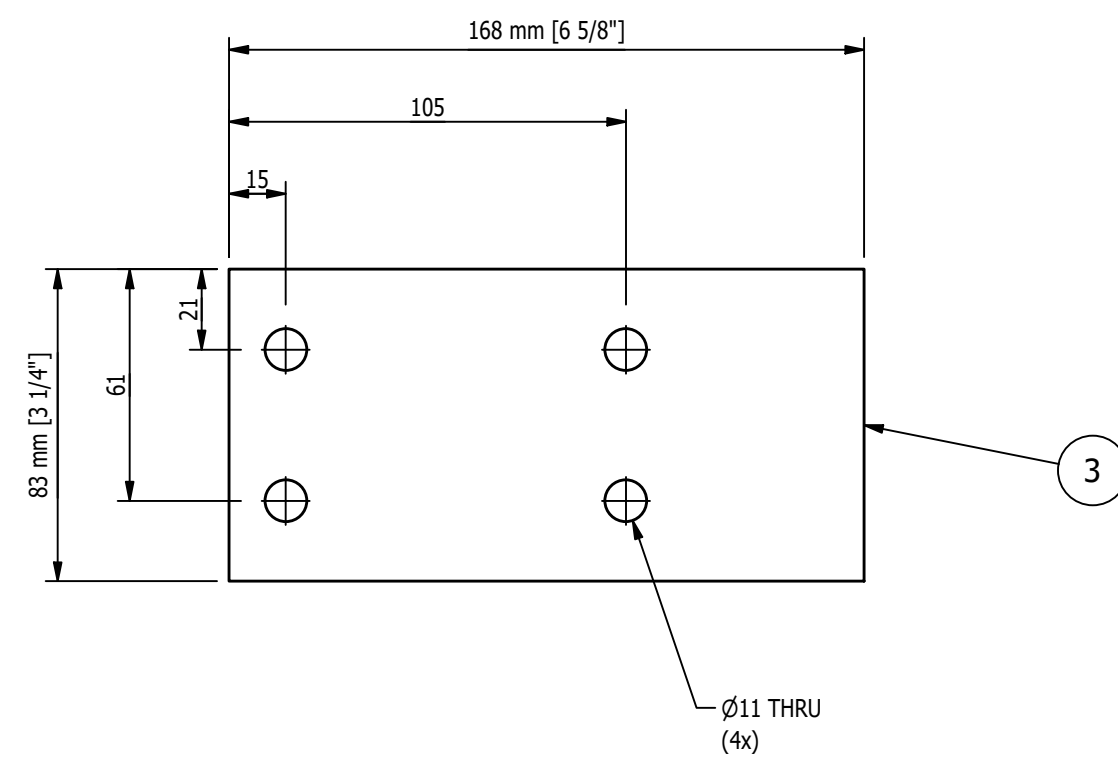
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

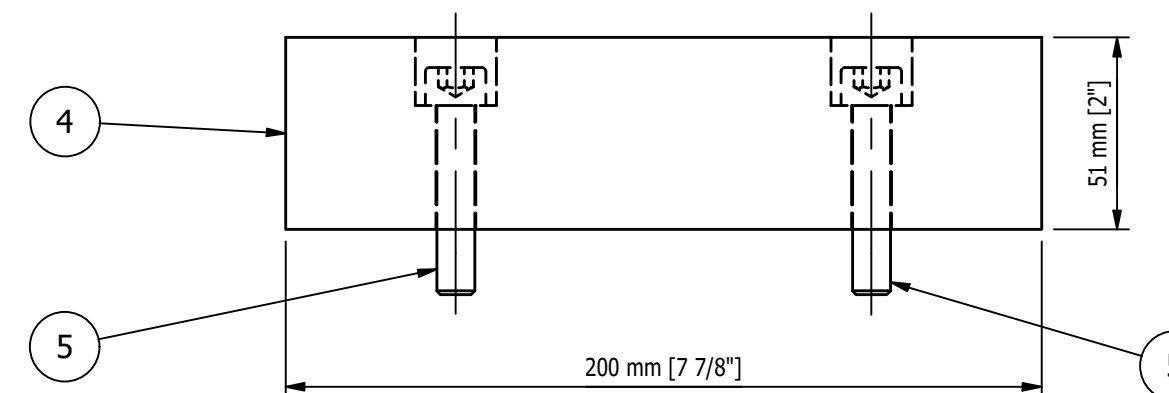
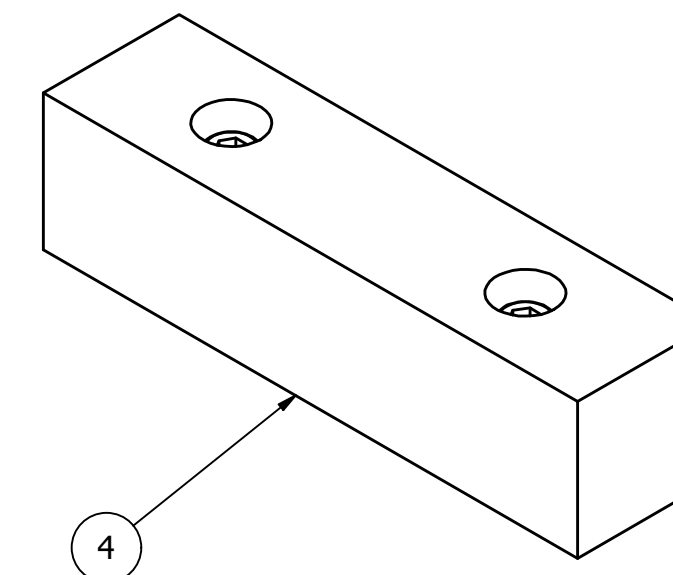
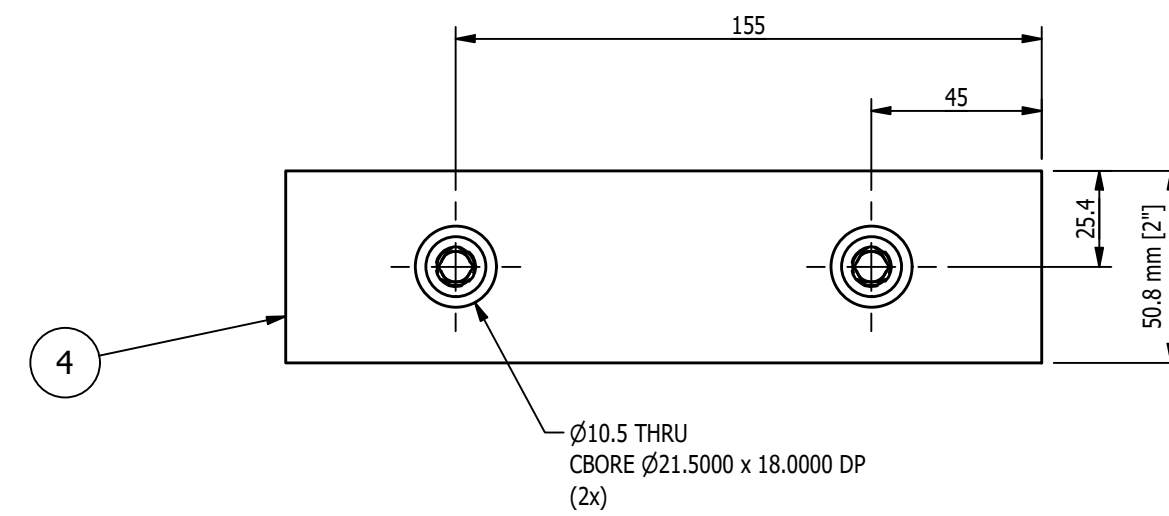
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



MK-D216A ~ Z REST PAD
SCALE 6"=1'-0"



MK-D216B ~ Z REST PAD SHIM
SCALE 6"=1'-0"



MK-D216C ~ CAM GUIDE
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D216A			
1	1	PL 2 x 3 1/4" (4140)	6 5/8"		
2	4	M10x1.5 x 40mm LG. HEX SOCKET HEAD CAP SCREW			
		TOTAL WEIGHT ~ 8.9 lbs			
		MK-D216B			
3	1	SHT 6 GA x 3 1/4	6 5/8"		
		TOTAL WEIGHT ~ 0.5 lbs			
		MK-D216C			
4	1	SQ. BAR 2" (1045 CRS)	7 7/8"		
5	2	M10x1.5 x 50mm LG. HEX SOCKET HEAD CAP SCREW			
		TOTAL WEIGHT ~ 8.8 lbs			

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

- PAINT NOTES:
- BLACK OXIDE MK-A
 - DO NOT PAINT MK-B
 - BLACK OXIDE MK-C

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/11/2022	HOLE CALLOUT REVISED, BALLOONS ADDED, ITEM '4' WAS (1020 CRS), PAINT NOTE REVISED	
A	MC	7/5/2022	FOR FABRICATION	

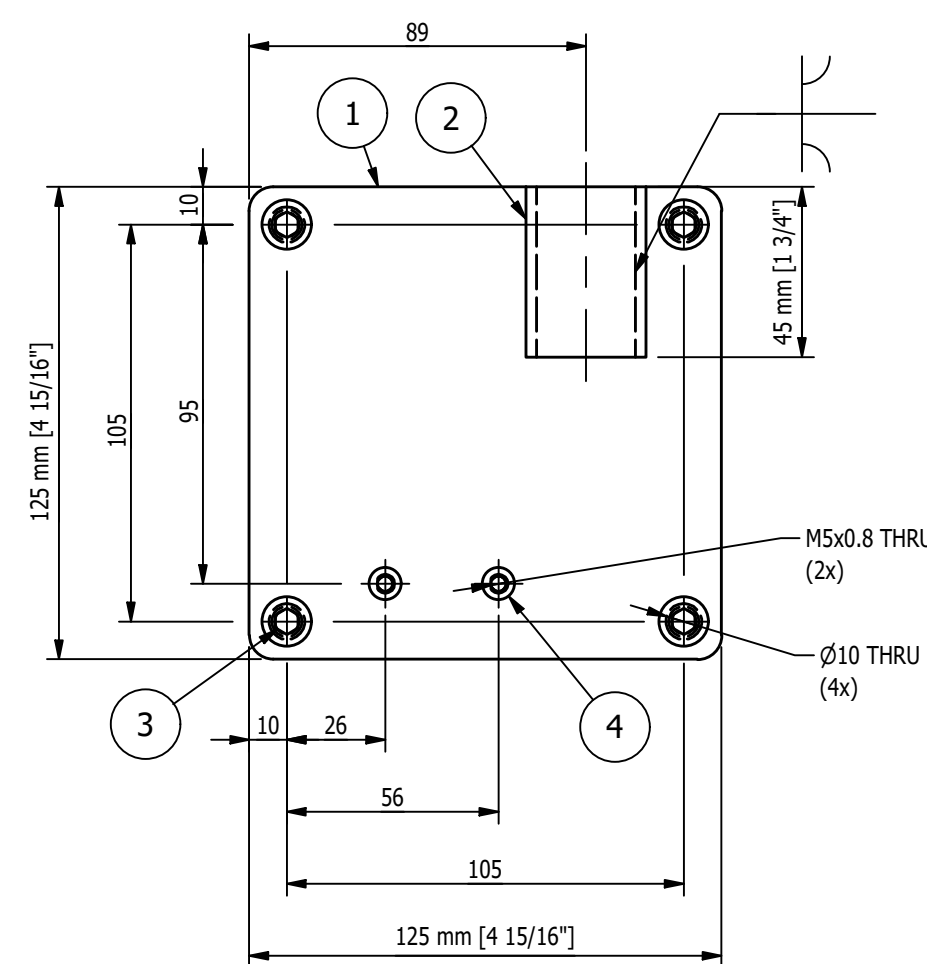
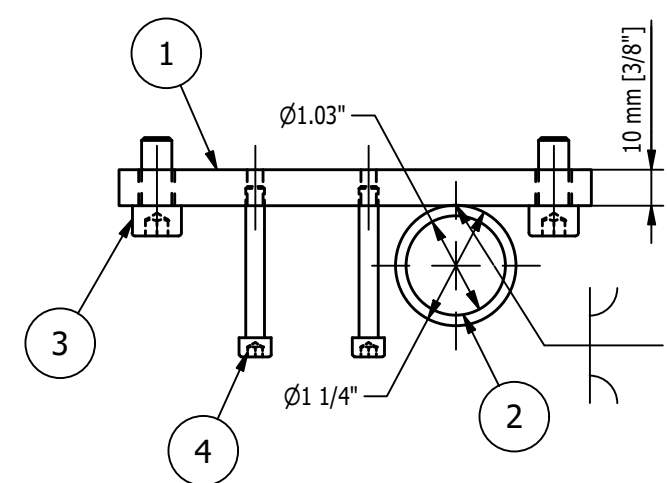
REVISION HISTORY	

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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	PWP
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D216	DWG DATE:	6/20/22
		REV:	B
		JOB No:	22096

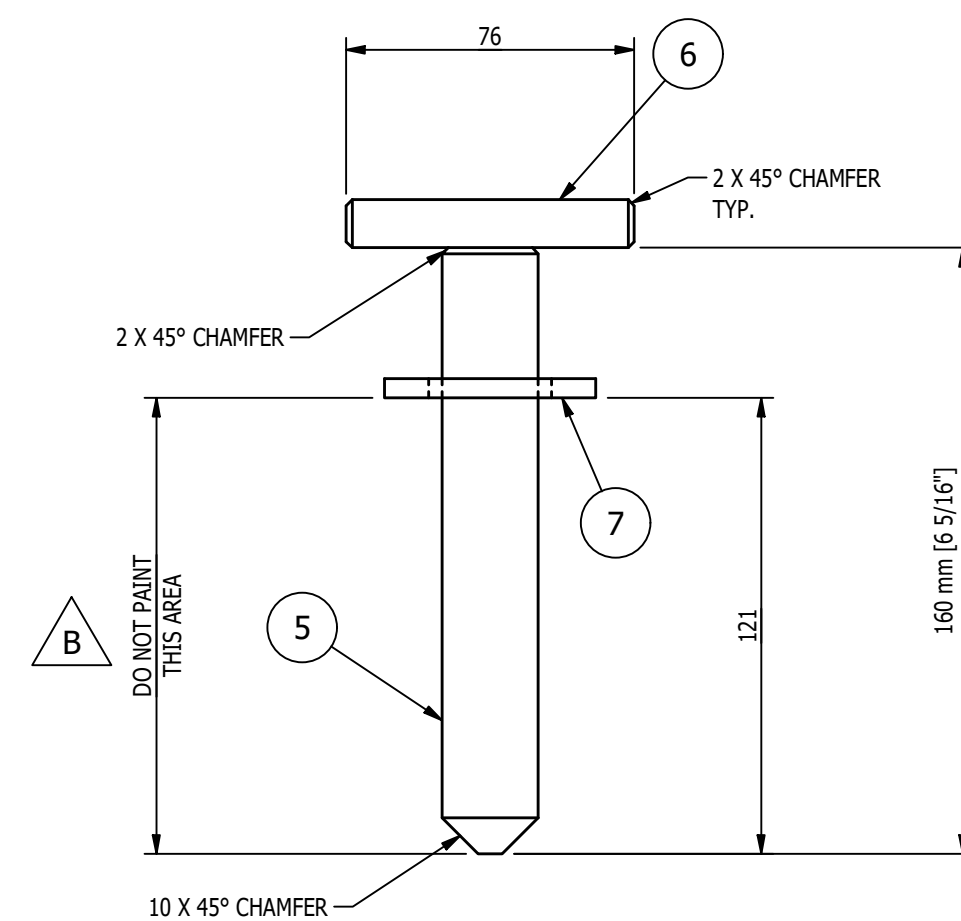
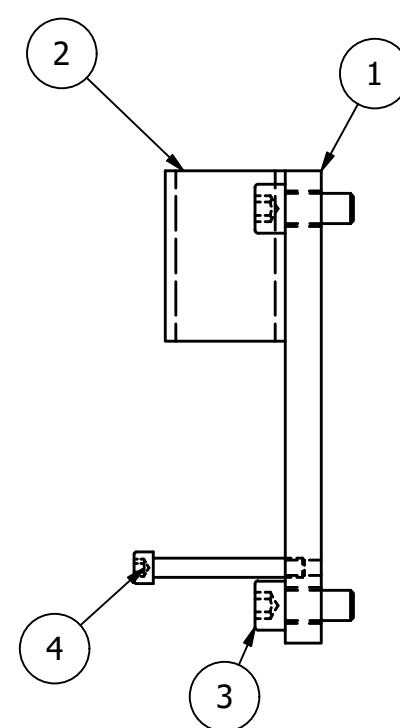
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Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D216

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

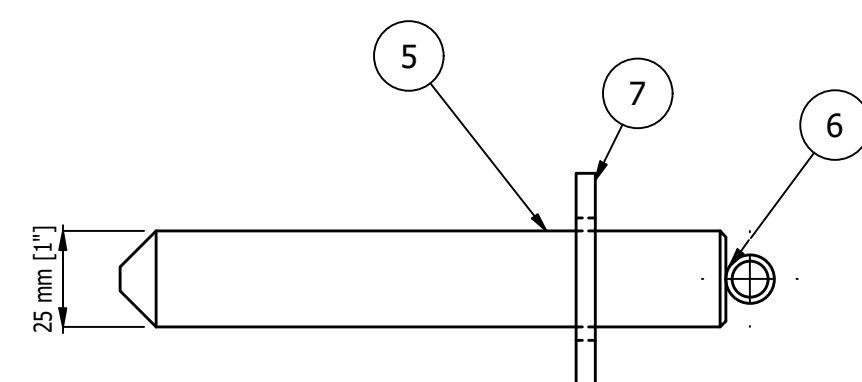
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" 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-D217A ~ HOLSTER WELDMENT
SCALE 6"=1'-0"



MK-D217B ~ LOCK-OUT PIN
SCALE 6"=1'-0"



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D217A			
1	1	PL 3/8 x 4 15/16"	4 15/16"		
2	1	TS 1 1/4 OD x 12GA DOM	1 3/4"		
3	4	M8x1.25 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
4	2	M5x0.8 x 40mm LG. HEX SOCKET HEAD CAP SCREW			
		TOTAL WEIGHT ~ 2.9 lbs			
		MK-D217B			
5	1	BAR Ø1 (1045)	6 5/16"		
6	1	BAR Ø1/2	3"		
7	1	M30 NARROW FLAT WASHER			
		TOTAL WEIGHT ~ 1.7 lbs			

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/11/2022	NOTE ADDED	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

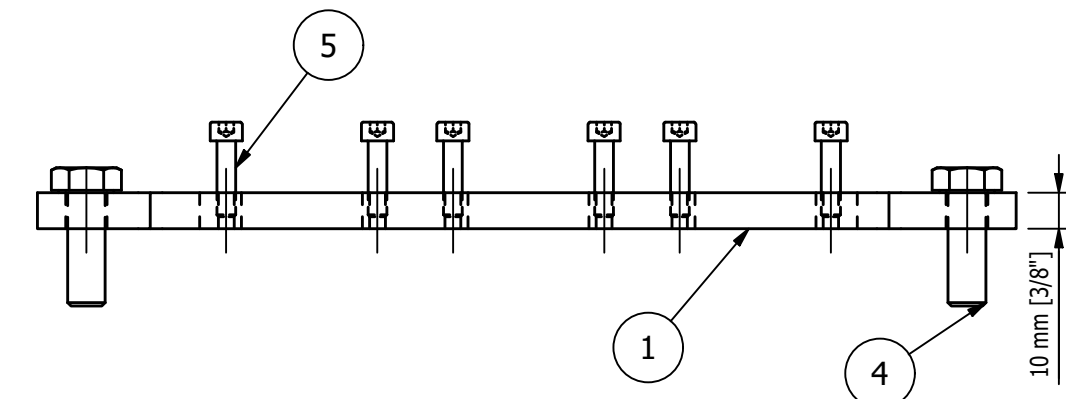
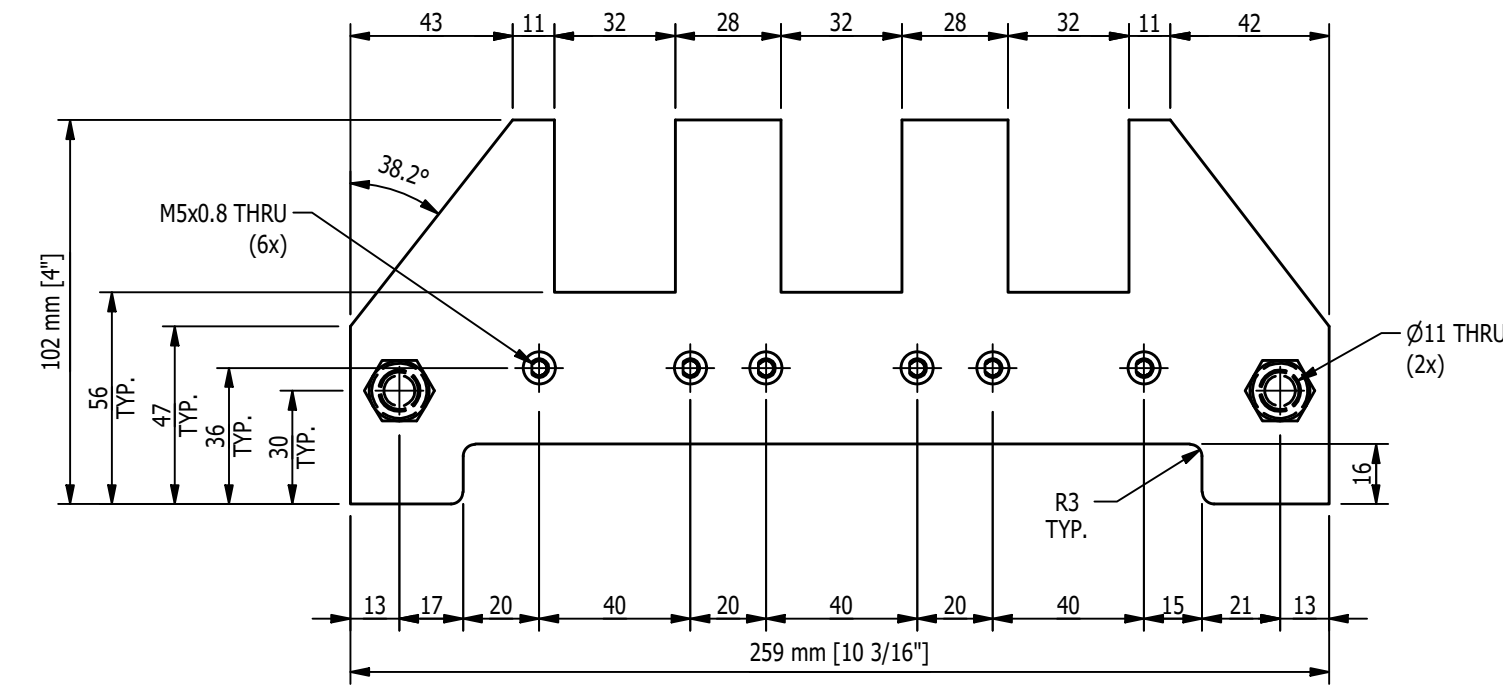
	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES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

CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D217	DWG DATE: 6/20/22
REV: B	JOB No: 22096

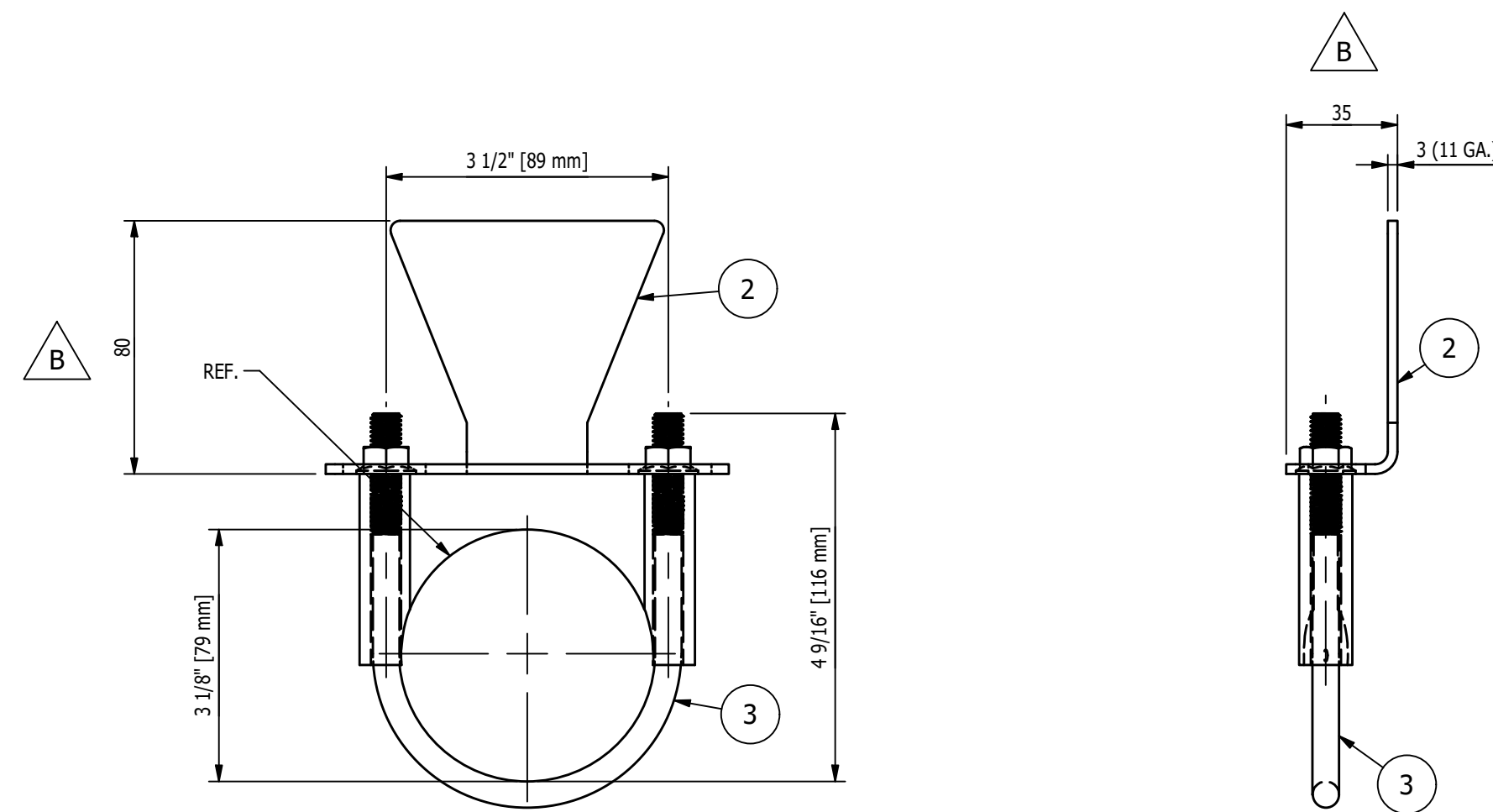
41100 Charleston Rd
 Suite 125
 Norcross, GA 30071
 Phone: (770) 440-8822
 Fax: (770) 440-8821
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D217 - REV B

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

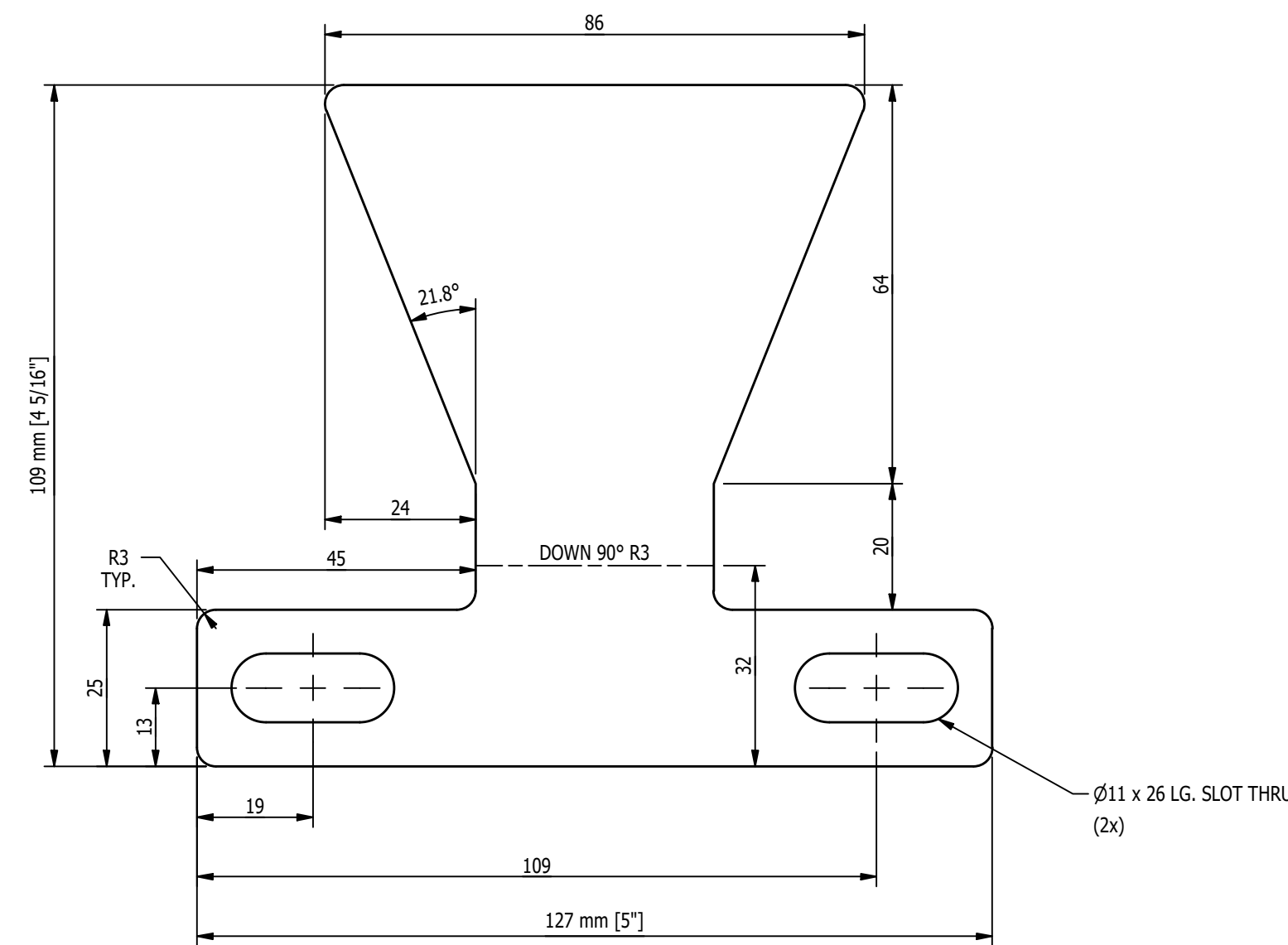
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO 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-D218A ~ SLOTTED SENSOR PLATE
SCALE 6"=1'-0"



MK-D218B ~ SLOT SENSOR LO BRACKET
SCALE 6"=1'-0"



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D218A			
1	1	BAR 3/8 x 4	10 3/16"		
4	2	M10x1.5 x 30mm LG. HEX CAP SCREW			
5	6	M5x0.8 x 20mm LG. HEX SOCKET HEAD CAP SCREW			
		TOTAL WEIGHT ~ 2.9 lbs			
		MK-D218B			
2	1	SHT 11 GA x 4 5/16	5"		
3	1	3/8"-16 THD. 3 1/8" ID U-BOLT CLAMP McMASTER PART NO. 3042T35		5-10	
		TOTAL WEIGHT ~ 0.5 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:**
- MK-A PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035
 - MK-B PAINT ALL FABRICATED STEEL WITH ONE
SHOP COAT OF PURE ORANGE RAL 2004

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/11/2022	DIM'S ADDED	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

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	TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH

CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D218	DWG DATE: 6/20/22
REV: B	JOB No: 22096

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

MAGNUM CONSULTING

41100 Charleston Rd.
Suite 125
Wood, MI 48095

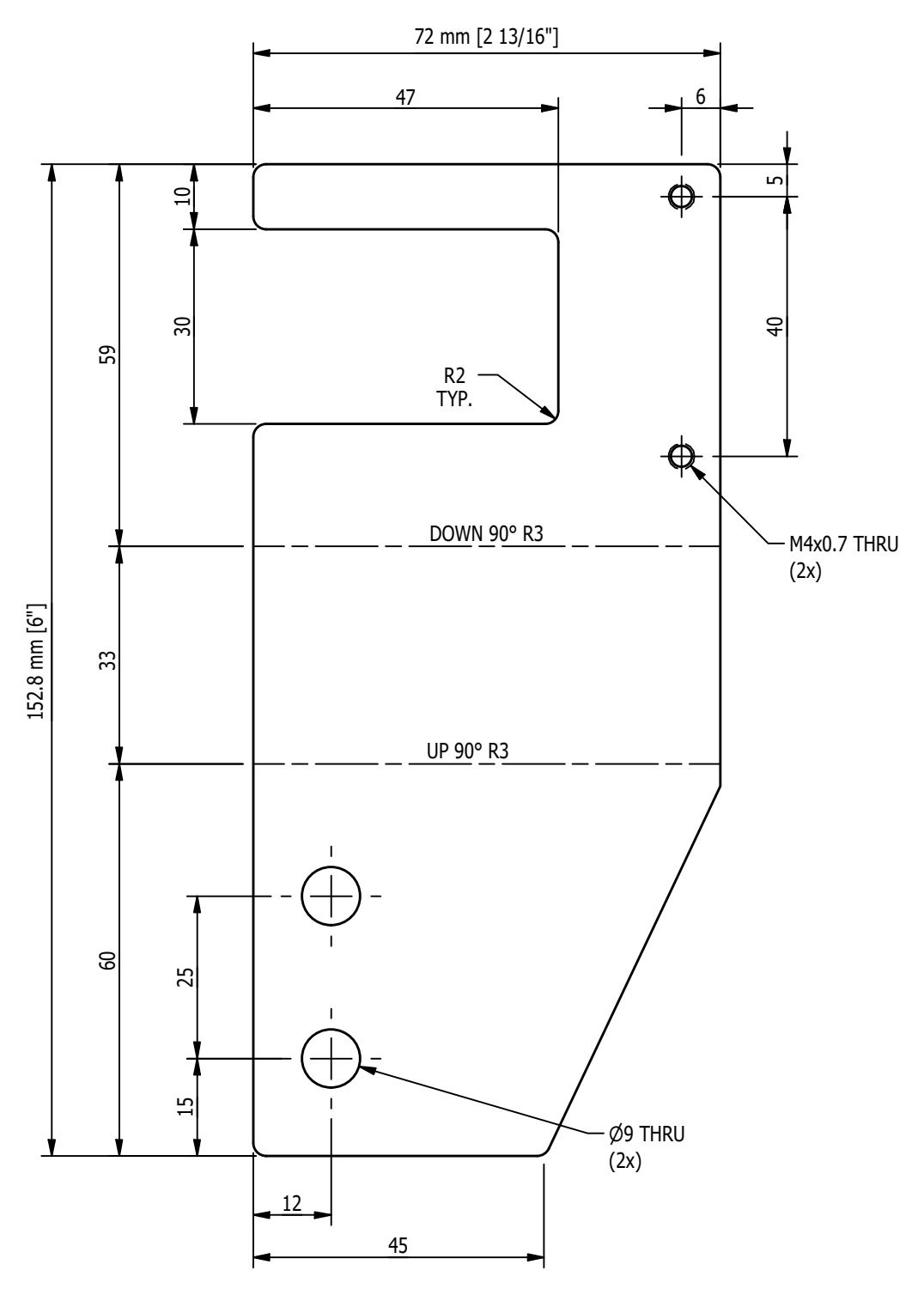
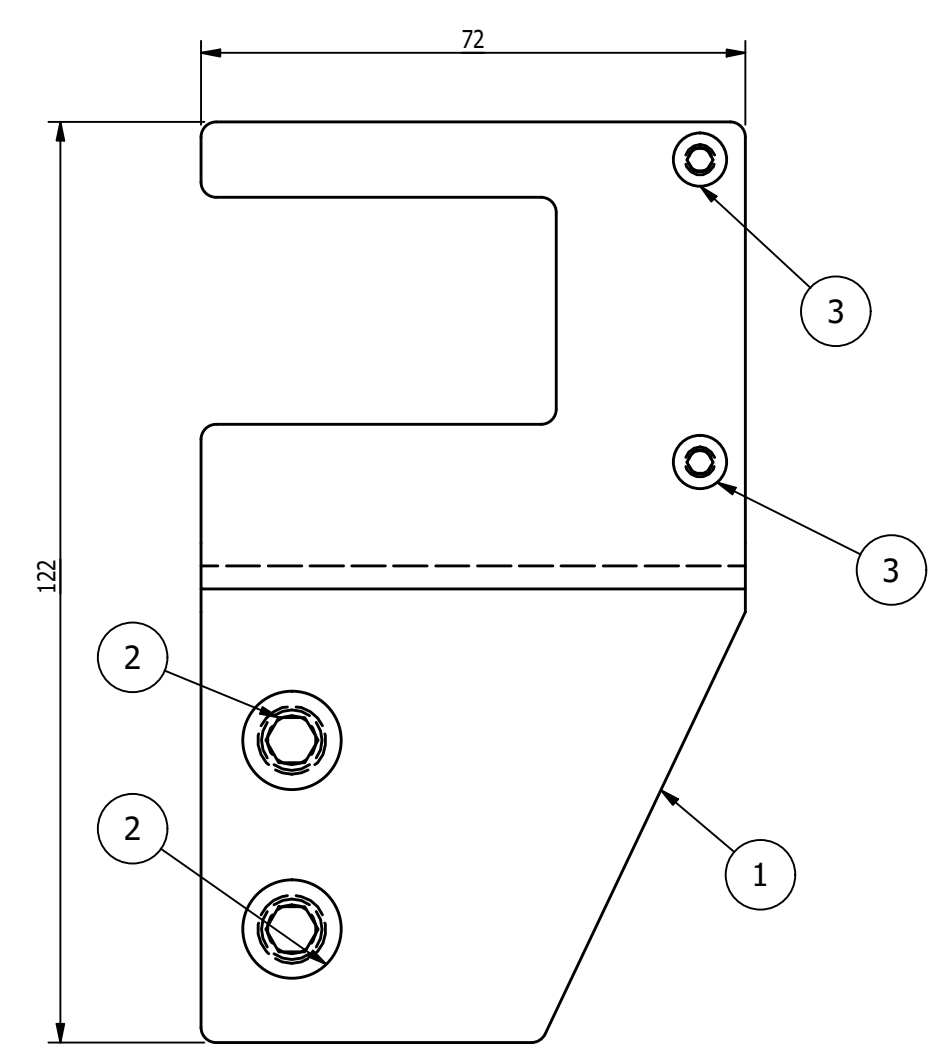
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D218

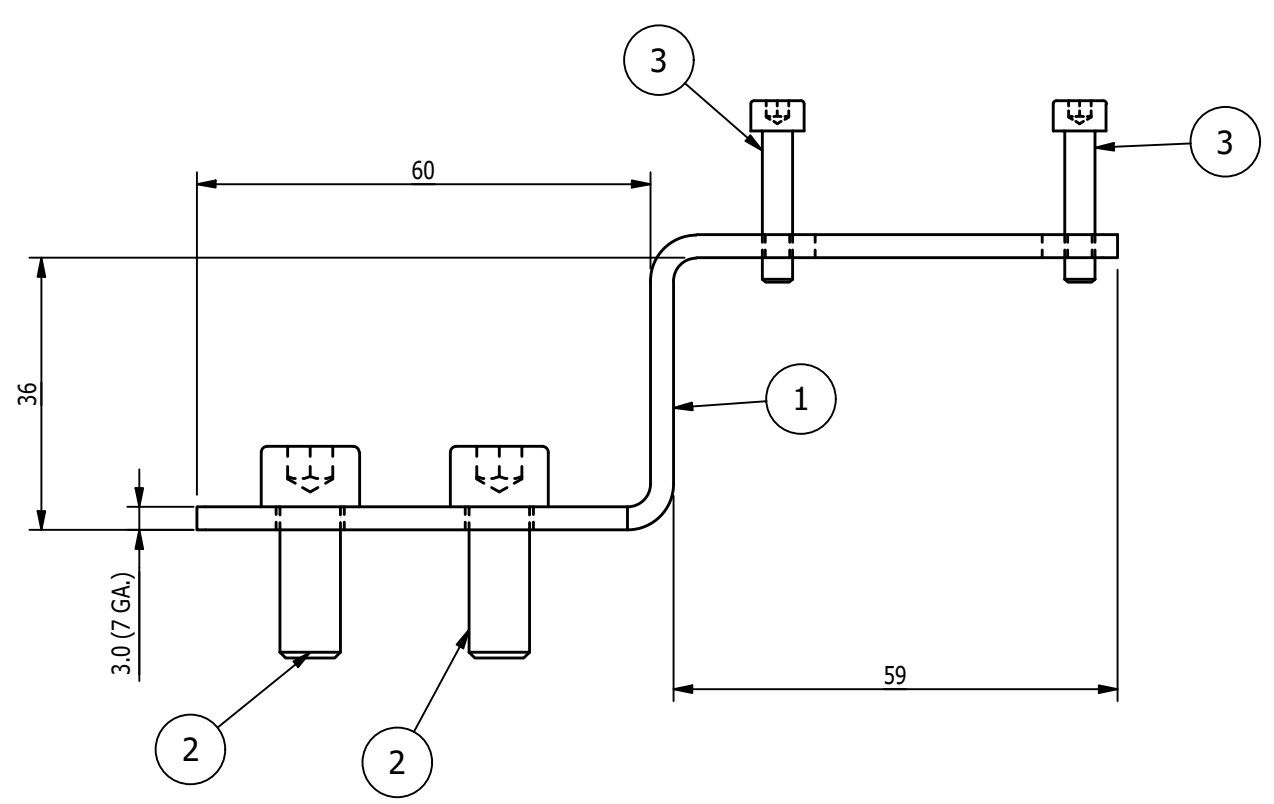
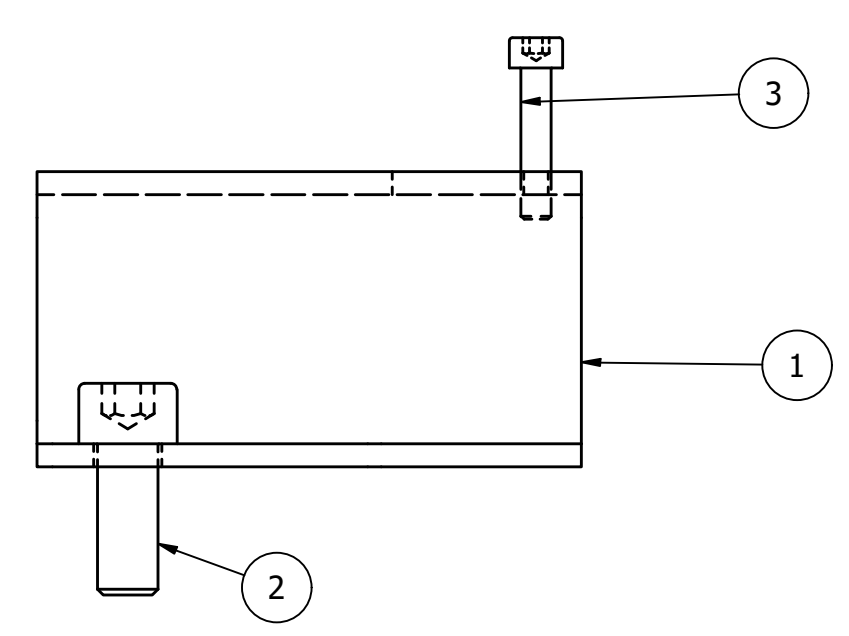
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- XX = ±.030
- XXX = ±.005
- FRACTIONS = ±1/16"
- ANGLES = ±1°30'
- BREAK ALL SHARP EDGES
- DEBURR ALL HOLES
- DO NOT SCALE DRAWING

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D219A			
1	1	SHT 7 GA x 2 13/16	6"		
2	2	M8x1.25 x 20mm LG. HEX SOCKET HEAD CAP SCREW			
3	2	M4x0.7 x 20mm LG. HEX SOCKET HEAD CAP SCREW			
		TOTAL WEIGHT ~ 0.5 lbs			



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



MK-D219A ~ SLOT SENSOR DO BRACKET
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	7/11/2022	BEND RADUIS REVISED	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: AH	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	CHECKED BY:	CW
CLIENT:	VOLVO	DWG DATE:	6/20/22
DRAWING No.	1875D219	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 SLUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

MAGNUM CONSULTING

41100 Clarkston Rd.
Suite 125
North, MI 48075

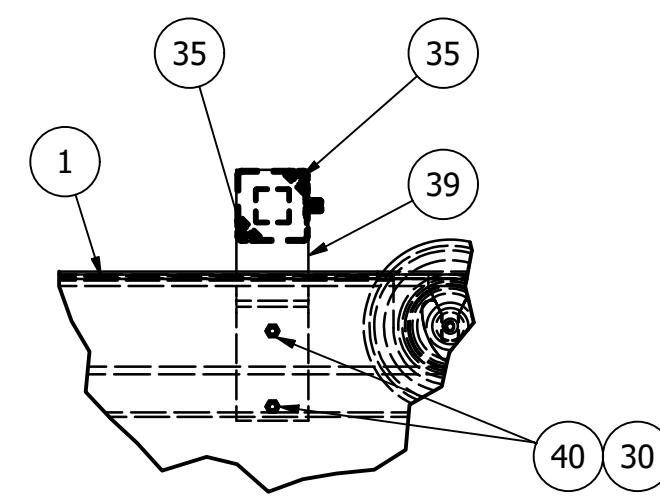
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D219

