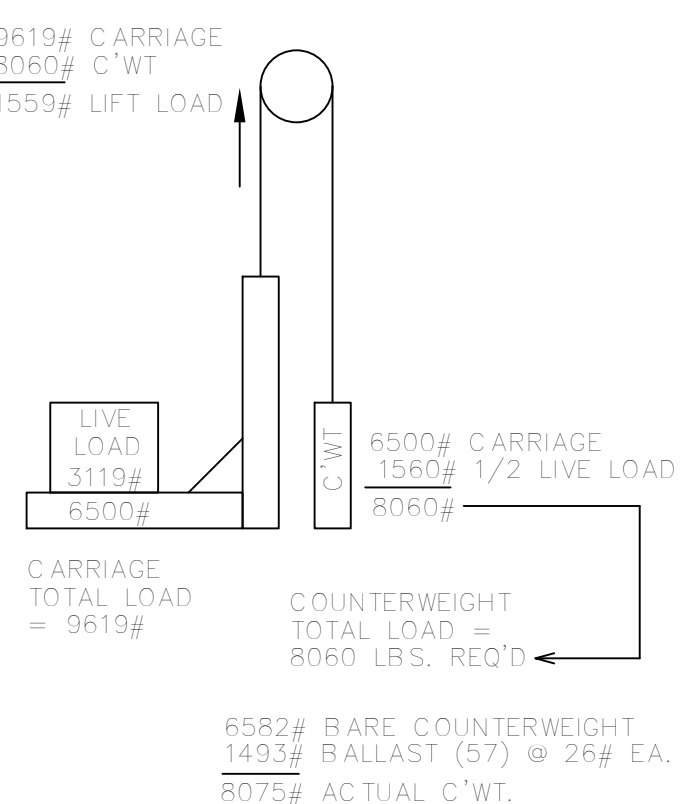


MK-D302A ~ VDL ASSEMBLY
SCALE 3/8"=1'-0"

WEIGHTS ARE SHOWN FOR REFERENCE ONLY

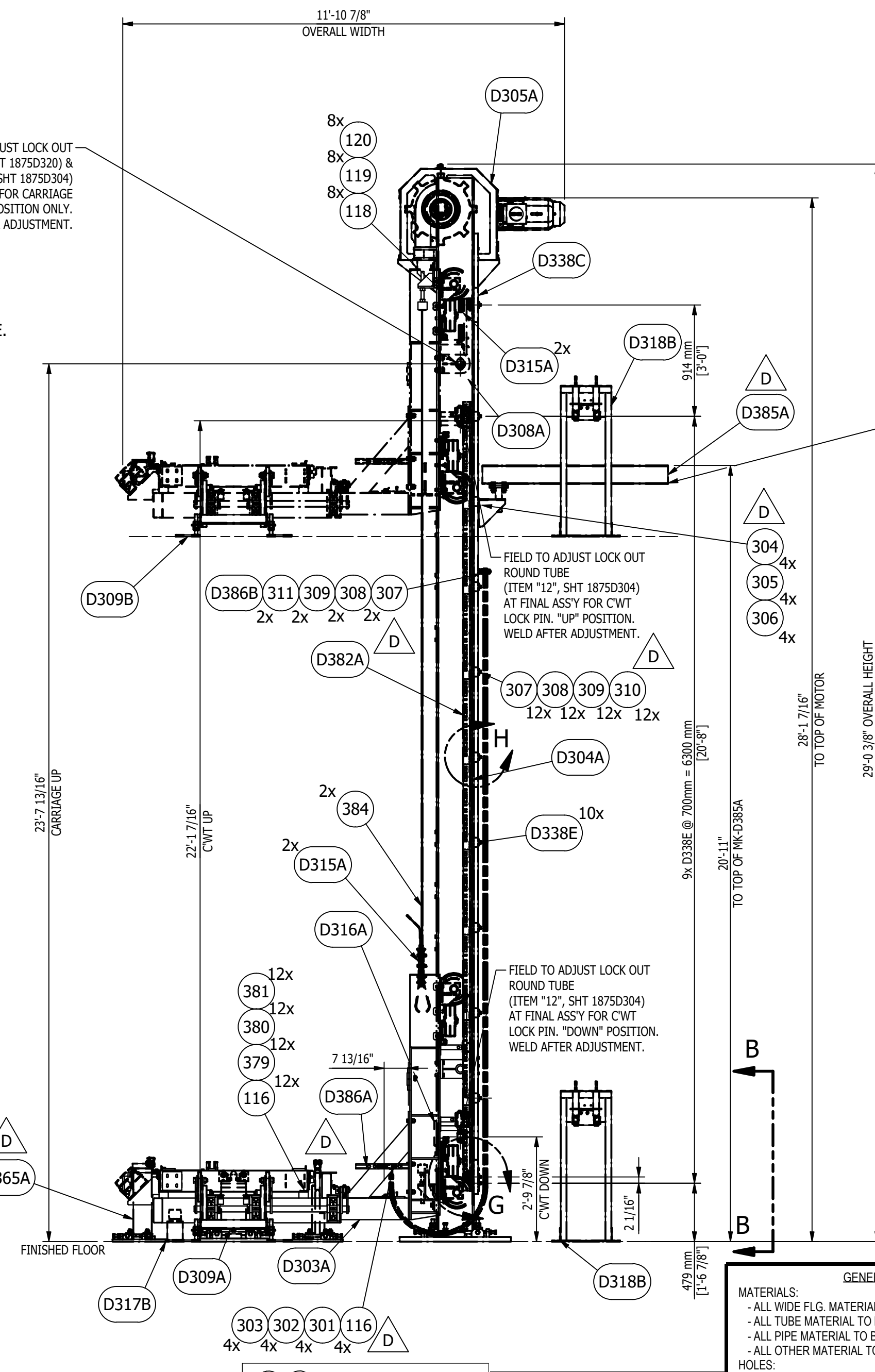
CALCULATIONS ARE SHOWN FOR REFERENCE ONLY



FIELD TO ADJUST LOCK OUT PLATE (MK-D322B, ITEM '3', SHT 1875D320) & ROUND TUBE (ITEM '12', SHT 1875D304) AT FINAL ASSY FOR CWT LOCK PIN. "UP" POSITION ONLY. WELD AFTER ADJUSTMENT.

FIELD TO LOCATE.

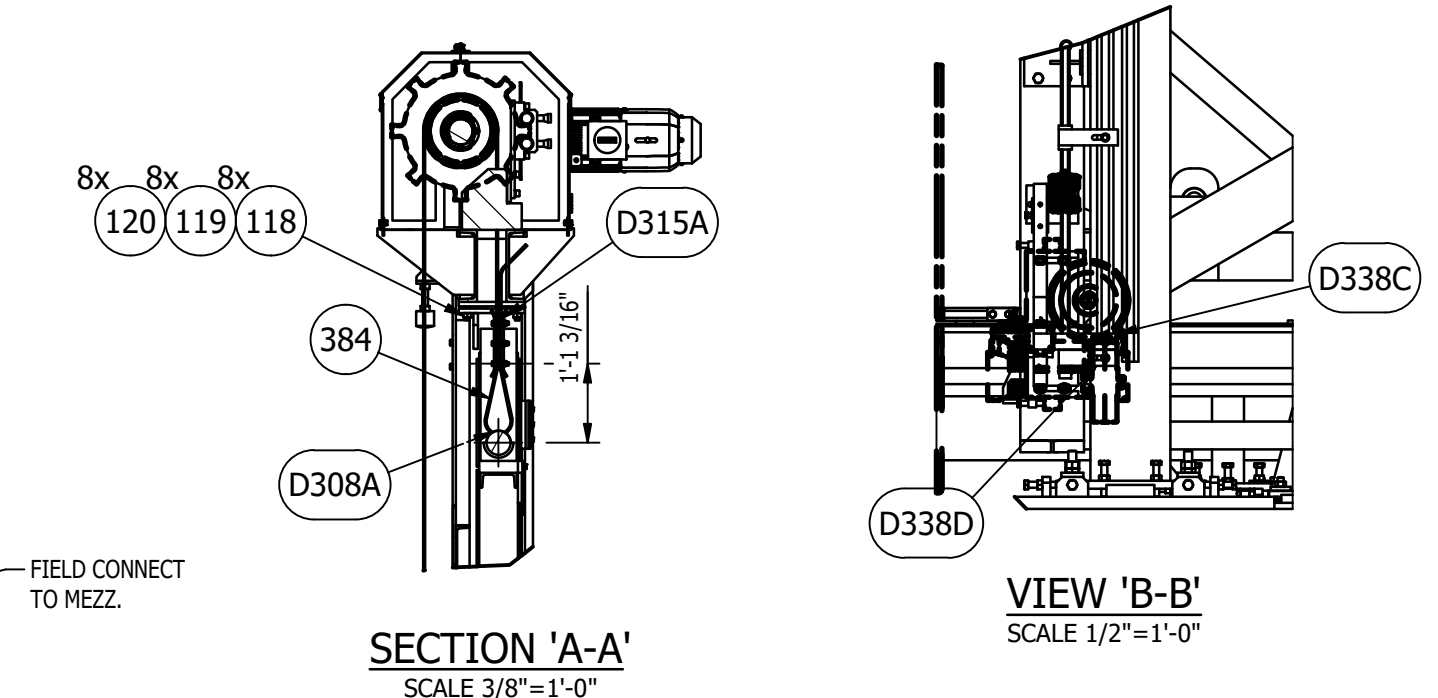
LOWER POSITION ONLY. FIELD WELD MK-D316A AT FINAL ASSEMBLY. FIELD TO LOCATE.



MAGNUM CONSULTING
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 Suite 125 Fax: (248) 777-8881
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MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D301 - 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



- 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.

SHEET 1 OF 3

REV	BY	DATE	DESCRIPTION	APP
D	MC	10/19/22	B.O.M. MOVED TO SHEET 2, ADDED SHEET 3, ADDED MK-D365A THRU D86B, ADDED ITEMS '301' THRU ITEM '315', ADDED SECTION 'F', ENLARGED VIEW 'G', ENLARGED VIEW 'H' & VIEW 'J-J', CALCULATIONS UPDATED	
C	MC	9/8/2022	CHANGED VIEW C, ADDED VIEW E	
B	MC	8/30/22	ADDED SHEET 2 TO SHOW ENLARGED VIEWS. ITEM '112' IS NOW ITEM 'D315A'. ADDED ITEM 'D365A'. ADDED ITEMS '118', '119', & '120', UPDATED NUMBERS OF ITEMS '281' THRU '284'	
A	MC	8/23/2022	FOR FABRICATION	

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 FENTON, MI 48430
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 www.millc.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D301

REV: D

JOB No. 22096

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 CHECKED BY: JCK
 DWG DATE: 8/23/22

GENERAL NOTES:

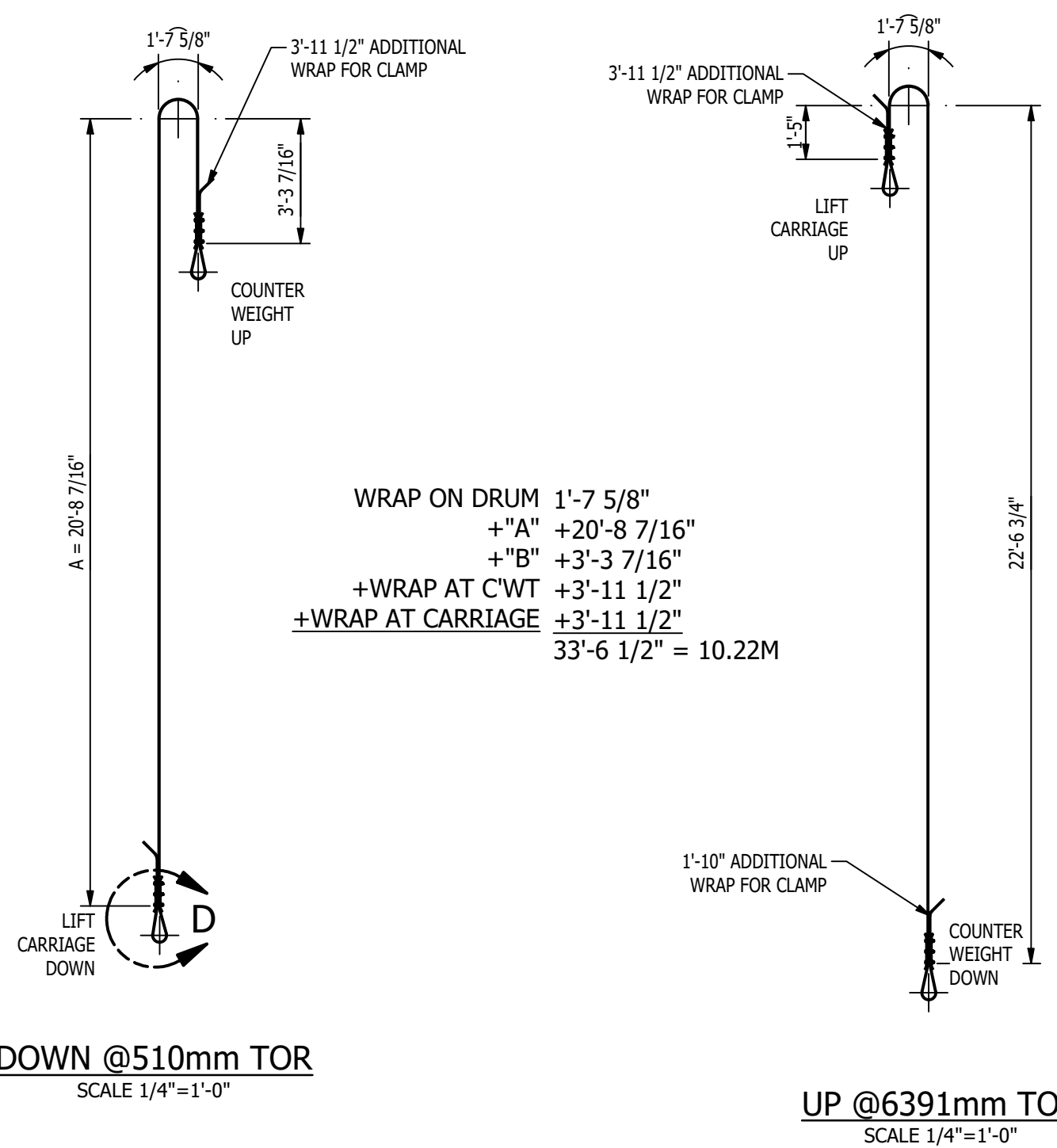
MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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

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

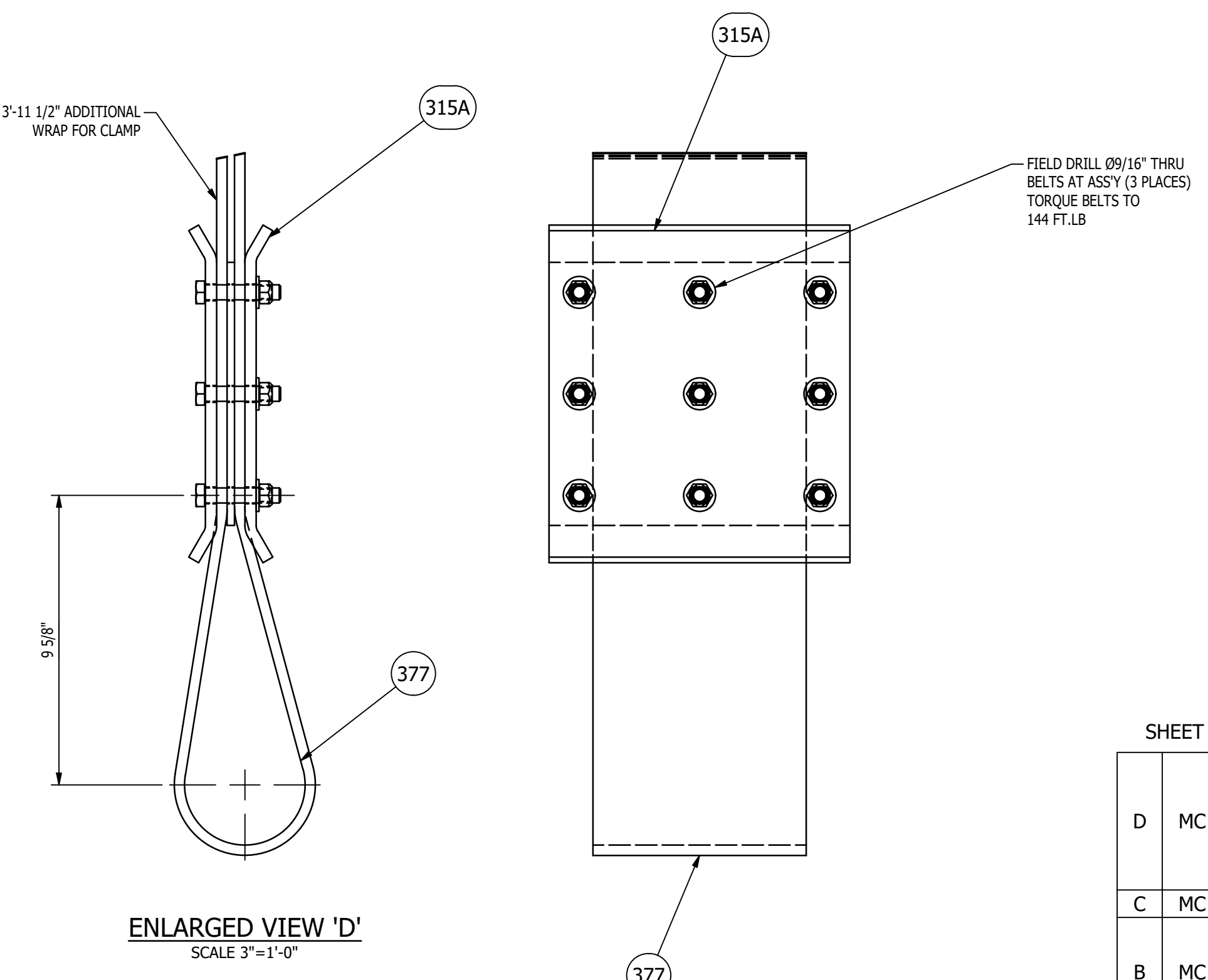
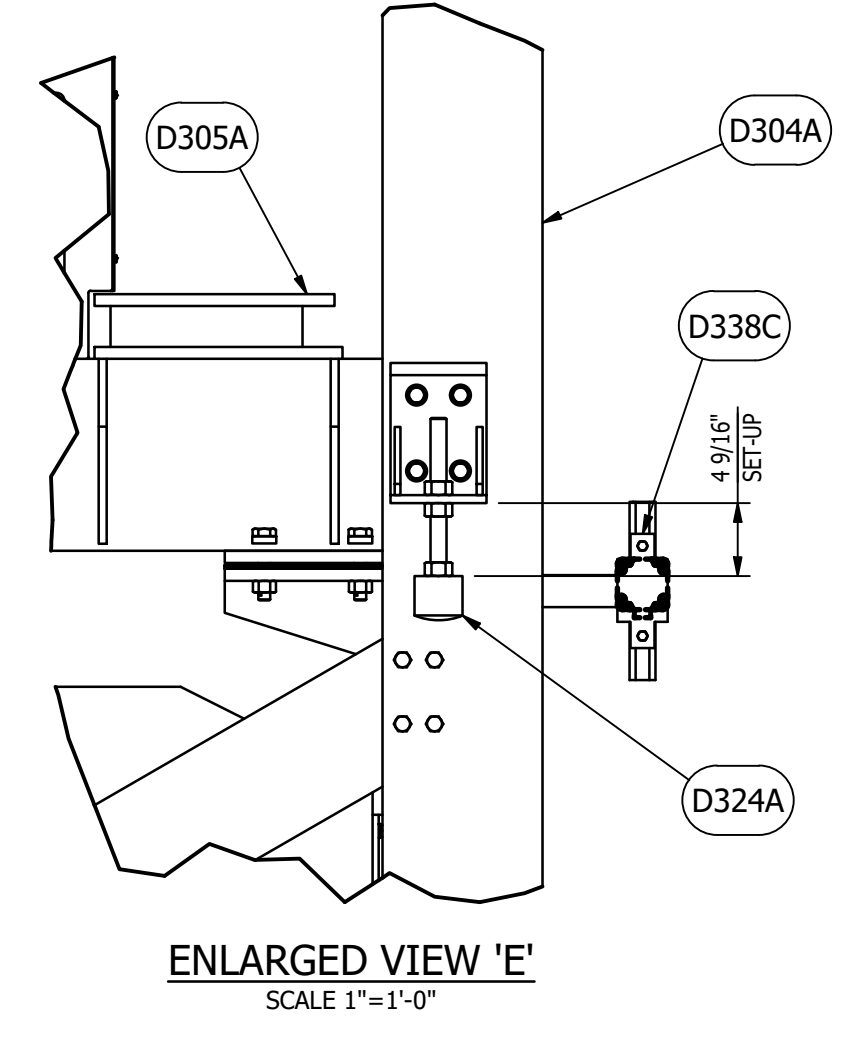
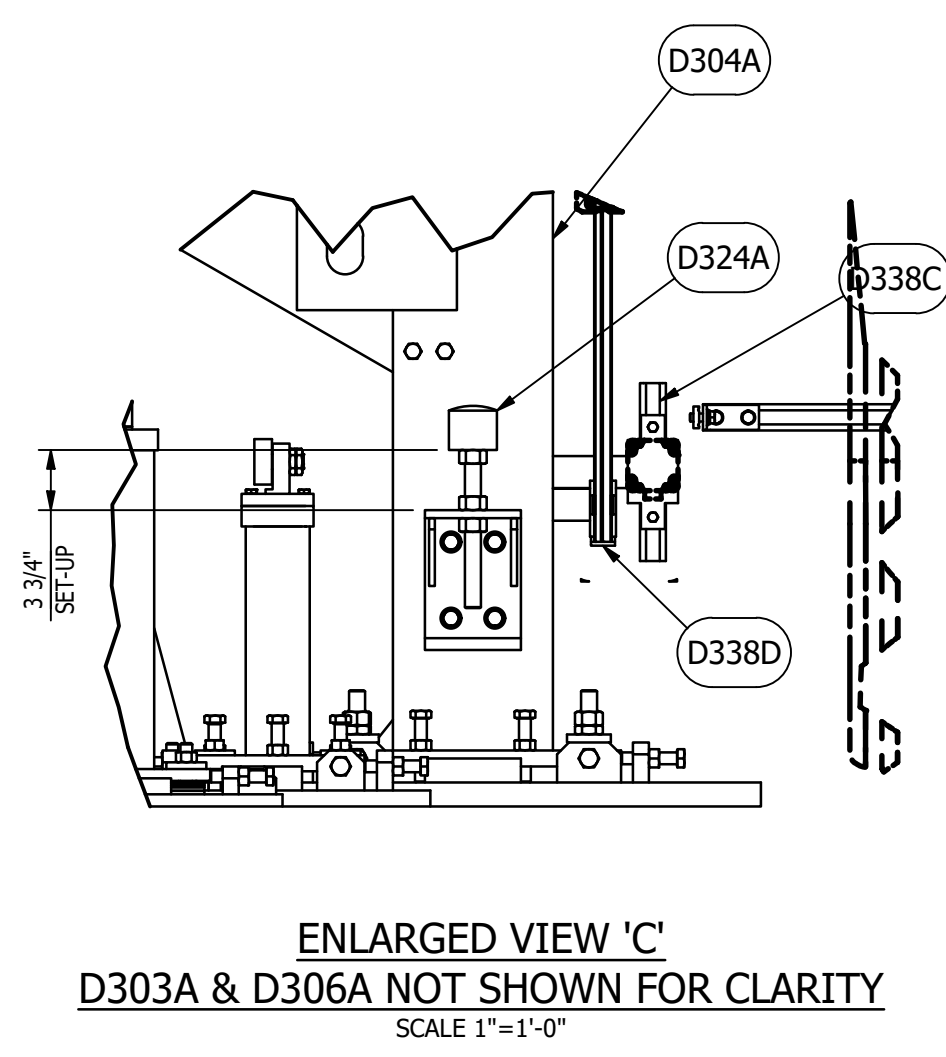
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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



MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D301A			
D303A	1	MK-D303A ~ VDL CARRIAGE ASSEMBLY			
D304A	1	MK-D304A ~ VDL COLUMN ASSEMBLY			
D305A	1	MK-D305A ~ VDL DRIVE ASSEMBLY			
D306A	1	MK-D220A ~ D-LOC PRB6 ASSEMBLY			
D308A	1	MK-D308A ~ VDL COUNTERWEIGHT ASSEMBLY			
D309A	2	MK-D309A ~ CARRIAGE POSITIONER ASM - FLOOR			
D309B	2	MK-D309B ~ CARRIAGE POSITIONER ASM - MEZZANINE			
D315A	4	MK-D315A ~ BELT CLAMP ASSEMBLY			
D316A	2	MK-D316A ~ CARRIAGE RETAINER PLATE			
D317B	2	MK-D317B ~ PALLET BUMPER STOP			
D318B	2	MK-D318B ~ LOCK-OUT PIN STAND ASSEMBLY			
D324A	4	MK-D324A ~ CARRIAGE BUMPER STOP			
D324D	10	MK-D324D ~ SPACER			
D328B	4	MK-D328B ~ MAST SHIM PACK			
D338C	2	MK-D338C ~ PROX MOUNT			
D338D	1	MK-D338D ~ RAIL BOTTOM STOP			
D338E	9	MK-D338E ~ PROFILE RAIL MOUNT			
D365A	1	MK-D365A ~ VDL D-LOC ASSEMBLY			
D382A	1	MK-D382A ~ PEPPERL-FUCHS CODE RAIL ASSEMBLY			
D385A	2	MK-D385A ~ LIFT GUIDE			
D386A	1	MK-D386A ~ LOWER CABLE SUPPORT			
D386B	1	MK-D386B ~ UPPER CABLE SUPPORT			

MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
116	16	1/2 SPRING LOCK WASHER			
118	8	3/4 HARDENED BEVEL WASHER			
119	8	3/4-10UNC x 4\"/>			



SHEET 2 OF 3

REV	BY	DATE	DESCRIPTION	APP
D	MC	10/19/22	B.O.M. MOVED TO SHEET 2, ADDED SHEET 3, ADDED MK-D365A THRU D86B, ADDED ITEMS '301' THRU ITEM '315', ADDED SECTION 'F', ENLARGED VIEW 'G', ENLARGED VIEW 'H' & VIEW 'J-J', CALCULATIONS UPDATED	
C	MC	9/8/2022	CHANGED VIEW C, ADDED VIEW E	
B	MC	8/30/22	ADDED SHEET 2 TO SHOW ENLARGED VIEWS. ITEM '112' IS NOW ITEM 'D315A'. ADDED ITEM 'D365A'. ADDED ITEMS '118', '119', & '120', UPDATED NUMBERS OF ITEMS '281' THRU '284'	
A	MC	8/23/2022	FOR FABRICATION	

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

MAGNUM Consulting
 41700 Gardenbrook Rd.
 Suite 102
 Novi, MI 48235
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 Fax: (248) 773-8051
 Web: www.millegnum.com
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 MAGNUM DRAWING #: 1875D301 - REV D

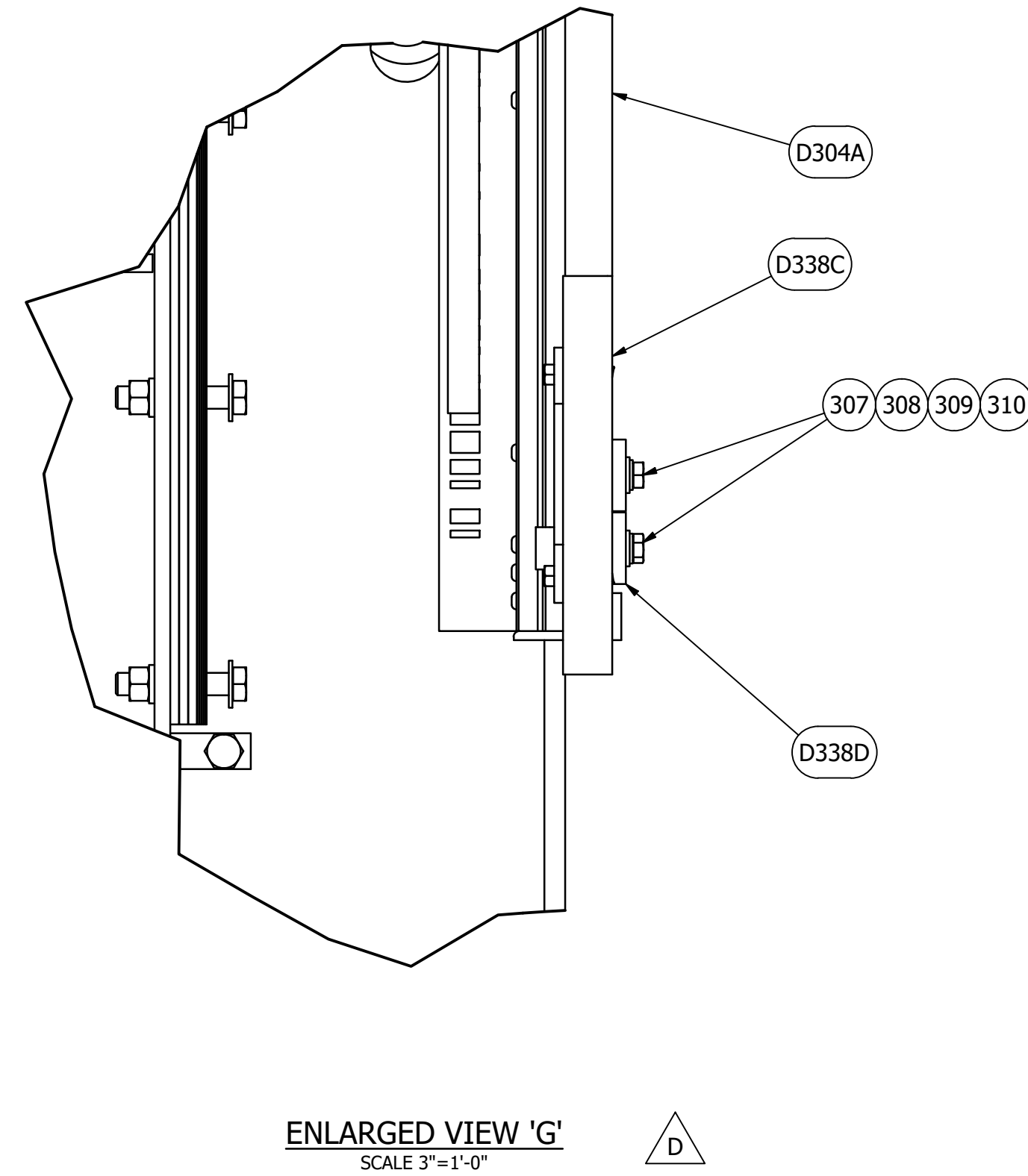
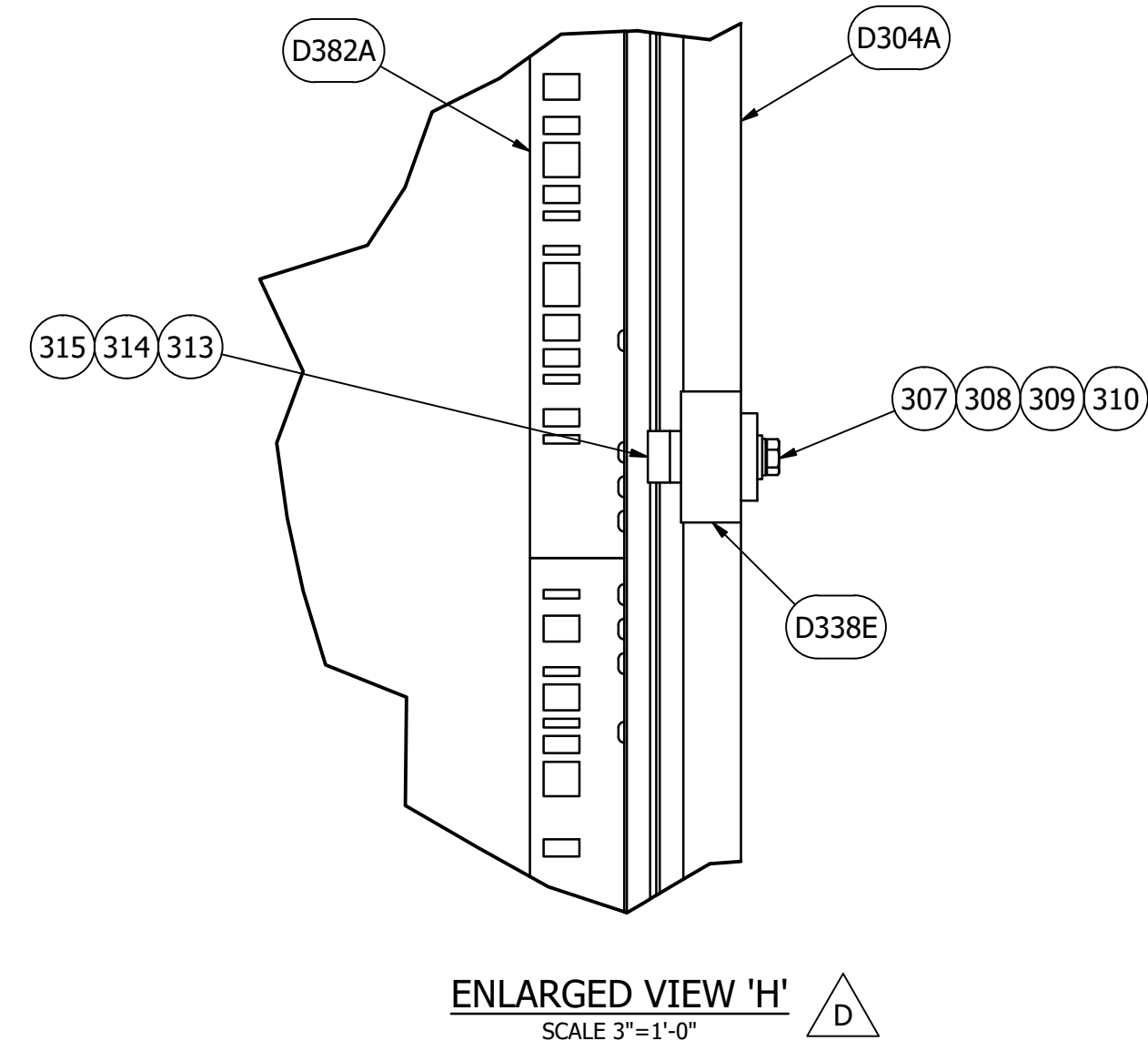
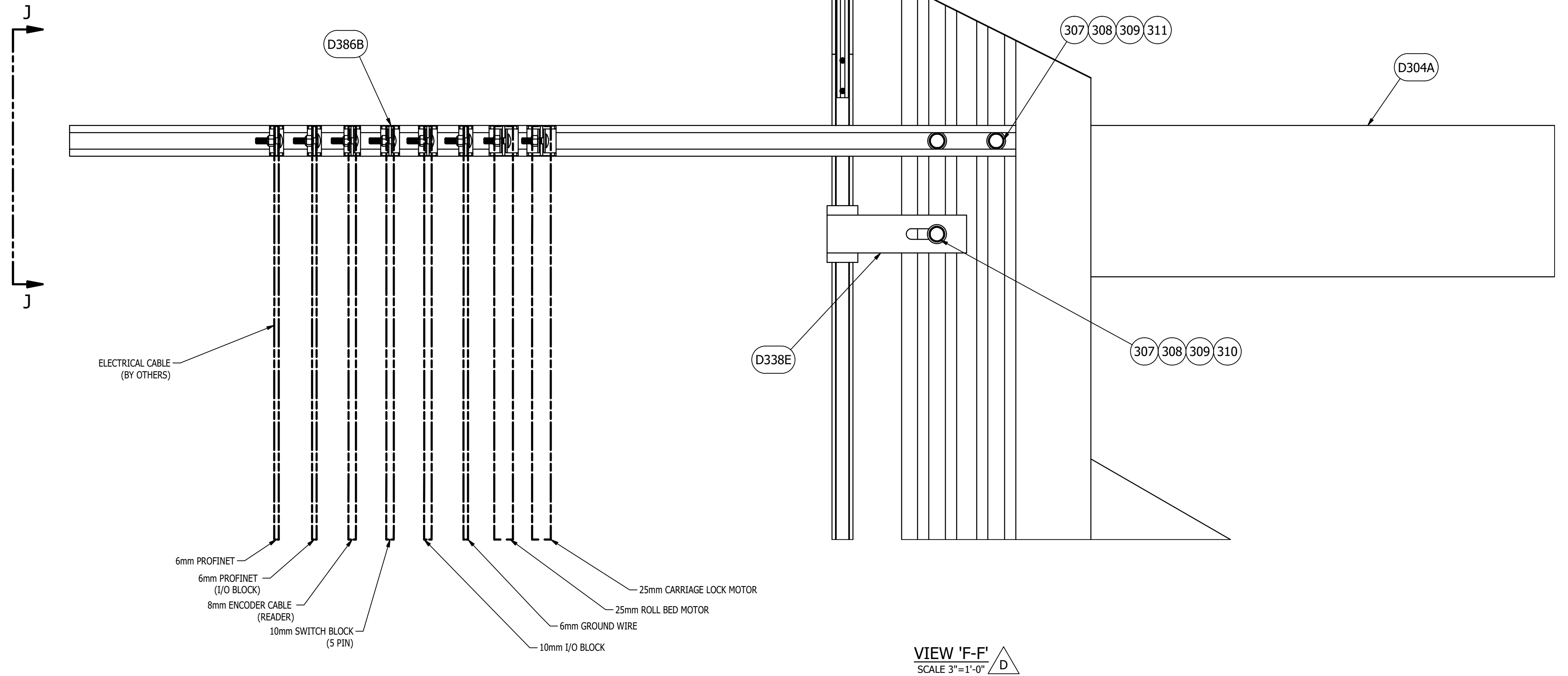
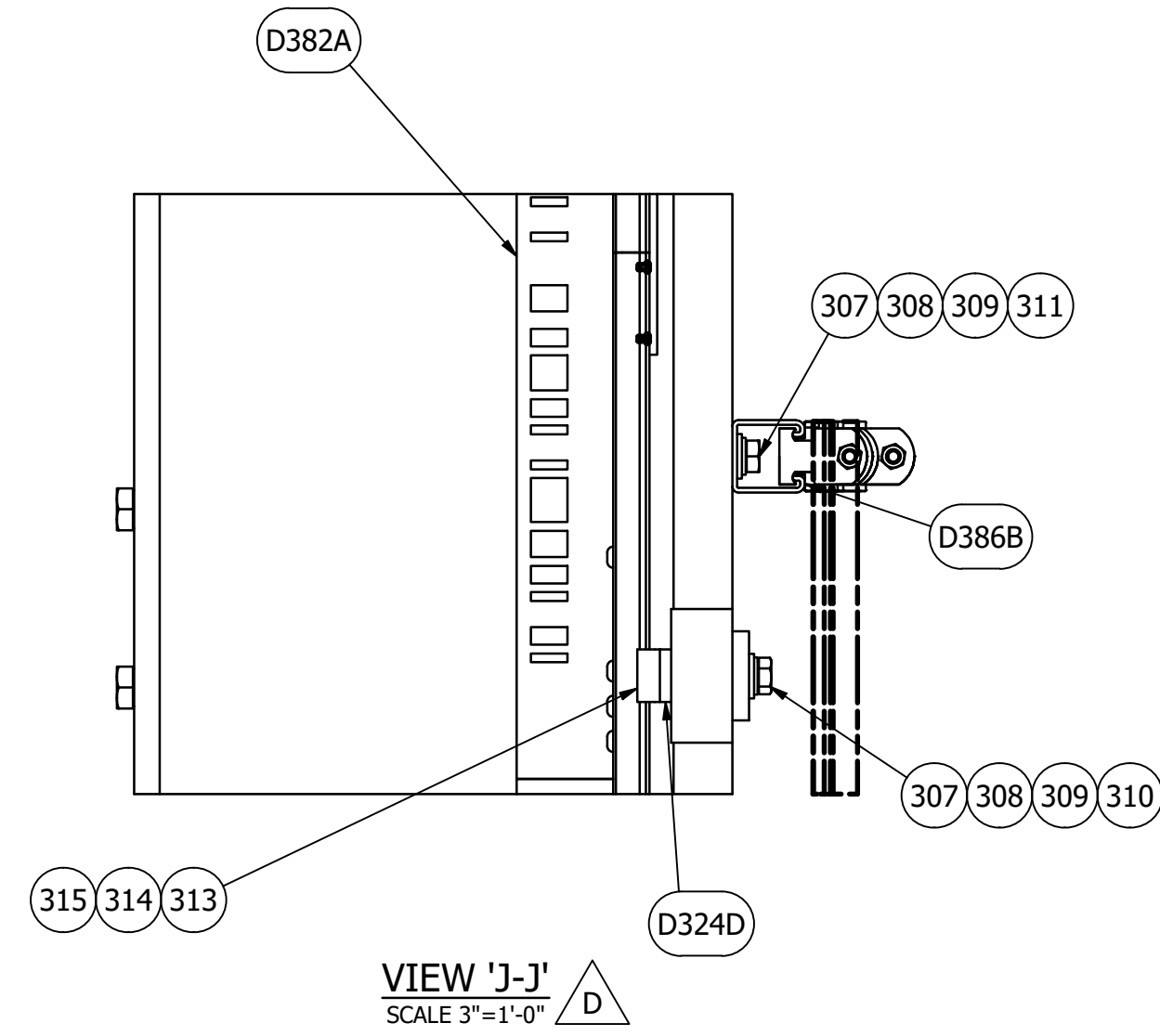
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 www.millicom.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D301

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 REV: D
 JOB No: 22096



SHEET 3 OF 3

REV	BY	DATE	DESCRIPTION	APP
D	MC	10/19/22	B.O.M. MOVED TO SHEET 2, ADDED SHEET 3, ADDED MK-D365A THRU D86B, ADDED ITEMS '301' THRU ITEM '315', ADDED SECTION 'F', ENLARGED VIEW 'G', ENLARGED VIEW 'H' & VIEW 'J-J', CALCULATIONS UPDATED	
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A	MC	8/23/2022	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 REINFRANT CUTS TO BE A MIN 1/2" RADIUS U.N.O.

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FENTON, MI 48430
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TITLE: P6700 CONVEYORS
CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D301

REV: D

JOB No: 22096

DRAWN BY: JC
CHECKED BY: JCK
DWG DATE: 8/23/22

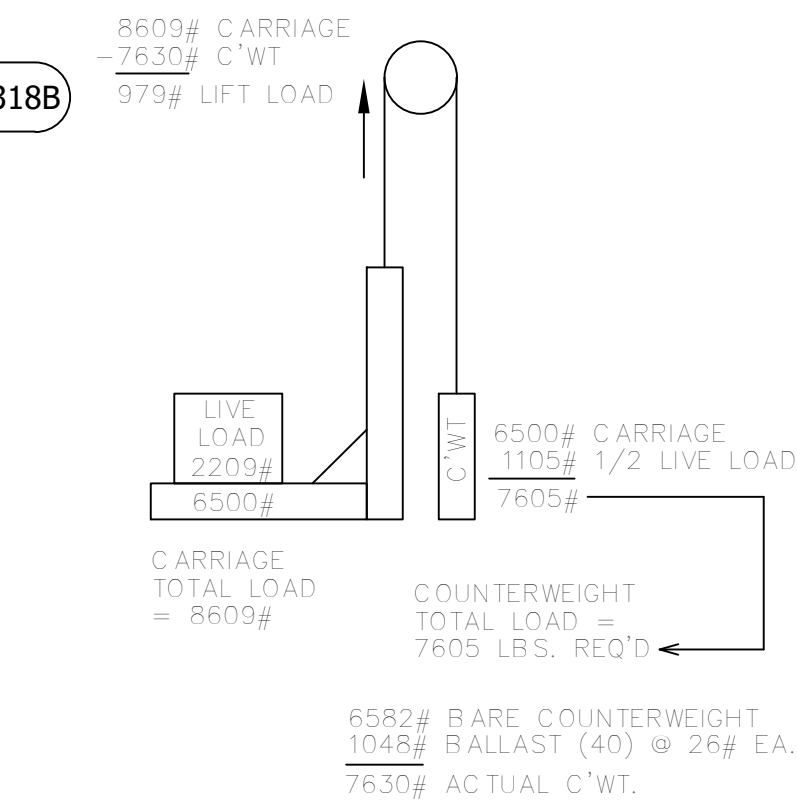
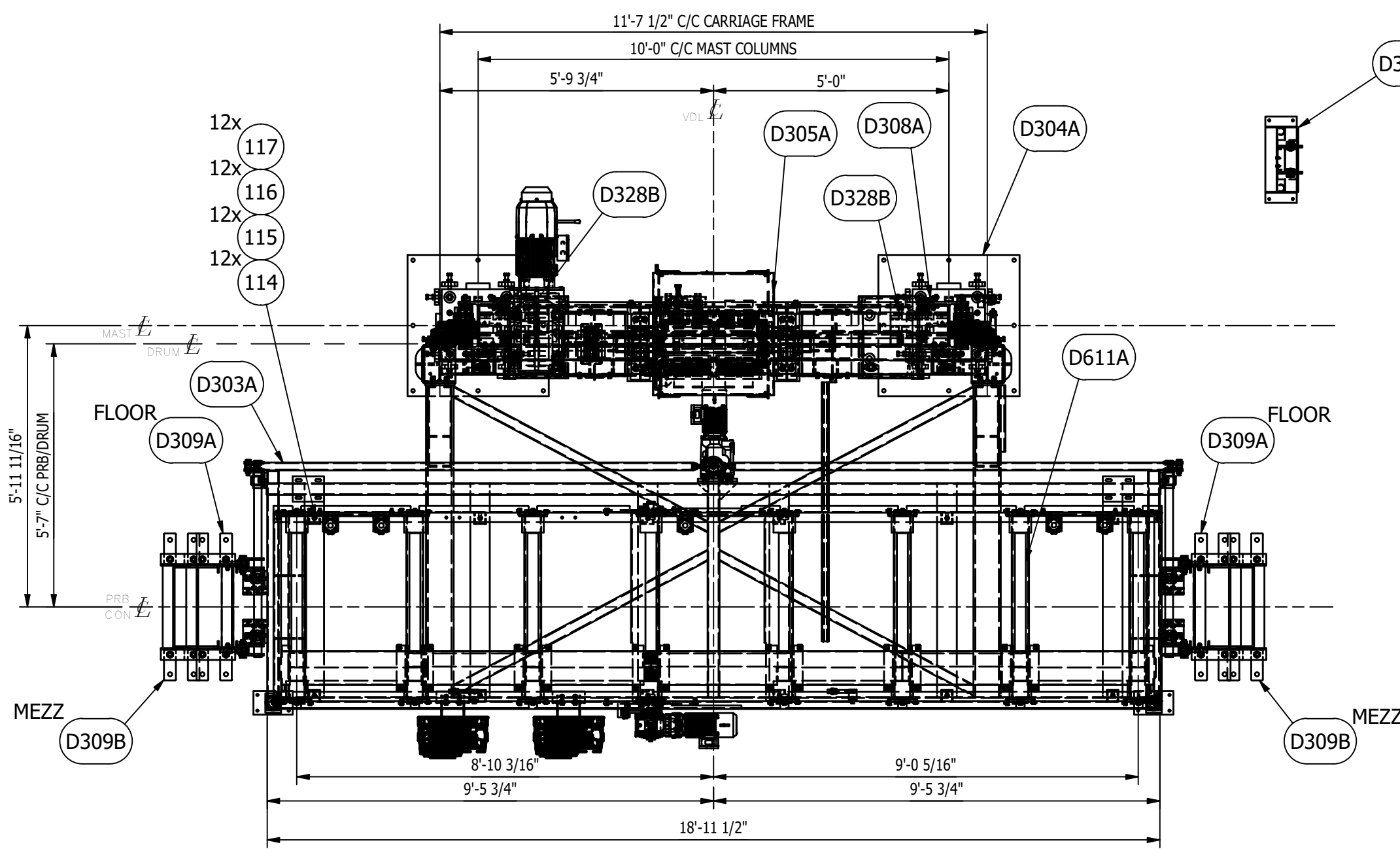
MAGNUM Consulting

4170 Southbrook Rd.
Suite 125
West, MI 48375

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

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MAGNUM DRAWING #: 1875D301 - REV D

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DEBURR ALL HOLES
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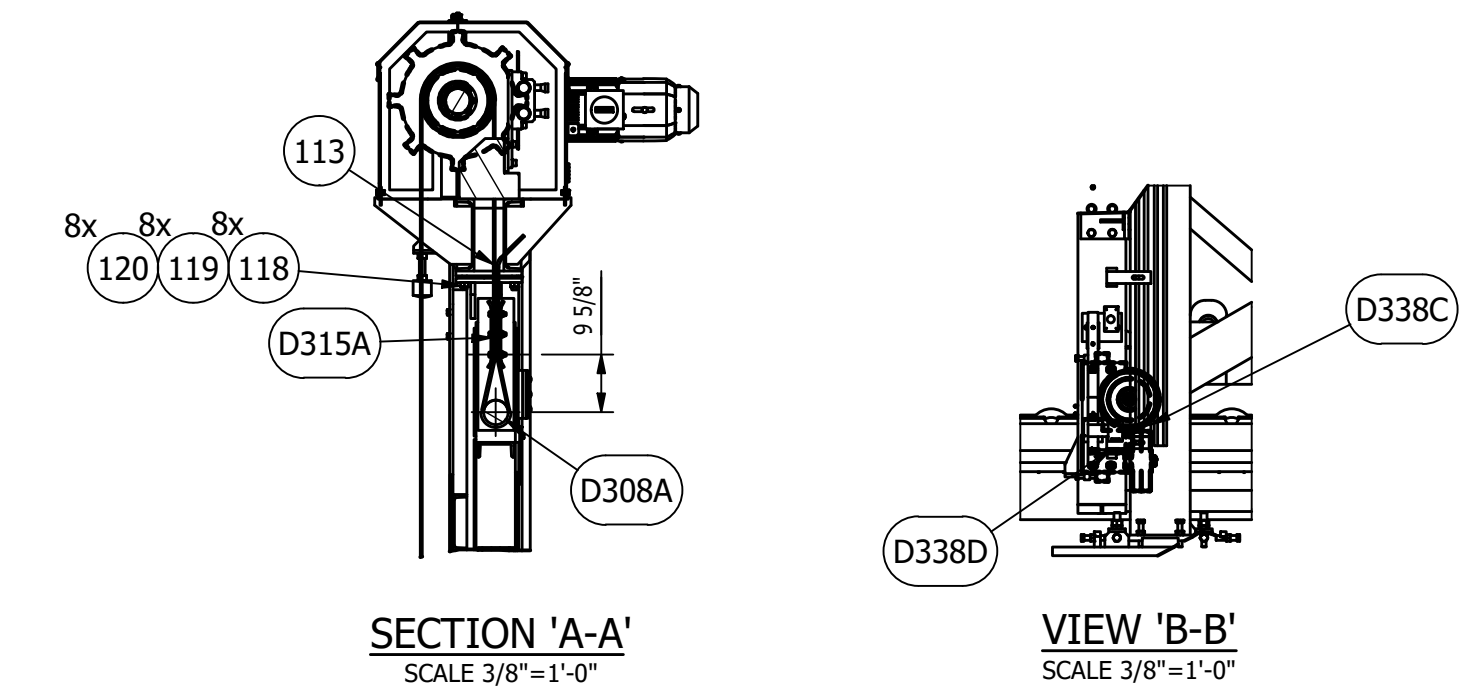
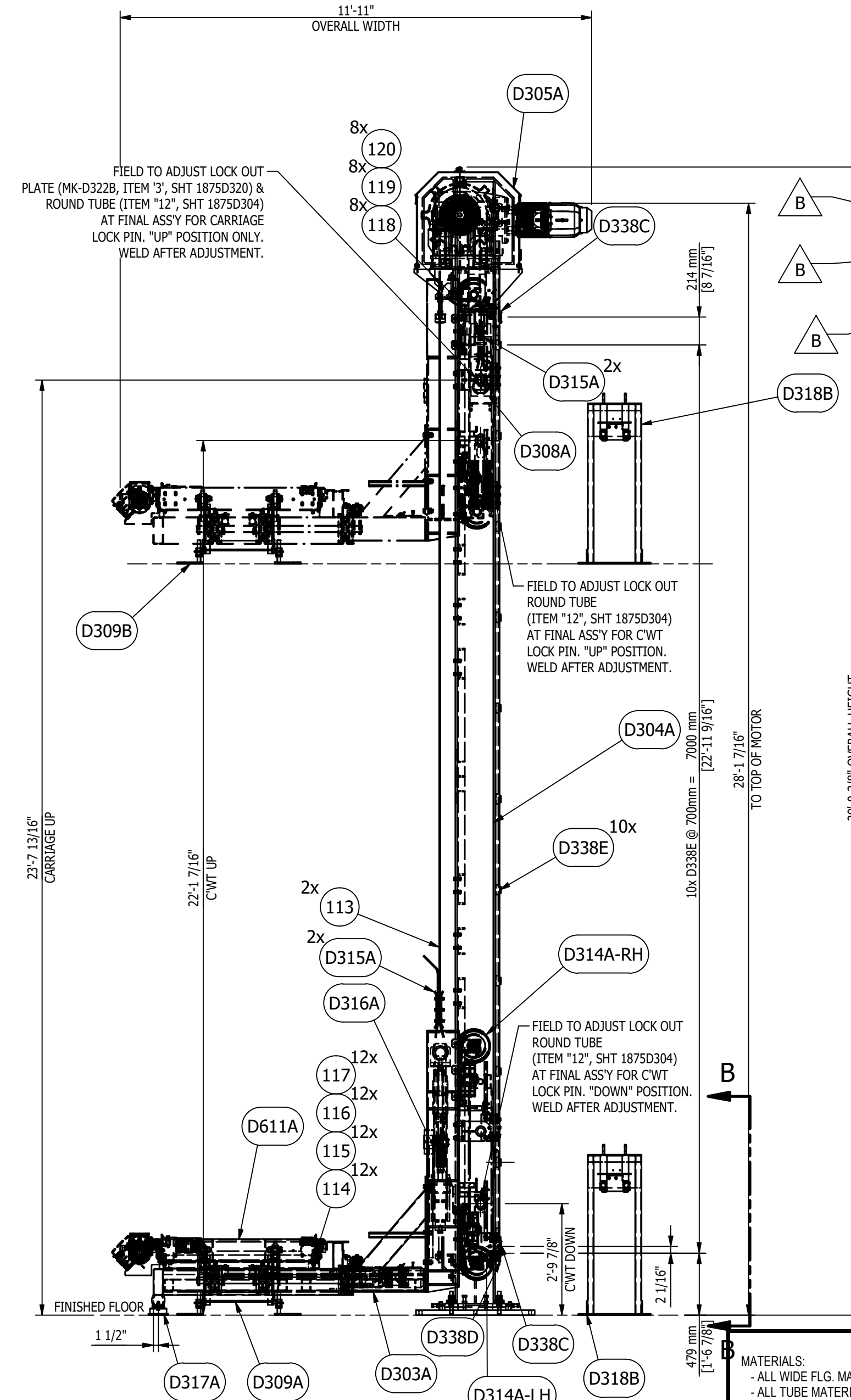
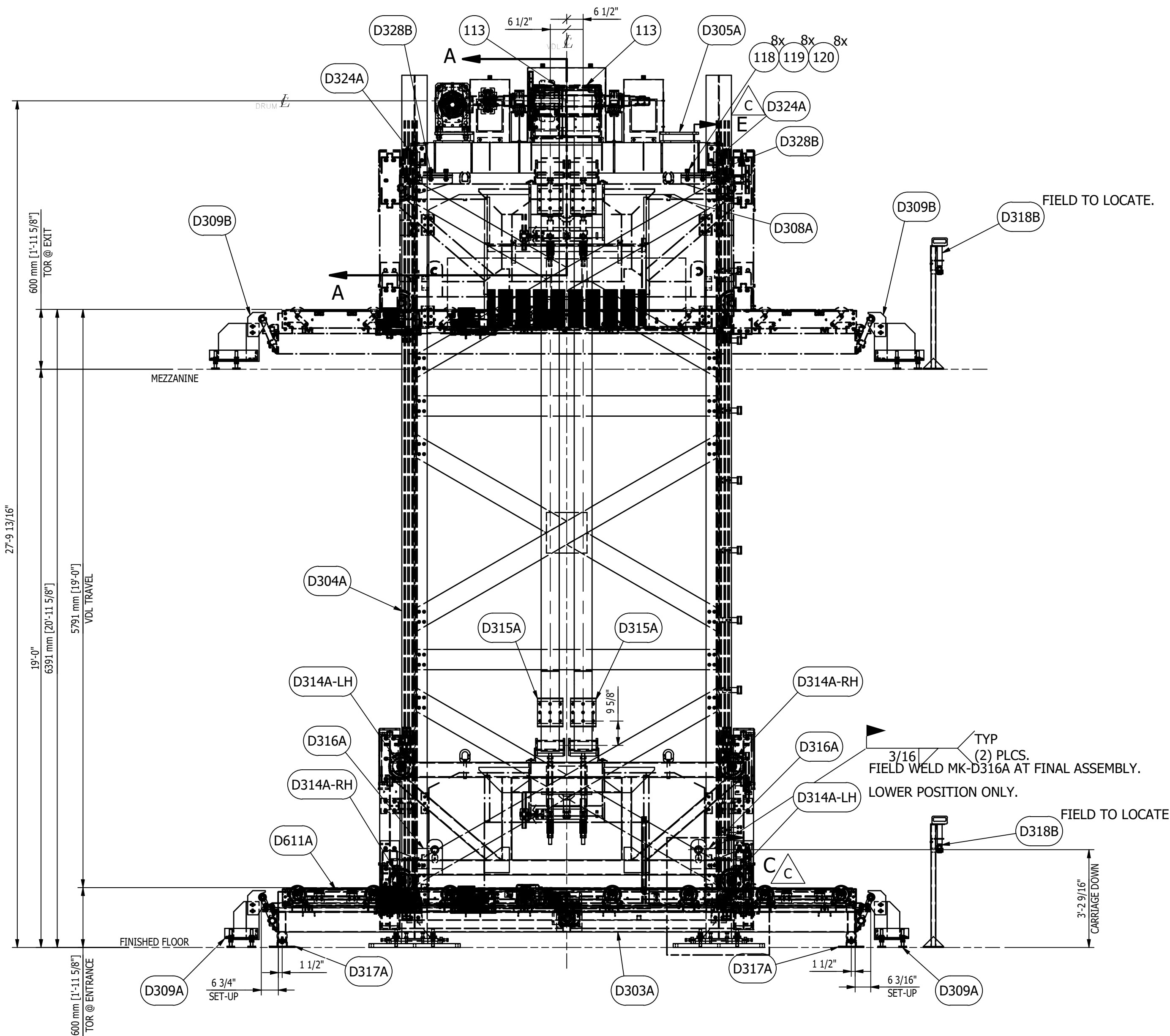
TECHNICAL DATA		LOADED SKID
LIVE LOAD	2209#	
COUNTERWEIGHT REQ'D	7605#	
TRAVEL	19'-0"	
MOTOR CAPACITY	10 HP	
MOTOR R.P.M.	29.67 RPM	
CARRIAGE SPEED	90 FPM	

LIFT SPEED FORMULA
 $29.67 \text{ RPM} \times \frac{\pi \times (11.81" \text{ DIA.})}{12} \times \frac{58.9 \text{ Hz}}{60.0 \text{ Hz}} = 90 \text{ F.P.M.}$

WEIGHTS ARE SHOWN FOR REFERENCE ONLY

CALCULATIONS ARE SHOWN FOR REFERENCE ONLY

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D302A			
D303A	1	MK-D303A ~ VDL CARRIAGE ASSEMBLY			
D304A	1	MK-D304A ~ VDL COLUMN ASSEMBLY			
D305A	1	MK-D305A ~ VDL DRIVE ASSEMBLY			
D308A	1	MK-D308A ~ VDL COUNTERWEIGHT ASSEMBLY			
D309A	2	MK-D309A ~ CARRIAGE POSITIONER ASM - FLOOR			
D309B	2	MK-D309B ~ CARRIAGE POSITIONER ASM - MEZZANINE			
D314A-RH	2	MK-D314A-RH ~ CARRIAGE GUIDE WHEEL ASSEMBLY			
D314A-LH	2	MK-D314A-LH ~ CARRIAGE GUIDE WHEEL ASSEMBLY			
D315A	4	MK-D315A ~ BELT CLAMP ASSEMBLY			
D316A	2	MK-D316A ~ CARRIAGE RETAINER PLATE			
D317A	2	MK-D317A ~ PALLET BUMPER STOP			
D318B	2	MK-D318B ~ LOCK-OUT PIN STAND ASSEMBLY			
D324A	4	MK-D324A ~ CARRIAGE BUMPER STOP			
D328B	4	MK-D328B ~ MAST SHIM PACK			
D338C	2	MK-D338C ~ PROX MOUNT			
D338D	1	MK-D338D ~ RAIL BOTTOM STOP			
D338E	10	MK-D338E ~ PROFILE RAIL MOUNT			
D611A	1	MK-D611A ~ 8-ROLL VDL ROLL BED			
113	2	LIFTING BELT, 180mm WIDE, 10.25 METERS LONG, 8.75mm THICK, CONTITECH PART NO. 5125 SX-33CE-GIK		7-5	
114	12	1/2-13UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
115	12	1/2 TYPE A NARROW FLAT WASHER			
116	12	1/2 SPRING LOCK WASHER			
117	12	1/2-13UNC HEX NUT			
118	8	3/4 HARDENED BEVEL WASHER			
119	8	3/4-10UNC x 4" LG. A325 HEX HEAD BOLT			
120	8	3/4-10UNC ANCO LOCK NUT A194 GR. 2H			
		TOTAL WEIGHT ~ 24640 LBS.			



- SHOP NOTES:**
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 - ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
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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.

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/8/2022	CHANGED VIEW C, ADDED VIEW E	
B	MC	8/30/22	ADDED SHEET 2 TO SHOW ENLARGED VIEWS. ITEM '112' IS NOW 'D315A'. ADDED ITEMS '118', '119', '120'	
A	MC	8/23/2022	FOR FABRICATION	

SHEET 1 OF 2

MK-D302A ~ VDL ASSEMBLY
SCALE 3/8"=1'-0"

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 West, MI 48375
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 Fax: (248) 773-8851
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 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D302

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

GENERAL NOTES:

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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.
- 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:

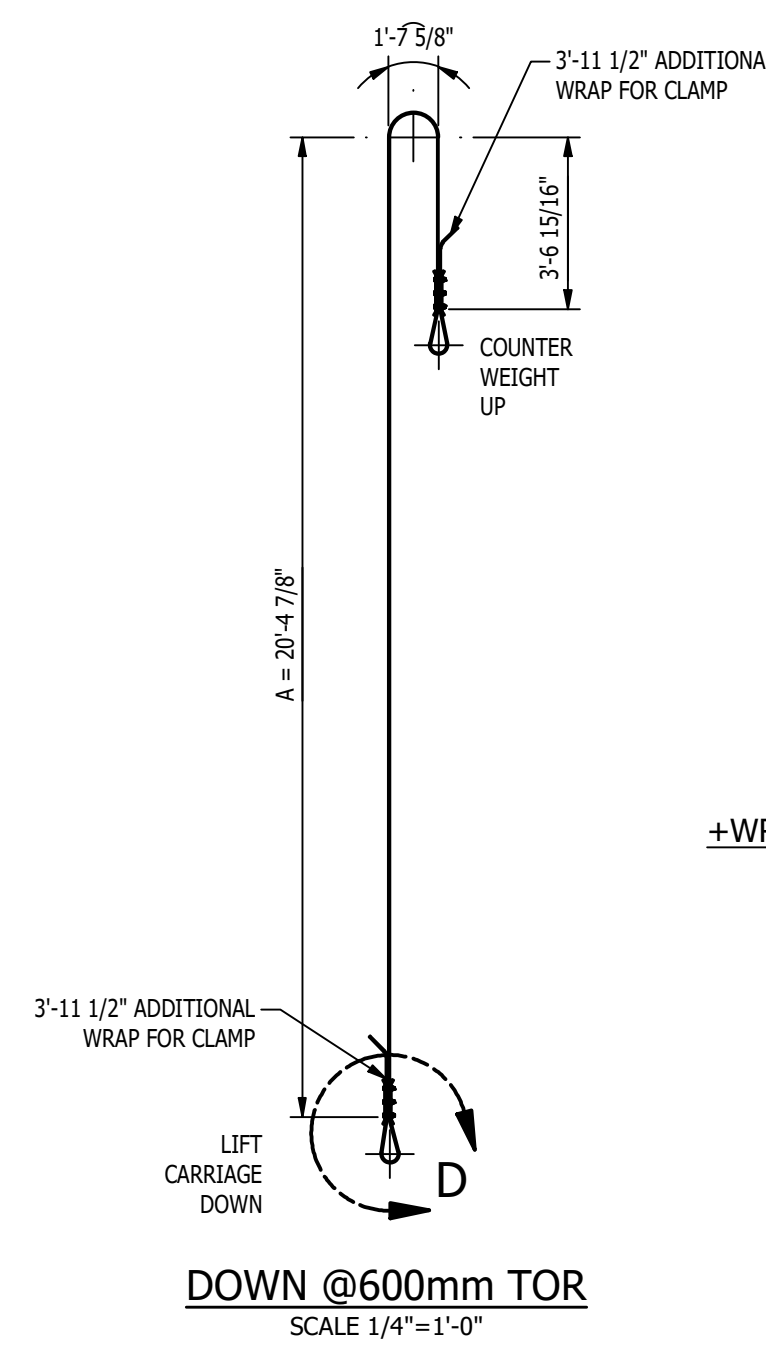
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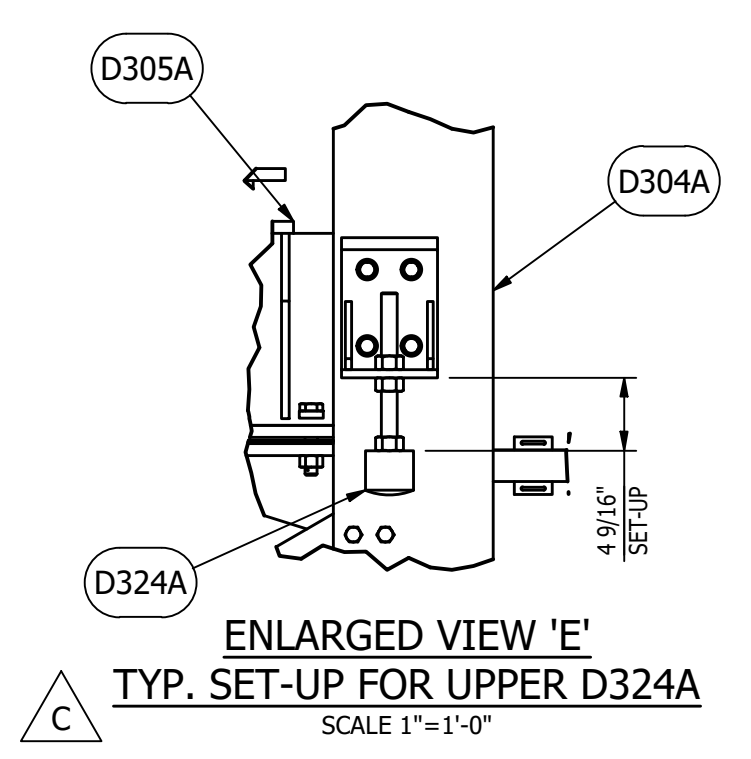
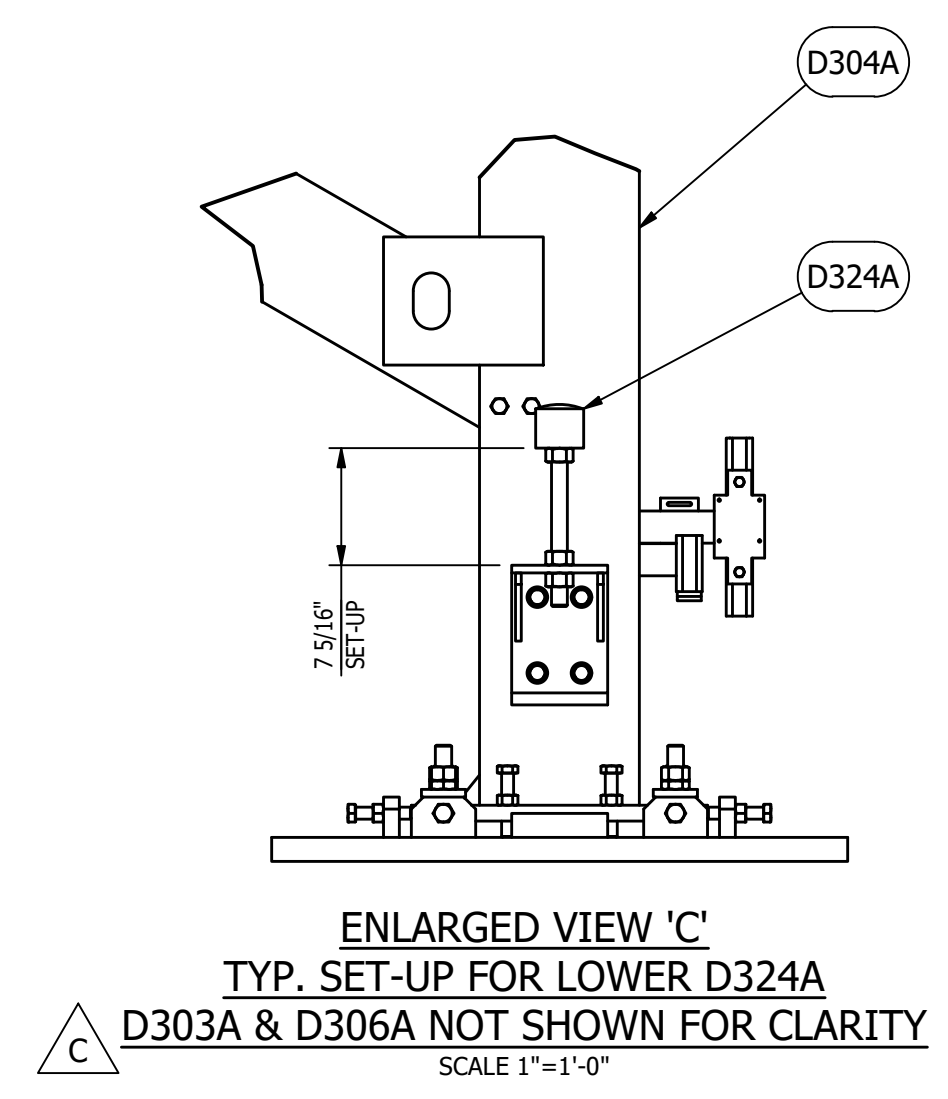
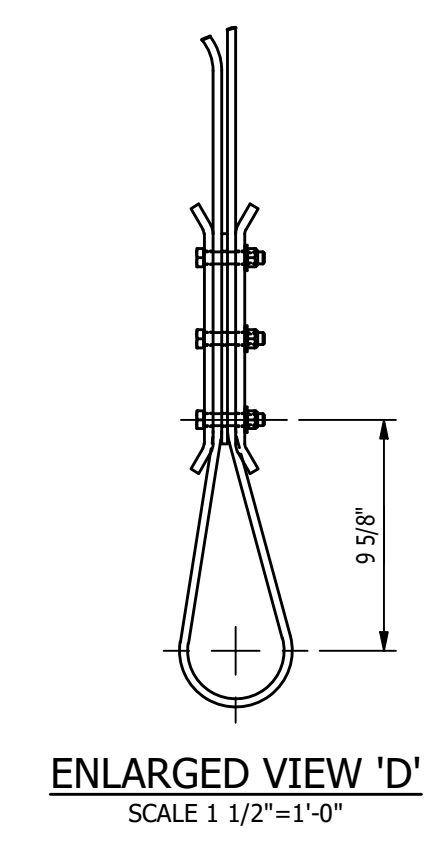
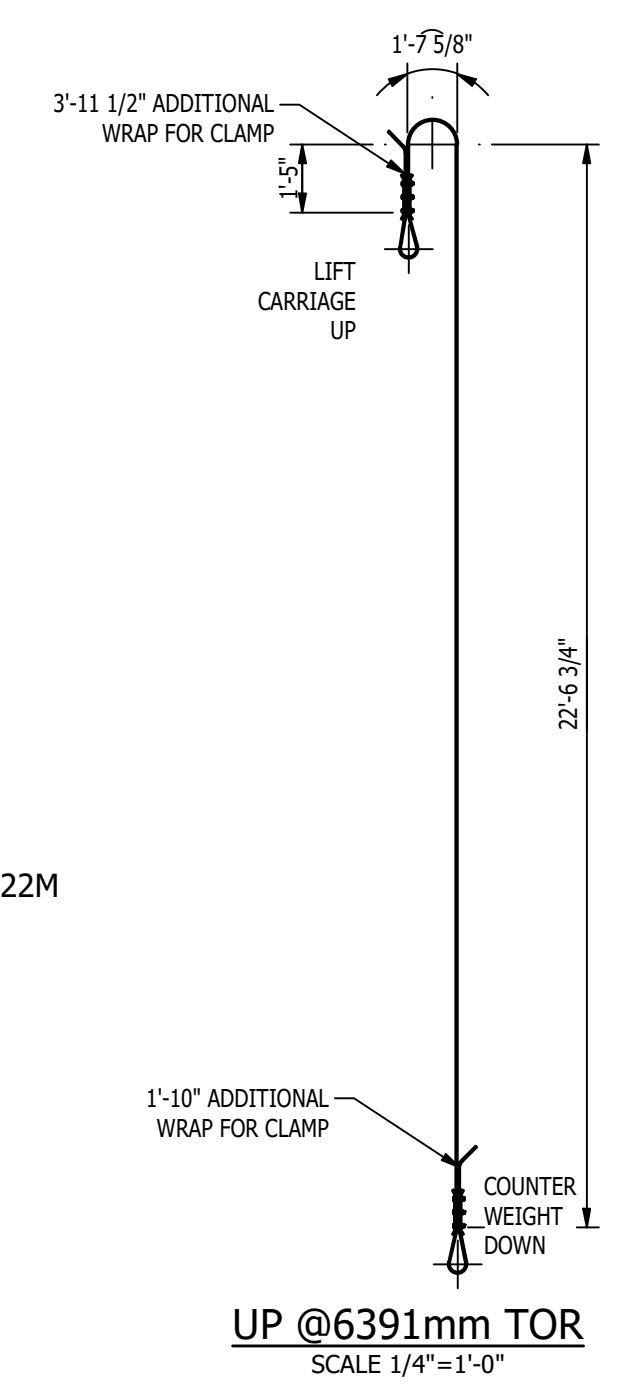
TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D302
REV: C

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CHECKED BY: JCK
DWG DATE: 8/23/22
JOB No: 22096




WRAP ON DRUM 1'-7 5/8"
 + "A" +20'-4 7/8"
 + "B" +3'-6 15/16"
 +WRAP AT CWT +3'-11 1/2"
 +WRAP AT CARRIAGE +3'-11 1/2"
 33'-6 1/2" = 10.22M



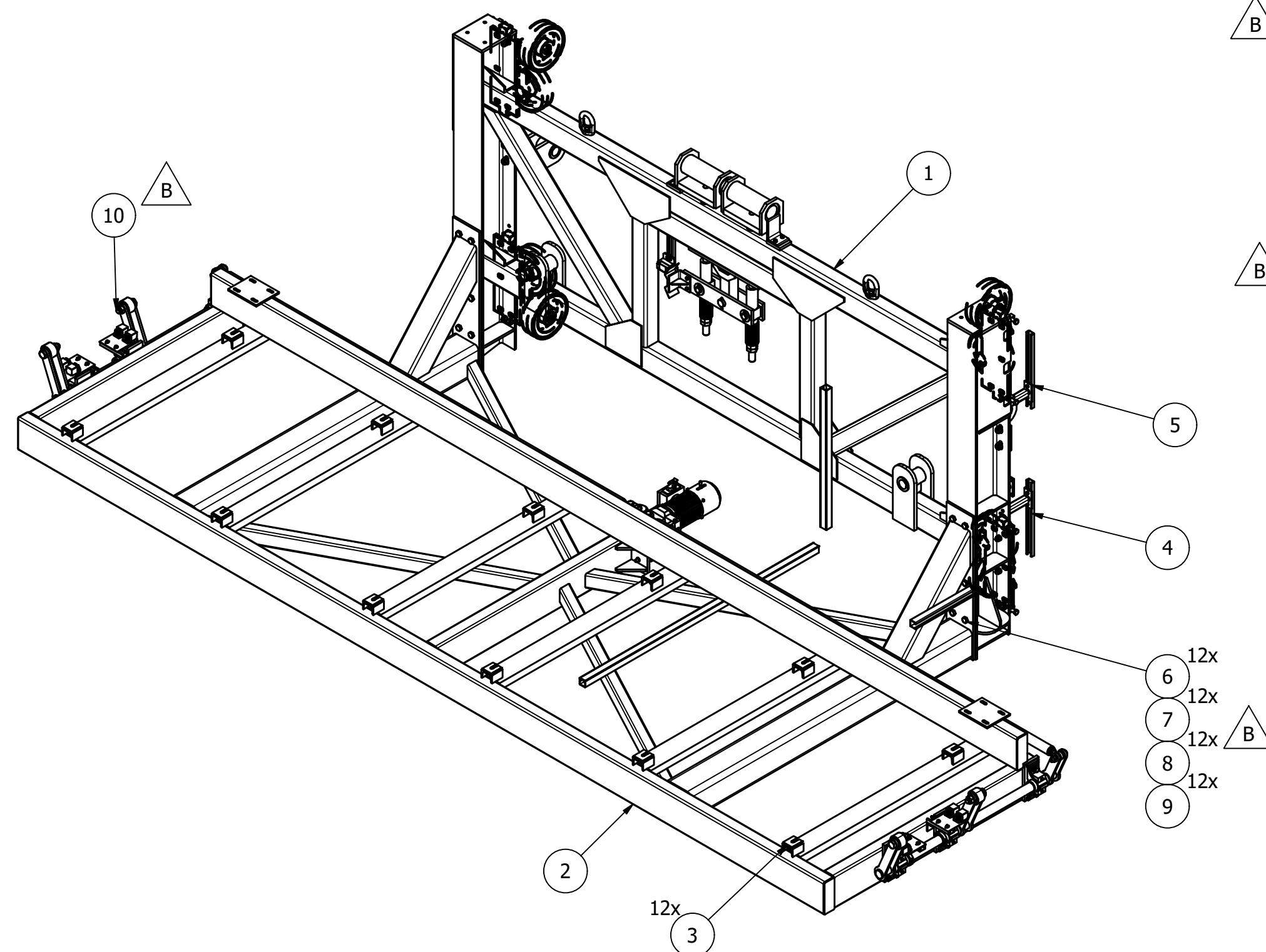
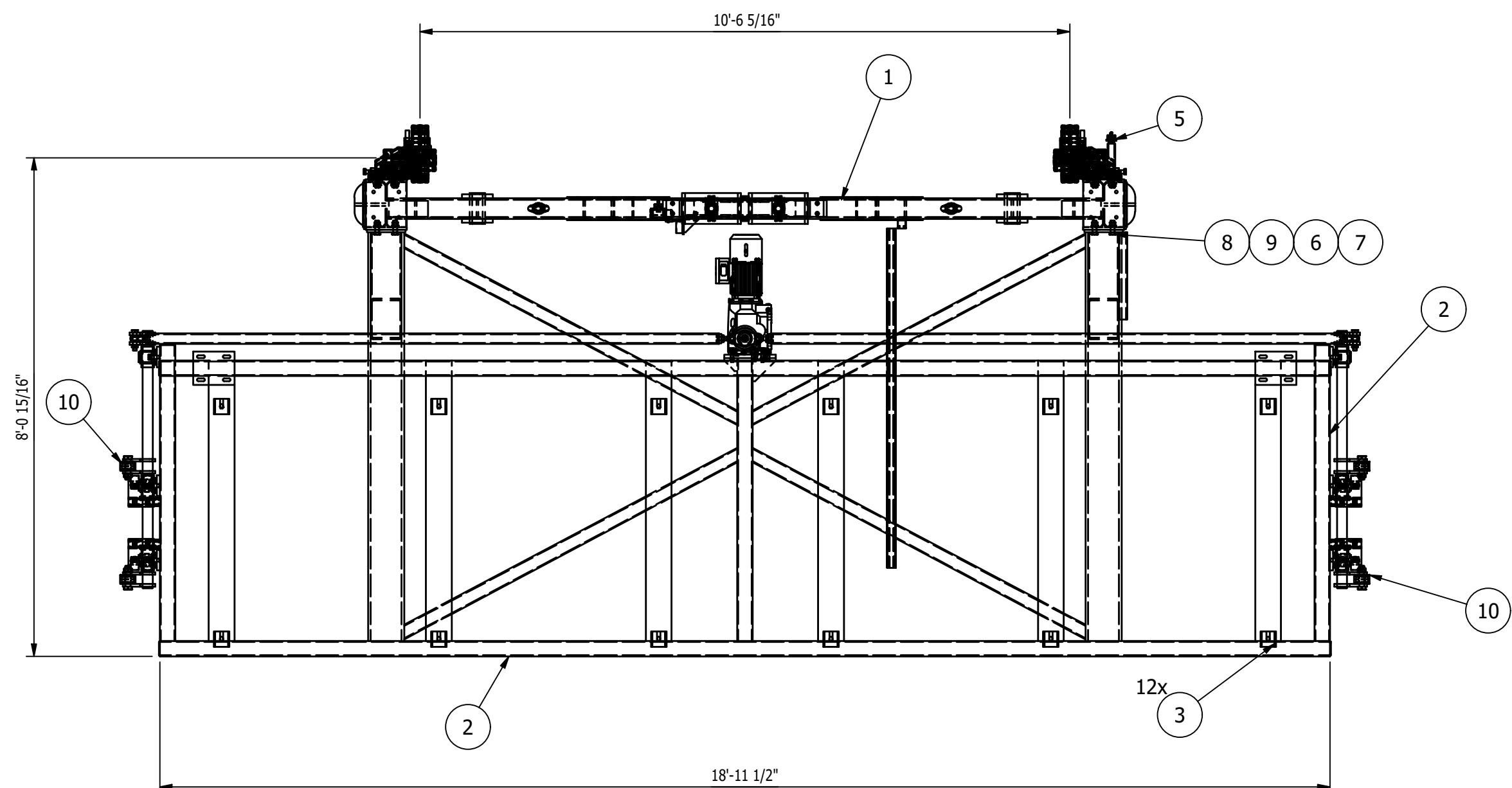
SHEET 2 OF 2
 SEE SHEET 1 FOR REVISION BLOCK

UNLESS OTHERWISE NOTED:
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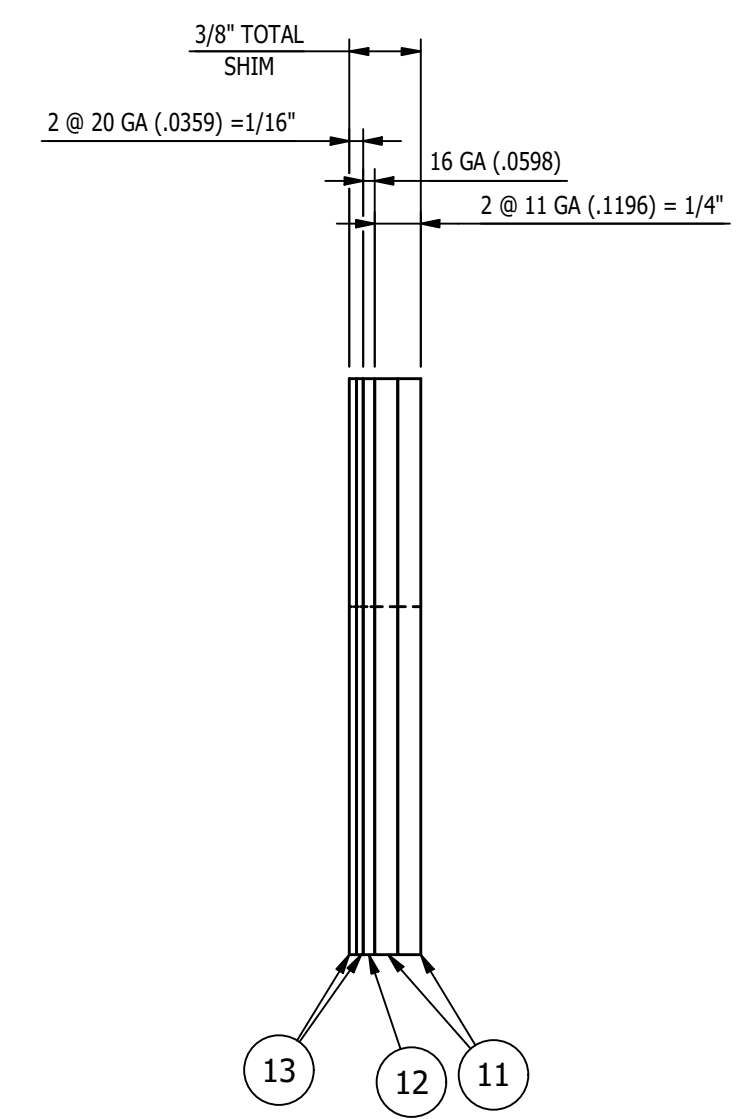
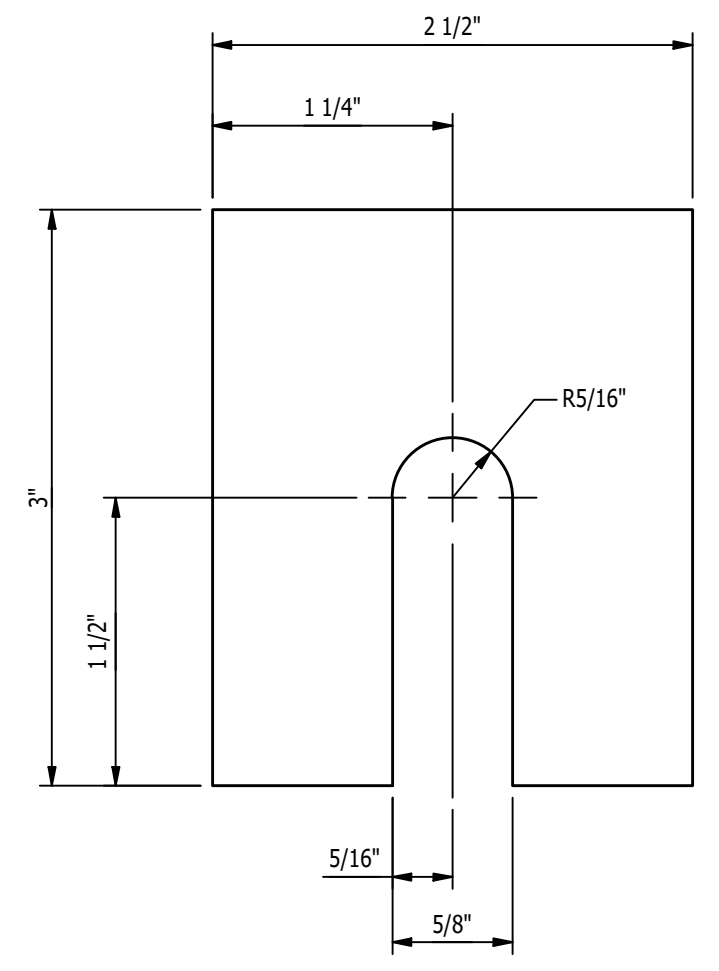
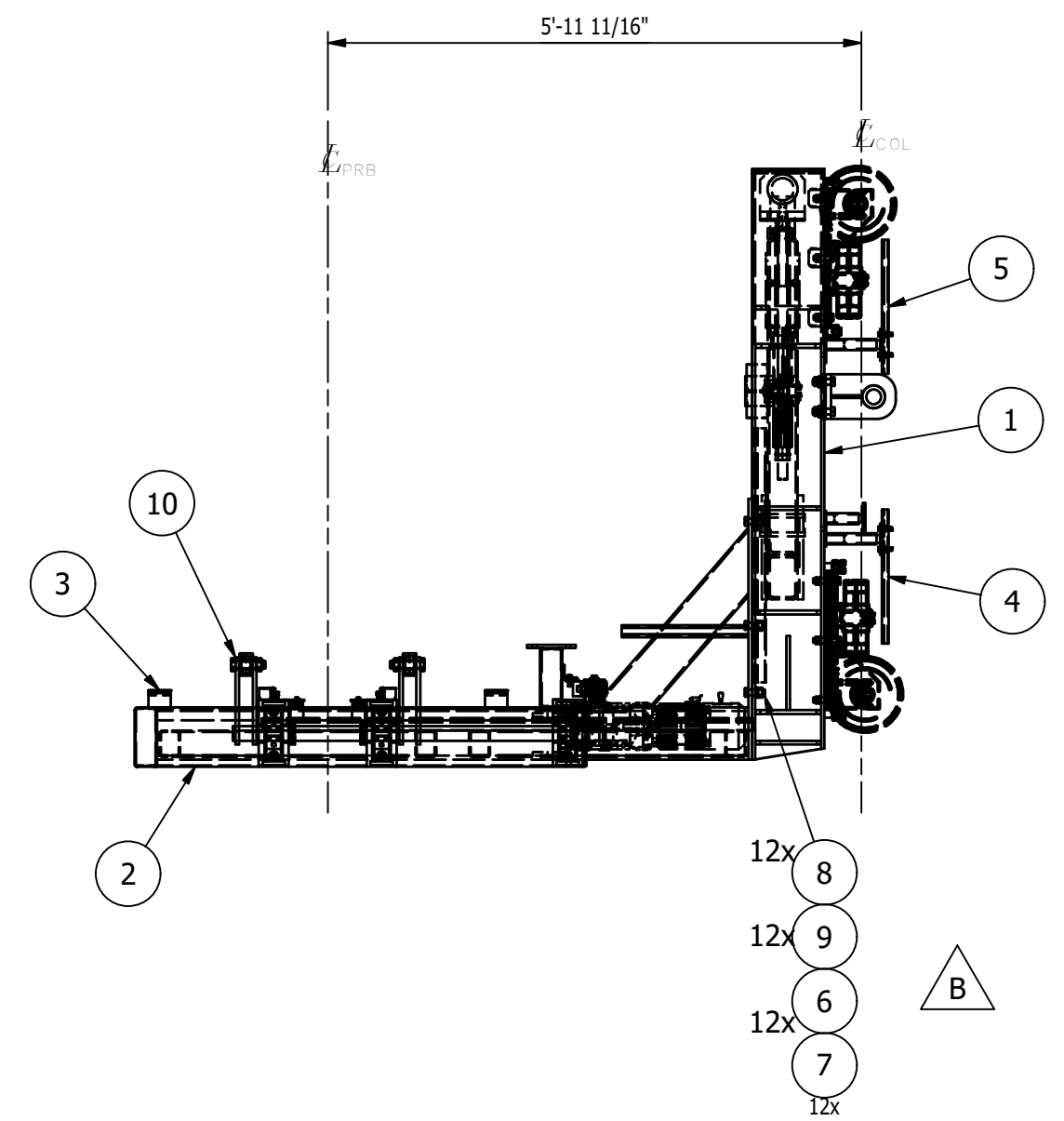
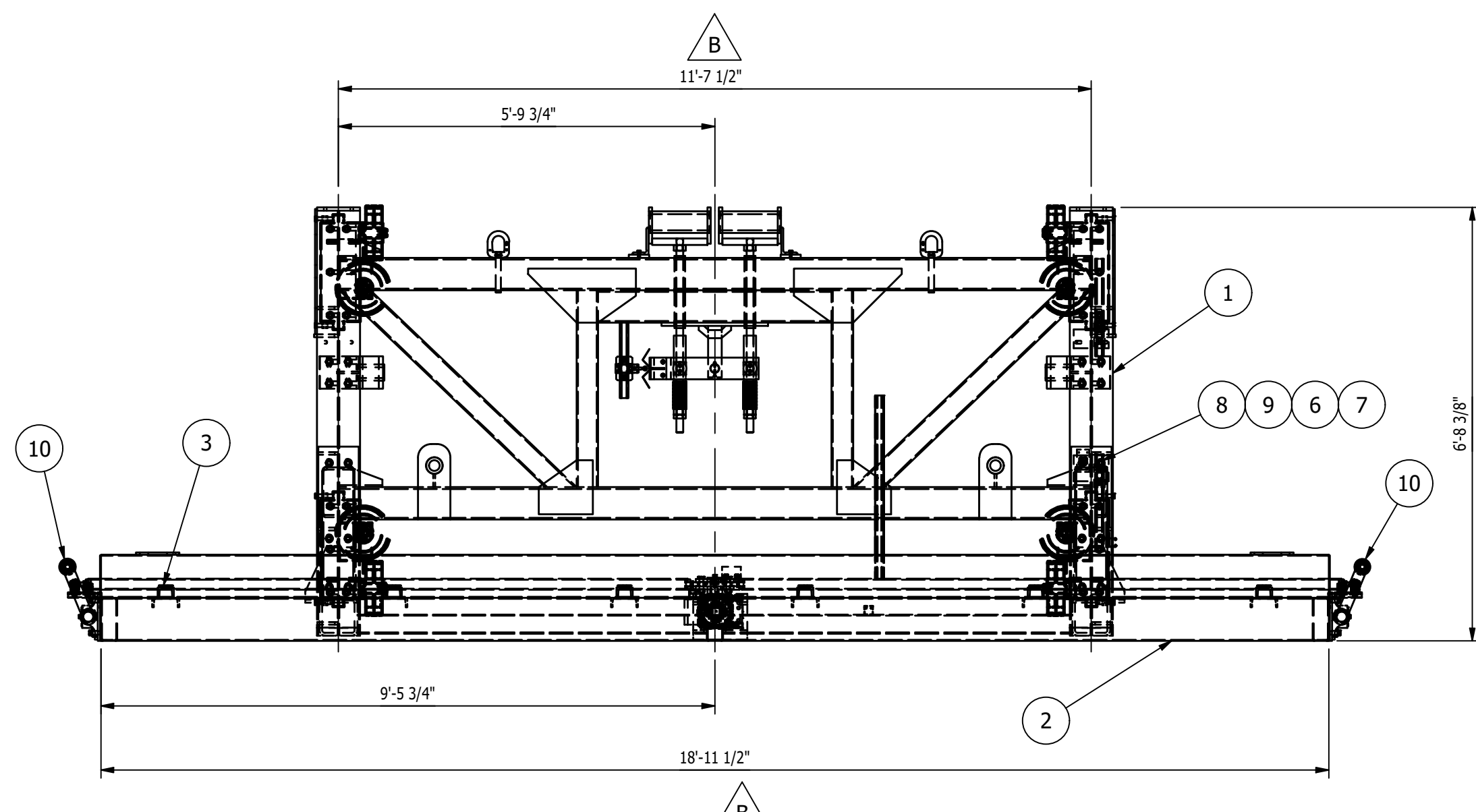
GENERAL NOTES:
 MATERIALS:
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 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
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 WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)
 PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 COPEES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

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	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D302	REV: C JOB No: 22096
DRAWN BY: JC CHECKED BY: JCK DWG DATE: 8/23/22		

C:\Users\jerman\Desktop\0010302_#1875\New_300_Drawing\Detail\1875D302.dwg



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D303A ~ VERTICAL CARRIAGE ASSEMBLY			
2	1	MK-D319A ~ HORIZONTAL CARRIAGE WELDMENT			
3	12	MK-D303B ~ PRB SHIM PACK			
4	1	MK-D338A ~ CODE READER MOUNT			
5	1	MK-D338B ~ SKI BAR MOUNT			
6	12	3/4 SPRING LOCK WASHER			
7	12	3/4-10UNC HEX NUT			
8	12	3/4-10UNC x 2 1/4" LG. HEX HEAD CAP SCREW, GR-8			
9	12	3/4 TYPE A NARROW FLAT WASHER			
10	1	MK-D307A ~ CARRIAGE LOCKING DEVICE ASSEMBLY			
		TOTAL WEIGHT			
MK-D303B					
11	2	SHT 11 GA x 2 1/2	3"		
12	1	SHT 16 GA x 2 1/2	3"		
13	2	SHT 20 GA x 2 1/2	3"		
1		TOTAL WEIGHT			



MK-D303A ~ VDL CARRIAGE ASSEMBLY
SCALE 1/2" = 1'-0"

MK-D303B ~ PRB SHIM PACK
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.

MAGNUM CONSULTING
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Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D303

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	ADDED D303B DETAIL, UPDATED DIM & BALLOONS	
A	MC	8-8-2022	FOR FABRICATION	

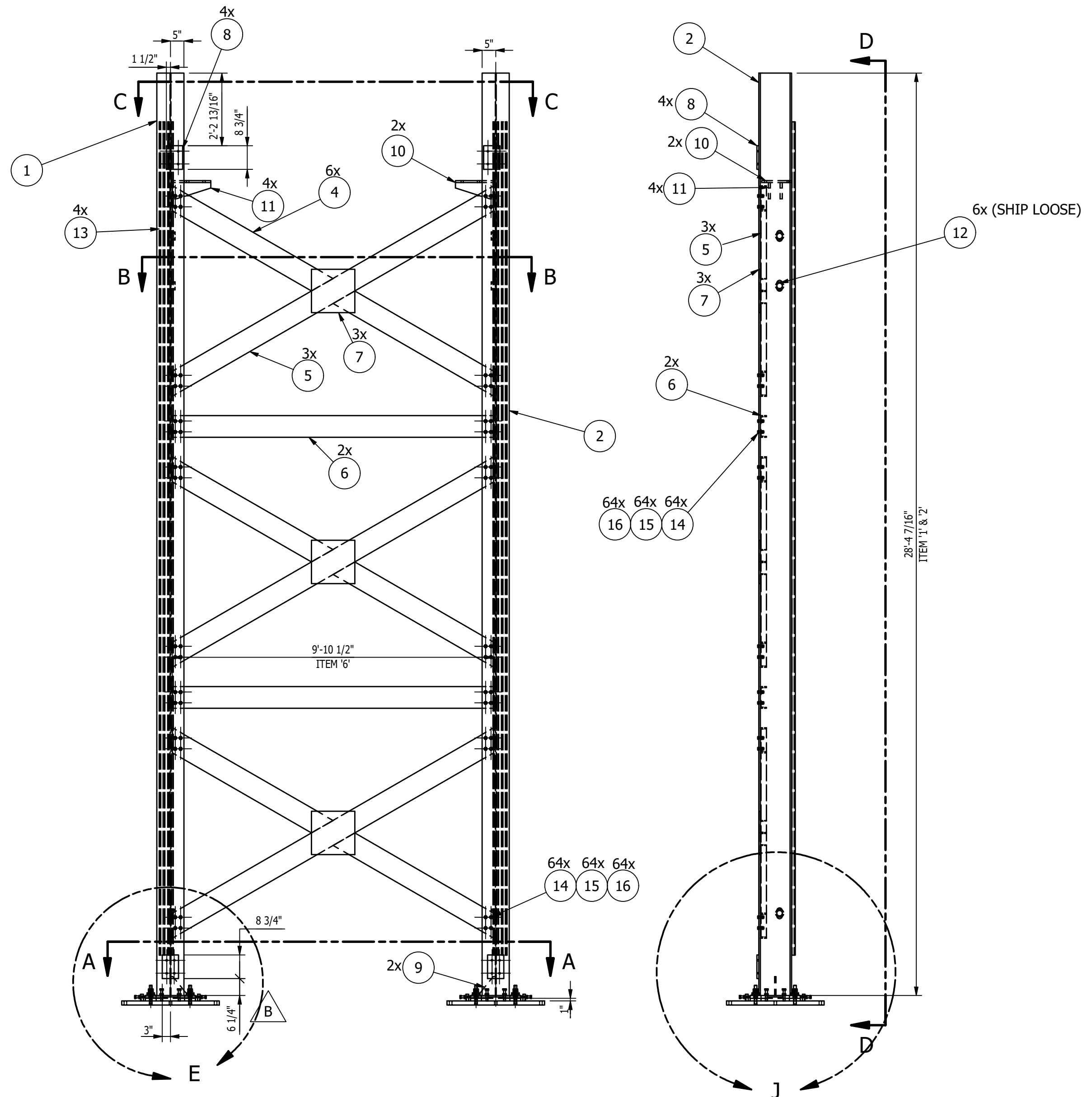
REVISION HISTORY

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

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No.: 1875D303
REV: B

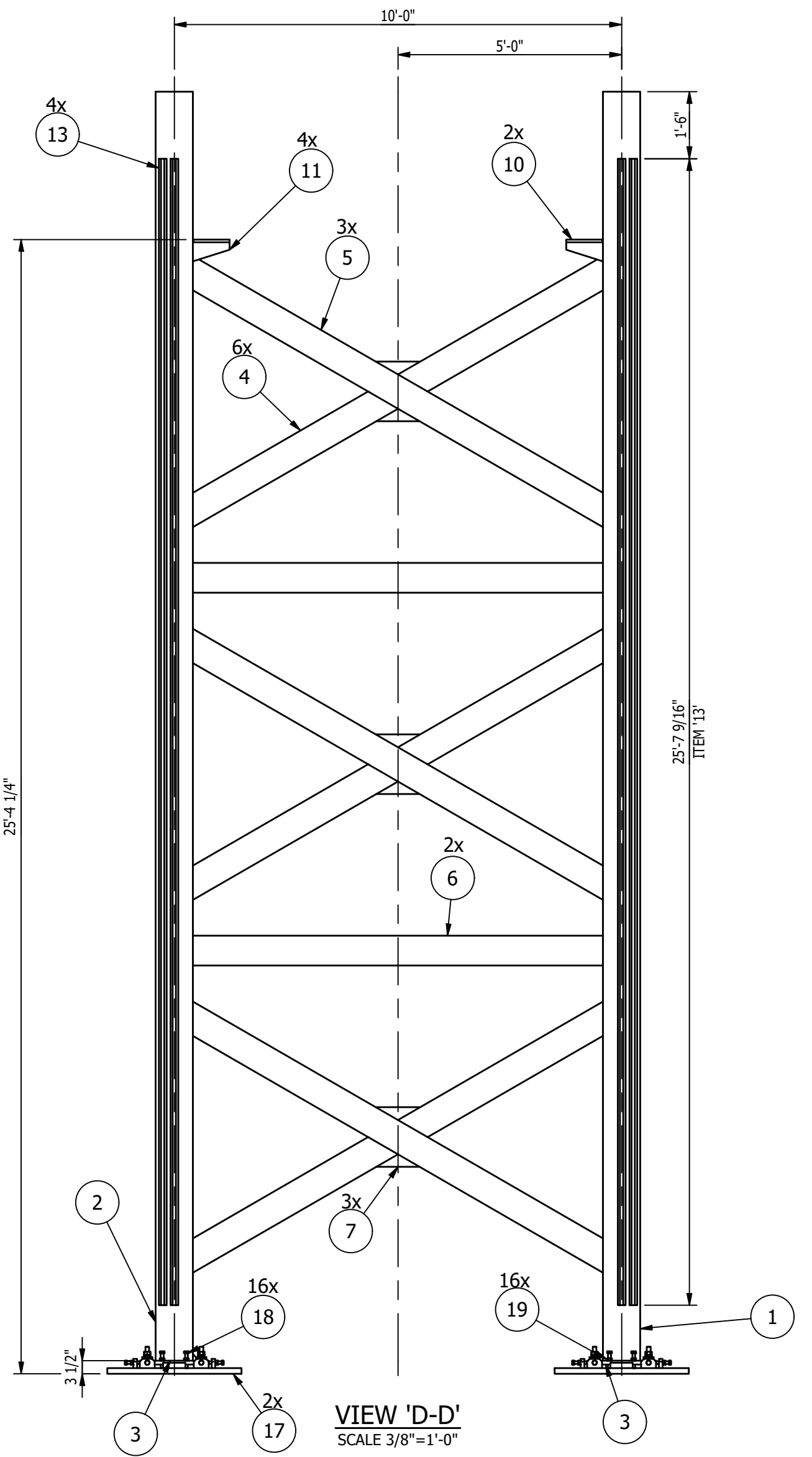
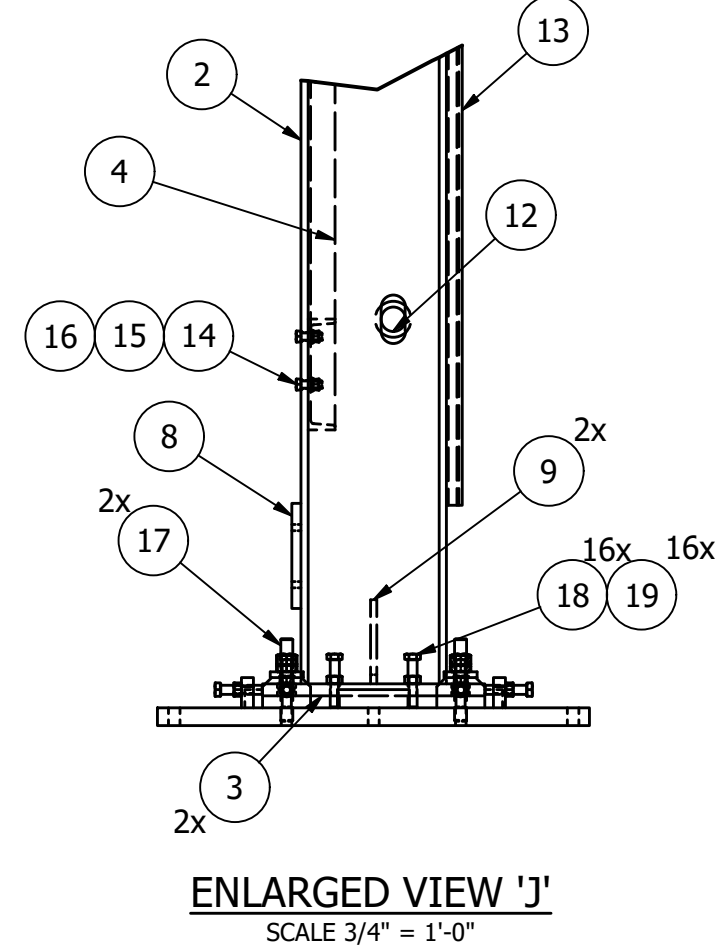
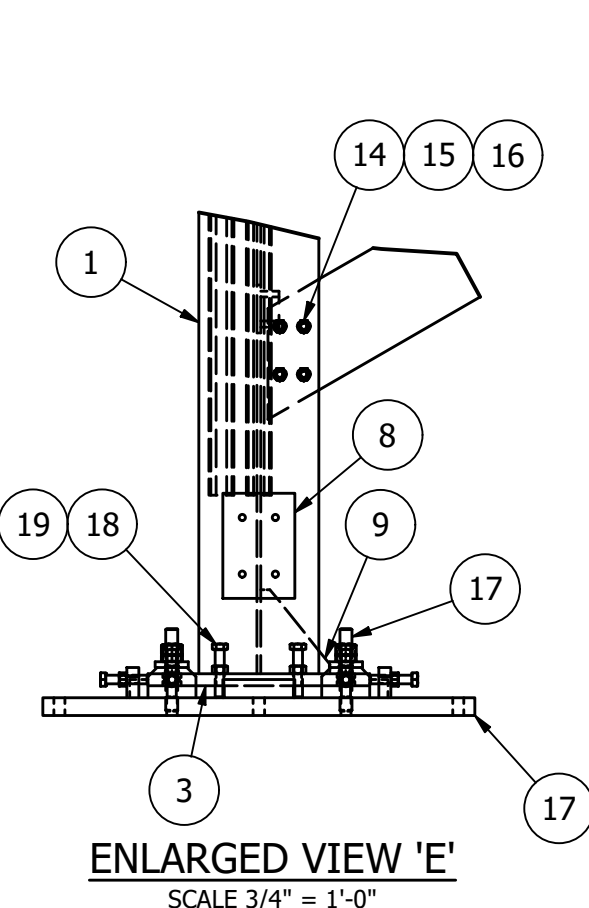
PROPRIETARY AND CONFIDENTIAL
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DRAWN BY: AH
CHECKED BY: JCK
DWG DATE:
JOB No.: 22096



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D304A			
1	1	W 12 x 53	28'-4 7/16"		
2	1	W 12 x 53	28'-4 7/16"		
3	2	PL 1 x 1'-6 1/2"	1'-6 1/2"		
4	6	C 8 x 11.5	5'-8 7/16"		
5	3	C 8 x 11.5	11'-9 7/16"		
6	2	C 8 x 11.5	9'-10 1/2"		
7	3	PL 1/2 x 1'-4"	1'-4"		
8	4	BAR 3/4 x 6	8 3/4"		
9	2	BAR 1/2 x 7	5 3/4"		
10	2	BAR 3/4 x 11	1'-2 11/16"		
11	4	BAR 3/4 x 6	1'-2 11/16"		
12	6	TS 3 OD x 1/2 DOM (SHIP LOOSE)	1 1/2"		
13	4	C-PROFILE MOUNTING CHANNEL, HALFEN PART NO. HM 52/34	25'-7 9/16"	7-16	
14	64	5/8-11UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
15	64	5/8 SPRING LOCK WASHER			
16	64	5/8-11UNC HEX NUT			
17	2	MK-D327A ~ COLUMN BASE			
18	16	3/4-10UNC x 4" LG. HEX HEAD CAP SCREW, FULLY THREADED			
19	16	3/4-10UNC HEX NUT			

MK-D304A ~ VDL COLUMN ASSEMBLY
SCALE 3/8"=1'-0"



- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.
 9. VIBRATORY STRESS RELIEVE WELDMENT
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
ITEM '12' - ONE SHOP COAT OF SAFETY YELLOW RAL 1023
OTHERS - ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/30/22	UPATED LOCATION OF ITEMS '10' & '11', ADDED ENLARGED VIEWS, DETAIL OF ITEM '5', & MODIFIED WELD SYMBOLS	
B	MC	8/19/2022	GENERAL ADDED DIMS, ABM NO. & DETAIL '6'	
A	MC	8-8-2022	FOR FABRICATION	

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

UNLESS OTHERWISE NOTED:

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

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

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

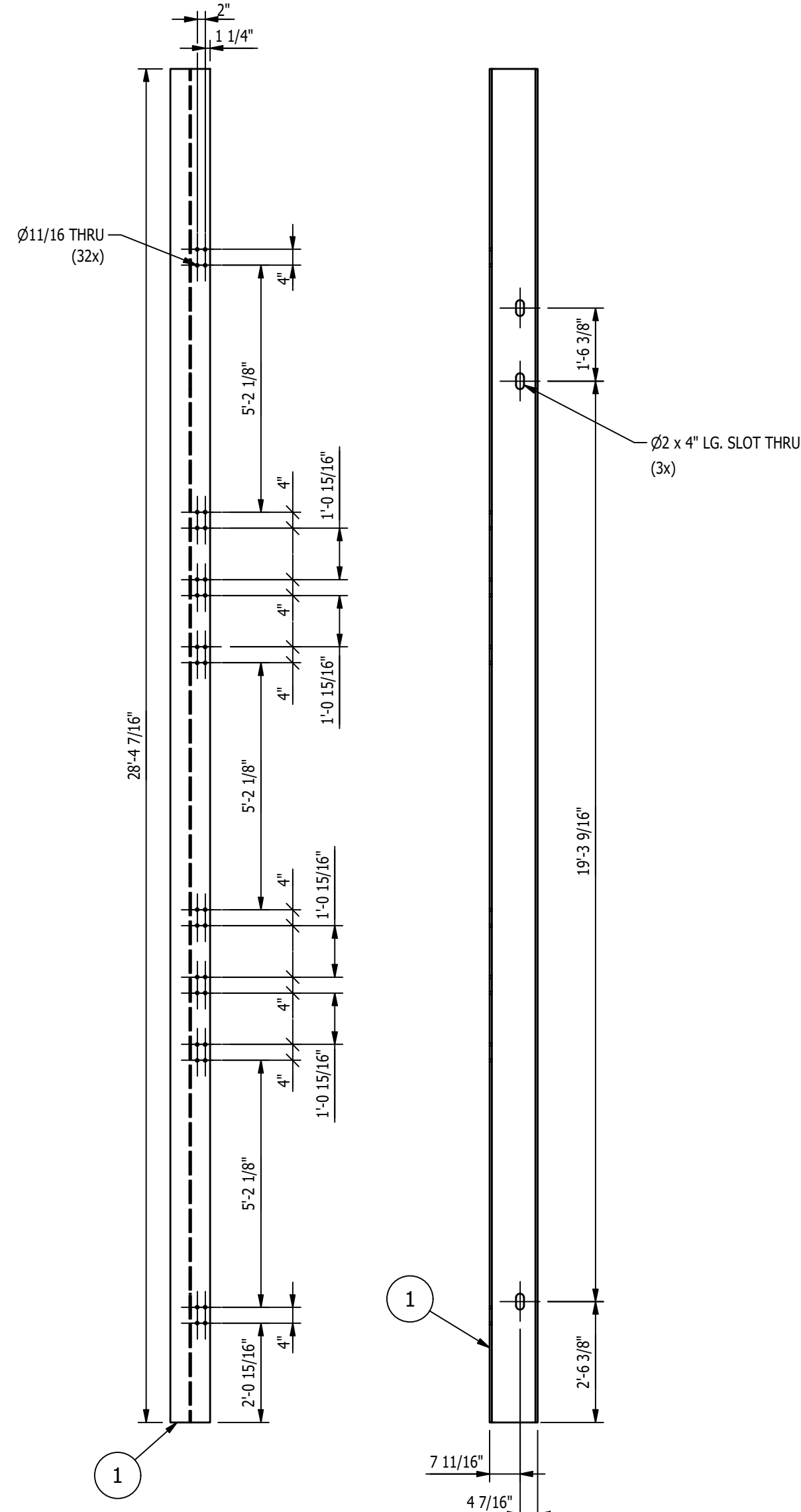
DRAWING No.: 1875D304

REV: C

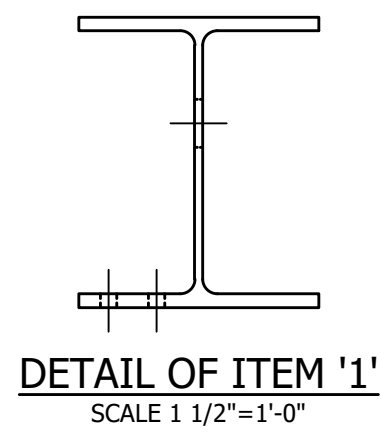
DRAWN BY: AH
CHECKED BY: JCK
DWG DATE: 7/21/22
JOB No.: 22096

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41100 Clarkston Rd.
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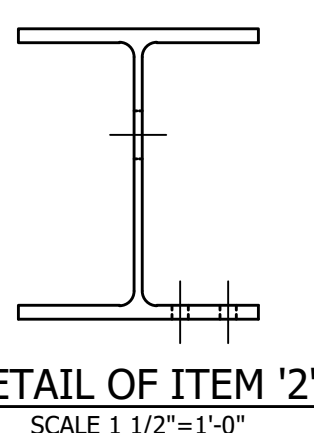
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MAGNUM DRAWING #: 1875D304 - REV C



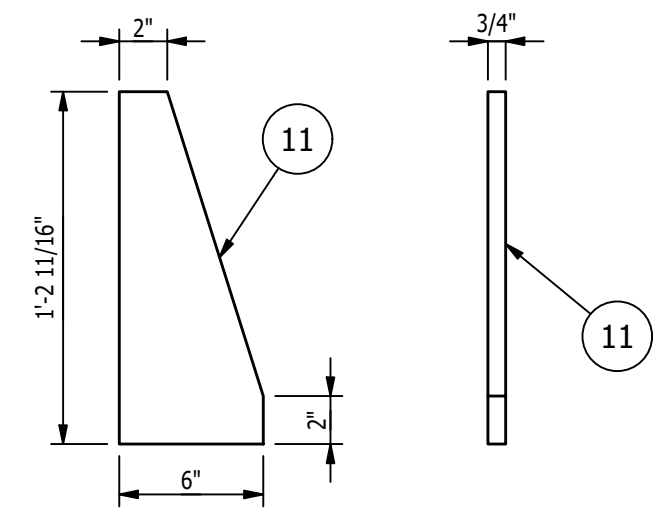
**DETAIL OF ITEM '1' SHOWN
DETAIL OF ITEM '2' OPPOSITE**
SCALE 3/8"=1'-0"



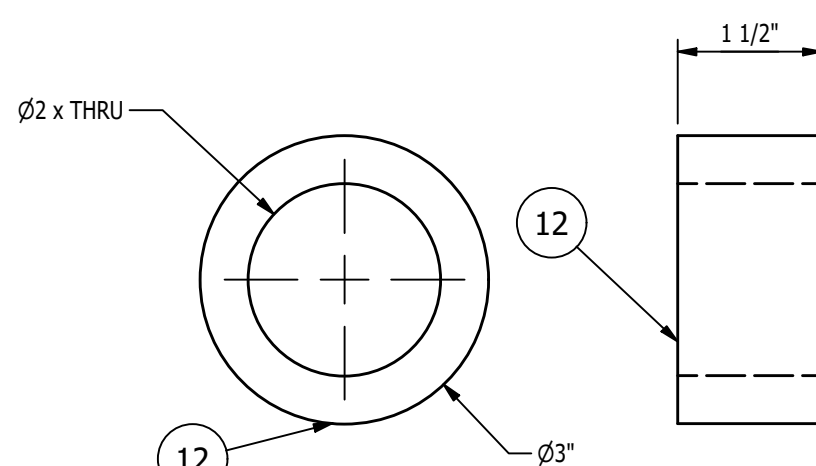
DETAIL OF ITEM '1'
SCALE 1 1/2"=1'-0"



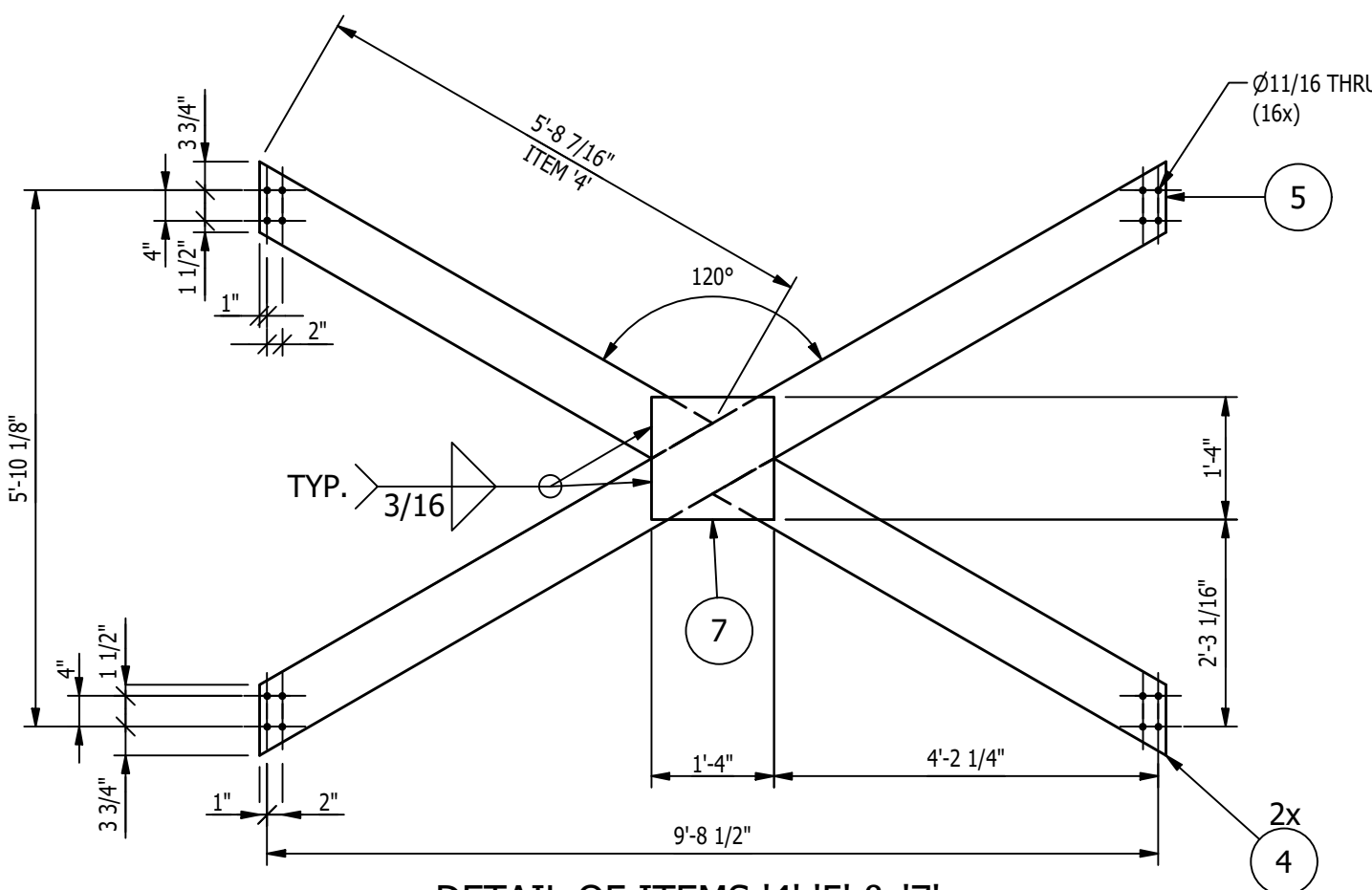
DETAIL OF ITEM '2'
SCALE 1 1/2"=1'-0"



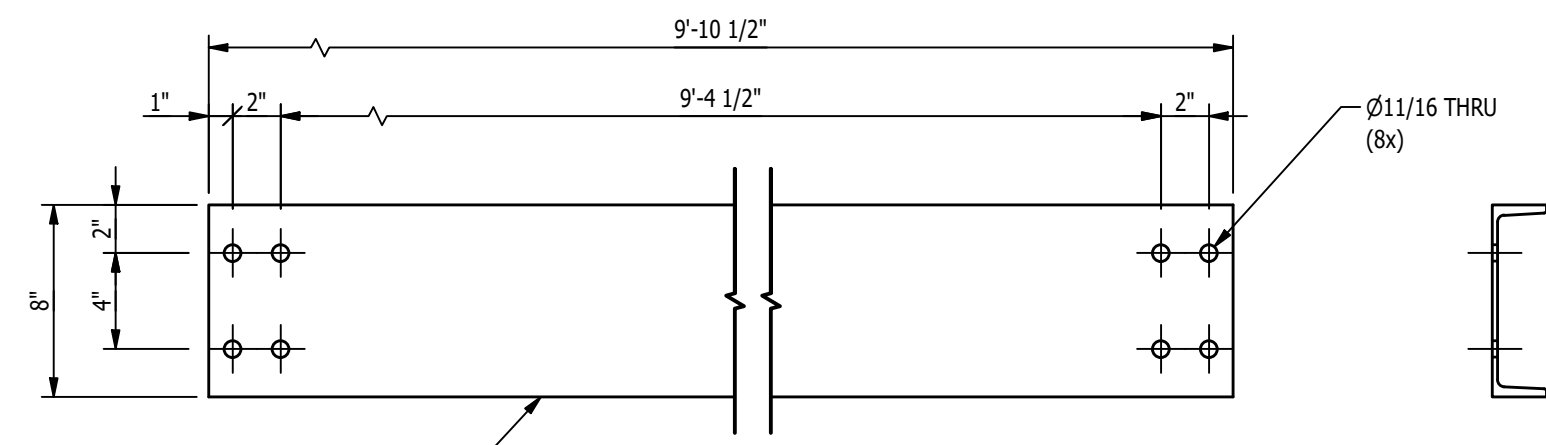
DETAIL OF ITEM '11'
SCALE 1 1/2"=1'-0"



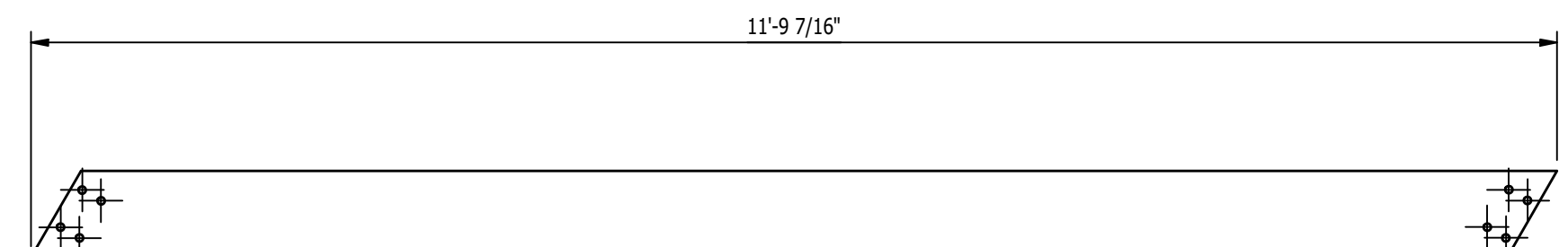
DETAIL OF ITEM '12'
SCALE 6"=1'-0"



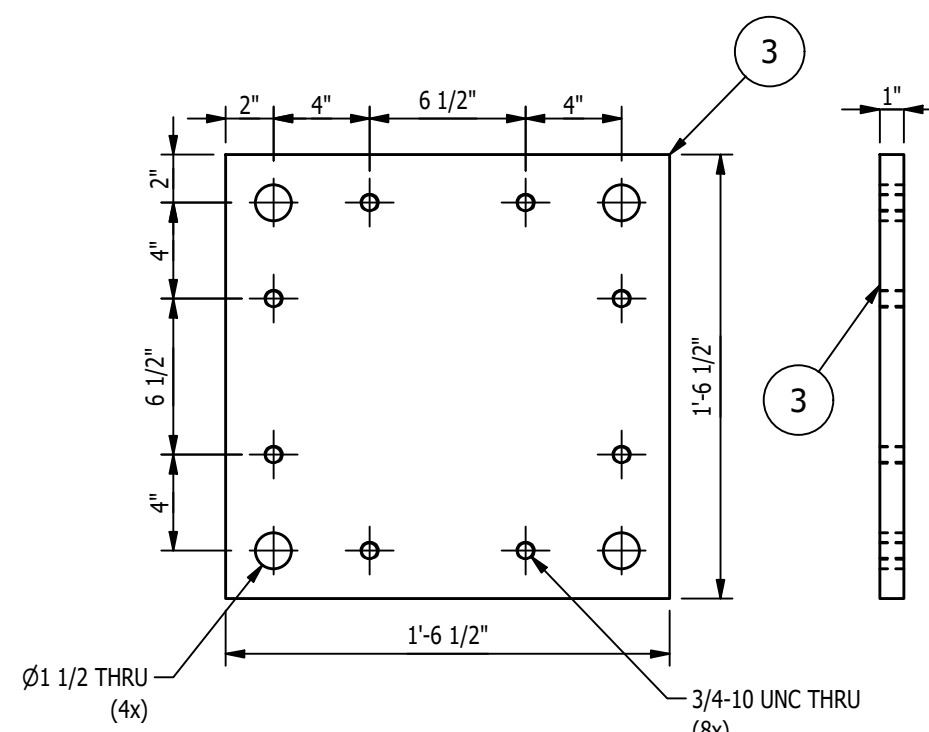
DETAIL OF ITEMS '4' '5' & '7'
SCALE 1/2"=1'-0"



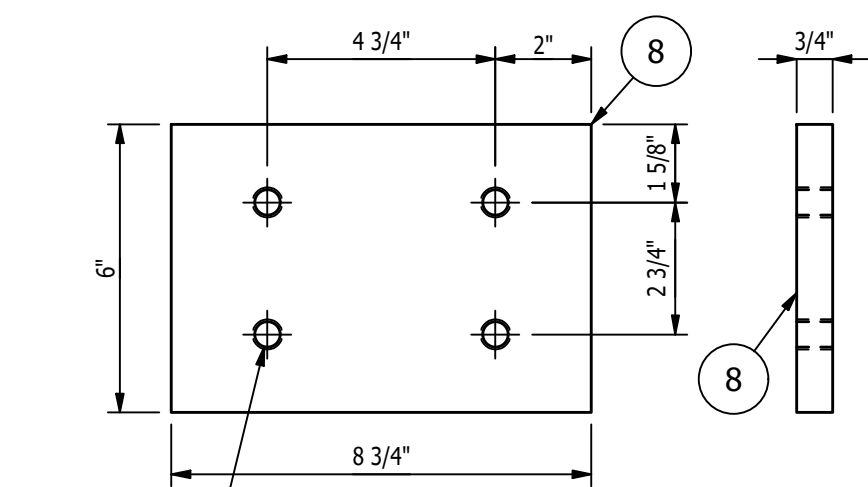
DETAIL OF ITEM '6'
SCALE 1 1/2"=1'-0"



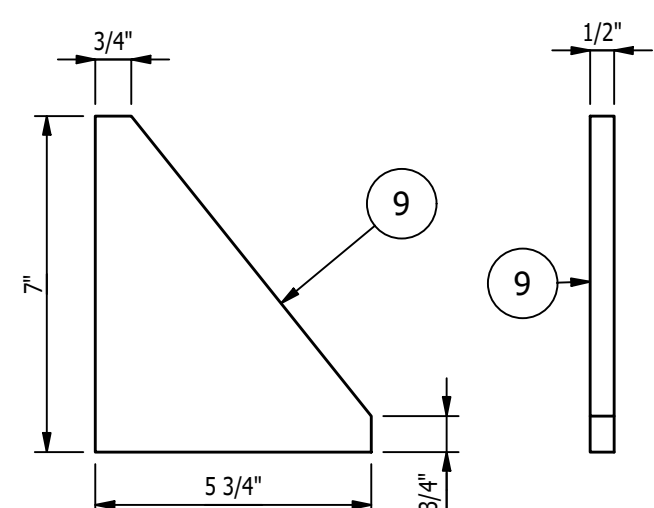
DETAIL OF ITEM '5'
SCALE 3/4"=1'-0"



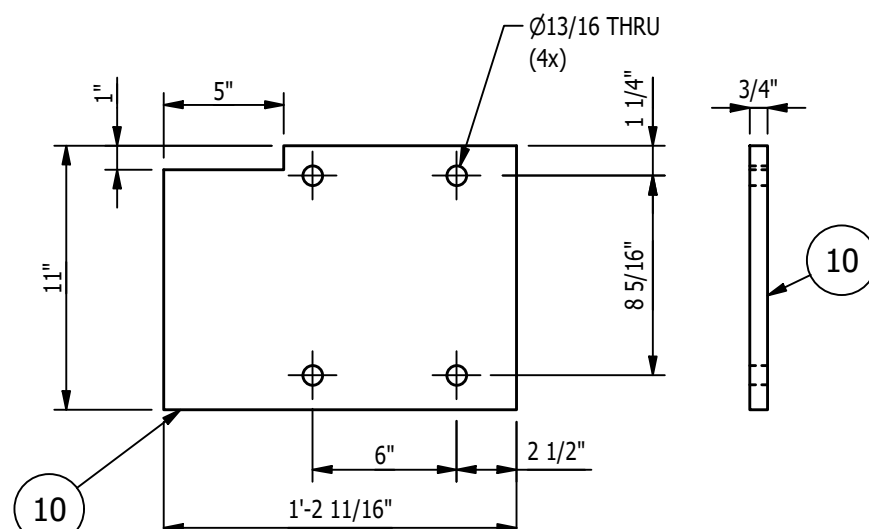
DETAIL OF ITEM '3'
SCALE 1 1/2"=1'-0"



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



DETAIL OF ITEM '9'
SCALE 3"=1'-0"



DETAIL OF ITEM '10'
SCALE 1 1/2"=1'-0"

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/30/22	UPDATED LOCATION OF ITEMS '10' & '11', ADDED ENLARGED VIEWS, DETAIL OF ITEM '5', & MODIFIED WELD SYMBOLS	
B	MC	8/19/2022	GENERAL ADDED DIMS, ABM NO. & DETAIL '6'	
A	MC	8-8-2022	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.
 COPE:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

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

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D304

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DRAWN BY: AH
CHECKED BY: JCK
DWG DATE: 7/21/22
JOB No: 22096

MAGNUM Consulting
 41100 QuakerRoad Rd.
 Suite 125
 Novi, MI 48235

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

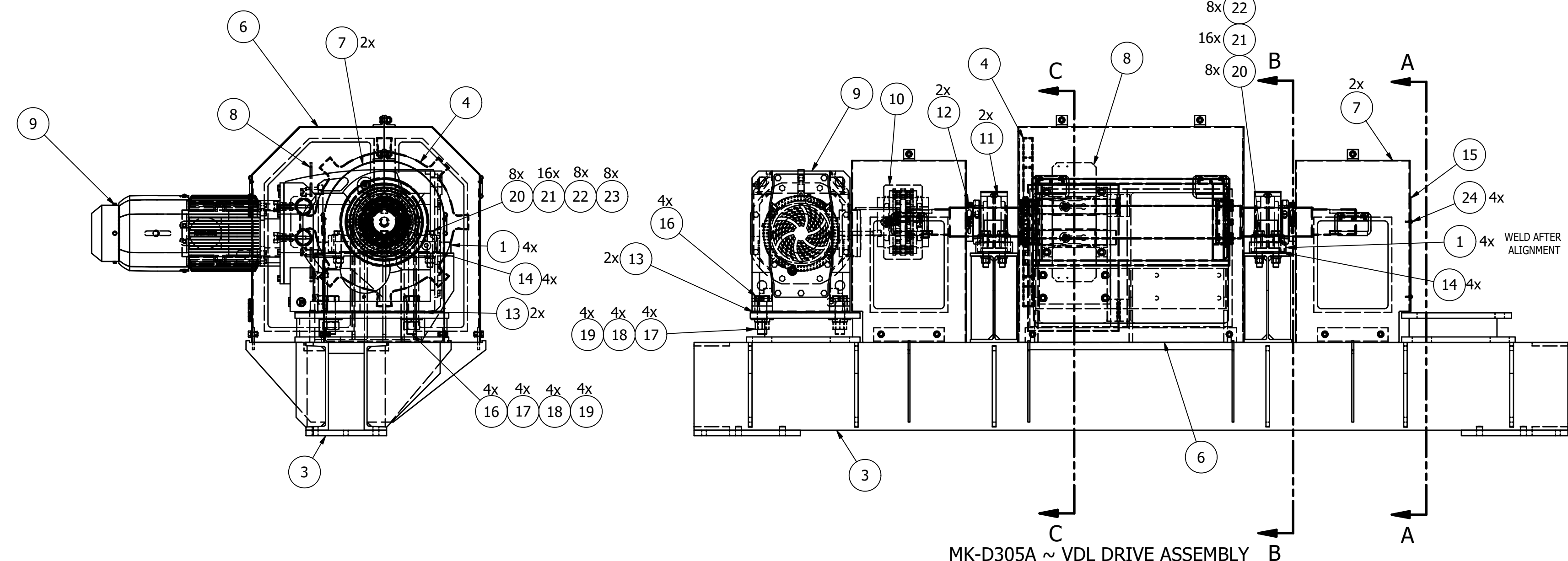
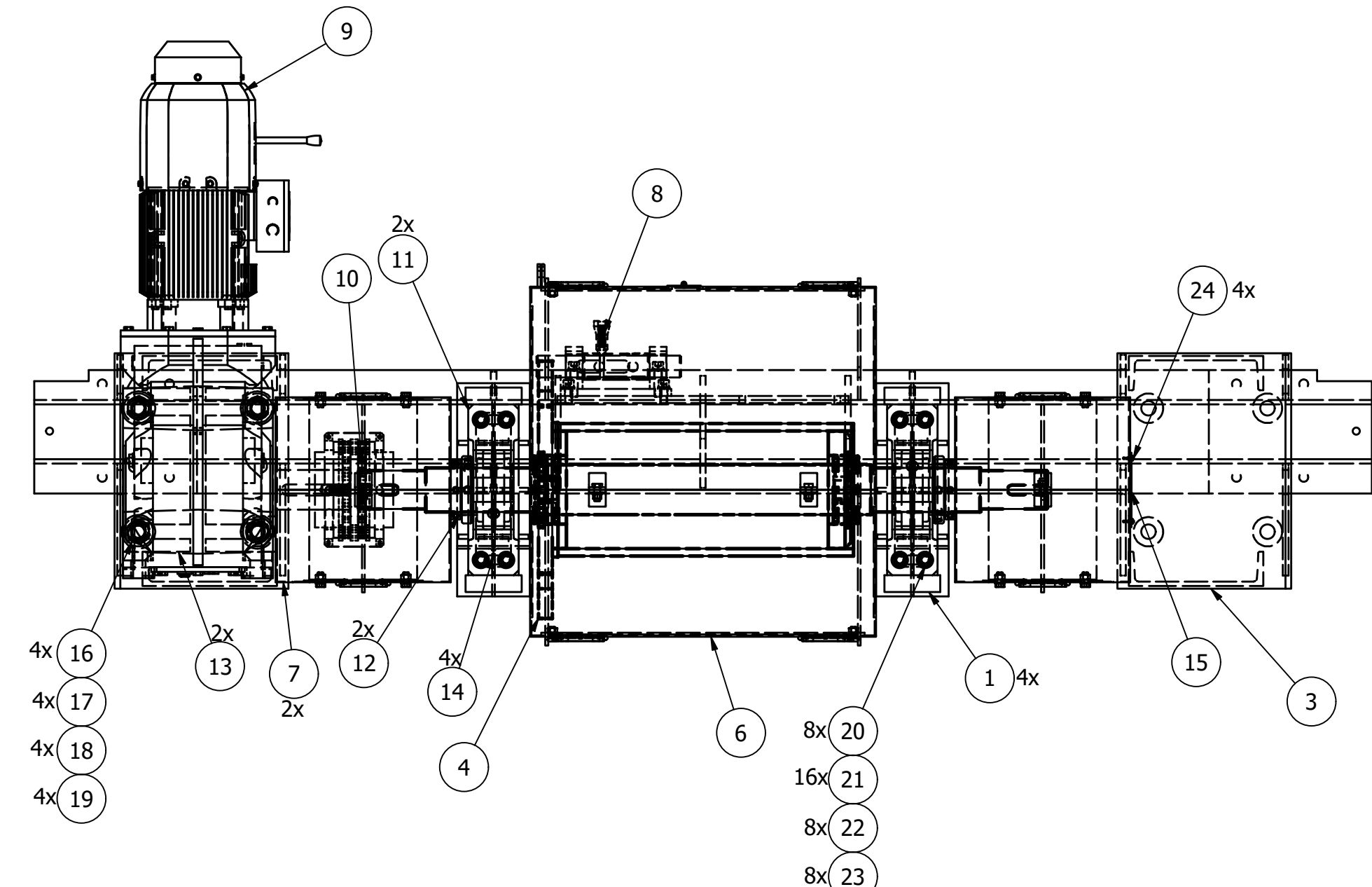
MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D304 - REV C

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

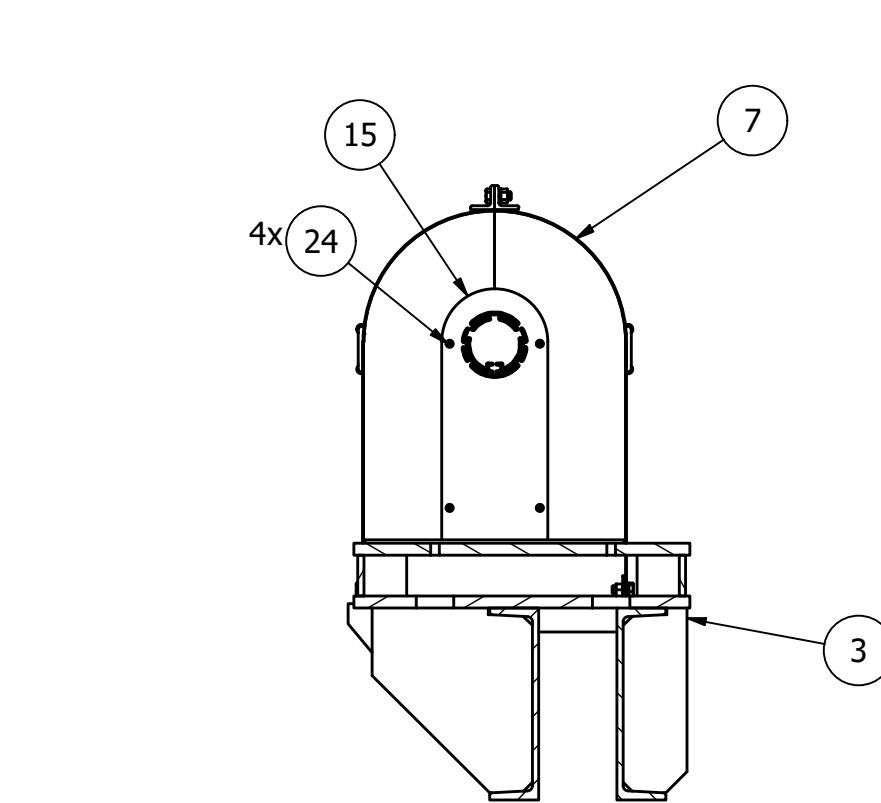
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BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D305A			
1	4	SQ. BAR 1 1/2 (SHIP LOOSE)	5"		
3	1	MK-D328A ~ VDL DRIVE WELDMENT			
4	1	MK-D331A ~ SHAFT ASSEMBLY			
6	1	MK-D329A ~ PULLEY GUARD			
7	2	MK-D330A ~ COUPLING GUARD			
8	1	MK-D332A ~ SPROCKET LOCK-OUT PIN ASSEMBLY			
9	1	VDL1 GEARMOTOR PER MOTOR DATA SHEET		1-5	
10	1	CHAIN COUPLING, 20 TOOTH SPROCKETS, 100-2 CHAIN, 0.72" BETWEEN SPROCKETS, 6.98" LENGTH THRU COUPLING, FIRST SPROCKET 3.4375" BORE, H6 TOLERANCE +.0009/-0.0000", WITH 0.875" +.002/-0.000" x " +.015/-0.000" KEYWAY, SECOND SPROCKET 90.00mm BORE, H6 TOLERANCE +.022/-0.000mm, WITH 25.00mm +.026/-0.026mm x 12.50mm +.2/-0mm KEYWAY, W/ 3/4-10 SETSCREWS, (ONE) CUP POINT & (ONE) OVAL POINT OVER KEY, (ONE) CONE POINT & (ONE) OVAL POINT @90DEG, KEYWAYS INLINE WITH SPROCKET TOOTH, DODGE PART NO. 10020, (APPROVAL DRAWING REQUIRED)		7-1	
11	2	S-2000 PILLOW BLOCK, 4-BOLT, 3-15/16" BORE, P4B-S2-315R, DODGE PART NO. 070373		7-2	
12	2	2-PIECE CLAMP COLLAR W/SET SCREW, 3 15/16" ID, McMASTER-CARR PART NO. 1069N24		7-7	
13	2	MK-D328C ~ DRIVE SHIM PACK			
14	4	MK-D328D ~ BEARING SHIM PACK			
15	1	MK-D330B ~ SHAFT COVER			
16	4	1 1/4-7UNC x 4 1/2" LG. HEX HEAD CAP SCREW			
17	4	1 1/4 TYPE A WIDE FLAT WASHER			
18	4	1 1/4 SPRING LOCK WASHER			
19	4	1 1/4-7UNC HEX NUT			
20	8	3/4-10UNC x 4 1/2" LG. HEX HEAD CAP SCREW			
21	16	3/4 TYPE A NARROW FLAT WASHER			
22	8	3/4 SPRING LOCK WASHER			
23	8	3/4-10UNC HEX NUT			
24	4	McMASTER CARR M5.5x19mm PHILIPS HEAD DRILLING SCREW, ZP, PART NO.90769A153		20-1	

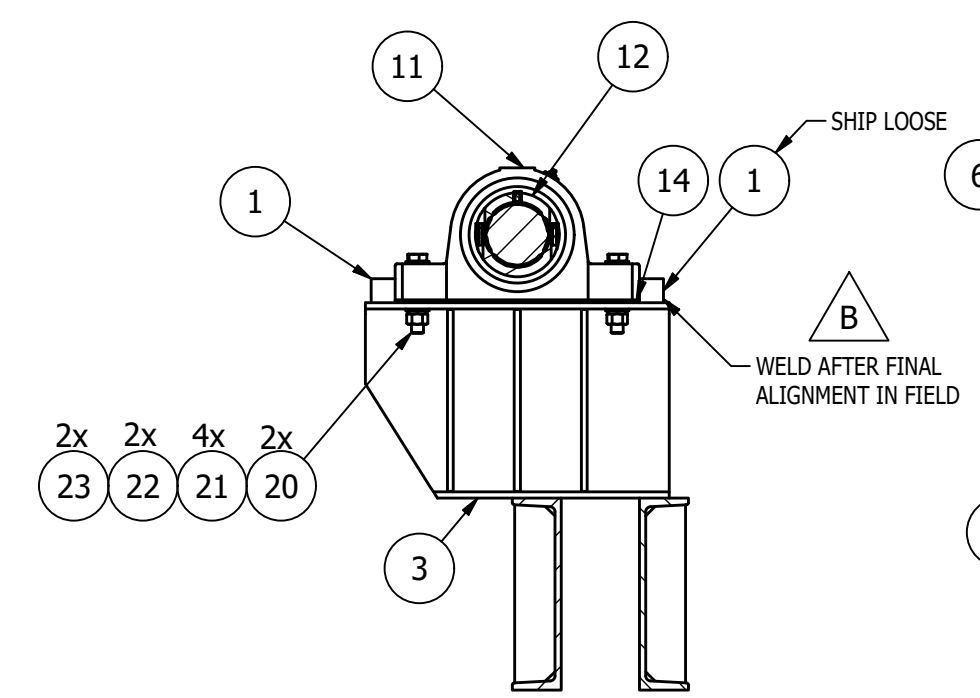
△ B



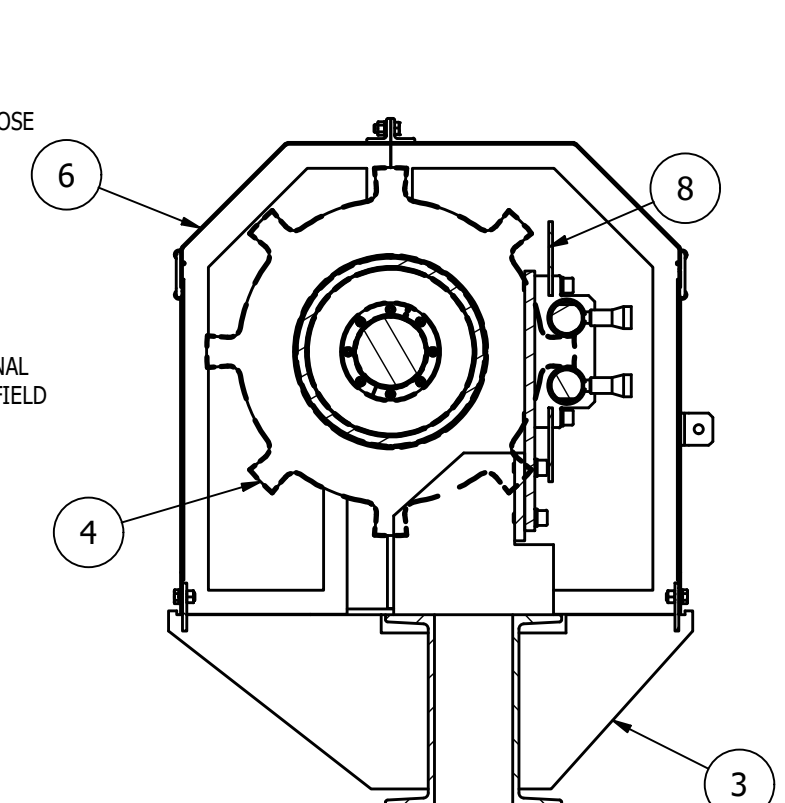
MK-D305A ~ VDL DRIVE ASSEMBLY
SCALE 1"=1'-0"



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



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



SECTION 'C-C'
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.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/18/2022	ADDED ABM # & NOTE.	
A	MC	8/8/2022	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:	AH
CLIENT:	VOLVO	CHECKED BY:	JCK
DRAWING No.	1875D305	DWG DATE:	7/21/22
REV:	B	JOB No:	22096

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)

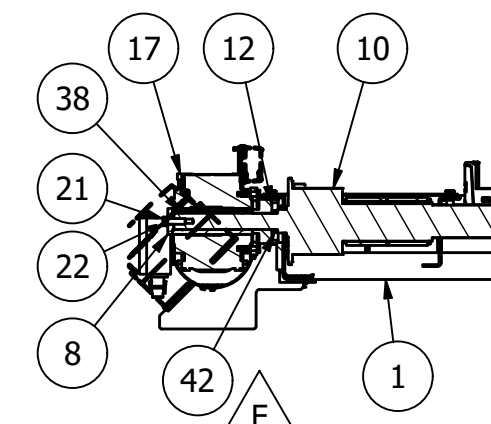
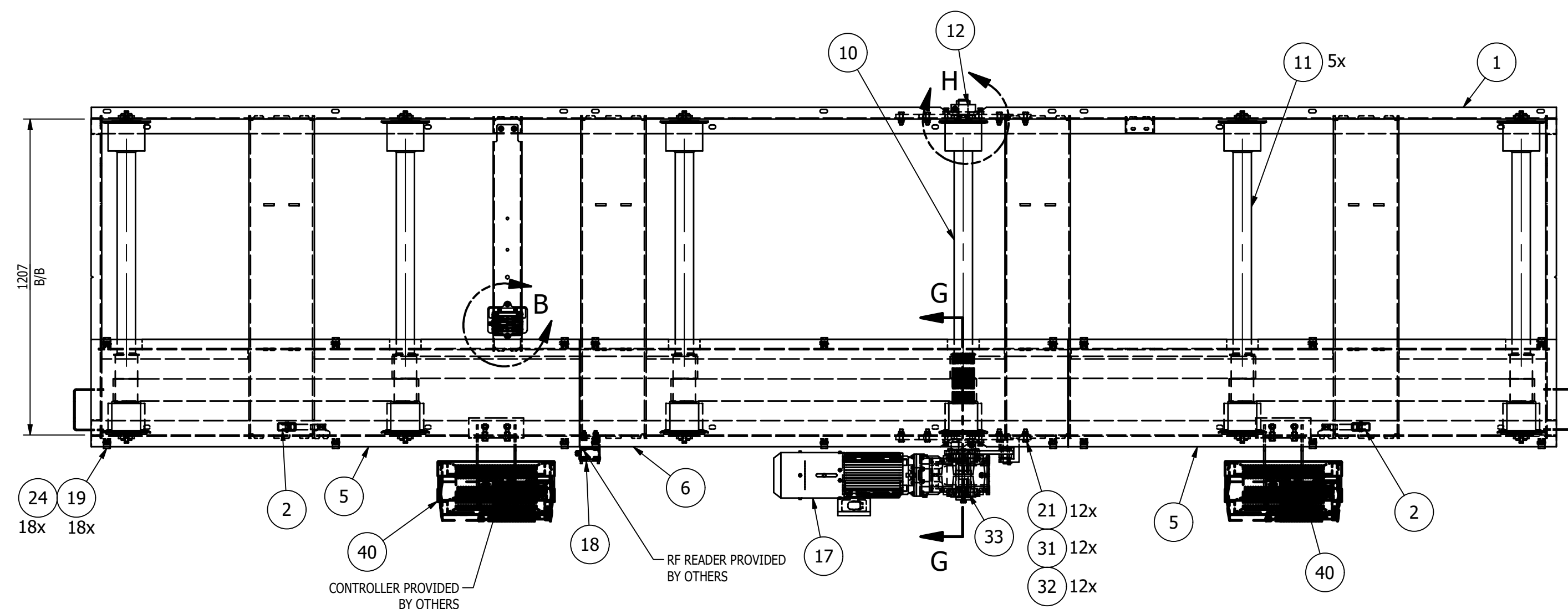
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

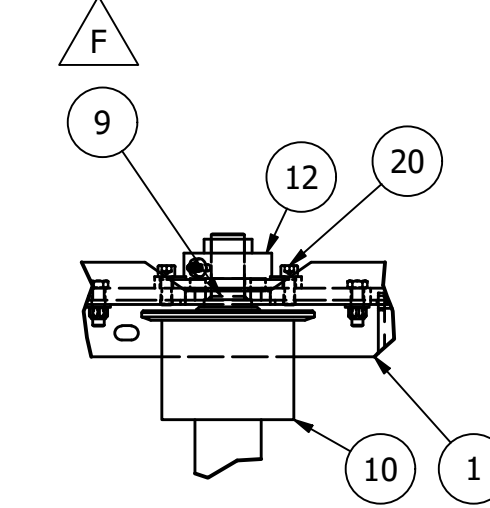
MAGNUM Consulting
41100 Clarkston Rd.
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MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D305

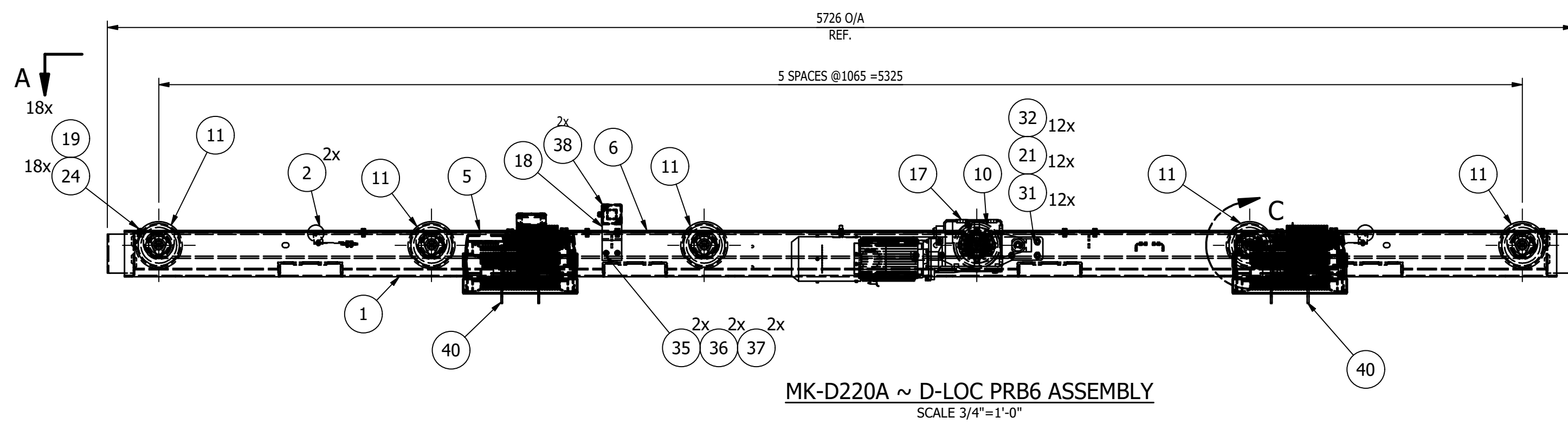
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XXX = ±.005
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ANGLES = ±1°30'
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DEBURR ALL HOLES
DO NOT SCALE DRAWING



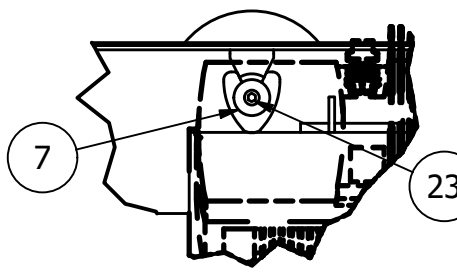
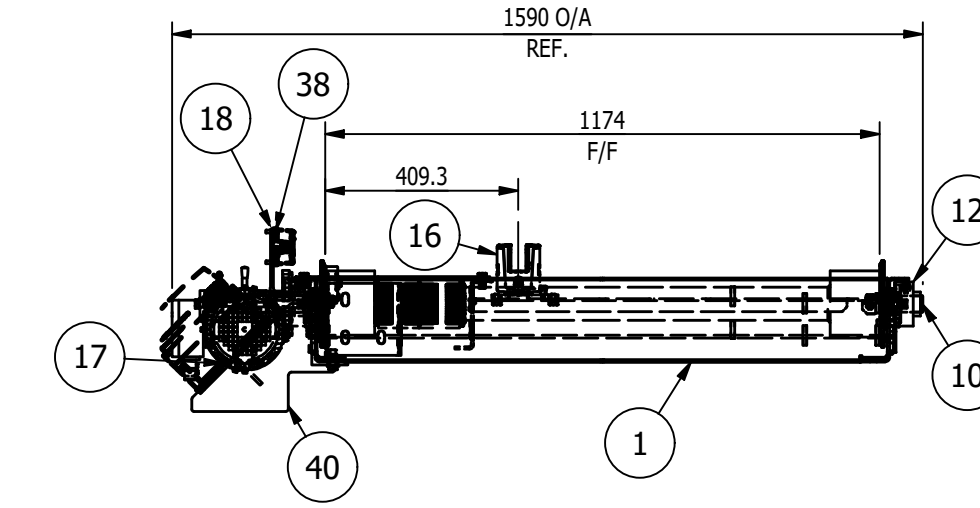
SECTION 'G-G'
SCALE 3/4" = 1'-0"



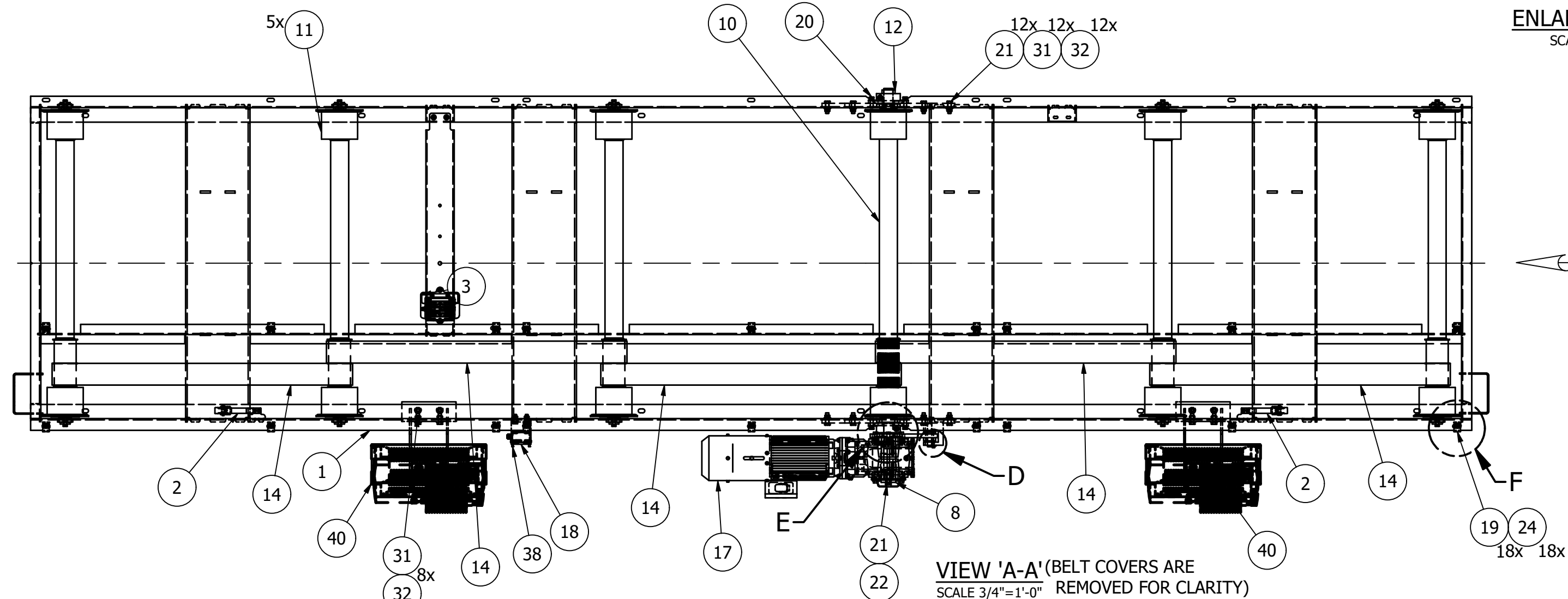
ENLARGED VIEW 'H'
SCALE 1 1/2" = 1'-0"



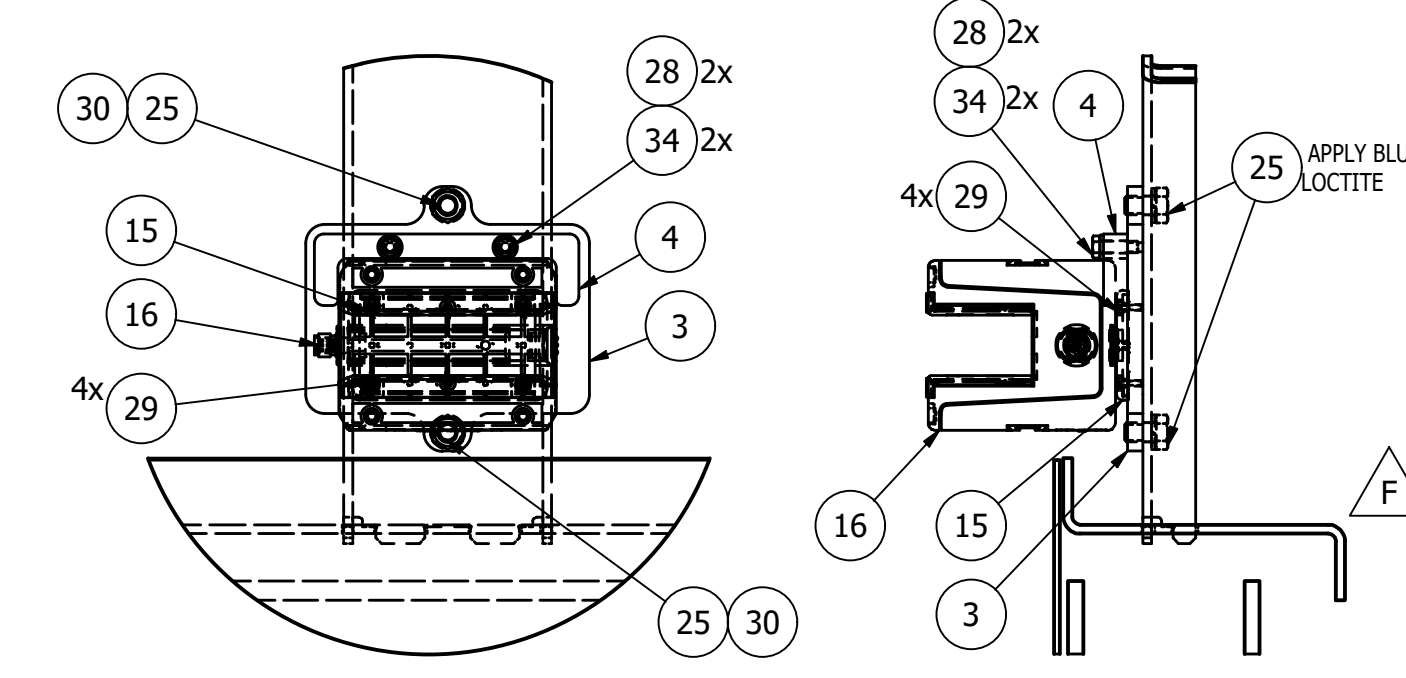
MK-D220A ~ D-LOC PRB6 ASSEMBLY
SCALE 3/4" = 1'-0"



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



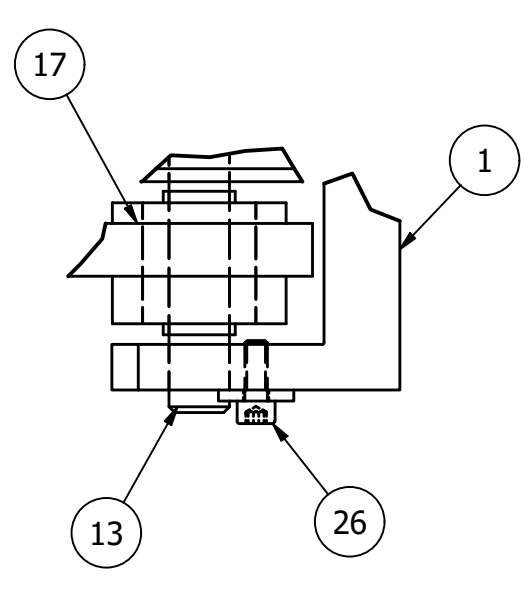
VIEW 'A-A' (BELT COVERS ARE REMOVED FOR CLARITY)
SCALE 3/4" = 1'-0"



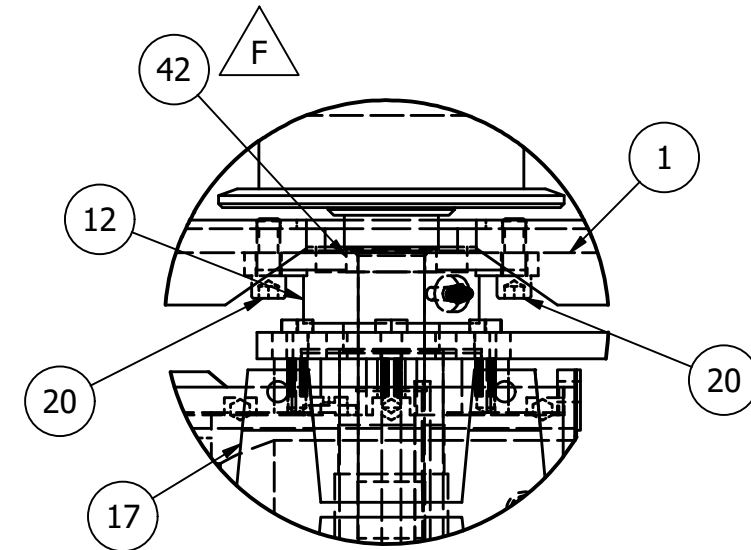
ENLARGED VIEW 'B'
SCALE 3" = 1'-0"

SPEED FORMULA (60HZ):

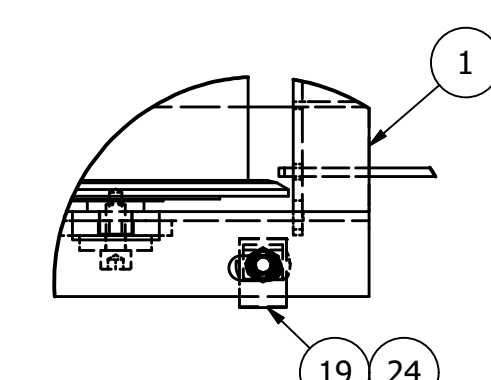
$$\pi \times 1740 \times \frac{1}{13.61} \times \frac{140}{1000} = 56.2 \text{ m/min} = 184.5 \text{ ft/min}$$



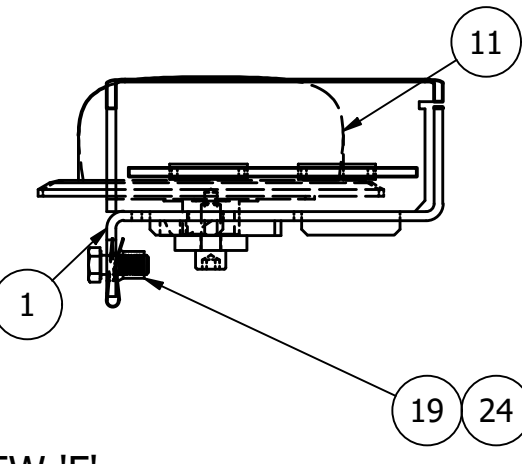
ENLARGED VIEW 'D'
SCALE 6" = 1'-0"



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



ENLARGED VIEW 'F'
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.