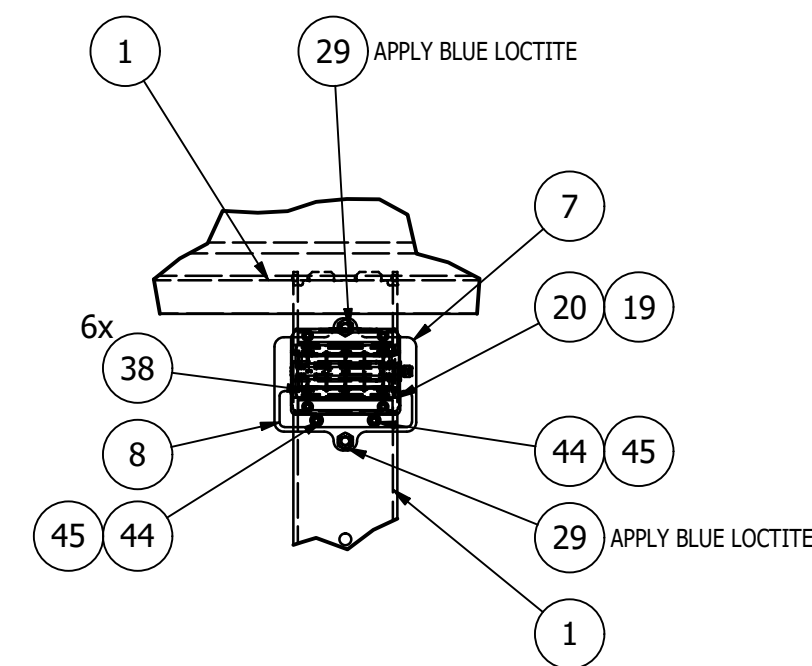
UNLESS OTHERWISE NOTED:

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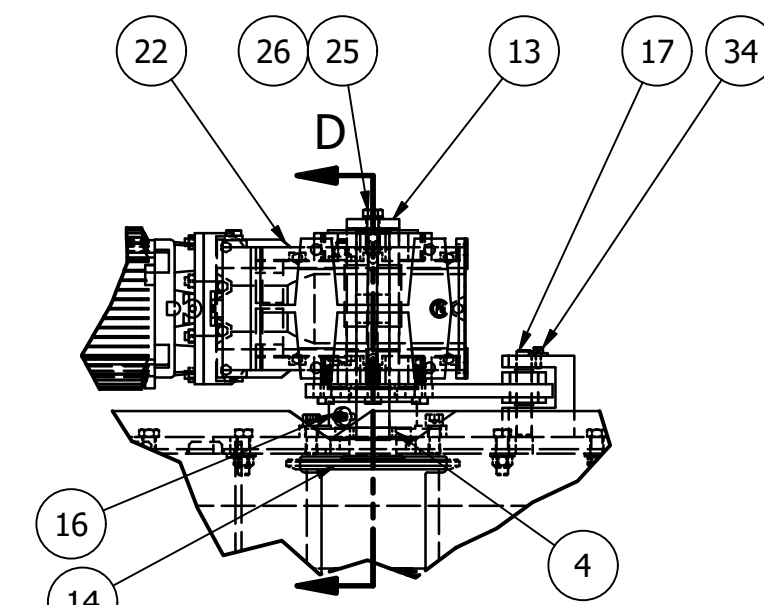
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



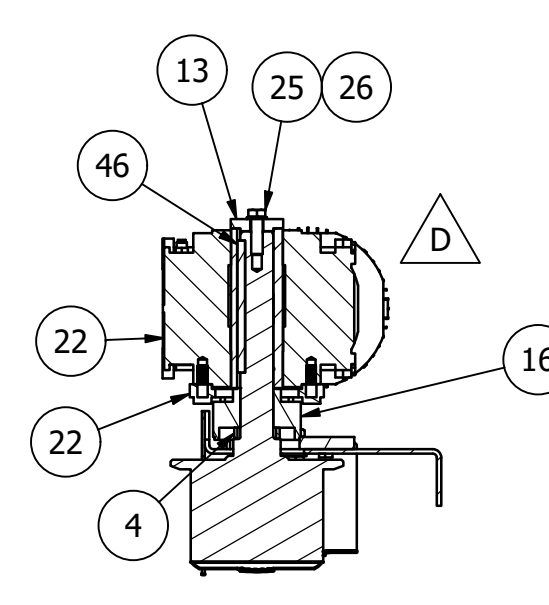
ENLARGED VIEW 'C'
SCALE 1 1/2"=1'-0"



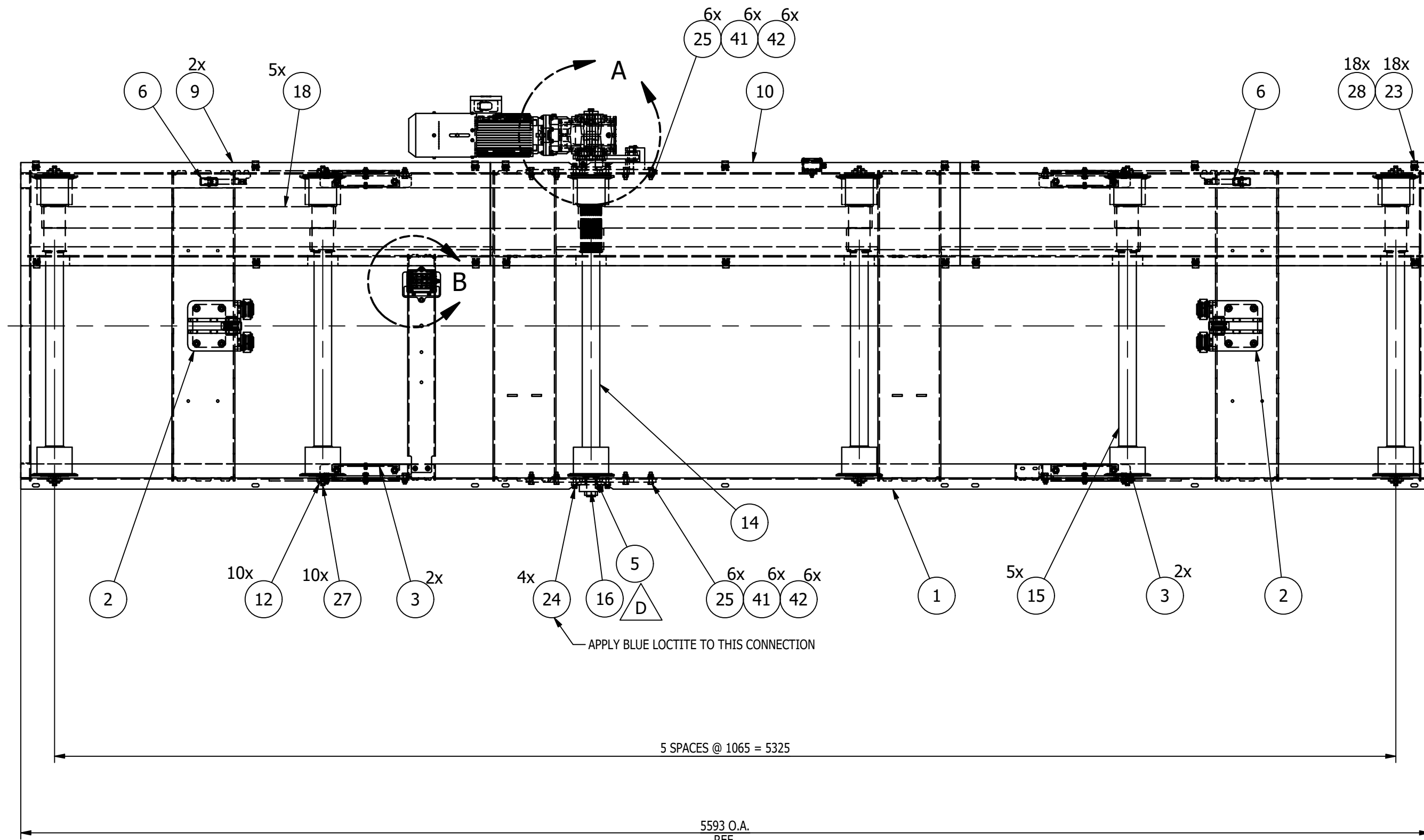
ENLARGED VIEW 'B'
SCALE 1 1/2"=1'-0"



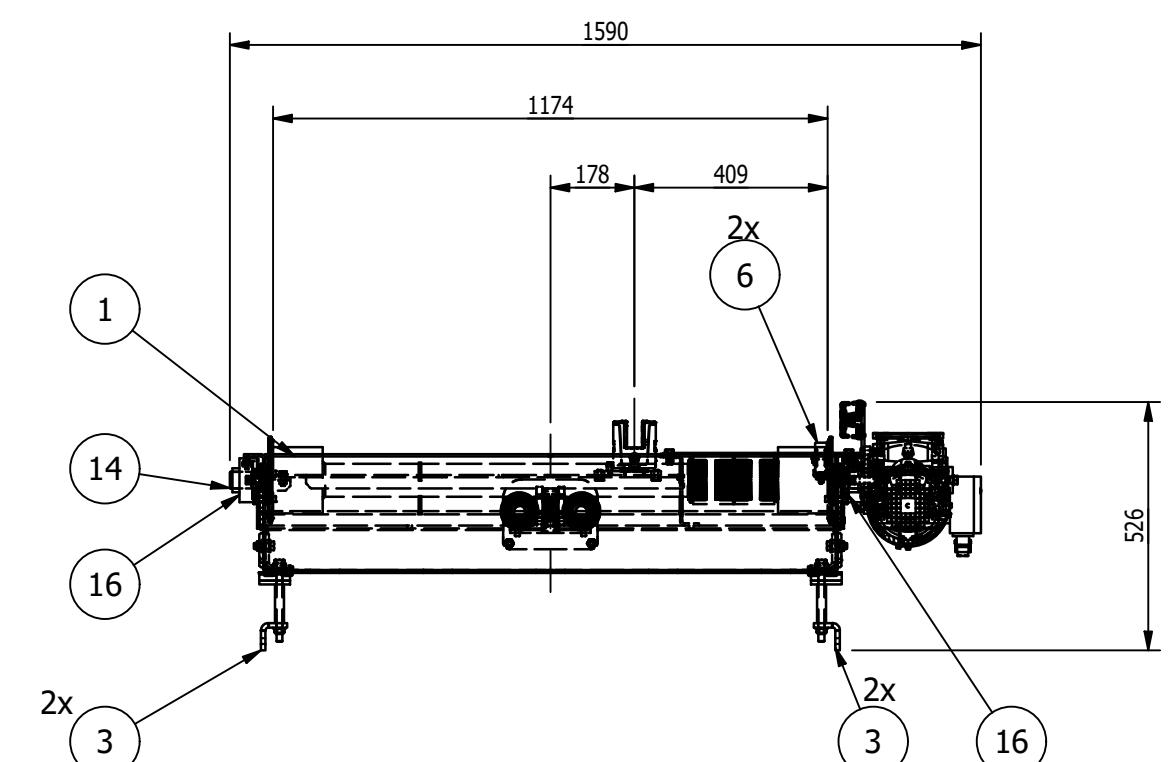
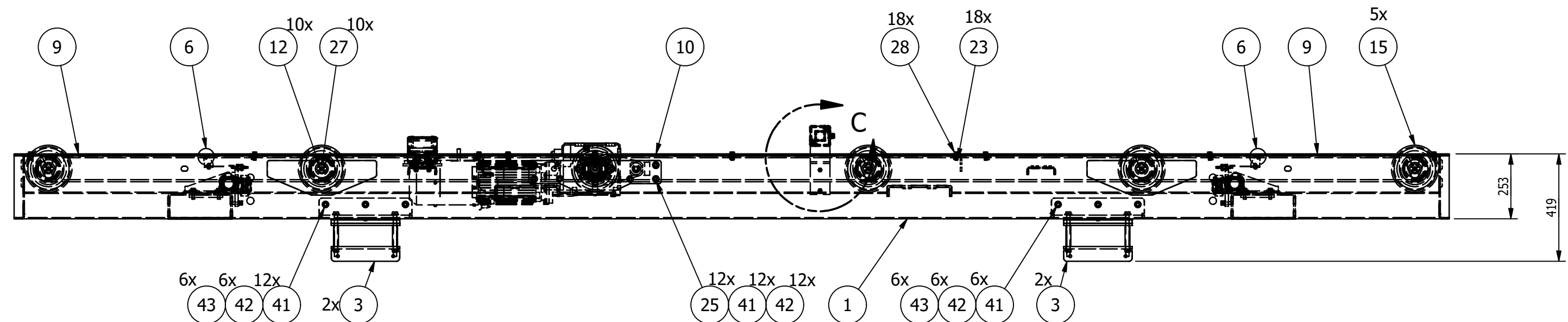
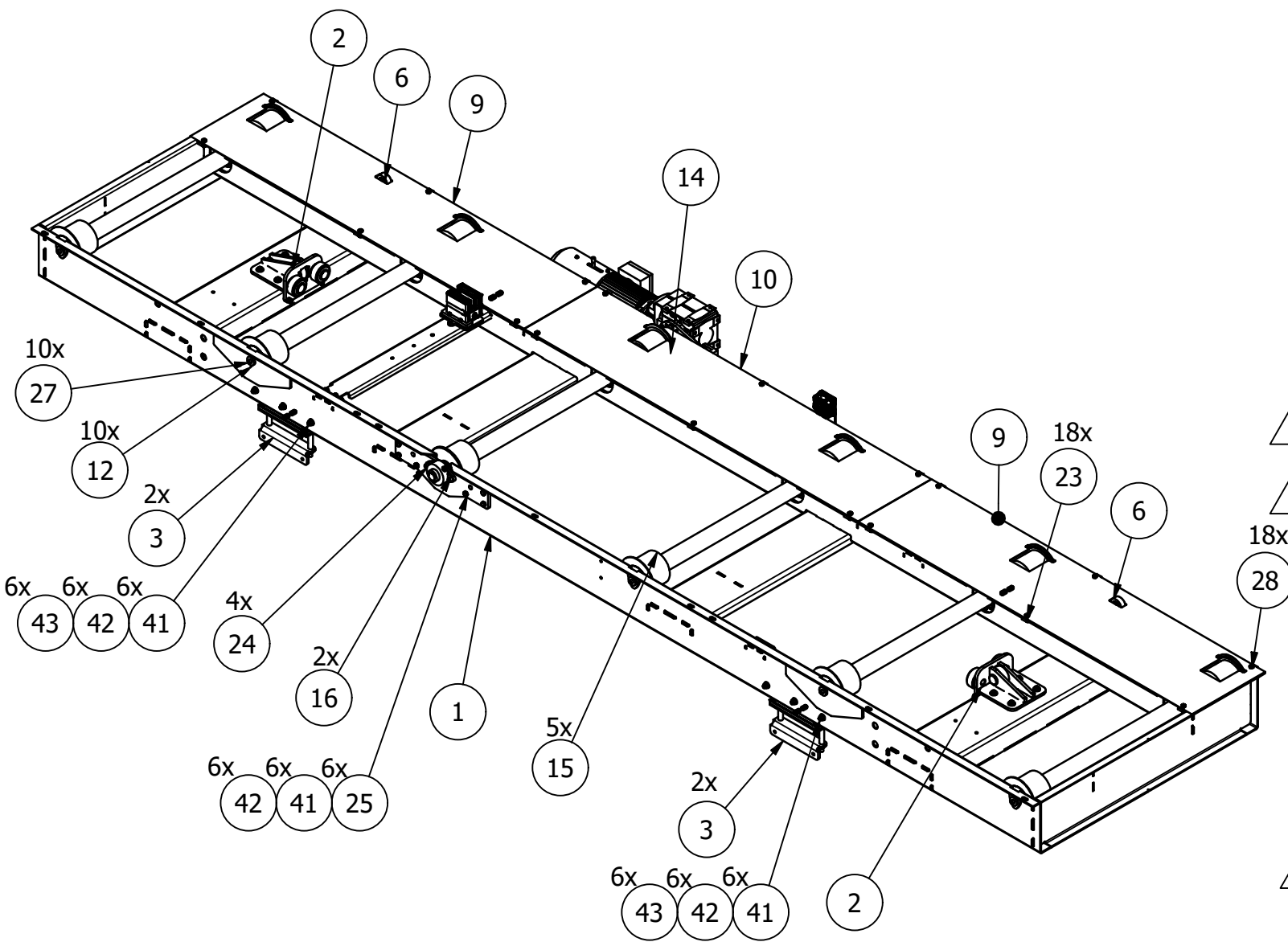
ENLARGED VIEW 'A'
SCALE 1 1/2"=1'-0"



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



MK-D220A ~ D-LOC PRB6 ASSEMBLY
SCALE 3/4"=1'-0"



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D220A			
1	1	MK-D221A ~ D-LOC PRB6 FRAME WELDMENT			
2	2	MK-D231A ~ GUIDE ROLLER ASSEMBLY			
3	4	MK-D236A ~ LIFTER BRACKET ASSEMBLY			
4	1	MK-D116A ~ DRIVE ROLLER SPACER			
5	1	MK-D116B ~ DRIVE ROLLER SPACER2			
6	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
7	1	MK-D119A ~ ENCODER READER MTG PL			
8	1	MK-D119B ~ ENCODER READER HORSESHOE PL			
9	2	MK-D120A ~ END COVER PLATE			
10	1	MK-D120B ~ MID COVER PLATE			
12	10	MK-D121A ~ ROLLER WASHER			
13	1	MK-D121B ~ MOTOR END SPACER			
14	1	PALLET DRIVER ROLLER, DUGOMRULLI PART NO 332192V M12			
15	5	PALLET DRIVEN ROLLER, DUGOMRULLI PART NO 329638V			
16	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
17	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
18	5	GATES POWERGRIP GT4 BELT ~ 2400-8MGT-85		2-1	
19	1	WCS-MP1 ~ BAR CODE READER MTG PLATE ~ PEPPERL&FUCHS		4-2	
20	1	WCS3B-LS310D READ HEAD ~ PEPPERL&FUCHS		4-1	
22	1	SIEMENS RB1 GEARMOTOR (SEE MOTOR DATA LIST)		1-1	
23	18	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
24	4	M12x1.75 x 30mm LG. HEX SOCKET HEAD CAP SCREW			
25	13	M12x1.75 x 40mm LG. HEX CAP SCREW			
26	1	M12 SPRING LOCK WASHER			
27	10	M10x1.5 x 25mm LG. HEX SOCKET HEAD CAP SCREW			
28	18	M10x1.5 x 25mm LG. HEX CAP SCREW			
29	2	M10x1.5 x 16mm LG. HEX CAP SCREW			
30	2	M8x1.25 x 25mm LG. HEX SOCKET HEAD CAP SCREW			
34	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
35	2	M5x0.8 x 12mm LG. HEX SOCKET HEAD CAP SCREW			
38	6	M3x0.5 x 10mm LG. HEX SOCKET HEAD CAP SCREW			
39	1	MK-D240A ~ RF CODE READER BRKT			
40	2	M8 x 1.25 STOVER LOCK NUT			
41	36	M12 NARROW FLAT WASHER			
42	24	M12 x 1.75 STOVER LOCK NUT			
43	12	M12x1.75 x 35mm LG. HEX CAP SCREW			
44	2	M6x1 x 20mm LG. HEX CAP SCREW			
45	2	M6 NARROW FLAT WASHER			
46	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	

- SHOP NOTES:**
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 - 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.

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Phone: (248) 772-8800
Fax: (248) 772-8801
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D220 - REV D

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

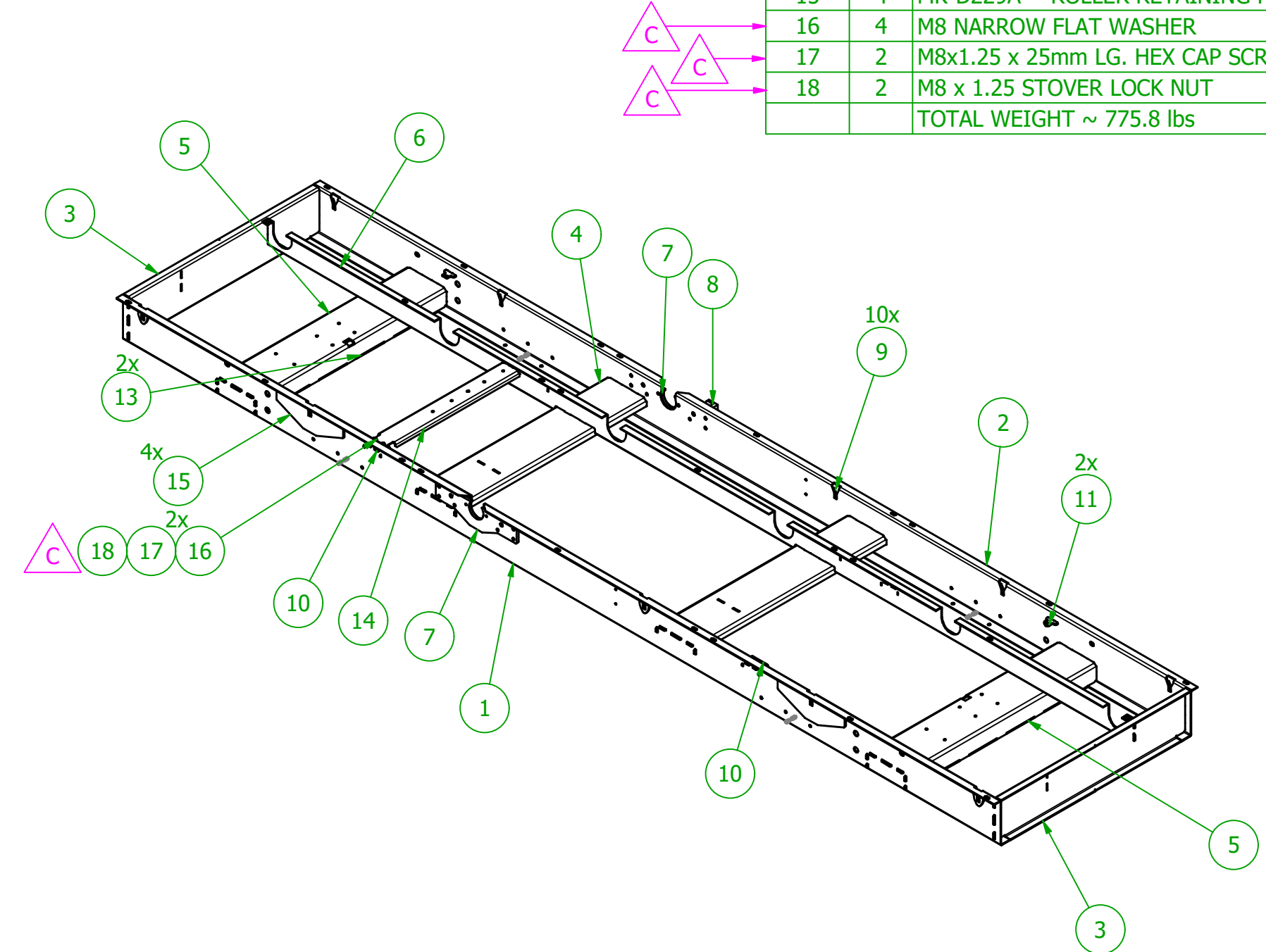
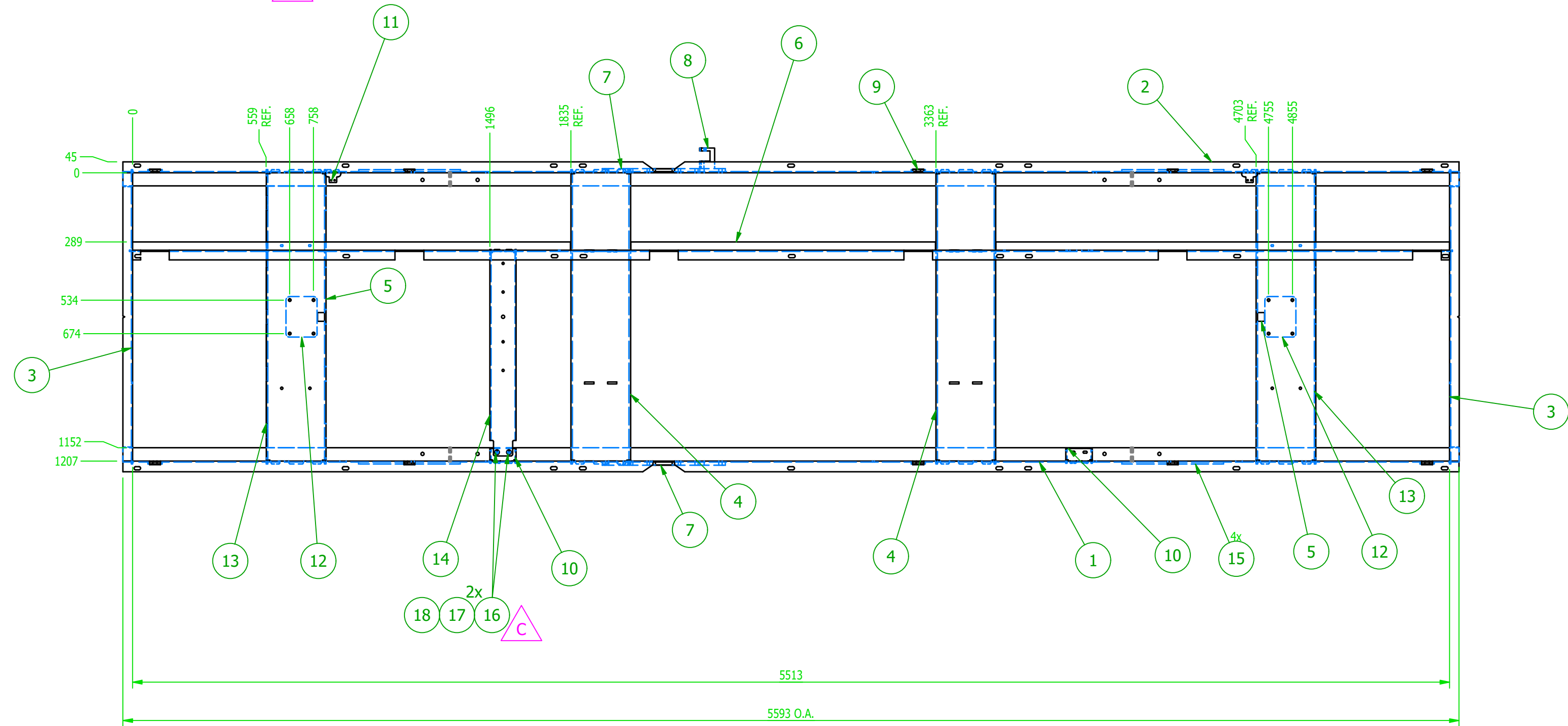
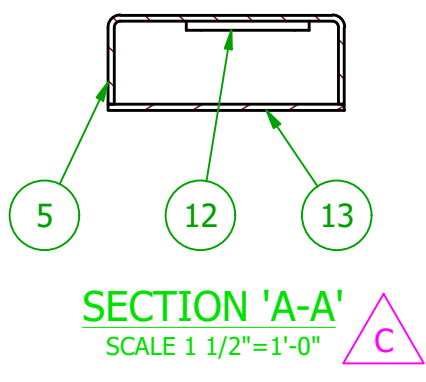
COPIES:

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

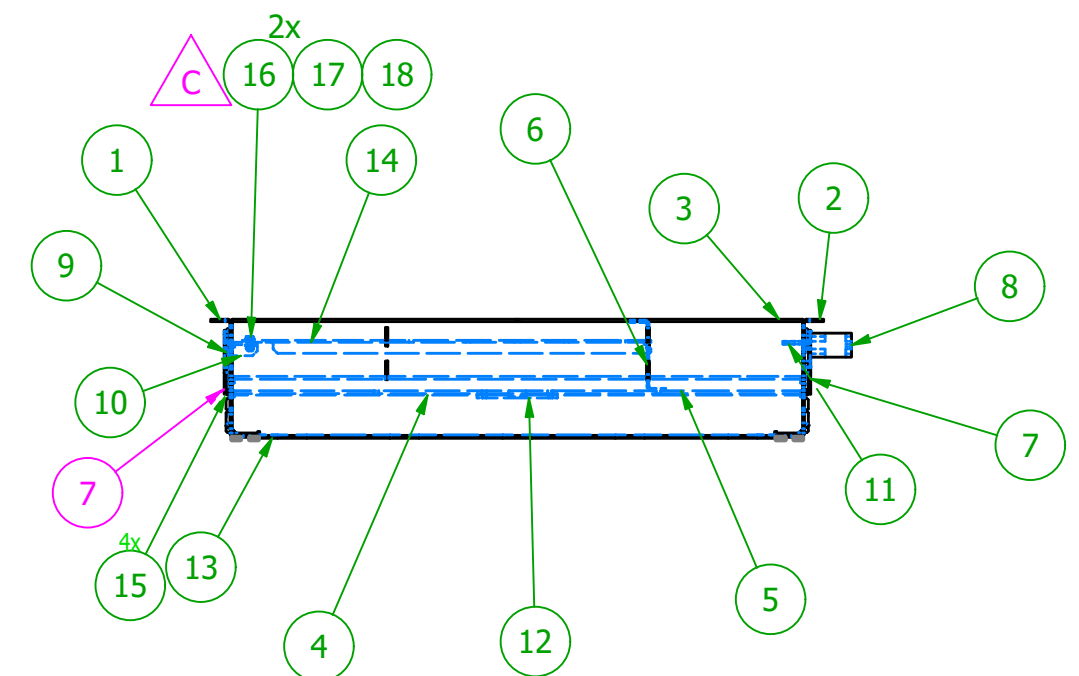
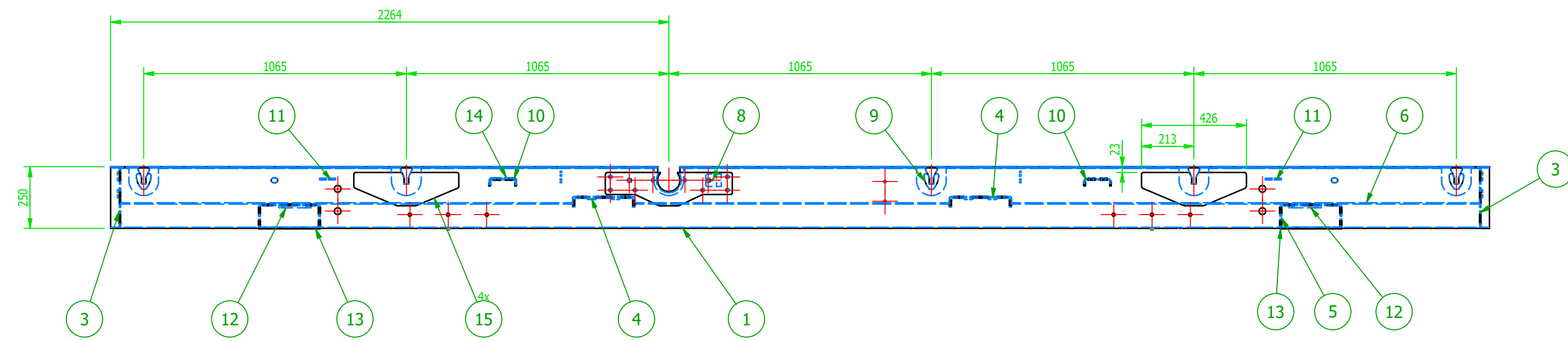
REV	BY	DATE	DESCRIPTION	APP
D	MC	7/27/2022	ADDED SPACER, ADDED ITEM '46', & SECTION D REMOVED ITEMS '31', '32', '36', '37'; ADDED ITEMS '41', '42', '43', '44', '45'; REVISED DESCRIPTION OF ITEM '6' & '17'; REVISED QTY OF ITEM '12' WAS 12 NOW 10, ITEM '25' WAS 1 NOW 13, ITEM '27' WAS 12 NOW 10, ITEM '38' WAS 4 NOW 6, ITEM '40' WAS 4 NOW 2; ADDED ABM # TO ITEMS '16' & '20'; REVISED SHOP NOTES; REVISED BALLOONS	
C	MC	7/13/2022		
B	MC	7/6/2022	ADDED ROLLER SUPPORT PLATES	
A	MC	7/1/2022	FOR FABRICATION	

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	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D220	DRAWN BY: AH CHECKED BY: CW DWG DATE: 6/20/22 REV: D JOB No: 22096

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D221A			
1	1	MK-D223A ~ SIDE FRAME			
2	1	MK-D224A ~ SIDE FRAME			
3	2	MK-1875D106A ~ END FRAME			
4	2	MK-D226A ~ INNER CROSS MEMBER			
5	2	MK-D227A ~ INNER CROSS MEMBER			
6	1	MK-D225A ~ MID FRAME			
7	2	MK-D111A ~ MOTOR MOUNTING PLATE			
8	1	MK-D111D ~ CLEVIS			
9	6	MK-D111B ~ RETAINER			
10	2	MK-D113A ~ BRACKET			
11	2	MK-D113B ~ ENCODER BRACKET			
12	2	MK-D227C ~ STIFFENER PLATE			
13	2	MK-D227B ~ STIFFENER PLATE			
14	1	MK-D118A ~ BAR CODE READER BRKT			
15	4	MK-D229A ~ ROLLER RETAINING PLATE			
16	4	M8 NARROW FLAT WASHER			
17	2	M8x1.25 x 25mm LG. HEX CAP SCREW			
18	2	M8 x 1.25 STOVER LOCK NUT			
		TOTAL WEIGHT ~ 775.8 lbs			



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



MK-D221A ~ D-LOC PRB6 FRAME WELDMENT
SCALE 3/4"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
C	MC	7/13/2022	ADDED ITEMS '16', '17', & '18'; UPDATED SHOP NOTES; ADDED SECTION 'A'	
B	MC	7/6/2022	ADDED ITEM #15 & QTY OF ITEM #9 WAS 10	
A	MC	7/1/2022	FOR FABRICATION	

MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH
	CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D221	REV: C	DWG DATE: 6/20/22
		JOB No: 22096

MAGNUM Consulting
 41100 Garden Road
 Suite 125
 Novi, MI 48275
 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 A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

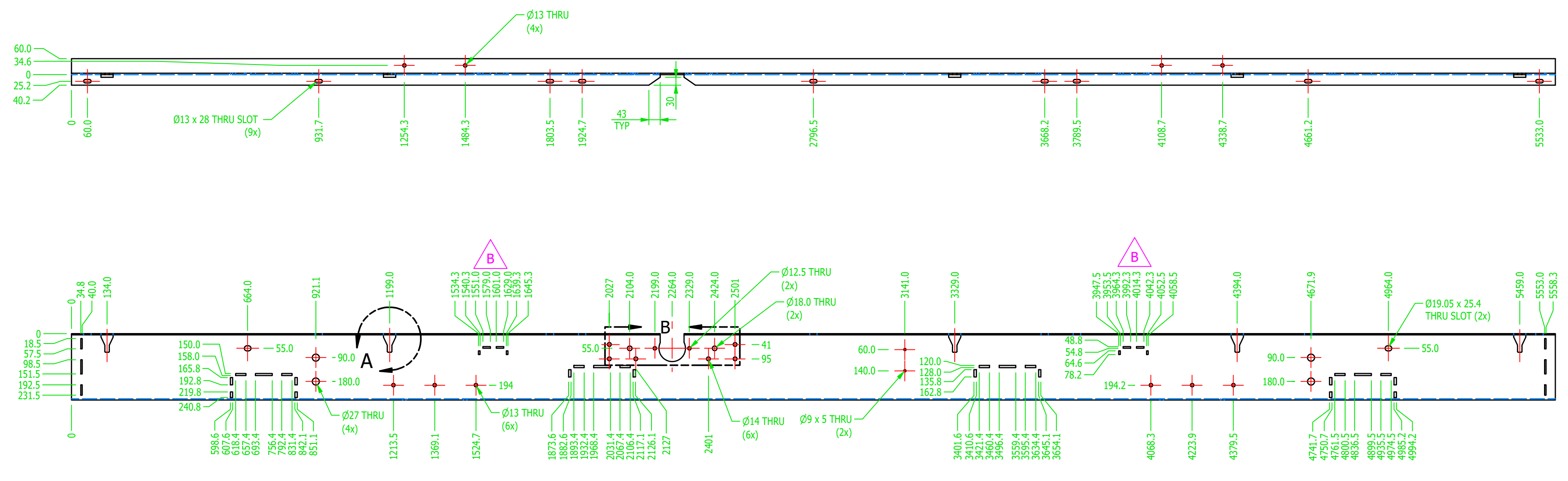
HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

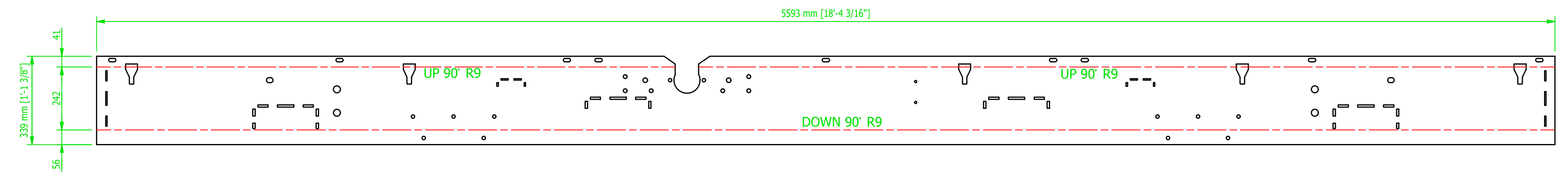
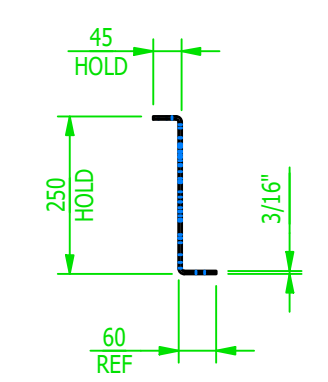
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D223A			
1	1	PL 3/16 x 1'-1 3/8"	18'-4 3/16"		
TOTAL WEIGHT ~ 153.5 lbs					

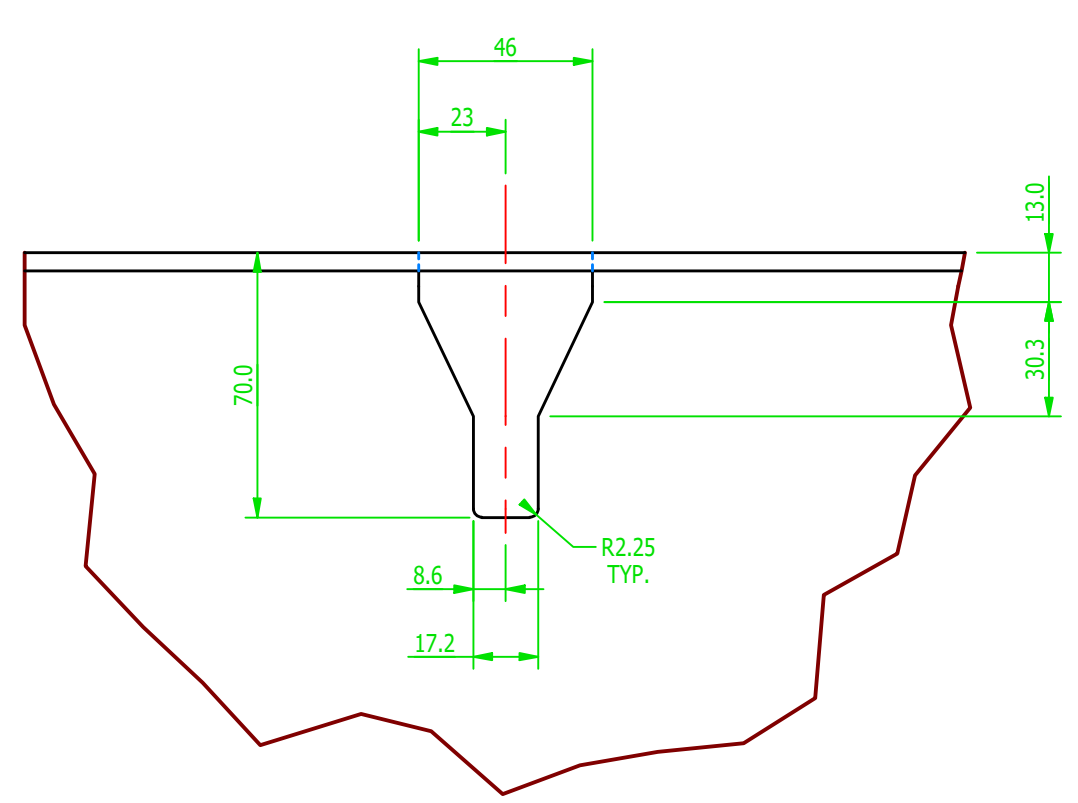


MK-D223A ~ SIDE FRAME
SCALE 1"=1'-0"

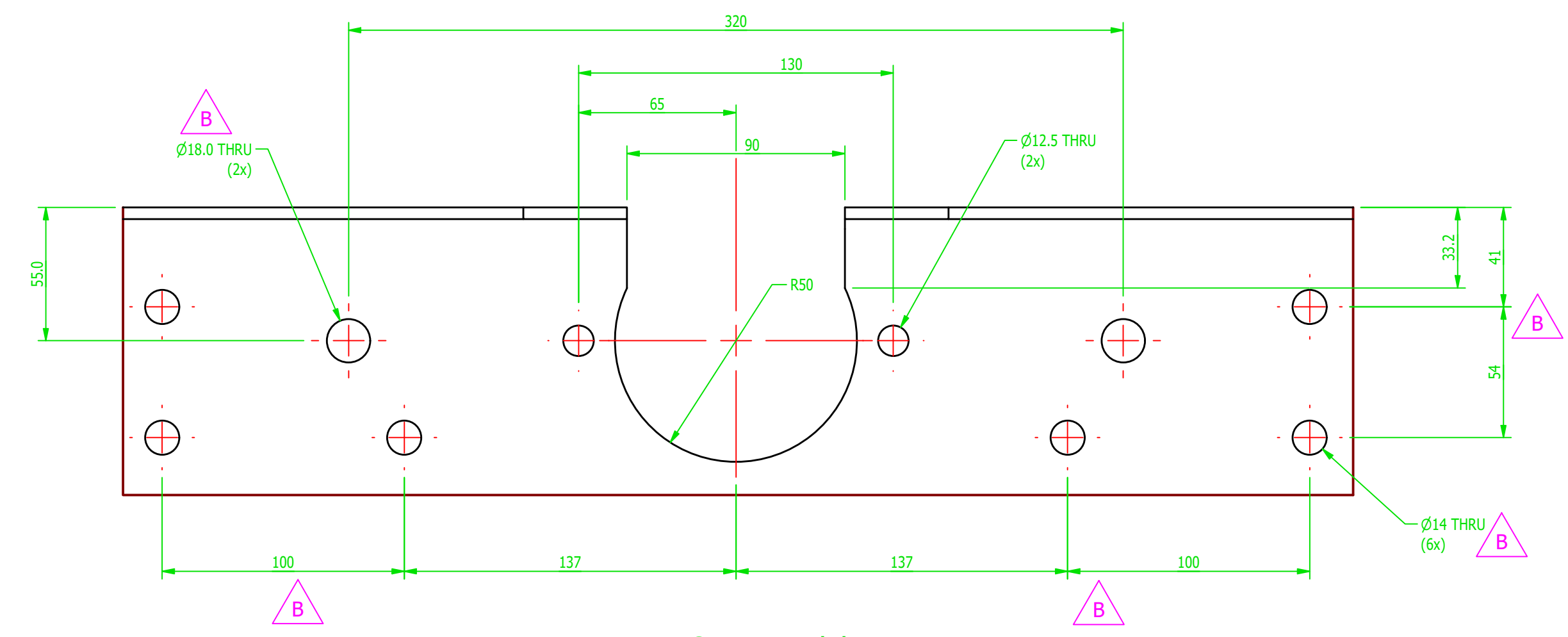


FLAT PATTERN OF ITEM '1'
SCALE 1"=1'-0"

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



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



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

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

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41100 Clarkston Rd.
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Fax: (248) 772-8851
Web: www.m4magnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D223

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.