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MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D306

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-D306A			
2	2	MK-D350A ~ D-LOC PRB6 FRAME WELDMENT			
3	1	MK-D114A ~ STATIC WHEEL ASSEMBLY			
4	1	MK-D119A ~ ENCODER READER MTG PL			
5	2	MK-D119B ~ ENCODER READER HORSESHOE PL			
6	1	MK-D120A ~ END COVER PLATE			
7	10	MK-D120B ~ MID COVER PLATE			
8	1	MK-D121A ~ ROLLER WASHER			
9	1	MK-D121B ~ MOTOR END SPACER			
10	1	MK-D116B ~ DRIVE ROLLER SPACER			
11	5	PALLET DRIVER ROLLER, DUGOMRULLI PART NO 332192V M12			
12	2	PALLET DRIVEN ROLLER, DUGOMRULLI PART NO 329638V			
13	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
14	5	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
15	1	GATES POWERGRIP GT4 BELT ~ 2400-8MGT-85		2-1	
16	1	WCS-MP1 ~ BAR CODE READER MTG PLATE ~ PEPPERL&FUCHS		4-2	
17	1	WCS3B-LS310D READ HEAD ~ PEPPERL&FUCHS		4-1	
18	1	SIEMENS RB3 GEARMOTOR (SEE MOTOR DATA LIST)		17-1	
19	18	MK-D384A ~ RF CODE READER BKT			
20	4	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
21	13	M12x1.75 x 30mm LG. HEX SOCKET HEAD CAP SCREW			
22	1	M12 SPRING LOCK WASHER			
23	10	M10x1.5 x 25mm LG. HEX SOCKET HEAD CAP SCREW			
24	18	M10x1.5 x 25mm LG. HEX SOCKET HEAD CAP SCREW			
25	2	M10x1.5 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
26	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
28	2	M6 NARROW FLAT WASHER			
29	4	M3x0.5 x 10mm LG. HEX SOCKET HEAD CAP SCREW			
30	2	M10 SPRING LOCK WASHER			
31	20	M12 NARROW FLAT WASHER			
32	20	M12 x 1.75 STOVER LOCK NUT			
33	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	
34	2	M6x1 x 20mm LG. HEX CAP SCREW			
35	2	M10 NARROW FLAT WASHER			
36	2	M10 x 1.5 STOVER LOCK NUT			
37	2	M10x1.5 x 30mm LG. HEX CAP SCREW			
38	2	M6x1 x 20mm LG. HEX SOCKET HEAD CAP SCREW			
39	0	STEP AP203/Cat5 V3.1			
40	2	MK-D614A ~ VDL CONTROLLER BRACKET			
41	8	M12x1.75 x 35mm LG. HEX CAP SCREW			
42	1	MK-D116A ~ DRIVE ROLLER SPACER			

REV	BY	DATE	DESCRIPTION	APP
F	MC	10/6/2022	MOVED ITEM 9, ADDED ITEM 42	
E	MC	9/29/22	ADDED ITEMS '40' & '41', QUANTITIES INCREASED FOR ITEMS '31' & '32'	
D	MC	8/30/22	ORIENTATION OF VIEW A-A UPDATED.	
C	MC	8/19/2022	REVISED SCREWS, BALLOONS	
B	MC	8/12/2022	RELOCATED RF READER BRACKET & REVISED CAP SCREW, WAS M5, ADDED M10 HARDWARE	
A	MC	8-8-2022	FOR FABRICATION	

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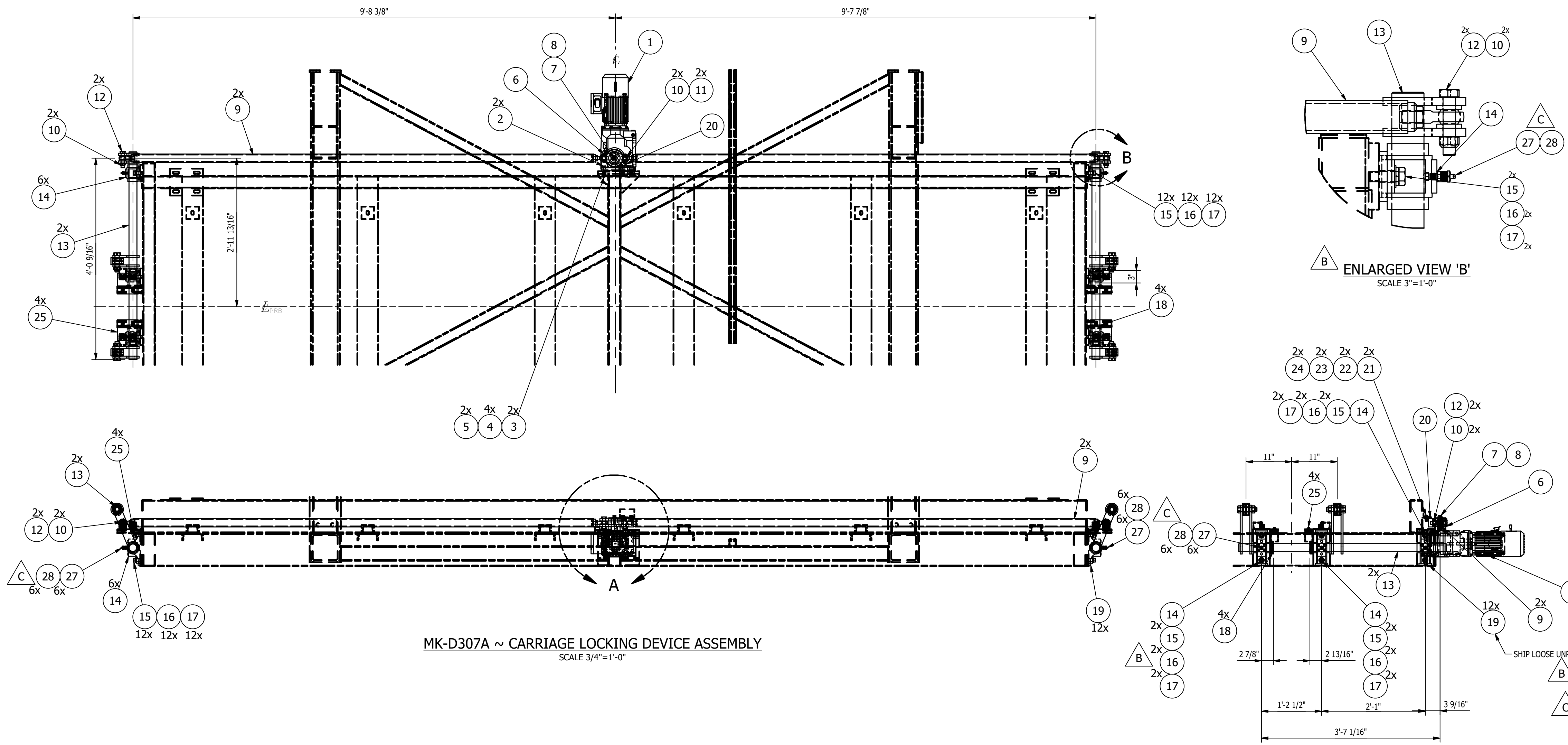
TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D306

REV: F

DRAWN BY: JC
CHECKED BY: JCK
DWG DATE: 8/1/22
JOB No: 22096



MK-D307A ~ CARRIAGE LOCKING DEVICE ASSEMBLY
SCALE 3/4"=1'-0"

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

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D307A VDL2 GEARMOTOR PER MOTOR DATA SHEET		1-6	
2	2	1/2-13UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
3	2	1/2-13UNC x 2 1/4" LG. HEX HEAD CAP SCREW			
4	4	1/2 SPRING LOCK WASHER			
5	2	1/2-13UNC HEX NUT			
6	1	MK-D339A ~ PIVOTING CRANK WELDMENT			
7	1	MK-D339D ~ CAP PLATE			
8	1	M12x1.75 x 30mm LG. HEX SOCKET HEAD CAP SCREW			
9	2	MK-D339B ~ CONNECTING SHAFT ASSEMBLY			
10	4	3/4-16UNF STOVER LOCK NUT			
11	2	3/4-16UNF x 2 3/4" LG. HEX HEAD CAP SCREW			
12	2	3/4-16UNF x 3 1/2" LG. HEX HEAD CAP SCREW			
13	2	MK-D339C ~ LOCKING SHAFT ASM			
14	6	SPLIT BABBITTED SLEEVE BEARING, 1-15/16" BORE, P2B-BASP-115, DODGE PART NO. 006052		7-3	
15	12	5/8 SPRING LOCK WASHER			
16	12	5/8 TYPE A NARROW FLAT WASHER			
17	12	5/8-11UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
18	4	2-PIECE CLAMP COLLAR, 1 15/16" ID, McMASTER-CARR PART NO. 6436K66		7-8	
19	12	SQ. BAR 1/2 (SHIP LOOSE, UNPAINTED)	3"		
20	1	D339E ~ CONNECTING SHAFT STOP WELDMENT			
21	2	3/8-16UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
22	2	3/8 TYPE A NARROW FLAT WASHER			
23	2	3/8 SPRING LOCK WASHER			
24	2	3/8-16UNC HEX NUT			
25	4	MK-D339F ~ LOCK INDICATOR ASM			
26	1	M12 SPRING LOCK WASHER			
27	6	DODGE 1/4 x 1/8 NPT REDUCER BUSHING		23-2	
28	6	DODGE 1/8 NPT GREASE FITTING		23-1	

- 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.

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/12/22	ADDED ITEMS '27' & '28'	
B	MC	8/19/2022	GENERAL ADDED BALLONS & VIEW & ITEM 26	
A	MC	8-8-2022	FOR FABRICATION	

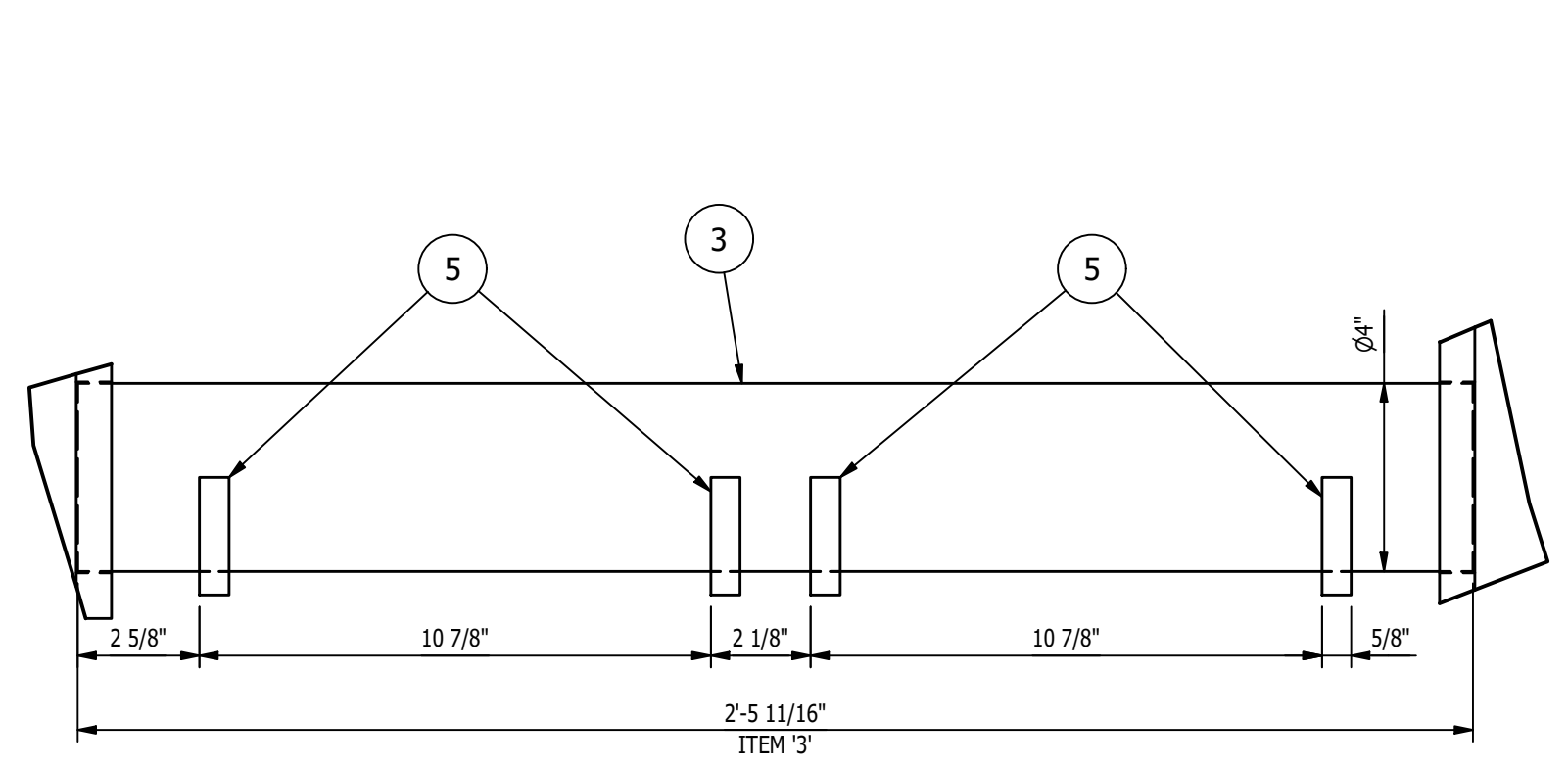
REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
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TITLE: P6700 CONVEYORS		DRAWN BY: AH		CHECKED BY: JCK	
CLIENT: VOLVO		DWG DATE: 7/22/22		JOB No: 22096	
DRAWING No. 1875D307		REV: C			

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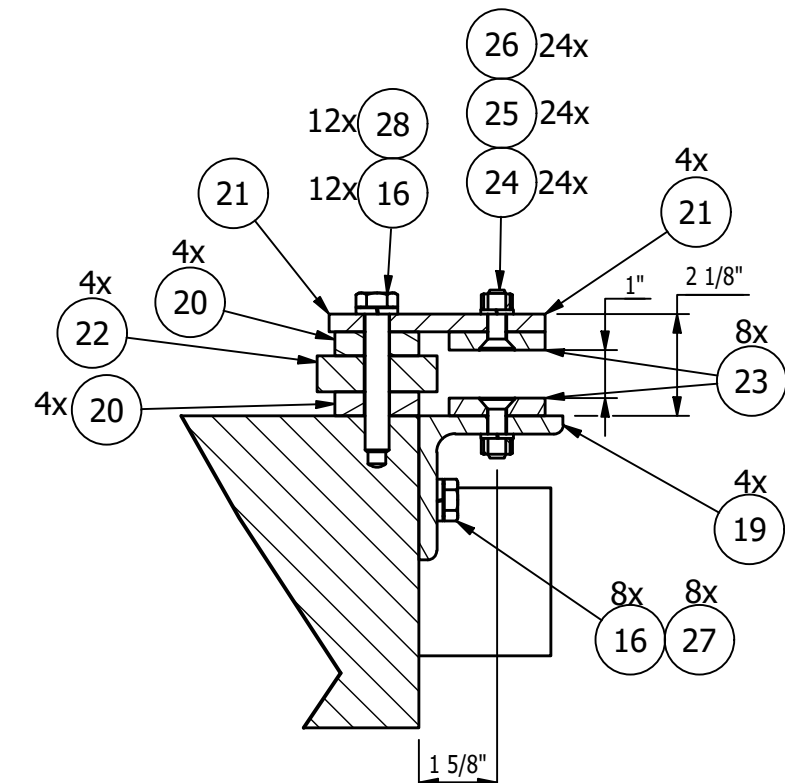
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

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 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.

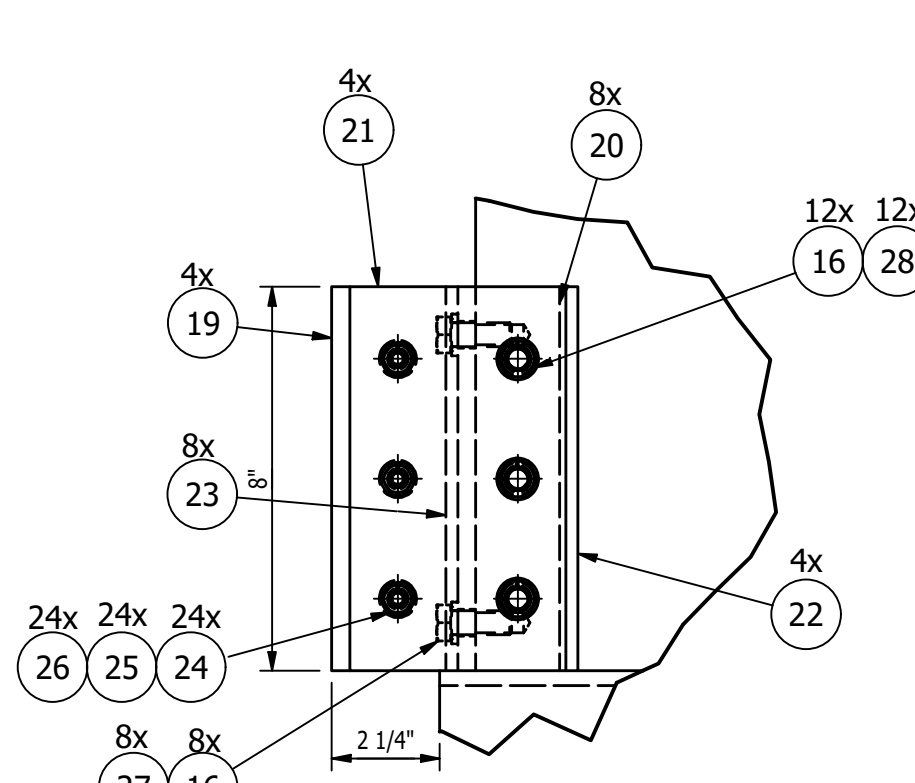
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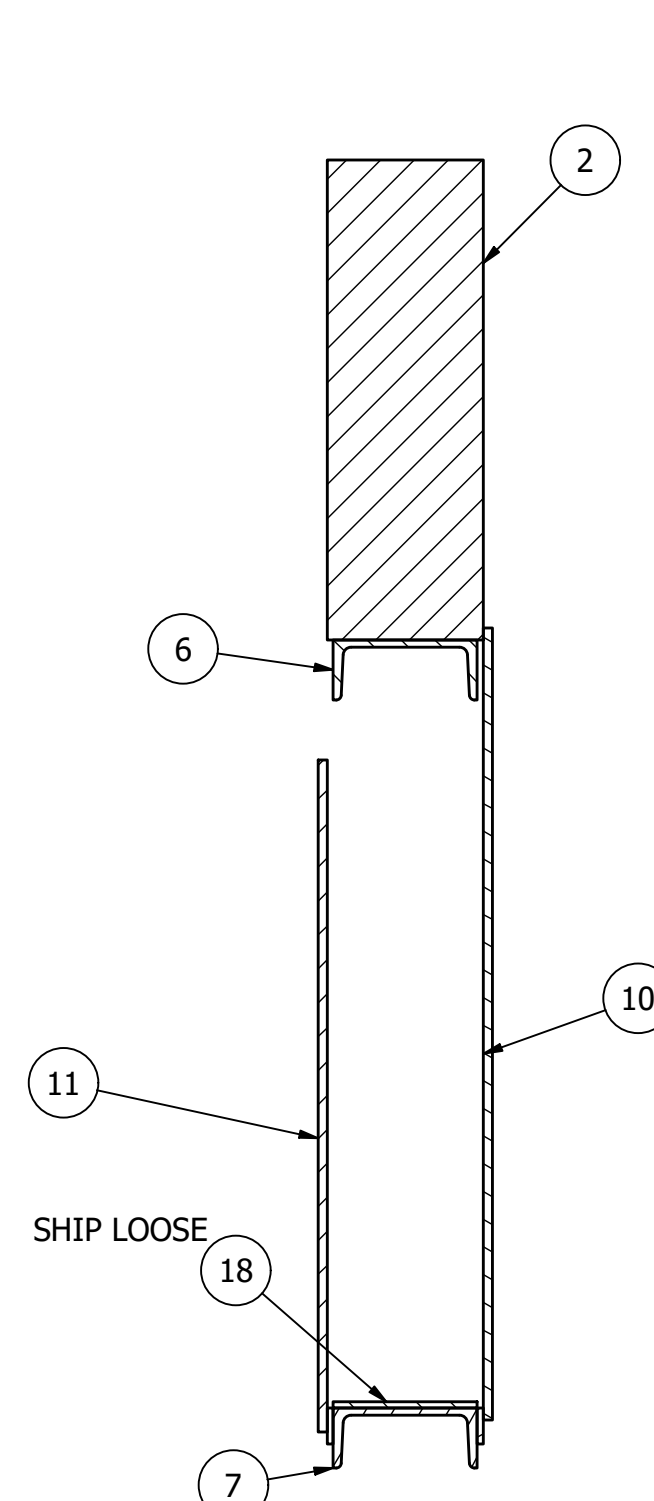
ENLARGED VIEW 'C'
SCALE 3" = 1'-0"



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

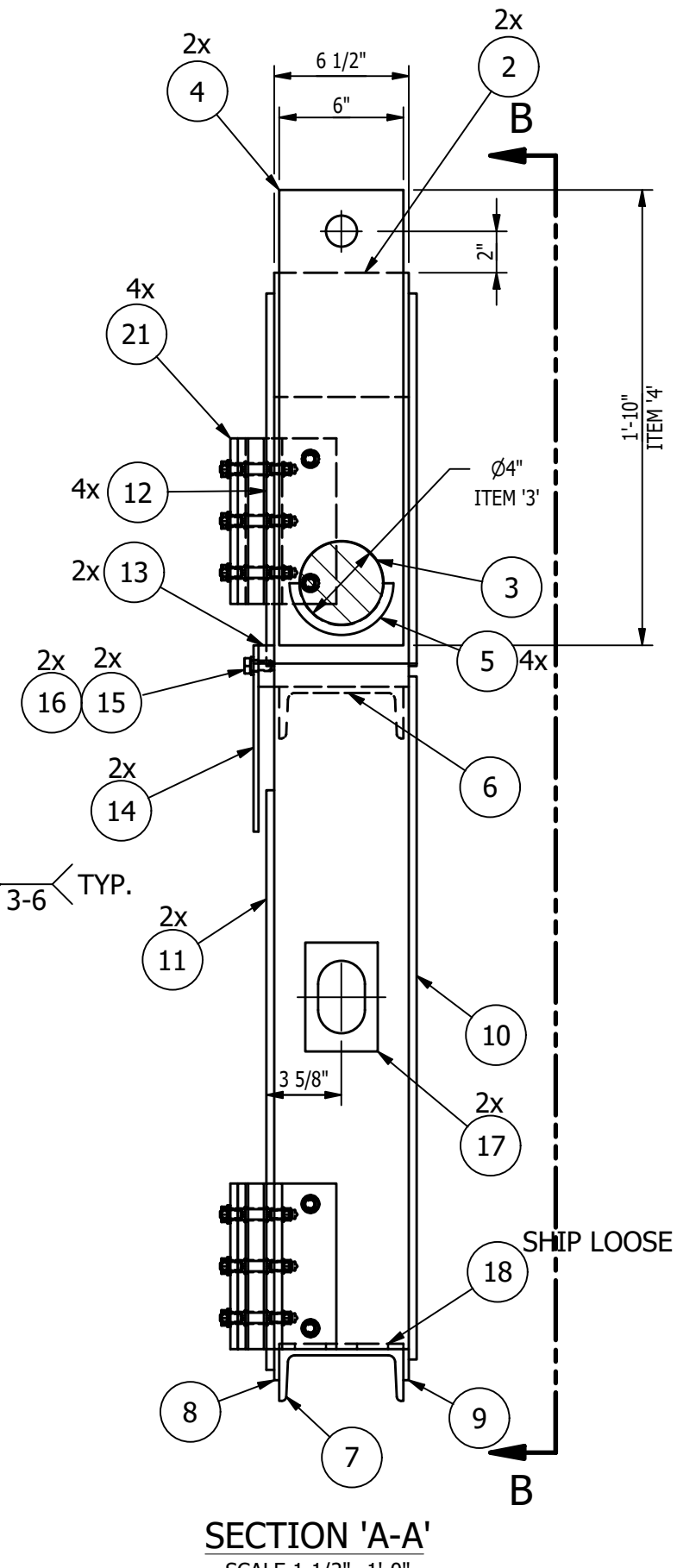
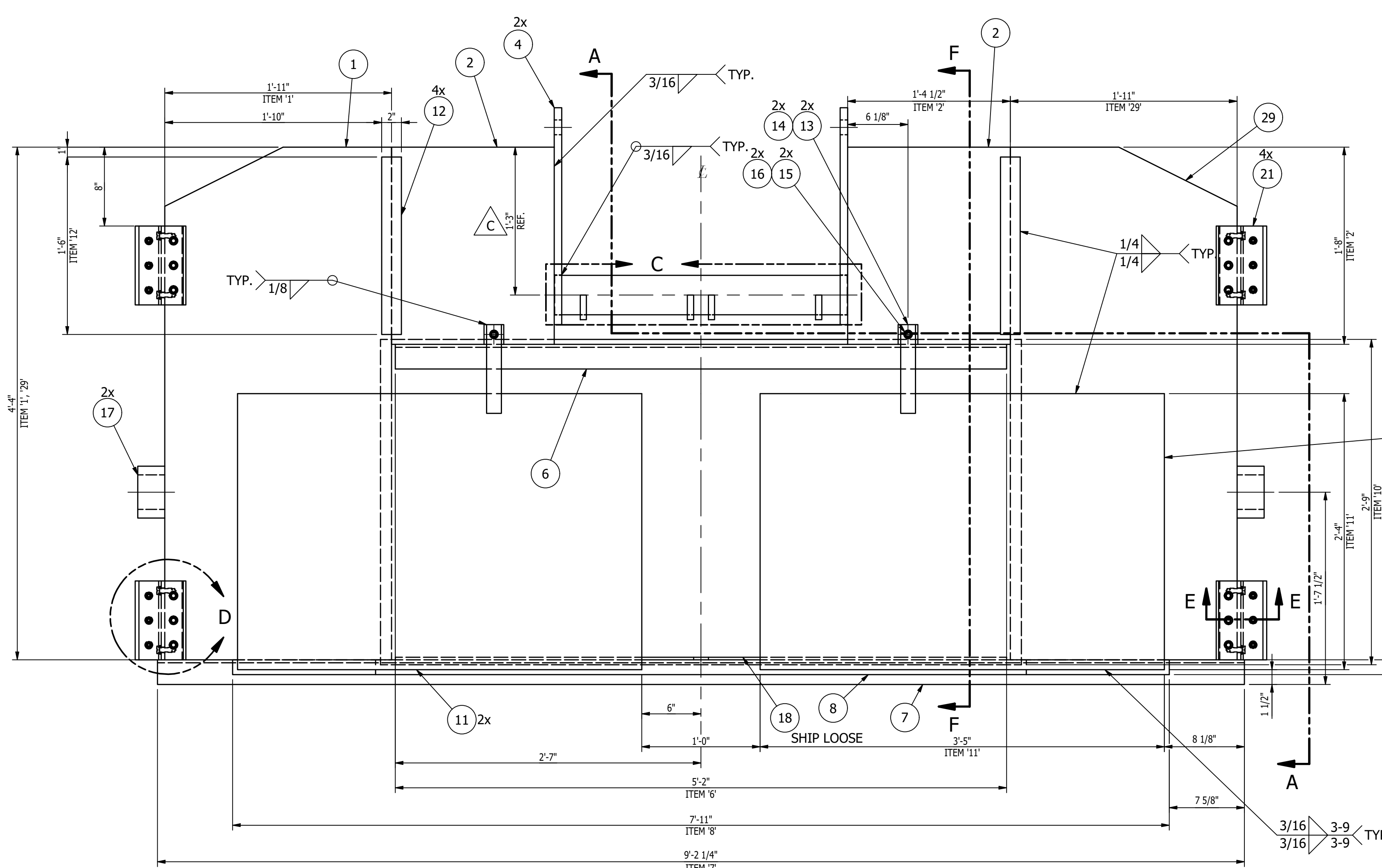
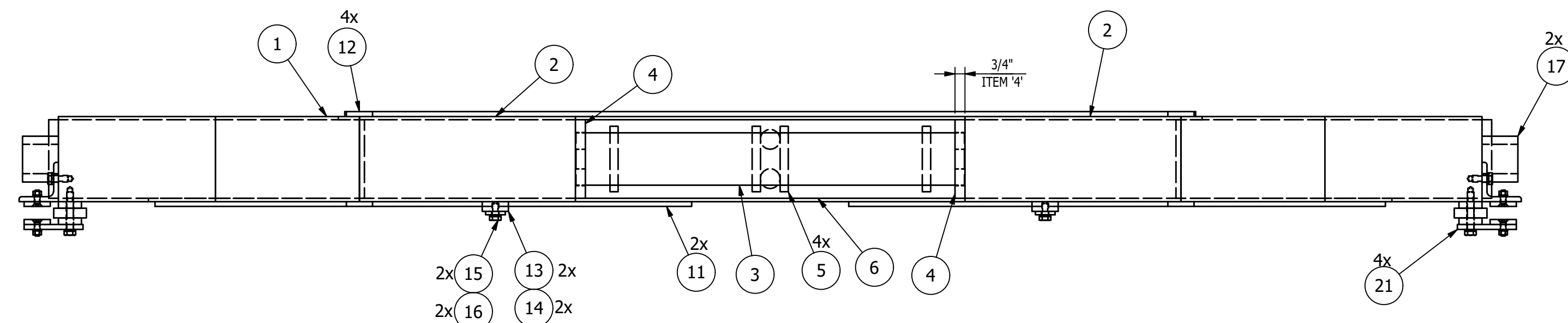


ENLARGED VIEW 'D'
SCALE 3" = 1'-0"

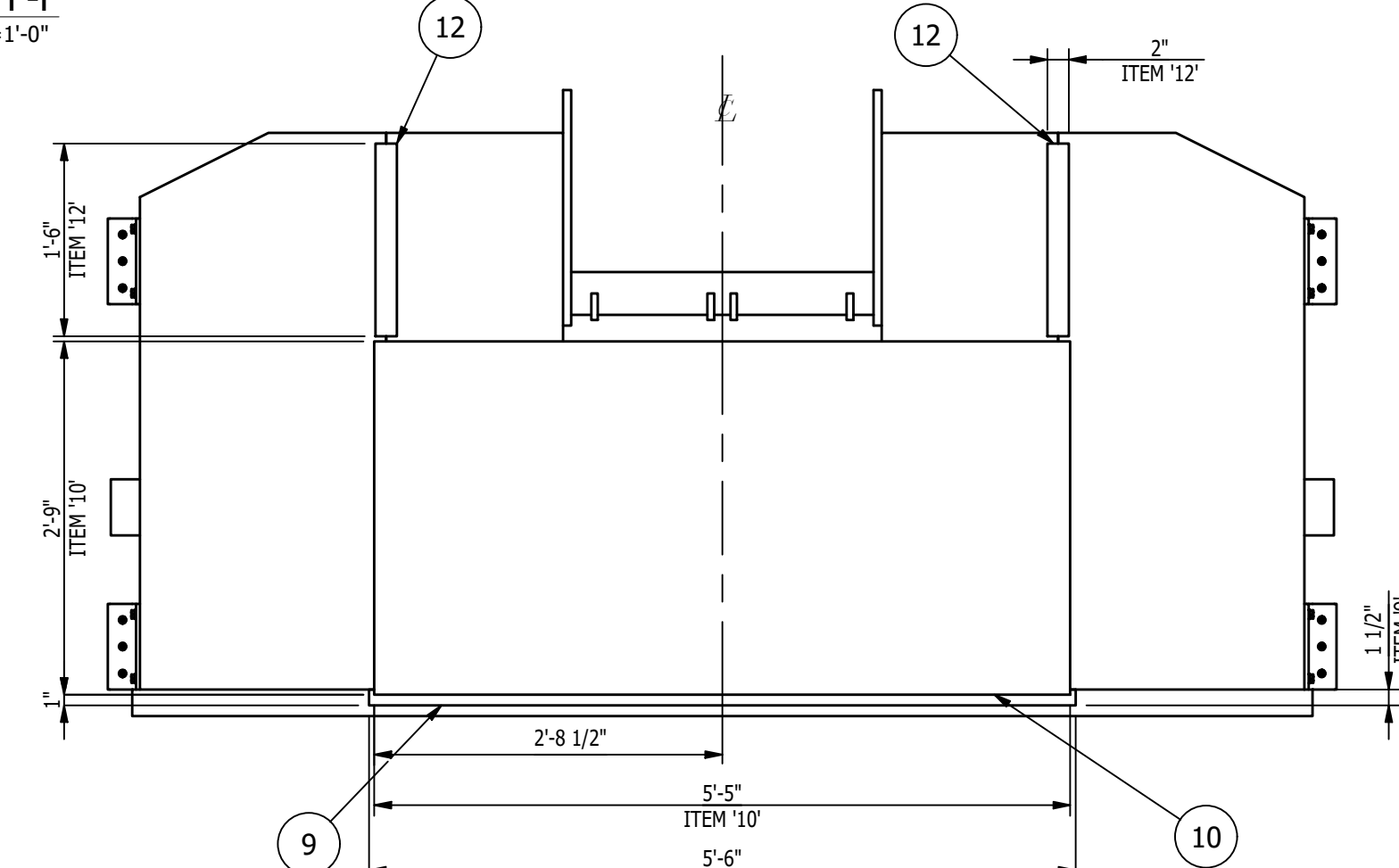


SECTION 'F-F'
SCALE 1 1/2" = 1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D308A			
1	1	PL 6 1/2 x 1'-11"	4'-4"		
2	2	PL 6 1/2 x 1'-4 1/2"	1'-8"		
3	1	BAR Ø4	2'-5 11/16"		
4	2	BAR 3/4 x 6	1'-10"		
5	4	TS 5 OD x 1/2 DOM	5/8"		
6	1	MC 6 x 12	5'-2"		
7	1	MC 6 x 12	9'-2 1/4"		
8	1	BAR 1/4 x 1 1/2	7'-11"		
9	1	BAR 1/4 x 1 1/2	5'-6"		
10	1	PL 3/8 x 2'-9"	5'-5"		
11	2	PL 3/8 x 2'-4"	3'-5"		
12	4	BAR 3/8 x 2	1'-6"		
13	2	BAR 3/4 x 2	2"		
14	2	BAR 1/4 x 1 1/2	9"		
15	2	1/2-13UNC x 1" LG. HEX HEAD CAP SCREW			
16	22	1/2 SPRING LOCK WASHER			
17	2	PL 2 3/4 x 3 1/2"	5 1/4"		
18	72	BAR 1/4 x 6	5'-2"		
19	4	L 3 x 3 x 3/8	8"		
20	8	BAR 1/2 x 1 3/4	8"		
21	4	BAR 3/8 x 4 1/2	8"		
22	4	UHMW BAR 3/4 x 2 1/2	8"		
23	8	UHMW BAR 3/8 x 2	8"		
24	24	3/8-16UNC x 1 1/4" LG. FLAT HEX SOCKET HEAD CAP SCREW			
25	24	3/8 SPRING LOCK WASHER			
26	24	3/8-16UNC HEX NUT			
27	8	1/2-13UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
28	12	1/2-13UNC x 3" LG. HEX HEAD CAP SCREW			
29	1	PL 6 1/2 x 1'-11"	4'-4"		
TOTAL WEIGHT = 8075 Lbs					



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



VIEW 'B-B'
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.
 9. VIBRATING STRESS RELIEVE WELDMENT
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE RAL 2004
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.
DO NOT PAINT UHMW

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/30/22	ADDED ITEM '29', CHAMFER ADDED AND HOLE SPACING UPDATED ON ITEM '1', ITEM '3' LOWERED 4", & ITEM '4' HOLE SPACING UPDATED	
B	MC	8/19/2022	ADDED PAINT NOTE & REVISION BLOCK ON SHT 2	
A	MC	8/8/2022	FOR FABRICATION	

SHEET 1 OF 2

MK-D308A ~ VDL COUNTERWEIGHT ASSEMBLY
SCALE 1 1/2" = 1'-0"

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MAGNUM DRAWING #: 1875D308

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.

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FENTON, MI 48430
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TITLE: P6700 CONVEYORS
CAMPUS BUILDING

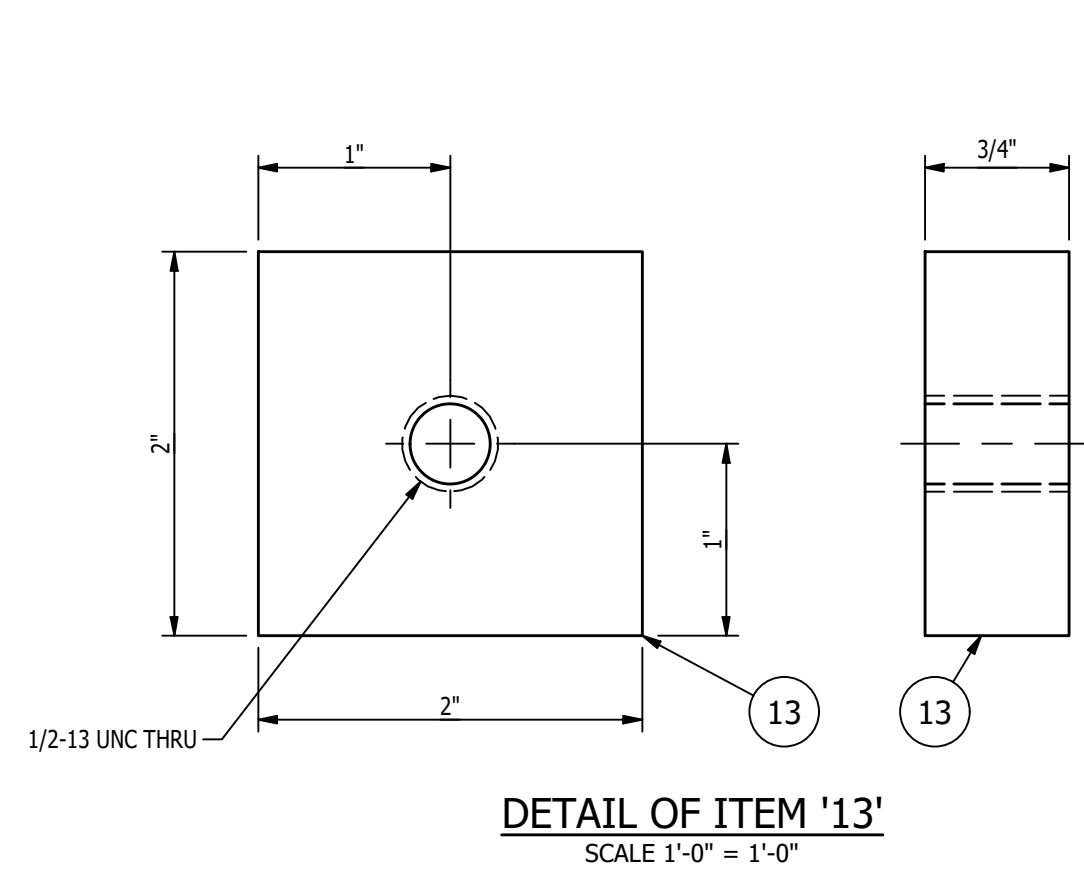
CLIENT: VOLVO

DRAWING No. 1875D308

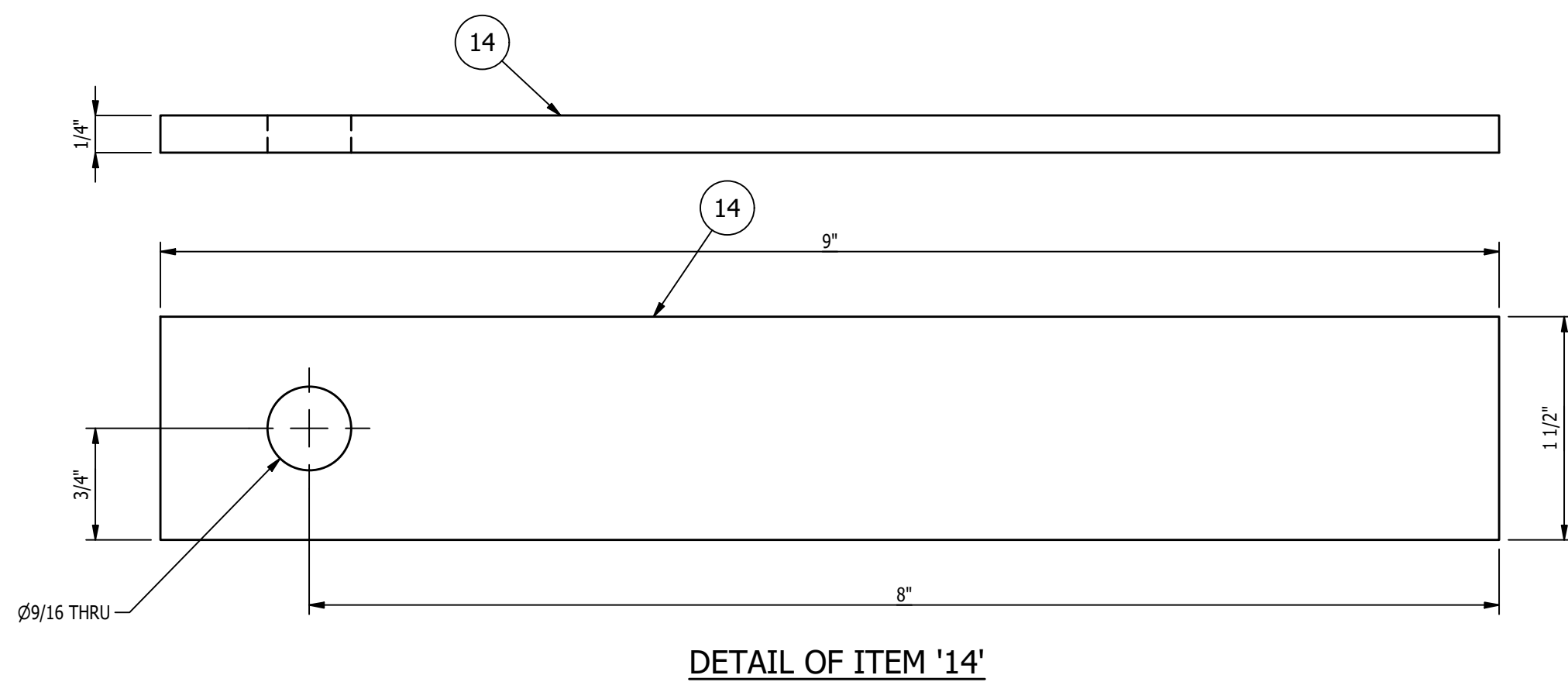
REV: C

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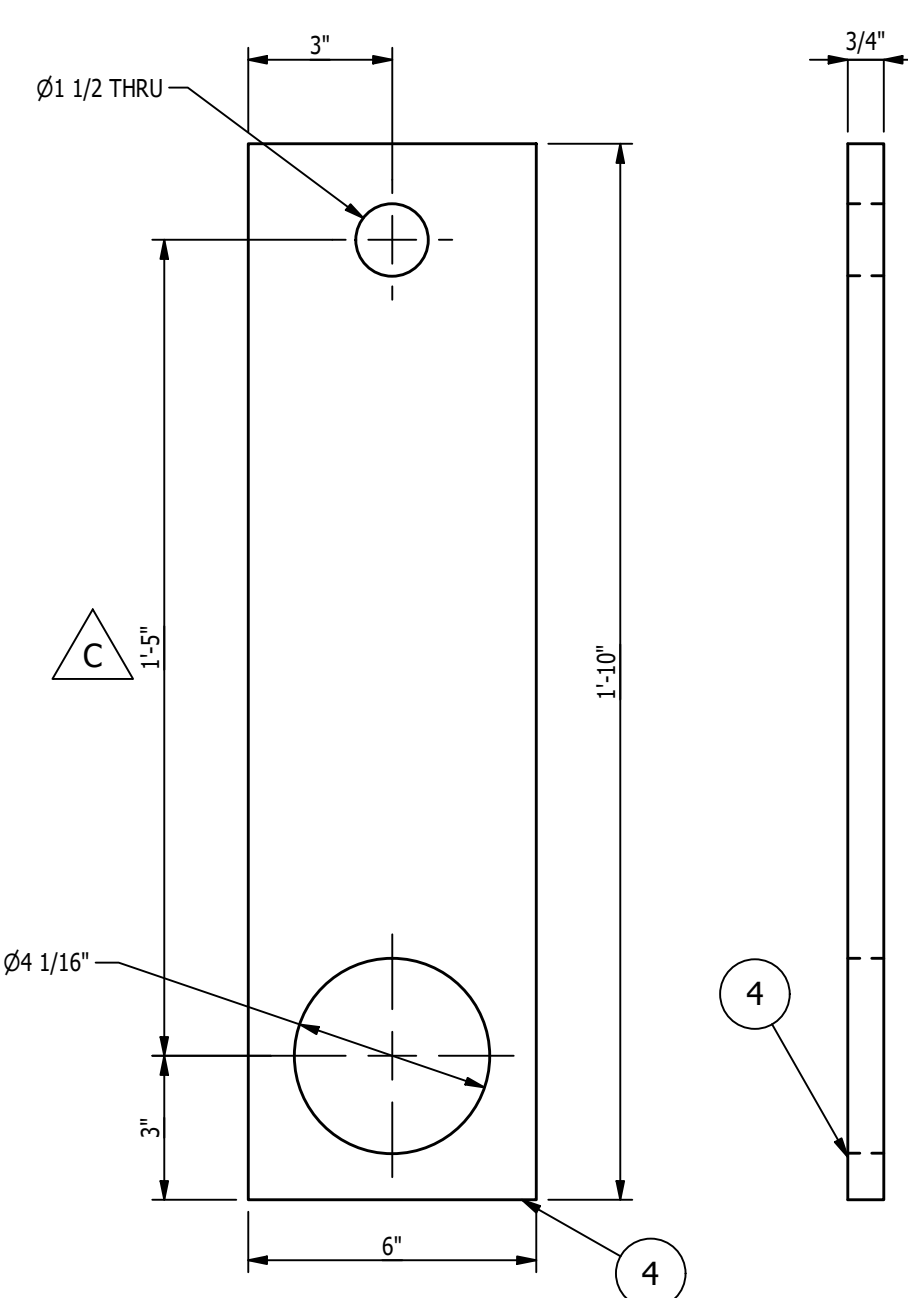
DRAWN BY: AH
CHECKED BY: JCK
DWG DATE: 7/21/22
JOB No.: 22096



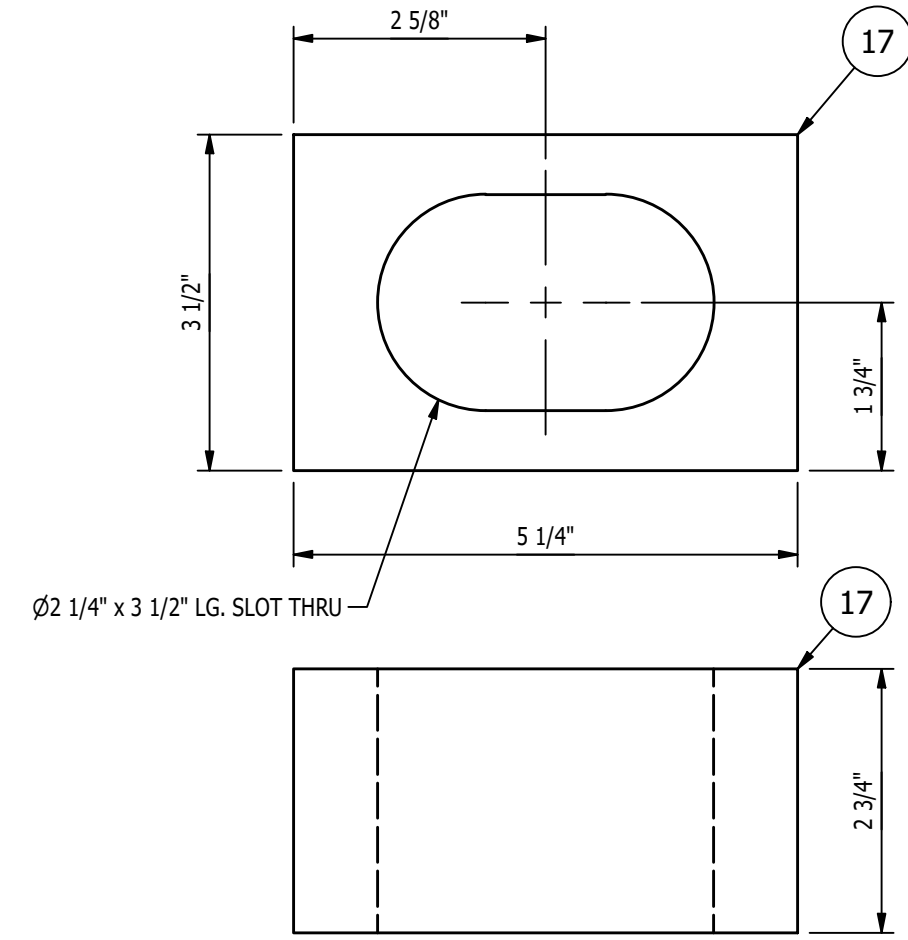
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SCALE 1'-0" = 1'-0"



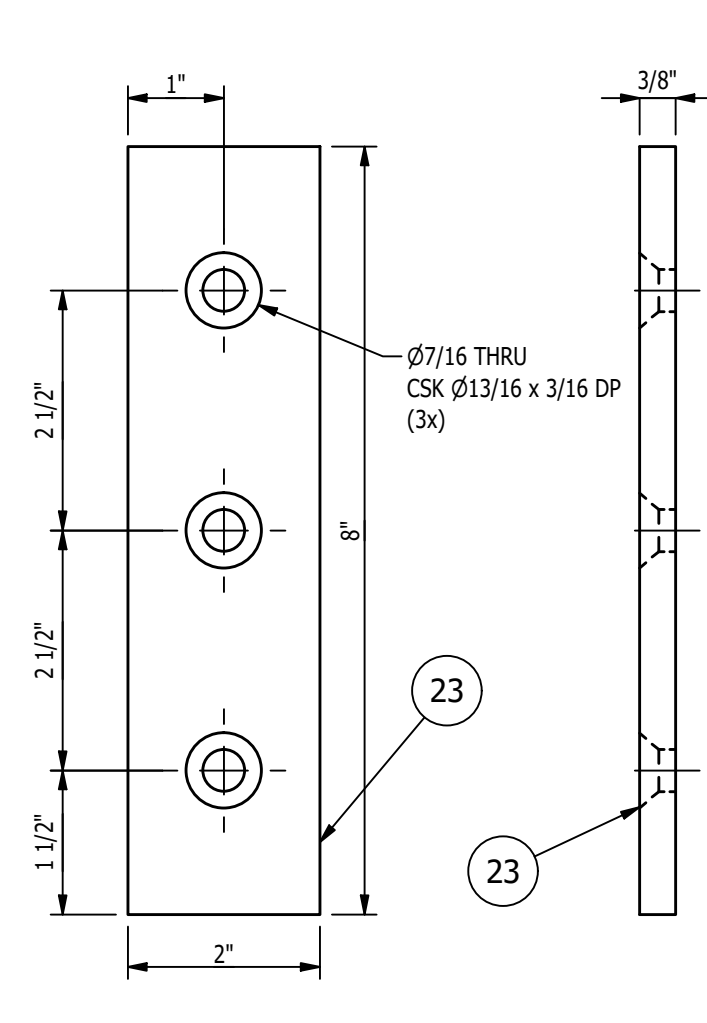
DETAIL OF ITEM '14'
SCALE 1'-0" = 1'-0"



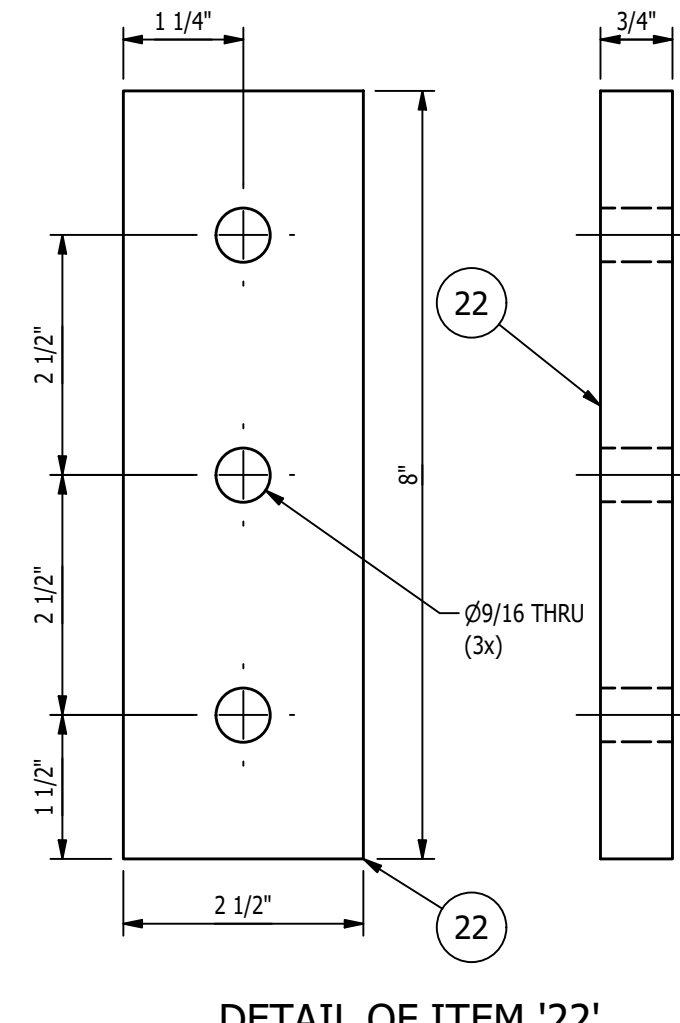
DETAIL OF ITEM '4'
SCALE 3" = 1'-0"



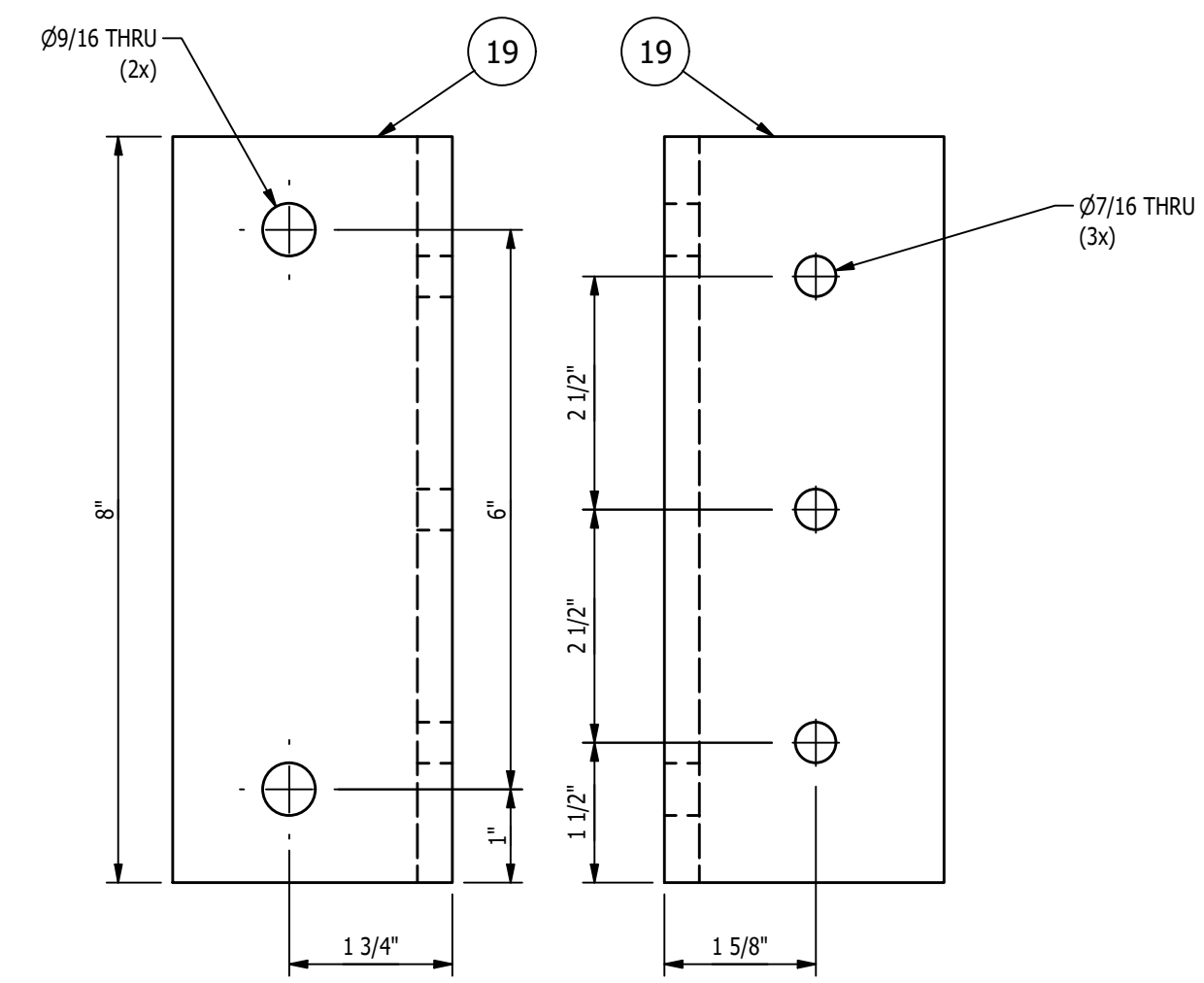
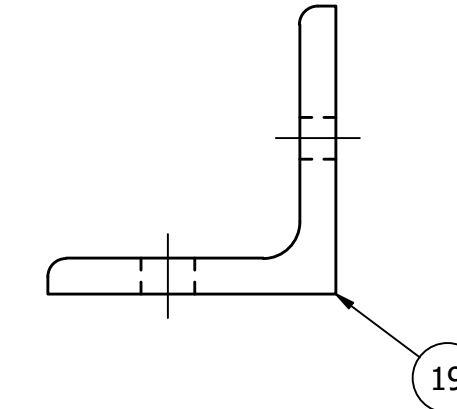
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SCALE 6" = 1'-0"



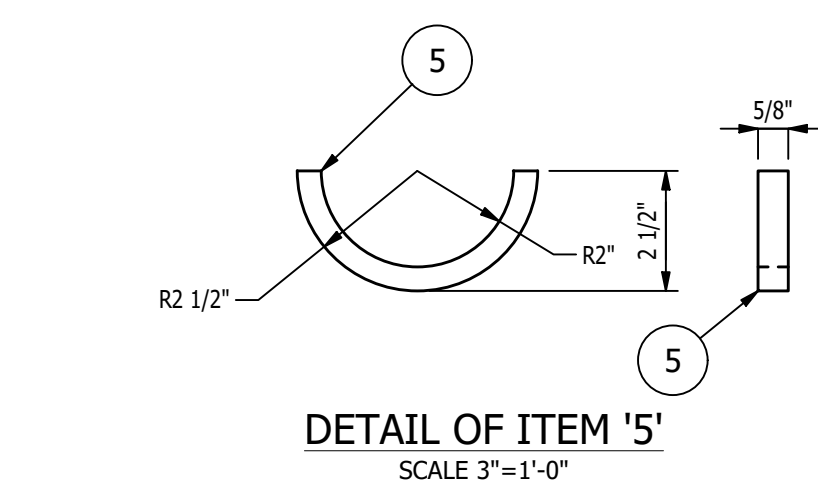
DETAIL OF ITEM '23'
SCALE 6" = 1'-0"



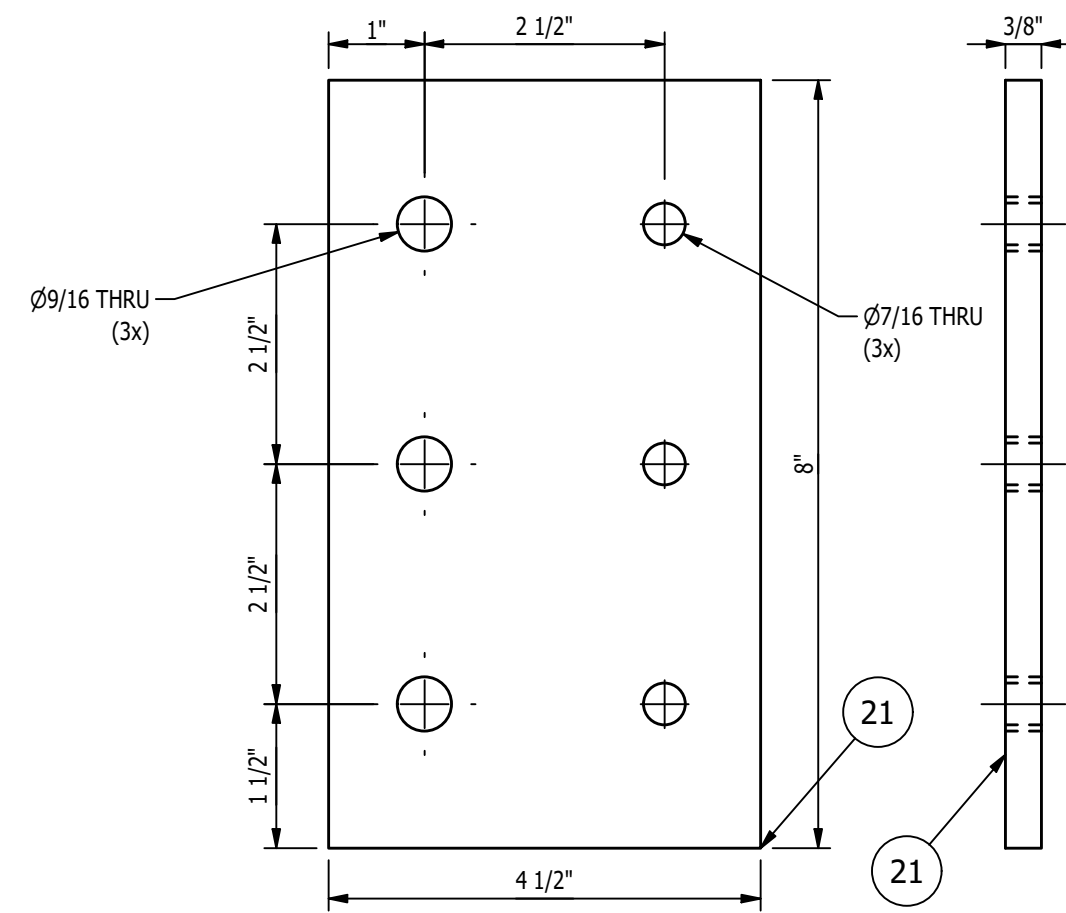
DETAIL OF ITEM '22'
SCALE 6" = 1'-0"



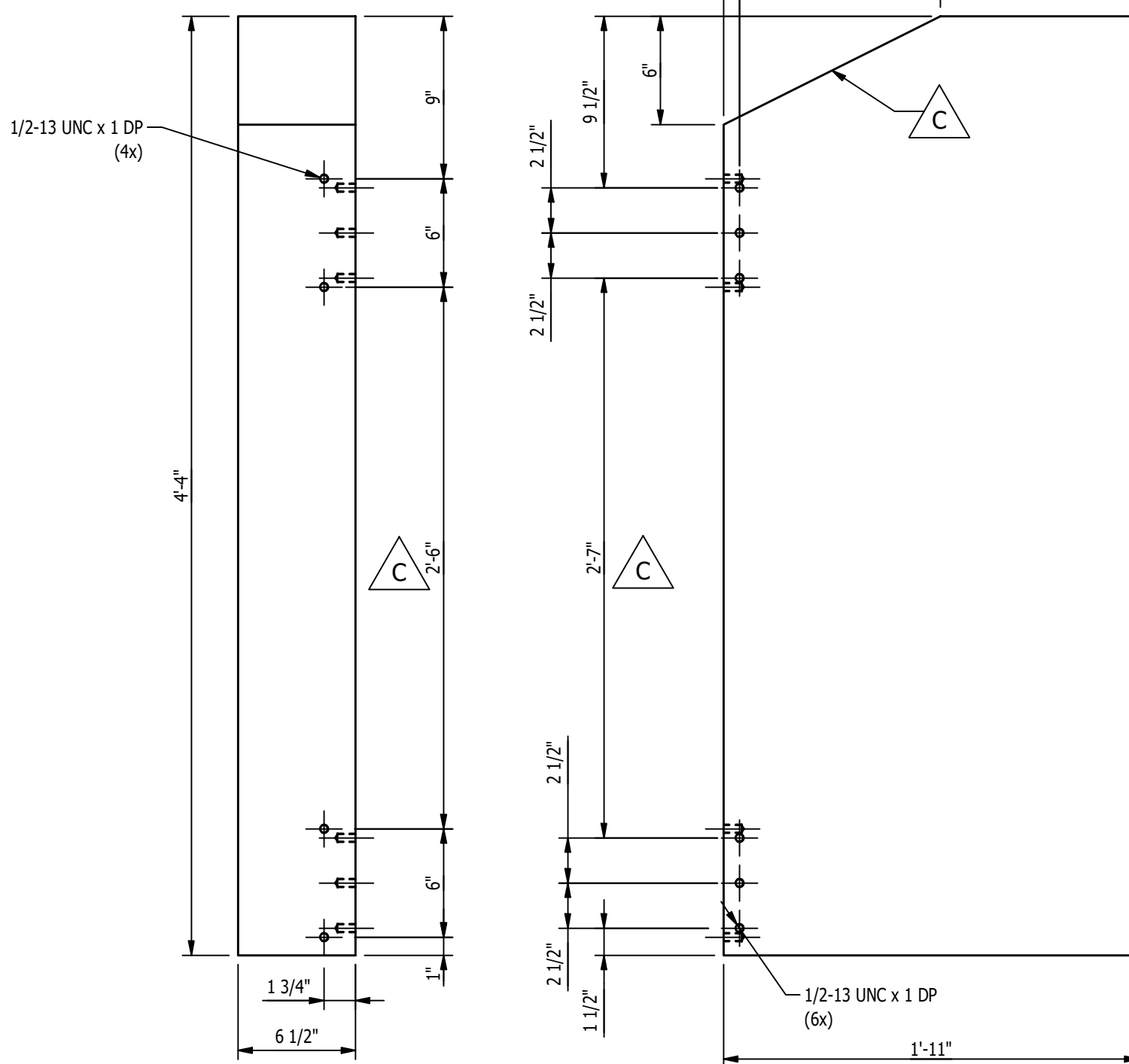
DETAIL OF ITEM '19'
SCALE 6" = 1'-0"



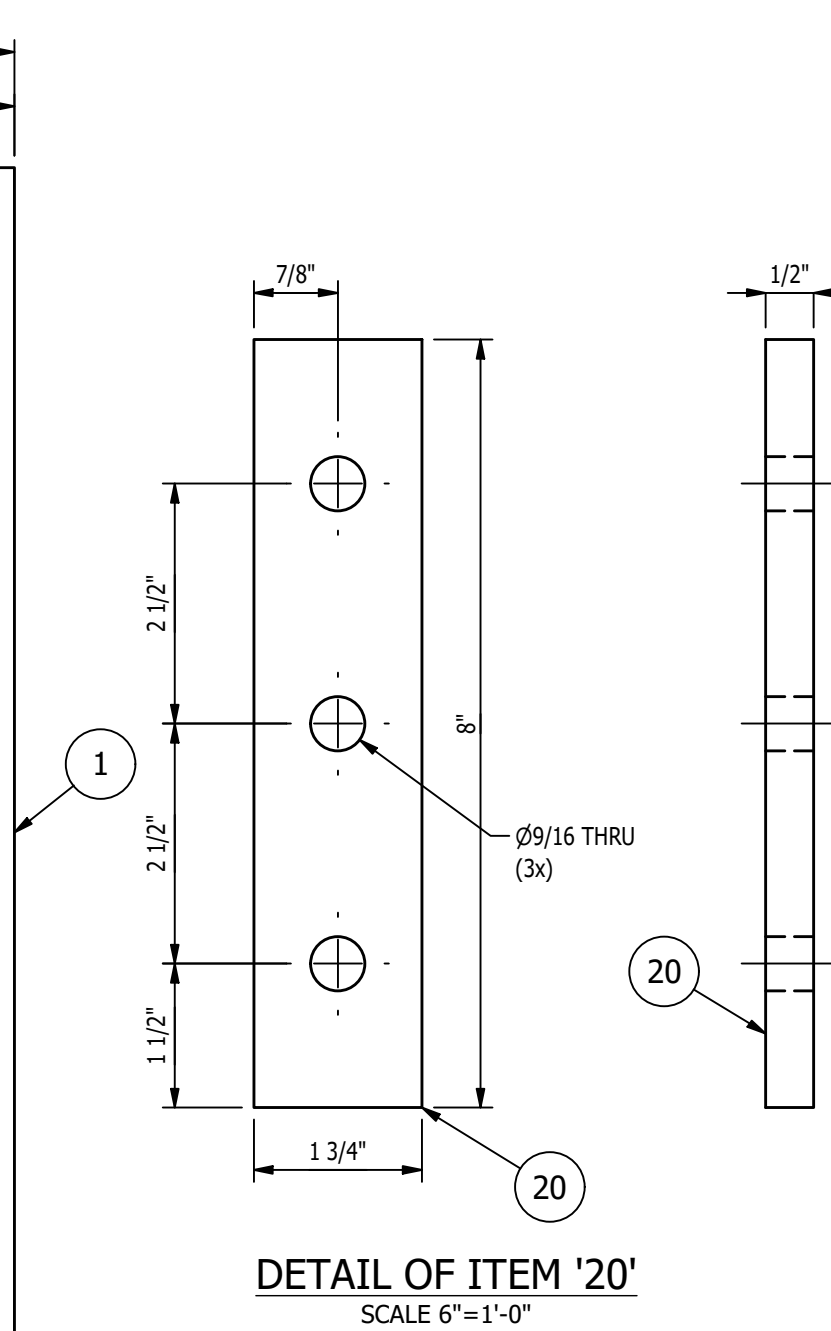
DETAIL OF ITEM '5'
SCALE 3" = 1'-0"



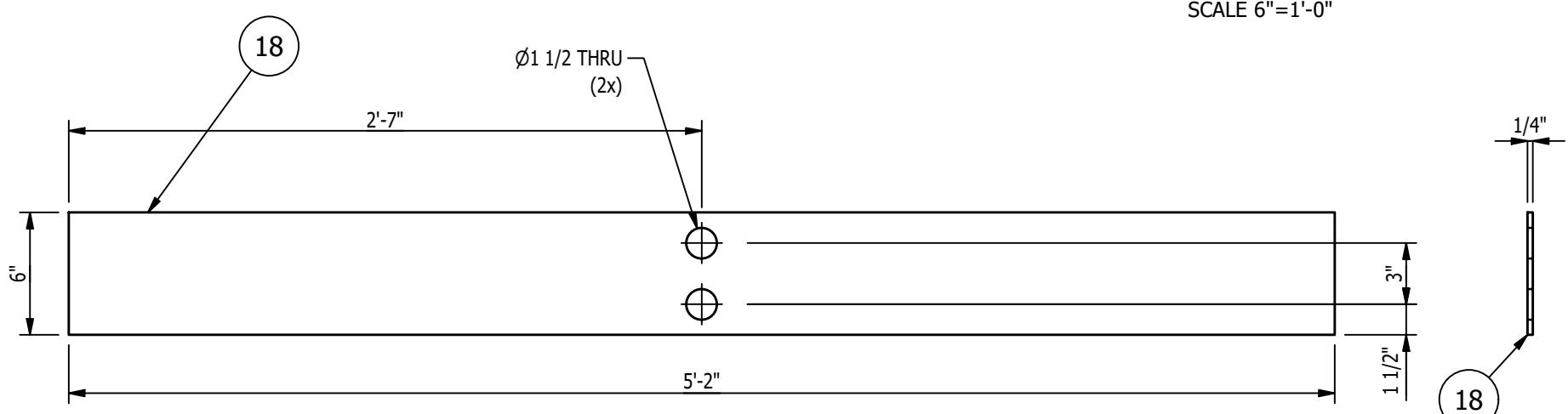
DETAIL OF ITEM '21'
SCALE 6" = 1'-0"



DETAIL OF ITEM '1' (SHOWN)
DETAIL OF ITEM '29' (OPPOSITE)
SCALE 1 1/2" = 1'-0"



DETAIL OF ITEM '20'
SCALE 6" = 1'-0"



DETAIL OF ITEM '18'
SCALE 1 1/2" = 1'-0"

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/30/22	ADDED ITEM '29', CHAMFER ADDED AND HOLE SPACING UPDATED ON ITEM '1', ITEM '3' LOWERED 4", & ITEM '4' HOLE SPACING UPDATED	
B	MC	8/19/2022	ADDED PAINT NOTE & REVISION BLOCK ON SHT 2	
A	MC	8/8/2022	FOR FABRICATION	

REVISION HISTORY

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.millic.com</p>	<p>TITLE: P6700 CONVEYORS CAMPUS BUILDING</p> <p>CLIENT: VOLVO</p> <p>DRAWING No. 1875D308</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</p> <p>XX = ±.030</p> <p>XXX = ±.005</p> <p>FRACTIONS = ±1/16"</p> <p>ANGLES = ±1°30'</p> <p>BREAK ALL SHARP EDGES</p> <p>DEBURR ALL HOLES</p> <p>DO NOT SCALE DRAWING</p>	<p>REVISION HISTORY</p> <p>REV: B</p>	

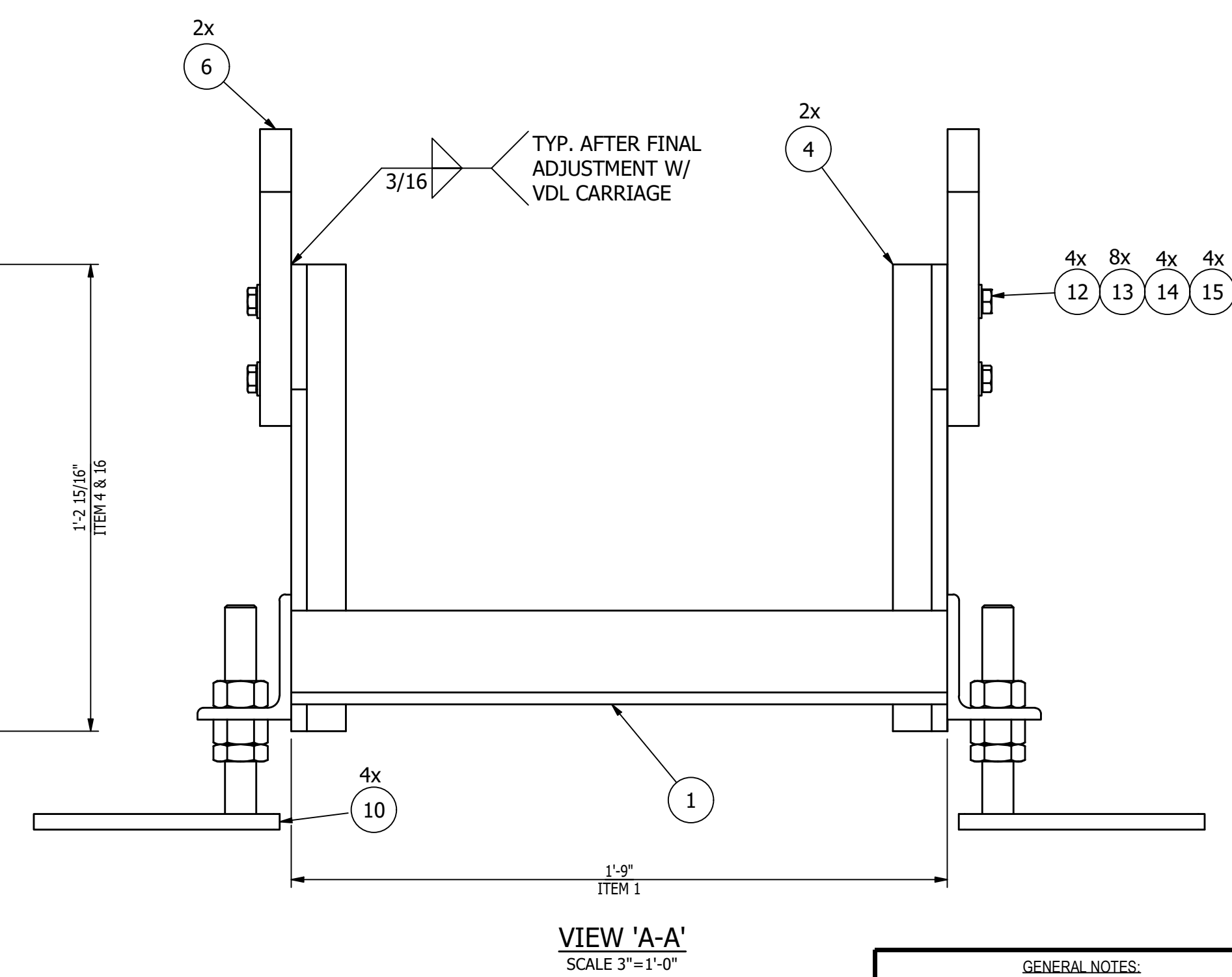
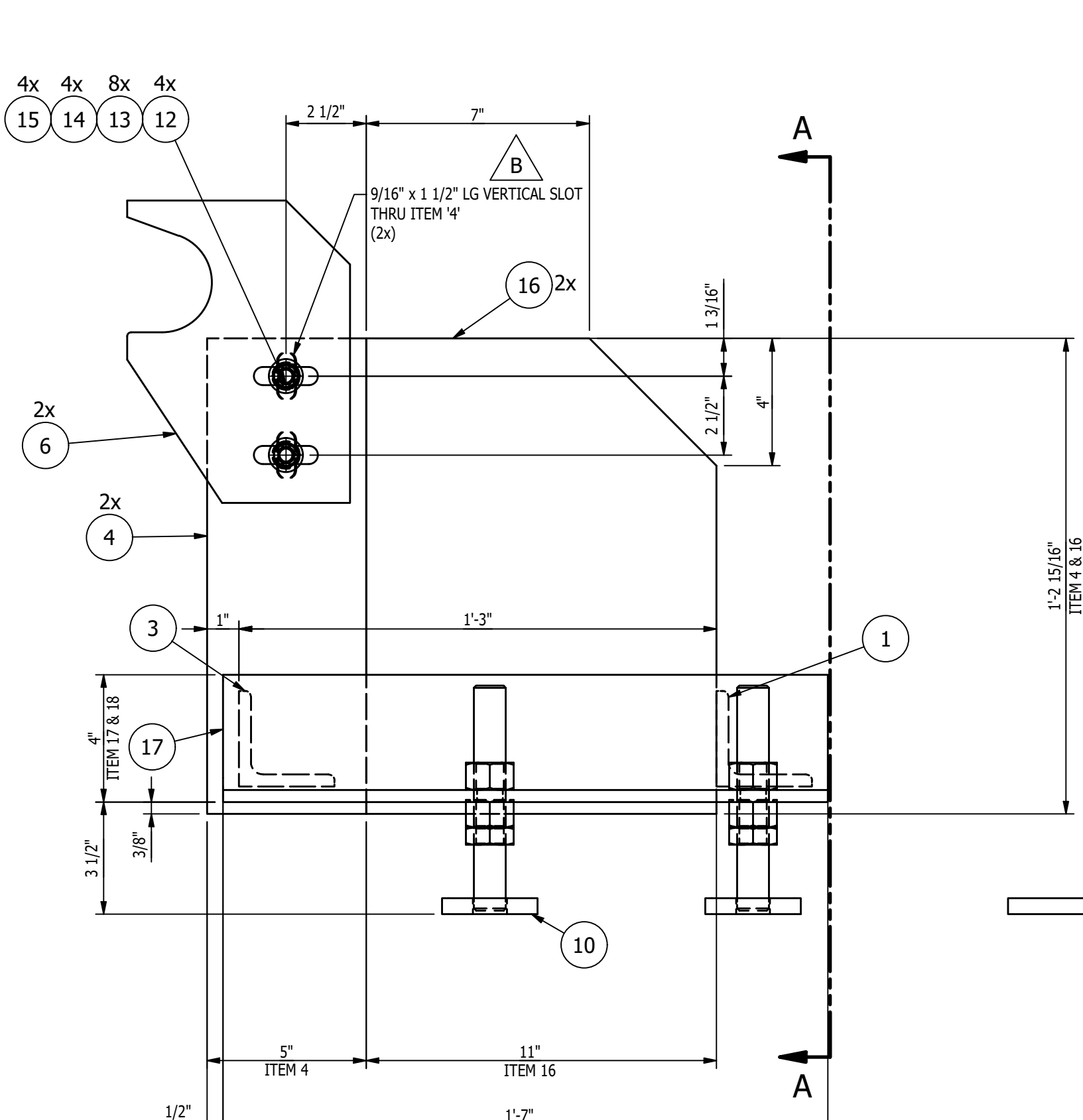
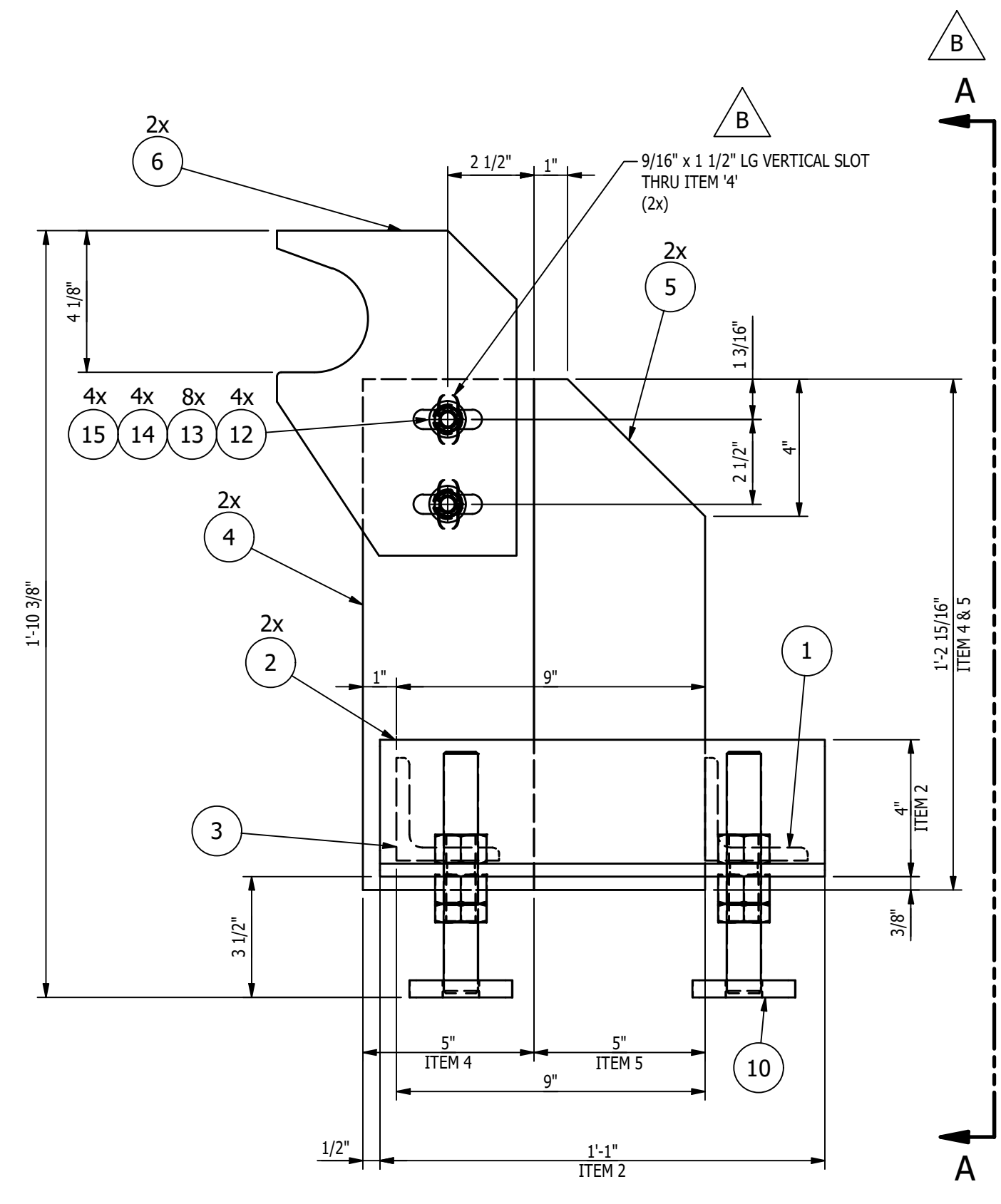
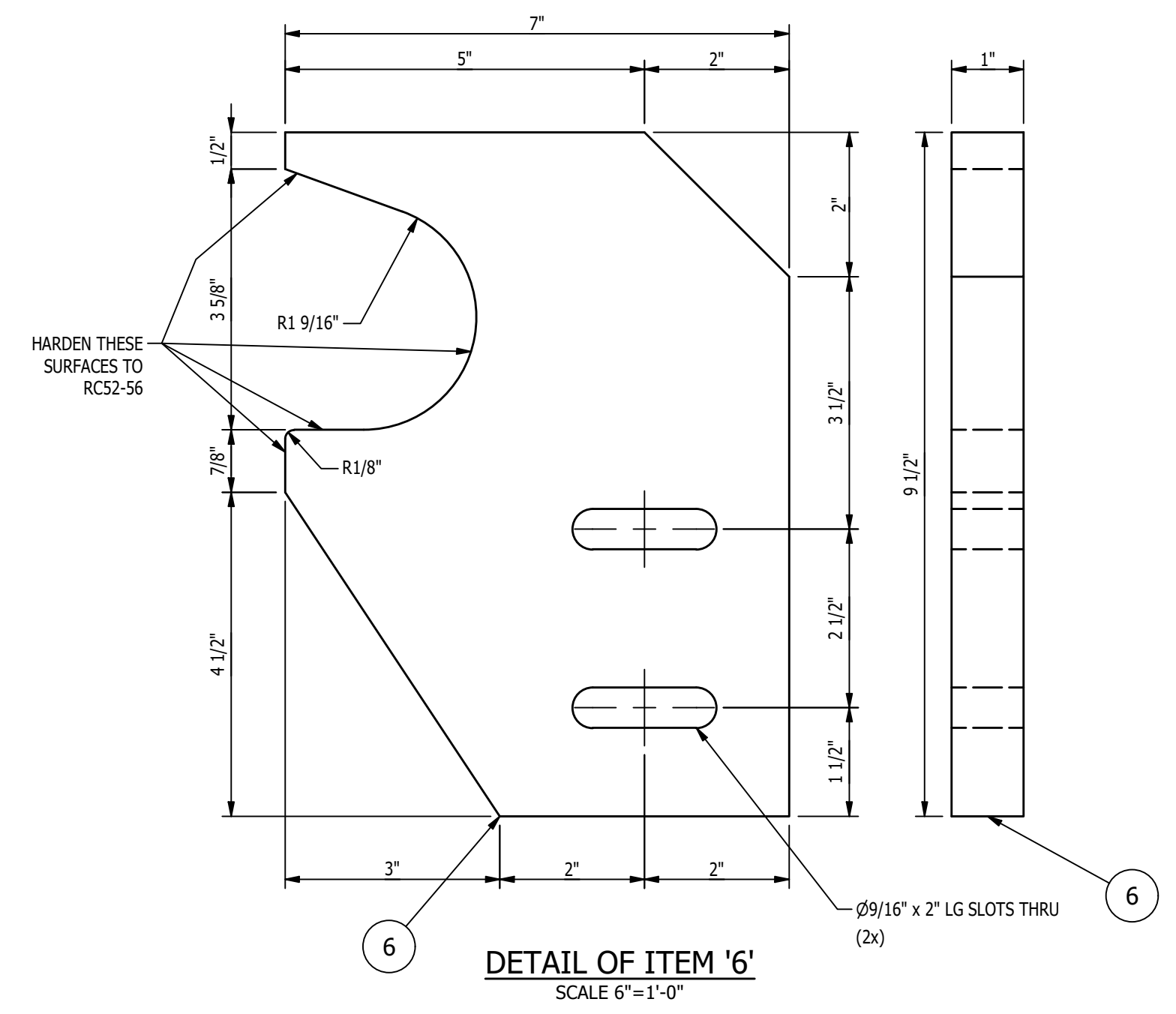
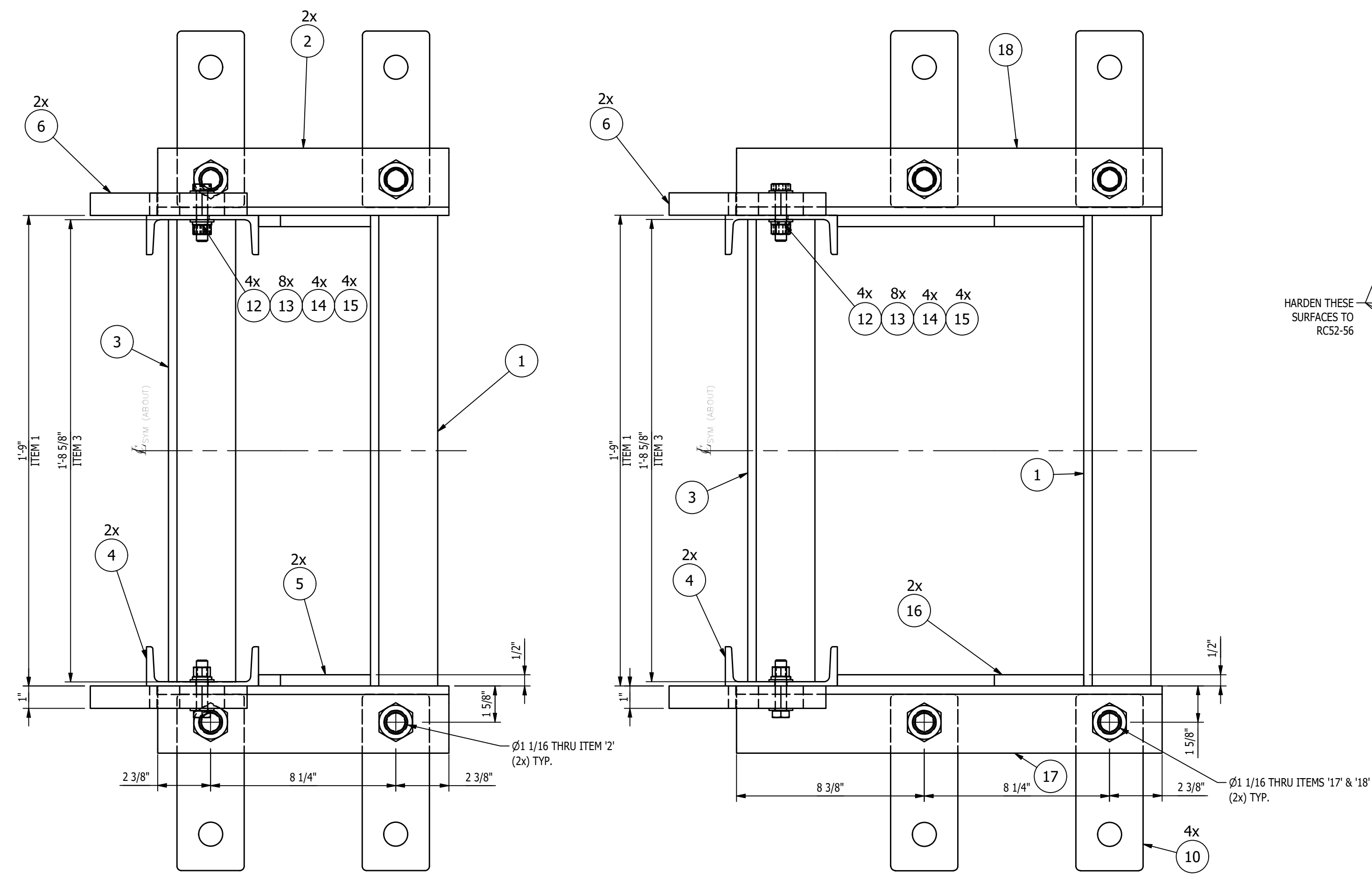
MAGNUM Consulting

41100 Clarkston Rd. Phone: (248) 773-6600
Suite 125 Fax: (248) 773-6601
Novi, MI 48220 Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D308

3/2023 1875D308.dwg

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D309A			
1	1	L 3 x 3 x 3/8	1'-9"		
2	2	L 4 x 3 x 3/8	1'-1"		
3	1	L 3 x 3 x 3/8	1'-8 5/8"		
4	2	C 5 x 6.7	1'-2 15/16"		
5	2	BAR 1/2 x 5	1'-2 15/16"		
6	2	PL 1 x 7"	9 1/2"		
10	4	MK-D007A ~ ADJUSTING SUPPORT			
12	4	1/2 SPRING LOCK WASHER			
13	8	1/2 TYPE A NARROW FLAT WASHER			
14	4	1/2-13UNC HEX NUT			
15	4	1/2-13UNC x 2 1/4" LG. HEX HEAD CAP SCREW			
		MK-D309B			
1	1	L 3 x 3 x 3/8	1'-9"		
3	1	L 3 x 3 x 3/8	1'-8 5/8"		
4	2	C 5 x 6.7	1'-2 15/16"		
6	2	PL 1 x 7"	9 1/2"		
10	4	MK-D007A ~ ADJUSTING SUPPORT			
12	4	1/2 SPRING LOCK WASHER			
13	8	1/2 TYPE A NARROW FLAT WASHER			
14	4	1/2-13UNC HEX NUT			
15	4	1/2-13UNC x 2 1/4" LG. HEX HEAD CAP SCREW			
16	2	PL 1/2 x 11"	1'-2 15/16"		
17	1	L 4 x 3 x 3/8	1'-7"		
18	1	L 4 x 3 x 3/8	1'-7"		



MK-309A ~ CARRIAGE POSITIONER ASSEMBLY - FLOOR
SCALE 3"=1'-0"

MK-309B ~ CARRIAGE POSITIONER ASSEMBLY - MEZZANINE
SCALE 3"=1'-0"

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	MODIFIED SLOT NOTE & ADDED VIEW SYMBOL	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: AH	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		CHECKED BY: JCK	
CLIENT: VOLVO		DWG DATE: 6/30/22	
DRAWING No. 1875D309		JOB No. 22096	
REV: B			

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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 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)

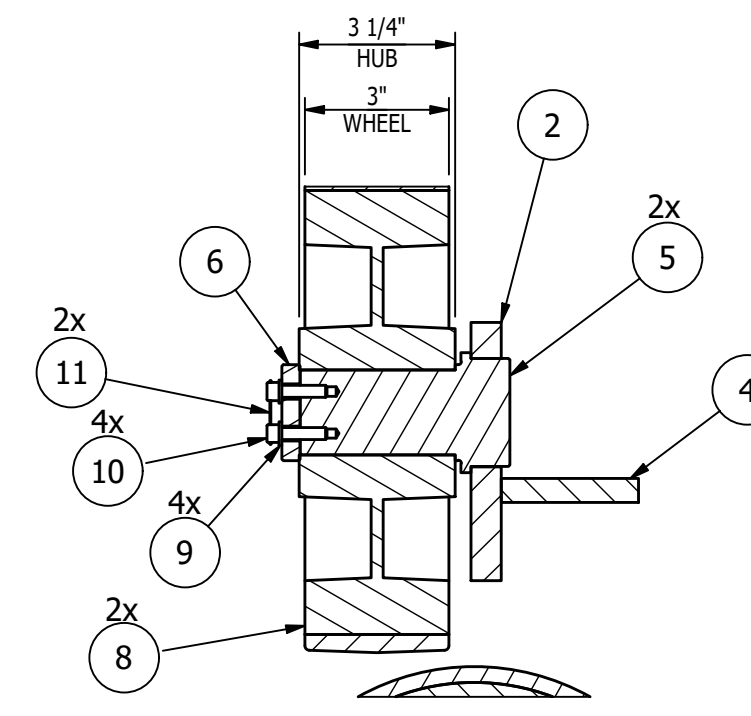
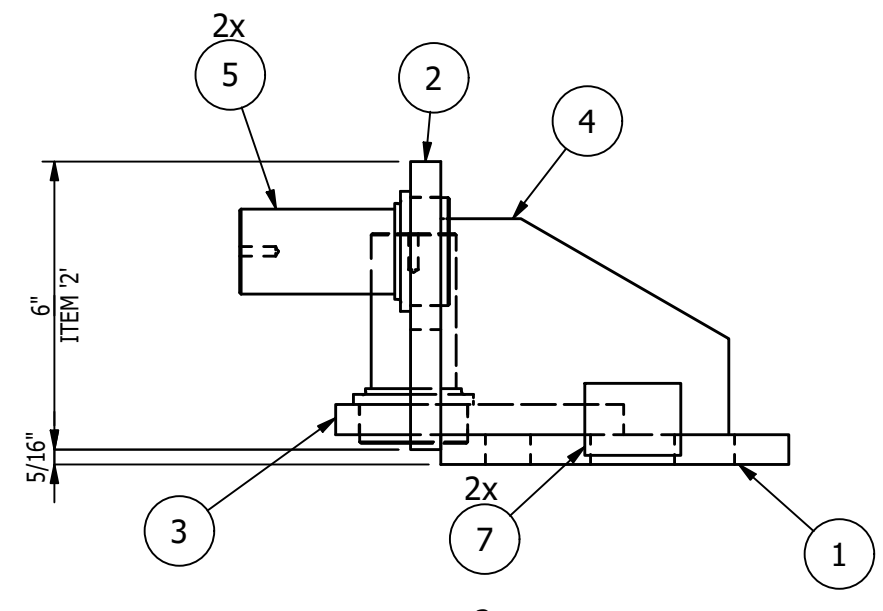
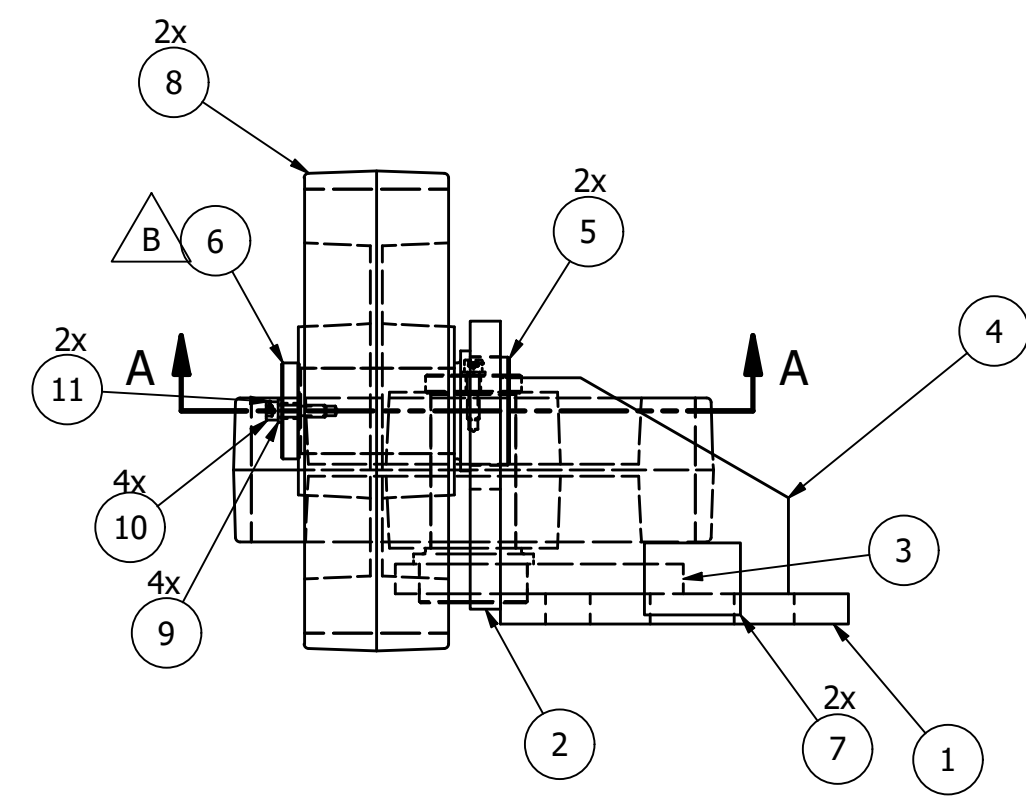
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

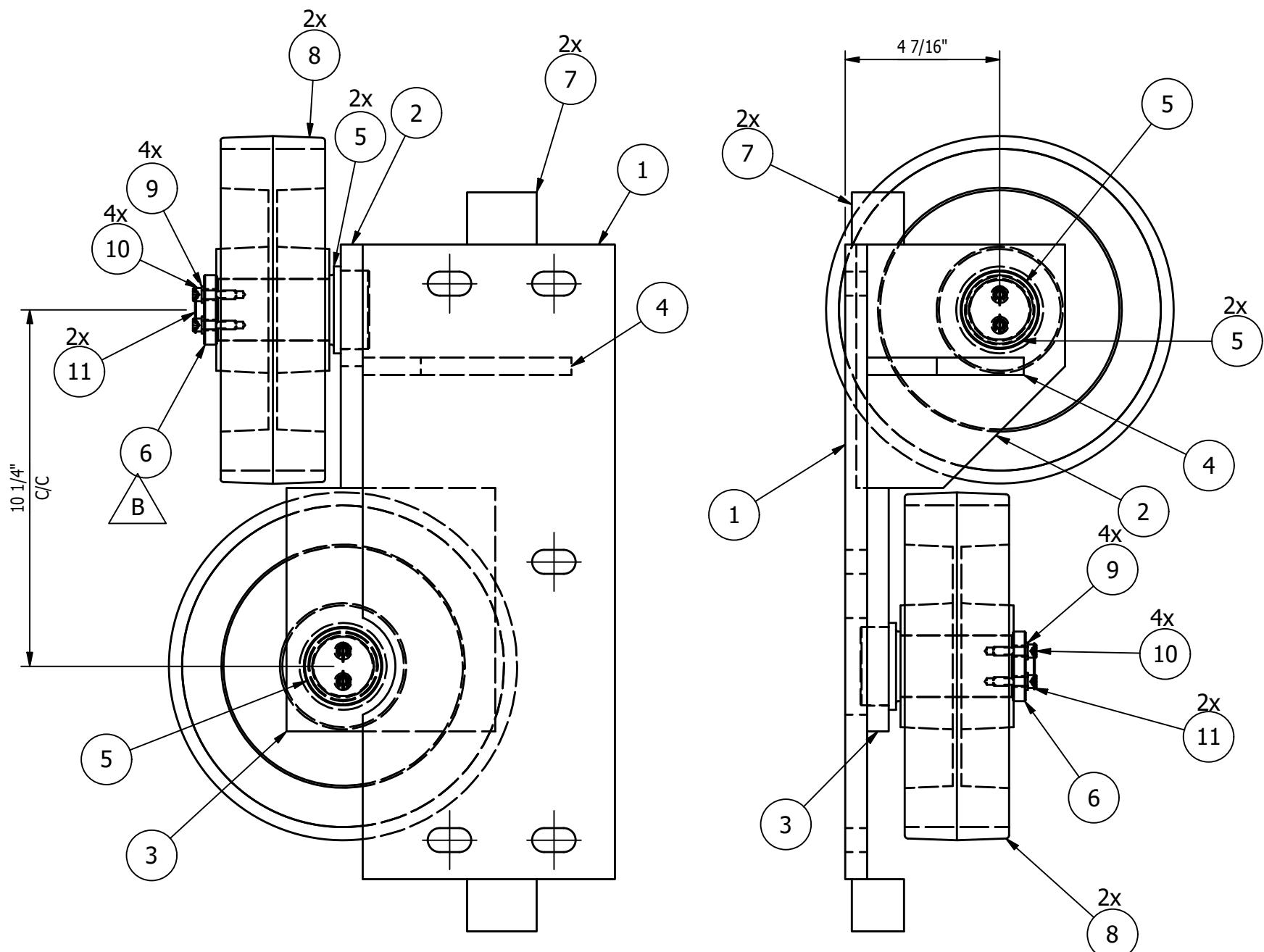
COPIES:

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

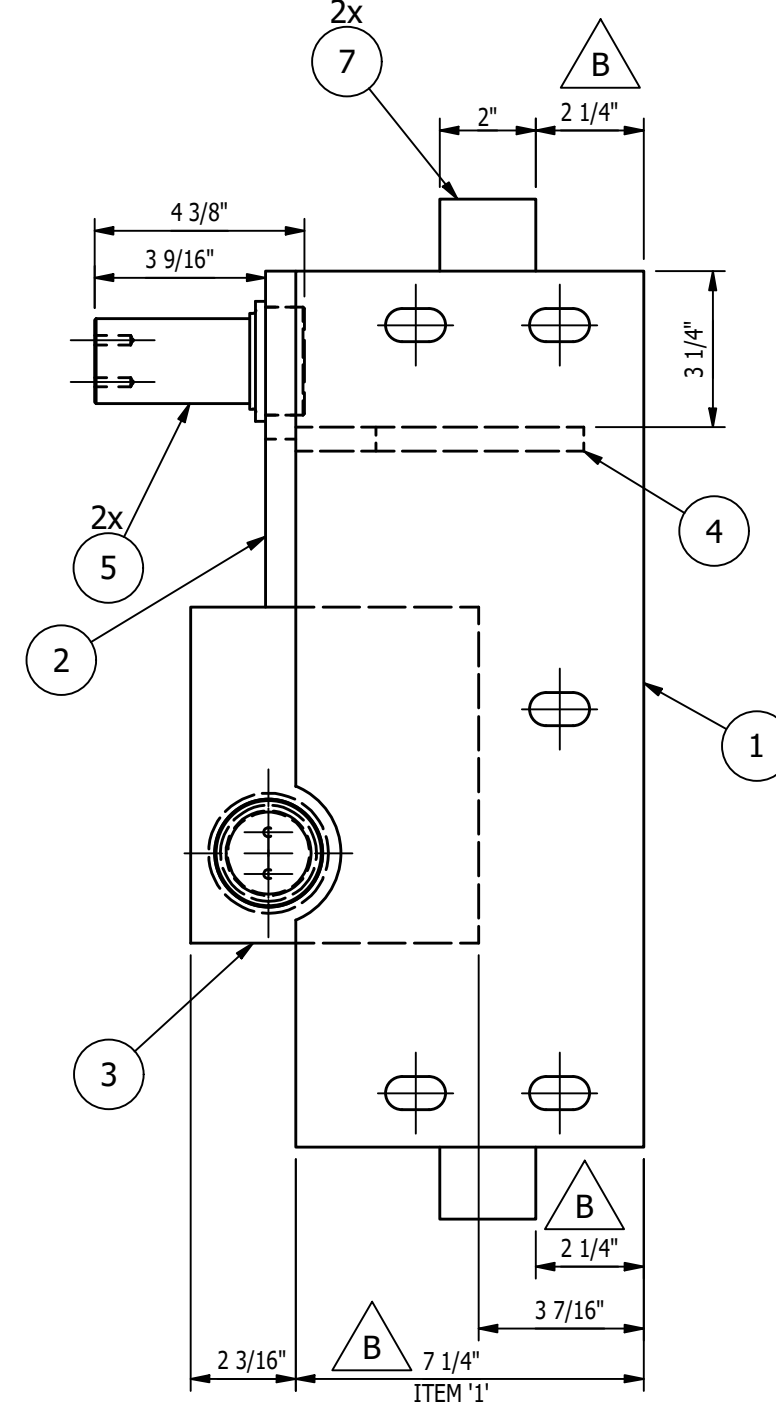
C:\Users\jerman\Desktop\0010301 - 1875D309.dwg 1875D309.dwg



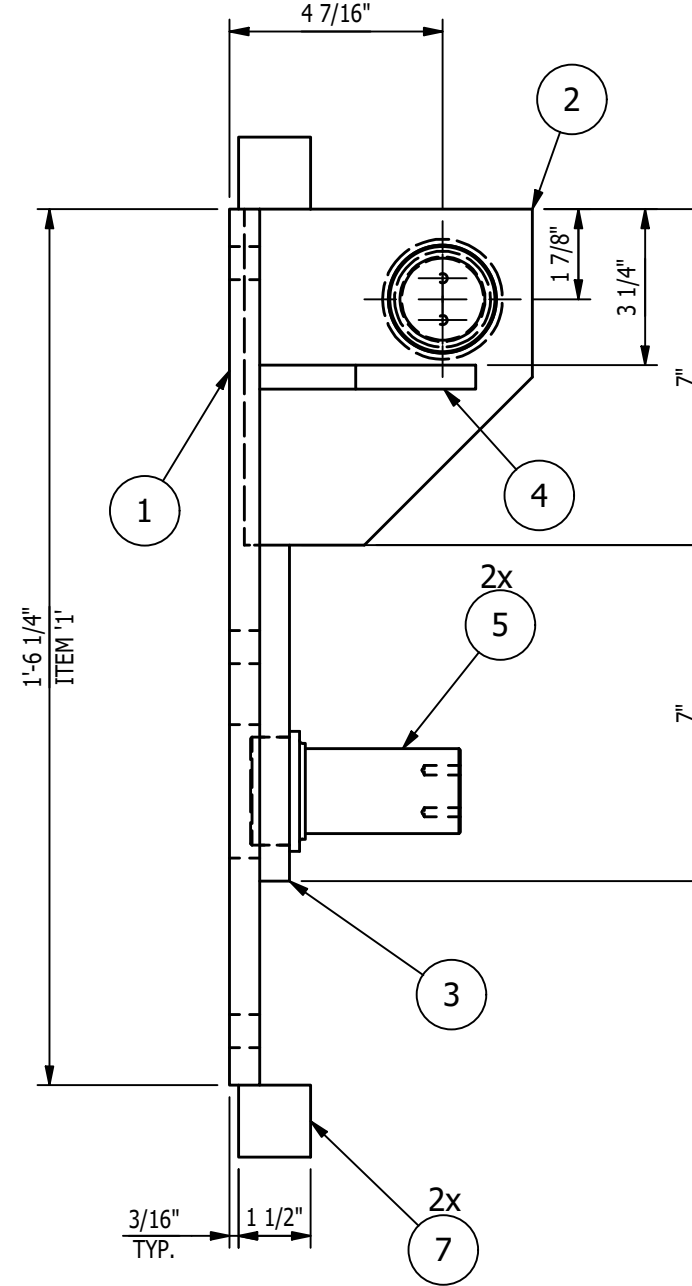
SECTION 'A-A'
SCALE 3"=1'-0"



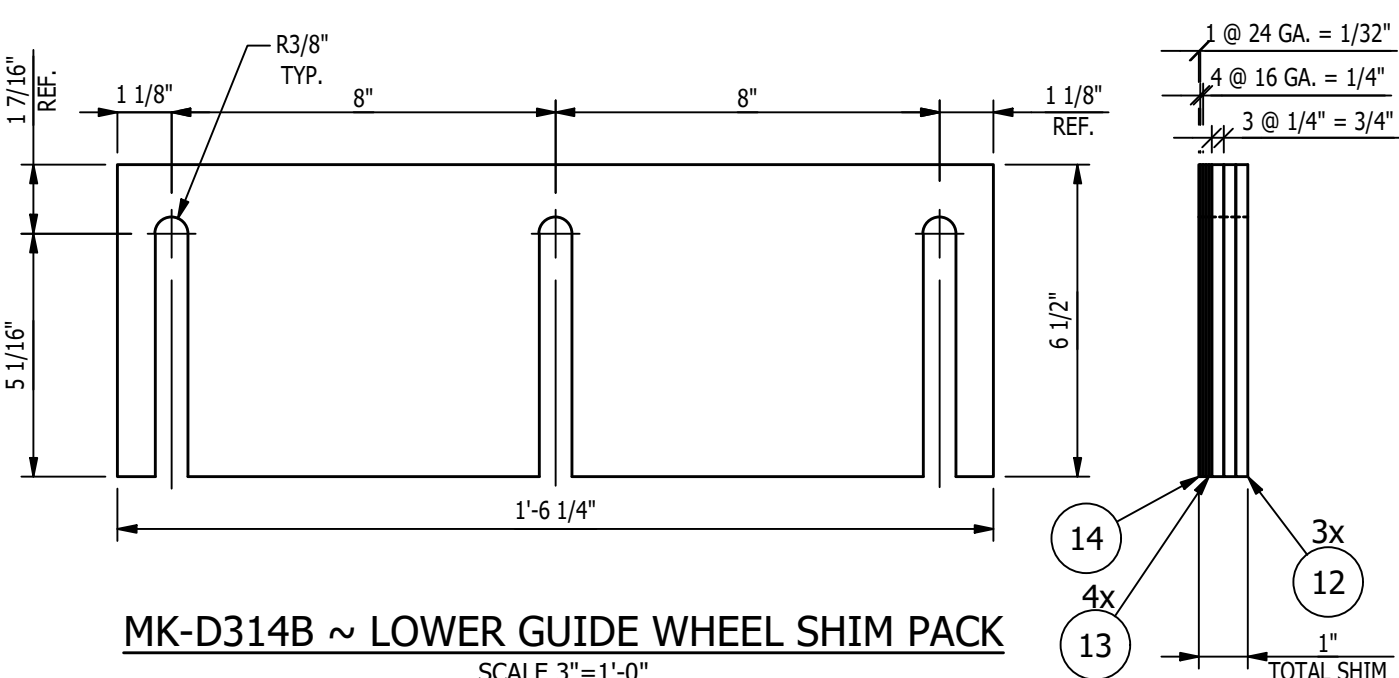
MK-D314A ~ CARRIAGE GUIDE WHEEL ASSEMBLY
RH SHOWN, LH OPPOSITE
SCALE 3"=1'-0"



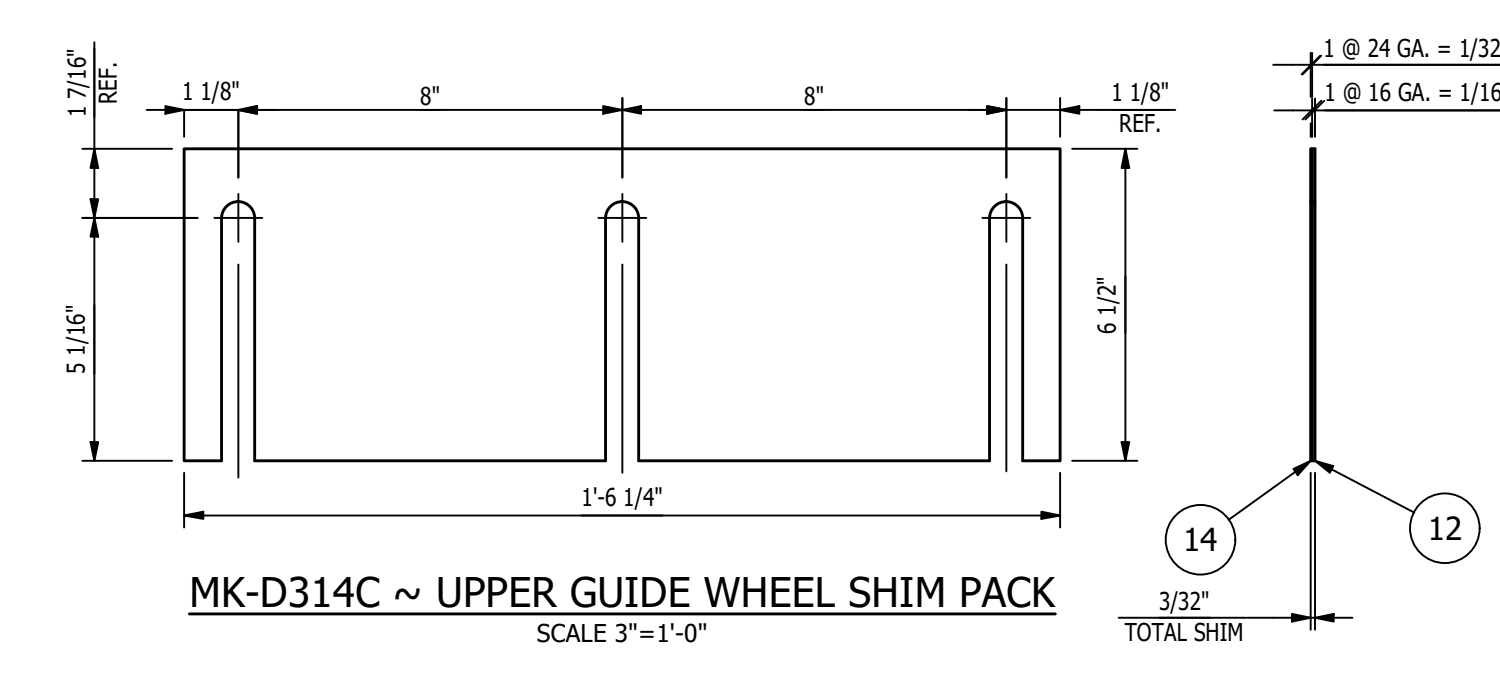
WELDMENT DETAIL RH AS SHOWN
LH OPPOSITE
SCALE 3"=1'-0"



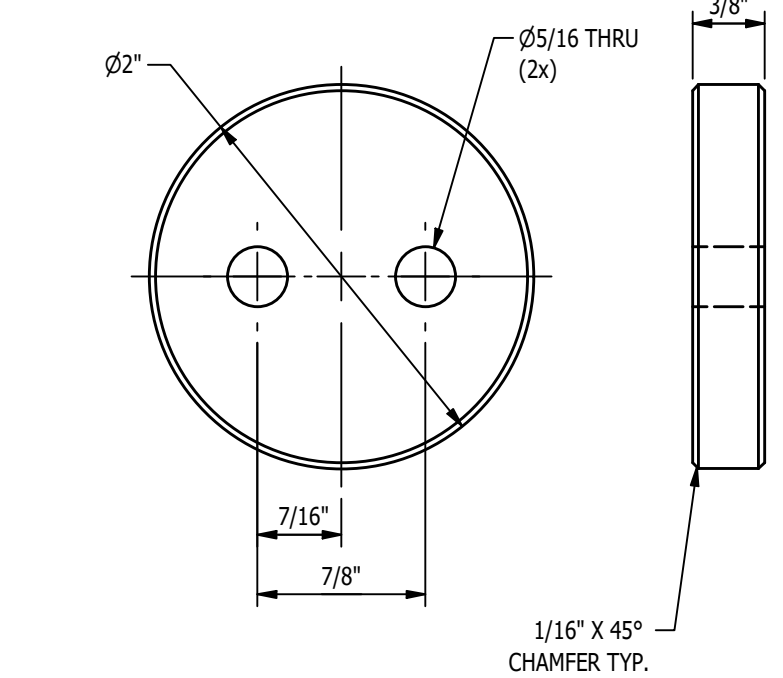
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
B	1	MK-D314A-RH			
1	1	PL 5/8 x 7 1/4"	1'-6 1/4"		
2	1	BAR 5/8 x 6	7"		
3	1	BAR 5/8 x 6	7"		
4	1	BAR 1/2 x 4 1/2	6"		
5	2	BAR Ø2 1/2	4 3/8"		
6	2	BAR Ø2	3/8"		
7	2	SQ. BAR 1 1/2	2"		
8	2	10" DIA. x 3" WIDE SOFT POLYURETHANE WHEEL W/45mm ID SEALED BALL BEARINGS & SPACER TUBE, NO LUBE FITTING, CASTER CONCEPTS PART NO. SPD03010701		7-14	
9	4	1/4 SPRING LOCK WASHER			
10	4	1/4-20UNC x 1" LG SHCS, WIRE LOCKABLE, 0.047" DRILLED HOLE, McMASTER-CARR PART NO. 90117A542		7-10	
11	2	ROUND BEND-AND-STAY SS WIRE, .025" DIA, 1/4 LB SPOOL, McMASTER-CARR PART NO. 8860K13	3"	7-11	
B	1	MK-D314A-LH			
1	1	PL 5/8 x 7 1/4"	1'-6 1/4"		
2	1	BAR 5/8 x 6	7"		
3	1	BAR 5/8 x 6	7"		
4	1	BAR 1/2 x 4 1/2	6"		
5	2	BAR Ø2 1/2	4 3/8"		
6	2	BAR Ø2	3/8"		
7	2	SQ. BAR 1 1/2	2"		
8	2	10" DIA. x 3" WIDE SOFT POLYURETHANE WHEEL W/45mm ID SEALED BALL BEARINGS & SPACER TUBE, NO LUBE FITTING, CASTER CONCEPTS PART NO. SPD03010701		7-14	
9	4	1/4 SPRING LOCK WASHER			
10	4	1/4-20UNC x 1" LG SHCS, WIRE LOCKABLE, 0.047" DRILLED HOLE, McMASTER-CARR PART NO. 90117A542		7-10	
11	2	ROUND BEND-AND-STAY SS WIRE, .025" DIA, 1/4 LB SPOOL, McMASTER-CARR PART NO. 8860K13	3"	7-11	
B	1	MK-D314B			
12	3	BAR 1/4 x 6 1/2	1'-6 1/4"		
13	4	SHT 16 GA x 6 1/2	1'-6 1/4"		
14	1	SHT 24 GA x 6 1/2	1'-6 1/4"		
B	1	MK-D314C			
13	1	SHT 16 GA x 6 1/2	1'-6 1/4"		
14	1	SHT 24 GA x 6 1/2	1'-6 1/4"		



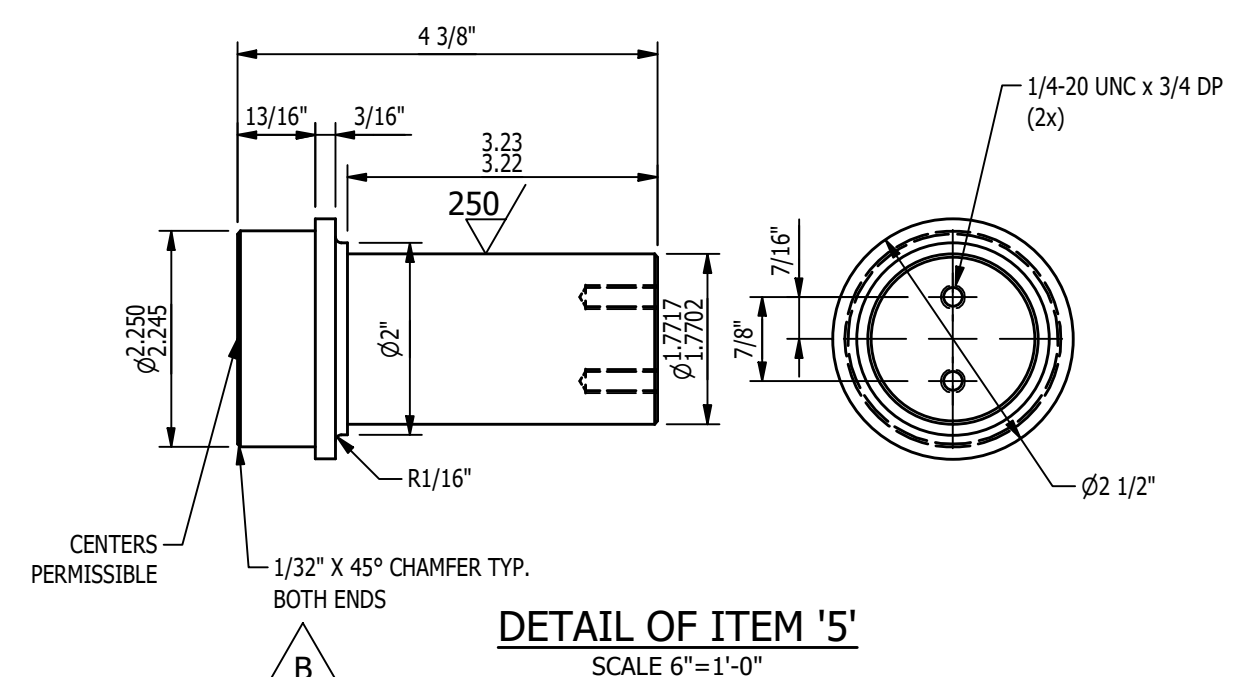
MK-D314B ~ LOWER GUIDE WHEEL SHIM PACK
SCALE 3"=1'-0"



MK-D314C ~ UPPER GUIDE WHEEL SHIM PACK
SCALE 3"=1'-0"



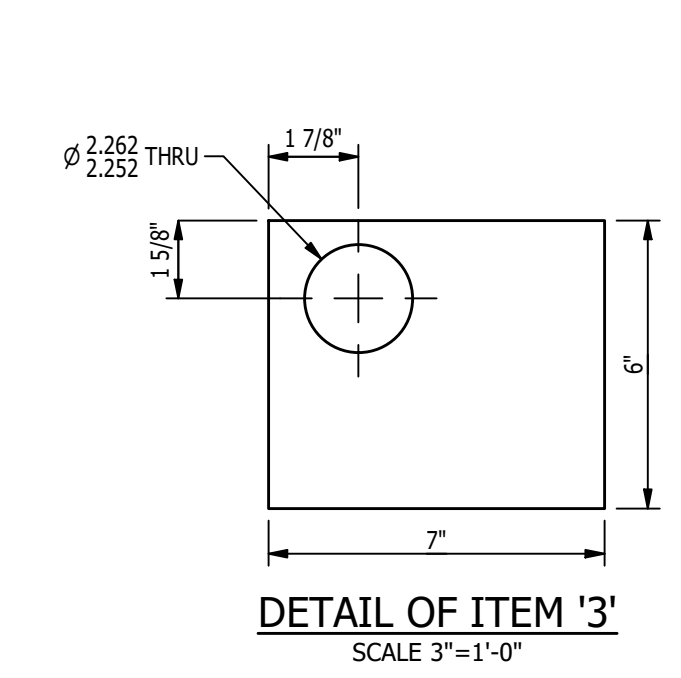
DETAIL OF ITEM '6'
SCALE 1'-0" = 1'-0"



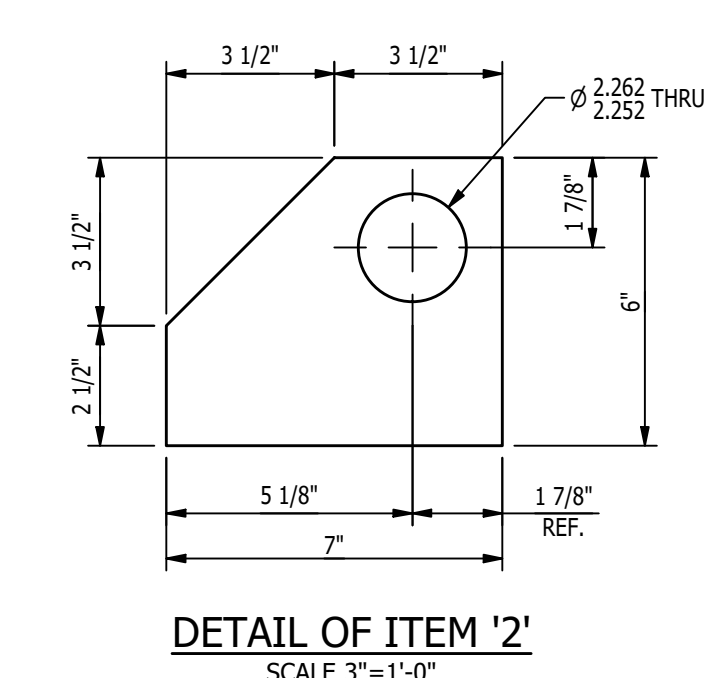
DETAIL OF ITEM '5'
SCALE 6"=1'-0"

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

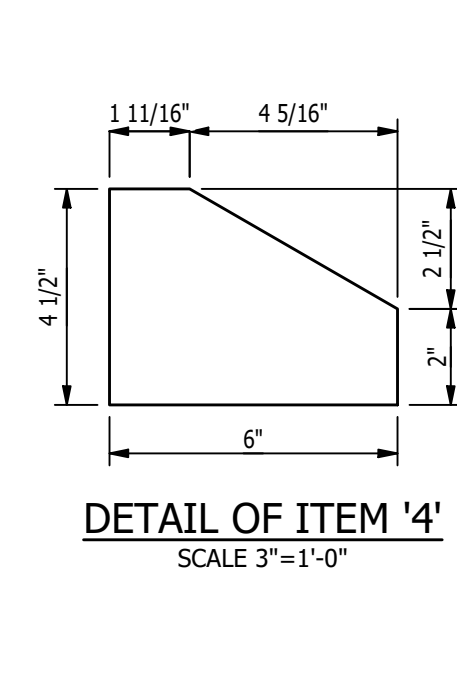
PAINT NOTES:
 PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.



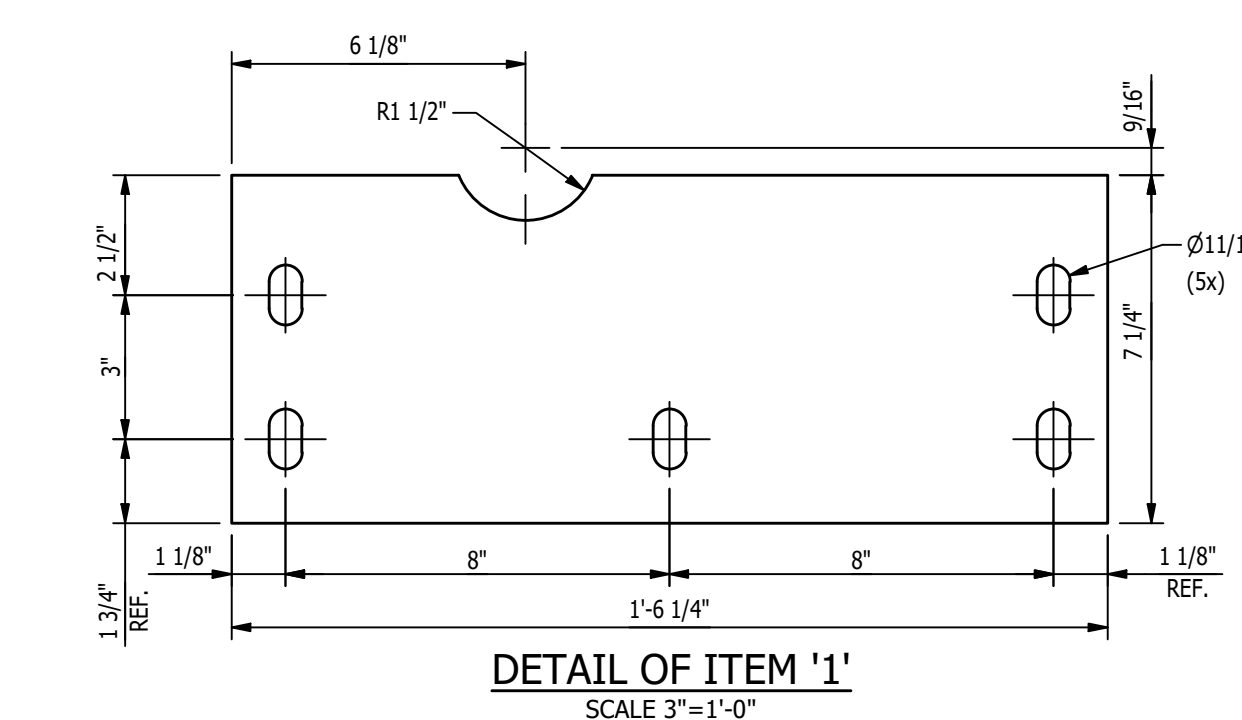
DETAIL OF ITEM '3'
SCALE 3"=1'-0"



DETAIL OF ITEM '2'
SCALE 3"=1'-0"



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



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

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

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D314

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	ADJUSTED PLATE WIDTH TO CORRECT OFFSETS, GENERAL & ADDED BALLOON	
A	MC	8/8/2022	FOR FABRICATION	

REVISION HISTORY

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

TITLE: P6700 CONVEYORS CAMPUS BUILDING

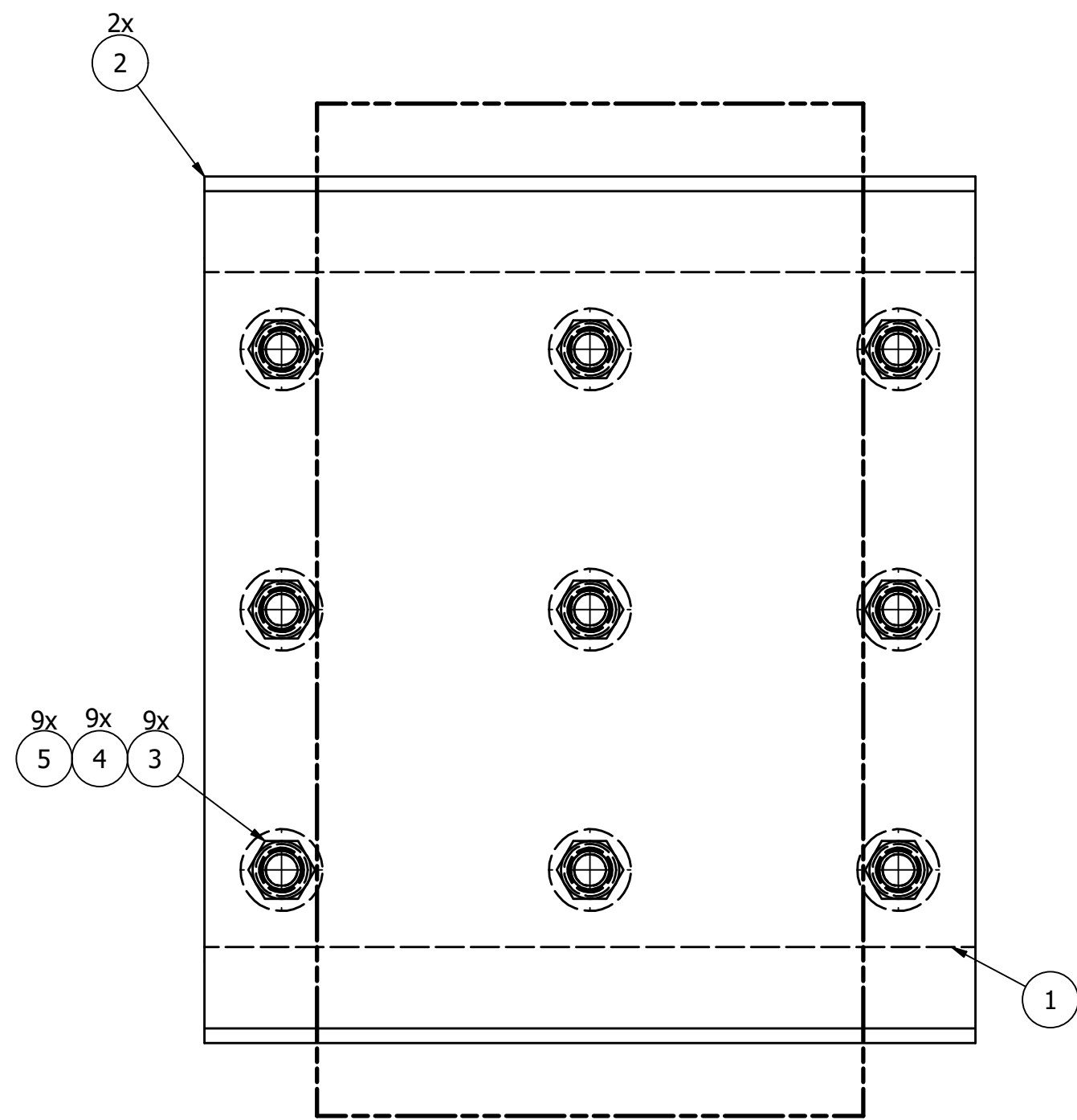
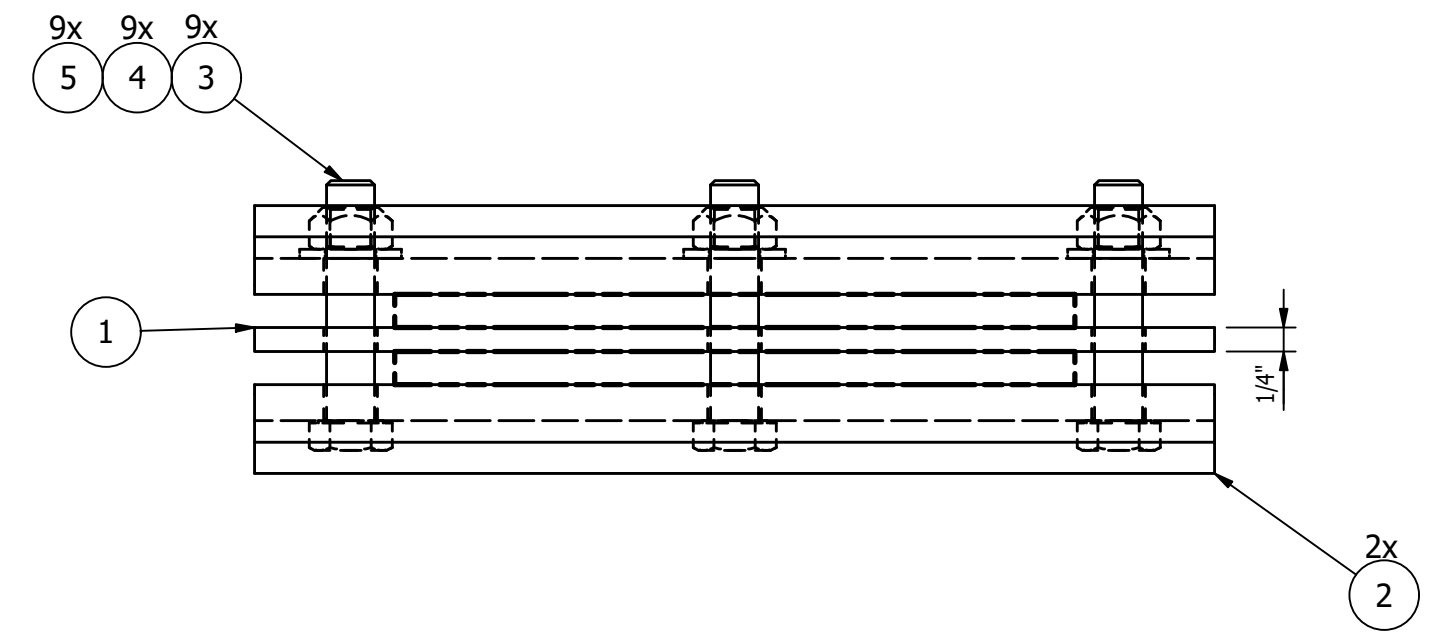
CLIENT: VOLVO

DRAWING No. 1875D314

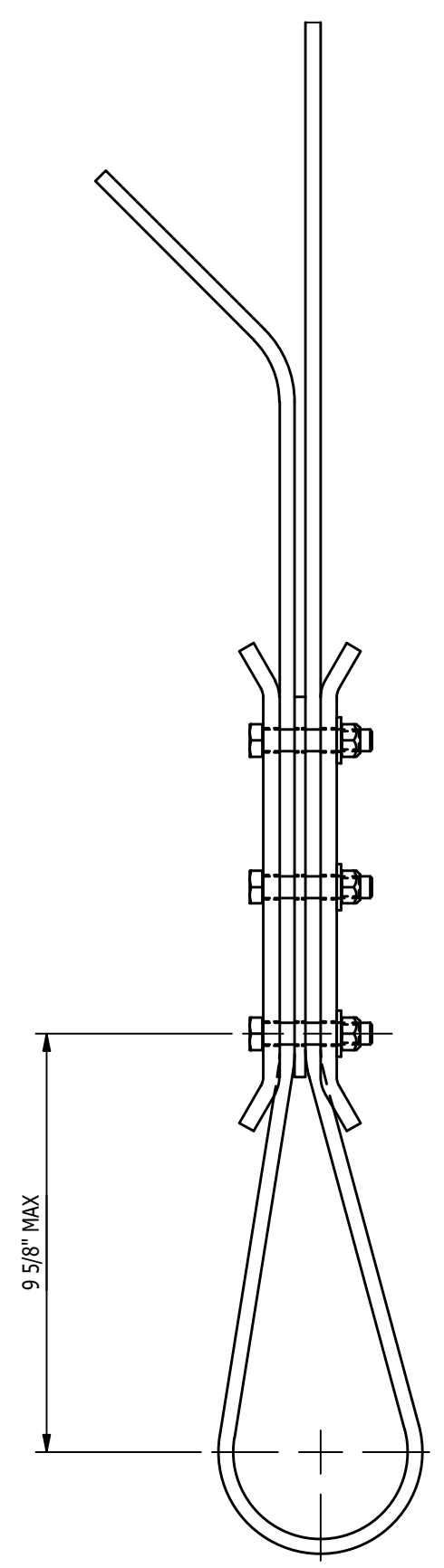
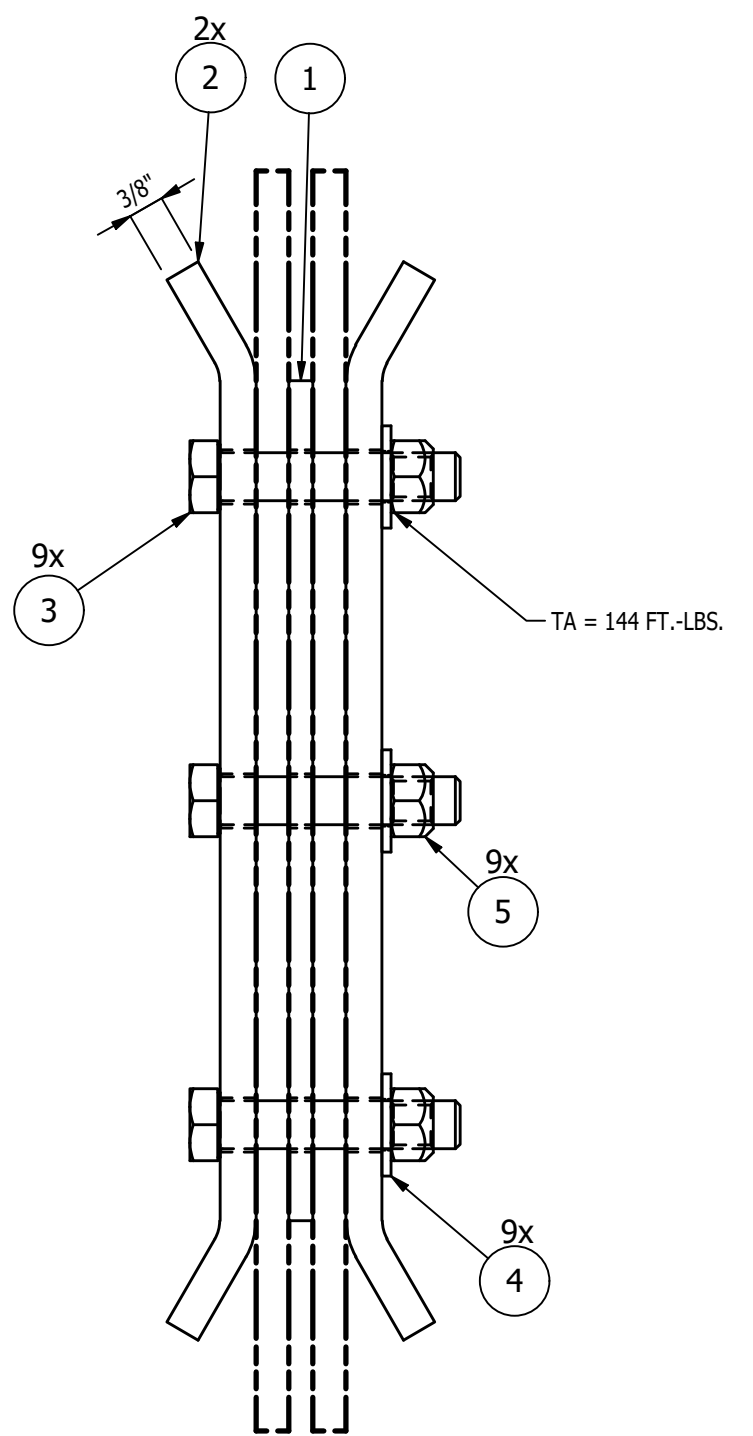
REV: B

DRAWN BY: AH
CHECKED BY: JCK
DWG DATE: 7/28/22
JOB No: 22096

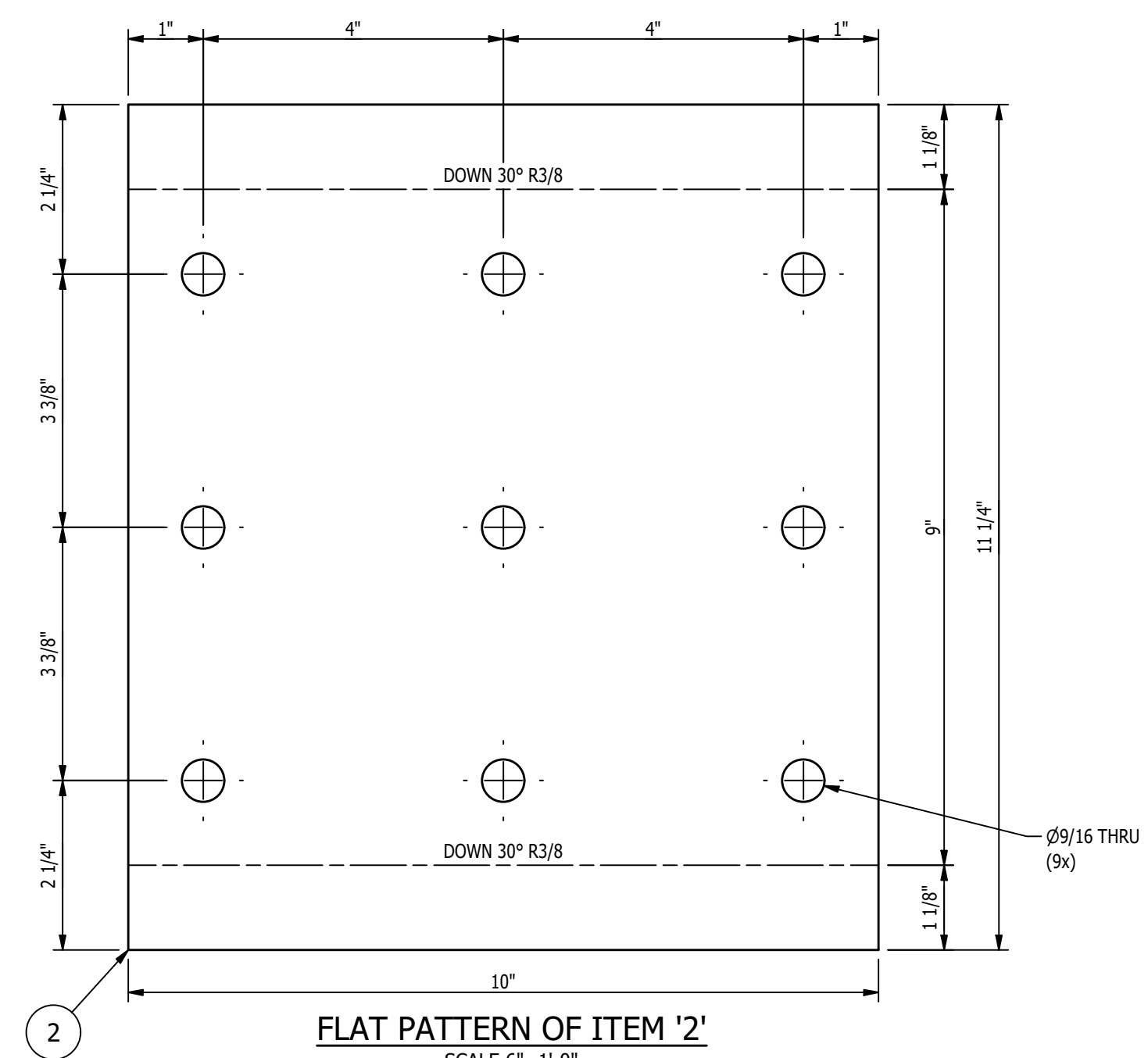
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D315A			
1	1	PLT 1/4 x 8 3/4	10"		
2	2	BAR 3/8 x 10, BEND	11 1/4"		
3	9	1/2-13UNC x 2 1/2" LG. HEX HEAD CAP SCREW			
4	9	1/2 TYPE A NARROW FLAT WASHER			
5	9	1/2-13UNC STOVER LOCK NUT			



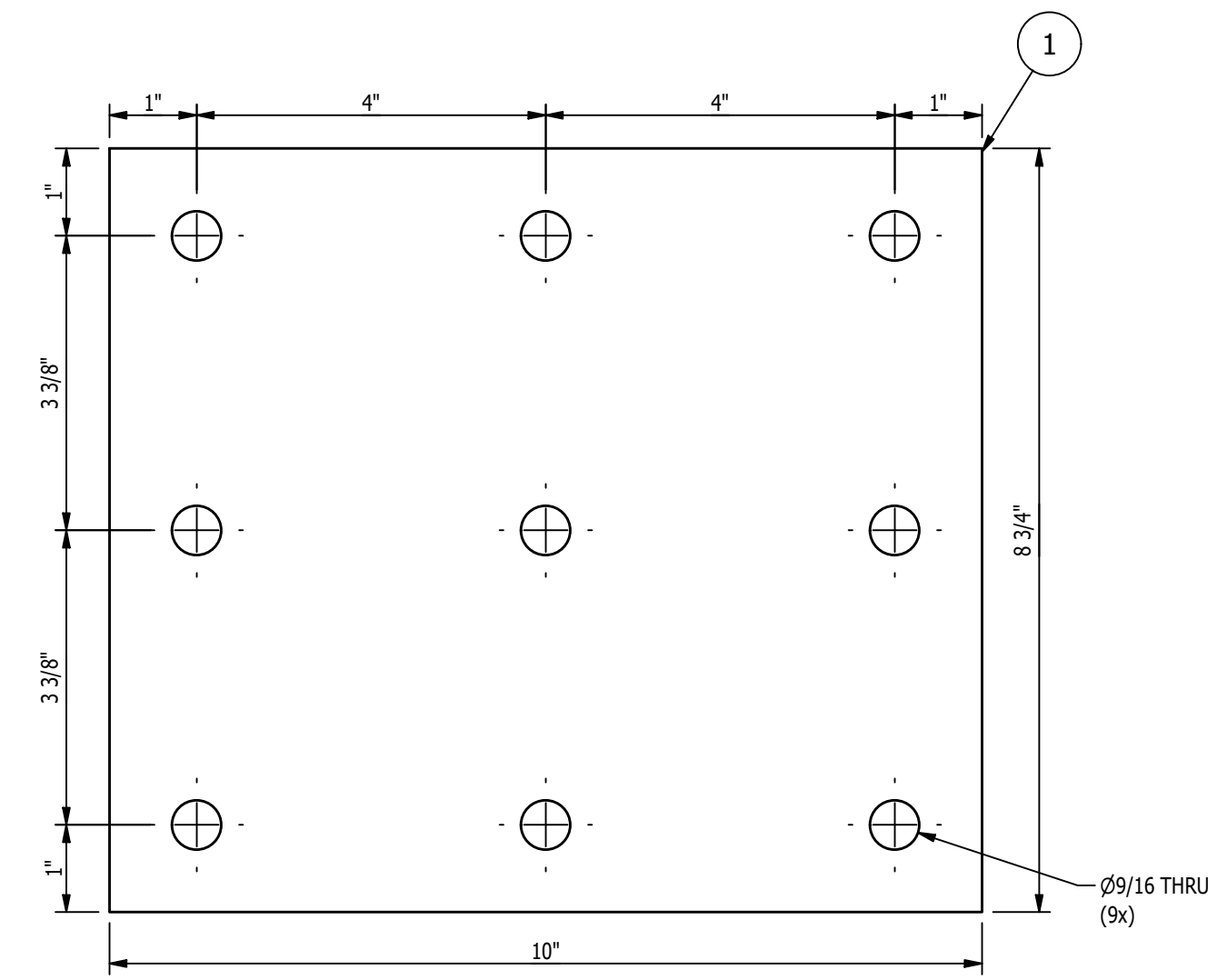
MK-D315A ~ BELT CLAMP ASSEMBLY
SCALE 6"=1'-0"



INSTALL VIEW
SCALE 3"=1'-0"



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



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

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/20/2022	ADDED INSTALL VIEW	
A	MC	8/8/2022	FOR FABRICATION	

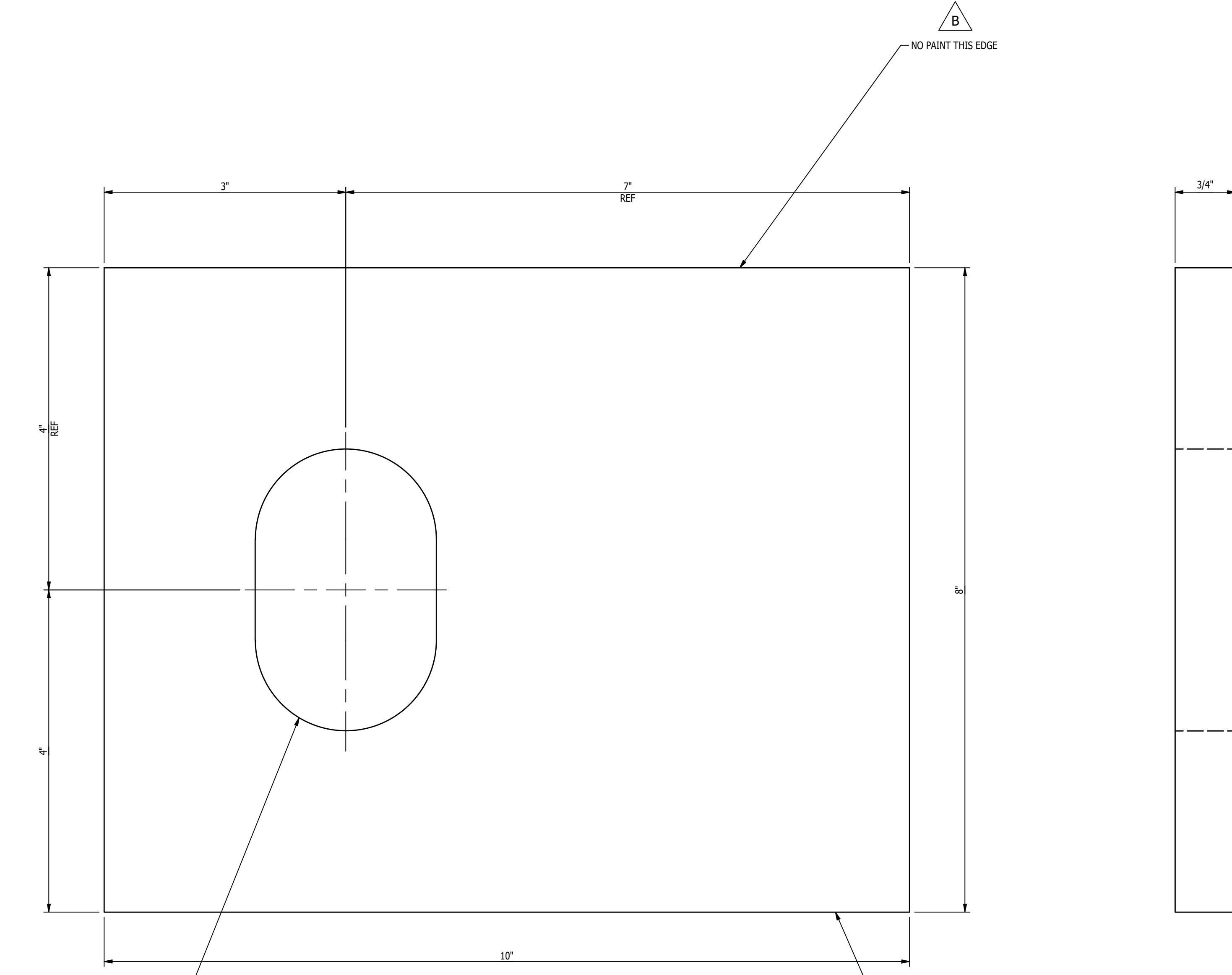
REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
		FENTON, MI 48430		DRAWING IS THE SOLE PROPERTY	
		PH: 810.373.0322 FAX: 810.373.0326		OF MILLER INDUSTRIES. ANY	
		www.millic.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: AH		JOB No:	
CLIENT: VOLVO		CHECKED BY: JCK		22096	
DRAWING No. 1875D315		DWG DATE: 7/22/22			
REV: B		JOB No:			

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41100 Clarkston Rd.
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Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D315

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-D316A			
1	1	BAR 3/4 x 8	10"		



MK-D316A ~ CARRIAGE RETAINER PLATE
SCALE 1'-0" = 1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 8. ALL SLOT LENGTHS ARE END TO END U.N.O.
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF SAFETY YELLOW RAL 1023
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/30/22	ADDED PAINT NOTES	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY				
 MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		<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:	AH
CLIENT:	VOLVO		CHECKED BY:	JCK
DRAWING No.	1875D316	REV:	B	JOB No: 22096
				DWG DATE: 7/22/22

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 41100 Charleston Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
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 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D316

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:

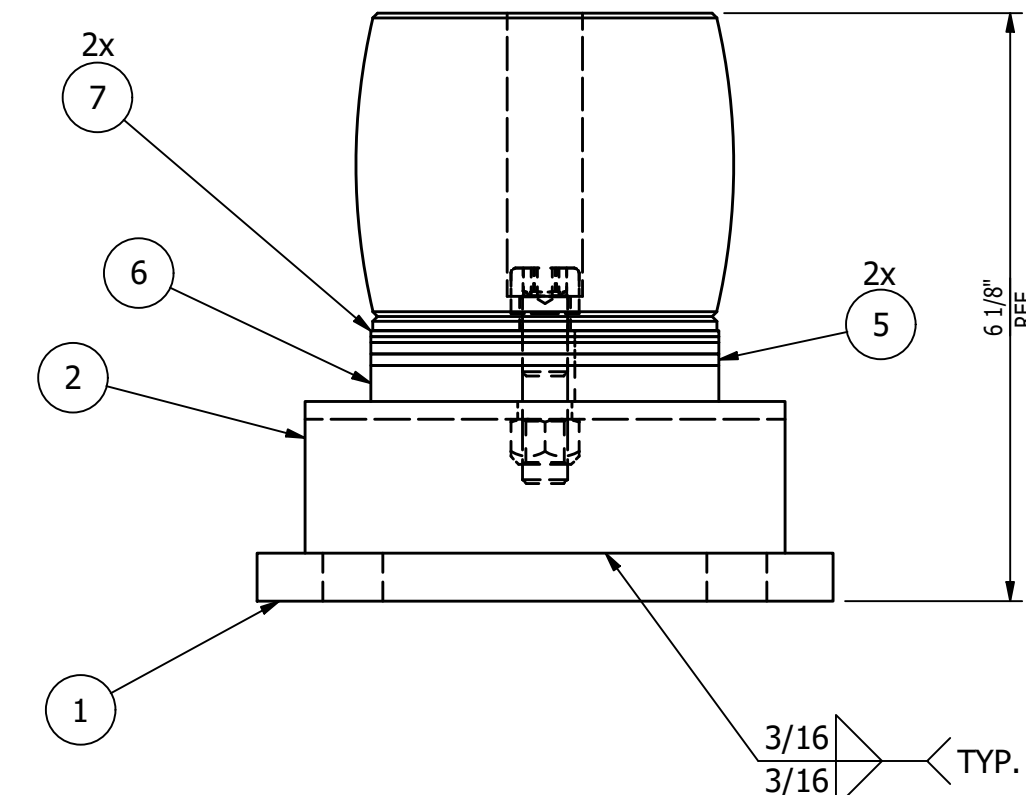
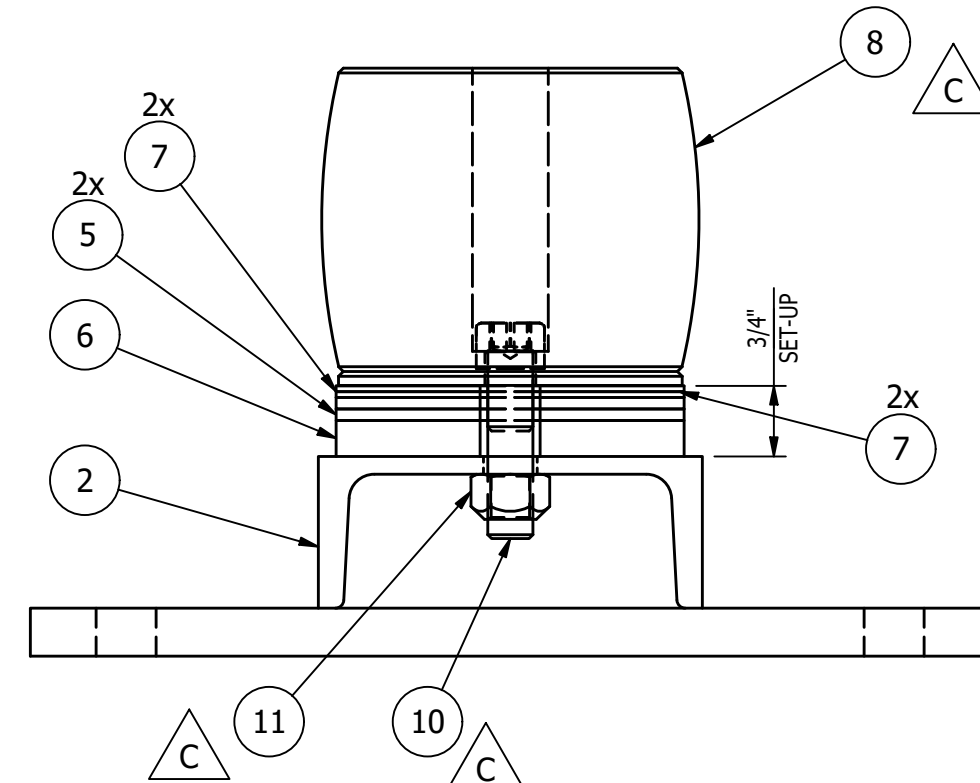
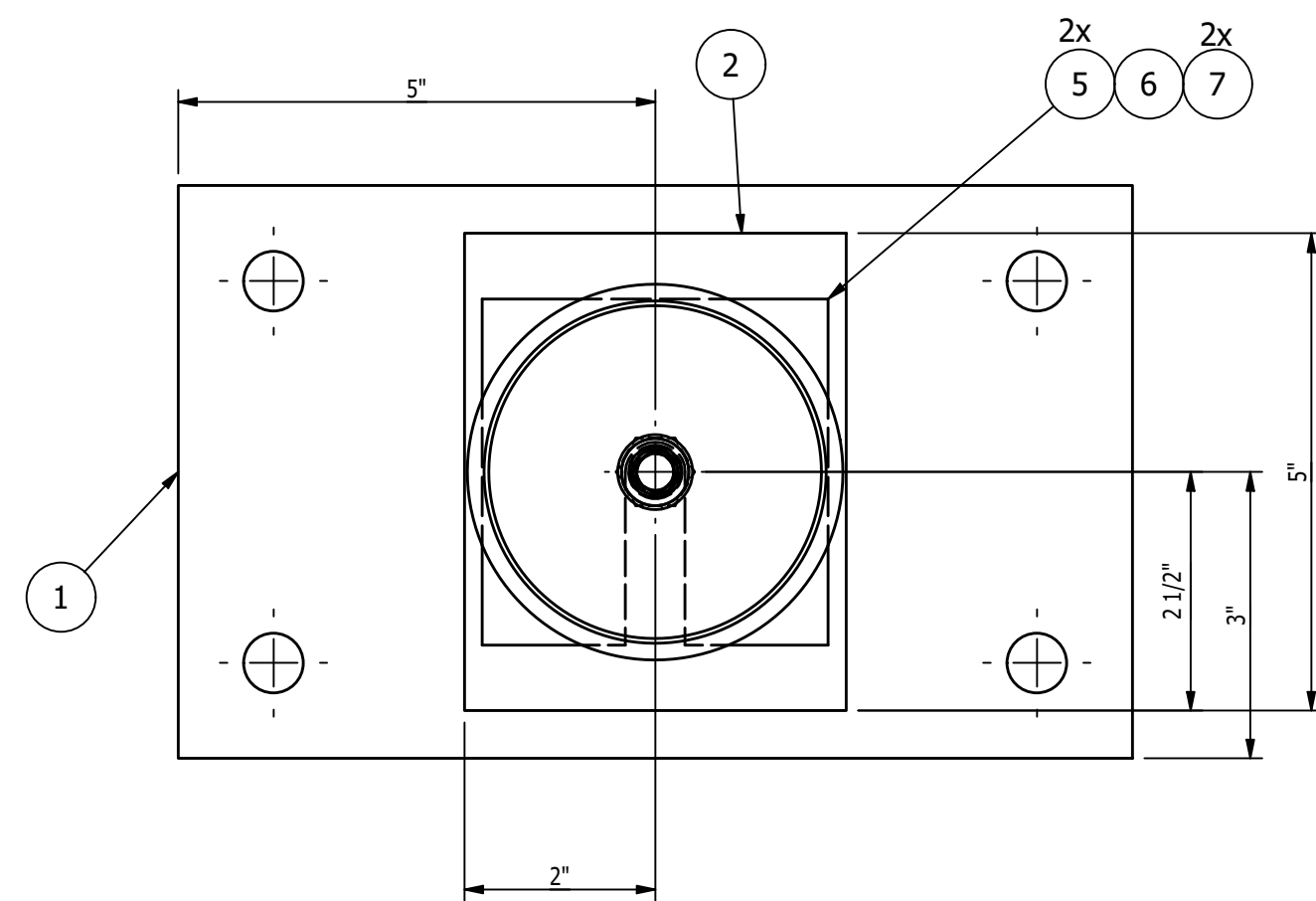
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

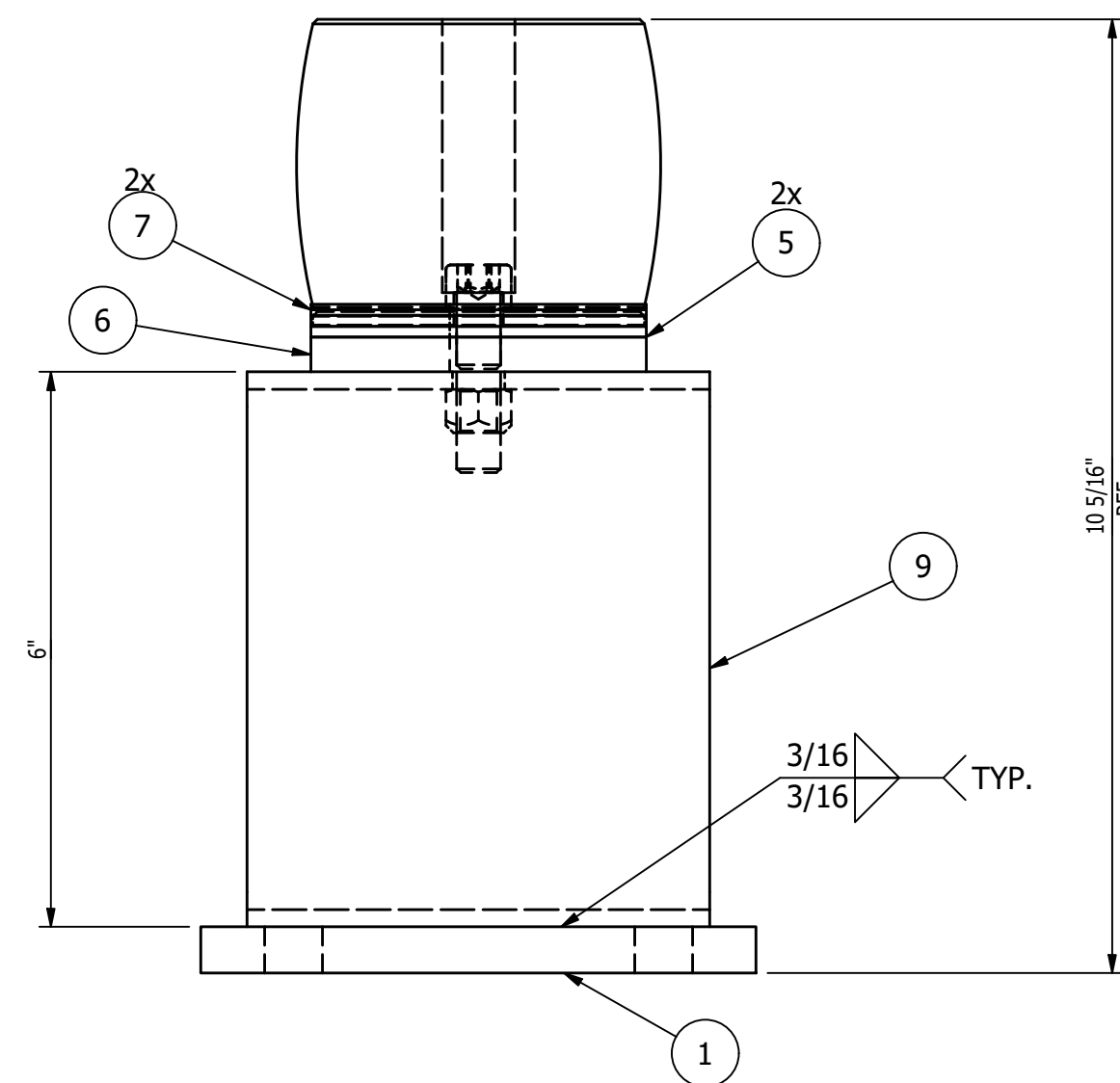
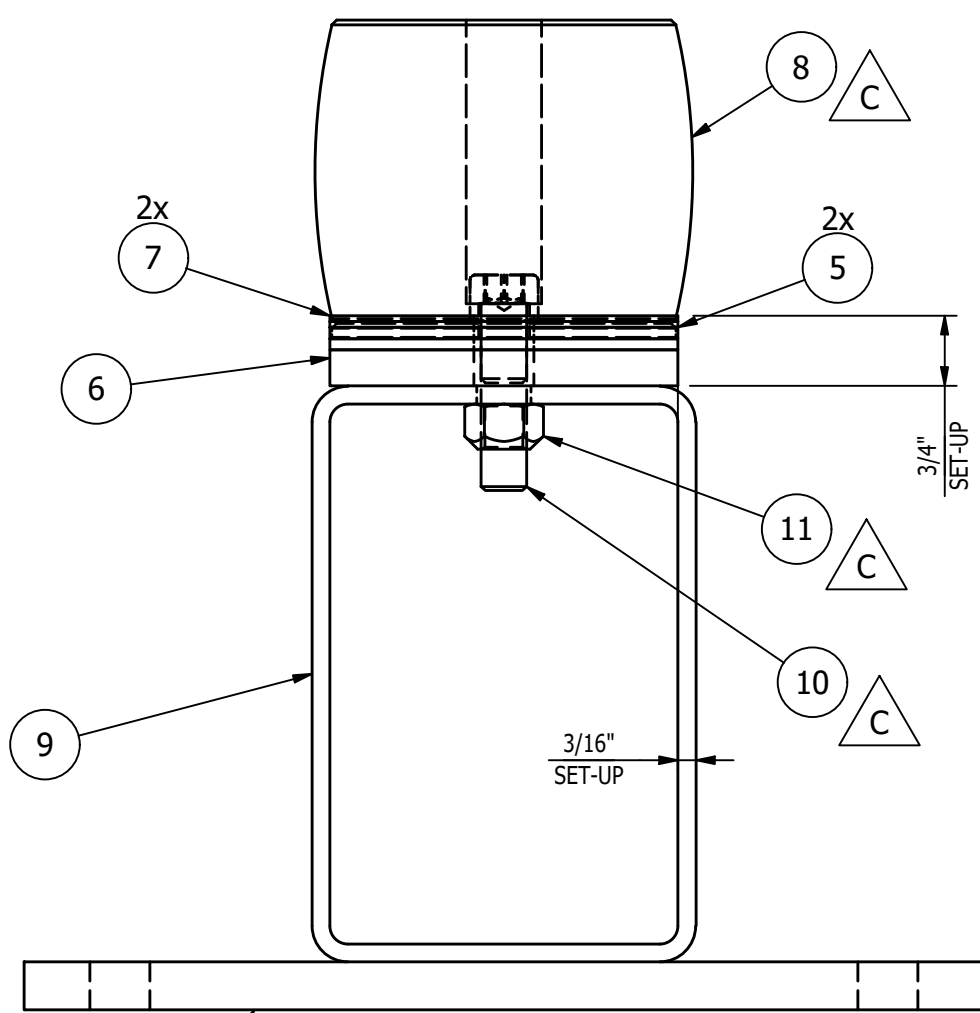
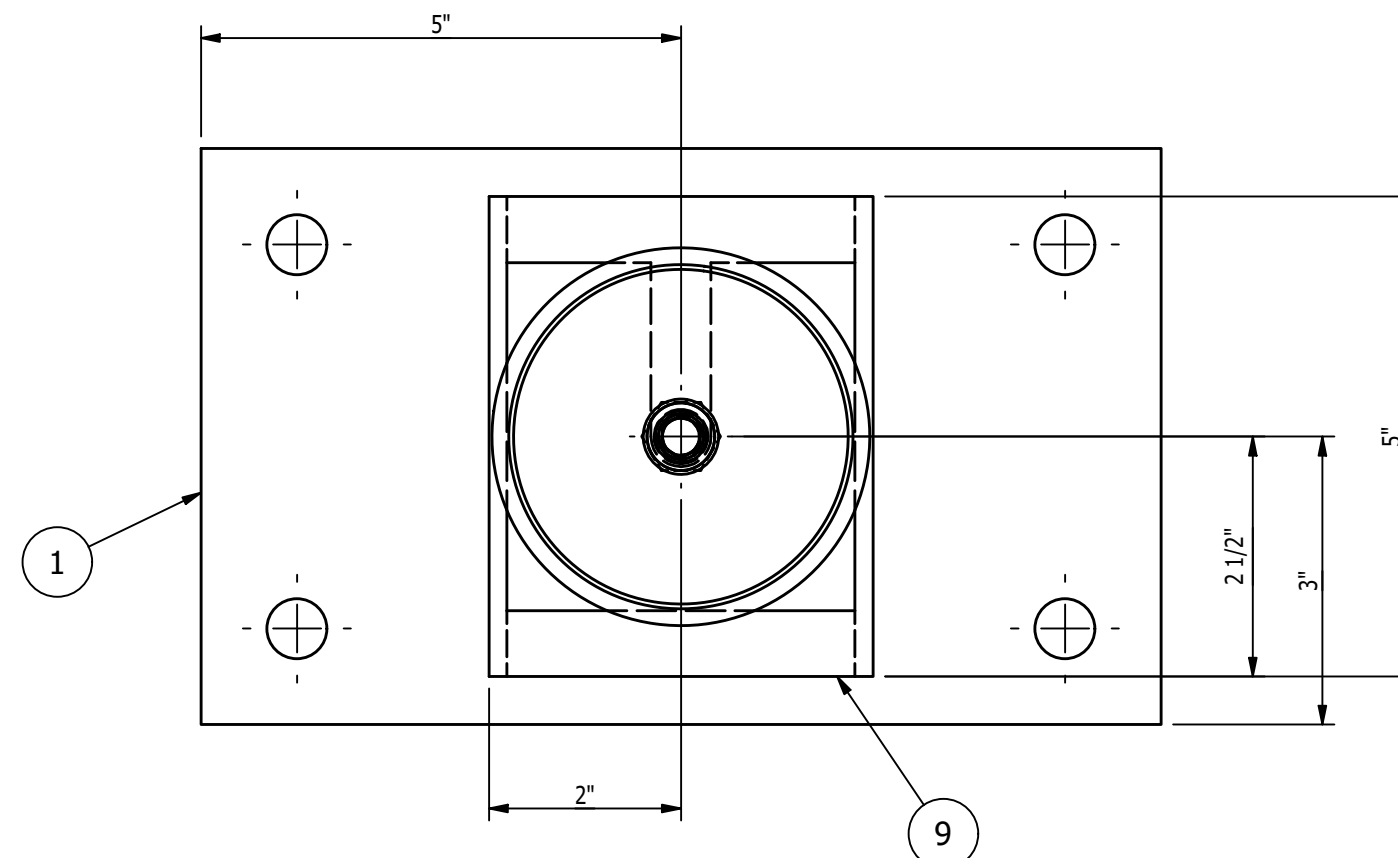
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

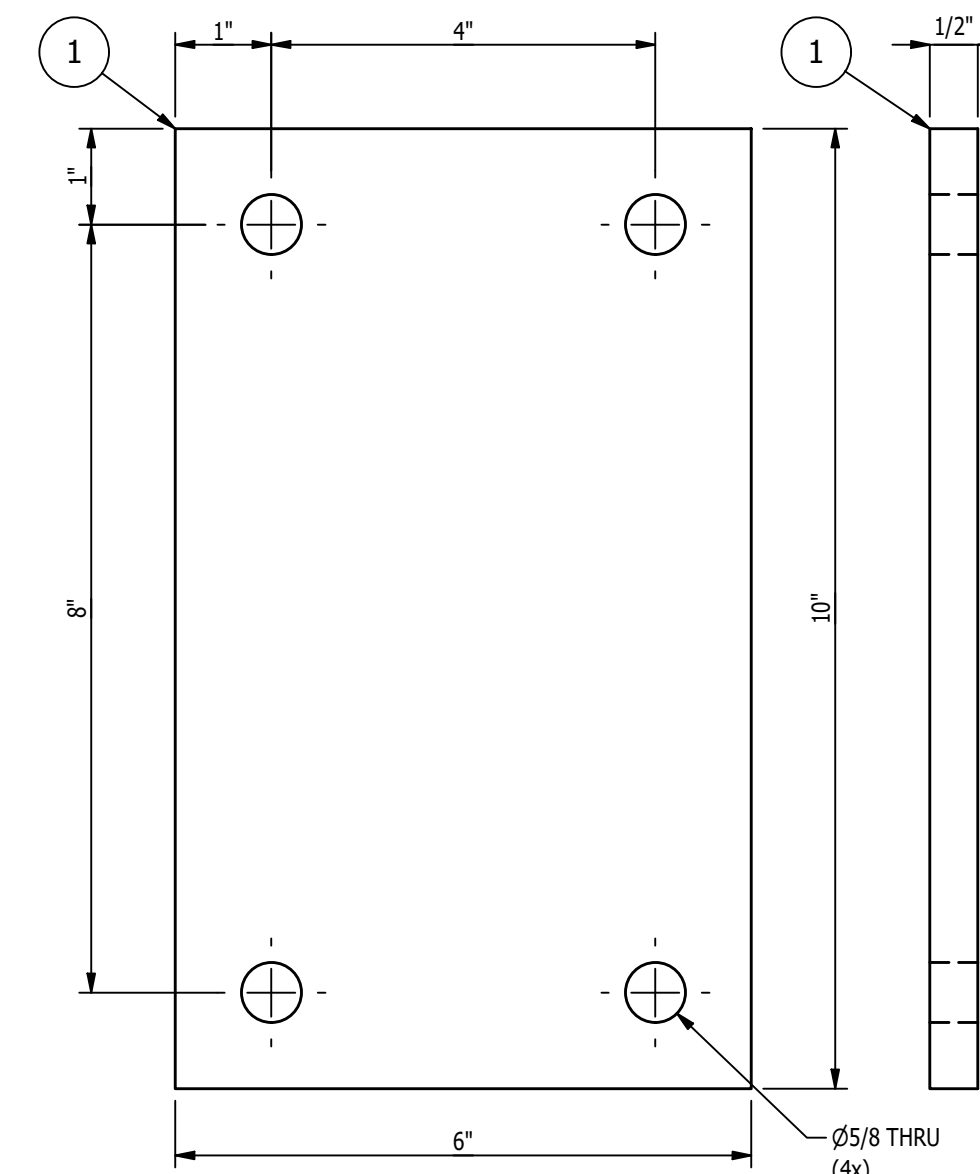
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



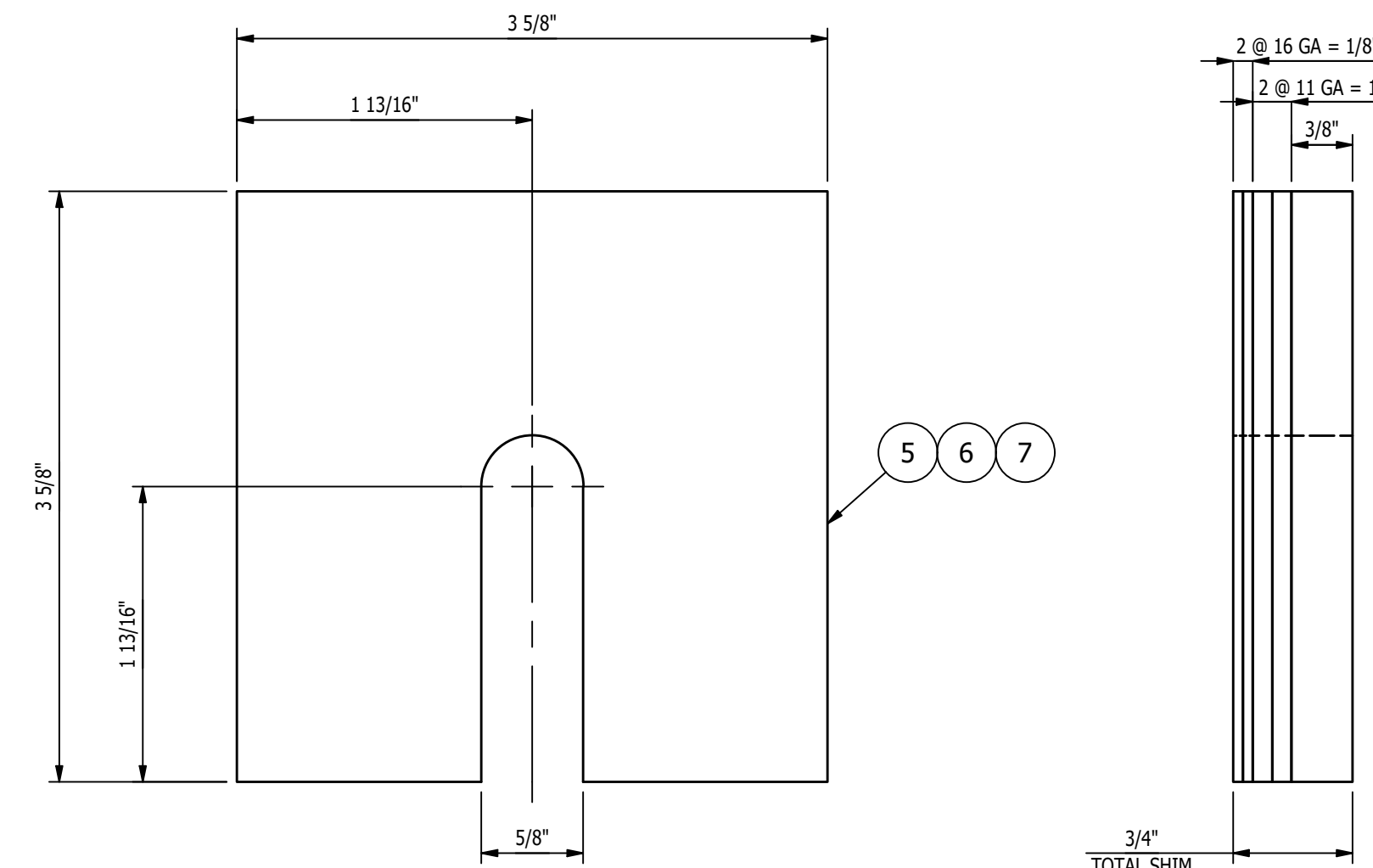
MK-D317A ~ PALLET BUMPER STOP
SCALE 6"=1'-0"



MK-D317B ~ PALLET BUMPER STOP
SCALE 6"=1'-0"



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



SHIM DETAIL
ITEMS '5' '6' & '7'
SCALE 1'-0" = 1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D317A			
1	1	PL 1/2 x 6"	10"		
2	1	C 4 x 5.4	5"		
5	2	SHT 11 GA x 3 5/8"	3 5/8"		
6	1	PL 3/8 x 3 5/8"	3 5/8"		
7	2	SHT 16 GA x 3 5/8"	3 5/8"		
8	1	ACE BUMPER TC 100-59		7-24	
10	1	M12x1.75 x 45mm LG. HEX SOCKET HEAD CAP SCREW			
11	1	M12 x 1.75 STOVER LOCK NUT			
		MK-D317B			
1	1	PL 1/2 x 6"	10"		
5	2	SHT 11 GA x 3 5/8"	3 5/8"		
6	1	PL 3/8 x 3 5/8"	3 5/8"		
7	2	SHT 16 GA x 3 5/8"	3 5/8"		
8	1	ACE BUMPER TC 100-59		7-24	
9	1	TS 6 x 4 x 3/16	5"		
10	1	M12x1.75 x 45mm LG. HEX SOCKET HEAD CAP SCREW			
11	1	M12 x 1.75 STOVER LOCK NUT			

SHOP NOTES:

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

PAINT NOTES:

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

REV	BY	DATE	DESCRIPTION	APP
C	MC	10/6/2022	CHANGED ACE BUMPER, HARDWARE	
B	MC	8/19/2022	ADDED ABM #	
A	MC	8/8/2022	FOR FABRICATION	

REVISION HISTORY

	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: AH
CLIENT: VOLVO	CHECKED BY: JCK
DRAWING No. 1875D317	DWG DATE: 7/12/22
REV: C	JOB No: 22096

MAGNUM CONSULTING
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Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D317 - 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 SNIUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

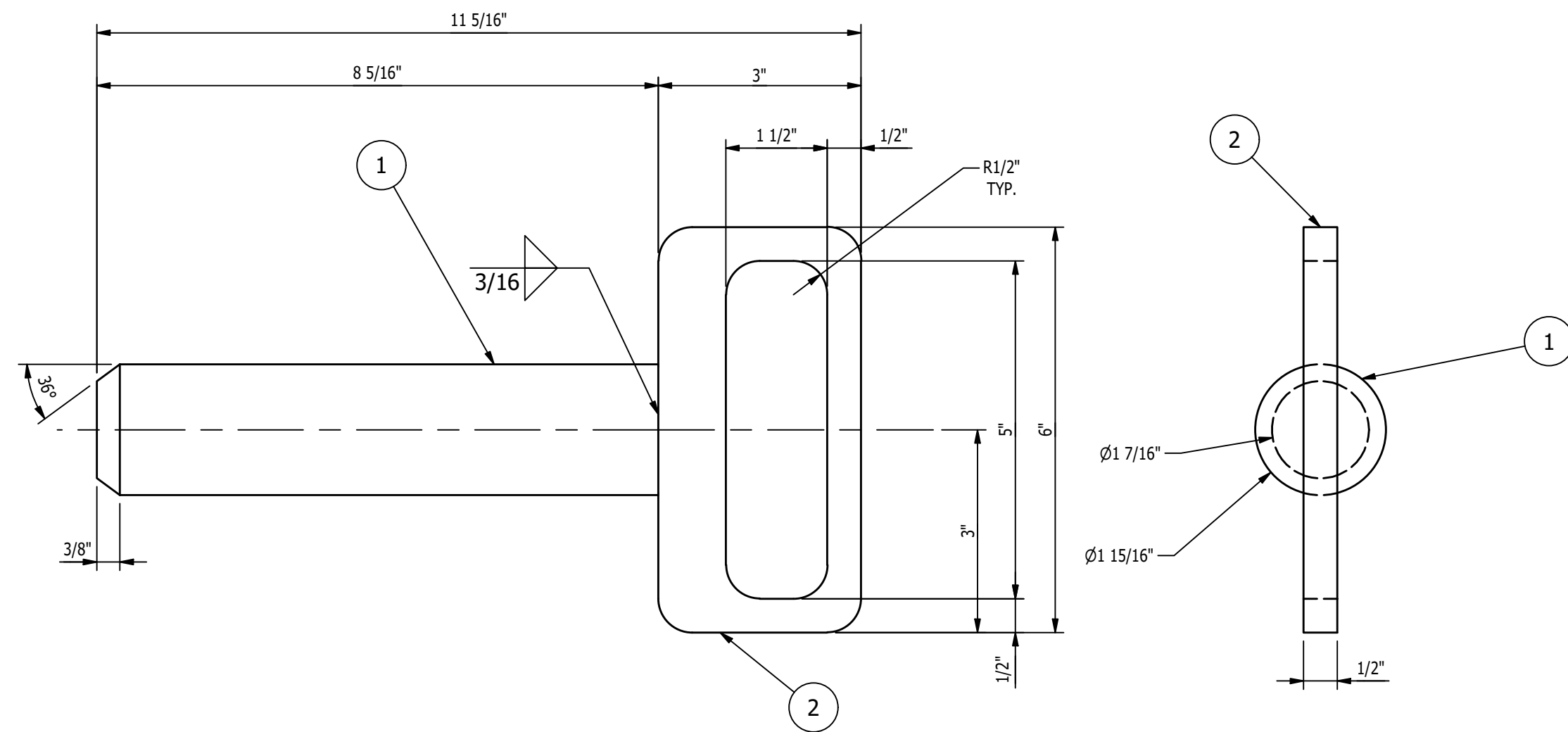
- ALL WELDS TO BE 'E70XX'. (PER AWS D1.1)

PAINT:

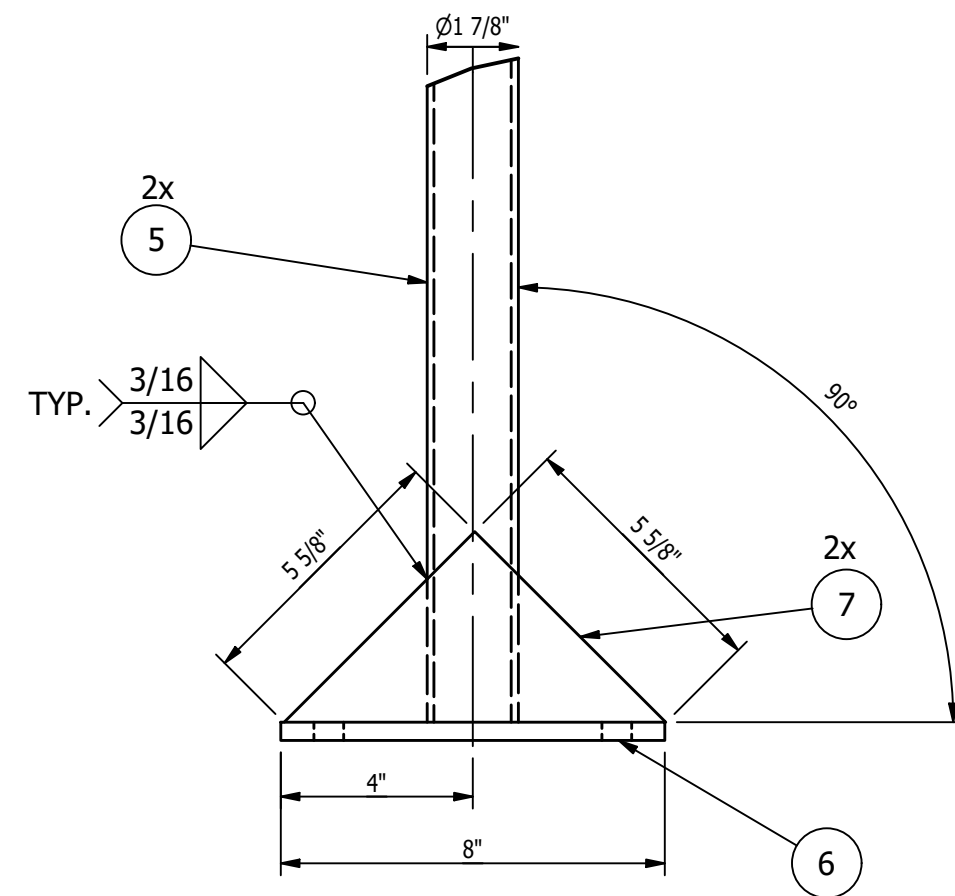
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

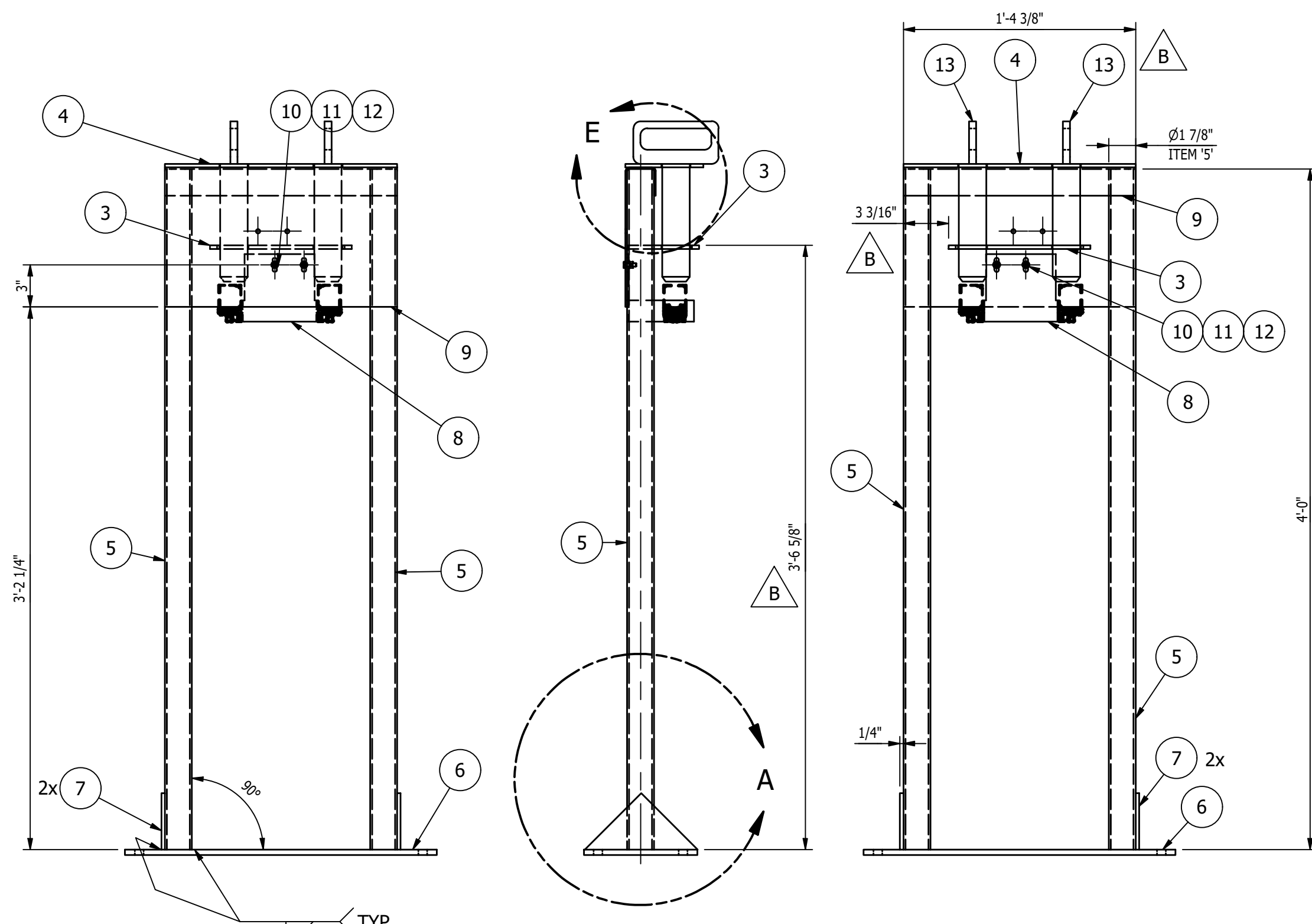


MK-D318A ~ LOCKING PIN
SCALE 6"=1'-0"

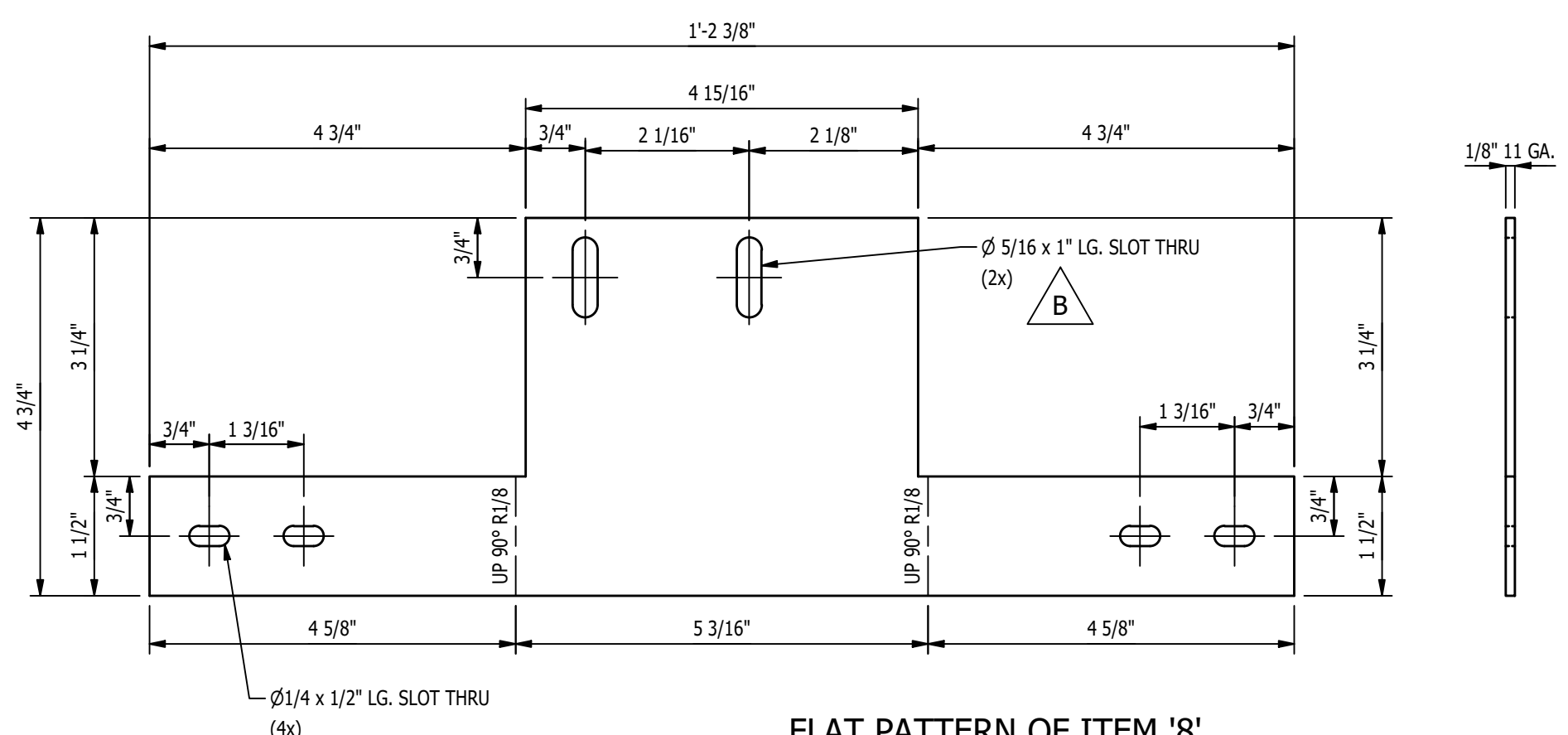


ENLARGED VIEW 'A'
SCALE 3"=1'-0"

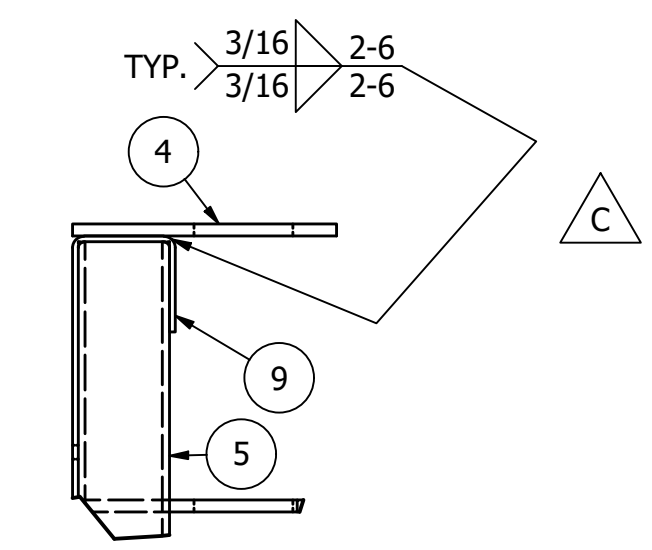
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D318A			
1	1	CRS Ø1 15/16	8 5/16"		
2	1	PL 1/2 x 3"	6"		
		MK-D318B			
3	1	PL 1/4 x 10"	5"		
4	1	PL 1/4 x 1'-4 3/8"	5 1/2"		
5	2	PIPE 1 1/2 SCH. 40	4'-0"		
6	1	PL 3/8 x 8"	1'-10"		
7	2	PL 1/4 x 5 5/8"	5 5/8"		
8	1	SHT 11 GA x 4 3/4"	1'-2 3/8"		
9	1	SHT 11 GA x 1'-1 1/2"	1'-4 3/8"		
10	2	1/4-20UNC HEX NUT			
11	2	1/4-20UNC x 3/4" LG. HEX HEAD CAP SCREW			
12	2	1/4 SPRING LOCK WASHER			
13	2	MK-D318A ~ LOCKING PIN			



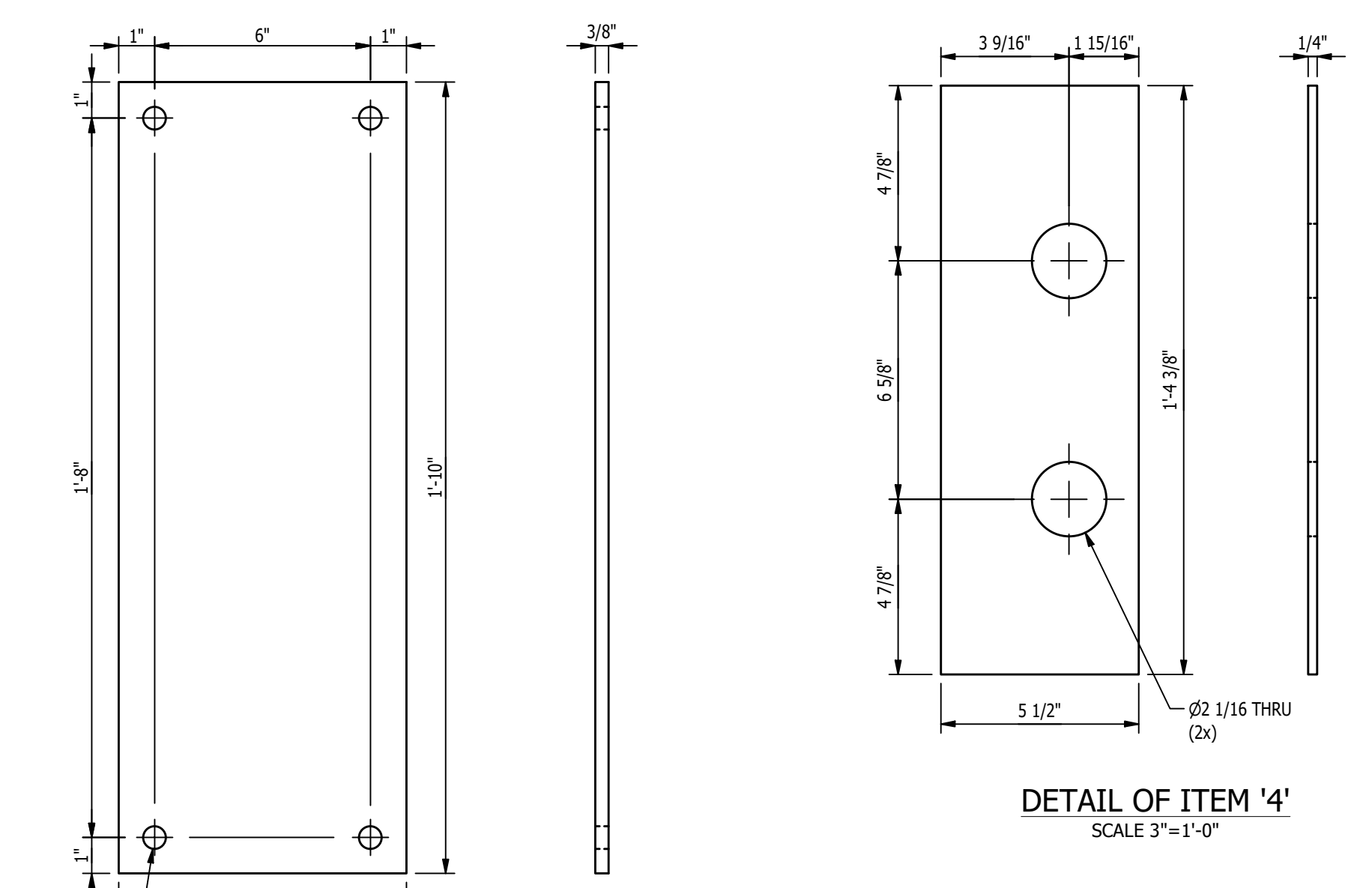
MK-D318B ~ LOCK-OUT PIN STAND ASSEMBLY
SCALE 1 1/2"=1'-0"



FLAT PATTERN OF ITEM '8'
SCALE 6"=1'-0"

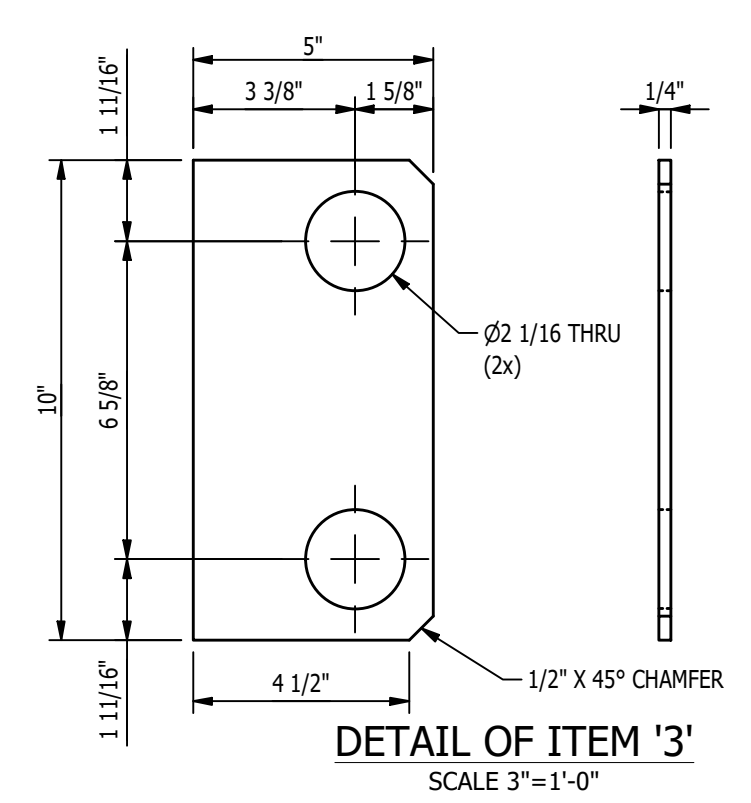


ENLARGED VIEW 'E'
SCALE 3"=1'-0"

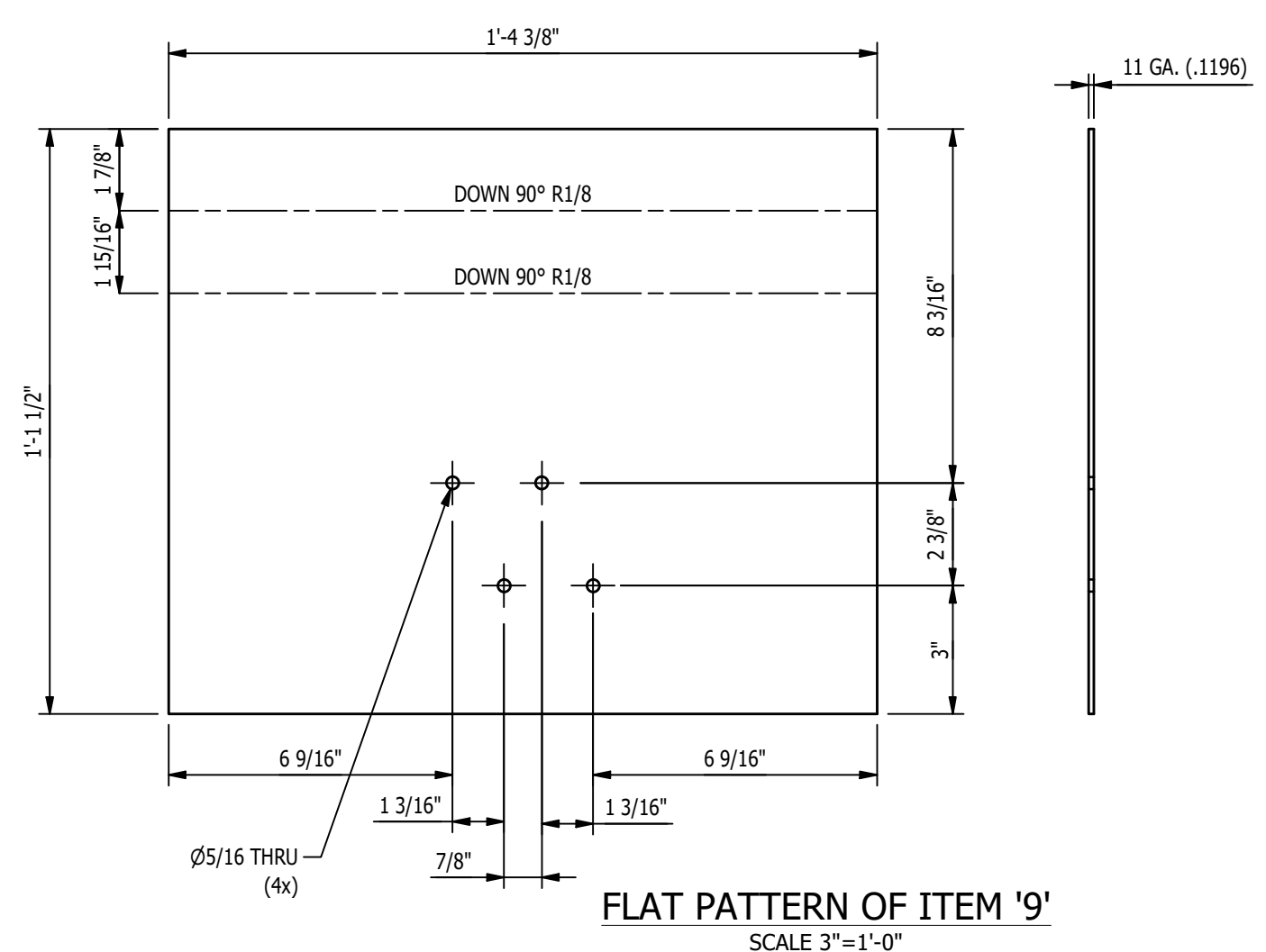


DETAIL OF ITEM '4'
SCALE 3"=1'-0"

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



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



FLAT PATTERN OF ITEM '9'
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
 MK-D318A - ONE SHOP COAT OF SAFETY YELLOW RAL 1023
 MK-D318B - ONE SHOP COAT OF LIGHT GREY RAL 7035
 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/30/22	UPDATED WELD SYMBOL LOCATION	
B	MC	8/19/2022	ADDED DIMS, BALLOON AND MODIFIED SLOT SIZE	
A	MC	8-8-2022	FOR FABRICATION	

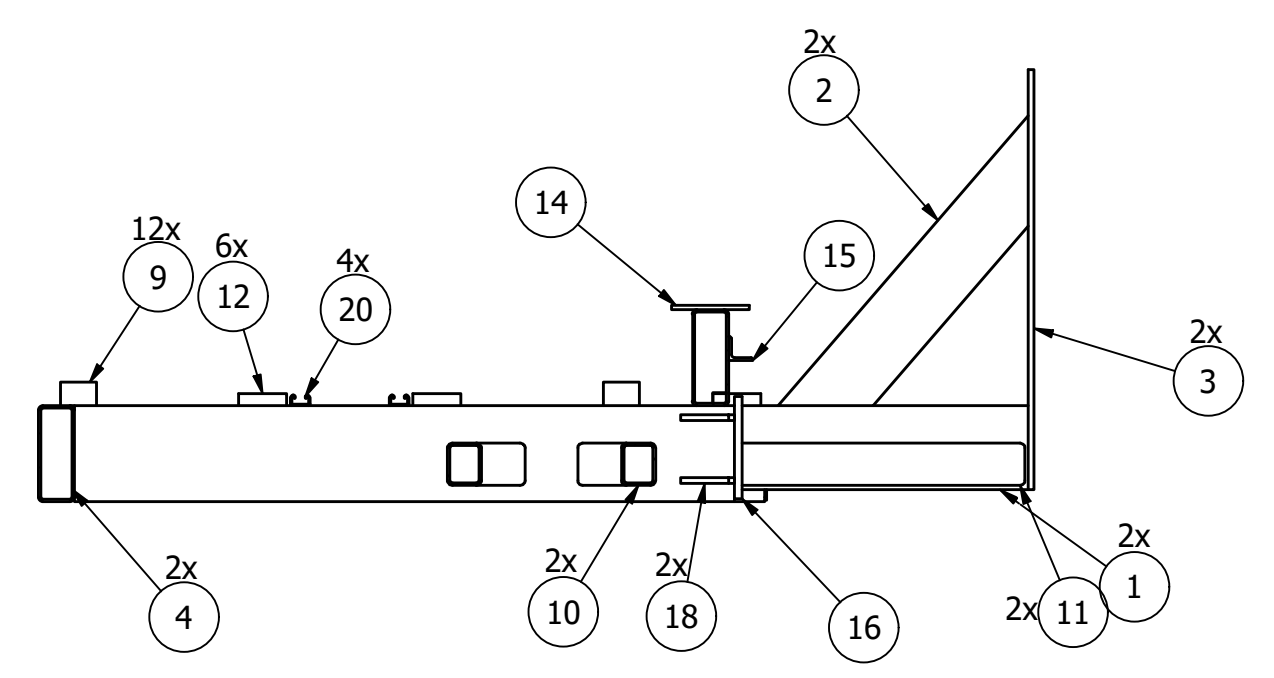
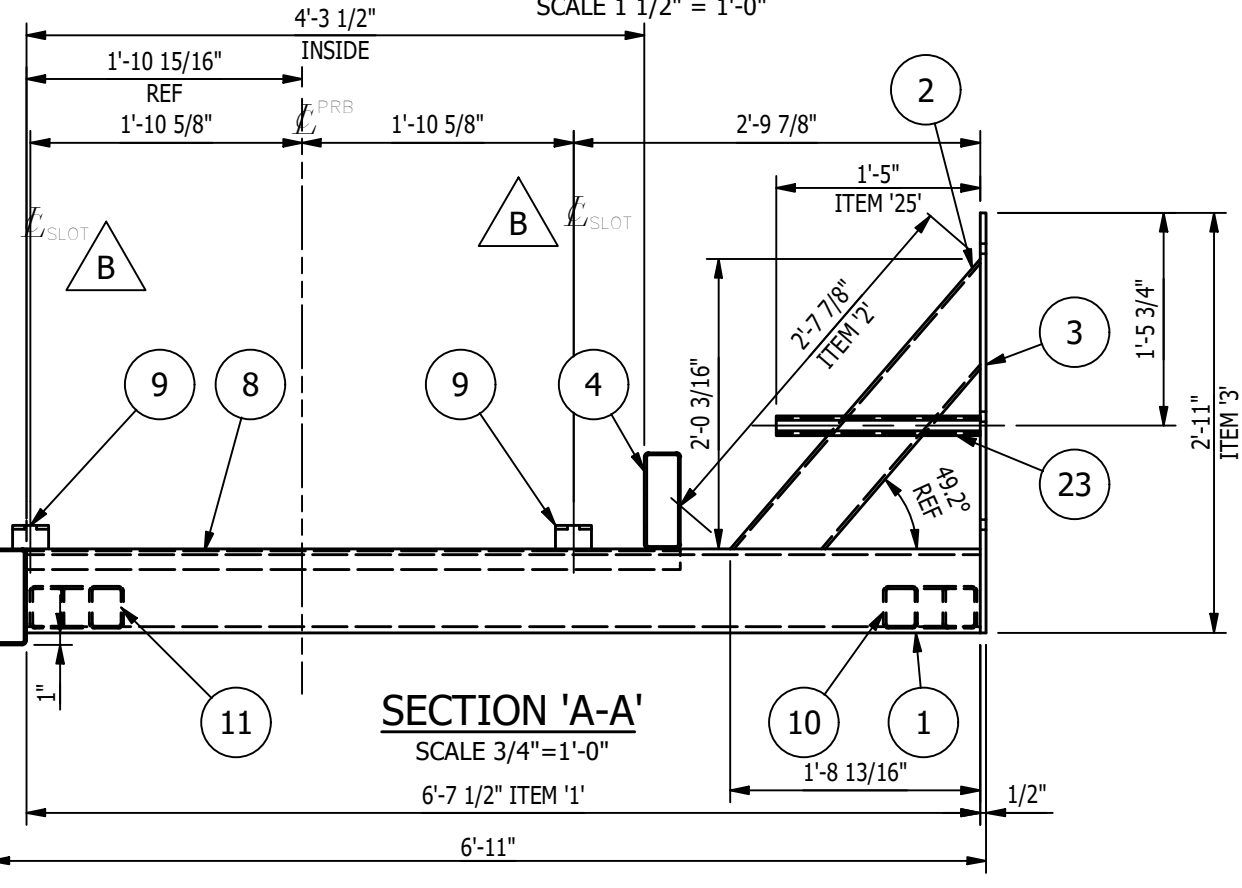
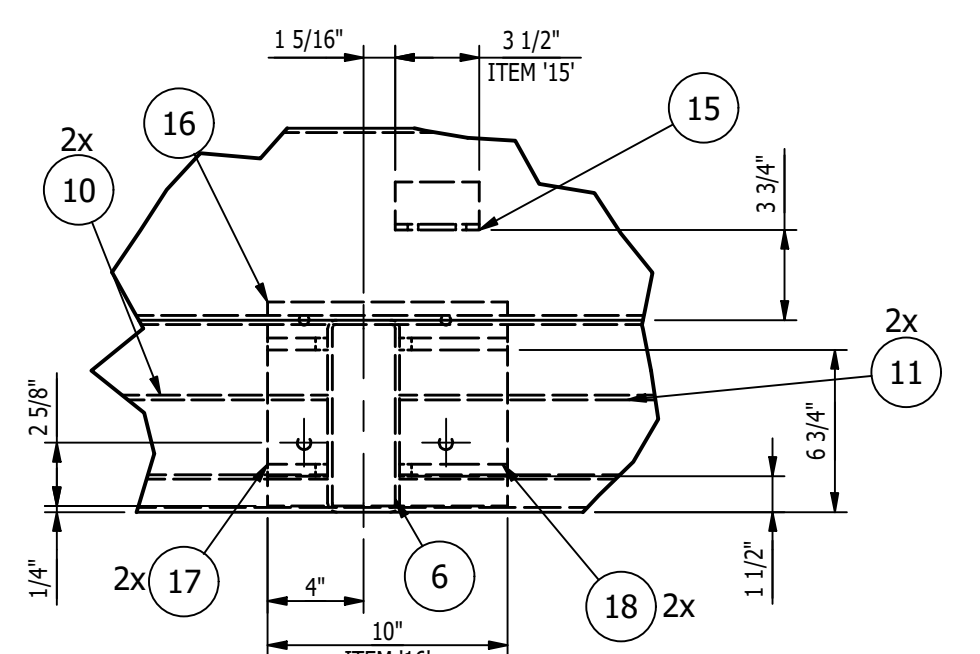
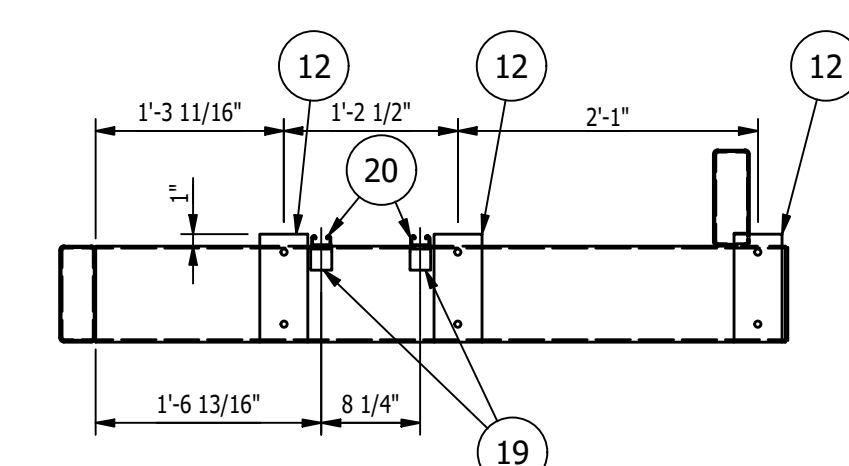
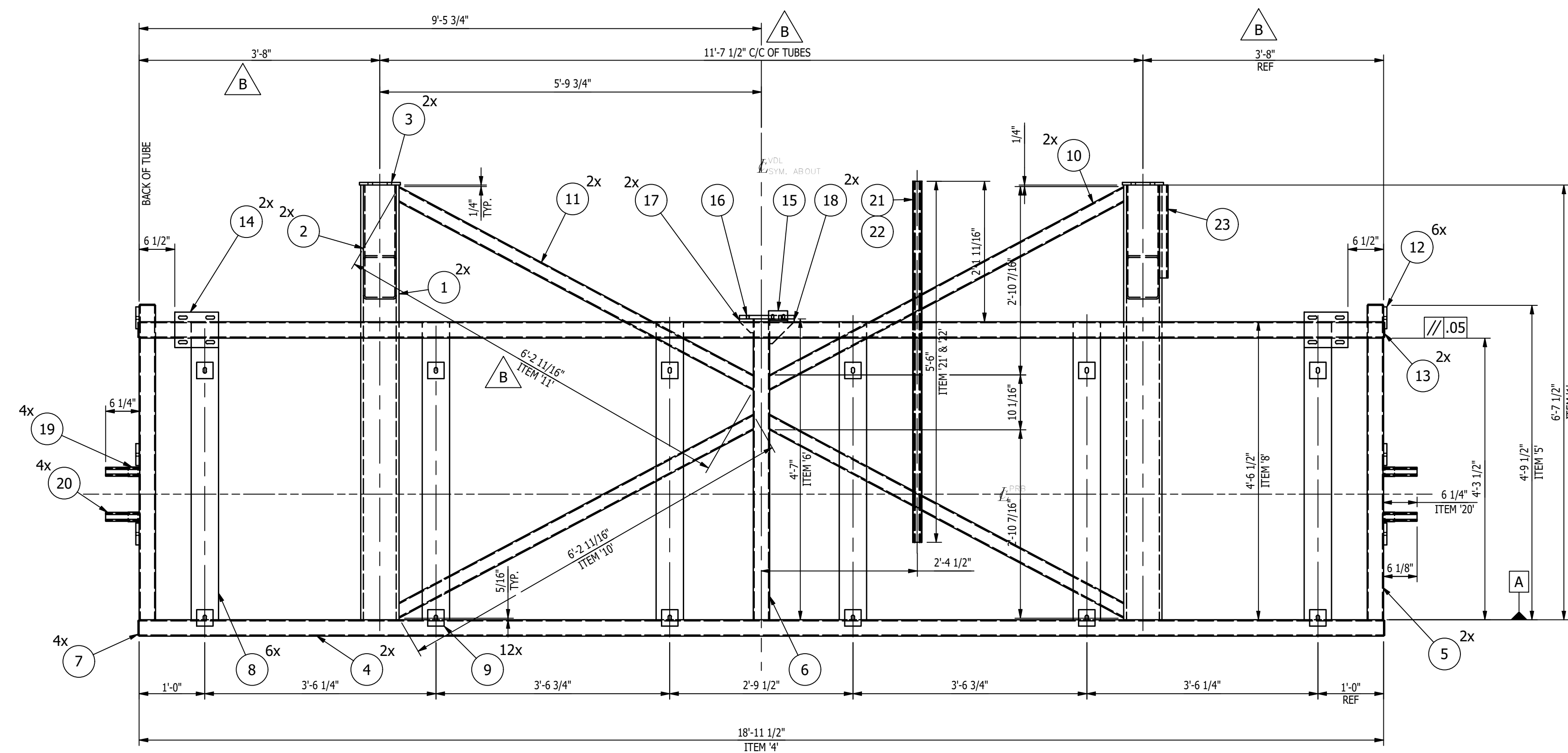
REVISION HISTORY		DRAWING INFORMATION	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	JCK
DRAWING No.	1875D318	DWG DATE:	7/7/22
REV:	C	JOB No.:	22096

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 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D318

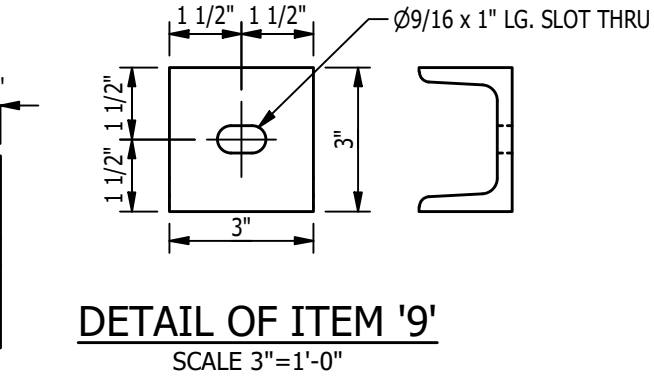
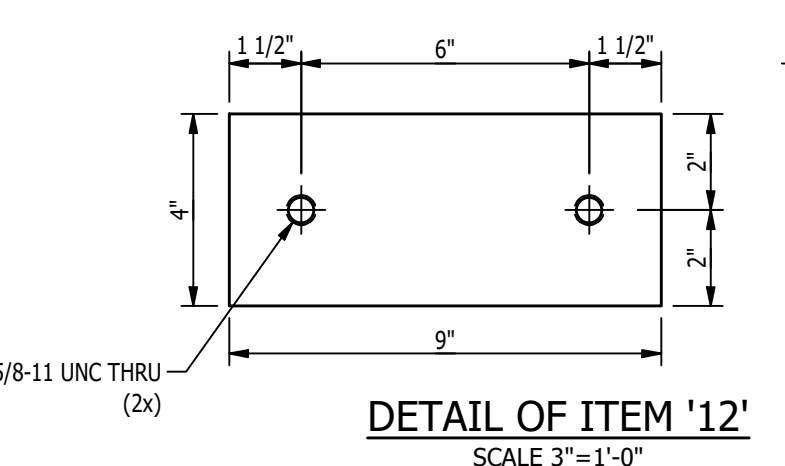
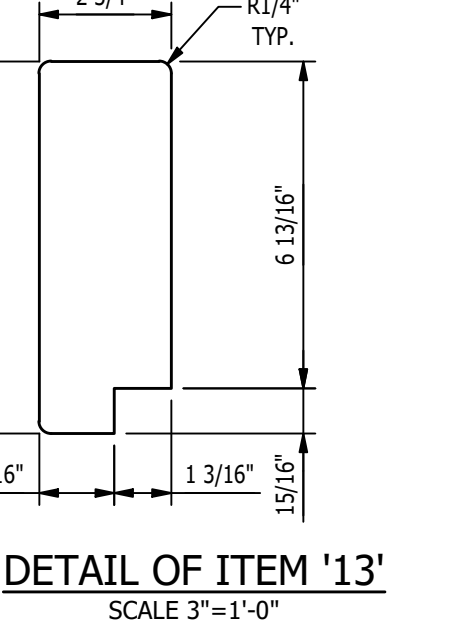
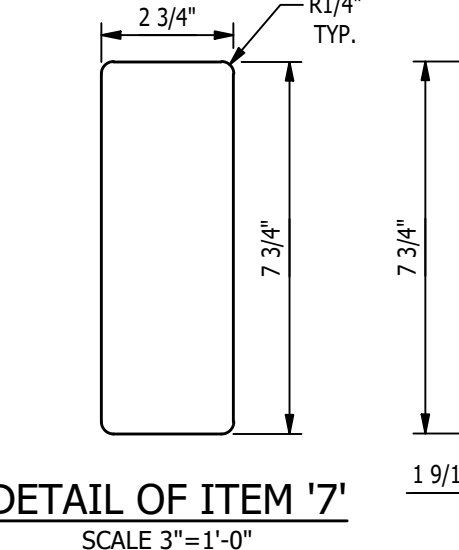
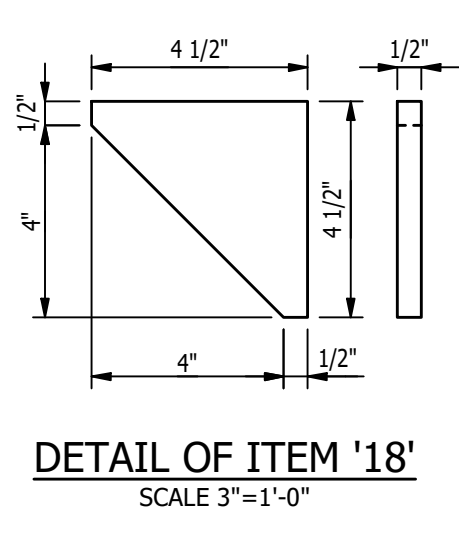
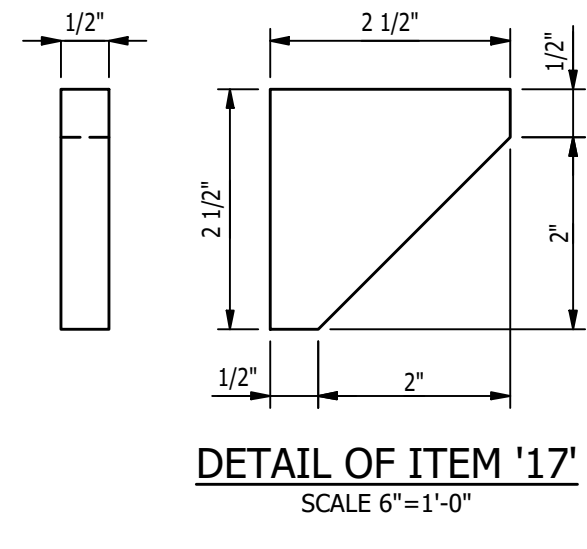
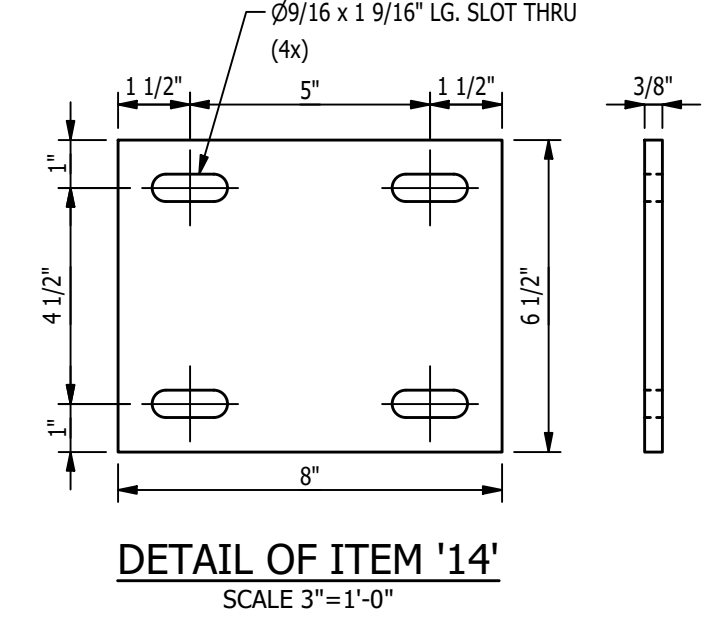
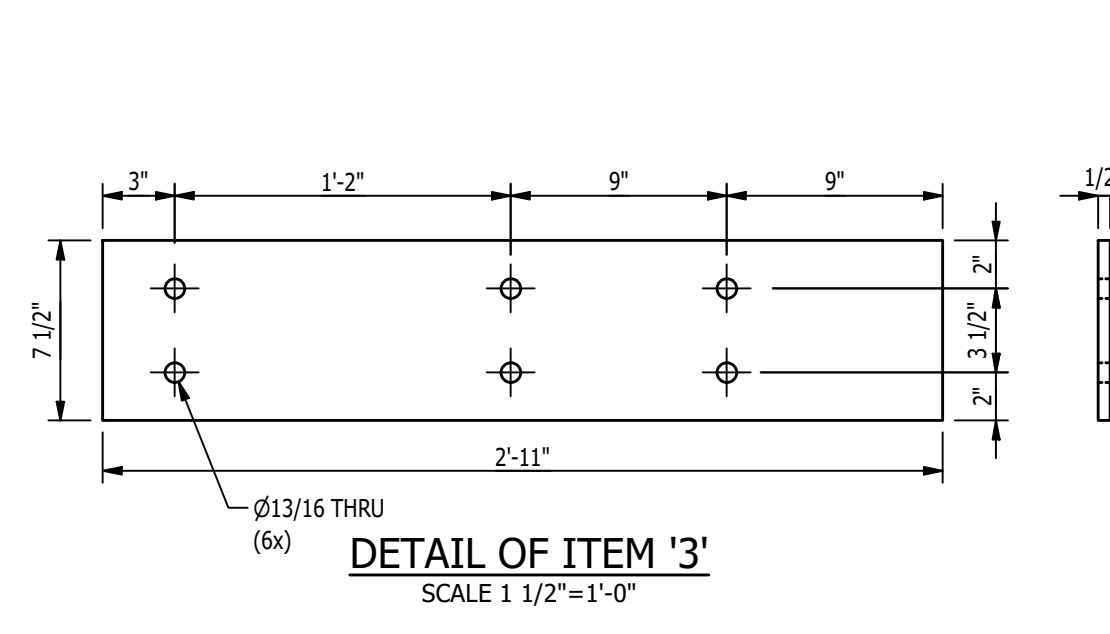
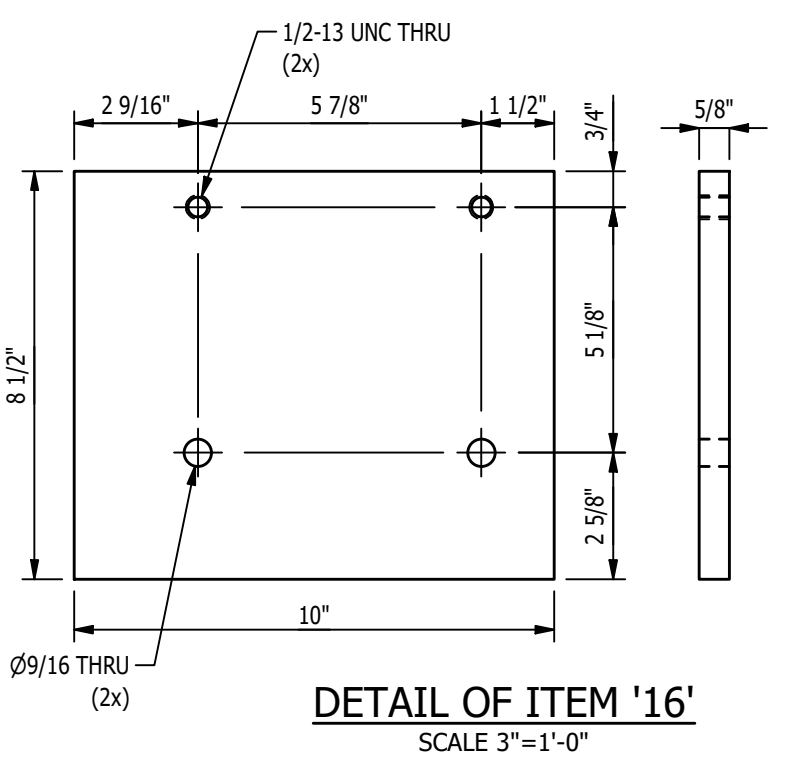
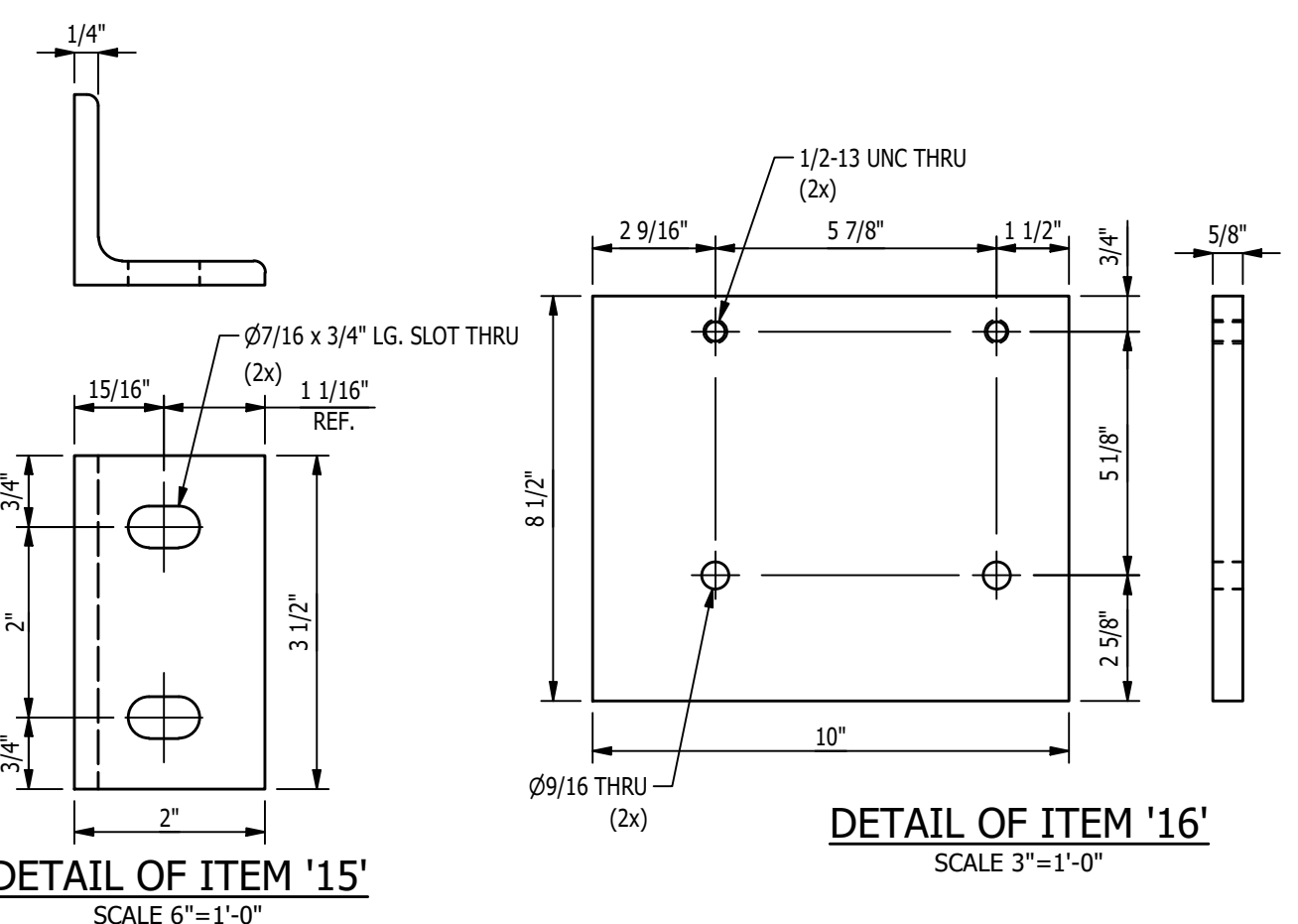
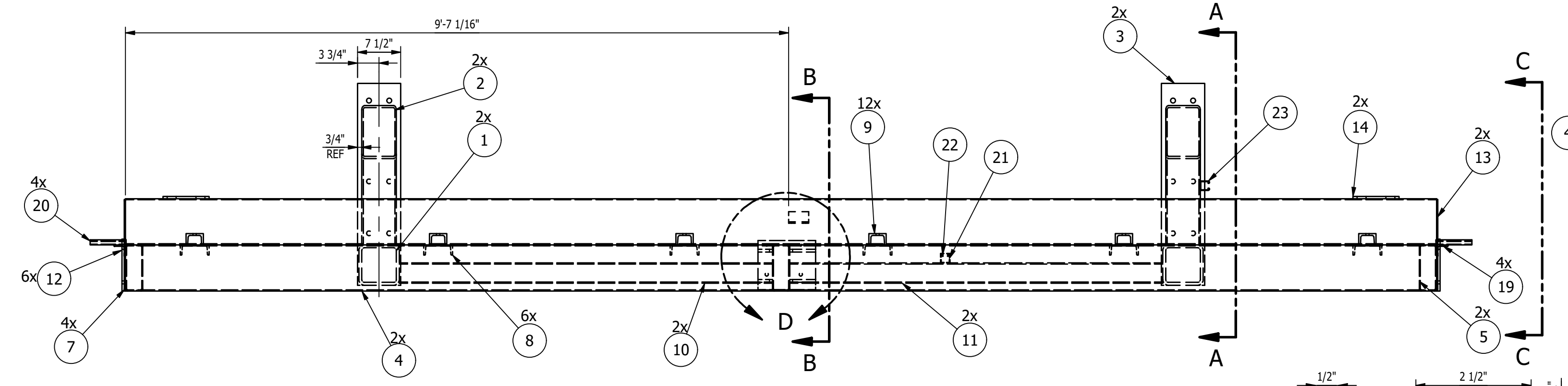
UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

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.

3:00p 1875D318 Rev. 040 Drawing/Details/1875D318.dwg



MK-D319A ~ HORIZONTAL CARRIAGE WELDMENT
 SCALE 3/4"=1'-0"



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D319A			
1	2	TS 7 x 7 x 1/2	6'-7 1/2"		
2	2	TS 6 x 6 x 1/4	2'-7 7/8"		
3	2	BAR 1/2 x 7 1/2	2'-11"		
4	2	TS 8 x 3 x 3/16	18'-11 1/2"		
5	2	TS 8 x 3 x 3/16	4'-9 1/2"		
6	1	TS 8 x 3 x 3/16	4'-7"		
7	4	SHT 6 GA x 2 3/4	7 3/4"		
8	6	C 5 x 6.7	4'-6 1/2"		
9	12	MC 3 x 7.1	3"		
10	2	TS 3 1/2 x 2 1/2 x 3/16	6'-2 11/16"		
11	2	TS 3 1/2 x 2 1/2 x 3/16	6'-2 11/16"		
12	6	BAR 5/8 x 4	9"		
13	2	SHT 6 GA x 2 3/4	7 3/4"		
14	2	BAR 3/8 x 6 1/2	8"		
15	1	L 2 x 2 x 1/4	3 1/2"		
16	1	BAR 5/8 x 10	8 1/2"		
17	2	BAR 1/2 x 2 1/2	2 1/2"		
18	2	BAR 1/2 x 4 1/2	4 1/2"		
19	4	L 2 x 2 x 1/4	1 3/4"		
20	4	UNISTRUT 1-5/8 x 7/8 12 GAGE METAL CHANNEL, PLAIN FINISH, PART NO. P3300-PL	6 1/4"		
21	1	UNISTRUT 1-5/8 x 1-5/8 12 GAGE METAL CHANNEL, PLAIN FINISH, PART NO. P1000-PL	5'-6"		
22	1	PVC CLOSURE STRIP, GRAY, UNISTRUT PART NO. P1184P-GY	5'-6"	20-6	
23	1	UNISTRUT 1-5/8 x 1-5/8 12 GAGE METAL CHANNEL, PLAIN FINISH, PART NO. P1000-PL	1'-5"		

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	ADJUSTED ARM SPACING, ADDED PAINT NOTE & UPDATED LENGTH	
A	MC	8-8-2022	FOR FABRICATION	

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

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

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH
CLIENT: VOLVO	CHECKED BY: JCK
DRAWING No. 1875D319	DWG DATE: 7/22/22
REV: B	JOB No: 22096

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

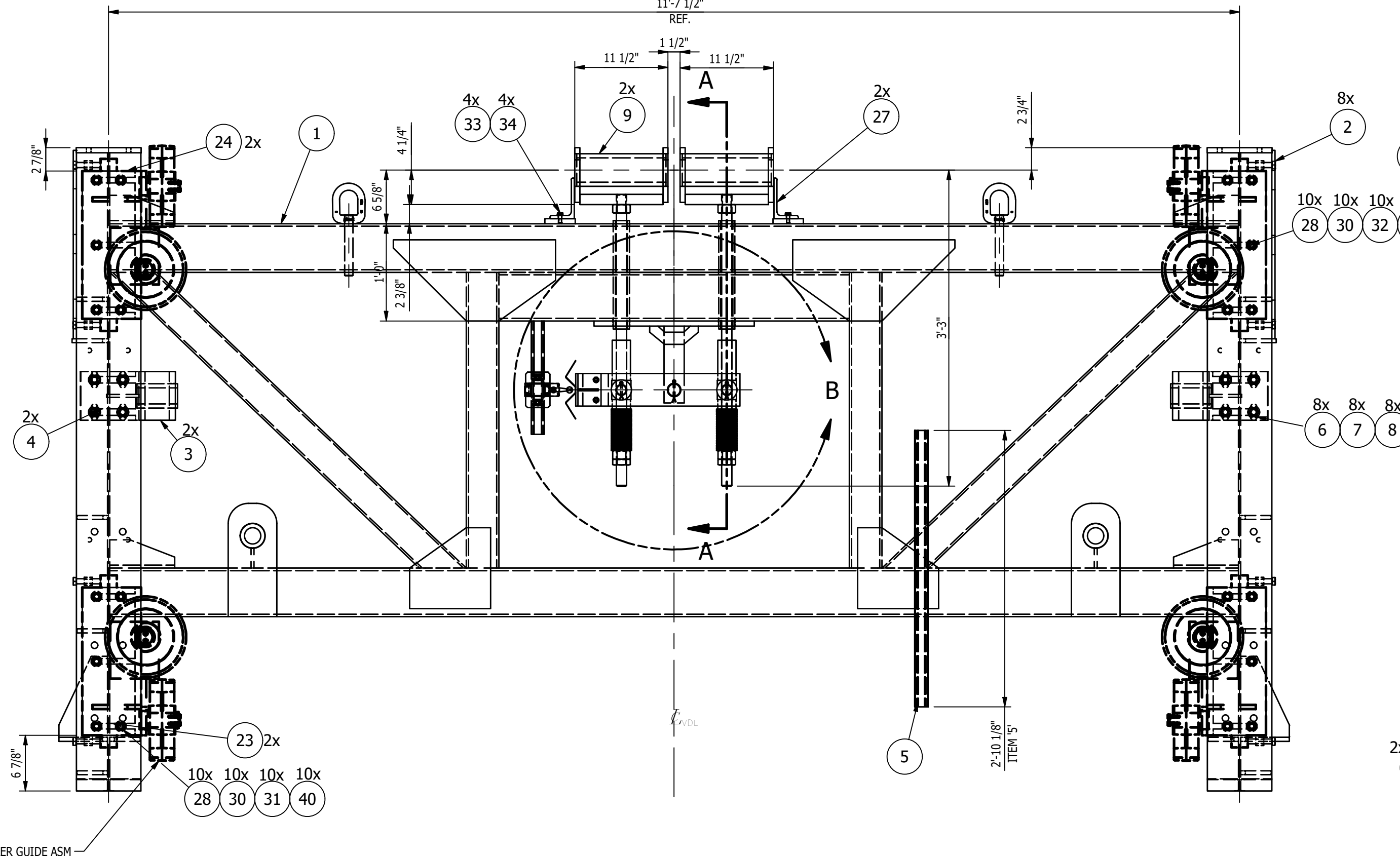
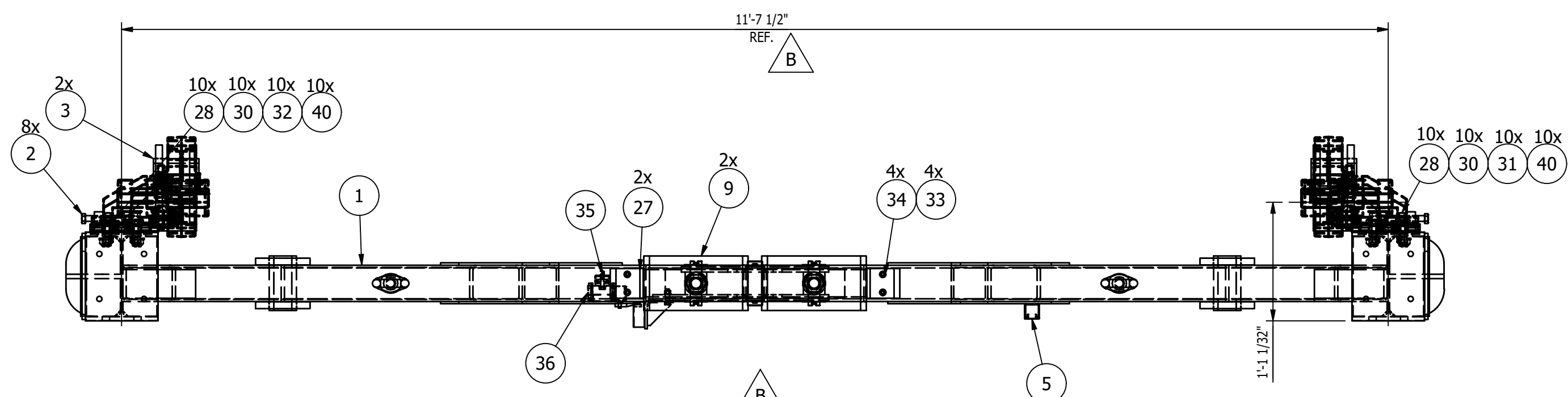
Phone: (248) 773-8889
 Fax: (248) 773-8851
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D319

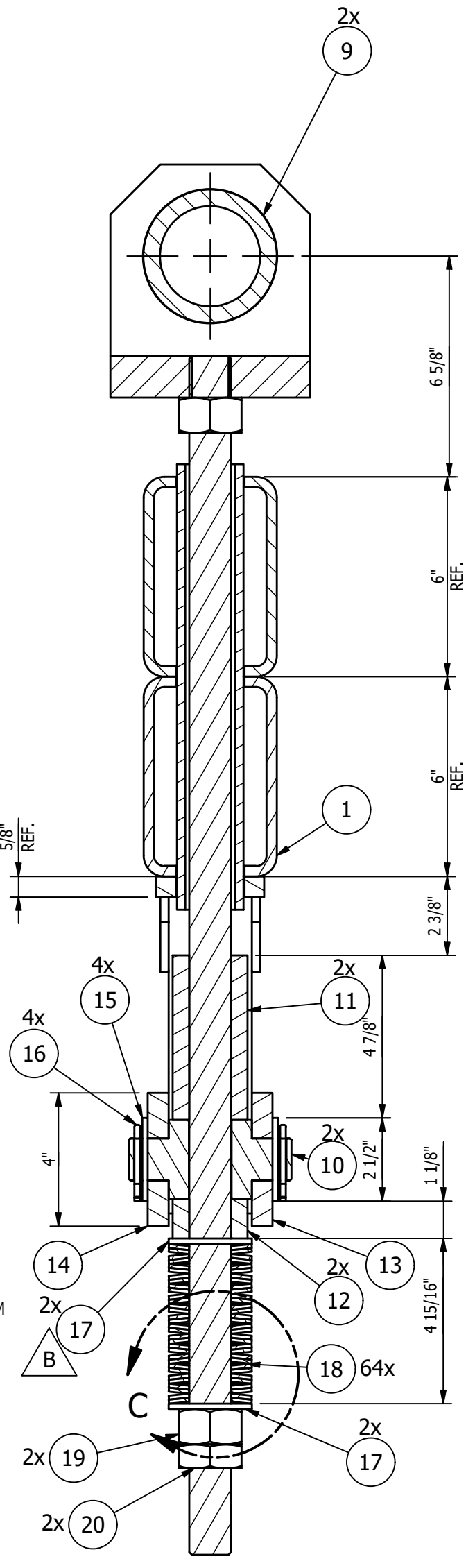
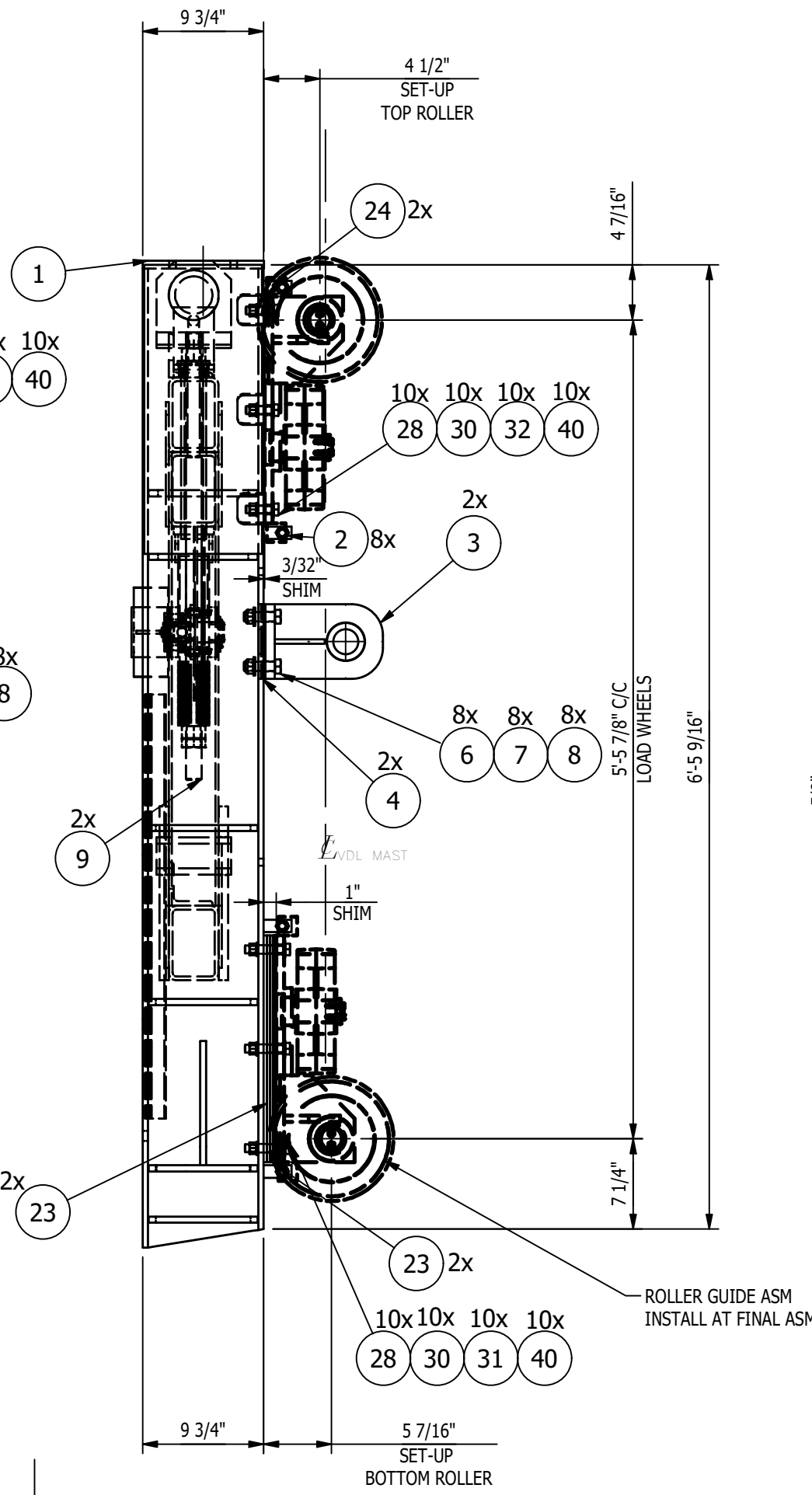
UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005

FRACTIONS = ±1/16"
 ANGLES = ±1°30'

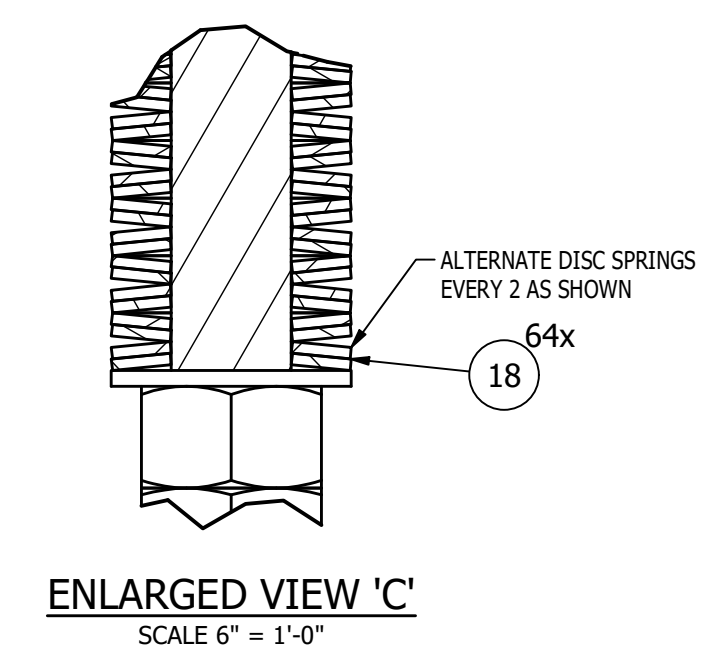
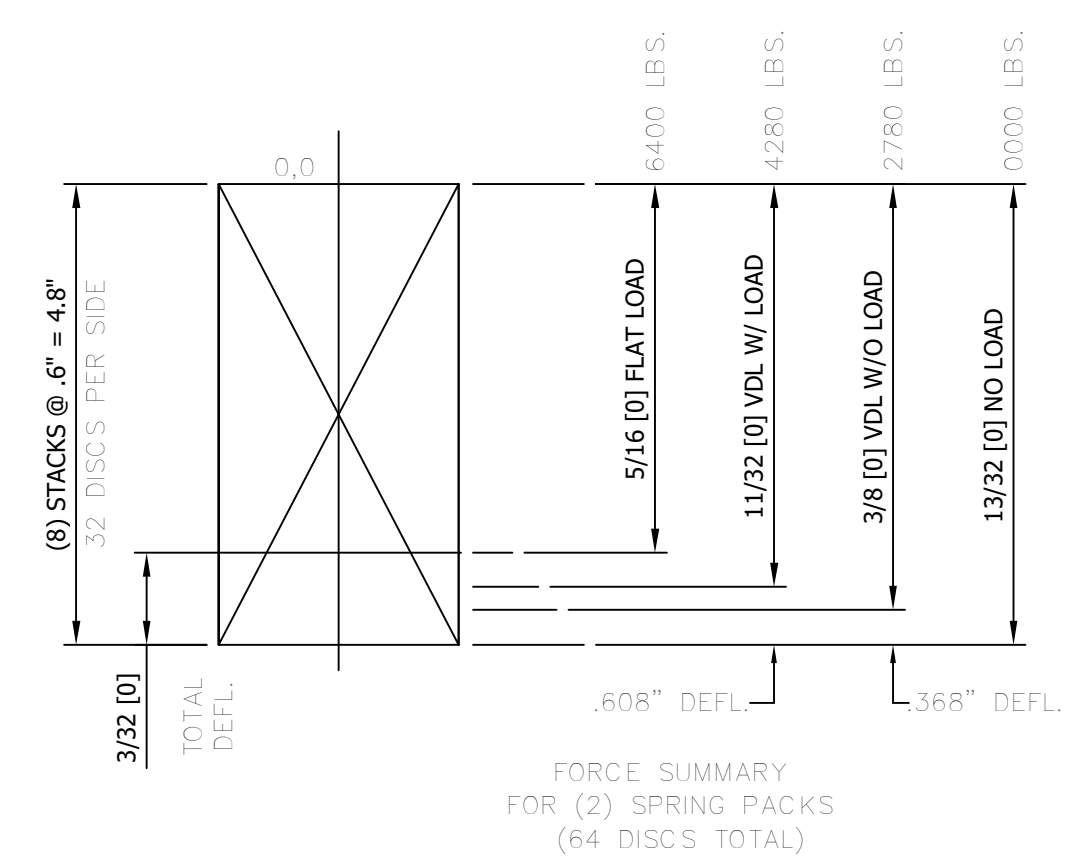
BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING



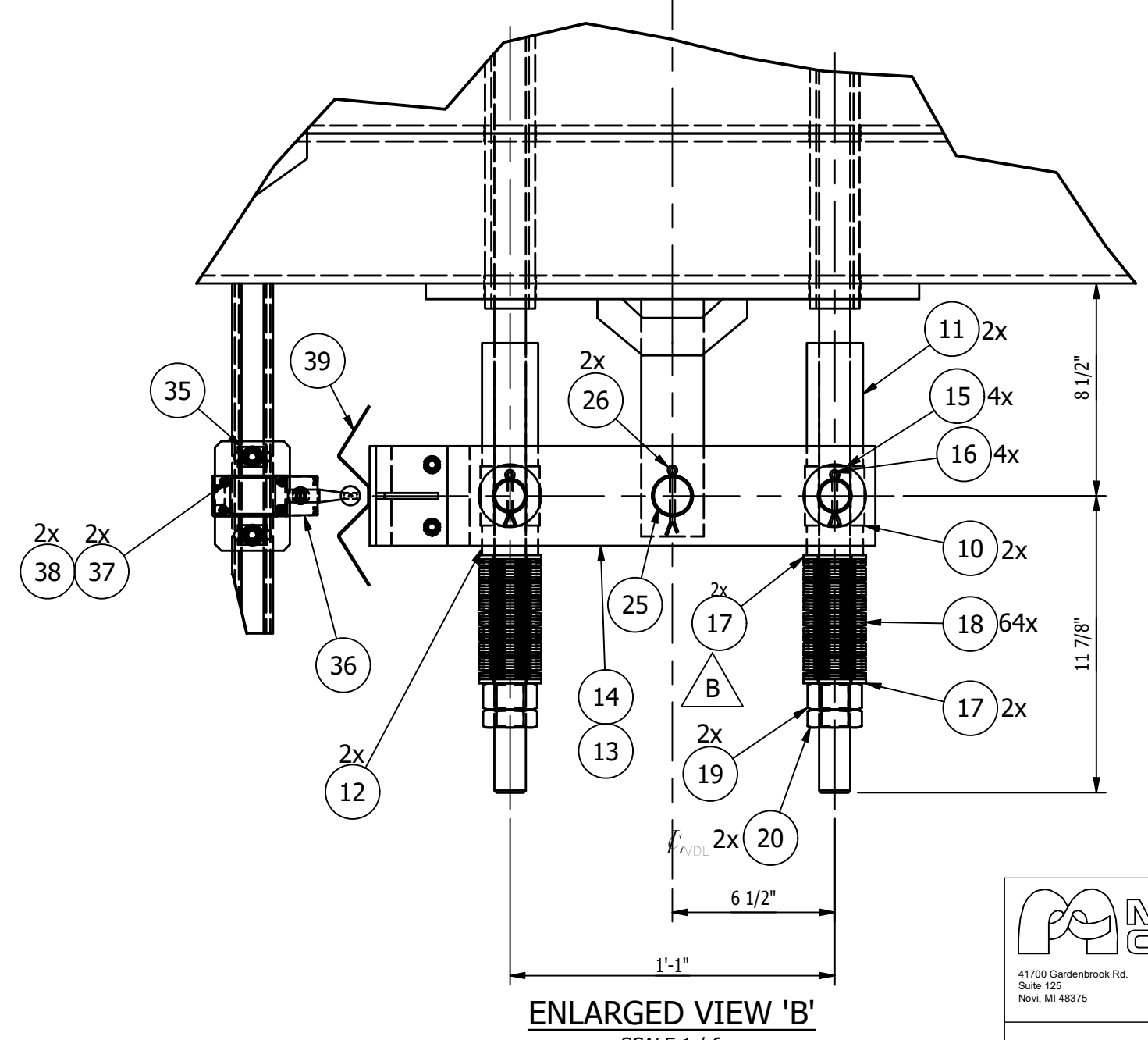
MK-D320A ~ VERTICAL CARRIAGE ASSEMBLY
SCALE 1"=1'-0"



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



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



ENLARGED VIEW 'B'
SCALE 1/4"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D320A			
2	8	5/8-11UNC x 3" LG. HEX HEAD CAP SCREW, FULLY THREADED			
3	2	MK-D322B ~ CARRIAGE LOCK-OUT PLATE			
4	2	MK-D322C ~ LOCK-OUT SHIM PACK			
5	1	PVC CLOSURE STRIP, GRAY, UNISTRUT PART NO. P1184P-GY	2'-10 1/8"	20-6	
6	8	3/4 FLAT HARDENED WASHER F436			
7	8	3/4-10UNC STOVER LOCK NUT			
8	8	3/4-10UNC x 2 1/2" LG. HEX HEAD CAP SCREW, GR-8			
9	2	MK-D325A ~ BELT YOKE			
10	2	MK-D325B ~ TEE PIVOT			
11	2	MK-D325C ~ TUBE SPACER			
12	2	MK-D325D ~ TUBE SPACER			
13	1	MK-D325E ~ PIVOT PLATE			
14	1	MK-D325F ~ PIVOT PLATE			
15	4	1 1/4 TYPE A NARROW FLAT WASHER			
16	4	3/16 x 1 3/4 LG. COTTER PIN			
17	4	1 1/4 FLAT WASHER, GRADE 8, ZINC PLATED			
18	64	BELLEVILLE DISC SPRING, 1.25" ID x 2.5" OD x 0.12" THICK, McMASTER-CARR PART NO. 9712K97		7-9	
19	2	1 1/4-7UNC HEX NUT			
20	2	1 1/4-7UNC HEX JAM NUT			
23	2	MK-D314B ~ LOWER GUIDE WHEEL SHIM PACK			
24	2	MK-D314C ~ UPPER GUIDE WHEEL SHIM PACK			
25	1	MK-D325G ~ CENTER PIVOT PIN			
26	2	3/16 x 2 1/4 LG. COTTER PIN			
27	2	MK-D325H ~ BELT YOKE GUIDE ANGLE			
28	20	5/8 SPRING LOCK WASHER			
30	20	5/8 TYPE A NARROW FLAT WASHER			
31	10	5/8-11UNC x 3 1/4" LG. HEX HEAD CAP SCREW			
32	10	5/8-11UNC x 2 1/4" LG. HEX HEAD CAP SCREW			
33	4	3/8 SPRING LOCK WASHER			
34	4	3/8-16UNC x 1" LG. HEX HEAD CAP SCREW			
35	1	MK-D324B ~ SLACK BELT LIMIT SWITCH PLATE			
36	1	ALLEN-BRADLEY 802T LIMIT SWITCH W/ 2" FIXED ARM (PROVIDED BY OTHERS)			
37	2	M4x0.7 x 45mm LG. HEX SOCKET HEAD CAP SCREW			
38	2	M4 SPRING LOCK WASHER			
39	1	MK-D324C ~ SLACK BELT DETECT FLAG			
40	20	5/8-11UNC HEX NUT			

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	UPDATED GEOMETRY & ADDED BALLOON & ABM #	
A	MC	8/8/2022	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:

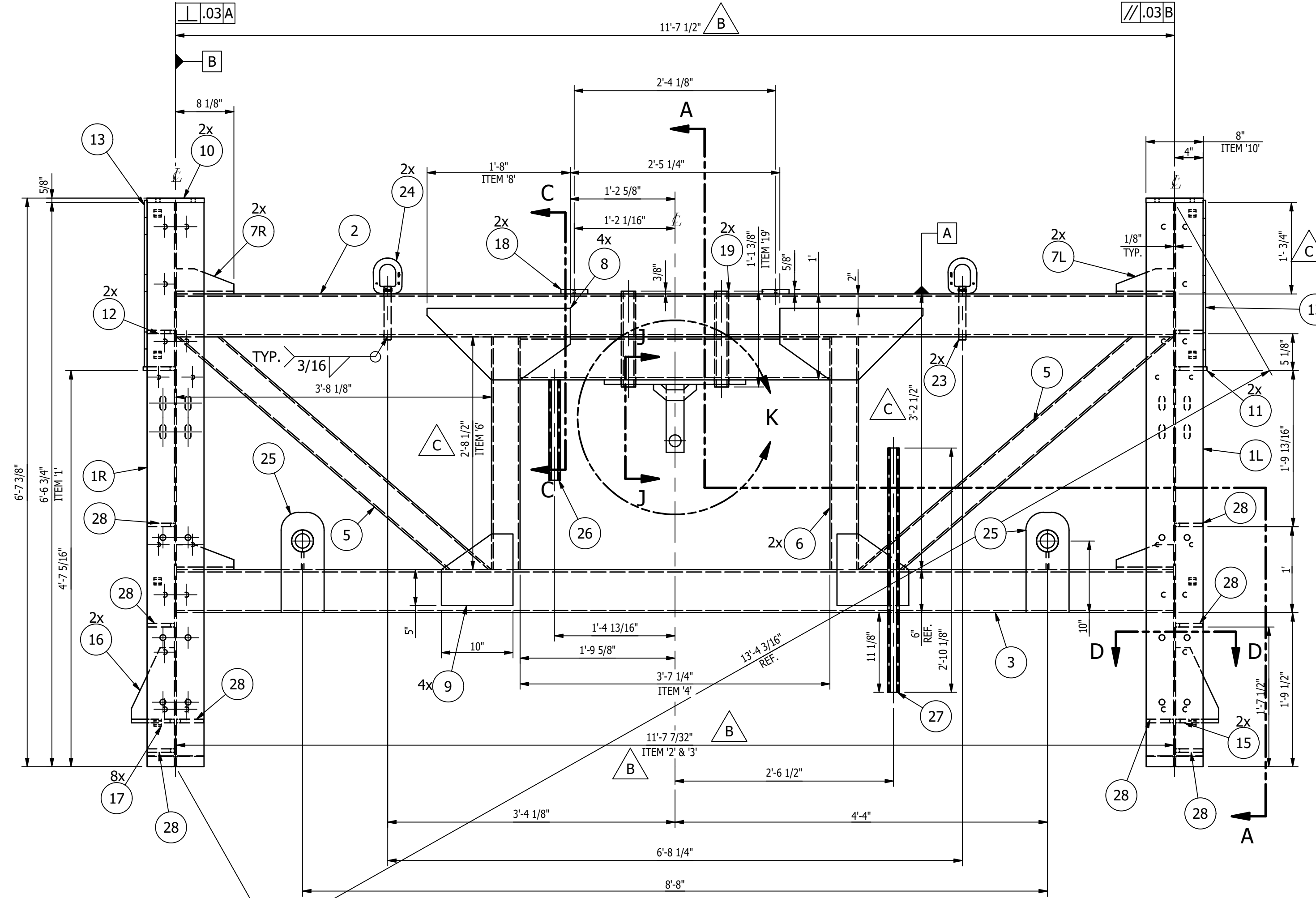
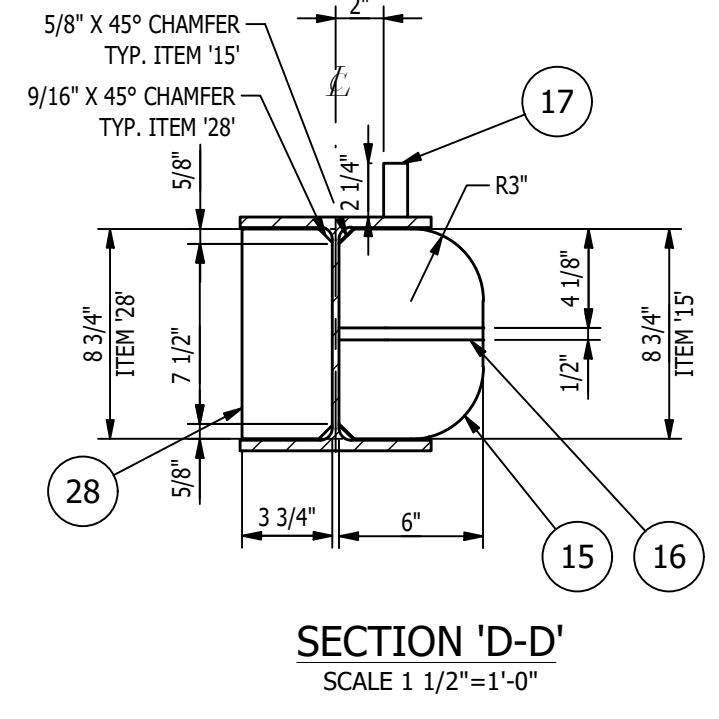
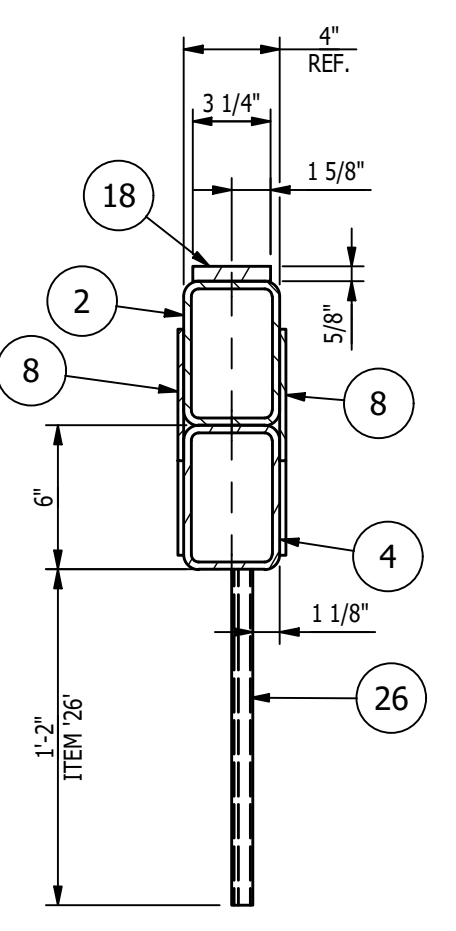
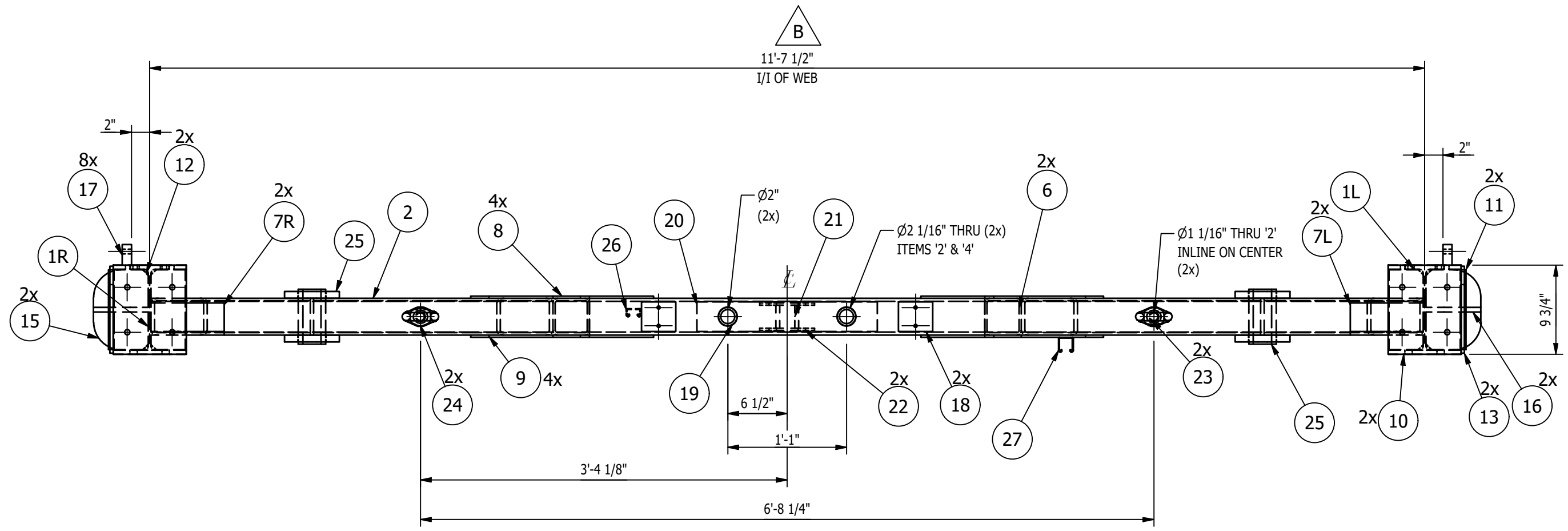
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

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3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
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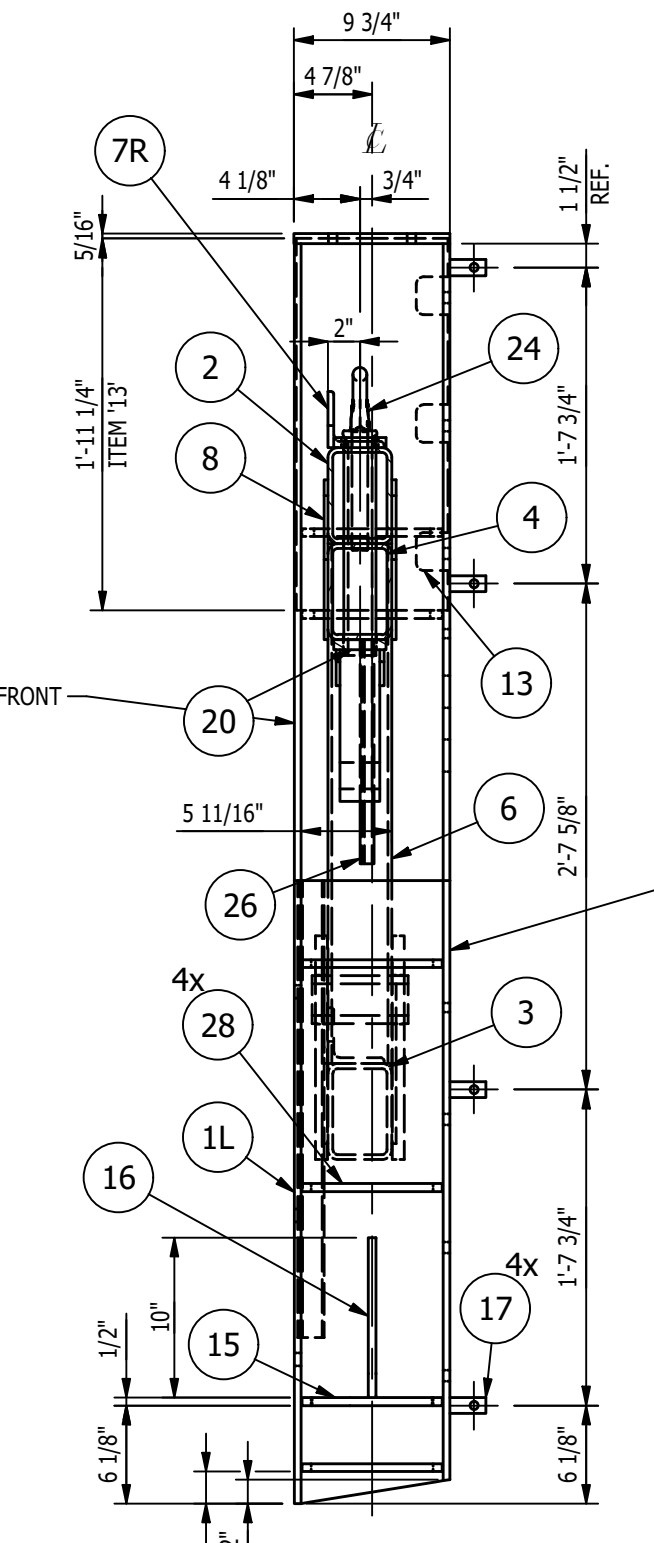
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	JCK
DRAWING No.	1875D320	DWG DATE:	7/21/22
REV:	B	JOB No.:	22096

MAGNUM Consulting
41100 Charleston Rd.
Suite 125
Wood, MI 48095
Phone: (248) 772-8882
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D320

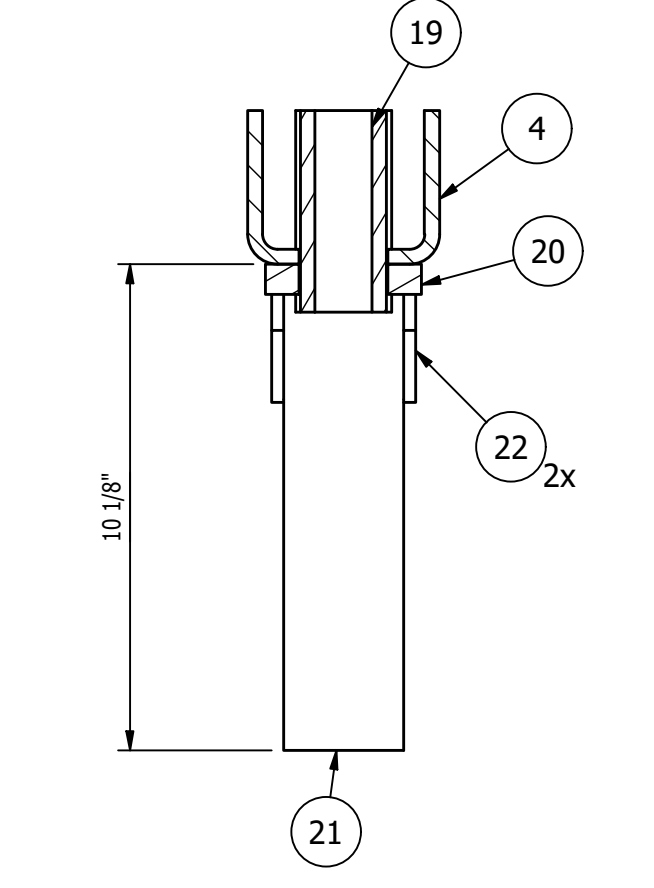
UNLESS OTHERWISE NOTED:
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XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



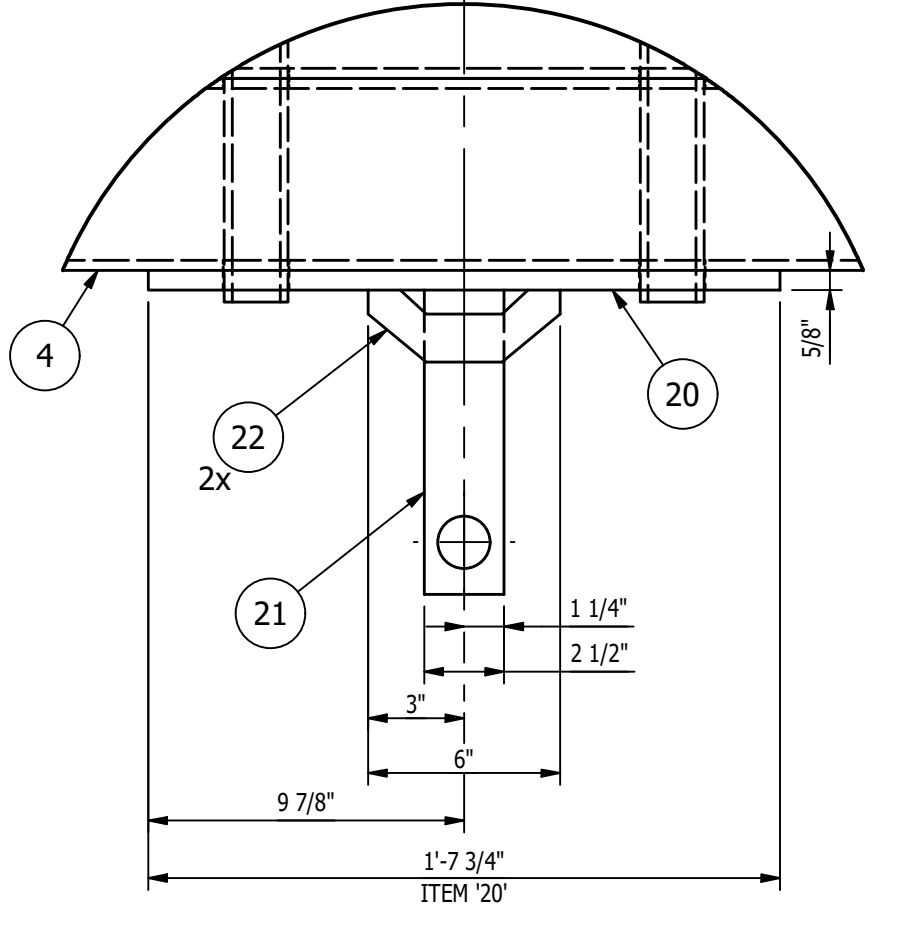
SECTION 'C-C'
SCALE 1 1/2"=1'-0"



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

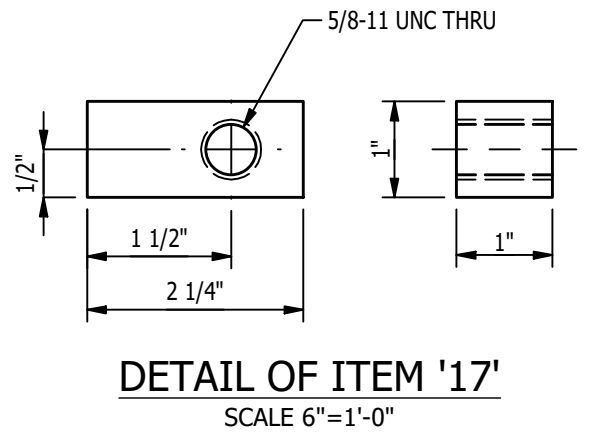


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SCALE 3"=1'-0"

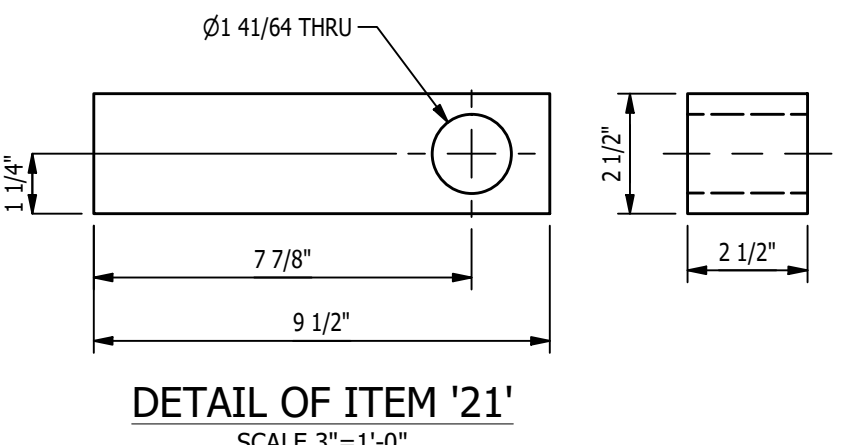


ENLARGED VIEW 'K'
SCALE 1 / 6

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D321A			
1R	1	W 10 x 33	6'-6 3/4"		
1L	1	W 10 x 33	6'-6 3/4"		
2	1	TS 6 x 4 x 5/16	11'-7 7/32"		
3	1	TS 6 x 4 x 5/16	11'-7 7/32"		
4	1	TS 6 x 4 x 5/16	3'-7 1/4"		
5	2	TS 4 x 4 x 1/4	4'-6 17/32"		
6	2	TS 4 x 4 x 1/4	2'-8 1/2"		
7R	2	L 3 1/2 x 3 1/2 x 3/8	8"		
7L	2	L 3 1/2 x 3 1/2 x 3/8	8"		
8	4	BAR 1/4 x 10	1'-8"		
9	4	BAR 1/4 x 10	10"		
10	2	BAR 5/8 x 8	9 3/4"		
11	2	BAR 1/2 x 4 1/2	8 3/4"		
12	2	BAR 1/2 x 4	8 3/4"		
13	2	PL 3/8 x 9 1/2"	1'-11 1/4"		
15	2	BAR 1/2 x 6	8 3/4"		
16	2	BAR 1/2 x 6	10"		
17	8	SQ. BAR 1	2 1/4"		
18	2	BAR 5/8 x 3 1/4	3 3/4"		
19	2	TS 2 OD x 1/4 DOM	1'-1 3/8"		
20	1	BAR 5/8 x 3 1/4	1'-7 3/4"		
21	1	SQ. BAR 2 1/2	9 1/2"		
22	2	BAR 1/4 x 2 1/4	6"		
23	2	THD. ROD 1-8UNC	7 1/2"		
24	2	G-400 FORGED EYE NUT, SIZE 7 W/1-8UNC THREAD, CROSBY PART NO. 1090599		7-6	
25	2	MK-D322A ~ CARRIAGE LOCK-OUT PLATE			
26	1	UNISTRUT 1-5/8 x 7/8 12 GAGE METAL CHANNEL, PLAIN FINISH, PART NO. P3300-PL	1'-2"		
27	1	UNISTRUT 1-5/8 x 1-5/8 12 GAGE METAL CHANNEL, PLAIN FINISH, PART NO. P1000-PL	2'-10 1/8"		
28	8	PL 1/2 x 3 3/4	8 3/4"		

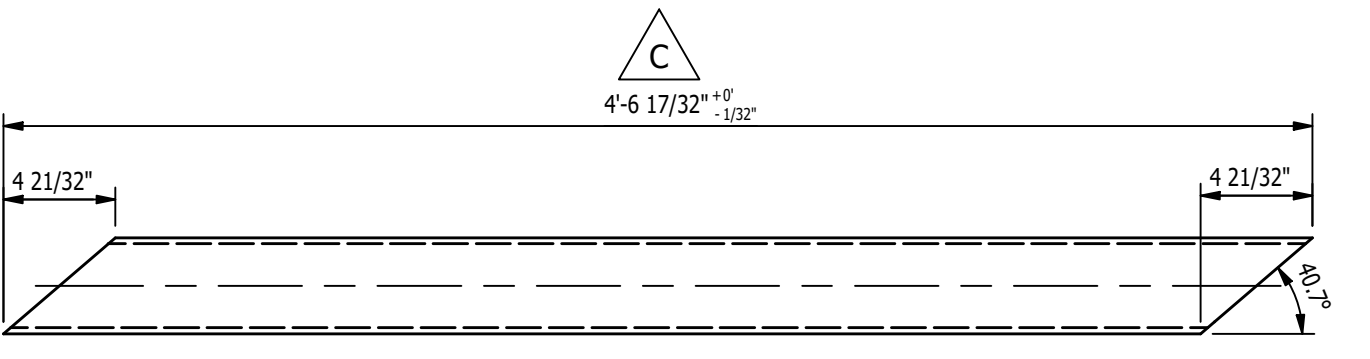


DETAIL OF ITEM '17'
SCALE 6"=1'-0"

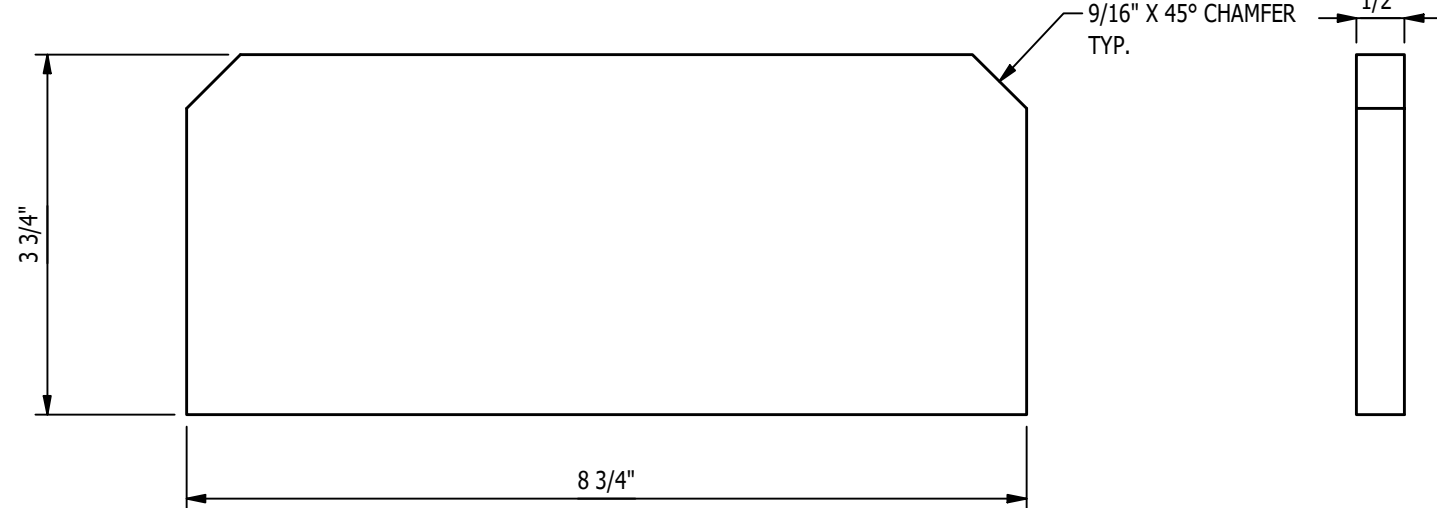


DETAIL OF ITEM '21'
SCALE 3"=1'-0"

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



DETAIL OF ITEM '5'
SCALE 1 1/2"=1'-0"



DETAIL OF ITEM '28'
SCALE 6"=1'-0"

SHEET 1 OF 2

MAGNUM Consulting
41100 Clarkston Road
Suite 125
Northville, MI 48165
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D321

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/30/22	ADDED DETAIL OF ITEM '28', ITEM '2' LOWERED 4", ITEM '6' LENGTH UPDATED, & 'ITEM '5' LENGTH AND CUTS UPDATED. DIMENSIONS UPDATED	
B	MC	8/19/2022	INCREASED WIDTH TO CLEAR VDL MASTS, ADJUSTED ITEM 2 & 3 LENGTH, CORRECTED ITEM '16', CORRECTED HOLE PATTERN IN ITEM '1'	
A	MC	8-8-2022	FOR FABRICATION	

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

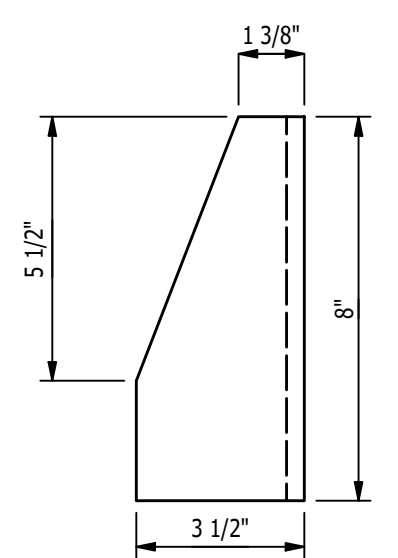
TITLE: P6700 CONVEYORS
CAMPUS BUILDING

CLIENT: VOLVO

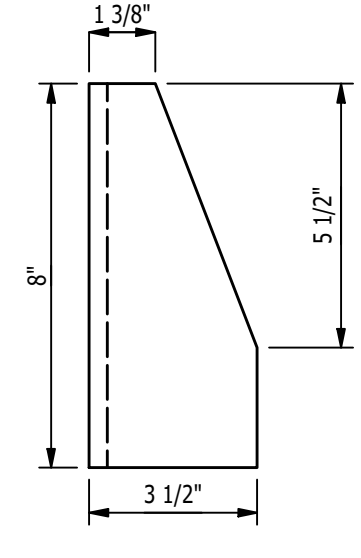
DRAWING No.: 1875D321

REV: C

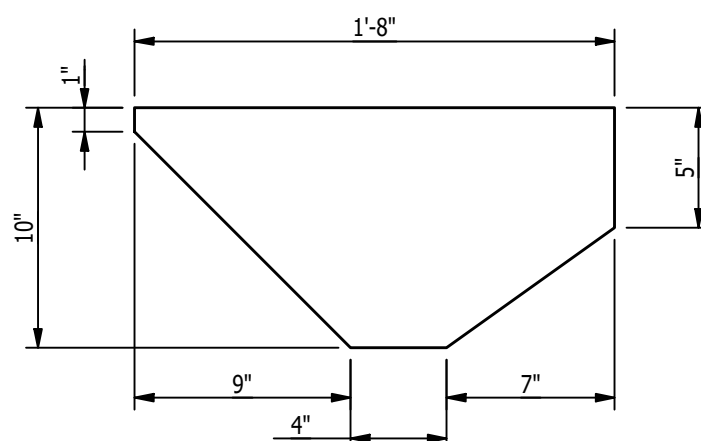
DRAWN BY: AH
CHECKED BY: JCK
DWG DATE: 7/21/22
JOB No.: 22096



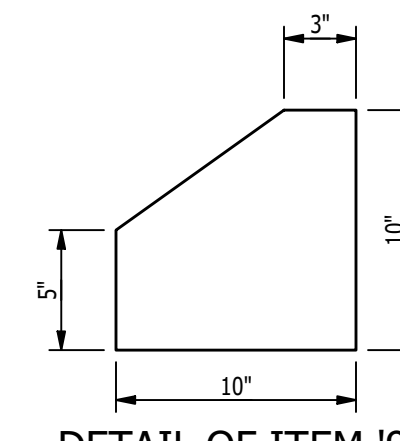
DETAIL OF ITEM '7R'
SCALE 3"=1'-0"



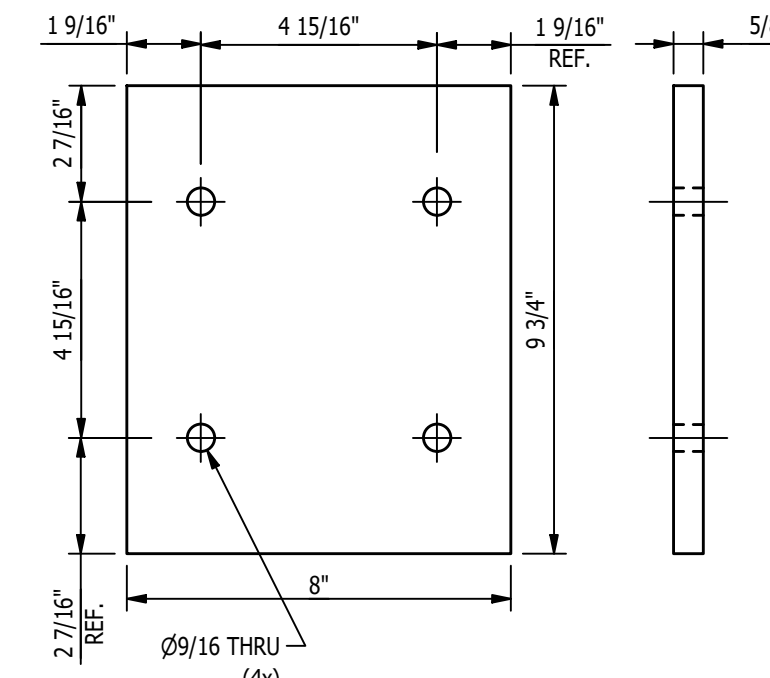
DETAIL OF ITEM '7L'
SCALE 3"=1'-0"