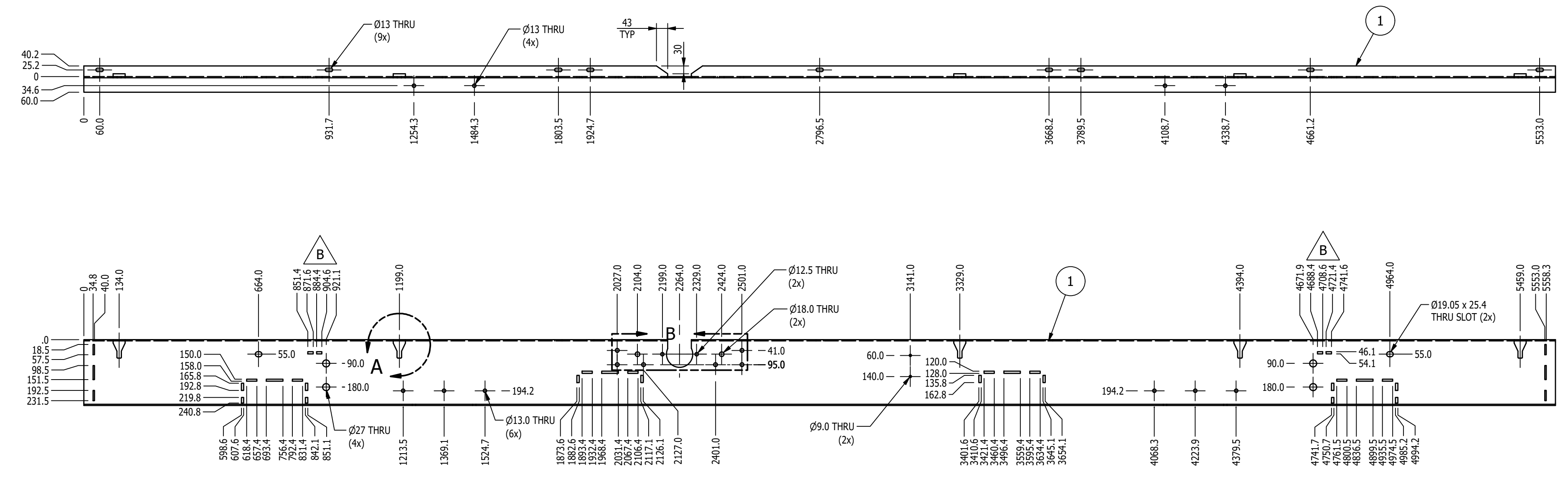
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

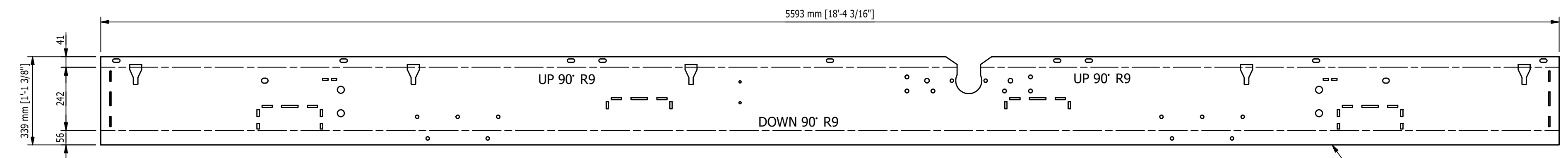
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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-D224A			
		PL 3/16 x 1'-1 3/8"	18'-4 3/16"		
		TOTAL WEIGHT ~ 153.6 lbs			

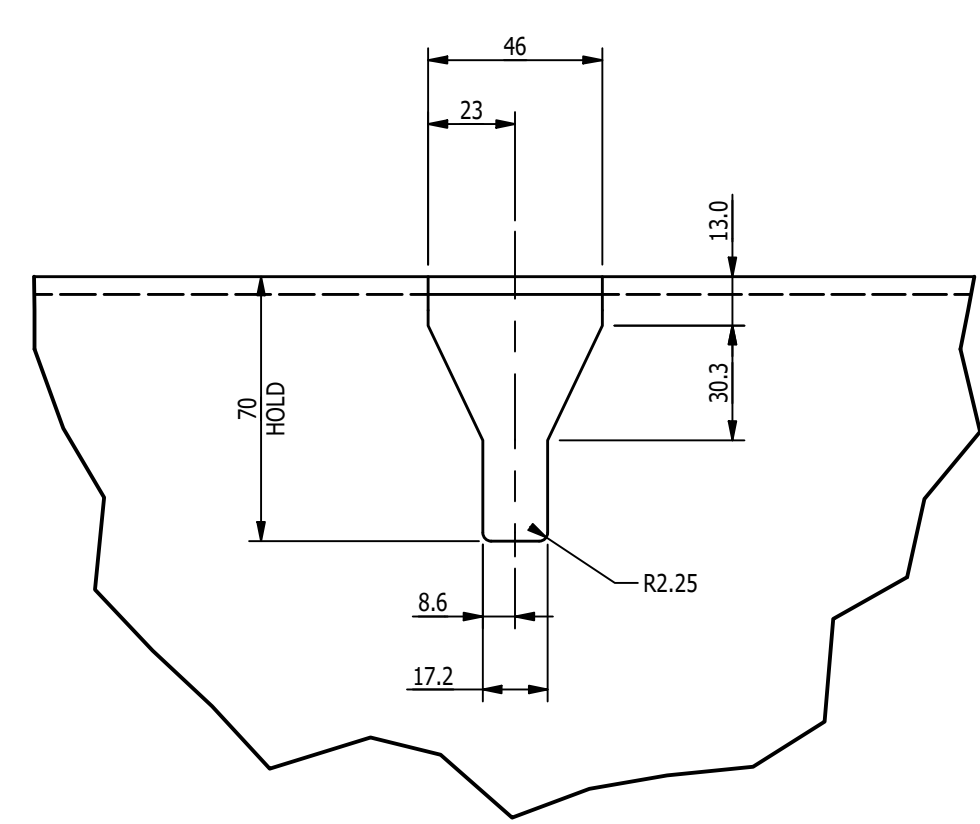


MK-D224A ~ SIDE FRAME
SCALE 1"=1'-0"

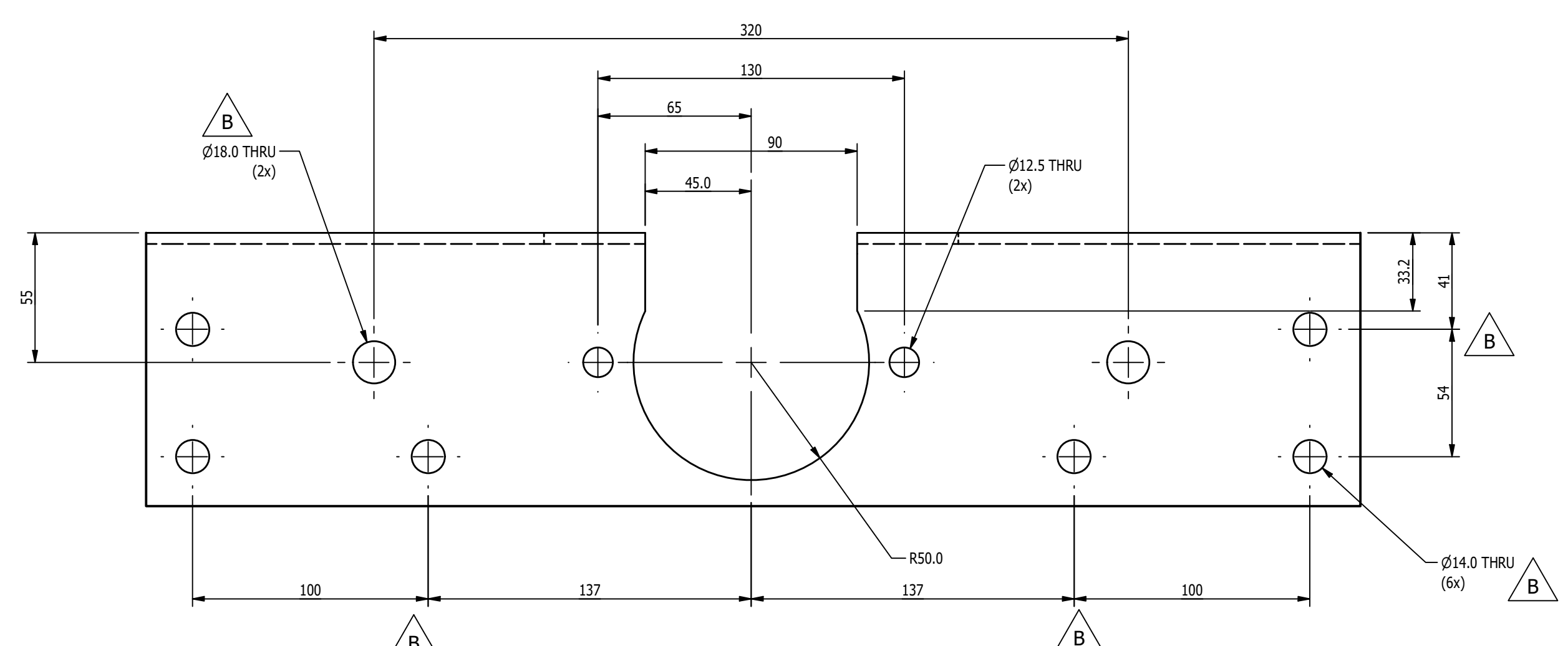


FLAT PATTERN OF ITEM '1'
SCALE 1"=1'-0"

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



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



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

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/14/2022	REVISED DIMENSIONS AND SHOP NOTE	
A	MC	7/5/2022	FOR FABRICATION	
REVISION HISTORY				

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Fax: (248) 773-8851
Web: www.m4magnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D224

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)

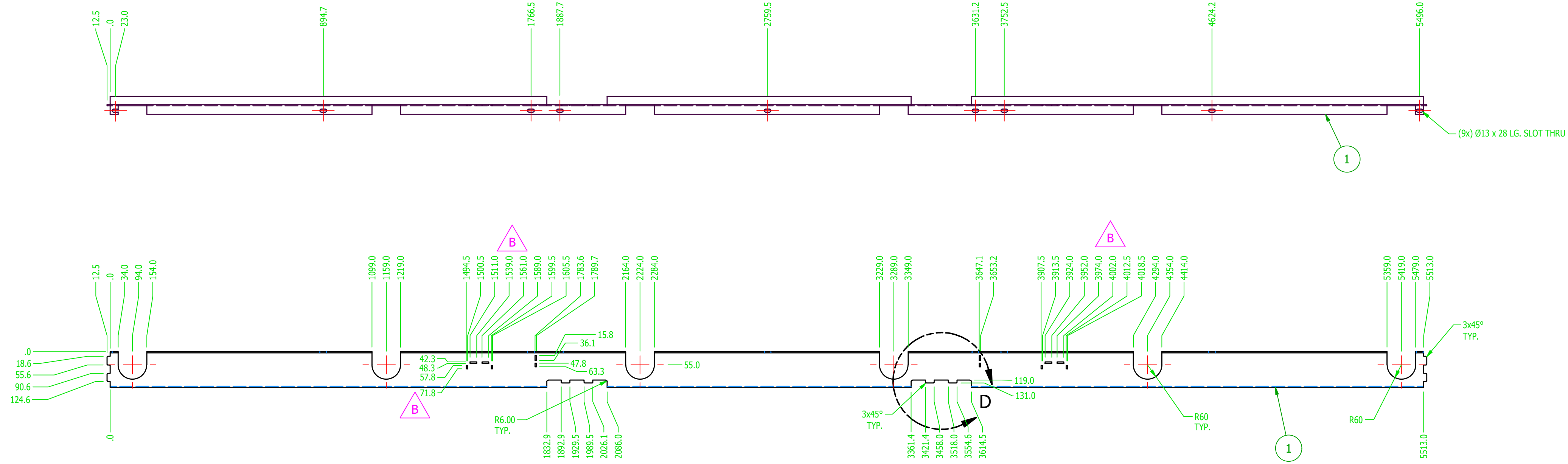
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

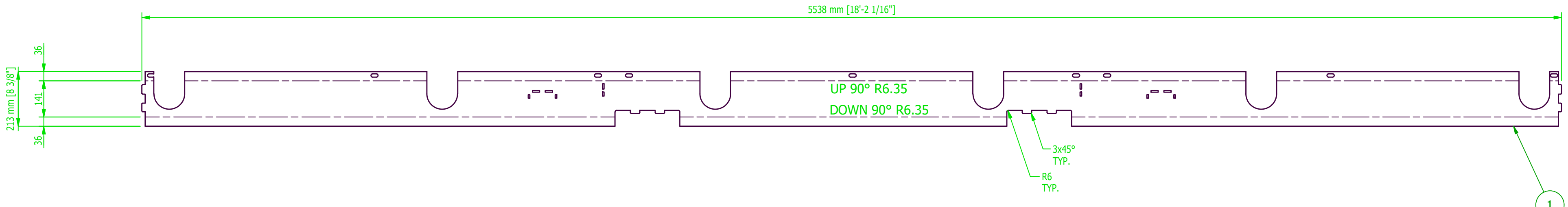
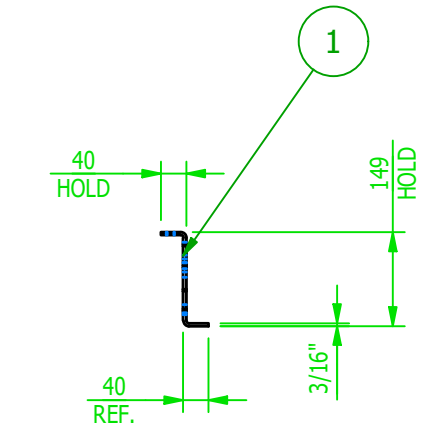
COPIES:

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

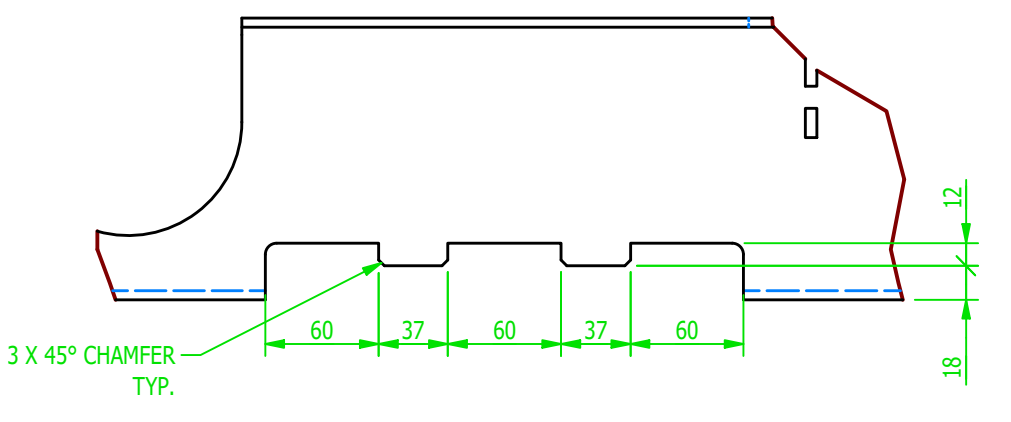
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D225A			
		PL 3/16 x 8 3/8"	18'-2 1/16"		
		TOTAL WEIGHT ~ 86.8 lbs			



MK-D225A ~ MID FRAME
SCALE 1"=1'-0"



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



ENLARGED VIEW 'D'
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

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/14/2022	REVISED DIMENSIONS AND SHOP NOTE	
A	MC	7/5/2022	FOR FABRICATION	

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	<small>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</small>
	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO	DRAWN BY: RPM CHECKED BY: CW DWG DATE: 6/20/22

MAGNUM CONSULTING
 41100 QuakerRoad Rd
 Suite 125
 Novi, MI 48235
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D225

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

GENERAL NOTES:

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

HOLES:

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

WELDS:

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

PAINT:

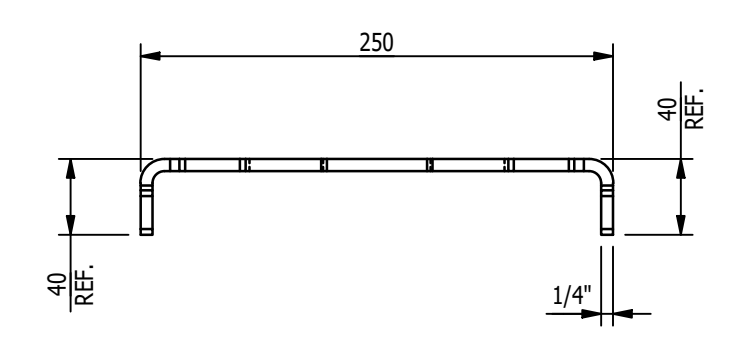
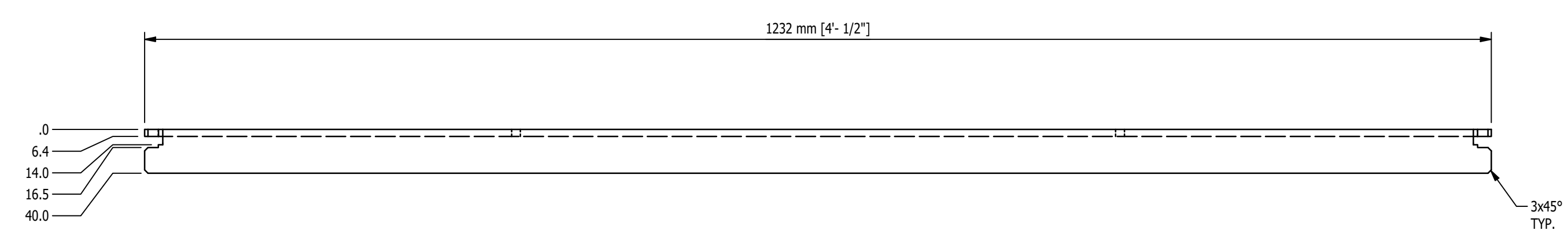
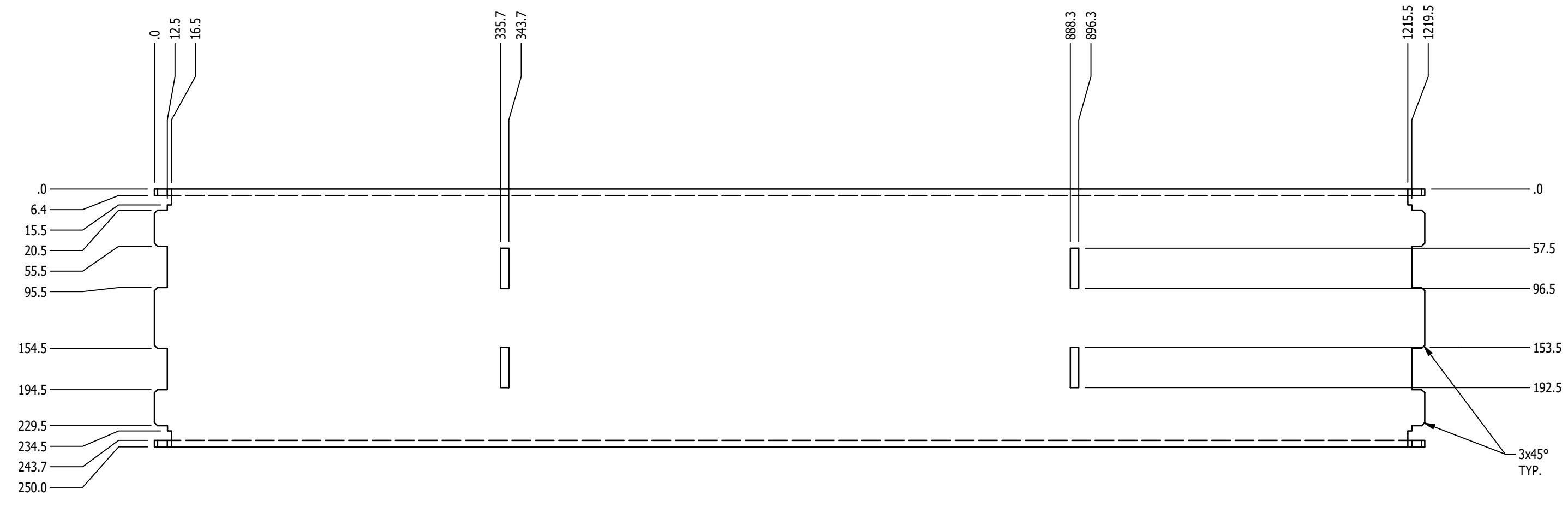
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

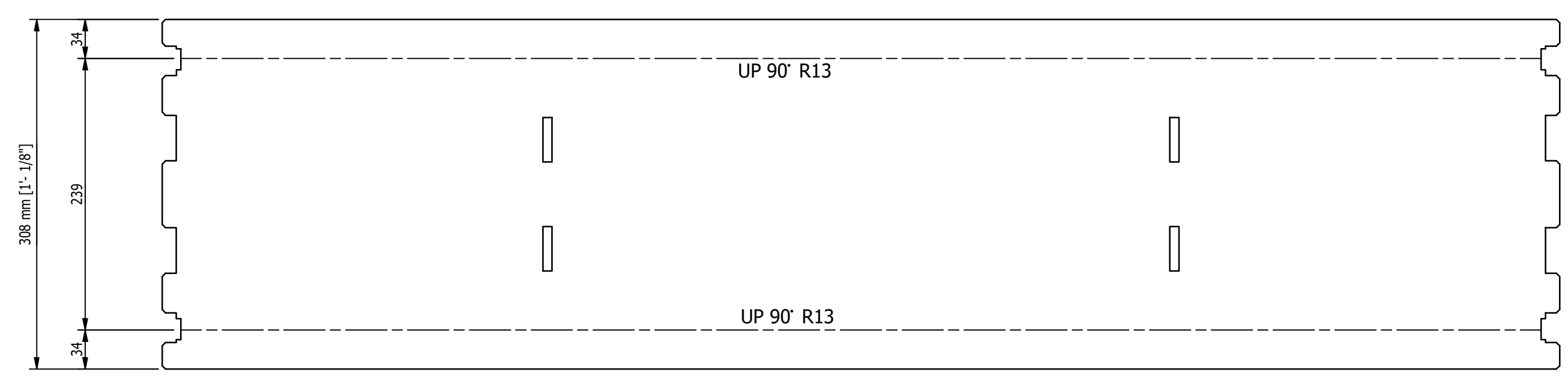
- ALL REFRANT CUTS TO BE A MIN 1/2" RADIUS U.N.O.

DRAWING No.	1875D225	REV:	B	JOB No:	22096
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BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D226A			
1	1	PL 1/4 x 1'-1/8"	4'- 1/2"		
		TOTAL WEIGHT ~ 41.4 lbs			



MK-D226A ~ INNER CROSS MEMBER
SCALE 3"=1'-0"



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

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

PAINT NOTES:
PAINT AFTER WELDING

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RPM
CLIENT:	VOLVO	CHECKED BY:	XXX
DRAWING No.	1875D226	DWG DATE:	6/17/22
REV:	A	JOB No:	22096

MAGNUM CONSULTING

41100 Charleston Rd.
Suite 125
North, MI 48315

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D226

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:

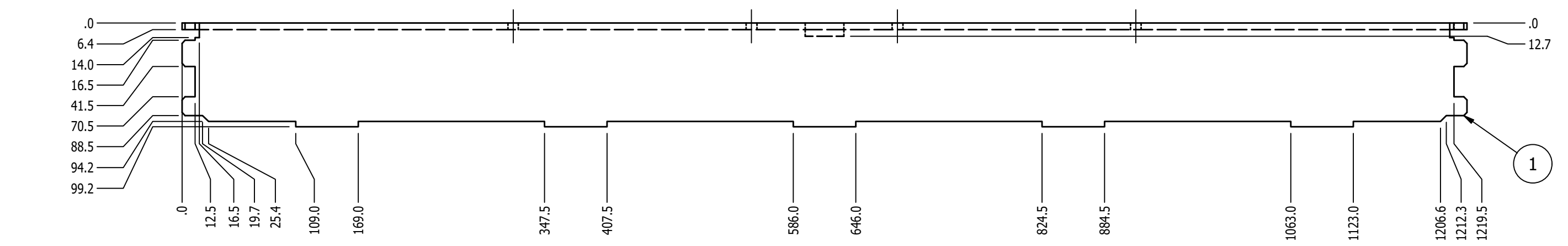
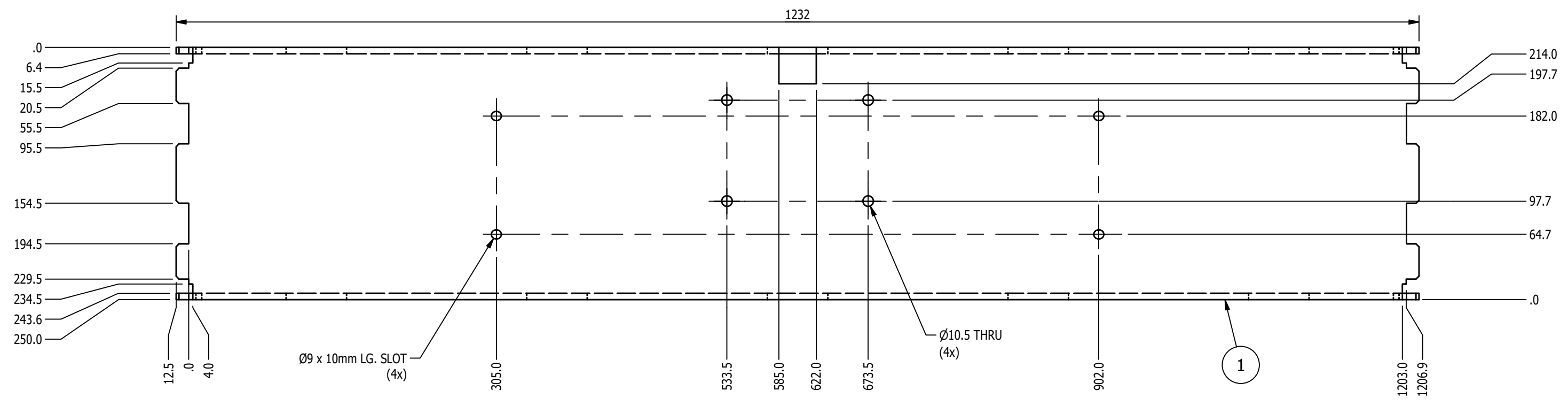
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

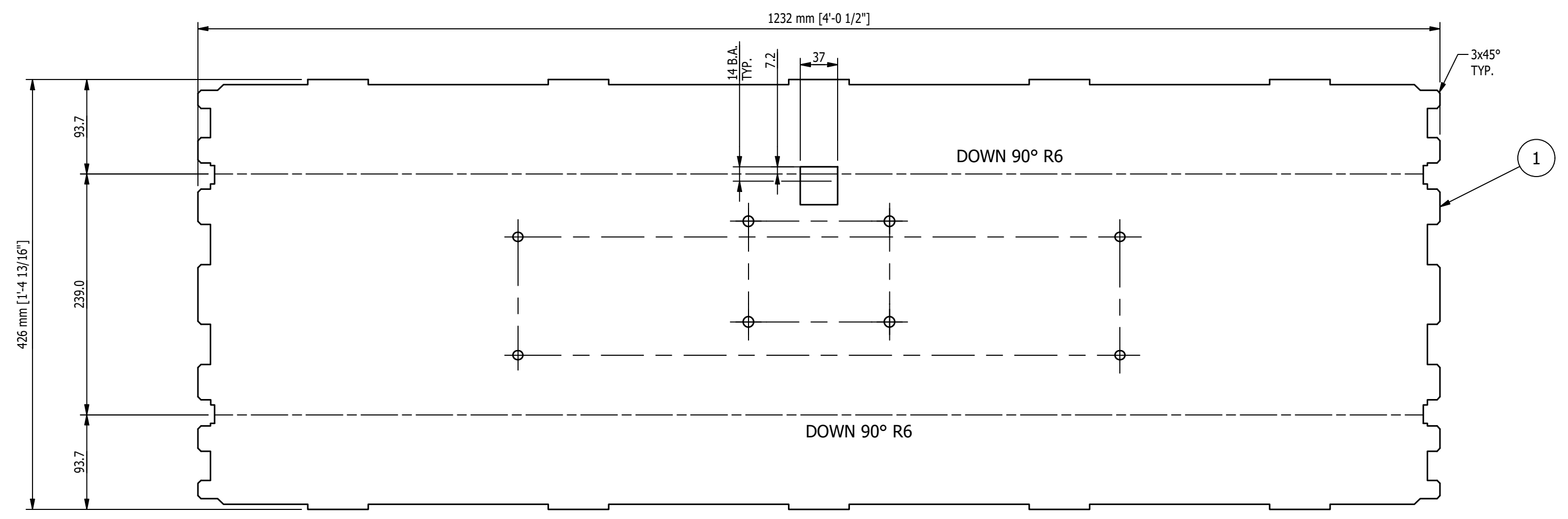
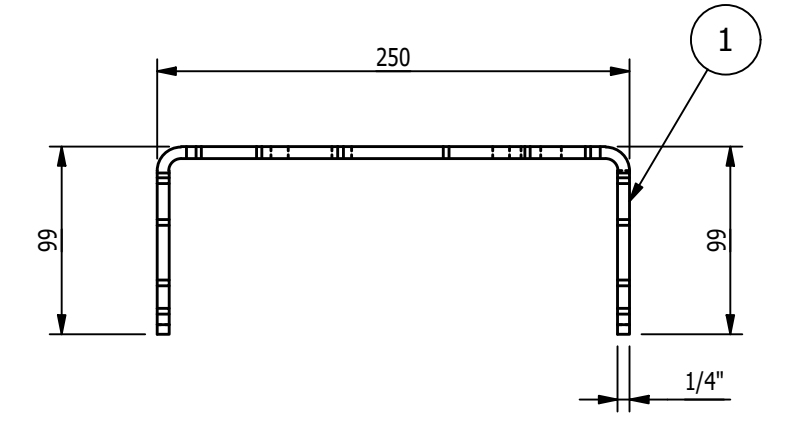
WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

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

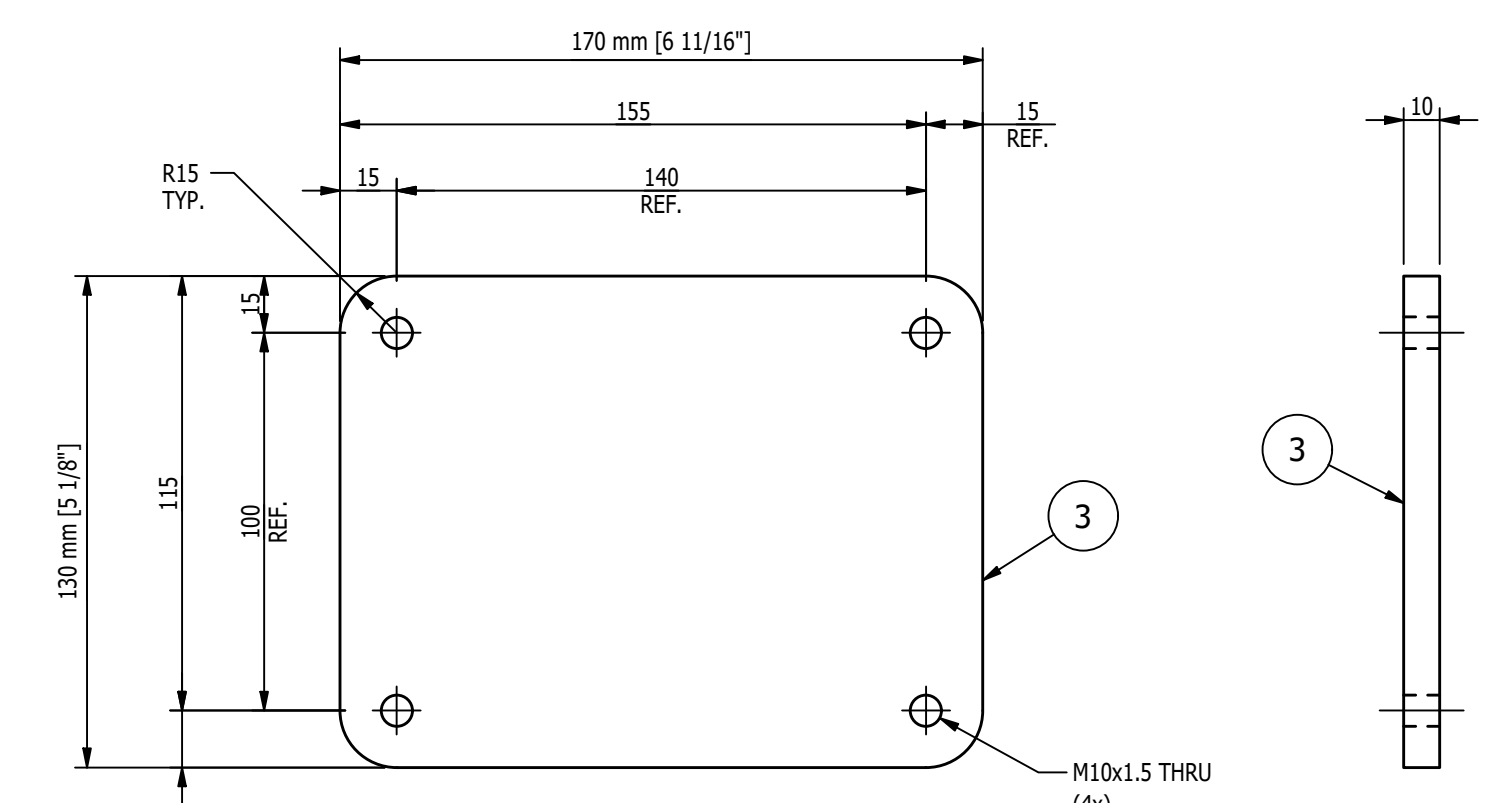
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



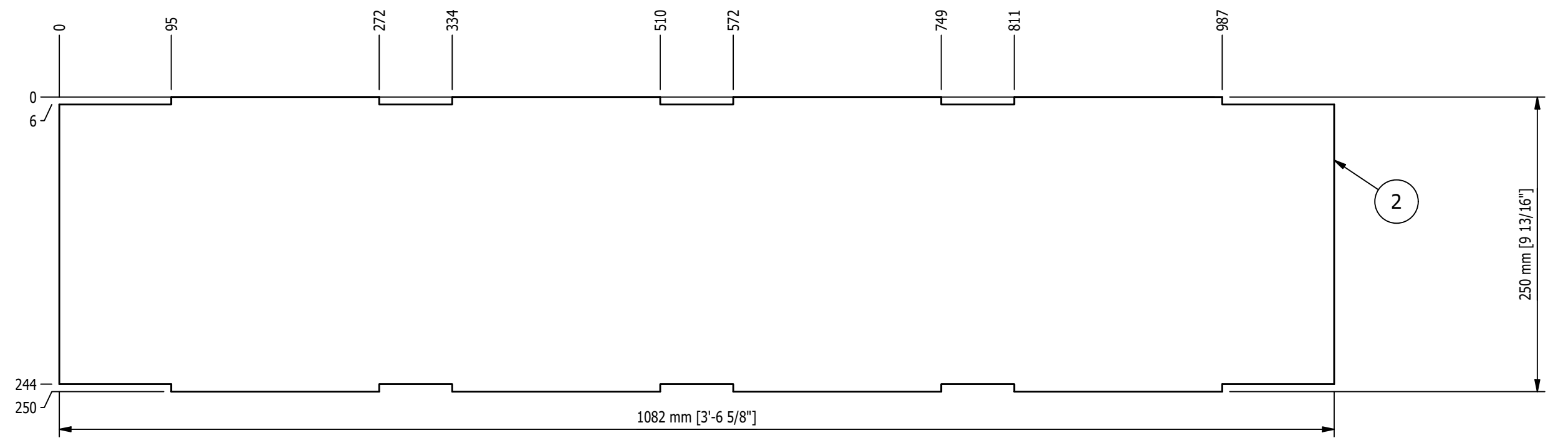
MK-D227A ~ INNER CROSS MEMBER
SCALE 3"=1'-0"



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



MK-D227C ~ STIFFENER PLATE
SCALE 6"=1'-0"



MK-D227B ~ STIFFENER PLATE
SCALE 3"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D227A			
1	1	PL 1/4 x 1'-4 13/16"	4'- 1/2"		
		TOTAL WEIGHT ~ 56.1 lbs			
		MK-D227B			
2	1	PL 1/4 x 9 13/16"	3'-7 1/8"		
		TOTAL WEIGHT ~ 29.7 lbs			
		MK-D227C			
3	1	PL 3/8 x 5 1/8"	6 11/16"		
		TOTAL WEIGHT ~ 3.6 lbs			

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

PAINT NOTES:
PAINT AFTER WELDING

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/23/2022	REVISED LENGTH AND SLOTS MK-D227B	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

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

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RPM
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D227	DWG DATE:	6/20/22
REV:	B	JOB No.:	22096

MAGNUM Consulting
41100 Clarkston Road
Suite 125
Novi, MI 48165

Phone: (248) 772-8800
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D227 - REV B

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

GENERAL NOTES:

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

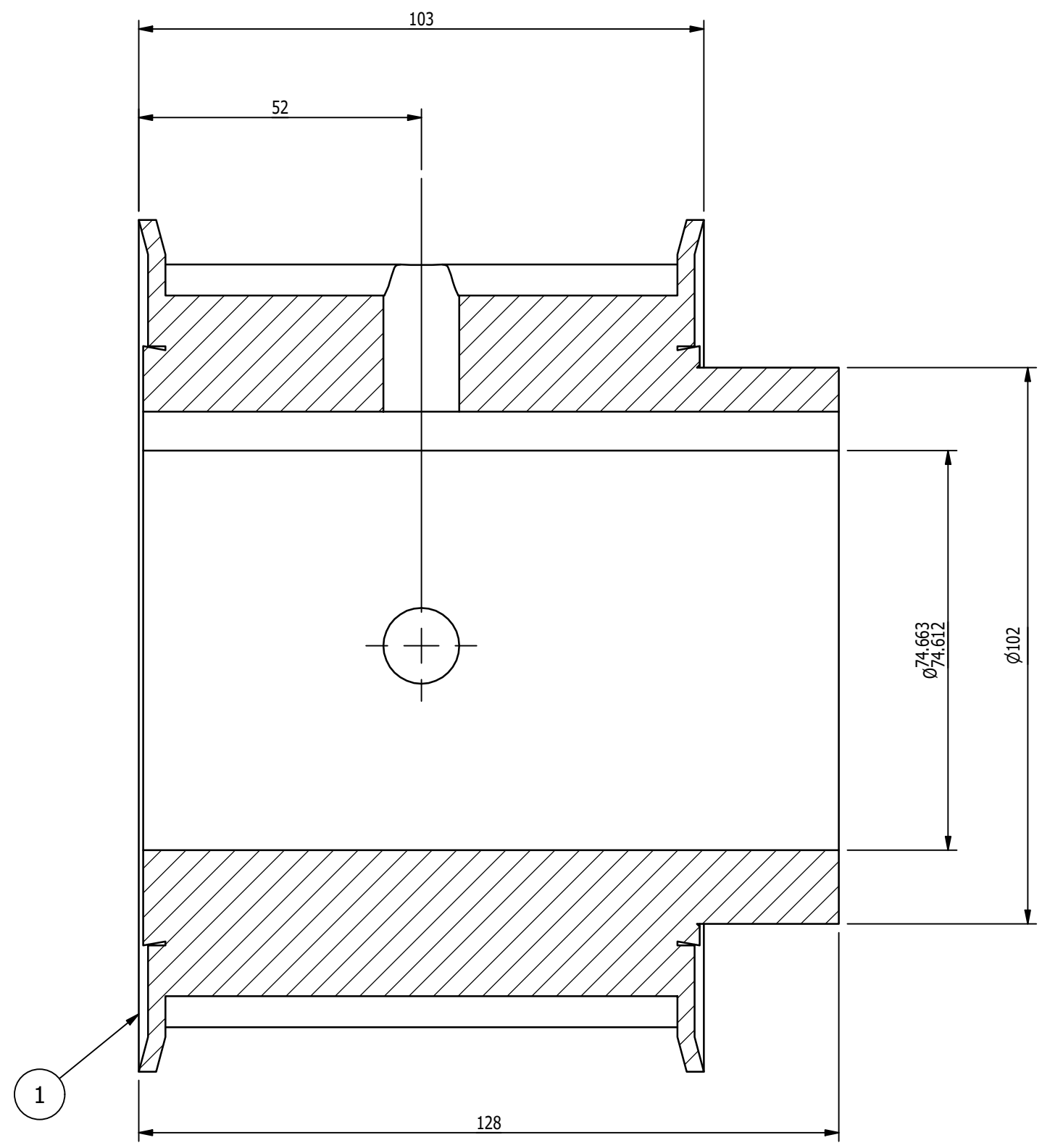
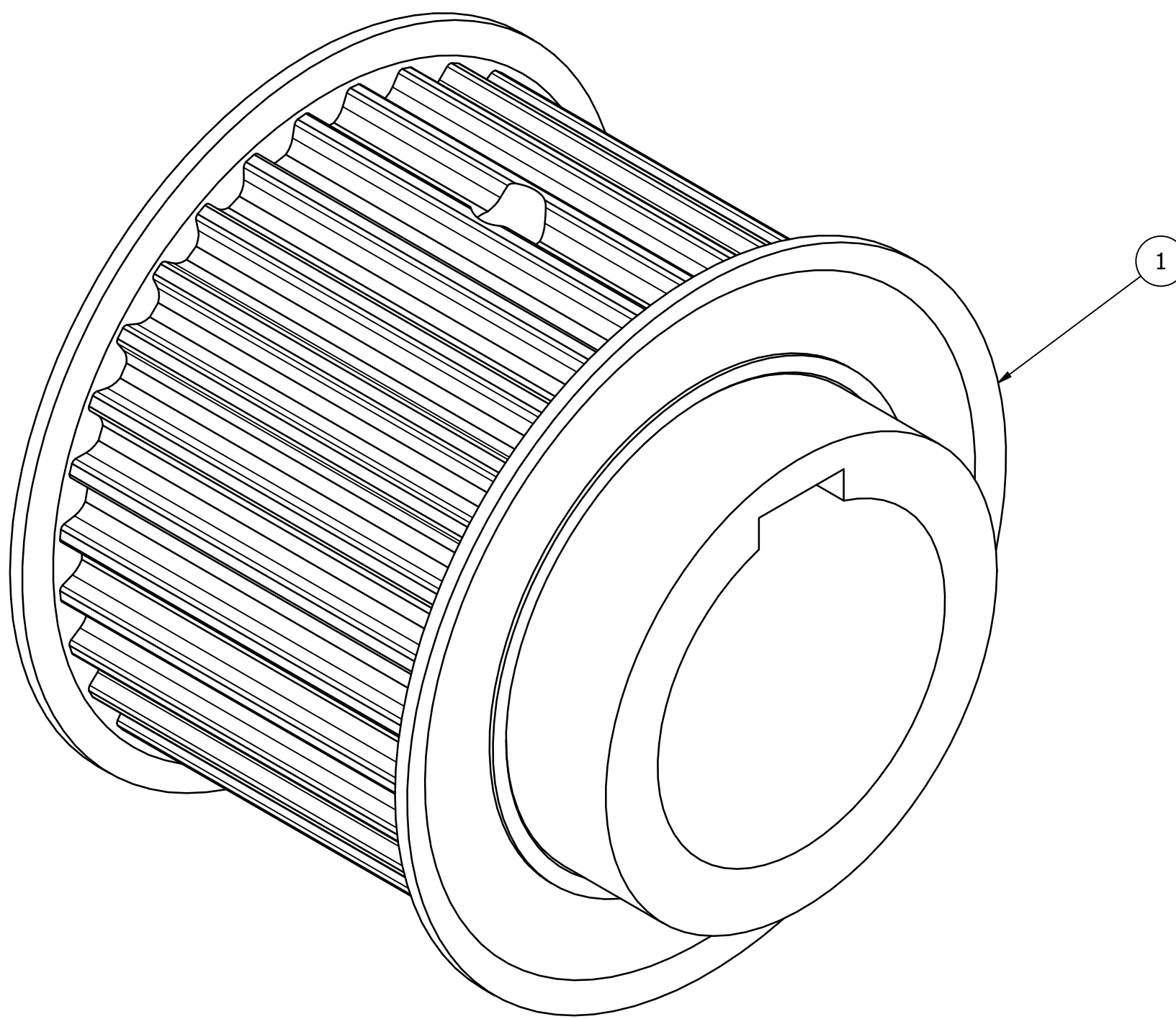
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

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

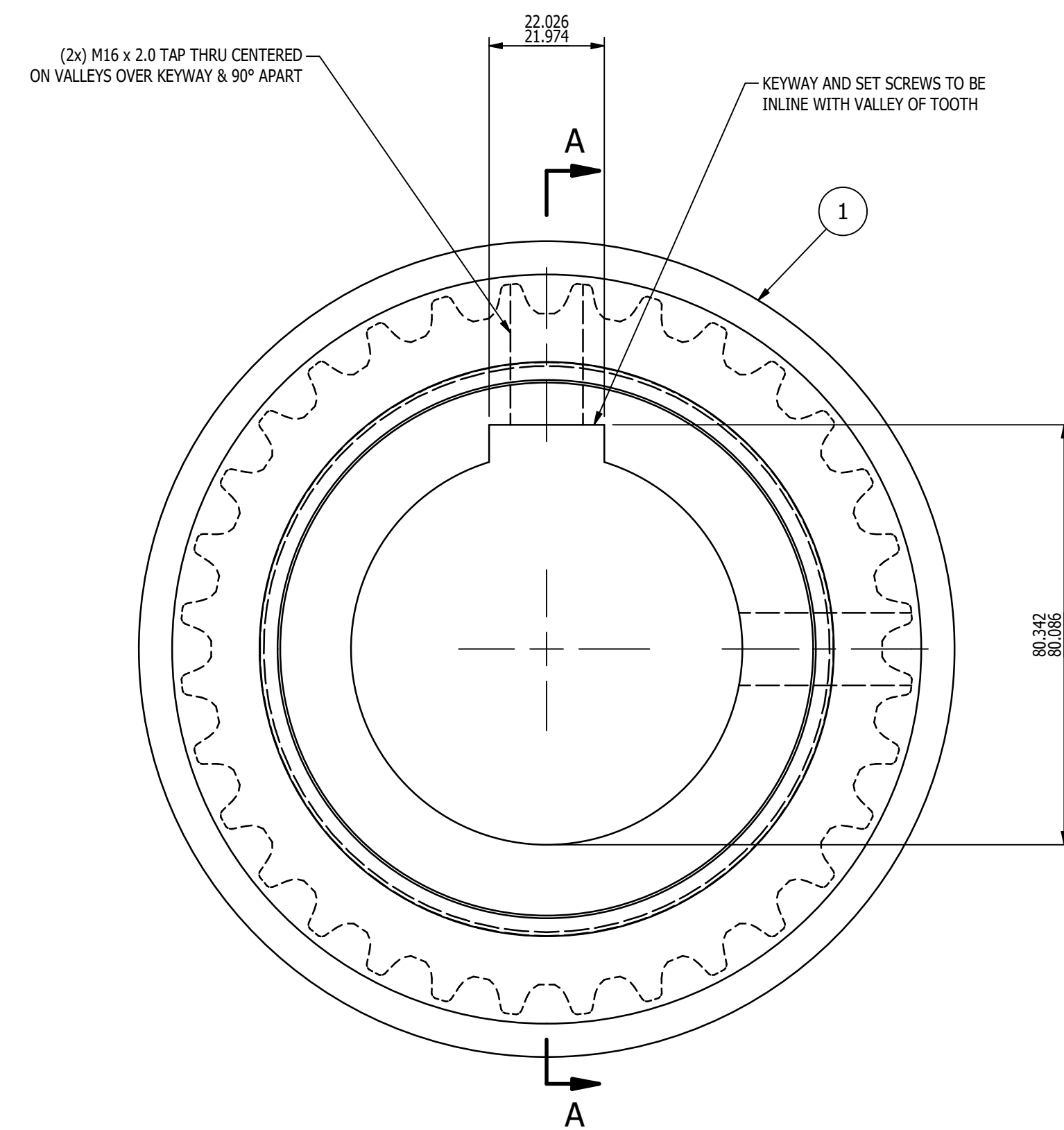
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