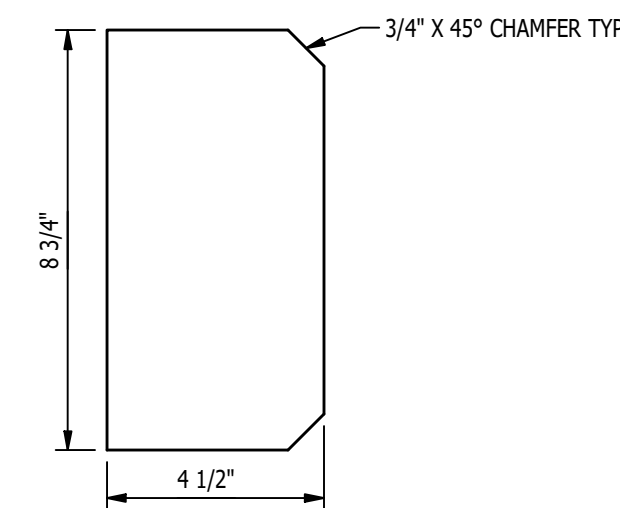
DETAIL OF ITEM '8'
SCALE 1 1/2"=1'-0"



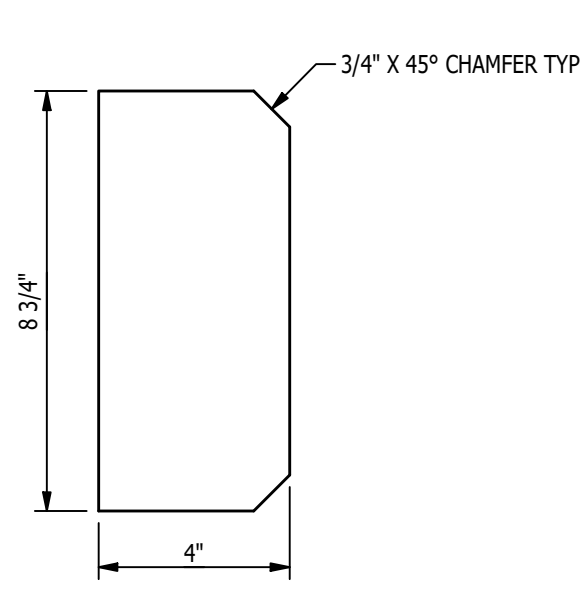
DETAIL OF ITEM '9'
SCALE 1 1/2"=1'-0"



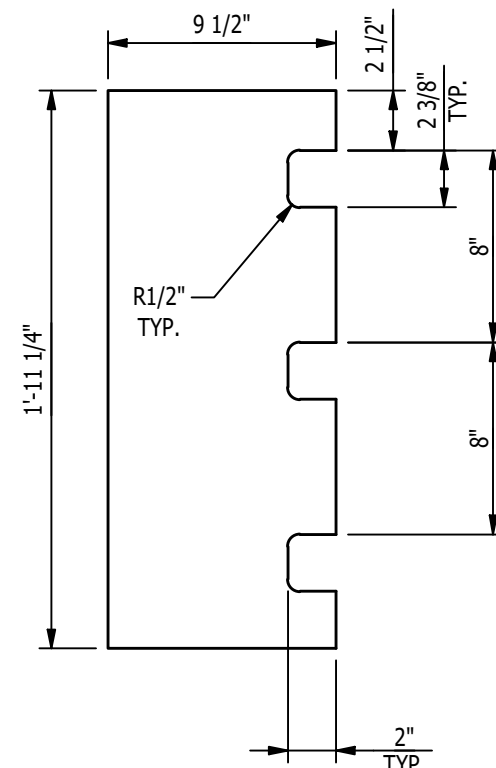
DETAIL OF ITEM '10'
SCALE 3"=1'-0"



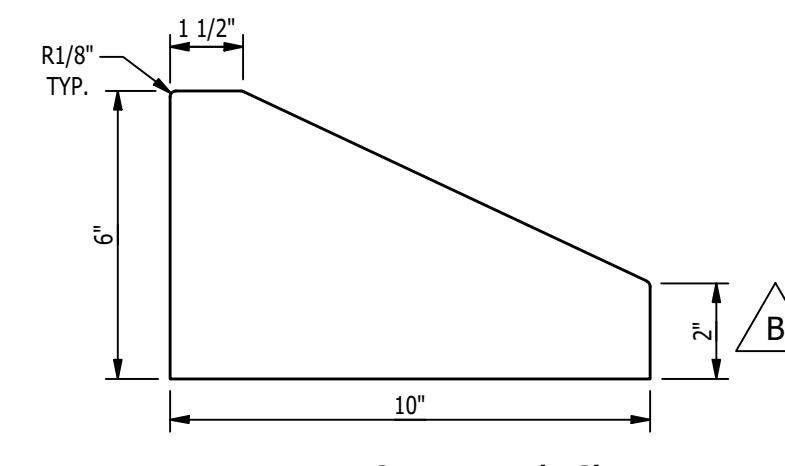
DETAIL OF ITEM '11'
SCALE 3"=1'-0"



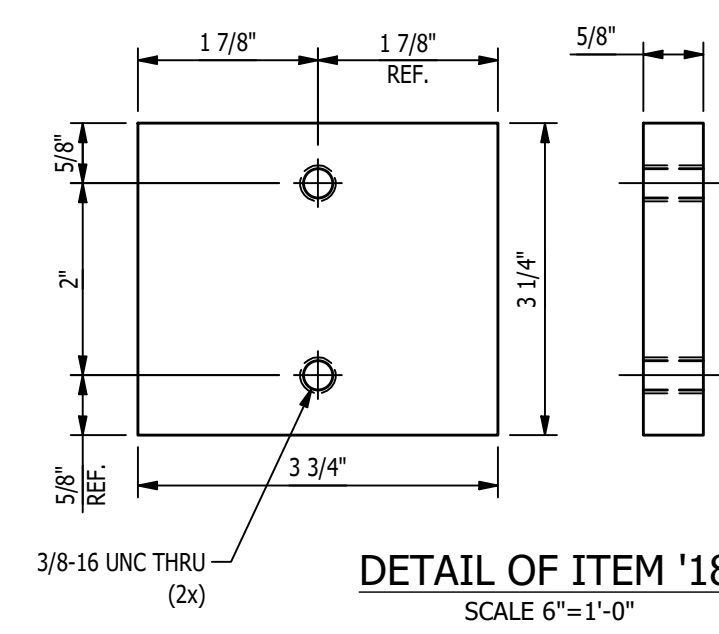
DETAIL OF ITEM '12'
SCALE 3"=1'-0"



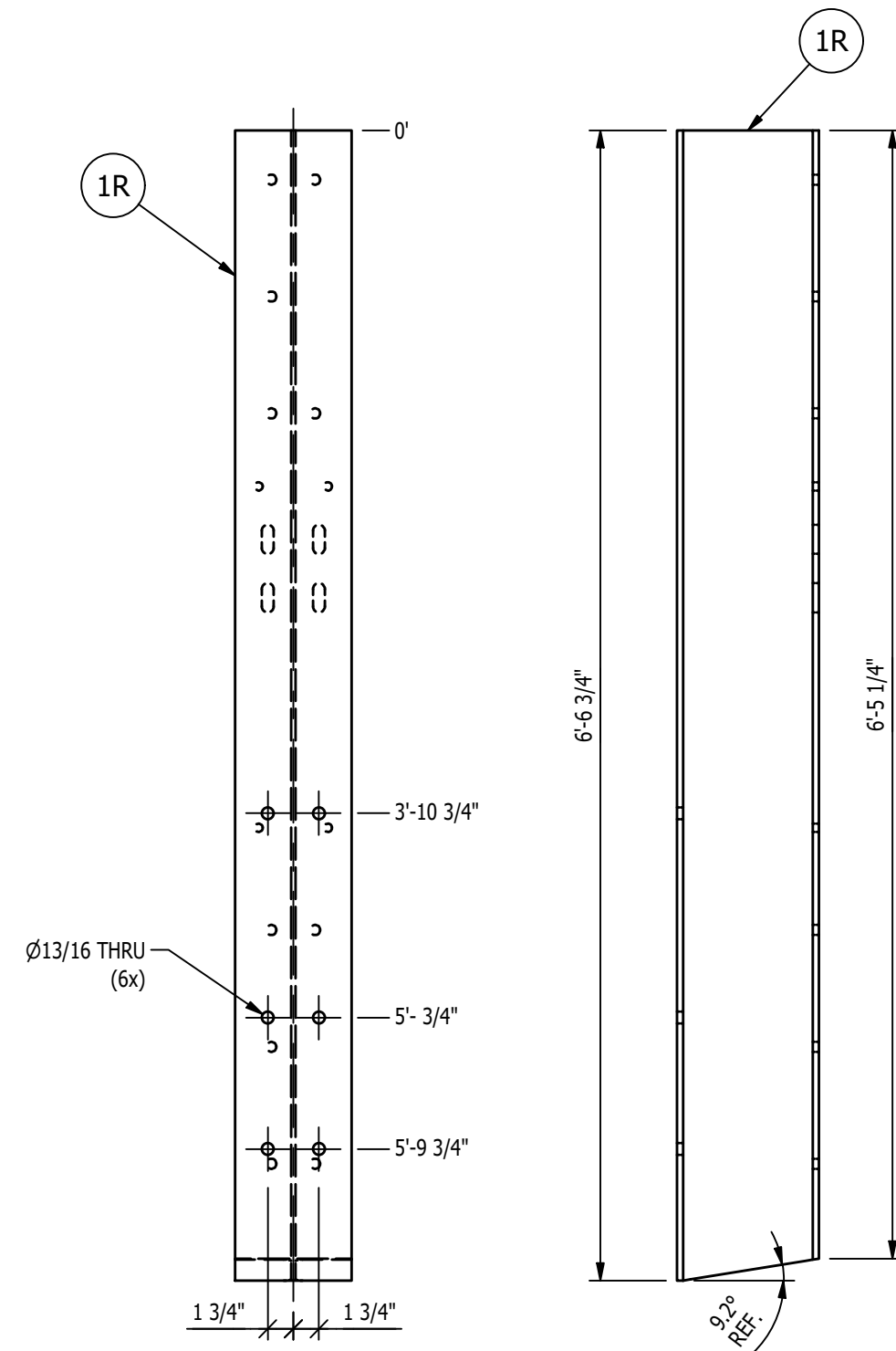
DETAIL OF ITEM '13'
SCALE 1 1/2"=1'-0"



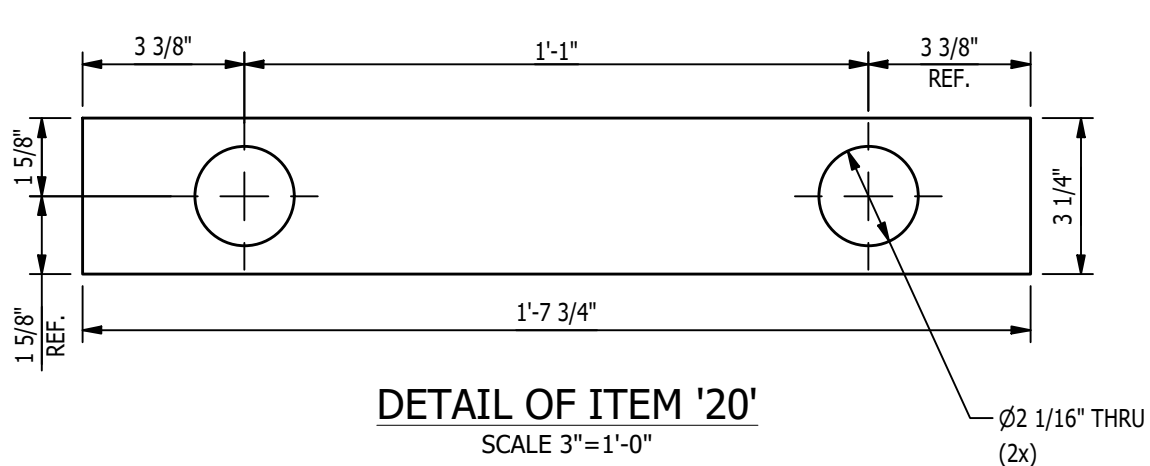
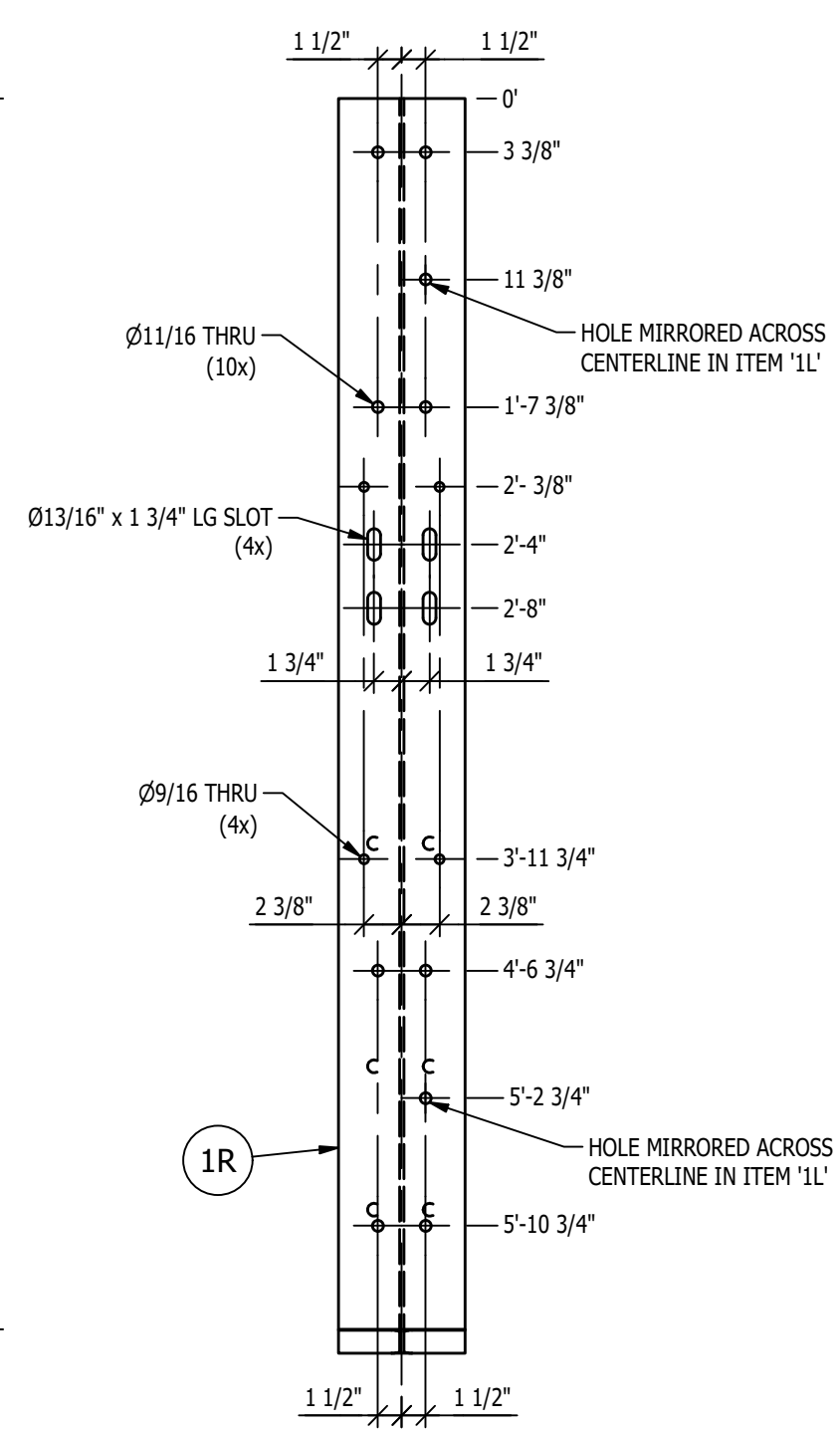
DETAIL OF ITEM '16'
SCALE 3"=1'-0"



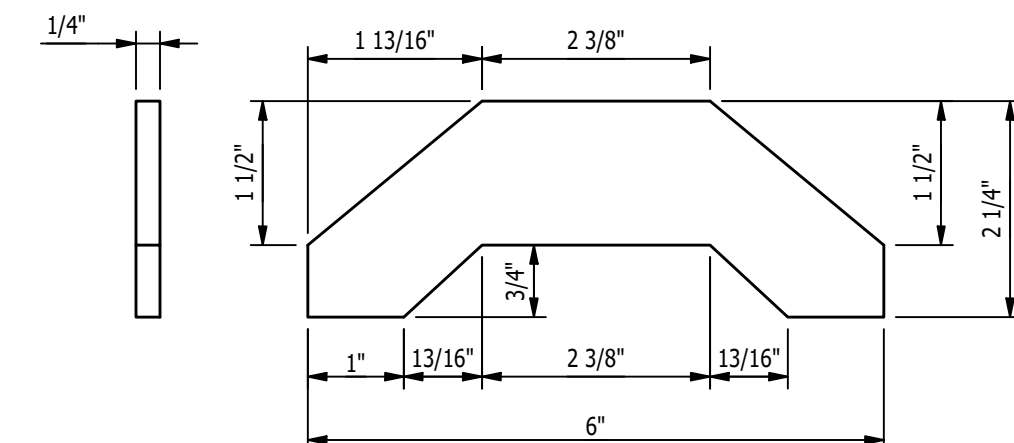
DETAIL OF ITEM '18'
SCALE 6"=1'-0"



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



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



DETAIL OF ITEM '22'
SCALE 6"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/30/22	ADDED DETAIL OF ITEM '28', ITEM '2' LOWERED 4", ITEM '6' LENGTH UPDATED, & 'ITEM '5' LENGTH AND CUTS UPDATED. DIMENSIONS UPDATED	
B	MC	8/19/2022	INCREASED WIDTH TO CLEAR VDL MASTS, ADJUSTED ITEM 2 & 3 LENGTH, CORRECTED ITEM '16', CORRECTED HOLE PATTERN IN ITEM '1' FOR FABRICATION	
A	MC	8-8-2022		

REVISION HISTORY

SHEET 2 OF 2

MAGNUM Consulting
41100 Clarkston Rd.
Suite 125
Novi, MI 48165
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
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XXX = ±.005
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DEBURR ALL HOLES
DO NOT SCALE DRAWING

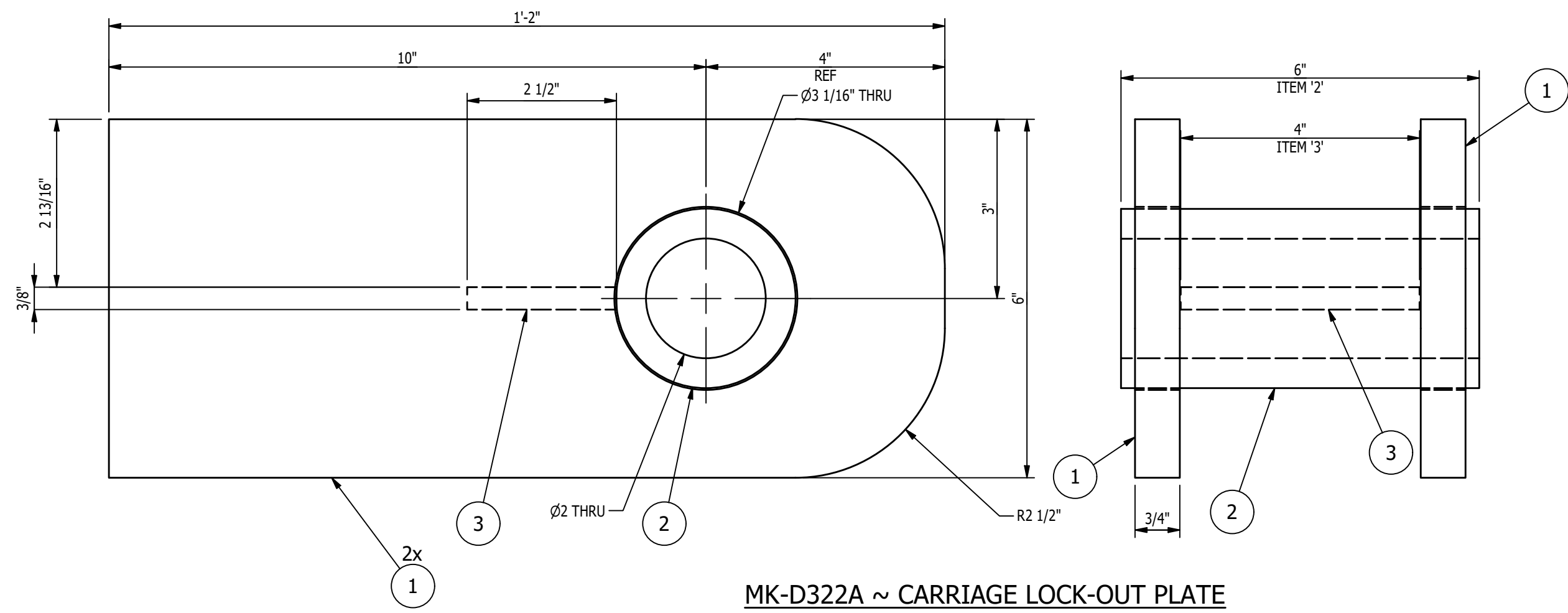
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
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WELDS: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

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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. **1875D321**
REV: **C**

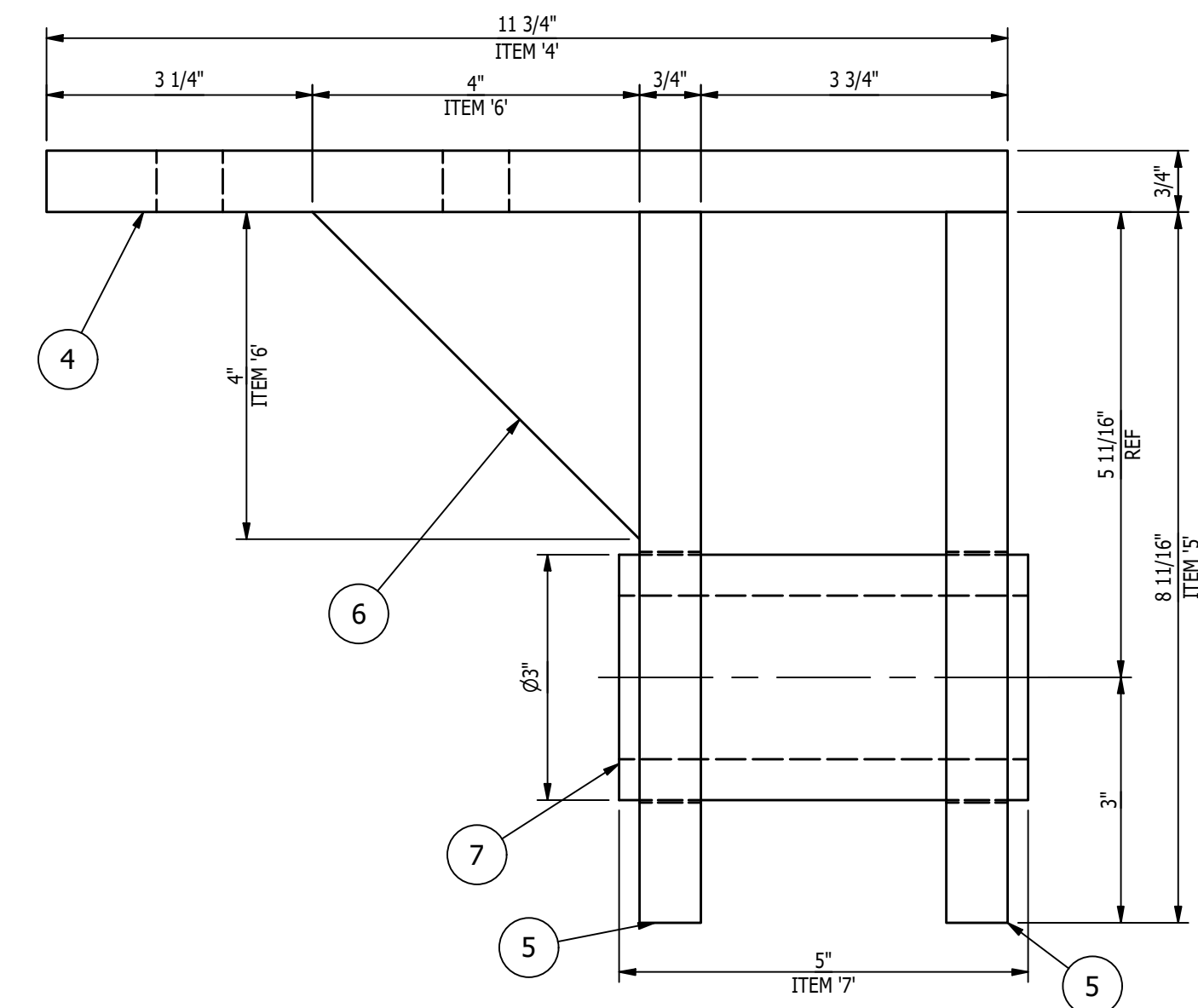
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DRAWN BY: **JC**
CHECKED BY: **JCK**
DWG DATE: **7/21/22**
JOB No: **22096**

3:00p 8/30/22 New Job Drawing/Details/1875D321.dwg

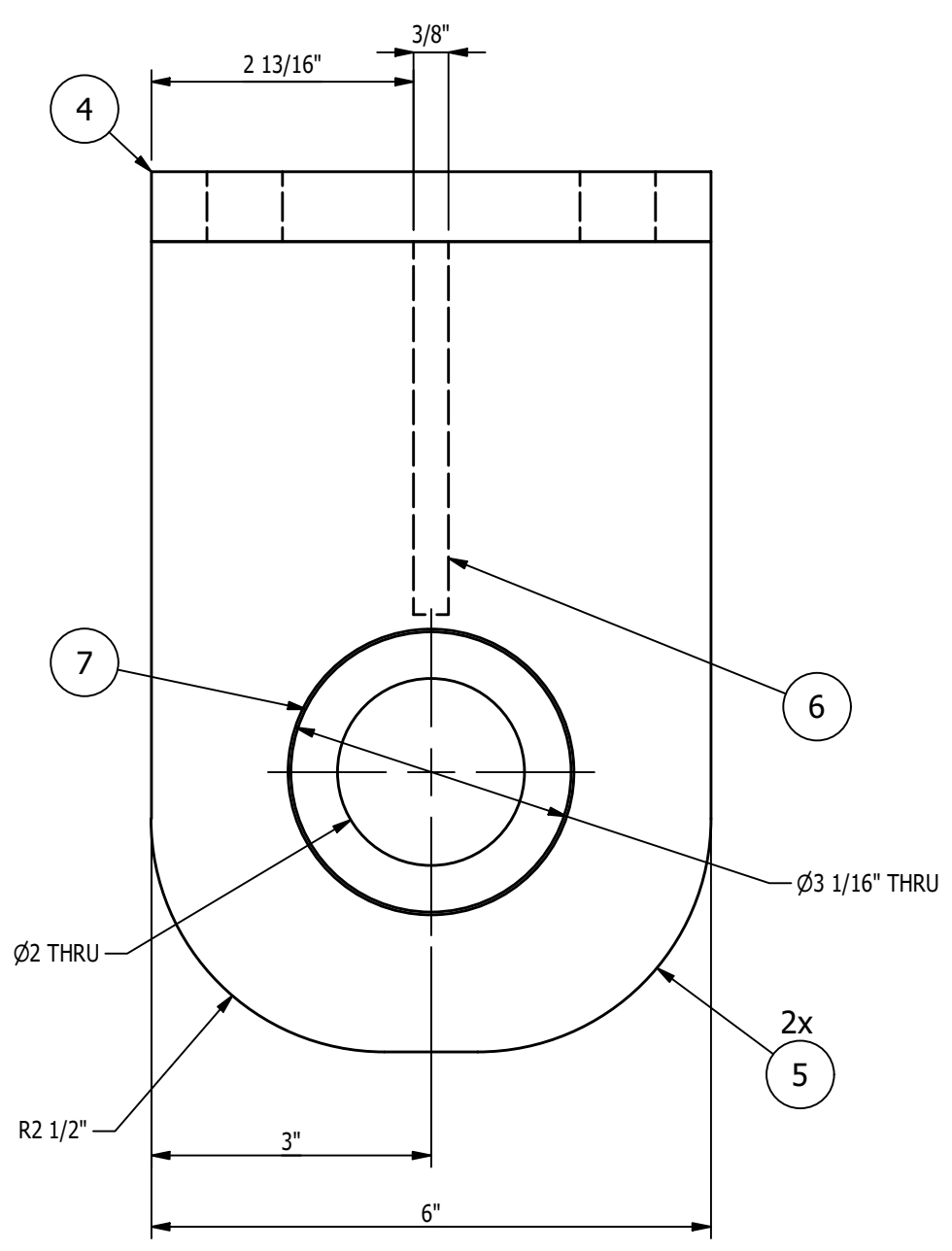


MK-D322A ~ CARRIAGE LOCK-OUT PLATE
SCALE 6"=1'-0"

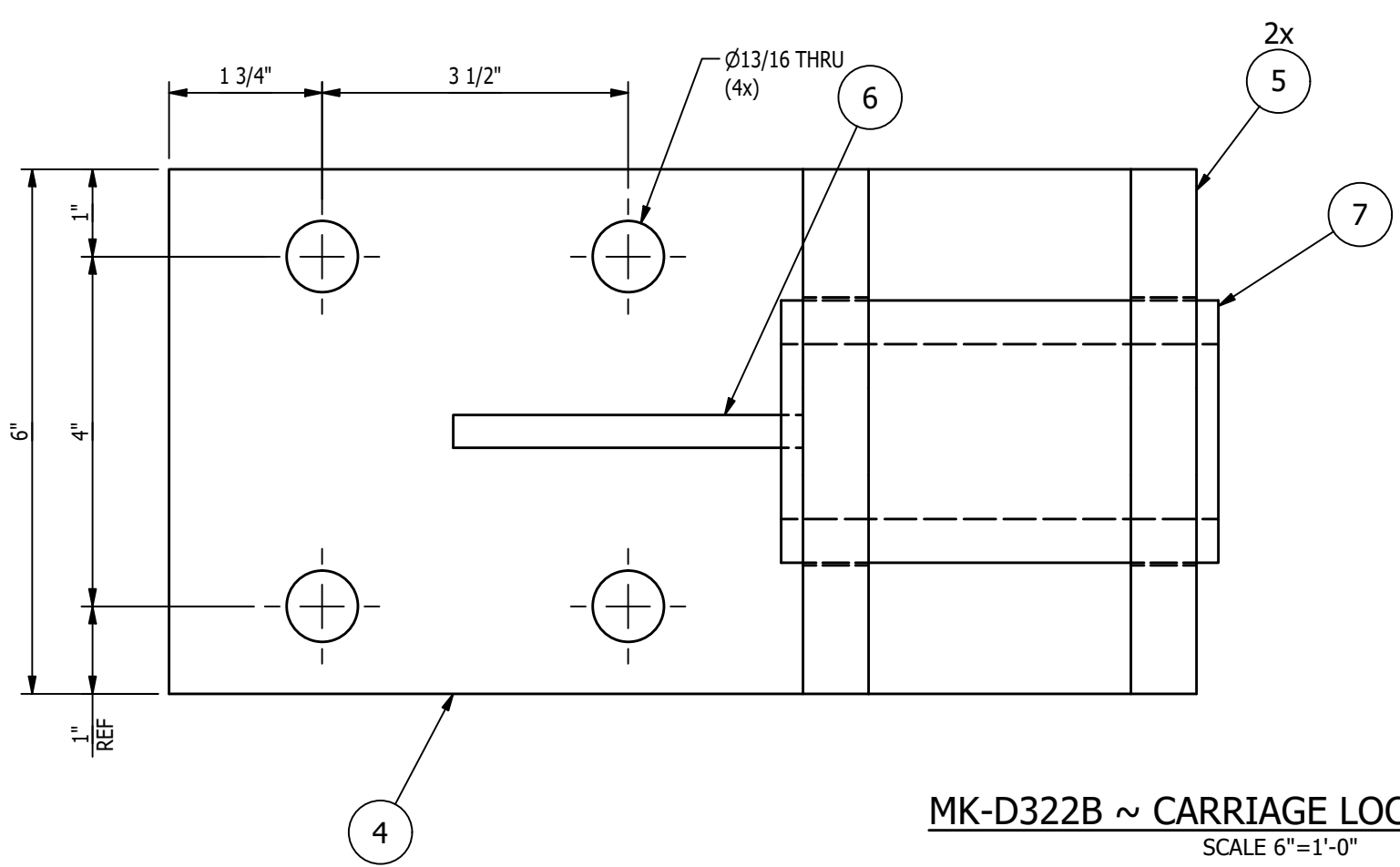
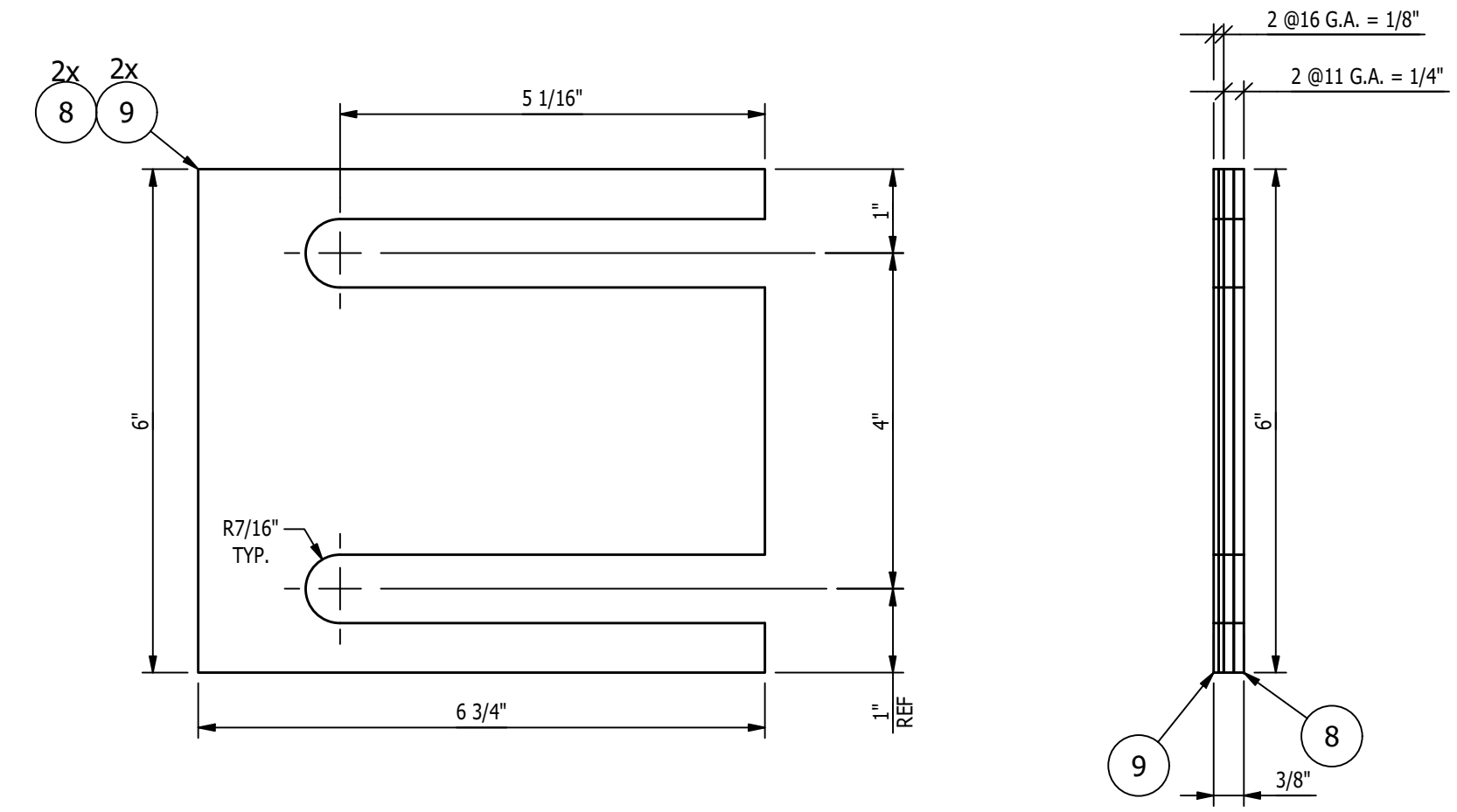
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
MK-D322A					
1	2	BAR 3/4 x 6	1'-2"		
2	1	TS 3 OD x 1/2 DOM	6"		
3	1	BAR 3/8 x 2 1/2	4"		
MK-D322B					
4	1	BAR 3/4 x 6	11 3/4"		
5	2	BAR 3/4 x 6	8 11/16"		
6	1	BAR 3/8 x 4	4"		
7	1	TS 3 OD x 1/2 DOM	5"		
MK-D322C					
8	2	SHT 11 GA x 6	6 3/4"		
9	2	SHT 16 GA x 6	6 3/4"		



MK-D322B ~ CARRIAGE LOCK-OUT PLATE
SCALE 6"=1'-0"



MK-D322C ~ LOCK-OUT SHIM PACK
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 MK-D322A OR MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	CHANGED PAINT NOTES	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY	
DESCRIPTION	APP

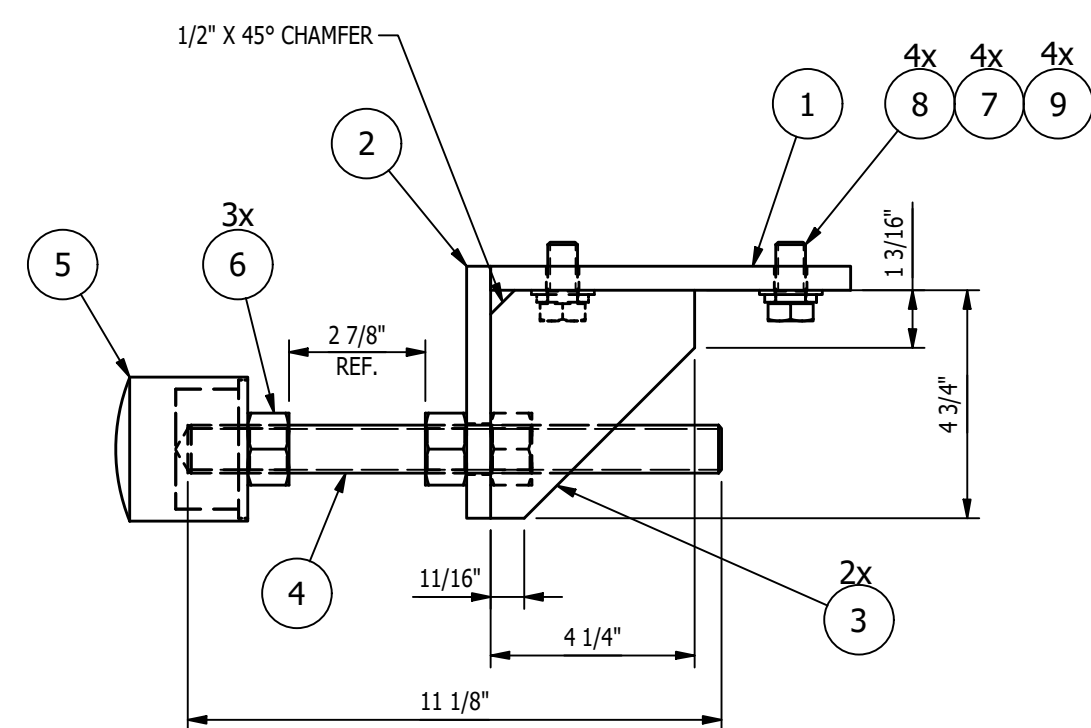
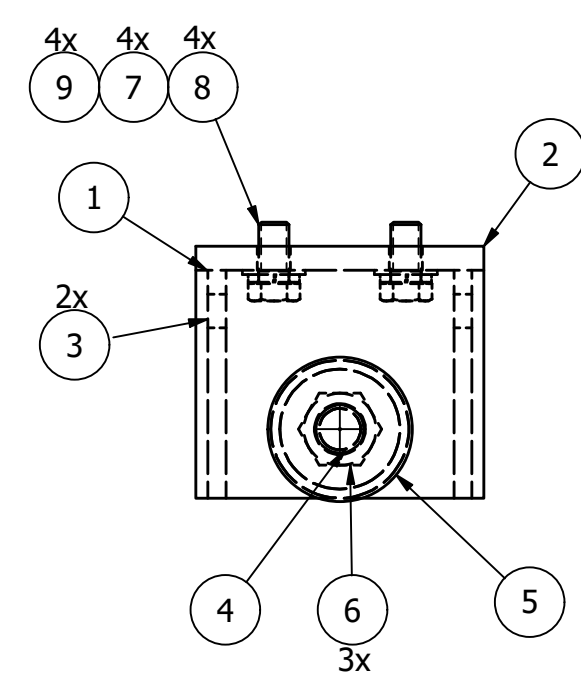
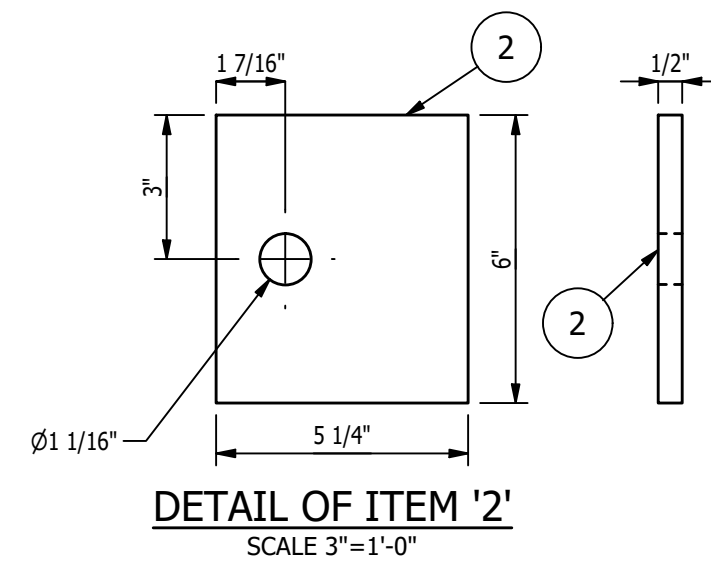
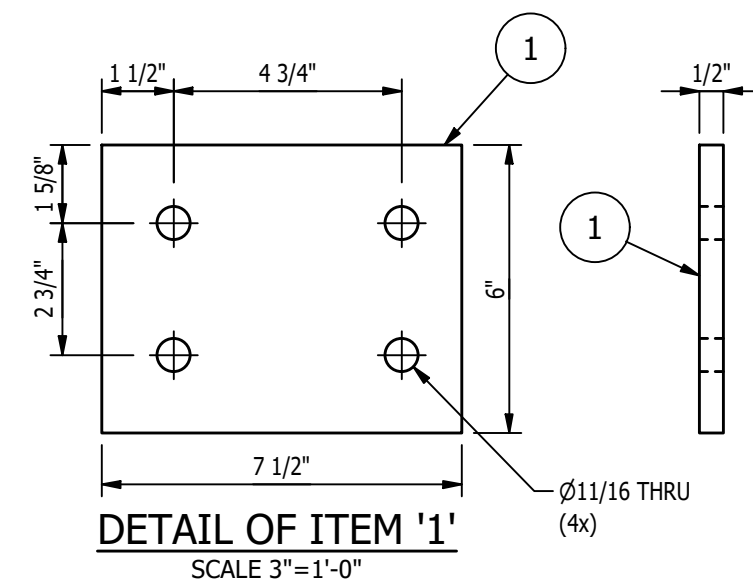
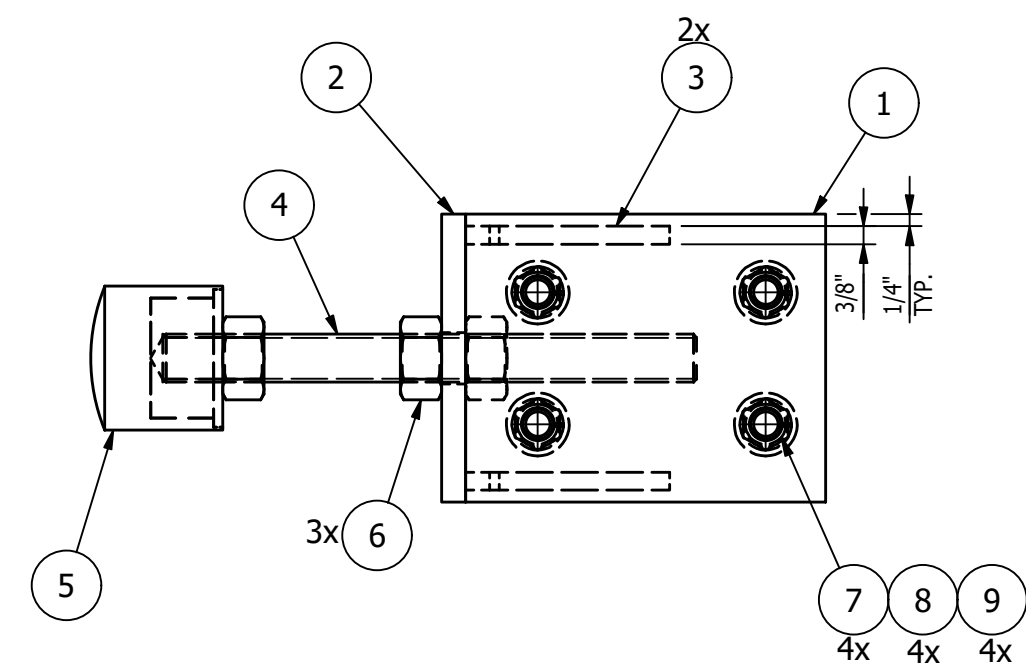
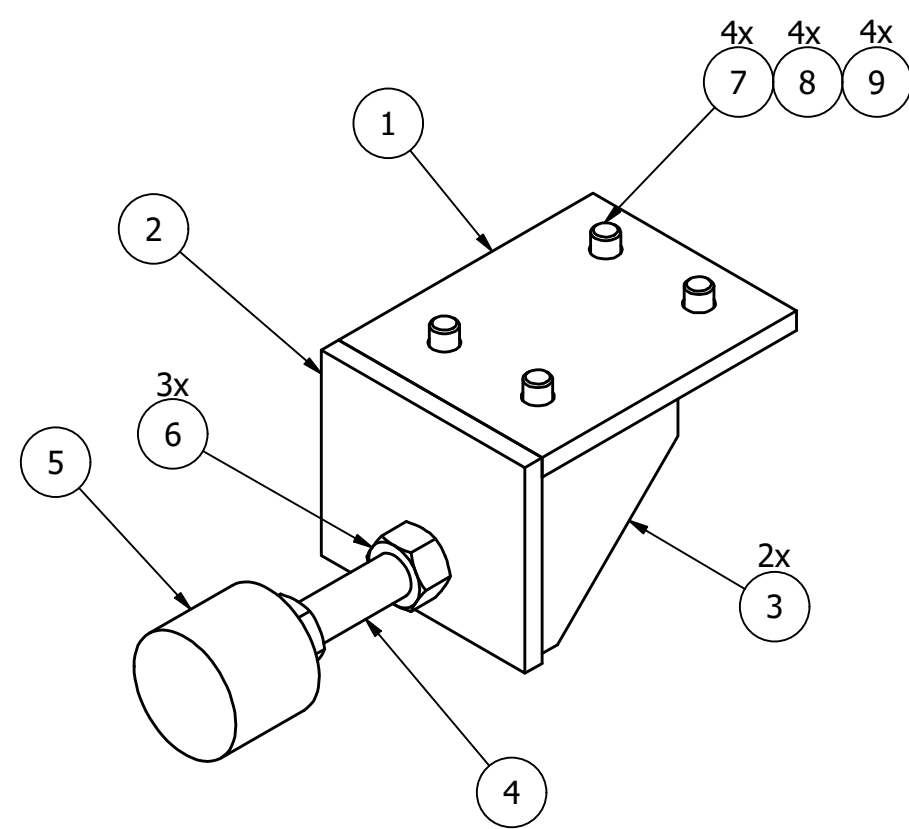
MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH
CLIENT: VOLVO	CHECKED BY: JK
DRAWING No. 1875D322	DWG DATE: 7/22/22
REV: B	JOB No: 22096

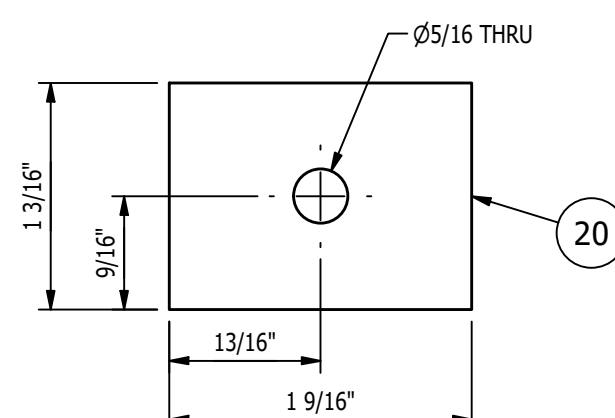
MAGNUM CONSULTING
 41100 QuakerRoad Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

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

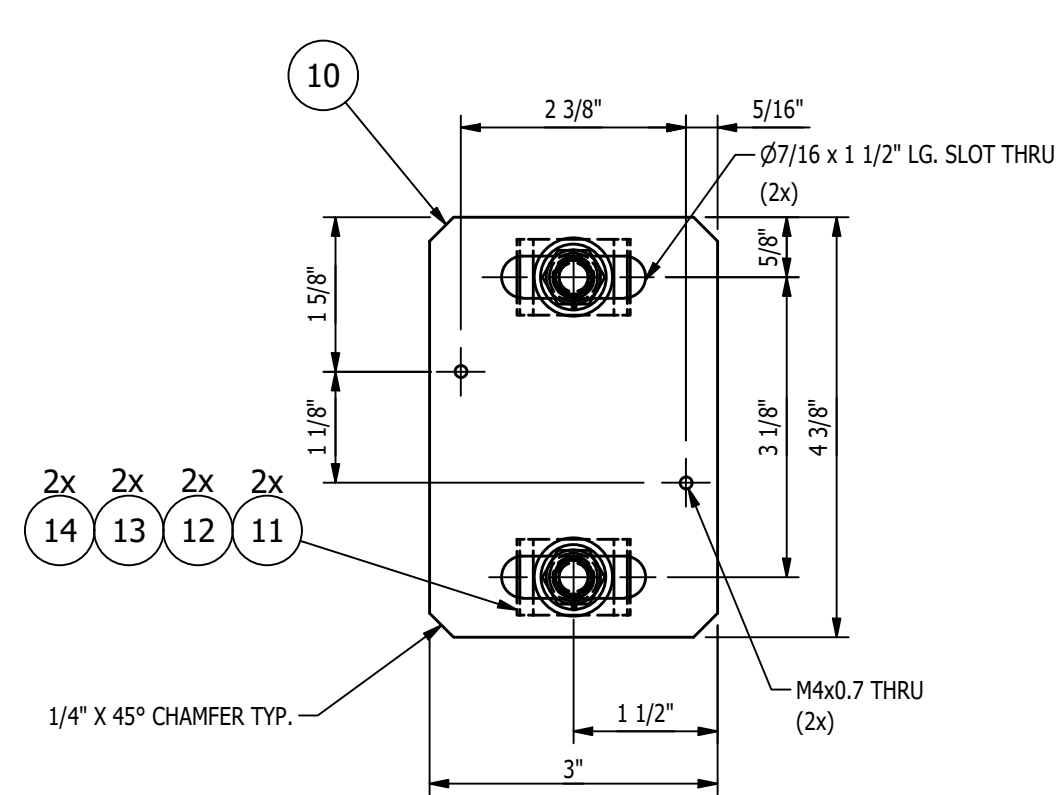
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO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



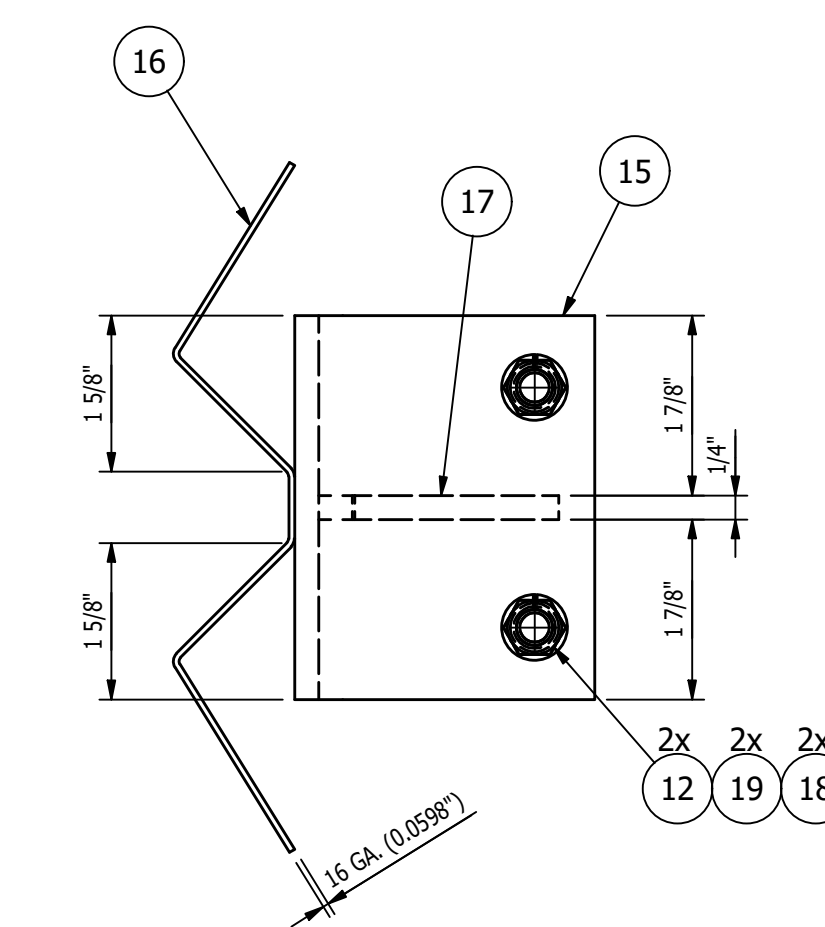
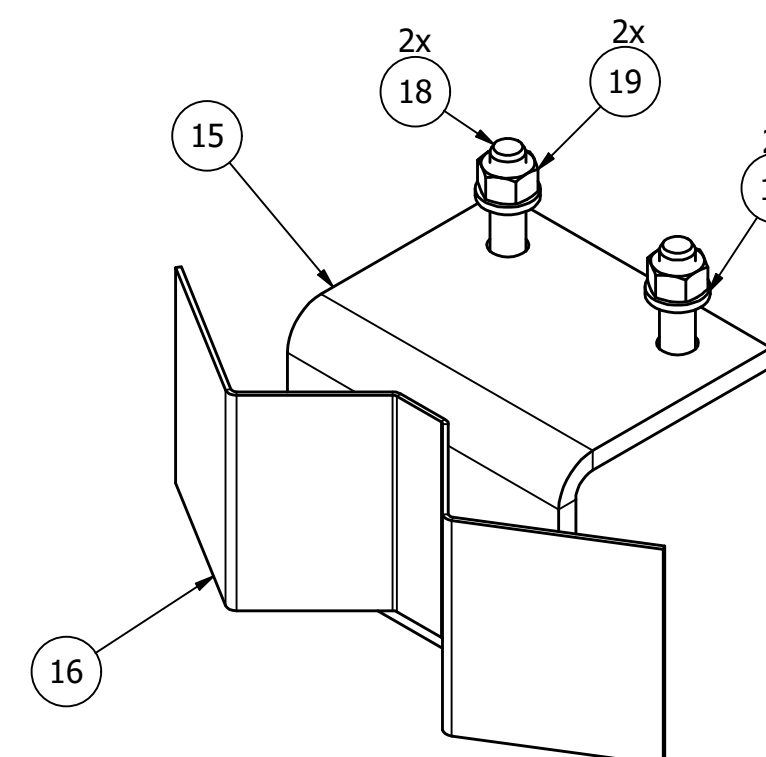
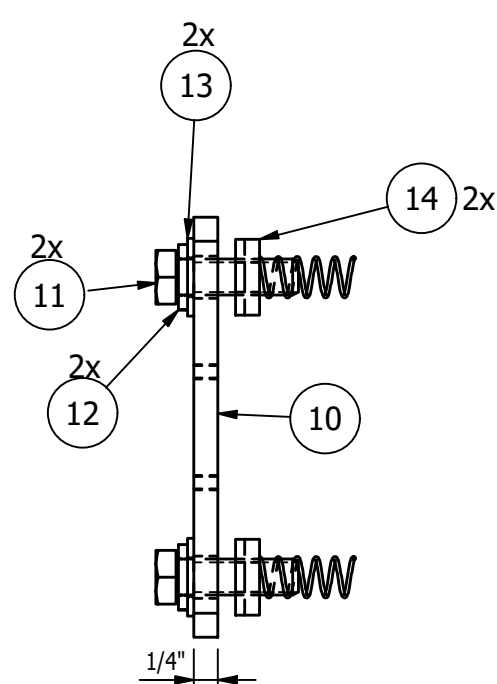
MK-D324A ~ CARRIAGE BUMPER STOP
SCALE 3"=1'-0"



MK-D324D ~ SPACER
SCALE 1'-0" = 1'-0"

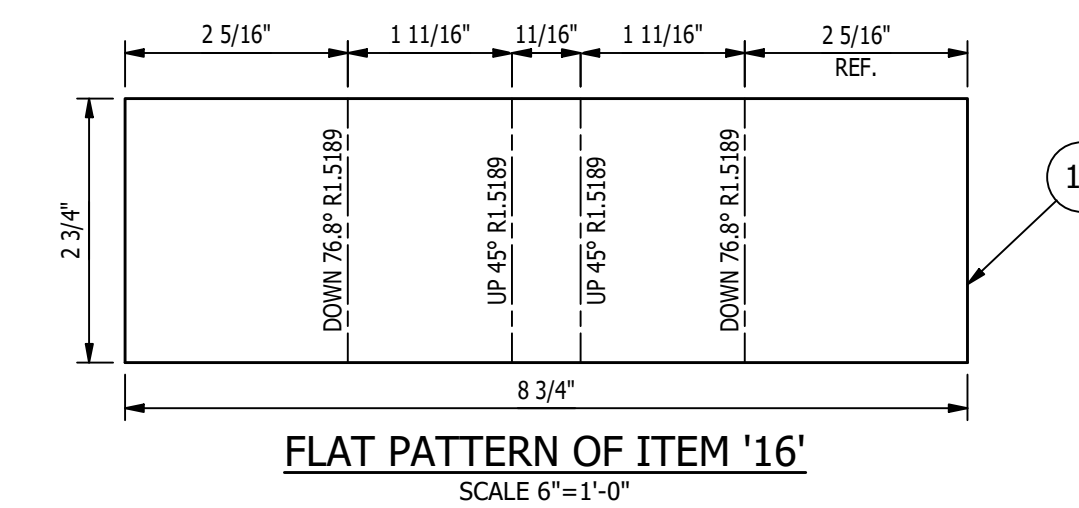
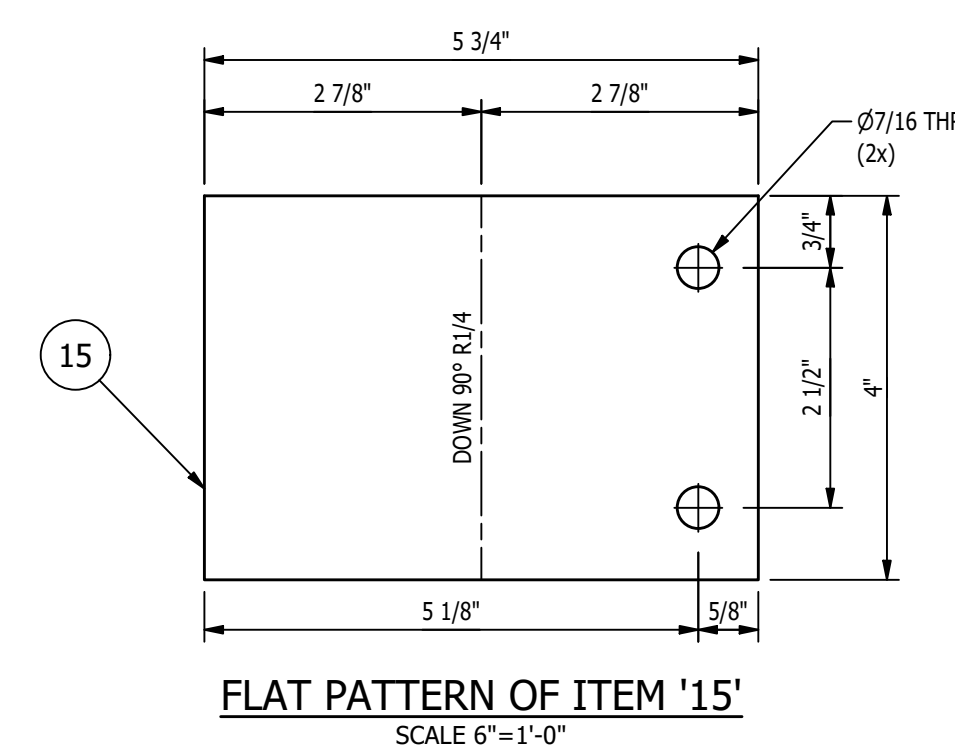


MK-D324B ~ SLACK BELT LIMIT SWITCH PLATE
SCALE 6"=1'-0"



MK-D324C ~ SLACK BELT DETECT FLAG
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D324A			
1	1	BAR 1/2 x 6	7 1/2"		
2	1	BAR 1/2 x 6	5 1/4"		
3	2	BAR 3/8 x 4 1/4	4 3/4"		
4	1	THD. ROD 1-8UNC	11 1/8"		
5	1	URETHANE BUMPER, 3" OD x 2 3/4" TALL, STILSON PART NO. BN-18-UR-RED		7-15	
6	3	1-8UNC HEX NUT			
7	4	5/8 TYPE A NARROW FLAT WASHER			
8	4	5/8-11UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
9	4	5/8 SPRING LOCK WASHER			
		MK-D324B			
10	1	BAR 1/4 x 3	4 3/8"		
11	2	3/8-16UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
12	2	3/8 SPRING LOCK WASHER			
13	2	3/8 TYPE A NARROW FLAT WASHER			
14	2	CHANNEL NUT FOR 3/8"-16 WITH SPRING, UNISTRUT P1008			
		MK-D324C			
12	2	3/8 SPRING LOCK WASHER			
15	1	BAR 1/4 x 4 (BEND)	5 3/4"		
16	1	SHT 16 GA x 2 3/4	8 3/4"		
17	1	BAR 1/4 x 2 1/2	2 1/2"		
18	2	3/8-16UNC x 1 1/2" LG. HEX HEAD CAP SCREW			
19	2	3/8-16UNC HEX NUT			
		MK-D324D			
20	1	PL 1/4 x 1 3/16"	1 9/16"		



PAINT NOTES:
PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER
ONE SHOP COAT OF PURE ORANGE RAL 2004
OR
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS
OF PURCHASED ITEMS.

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

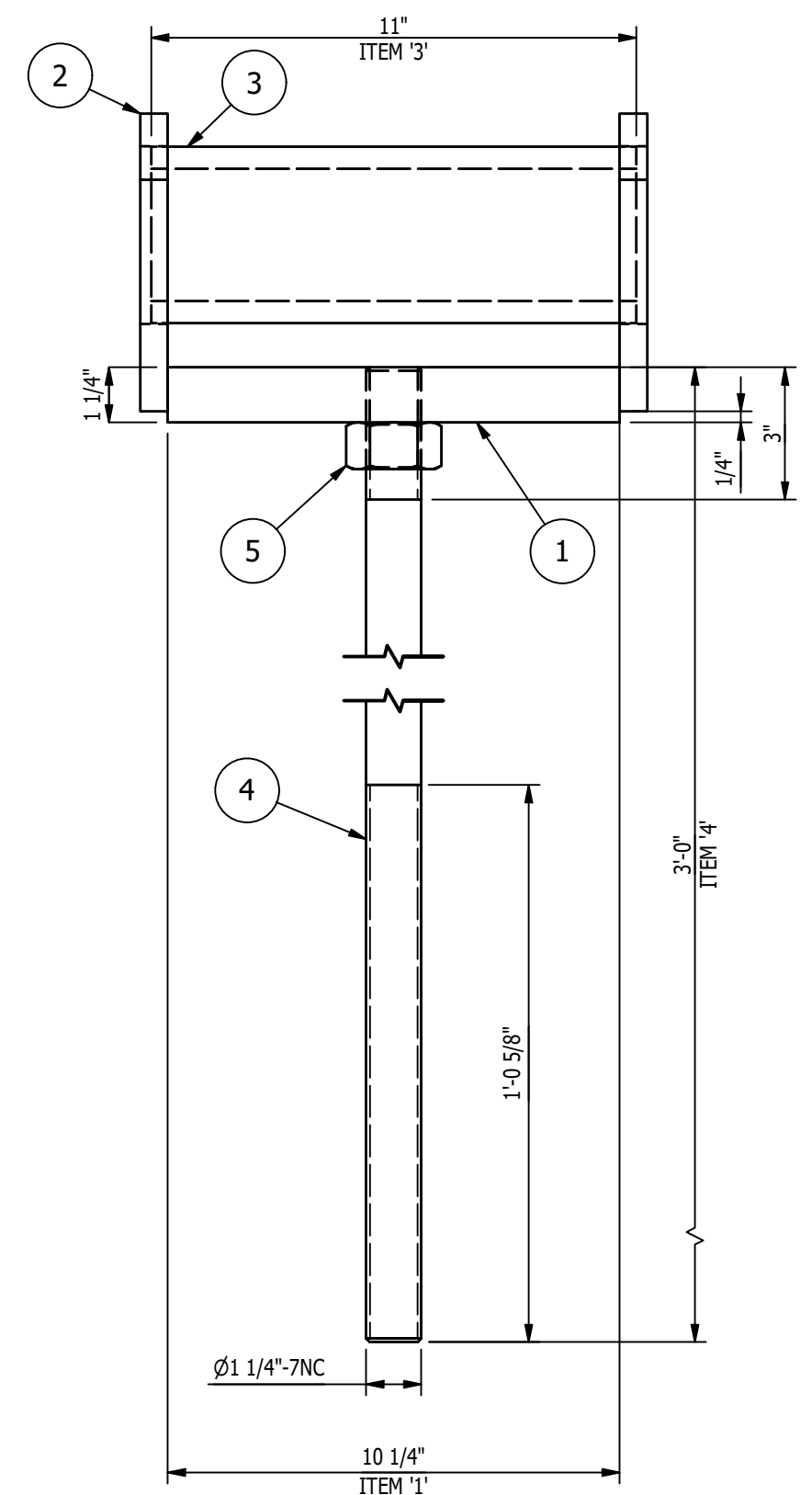
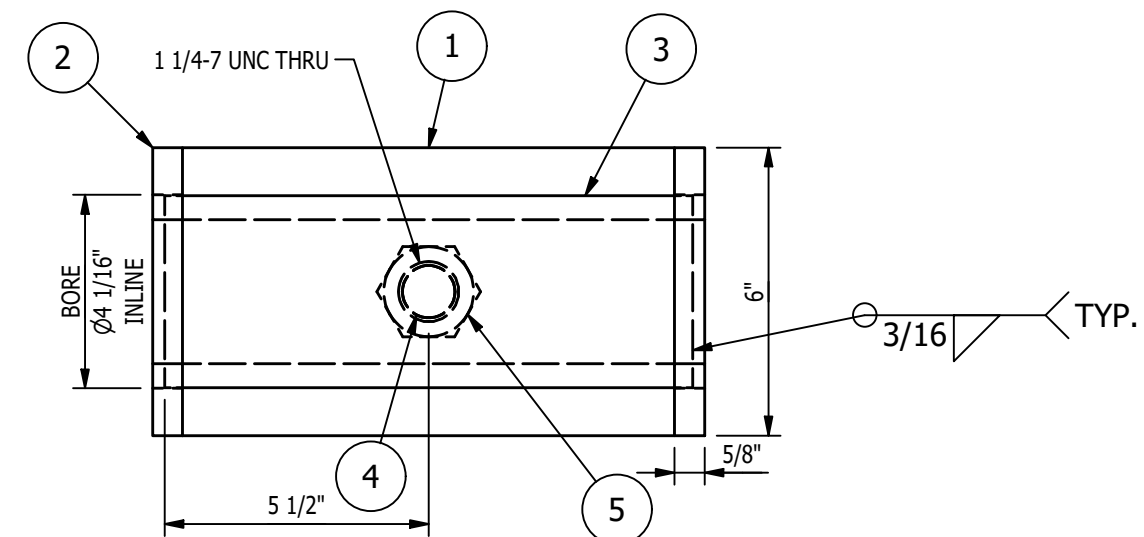
REV	BY	DATE	DESCRIPTION	APP
B	MC	10/19/22	ADDED MK-D324D	
A	MC	8/8/2022	FOR FABRICATION	

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.millc.com	
CLIENT: VOLVO	DRAWING No. 1875D324	DRAWN BY: AH	CHECKED BY: JCK
REV: B	JOB No: 22096	DWG DATE: 7/21/22	

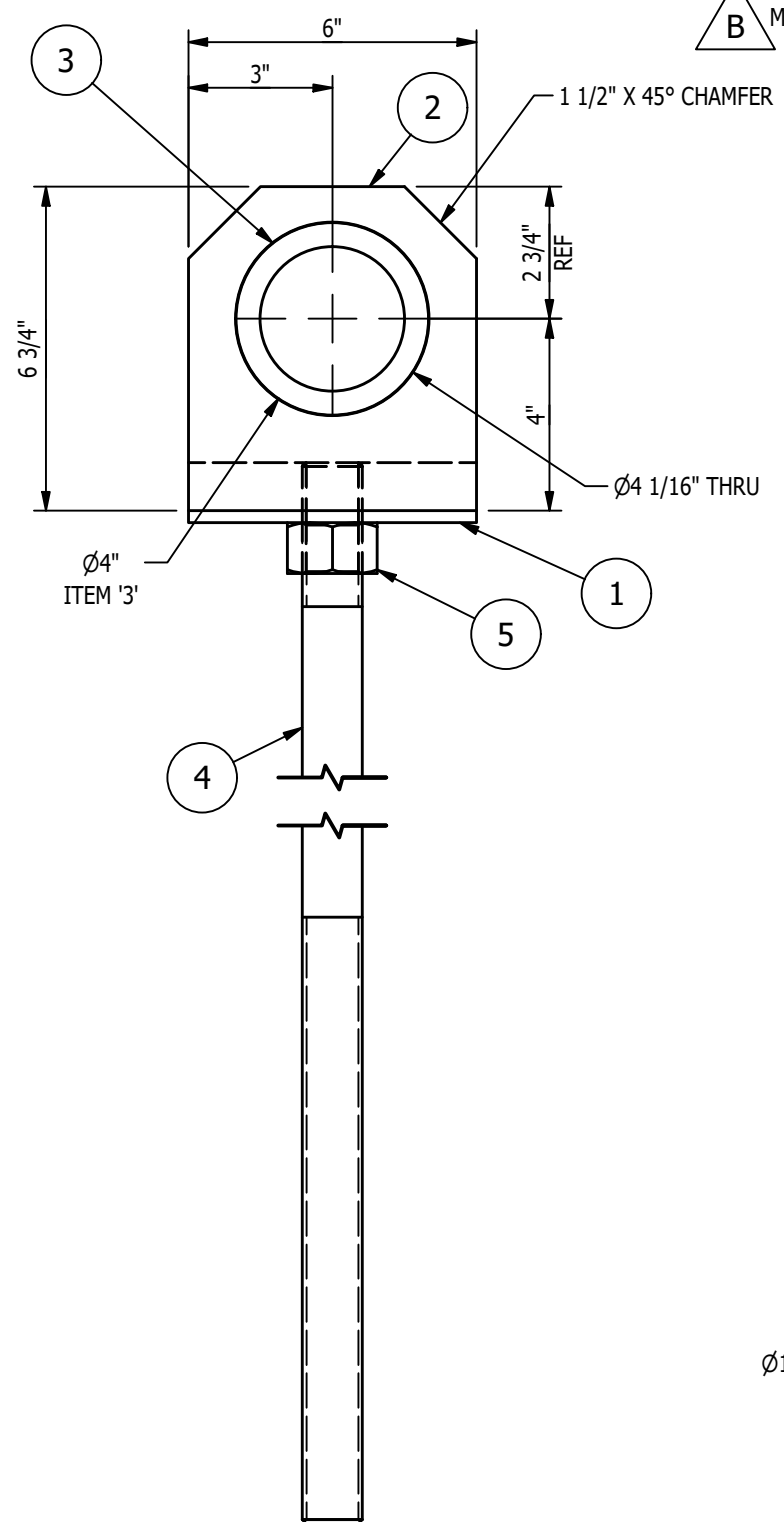
MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
North, MI 48055
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D324

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

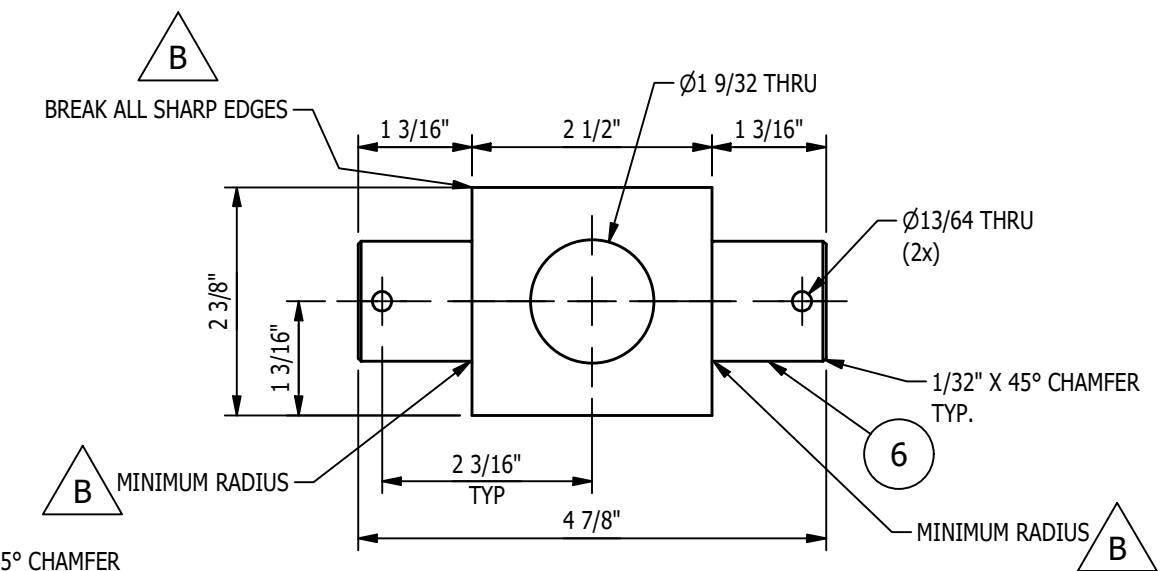
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" 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.



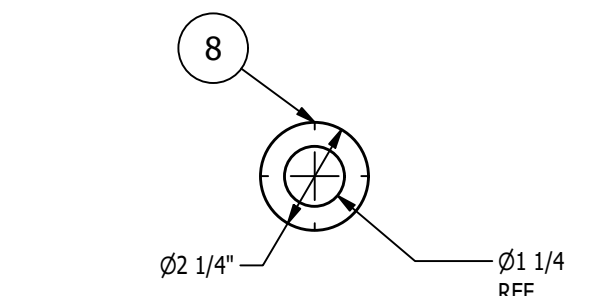
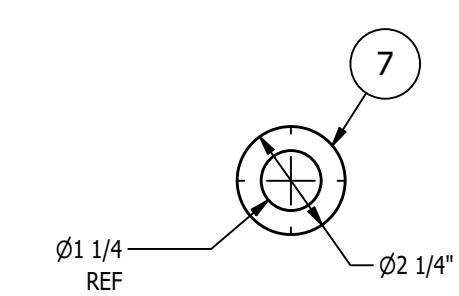
MK-D325A ~ BELT YOKE
SCALE 3"=1'-0"



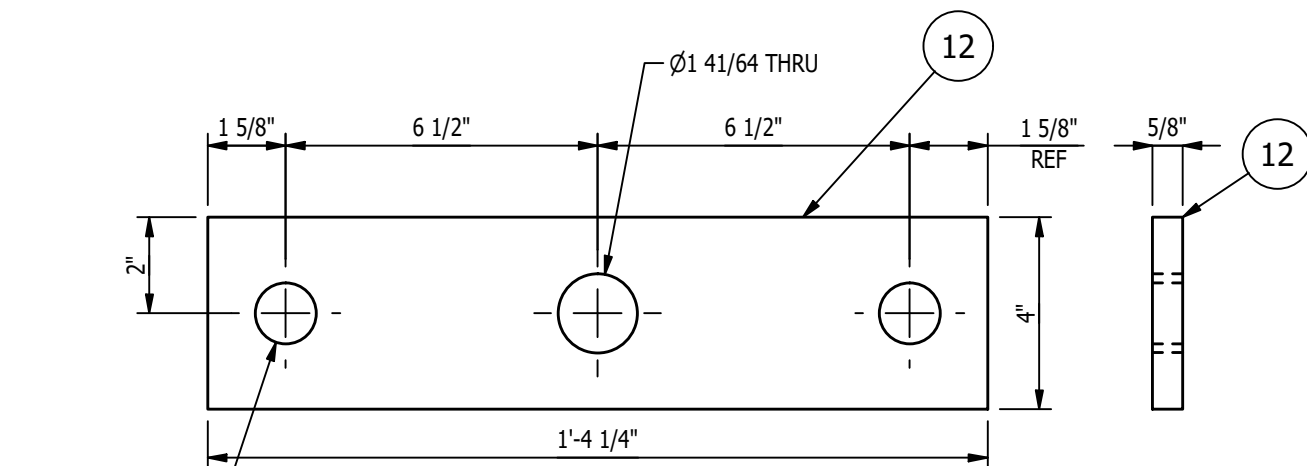
MK-D325B ~ TEE PIVOT
SCALE 6"=1'-0"



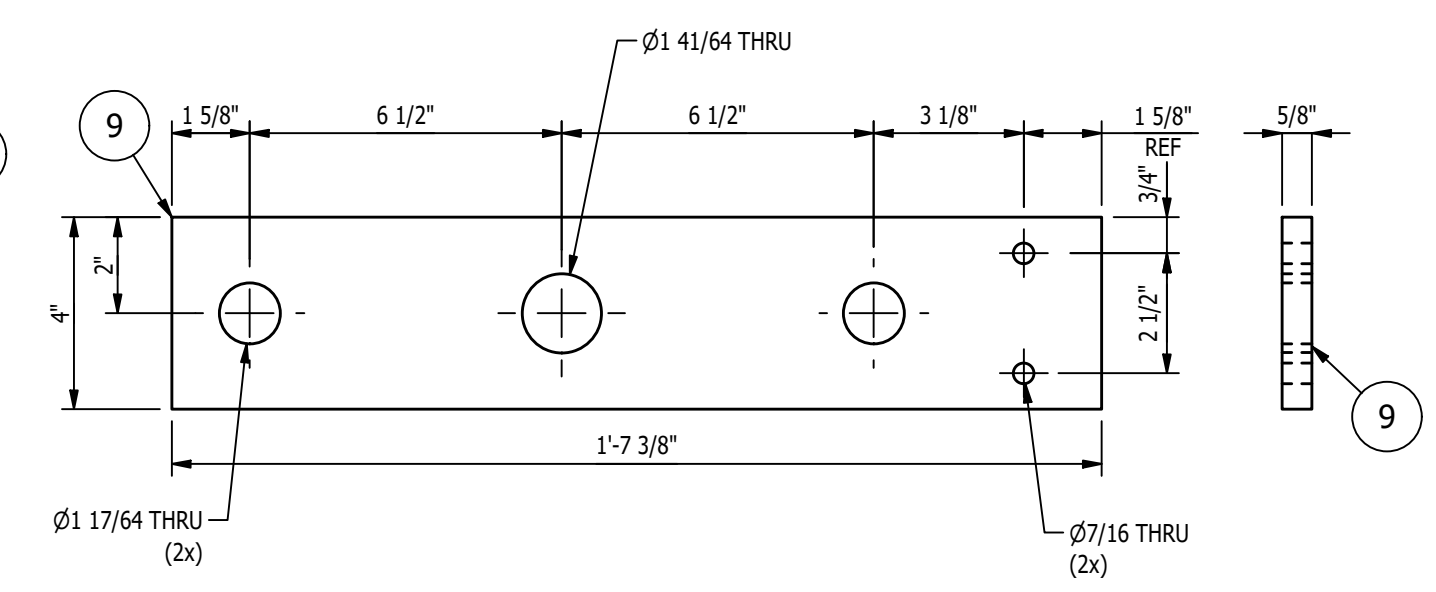
MK-D325C ~ TUBE SPACER
SCALE 3"=1'-0"



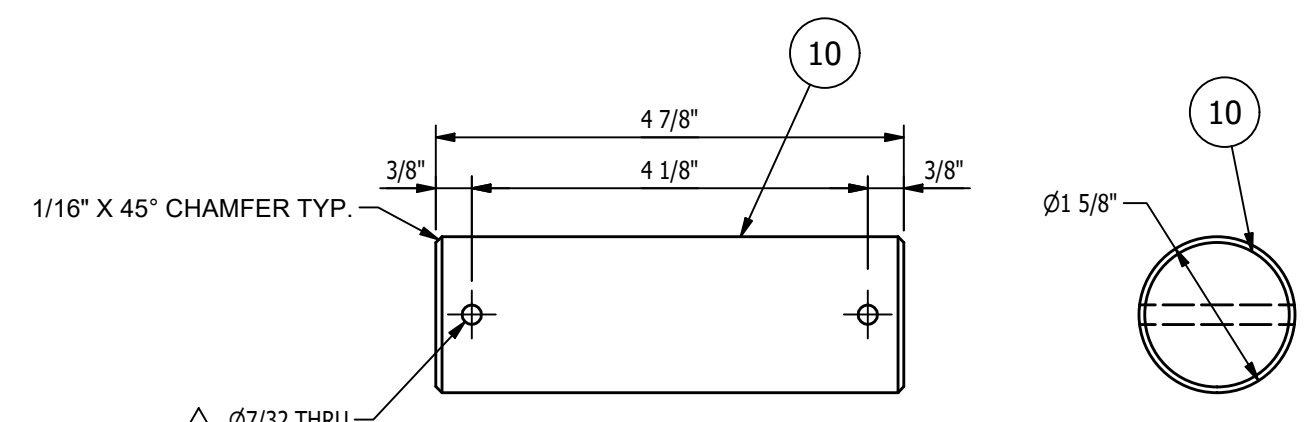
MK-D325D ~ TUBE SPACER
SCALE 3"=1'-0"



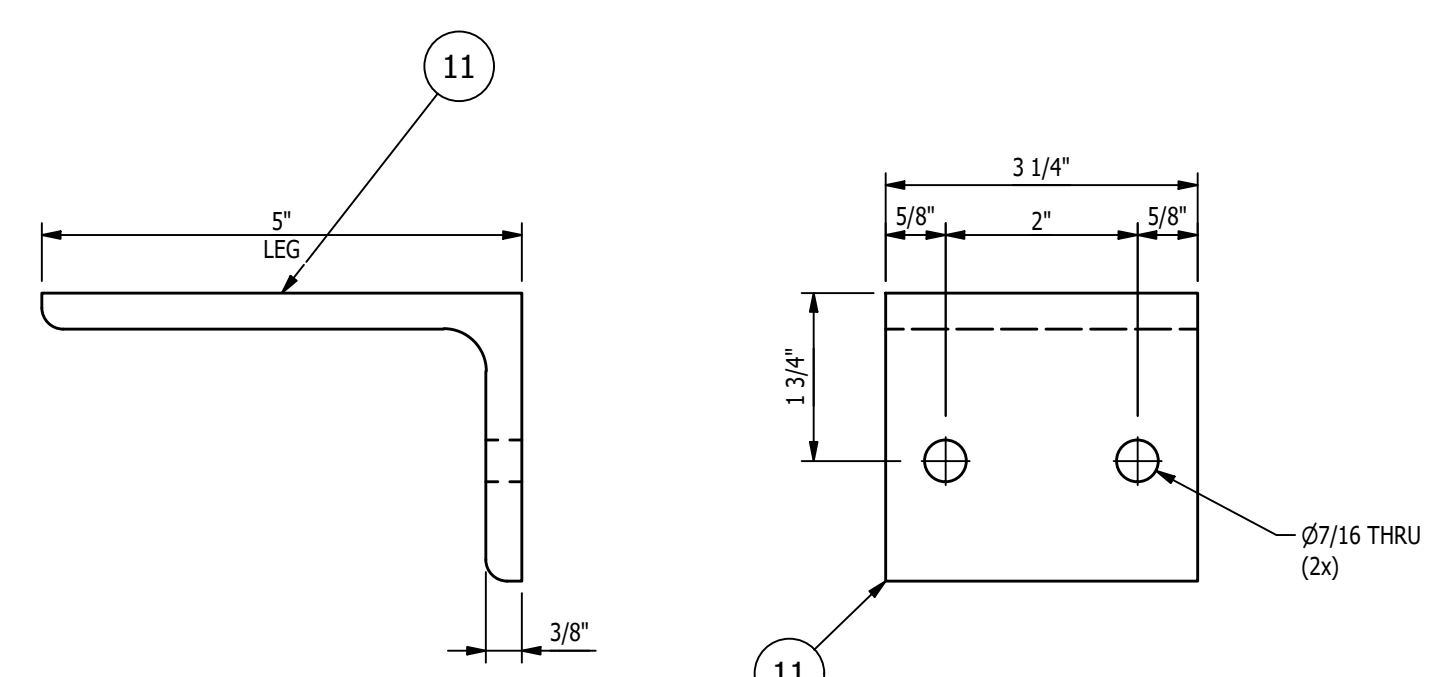
MK-D325E ~ PIVOT PLATE
SCALE 3"=1'-0"



MK-D325F ~ PIVOT PLATE
SCALE 3"=1'-0"



MK-D325G ~ CENTER PIVOT PIN
SCALE 6"=1'-0"



MK-D325H ~ BELT YOKE GUIDE ANGLE
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D325A			
1	1	BAR 1 1/4 x 6	10 1/4"		
2	2	BAR 5/8 x 6	6 3/4"		
3	1	TS 4 OD x 1/2 DOM	11"		
4	1	BAR Ø1 1/4	3'-0"		
5	1	1 1/4-7UNC HEX NUT			
		MK-D325B			
6	1	SQ. BAR 2 3/8 (1018)	4 7/8"		
		MK-D325C			
7	1	TS 2 1/4 OD x 1/2 DOM	4 15/16"		
		MK-D325D			
8	1	TS 2 1/4 OD x 1/2 DOM	1 3/16"		
		MK-D325E			
12	1	BAR 5/8 x 4	1'-4 1/4"		
		MK-D325F			
9	1	BAR 5/8 x 4	1'-7 3/8"		
		MK-D325G			
10	1	BAR Ø1 5/8	4 7/8"		
		MK-D325H			
11	1	L 5 x 3 x 3/8	3 1/4"		

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	ADJUSTED ITEM NUMBERS & ADDED SURFACING NOTES	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: AH	
MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		CHECKED BY: JCK DWG DATE: 7/21/22	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		JOB No: 22096	
CLIENT: VOLVO		REV: B	
DRAWING No. 1875D325		APP	

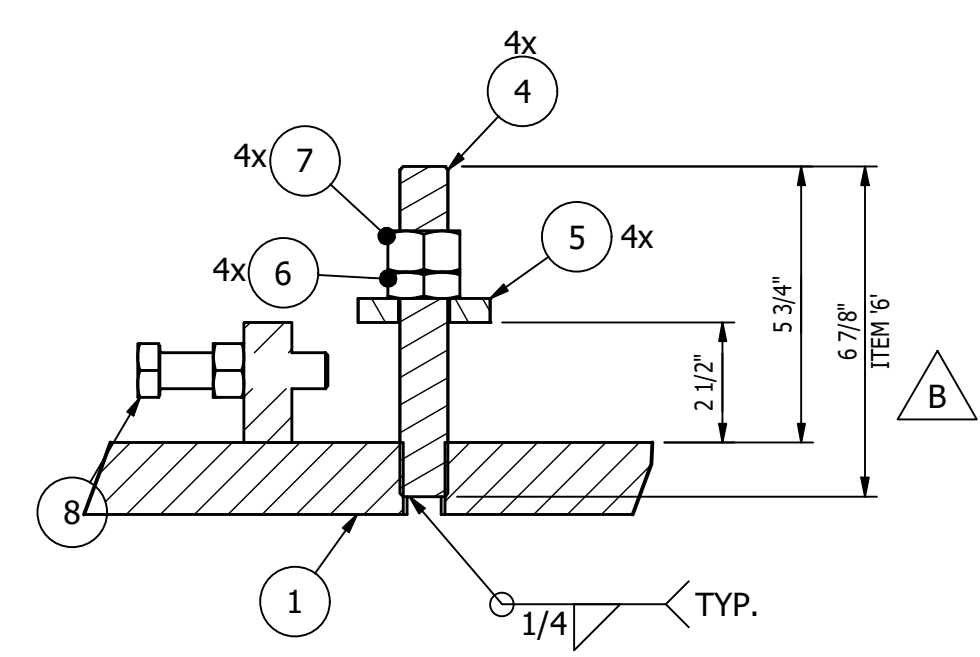
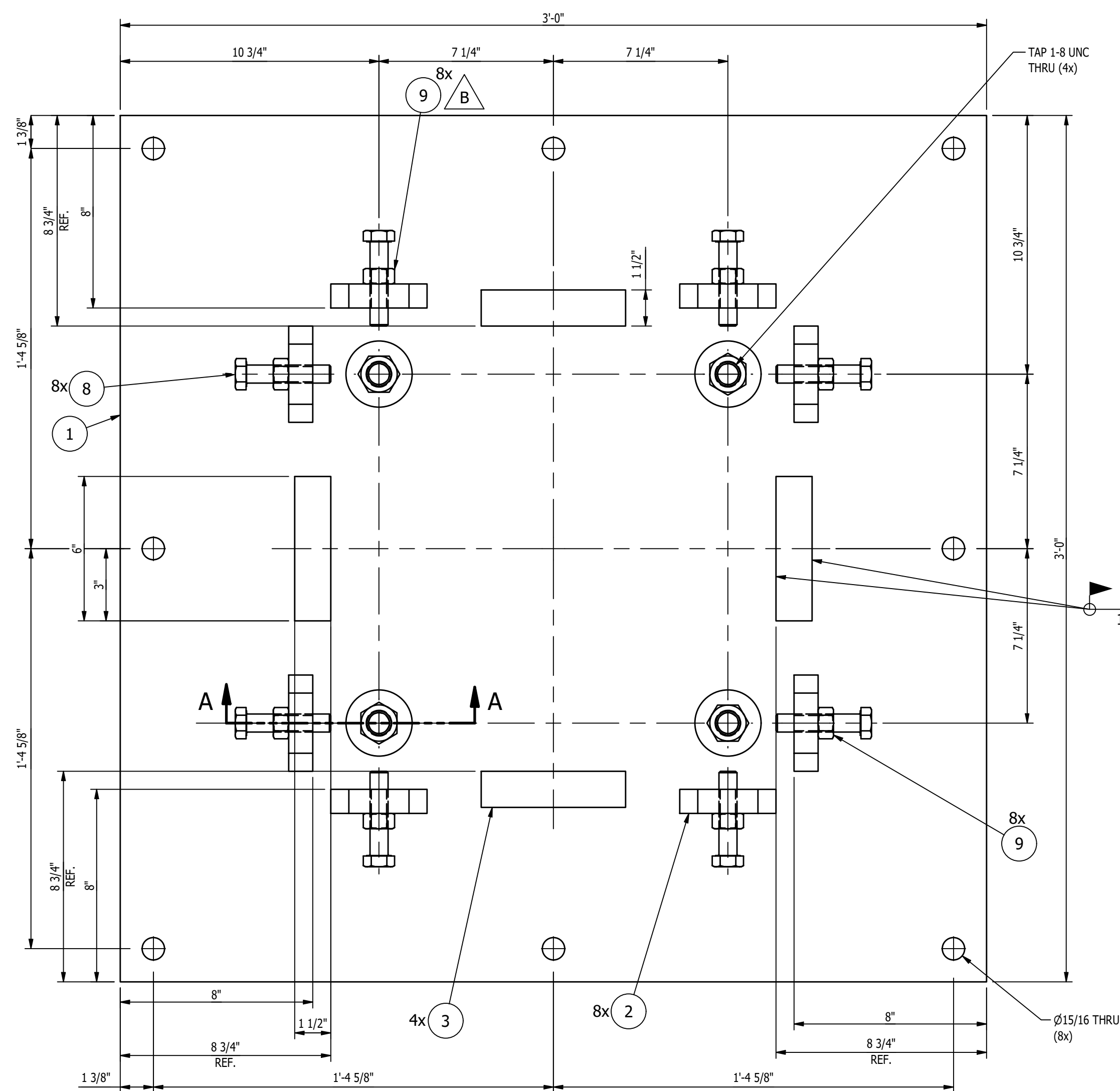
MAGNUM CONSULTING
 41100 QuakerRoad Rd.
 Suite 125
 Novi, MI 48235
 Phone: (248) 773-8833
 Fax: (248) 773-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D325

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

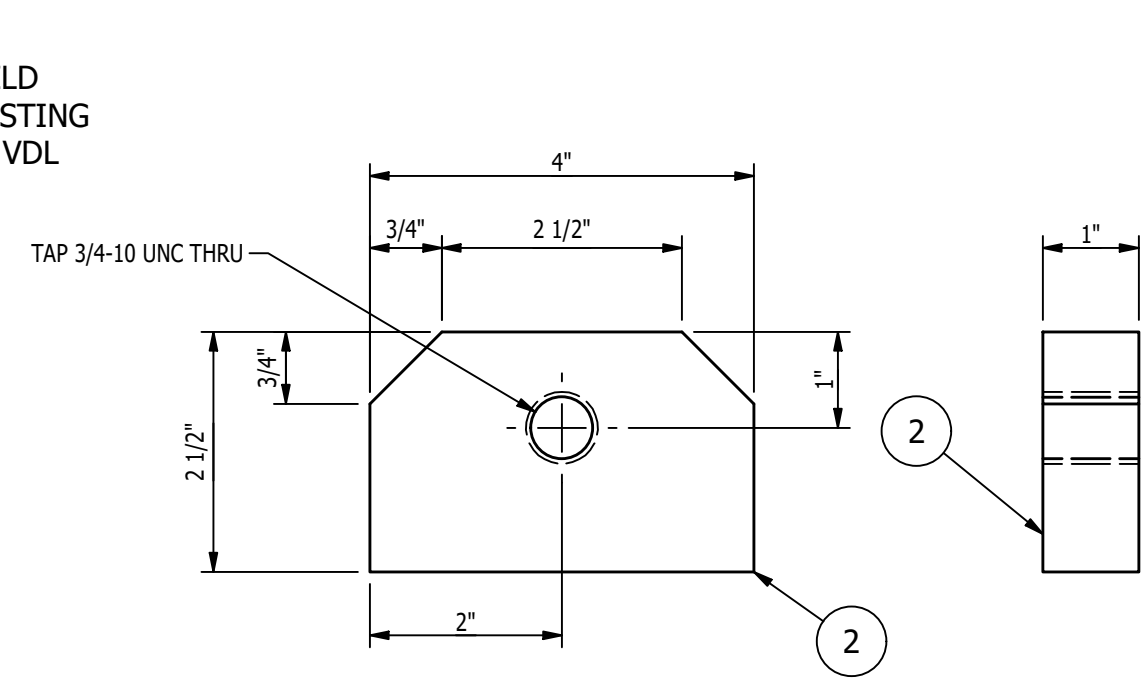
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO 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-D327A			
1	1	PL 1 1/2 x 3'	3'-0"		
2	8	BAR 1 x 2 1/2	4"		
3	4	SQ. BAR 1 1/2	6"		
4	4	THD. ROD 1-8UNC	6 7/8"		
5	4	BAR Ø2 3/4 (1045)	1/2"		
6	4	1-8UNC HEX NUT			
7	4	1-8UNC HEX JAM NUT			
8	8	3/4-10UNC x 3 1/2" LG. HEX HEAD CAP SCREW, FULLY THREADED			
9	8	3/4-10UNC HEX NUT			

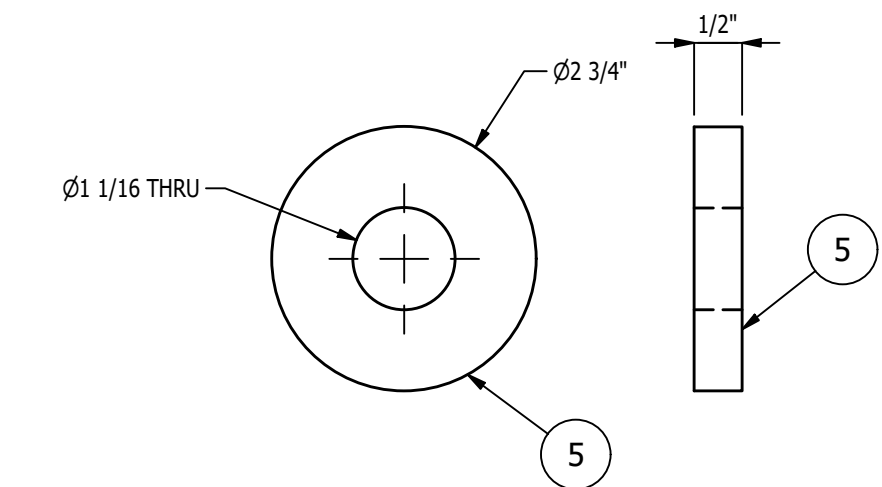
SHIP ITEM '3' LOOSE



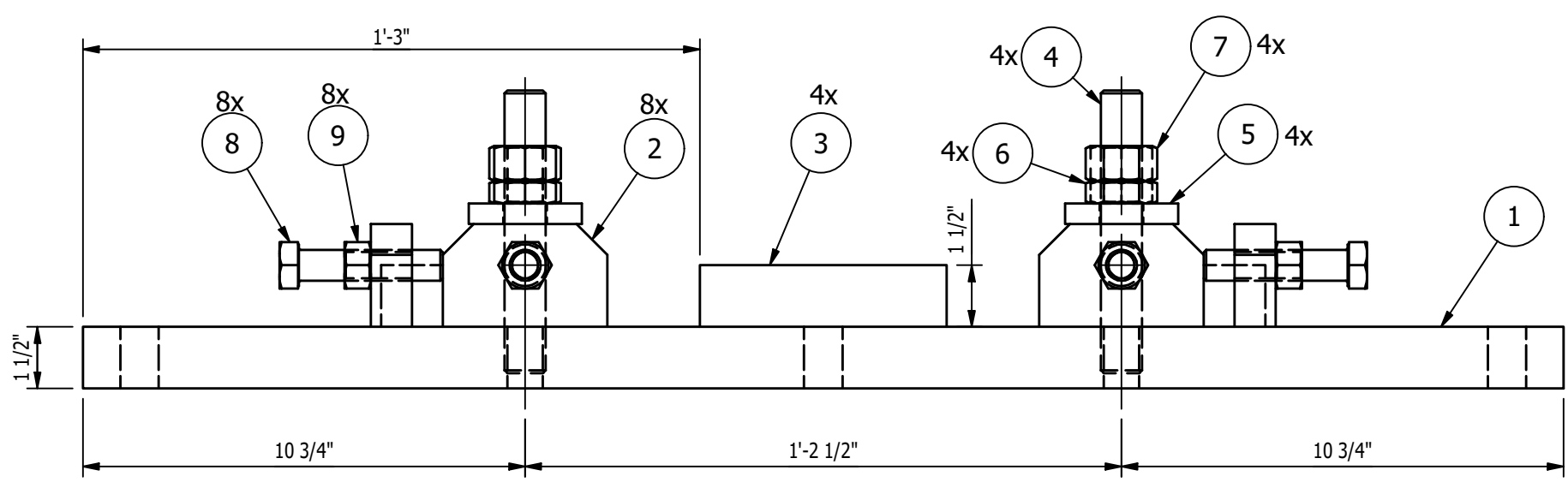
SECTION 'A-A' TYP.
SCALE 3"=1'-0"



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



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



MK-D327A ~ COLUMN BASE
SCALE 3"=1'-0"

TYP. FIELD WELD AFTER TESTING & DEBUG VDL

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

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

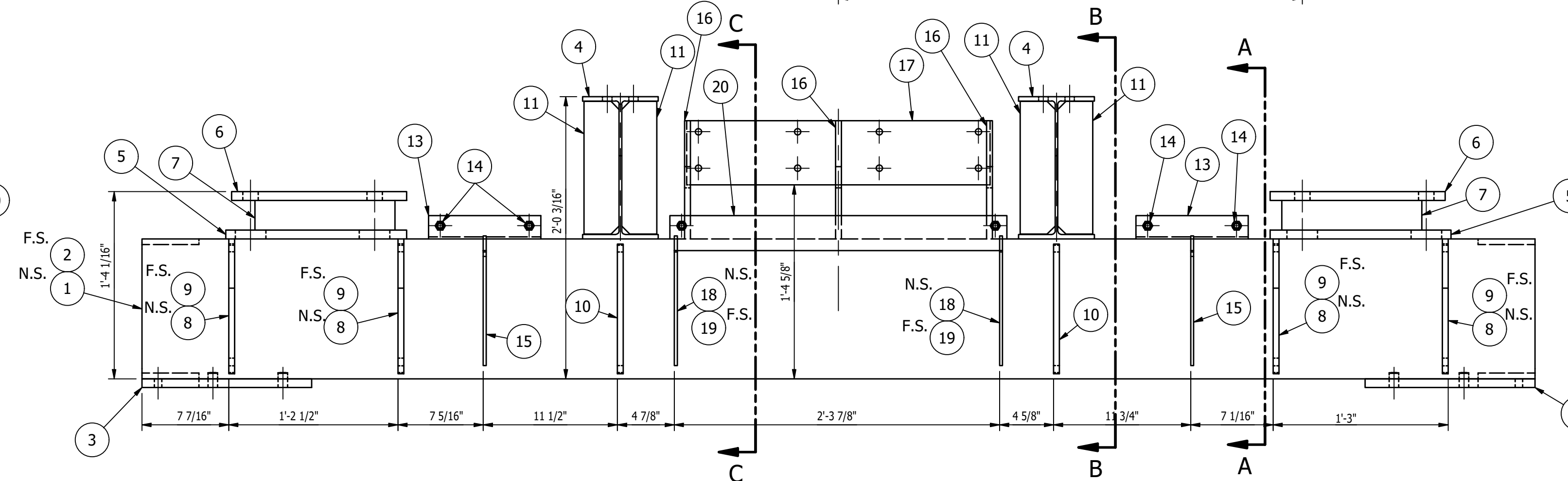
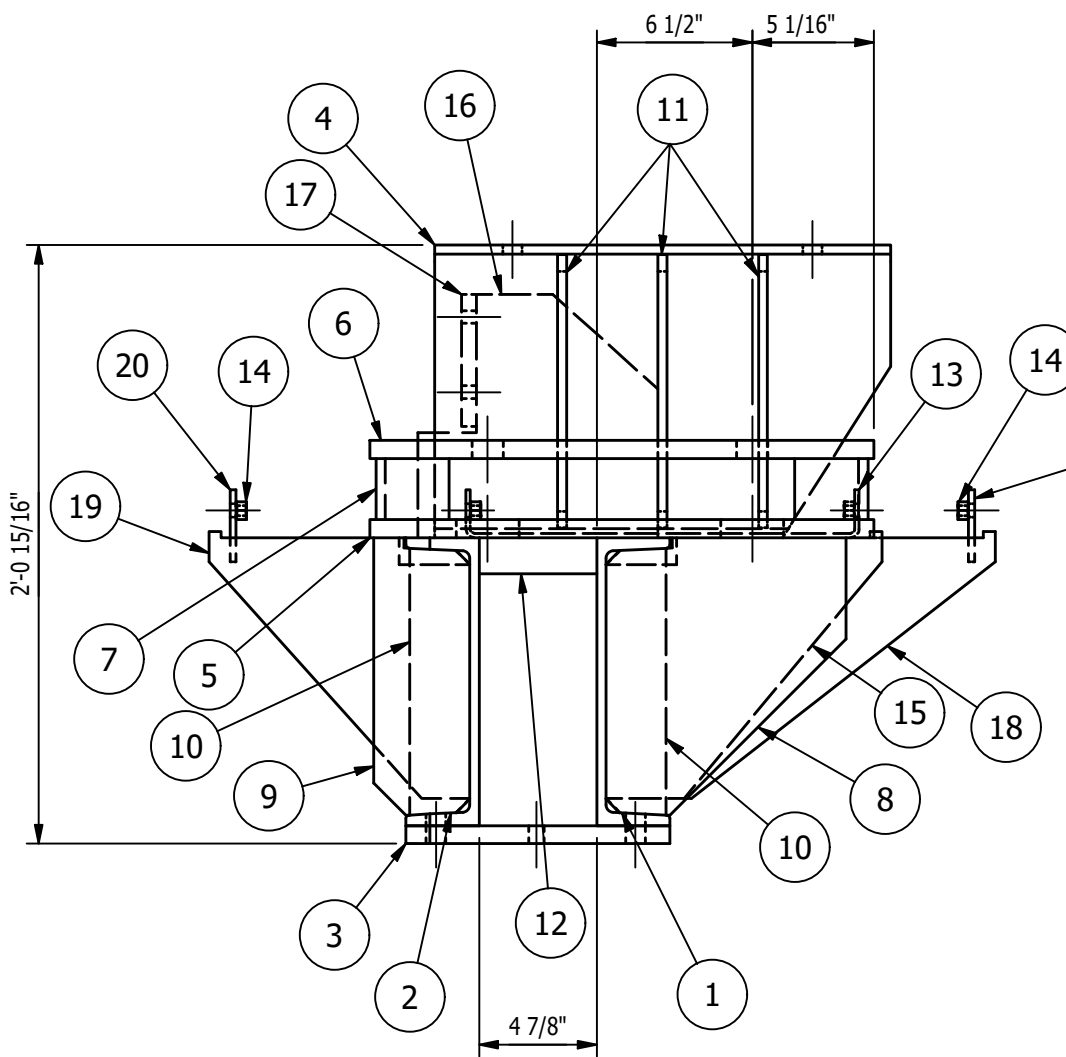
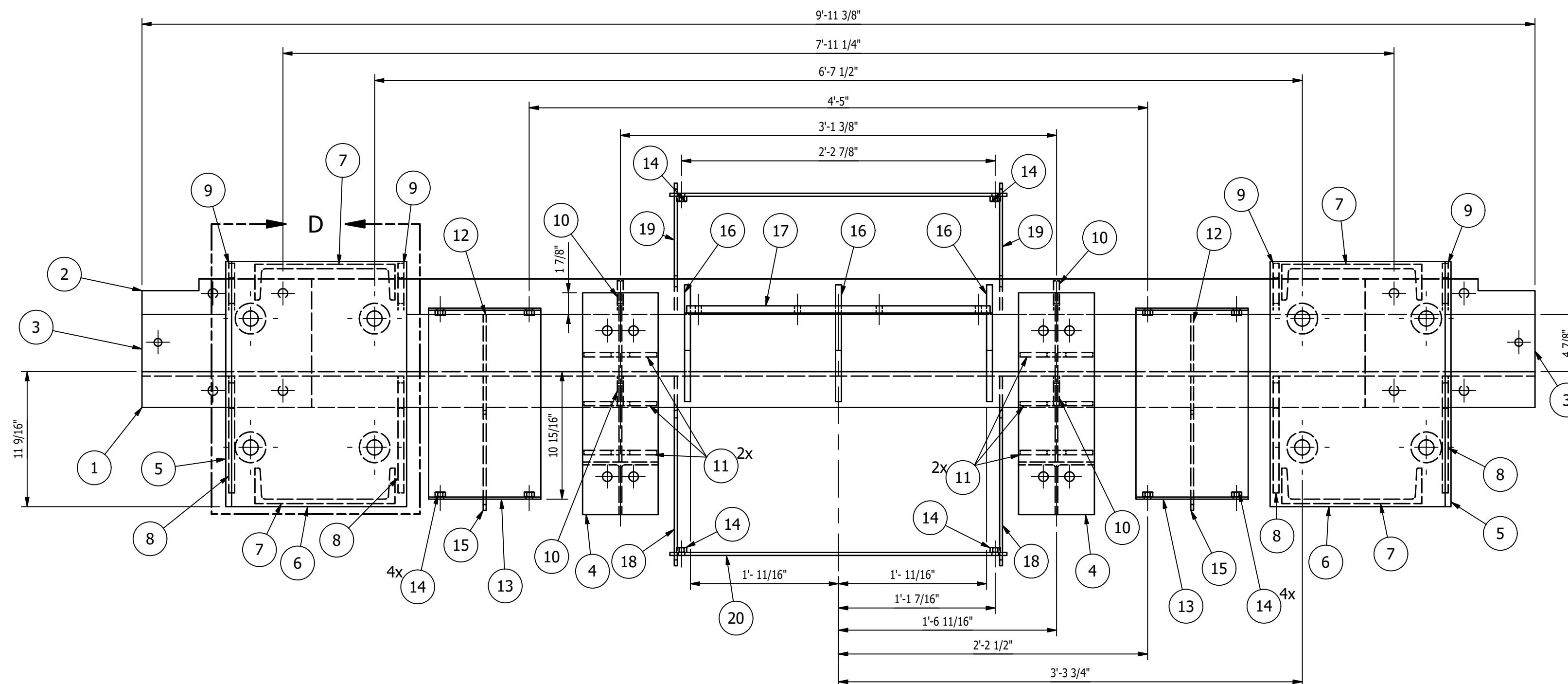
REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	GENERAL UPDATED BALLOONS & DIMS	
A	MC	8/8/2022	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: AH	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		CHECKED BY: JCK	
CLIENT: VOLVO		DWG DATE: 7/21/22	
DRAWING No. 1875D327		JOB No. 22096	
REV: B			

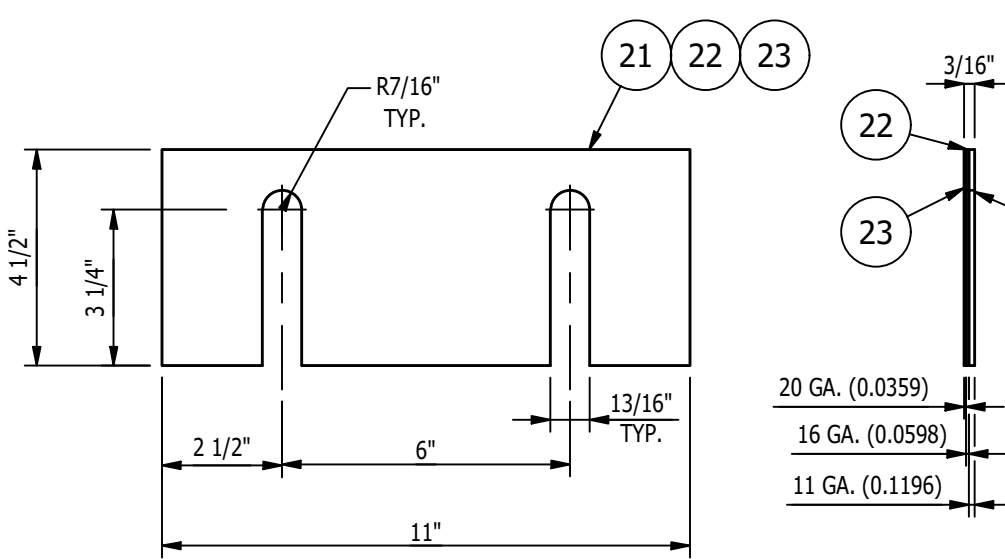
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" 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 QuakerRoad Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D327

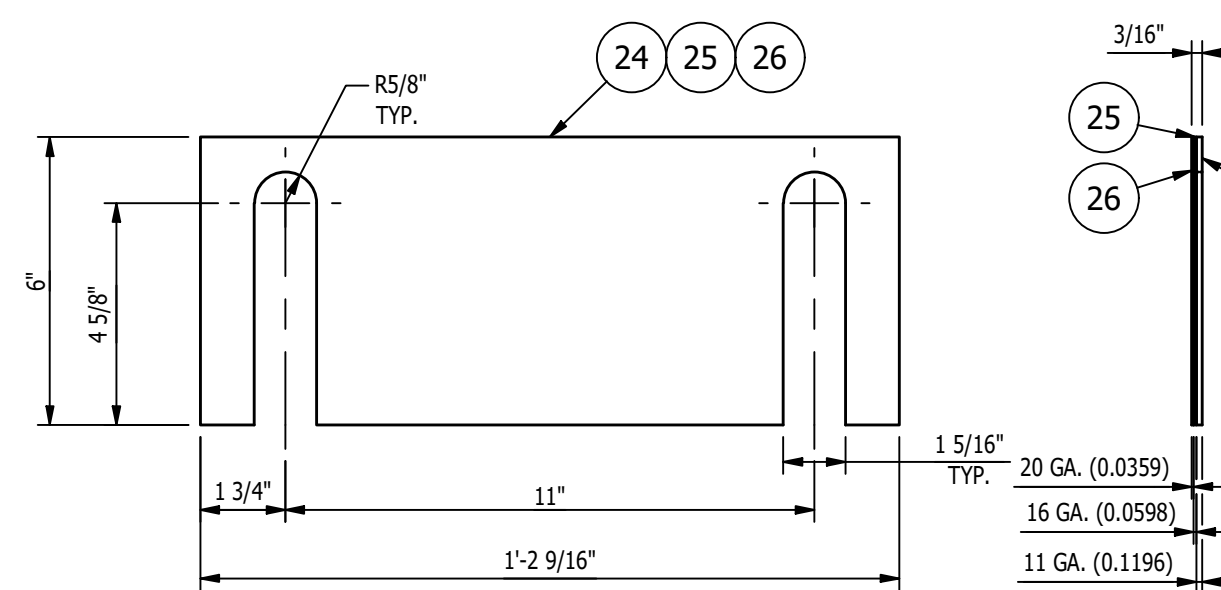
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



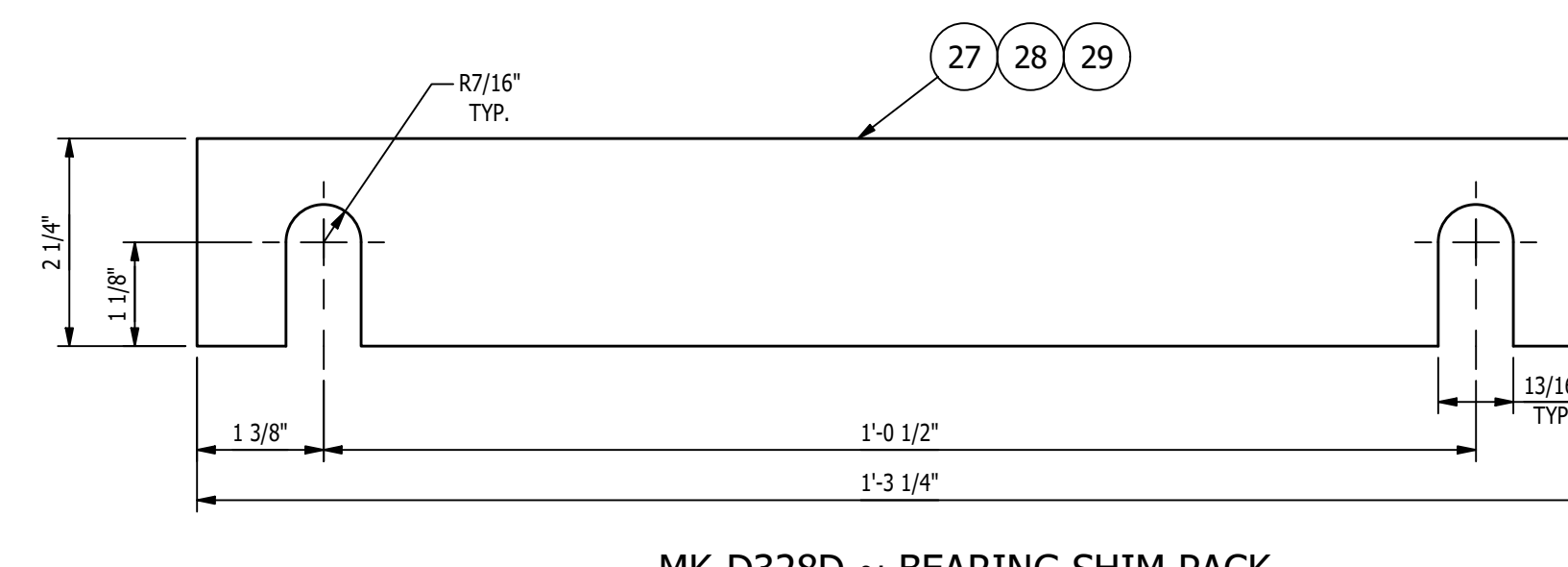
MK-D328A ~ DRIVE WELDMENT
SCALE 1 1/2"=1'-0"



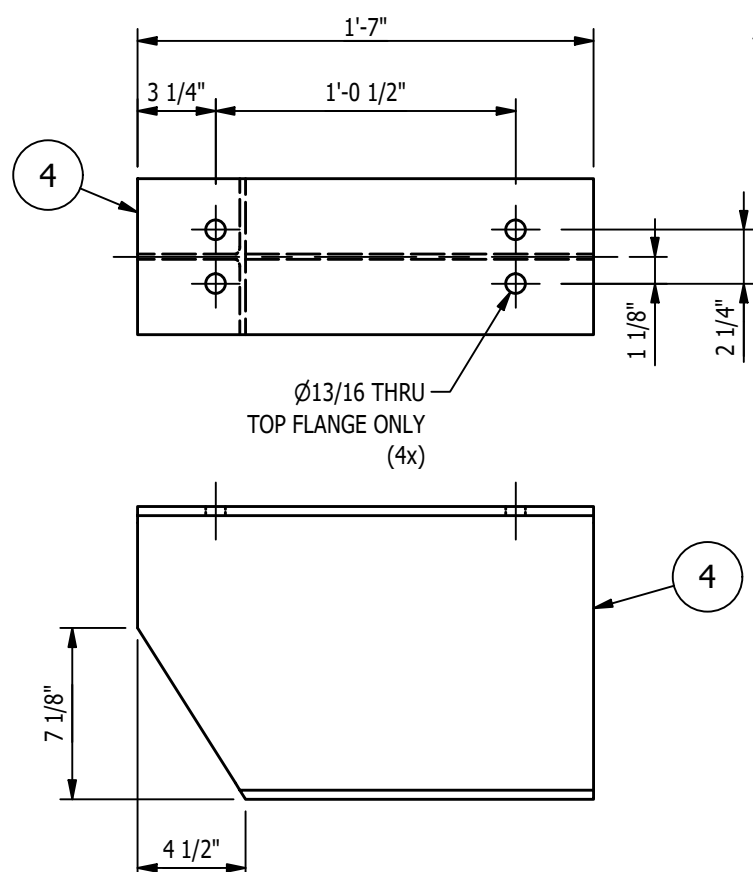
MK-D328B ~ MAST SHIM PACK
SCALE 3"=1'-0"



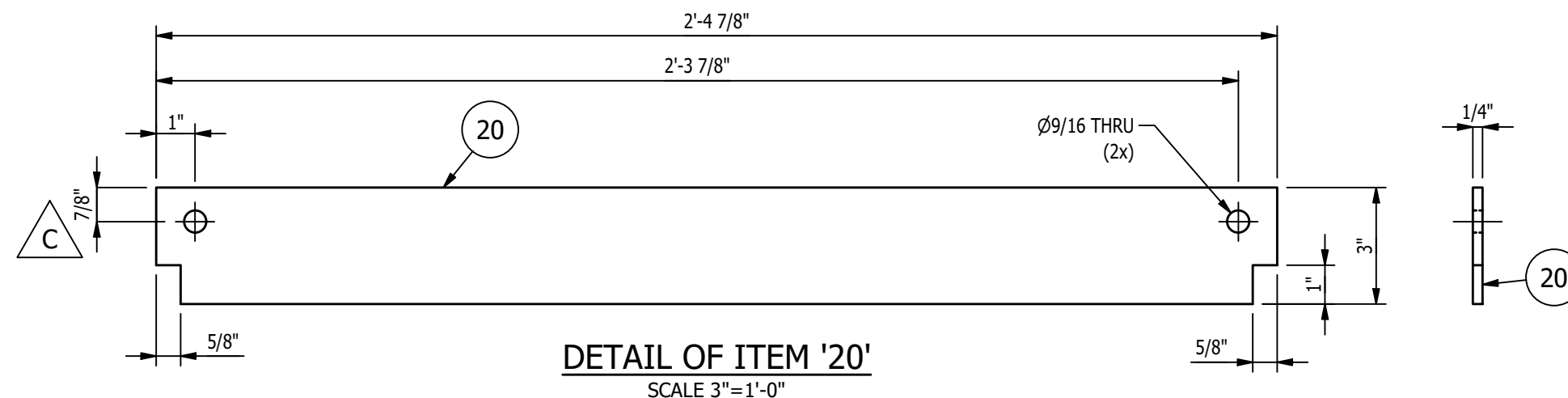
MK-D328C ~ DRIVE SHIM PACK
SCALE 3"=1'-0"



MK-D328D ~ BEARING SHIM PACK
SCALE 6"=1'-0"

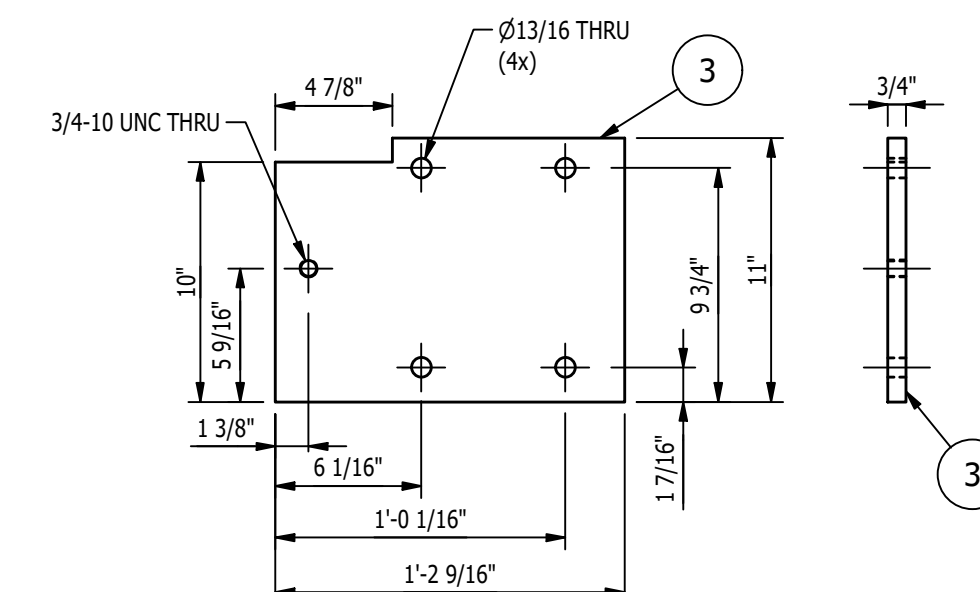


DETAIL OF ITEM '4'
SCALE 1 1/2"=1'-0"



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D328A			
1	1	C 12 x 25	9'-11 3/8"		
2	1	C 12 x 25	9'-11 3/8"		
3	2	BAR 3/4 x 11	1'-2 9/16"		
4	2	W 12 x 26	1'-7"		
5	2	PL 3/4 x 1'-3 1/2"	1'-9"		
6	2	PL 3/4 x 1'-3"	1'-9"		
7	4	C 12 x 25	2 9/16"		
8	4	BAR 1/2 x 10	11 9/16"		
9	4	BAR 1/2 x 4	11 9/16"		
10	4	BAR 1/2 x 2 1/2	11 1/8"		
11	12	BAR 3/8 x 3	11 3/8"		
12	2	BAR 1/4 x 1 1/2	4 7/8"		
13	2	SHT 7 GA x 9 5/8	1'-7 11/16"		
14	12	1/2-13UNC HEX NUT			
15	2	PL 1/4 x 11 1/2"	11 1/8"		
16	3	BAR 1/2 x 10	10 1/8"		
17	1	BAR 5/8 x 5 1/2	2'-2"		
18	2	PL 1/4 x 11 1/8"	1'-4 1/4"		
19	2	PL 1/4 x 11 1/8"	10 7/8"		
20	2	BAR 1/4 x 3	2'-4 7/8"		
		MK-D328B			
21	1	SHT 11 GA x 4 1/2	11"		
22	1	SHT 16 GA x 4 1/2	11"		
23	1	SHT 20 GA x 4 1/2	11"		
		MK-D328C			
24	1	SHT 11 GA x 6	1'-2 9/16"		
25	1	SHT 16 GA x 6	1'-2 9/16"		
26	1	SHT 20 GA x 6	1'-2 9/16"		
		MK-D328D			
27	1	SHT 11 GA x 2 1/4	1'-3 1/4"		
28	1	SHT 16 GA x 2 1/4	1'-3 1/4"		
29	1	SHT 20 GA x 2 1/4	1'-3 1/4"		



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

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

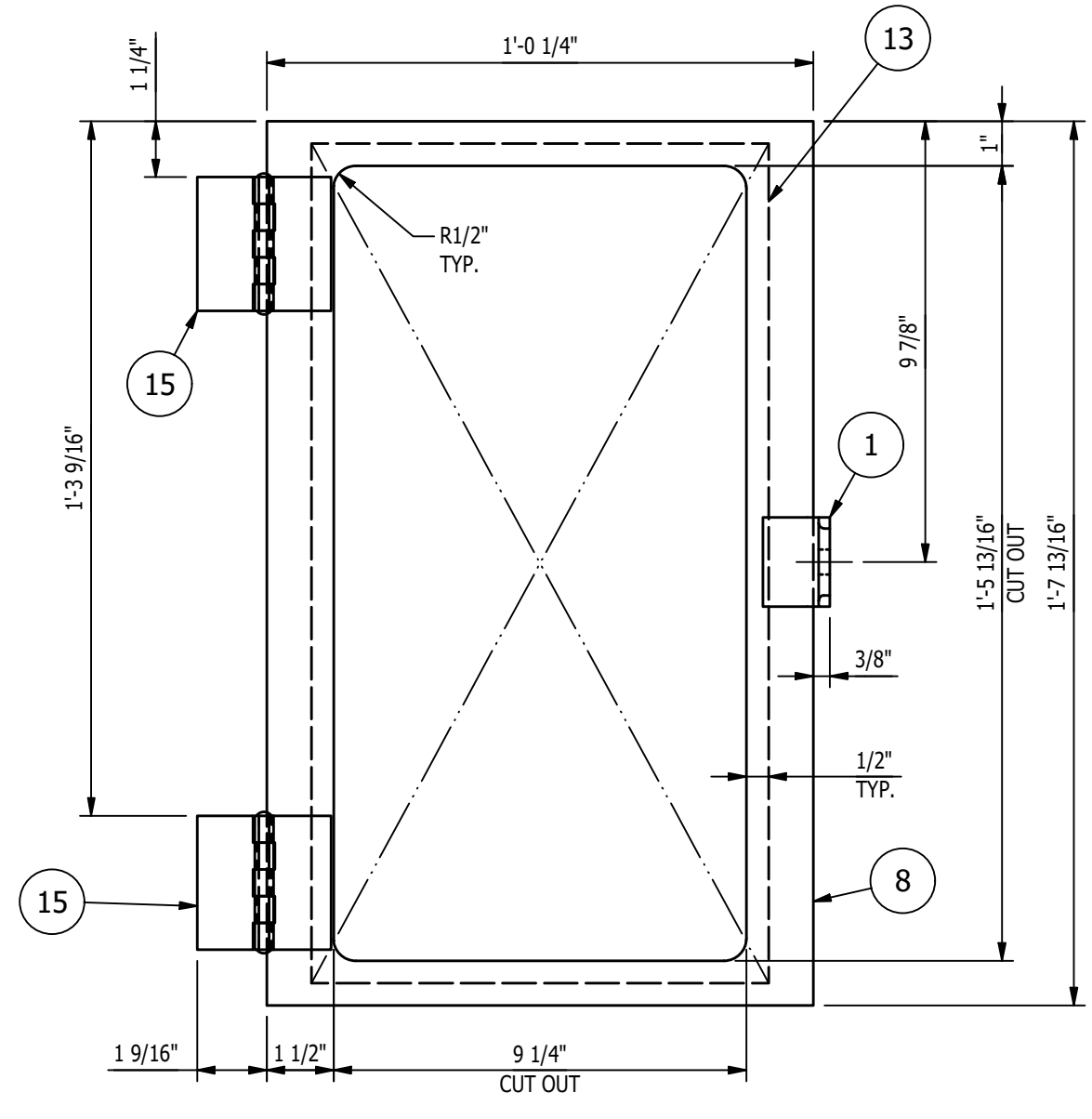
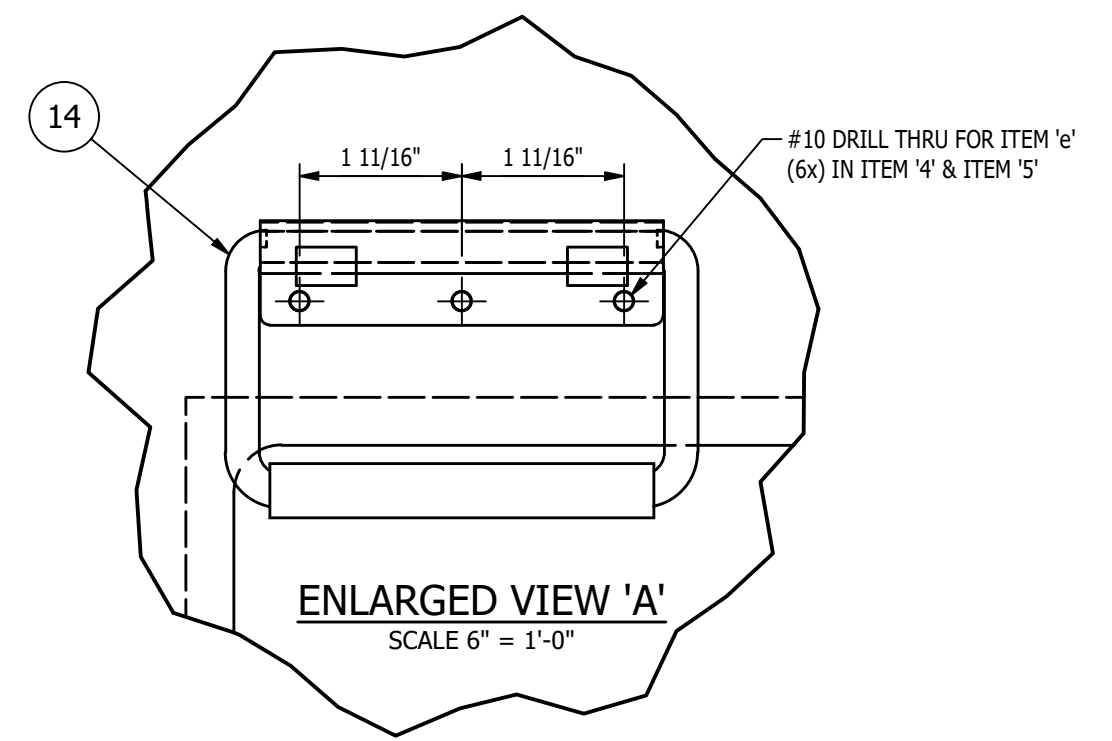
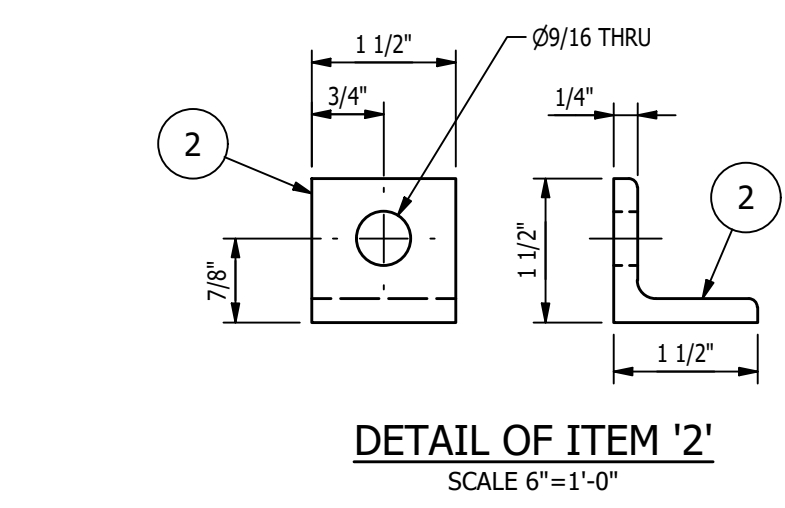
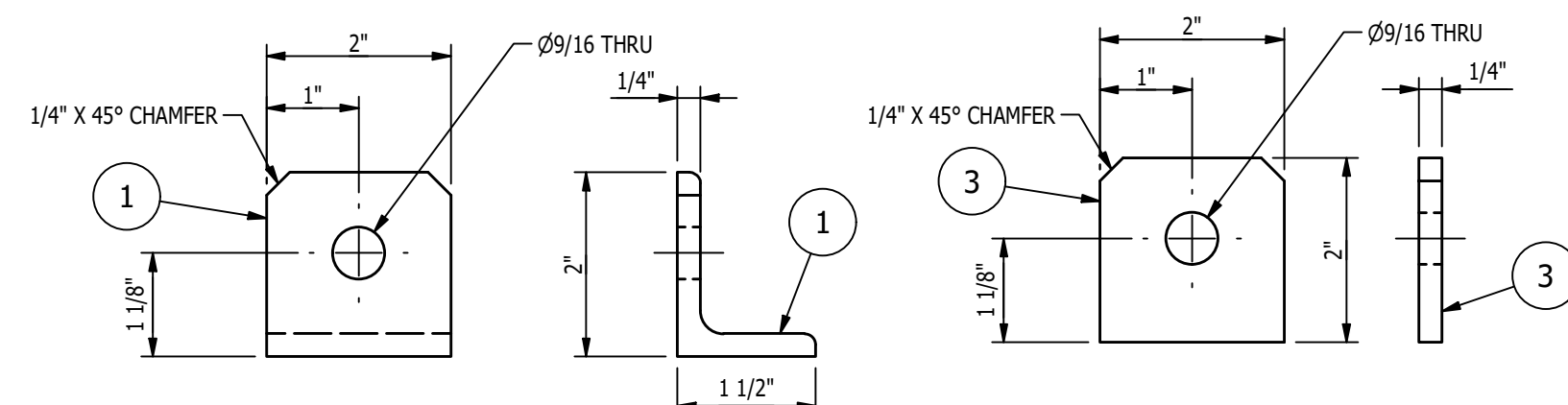
REV	BY	DATE	DESCRIPTION	APP
C	MC	9/8/2022	ADDED HOLE DIM	
B	MC	8/19/2022	GENERAL UPDATED DIMS	
A	MC	8/8/2022	FOR FABRICATION	

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: RPM		CHECKED BY: JCK	
CLIENT: VOLVO		DWG DATE: 7/12/22		JOB No: 22096	
DRAWING No. 1875D328		REV: C			

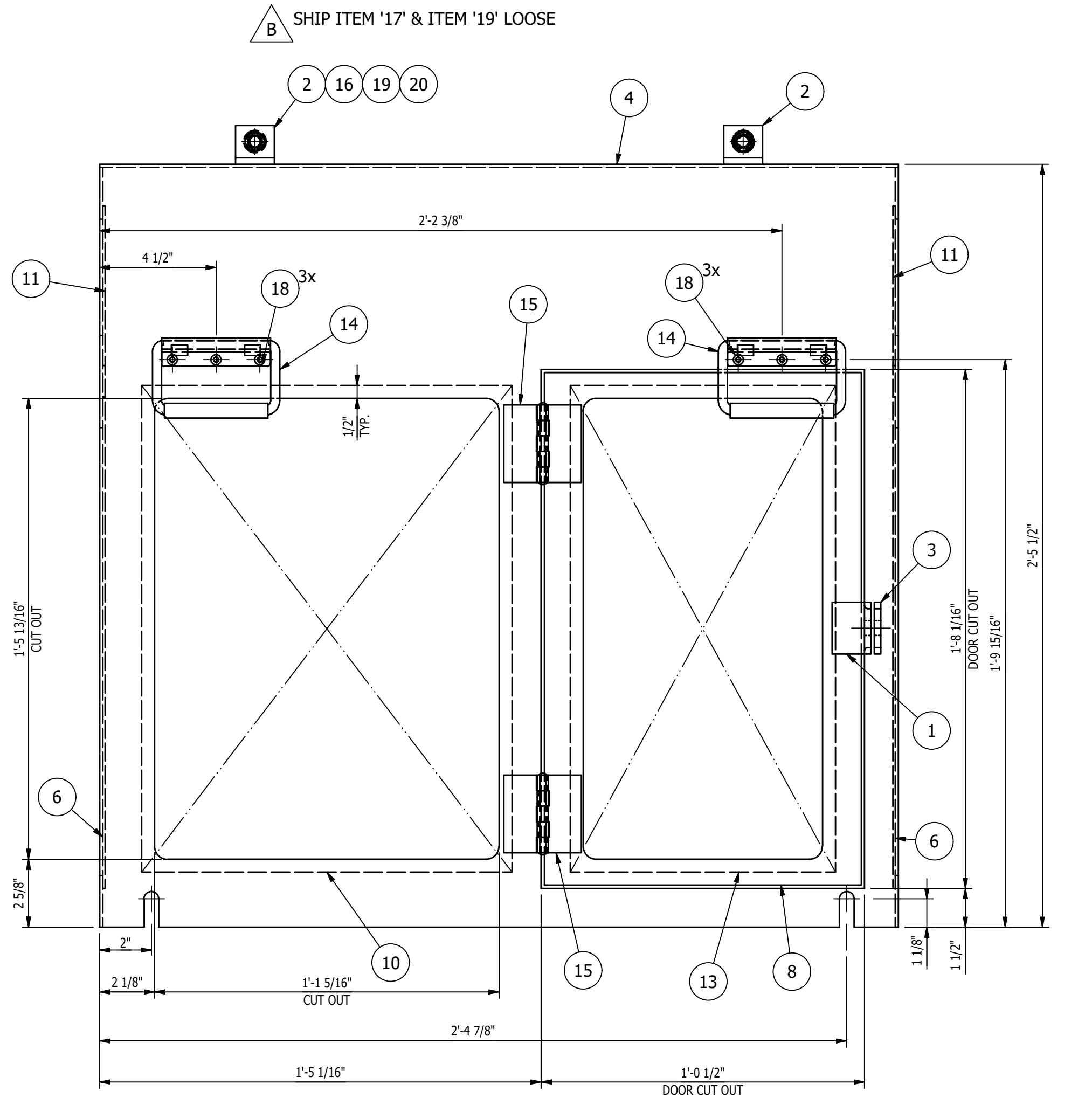
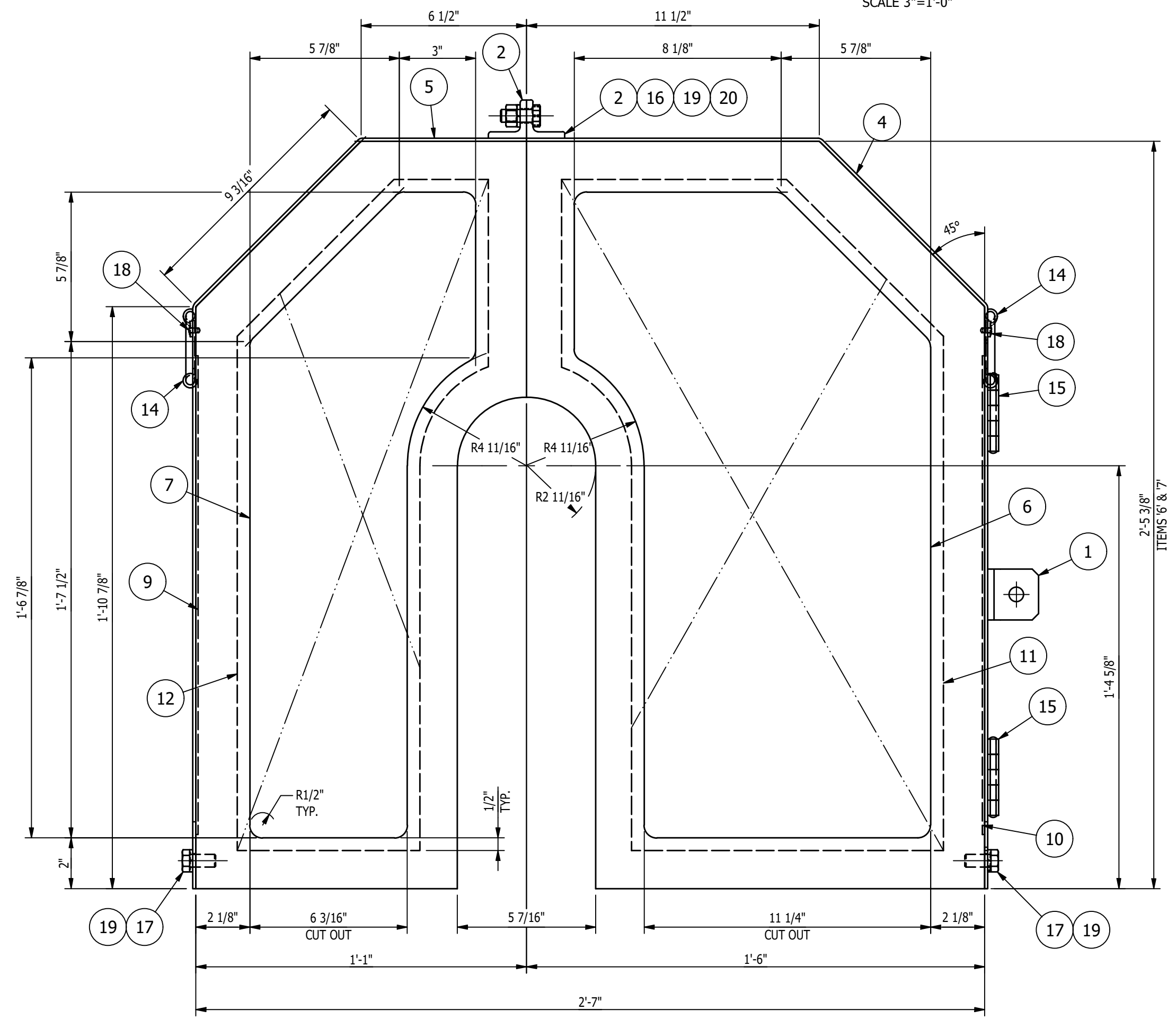
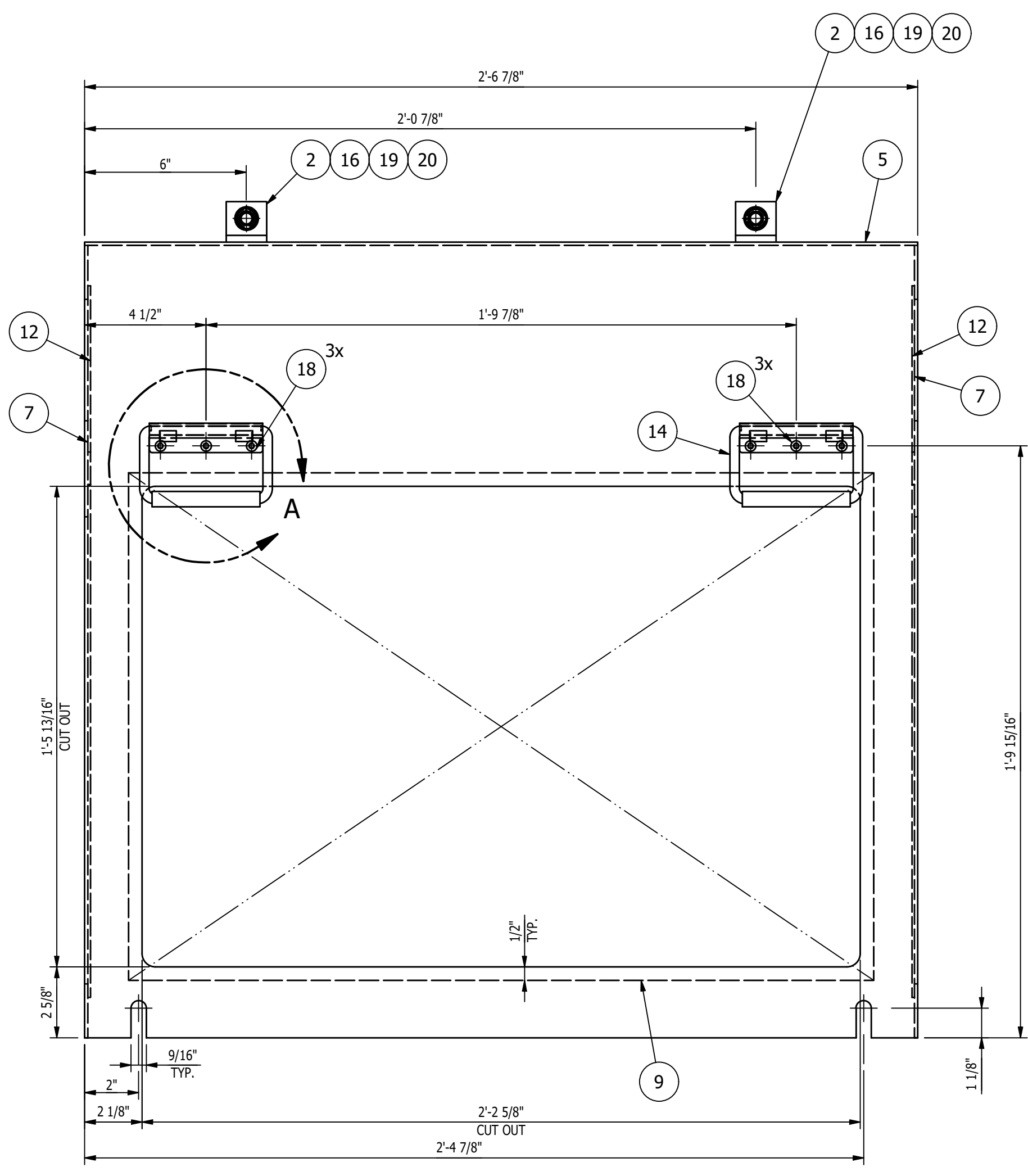
MAGNUM CONSULTING
 41100 QuakerRoad Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 373-8833
 Fax: (248) 373-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D328

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-D329A			
1	1	L 2 x 1 1/2 x 1/4	2"		
2	4	L 1 1/2 x 1 1/2 x 1/4	1 1/2"		
3	1	BAR 1/4 x 2	2"		
4	1	SHT 11 GA x 2'-6 7/8"	3'-7 5/8"		
5	1	SHT 11 GA x 2'-6 7/8"	3'-2 5/8"		
6	2	SHT 11 GA x 18	2'-5 3/8"		
7	2	SHT 11 GA x 13	2'-5 3/8"		
8	1	SHT 11 GA x 12 1/4	1'-7 13/16"		
9	1	EXP MTL, 1/2-#13 x 18 13/16"	2'-3 5/8"		
10	1	EXP MTL, 1/2-#13 x 14 5/16"	1'-6 13/16"		
11	2	EXP MTL, 1/2-#13 x 15"	2'-2 3/8"		
12	2	EXP MTL, 1/2-#13 x 9 7/8"	2'-2 3/8"		
13	1	EXP MTL, 1/2-#13 x 10 1/4"	1'-6 13/16"		
14	4	NEILSEN HANDLE 1/2" PLATE STYLE, REID TOOL CO. #NSH-100		20-2	
15	2	HINGE 3" x 3" x 3/32" SURFACE MOUNT W/ 1/4" PIN, McMASTER CARR PART #16175A24		20-3	
16	2	1/2-13UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
17	4	1/2-13UNC x 1" LG. HEX HEAD CAP SCREW			
18	12	3/16" x 1/4" LG. POP RIVET			
19	6	1/2 SPRING LOCK WASHER			
20	2	1/2-13UNC HEX NUT			



MK-D329A ~ PULLEY GUARD
SCALE 3"=1'-0"

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

PAINT NOTES:
PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF SAFETY YELLOW RAL 1023
PAINT EXP MTL BLACK RAL 9005
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

SHEET 1 OF 2

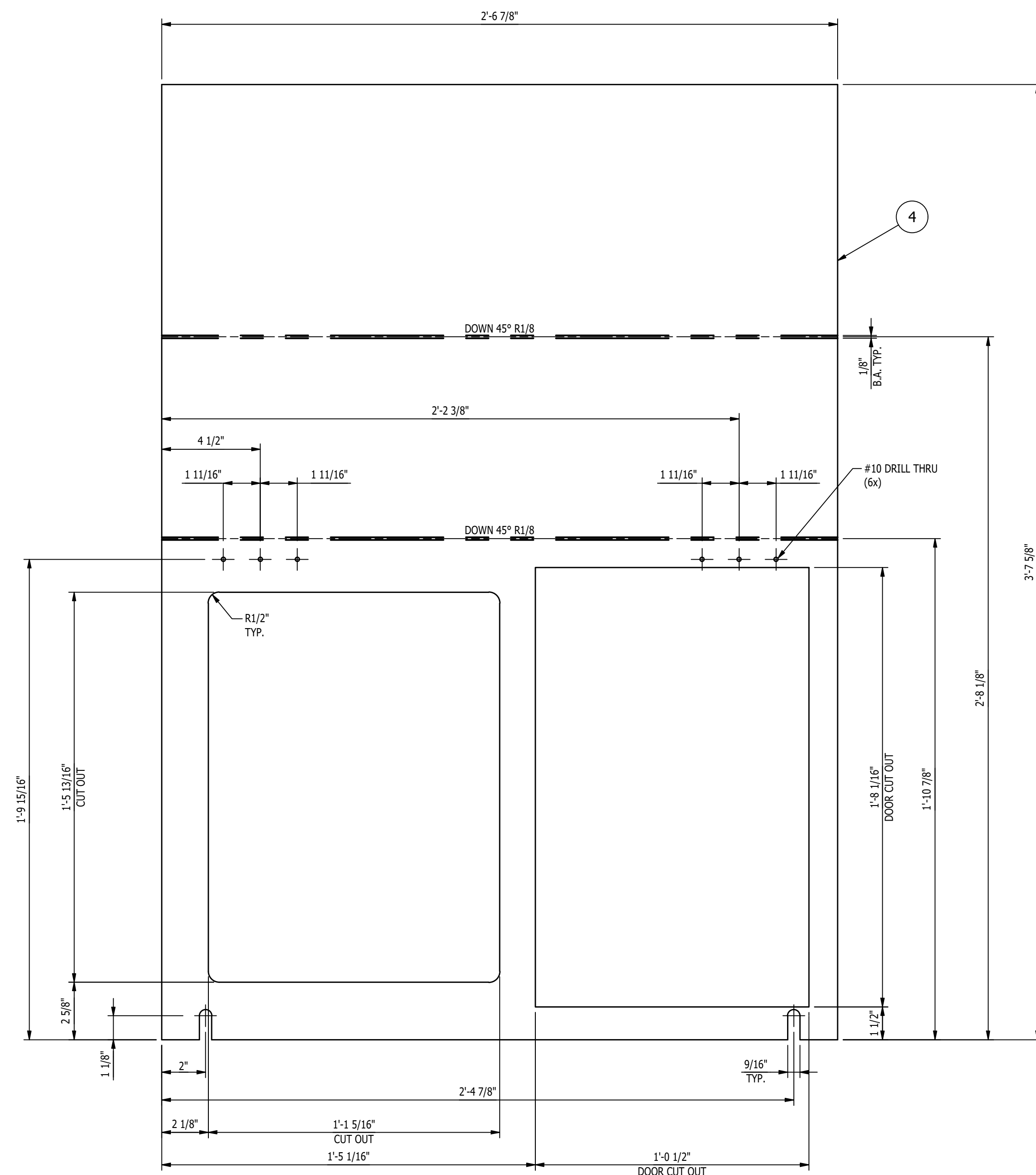
MAGNUM CONSULTING
41100 Charleston Rd
Suite 125
Norcross, GA 30075
Phone: (770) 447-8888
Fax: (770) 447-8881
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D329

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

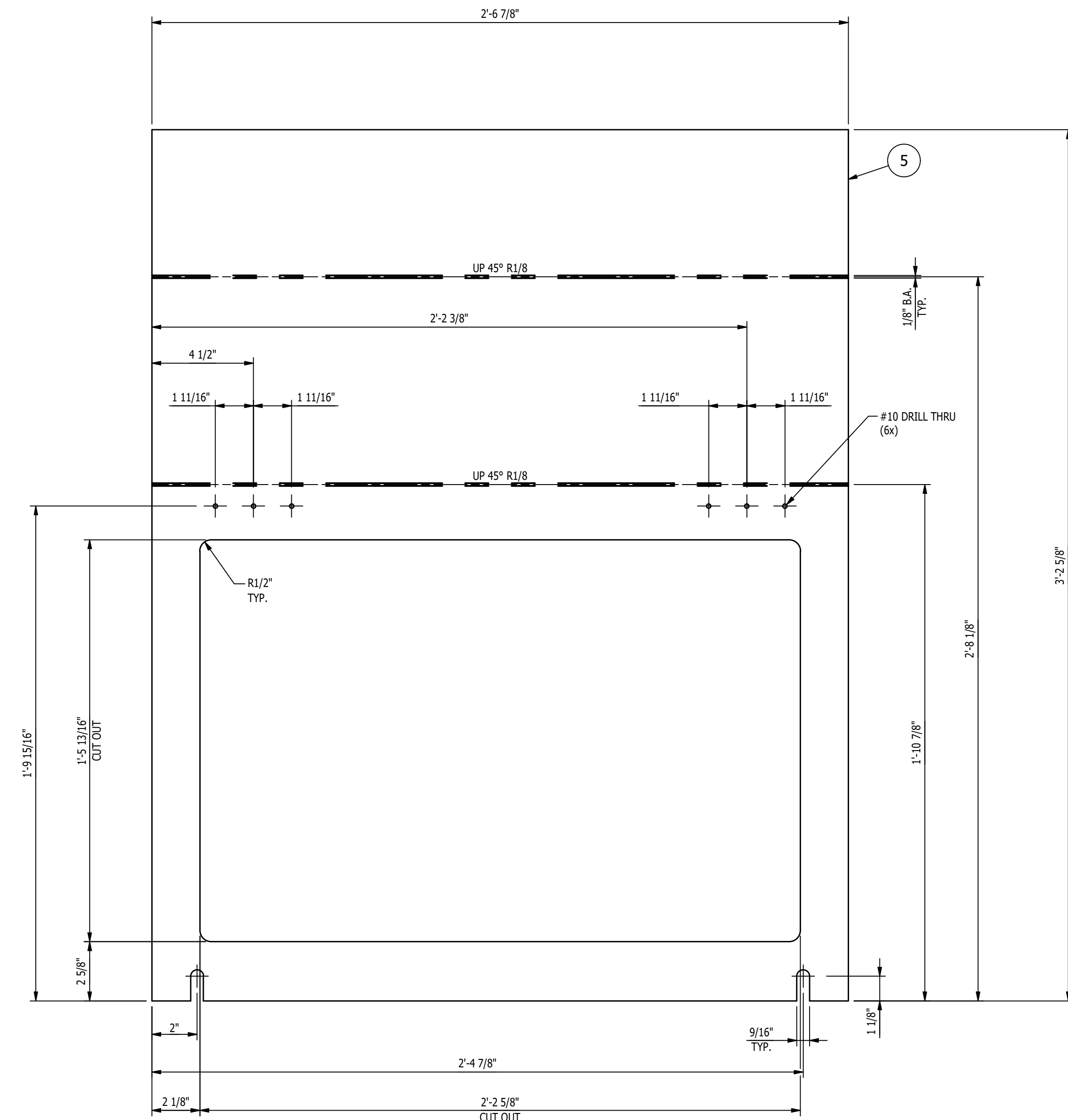
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4"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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	ADDED ABM, CHANGED PAINT NOTES, & ADDED NOTE FOR LOOSE ITEMS, ADDED DETAILS FOR ITEMS '11' & '12'	
A	MC	8-8-2022	FOR FABRICATION	

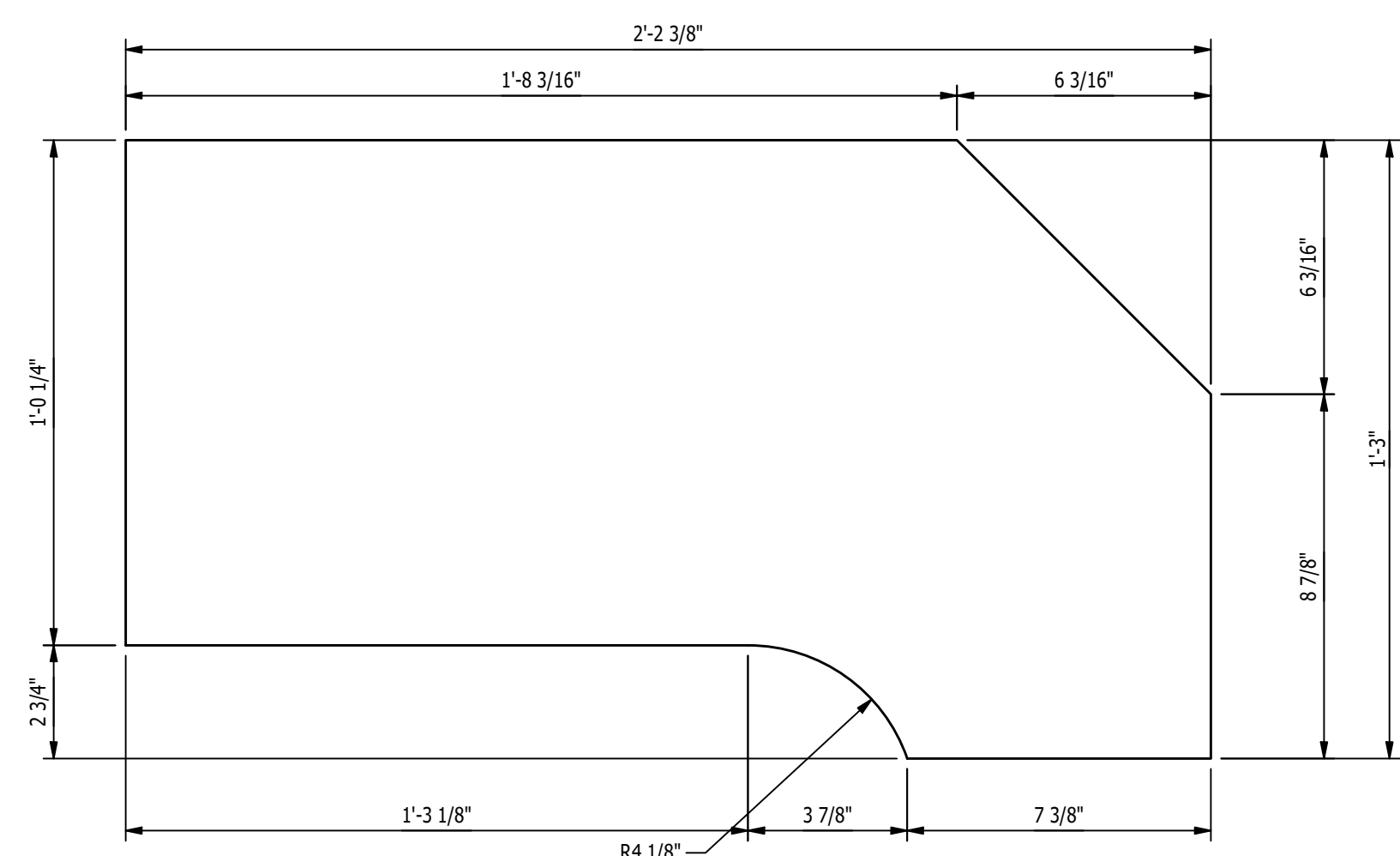
 MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RPM
CLIENT:	VOLVO	CHECKED BY:	JCK
DRAWING No.	1875D329	DWG DATE:	7/11/22
REV:	B	JOB No.:	22096



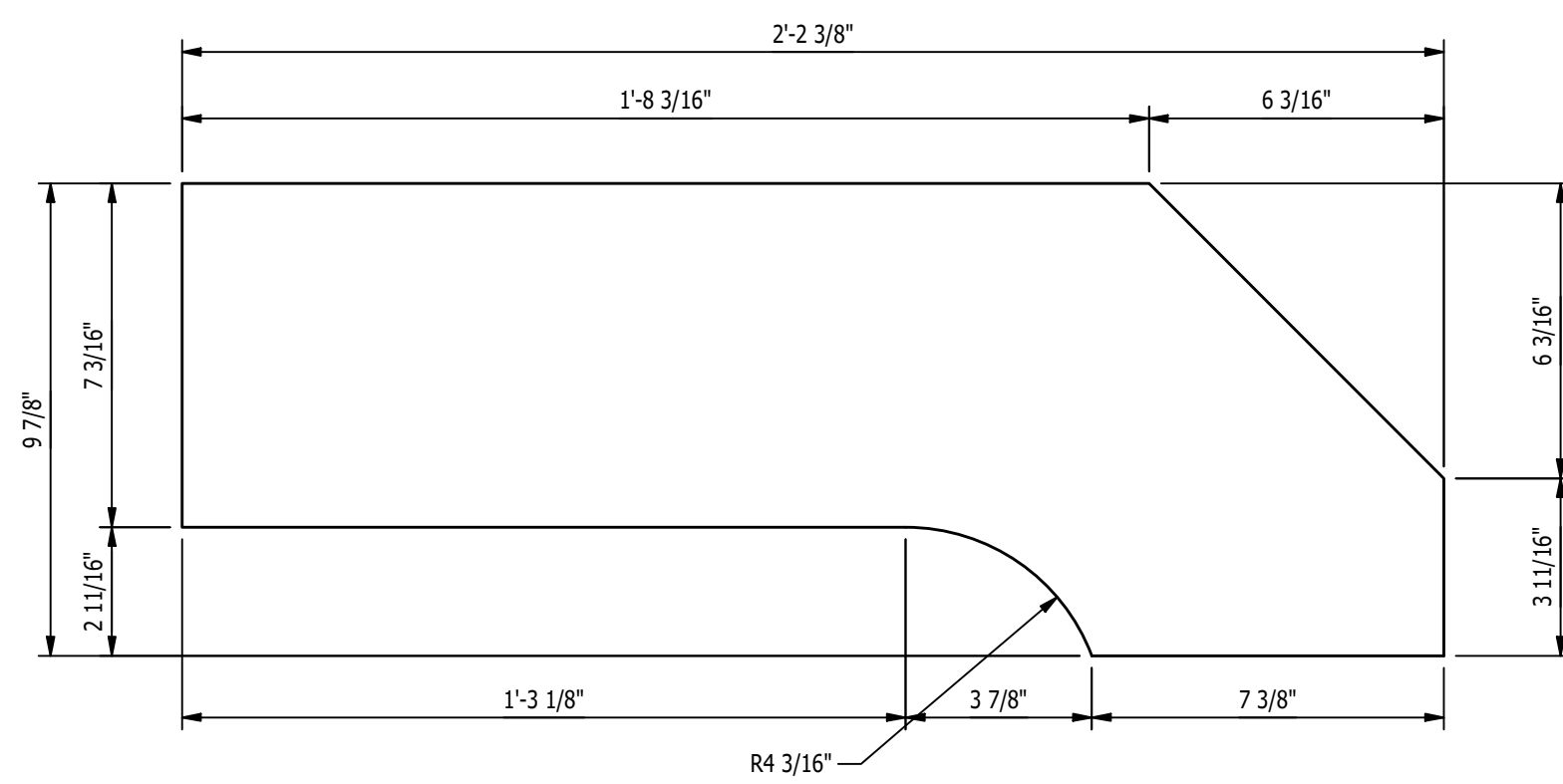
FLAT PATTERN OF ITEM '4'
SCALE 3"=1'-0"



FLAT PATTERN OF ITEM '5'
SCALE 3"=1'-0"



FLAT PATTERN OF ITEM '11'
SCALE 3"=1'-0"



FLAT PATTERN OF ITEM '12'
SCALE 3"=1'-0"

MAGNUM Consulting
4170 Gardenbrook Rd.
Suite 125
Novi, MI 48375
Phone: (248) 772-8000
Fax: (248) 772-8001
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D329

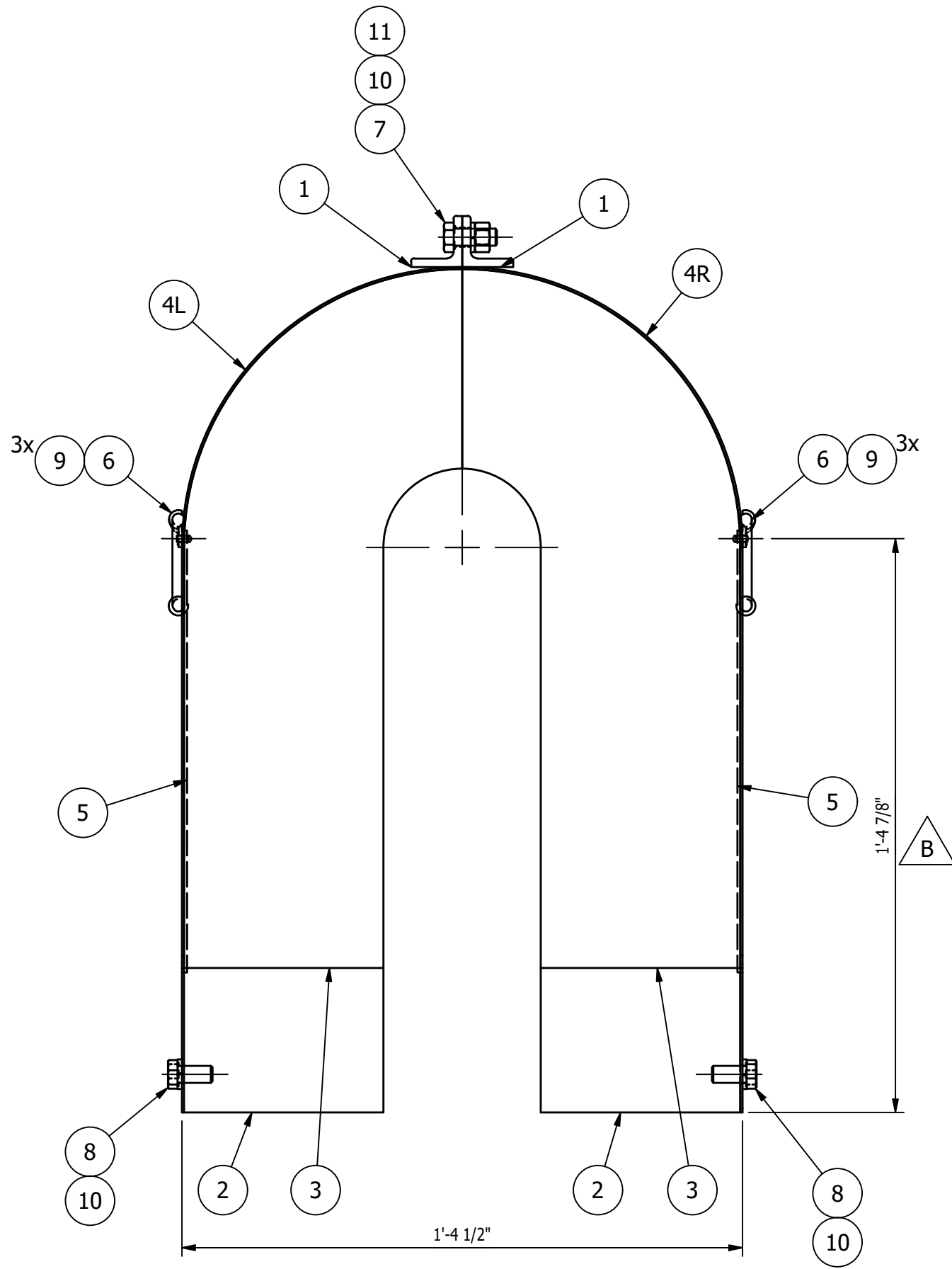
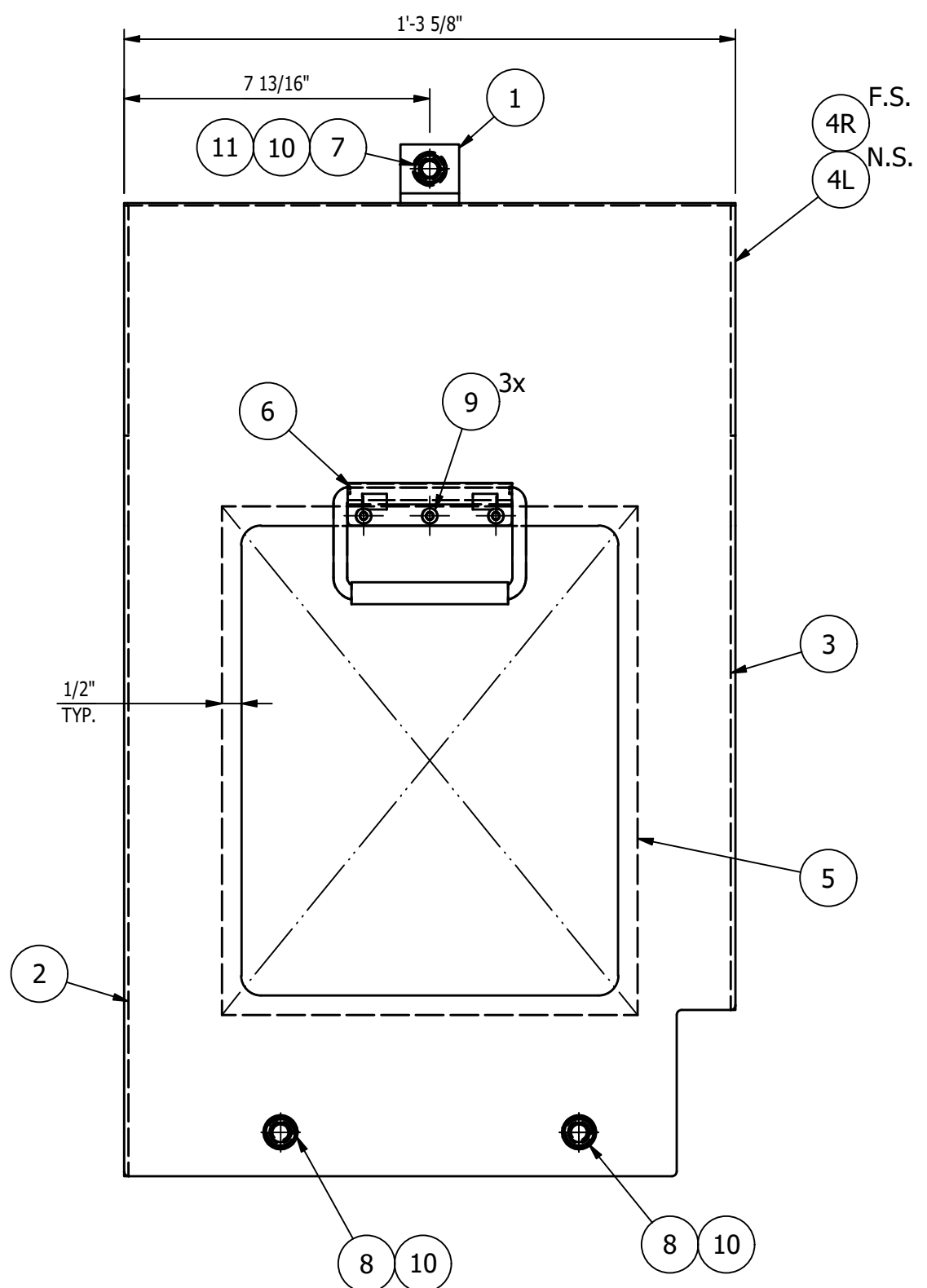
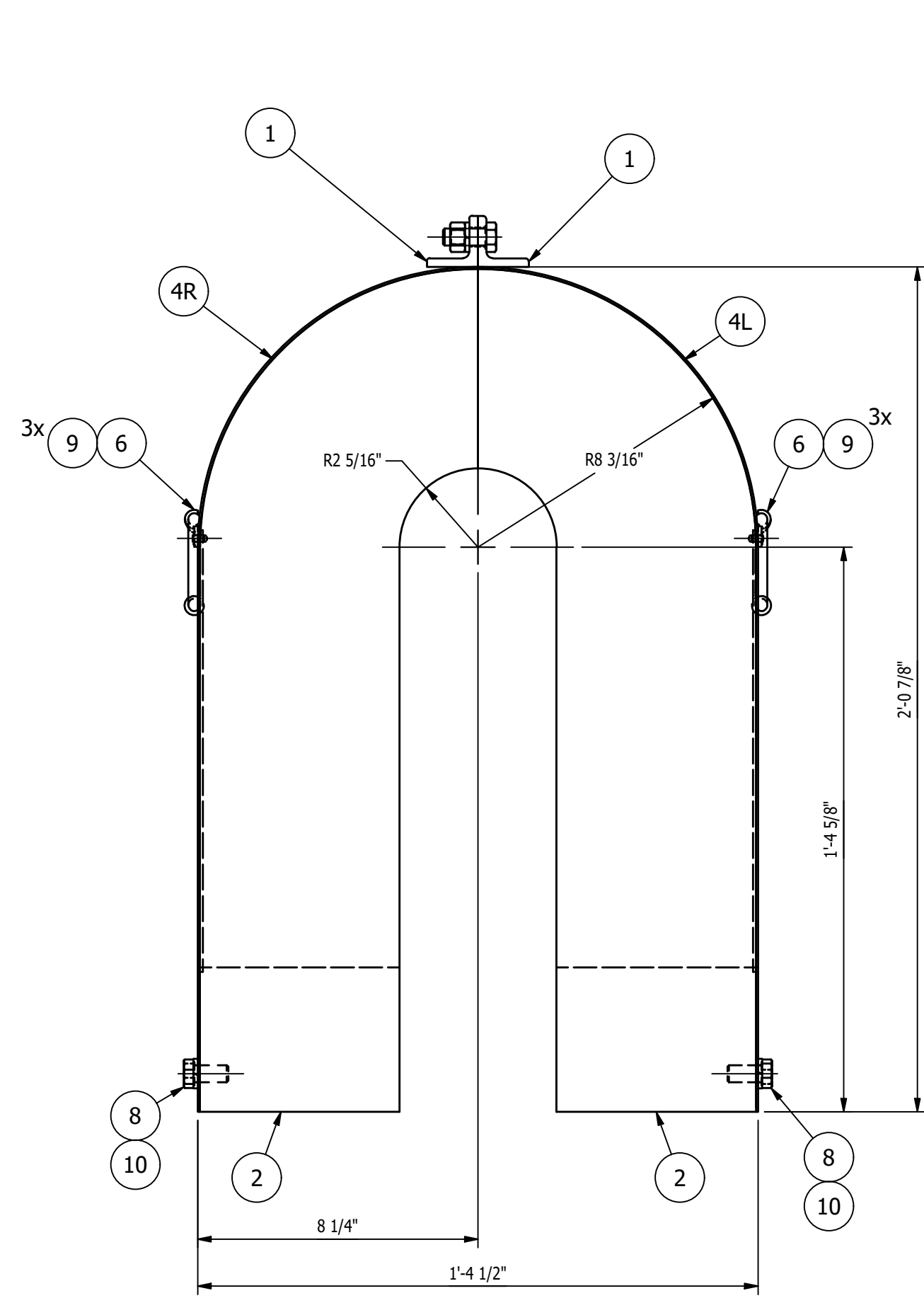
SHEET 2 OF 2
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

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

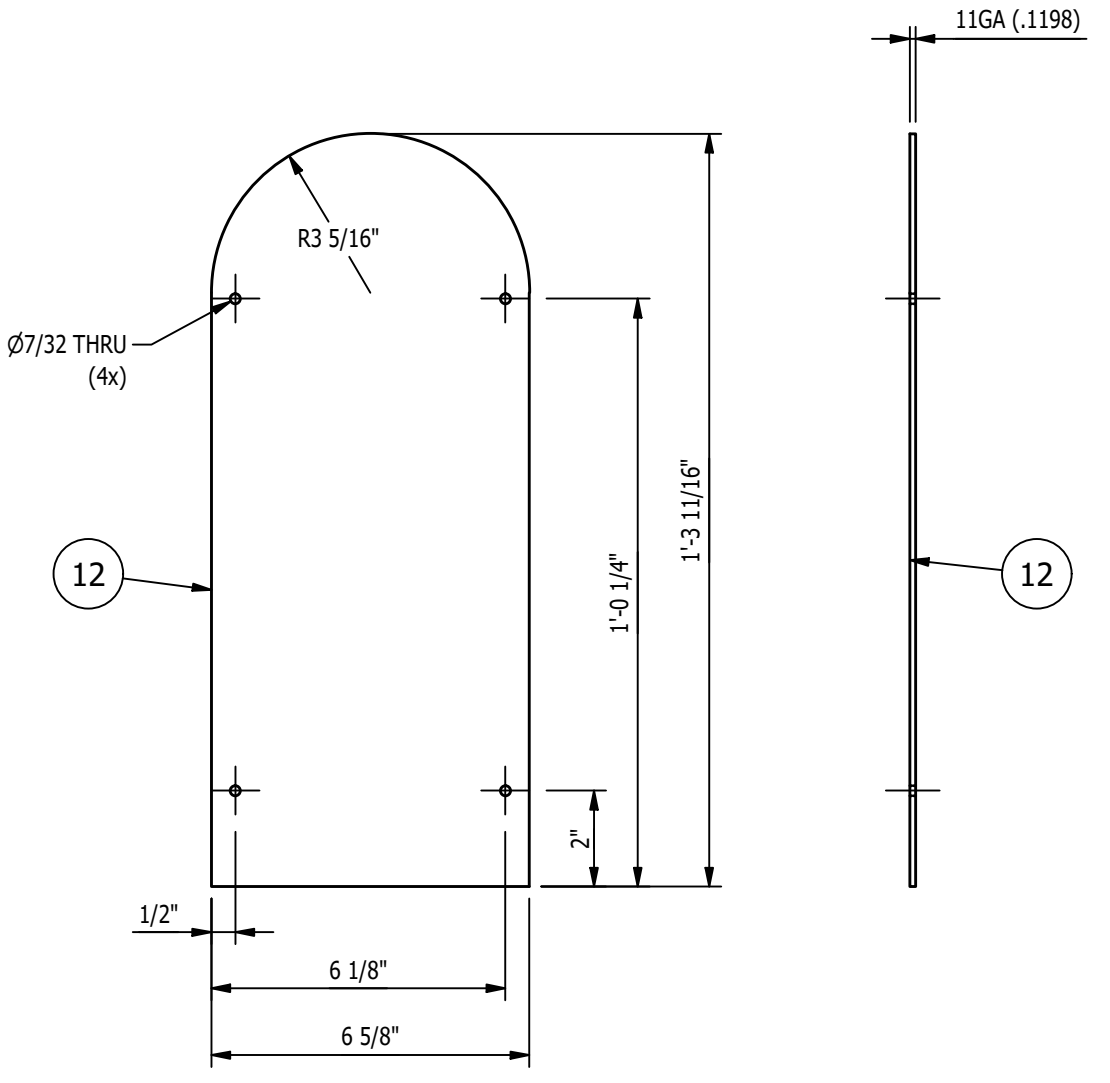
REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	ADDED ABM, CHANGED PAINT NOTES, & ADDED NOTE FOR LOOSE ITEMS, ADDED DETAILS FOR ITEMS '11' & '12'	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY

mi	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: RPM
CLIENT:	VOLVO	CHECKED BY: JCK
DRAWING No.	1875D329	DWG DATE: 7/12/22
REV:	B	JOB No: 22096

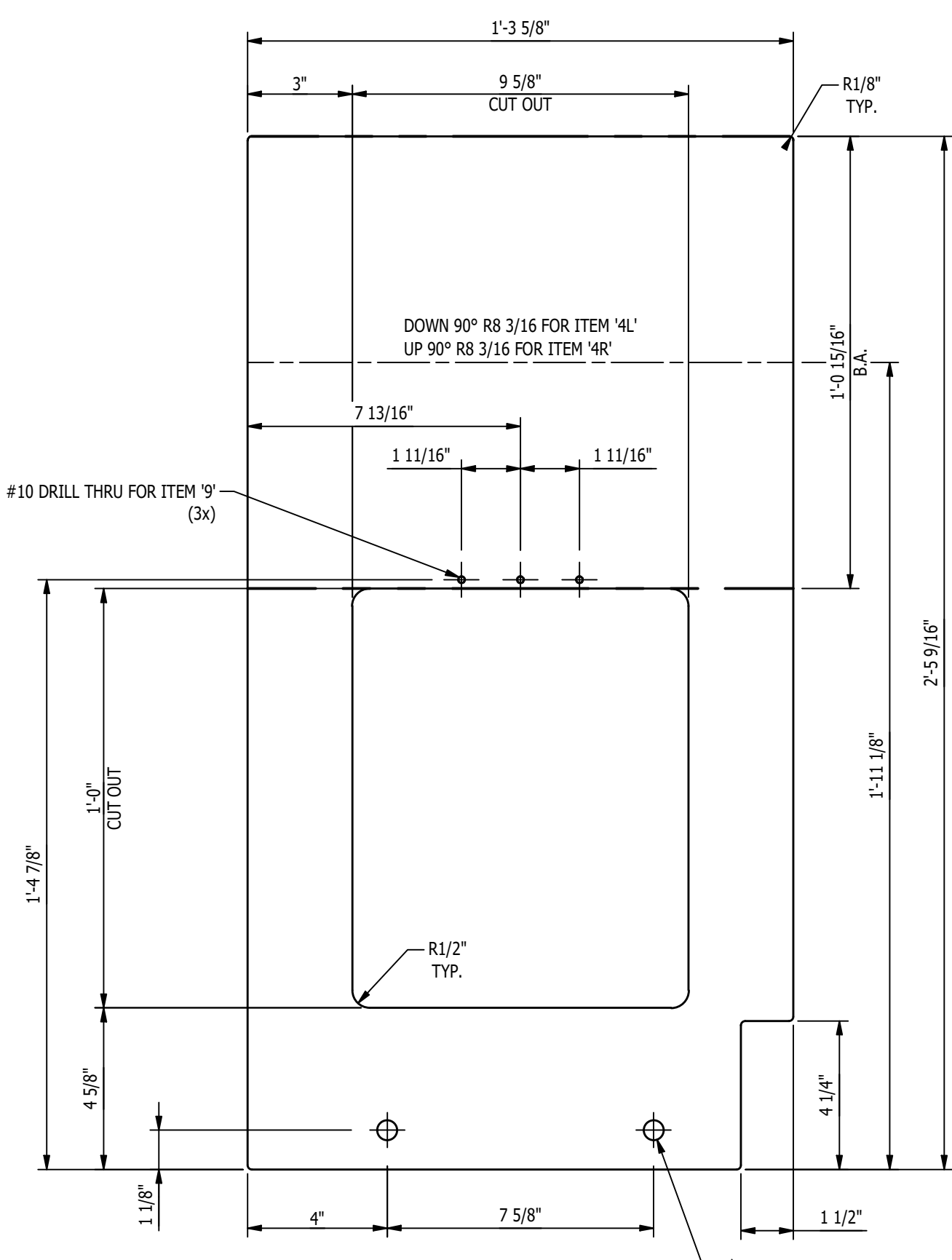


BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D330A			
1	2	L 1 1/2 x 1 1/2 x 1/4	1 1/2"		
2	2	SHT 11 GA x 8 3/16	2'- 13/16"		
3	2	SHT 11 GA x 8 3/16	1'-8 9/16"		
4L	1	SHT 16 GA x 1'-3 5/8	2'-5 9/16"		
4R	1	SHT 16 GA x 1'-3 5/8	2'-5 9/16"		
5	2	EXP MTL, 1/2-#13 x 13	10 5/8"		
6	2	NEILSEN HANDLE 1/2" PLATE STYLE, REID TOOL CO. #NSH-100		20-2	
7	1	1/2-13UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
8	4	1/2-13UNC x 1" LG. HEX HEAD CAP SCREW			
9	6	3/16" x 1/4" LG. POP RIVET			
10	5	1/2 SPRING LOCK WASHER			
11	1	1/2-13UNC HEX NUT			
		MK-D330B			
12	1	SHT 11 GA x 6 5/8	1'-3 11/16"		

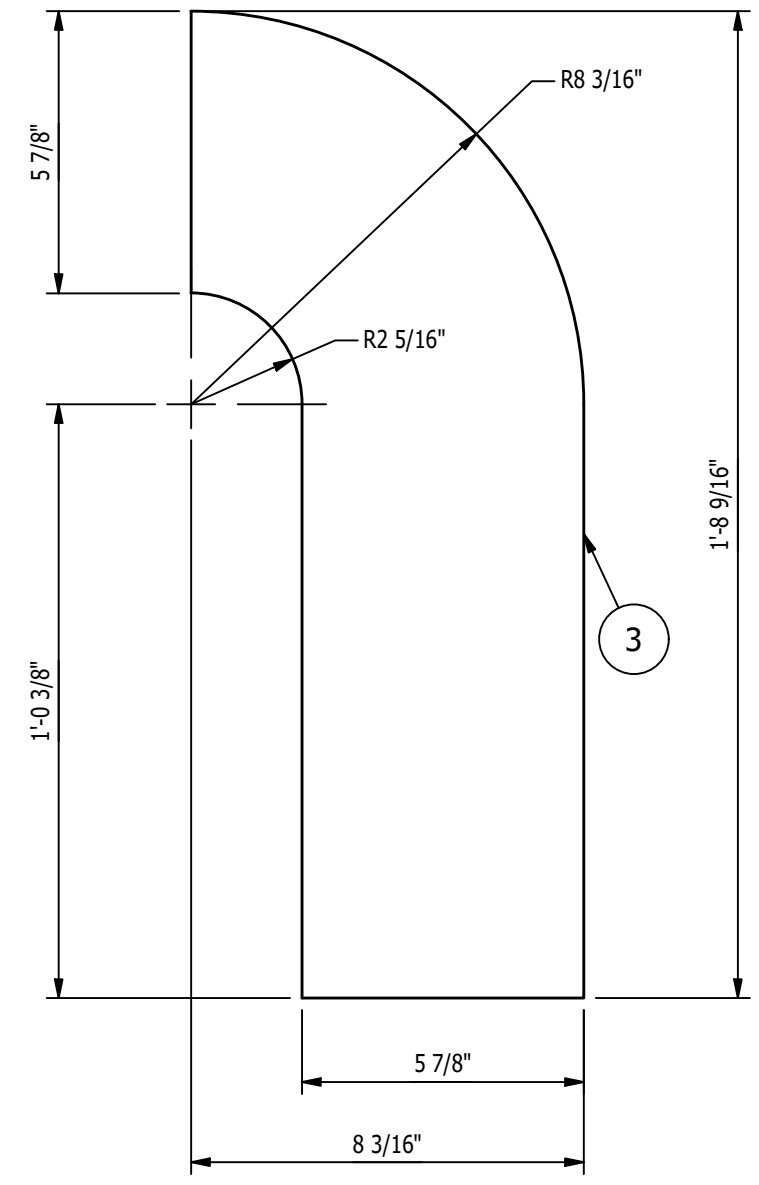


MK-D330A ~ COUPLING GUARD
SCALE 3"=1'-0"

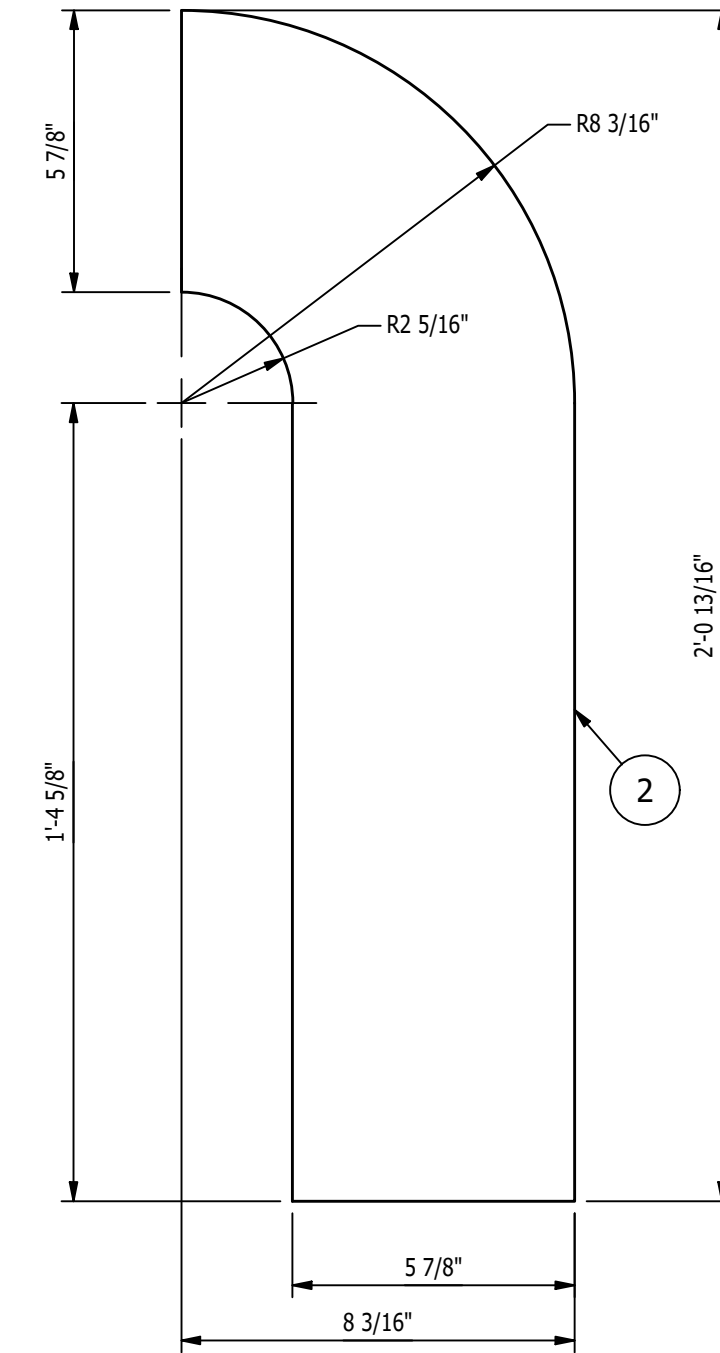
MK-D330B ~ SHAFT COVER
SCALE 3"=1'-0"



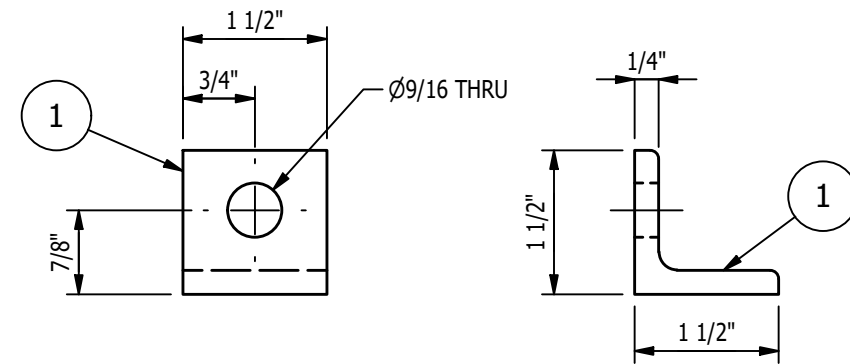
FLAT PATTERN OF 'ITEM 4L/4R'
SCALE 3"=1'-0"



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



DETAIL OF ITEM '2'
SCALE 3"=1'-0"



DETAIL OF ITEM '1'
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 ALL FABRICATED STEEL
 - ONE SHOP COAT OF SAFETY YELLOW RAL 1023
 - PAINT EXP MTL BLACK RAL 9005
 - DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	ADDED ABM # & LOCATION DIM	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

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

TITLE: P6700 CONVEYORS
CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No.: 1875D330

REV: B

JOB No.: 22096

DRAWN BY: RPM

CHECKED BY: JCK

DWG DATE: 7/12/22

MAGNUM CONSULTING

4100 Gardenbrook Rd.
Suite 125
West, MI 48375

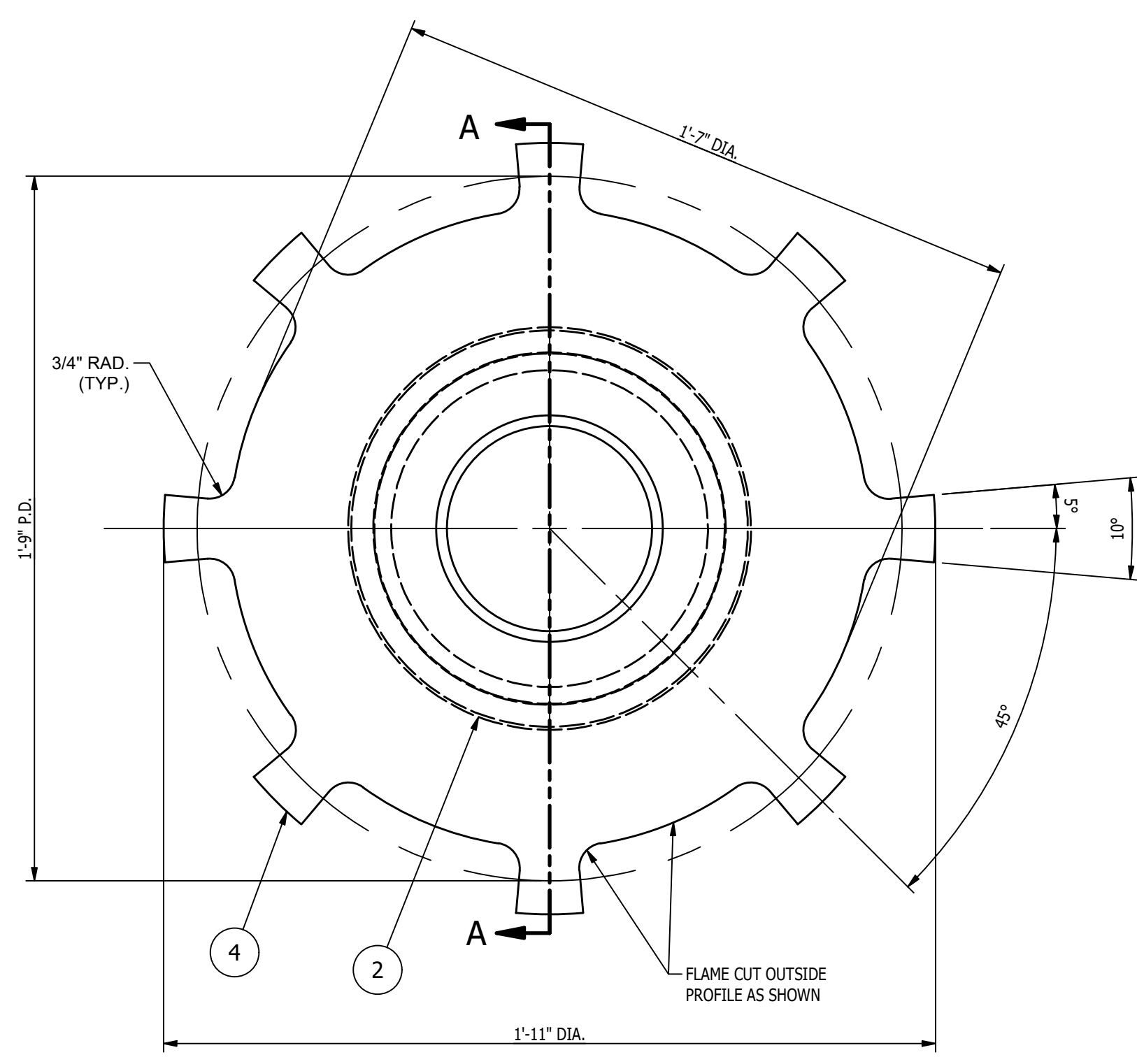
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875

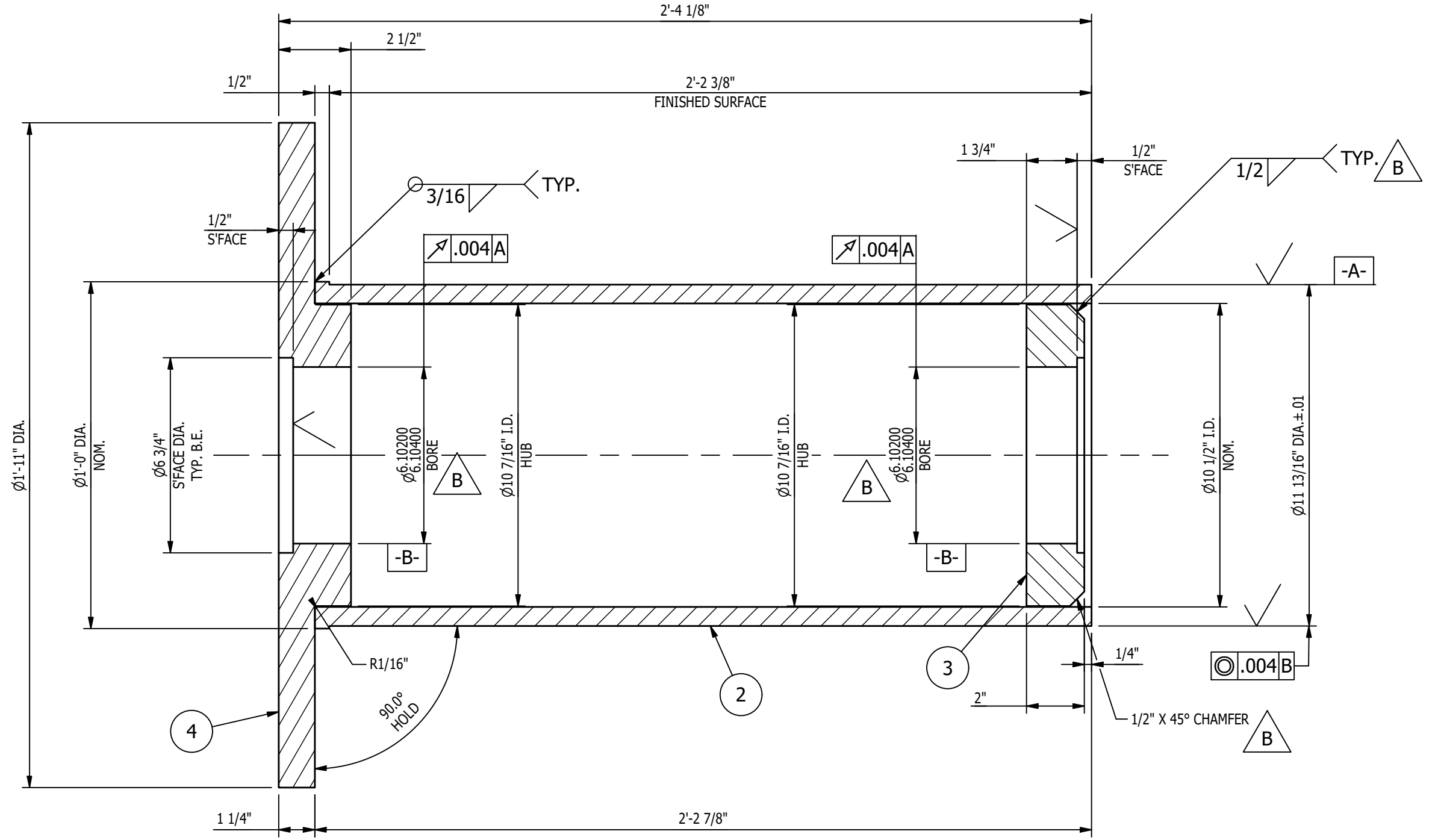
MAGNUM DRAWING #: 1875D330

UNLESS OTHERWISE NOTED:

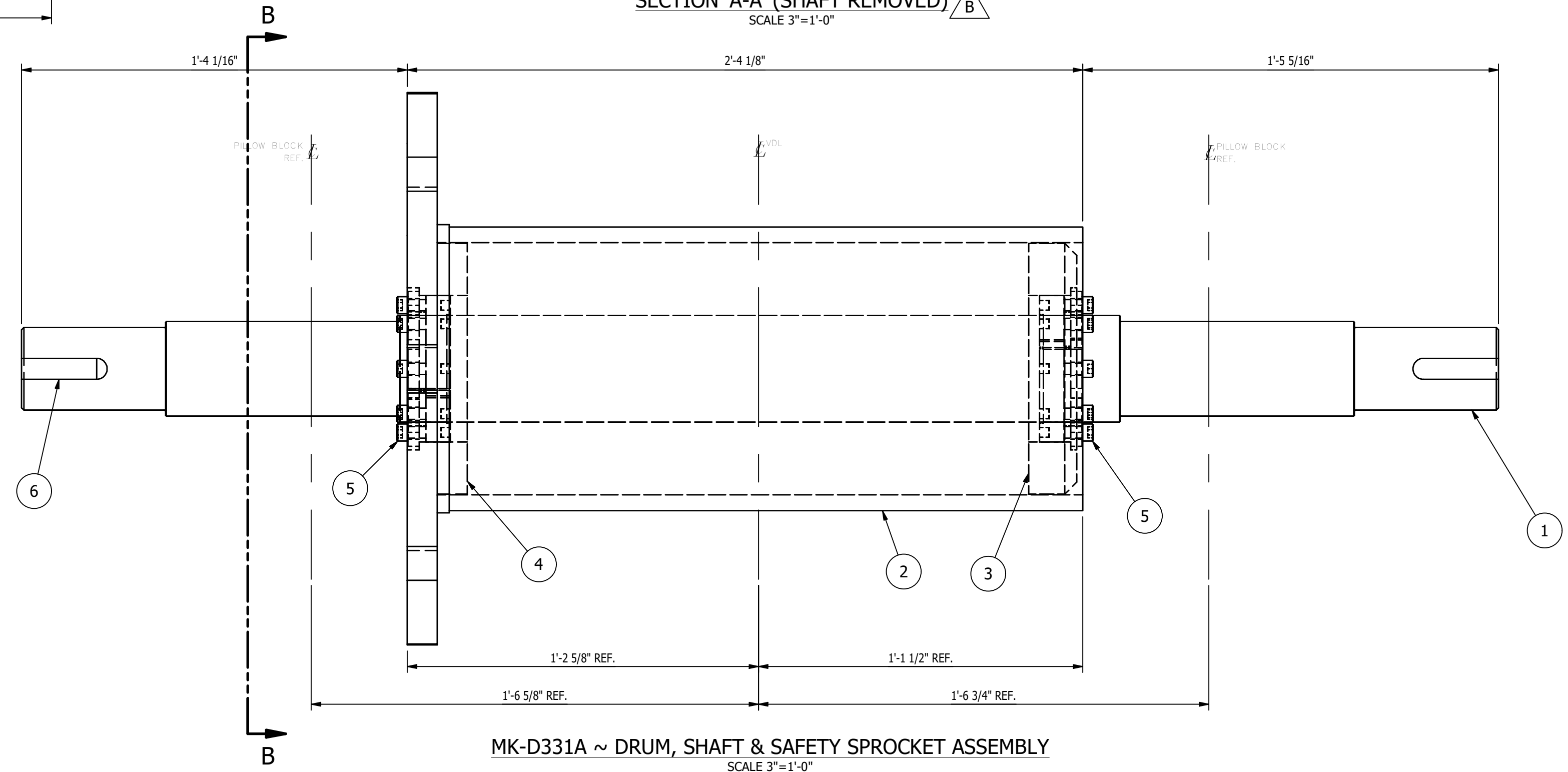
- X = ±.060
- XX = ±.030
- XXX = ±.005
- FRACTIONS = ±1/16"
- ANGLES = ±1°30'
- BREAK ALL SHARP EDGES
- DEBURR ALL HOLES
- DO NOT SCALE DRAWING



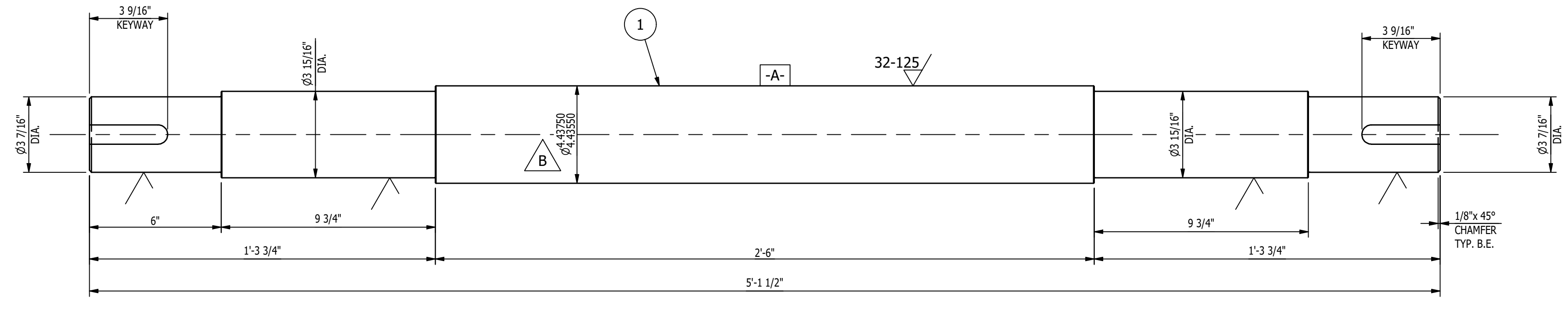
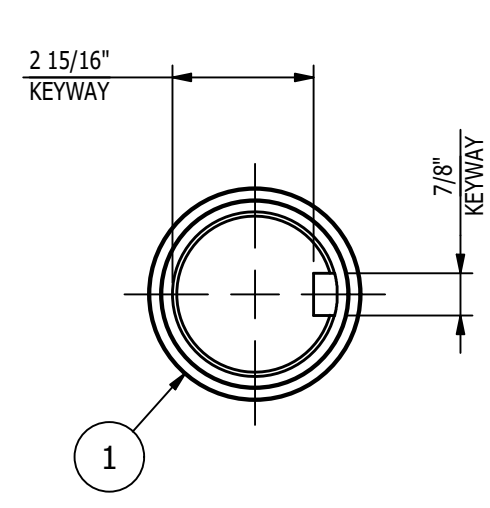
SECTION 'B-B' (SHAFT REMOVED)
SCALE 3"=1'-0"



SECTION 'A-A' (SHAFT REMOVED)
SCALE 3"=1'-0"



MK-D331A ~ DRUM, SHAFT & SAFETY SPROCKET ASSEMBLY
SCALE 3"=1'-0"



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D331A			
1	1	BAR Ø4 1/2 (1045)	5'-1 1/2"		
2	1	TS 12 OD x 0.75 WALL DOM	2'-2 7/8"		
3	1	PL 2 x 10 7/16"	10 7/16"		
4	1	PL 2 1/2 x 1'-11"	1'-11"		
5	2	B-LOC B106 SERIES KEYLESS BUSHING, 4 7/16" BORE, 6.102" HUB, 1.772" LENGTH THRU BORE, FENNER DRIVES PART NO. B602407		7-4	
6	1	7/8 x 7/8 KEYSTOCK	3 1/8"		

- B-LOC INSTALLATION:**
- DO NOT USE MOLYBDENUM DISULFIDE (ANTI-SEIZE) ON SCREWS.
 - 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.
 - 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).
 - AFTER INSERTING KEYLESS BUSHING INTO HUB BORE, RELOCATE LOCKING SCREWS USED FOR SEPARATING PARTS 1 AND 2.
 - 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.
 - USE TORQUE WRENCH AND SET IT APPROXIMATELY 5% HIGHER THAN THE 135 FT LBS TIGHTENING TORQUE REQUIRED. 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.
 - 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.
 - RESET TORQUE WRENCH TO SPECIFIED TORQUE (MA) AND CHECK ALL LOCKING SCREWS. NO SCREW SHOULD TURN AT THIS POINT, OTHERWISE REPEAT STEPS 6 AND 7.

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

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

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/30/22	ADDED LINE 9 TO SHOP NOTES	
B	MC	8/19/2022	ADDED B-LOC INSTALL, OTHER NOTES, CORRECTED TOLERANCES	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: RPM	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		CHECKED BY: JCK	
CLIENT: VOLVO		DWG DATE: 7/18/22	
DRAWING No. 1875D331		JOB No. 22096	
REV: C			

MAGNUM CONSULTING
41100 Charleston Rd
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North, MI 48175
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D331

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

GENERAL NOTES:

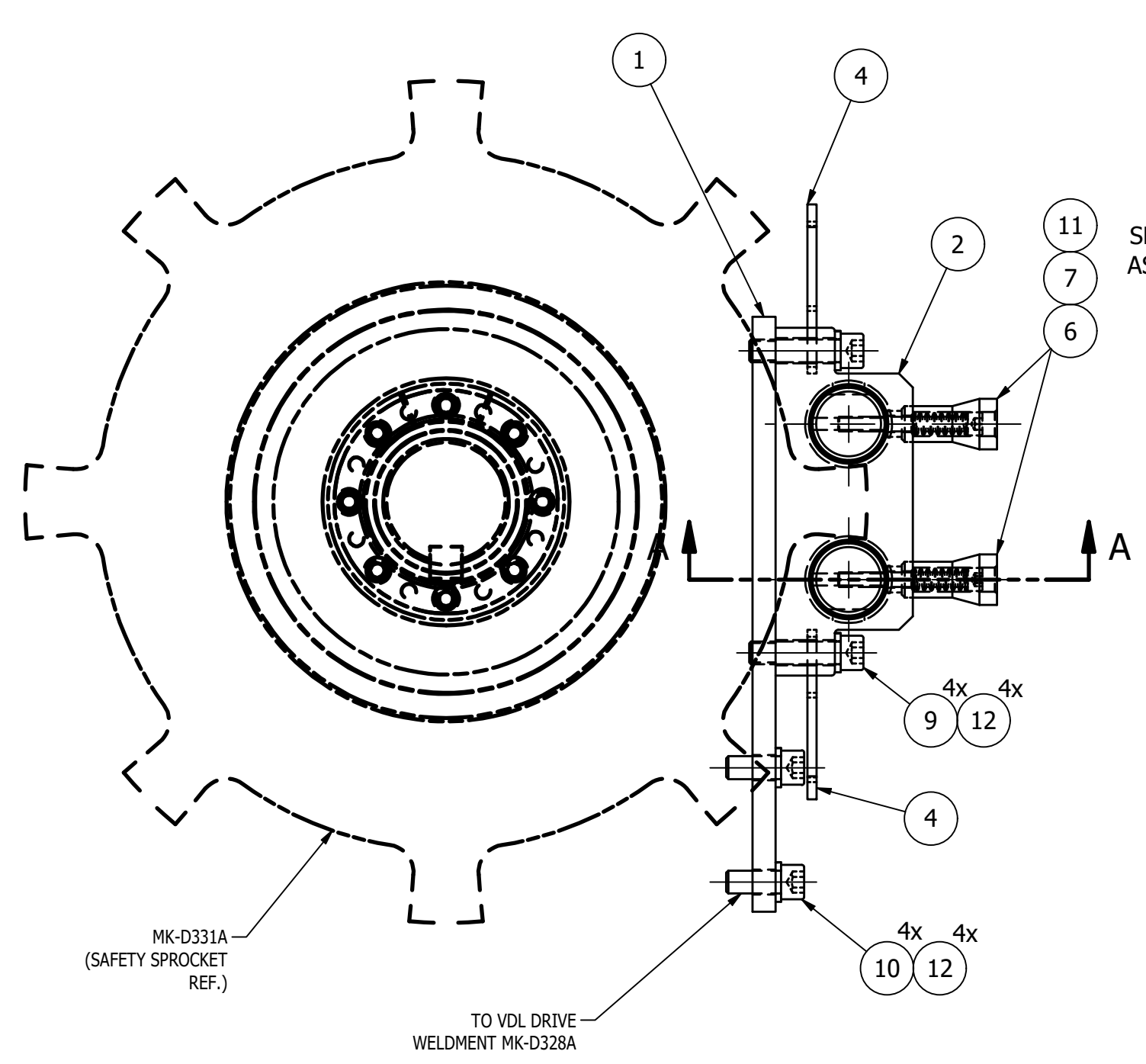
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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

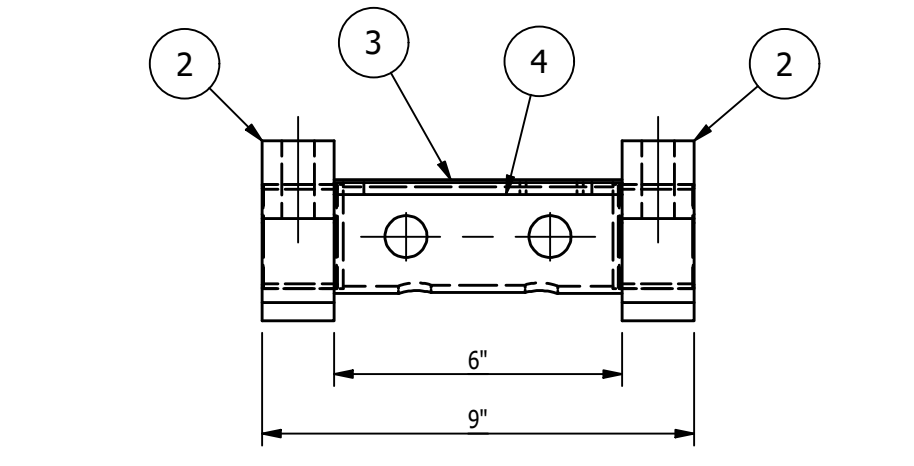
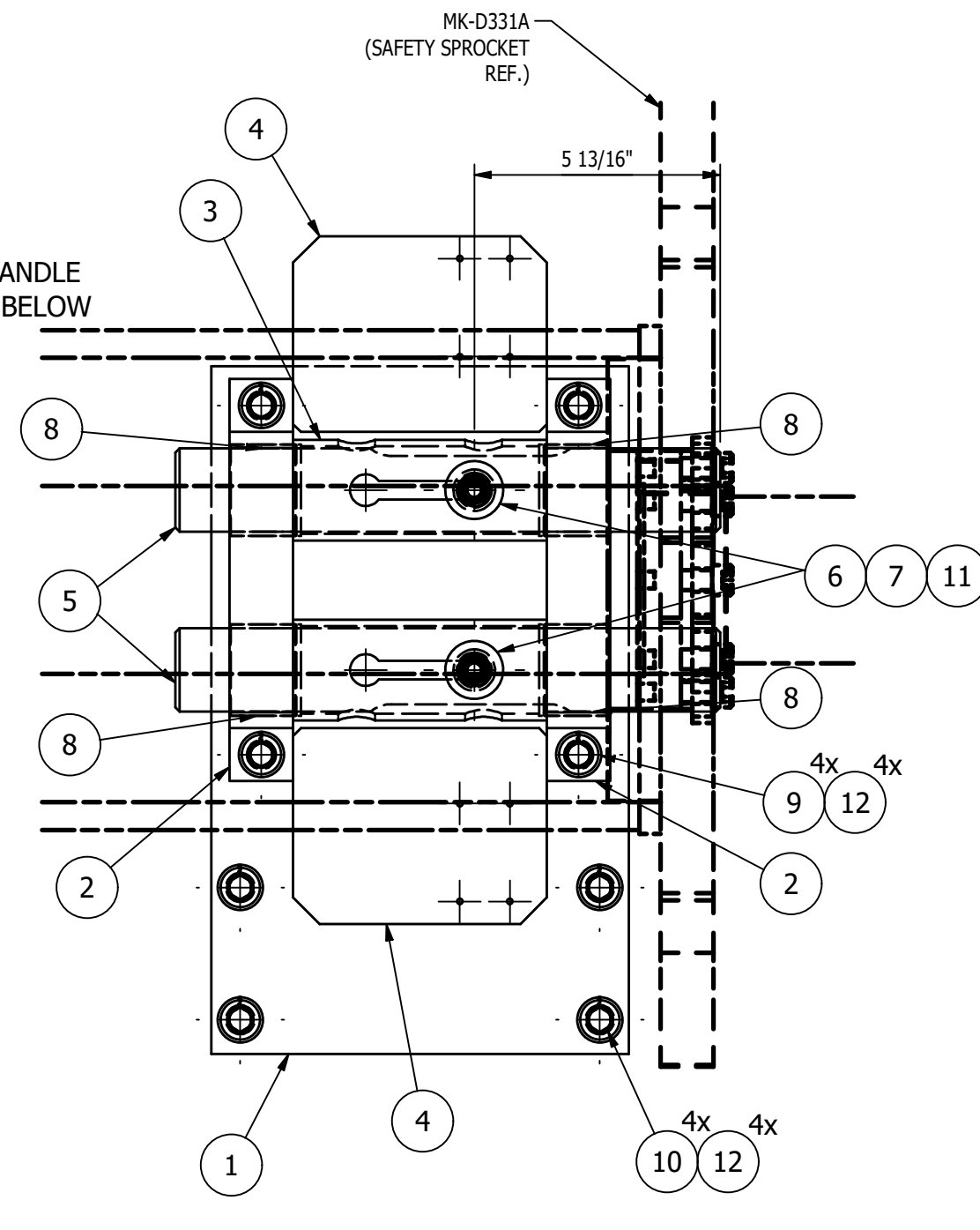
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

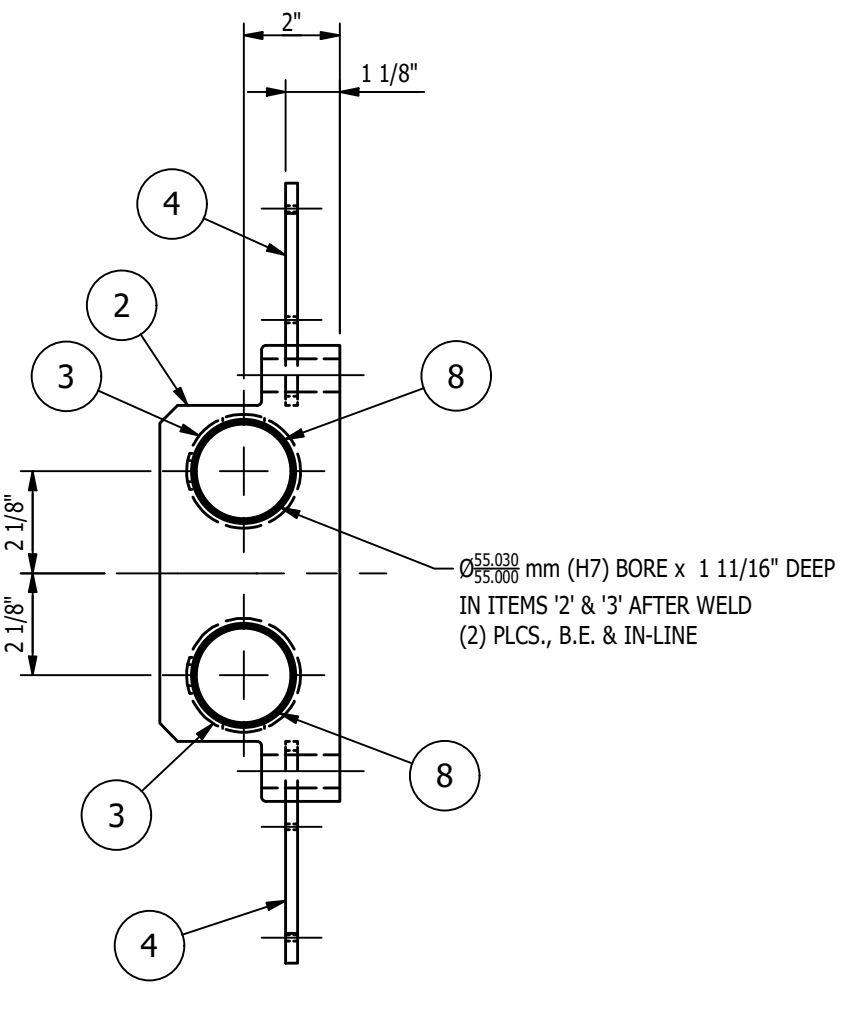
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



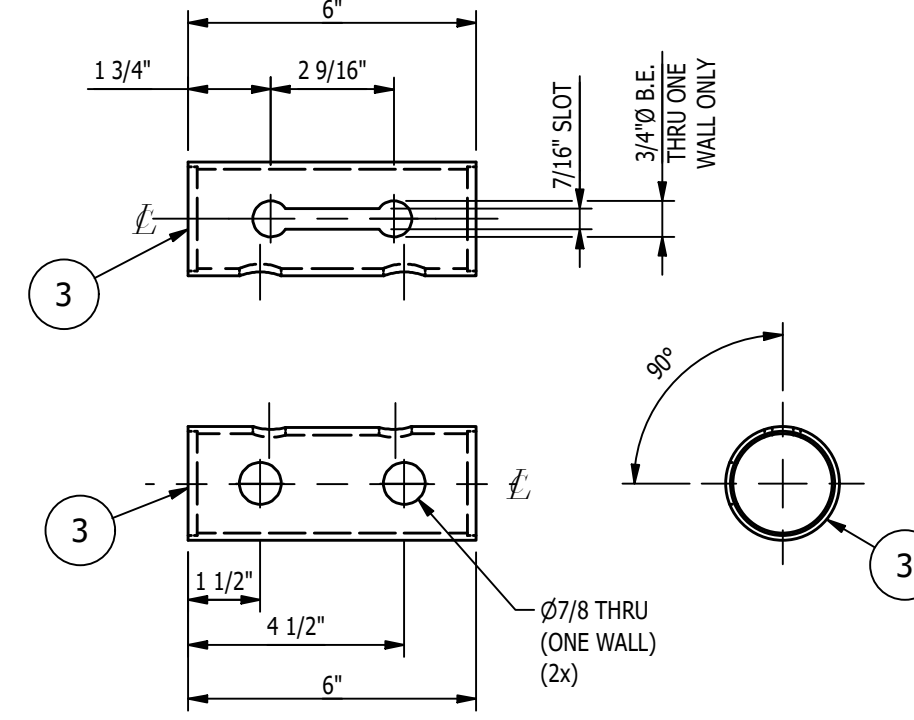
MK-D332A ~ SPROCKET LOCK-OUT PIN ASSEMBLY
SCALE 3"=1'-0"



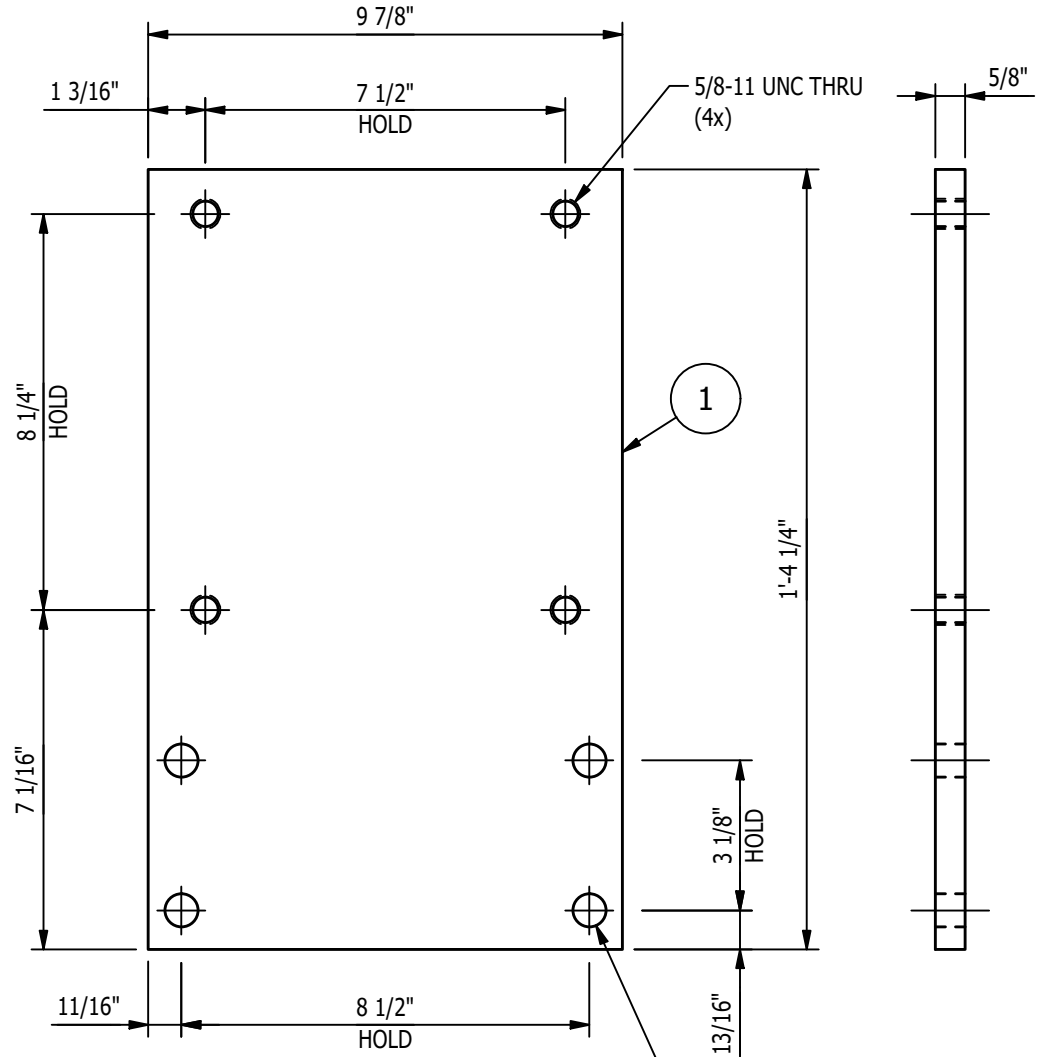
WELDMENT DETAIL OF ITEMS '2', '3' & '4'
SCALE 3"=1'-0"



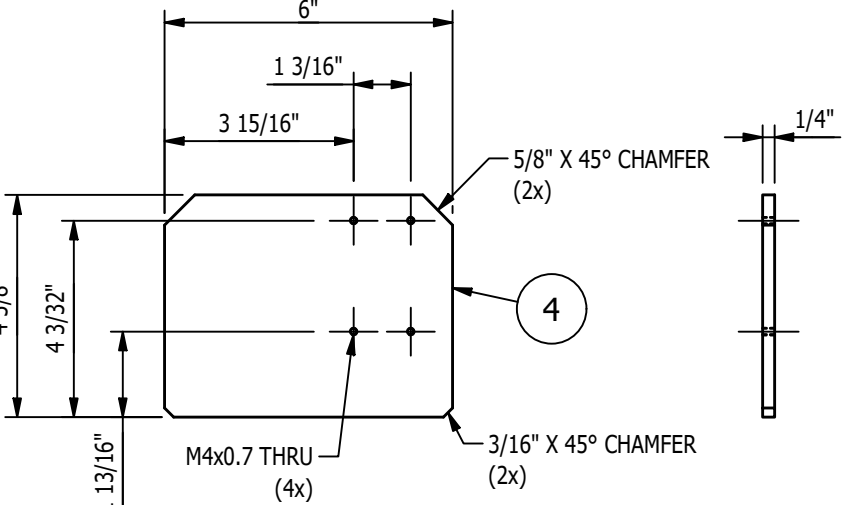
DETAIL OF ITEM '2'
SCALE 3"=1'-0"



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



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

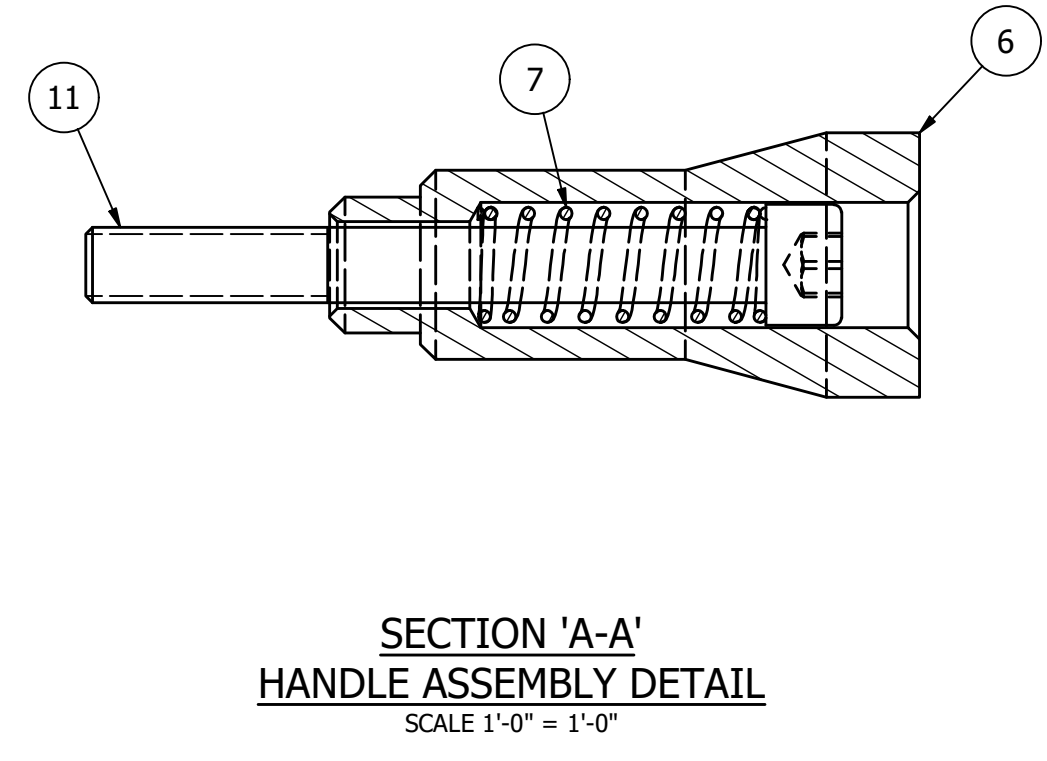


DETAIL OF ITEM '4'
SCALE 3"=1'-0"

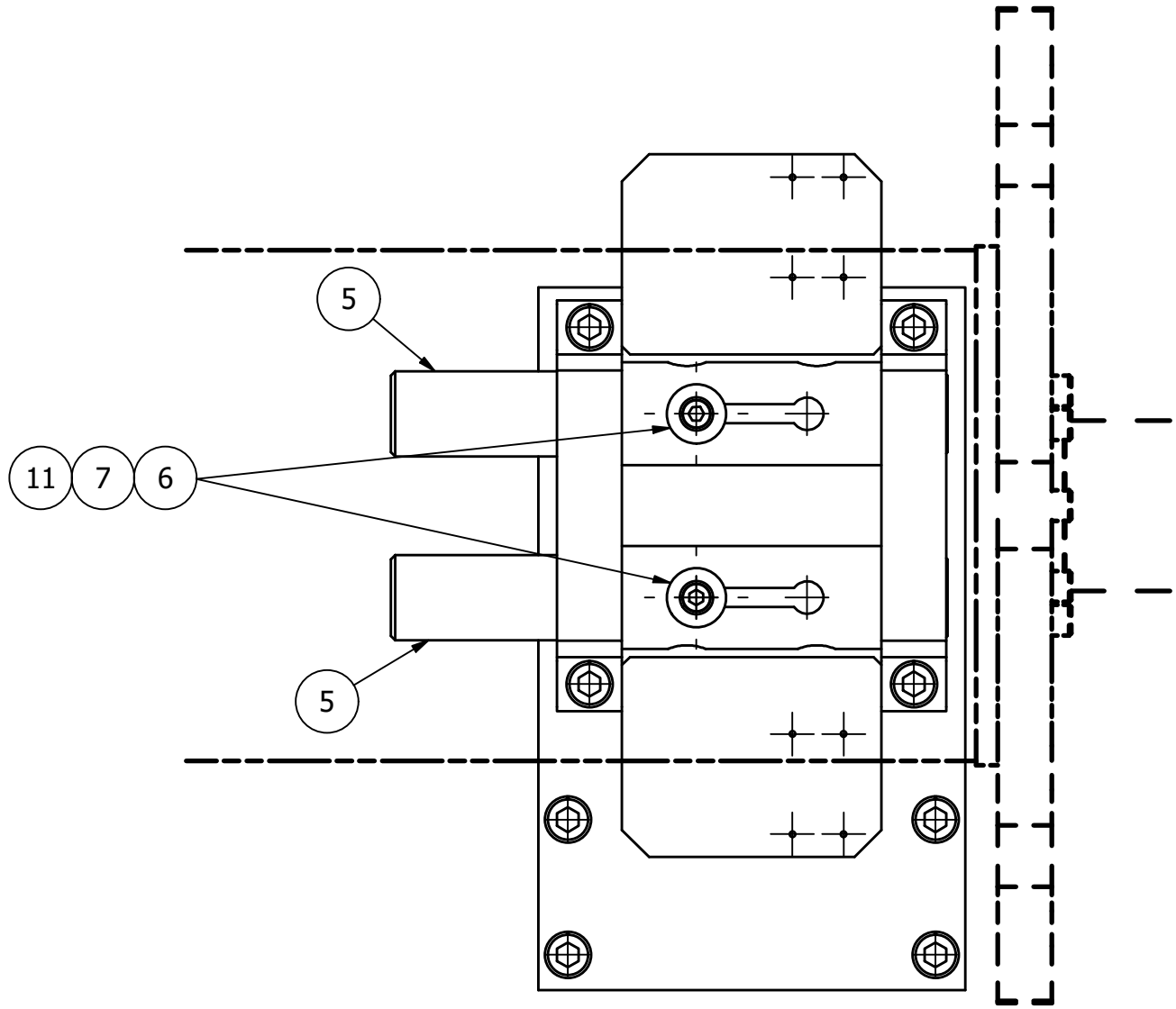
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D332A			
1	1	PL 5/8 x 9 7/8"	1'-4 1/4"		
2	2	PL 1 1/2 x 3 3/4"	9 1/2"		
3	2	PIPE 2 SCH. 40	6"		
4	2	BAR 1/4 x 6	4 5/8"		
5	2	MK-D333A ~ VDL PIN DETAIL			
6	2	MK-D334A ~ HANDLE DETAIL	3 1/16"		
7	2	COMPRESSION SPRING, 0.6" O.D. x 0.474 I.D. x 1.5" LG, McMASTER-CARR #9434K153 OR EQUIV.		20-4	
8	4	BRONZE BUSHING, 50mm I.D. x 55mm O.D. x 40mm LG., NOMO #5040-DUB-GGB OR EQUIV.		7-22	
9	4	5/8-11UNC x 2 1/2" LG. HEX SOCKET HEAD CAP SCREW			
10	4	5/8-11UNC x 1 1/2" LG. HEX SOCKET HEAD CAP SCREW			
11	2	M10x1.5 x 90mm LG. HEX SOCKET HEAD CAP SCREW			
12	8	5/8 SPRING LOCK WASHER			

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

PAINT NOTES:
 PAINT ALL FABRICATED STEEL
 ONE SHOP COAT OF SAFETY YELLOW RAL 1023
 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.



SECTION 'A-A' HANDLE ASSEMBLY DETAIL
SCALE 1'-0" = 1'-0"



VIEW WITH PINS RETRACTED
SCALE 3"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/7/2022	REPLACED ABM #20-5 W/#7-22	
B	MC	8/19/2022	ADDED ABM #S	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY

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

TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D332

REV: C

JOB No. 22096

DRAWN BY: RPM

CHECKED BY: JCK

DWG DATE: 7/8/22

MAGNUM CONSULTING
 41100 Charleston Rd.
 Suite 125
 Noris, MI 48275

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

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D332

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.

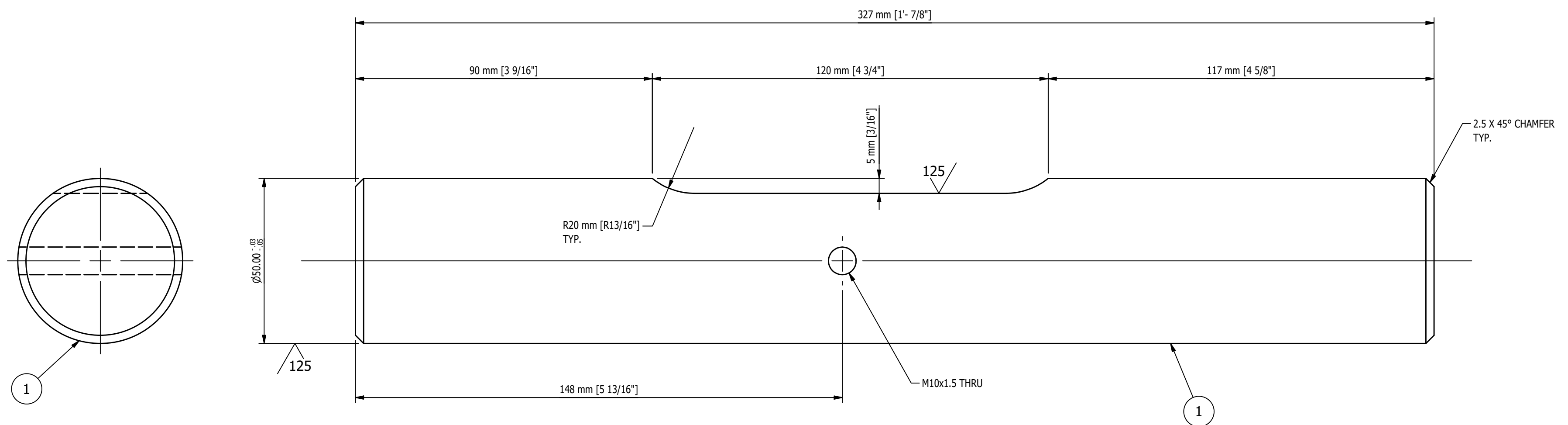
HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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-D333A			
1	1	BAR 2" (1045)	1'- 7/8"		
	1	TOTAL WEIGHT			




MK-D333A ~ PIN DETAIL
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.

REV	BY	DATE	DESCRIPTION	APP
A	MC	8-8-2022	FOR FABRICATION	

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

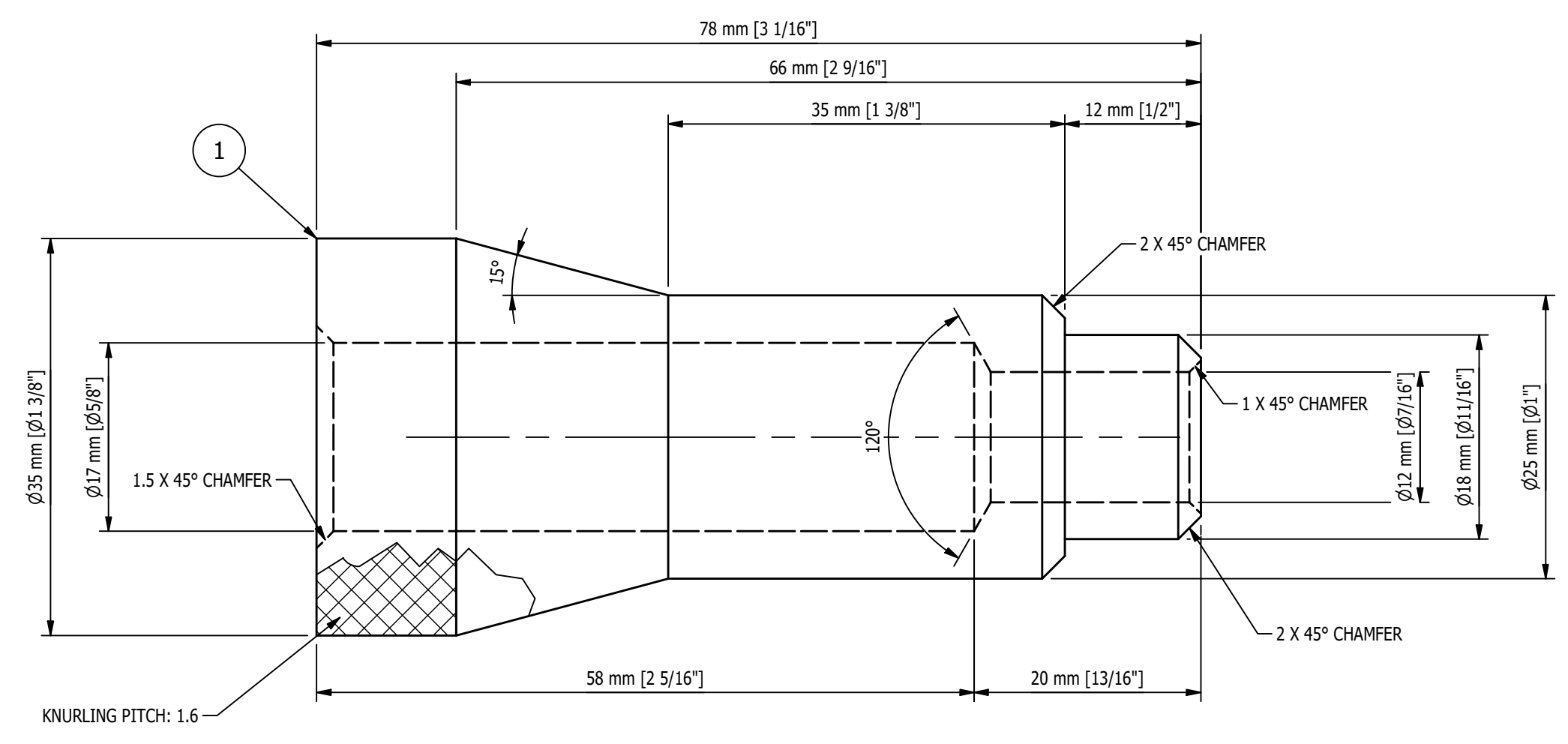
TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RPM
CLIENT: VOLVO	CHECKED BY: JCK
DRAWING No. 1875D333	DWG DATE: 7/11/22
REV: A	JOB No: 22096

	
41100 Charleston Rd. Suite 125 Novi, MI 48275	Phone: (248) 373-8833 Fax: (248) 373-8851 Web: www.mmagnum.com
MAGNUM JOB #: 1875	
MAGNUM DRAWING #: 1875D333	

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-D334A			
1	1	BAR 35mm DIA. (SS400)	3 1/16"		



MK-D334A ~ HANDLE DETAIL
SCALE 2:1

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	8-8-2022	FOR FABRICATION	

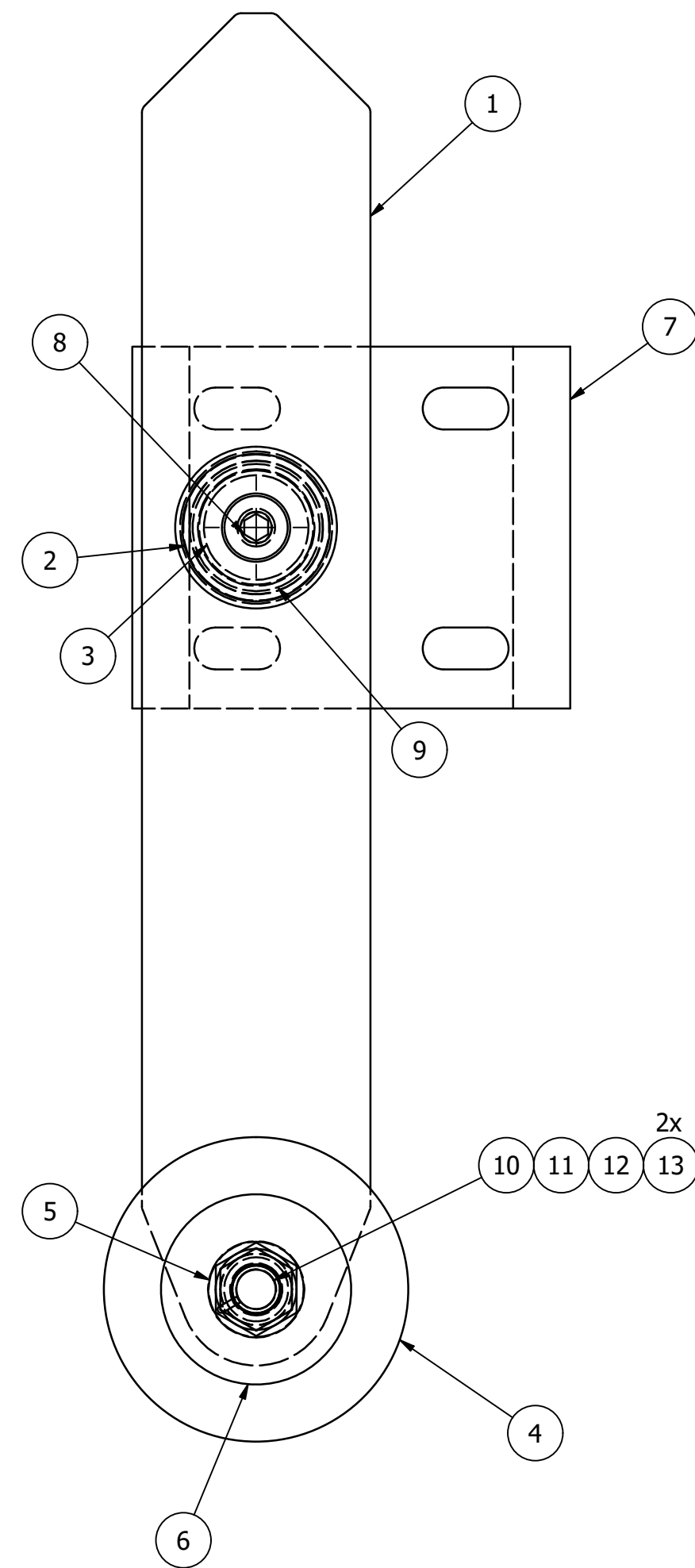
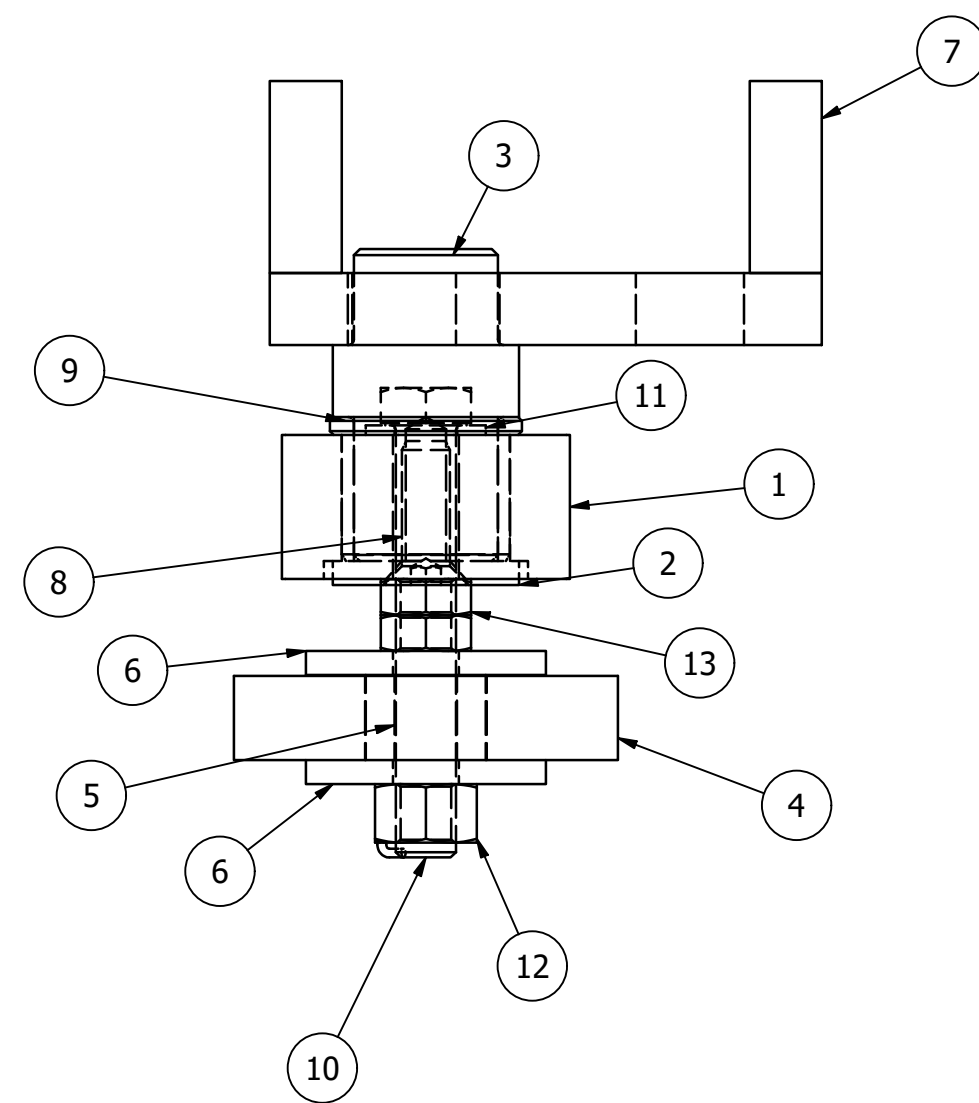
	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	<small>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</small>
	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D334	DRAWN BY: RPM CHECKED BY: JCK DWG DATE: 7/11/22 JOB No: 22096

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

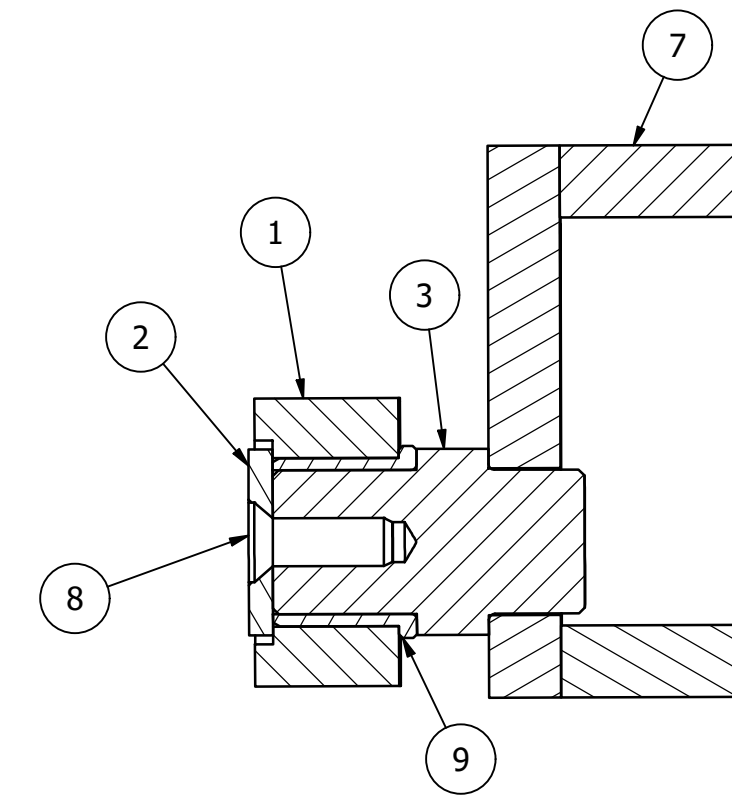
MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D334

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

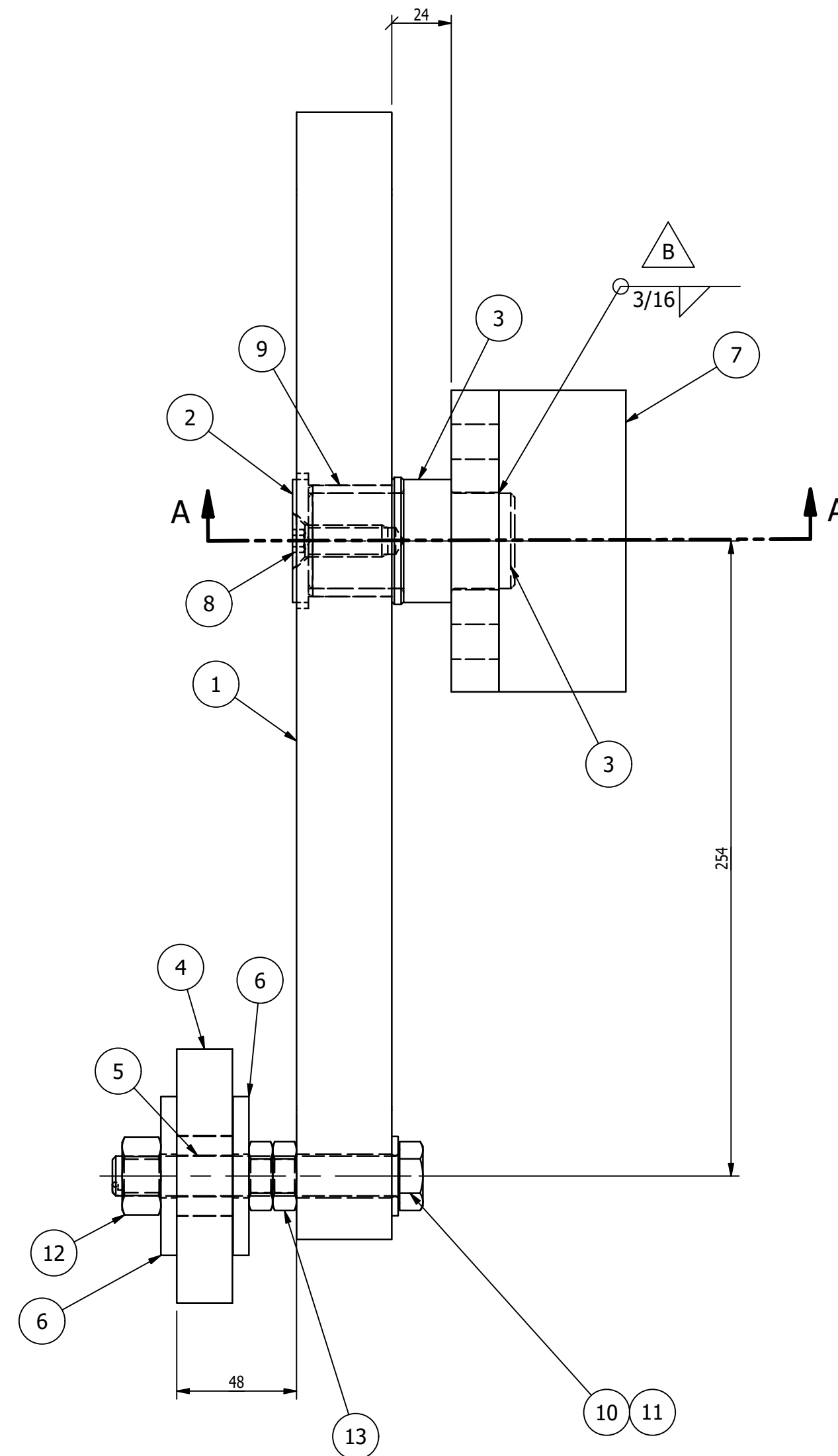
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO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



MK-D335A ~ GRAVITY STOP ASSEMBLY - RH (SHOWN)
 MK-D335B ~ GRAVITY STOP ASSEMBLY (OPPOSITE)
 SCALE 6"=1'-0"



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



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D335A			
1	1	MK-D055A ~ GRAVITY STOP ARM			
2	1	MK-D056A ~ KEEPER PLATE			
3	1	MK-D056B ~ PIVOT SHAFT DETAIL			
4	1	MK-D056C ~ PIVOT WHEEL			
5	1	MK-D056D ~ PIVOT SHAFT			
6	2	MK-D056E ~ WHEEL PLATE			
7	1	MK-D336A ~ GRAVITY STOP WELDMENT			
8	1	1/2-13UNC x 1 1/2" LG. FLAT HEX SOCKET HEAD CAP SCREW			
9	1	BRONZE FLANGED BEARING, 1 3/4 OD x 1 3/4 ID x 1 1/2 LG, BUNTING PART NO. EBCF242812		6-8	
10	1	5/8-11UNC x 4 1/2" LG. HEX HEAD CAP SCREW			
11	1	5/8 TYPE B NARROW FLAT WASHER			
12	1	5/8-11UNC ANCO LOCK NUT A194 GR. 2H			
13	2	5/8-11UNC HEX JAM NUT			
		MK-D335B			
1	1	MK-D055A ~ GRAVITY STOP ARM			
2	1	MK-D056A ~ KEEPER PLATE			
3	1	MK-D056B ~ PIVOT SHAFT DETAIL			
4	1	MK-D056C ~ PIVOT WHEEL			
5	1	MK-D056D ~ PIVOT SHAFT			
6	2	MK-D056E ~ WHEEL PLATE			
7	1	MK-D336A ~ GRAVITY STOP WELDMENT			
8	1	1/2-13UNC x 1 1/2" LG. FLAT HEX SOCKET HEAD CAP SCREW			
9	1	BRONZE FLANGED BEARING, 1 3/4 OD x 1 3/4 ID x 1 1/2 LG, BUNTING PART NO. EBCF242812		6-8	
10	1	5/8-11UNC x 4 1/2" LG. HEX HEAD CAP SCREW			
11	1	5/8 TYPE B NARROW FLAT WASHER			
12	1	5/8-11UNC ANCO LOCK NUT A194 GR. 2H			
13	2	5/8-11UNC HEX JAM NUT			

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	ADDED WELD NOTE	
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY	
B	MC 10/10/22 ADDED WELD NOTE
A	MC 9/16/22 FOR FABRICATION

MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D335	DWG DATE:	6/7/22
		REV:	B
		JOB No:	22096

MAGNUM Consulting
 41100 Dardickwood Rd. Suite 125 West, MI 48375
 Phone: (248) 772-8822 Fax: (248) 772-8851 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D335 - REV B

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

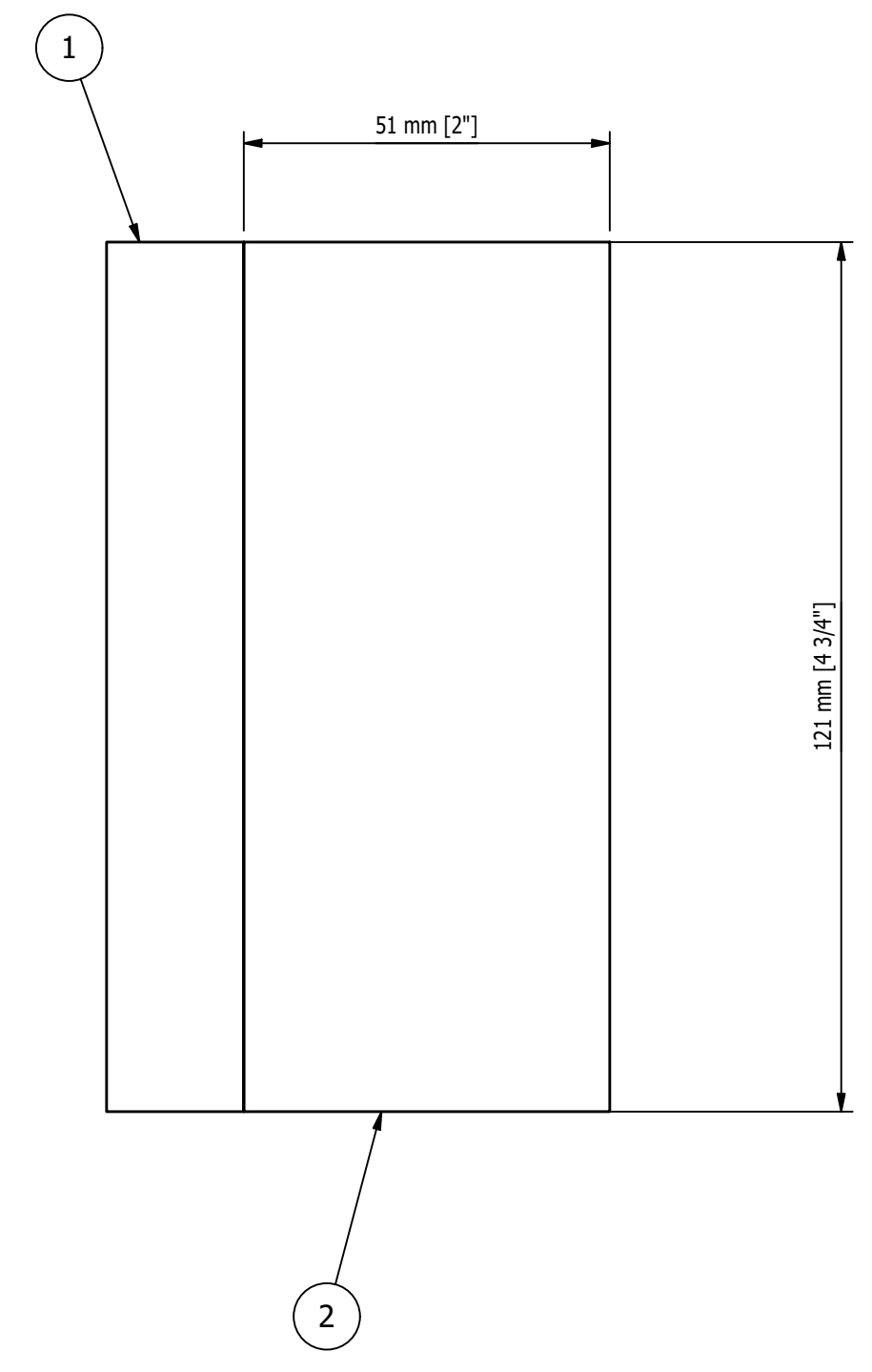
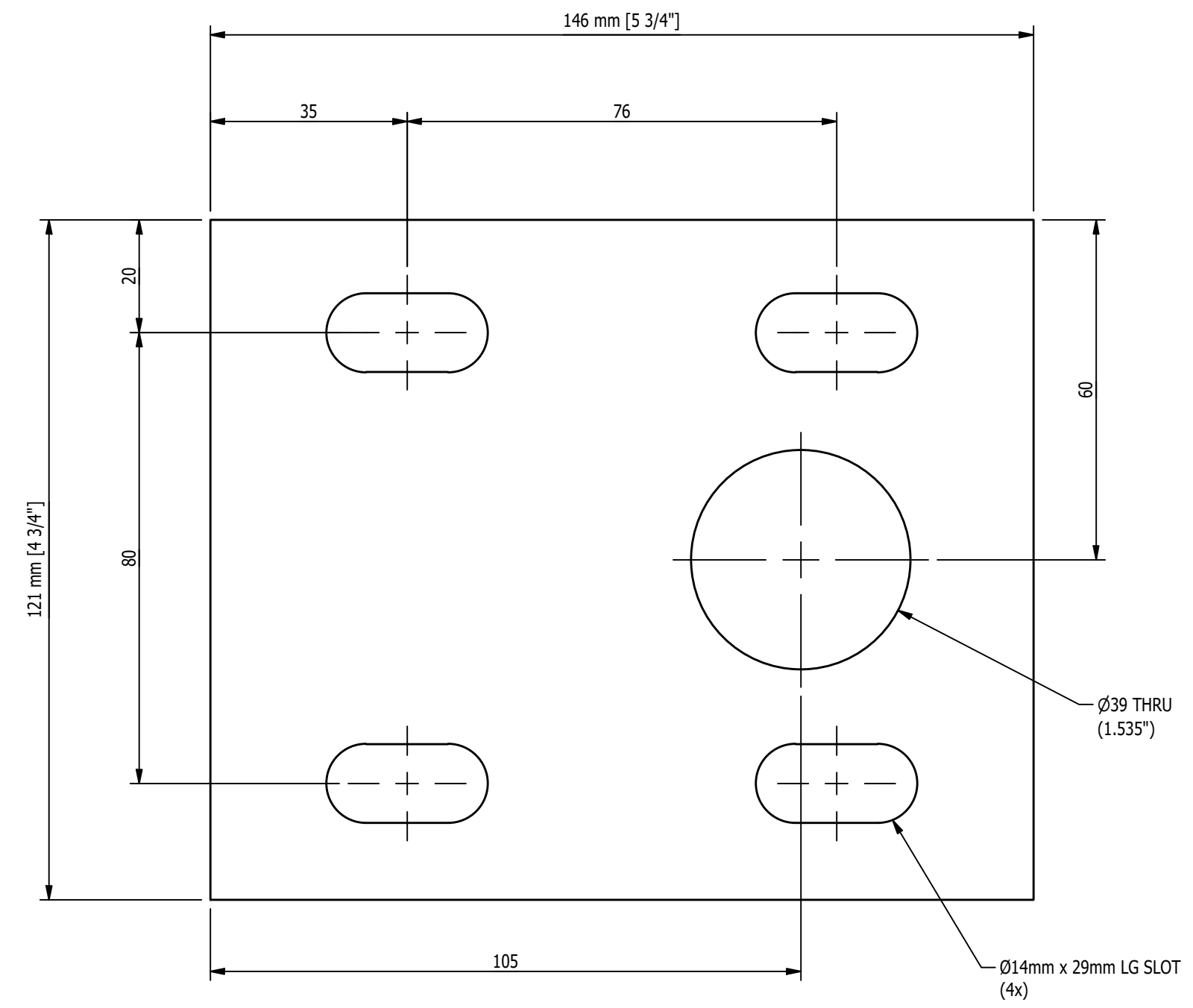
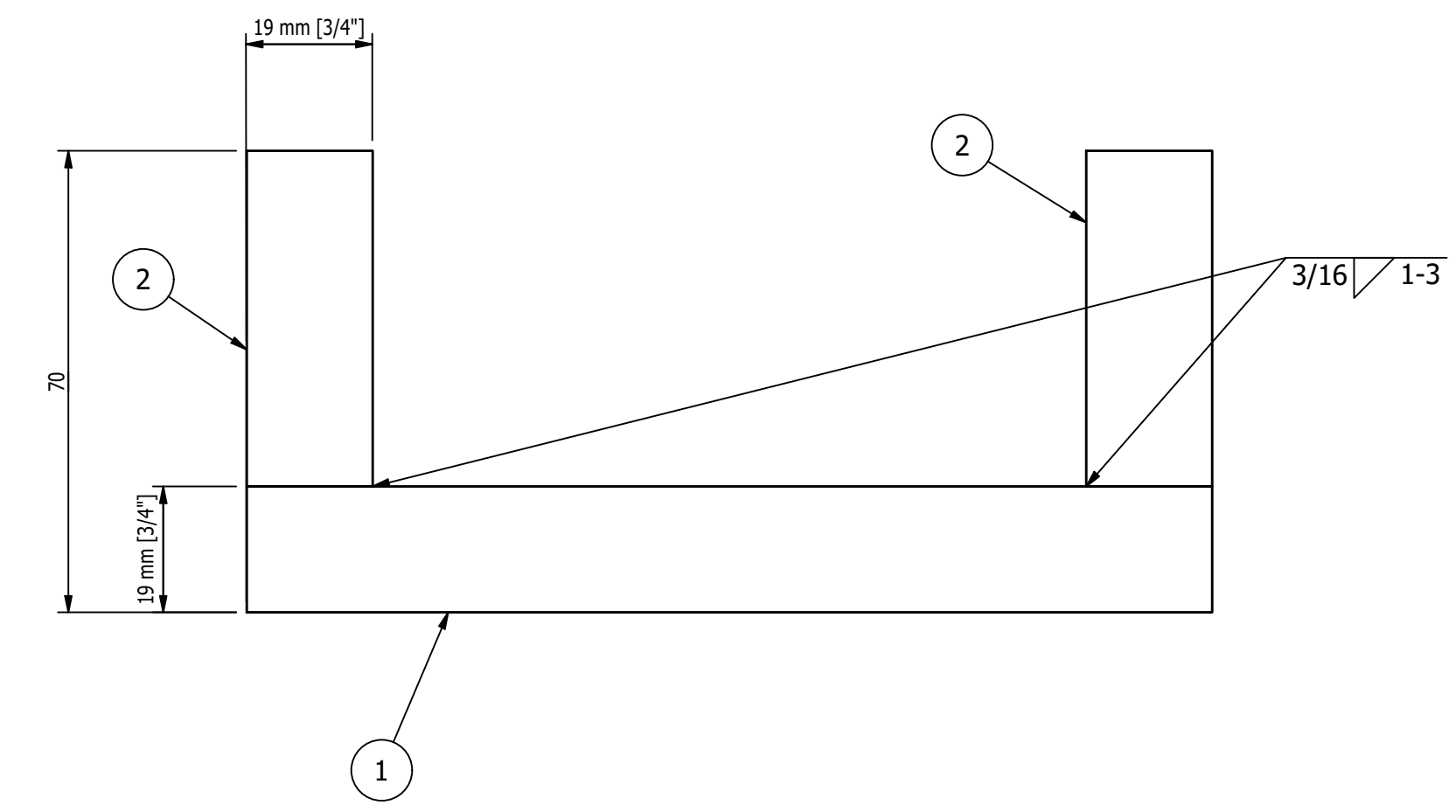
PAINT:

- 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-D336A			
1	1	BAR 3/4 x 5 3/4	4 3/4"		
2	2	BAR 3/4 x 2	4 3/4"		



MK-D336A ~ GRAVITY STOP WELDMENT
SCALE 1'-0" = 1'-0"

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

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/11/22	FOR FABRICATION	

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

CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D336	DWG DATE: 8/11/22
REV: A	JOB No: 22096

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

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D336

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:

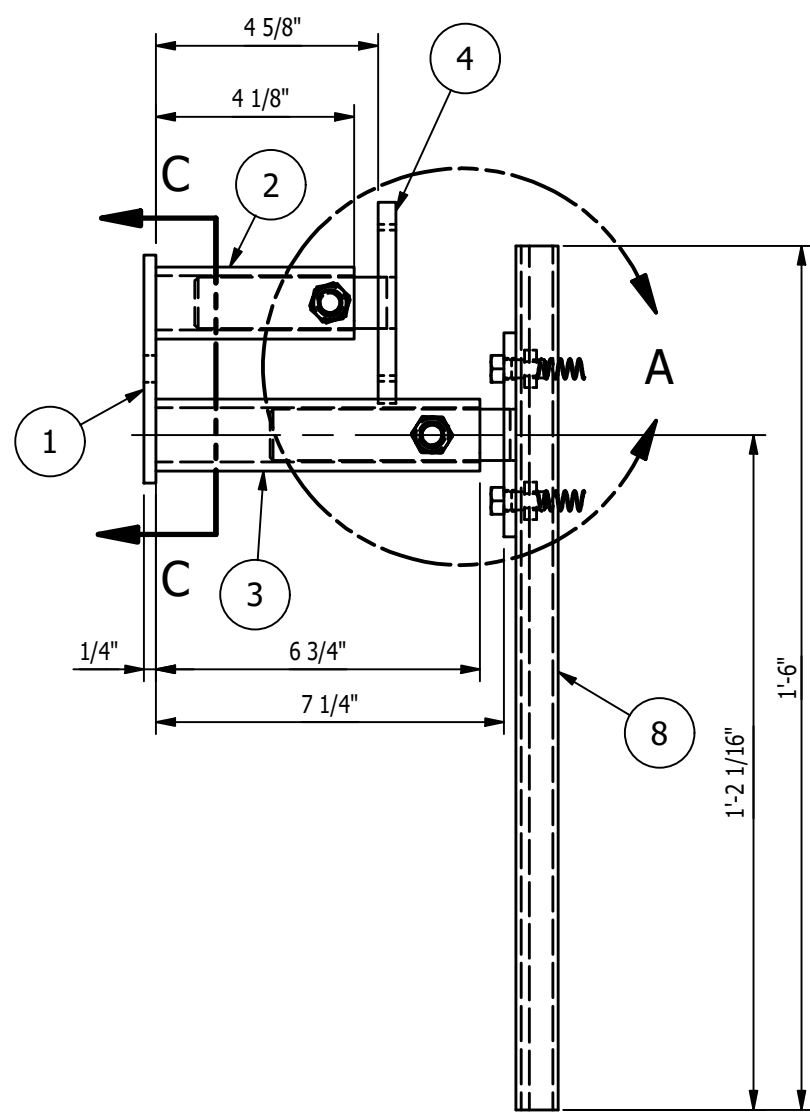
MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

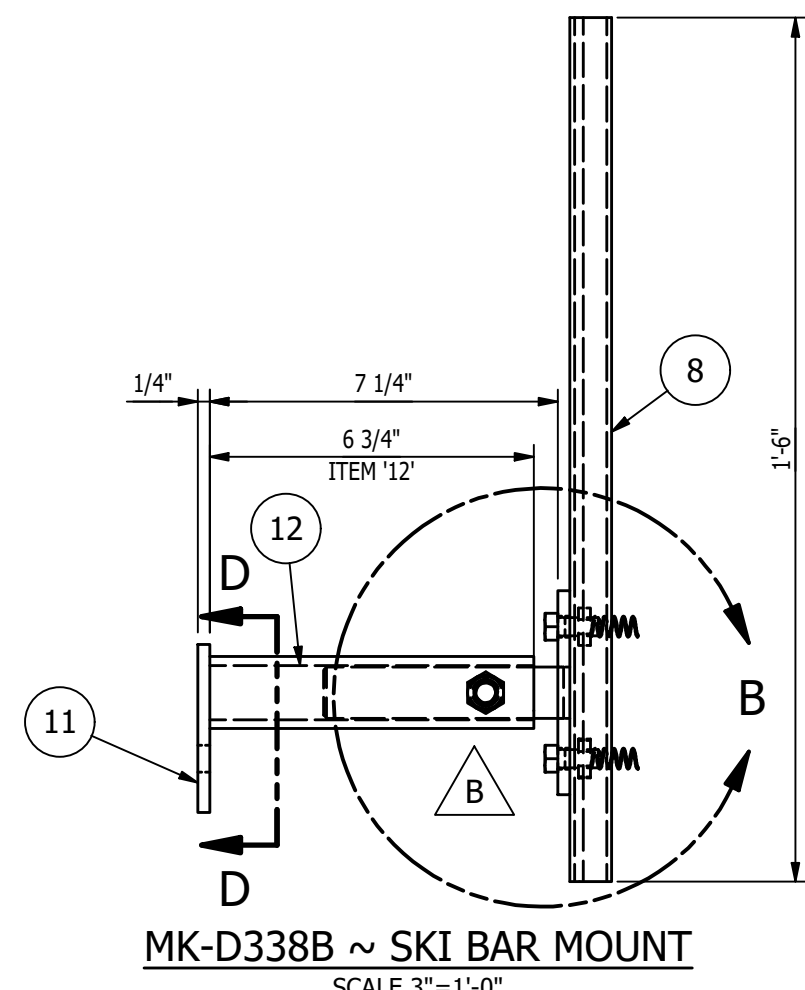
WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

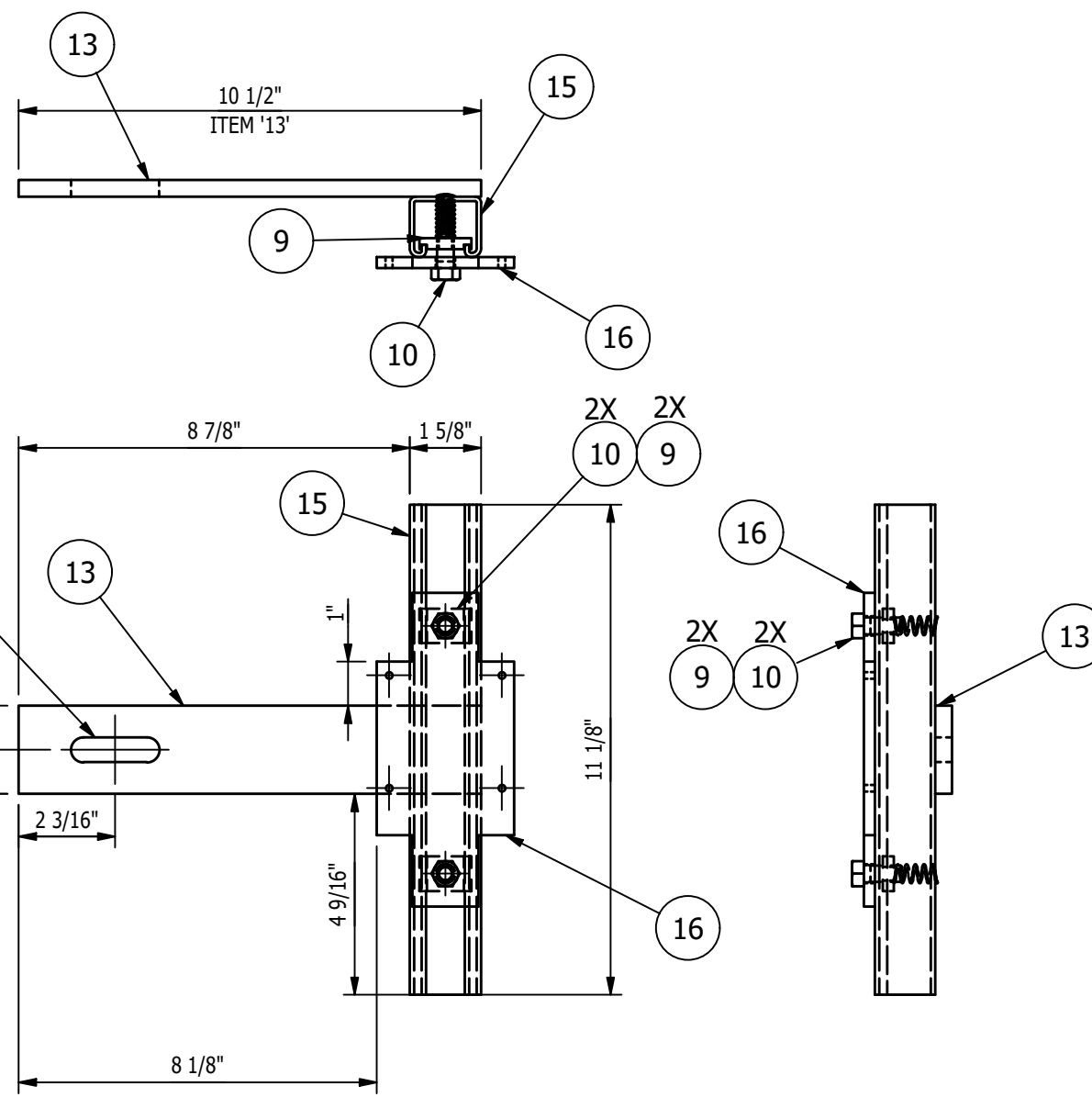
COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



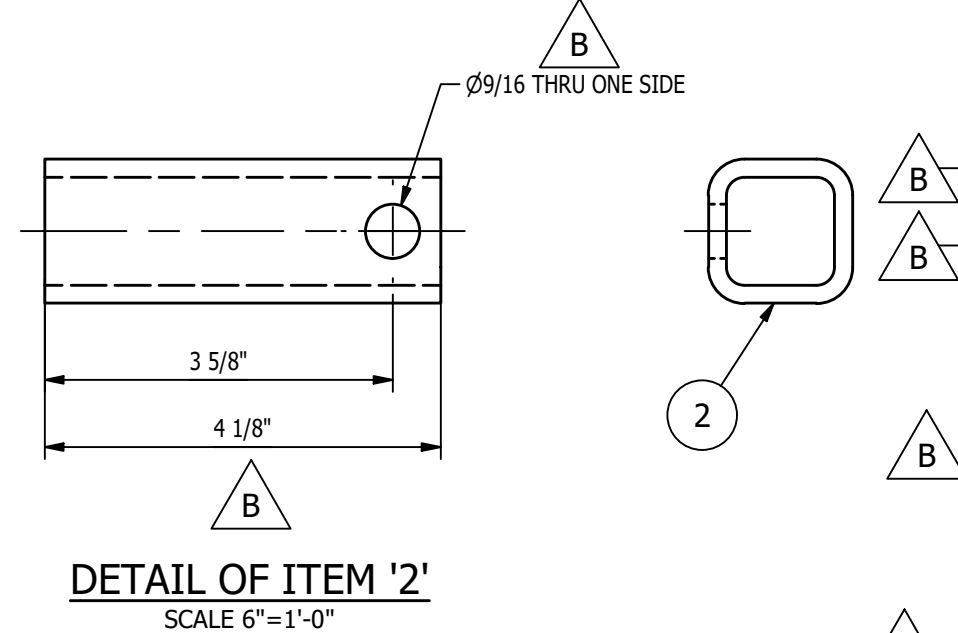
MK-D338A ~ CODE READER MOUNT
SCALE 3"=1'-0"



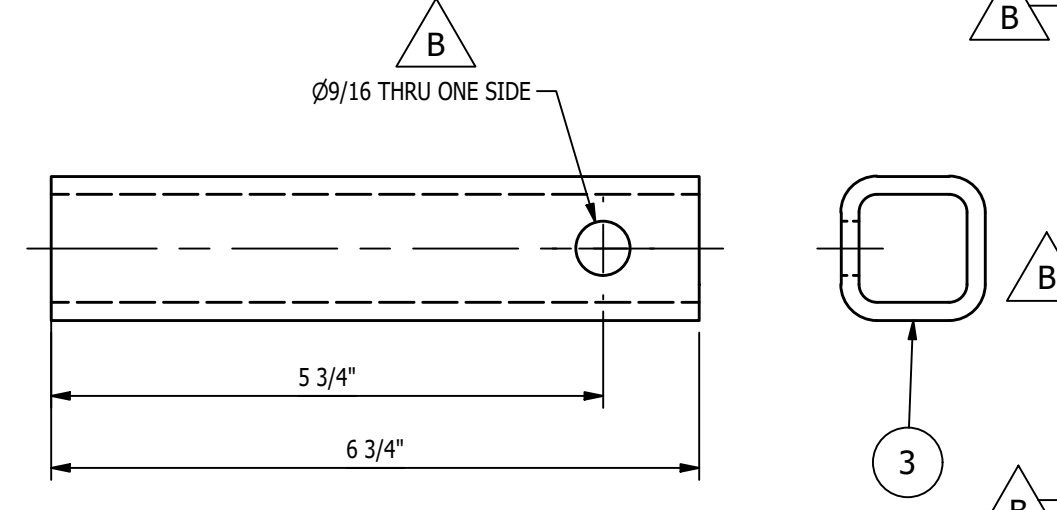
MK-D338B ~ SKI BAR MOUNT
SCALE 3"=1'-0"



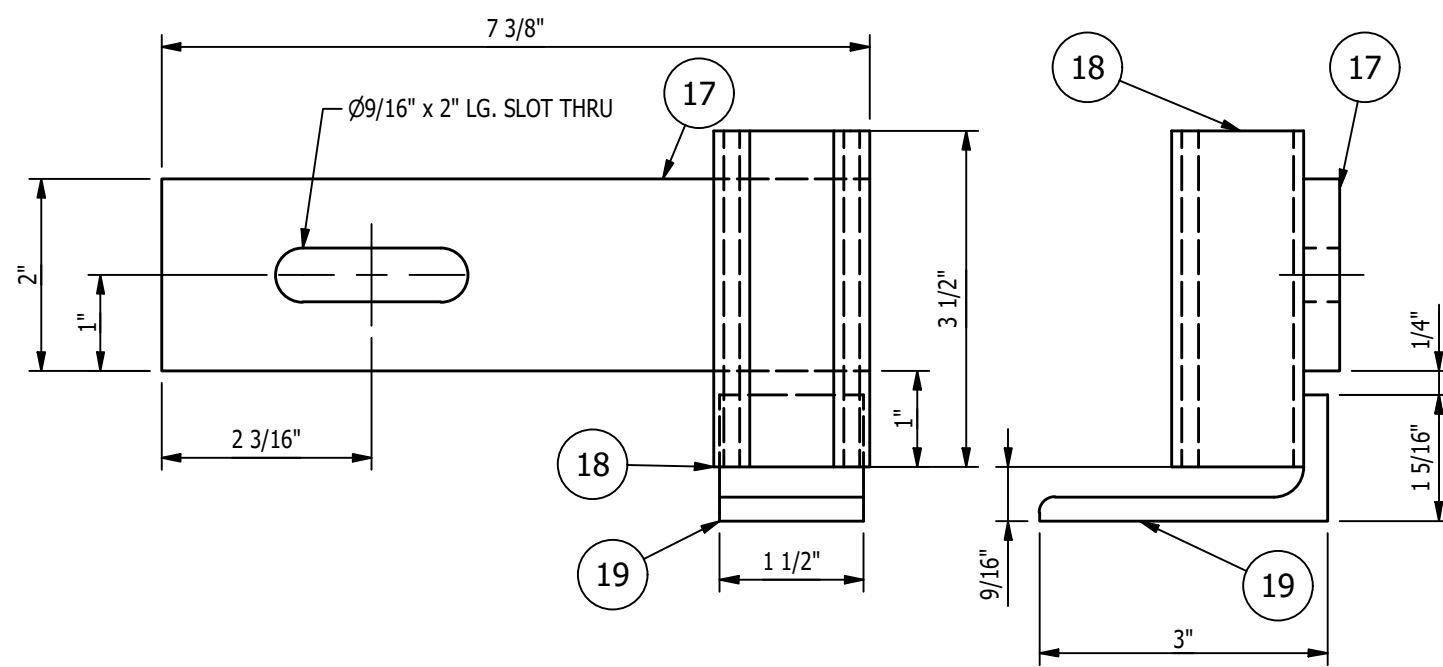
MK-D338C ~ PROX MOUNT
SCALE 3"=1'-0"



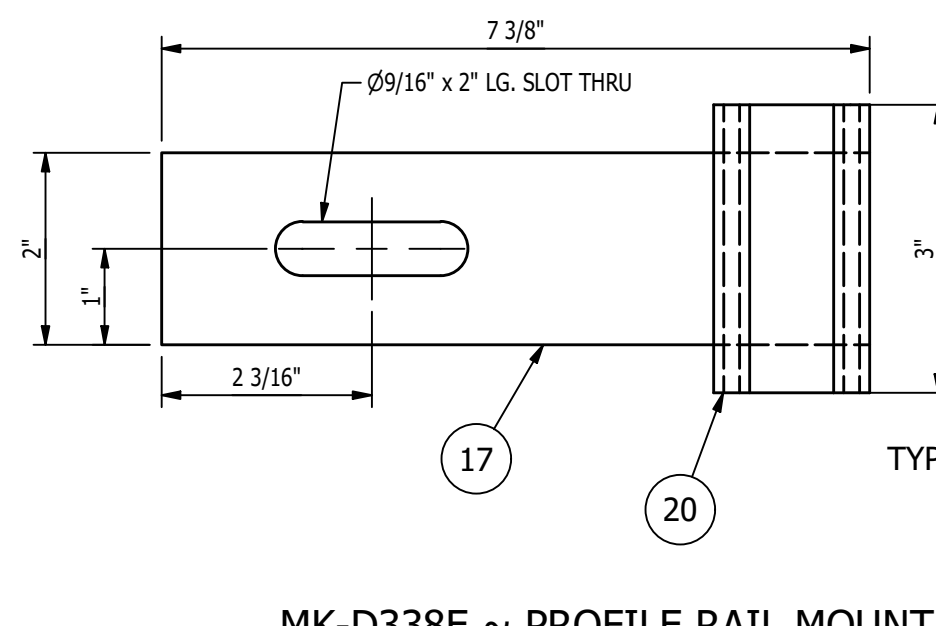
DETAIL OF ITEM '2'
SCALE 6"=1'-0"



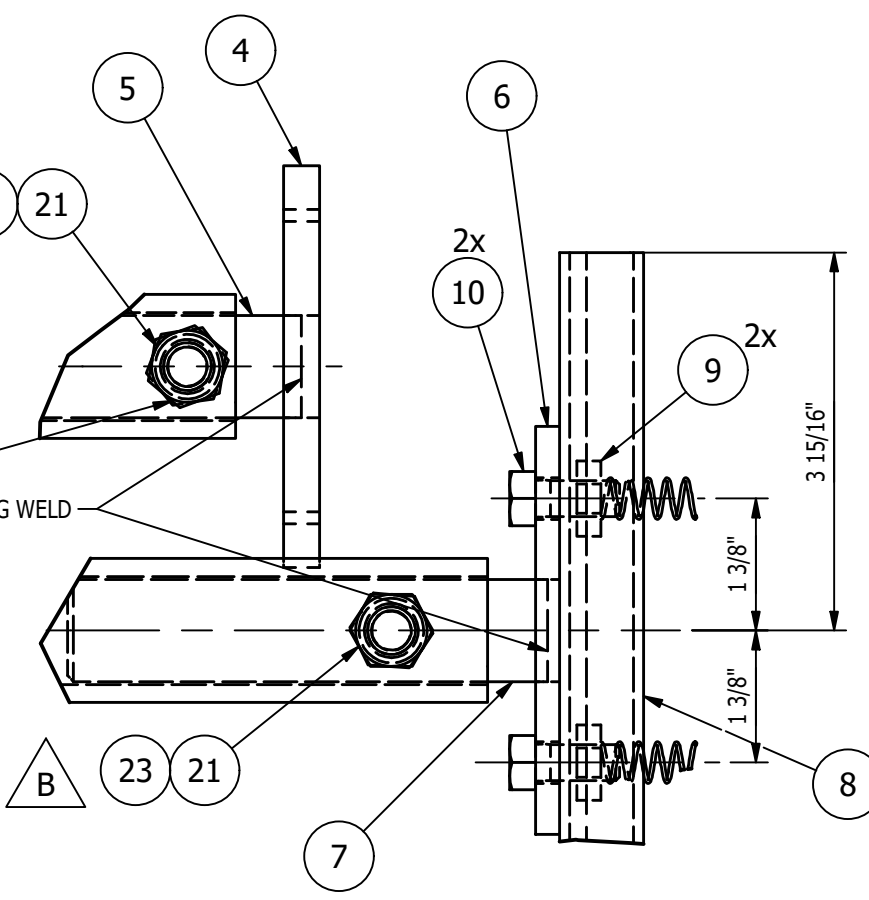
DETAIL OF ITEM '3'
SCALE 6"=1'-0"



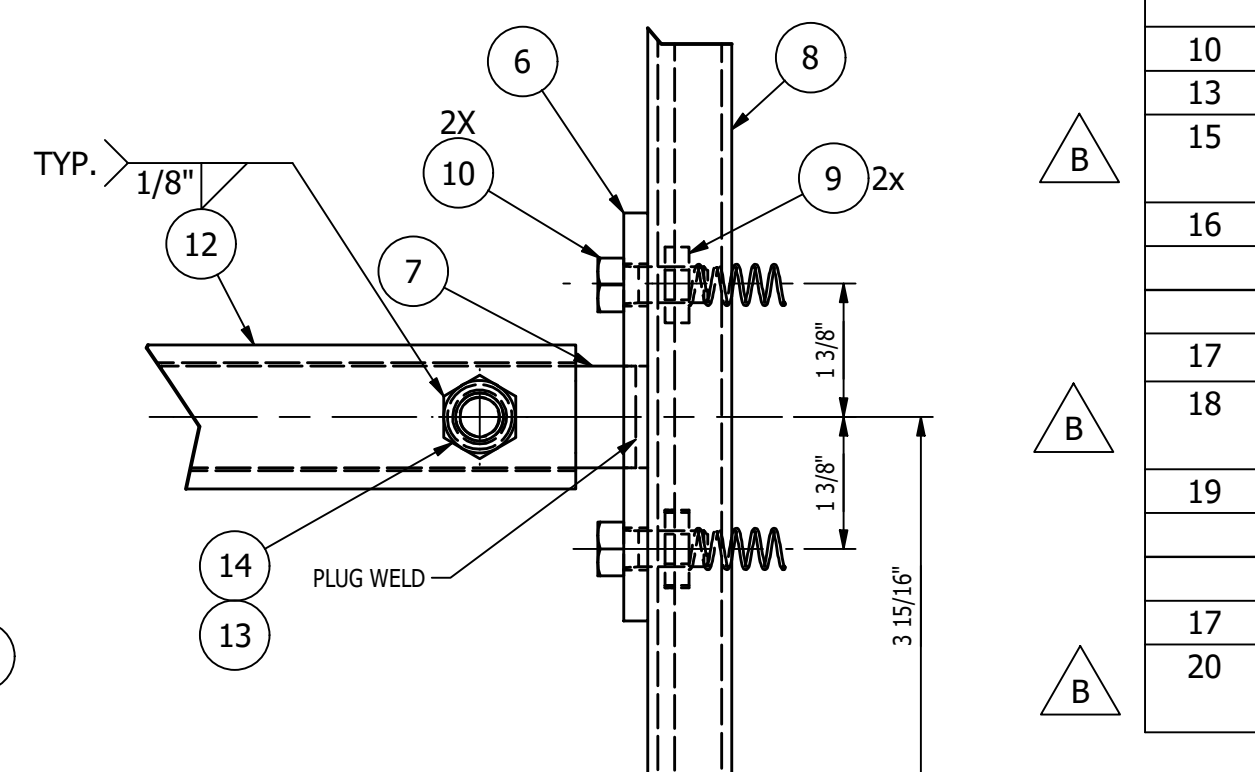
MK-D338D ~ RAIL BOTTOM STOP
SCALE 6"=1'-0"



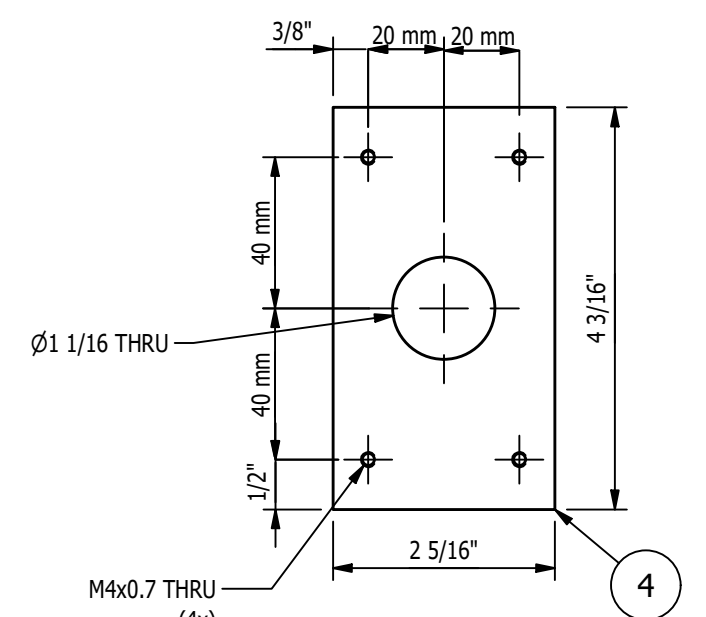
MK-D338E ~ PROFILE RAIL MOUNT
SCALE 6"=1'-0"



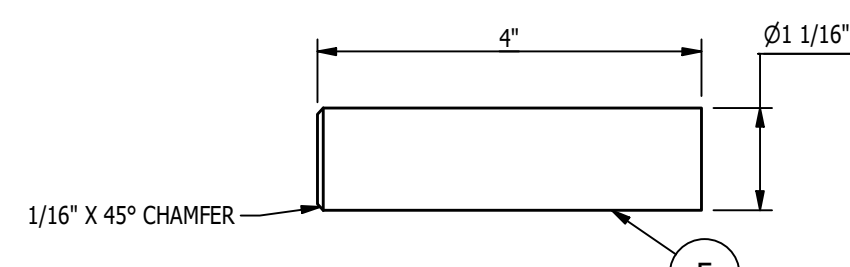
ENLARGED VIEW 'A'
SCALE 6"=1'-0"



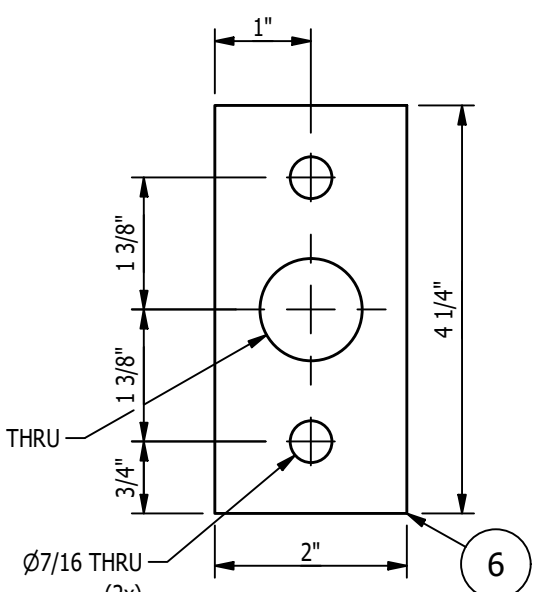
ENLARGED VIEW 'B'
SCALE 6"=1'-0"



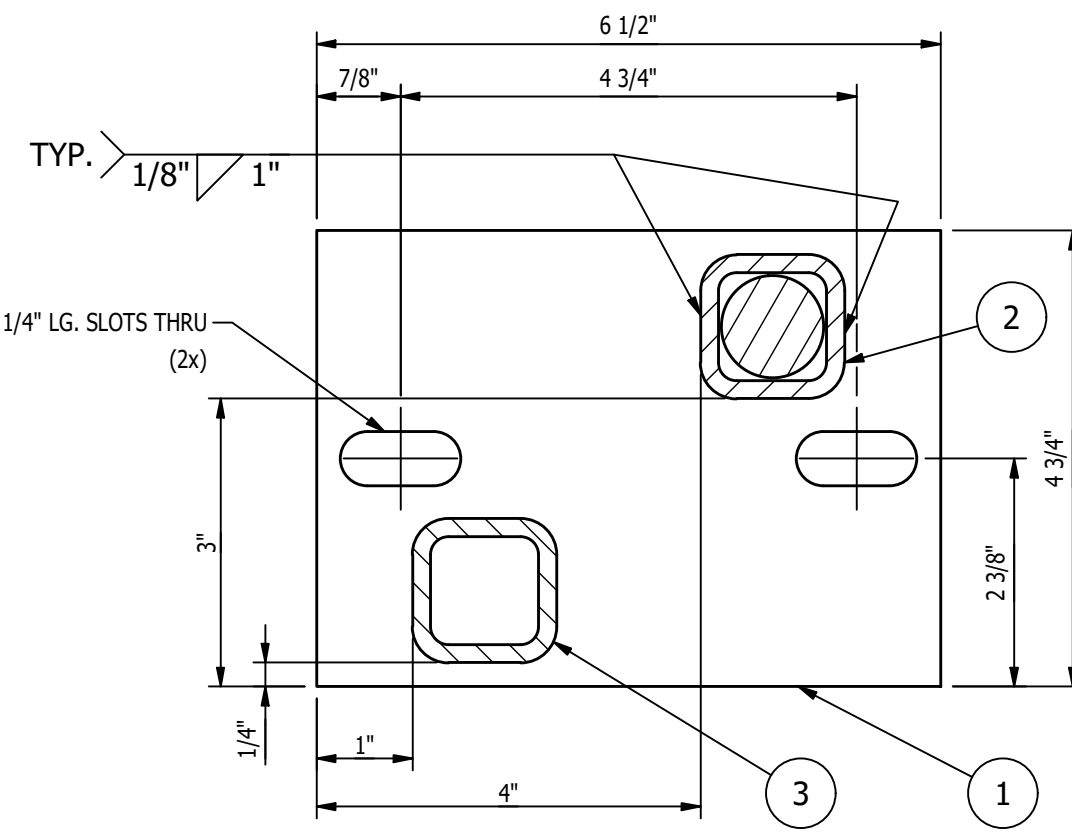
DETAIL OF ITEM '4'
SCALE 6"=1'-0"



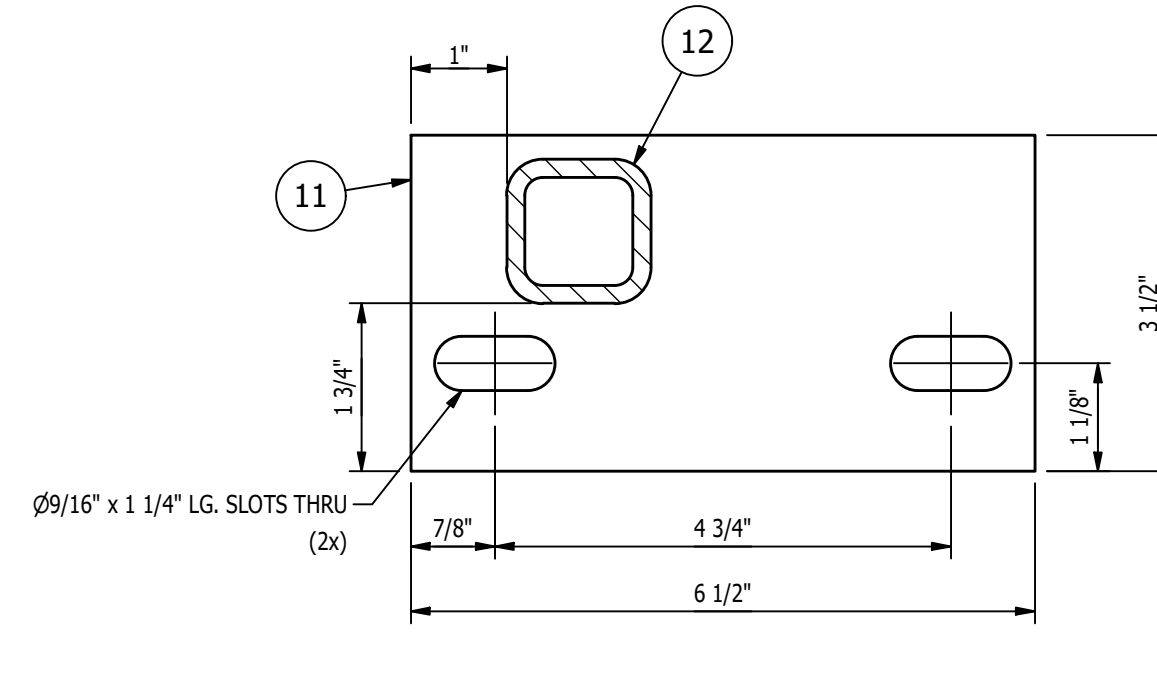
DETAIL OF ITEM '5'
SCALE 6"=1'-0"



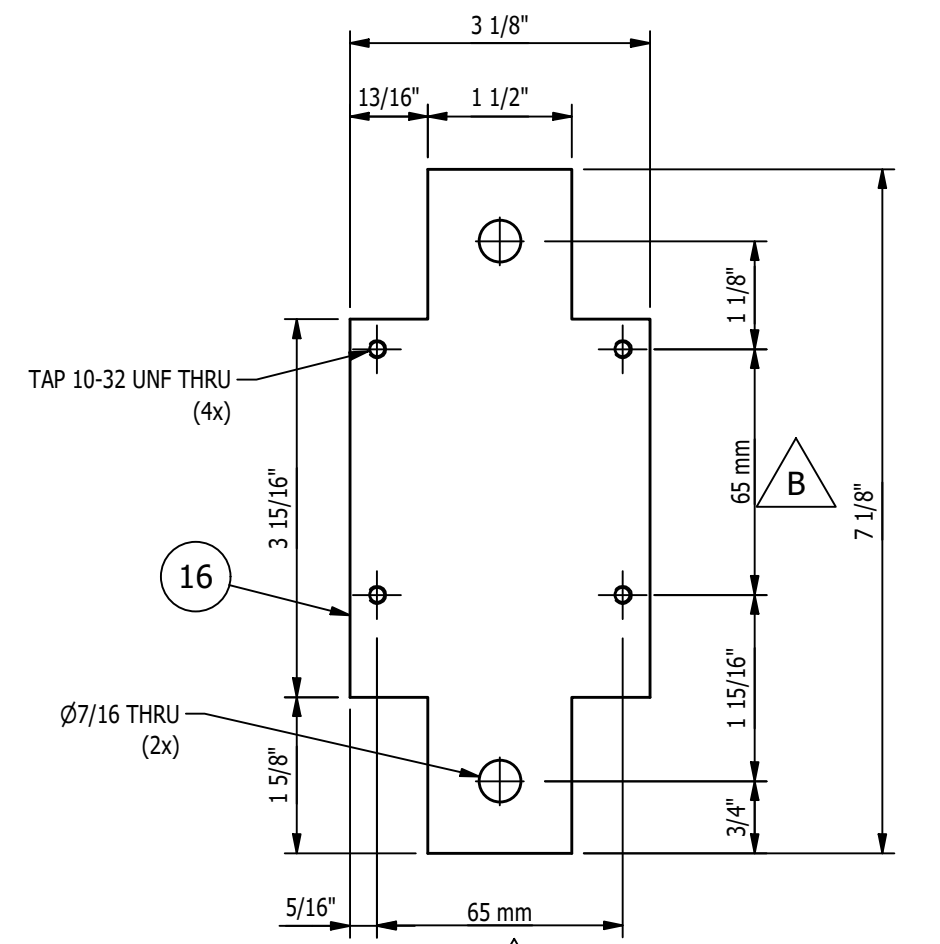
DETAIL OF ITEM '6'
SCALE 6"=1'-0"



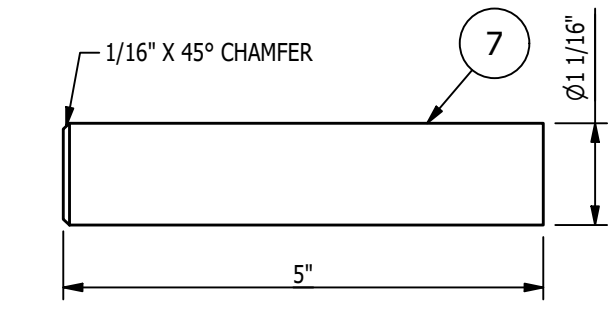
SECTION 'C-C'
SCALE 6"=1'-0"



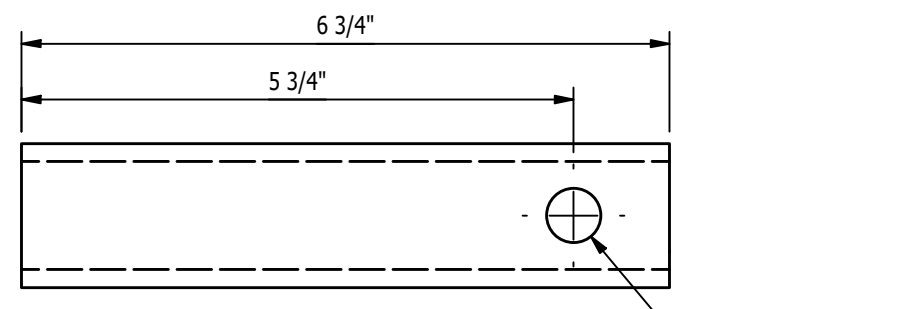
SECTION 'D-D'
SCALE 6"=1'-0"



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



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



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D338A			
1	1	PL 1/4 x 4 3/4"	6 1/2"		
2	1	HSS 1 1/2 x 1 1/2 x 7 GA. A513	4 1/8"		
3	1	HSS 1 1/2 x 1 1/2 x 7 GA. A513	6 3/4"		
4	1	PL 3/8 x 2 5/16"	4 3/16"		
5	1	BAR Ø1 1/16	4"		
6	1	PL 1/4 x 2"	4 1/4"		
7	1	BAR Ø1 1/16	5"		
8	1	UNISTRUT 1-5/8 x 7/8 12 GAGE METAL CHANNEL, PART NO. P3300-PL	1'-6"		
9	2	CHANNEL NUT FOR 3/8"-16 WITH SPRING, UNISTRUT P1008			
10	2	3/8-16UNC x 7/8" LG. HEX HEAD BOLT			
21	2	1/2-13UNC HEX NUT			
23	2	1/2-13UNC x 1" LG. HEX HEAD CAP SCREW			
		MK-D338B			
6	1	PL 1/4 x 2"	4 1/4"		
7	1	BAR Ø1 1/16	5"		
8	1	UNISTRUT 1-5/8 x 7/8 12 GAGE METAL CHANNEL, PART NO. P3300-PL	1'-6"		
9	2	CHANNEL NUT FOR 3/8"-16 WITH SPRING, UNISTRUT P1008			
10	2	3/8-16UNC x 7/8" LG. HEX HEAD BOLT			
11	1	PL 1/4 x 3 1/2"	6 1/2"		
12	1	HSS 1 1/2 x 1 1/2 x 7 GA. A513	6 3/4"		
13	1	1/2-13UNC HEX NUT			
14	1	1/2-13UNC x 1" LG. HEX HEAD CAP SCREW			
		MK-D338C			
9	2	CHANNEL NUT FOR 3/8"-16 WITH SPRING, UNISTRUT P1008			
10	2	3/8-16UNC x 7/8" LG. HEX HEAD BOLT			
13	1	PL 3/8 x 2"	10 1/2"		
15	1	UNISTRUT 1-5/8 x 1-3/8 12 GAGE METAL CHANNEL, PART NO. P3000-PL	11 1/8"		
16	1	PL 1/4 x 3 1/8"	7 1/8"		
		MK-D338D			
17	1	PL 3/8 x 2"	7 3/8"		
18	1	UNISTRUT 1-5/8 x 1-3/8 12 GAGE METAL CHANNEL, PART NO. P3000-PL	3 1/2"		
19	1	L 3 x 2 x 1/4	1 1/2"		
		MK-D338E			
17	1	PL 3/8 x 2"	7 3/8"		
20	1	UNISTRUT 1-5/8 x 1-3/8 12 GAGE METAL CHANNEL, PART NO. P3000-PL	3"		

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

PAINT NOTES:
 PAINT ALL FABRICATED STEEL PER BUILD MATRIX EITHER

ONE SHOP COAT OF PURE ORANGE RAL 2004 ON MK-D338A & MK-D338B
 ONE SHOP COAT OF LIGHT GREY RAL 7035 ON MK-D338C, MK-D338D, & MK-D338E
 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/19/22	ADJUSTED HOLE LOCATIONS ON ITEM '16', ADDED ITEMS '21' & '23', LENGTH OF ITEM '2' SHORTENED, REMOVED ITEM '14', UPDATED DESCRIPTIONS OF ITEMS '2', '3', '8', '12', '15', '18', & '20', CHANGED SIZE ITEMS 5, 7; ADDED HOLE AND DETAIL VIEW ITEM 12	
A	MC	8-8-2022	FOR FABRICATION	