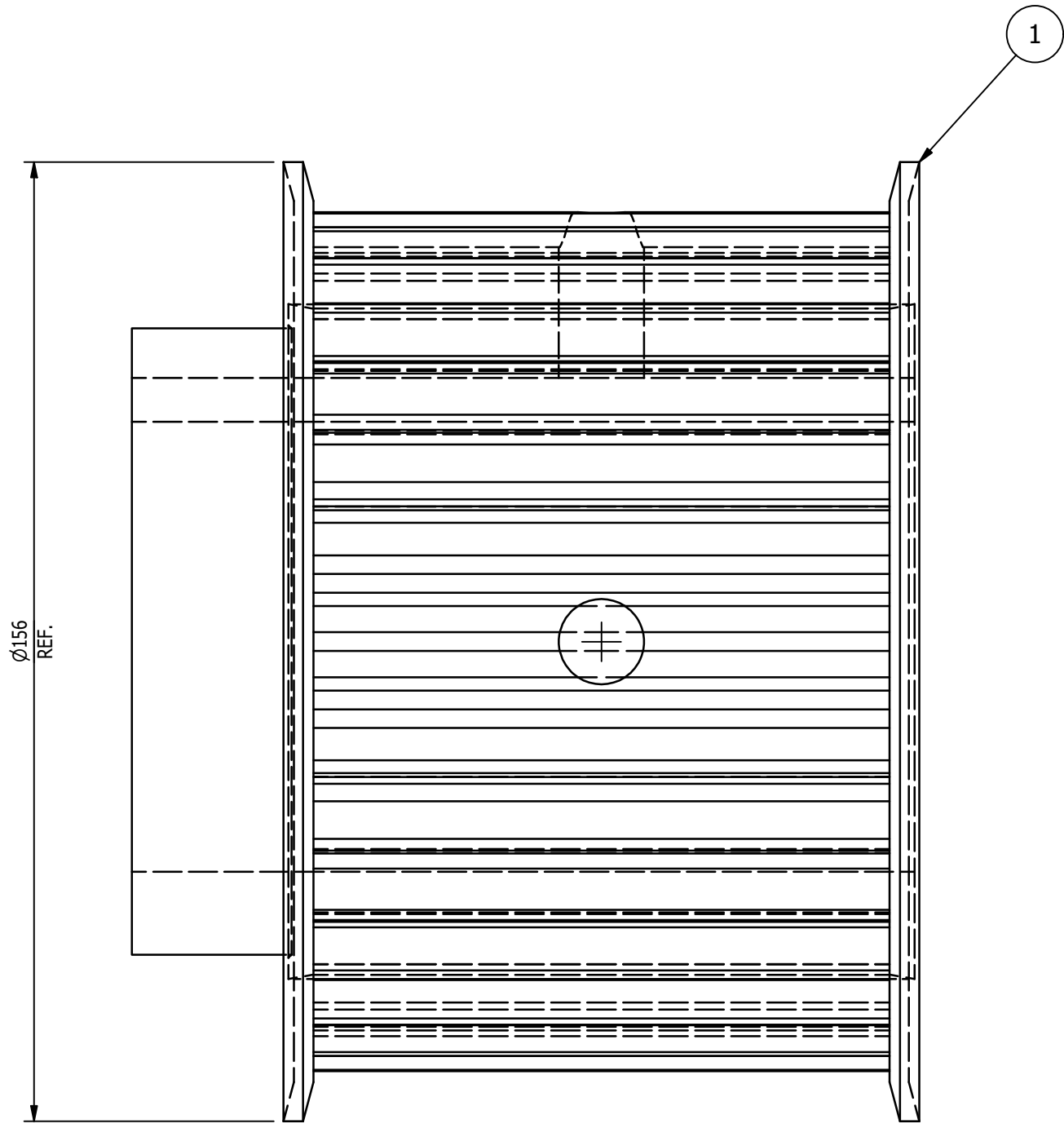
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D228A			
		SPROCKET, GATES POWERGRIP		5-2	
		PART_NO P32-14MGT-85			
		TOTAL WEIGHT ~ 18.4 lbs			



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



MK-D228A ~ GATES 32 TOOTH SPROCKET
SCALE 1'-0" = 1'-0"



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

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
		FENTON, MI 48430		DRAWING IS THE SOLE PROPERTY	
		PH: 810.373.0322 FAX: 810.373.0326		OF MILLER INDUSTRIES. ANY	
		www.millic.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORA		DRAWN BY: RPM		CHECKED BY: XXX	
CLIENT: VOLVO		DWG DATE: 6/17/22		JOB No: 22096	
DRAWING No. 1875D228		REV: A			

MAGNUM Consulting
41100 Dardickwood Rd.
Suite 125
North, MI 48135
Phone: (248) 772-8882
Fax: (248) 772-8851
Web: www.mmagnum.com

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

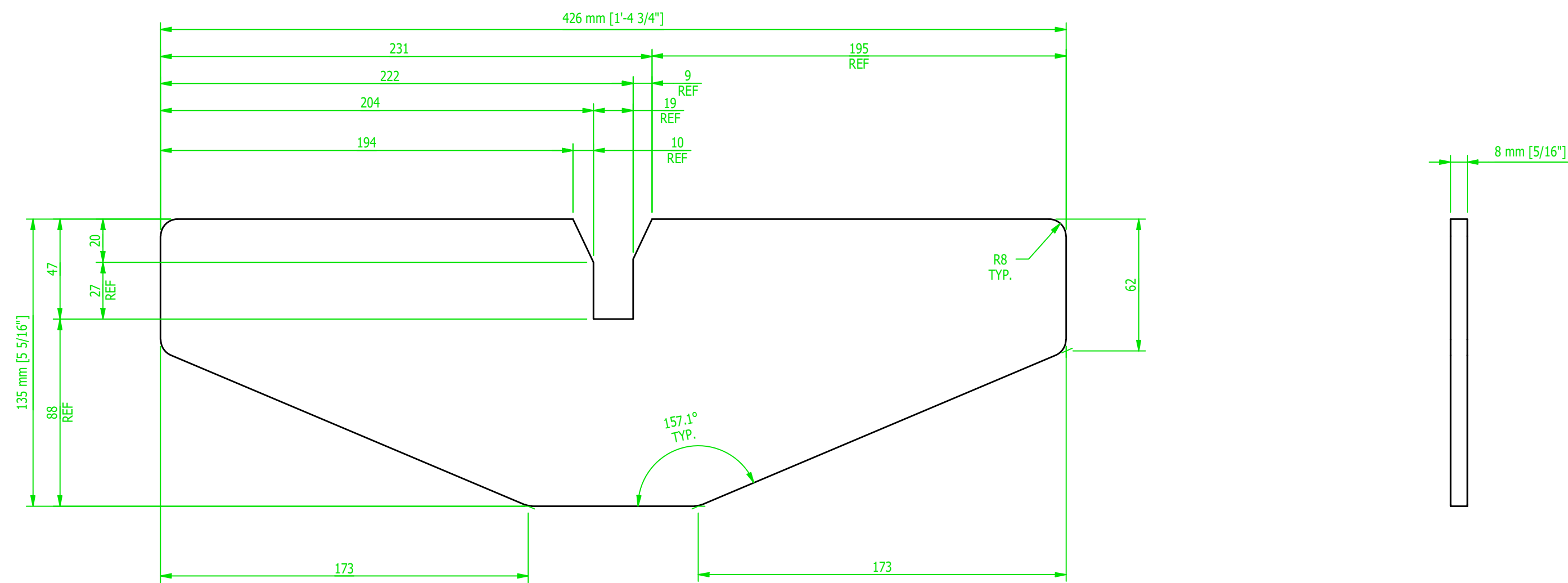
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
	1	MK-D229A			
1	1	PL 3/16 x 5 5/16"	1'-4 3/4"		



MK-D229A ~ ROLLER RETAINING PLATE
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:**
1. PAINT (ONE) SHOP COAT PRIMER.
 2. PAINT (2) FINISH COATS

REV	BY	DATE	DESCRIPTION	APP
A	MC	7-06-2022	FOR FABRICATION	

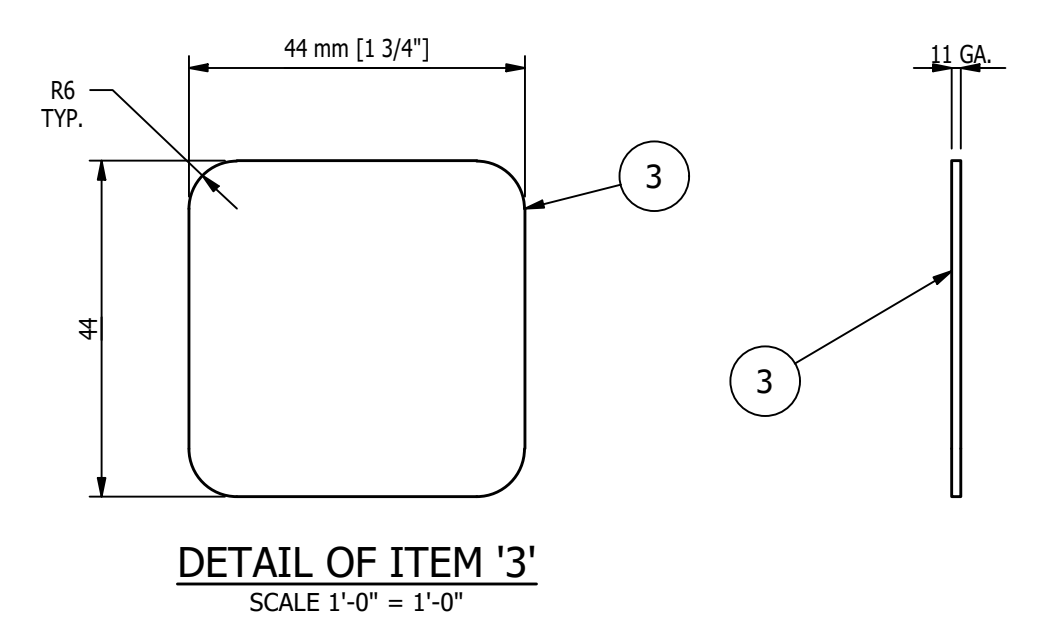
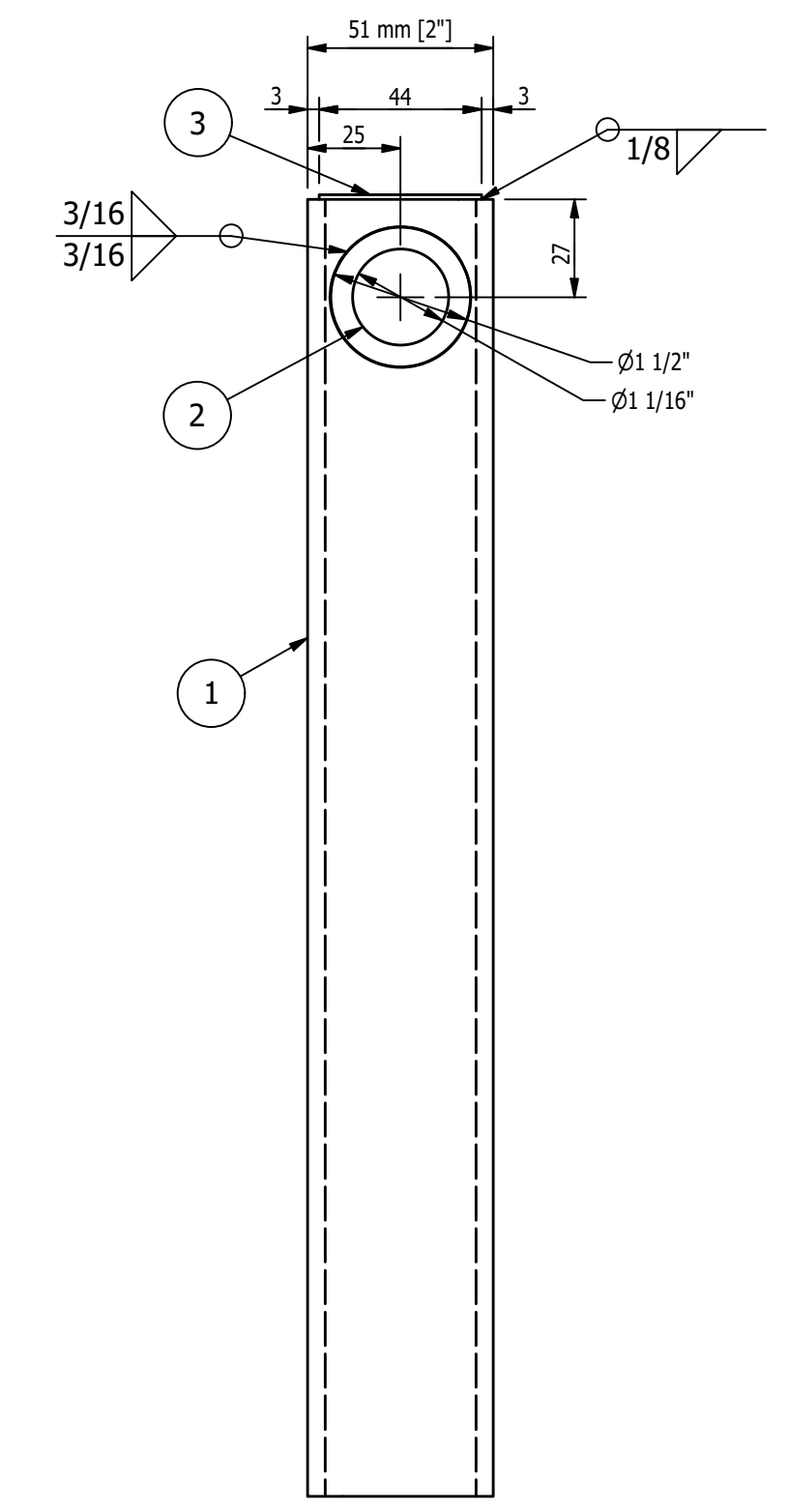
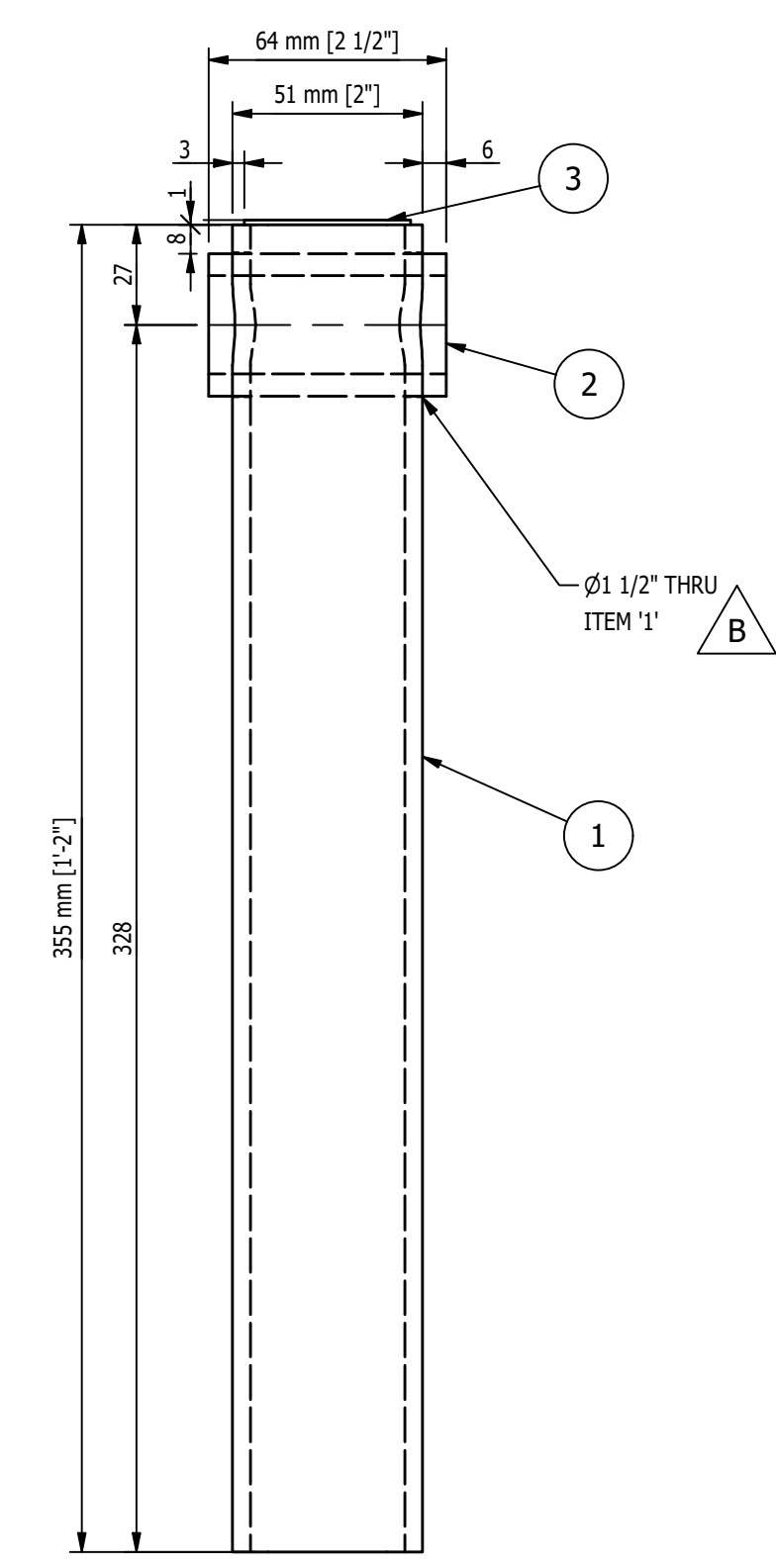
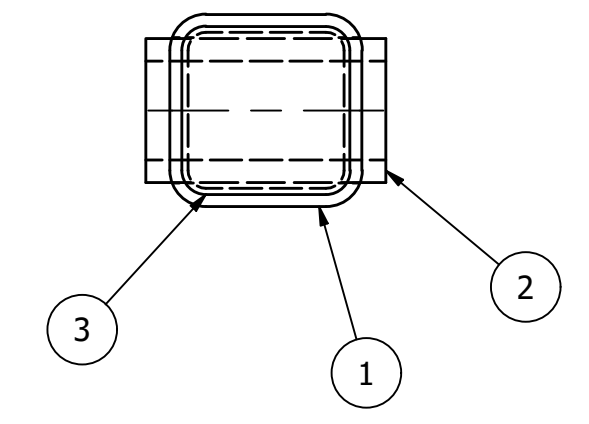
REVISION HISTORY

<p>41100 QuakerRoad Rd. Suite 125 North, MI 48315</p> <p>Phone: (248) 373-8833 Fax: (248) 373-8851 Web: www.mmagnum.com</p>	<p>GENERAL NOTES:</p> <p>MATERIALS:</p> <ul style="list-style-type: none"> - 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. <p>HOLES:</p> <ul style="list-style-type: none"> - 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. <p>WELDS:</p> <ul style="list-style-type: none"> - ALL WELDS TO BE "E70XX", (PER AWS D1.1) <p>PAINT:</p> <ul style="list-style-type: none"> - PAINT PER CUSTOMER SPECIFICATIONS U.N.O. <p>COPIES:</p> <ul style="list-style-type: none"> - ALL REINFRANT CUTS TO BE A MIN 1/2" RADIUS U.N.O. 	<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com</p>	<p>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</p>
<p>UNLESS OTHERWISE NOTED:</p> <p>X = ±.060 XX = ±.030 XXX = ±.005</p> <p>FRACTIONS = ±1/16" ANGLES = ±1°30'</p> <p>BREAK ALL SHARP EDGES DEBURR ALL HOLES DO NOT SCALE DRAWING</p>		<p>REV: A</p> <p>JOB No: 22096</p>	

MAGNUM CONSULTING

MAGNUM JOB #:
MAGNUM DRAWING #:

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D230A			
1	1	TS 2 x 2 x 1/4	1'-2"		
2	1	TS 1 1/2 OD x 15/64 DOM	2 1/2"		
3	1	SHT 11 GA x 1 3/4	1 3/4"		
TOTAL WEIGHT ~ 5.5 lbs					



D230A ~ SAFETY PIN WELDMENT
SCALE 6"=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 AFTER WELDING TO BASE

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/11/2022	HOLE NOTE REVISED	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

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

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D230	DWG DATE:	6/20/22
REV:	B	JOB No:	22096

MAGNUM CONSULTING

41100 QuakerRoad Rd.
Suite 125
North, MI 48175

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D230

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:

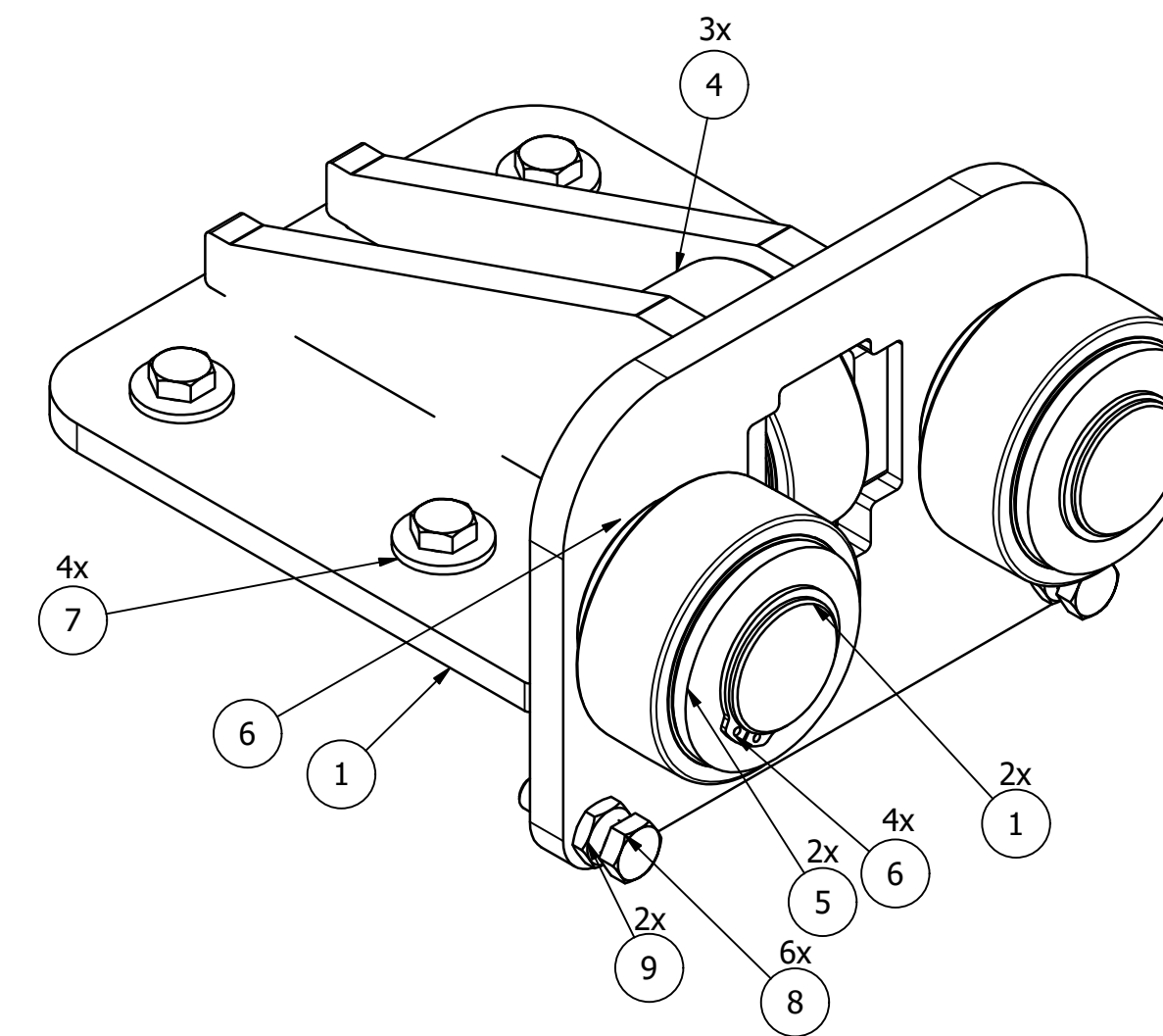
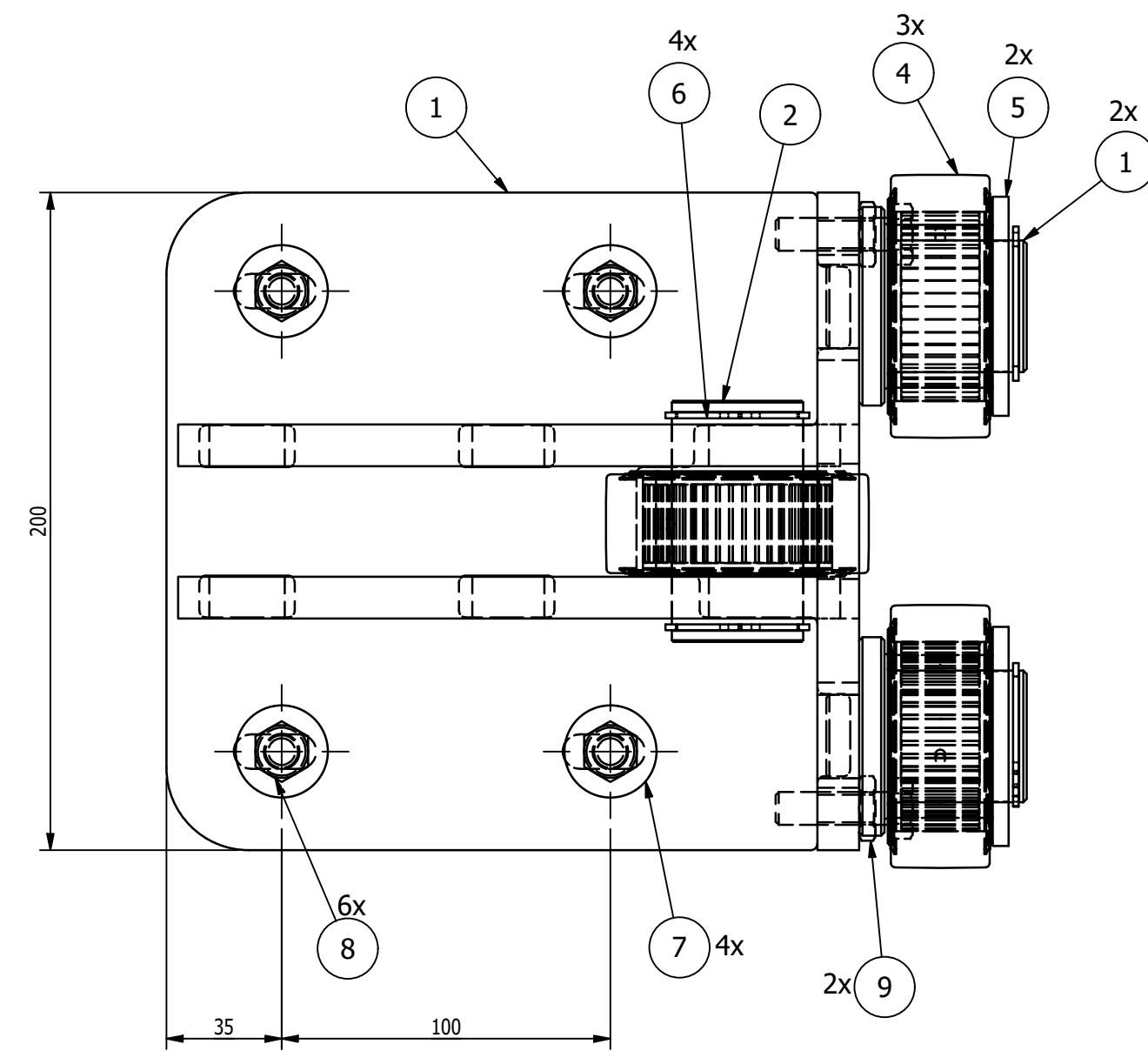
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

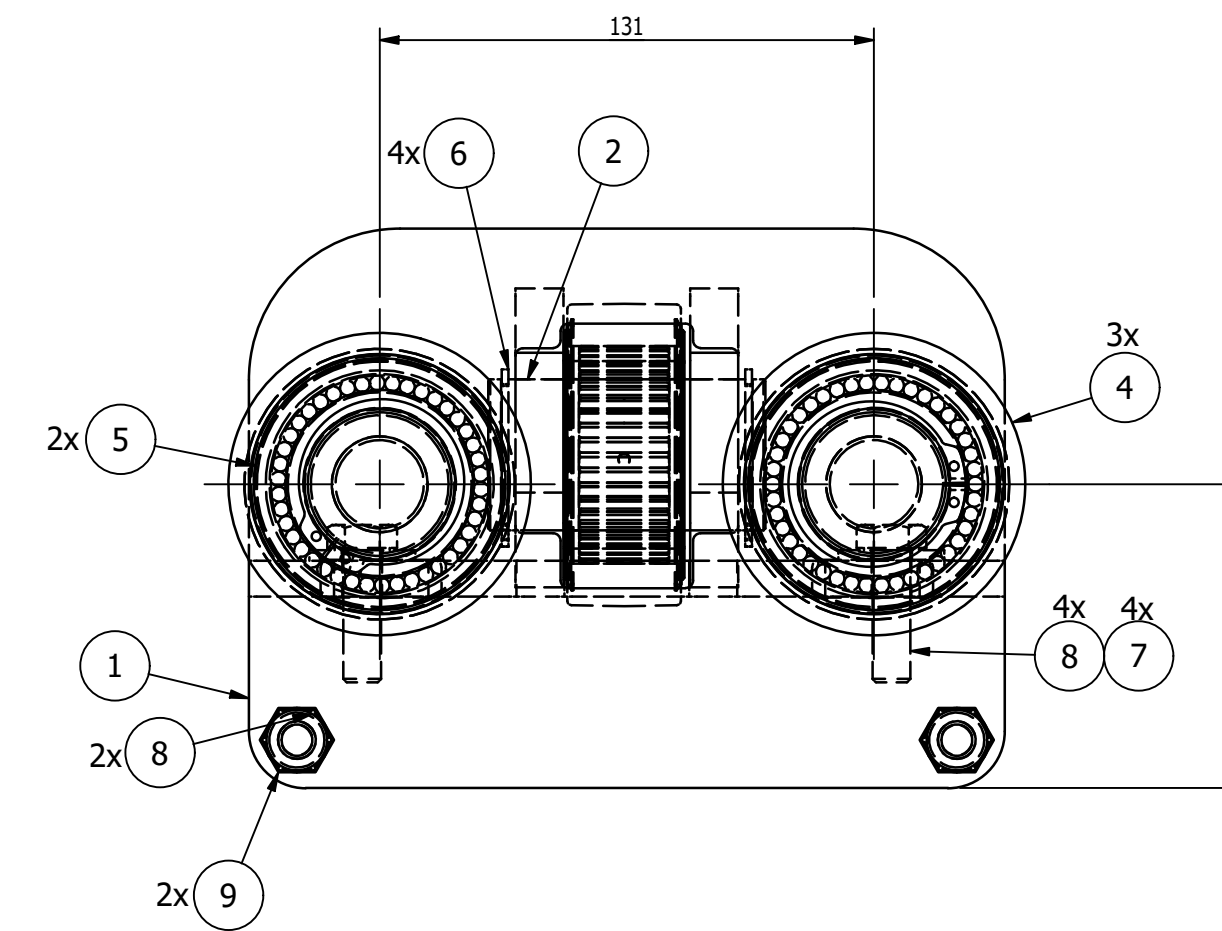
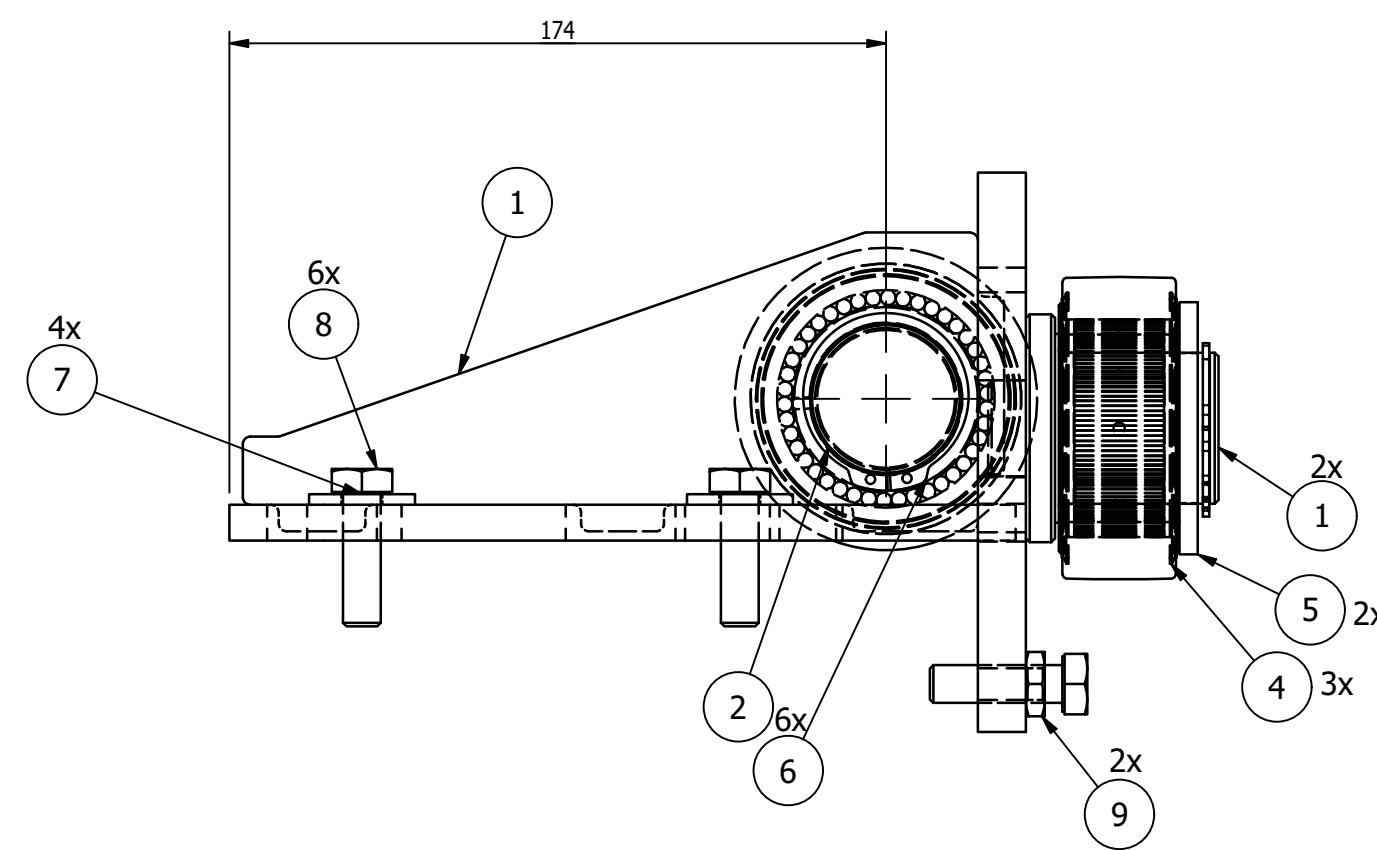
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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-D231A			
1	1	MK-D232A ~ GUIDE ROLLER WELDMENT AND MACHINING			
2	1	MK-D233A ~ LIFTER BRACKET 40mm SHAFT			
4	3	INA TRACK ROLLER NUTR40		5-7	
5	2	MK-D233B ~ GUIDE ROLLER SPACER			
6	4	EXTERNAL RETAINING RING PART McMASTER-CARR 98541A167		5-8	
7	4	M10 REGULAR FLAT WASHER			
8	6	M10x1.5 x 35mm LG. HEX CAP SCREW			
9	2	M10 x 1.5 HEX JAM NUT			
		TOTAL WEIGHT ~ 20.9 lbs			



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

- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004

MK-D231A ~ GUIDE ROLLER ASSEMBLY
SCALE 6"=1'-0"

A	MC	7/5/2022	FOR FABRICATION	
REV	BY	DATE	DESCRIPTION	APP

REVISION HISTORY

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

CLIENT: VOLVO	DWG DATE:
DRAWING No. 1875D231	REV: A
JOB No: 22096	

4110 QuakerRoad Rd.
 Suite 125
 West, MI 48375

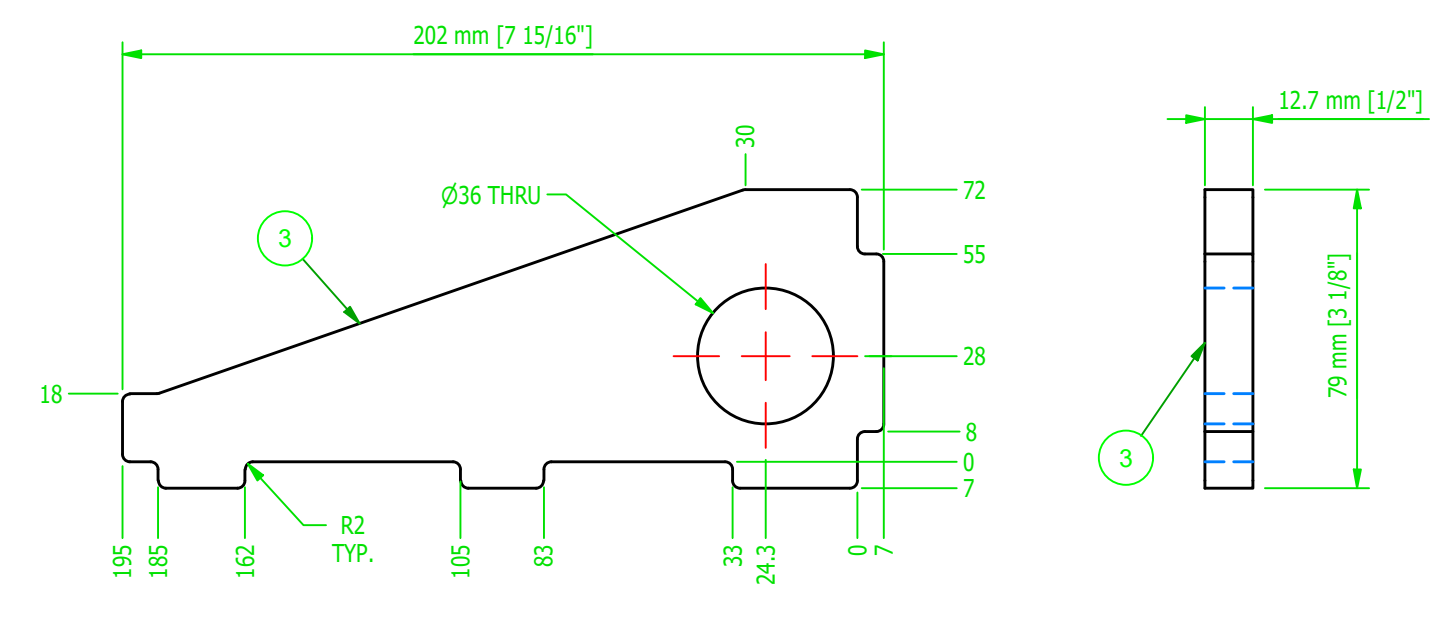
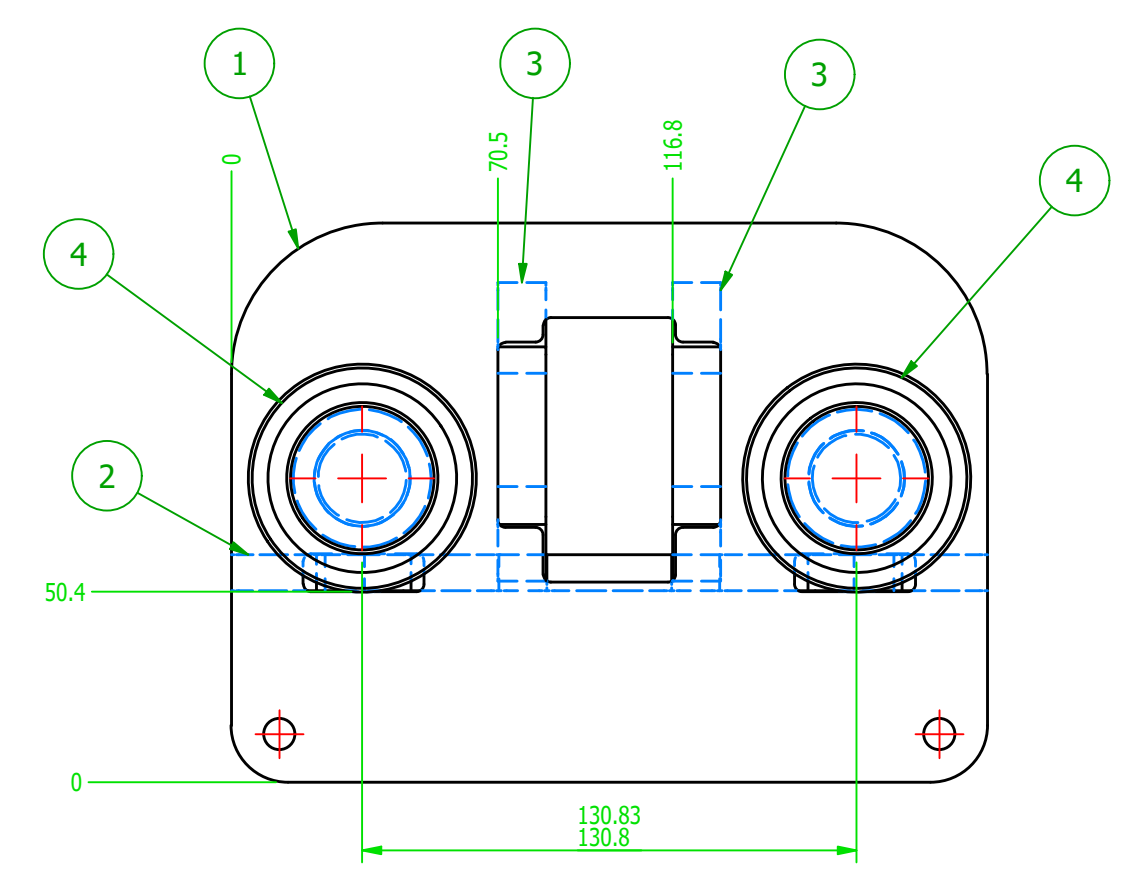
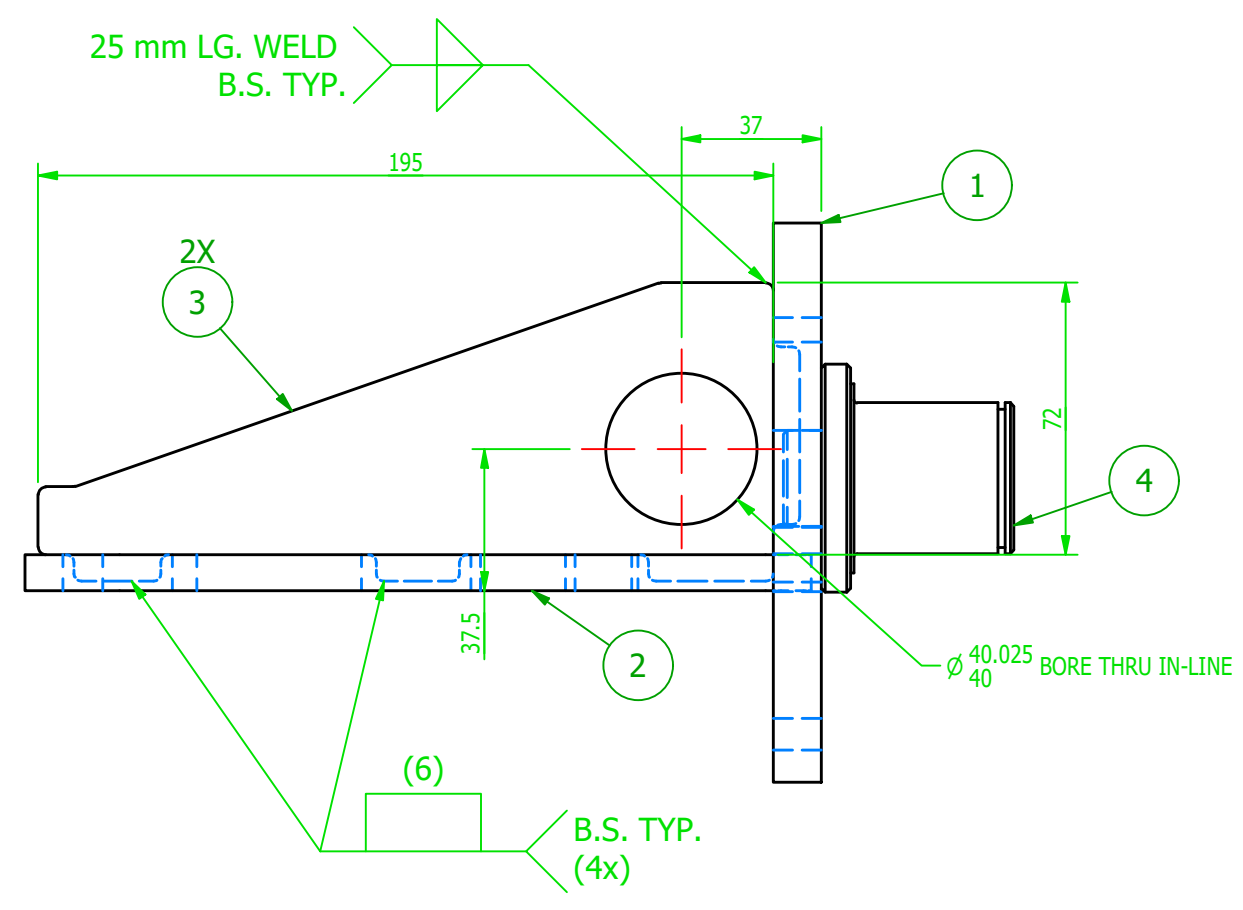
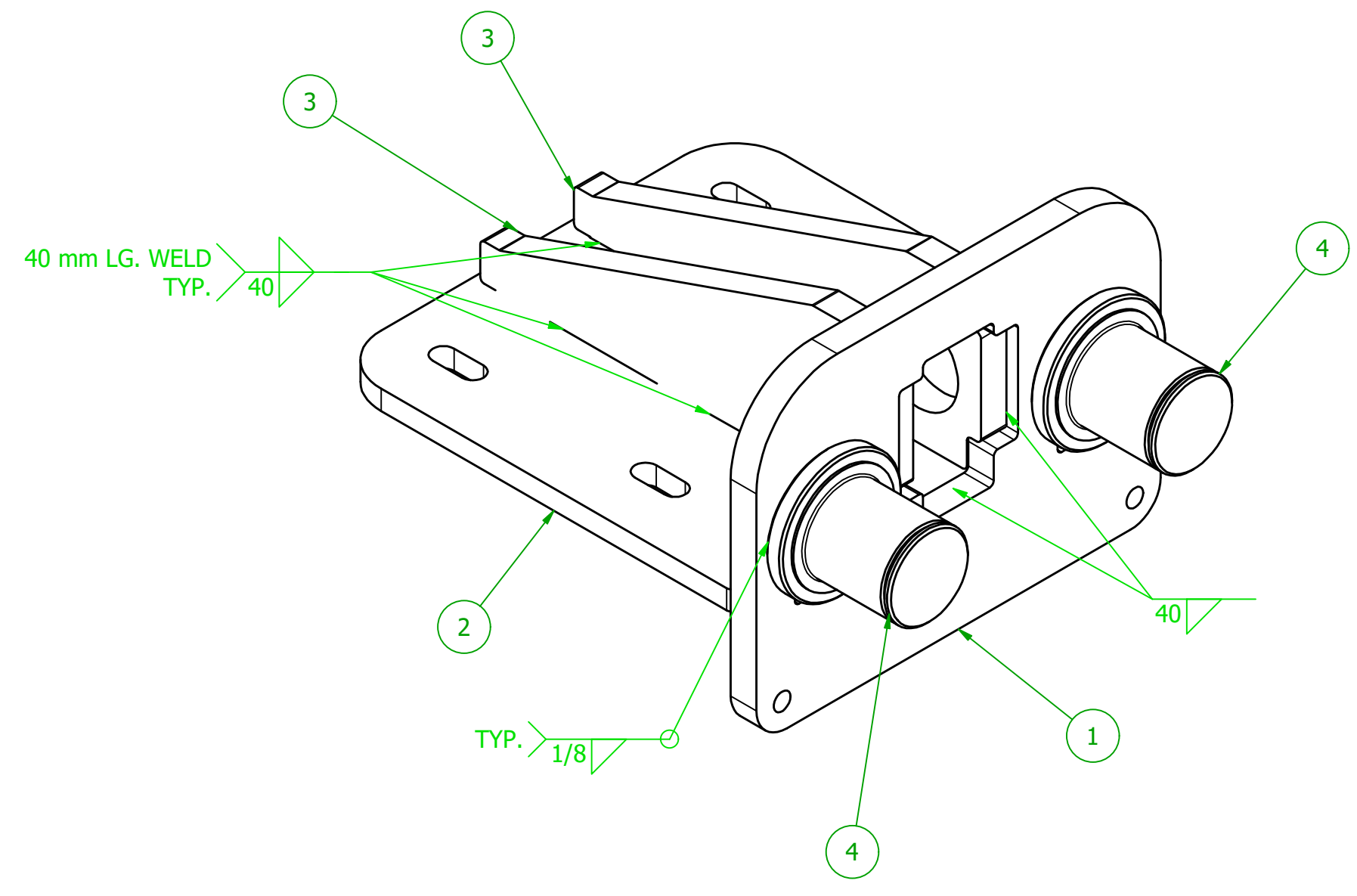
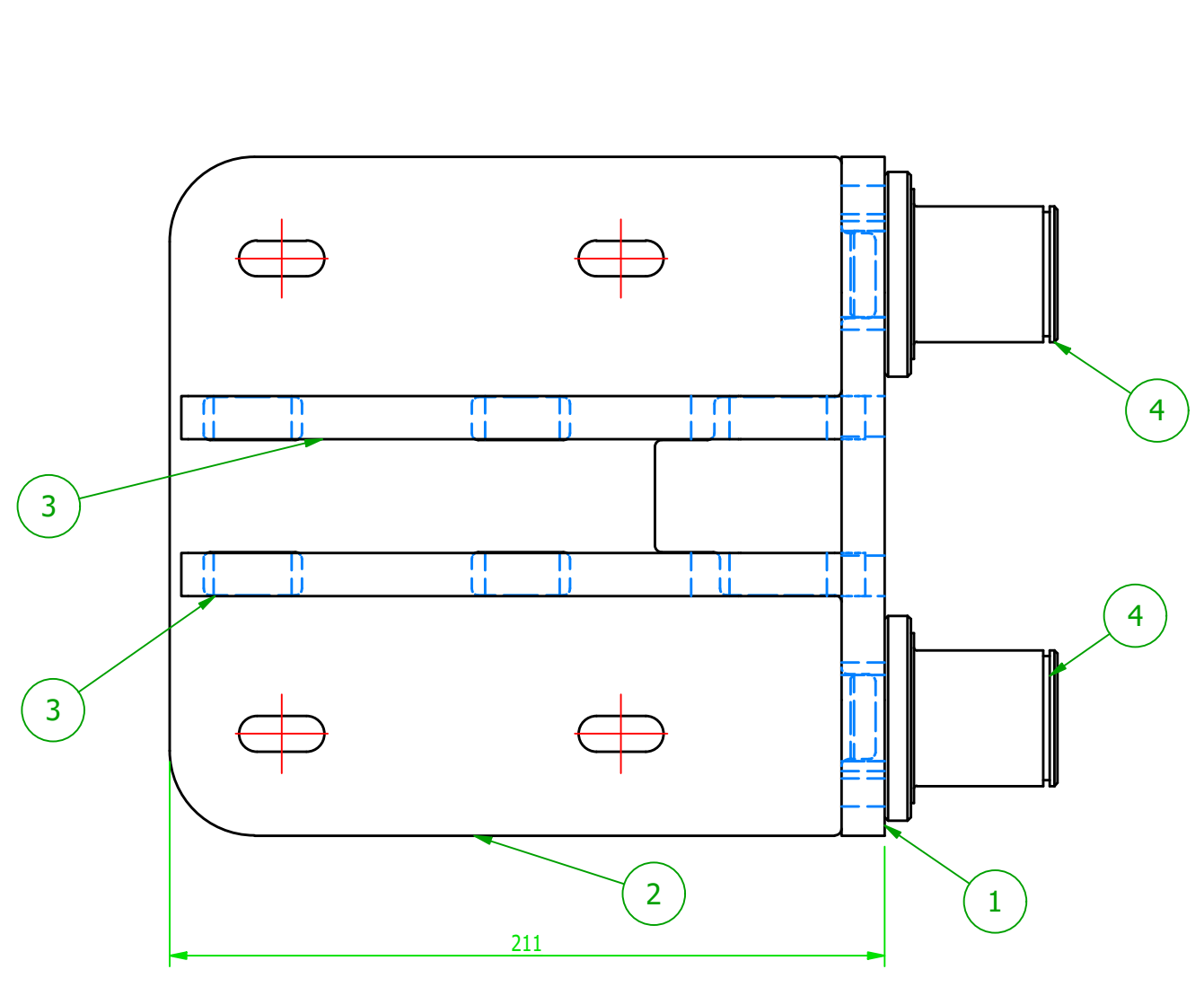
Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D231