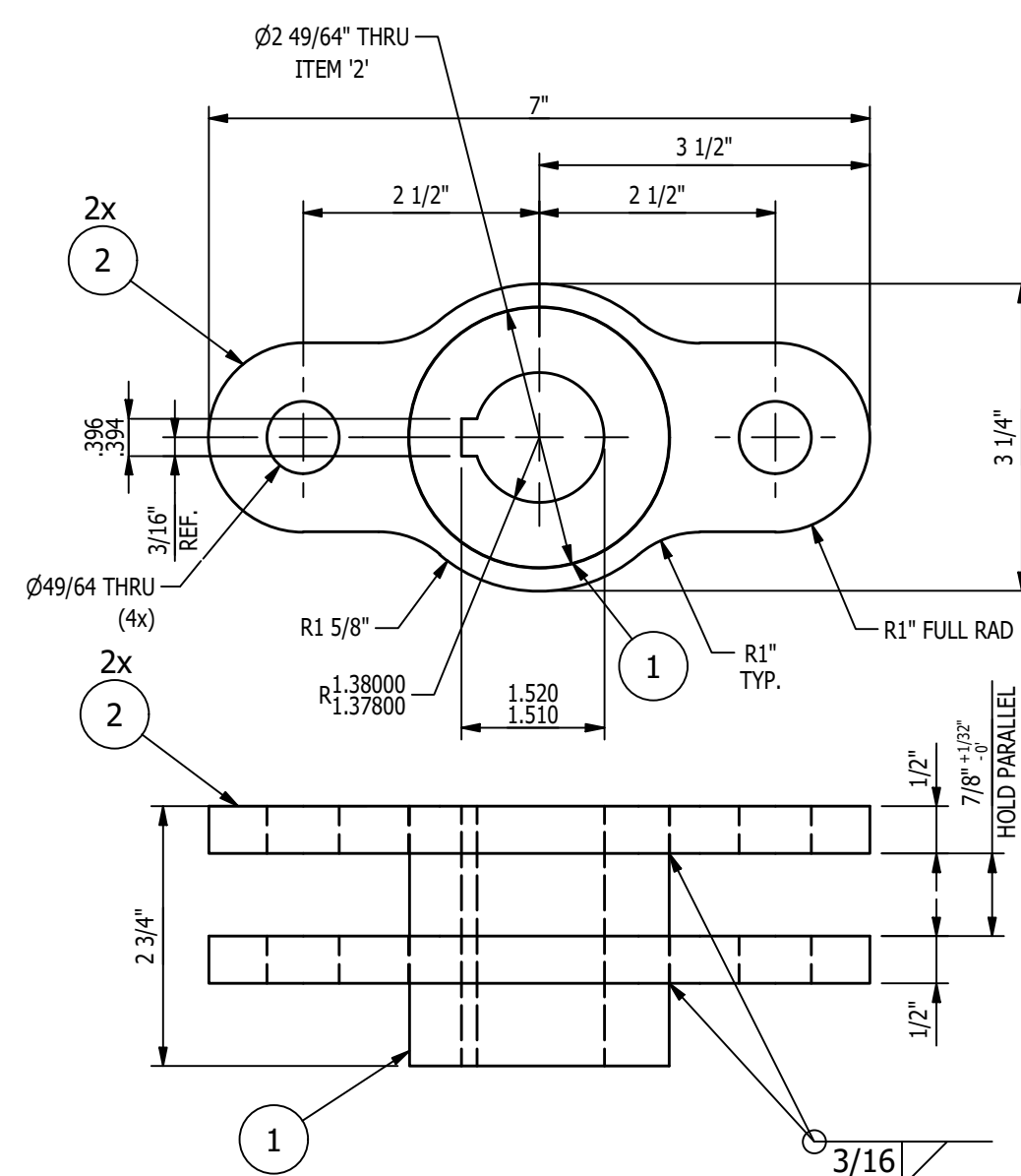
REVISION HISTORY	
REV	APP

<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com</p>	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D338	DRAWN BY: AH CHECKED BY: JCK DWG DATE: 7/11/22 JOB No: 22096

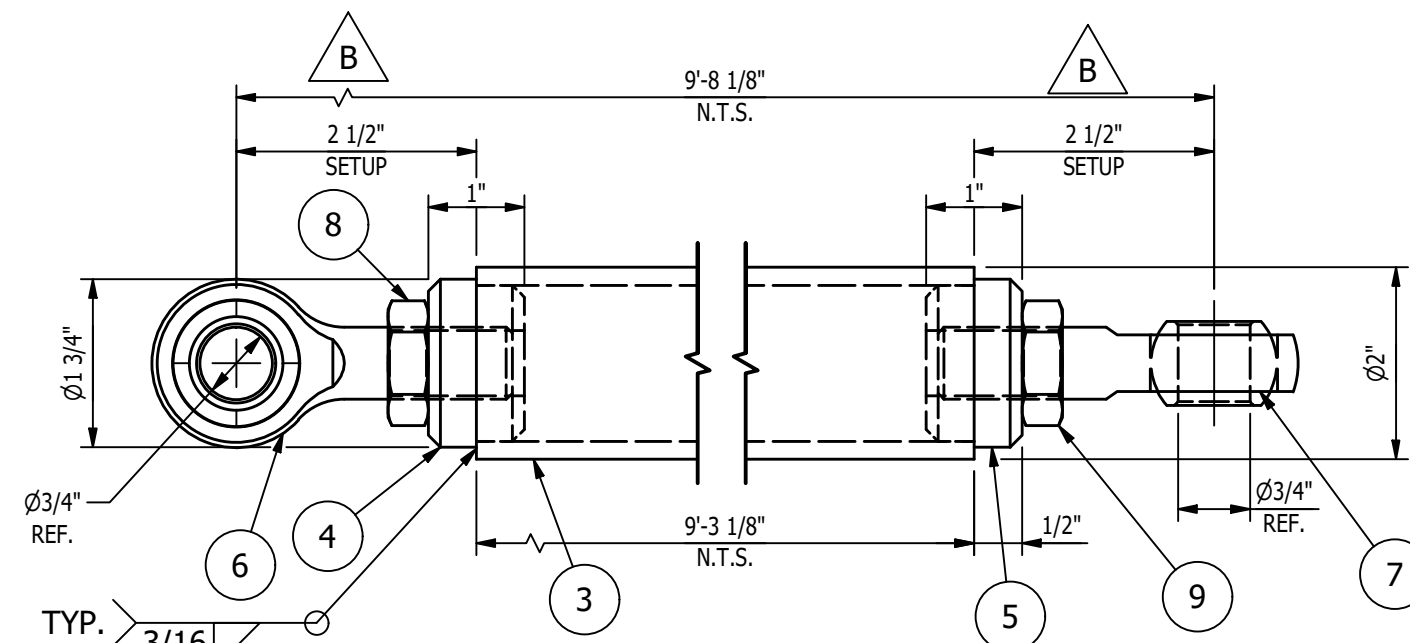
MAGNUM CONSULTING
 41100 Charleston Rd.
 Suite 125
 Norcross, GA 30052
 Phone: (770) 772-8822
 Fax: (770) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D338

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

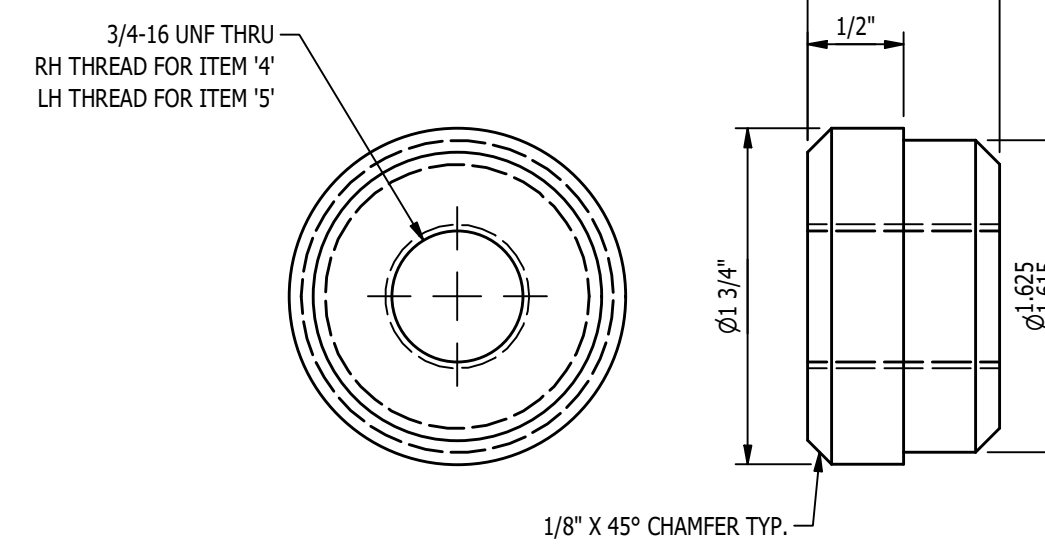
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO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



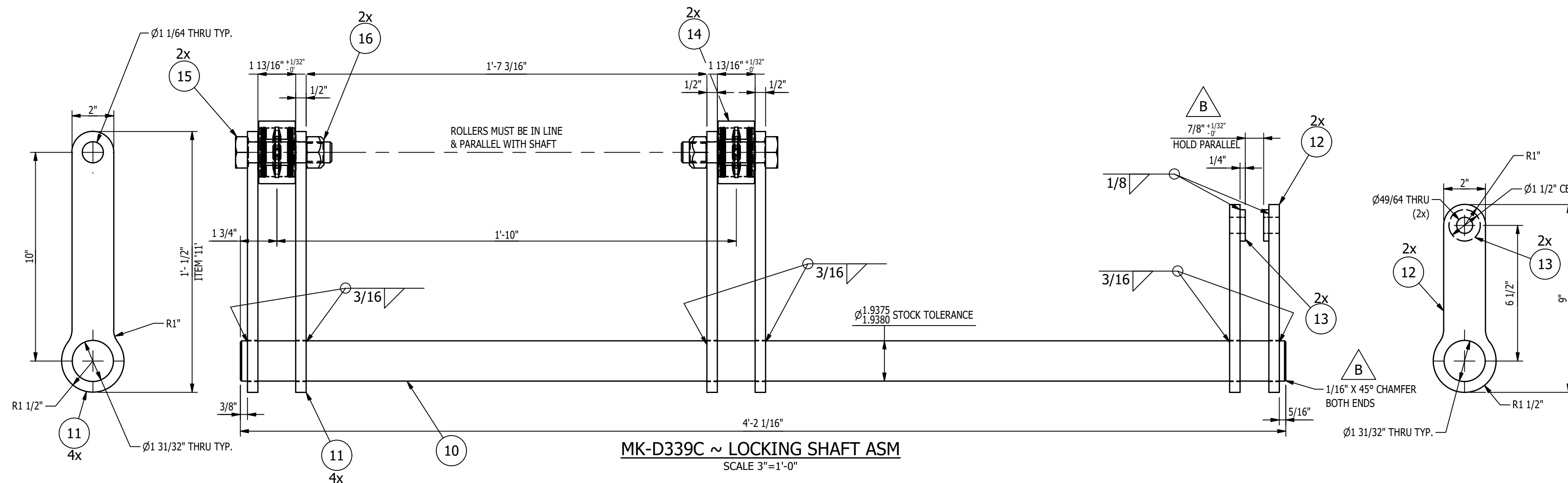
MK-D339A ~ PIVOTING CRANK WELDMENT
SCALE 6"=1'-0"



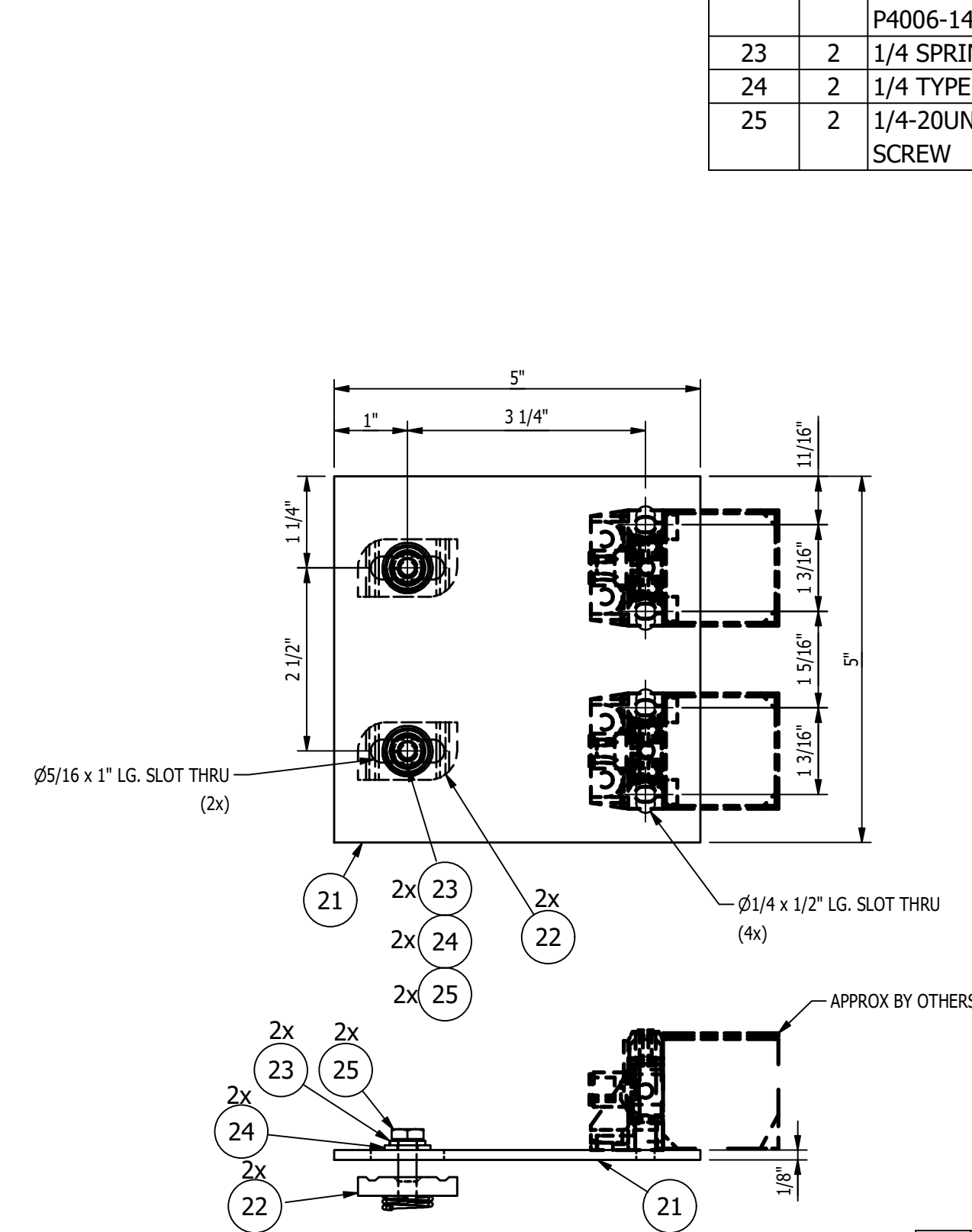
MK-D339B ~ CONNECTING SHAFT ASSEMBLY
SCALE 6"=1'-0"



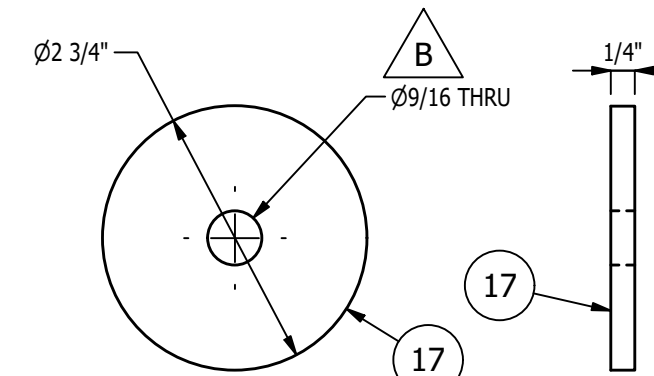
DETAIL OF ITEMS '4' & '5'
SCALE 1'-0"=1'-0"



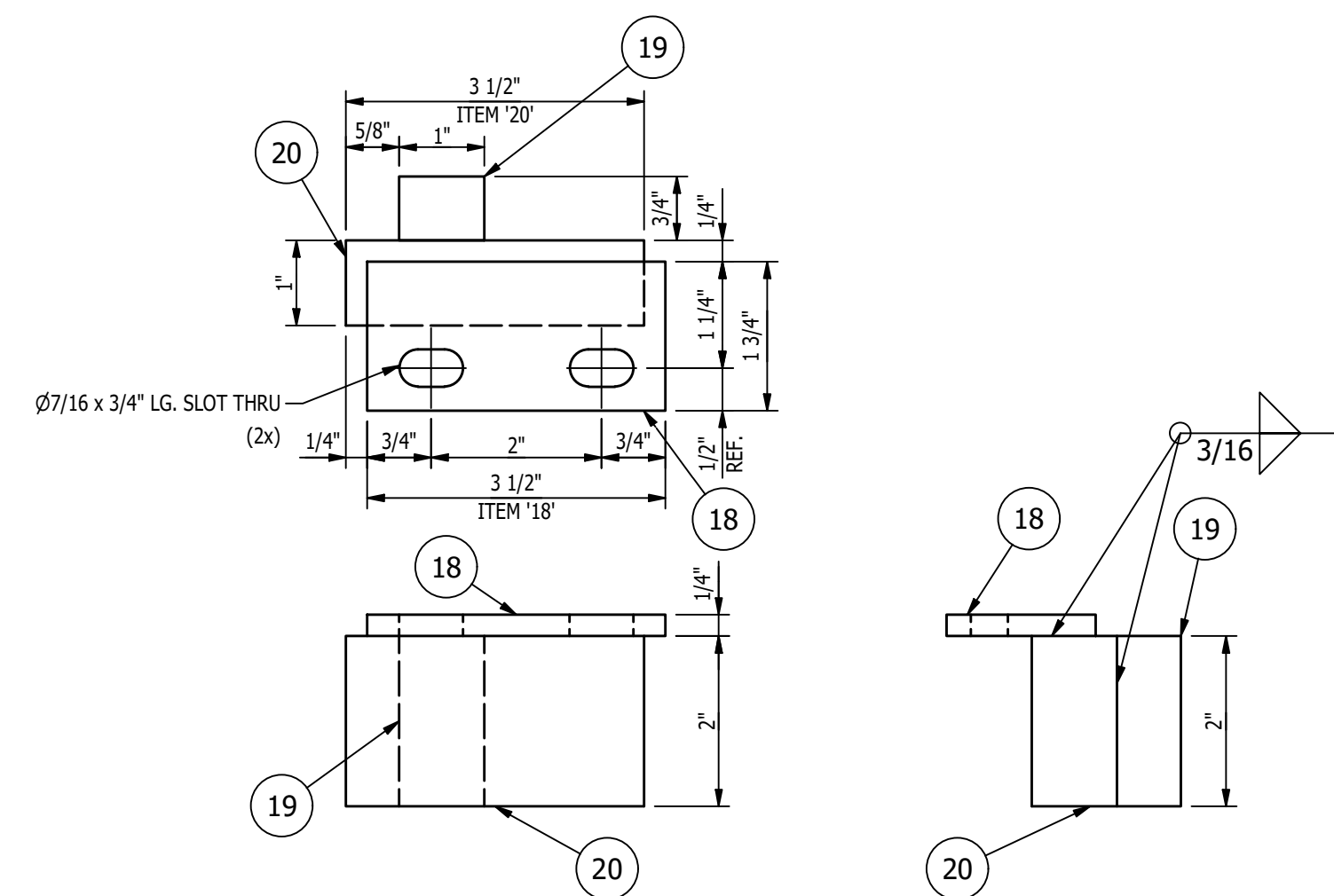
MK-D339C ~ LOCKING SHAFT ASM
SCALE 3"=1'-0"



MK-D339F ~ LOCK INDICATOR ASM
SCALE 6"=1'-0"



MK-D339D ~ CAP PLATE
SCALE 6"=1'-0"



D339E ~ CONNECTING SHAFT STOP WELDMENT
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D339A			
1	1	BAR Ø2 3/4	2 3/4"		
2	2	BAR 1/2 x 3 1/4	7"		
		MK-D339B			
3	1	TS 2 OD x 3/16 DOM	9'-3 1/8"		
4	1	BAR Ø1 3/4	1"		
5	1	BAR Ø1 3/4	1"		
6	1	3/4-16UNF RH THREAD BALL JOINT ROD END, 3/4" BORE, McMASTER-CARR PART NO. 60645K18 (RIGHT HAND)		7-12	
7	1	3/4-16UNF LH THREAD BALL JOINT ROD END, 3/4" BORE, McMASTER-CARR PART NO. 60645K18 (LEFT HAND)		7-13	
8	1	3/4-16UNF HEX JAM NUT			
9	1	3/4-16UNF LH THREAD HEX JAM NUT			
		MK-D339C			
10	1	BAR Ø1 15/16 (TG&P)	4'-2 1/16"		
11	4	BAR 1/2 x 3	1'- 1/2"		
12	2	BAR 1/2 x 3	9"		
13	2	BAR Ø1 1/2	1/4"		
14	2	PLAIN TRACK ROLLER, 3" OD x 1.75" WIDE, 1.005" BORE, PCI PART NO. PTRY-3.00		7-23	
15	2	1-8UNC x 4" LG. HEX HEAD CAP SCREW			
16	2	1-8UNC STOVER LOCK NUT			
		MK-D339D			
17	1	BAR Ø2 3/4	1/4"		
		MK-D339E			
18	1	BAR 1/4 x 1 3/4	3 1/2"		
19	1	BAR 3/4 x 1	2"		
20	1	BAR 1 x 2	3 1/2"		
		MK-D339F			
21	1	SHT 10 GA x 5	5"		
22	2	CHANNEL NUT FOR 1/4"-20 WITH SPRING, UNISTRUT PART NO. P4006-1420-EG			
23	2	1/4 SPRING LOCK WASHER			
24	2	1/4 TYPE A NARROW FLAT WASHER			
25	2	1/4-20UNC x 7/8" LG. HEX HEAD CAP SCREW			

SHOP NOTES:

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

PAINT NOTES:

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	ADDED SET-UP DIMS & NOTES	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY	
DESCRIPTION	APP

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

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH
CLIENT: VOLVO	CHECKED BY: JCK
DRAWING No. 1875D339	DWG DATE: 7/27/22
REV: B	JOB No: 22096

MAGNUM CONSULTING
41100 QuakerRoad Rd.
Suite 125
North, MI 48135
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 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)

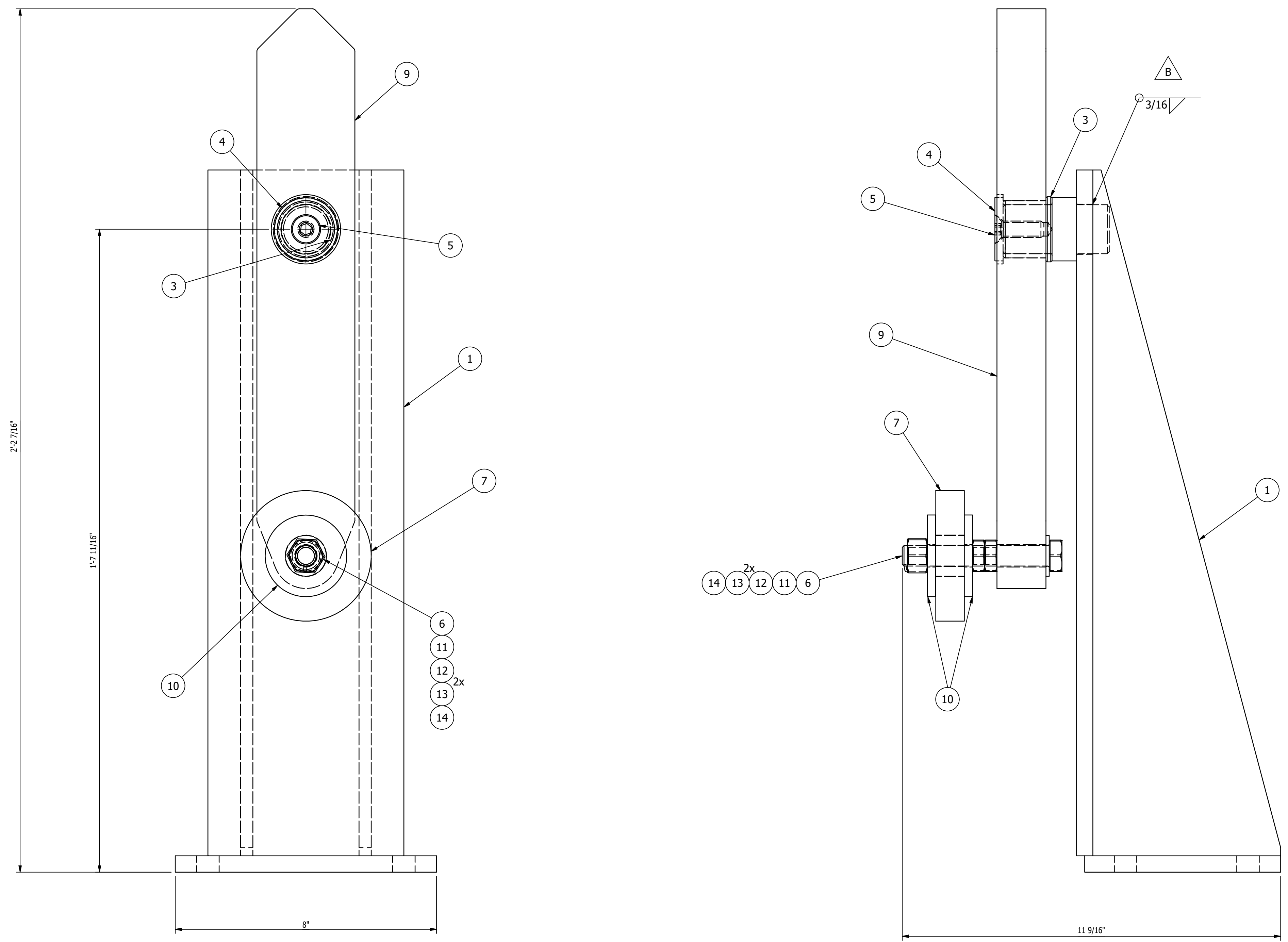
PAINT:

- 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-D340C			
1	1	MK-D341A ~ FLOOR STOP WELDMENT			
3	1	BRONZE FLANGED BEARING, 1 3/4 OD x 1 3/4 ID x 1 1/2 LG, BUNTING PART NO. EBCF242812		6-8	
4	1	MK-D056A ~ KEEPER PLATE			
5	1	1/2-13UNC x 1 1/2" LG. FLAT HEX SOCKET HEAD CAP SCREW			
6	1	5/8-11UNC x 4 1/2" LG. HEX HEAD CAP SCREW			
7	1	MK-D056C ~ PIVOT WHEEL			
9	1	MK-D055A ~ GRAVITY STOP ARM			
10	2	MK-D056E ~ WHEEL PLATE			
11	1	ANCO LOCK NUT, 5/8-11, A194 -2H, PLAIN			
12	2	5/8-11UNC HEX JAM NUT			
13	1	MK-D056D ~ PIVOT SHAFT			
14	1	5/8 TYPE B NARROW FLAT WASHER			



MK-D340C ~ MECHANICAL STOP MEZZANINE MOUNTED
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.

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	ADDED WELD NOTE	
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING
CLIENT:	VOLVO
DRAWING No.	1875D340
REV:	B
DRAWN BY:	AH
CHECKED BY:	JCK
DWG DATE:	7/27/22
JOB No:	22096

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

MAGNUM CONSULTING

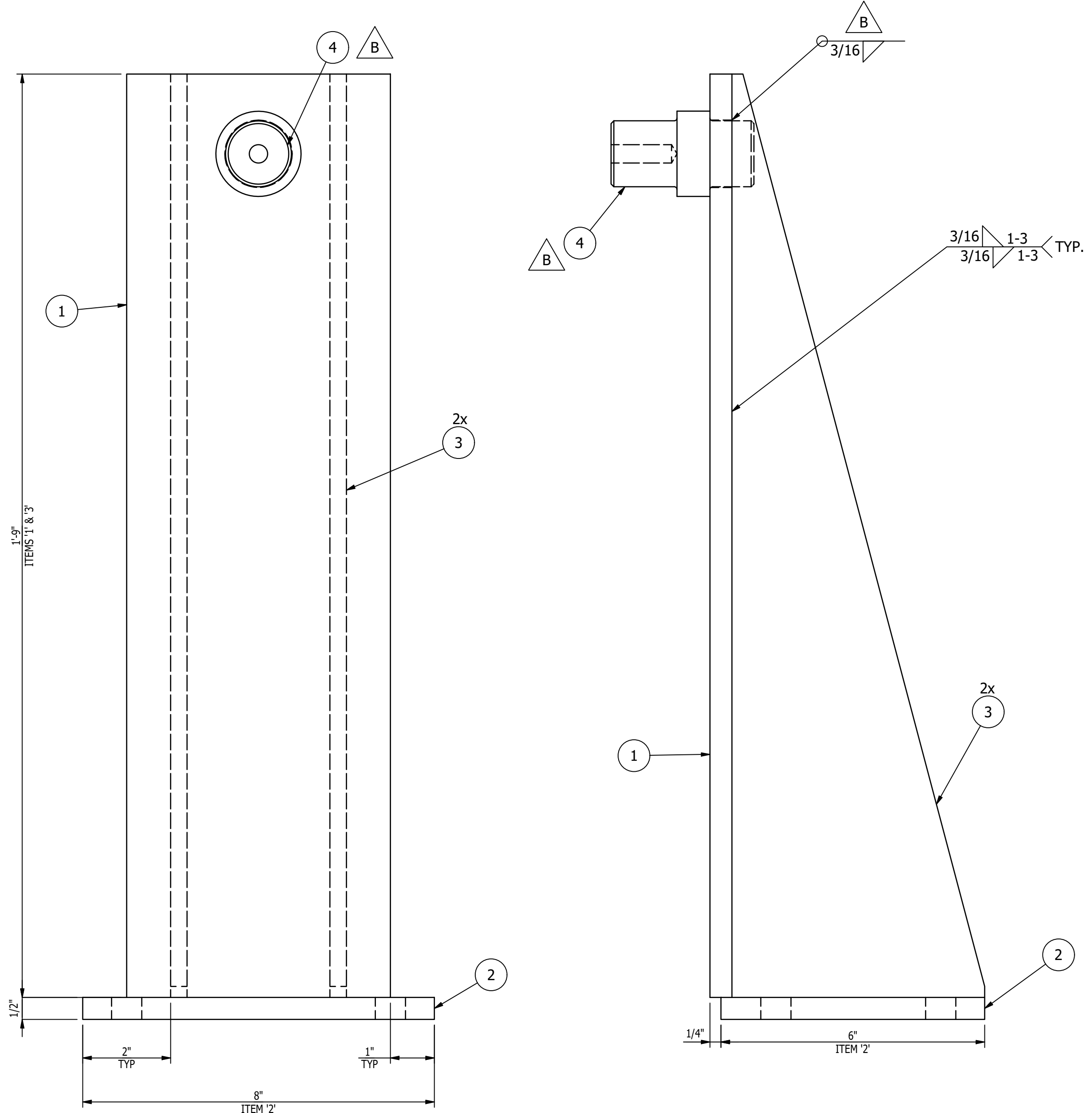
41100 Dardickwood Rd.
Suite 125
North, MI 48135

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

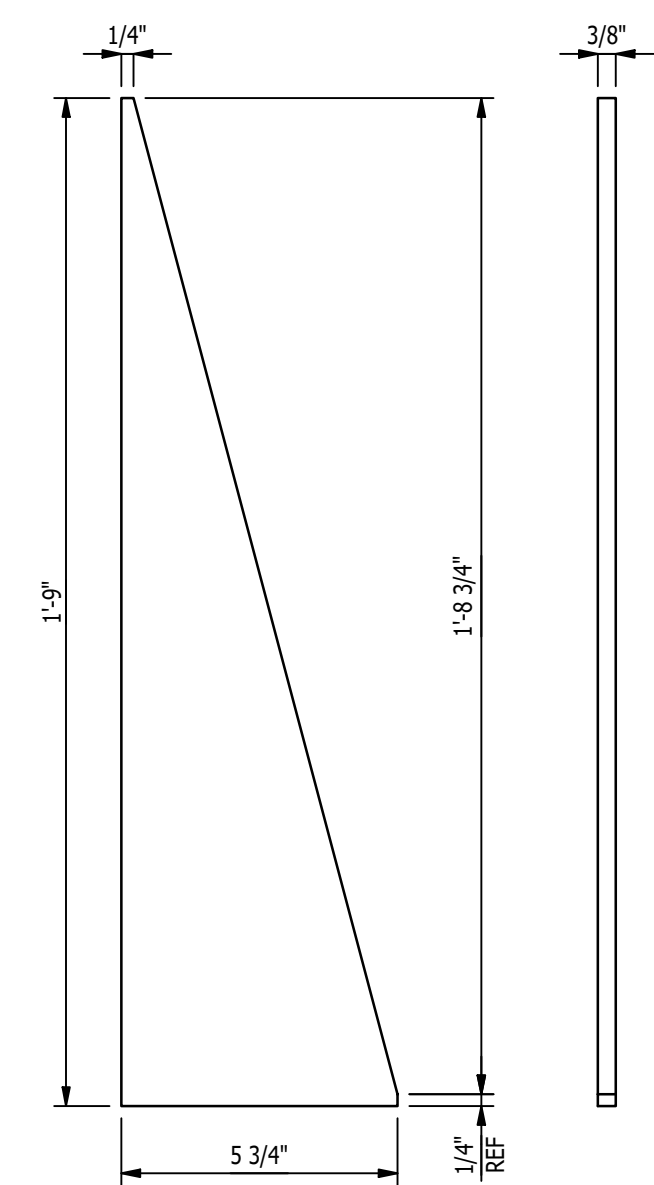
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D340 - REV B

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

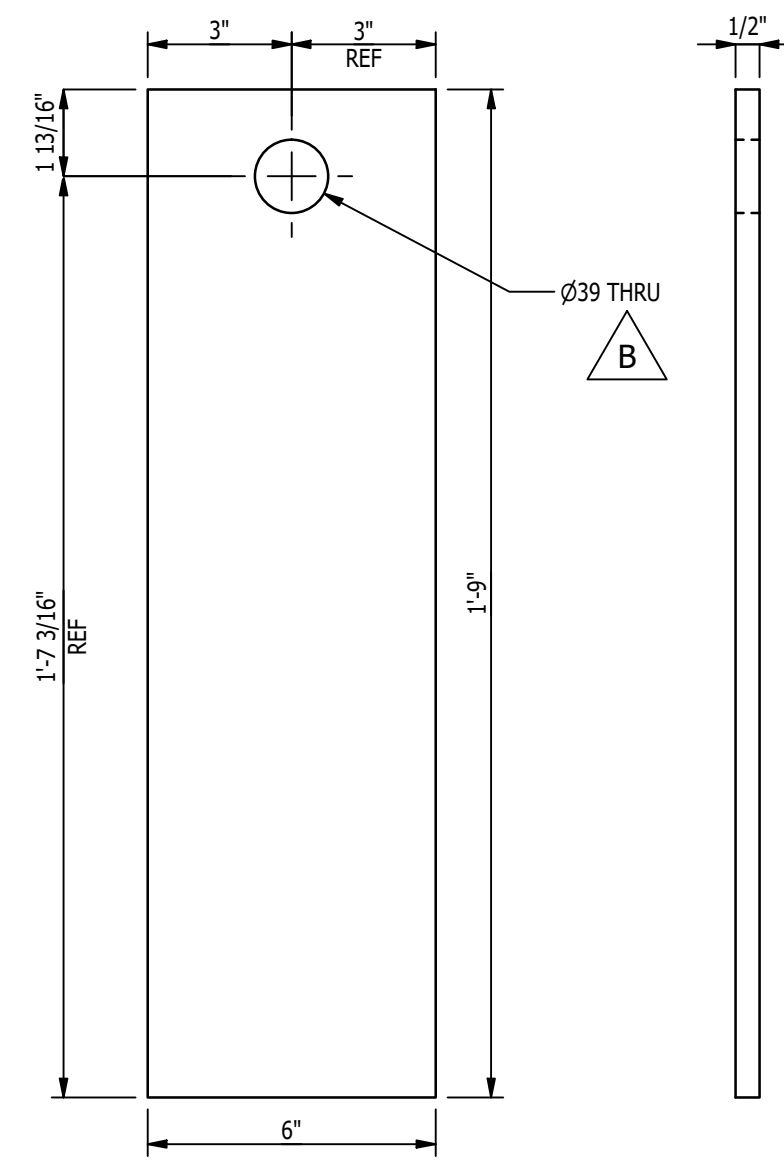
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D341A			
1	1	BAR 1/2 x 6	1'-9"		
2	1	BAR 1/2 x 6	8"		
3	2	PL 3/8 x 5 3/4"	1'-9"		
4	1	MK-D056B ~ PIVOT SHAFT DETAIL			



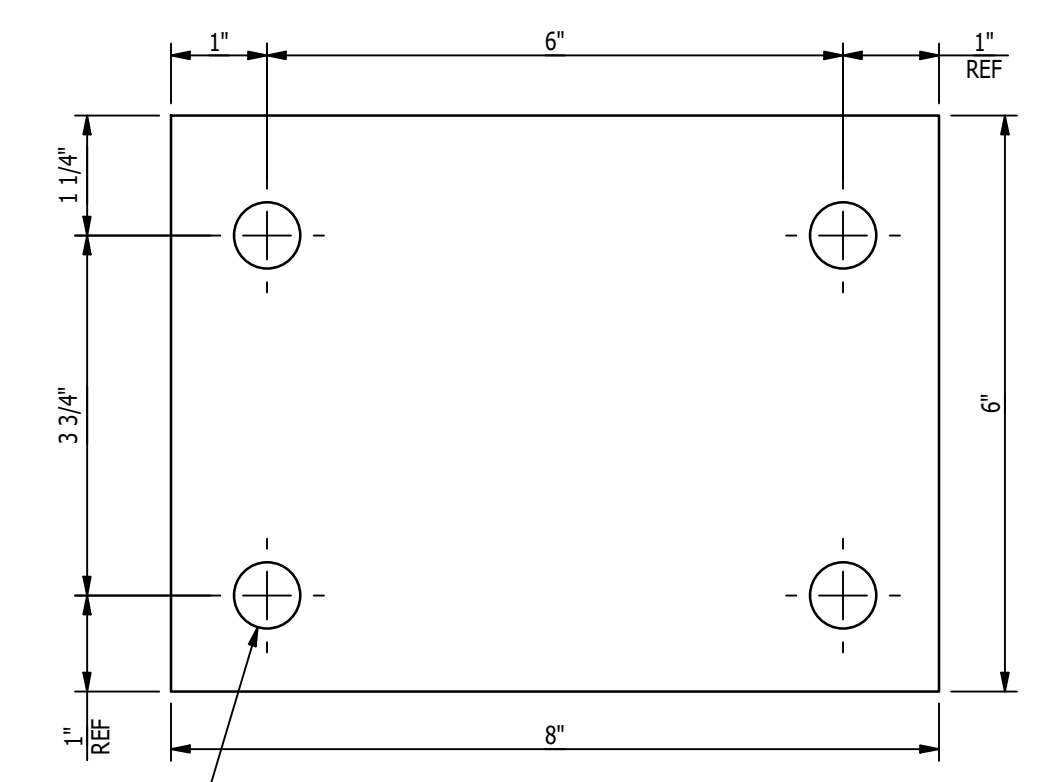
MK-D341A ~ FLOOR STOP WELDMENT
SCALE 6"=1'-0"



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



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



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

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

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

REVISION HISTORY		MILLER INDUSTRIES	
		3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	JK
DRAWING No.	1875D341	DWG DATE:	7/27/22
REV:	B	JOB No:	22096

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D341 - REV B

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

GENERAL NOTES:

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

HOLES:

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

WELDS:

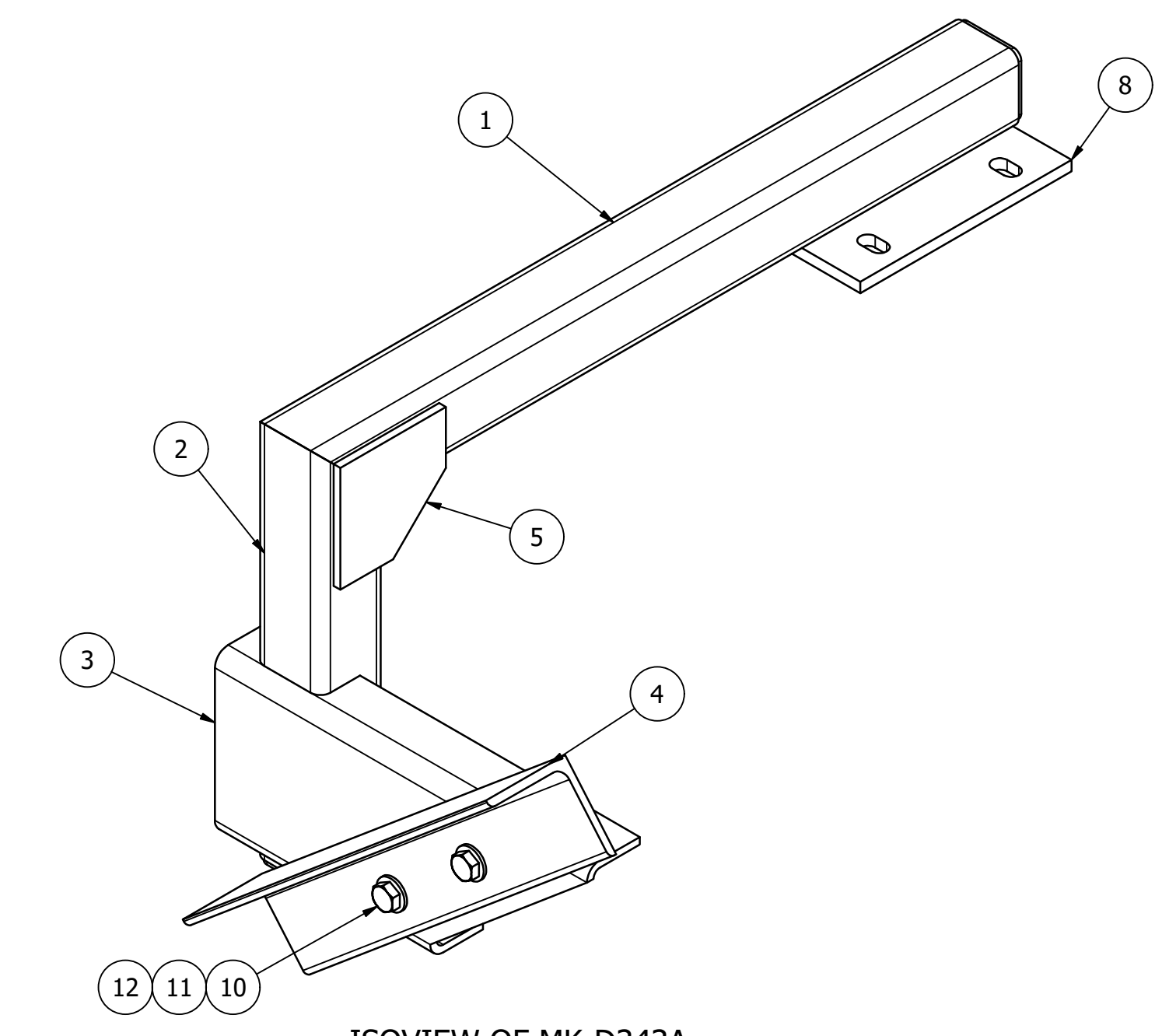
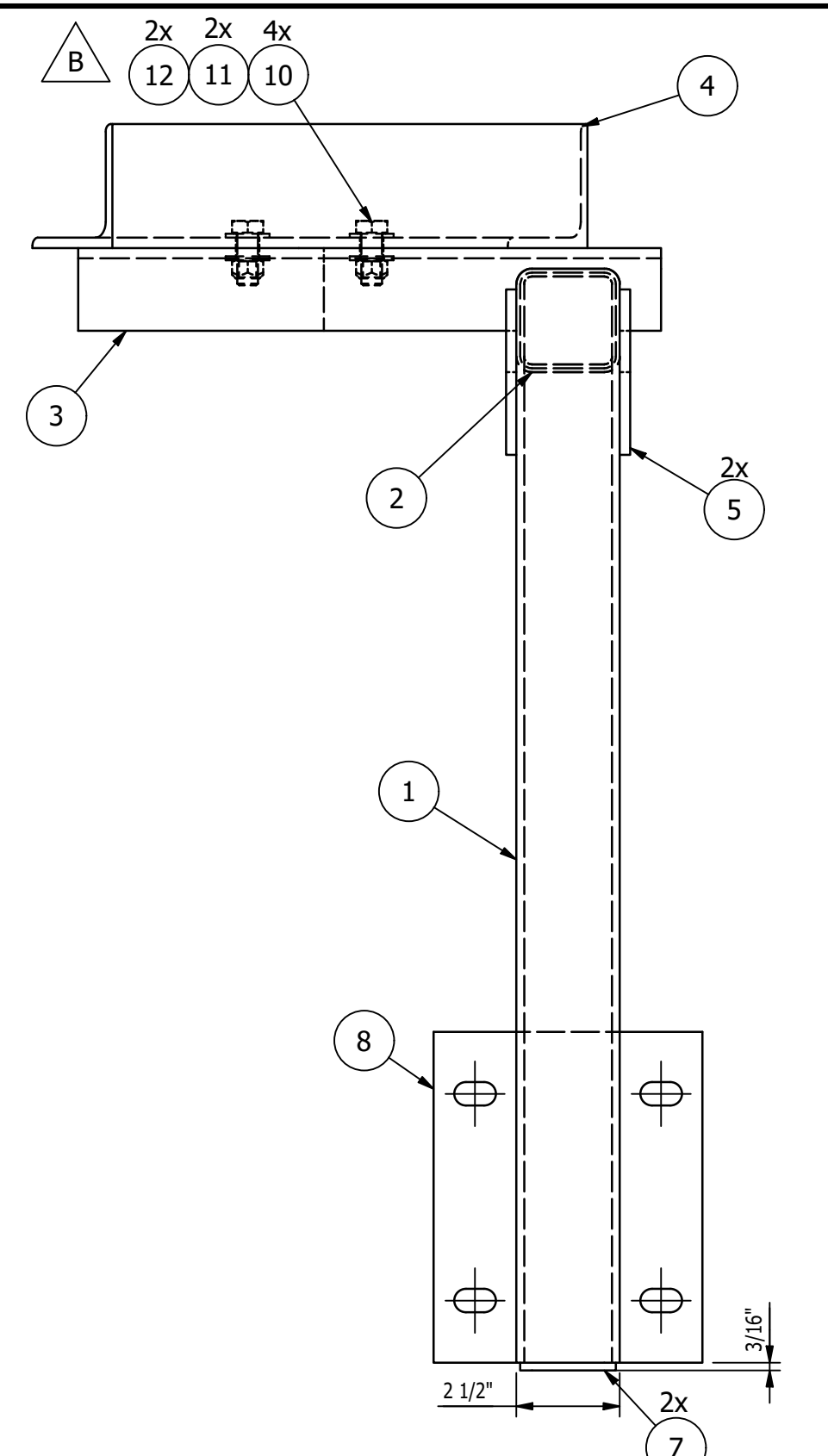
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:

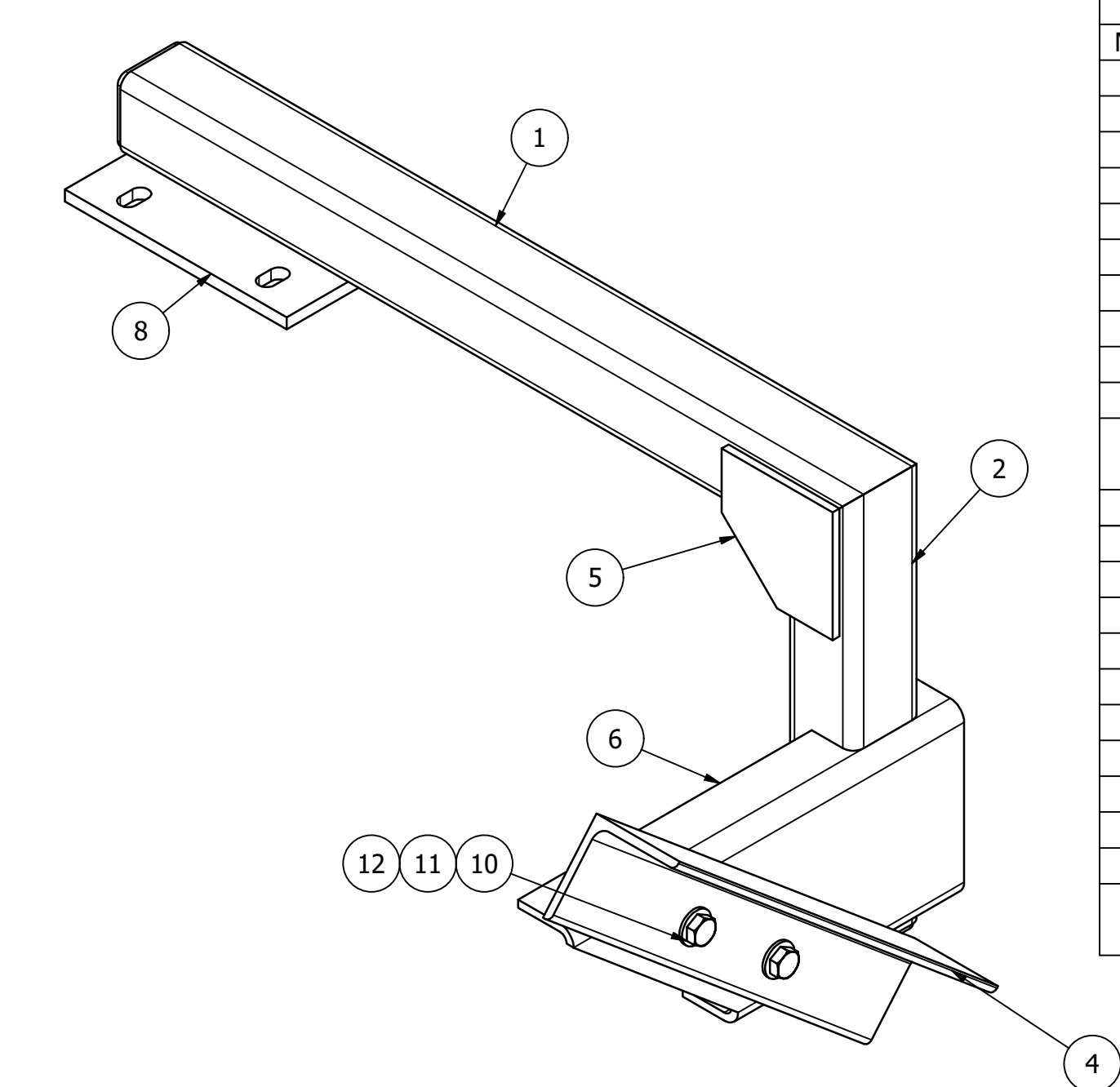
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

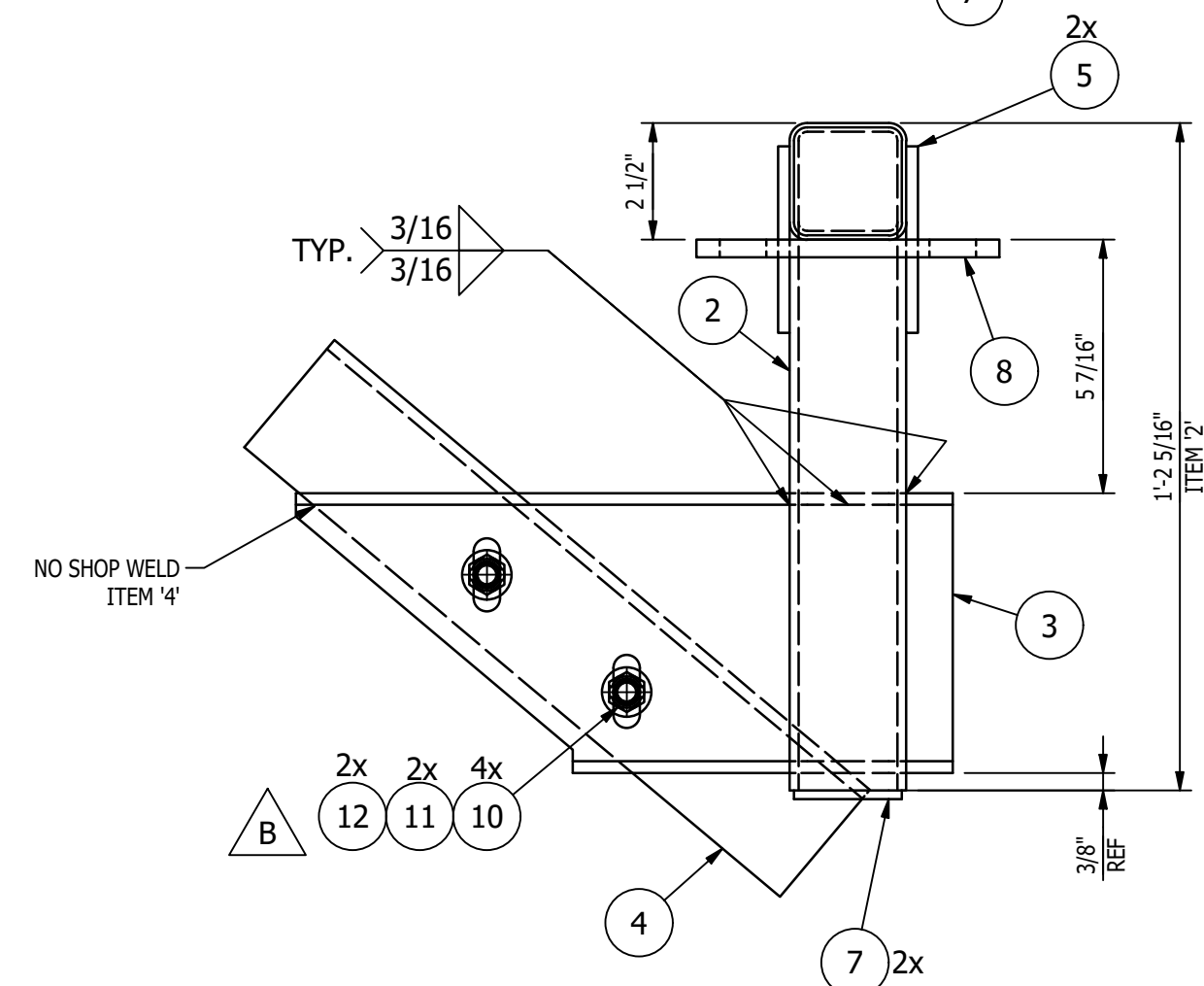


ISOVIEW OF MK-D343A
SCALE 3"=1'-0"

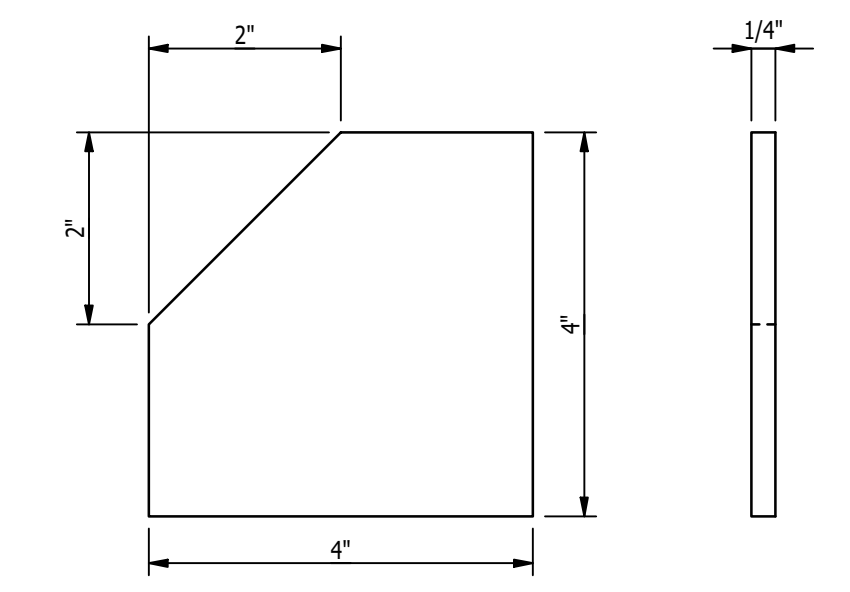
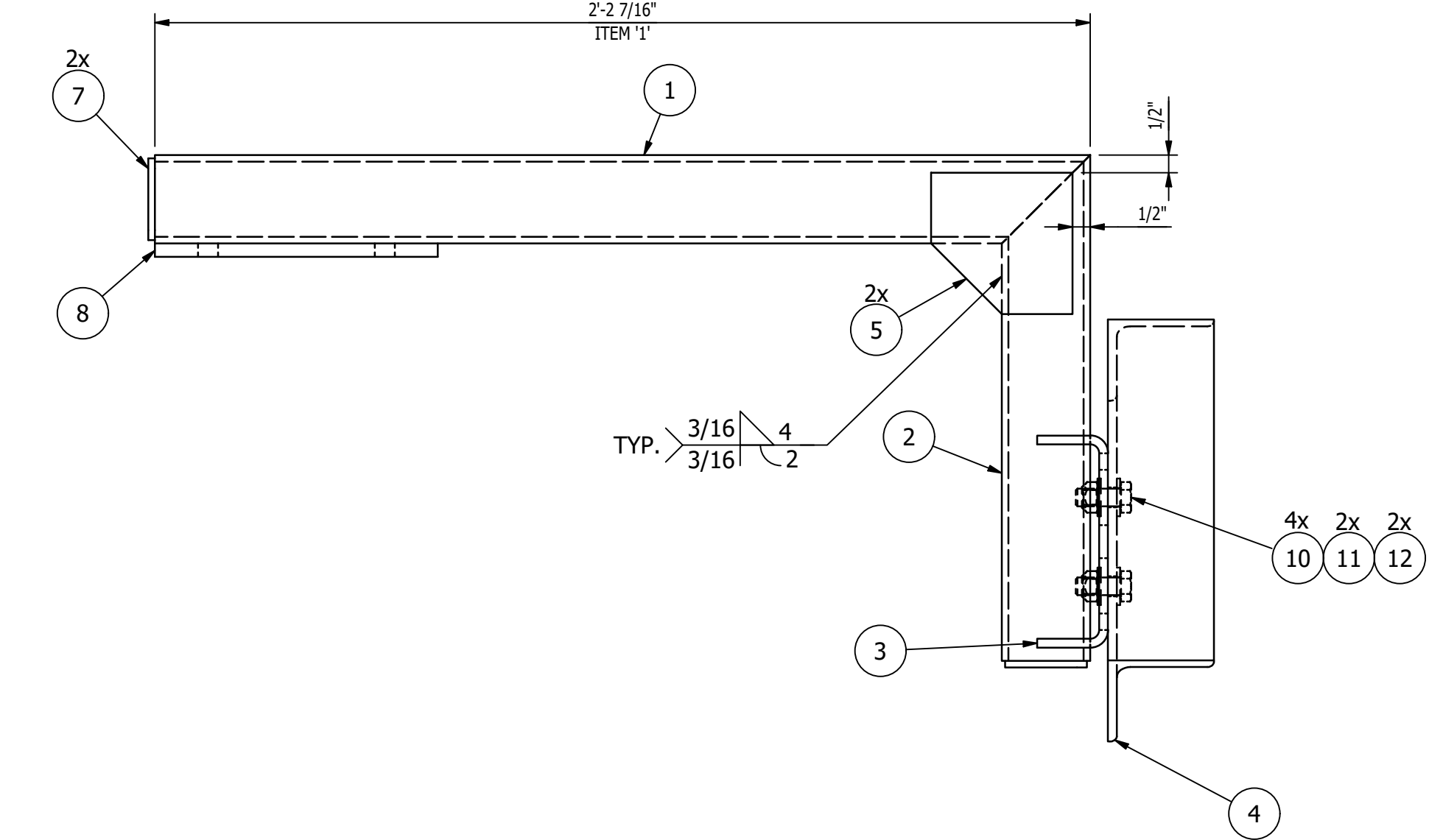


ISOVIEW OF MK-D343B
SCALE 3"=1'-0"

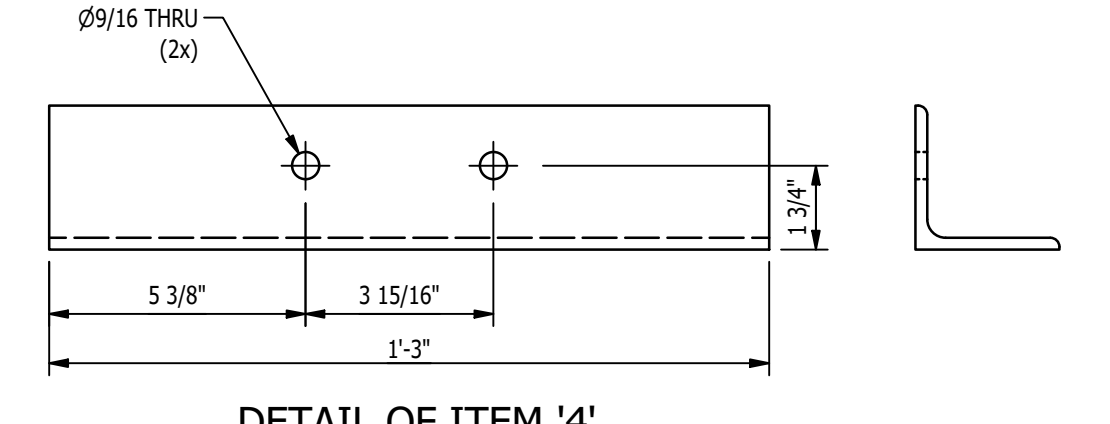
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
MK-D343A					
1	1	TS 2 1/2 x 2 1/2 x 7 GA	2'-2 7/16"		
2	1	TS 2 1/2 x 2 1/2 x 7 GA	1'-2 5/16"		
3	1	PL 1/4 x 9 1/16	1'-2 1/8"		
4	1	L 3 x 3 x 1/4	1'-3"		
5	2	BAR 1/4 x 4	4"		
7	2	PL 3/16 x 2 5/16"	2 5/16"		
8	1	BAR 3/8 x 6 1/2	8"		
10	4	1/2 TYPE A NARROW FLAT WASHER			
11	2	1/2-13UNC STOVER LOCK NUT			
12	2	1/2-13UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
MK-D343B					
1	1	TS 2 1/2 x 2 1/2 x 7 GA	2'-2 7/16"		
2	1	TS 2 1/2 x 2 1/2 x 7 GA	1'-2 5/16"		
4	1	L 3 x 3 x 1/4	1'-3"		
5	2	BAR 1/4 x 4	4"		
6	1	PL 1/4 x 9 1/16	1'-2 1/8"		
7	2	PL 3/16 x 2 5/16"	2 5/16"		
8	1	BAR 3/8 x 6 1/2	8"		
10	4	1/2 TYPE A NARROW FLAT WASHER			
11	2	1/2-13UNC STOVER LOCK NUT			
12	2	1/2-13UNC x 1 1/4" LG. HEX HEAD CAP SCREW			



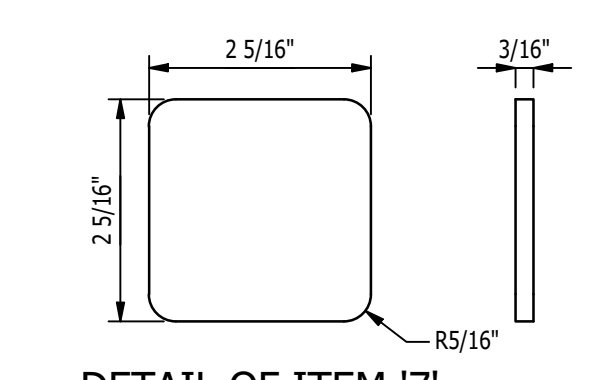
MK-D343A ~ MECHANICAL STOP TRIPPER-RH SHOWN
MK-D343B ~ MECHANICAL STOP TRIGGER-LH OPPOSITE
SCALE 3"=1'-0"



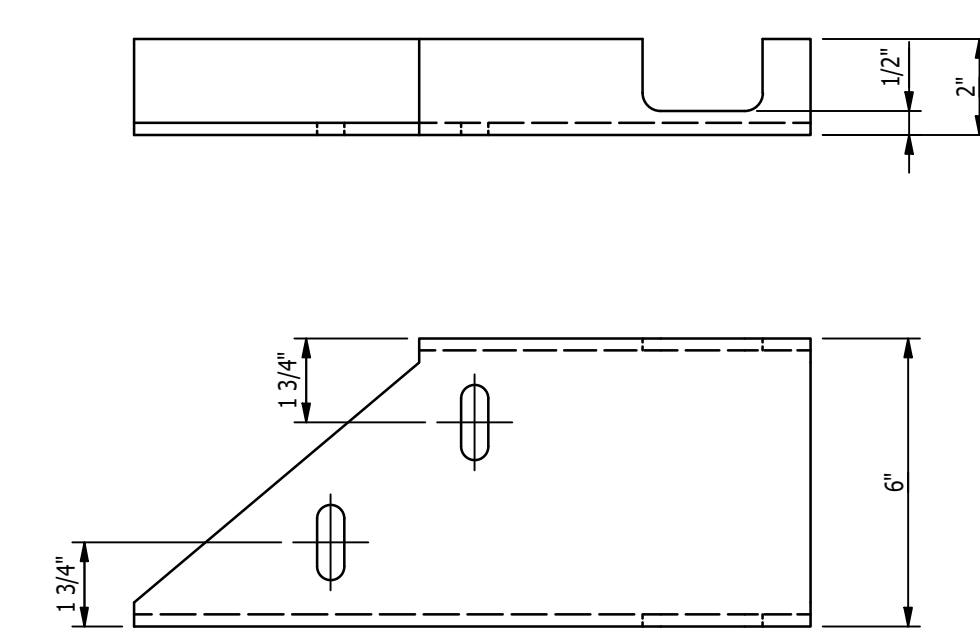
DETAIL OF ITEM '5'
SCALE 6"=1'-0"



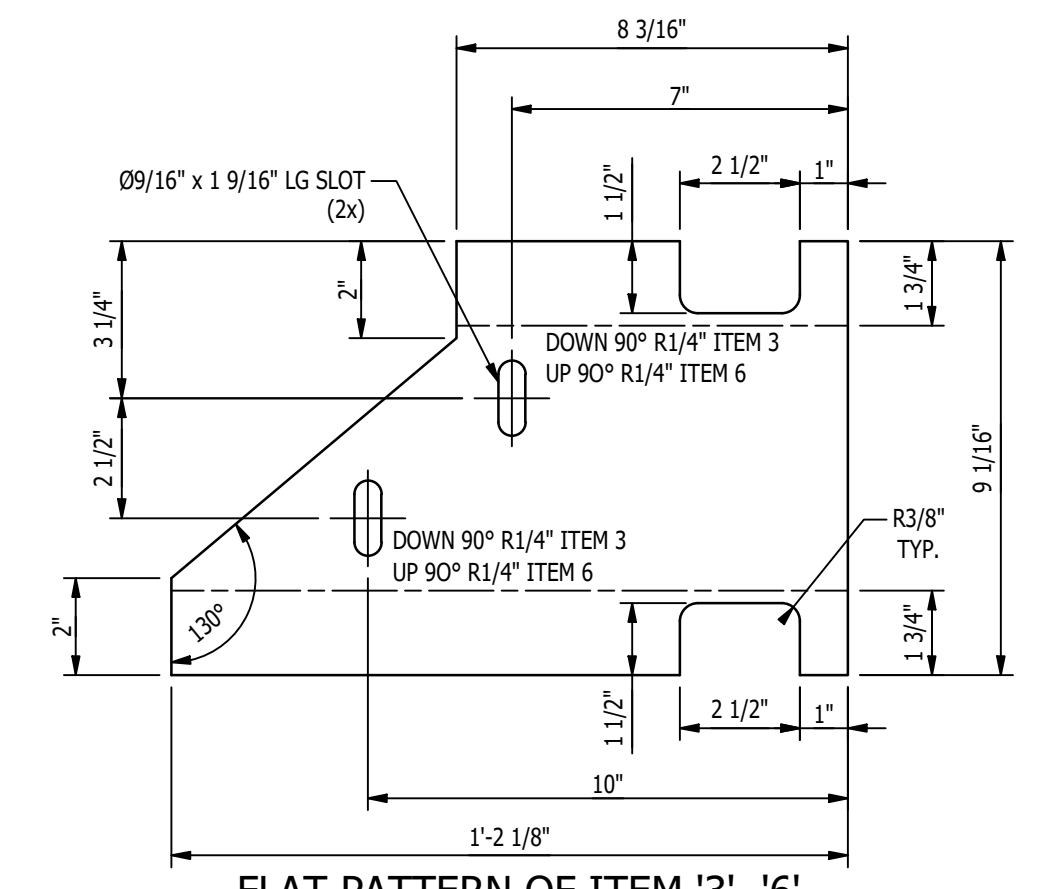
DETAIL OF ITEM '4'
SCALE 3"=1'-0"



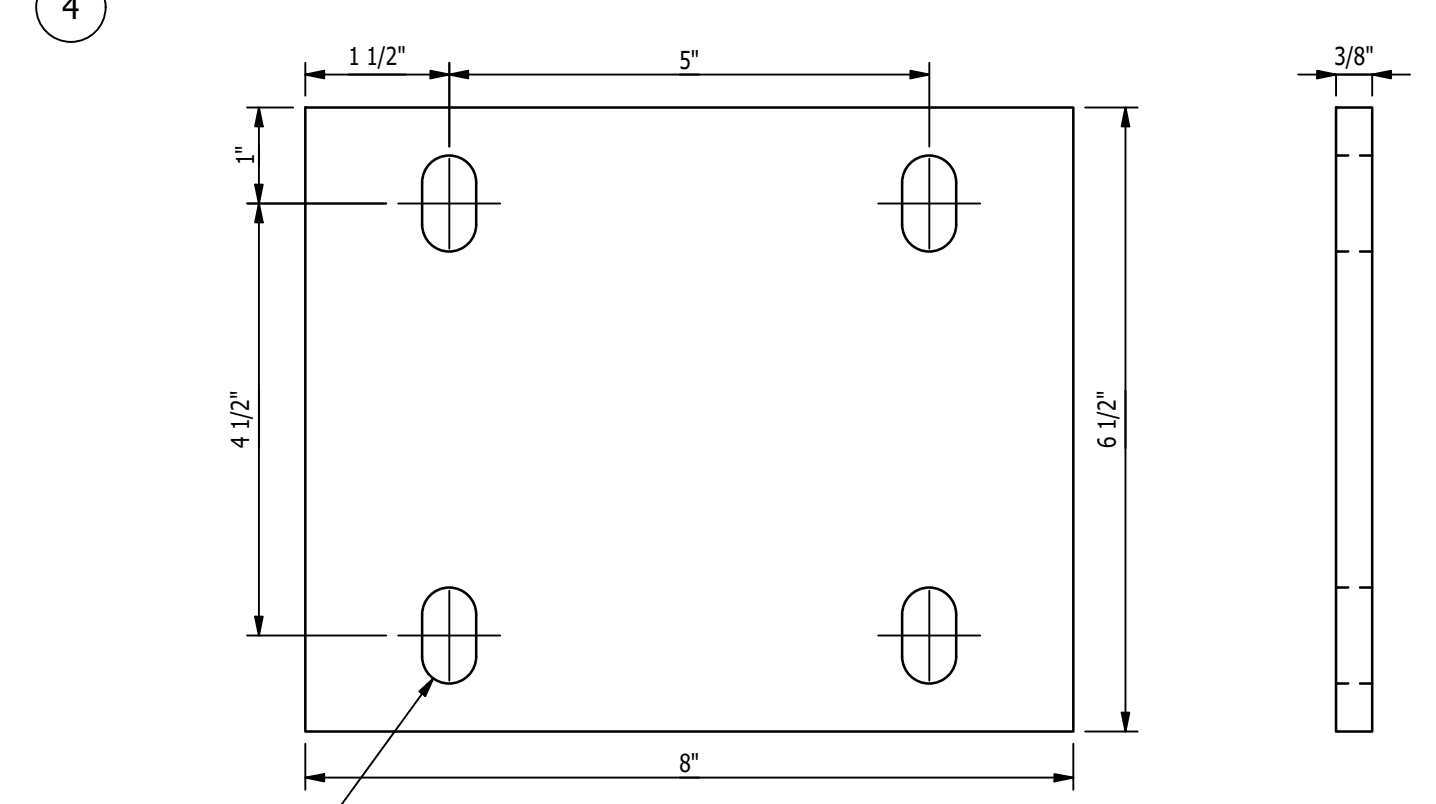
DETAIL OF ITEM '7'
SCALE 6"=1'-0"



DETAIL OF ITEM '3' (SHOWN)
DETAIL OF ITEM '6' (OPPOSITE)
SCALE 3"=1'-0"



FLAT PATTERN OF ITEM '3', '6'
SCALE 3"=1'-0"



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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	REVISED BALLOON QTYS	
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY	
B	MC 10/10/22 REVISED BALLOON QTYS
A	MC 9/16/22 FOR FABRICATION

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

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH
CLIENT: VOLVO	CHECKED BY: JCK
DRAWING No. 1875D343	DWG DATE: 7/28/22
REV: B	JOB No. 22096

MAGNUM CONSULTING
41100 Dardanelle Road
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.m4magnum.com

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

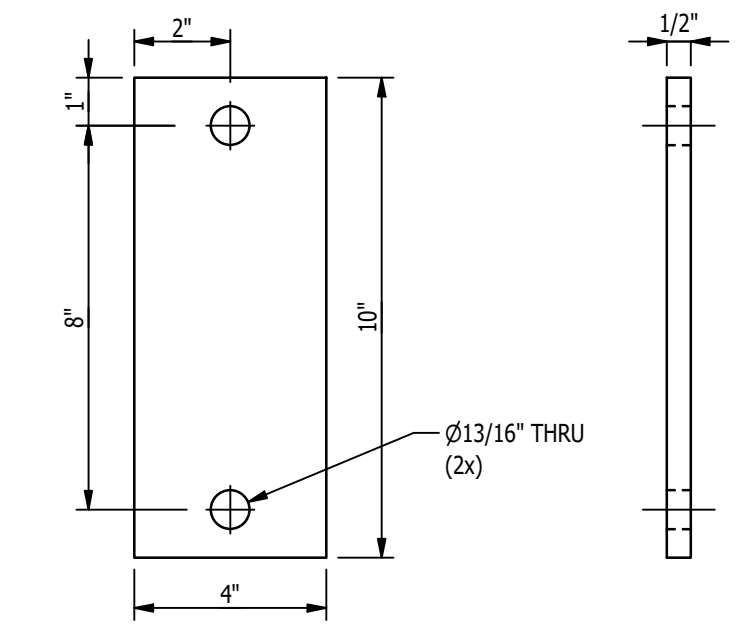
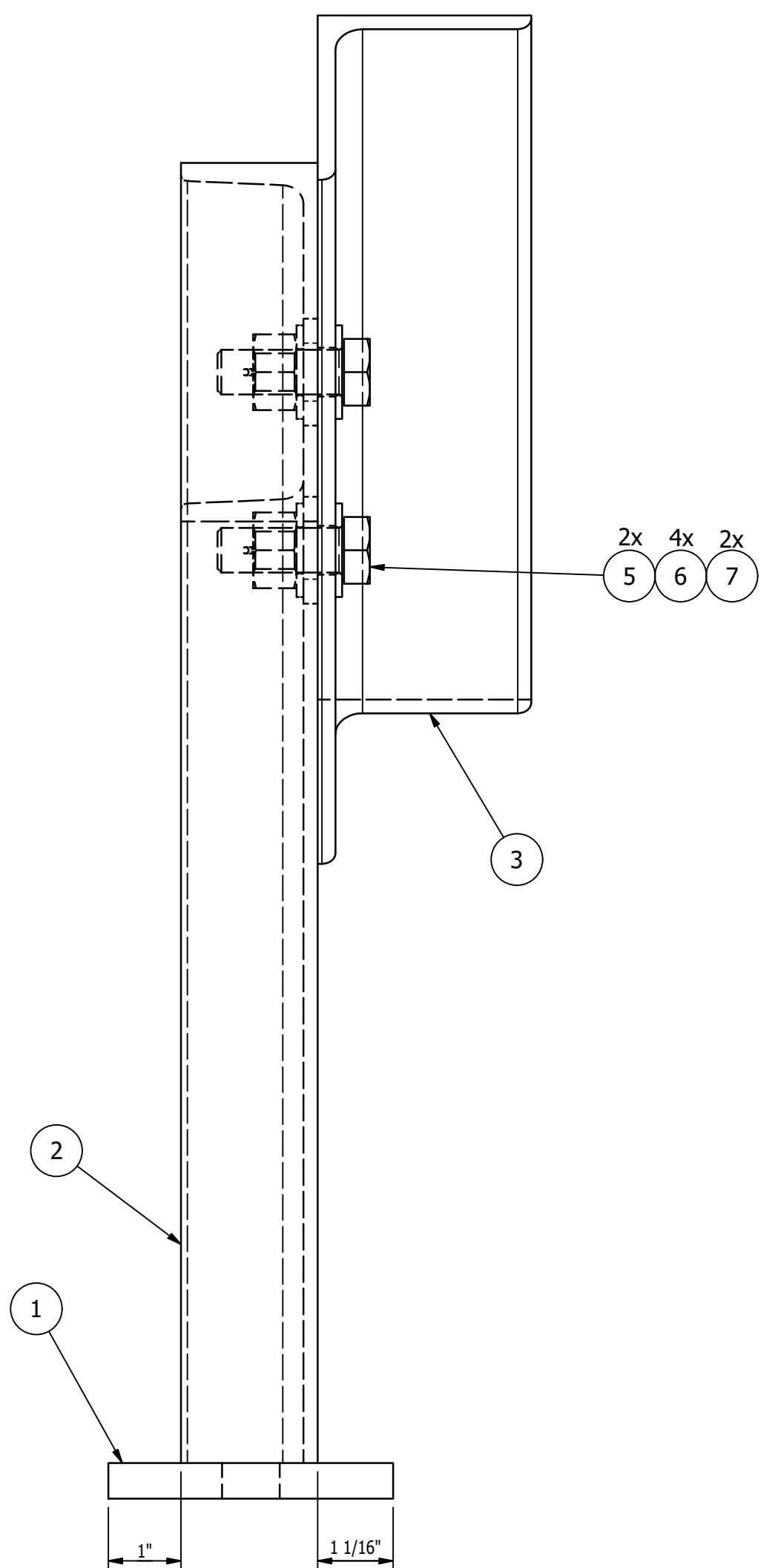
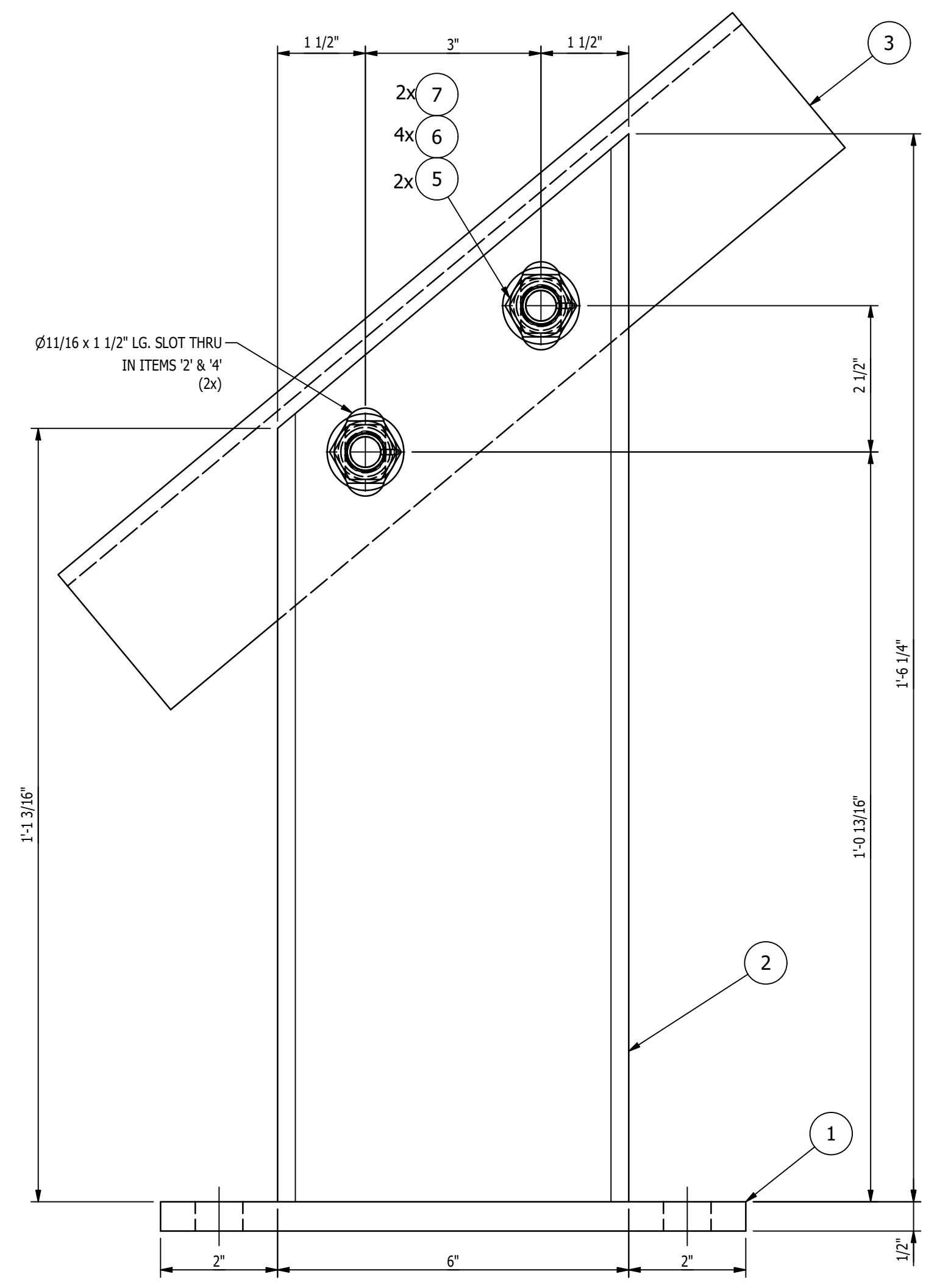
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

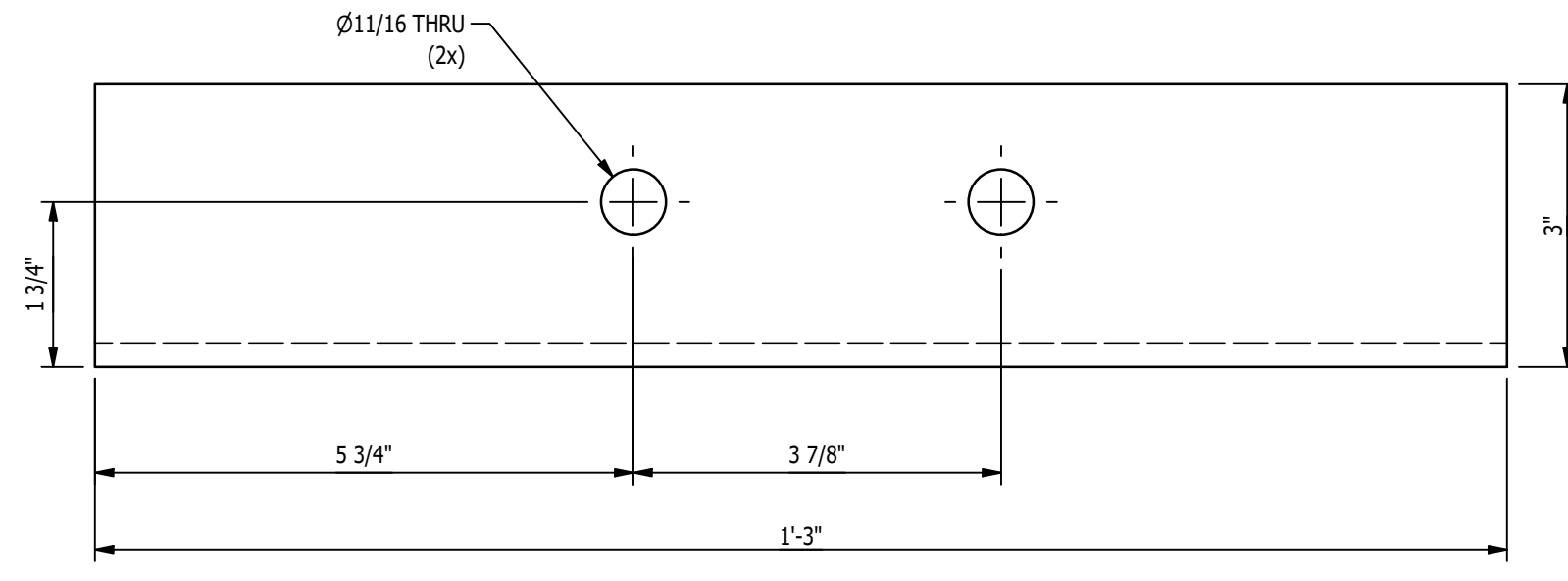
COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D345A			
1	1	BAR 1/2 x 4	10"		
2	1	C 6 x 8.2	1'-6 1/4"		
3	1	L 3 x 3 x 1/4	1'-3"		
5	2	5/8-11UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
6	4	5/8 TYPE A NARROW FLAT WASHER			
7	2	5/8-11UNC ANCO LOCK NUT A194 GR. 2H			
		MK-D345B			
1	1	BAR 1/2 x 4	10"		
3	1	L 3 x 3 x 1/4	1'-3"		
4	1	C 6 x 8.2	1'-6 1/4"		
5	2	5/8-11UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
6	4	5/8 TYPE A NARROW FLAT WASHER			
7	2	5/8-11UNC ANCO LOCK NUT A194 GR. 2H			

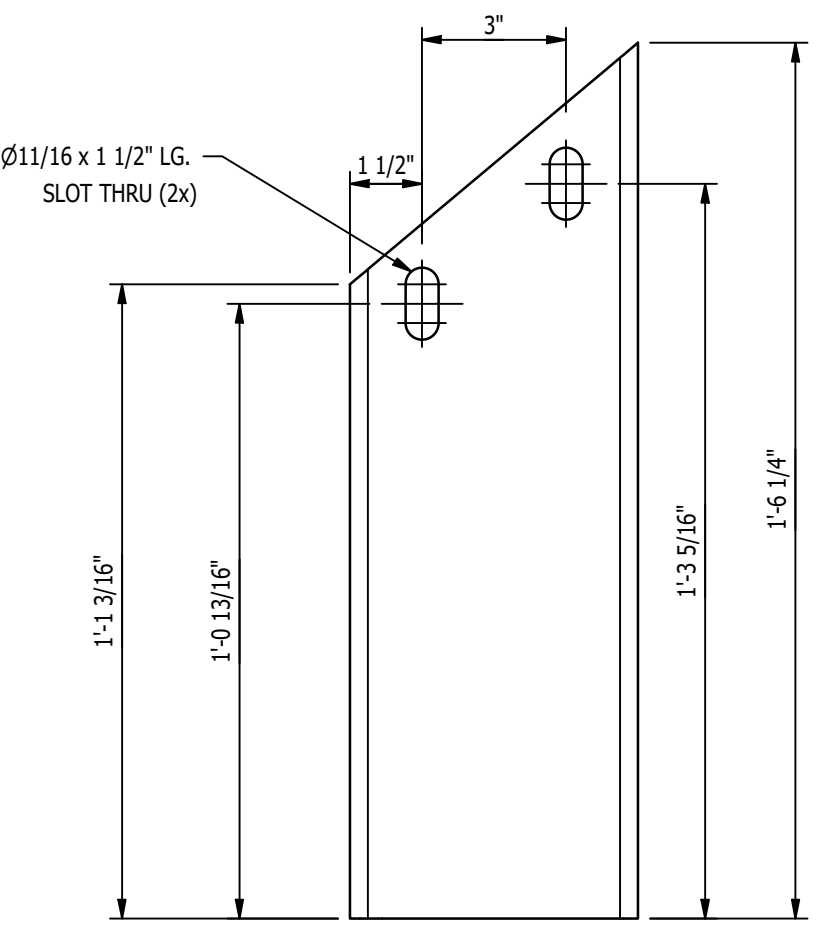


DETAIL OF ITEM '1'
SCALE 3\"/>



DETAIL OF ITEM '3'
SCALE 6\"/>

MK-D345A ~ STOP TRIPPER - FLOOR-RH SHOWN
MK-D345B ~ STOP TRIPPER - FLOOR-LH OPPOSITE
SCALE 6\"/>



DETAIL ITEM 2 (SHOWN)
DETAIL ITEM 4 (OPPOSITE)
SCALE 3\"/>

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16\"/>
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	ADDED DETAIL VIEW ITEM 2, 4	
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY

MAGNUM CONSULTING
41700 Dardick Road
Suite 125
North, MI 48135
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D345 - REV B

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

GENERAL NOTES:

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

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

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

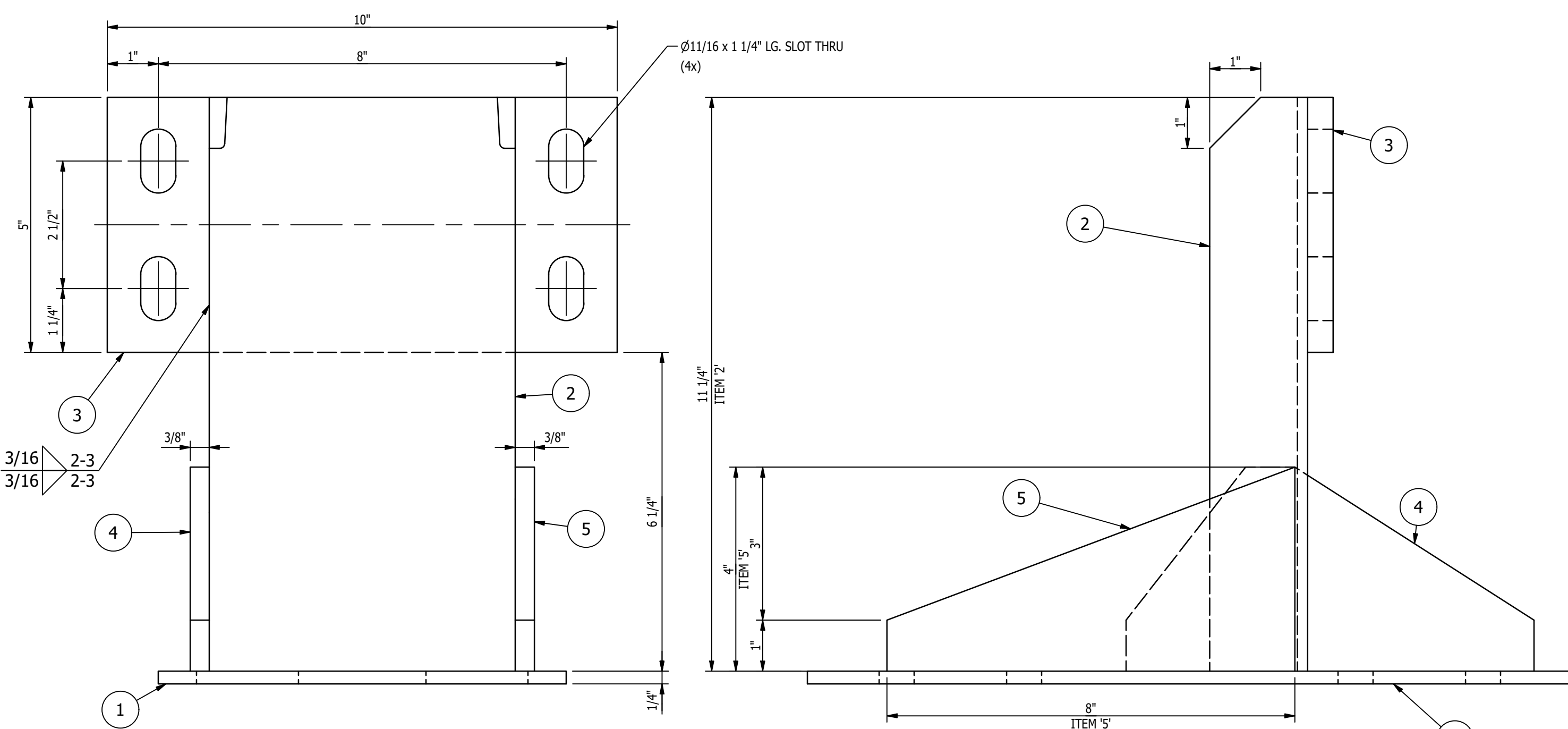
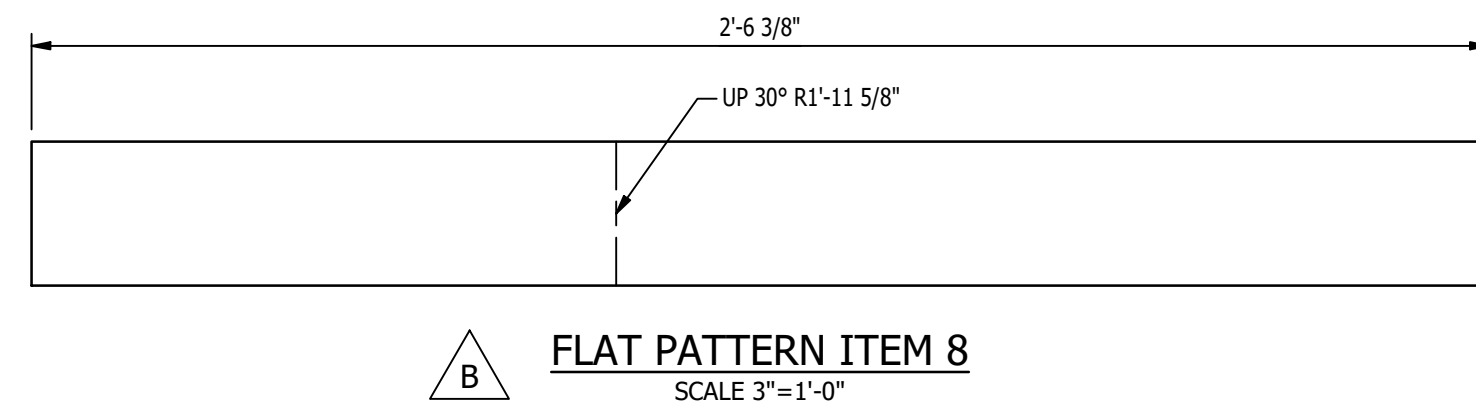
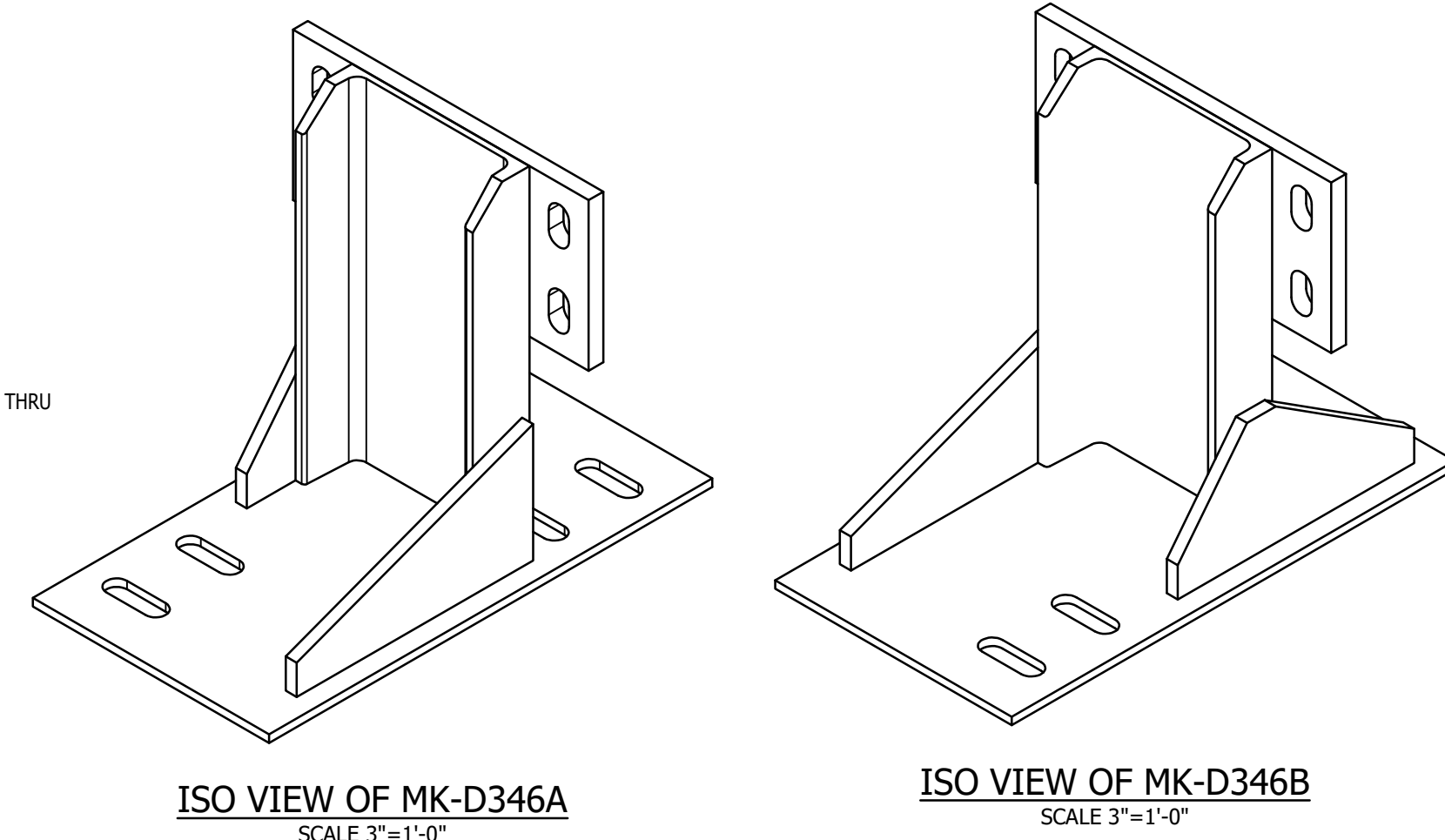
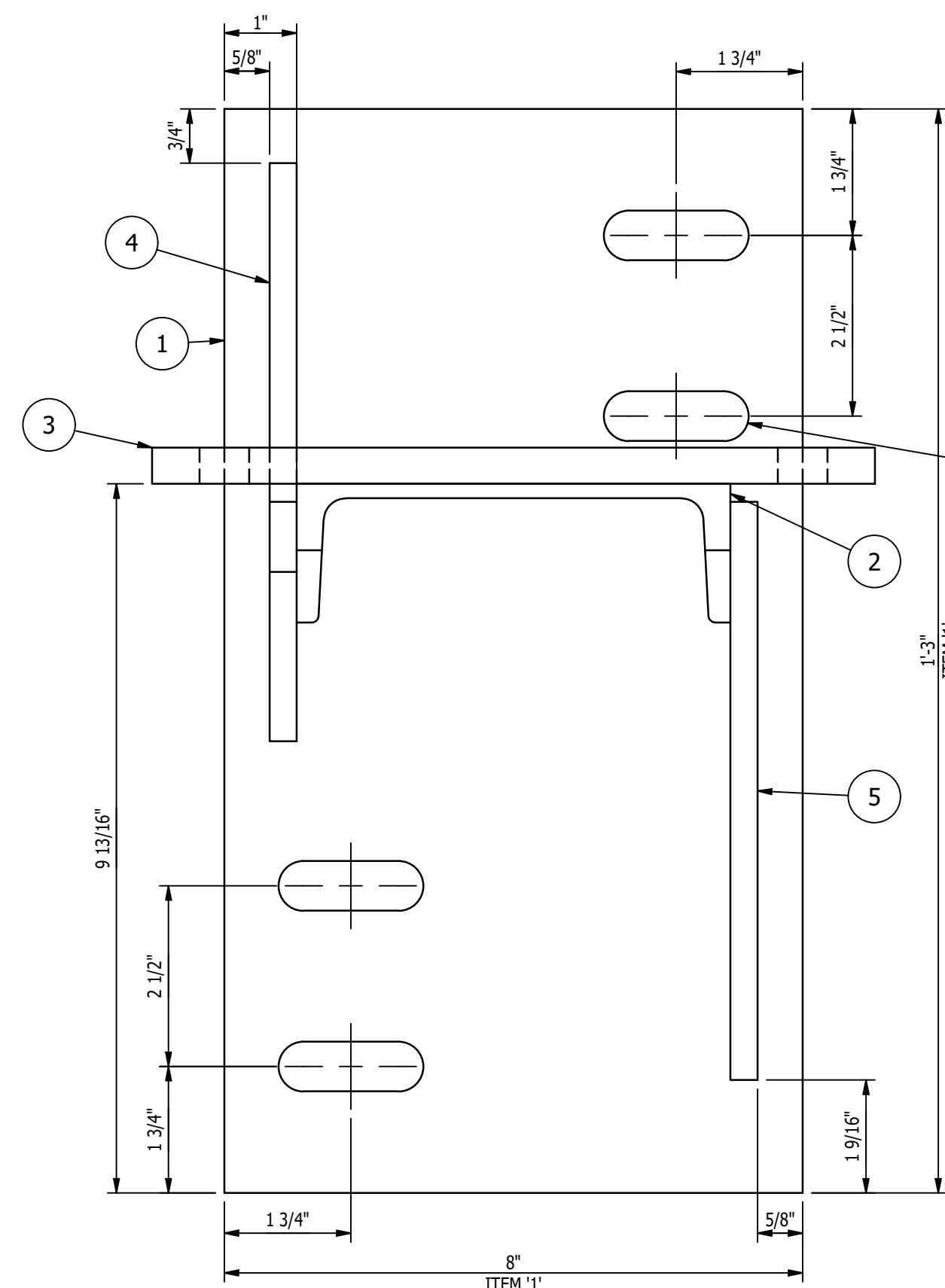
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

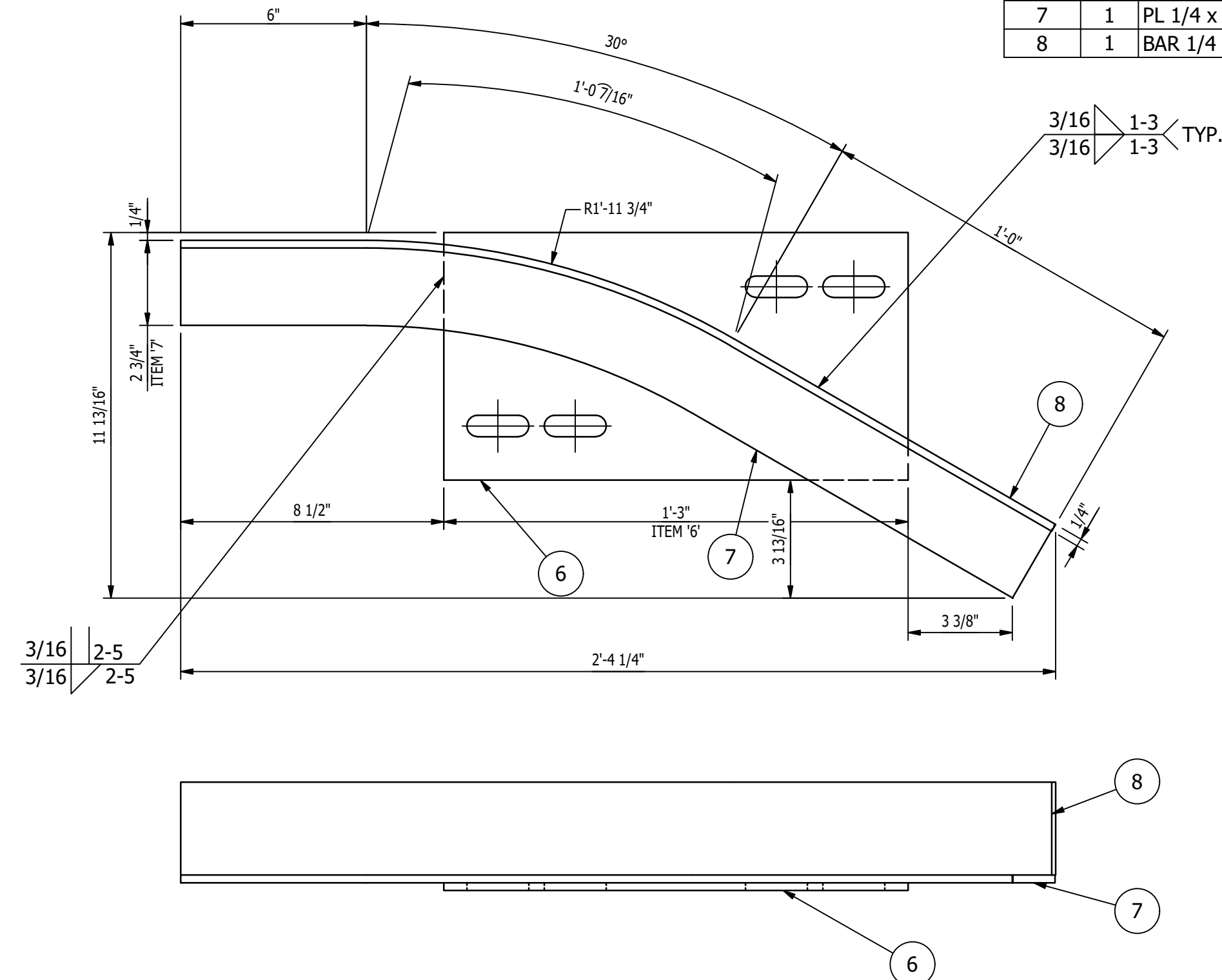
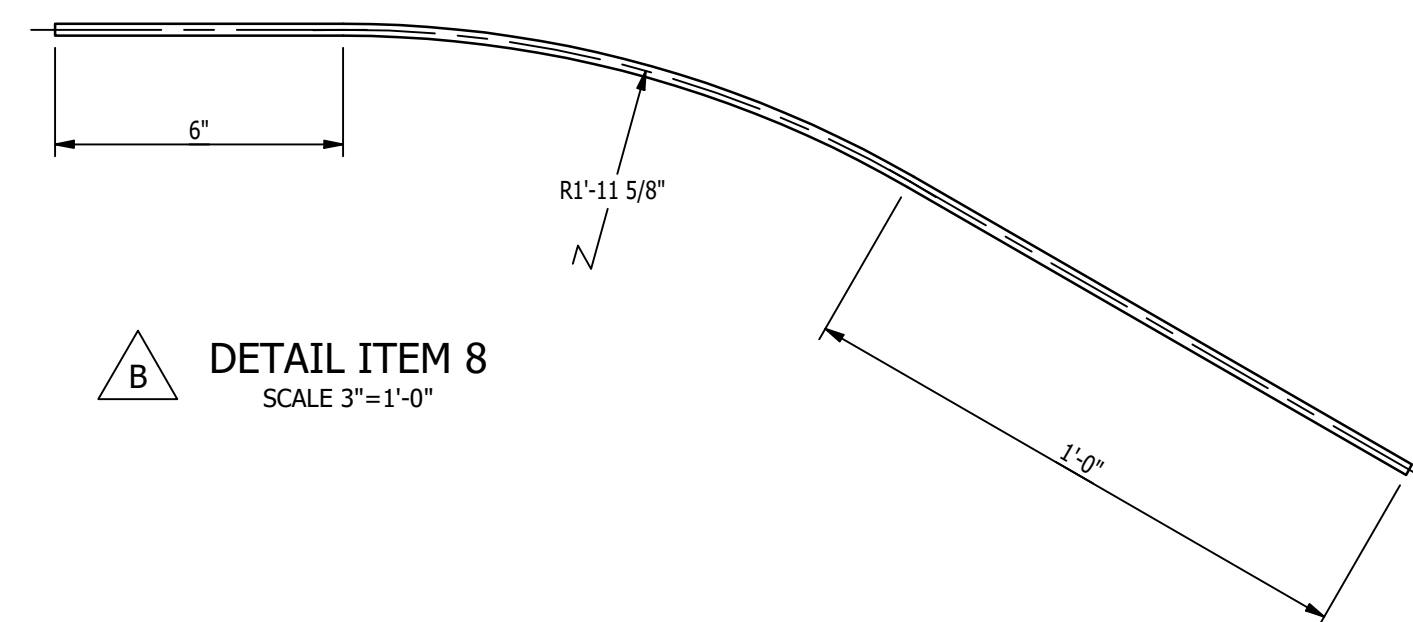
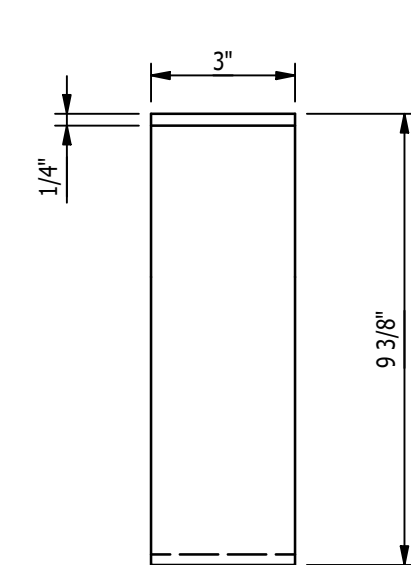
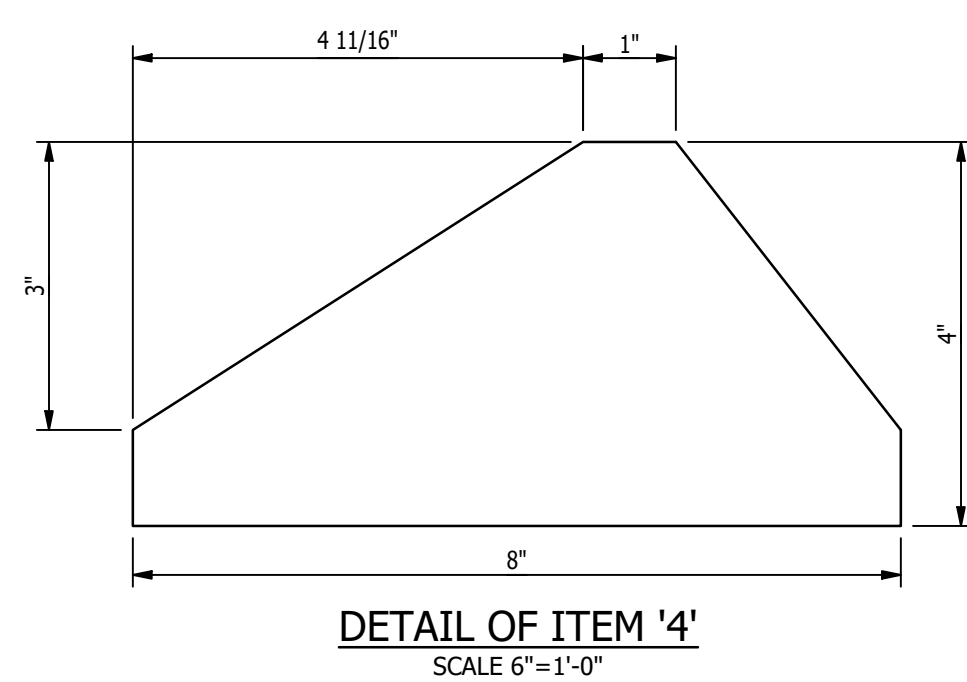
MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No.: 1875D345
REV: B

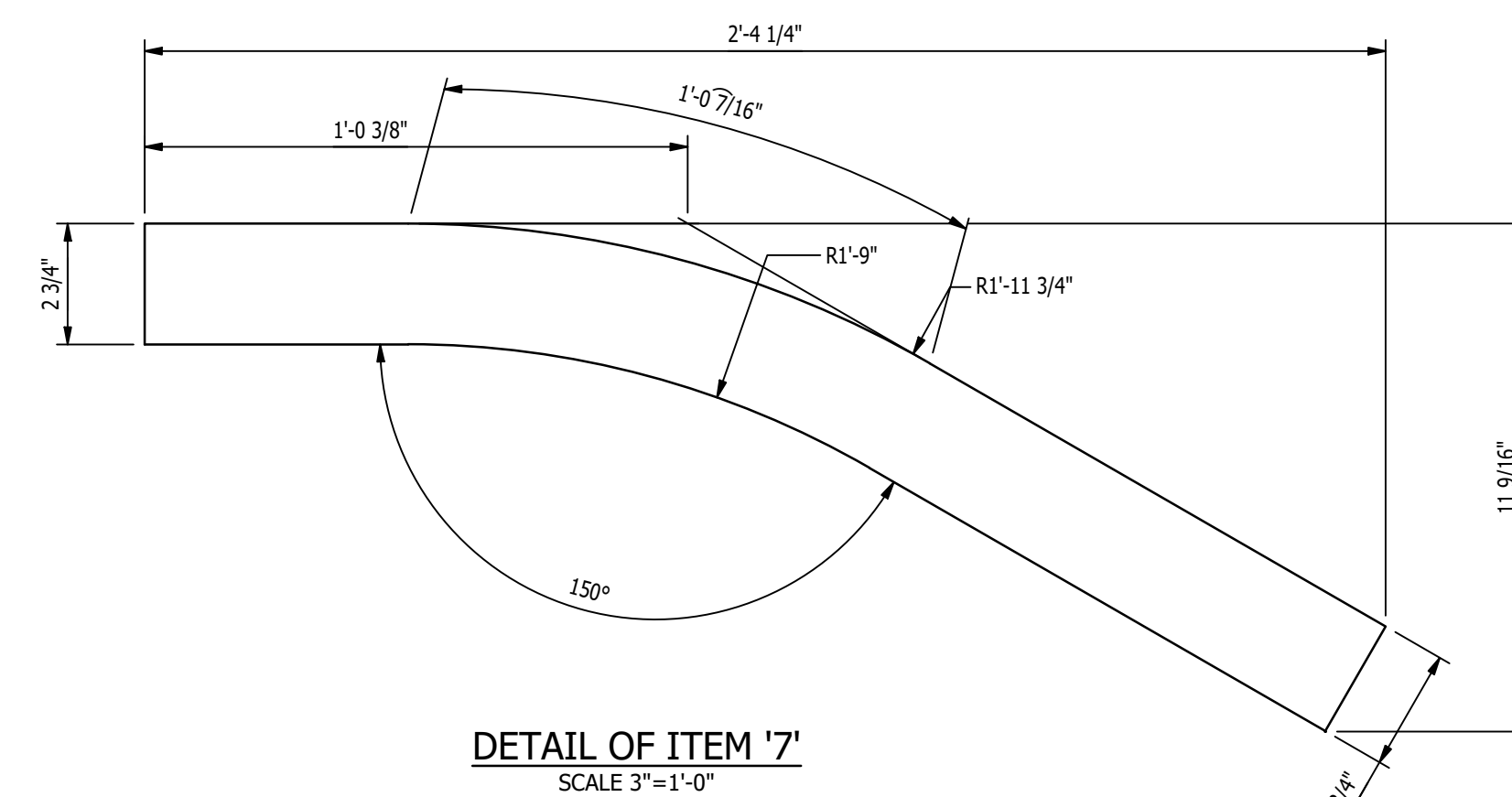
DRAWN BY: AH
CHECKED BY: JCK
DWG DATE: 7/28/22
JOB No.: 22096



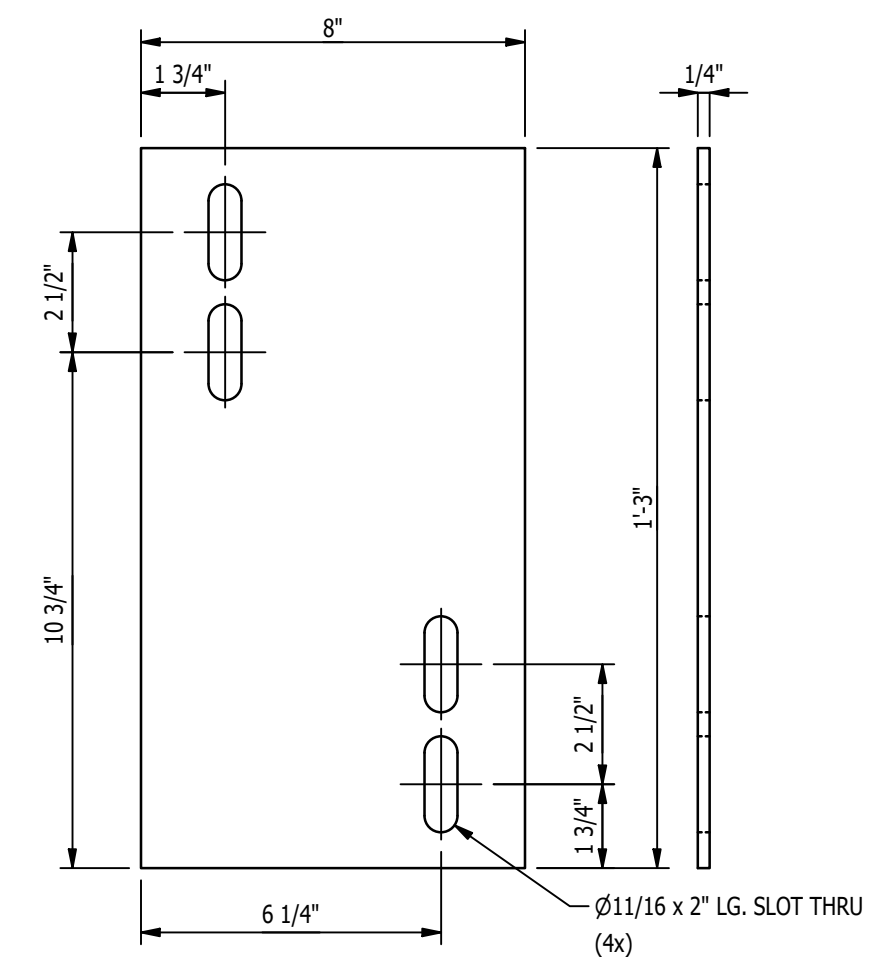
MK-D346A ~ STOP TRIPPER MEZZANINE WELDMT RH SHOWN
MK-D346B ~ STOP TRIPPER MEZZANINE WELDMT LH OPPOSITE
SCALE 6"=1'-0"



MK-D346C ~ STOP TRIPPER MEZZANINE WELDMT RH SHOWN
MK-D346D ~ STOP TRIPPER MEZZANINE WELDMT LH OPPOSITE
SCALE 3"=1'-0"



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



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D346A			
1	1	BAR 1/4 x 8	1'-3"		
2	1	C 6 x 8.2	11 1/4"		
3	1	BAR 1/2 x 5	10"		
4	1	BAR 3/8 x 4	8"		
5	1	BAR 3/8 x 4	8"		
		MK-D346B			
1	1	BAR 1/4 x 8	1'-3"		
2	1	C 6 x 8.2	11 1/4"		
3	1	BAR 1/2 x 5	10"		
4	1	BAR 3/8 x 4	8"		
5	1	BAR 3/8 x 4	8"		
		MK-D346C			
6	1	BAR 1/4 x 8	1'-3"		
7	1	PL 1/4 x 11 9/16"	2'-4 1/4"		
8	1	BAR 1/4 x 3	4'-0"		
		MK-D346D			
6	1	BAR 1/4 x 8	1'-3"		
7	1	PL 1/4 x 11 9/16"	2'-4 1/4"		
8	1	BAR 1/4 x 3	2'-6 3/8"		

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	ADDED DETAIL AND FLAT PATTERN ITEM 8, CHANGED LENGTH ITEM 8	
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

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

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

WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

MAGNUM CONSULTING
41100 Garfieldwood Rd
Suite 125
North, MI 48125
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D346 - 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

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. **1875D346**

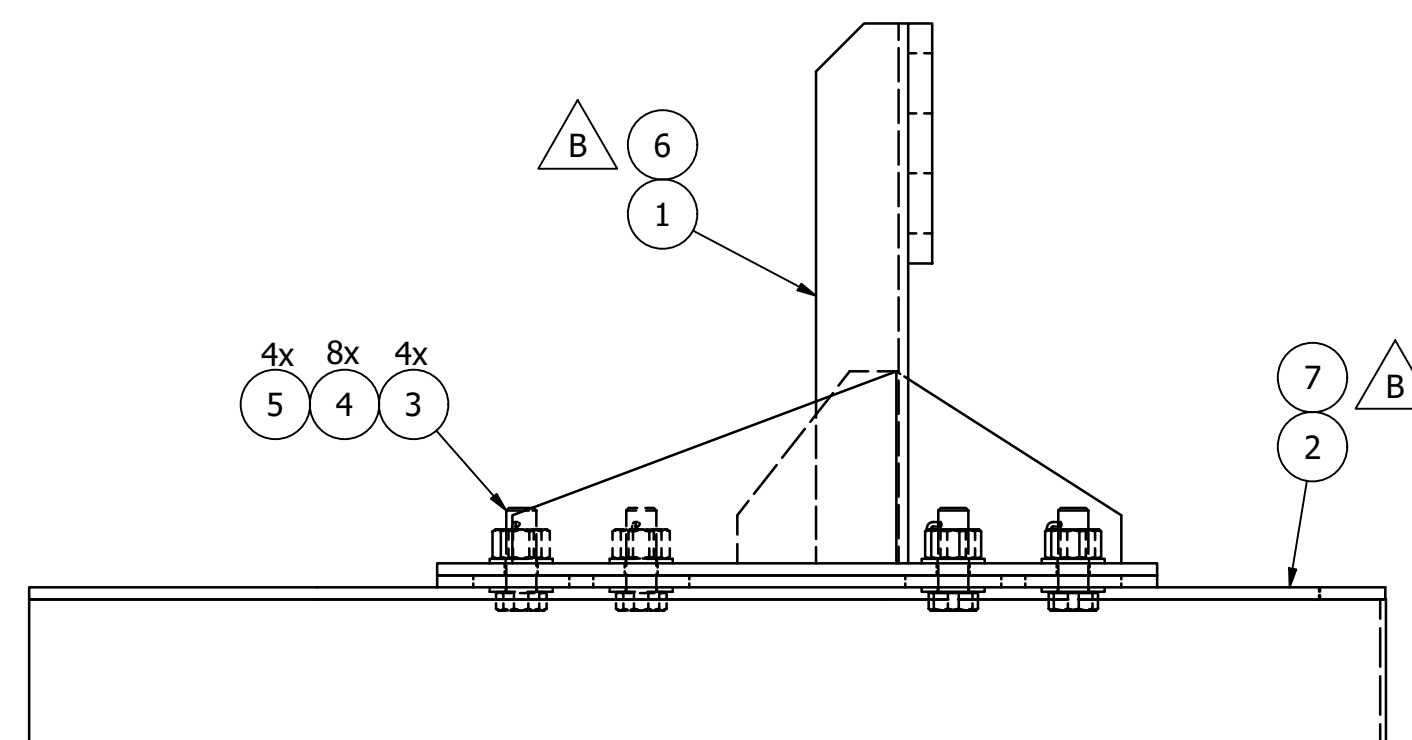
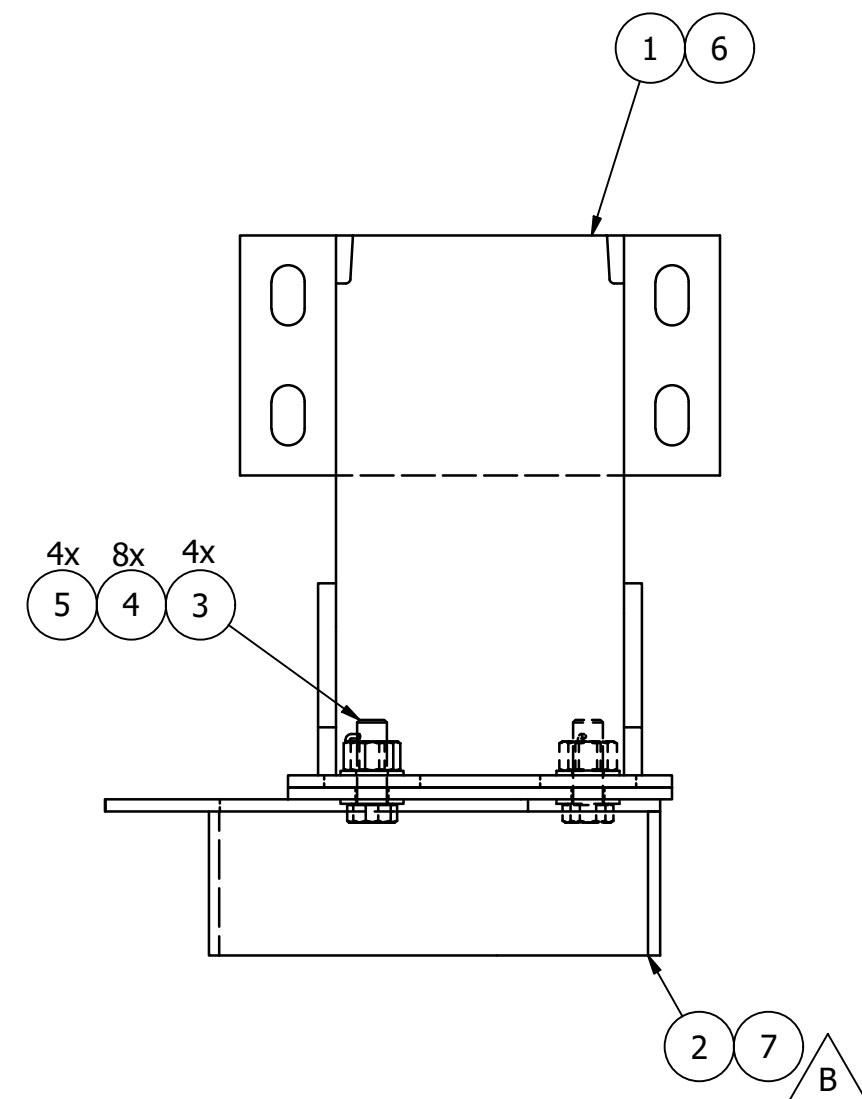
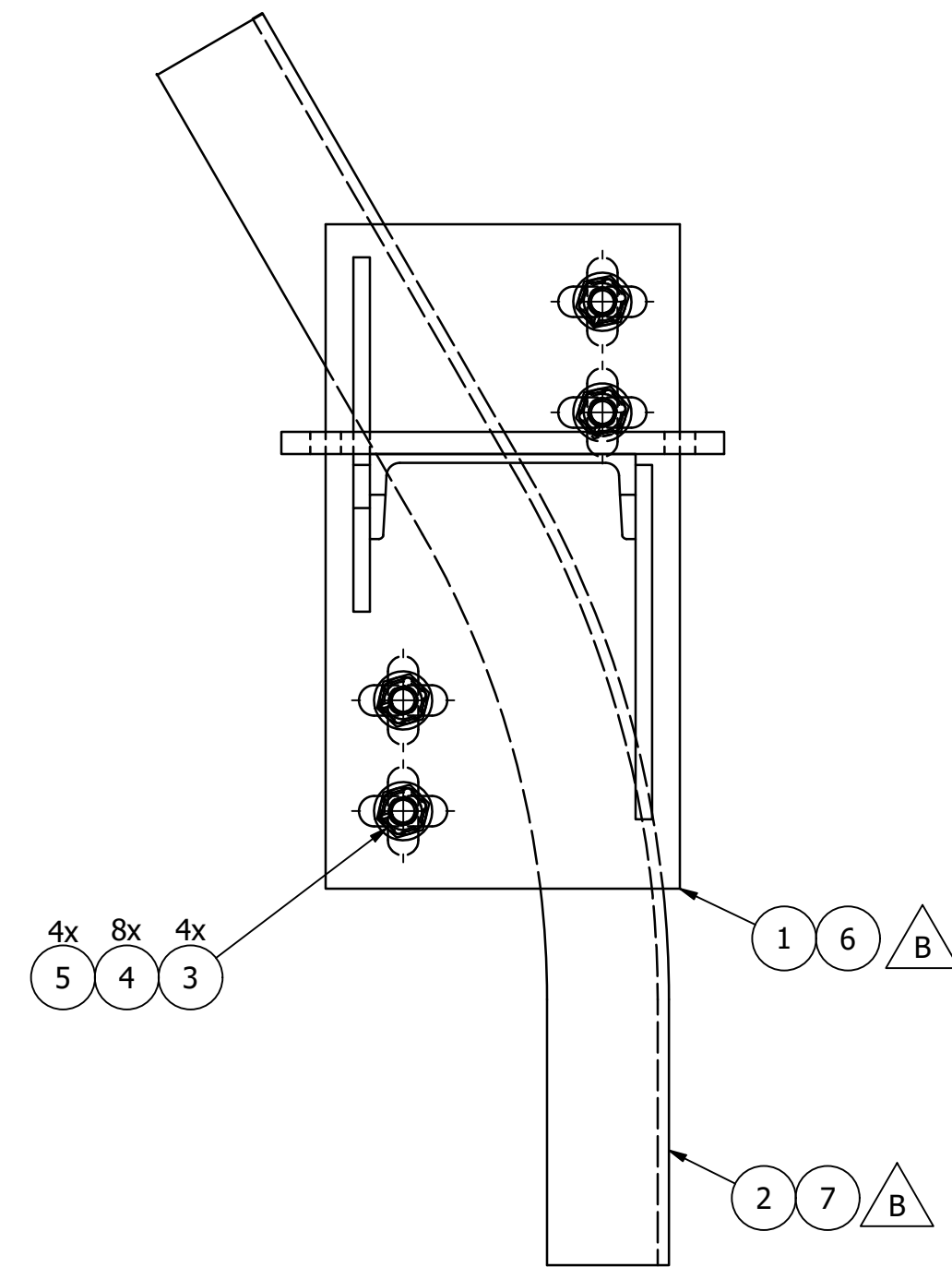
REV: **B**

DRAWN BY: **AH**

CHECKED BY: **JCK**

DWG DATE: **7/28/22**

JOB No: **22096**



MK-D347A ~ STOP TRIPPER MEZZANINE RH SHOWN
 MK-D347B ~ STOP TRIPPER MEZZANINE LH OPPOSITE
 SCALE 3"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D347A			
1	1	MK-D346A ~ STOP TRIPPER MEZZANINE WELDMENT RH			
2	1	MK-D346C ~ STOP TRIPPER MEZZANINE WELDMENT RH			
3	4	5/8-11UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
4	8	5/8 TYPE A NARROW FLAT WASHER			
5	4	5/8-11UNC ANCO LOCK NUT A194 GR. 2H			
		MK-D347B			
3	4	5/8-11UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
4	8	5/8 TYPE A NARROW FLAT WASHER			
5	4	5/8-11UNC ANCO LOCK NUT A194 GR. 2H			
6	1	MK-D346B ~ STOP TRIPPER MEZZANINE WELDMENT LH			
7	1	MK-D346D ~ STOP TRIPPER MEZZANINE WELDMENT LH			

B
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.

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	REVISED BALLOONS, ITEMS IN BOM	
A	MC	9/16/22	FOR FABRICATION	

REVISION HISTORY	
DESCRIPTION	APP

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

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH
CLIENT: VOLVO	CHECKED BY: JCK
DRAWING No. 1875D347	DWG DATE: 7/28/22
REV: B	JOB No: 22096

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

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

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D347 - REV B

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

GENERAL NOTES:

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

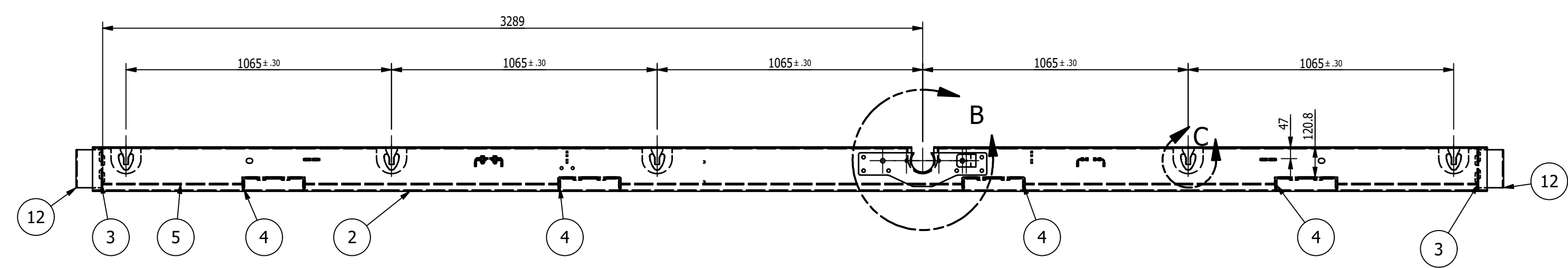
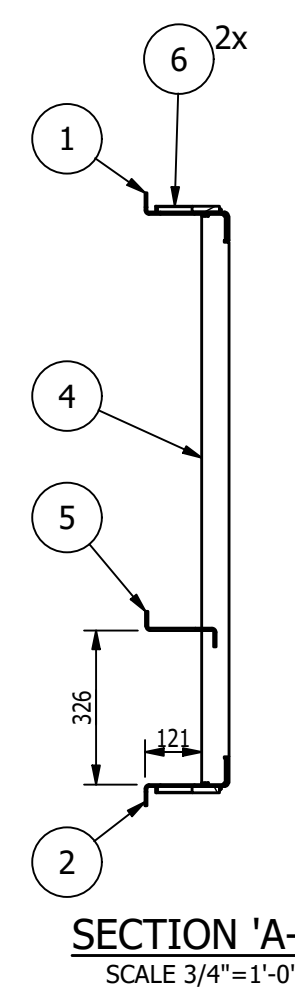
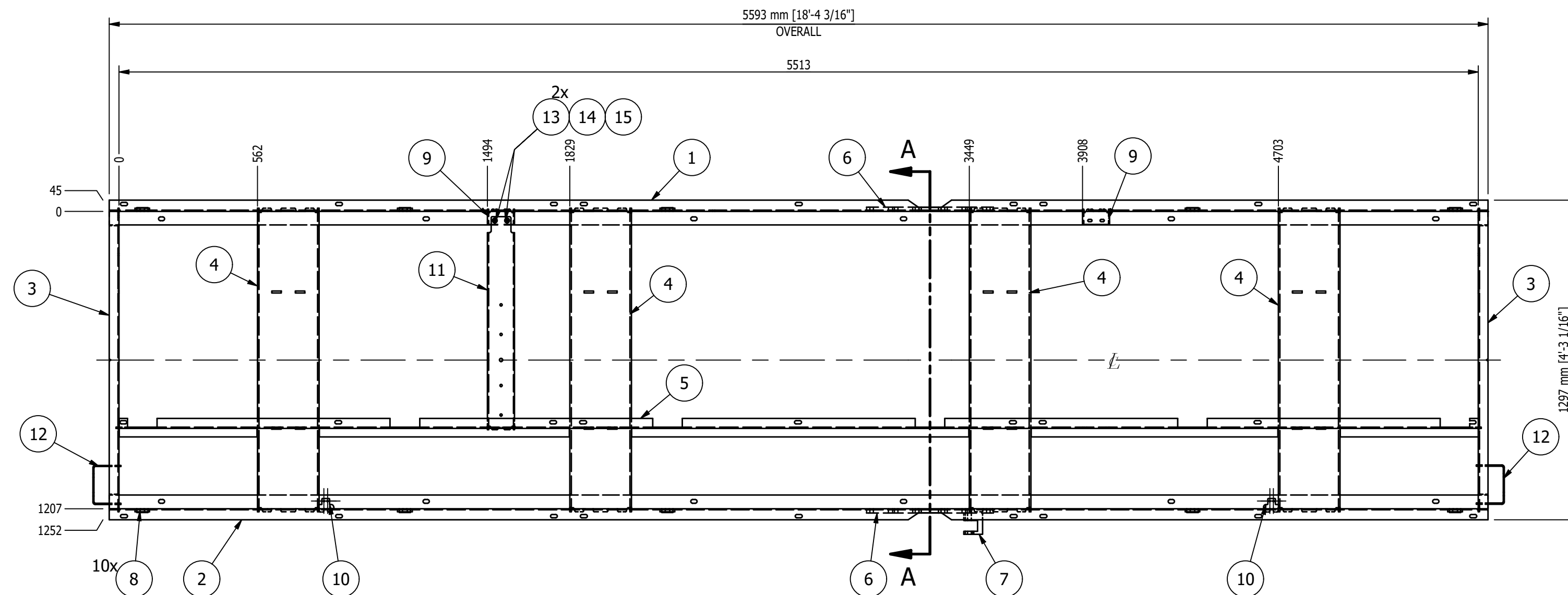
HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

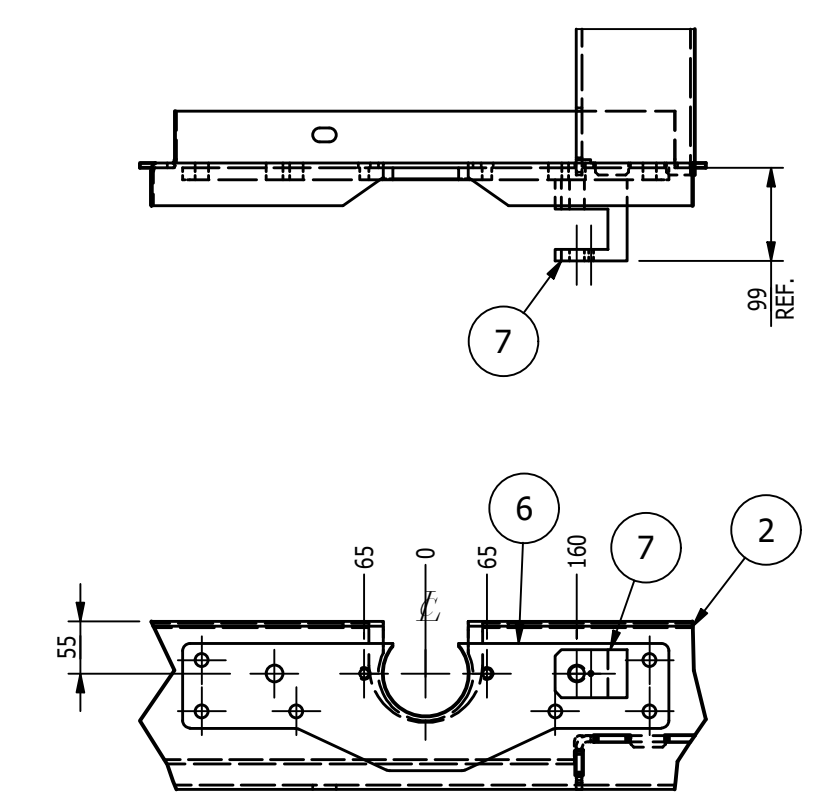
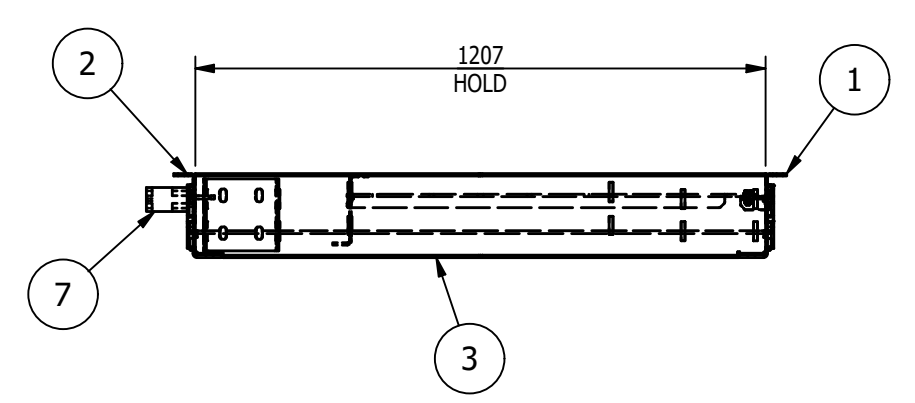
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

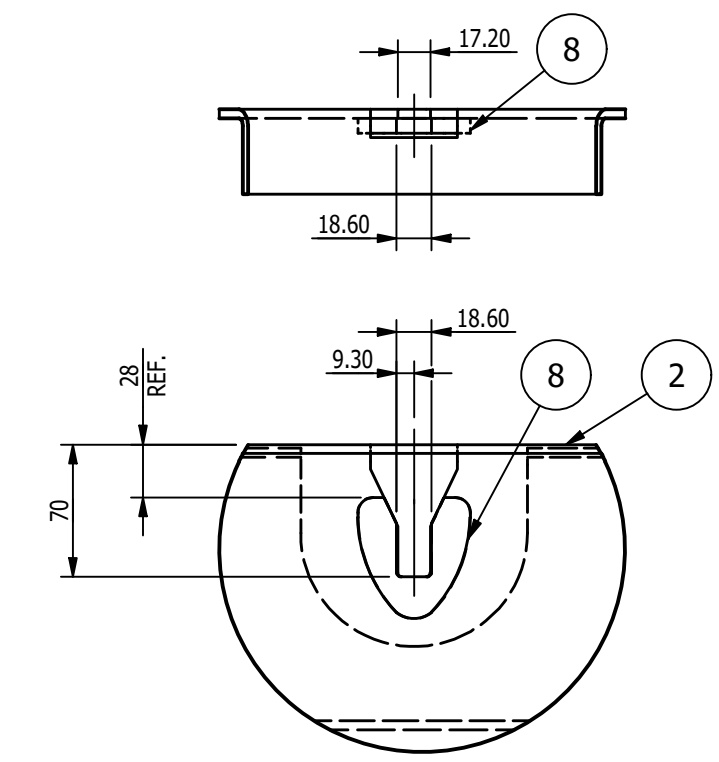
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D350A			
1	1	MK-D351A ~ SIDE FRAME			
2	1	MK-D352A ~ SIDE FRAME			
3	2	MK-D353A ~ END FRAME			
4	4	MK-D354A ~ INNER CROSS MEMBER			
5	1	MK-D356A ~ MID FRAME			
6	2	MK-D111A ~ MOTOR MOUNTING PLATE			
7	1	MK-D111D ~ CLEVIS			
8	10	MK-D111B ~ RETAINER			
9	2	MK-D113A ~ BRACKET			
10	2	MK-D113B ~ ENCODER BRACKET			
11	1	MK-D118A ~ BAR CODE READER BRKT			
12	2	MK-D359A ~ GRAVITY STOP EXTENSION			
13	4	M8 NARROW FLAT WASHER			
14	2	M8x1.25 x 25mm LG. HEX CAP SCREW			
15	2	M8 x 1.25 STOVER LOCK NUT			



MK-D350A ~ D-LOC PRB6 FRAME WELDMENT
SCALE 3/4"=1'-0"



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



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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	UPDATED GEOMETRY	
A	MC	8-8-2022	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: JC
CLIENT: VOLVO	CHECKED BY: JCK
DRAWING No. 1875D350	DWG DATE: 7/28/22
REV: B	JOB No: 22096

MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
North, MI 48075
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)

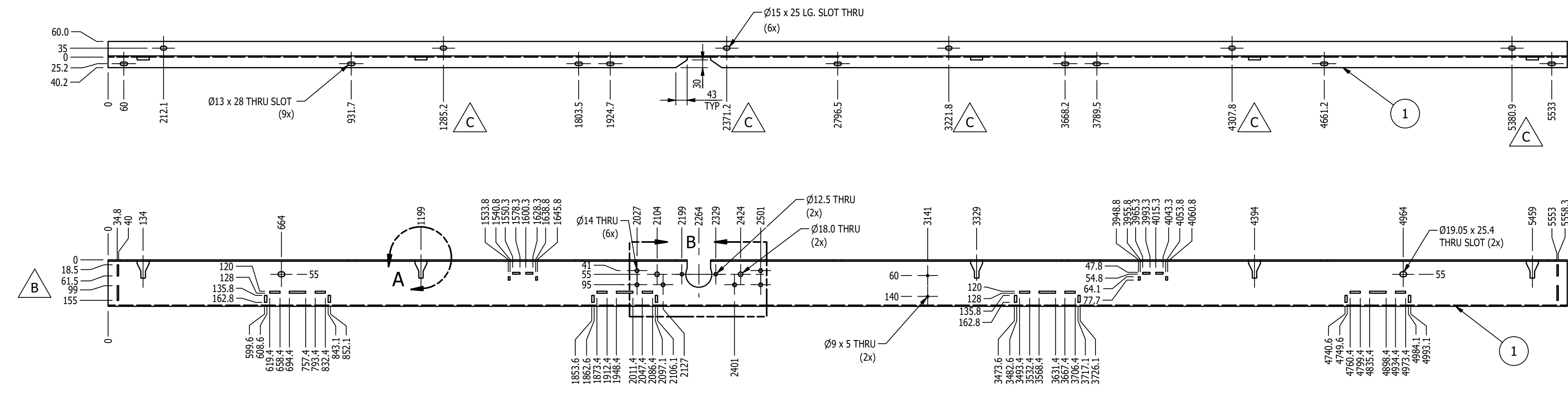
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

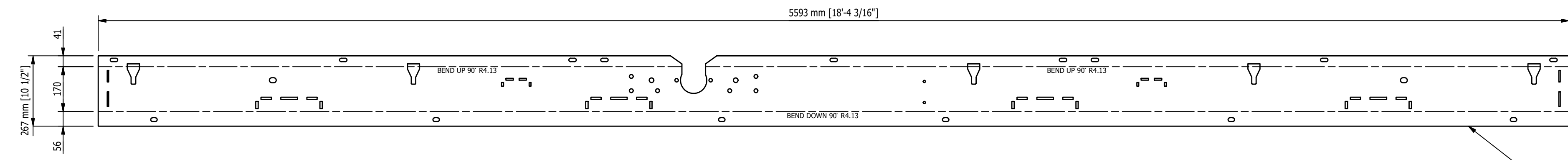
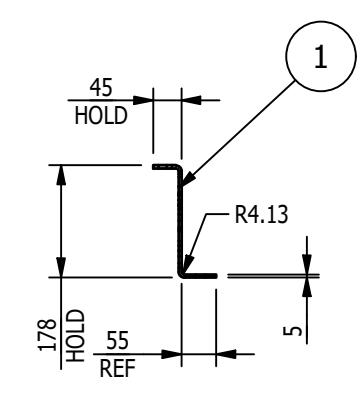
COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	PL 3/16 x 10 1/2"	18'-4 3/16"		



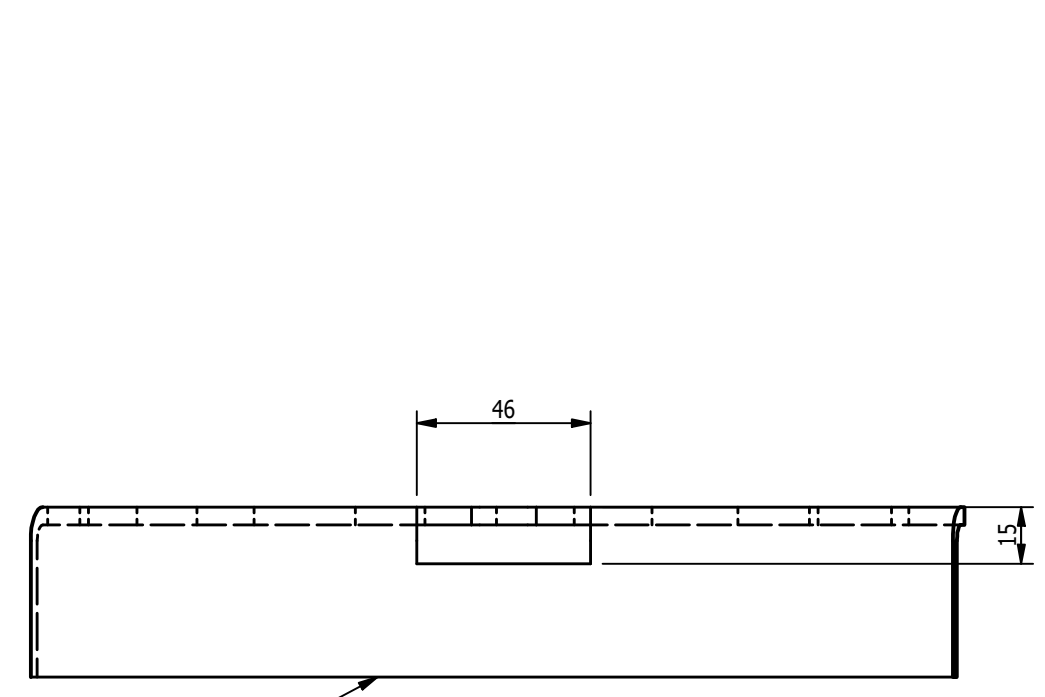
MK-D351A ~ SIDE FRAME
SCALE 1"=1'-0"



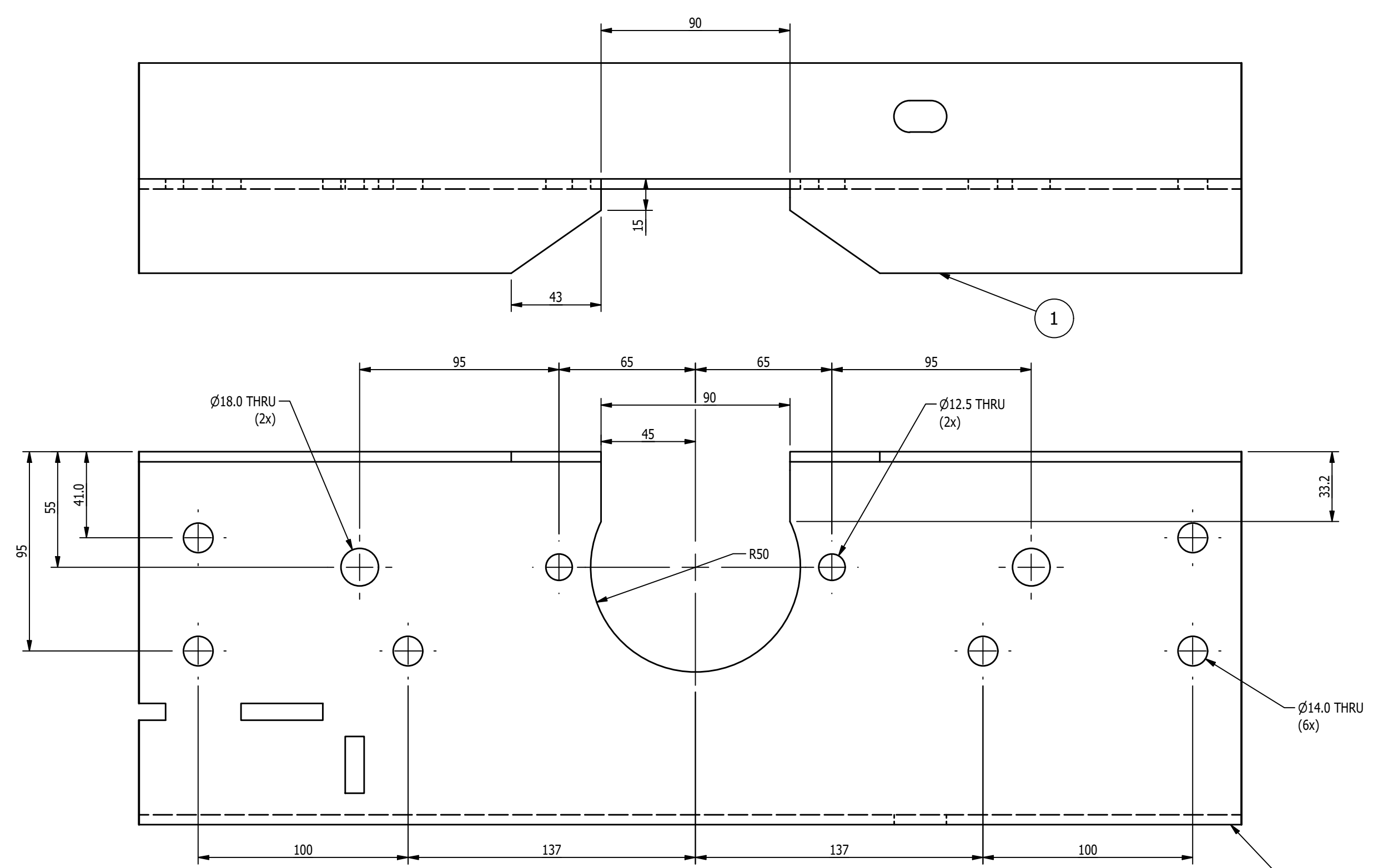
FLAT PATTERN OF ITEM '1'
SCALE 1"=1'-0"

- 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:
NO PAINT



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



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

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/30/22	CORRECTED THE SLOT SPACING	
B	MC	8/19/2022	REVISED END SLOT DIMENSIONS & FILLETED ROLL BED SLOTS	
A	MC	8-8-2022	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: AH		CHECKED BY: JCK	
CLIENT: VOLVO		DWG DATE: 7/28/22		JOB No: 22096	
DRAWING No. 1875D351		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 SNUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

MAGNUM CONSULTING

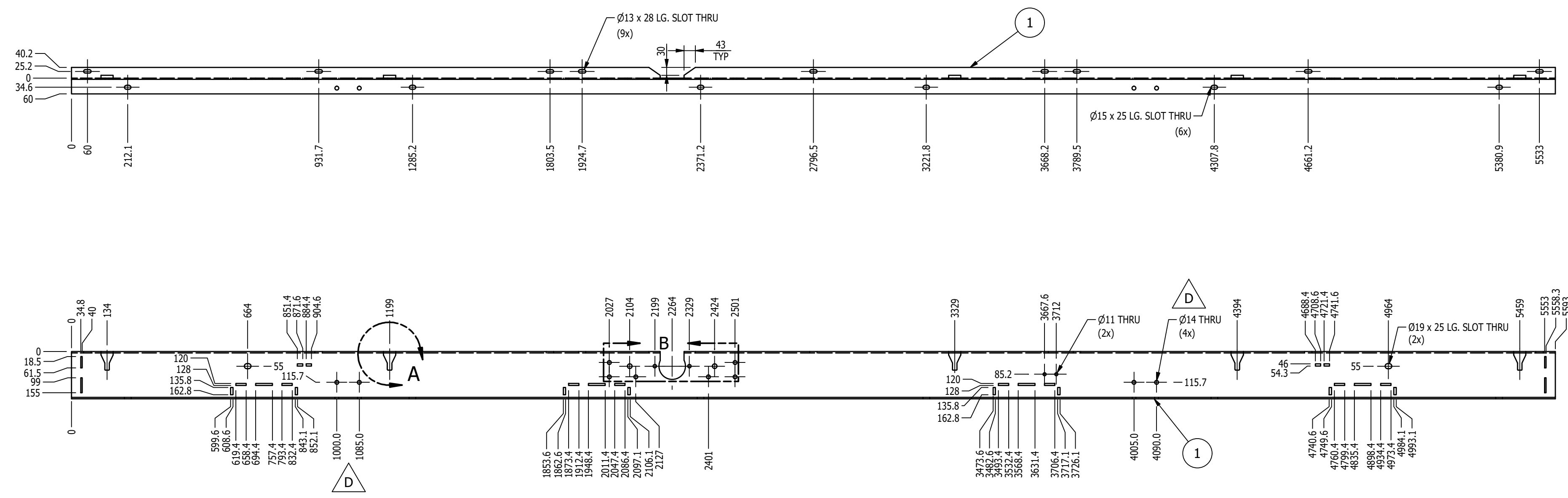
41100 Clarkston Rd.
Suite 125
West, MI 48375

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

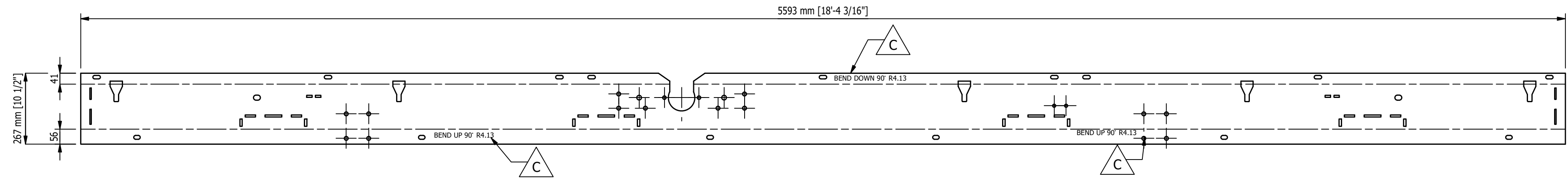
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D351

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

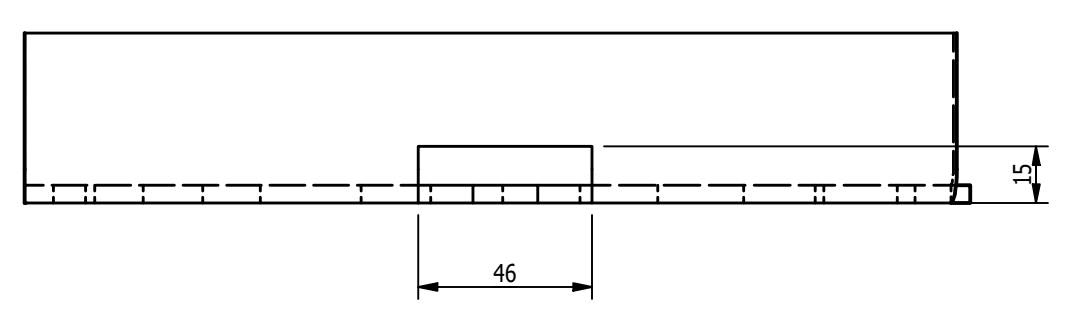
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	PL 3/16 x 10 1/2"	18'-4 3/16"		



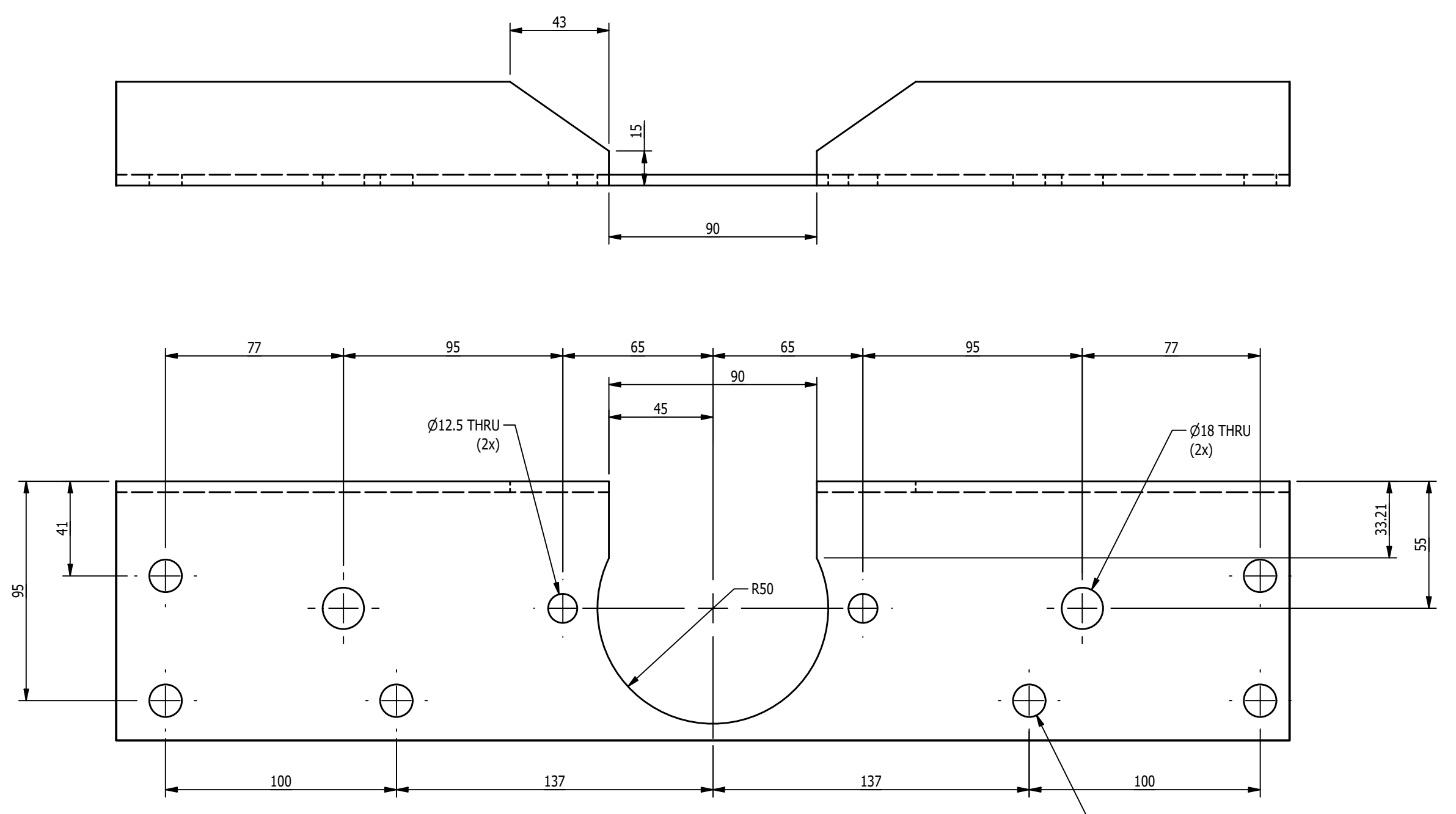
MK-D352A ~ SIDE FRAME
SCALE 1"=1'-0"



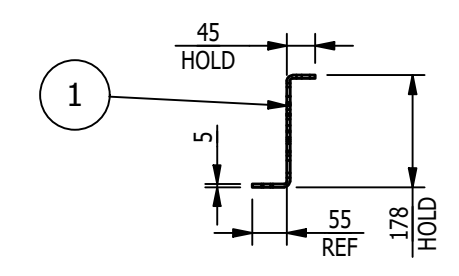
FLAT PATTERN OF ITEM '1'
SCALE 1"=1'-0"



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



ENLARGED VIEW '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:
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
D	MC	9/29/22	ADDED HOLES FOR CONTROLLER BRACKET	
C	MC	9/20/2022	ROTATED FLAT PATTERN 180 DEG, CHANGED BEND NOTES	
B	MC	8/19/2022	REVISED END SLOT LENGTHS & FILLETED ROLL BED SLOTS	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY		DRAWN BY:	
		AH	
		CHECKED BY:	JCK
		DWG DATE:	7/29/22
		DRAWING No.	1875D352
		REV:	D
		JOB No:	22096

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

MAGNUM Consulting

4100 Clarkston Rd
Suite 125
West, MI 48375

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D352

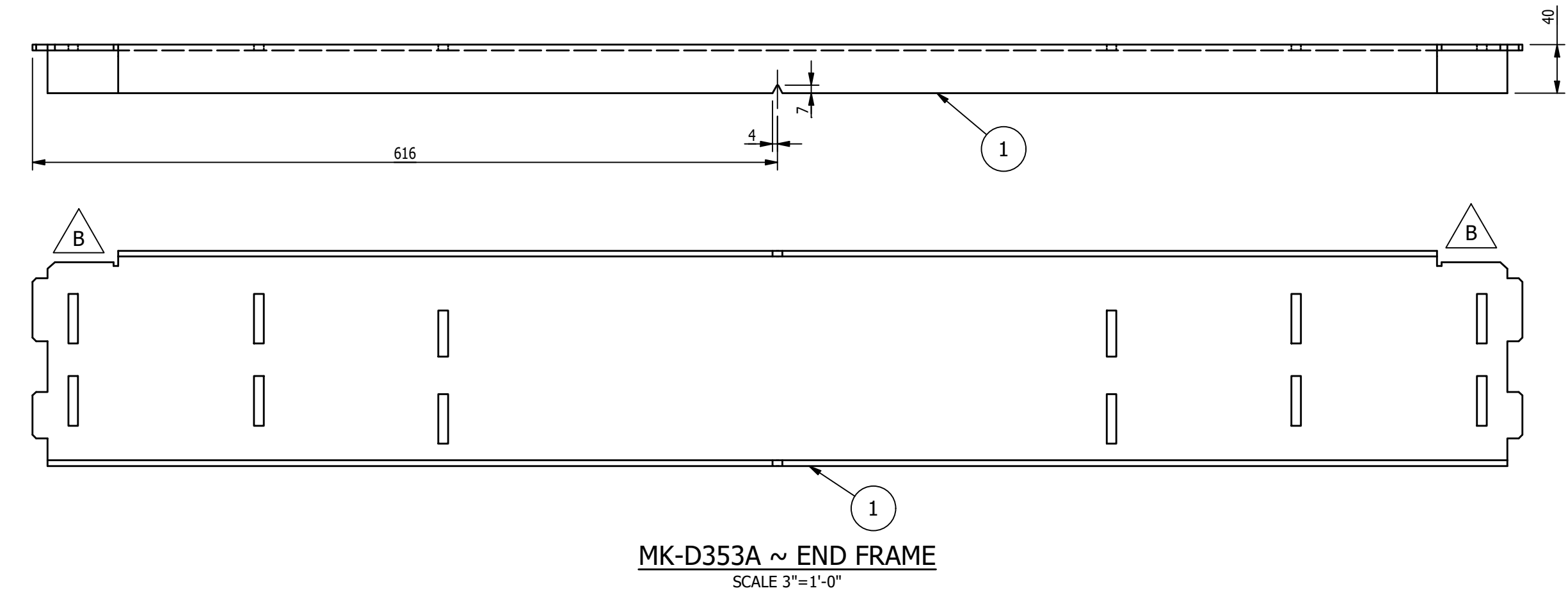
UNLESS OTHERWISE NOTED:

X = ±.060
XX = ±.030
XXX = ±.005

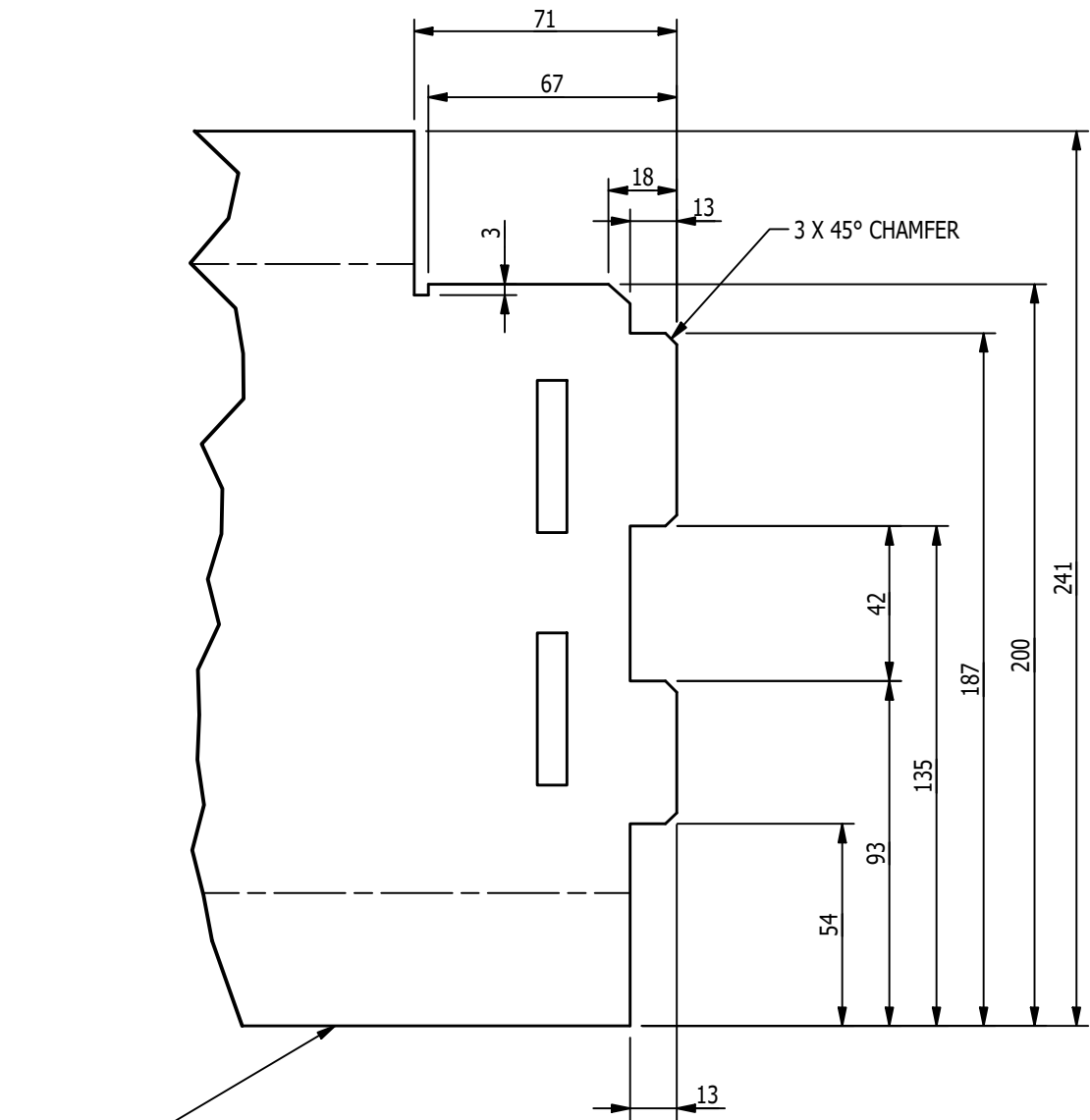
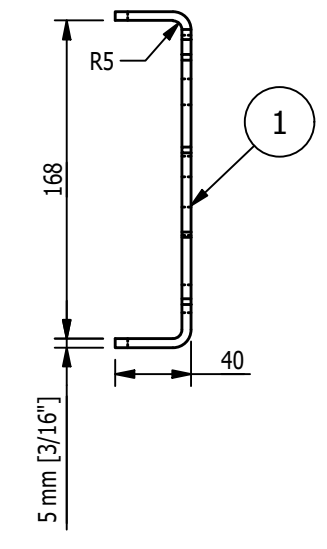
FRACTIONS = ±1/16"
ANGLES = ±1°30'

BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

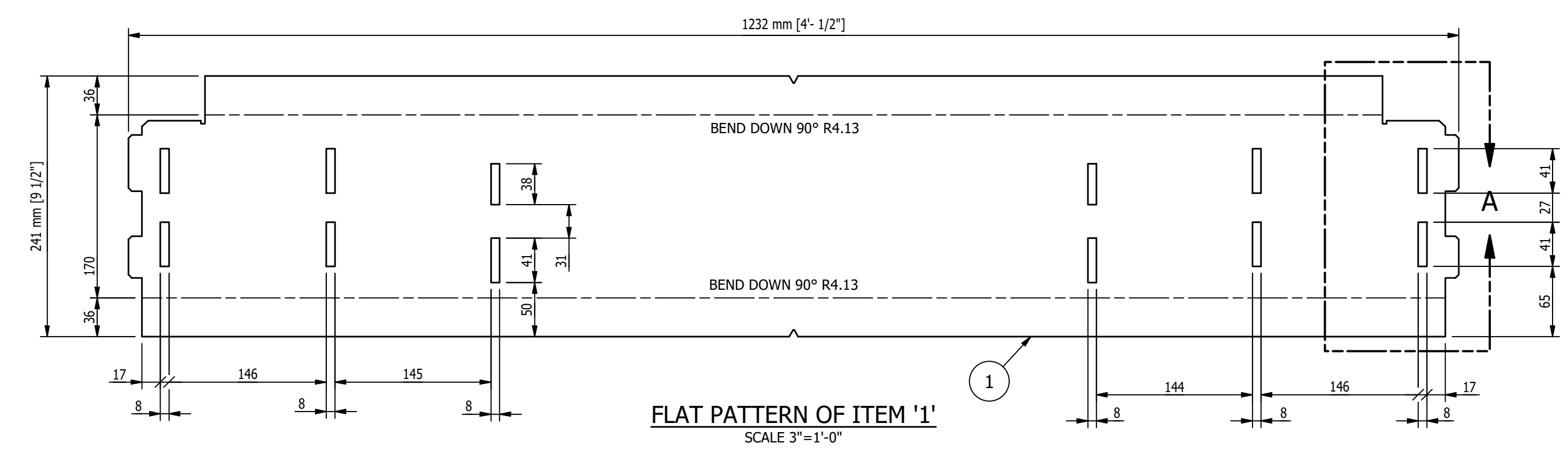
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D353A			
		PL 3/16 x 9 1/2"	4'- 1/2"		



MK-D353A ~ END FRAME
SCALE 3"=1'-0"



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



FLAT PATTERN OF ITEM '1'
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:**
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	REVISED TABS	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY	
	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.com
TITLE:	P6700 CONVEYORS CAMPUS BUILDING
CLIENT:	VOLVO
DRAWING No.	1875D353
REV:	B
DRAWN BY:	AH
CHECKED BY:	JCK
DWG DATE:	7/29/22
JOB No:	22096

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

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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.