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 ANGLES = ±1°30'
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 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

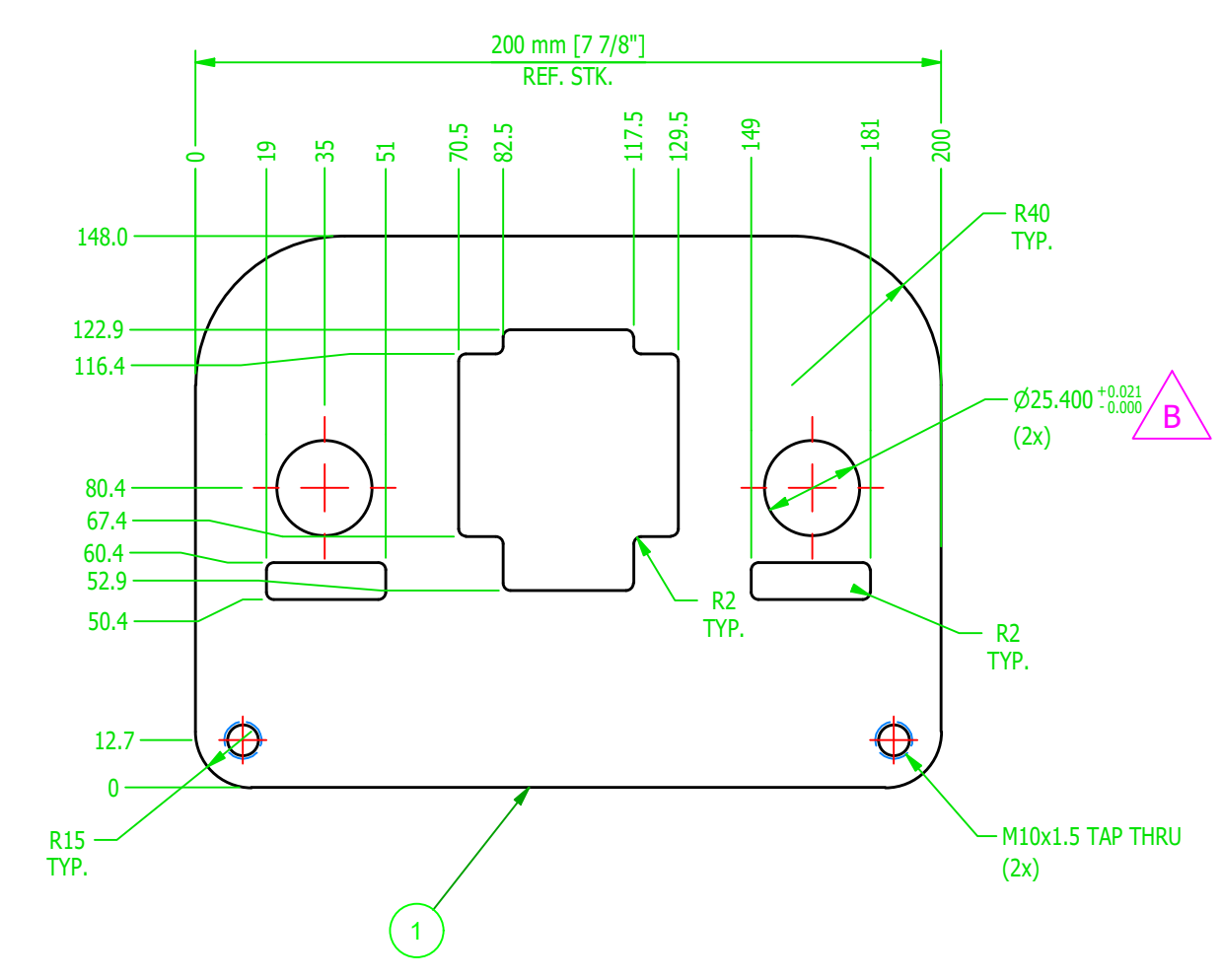
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO 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-D232A			
1	1	PL 1/2 x 5 13/16"	7 7/8"		
2	1	PL 3/8 x 7 7/8"	8 3/16"		
3	2	PL 1/2 x 3 1/8"	7 15/16"		
4	2	MK-D233C ~ GUIDE ROLLER STUD			
TOTAL WEIGHT ~ 17.6 lbs					

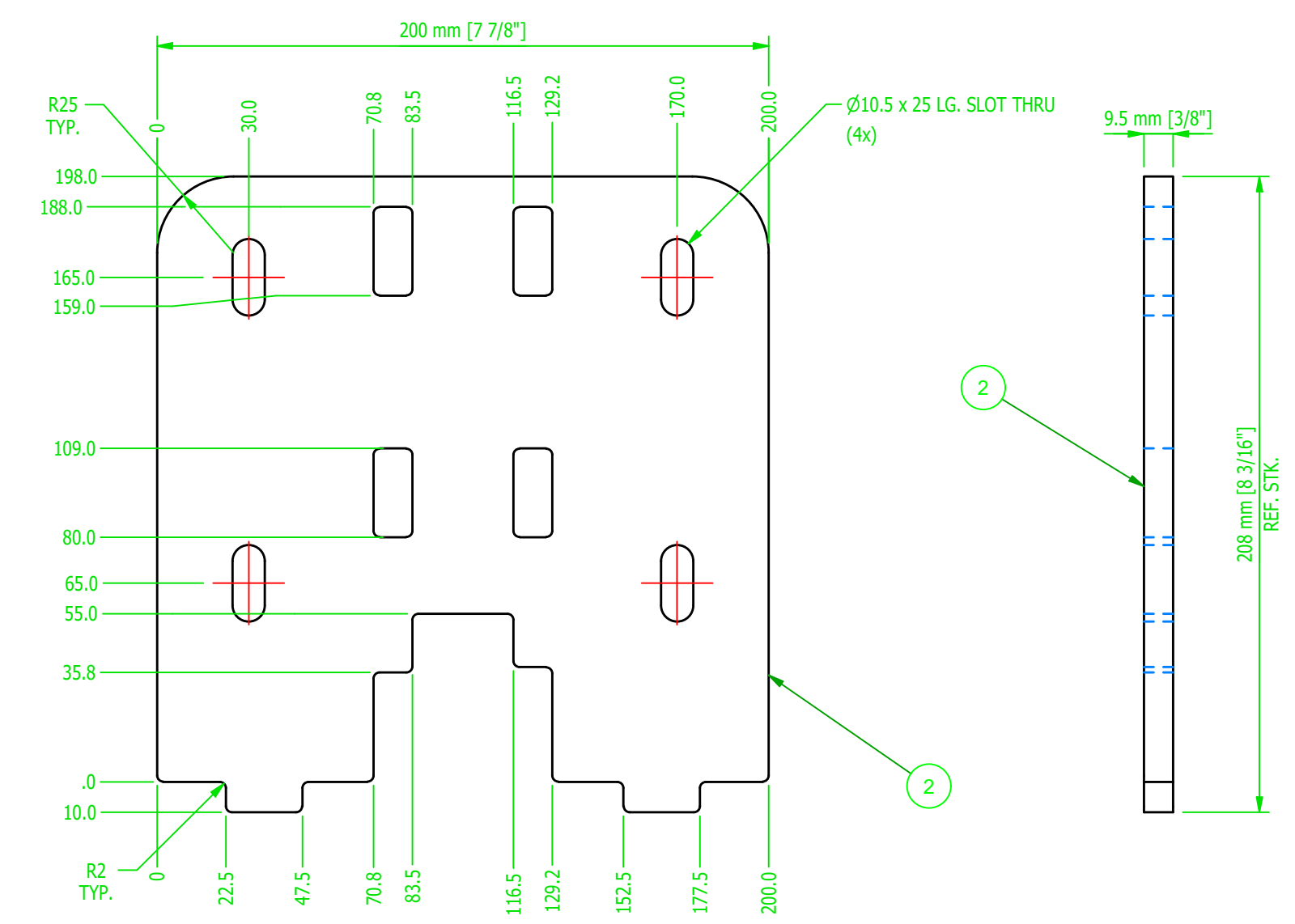


DETAIL OF ITEM '3'
SCALE 6"=1'-0"

MK-D232A ~ GUIDE ROLLER WELDMENT AND MACHINING
SCALE 6"=1'-0"



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



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

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

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

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	3070 W. THOMPSON RD.	FENTON, MI 48430	PH: 810.373.0322	FAX: 810.373.0326
CLIENT:	VOLVO				
DRAWING No.	1875D232	REV:	B	JOB No:	22096
		DRAWN BY:	AH	CHECKED BY:	CW
		DWG DATE:	6/20/22		

MAGNUM Consulting
41100 Charleston Rd. Suite 125 West, MI 48375
Phone: (248) 772-8889 Fax: (248) 772-8851 Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D232

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DEBURR ALL HOLES
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- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
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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)

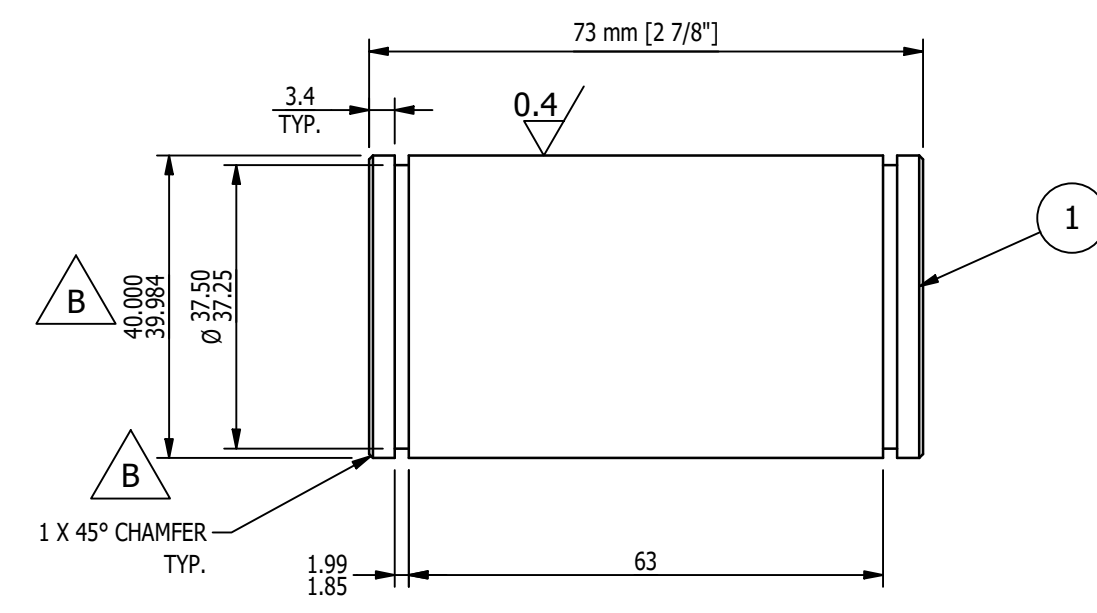
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

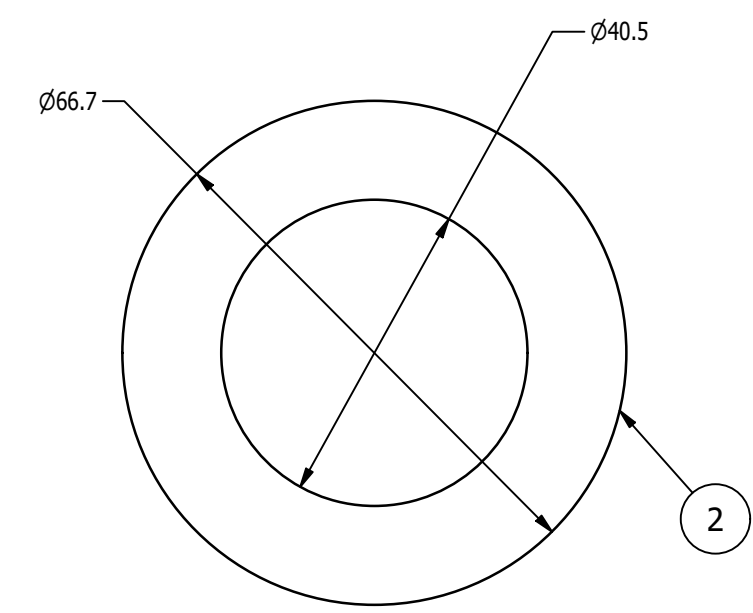
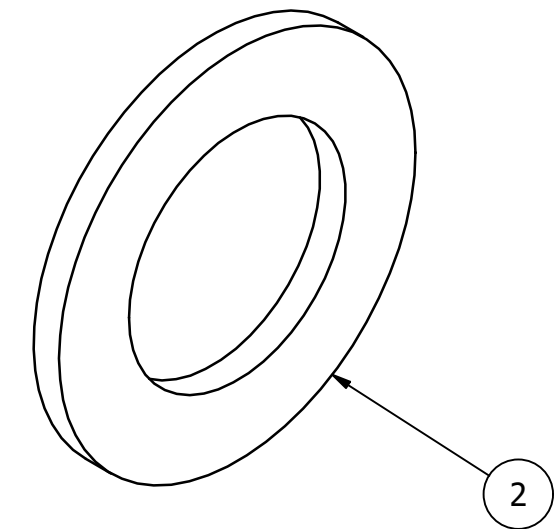
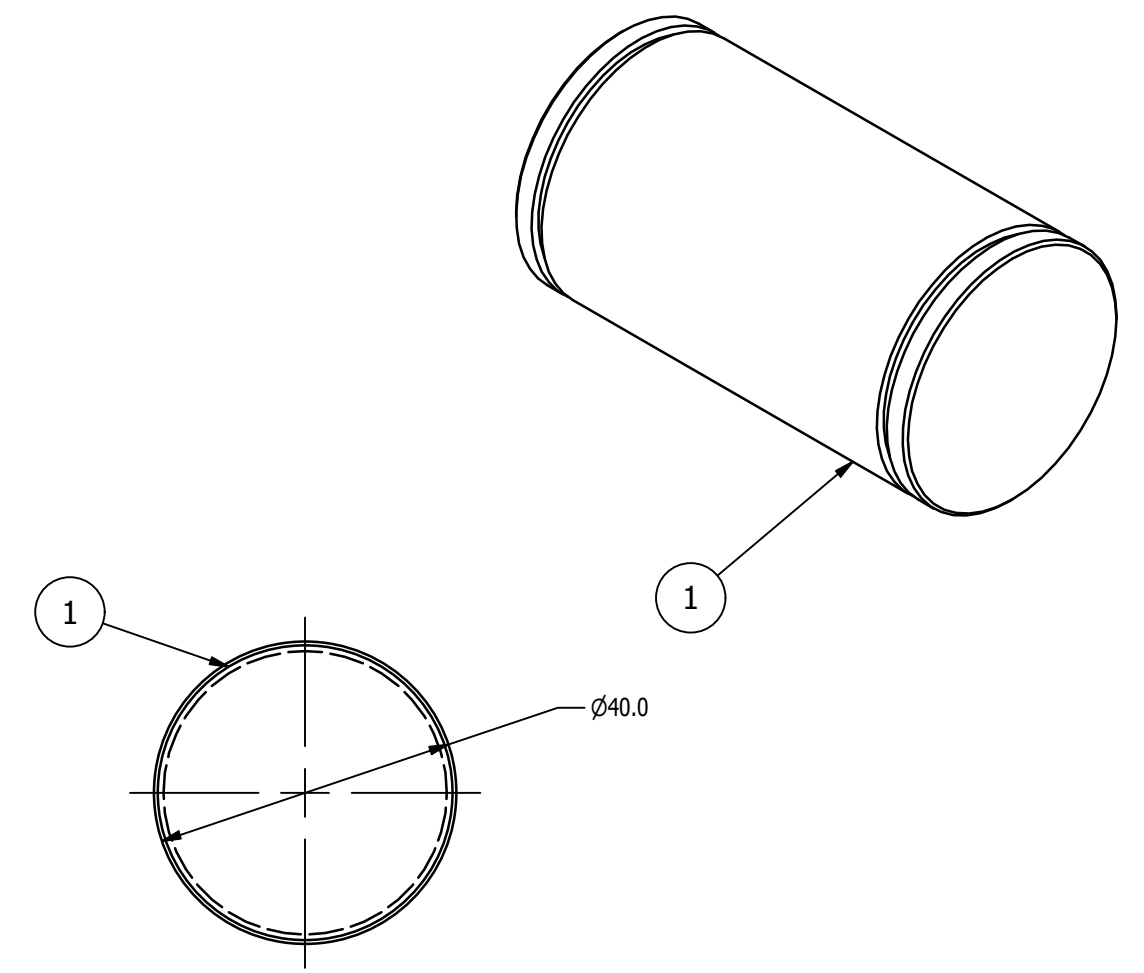
COPIES:

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

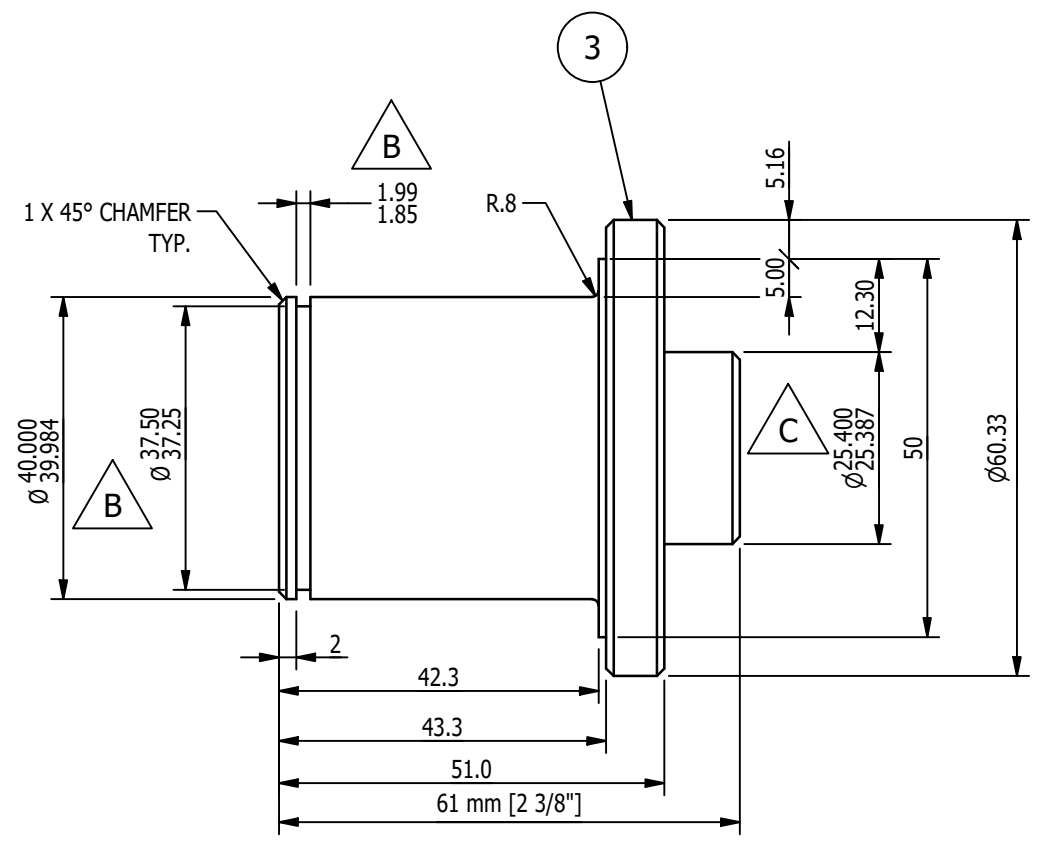
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D233A			
1	1	BAR Ø1 5/8 (1045)	2 7/8"		
		TOTAL WEIGHT ~ 1.6 lbs			
		MK-D233B			
2	1	PL 3/16 x 2 5/8"	2 5/8"		
		MK-D233C			
3	1	BAR Ø2 3/8	2 3/8"		
		TOTAL WEIGHT ~ 1.4 lbs			



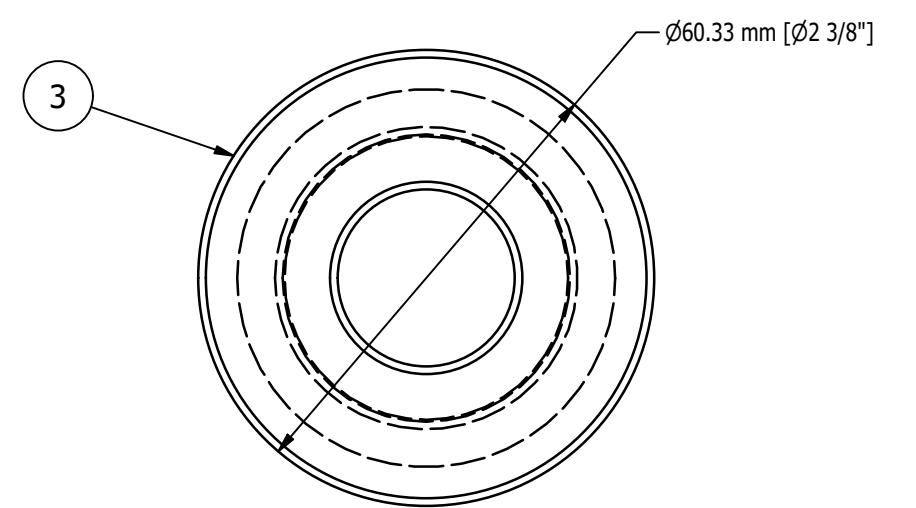
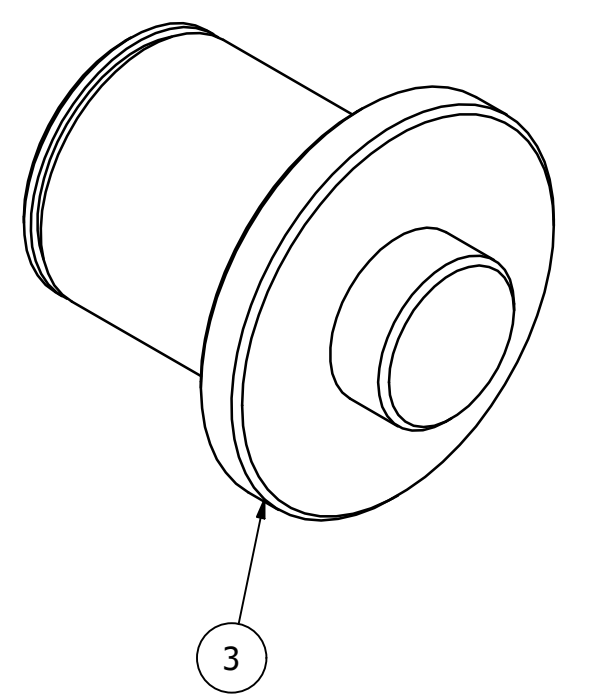
MK-D233A ~ LIFTER BRACKET 40mm SHAFT
SCALE 1'-0" = 1'-0"



MK-D233B ~ GUIDE ROLLER SPACER
SCALE 1'-0" = 1'-0"



MK-D233C ~ GUIDE ROLLER STUD
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:**
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
C	MC	7/27/2022	DIM TOL'S REVISED	
B	MC	7/15/2022	REVISED DIMENSIONS AND SHOP NOTE	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY			
C	MC	7/27/2022	DIM TOL'S REVISED
B	MC	7/15/2022	REVISED DIMENSIONS AND SHOP NOTE
A	MC	7/5/2022	FOR FABRICATION

MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D233 REV: C

MAGNUM Consulting
 41700 Dardickwood Rd.
 Suite 125
 Novi, MI 48235
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D233 - 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 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.

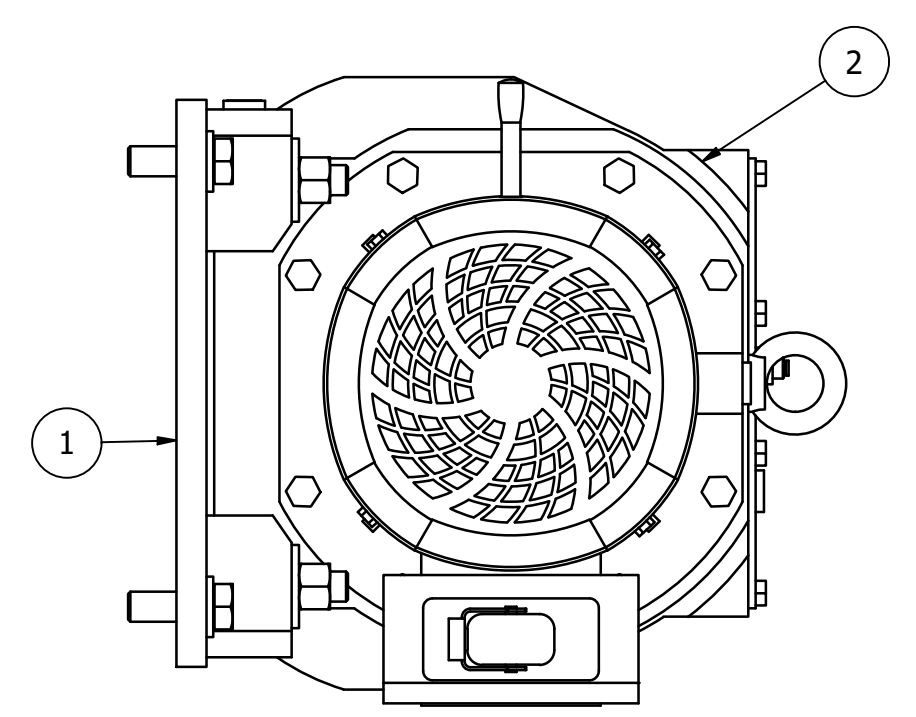
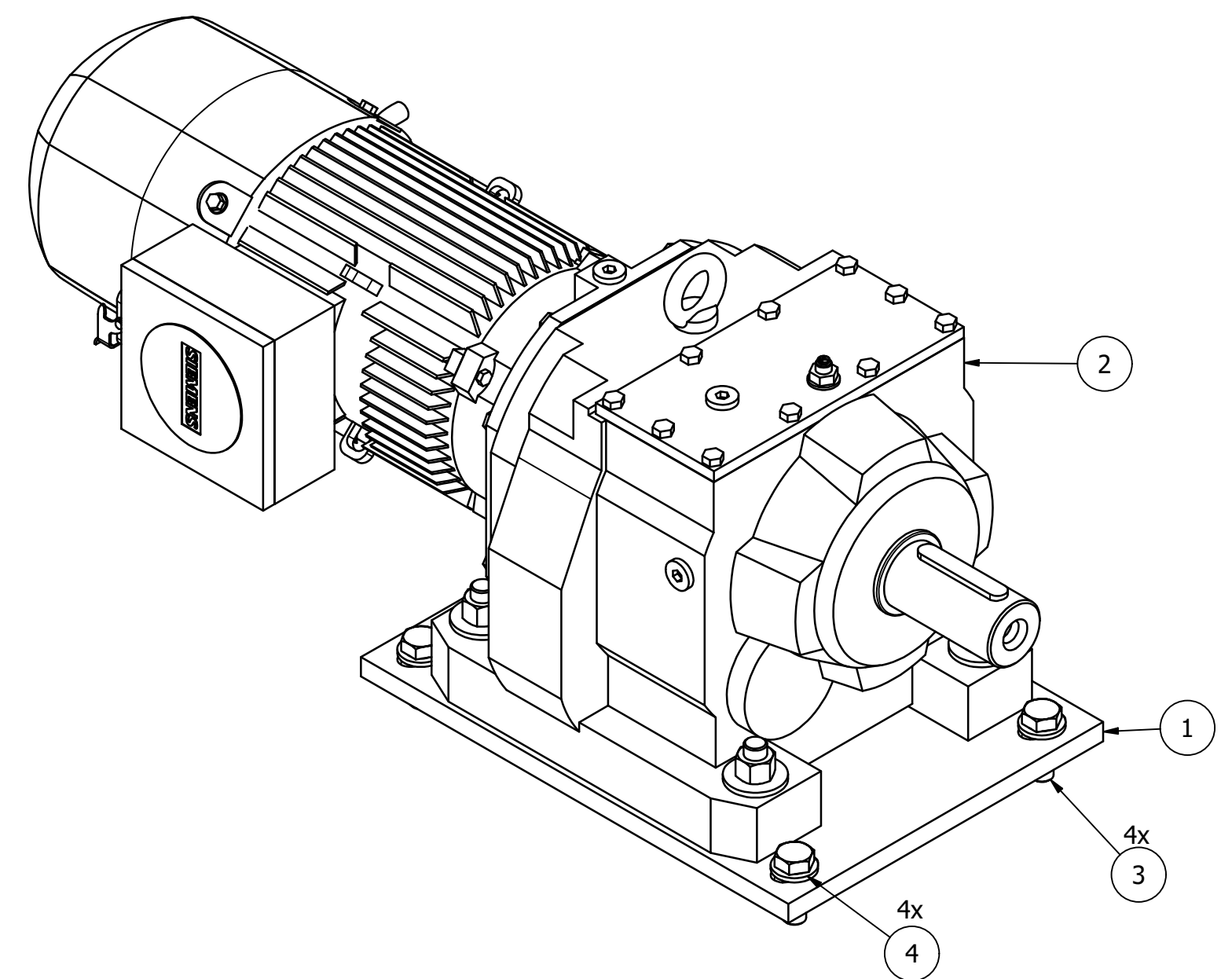
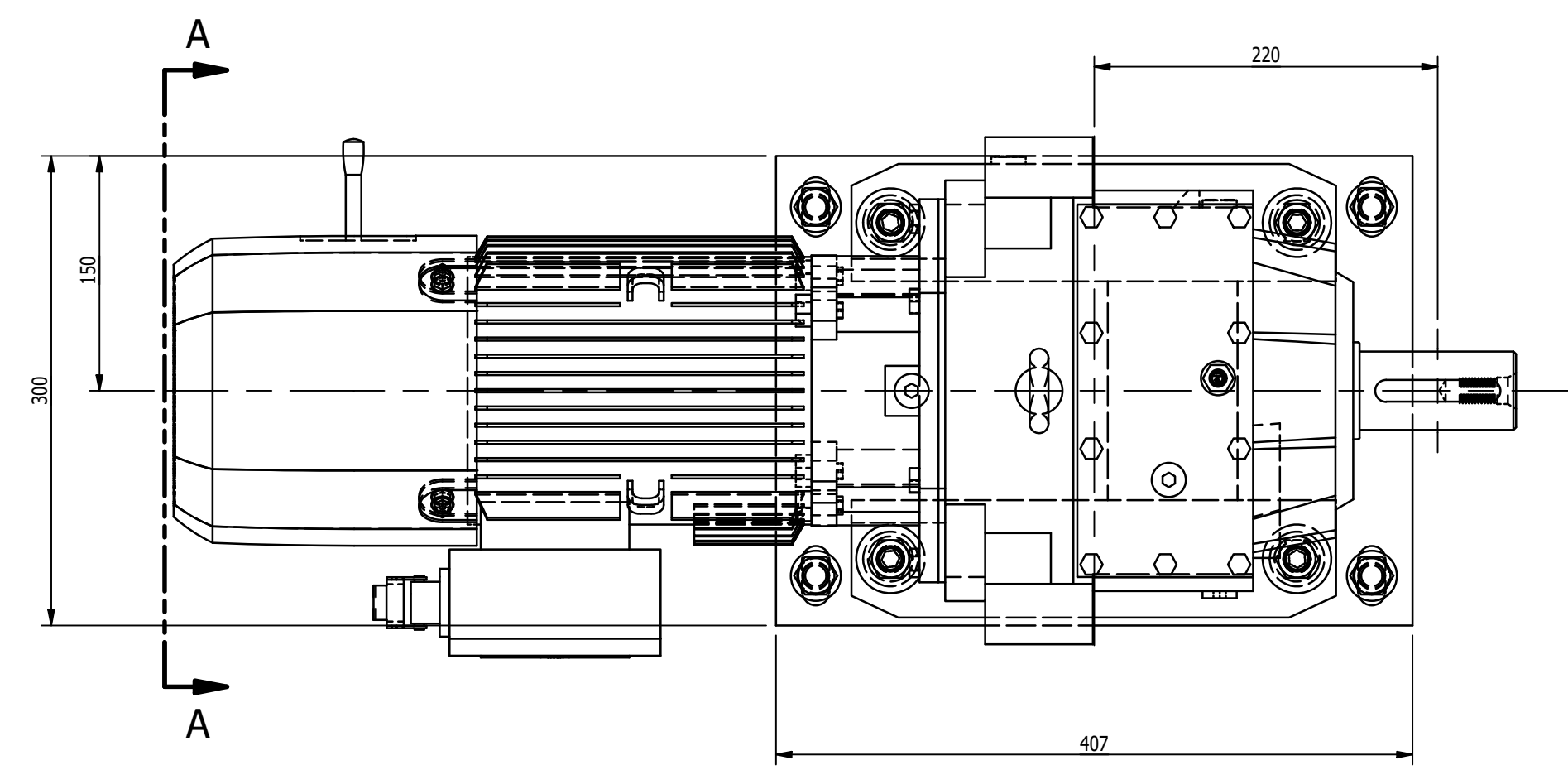
HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

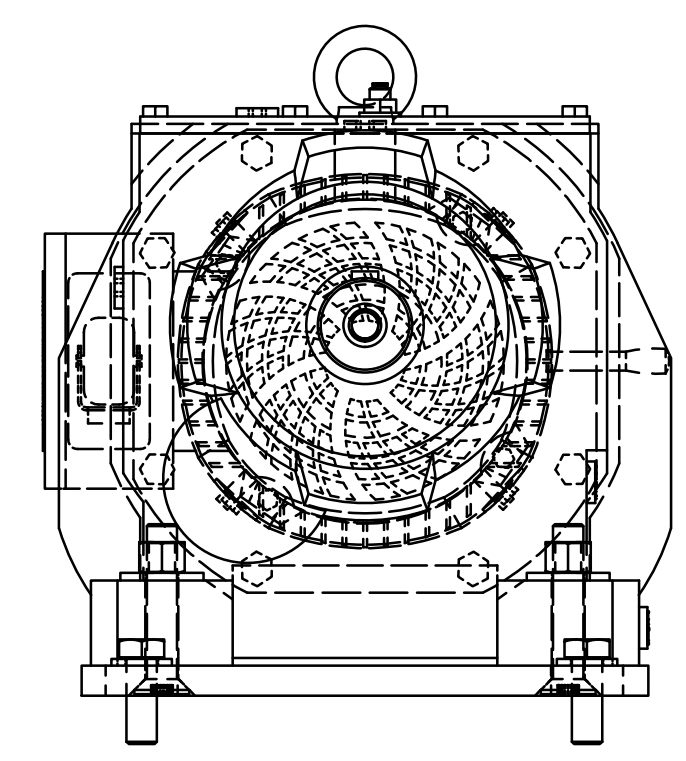
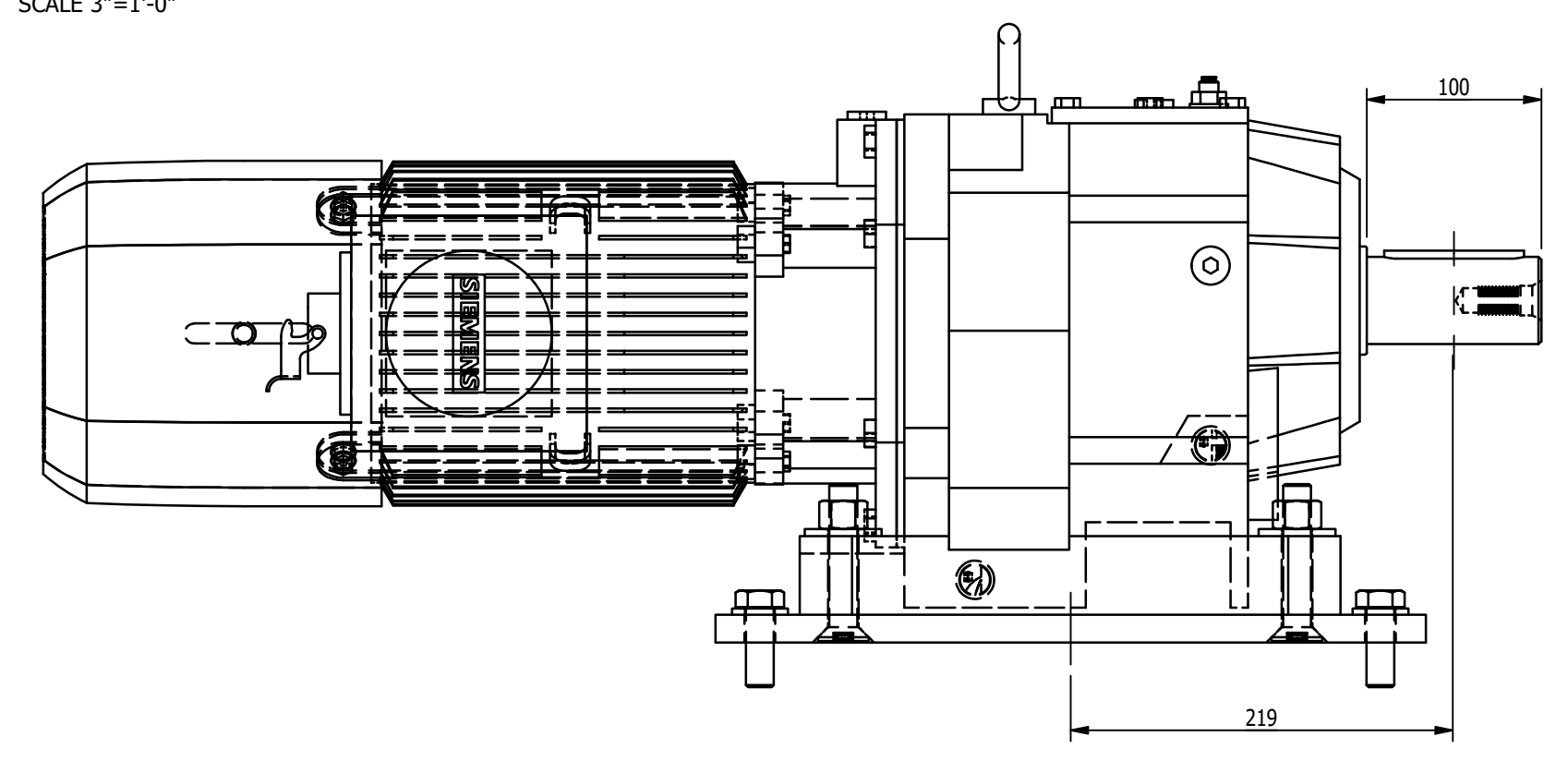
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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-D234A ~ 90mm LIFTER REDUCER MOTOR BASE ASSEMBLY			
2	1	SIEMENS LT1 GEARMOTOR (SEE MOTOR DATA LIST)		12-1	
3	4	M16x2 x 45mm LG. HEX CAP SCREW			
4	4	M16 NARROW FLAT WASHER			
TOTAL WEIGHT ~ 107.2 lbs					