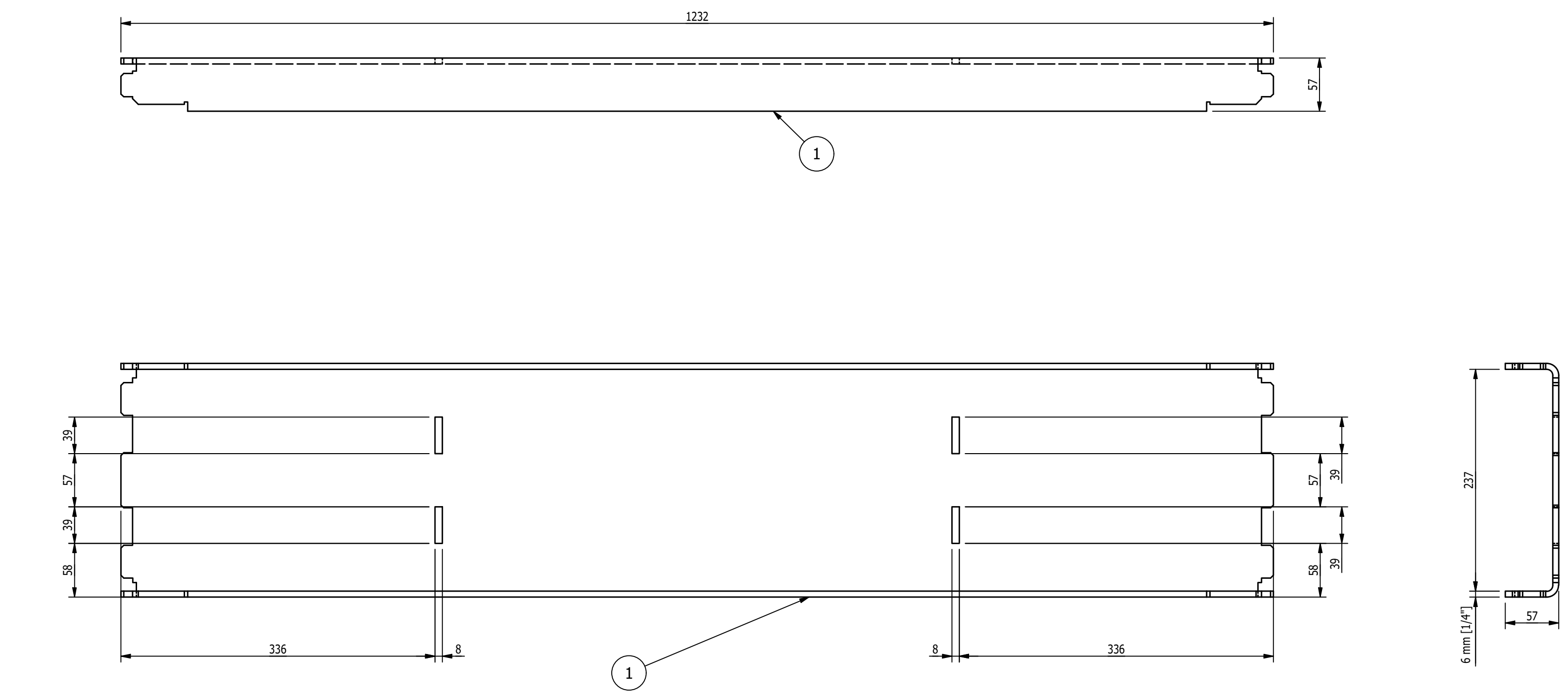
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

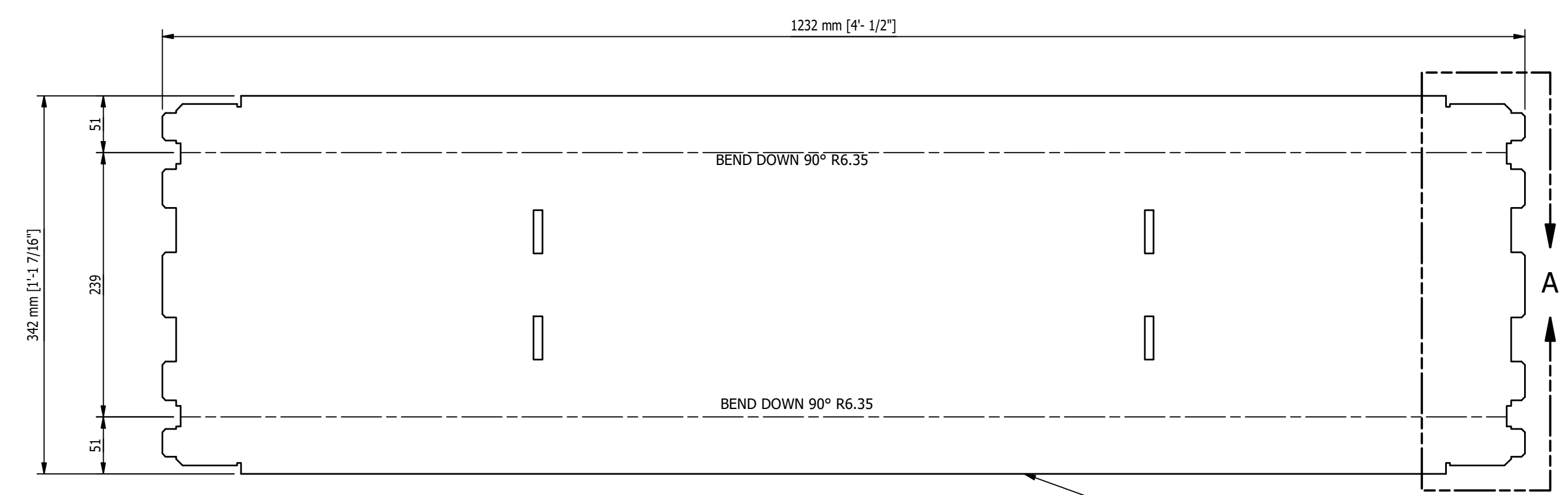
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

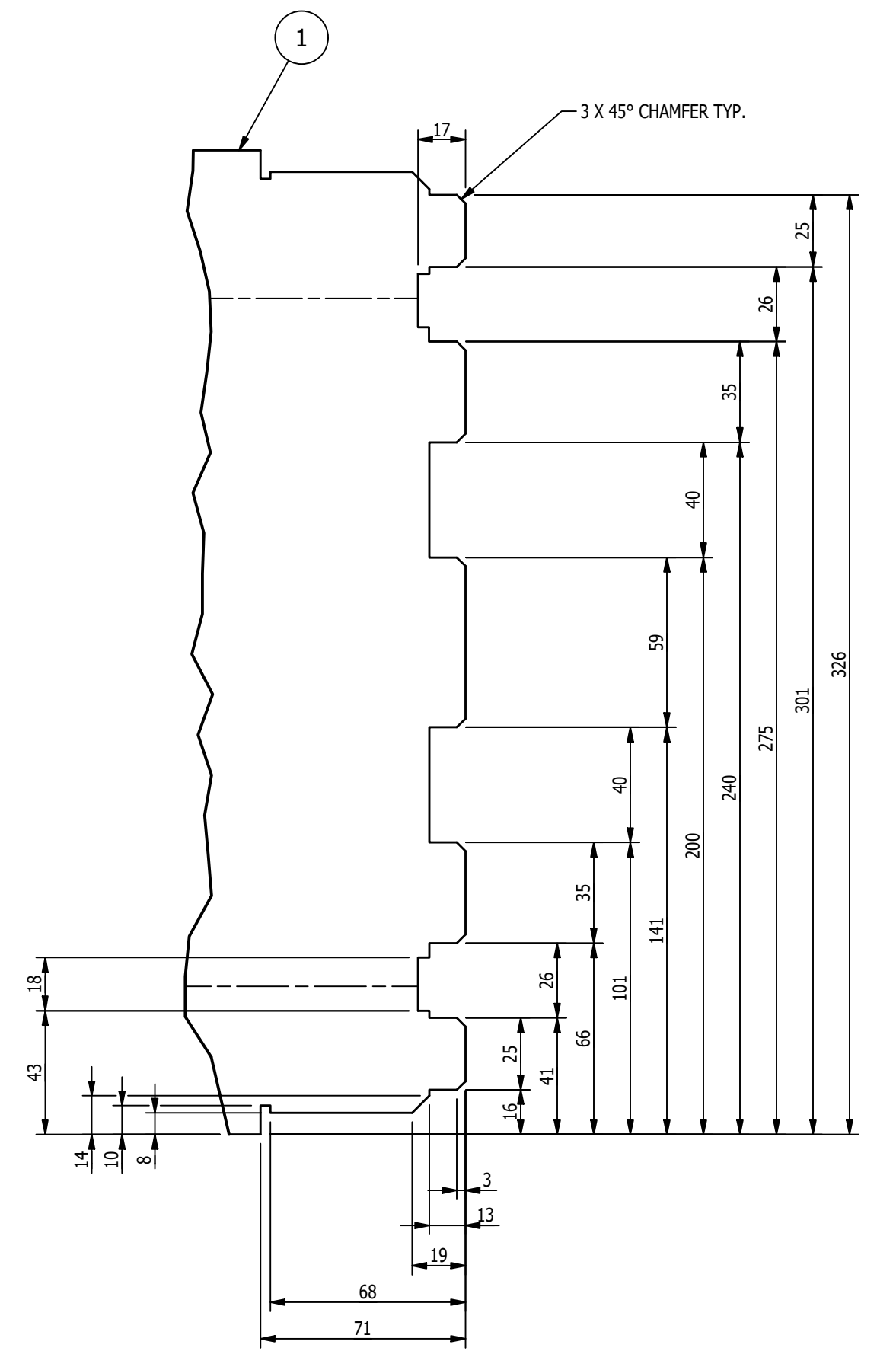
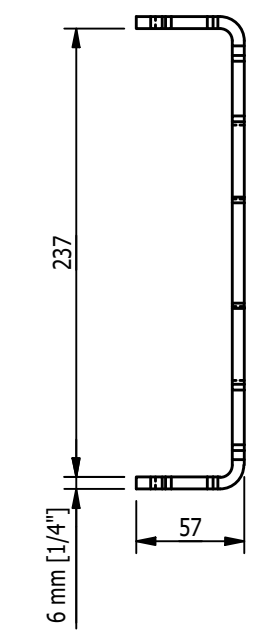
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	PL 1/4 x 1'-1 7/16"	4'- 1/2"		



MK-D354A ~ INNER CROSS MEMBER
SCALE 3"=1'-0"



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



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

- SHOP NOTES:**
1. 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	8/19/2022	UPDATED PAINT NOTE	
A	MC	8-8-2022	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:	AH
CLIENT:	VOLVO	CHECKED BY:	JCK
DRAWING No.	1875D354	DWG DATE:	7/29/22
		REV:	B
		JOB No:	22096

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D354

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

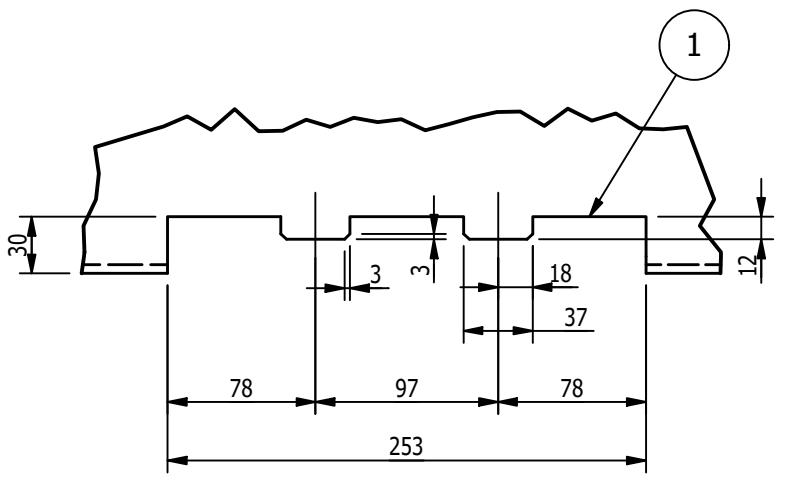
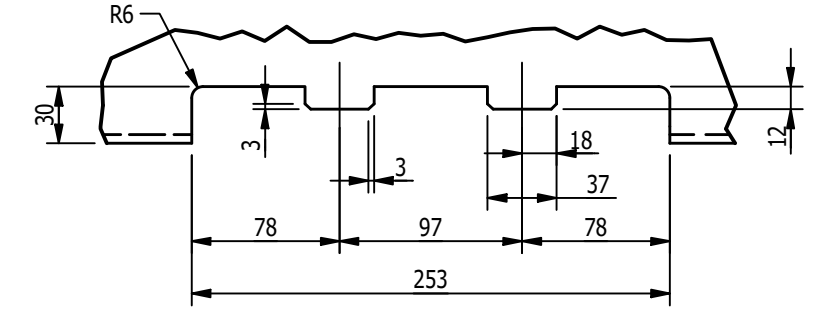
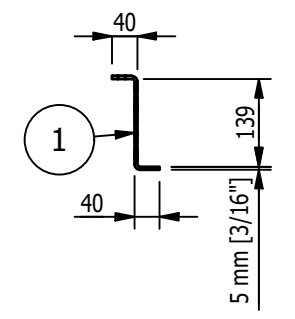
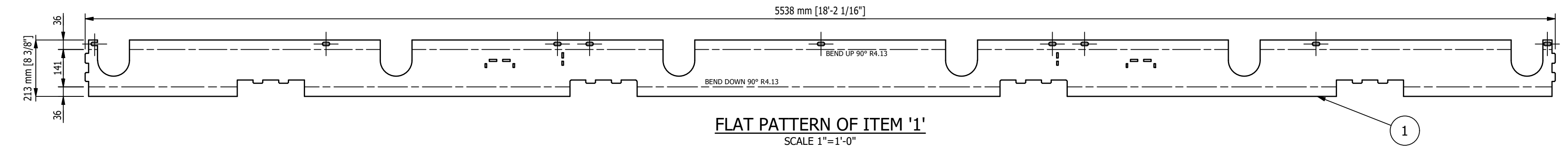
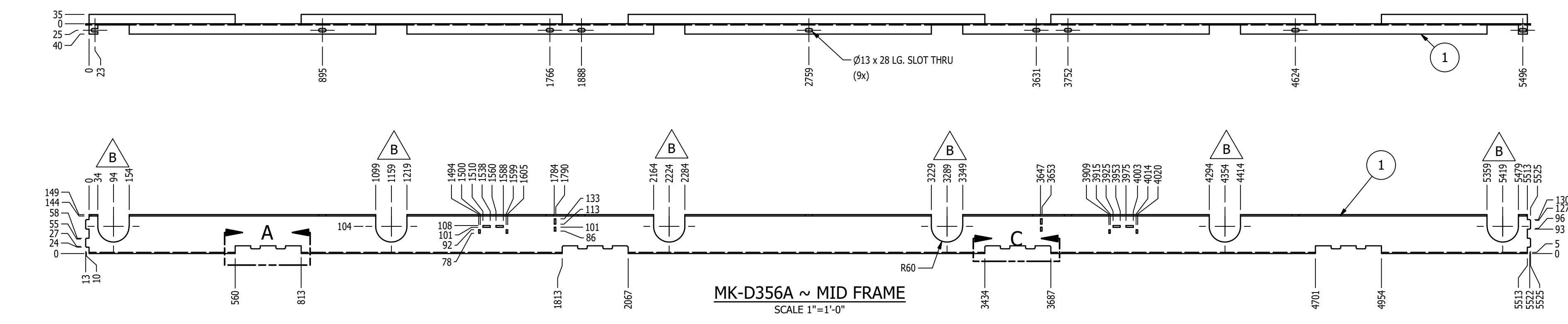
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D356A	18'-2 1/16"		
		PL 3/16 x 8 3/8"			



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

PAINT NOTES:
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	REVISED CUT-OUT WIDTH TO 120mm	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

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

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	JCK
DRAWING No.	1875D356	DWG DATE:	7/29/22
		REV:	B
		JOB No.:	22096

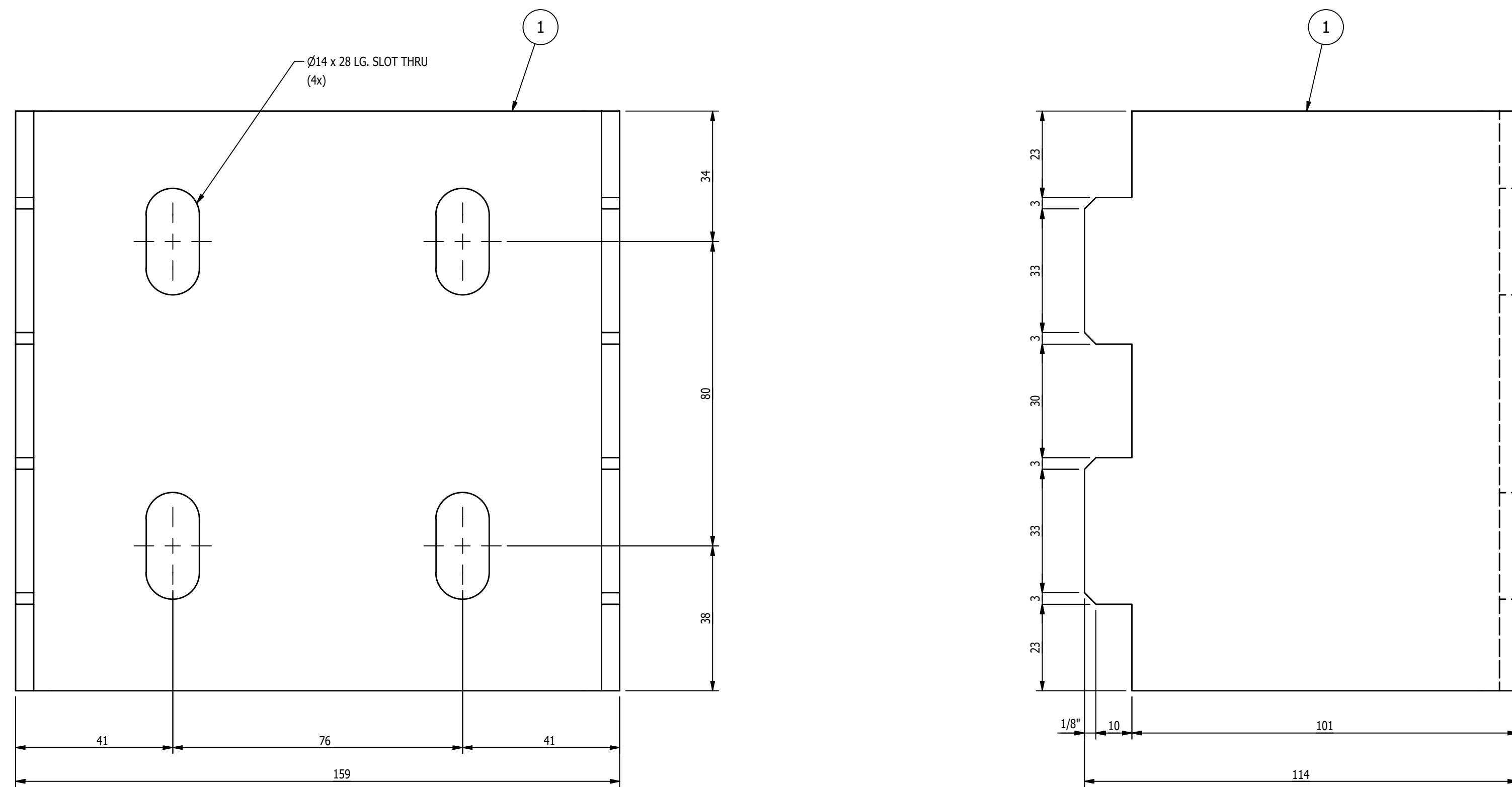
MAGNUM CONSULTING
41100 Charleston Rd.
Suite 125
North, MI 48175

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

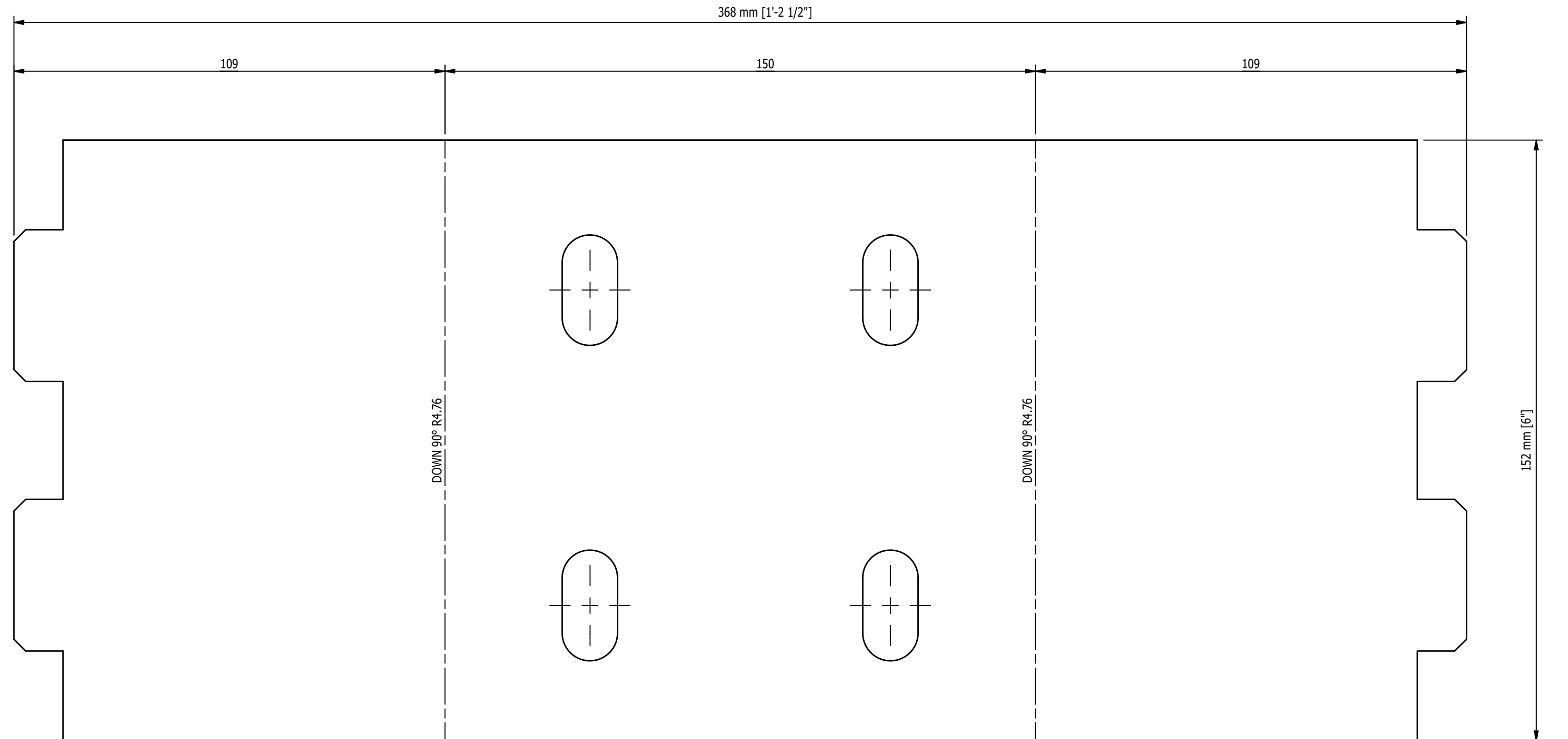
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D356

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-D359A			
1	1	PL 3/16 x 6	1'-2 1/2"		



MK-D359A ~ GRAVITY STOP EXTENSION
SCALE 1'-0" = 1'-0"



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

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

PAINT NOTES:
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/19/2022	REVISED PAINT NOTE	
A	MC	8-8-2022	FOR FABRICATION	

REVISION HISTORY	
B	MC 8/19/2022 REVISED PAINT NOTE
A	MC 8-8-2022 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: JCK
DRAWING No. 1875D359	DWG DATE: 8/1/22
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.

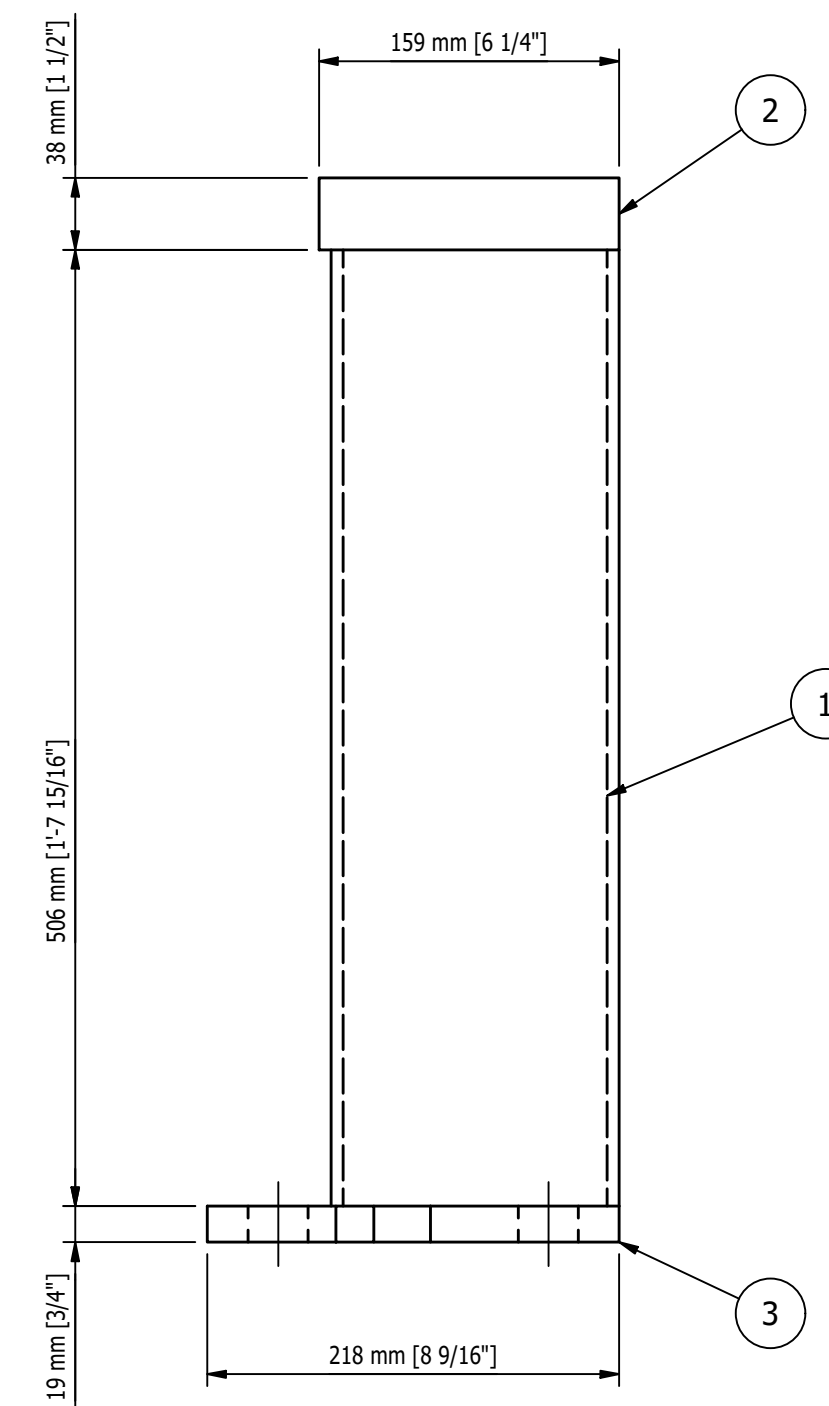
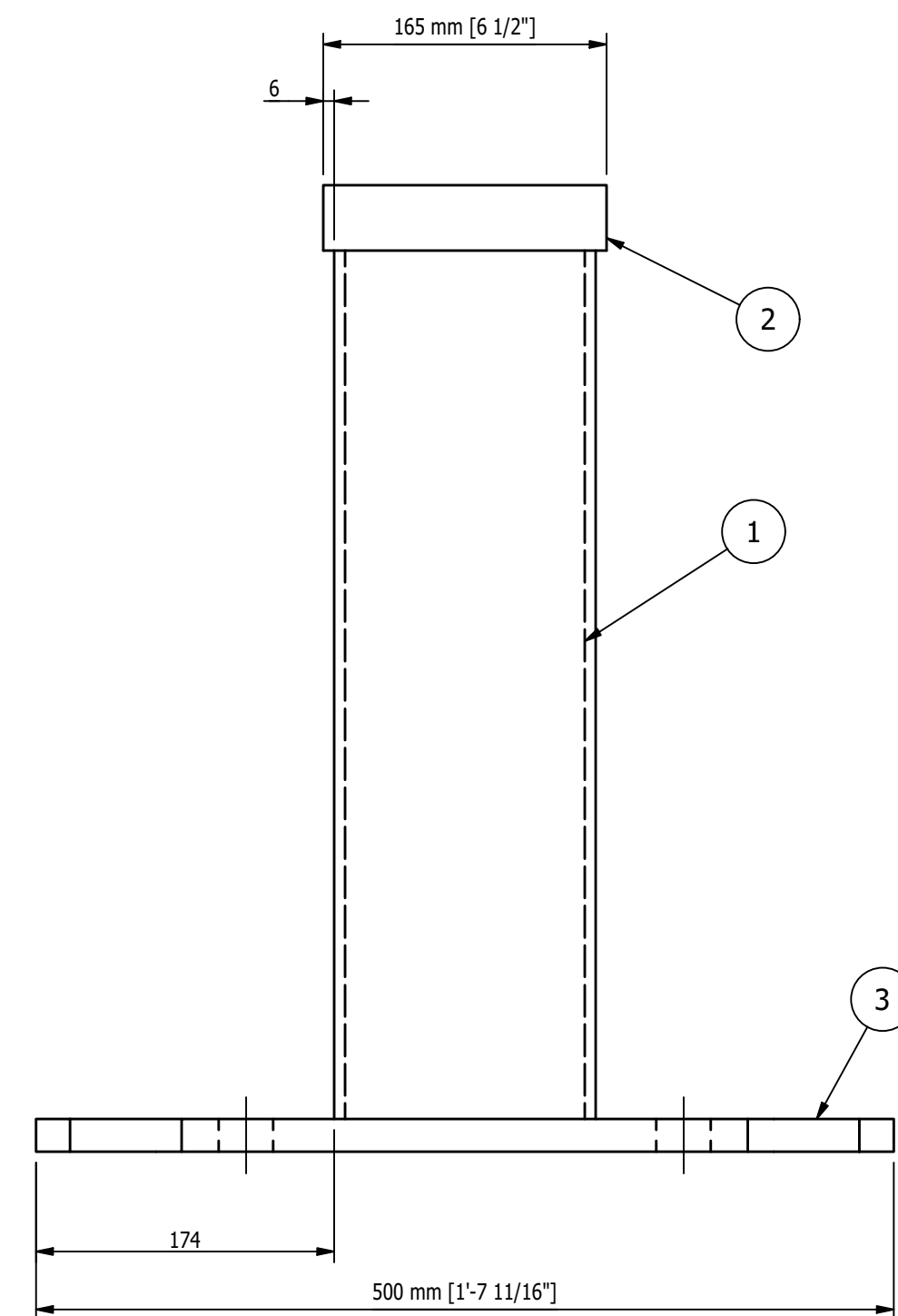
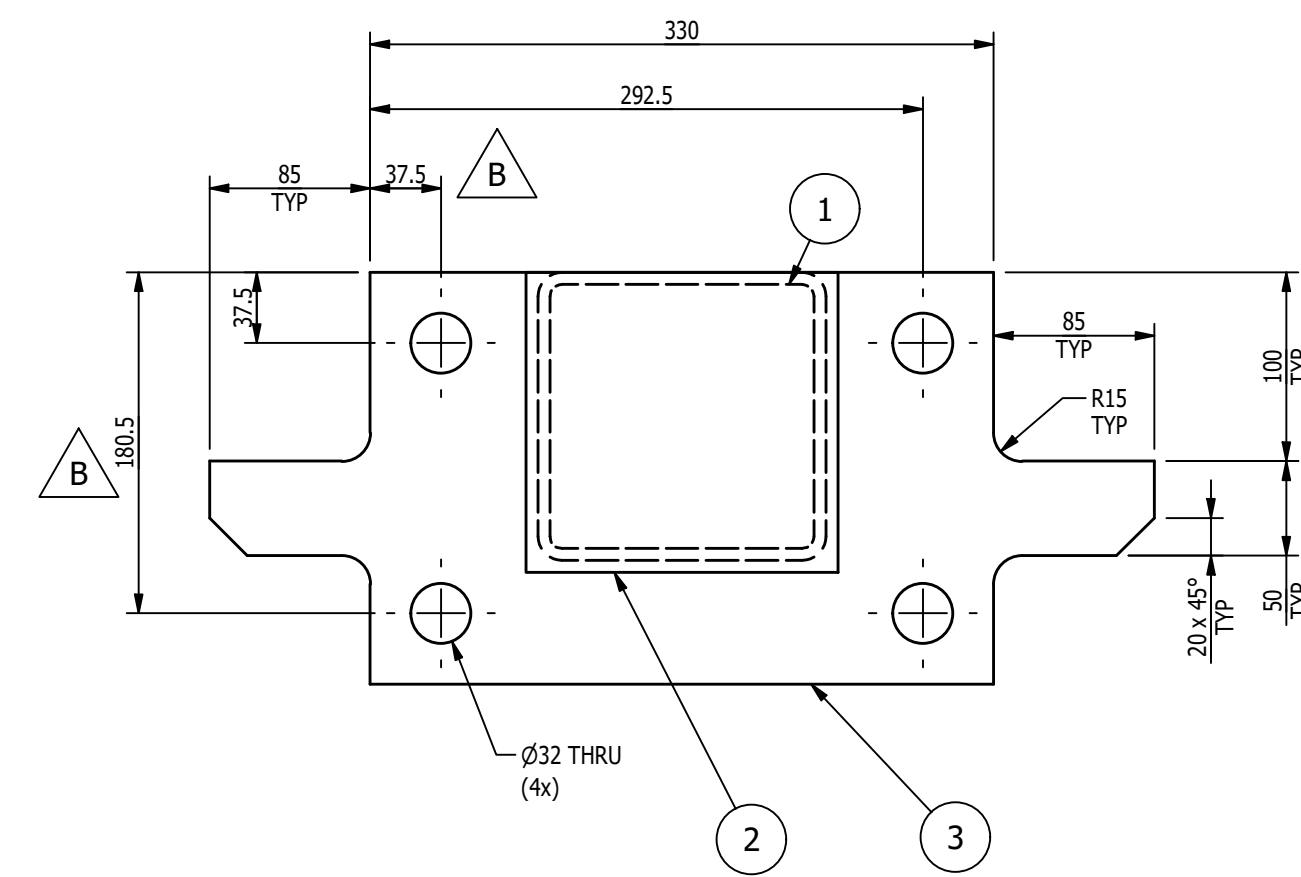
MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
North, MI 48135

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D359

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-D360A ~ REST PAD STANCHION WELDMENT
SCALE 3"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D360A			
1	1	TS 6 x 6 x 1/4	1'-7 15/16"		
2	1	PL 1 1/2 x 6 1/4"	6 1/2"		
3	1	PL 3/4 x 8 9/16"	1'-7 11/16"		

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

PAINT NOTES:
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	CHANGED HOLE DIM PRECISION	
A	MC	8/26/2022	FOR FABRICATION	

REVISION HISTORY

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
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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	PWP
CLIENT:	VOLVO	CHECKED BY:	JCK
DRAWING No.	1875D360	DWG DATE:	8/1/22
REV:	B	JOB No:	22096

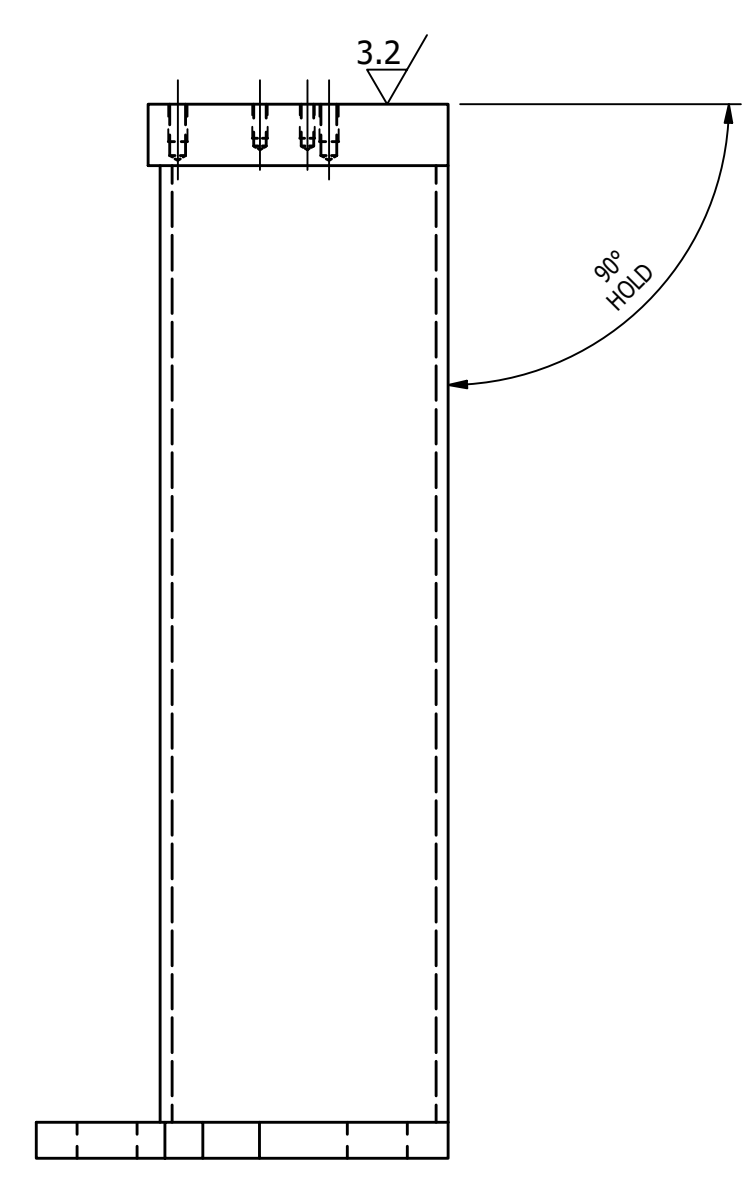
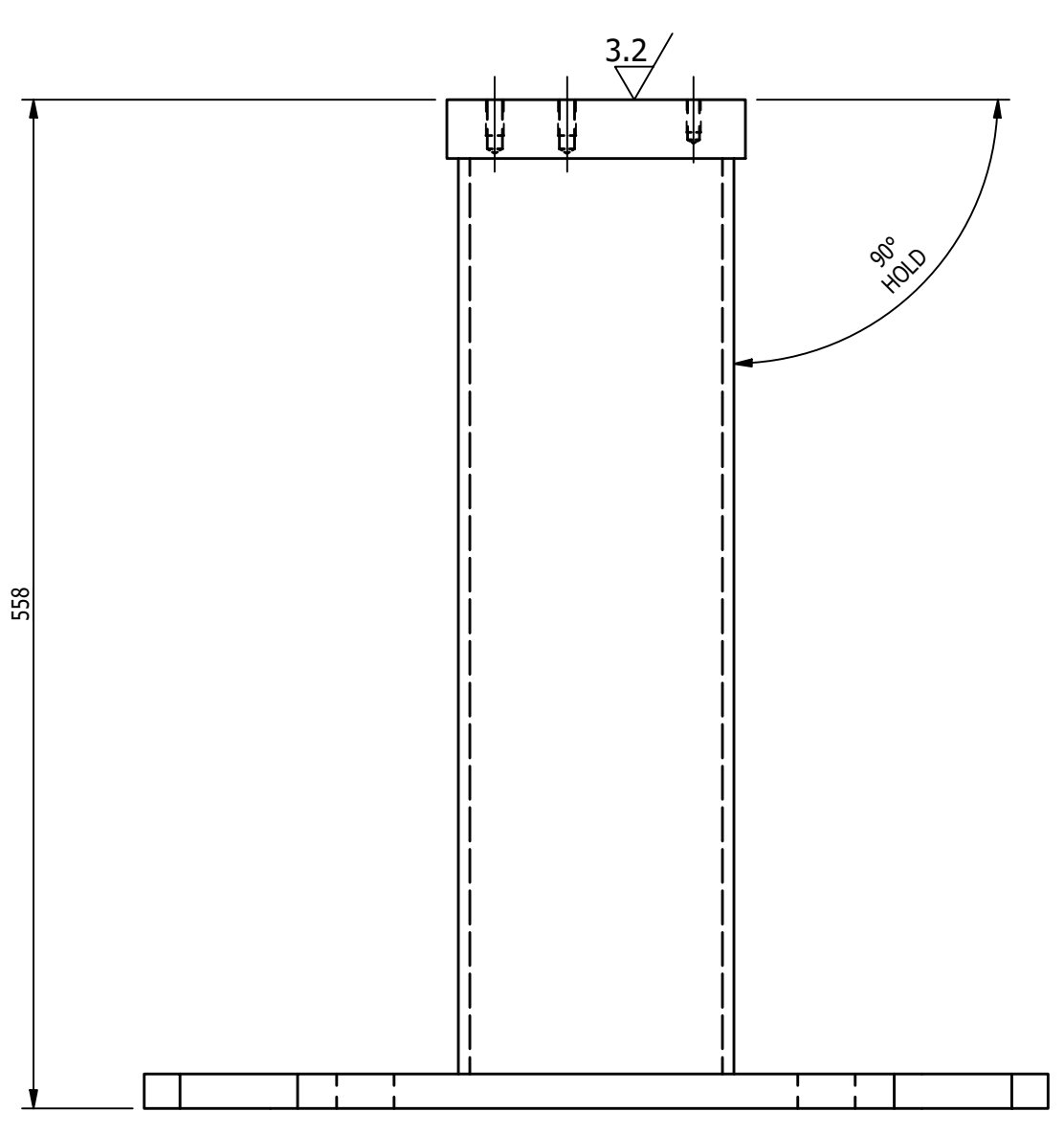
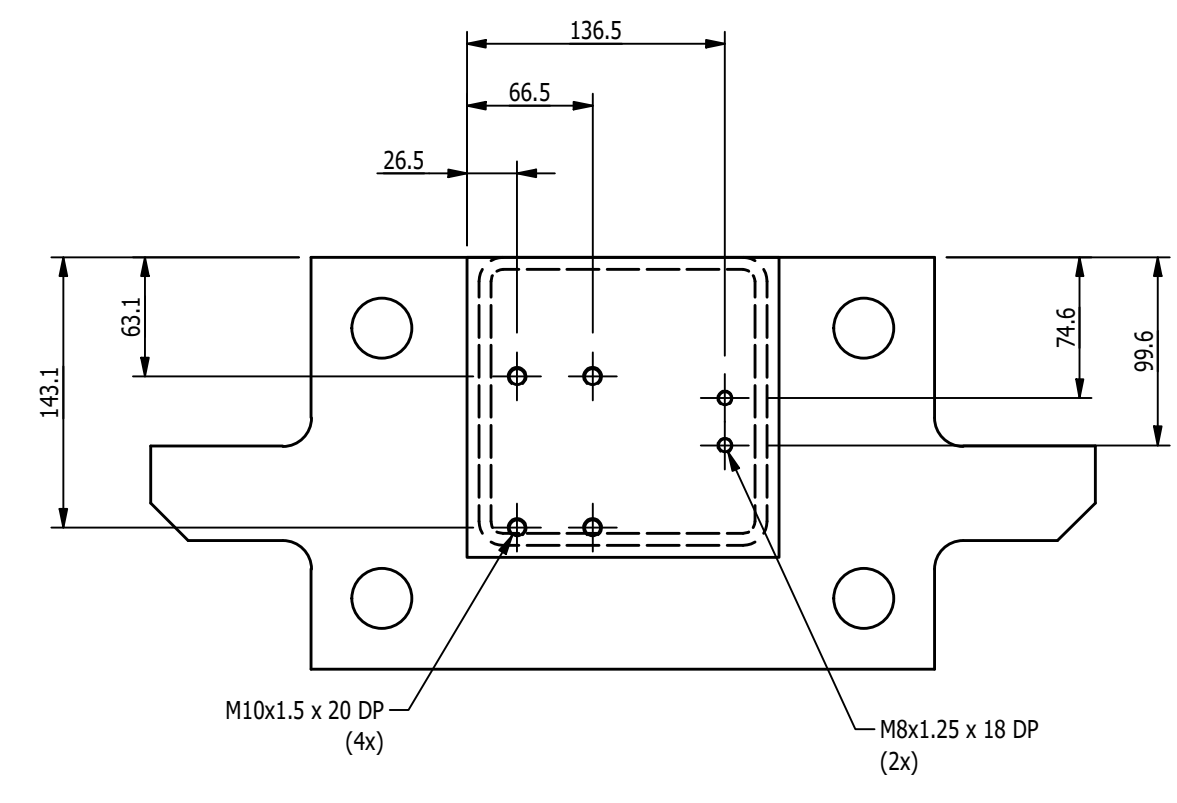
MAGNUM Consulting
41100 Clarkston Rd.
Suite 125
North, MI 48075
Phone: (248) 373-8833
Fax: (248) 373-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D360

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-D361A MK-D360A ~ REST PAD STANCHION WELDMENT			



MK-D361A ~ REST PAD STANCHION MACHINE
SCALE 3"=1'-0"

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/26/2022	FOR FABRICATION	

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO	DRAWN BY: PWP CHECKED BY: JCK DWG DATE: 8/1/22

MAGNUM CONSULTING

41100 Clarkston Road
Suite 125
North, MI 48135

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D361

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:

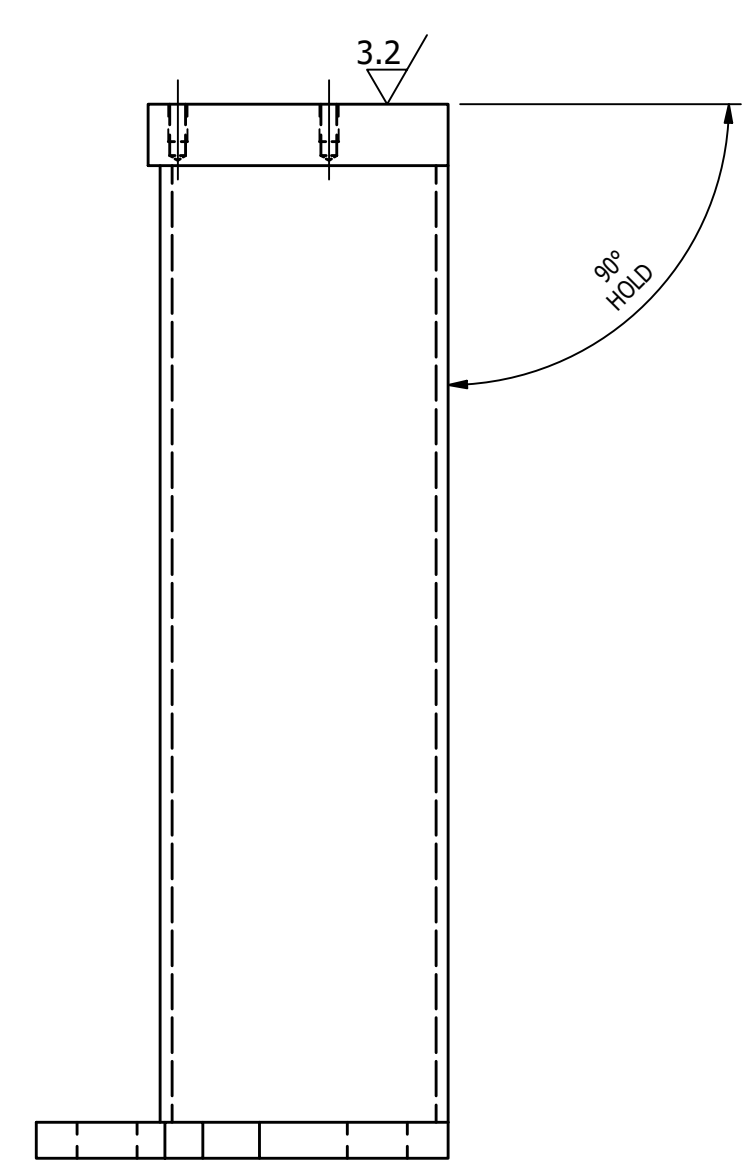
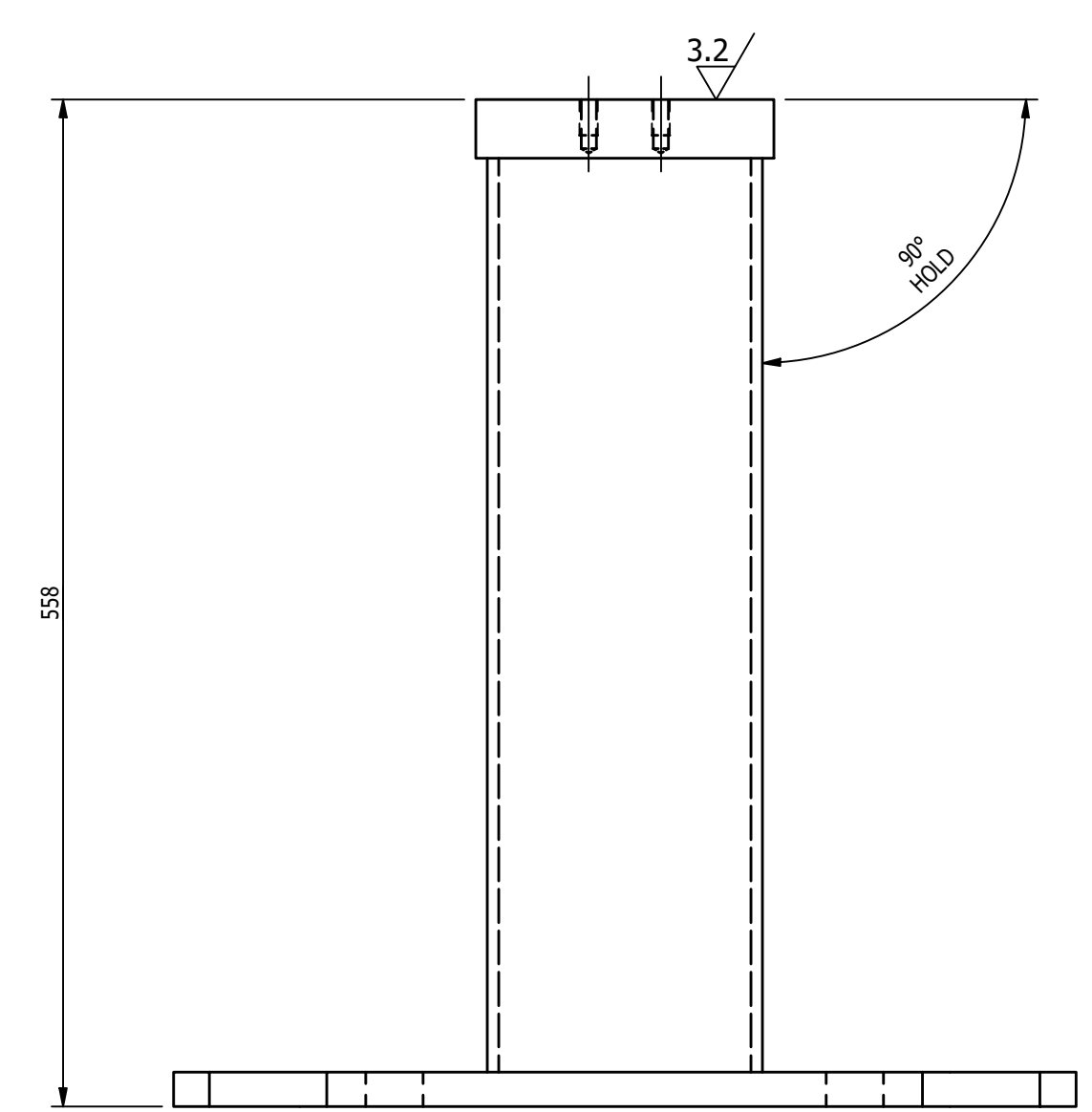
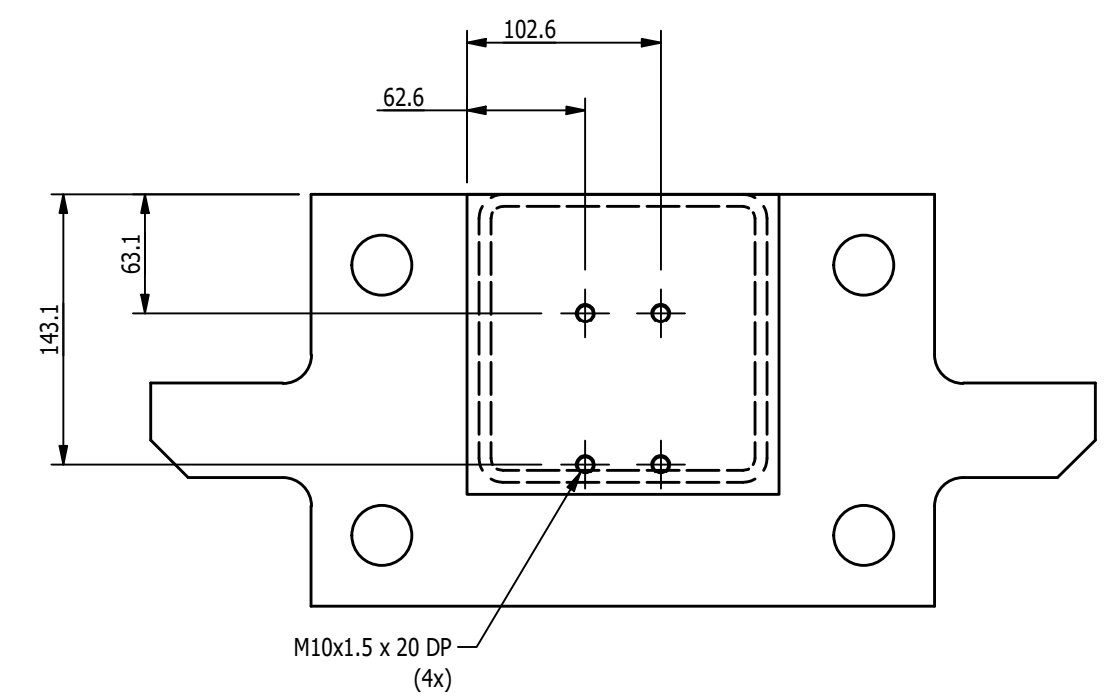
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

DRAWING No. 1875D361	REV: A	JOB No: 22096
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BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D362A MK-D360A ~ REST PAD STANCHION WELDMENT			



MK-D362A ~ REST PAD STANCHION MACHINE
SCALE 3"=1'-0"

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/26/2022	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 DRAWING No. 1875D362 REV: A

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 41100 Charleston Rd.
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 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D362

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:

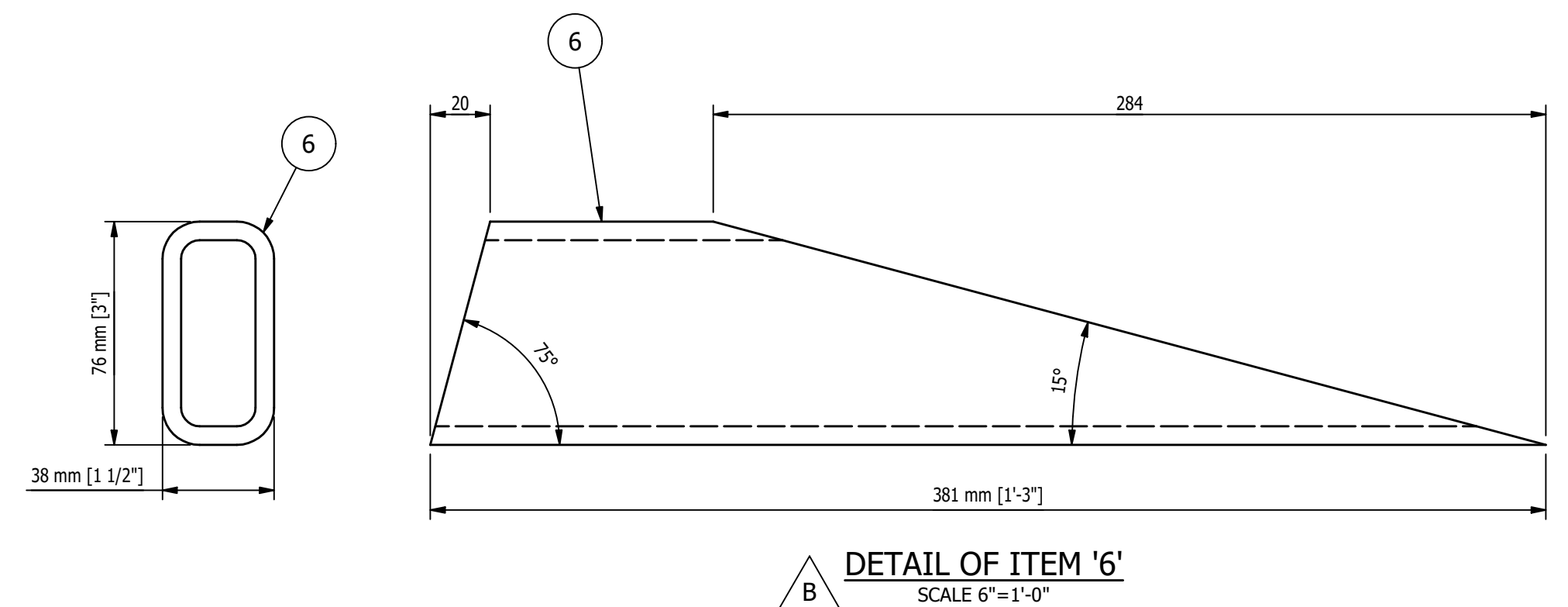
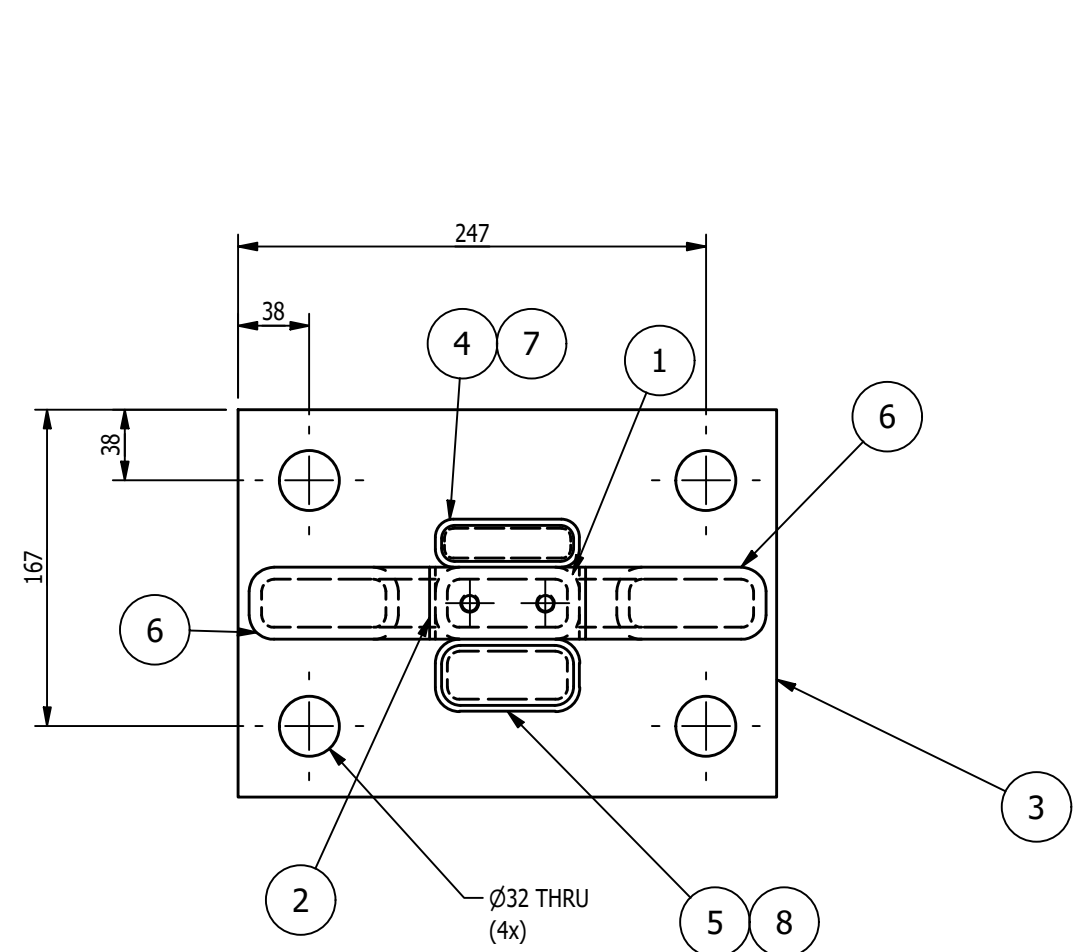
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

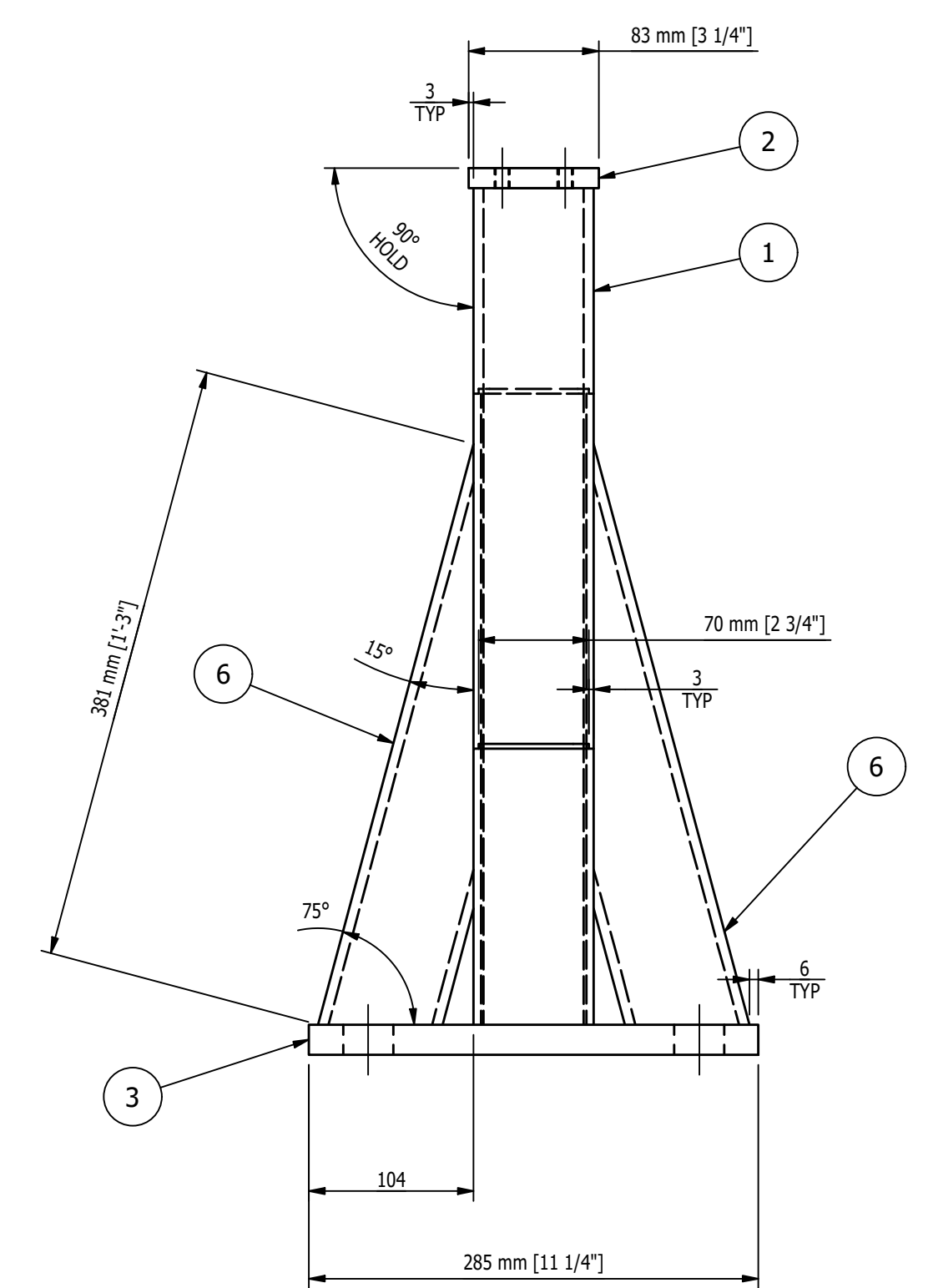
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

DRAWN BY: PWP	CHECKED BY: JCK	DWG DATE: 8/8/22	JOB No: 22096
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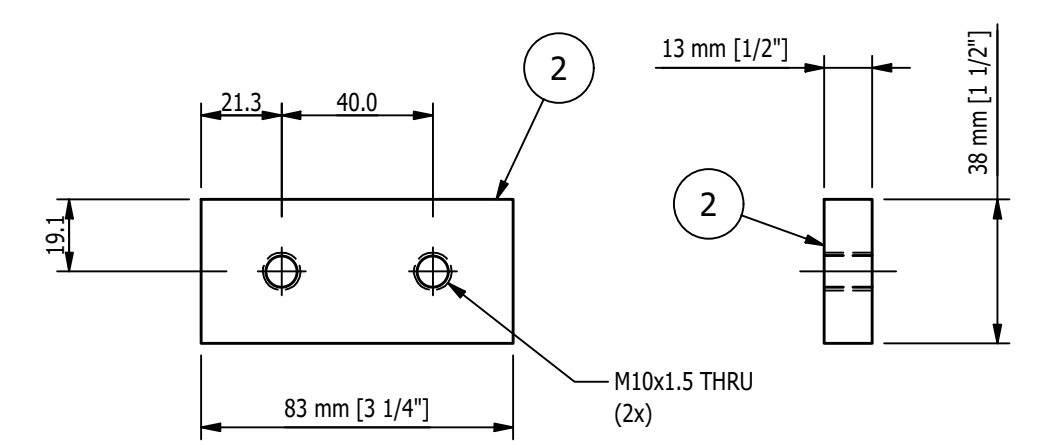
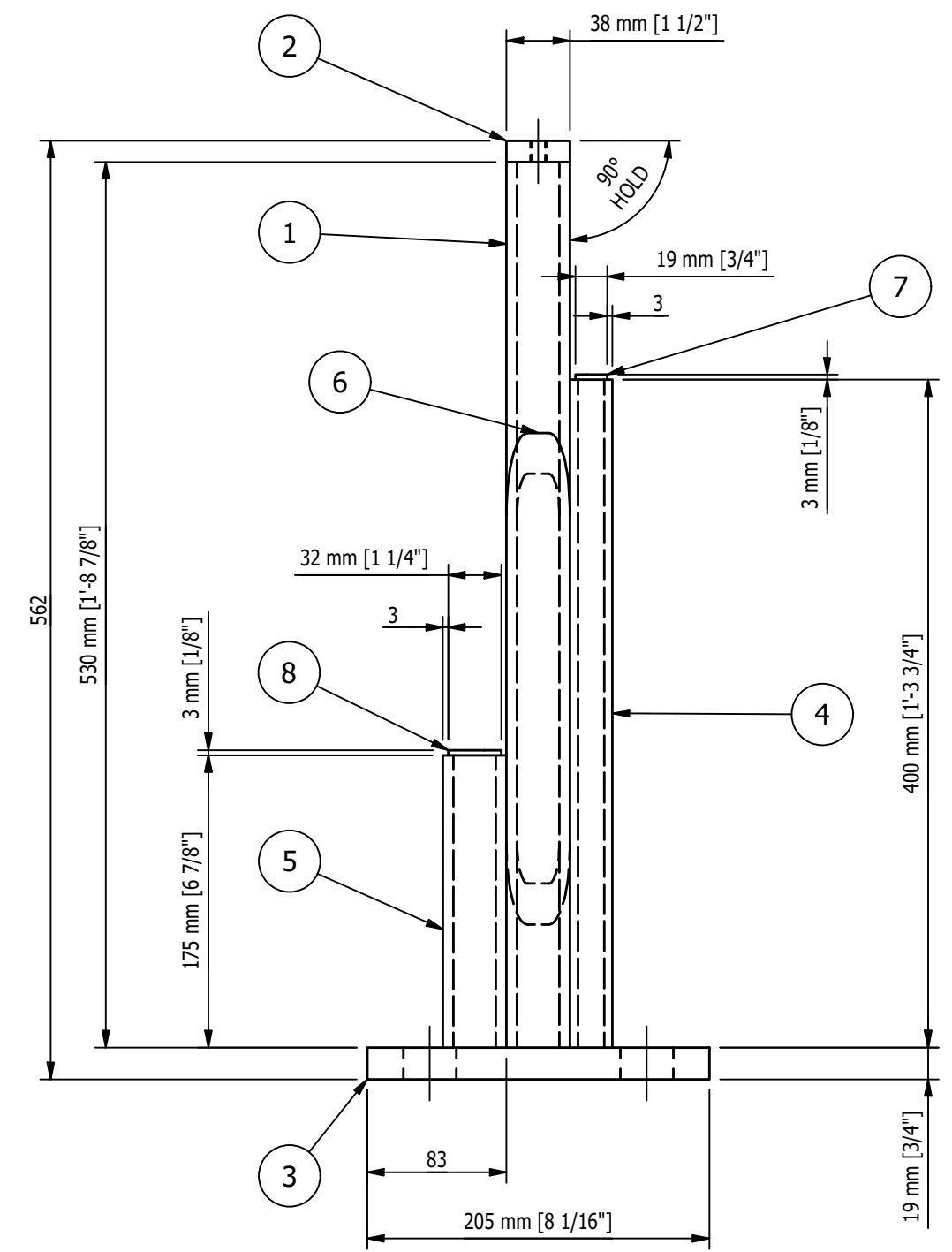
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D363A			
1	1	TS 3 x 1 1/2 x 1/4	1'-8 7/8"		
2	1	BAR 1/2 x 1 1/2	3 1/4"		
3	1	PL 3/4 x 8 1/16"	11 1/4"		
4	1	TS 3 x 1 x 3/16	1'-3 3/4"		
5	1	TS 3 x 1 1/2 x 1/4	6 7/8"		
6	2	TS 3 x 1 1/2 x 1/4	1'-3"		
7	1	SHT 11 GA x 3/4"	2 3/4"		
8	1	SHT 11 GA x 1 1/4"	2 3/4"		



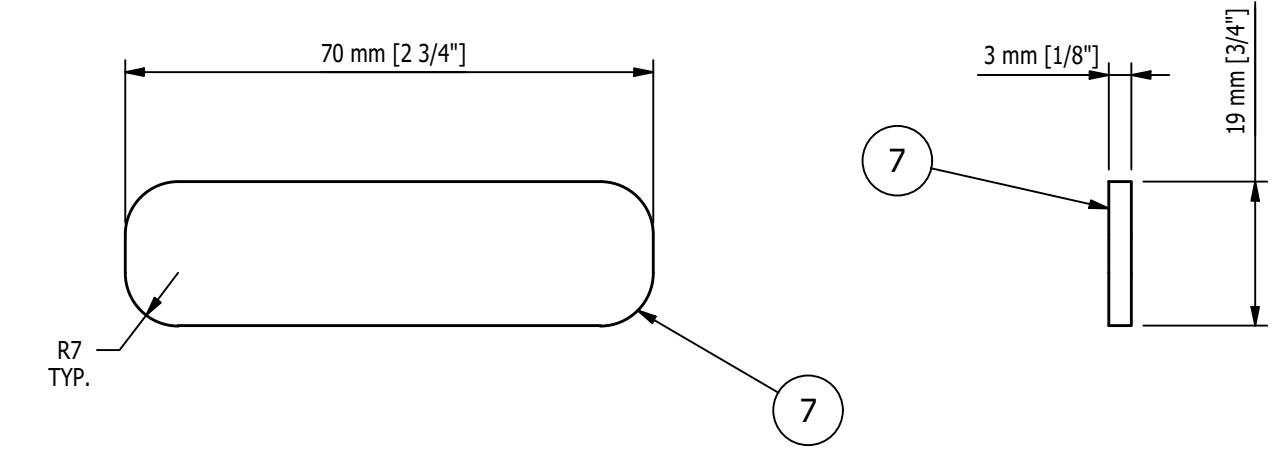
DETAIL OF ITEM '6'
SCALE 6"=1'-0"



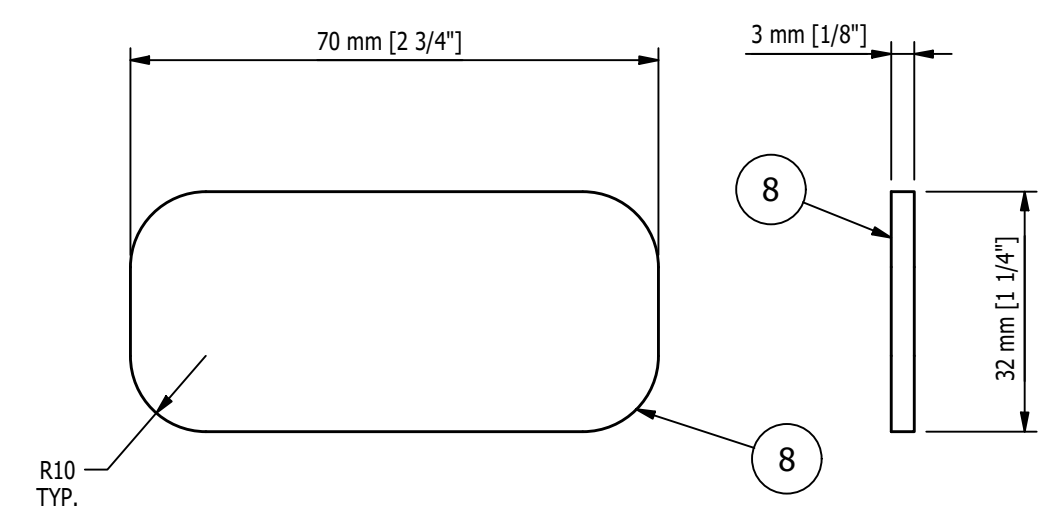
MK-D363A ~ REST PAD STANCHION
SCALE 3"=1'-0"



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



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



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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	ADDED DETAIL VIEW OF ITEM '6' & DIMS	
A	MC	8/26/2022	FOR FABRICATION	

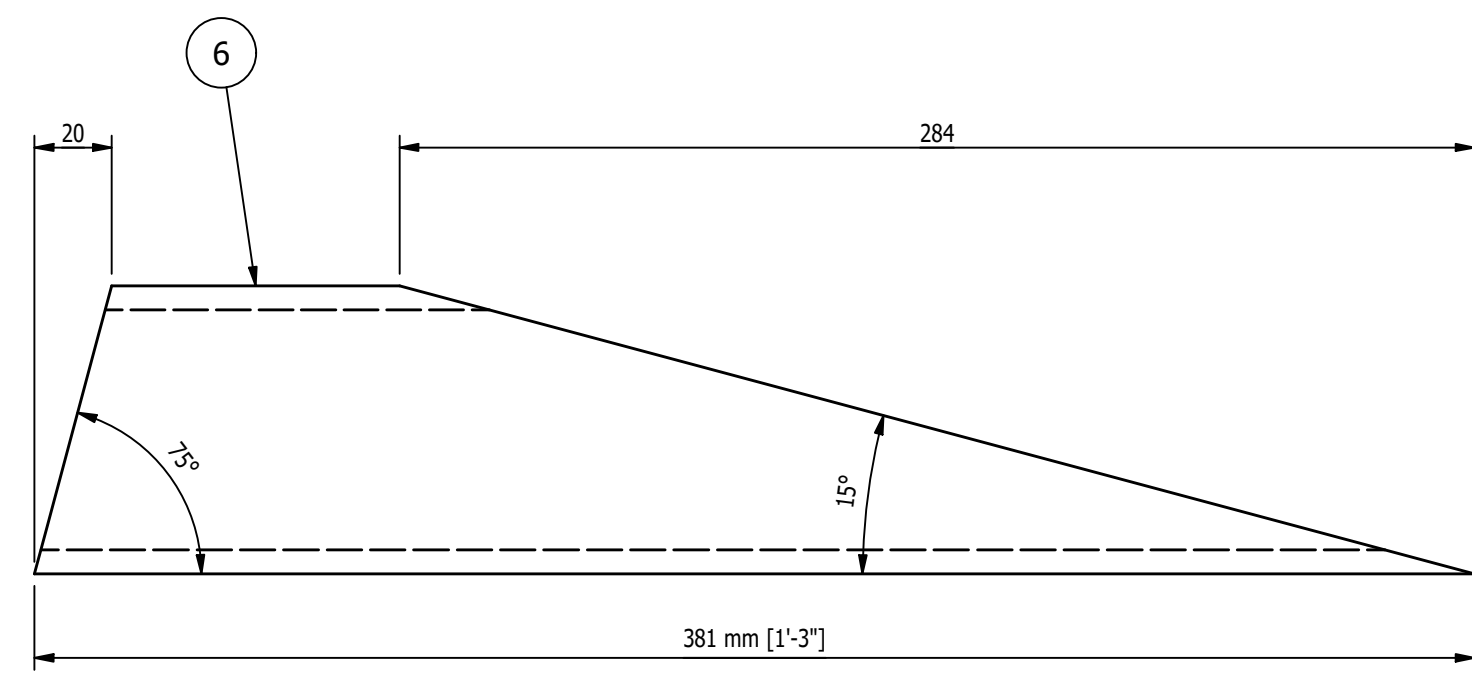
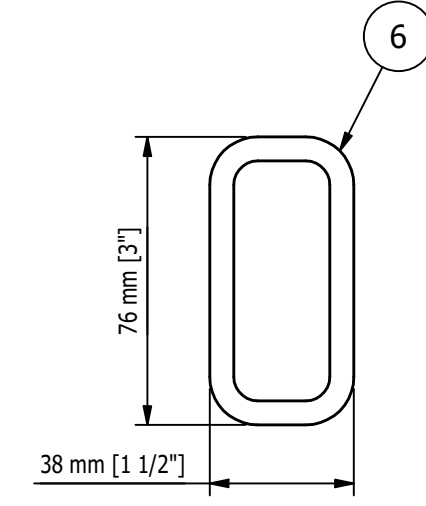
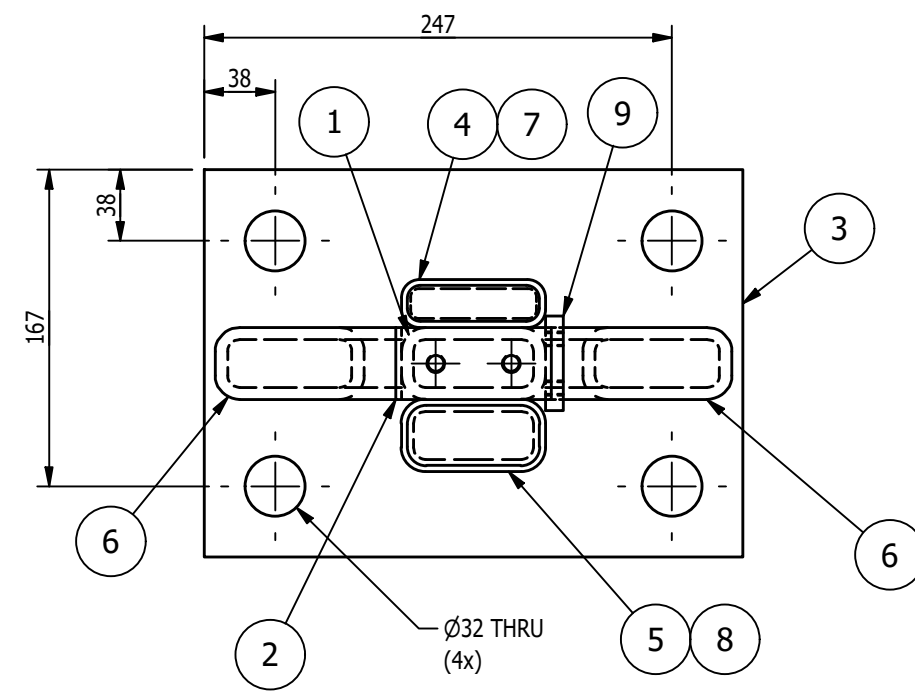
REVISION HISTORY		MILLER INDUSTRIES	
		3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: PWP	
CLIENT: VOLVO		CHECKED BY: JCK	
DRAWING No. 1875D363		DWG DATE: 8/1/22	
REV: B		JOB No: 22096	

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.

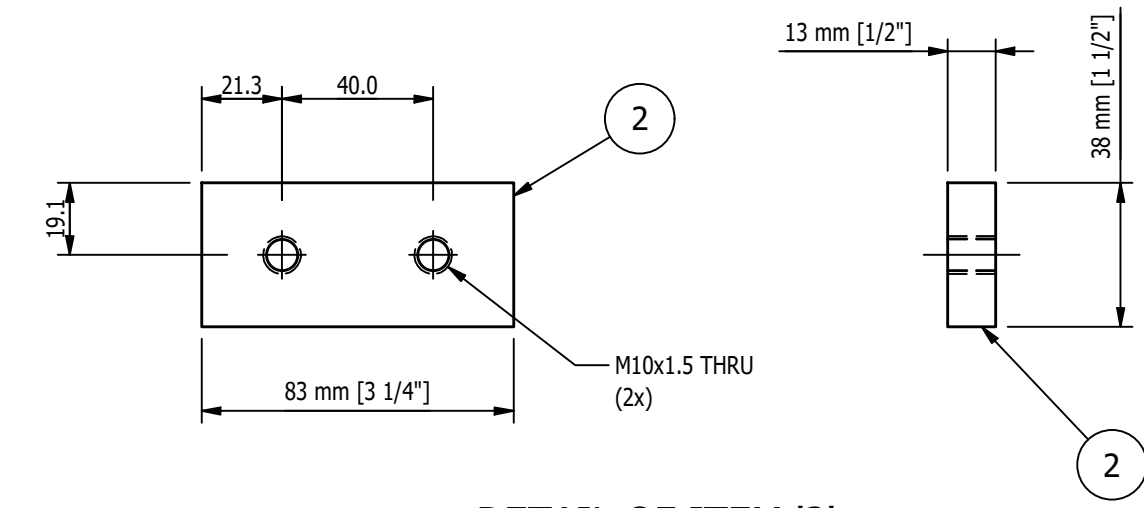
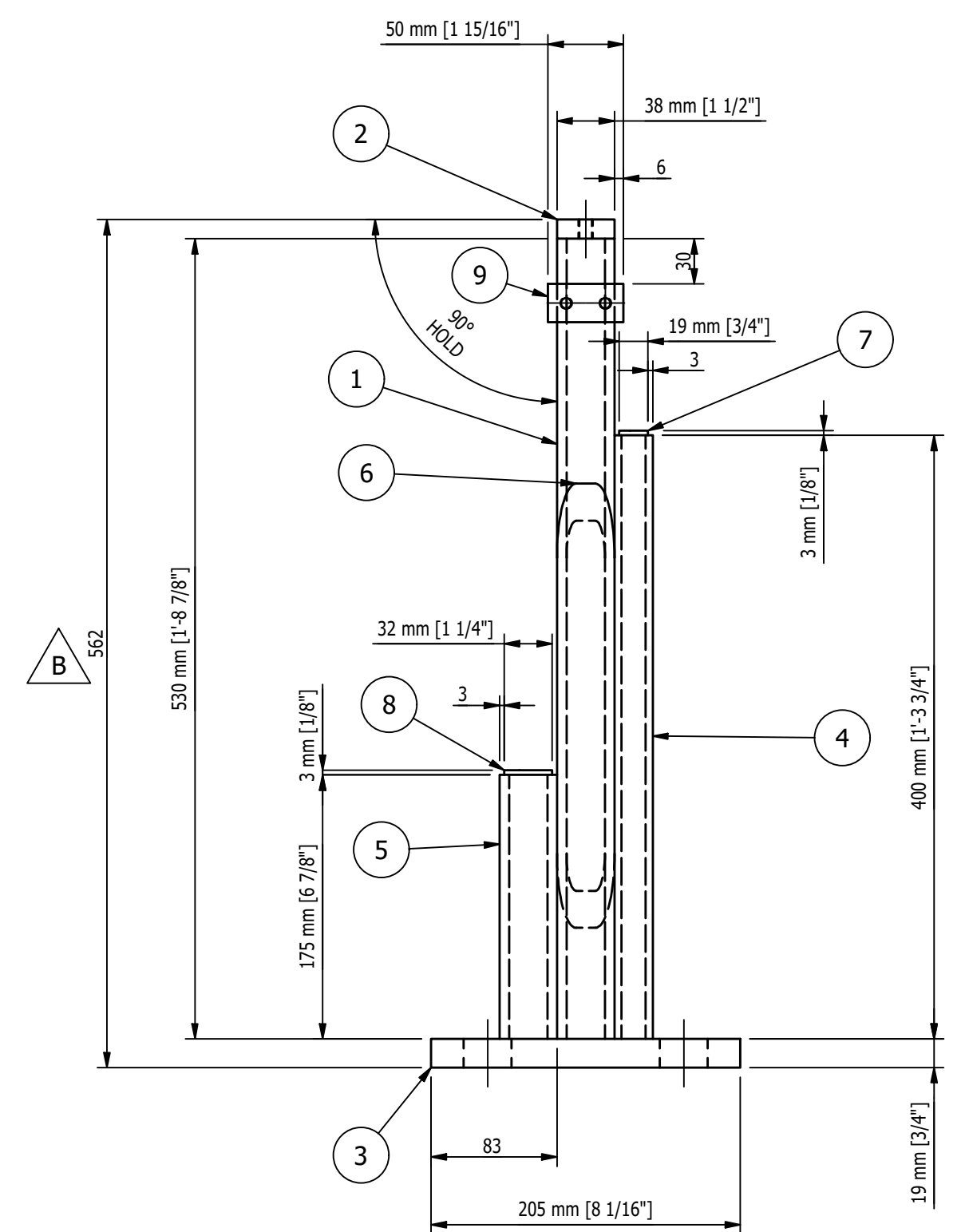
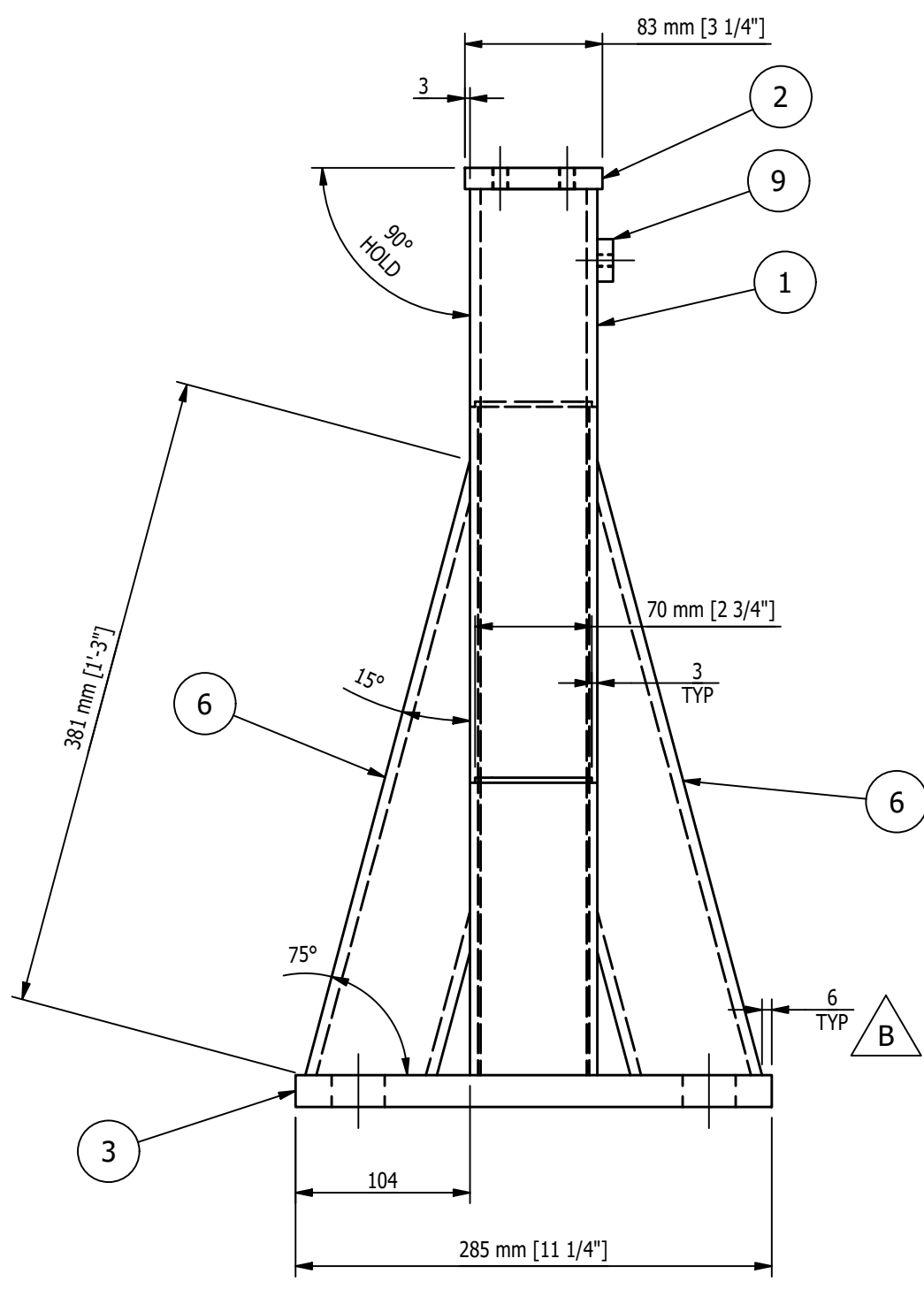
MAGNUM CONSULTING
41100 Clarkston Road
Suite 125
Northville, MI 48165
Phone: (248) 373-8833
Fax: (248) 373-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D363

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

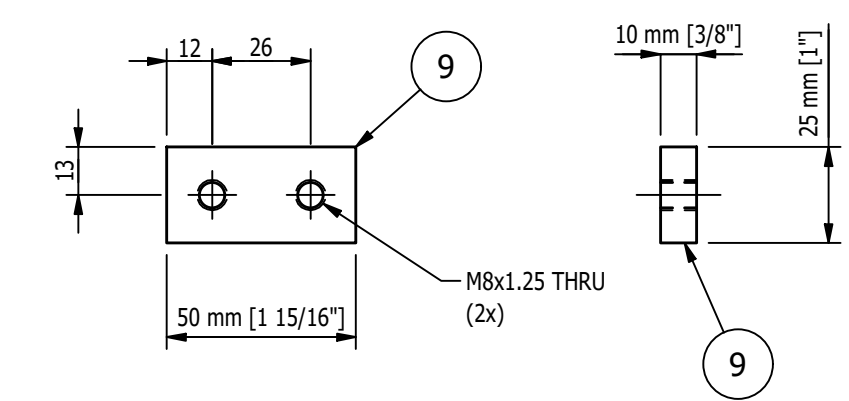
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D364A			
1	1	TS 3 x 1 1/2 x 1/4	1'-8 7/8"		
2	1	BAR 1/2 x 1 1/2	3 1/4"		
3	1	PL 3/4 x 8 1/16"	11 1/4"		
4	1	TS 3 x 1 x 3/16	1'-3 3/4"		
5	1	TS 3 x 1 1/2 x 1/4	6 7/8"		
6	2	TS 3 x 1 1/2 x 1/4	1'-3"		
7	1	SHT 11 GA x 3/4	2 3/4"		
8	1	SHT 11 GA x 1 1/4	2 3/4"		
9	1	BAR 3/8 x 1	1 15/16"		



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

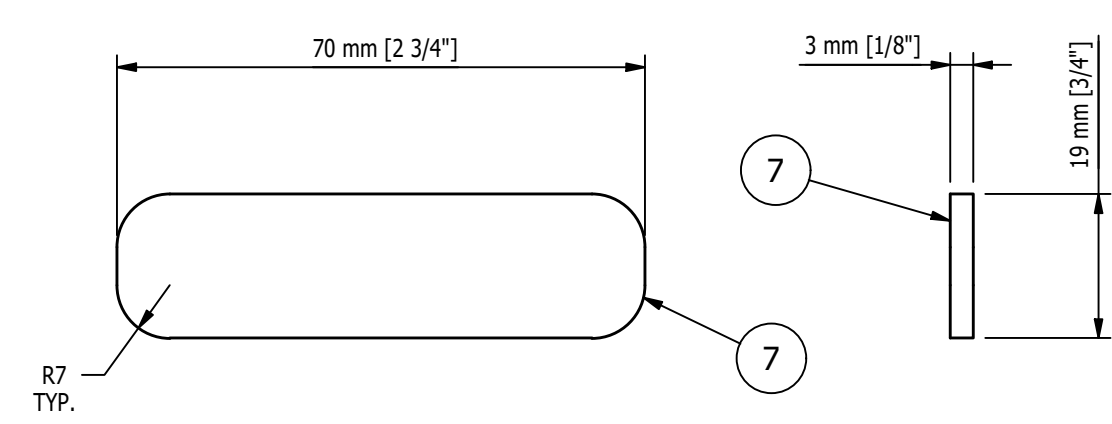


DETAIL OF ITEM '2'
SCALE 6"=1'-0"

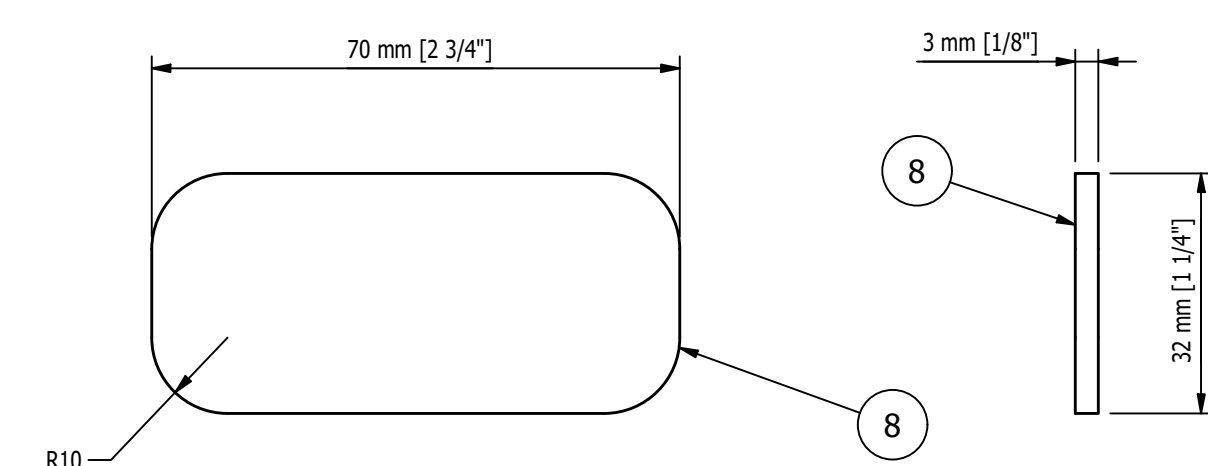


DETAIL OF ITEM '9'
SCALE 6"=1'-0"

MK-D364A ~ REST PAD STANCHION
SCALE 3"=1'-0"



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



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

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	ADDED DETAIL VIEW OF ITEM '6' & DIMS	
A	MC	8/26/2022	FOR FABRICATION	

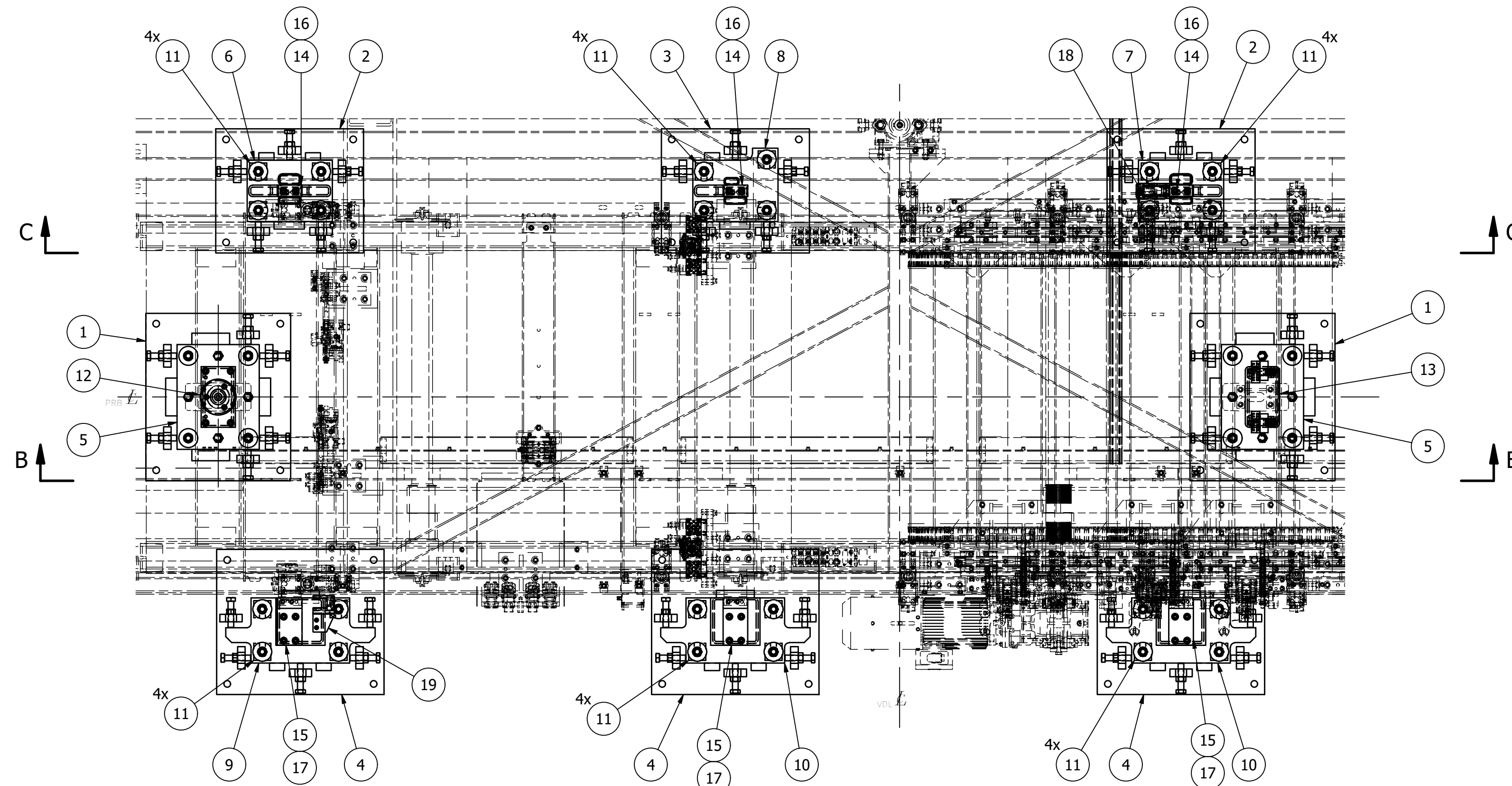
REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
		FENTON, MI 48430		DRAWING IS THE SOLE PROPERTY	
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TITLE: P6700 CONVEYORS		DRAWN BY: PWP		CHECKED BY: JCK	
CLIENT: VOLVO		DWG DATE: 8/1/22		JOB No: 22096	
DRAWING No. 1875D364		REV: B			

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41100 Clarkston Rd
Suite 125
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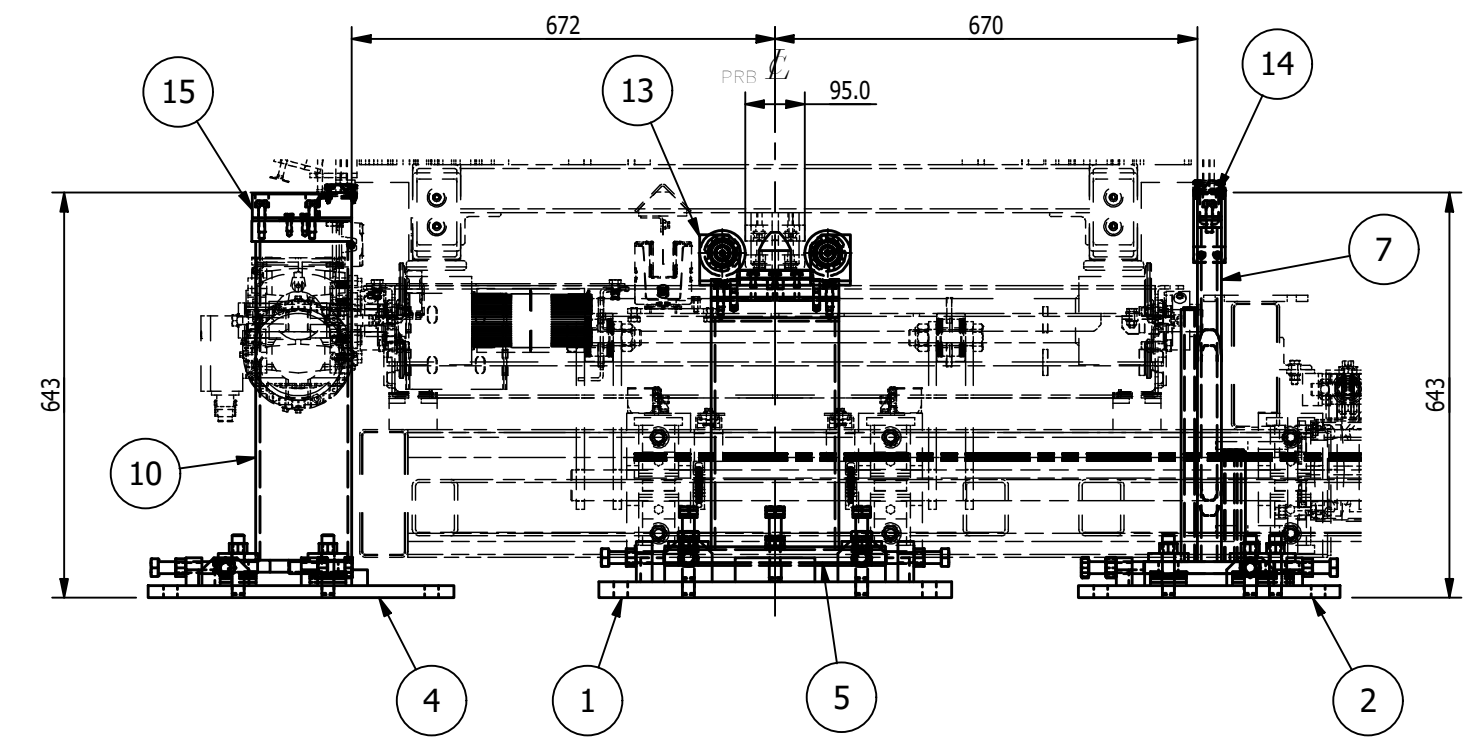
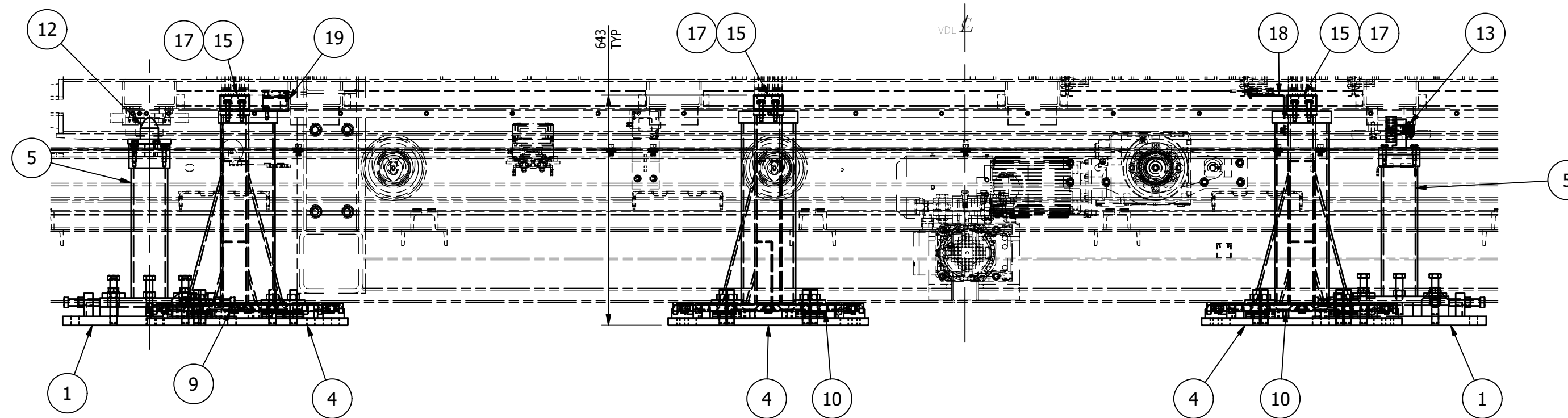
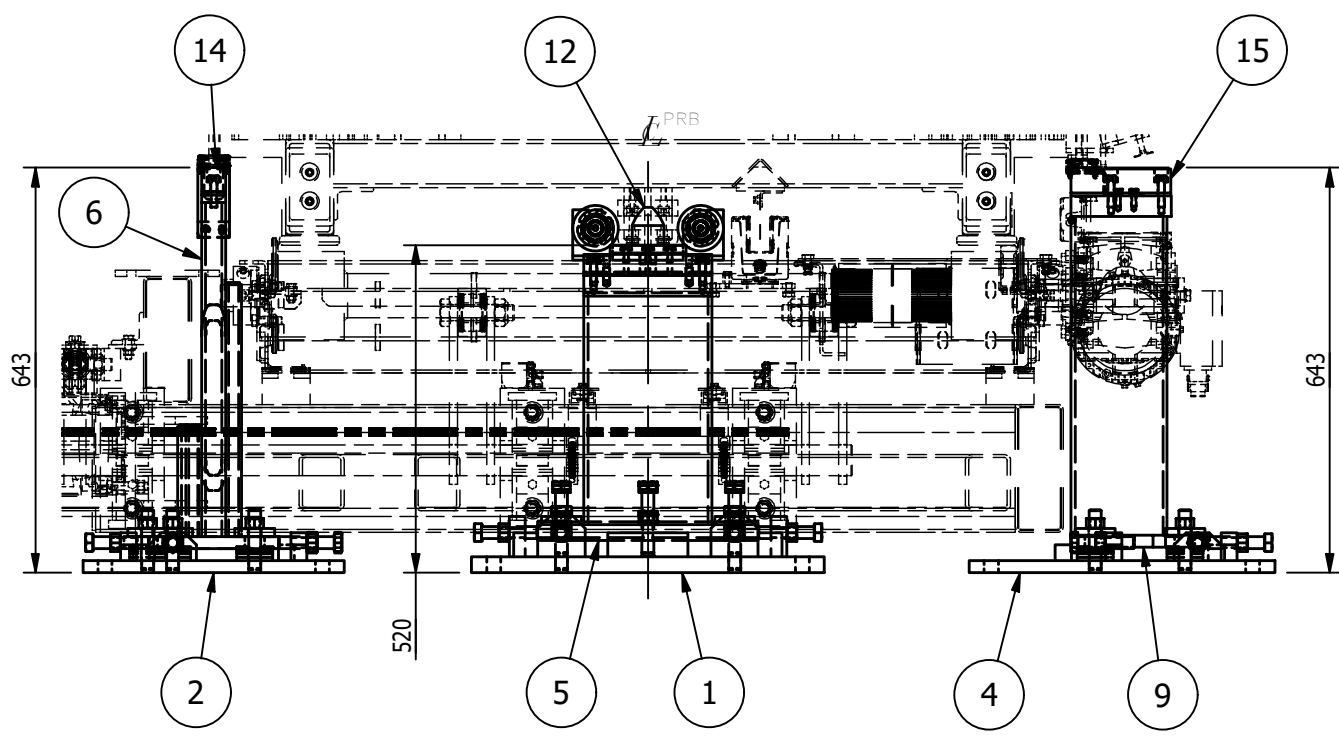
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D364

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

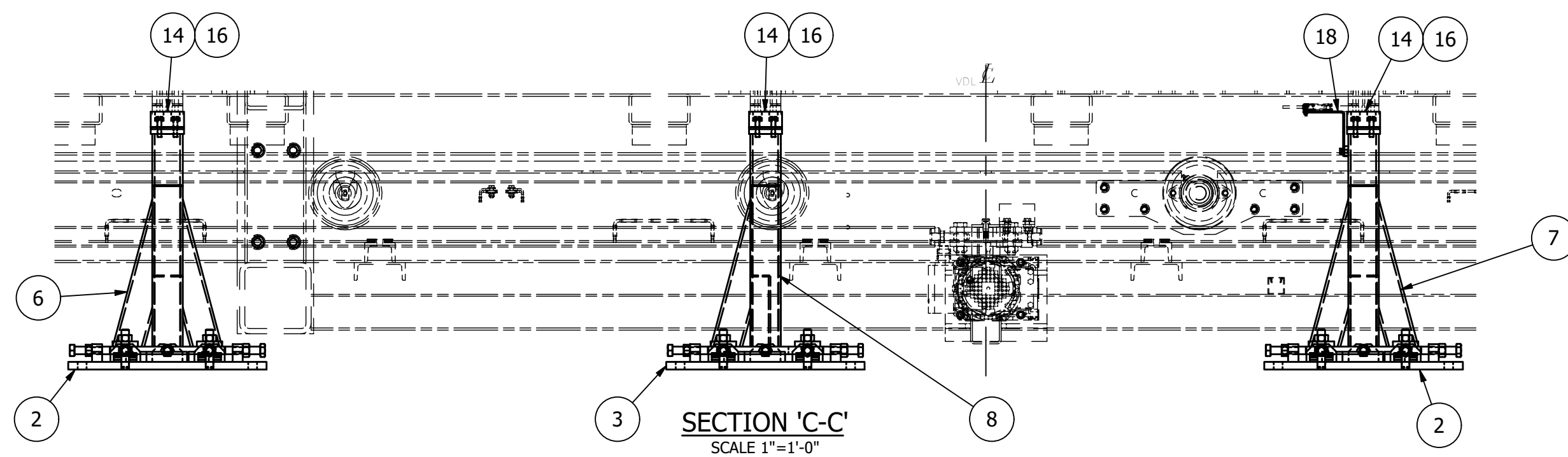
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN 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.



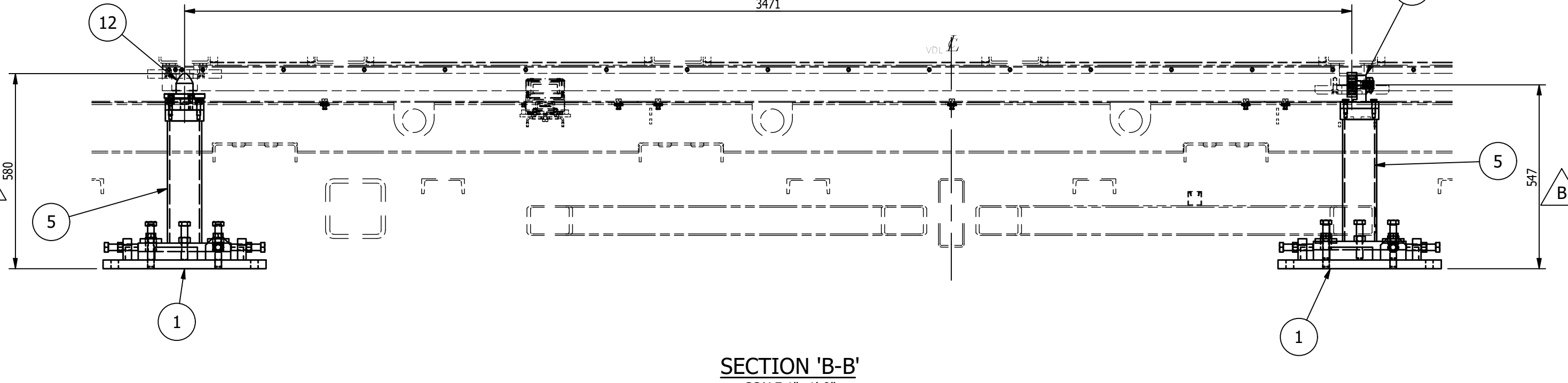
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D365A			
1	2	MK-D372A ~ STANCHION BASE			
2	2	MK-D377A ~ STANCHION BASE			
3	1	MK-D378A ~ STANCHION BASE			
4	3	MK-D376A ~ STANCHION BASE			
5	2	MK-D373A ~ STANCHION MACH (LOCATOR)			
6	1	MK-D363A ~ REST PAD STANCHION			
7	1	MK-D364A ~ REST PAD STANCHION			
8	1	MK-D381A ~ REST PAD STANCHION			
9	1	MK-D361A ~ REST PAD STANCHION MACHINE			
10	2	MK-D362A ~ REST PAD STANCHION MACHINE			
11	24	MK-D366C ~ SHIM PACK			
12	1	MK-D383A ~ 4 WAY LOCATOR PIN ASSEMBLY			
13	1	MK-D369A ~ 2 WAY LOCATOR ASSEMBLY			
14	3	MK-D366A ~ D-LOC REST PAD			
15	3	MK-D379A ~ Z REST PAD			
16	3	MK-D366B ~ Z REST PAD SHIM			
17	3	MK-D379B ~ Z REST PAD SHIM			
18	1	MK-D367A ~ BRACKET			
19	1	MK-D219A ~ SLOT SENSOR DO BRACKET			
		TOTAL WEIGHT ~ 1477.5 lbs			



MK-D365A ~ VDL D-LOC ASSEMBLY
SCALE 1"=1'-0"



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



SECTION 'B-B'
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.

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MAGNUM DRAWING #: 1875D365

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

GENERAL NOTES:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	CORRECTED LOCATOR SET-UP HEIGHT	
A	MC	8/26/2022	FOR FABRICATION	

SHEET 1 OF 2

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FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
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TITLE: P6700 CONVEYORS
CAMPUS BUILDING

CLIENT: VOLVO

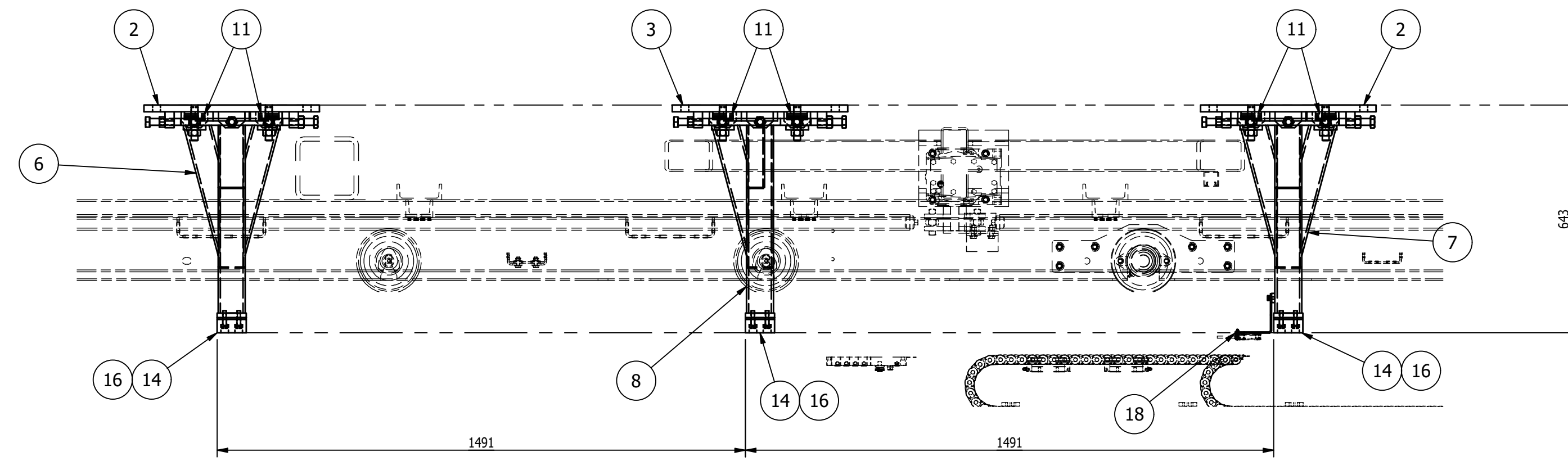
DRAWING No.: 1875D365

REV: A

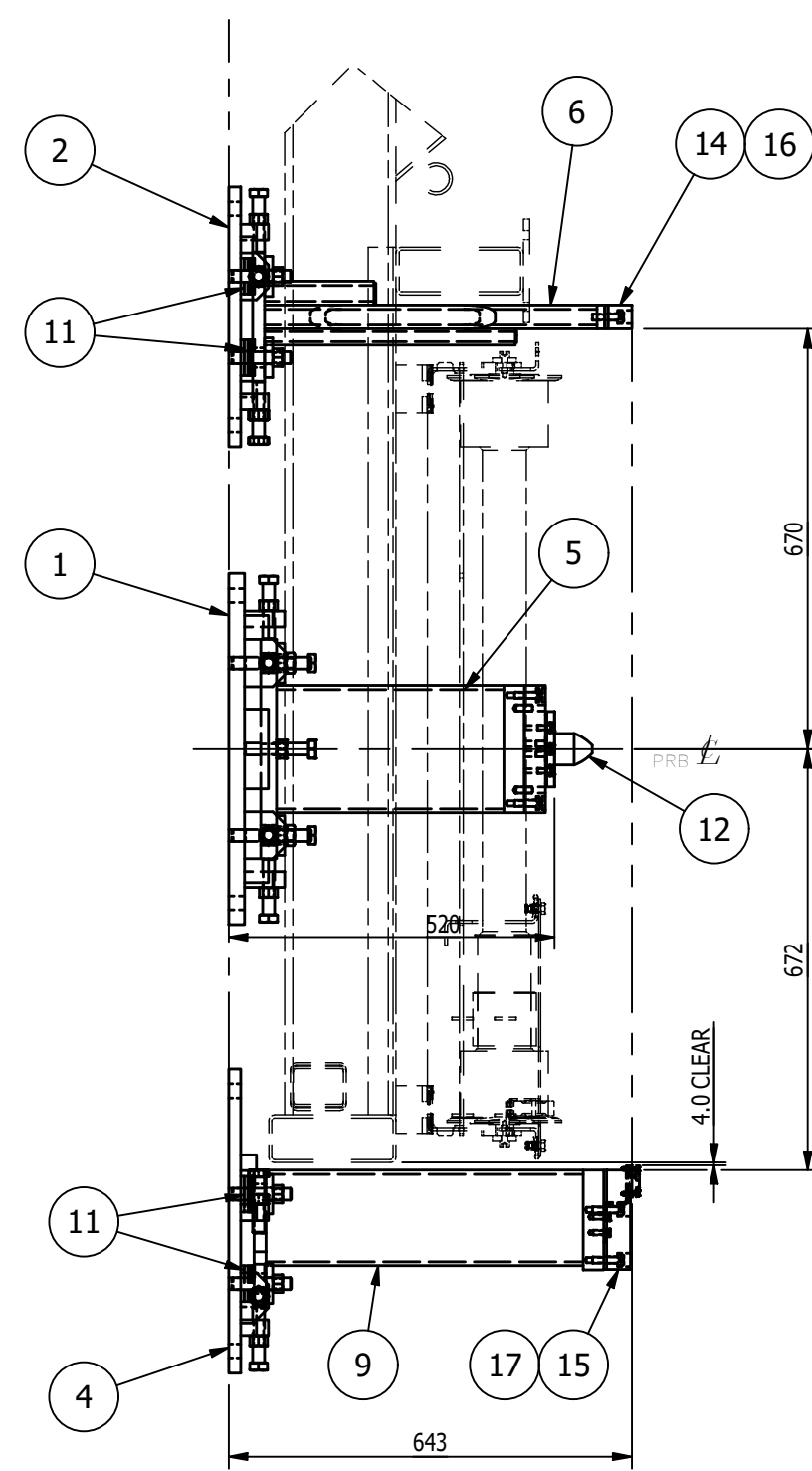
JOB No.: 22096

DRAWN BY: PWP
CHECKED BY: JCK
DWG DATE:
JOB No.: 22096

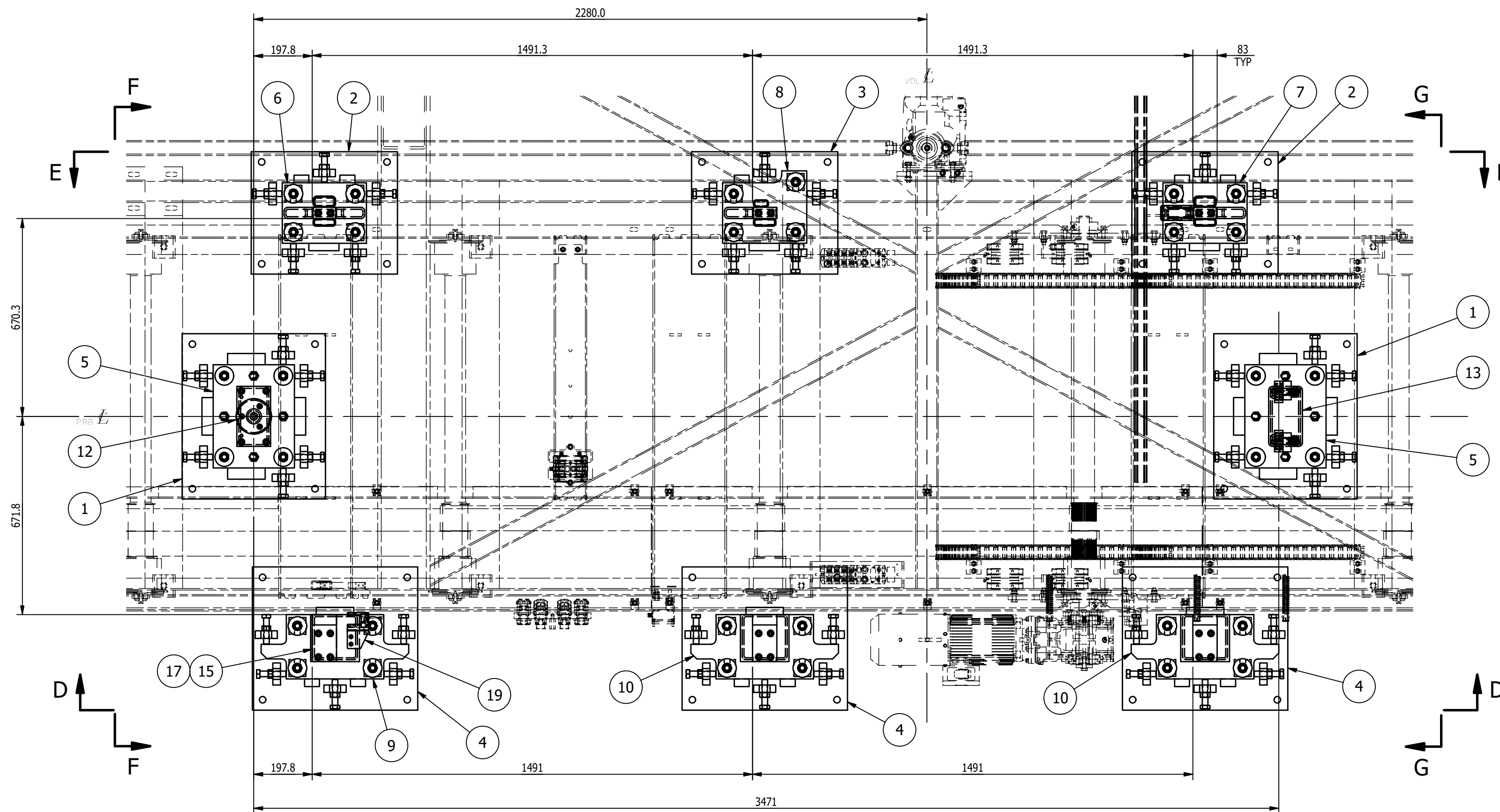
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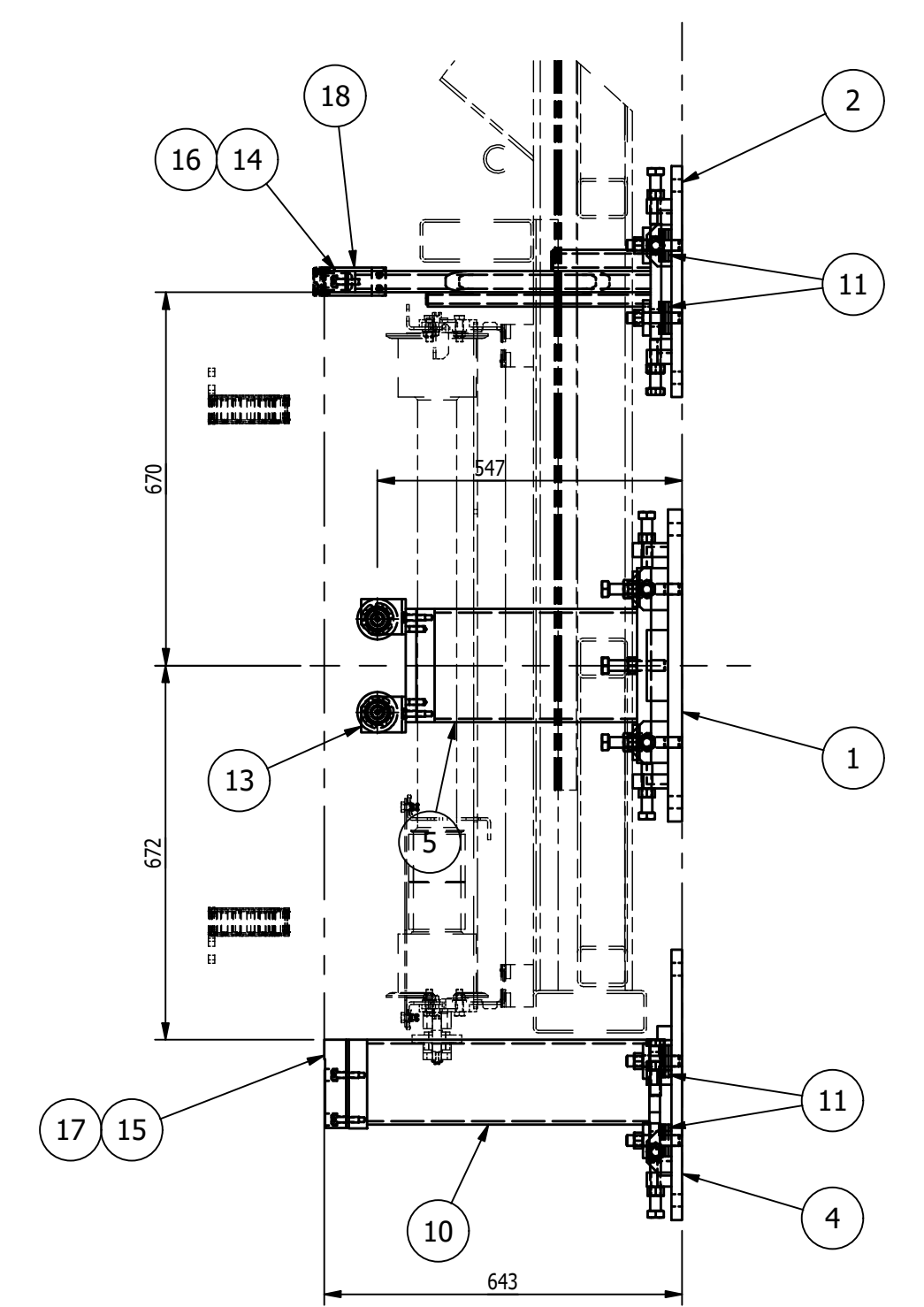
SECTION 'E-E'
SCALE 1"=1'-0"



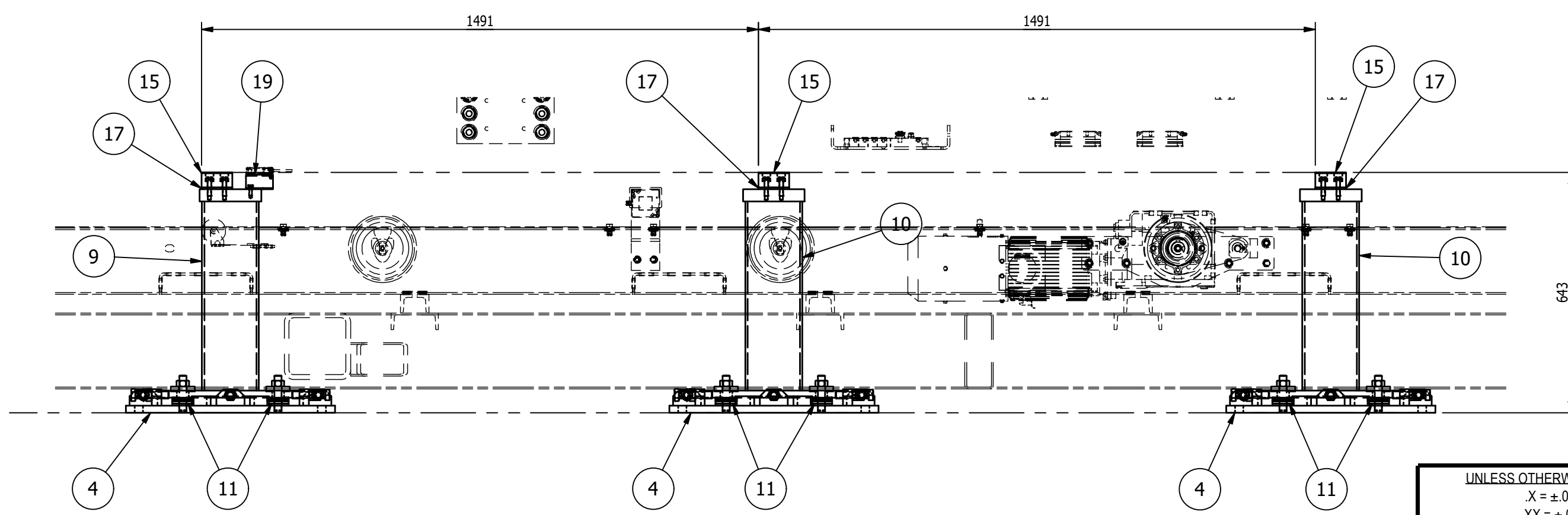
VIEW 'F-F'
SCALE 1"=1'-0"



MK-D365A ~ VDL D-LOC ASSEMBLY ~ SET-UP
SCALE 1"=1'-0"



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



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

SHEET 2 OF 2
SEE SHEET 1 FOR REVISION BLOCK

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

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



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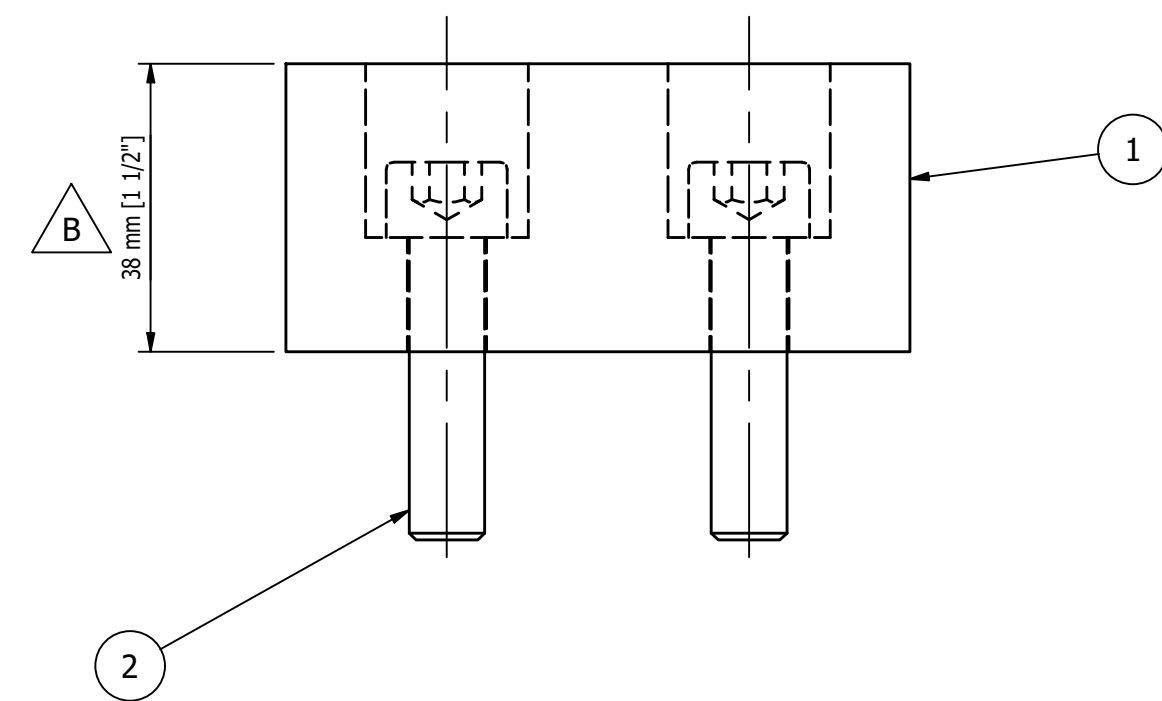
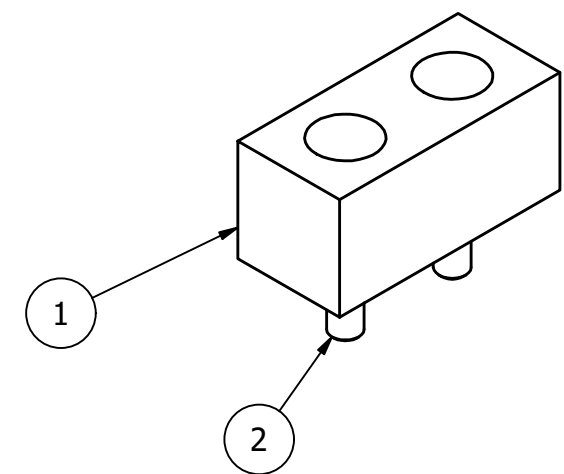
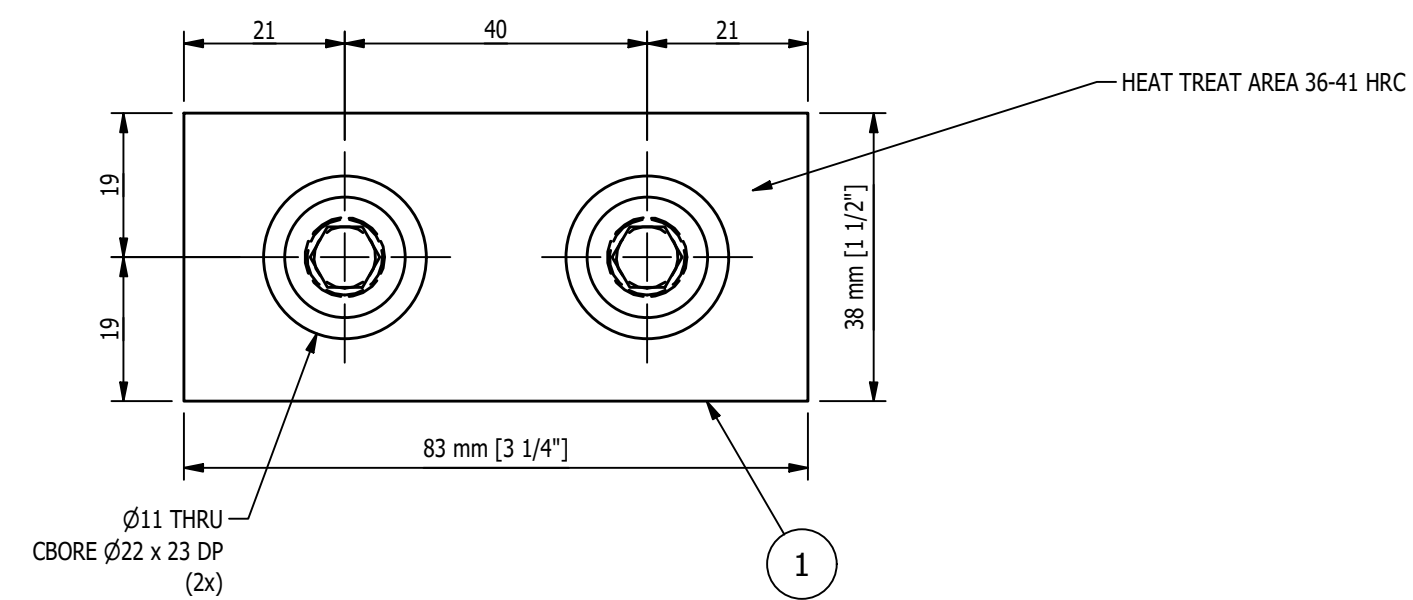
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TITLE: P6700 CONVEYORS
CAMPUS BUILDING

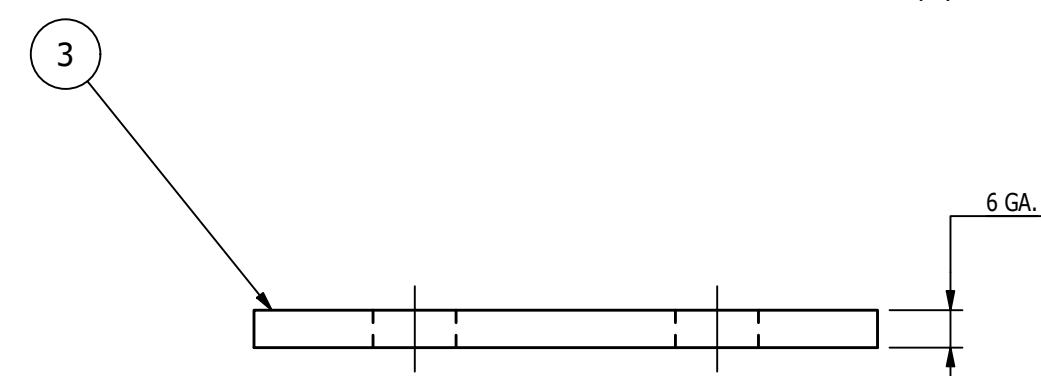
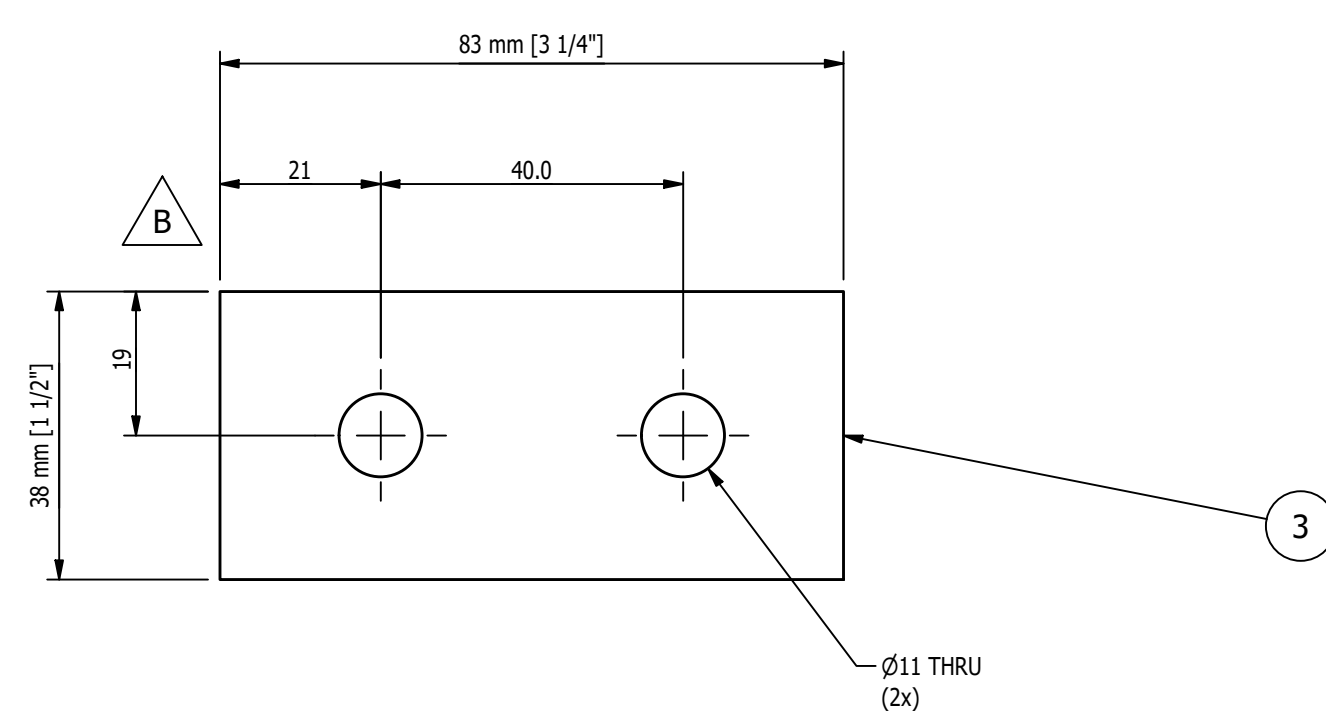
CLIENT: VOLVO