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



MK-D234A ~ 90mm LIFTER REDUCER BASE ASSEMBLY
SCALE 3"=1'-0"

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

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/5/2022	FOR FABRICATION	

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

CLIENT: VOLVO DRAWING No. 1875D234 REV: A	JOB No: 22096
---	---------------

MAGNUM Consulting
 4110 Charleston Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D234

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:

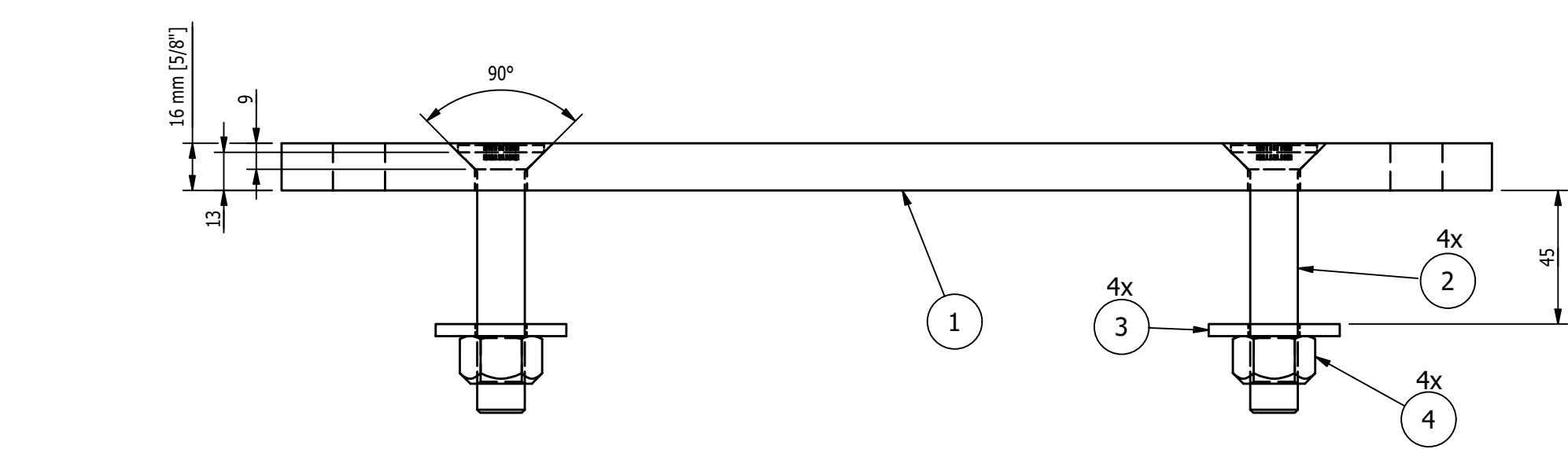
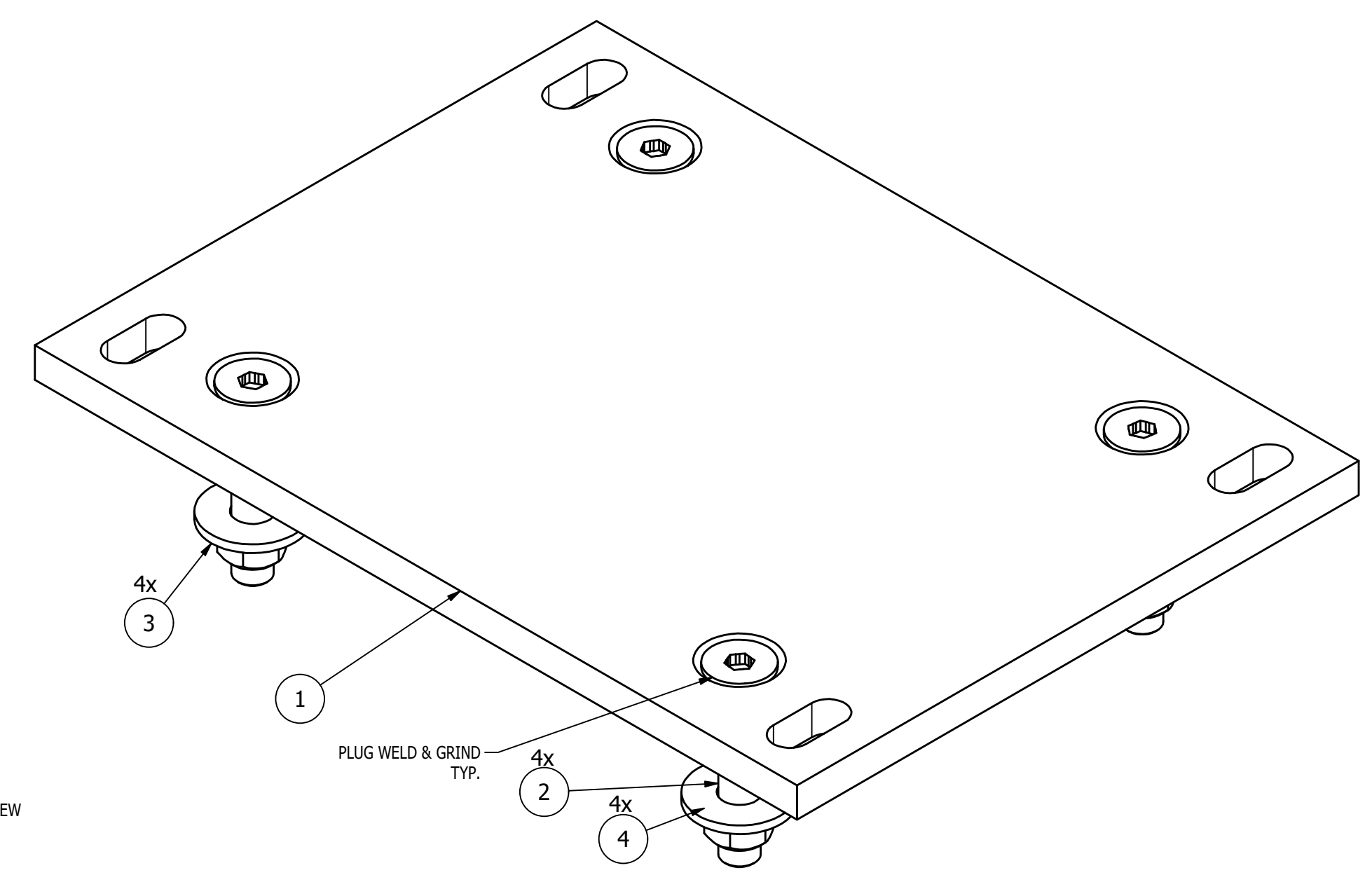
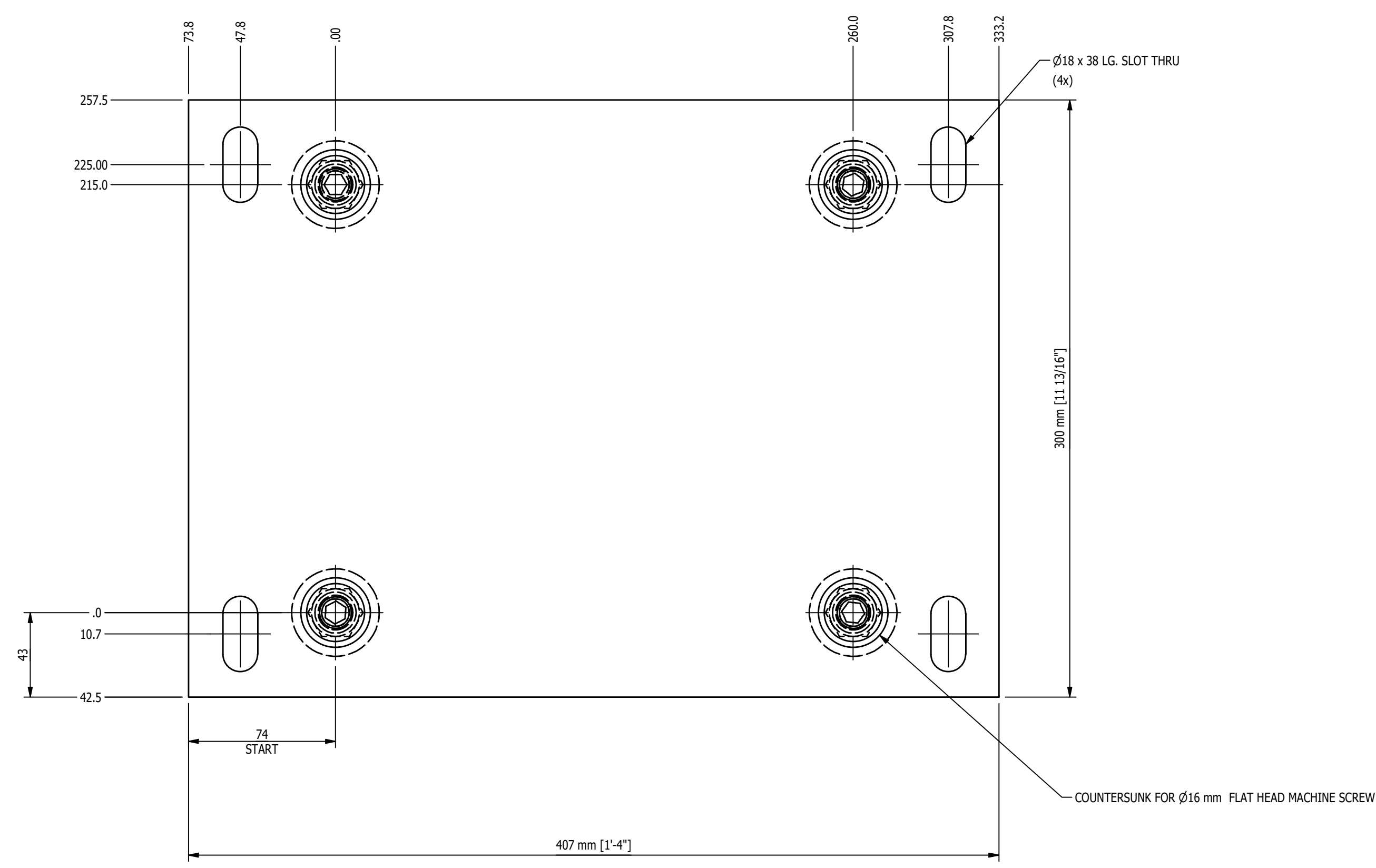
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D235A			
1	1	PL 5/8 x 11 13/16"	1'-4"		
2	4	M16x2 x 90mm LG. FLAT HEX SOCKET HEAD CAP SCREW			
3	4	M16 REGULAR FLAT WASHER			
4	4	M16 x 2 STOVER LOCK NUT			
		TOTAL WEIGHT ~ 34.6 lbs			

B



- 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

MK-D235A ~ 90mm LIFTER REDUCER MOTOR BASE ASSEMBLY
SCALE 6"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/11/2022	ITEM '4' WAS M16 x 2 HEX NUT	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY	
	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com
TITLE:	P6700 CONVEYORS CAMPUS BUILDING
CLIENT:	VOLVO
DRAWING No.	1875D235
REV:	B
DRAWN BY:	AH
CHECKED BY:	CW
DWG DATE:	6/20/22
JOB No:	22096

MAGNUM Consulting
41100 QuakerRoad Rd.
Suite 125
North, MI 48175
Phone: (248) 373-8833
Fax: (248) 373-8851
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.

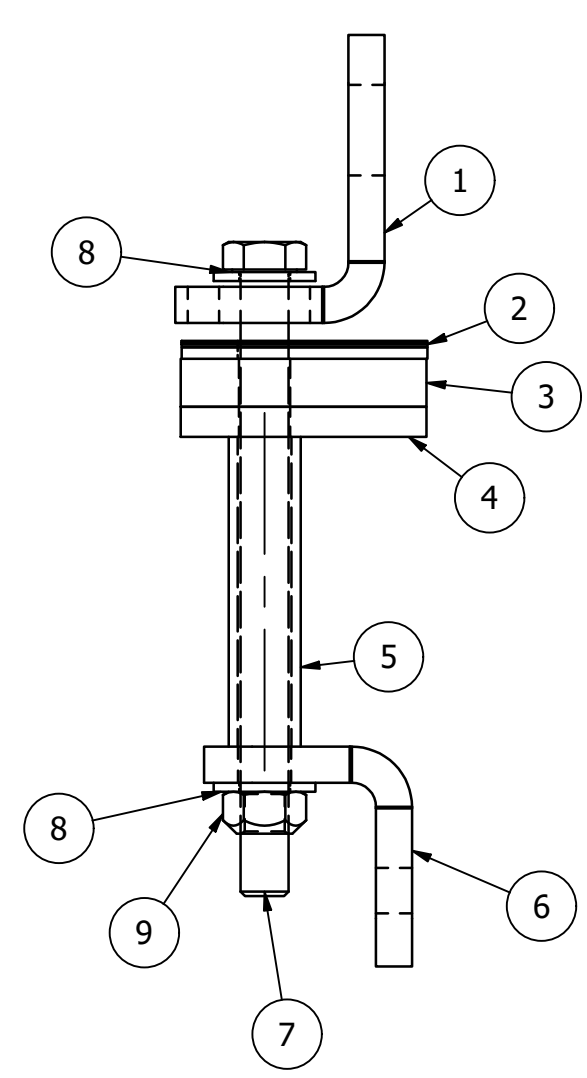
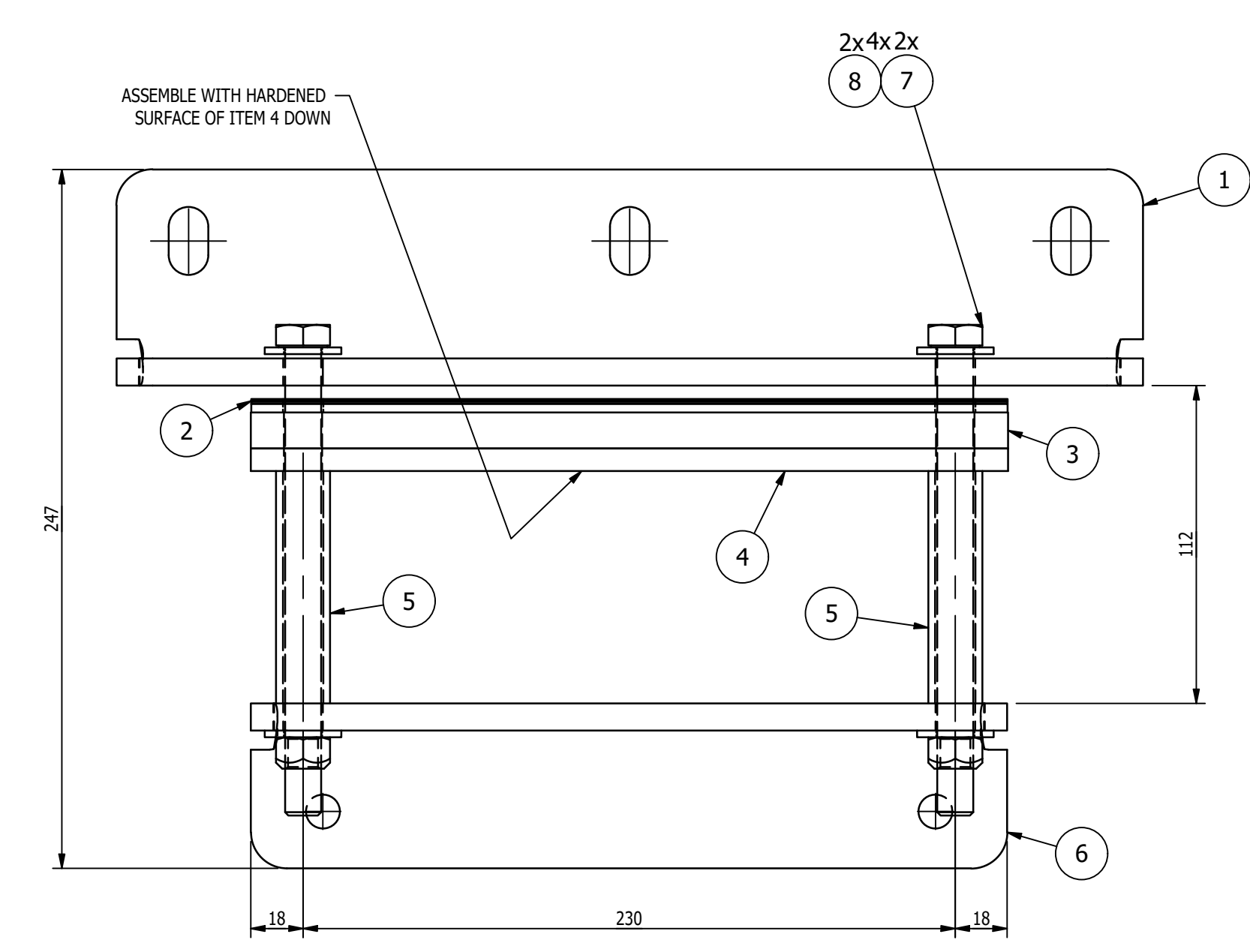
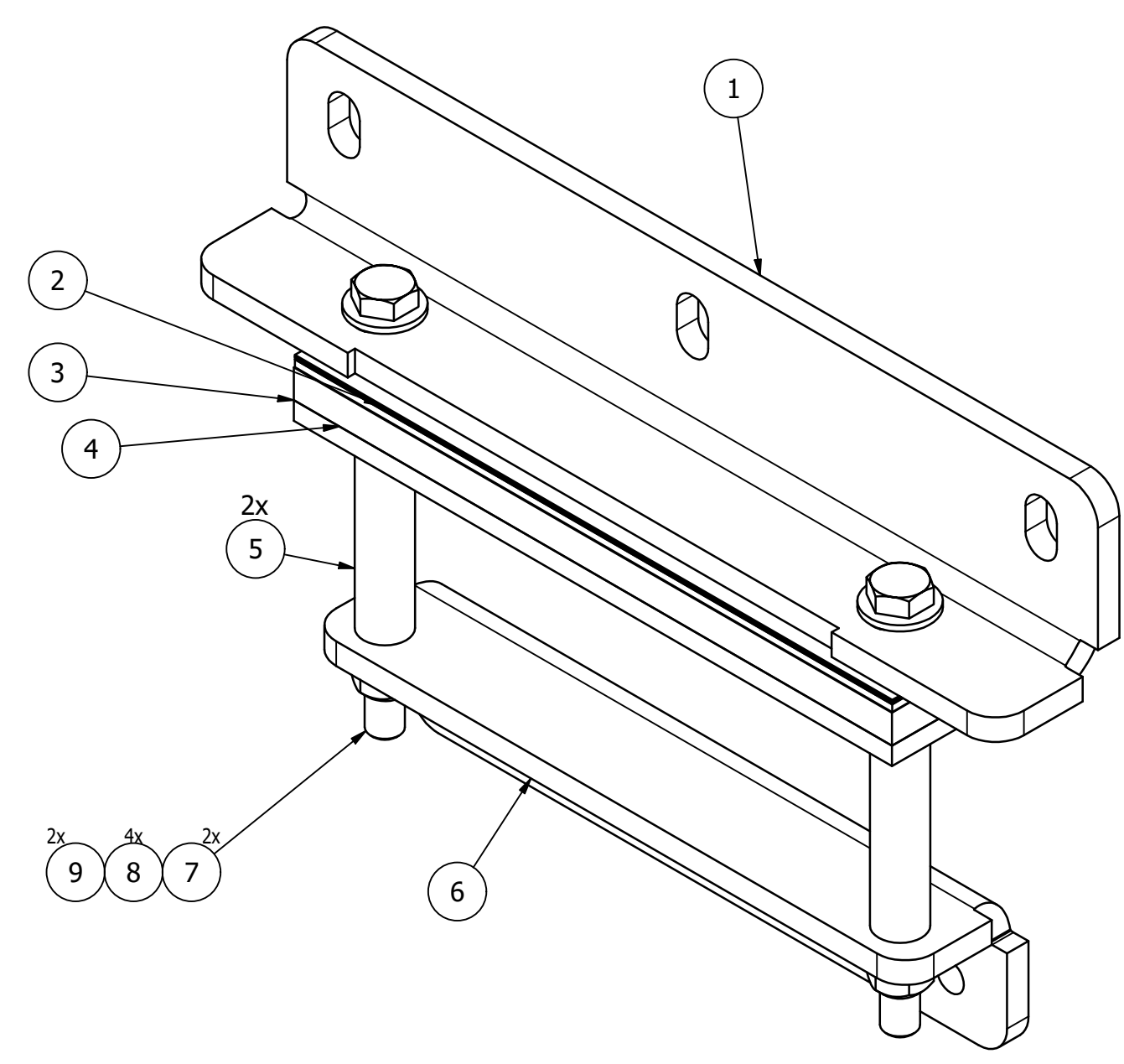
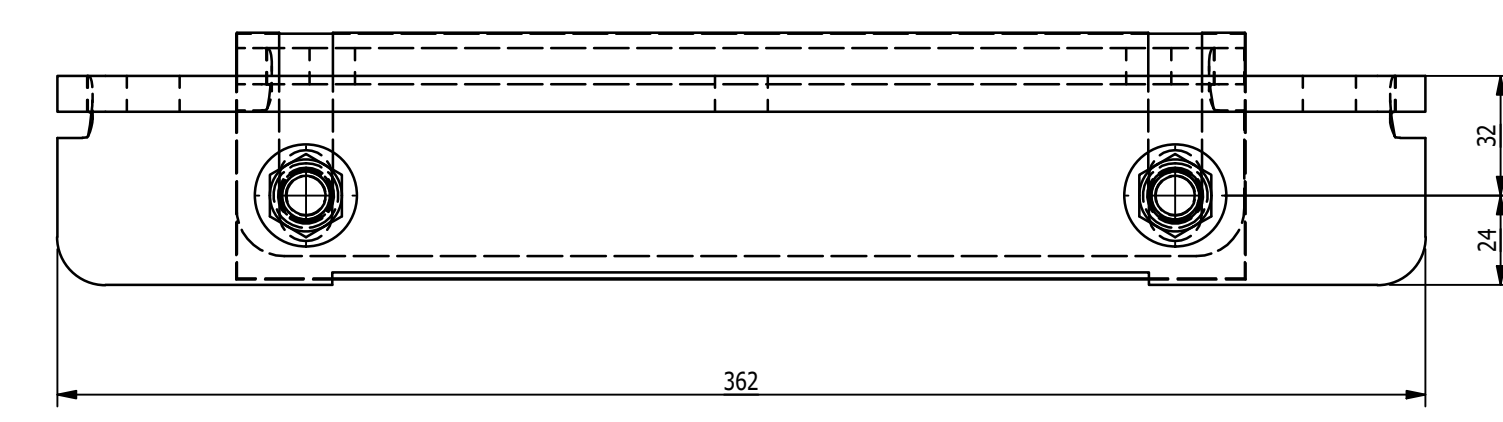
WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

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

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

3:00p - 1875D235 Rev B Drawing Issues 2022-07-12 Rev C D:\CUC\1875D235.dwg

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D236A			
1	1	MK-D237A ~ LIFTER UPPER BRACKET			
2	1	MK-D239A ~ SHIM PACK			
3	1	MK-D238A ~ LIFTER PLATE			
4	1	MK-D238B ~ LIFTER PLATE			
5	2	MK-D238C ~ LIFTER BRACKET SPACER			
6	1	MK-D237B ~ LIFTER LOWER BRACKET			
7	2	1/2-13UNC x 6 1/2" LG. HEX HEAD CAP SCREW ~ GR 5			
8	4	1/2 TYPE A NARROW FLAT WASHER			
9	2	1/2-13UNC STOVER LOCK NUT			
		TOTAL WEIGHT ~ 19.5 lbs			



MK-D236A ~ LIFTER BRACKET ASSEMBLY
SCALE 6"=1'-0"

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

PAINT NOTES:
PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/5/2022	FOR FABRICATION	

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	<small>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</small>
	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO	DRAWN BY: AH CHECKED BY: XXX DWG DATE:

DRAWING No. 1875D236	REV: A	JOB No: 22096
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41100 Dardickwood Rd.
Suite 125
West, MI 48375

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D236

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.

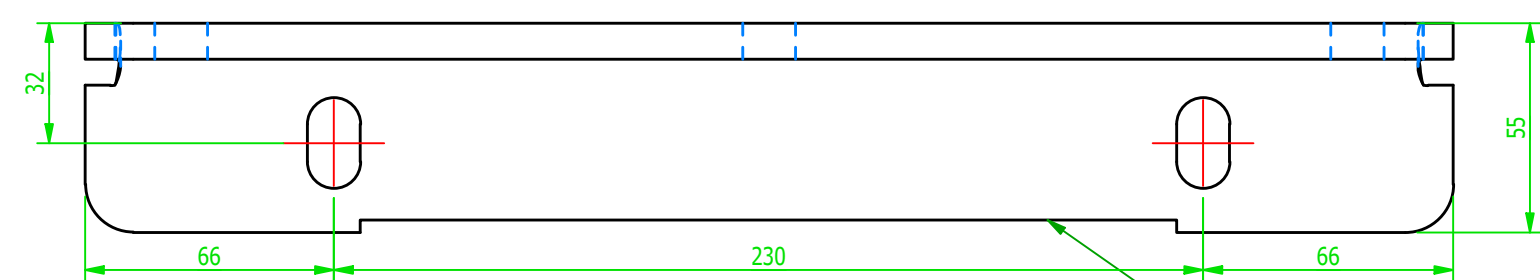
HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

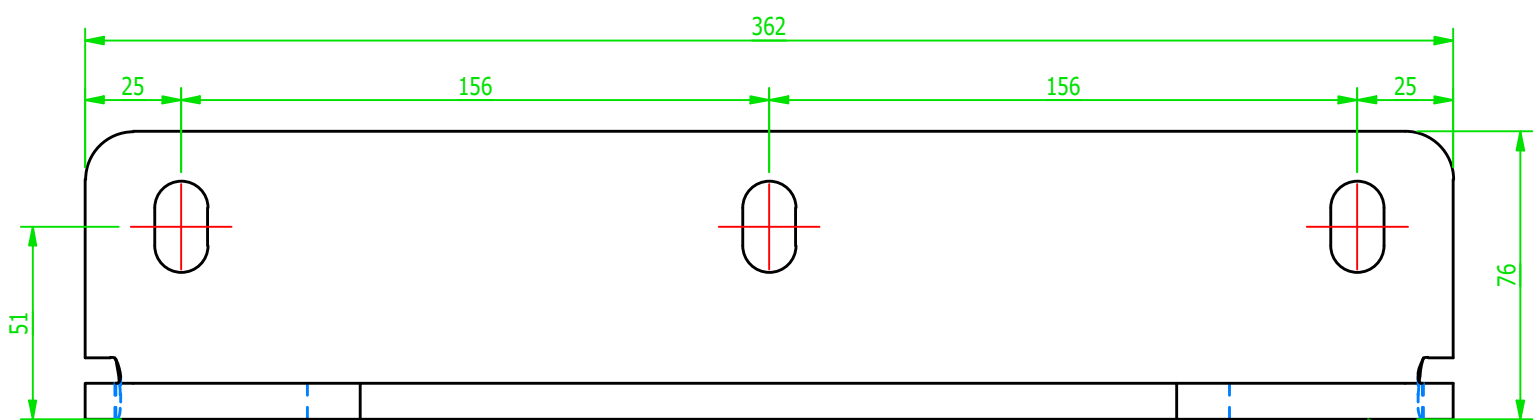
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D237A			
1	1	PL 3/8 x 4 9/16"	1'-2 1/4"		
		TOTAL WEIGHT ~ 6.6 lbs			
		MK-D237B			
2	1	PL 3/8 x 3 7/8"	10 1/2"		
		TOTAL WEIGHT ~ 4.2 lbs			

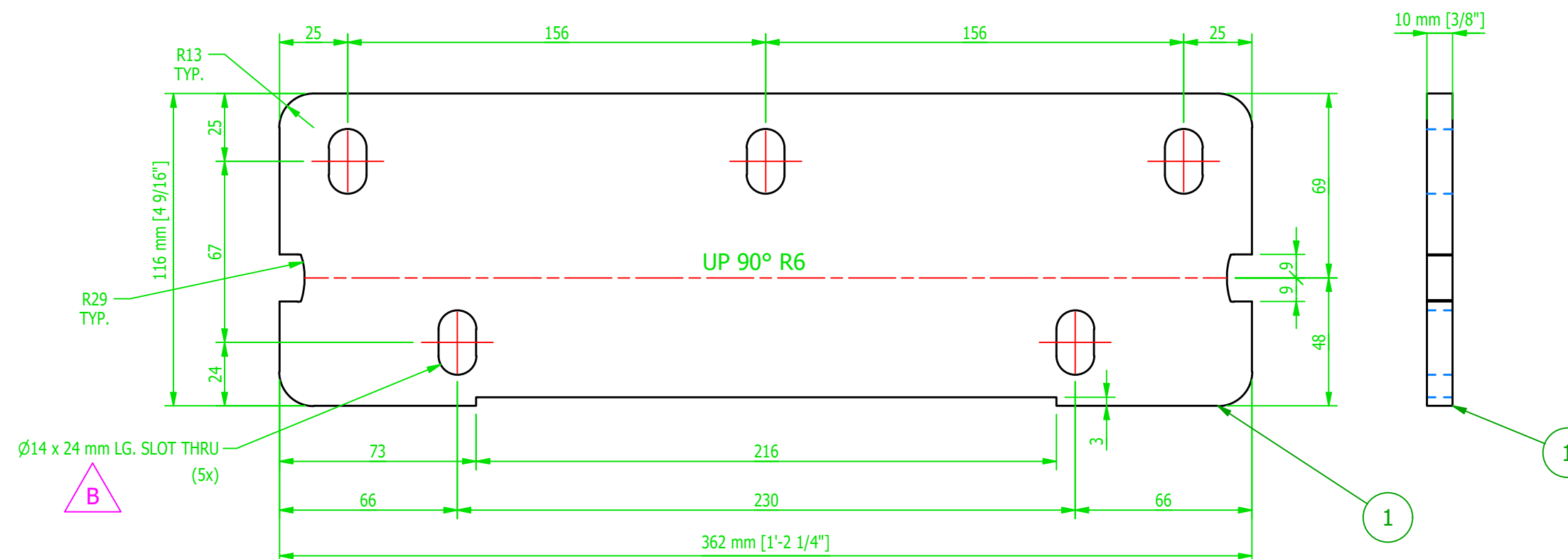


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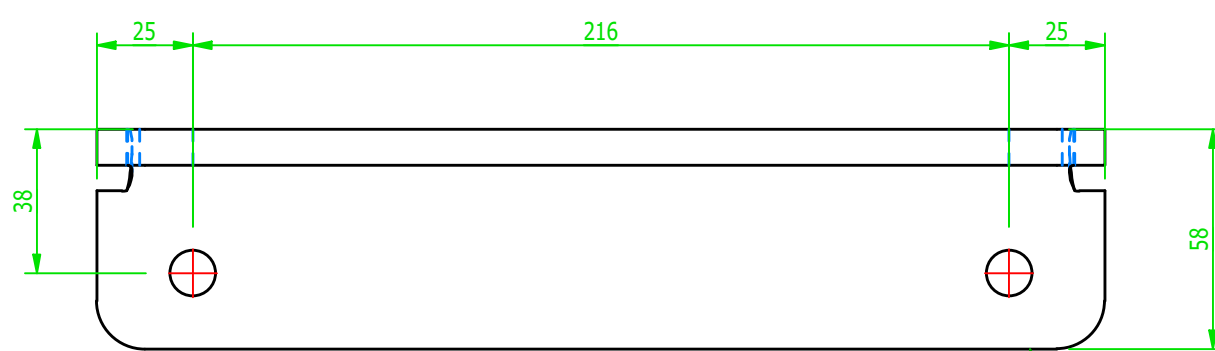
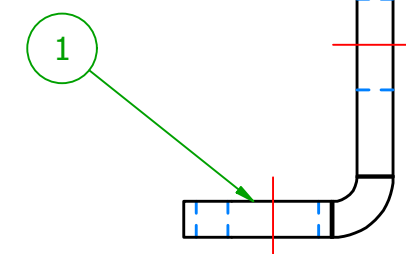


1

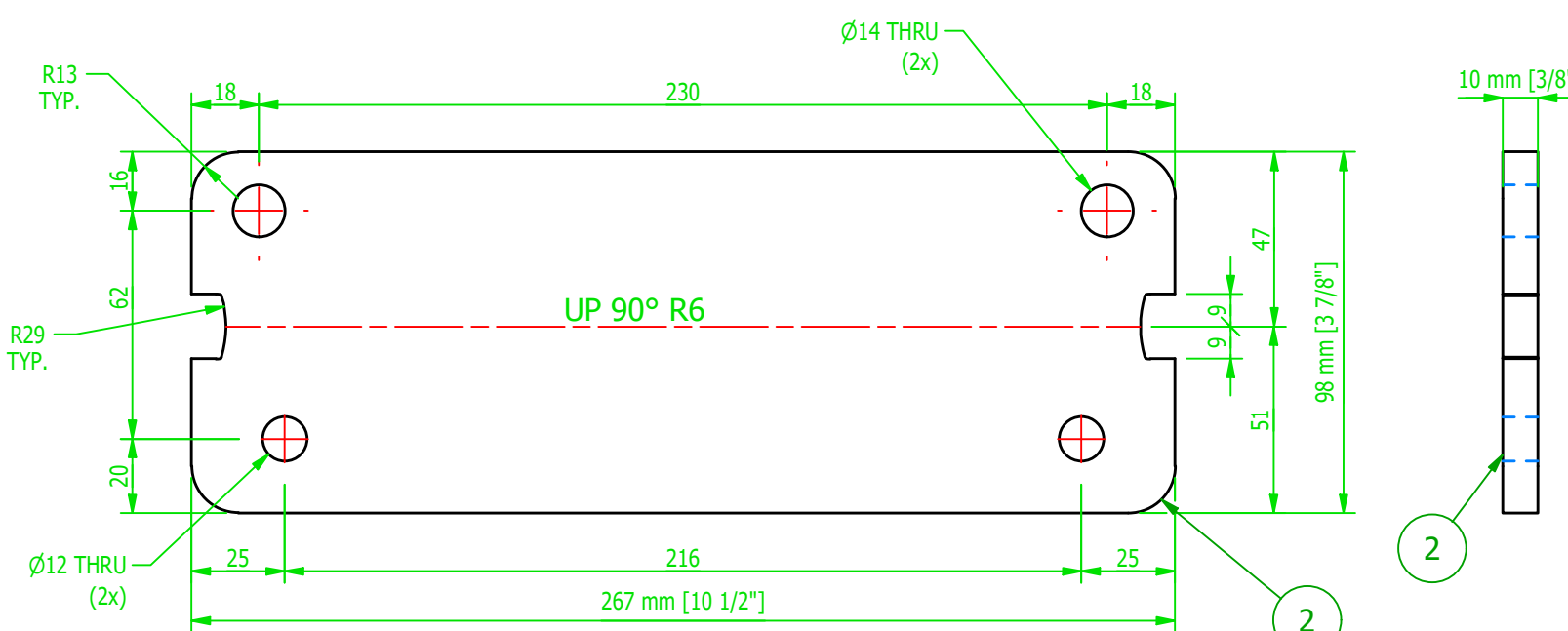
MK-D237A ~ LIFTER UPPER BRACKET
SCALE 6"=1'-0"



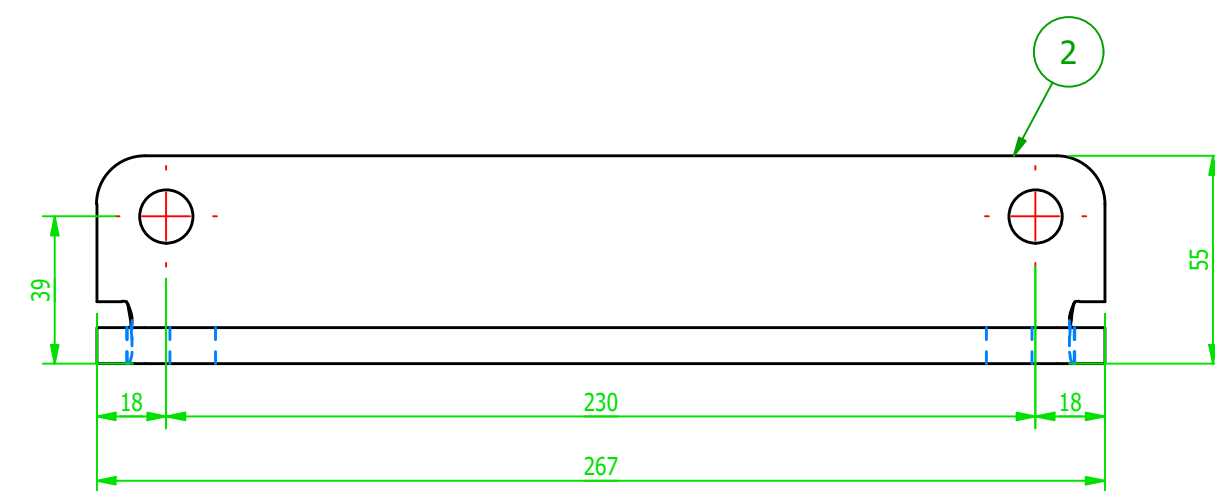
FLAT PATTERN OF ITEM '1'
SCALE 6"=1'-0"



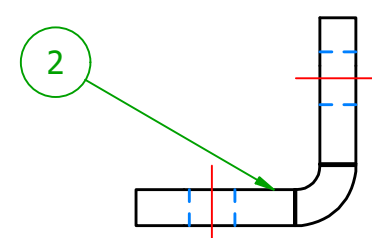
2



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



MK-D237B ~ LIFTER LOWER BRACKET
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

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/15/2022	REVISED DIMENSION AND SHOP NOTE	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.com</p>	<p>TITLE: P6700 CONVEYORS CAMPUS BUILDING</p> <p>CLIENT: VOLVO</p> <p>DRAWING No. 1875D237</p>	<p>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</p>
<p>REV: B</p>	<p>JOB No: 22096</p>	

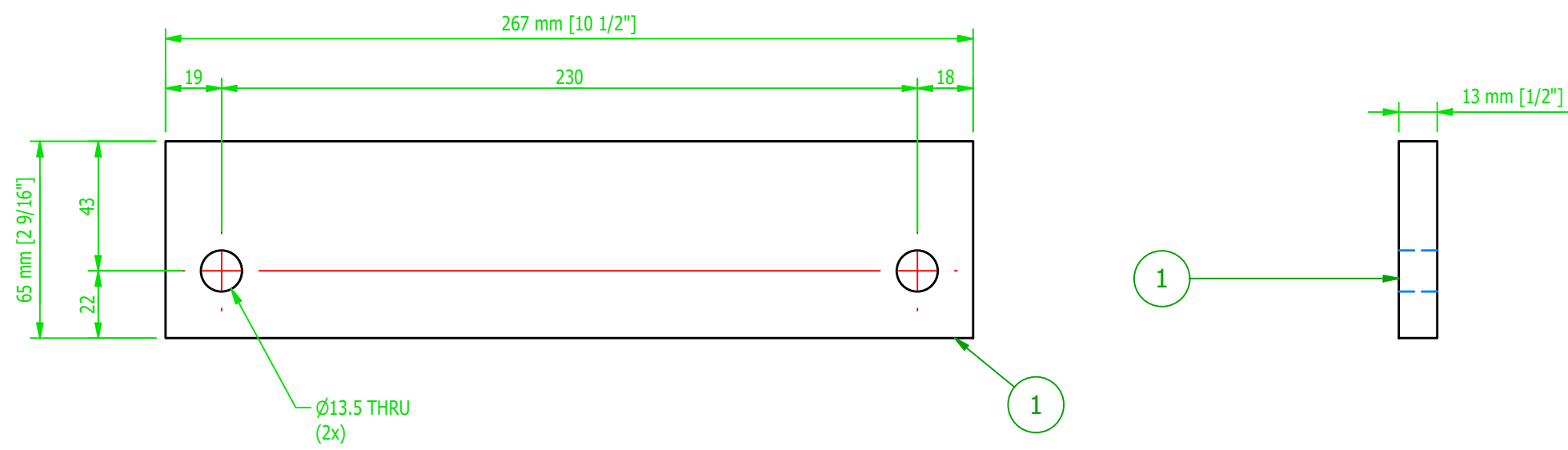
MAGNUM Consulting

41100 QuakerRoad Rd.
Suite 125
North, MI 48175

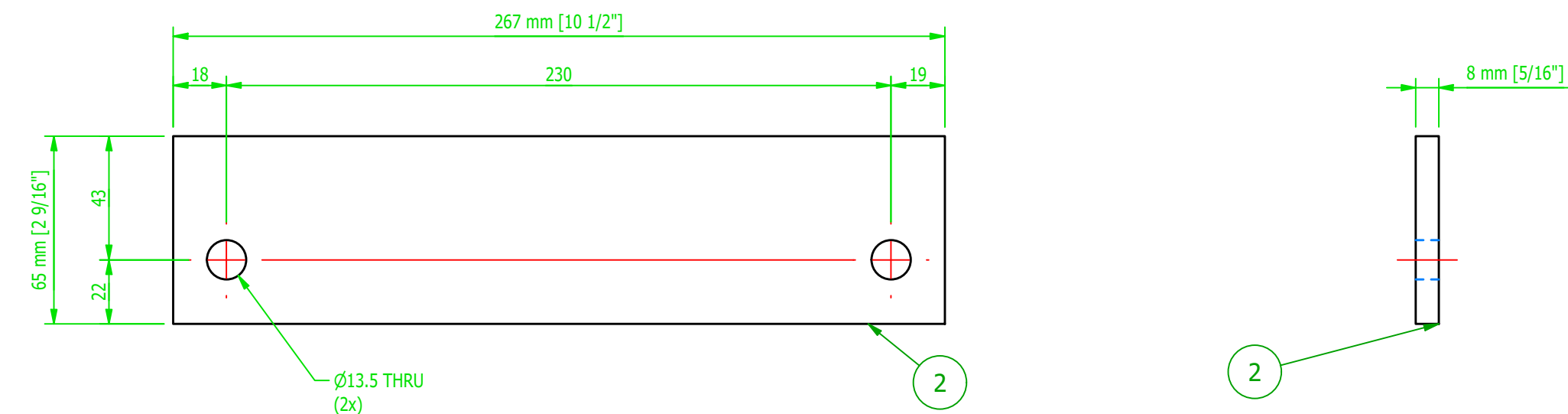
Phone: (248) 772-8822
Fax: (248) 772-8811
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D237

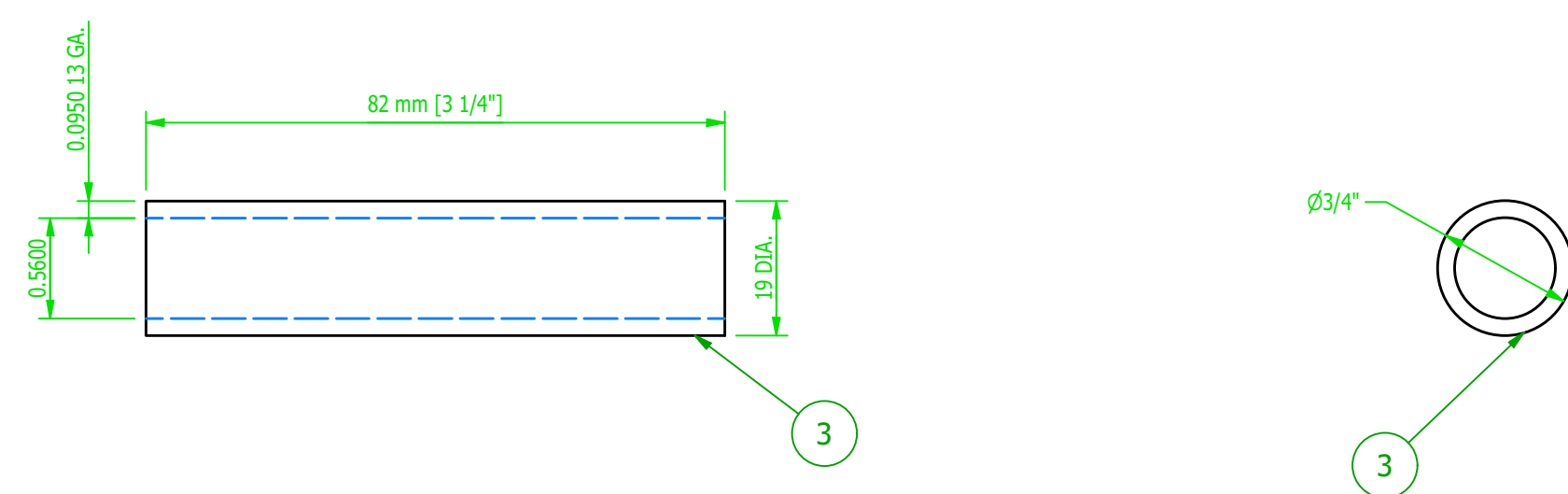
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



MK-D238A ~ LIFTER PLATE
SCALE 6"=1'-0"



MK-D238B ~ LIFTER PLATE △
SCALE 6"=1'-0"



MK-D238C ~ LIFTER BRACKET SPACER
SCALE 1'-0" = 1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D238A			
1	1	PL 1/2 x 2 9/16"	10 1/2"		
		TOTAL WEIGHT ~ 3.8 lbs			
		MK-D238B			
△ 2	1	PL 5/16 x 2 9/16" ~ SURE ALLOY 500 STEEL	10 1/2"		
		TOTAL WEIGHT ~ 2.4 lbs			
		MK-D238C			
3	1	TS 3/4 OD x 13 GA ~ ASTM A513 TYPE 5 TUBE	3 1/4"		
		TOTAL WEIGHT ~ 0.2 lbs			

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/15/2022	REVISED MATERIAL SPECIFICATION & SHOP NOTE	
A	MC	7/5/2022	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.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.
CLIENT:	VOLVO	DRAWN BY:	AH
DRAWING No.	1875D238	CHECKED BY:	CW
REV:	A	DWG DATE:	6/20/22
		JOB No.:	22096

MAGNUM Consulting
41100 QuakerRoad Rd.
Suite 125
North, MI 48175
Phone: (248) 772-8822
Fax: (248) 772-8821
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D238

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)

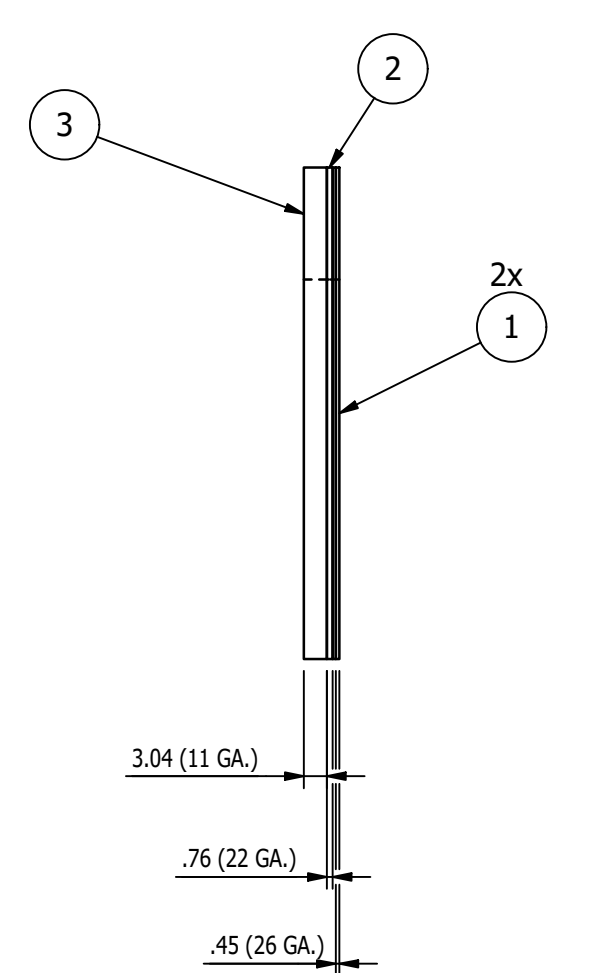
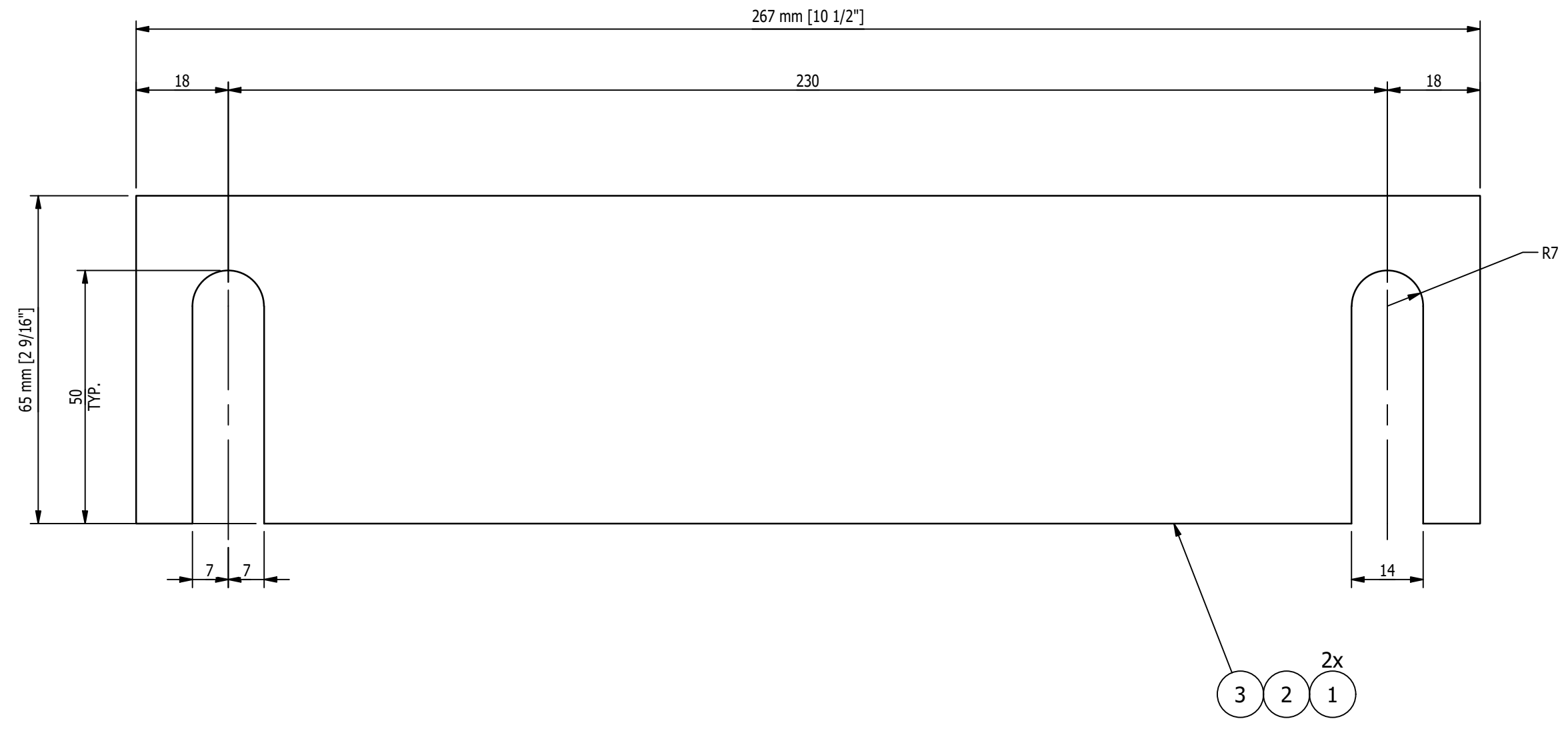
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D239A			
1	2	SHT 26 GA x 2 9/16"	10 1/2"		
2	1	SHT 22 GA x 2 9/16"	10 1/2"		
3	1	SHT 11 GA x 2 9/16"	10 1/2"		
TOTAL WEIGHT ~ 1.3 lbs					




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

PAINT NOTES:
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
A	MC	7/5/2022	FOR FABRICATION	

 MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: AH
CLIENT: VOLVO		CHECKED BY: XXX
DRAWING No. 1875D239		DWG DATE:
REV: A		JOB No: 22096



41100 QuakerRoad Rd.
Suite 125
West, MI 48375

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D239

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)

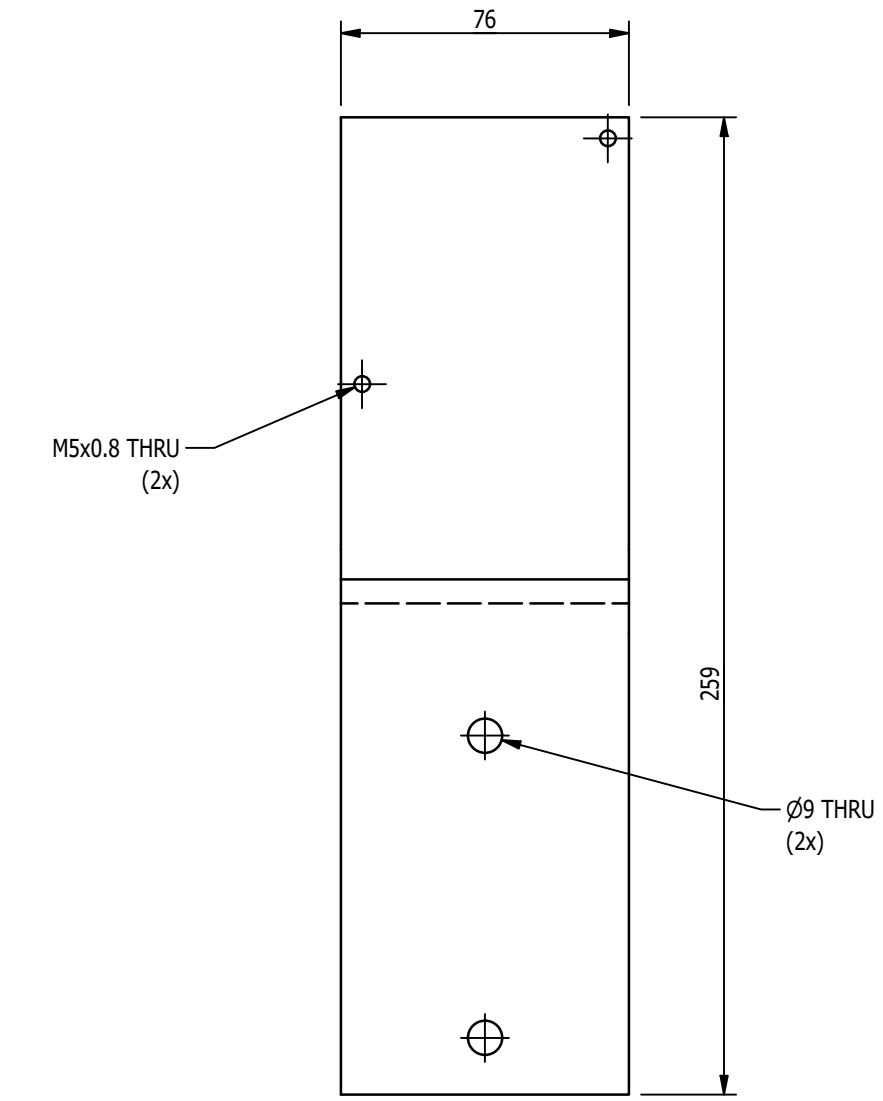
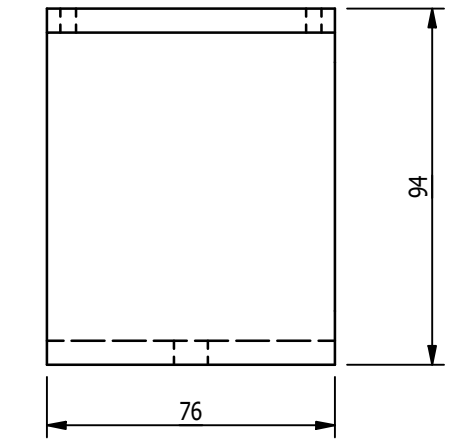
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

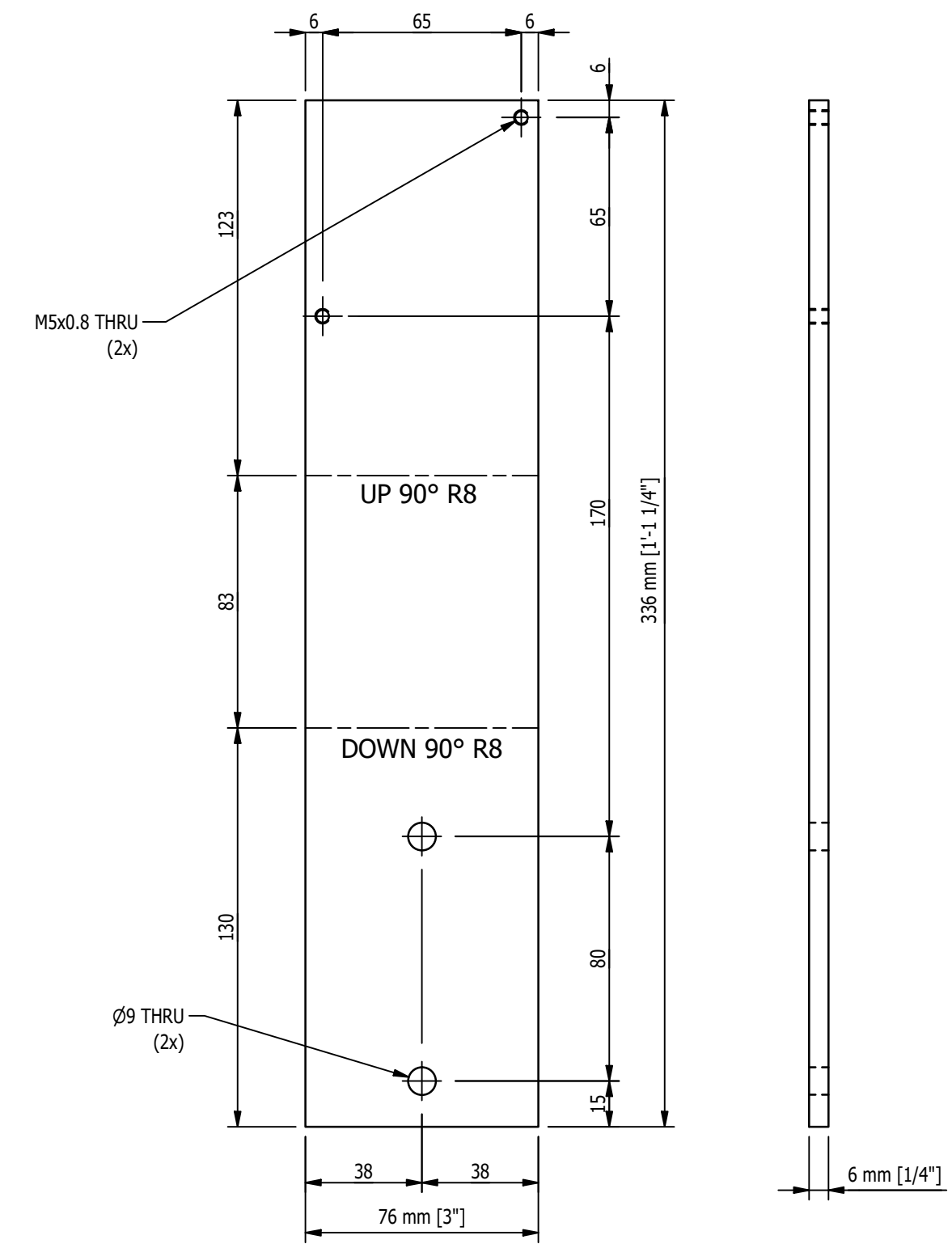
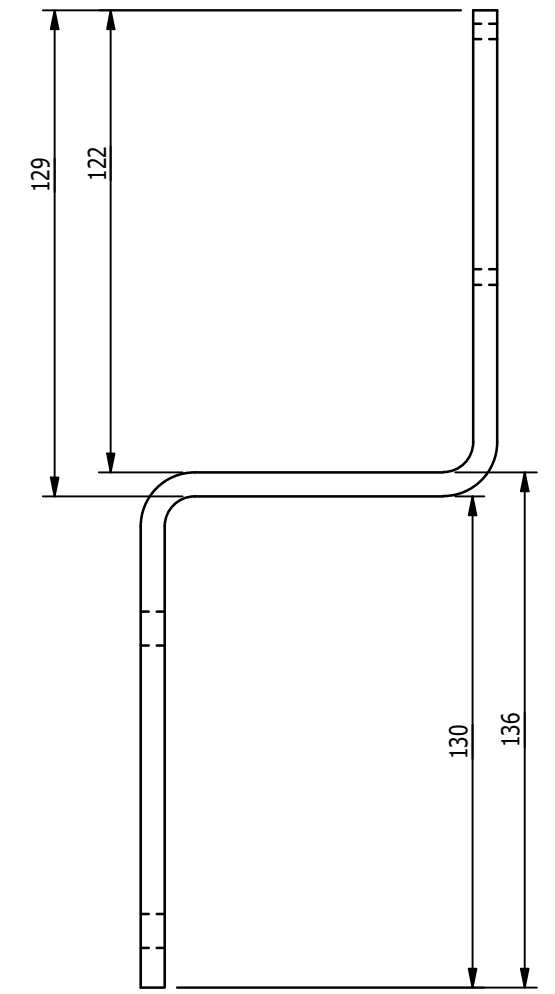
COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D240A			
1	1	BAR 1/4 x 3	1'-1 1/4"		
TOTAL WEIGHT ~ 3.2 lbs					



MK-D240A ~ RF CODE READER BKT
SCALE 6"=1'-0"



FLAT PATTERN OF ITEM '1'
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 ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D240

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.

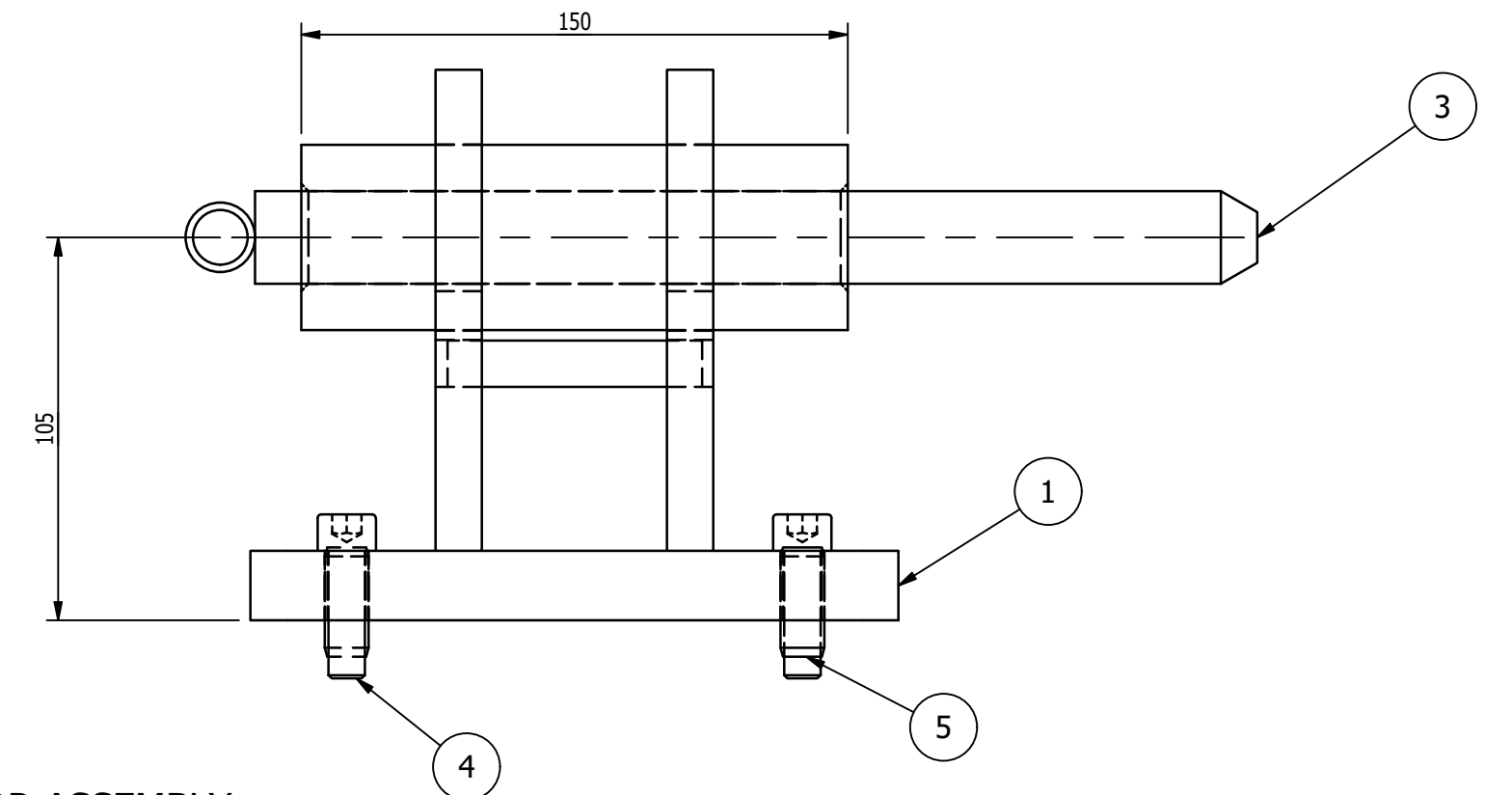
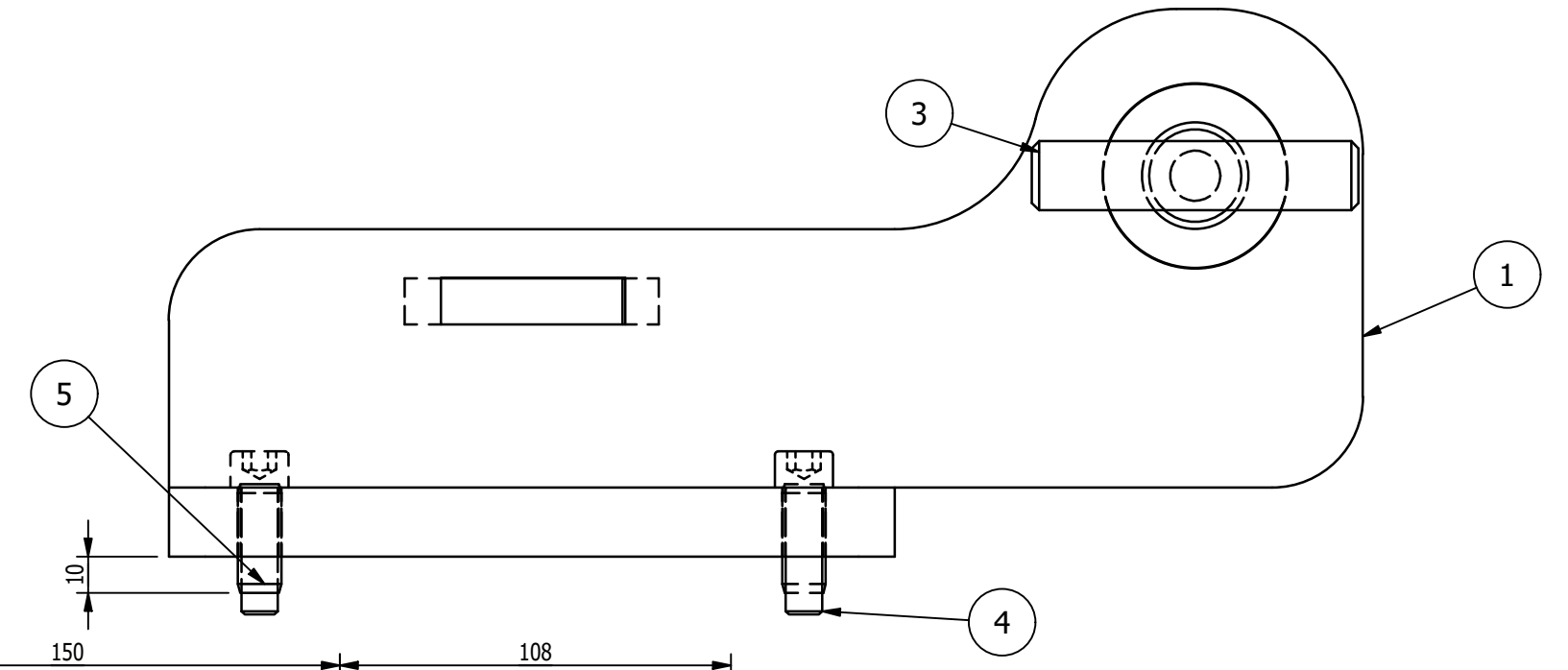
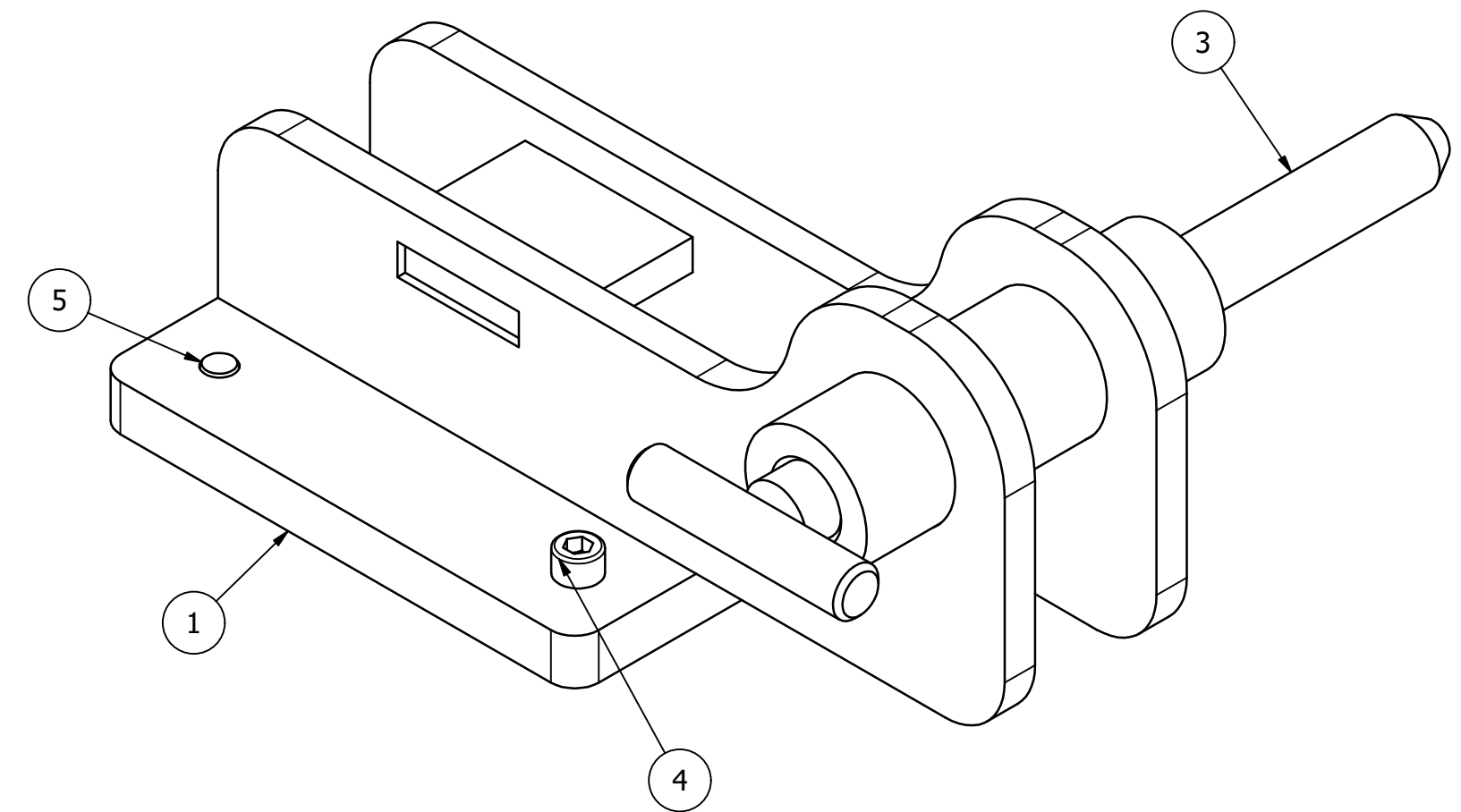
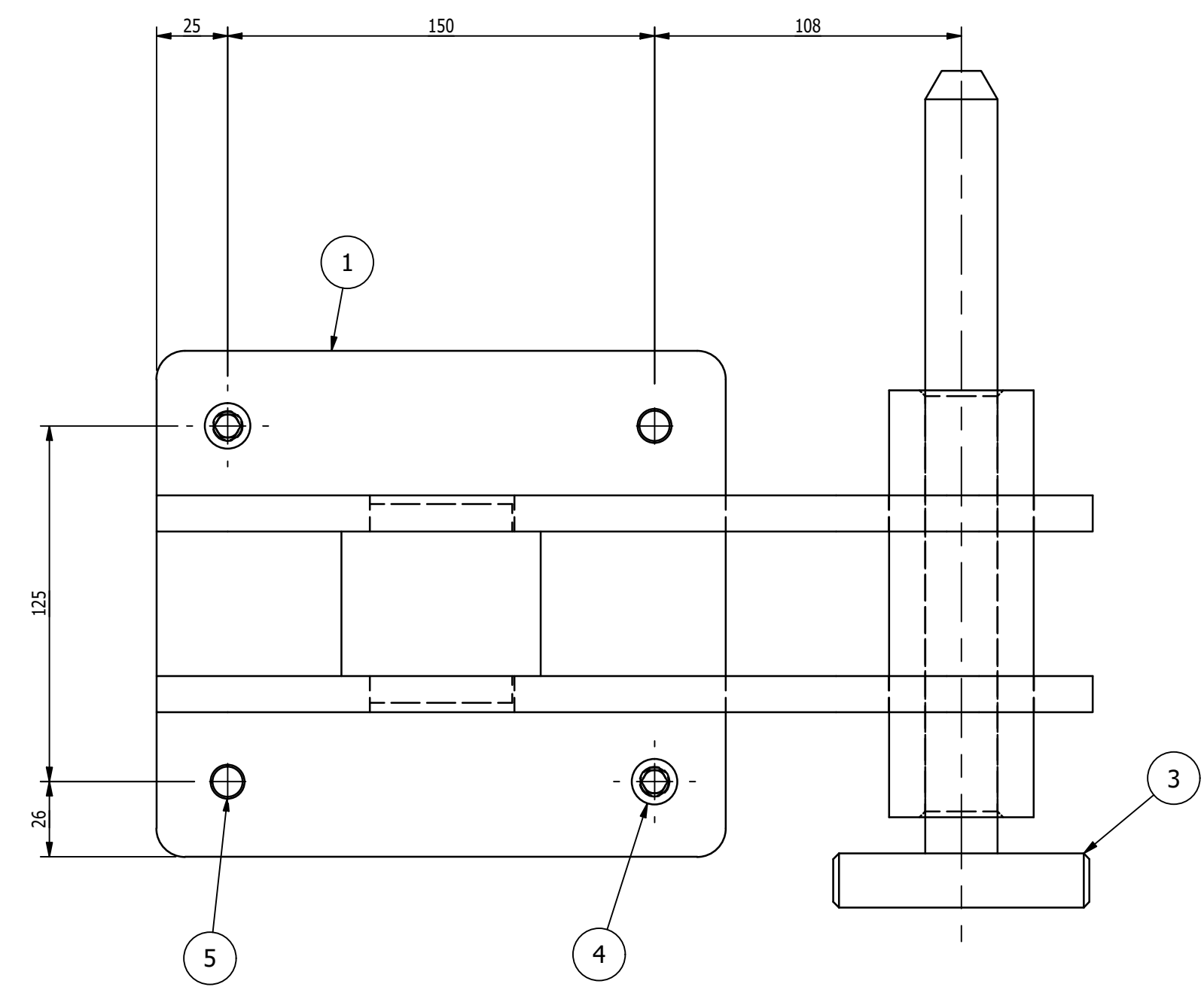
WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

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	7/5/2022	FOR FABRICATION	
REVISION HISTORY				
			MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING			DRAWN BY: AH	
CLIENT: VOLVO			CHECKED BY: XXX	
DRAWING No. 1875D240			REV: A	JOB No: 22096

3:00p 7/18/2022 New Job Drawing/Issue/22-240 Miller File P670025096.dwg



MK-D241A ~ SAFETY PIN WELDMENT LOCATOR ASSEMBLY
SCALE 6"=1'-0"

MK-D241B ~ SAFETY PIN WELDMENT LOCATOR ASSEMBLY
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D241A			
1	1	MK-D242A ~ SAFETY PIN WELDMENT LOCATOR MACHINING			
3	1	MK-D244A ~ SAFETY PIN WELDMENT LOCATOR PIN			
4	2	M10x1.5 x 35mm LG. HEX SOCKET HEAD CAP SCREW			
5	2	DOWEL PIN, UNDERSIZED, 12mm x 30mm LG.			
		MK-D241B			
2	1	MK-D242B ~ SAFETY PIN WELDMENT LOCATOR MACHINING			
3	1	MK-D244A ~ SAFETY PIN WELDMENT LOCATOR PIN			
4	2	M10x1.5 x 35mm LG. HEX SOCKET HEAD CAP SCREW			
5	2	DOWEL PIN, UNDERSIZED, 12mm x 30mm LG.			

- 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:
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/14/22	ITEM '5' WAS M10 DOWEL, ITEM '4' WAS M12x1.75 mm LG. HEX SOCKET HEAD CAP SCREW	
A	MC	7/5/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: RJB	
MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 6/20/22	
DRAWING No. 1875D241		JOB No. 22096	
REV: B			

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

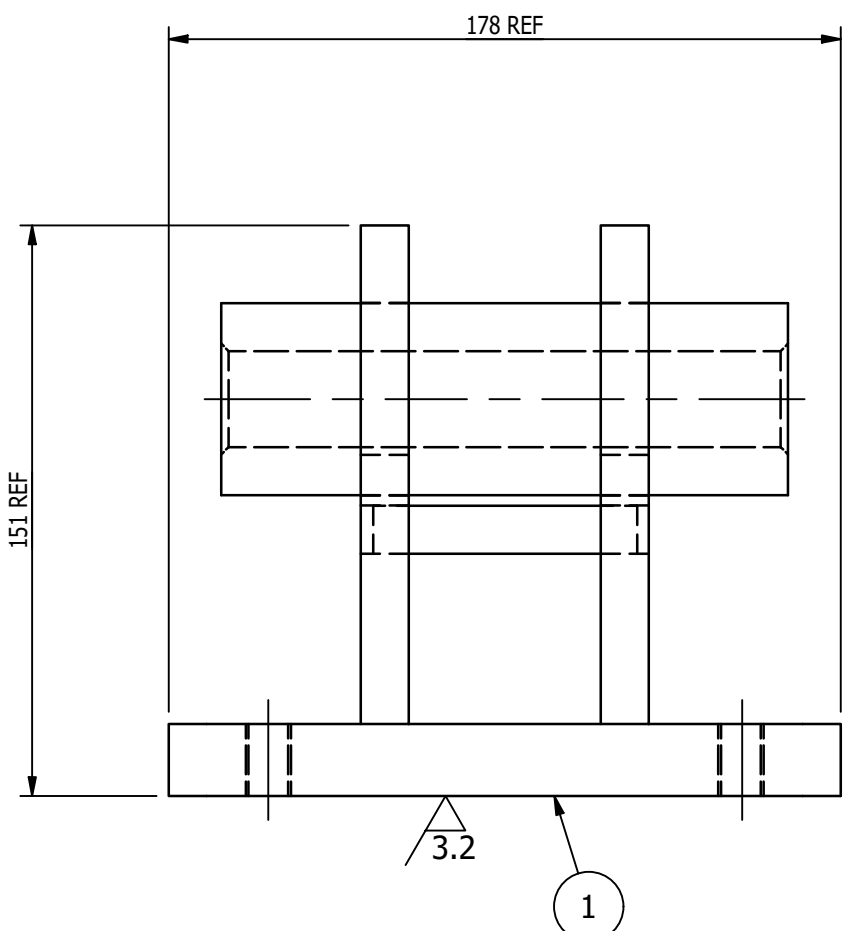
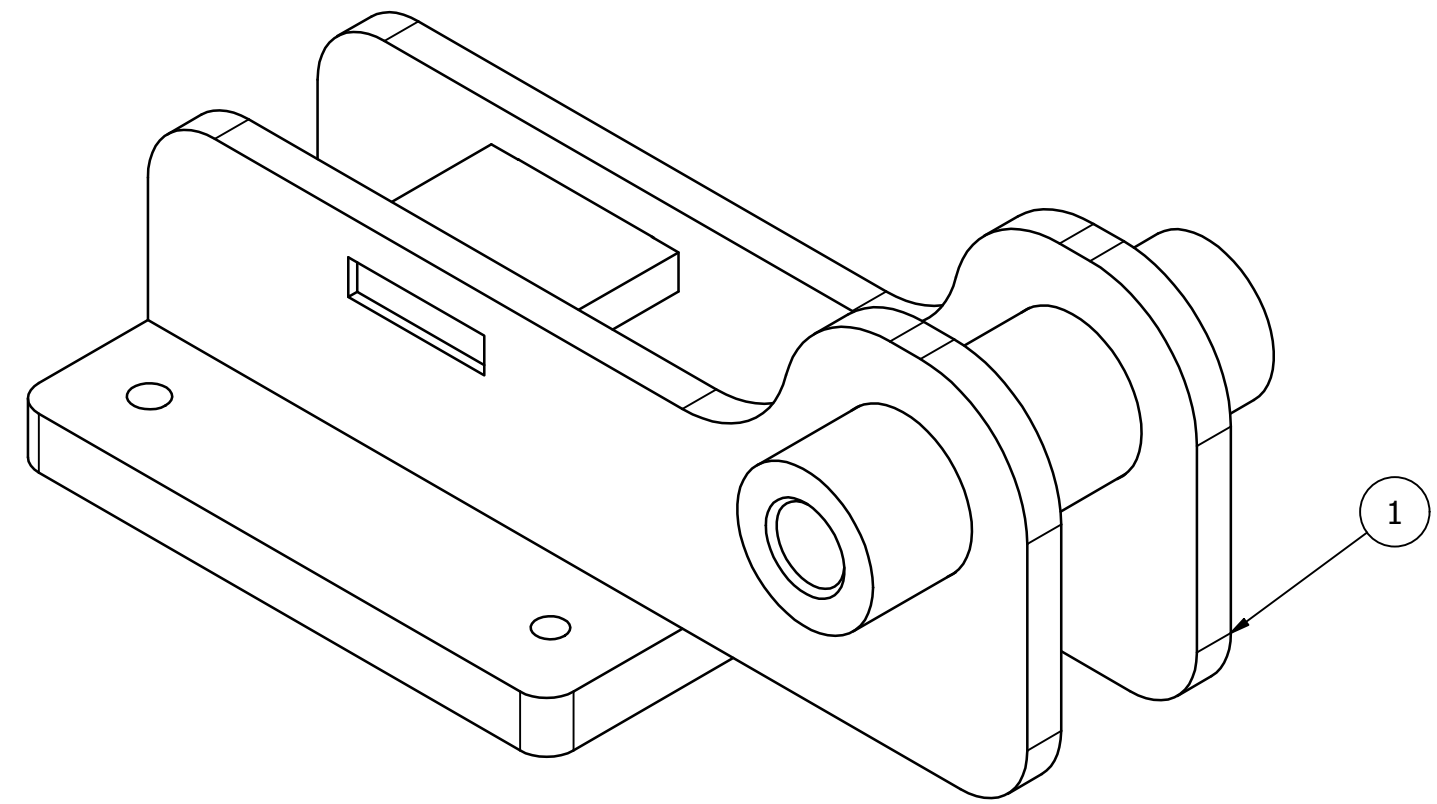
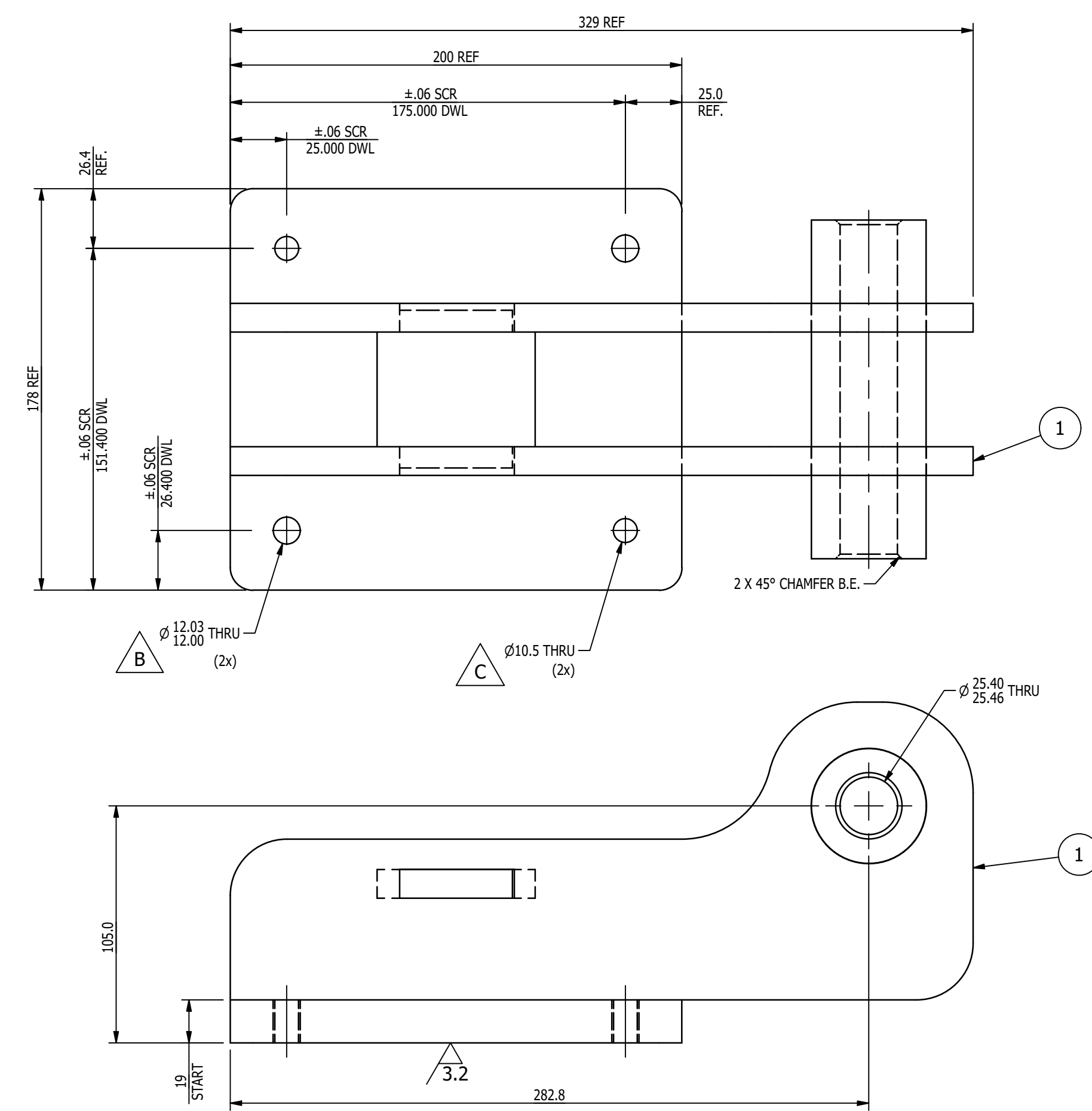
41100 Gardenbrook Rd.
Suite 125
West, MI 48375

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

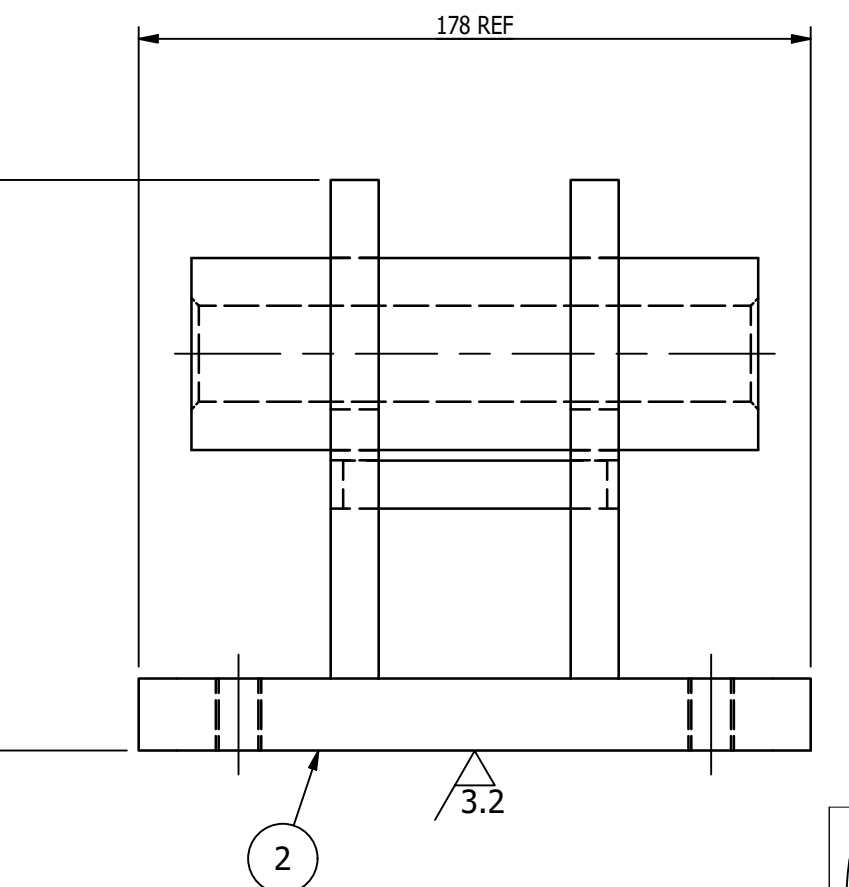
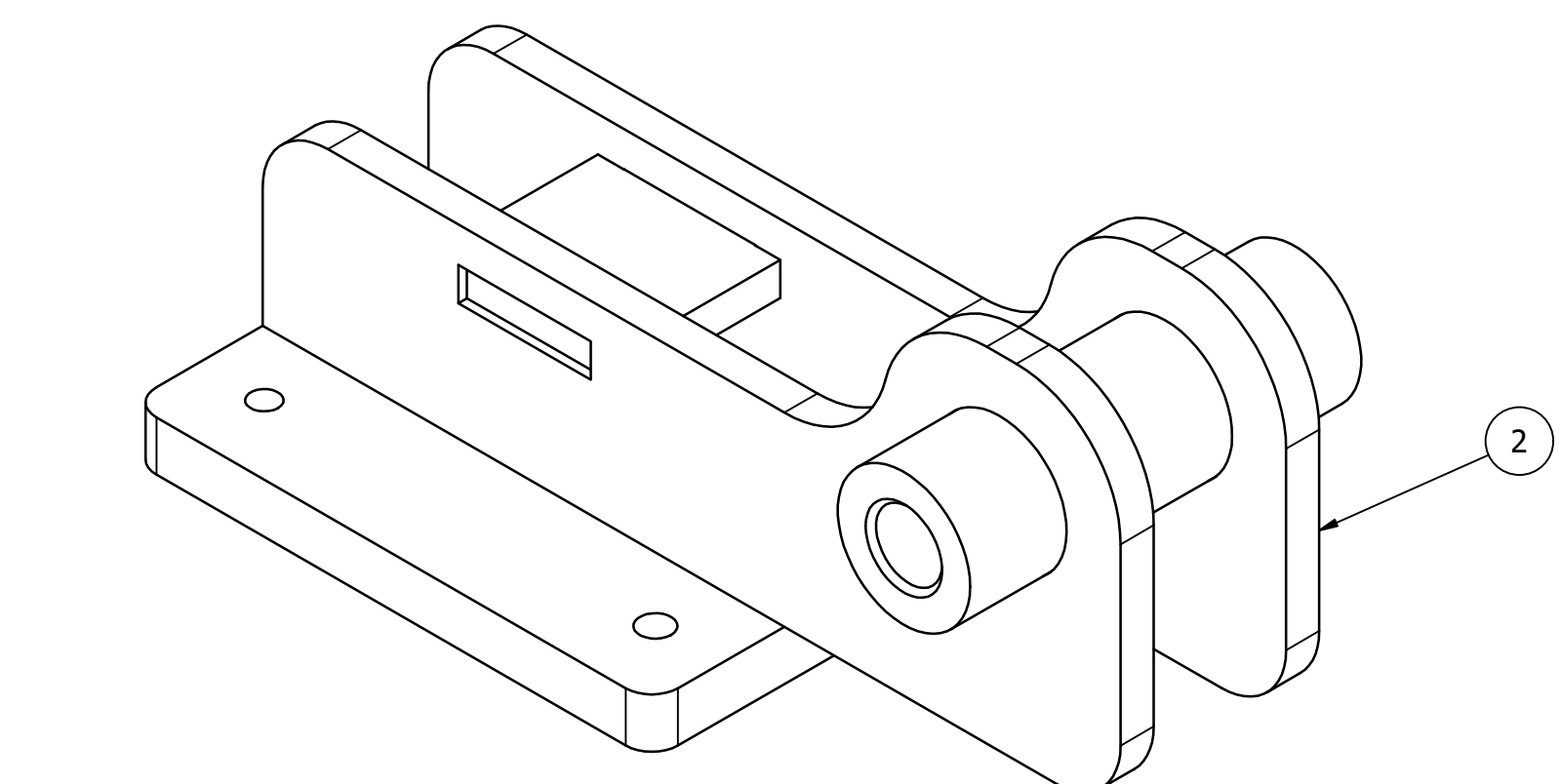
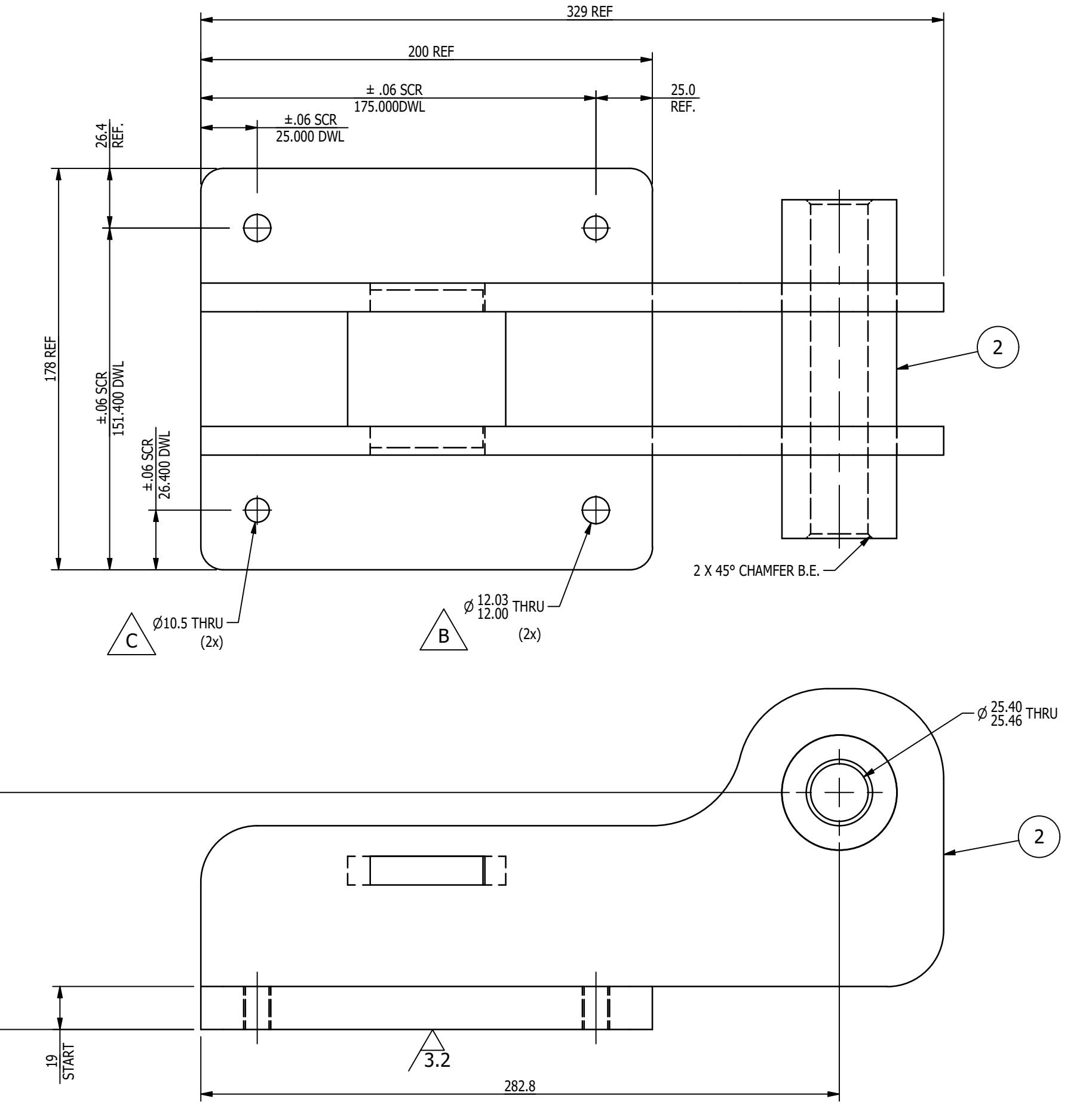
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D241 - REV B

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D242A MK-D243A ~ SAFETY PIN WELDMENT LOCATOR WELDMENT			
TOTAL WEIGHT ~ 27.8 lbs					
2	1	MK-D242B MK-D243A ~ SAFETY PIN WELDMENT LOCATOR WELDMENT			
TOTAL WEIGHT ~ 27.8 lbs					



MK-D242A ~ SAFETY PIN WELDMENT LOCATOR MACHINING
SCALE 6"=1'-0"



MK-D242B ~ SAFETY PIN WELDMENT LOCATOR MACHINING
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:
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
C	MC	10/14/22	10.5 DIA. WAS 12.5 DIA.	
B	MC	7/12/22	DIM'S REVISED, 12.03/12.00 DIA WAS 10.00/10.03 DIA	
A	MC	7/5/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: RJB	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 6/20/22	
DRAWING No. 1875D242		JOB No: 22096	
REV: C			

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

MAGNUM CONSULTING

41100 QuakerRoad Rd
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West, MI 48375

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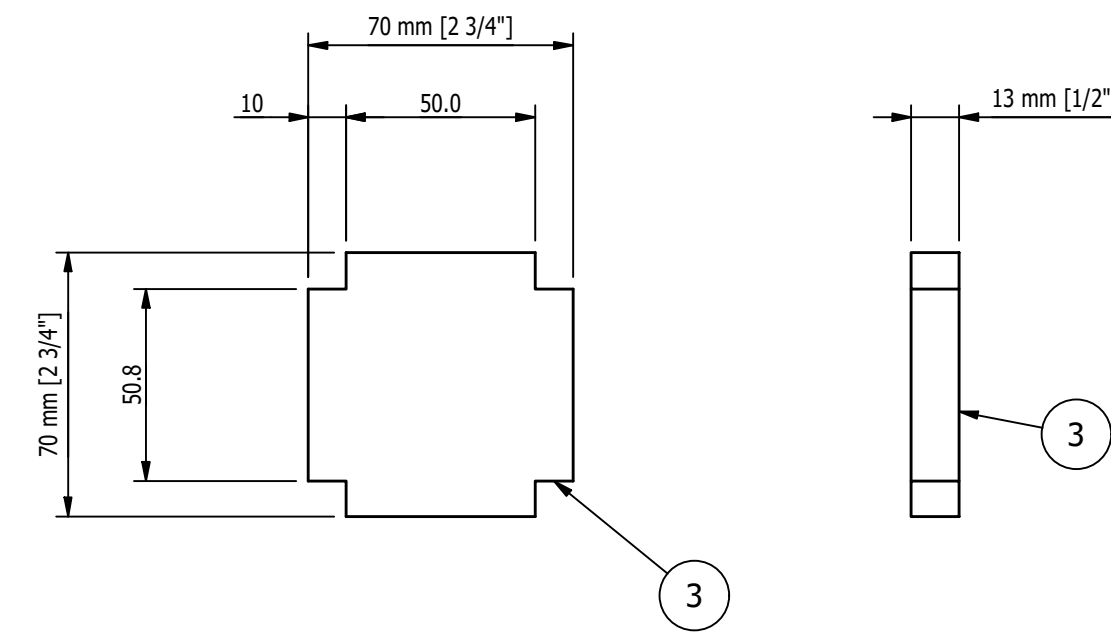
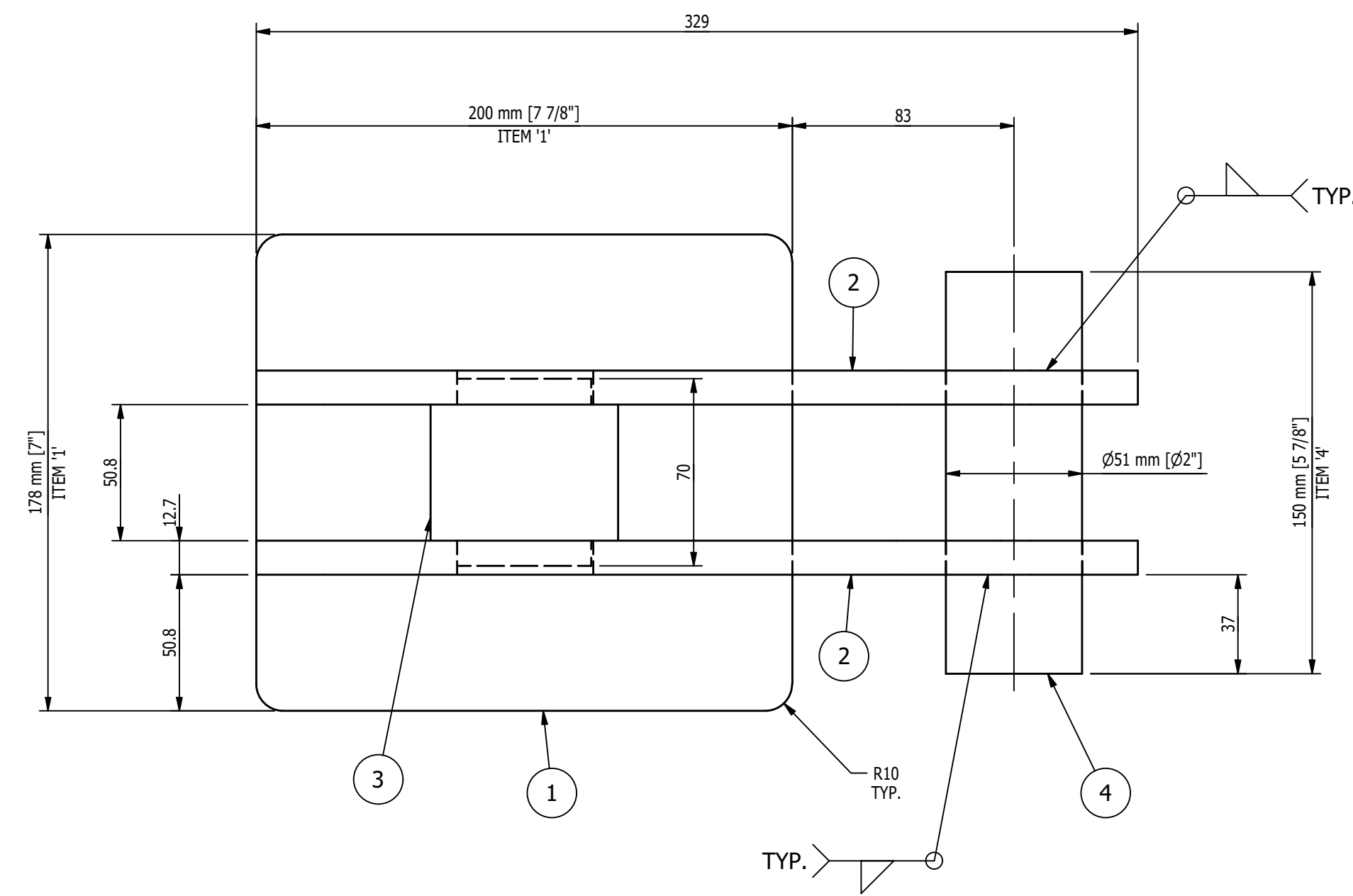
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D242 - REV C

UNLESS OTHERWISE NOTED:

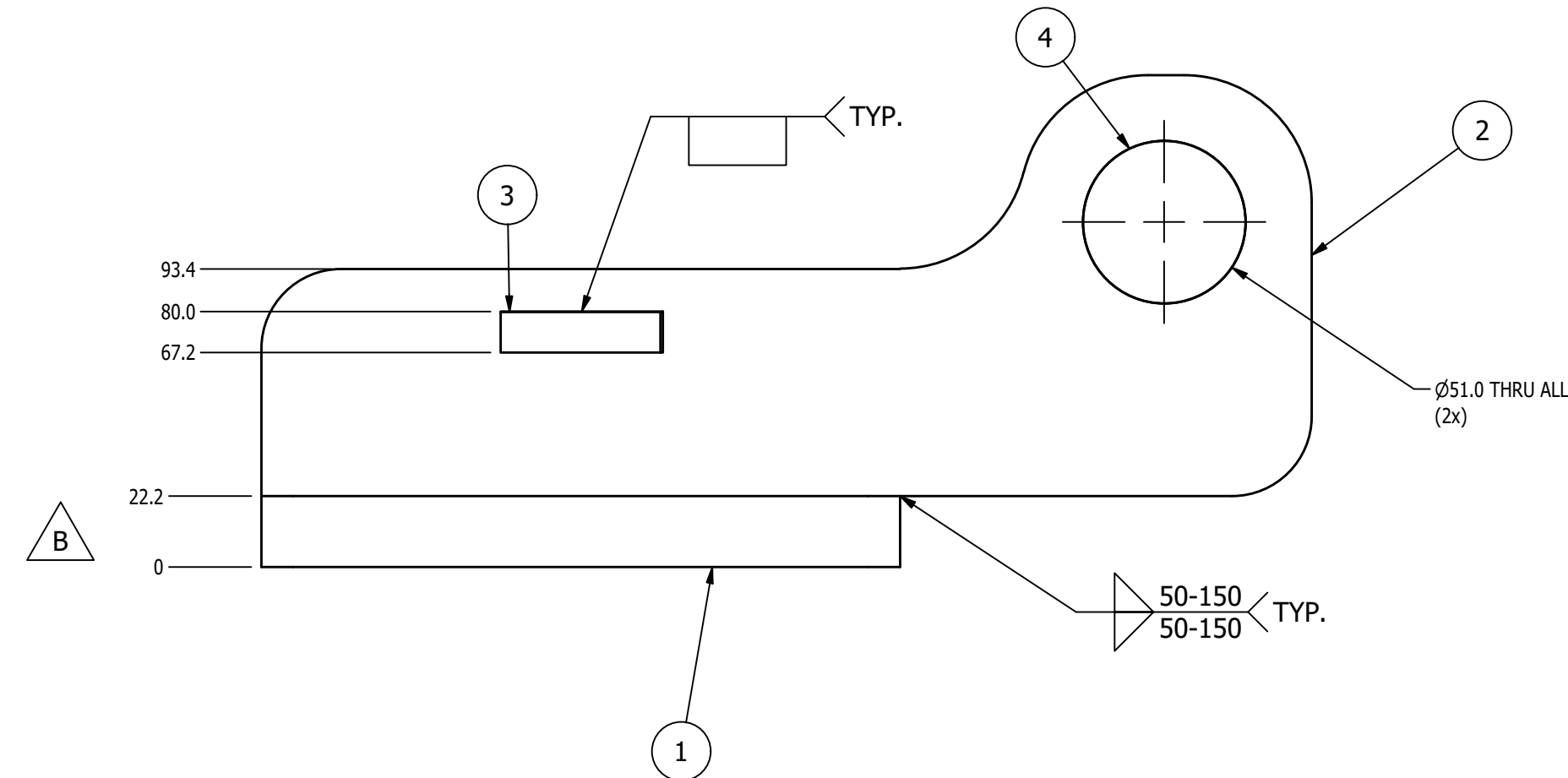
X = ±.060
XX = ±.030
XXX = ±.005

FRACTIONS = ±1/16"
ANGLES = ±1°30'

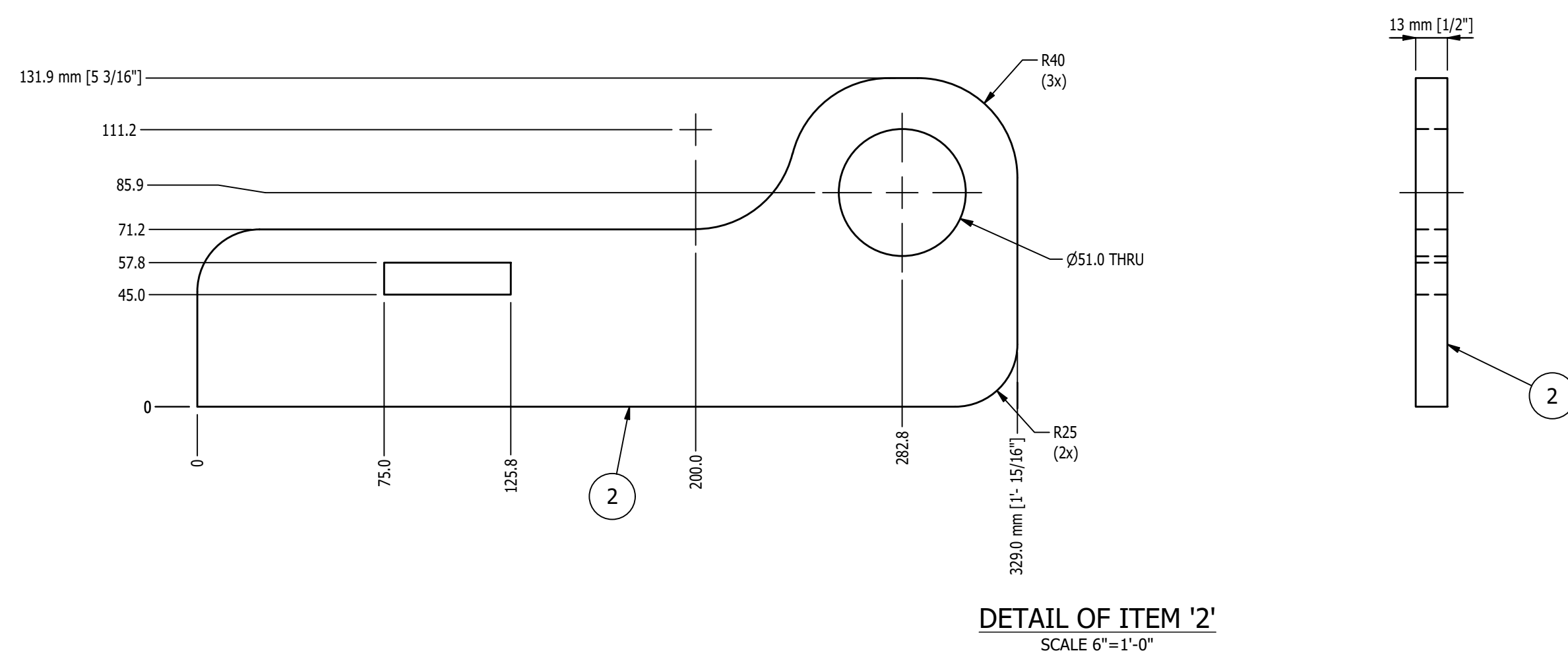
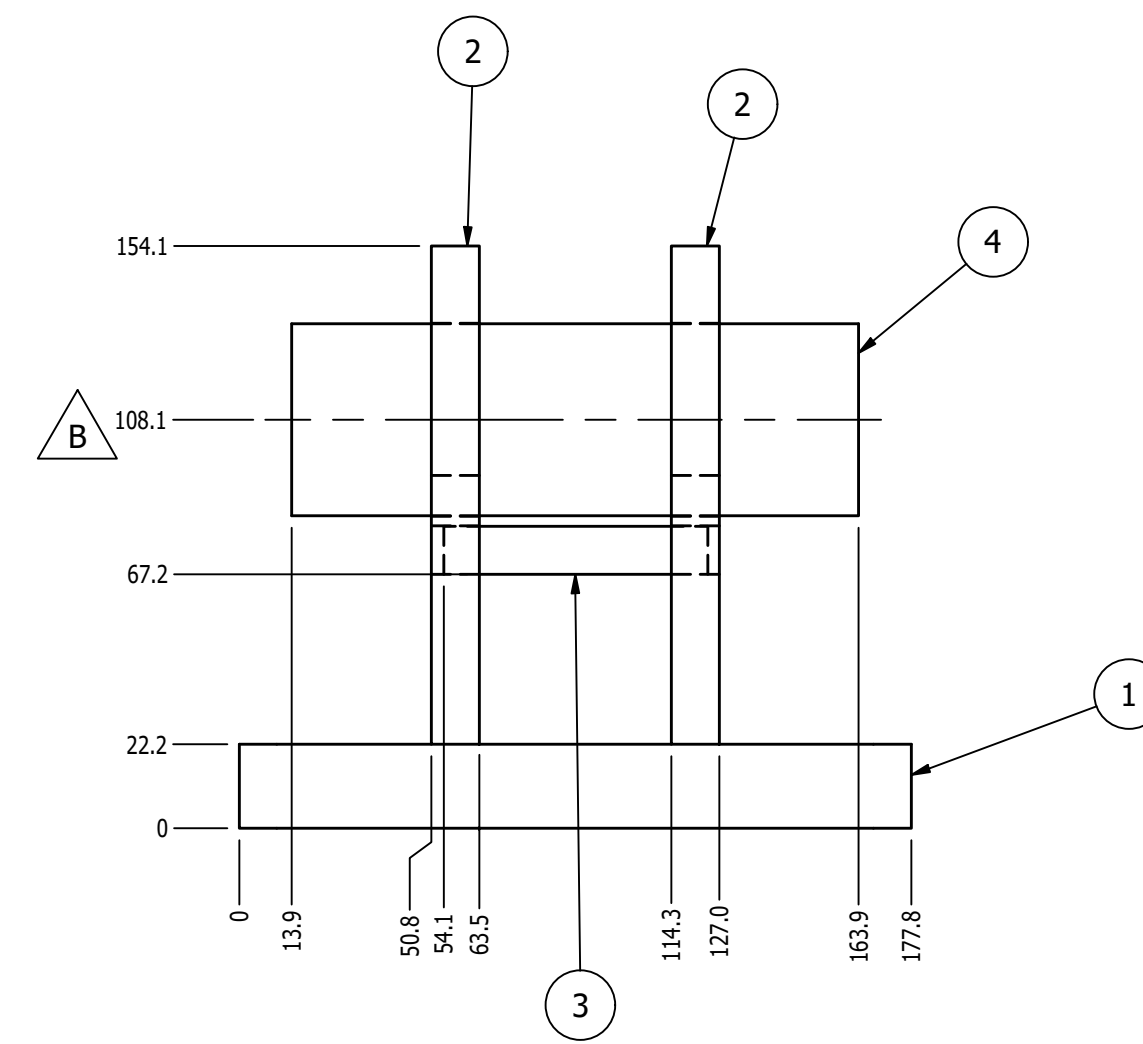
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



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



MK-D243A ~ SAFETY PIN WELDMENT LOCATOR WELDMENT
SCALE 6"=1'-0"



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D243A			
1	1	BAR 7/8 x 7	7 7/8"		
2	2	BAR 1/2 x 5 3/16"	1'- 15/16"		
3	1	BAR 1/2 x 2 3/4	2 3/4"		
4	1	BAR Ø2	5 7/8"		

- 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
ONE SHOP COAT OF LIGHT GREY RAL 7035

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/12/22	DIM REMOVED, DIM 108.1 WAS 113.5	
A	MC	7/5/22	FOR FABRICATION	

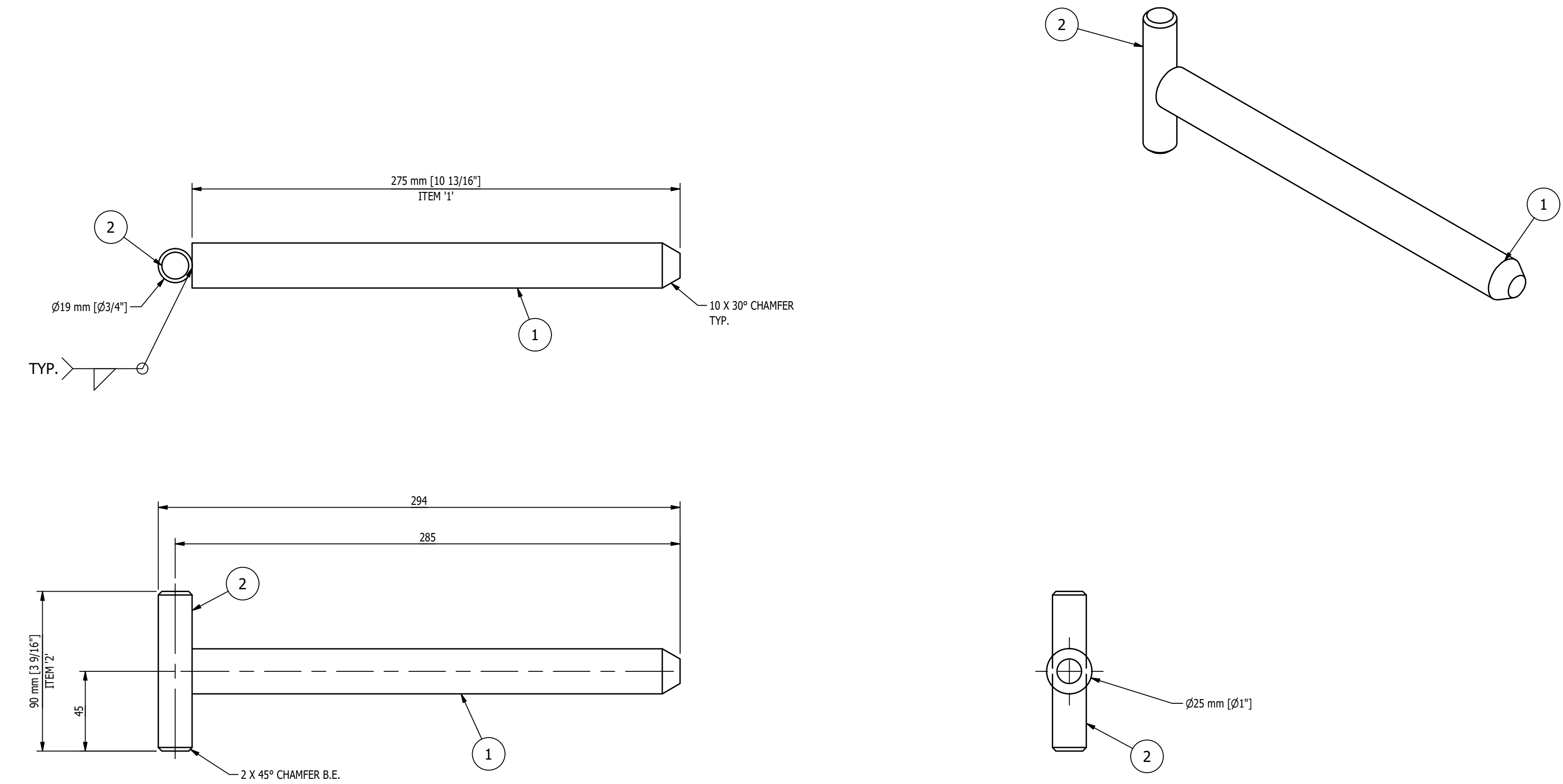
REVISION HISTORY				
		MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milc.com		
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: RJB CHECKED BY: CW DWG DATE: 6/20/22		
CLIENT: VOLVO		REV: B JOB No: 22096		
DRAWING No. 1875D243		REV: B JOB No: 22096		

MAGNUM CONSULTING
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 Novi, MI 48275
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 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D243

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-D244A			
1	1	BAR Ø1	10 13/16"		
2	1	BAR Ø3/4	3 9/16"		



MK-D244A ~ SAFETY PIN WELDMENT LOCATOR PIN
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:**
1. DO NOT PAINT

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

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB CHECKED BY: CW DWG DATE: 6/20/22

CLIENT: VOLVO DRAWING No. 1875D244 REV: A	JOB No: 22096
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MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D244

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 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)

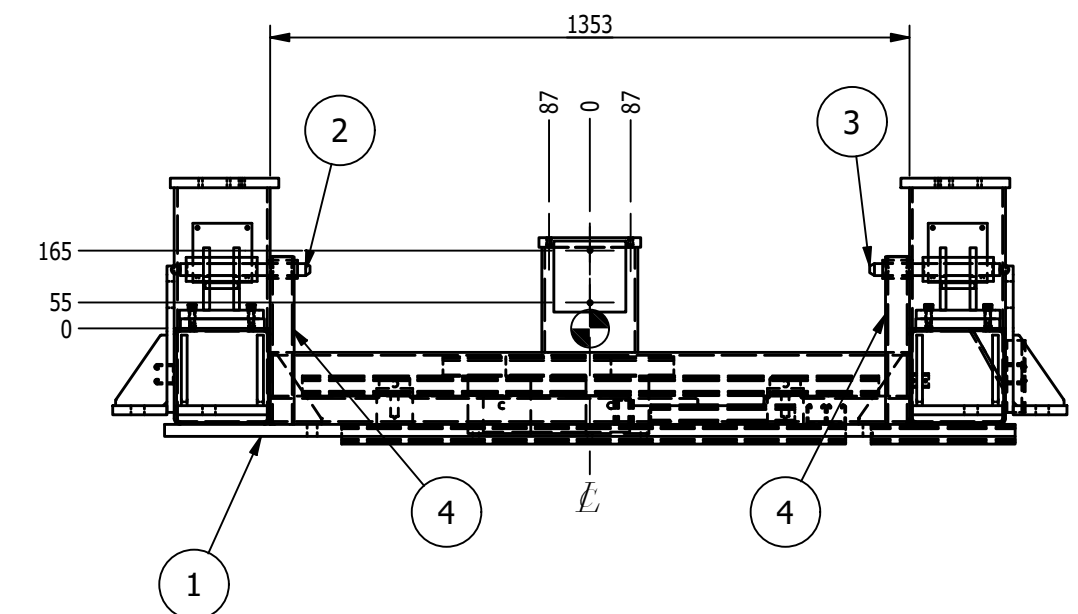
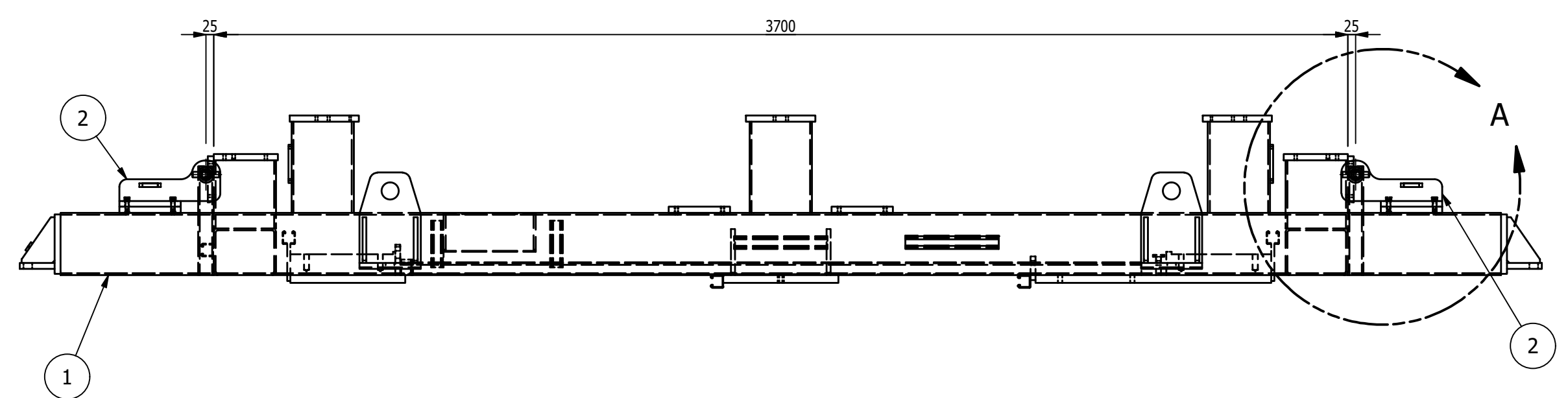
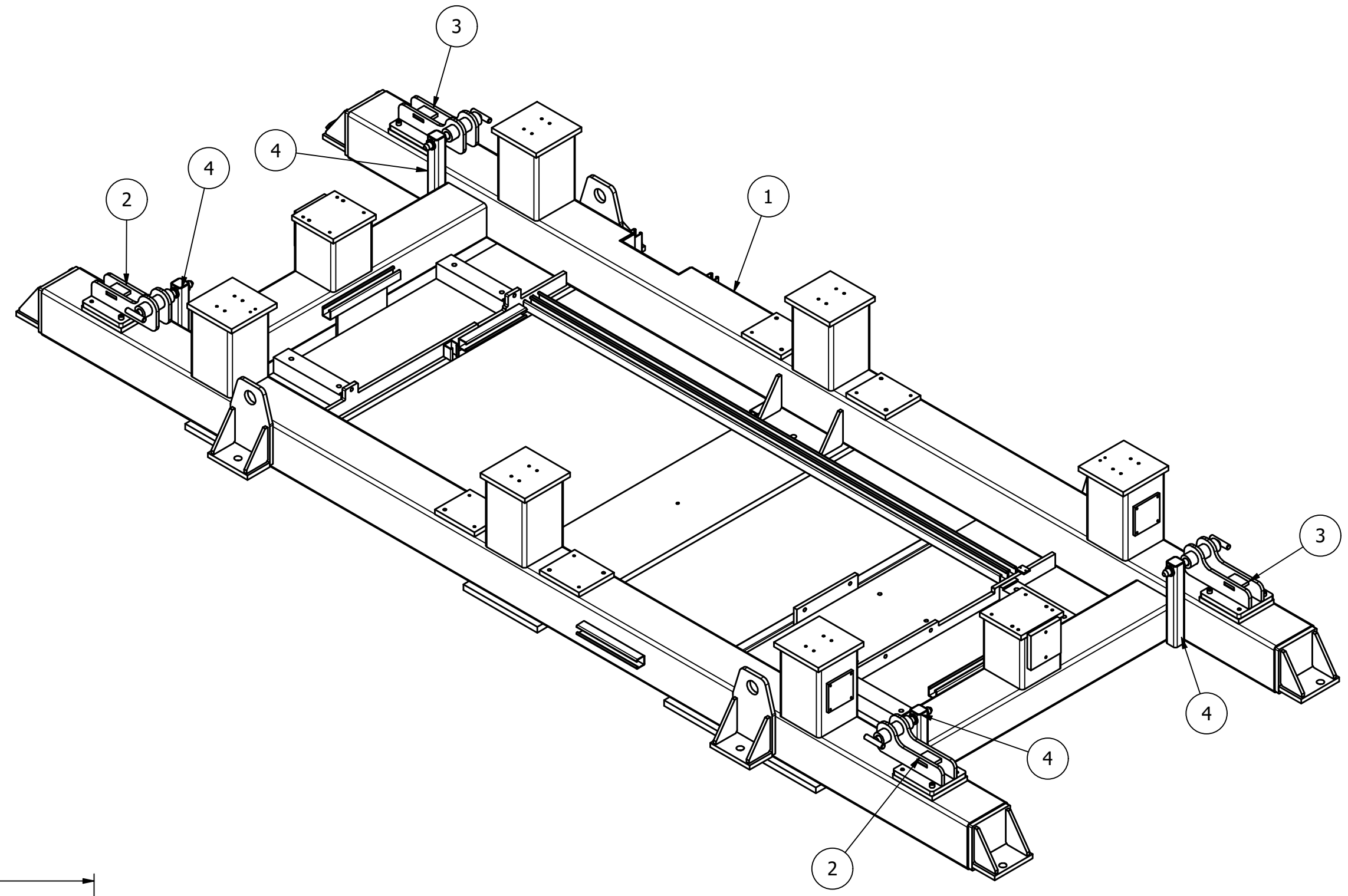
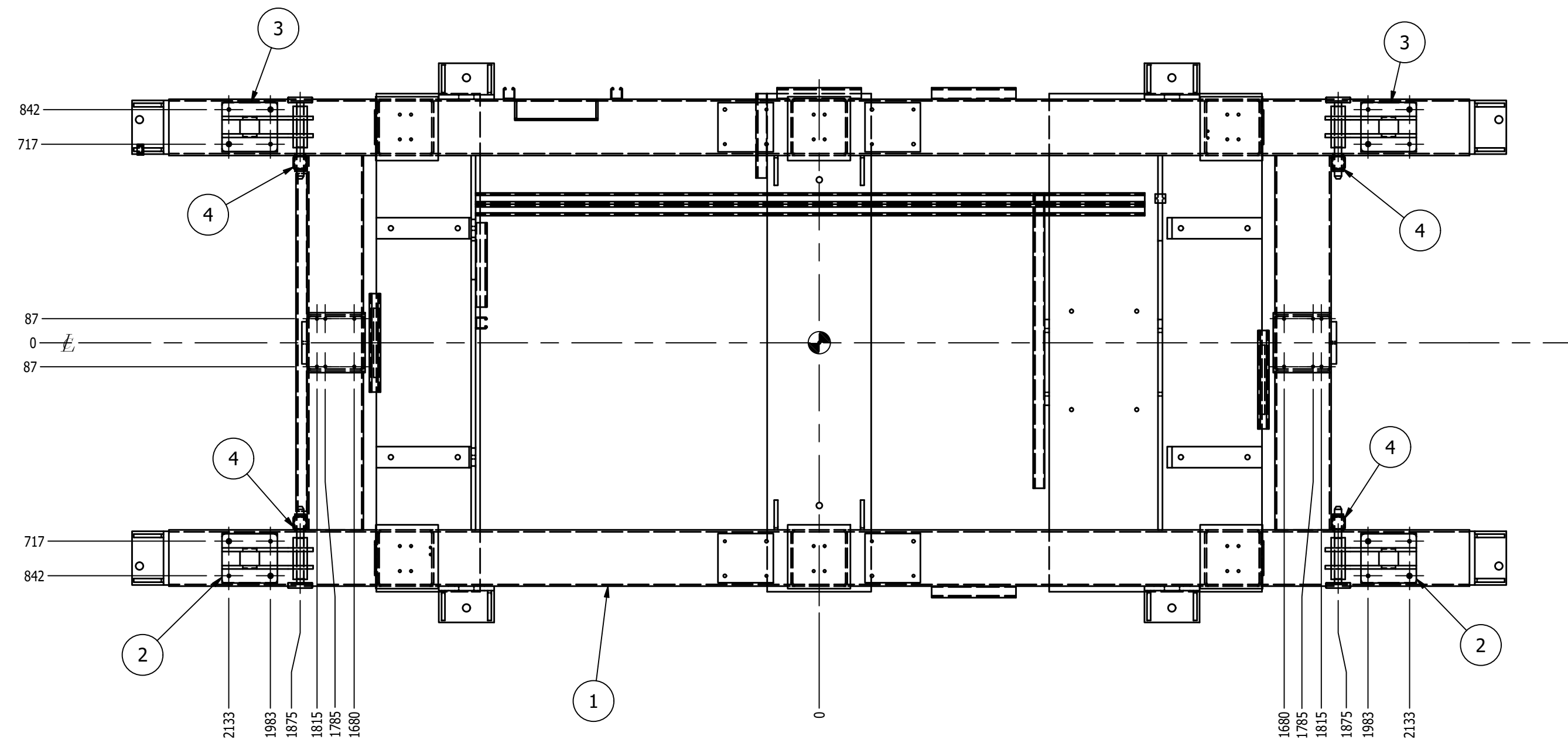
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

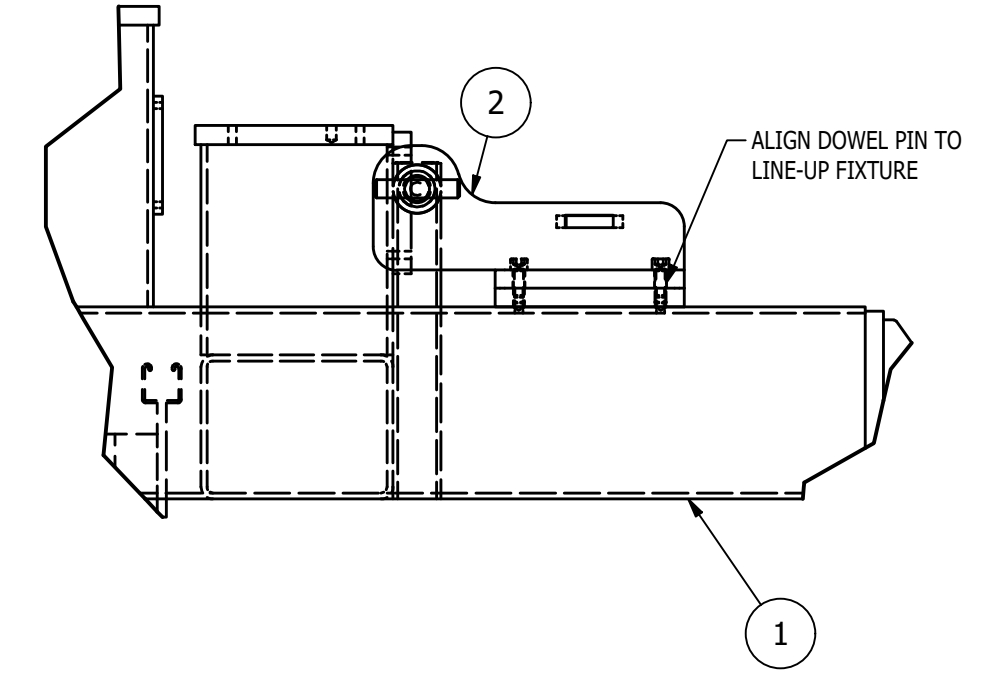
- ALL REINTRANT CUTS TO BE A MIN 1/2" RADIUS U.N.O.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D245A			
1	1	MK-D203A ~ LIFTER BASE MACHINING			
2	2	MK-D241A ~ SAFETY PIN WELDMENT LOCATOR ASSEMBLY			
3	2	MK-D241B ~ SAFETY PIN WELDMENT LOCATOR ASSEMBLY			
4	4	MK-D230A ~ SAFETY PIN WELDMENT			



MK-D245A ~ SAFETY PIN WELDMENT PLACEMENT
SCALE 3/4"=1'-0"

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



NOTE: USE ITEM '2' & '3' TO LOCATE MK-D230A. REMOVE AFTER WELDING 230A IN PLACE.

- 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:**
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	7/29/22	DELETED REF. ITEM NOTES, ADDED ITEM 4	
A	MC	7/5/22	FOR FABRICATION	

REVISION HISTORY				
B	MC	7/29/22	DELETED REF. ITEM NOTES, ADDED ITEM 4	
A	MC	7/5/22	FOR FABRICATION	

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FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millc.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D245	DWG DATE:	6/20/22
REV:	B	JOB No.:	22096

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- 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:

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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.