DRAWING No. 1875D365

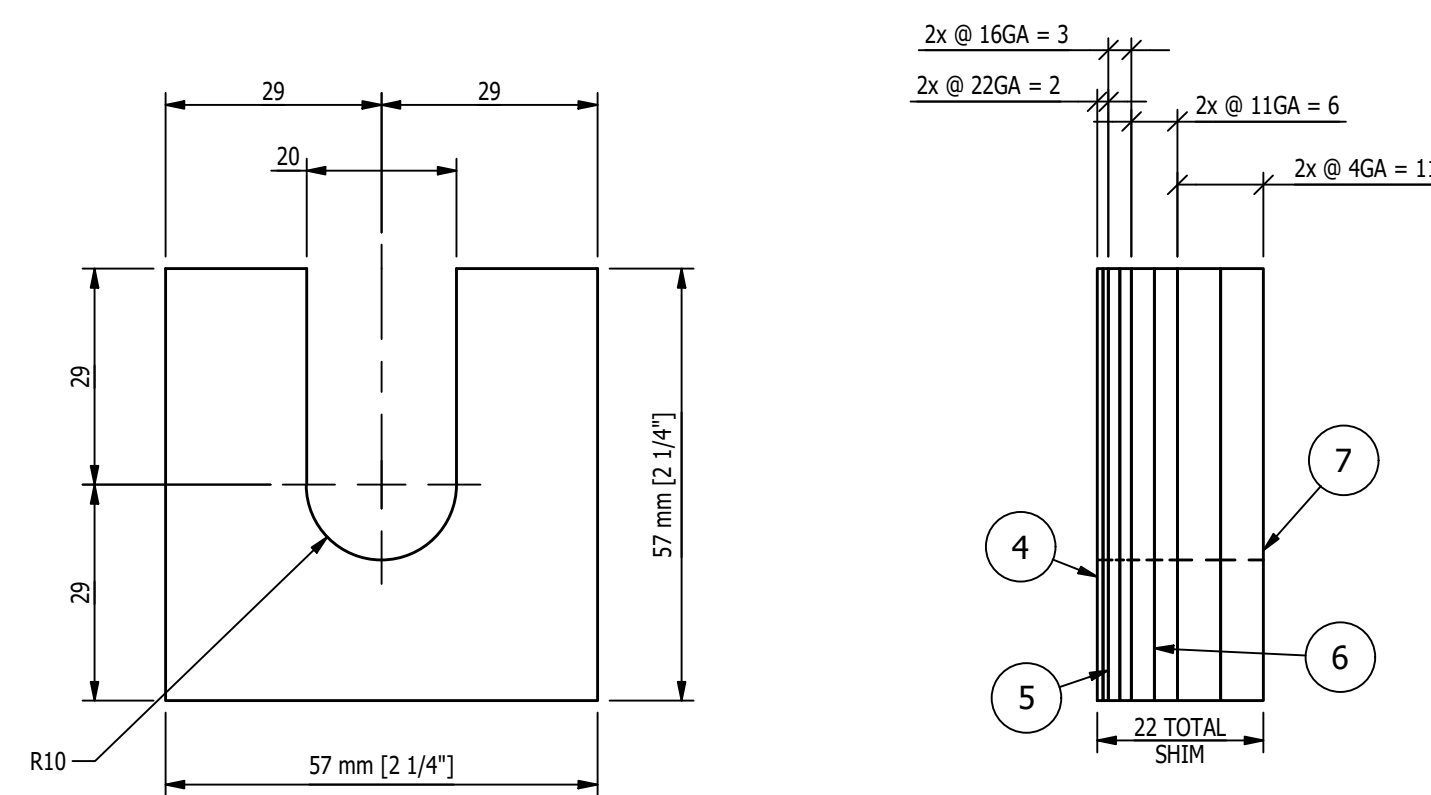
REV: A	JOB No: 22096
DWG DATE:	CHECKED BY: JCK
	DRAWN BY: PWP



MK-D366A ~ D-LOC REST PAD
SCALE 1'-0" = 1'-0"



MK-D366B ~ Z REST PAD SHIM
SCALE 1'-0" = 1'-0"



MK-D366C ~ SHIM PACK
SCALE 1'-0" = 1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D366A			
1	1	BAR 1 1/2 x 1 1/2 (4140)	3 1/4"		
2	2	M10x1.5 x 40mm LG. HEX SOCKET HEAD CAP SCREW			
		MK-D366B			
3	1	SHT 6 GA x 1 1/2	3 1/4"		
		MK-D366C			
4	2	SHT 22 GA x 2 1/4	2 1/4"		
5	2	SHT 16 GA x 2 1/4	2 1/4"		
6	2	SHT 11 GA x 2 1/4	2 1/4"		
7	2	SHT 4 GA x 2 1/4	2 1/4"		

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	UPDATED DIM PRECISION, BOM LENGTHS FOR ITEM '3' & ADDED STOCK DIM FOR FABRICATION	
A	MC	8/26/22	FOR FABRICATION	

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TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: PWP
CLIENT: VOLVO		CHECKED BY: JCK
DRAWING No. 1875D366		DWG DATE: 8/15/22
REV: B		JOB No: 22096

MAGNUM Consulting
 41100 Charleston Rd.
 Suite 125
 Noris, MI 48275
 Phone: (248) 373-8833
 Fax: (248) 373-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D366

UNLESS OTHERWISE NOTED:
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 FRACTIONS = ±1/16"
 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)

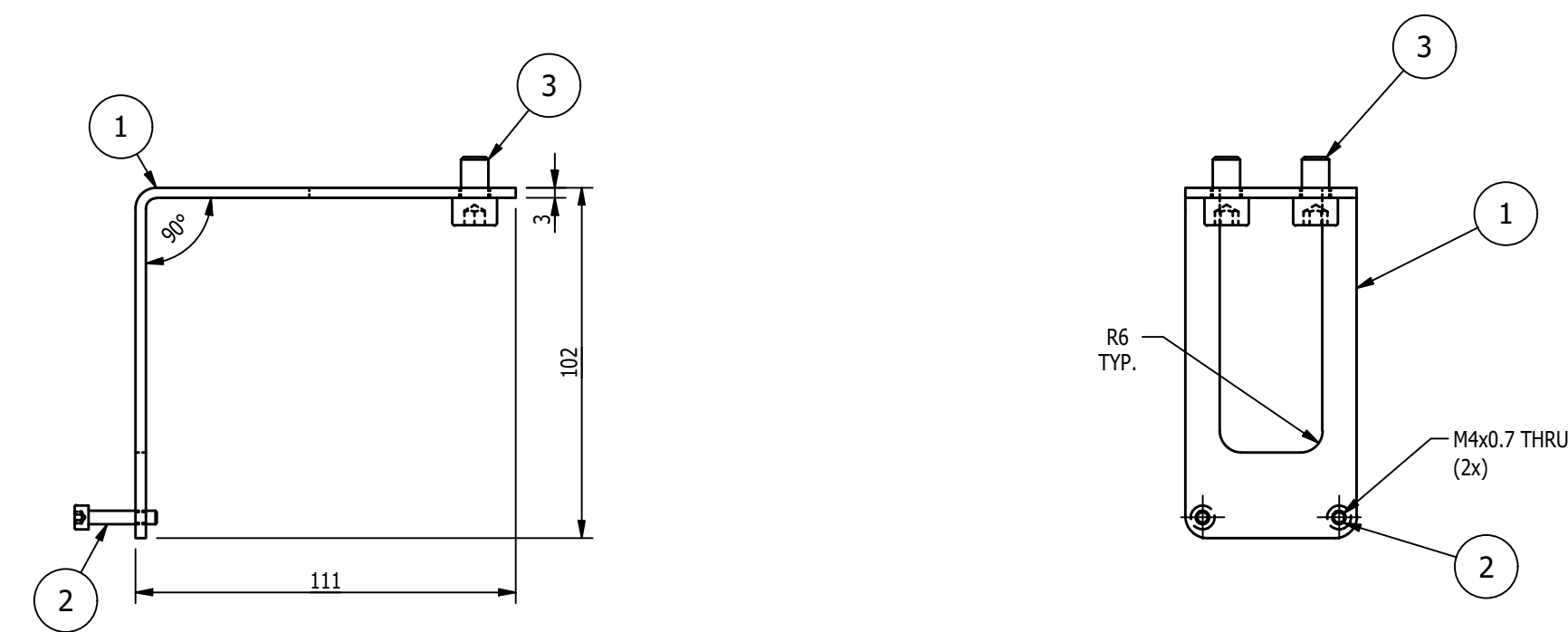
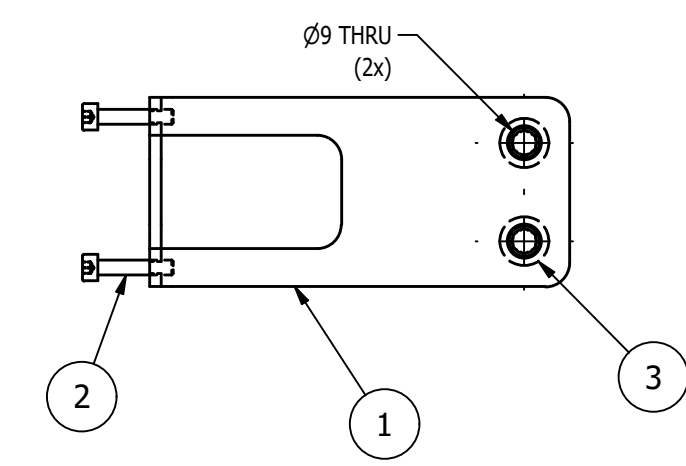
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

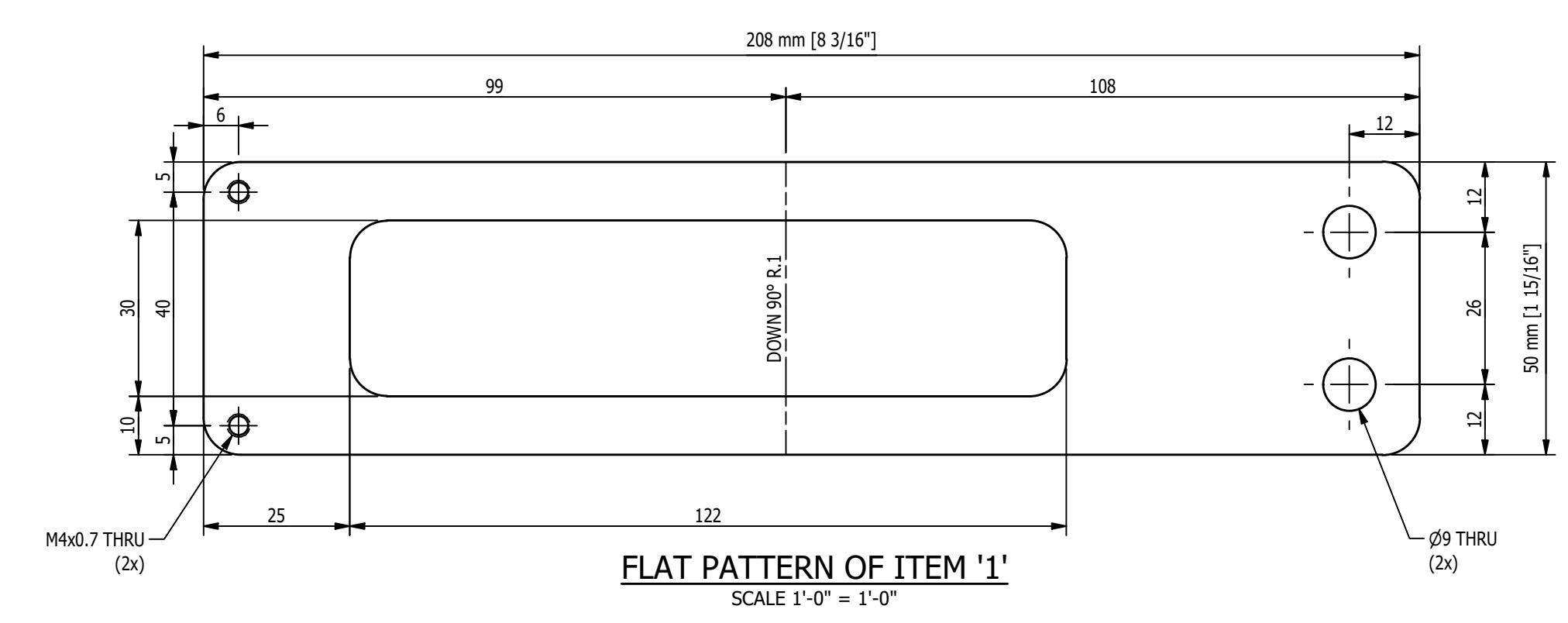
COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D367A			
1	1	SHT 11 GA x 1 15/16	8 3/16"		
2	2	M4x0.7 x 20mm LG. HEX SOCKET HEAD CAP SCREW			
3	2	M8x1.25 x 12mm LG. HEX SOCKET HEAD CAP SCREW			



MK-D367A ~ BRACKET
SCALE 6"=1'-0"



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

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/26/2022	FOR FABRICATION	

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	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO	DRAWN BY: AH CHECKED BY: JCK DWG DATE: 8/15/22

DRAWING No. 1875D367	REV: A	JOB No: 22096
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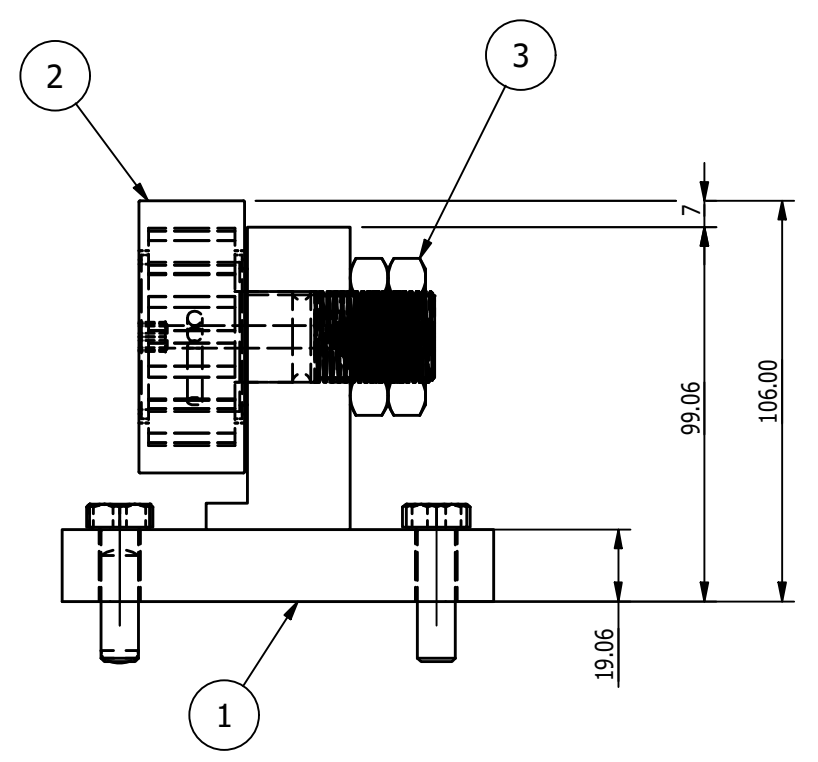
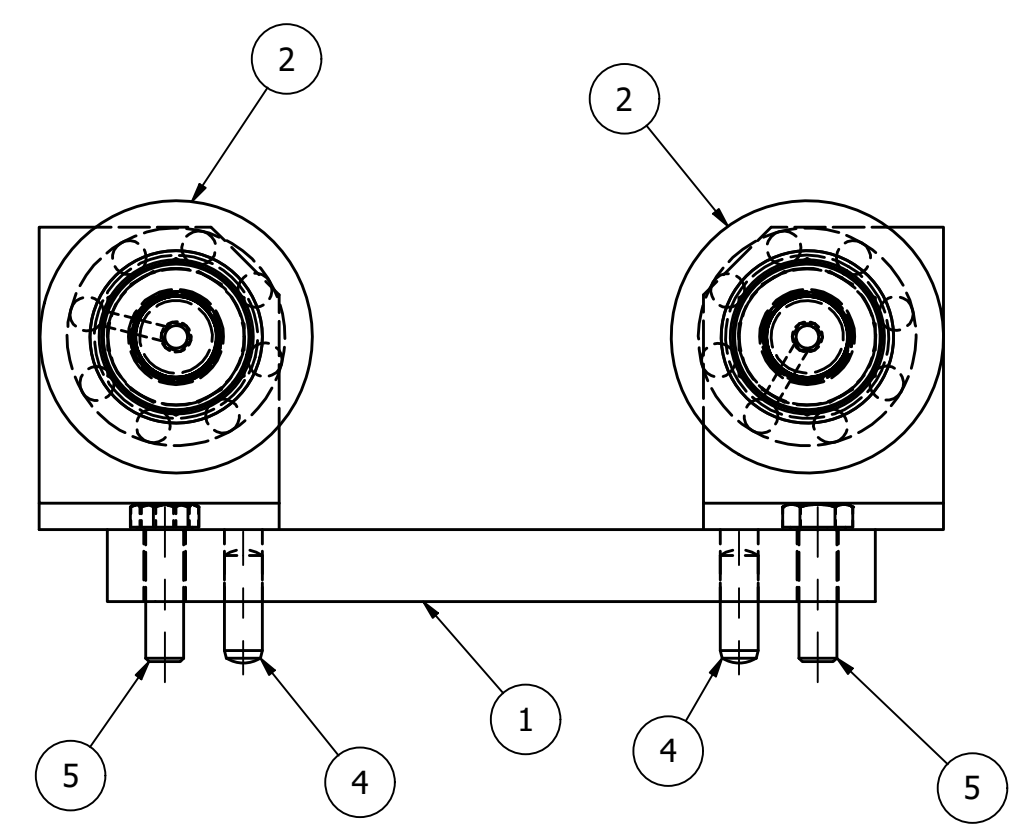
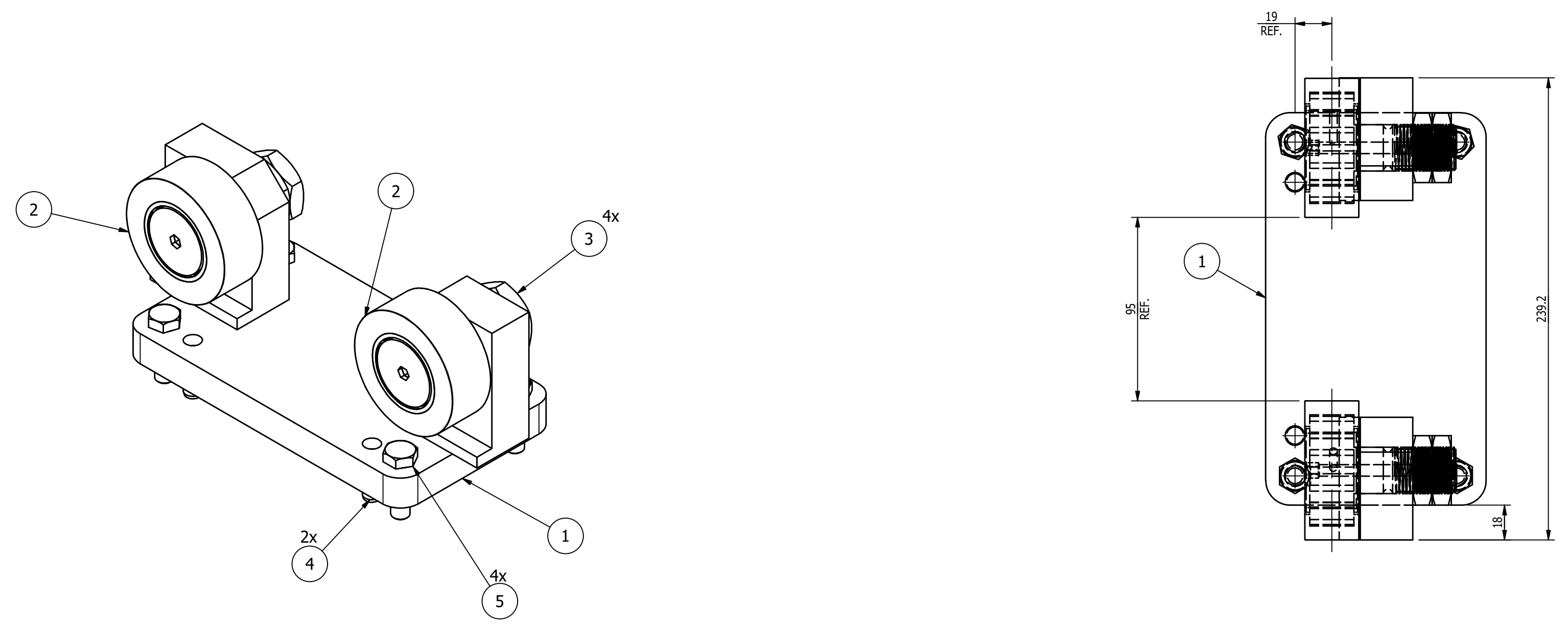
41100 Charleston Rd.
 Suite 125
 Norcross, GA 30071
 Phone: (770) 440-8822
 Fax: (770) 440-8821
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D367

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-D369A			
1	1	MK-D370A ~ 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 35mm LG. HEX CAP SCREW			



MK-D369A ~ 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
A	MC	8/26/2022	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: JC	
MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milc.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		CHECKED BY: JCK	
CLIENT: VOLVO		DWG DATE: 8/1/22	
DRAWING No. 1875D369		JOB No: 22096	

41100 Charleston Rd.
Suite 125
North, MI 48430

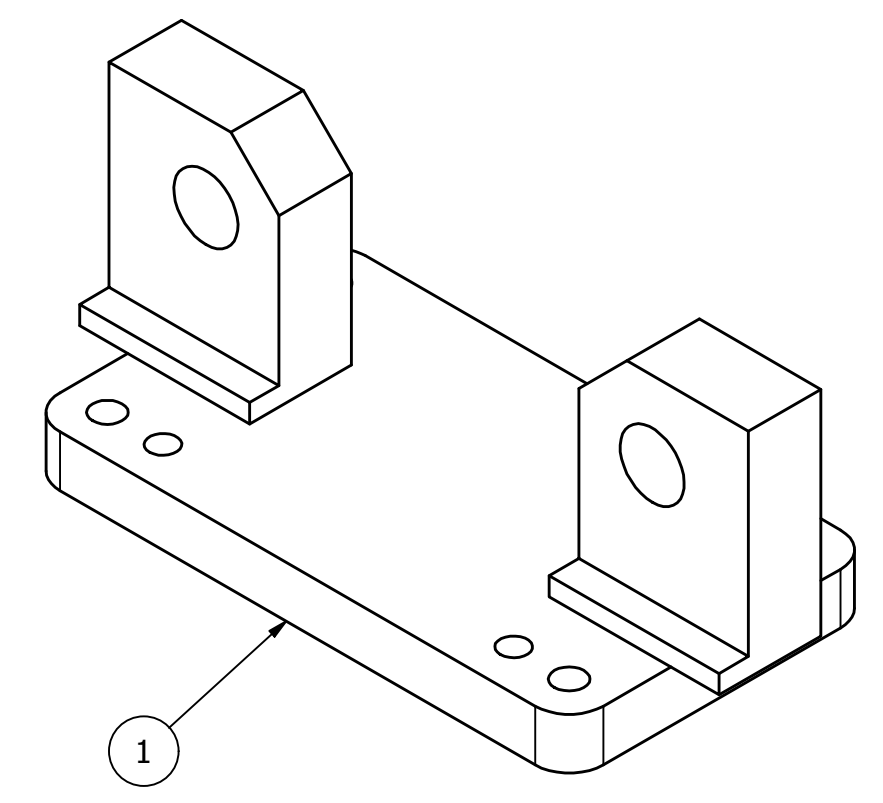
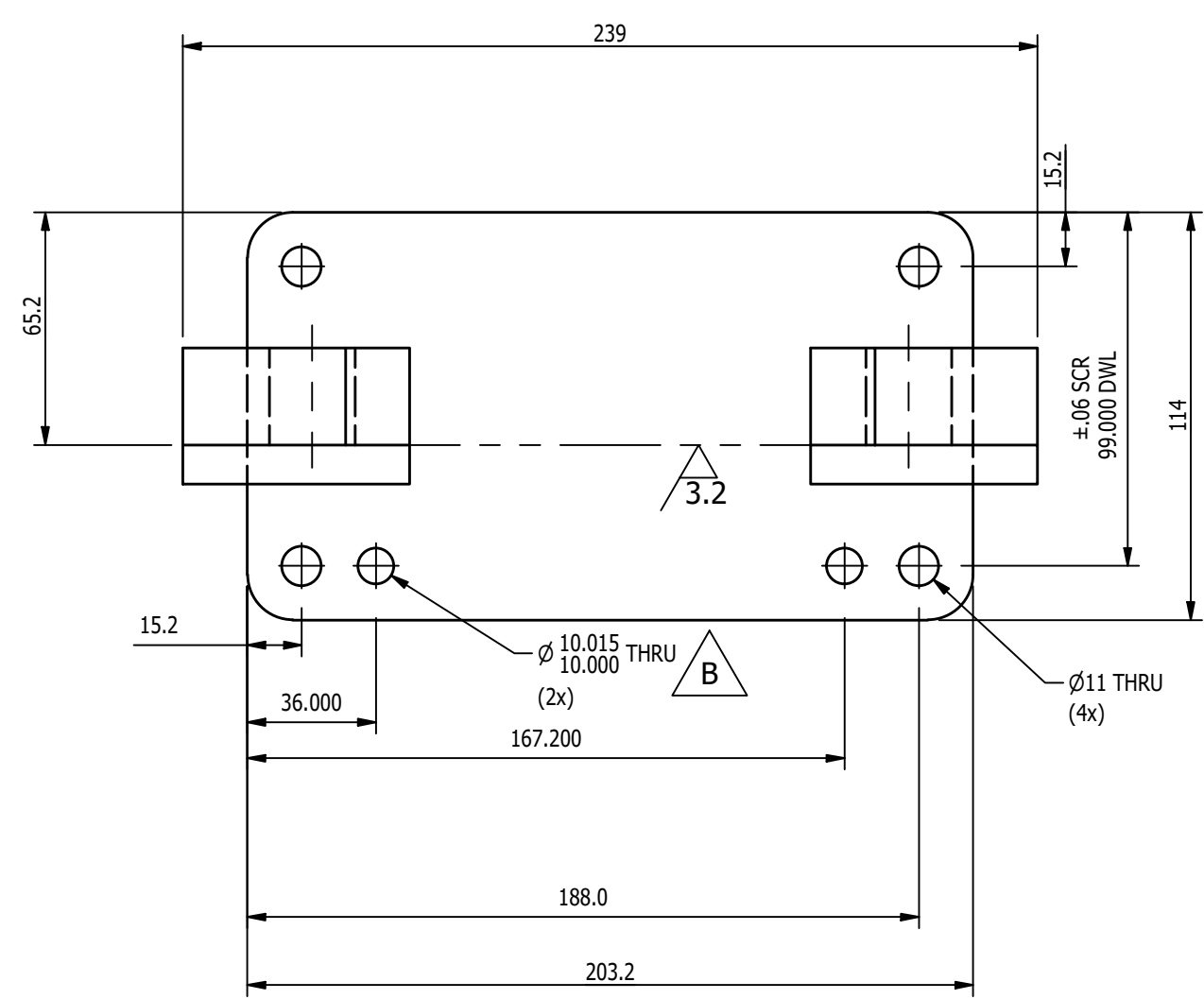
Phone: (248) 773-8833
Fax: (248) 773-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D369

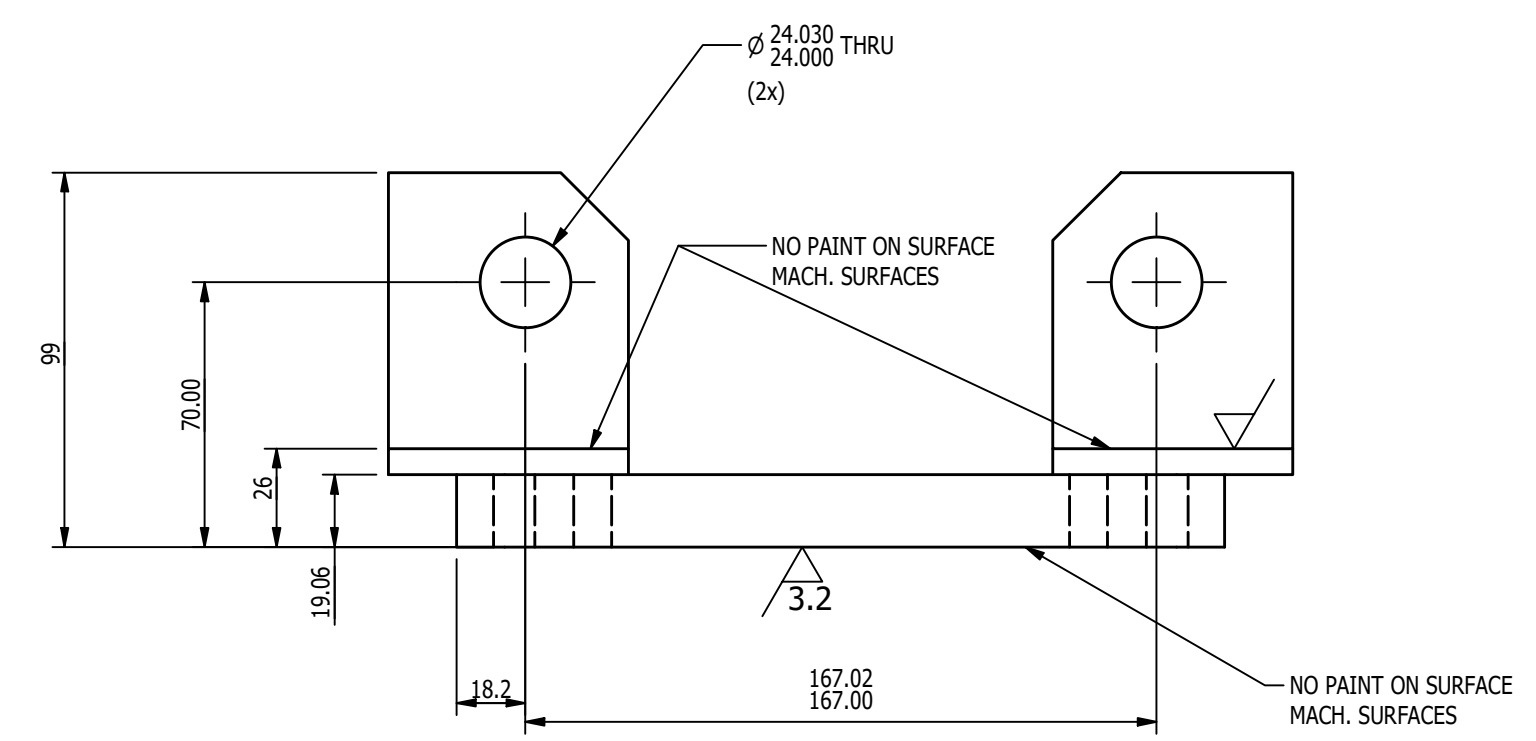
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XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM 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-D370A			
		MK-D371A ~ 2 WAY LOCATOR WELDMENT			



NO PAINT ON MACH. SURFACES



MK-D370A ~ 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 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
B	MC	9/7/2022	UPDATED TOLERANCE	
A	MC	8/26/2022	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: JC	
		CHECKED BY: JCK	
		DWG DATE: 8/1/22	
		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 QuakerRoad Rd.
Suite 125
North, MI 48175

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Fax: (248) 373-8851
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MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D370

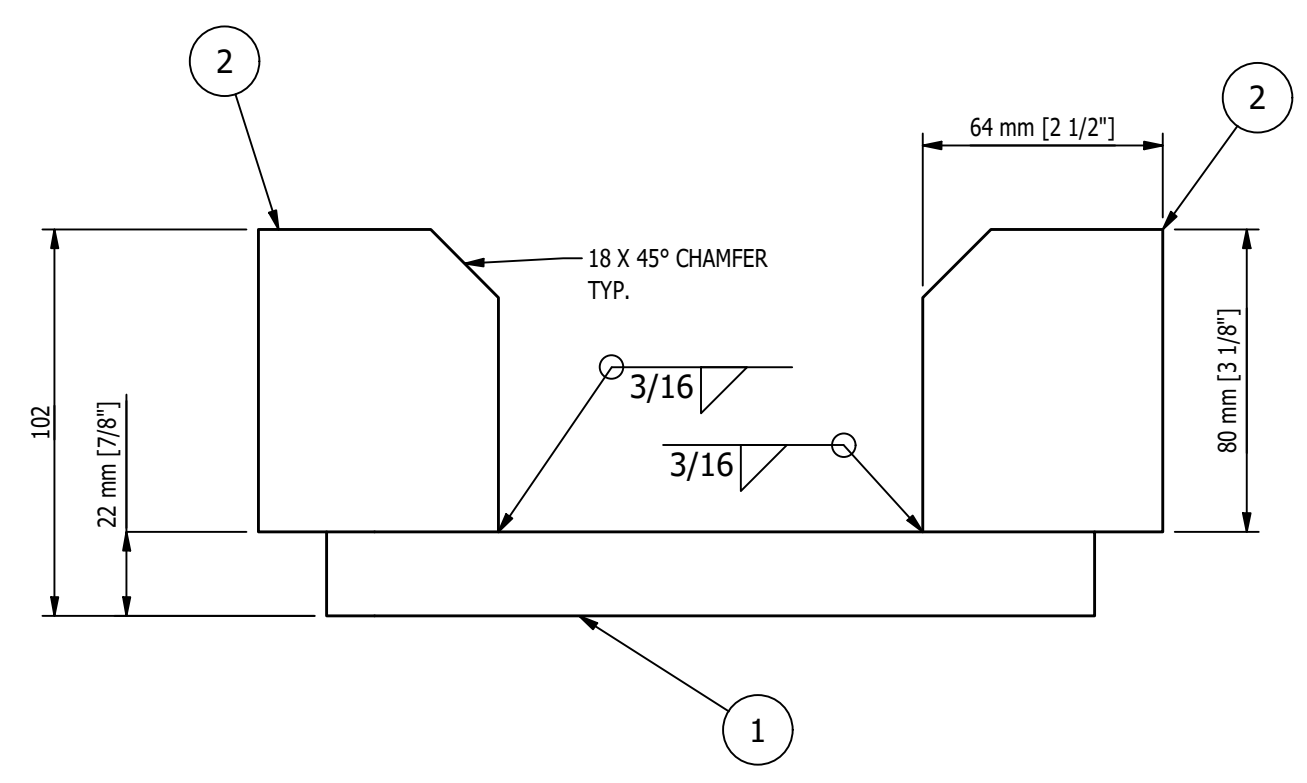
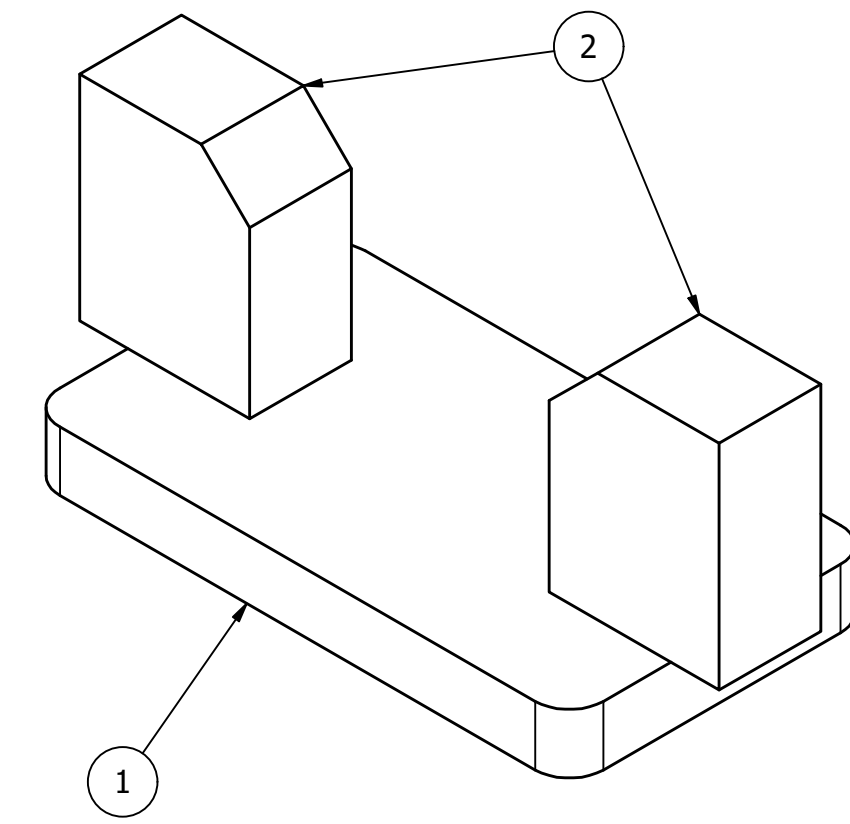
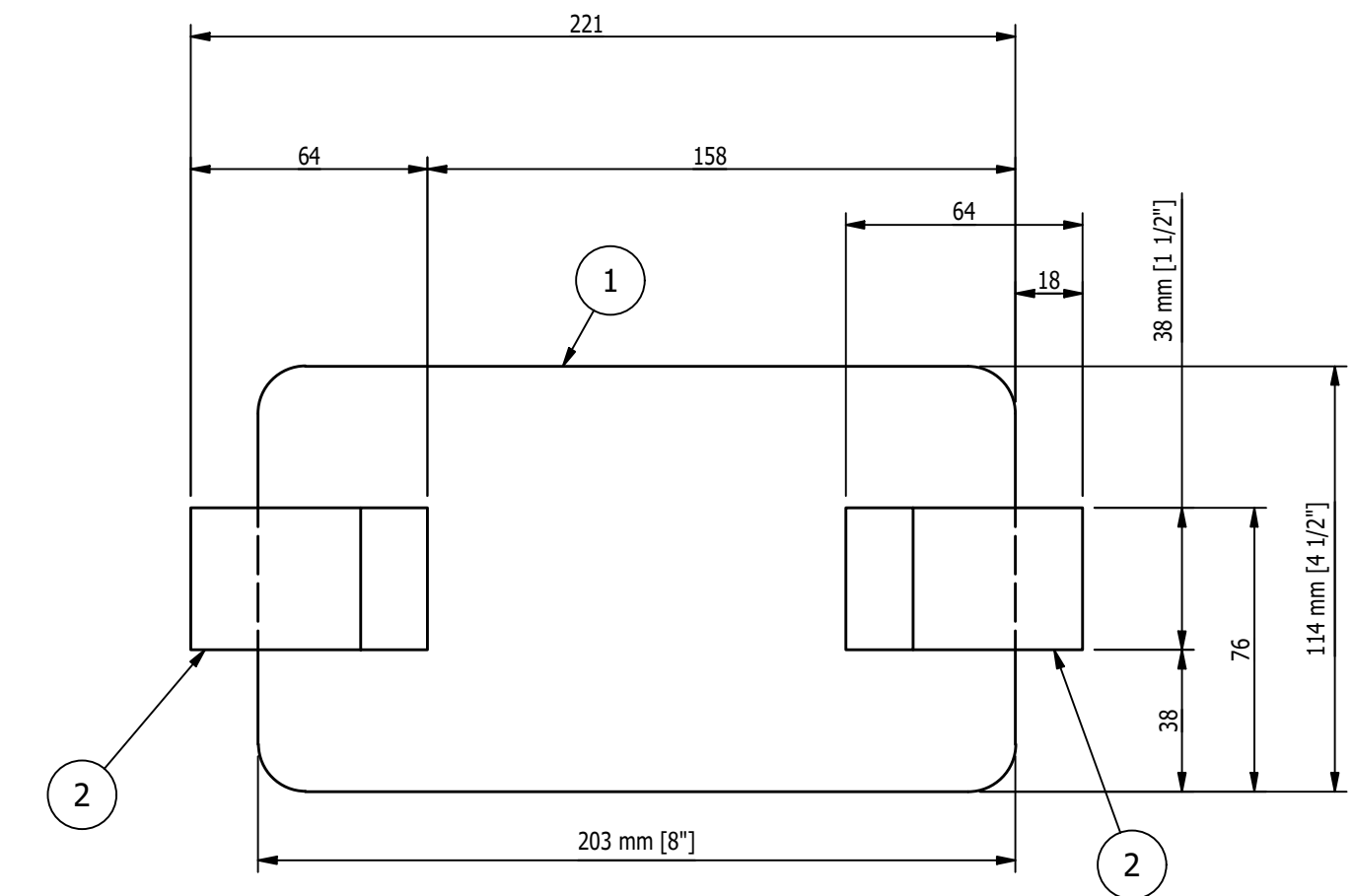
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ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



MILLER INDUSTRIES
3070 W. THOMPSON RD.
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BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D371A			
1	1	BAR 7/8 x 8	4 1/2"		
2	2	BAR 1 1/2 x 2 1/2	3 1/8"		




MK-D371A ~ 2 WAY LOCATOR WELDMENT
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
A	MC	8/26/2022	FOR FABRICATION	

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	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO DRAWING No. 1875D371

DRAWN BY: JC CHECKED BY: JCK DWG DATE: 8/1/22	REV: A JOB No: 22096
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41100 QuakerRoad Rd.
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Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D371

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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

GENERAL NOTES:

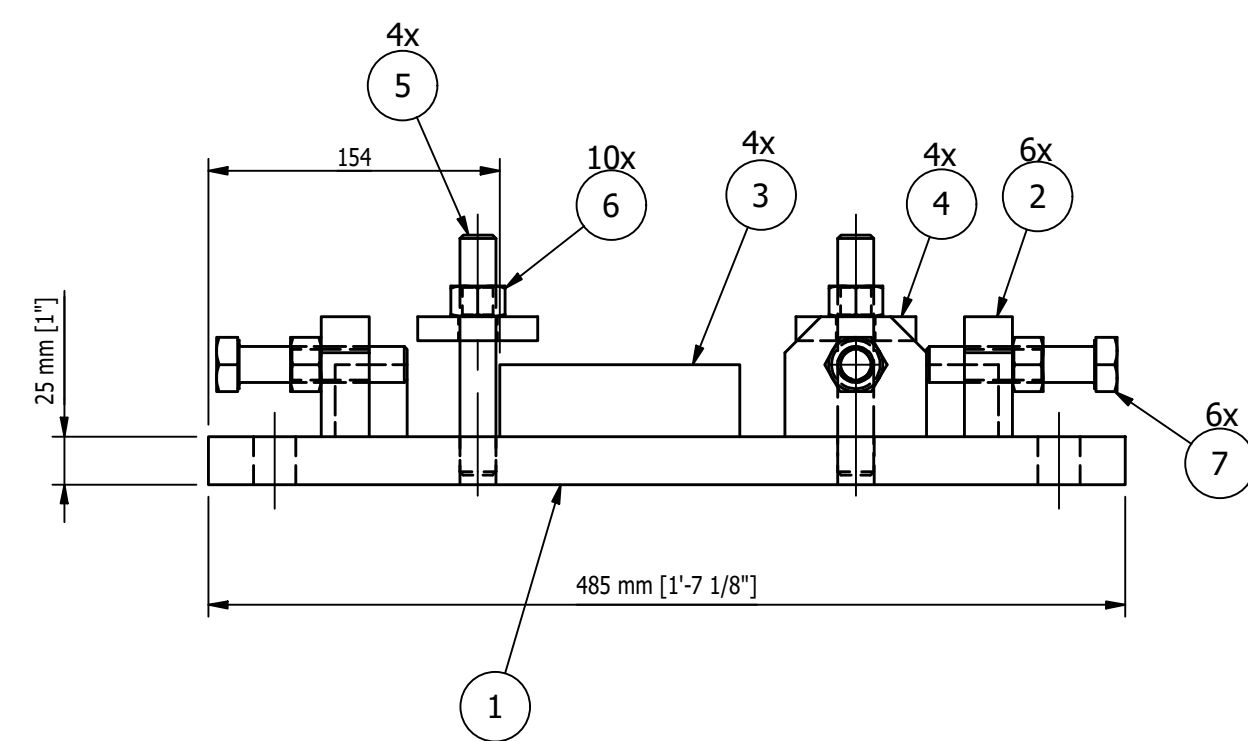
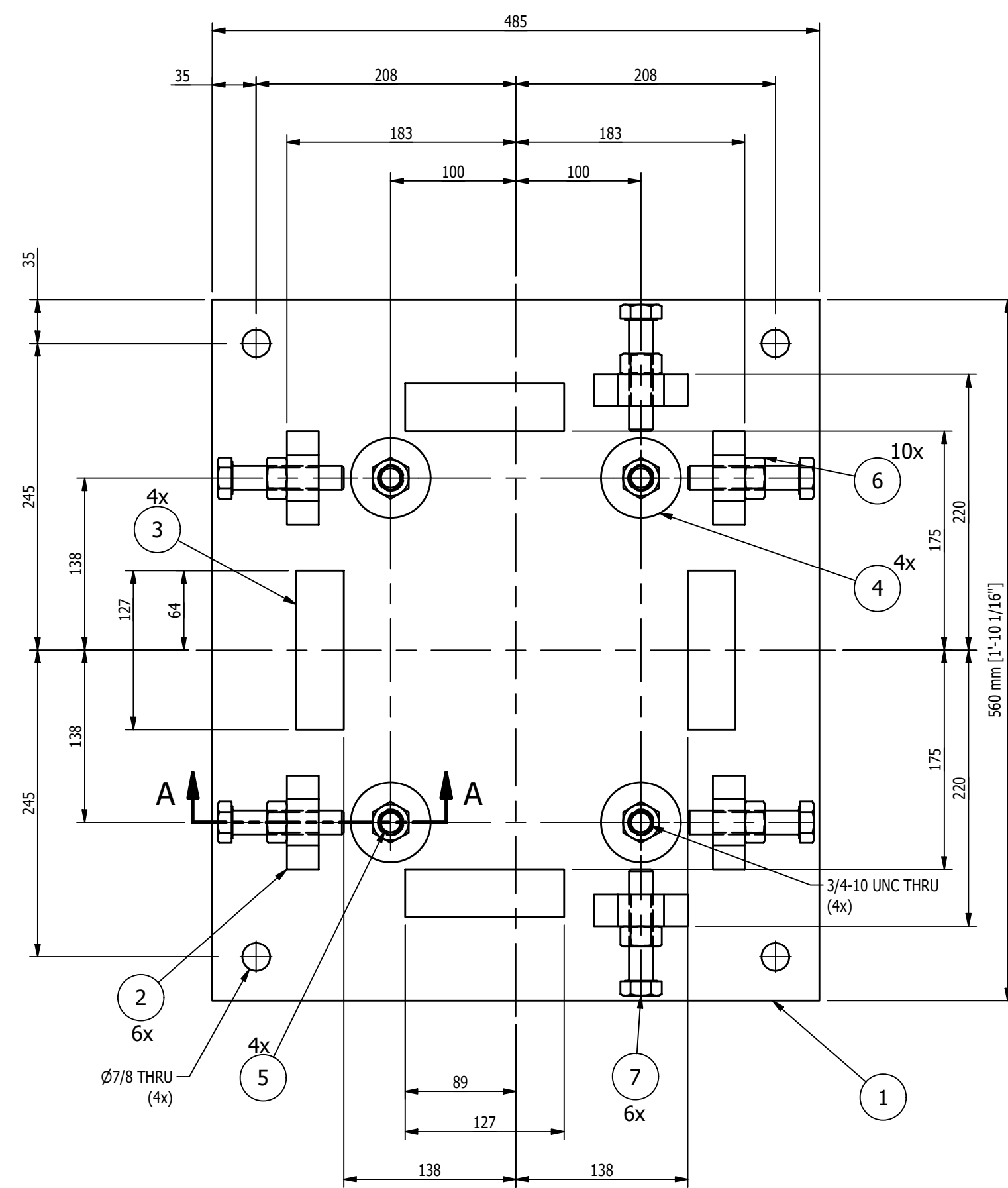
MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

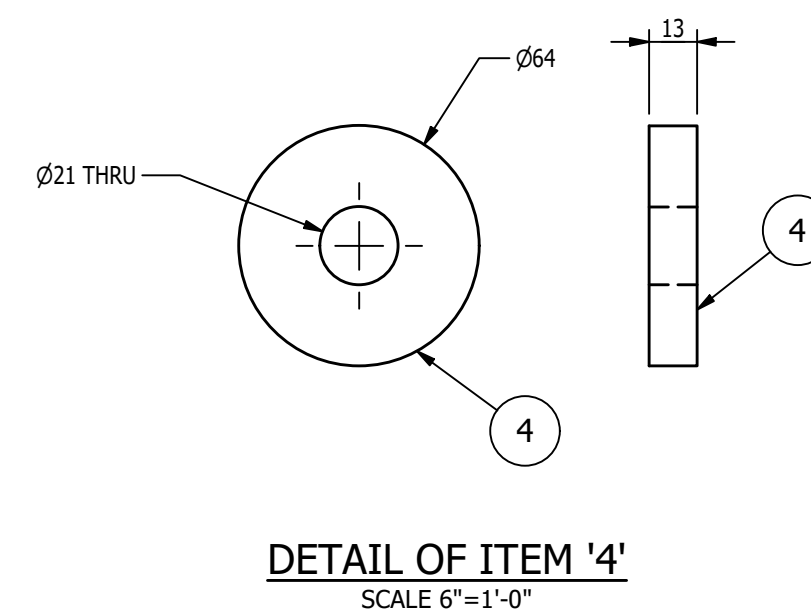
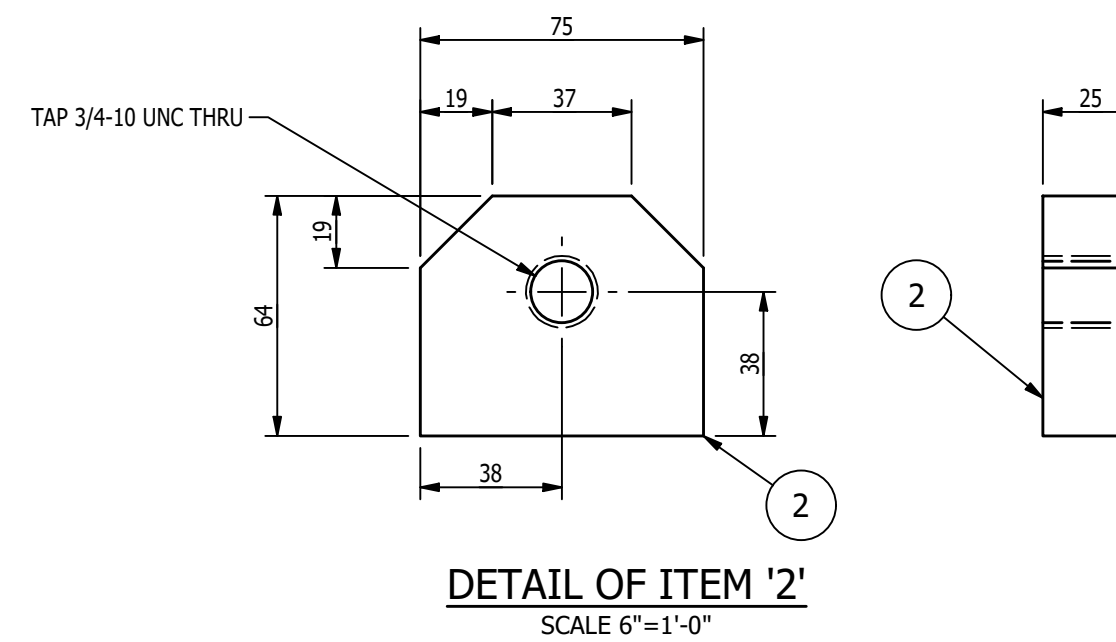
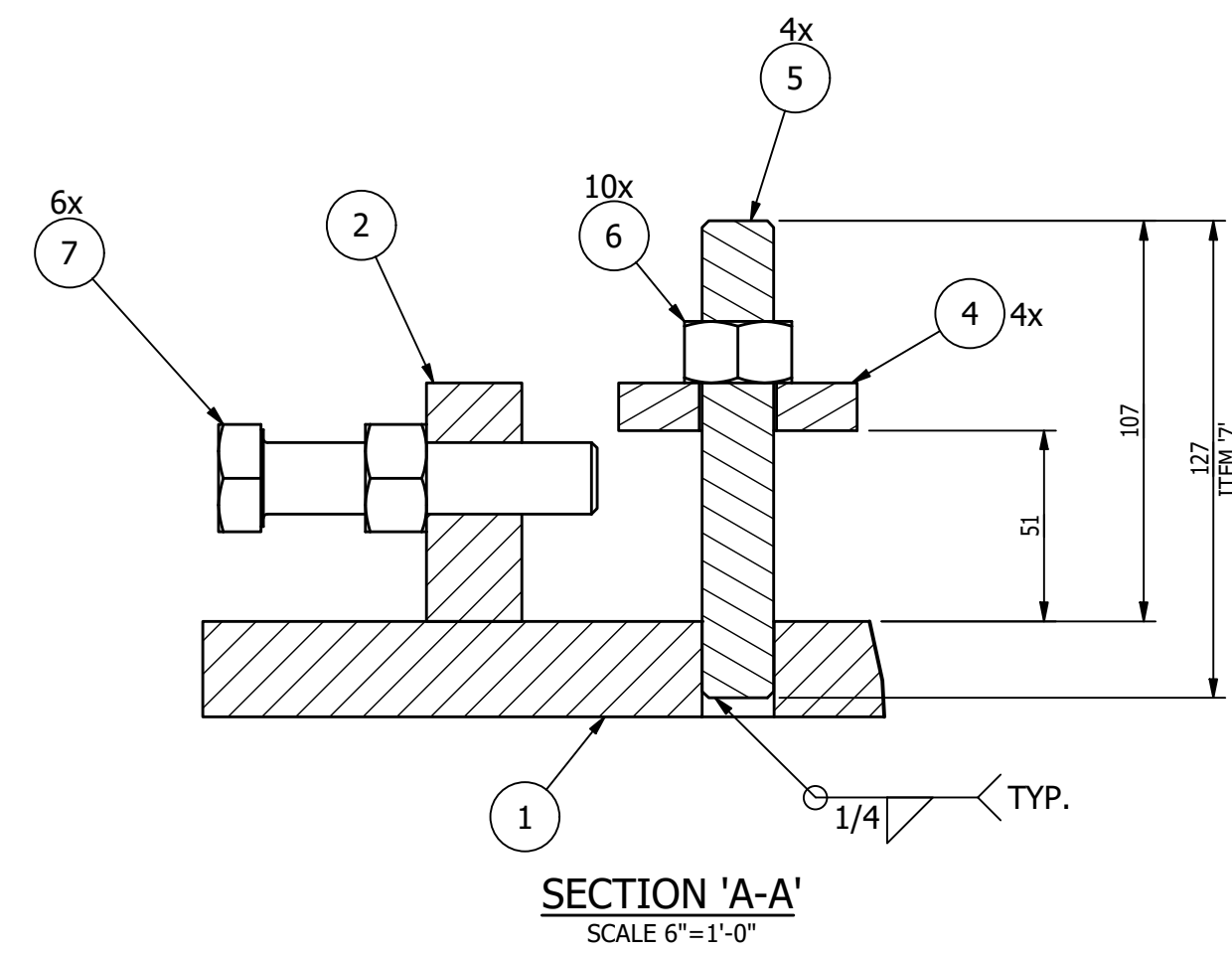
WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

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



MK-D372A ~ STANCHION BASE
SCALE 3"=1'-0"



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D372A			
1	1	PL 1 x 1'-7 1/8"	1'-10 1/16"		
2	6	BAR 1 x 2 1/2	2 15/16"		
3	4	SQ. BAR 1 1/2	5"		
4	4	BAR Ø2 3/4 (1045)	1/2"		
5	4	THD. ROD 3/4-10UNC	5"		
6	10	3/4-10UNC HEX NUT			
7	6	3/4-10UNC x 3 1/2" LG. HEX HEAD CAP SCREW, FULLY THREADED			

SHIP ITEM '3' LOOSE

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

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/26/2022	FOR FABRICATION	

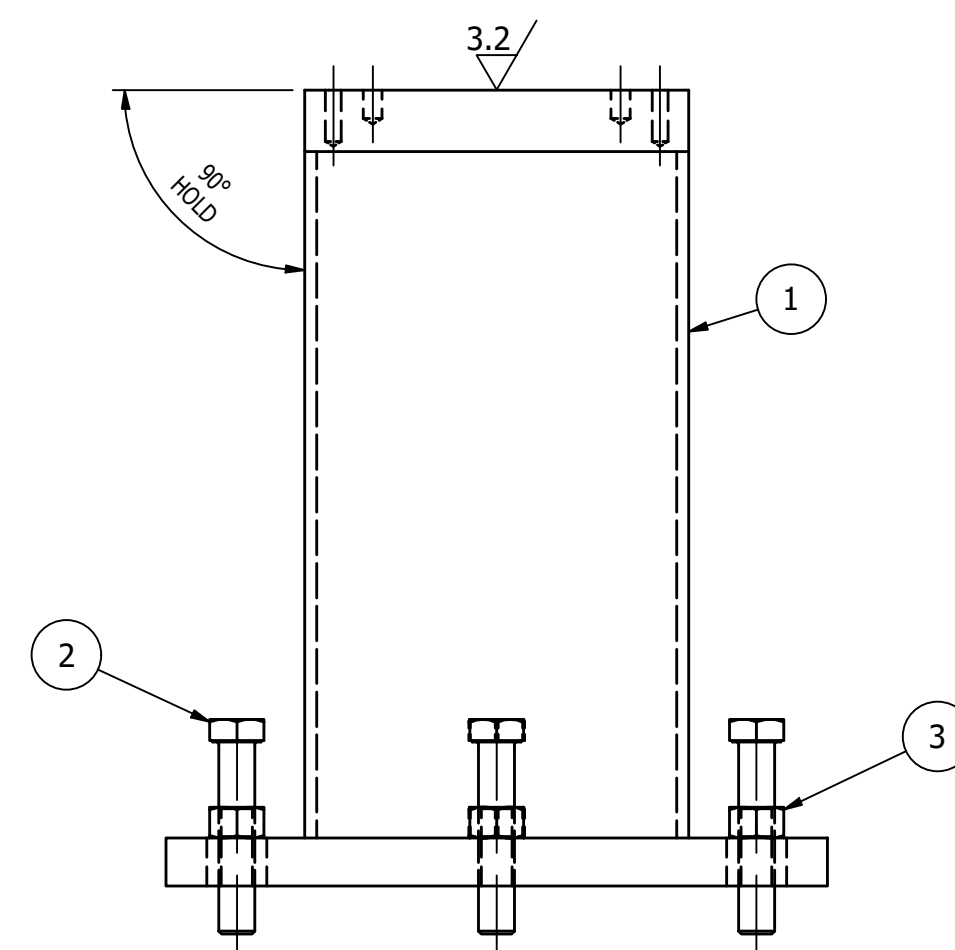
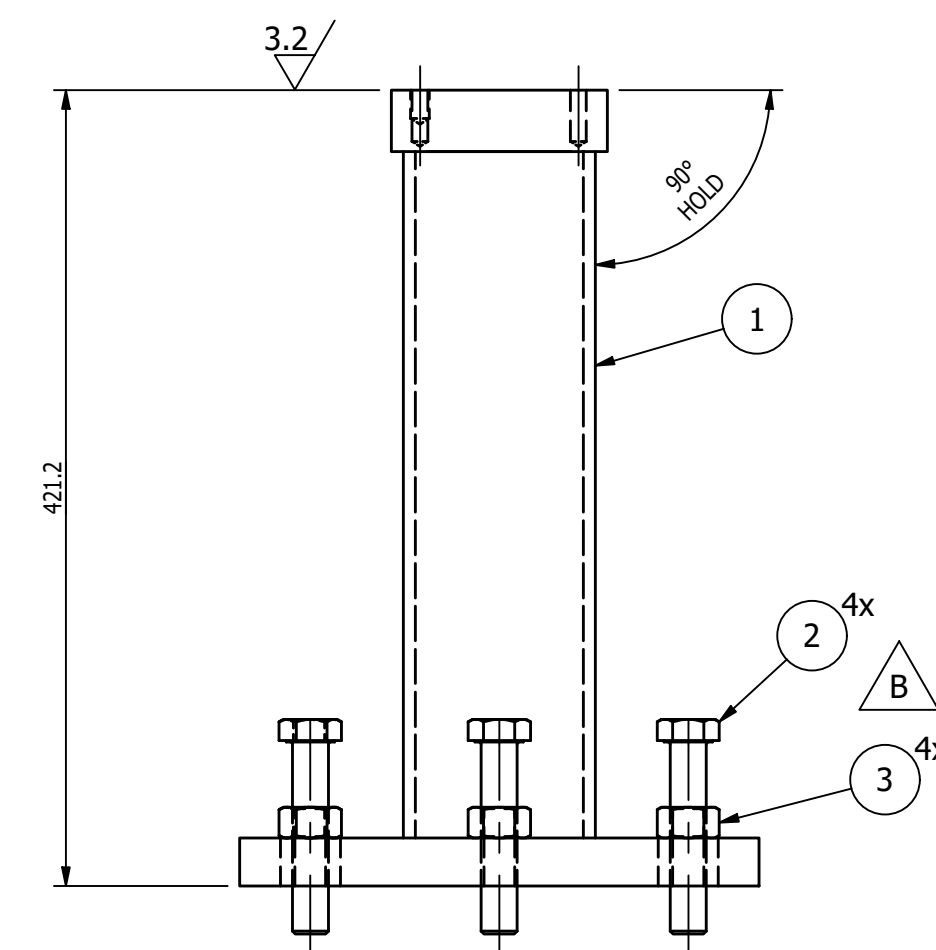
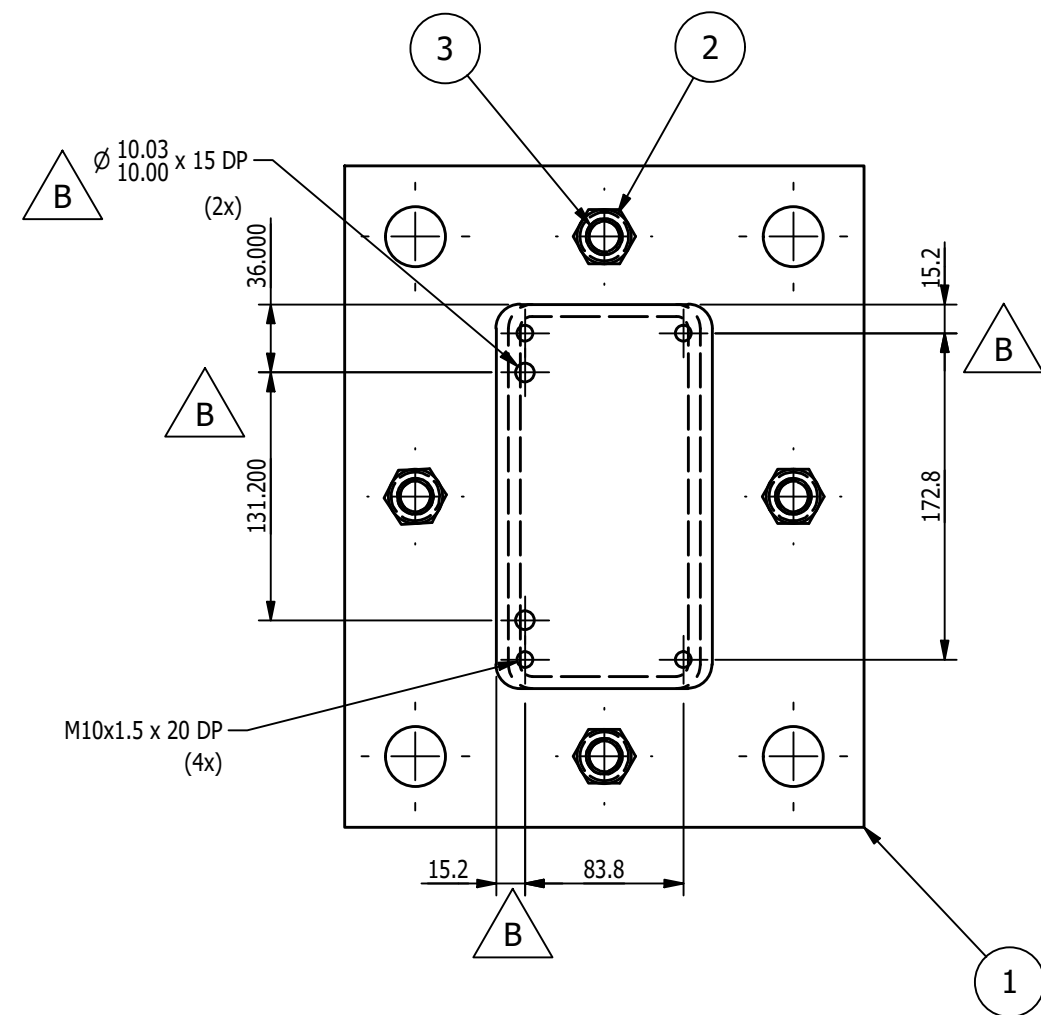
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	TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO	DRAWN BY: AH CHECKED BY: JCK DWG DATE: 8/9/22

DRAWING No. 1875D372	REV: A	JOB No: 22096
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 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-D373A ~ STANCHION MACH (LOCATOR)
SCALE 3"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D373A ~ STANCHION WELDMENT (LOCATOR)			
2	4	3/4-10UNC x 4" LG. HEX HEAD CAP SCREW, FULLY THREADED			
3	4	3/4-10UNC HEX NUT			

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	UPDATED HOLE DIM TOLERANCES	
A	MC	8/26/2022	FOR FABRICATION	

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		www.millc.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: AH		CHECKED BY: JCK	
CLIENT: VOLVO		DWG DATE: 8/15/22		JOB No: 22096	
DRAWING No. 1875D373		REV: B			

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North, MI 48175
Phone: (248) 773-8833
Fax: (248) 773-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D373

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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

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)

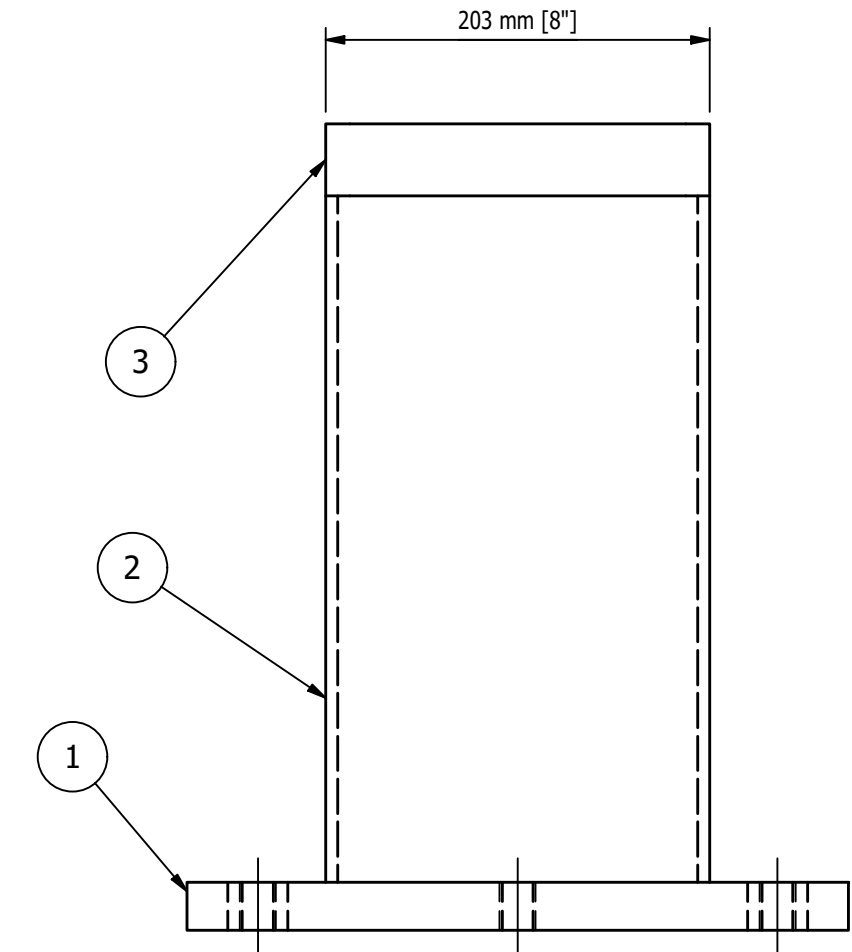
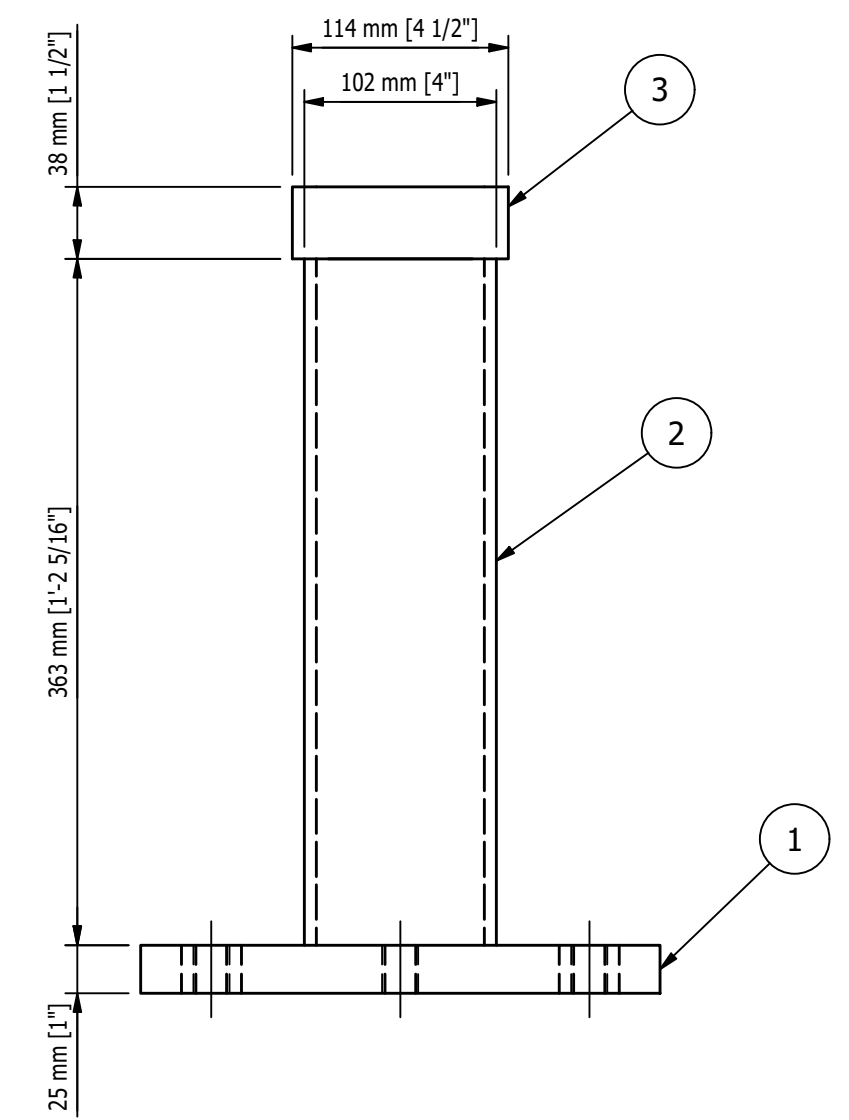
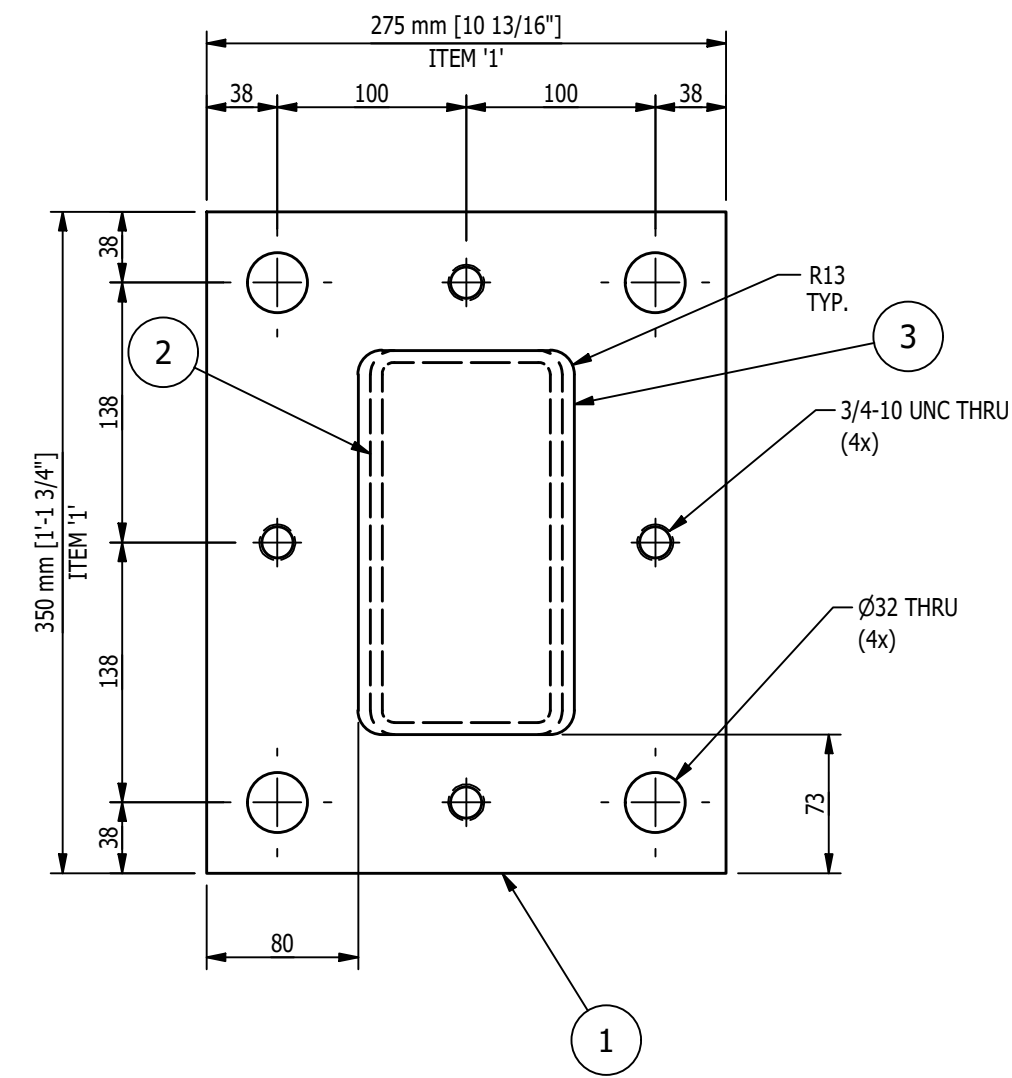
PAINT:

- 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-D374A			
1	1	PL 1 x 1'-1 3/4"	10 13/16"		
2	1	TS 8 x 4 x 1/4	1'-2 5/16"		
3	1	PL 1 1/2" x 4 1/2"	8"		



MK-D374A ~ STANCHION WELDMENT (LOCATOR)
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:**
NO PAINT

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/26/2022	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: JCK
DRAWING No. 1875D374	DWG DATE: 8/15/22
REV: A	JOB No: 22096

MAGNUM Consulting
41100 QuakerRoad Rd.
Suite 125
North, MI 48315
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D374

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)

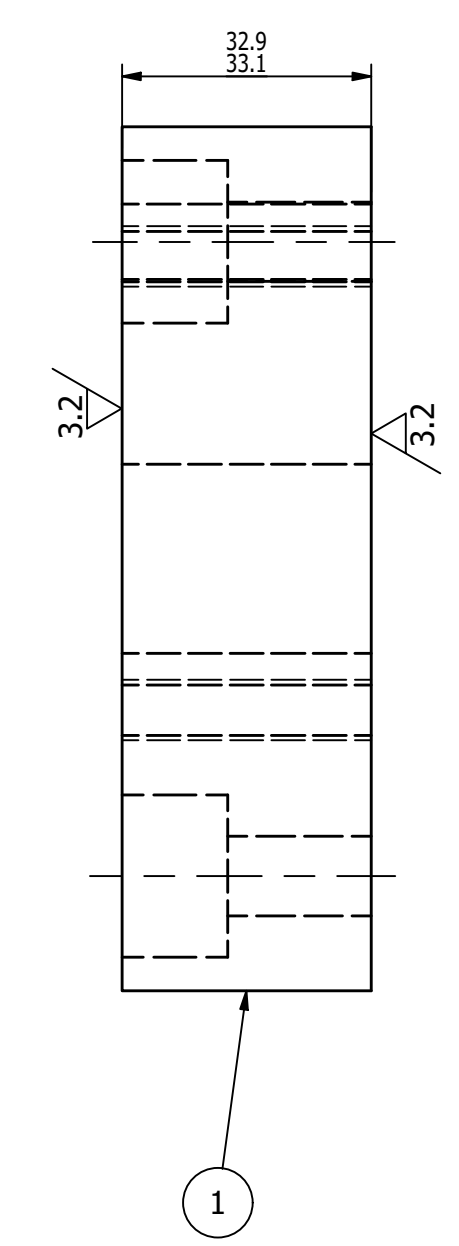
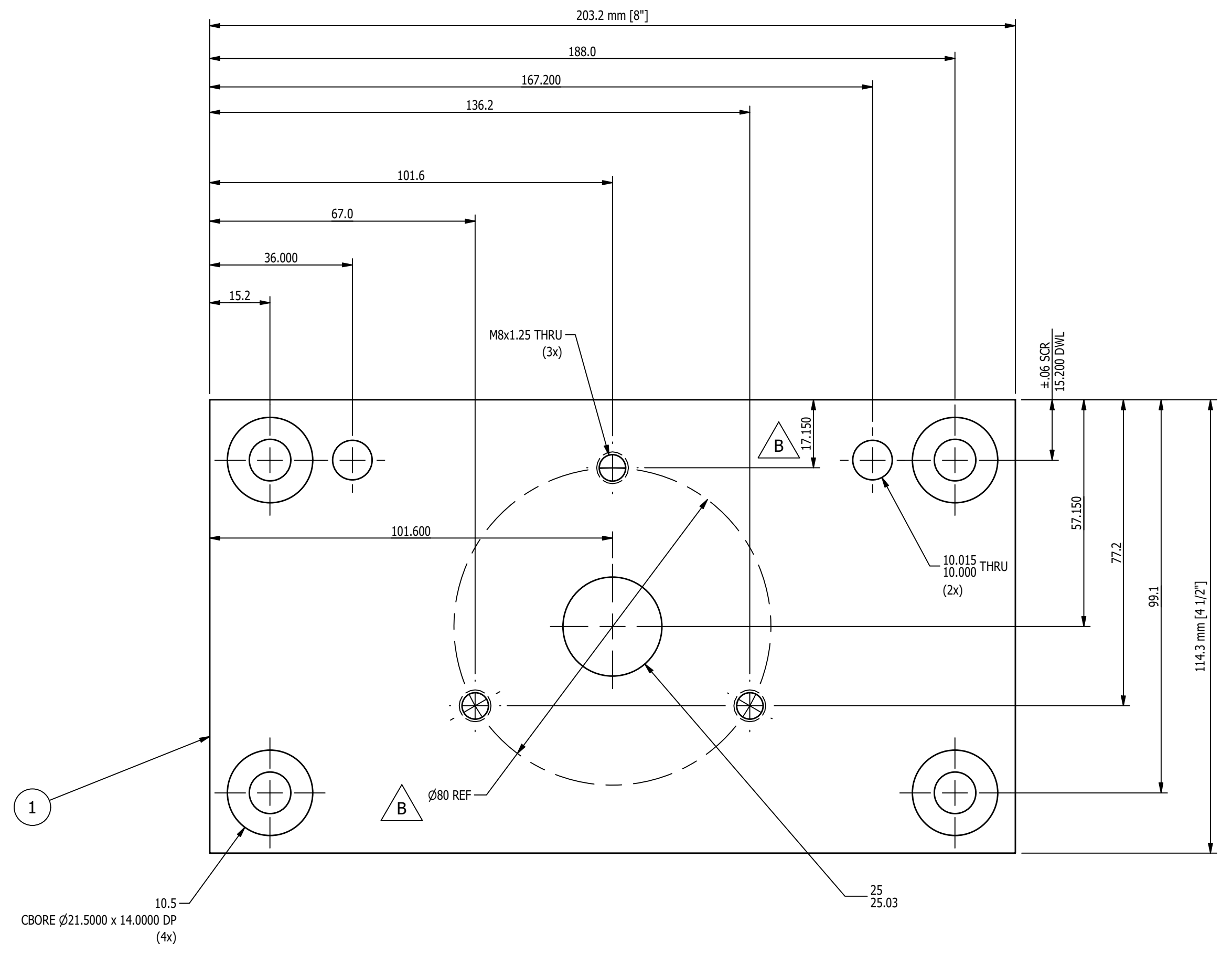
PAINT:

- 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-D375A			
1	1	BAR 1 1/2 x 4 1/2	8"		



MK-D375A ~ 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
B	MC	9/7/2022	ADDED DIMS	
A	MC	8/26/2022	FOR FABRICATION	

REVISION HISTORY

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--	---	---

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: AH
CLIENT: VOLVO	CHECKED BY: JCK
DRAWING No. 1875D375	DWG DATE: 8/9/22
REV: B	JOB No: 22096

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

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

GENERAL NOTES:

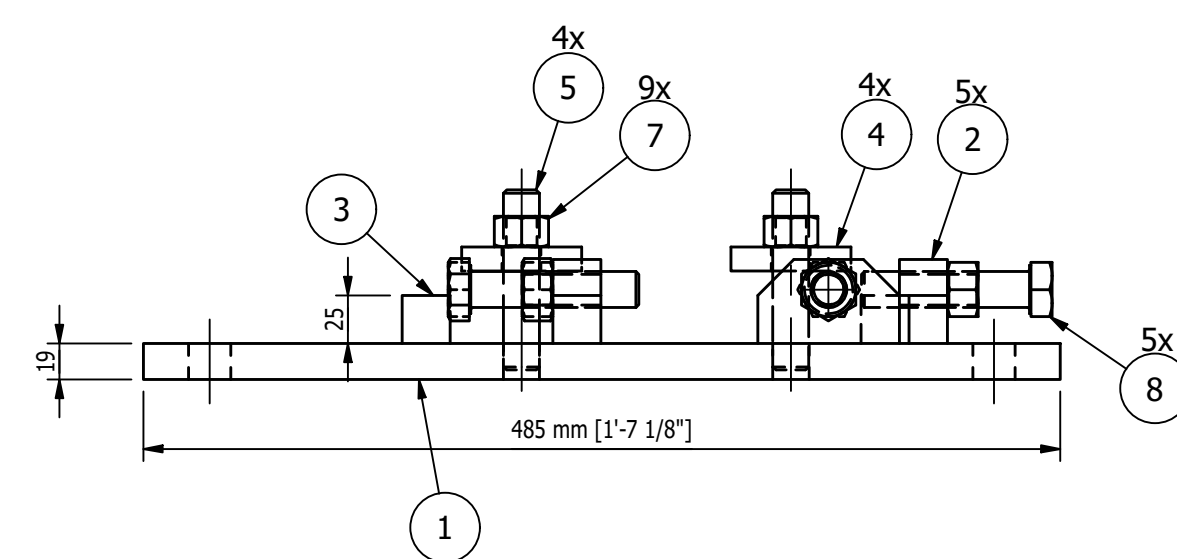
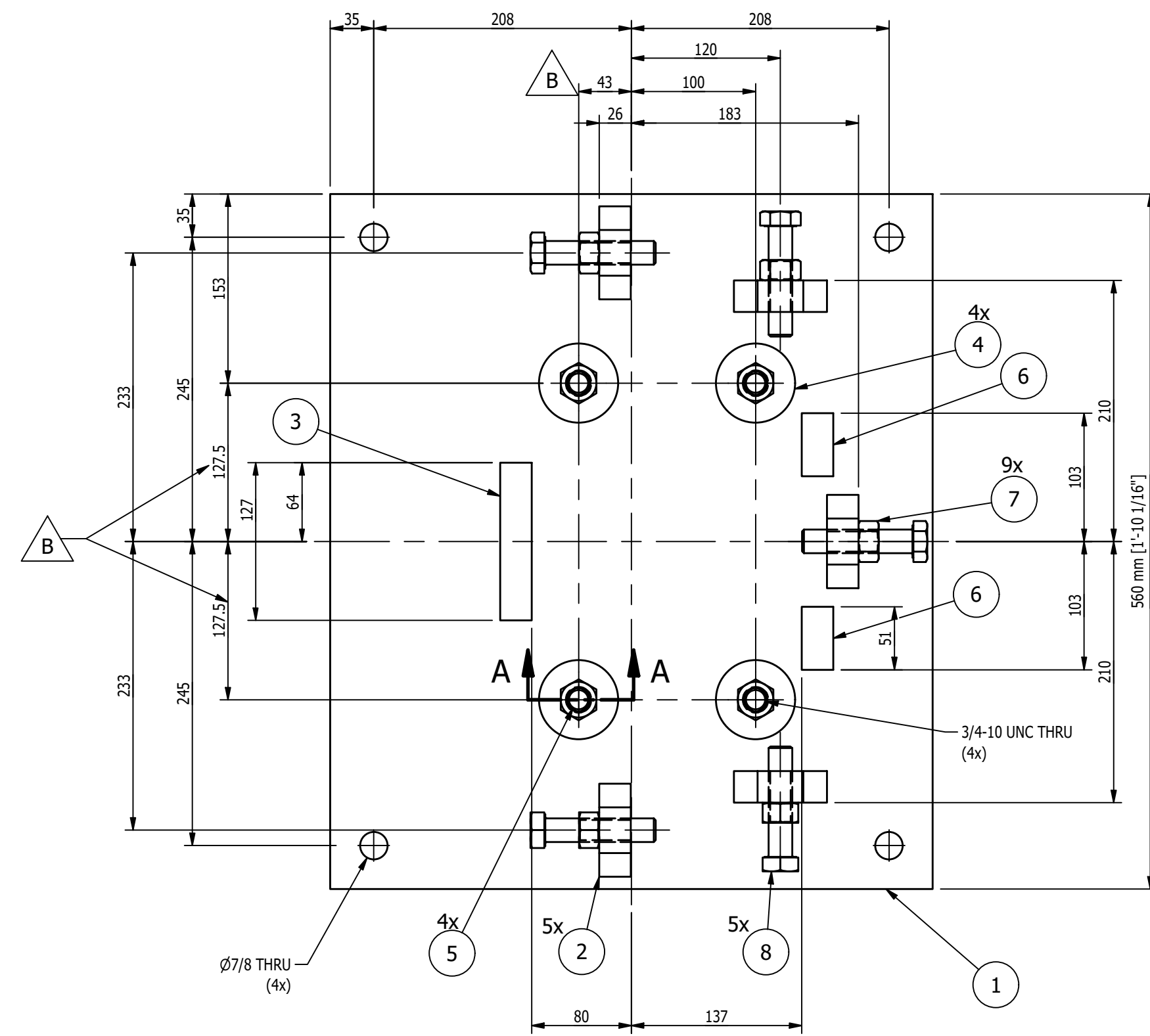
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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

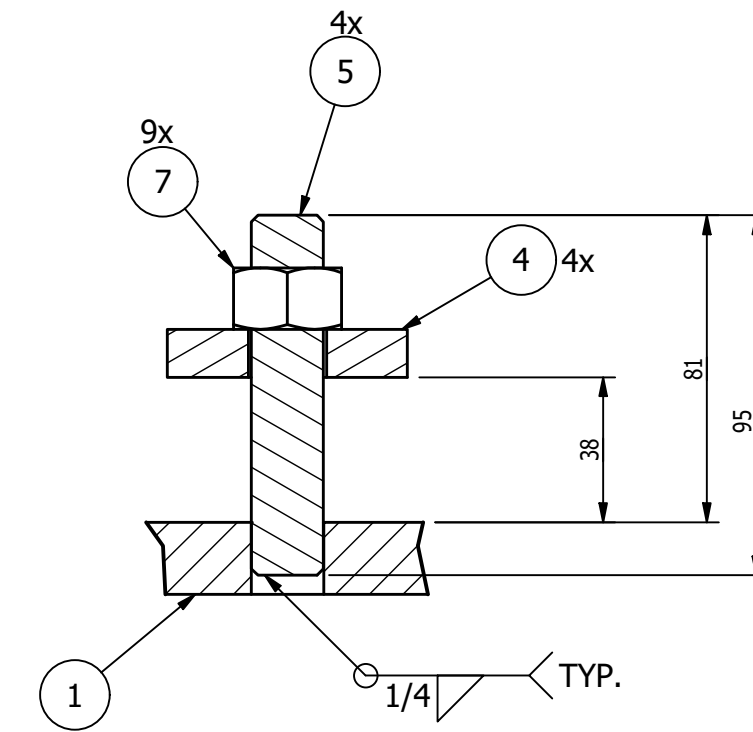
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

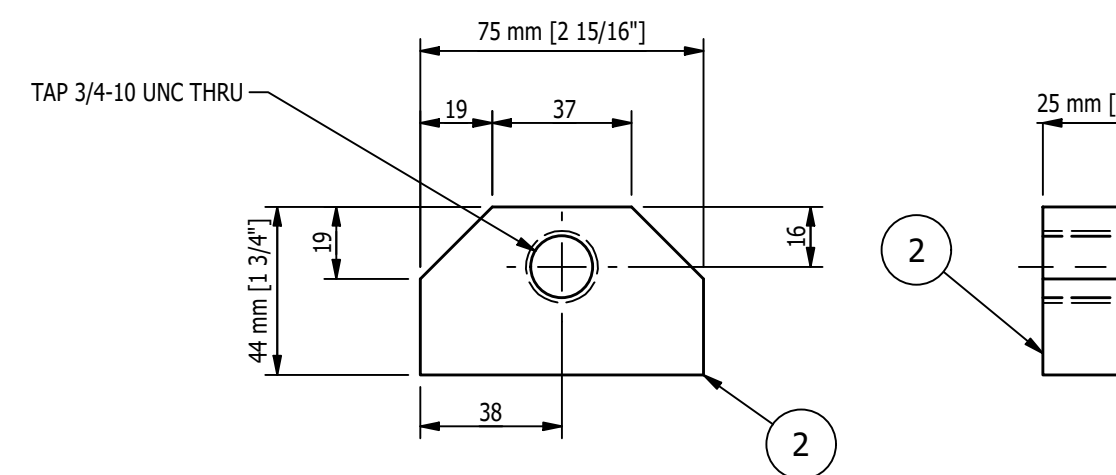
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



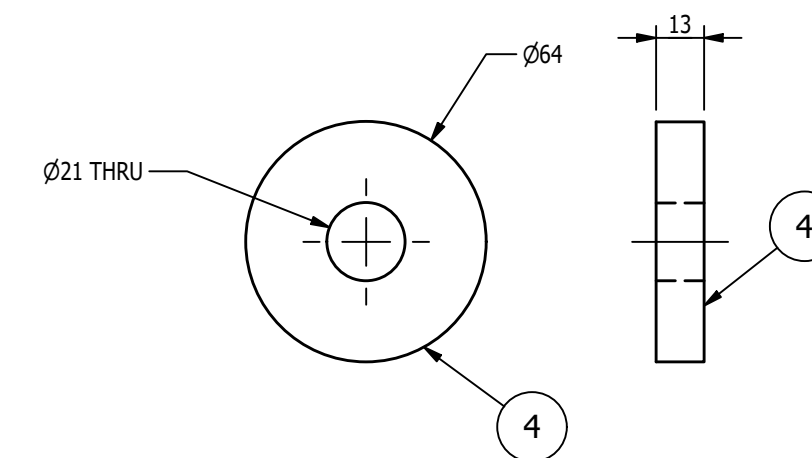
MK-D376A ~ STANCHION BASE
SCALE 3"=1'-0"



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



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



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D376A			
1	1	PL 1 x 1'-7 1/8"	1'-10 1/16"		
2	5	BAR 1 x 1 3/4	2 15/16"		
3	1	SQ. BAR 1 1/2	5"		
4	4	BAR Ø2 1/2 (1045)	1/2"		
5	4	THD. ROD 3/4-10UNC	3 3/4"		
6	2	SQ. BAR 1 1/2	2"		
7	9	3/4-10UNC HEX NUT			
8	5	3/4-10UNC x 3 1/2" LG. HEX HEAD CAP SCREW, FULLY THREADED			

SHIP ITEM '3' & '6' LOOSE

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	UPDATED DIMS, CORRECTED ITEM '4' DIA.	
A	MC	8/26/2022	FOR FABRICATION	

REVISION HISTORY

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

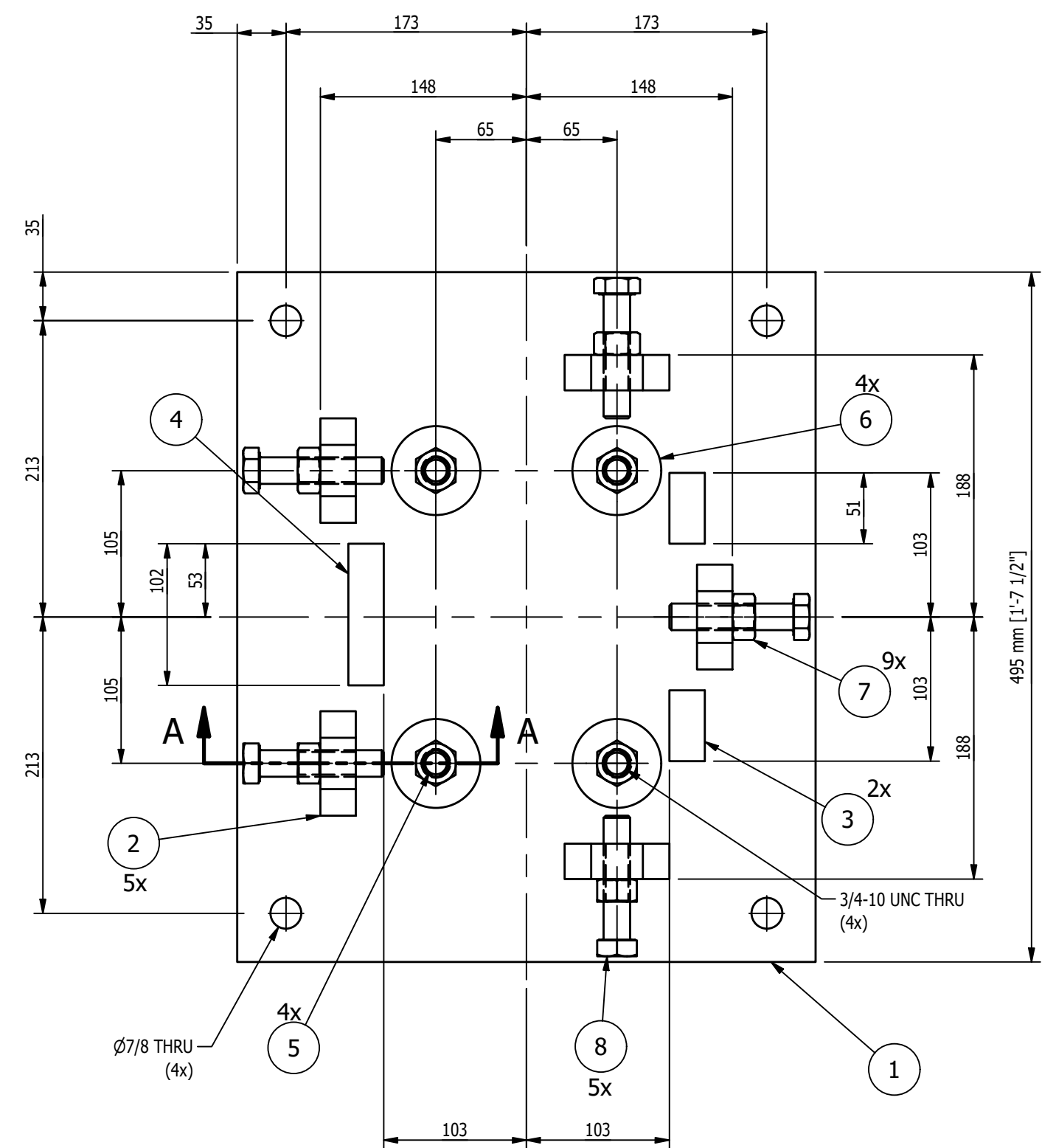
MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

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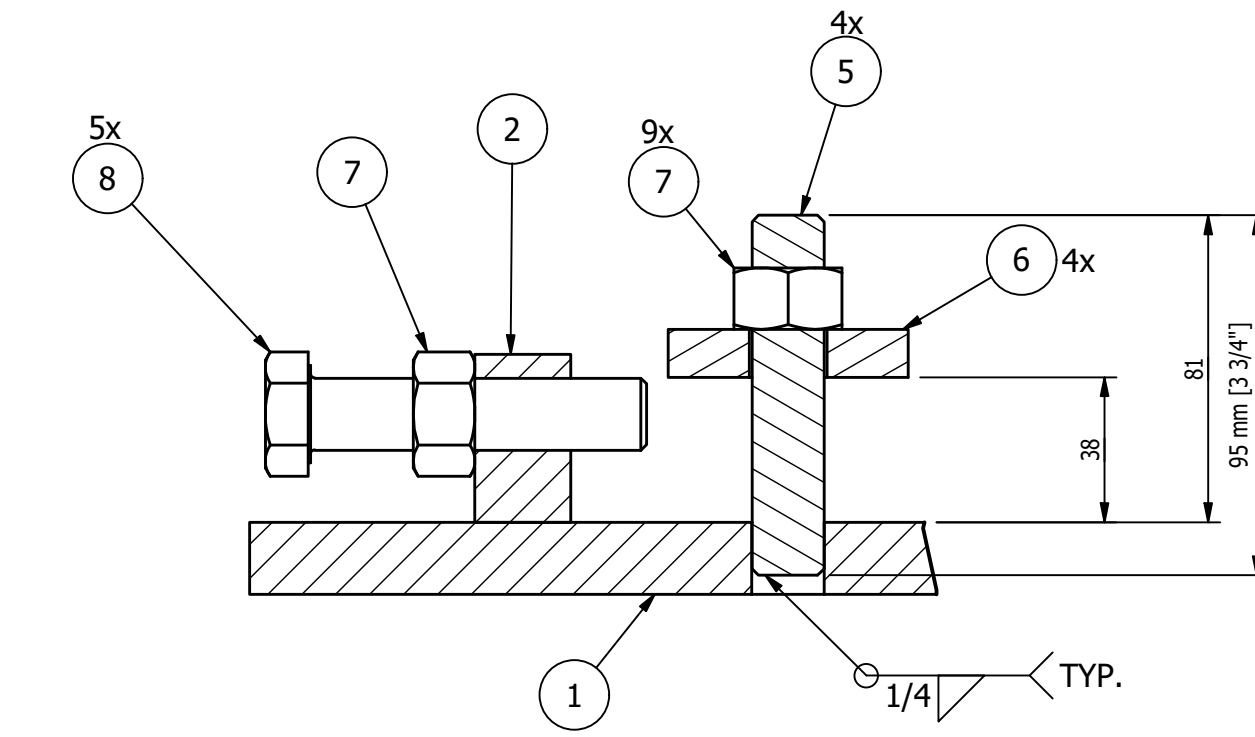
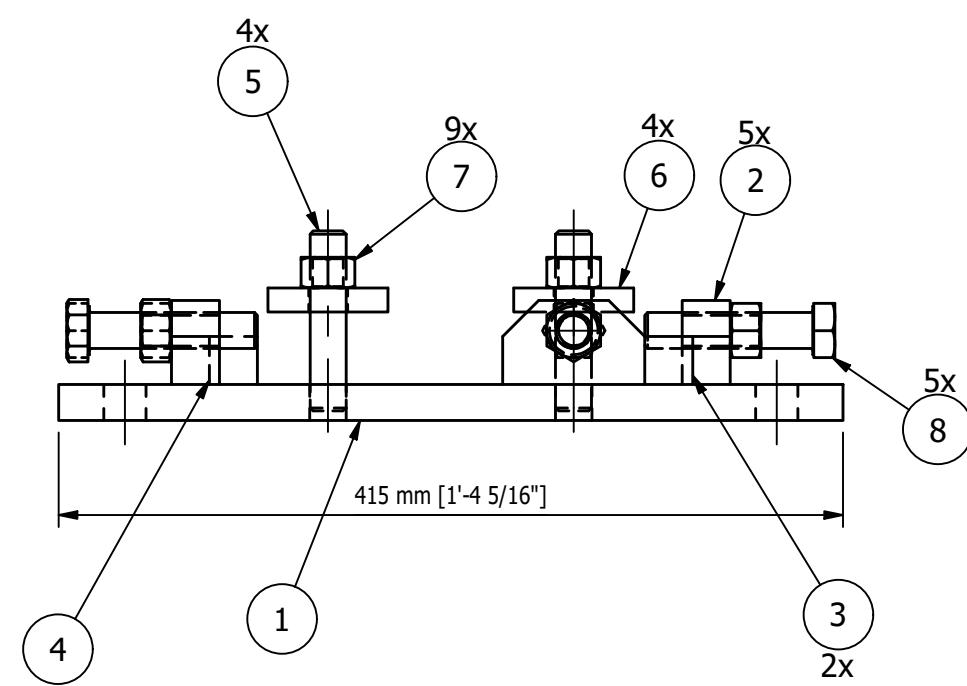
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	JCK
DRAWING No.	1875D376	DWG DATE:	8/9/22
REV:	B	JOB No:	22096

MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
Novi, MI 48165
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D376

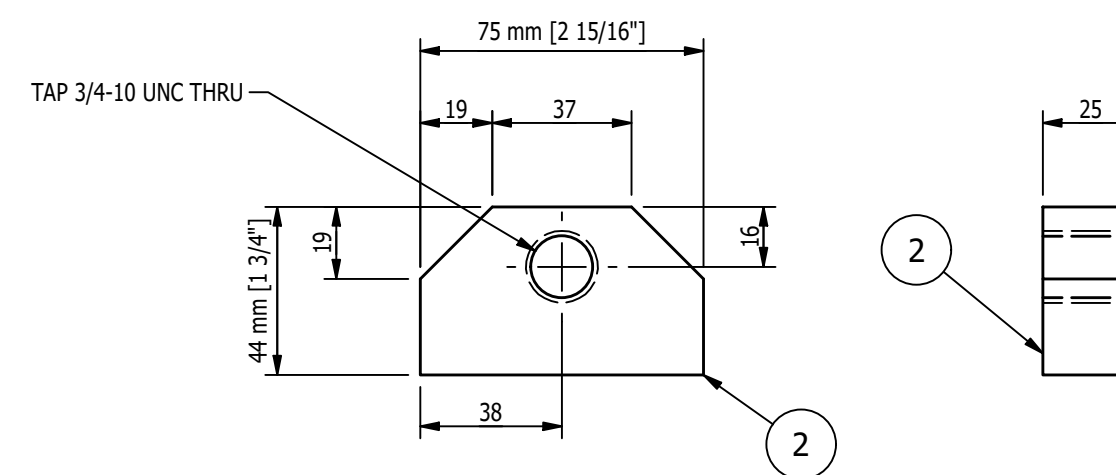
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



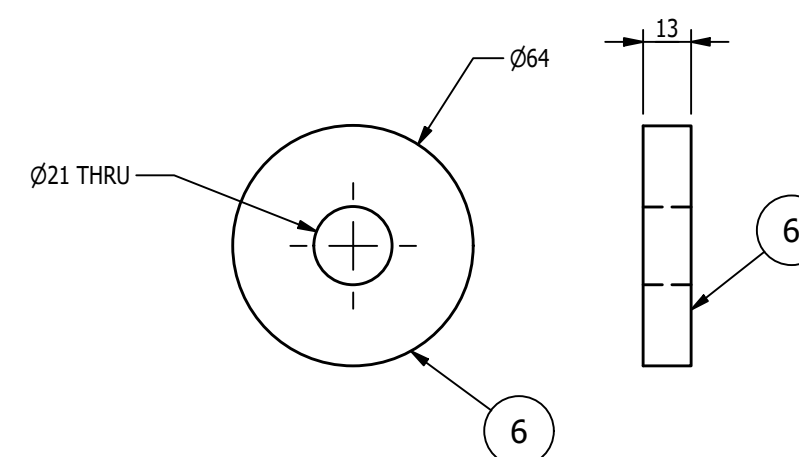
MK-D377A ~ STANCHION BASE
SCALE 3"=1'-0"



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



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



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D377A			
1	1	PL 1 x 1'-4 5/16"	1'-7 1/2"		
2	5	BAR 1 x 1 3/4	2 15/16"		
3	2	SQ. BAR 1 1/2	2"		
4	1	SQ. BAR 1 1/2	4"		
5	4	THD. ROD 3/4-10UNC	3 3/4"		
6	4	BAR Ø2 1/2 (1045)	1/2"		
7	9	3/4-10UNC HEX NUT			
8	5	3/4-10UNC x 3 1/2" LG. HEX HEAD CAP SCREW, FULLY THREADED			

SHIP ITEM '3' LOOSE

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	CORRECTED ITEM '6' DIAMETER	
A	MC	8/26/2022	FOR FABRICATION	

REVISION HISTORY

<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.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>

GENERAL NOTES:

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

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

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

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

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

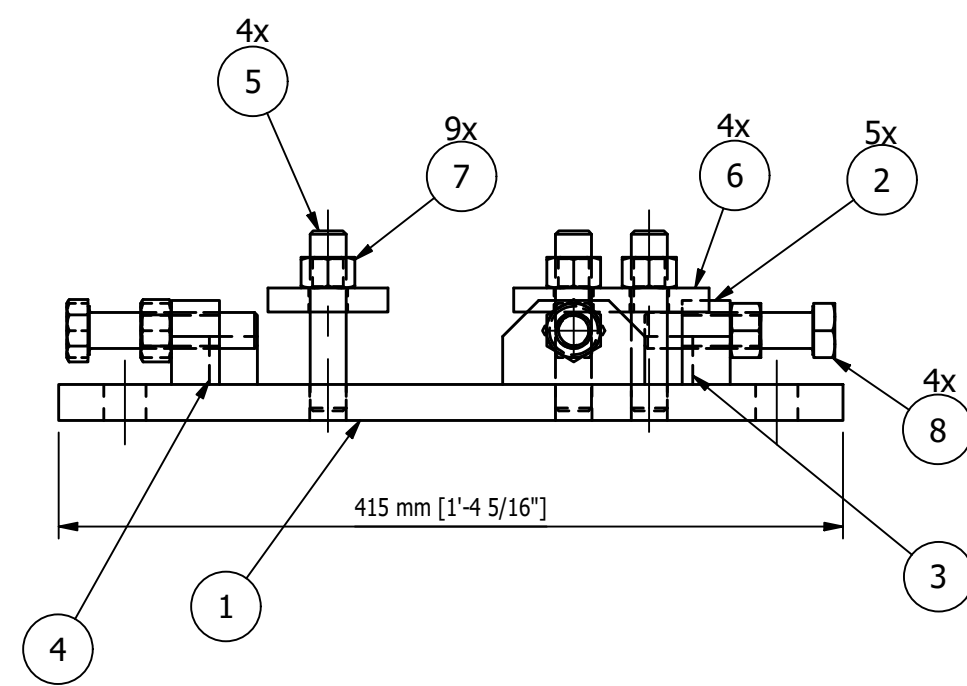
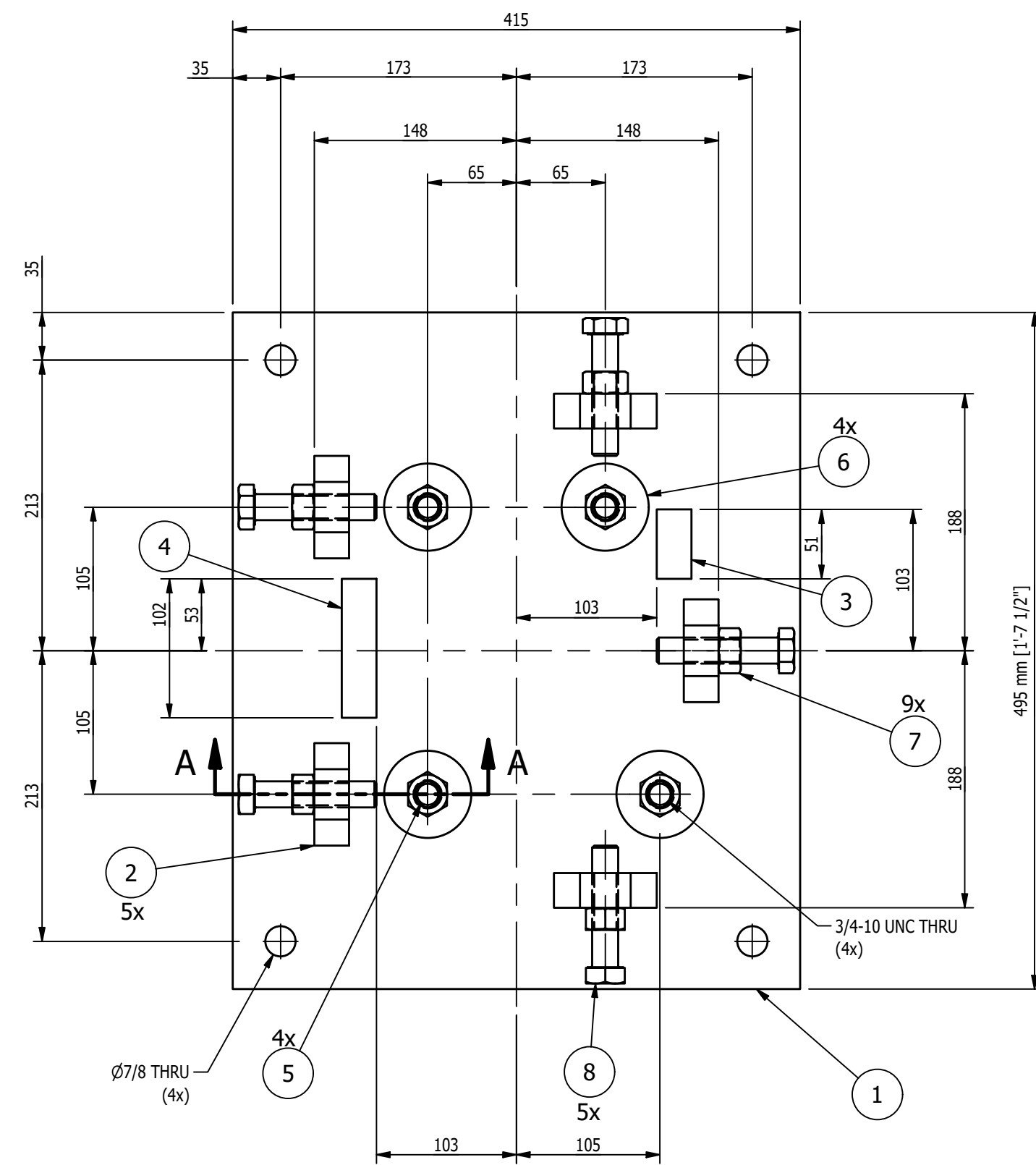
MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
North, MI 48075

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

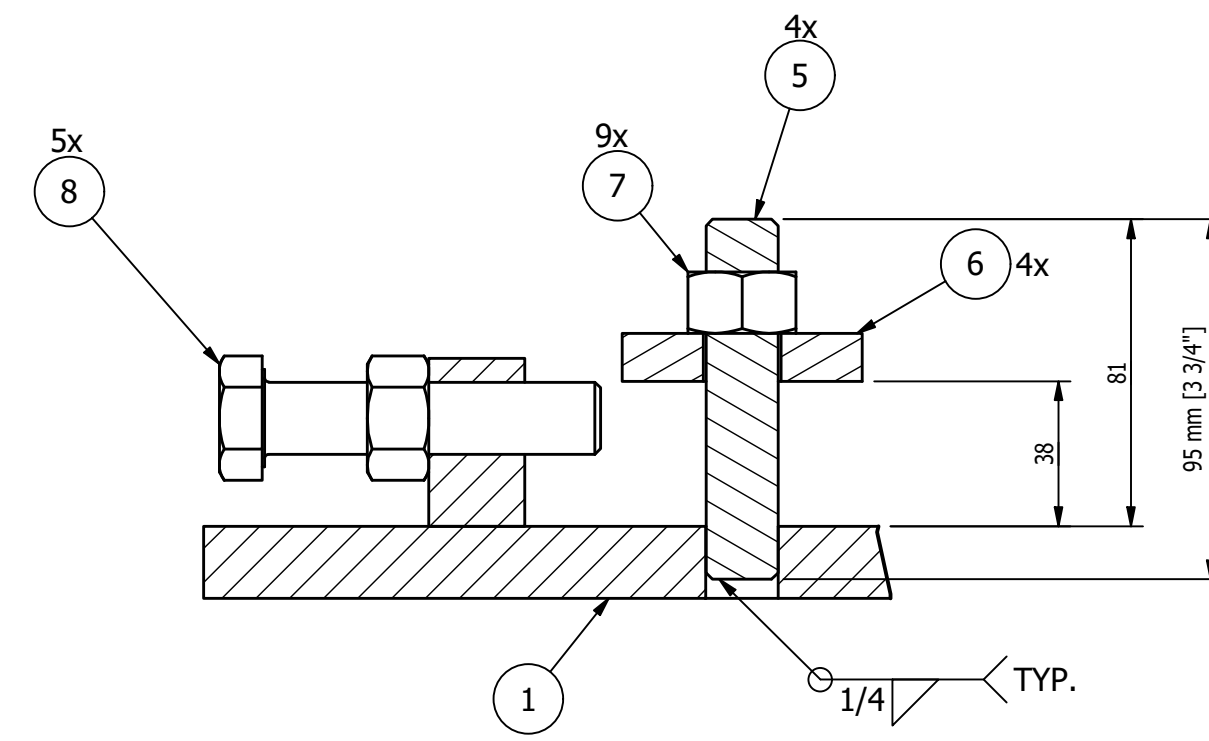
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D377

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

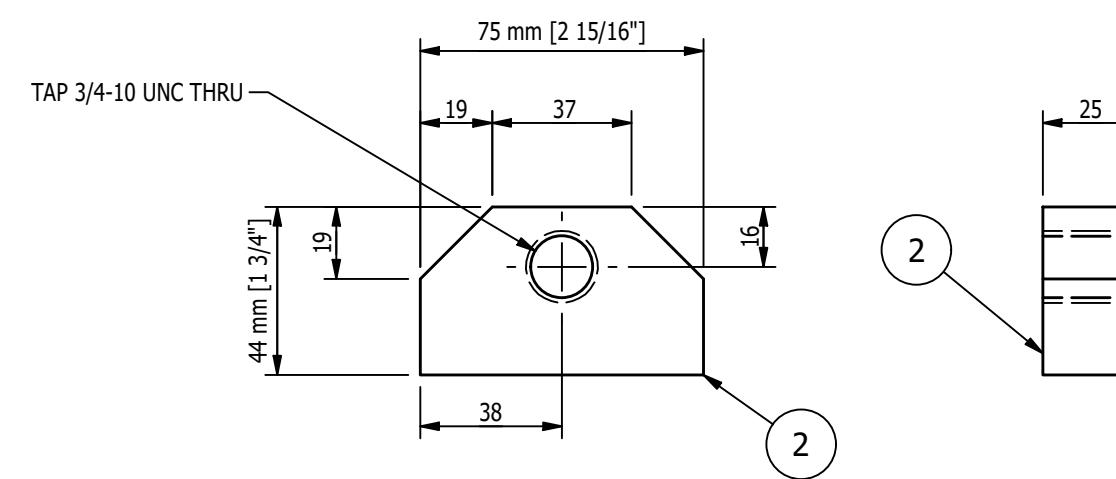
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



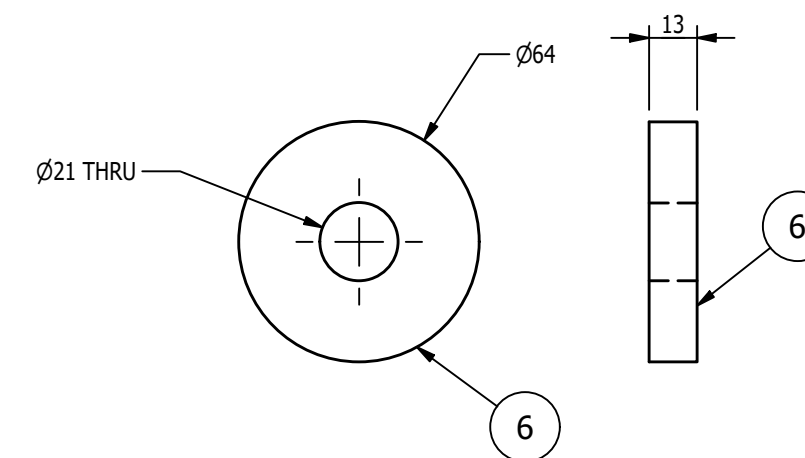
MK-D378A ~ STANCHION BASE
SCALE 3"=1'-0"



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



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



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D378A			
1	1	PL 1 x 1'-4 5/16"	1'-7 1/2"		
2	5	BAR 1 x 1 3/4	2 15/16"		
3	1	SQ. BAR 1 1/2	2"		
4	1	SQ. BAR 1 1/2	4"		
5	4	THD. ROD 3/4-10UNC	3 3/4"		
6	4	BAR Ø2 1/2 (1045)	1/2"		
7	9	3/4-10UNC HEX NUT			
8	5	3/4-10UNC x 3 1/2" LG. HEX HEAD CAP SCREW, FULLY THREADED			

SHIP ITEM '3' LOOSE

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	UPDATED ITEM '6' DIAMETER	
A	MC	8/26/2022	FOR FABRICATION	

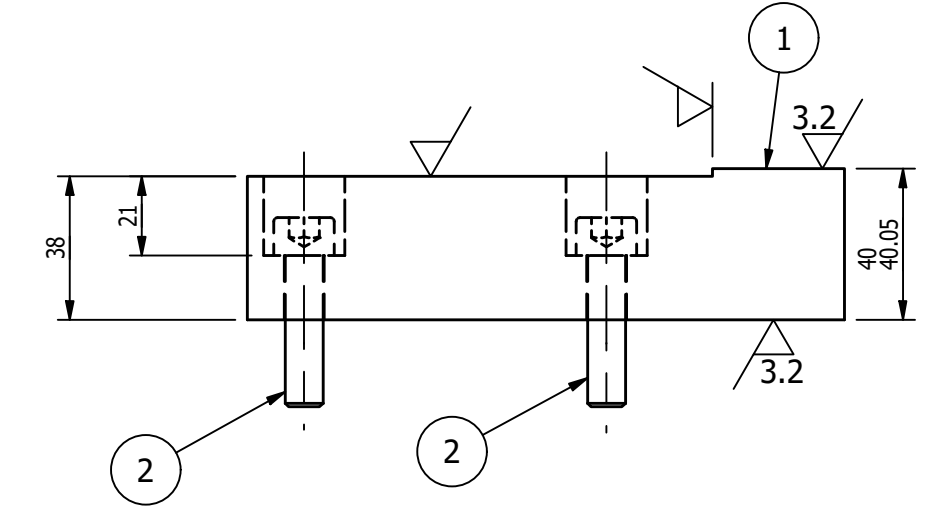
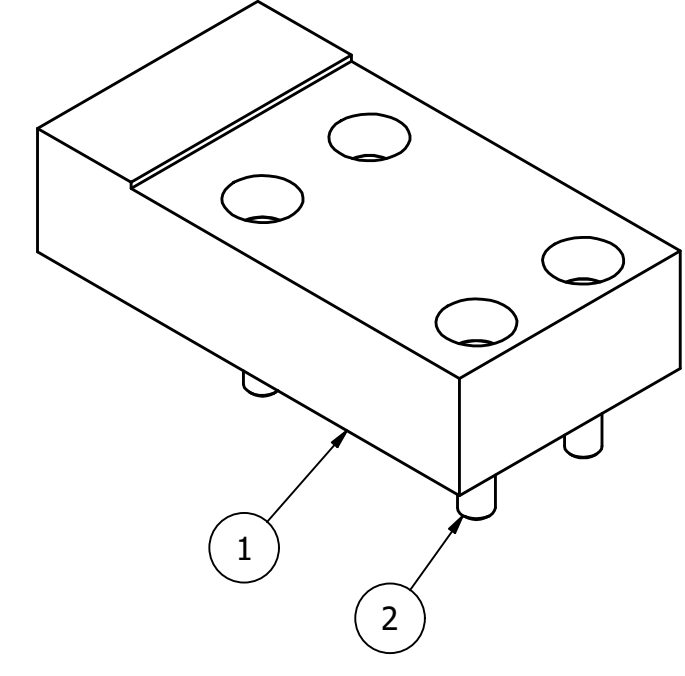
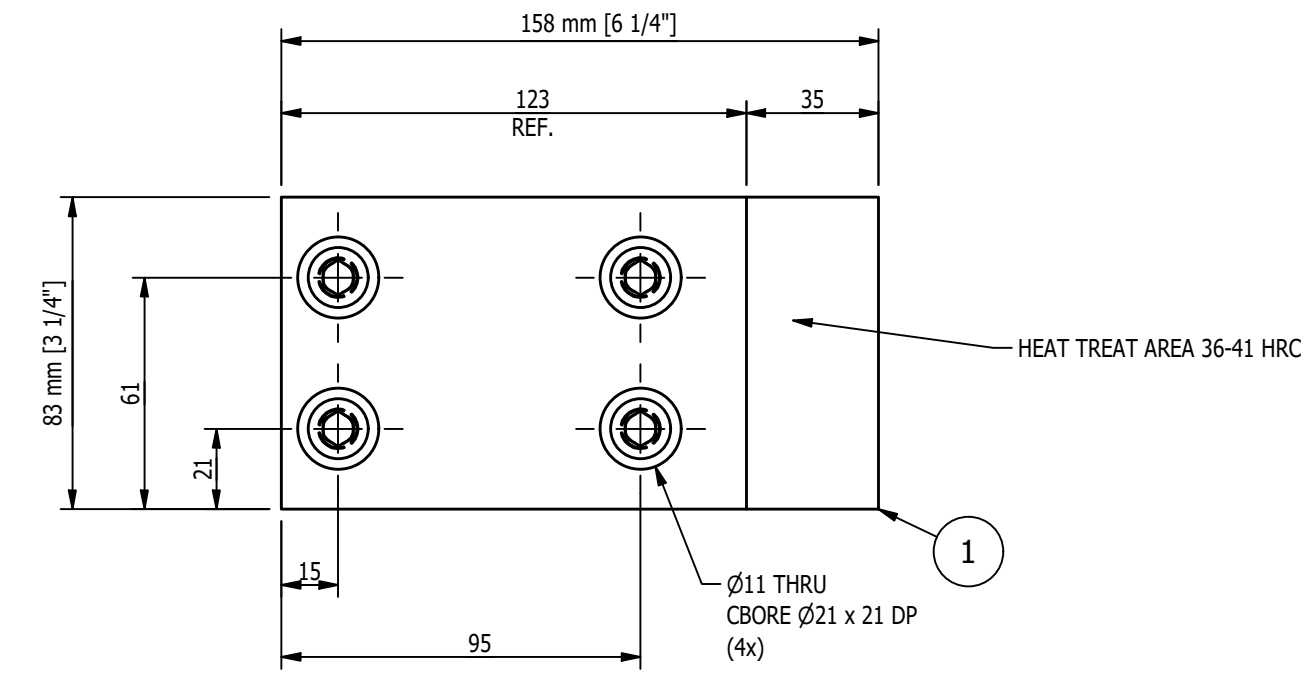
REVISION HISTORY

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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	JCK
DRAWING No.	1875D378	DWG DATE:	8/9/22
REV:	B	JOB No.:	22096

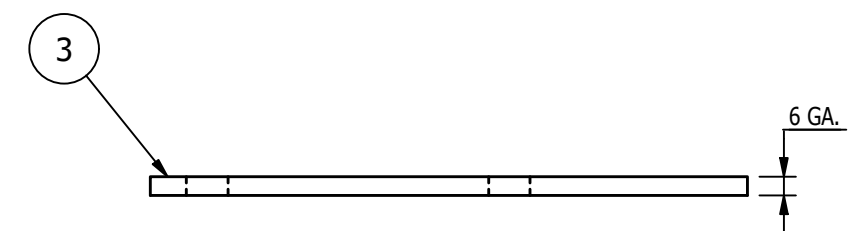
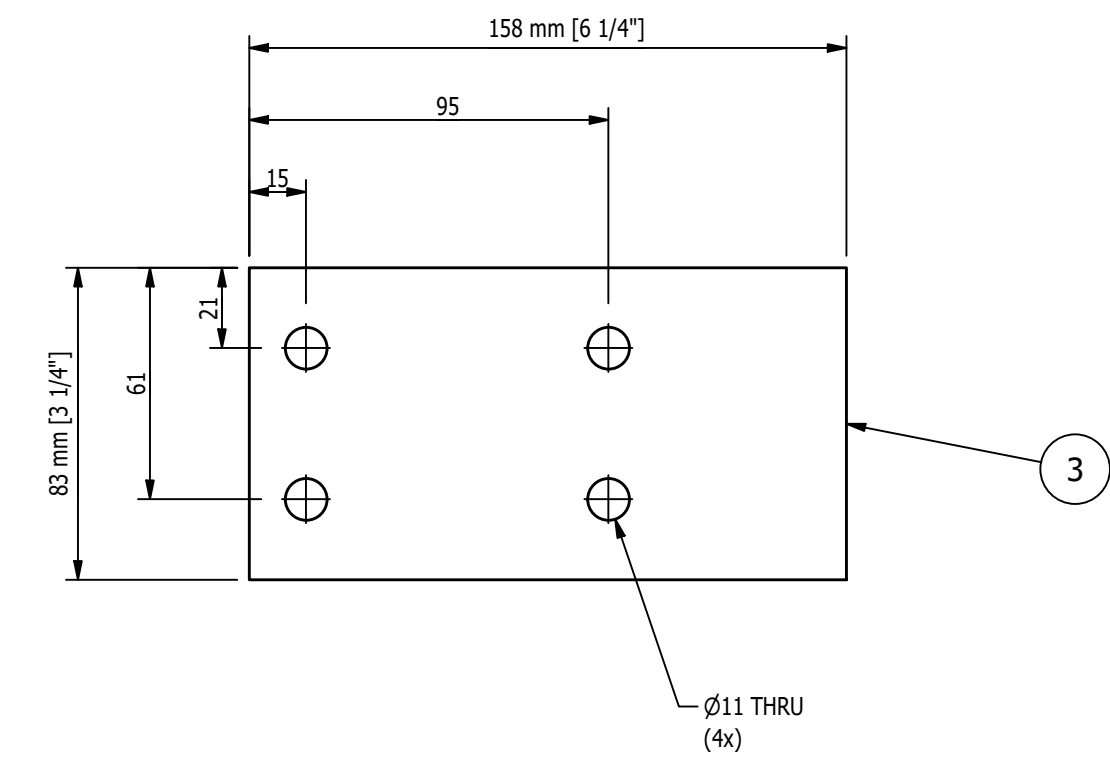
MAGNUM CONSULTING
 4110 QuakerRoad Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

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



MK-D379A ~ Z REST PAD
SCALE 6"=1'-0"



MK-D379B ~ Z REST PAD SHIM
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D379A			
1	1	PL 2 x 3 1/4" (4140)	6 1/4"		
2	4	M10x1.5 x 40mm LG. HEX SOCKET HEAD CAP SCREW			
		MK-D379B			
3	1	SHT 6 GA x 3 1/4	6 1/4"		

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

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/26/2022	FOR FABRICATION	

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

CLIENT: VOLVO	CHECKED BY: JCK
DRAWING No. 1875D379	DWG DATE: 8/8/22
REV: A	JOB No: 22096

41100 QuakerRoad Rd
 Suite 125
 Novi, MI 48275

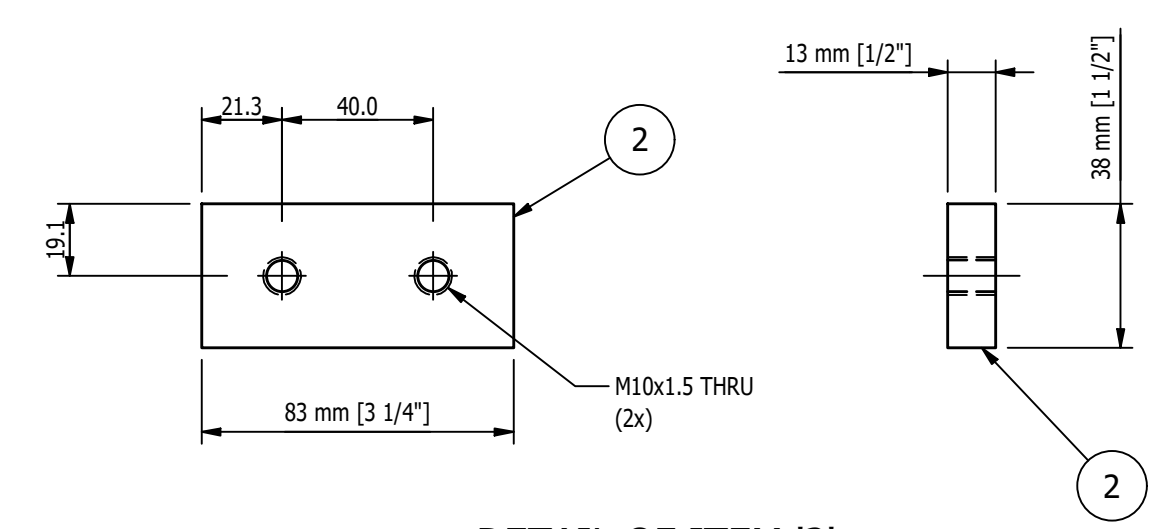
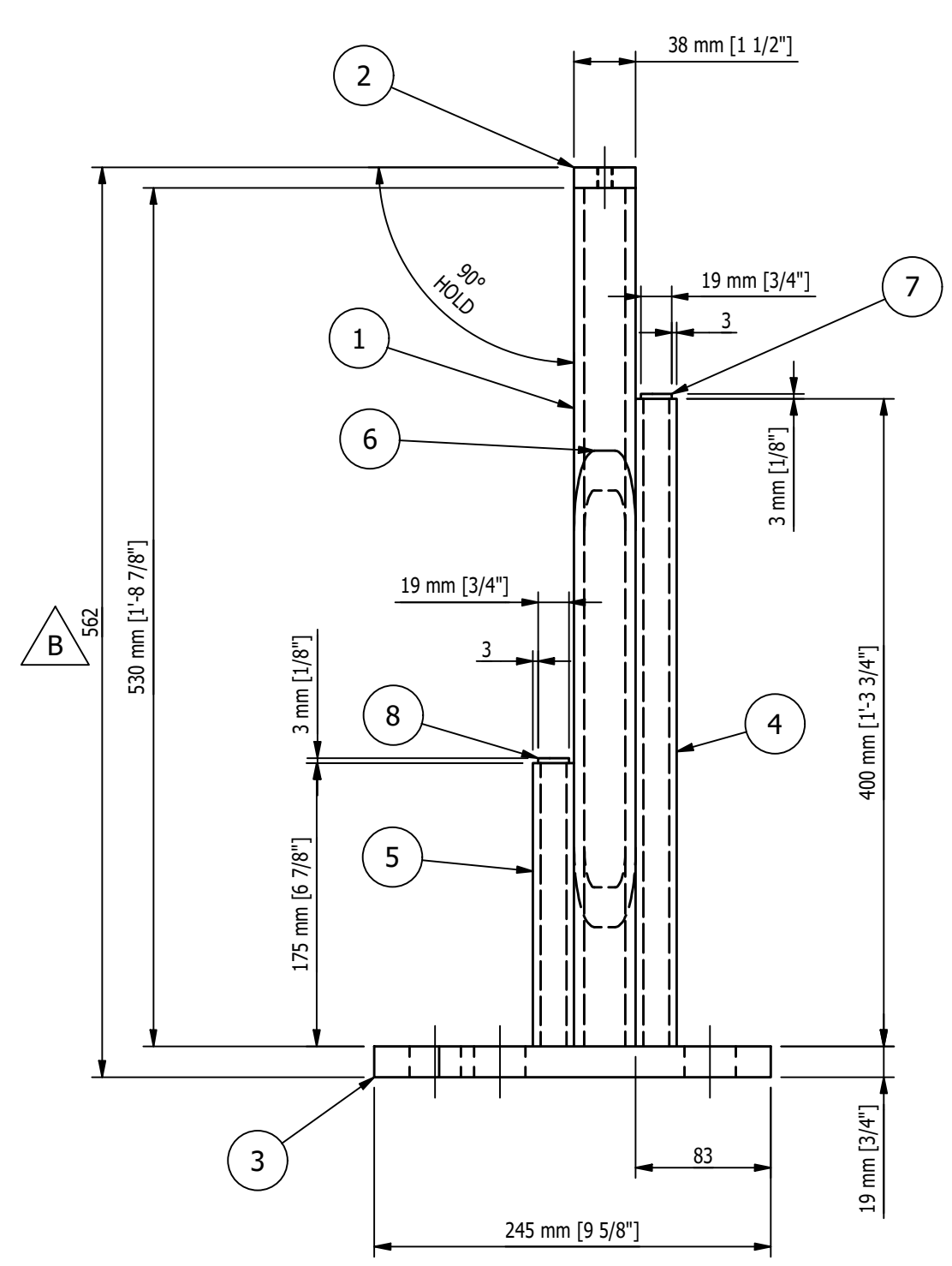
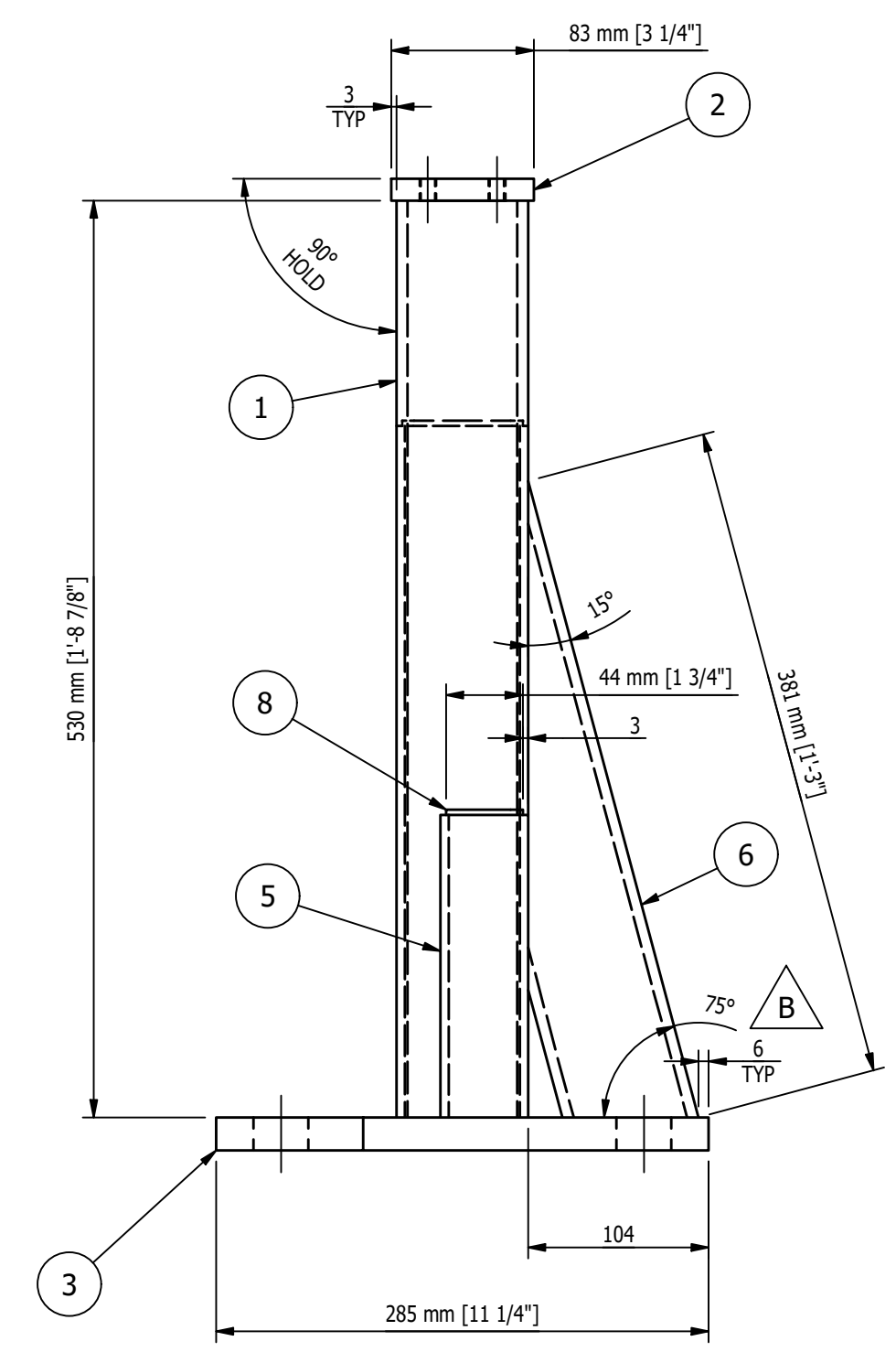
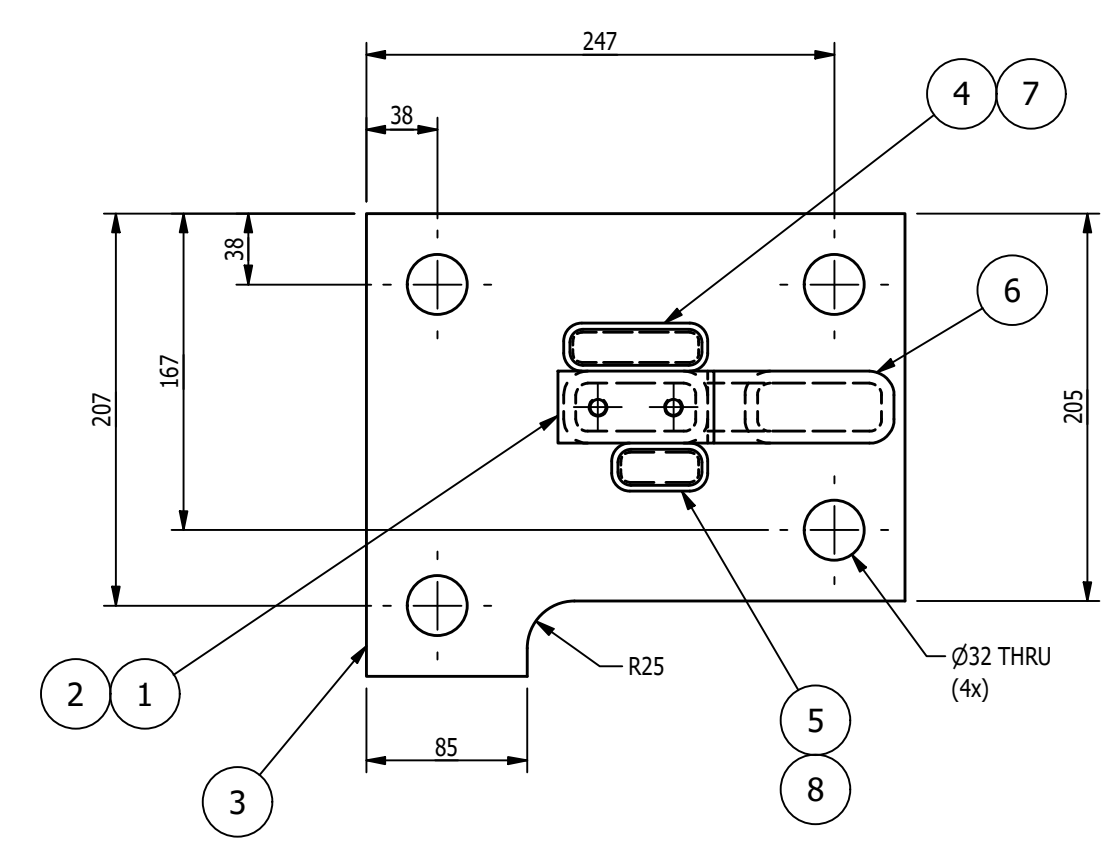
Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D379

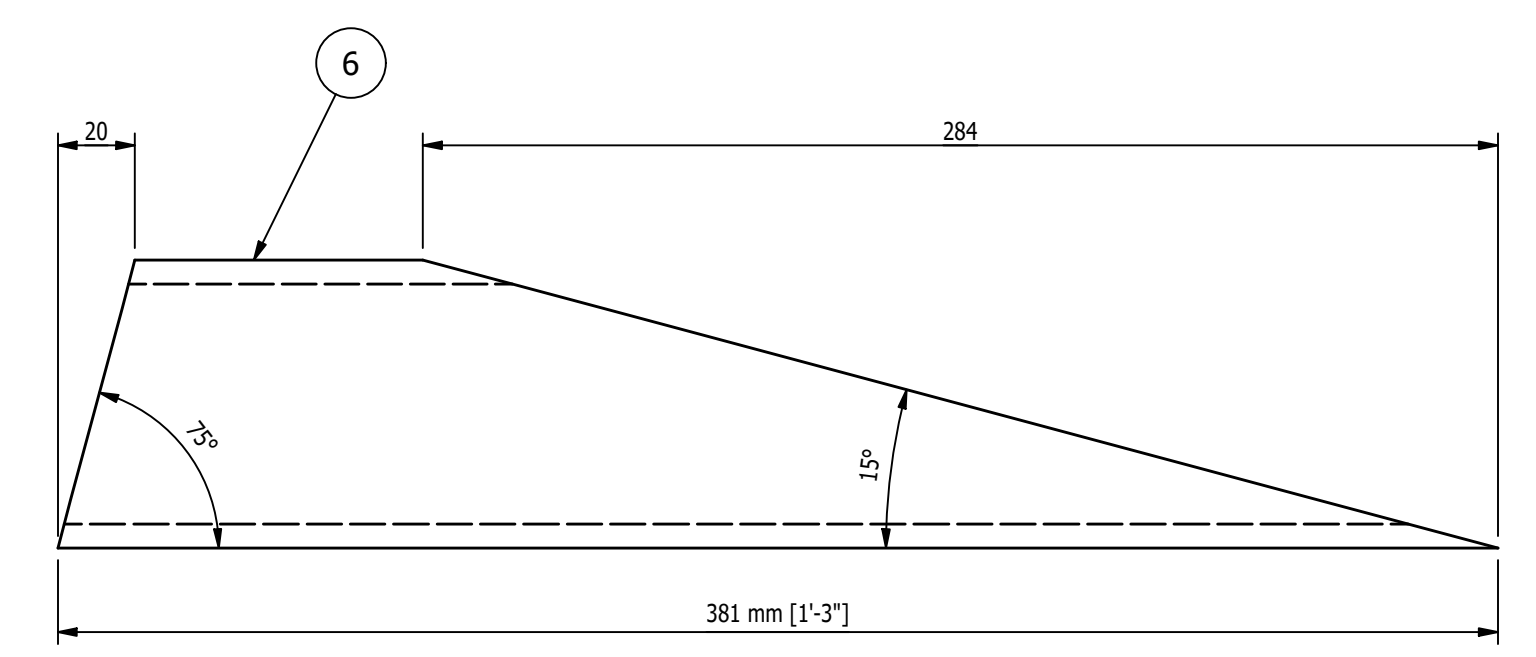
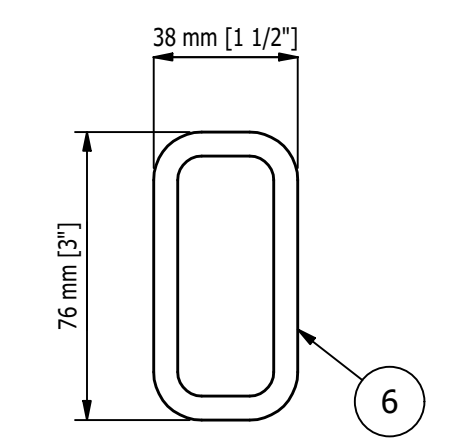
UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

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-D381A			
1	1	TS 3 x 1 1/2 x 1/4	1'-8 7/8"		
2	1	BAR 1/2 x 1 1/2	3 1/4"		
3	1	PL 3/4 x 9 5/8"	11 1/4"		
4	1	TS 3 x 1 x 3/16	1'-3 3/4"		
5	1	TS 2 x 1 x 3/16	6 7/8"		
6	1	TS 3 x 1 1/2 x 1/4	1'-3"		
7	1	SHT 11 GA x 3/4"	2 3/4"		
8	1	SHT 11 GA x 3/4"	1 3/4"		



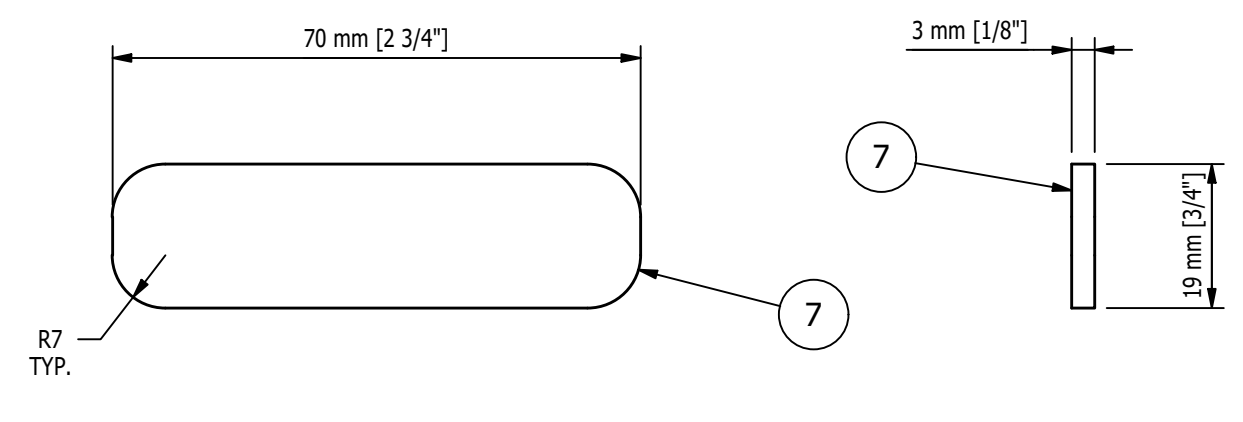
DETAIL OF ITEM '2'
SCALE 6"=1'-0"



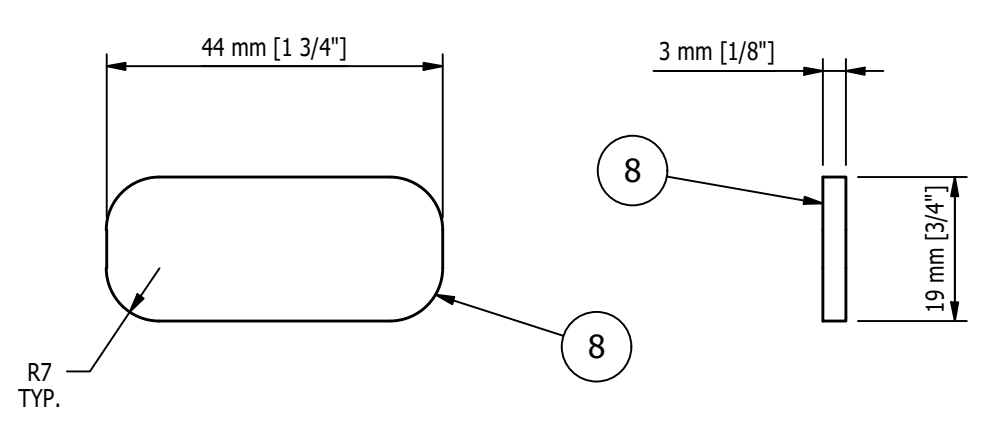
DETAIL OF ITEM '6'
SCALE 6"=1'-0"

MK-D381A ~ REST PAD STANCHION
SCALE 3"=1'-0"

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



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



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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	ADDED DETAIL VIEW OF ITEM '6' & DIMS	
A	MC	8/26/2022	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.	
		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: PWP			
CLIENT: VOLVO		CHECKED BY: JCK			
DRAWING No. 1875D381		REV: B		JOB No: 22096	
		DWG DATE: 8/1/22			

MAGNUM CONSULTING
4100 Clarkston Rd. Suite 125, Novi, MI 48225
Phone: (248) 772-8822 Fax: (248) 772-8851 Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D381

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

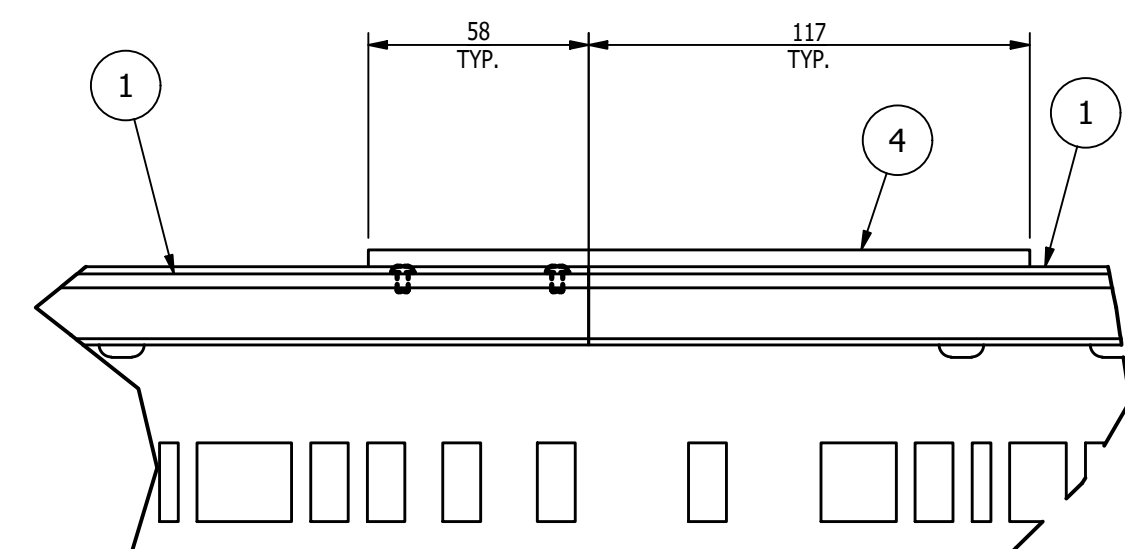
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

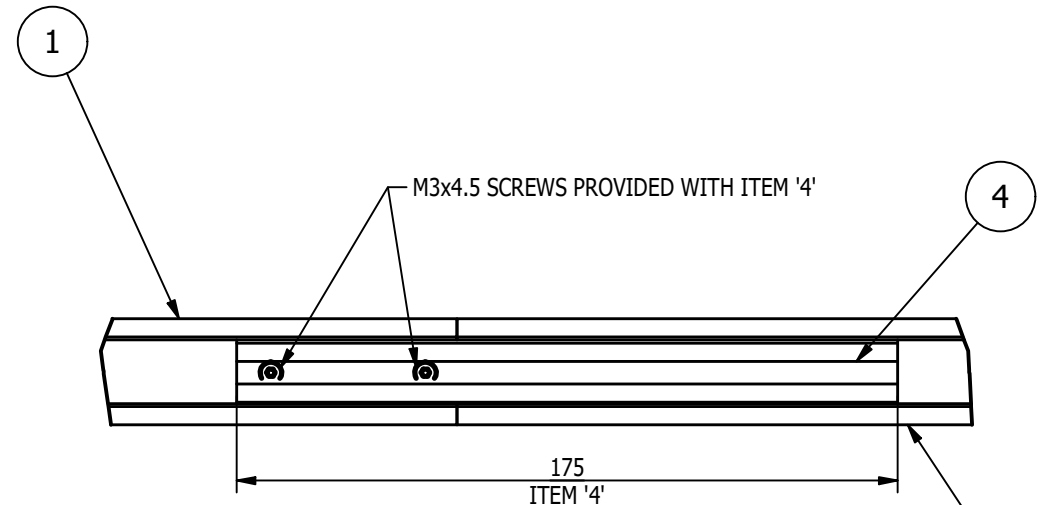
COPIES:

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

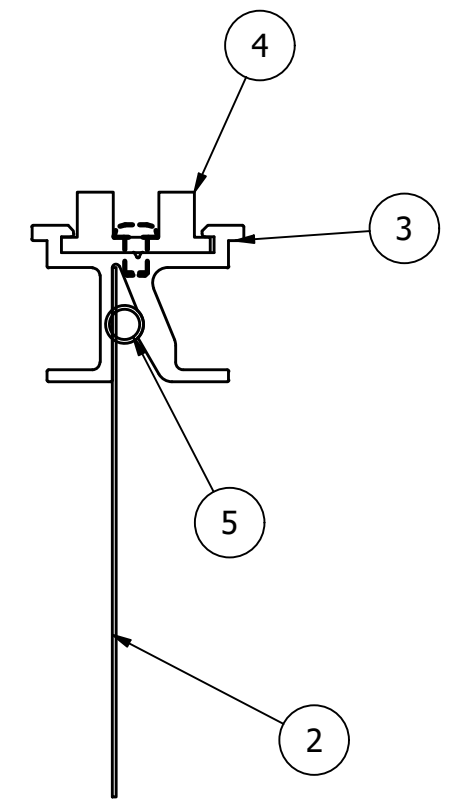
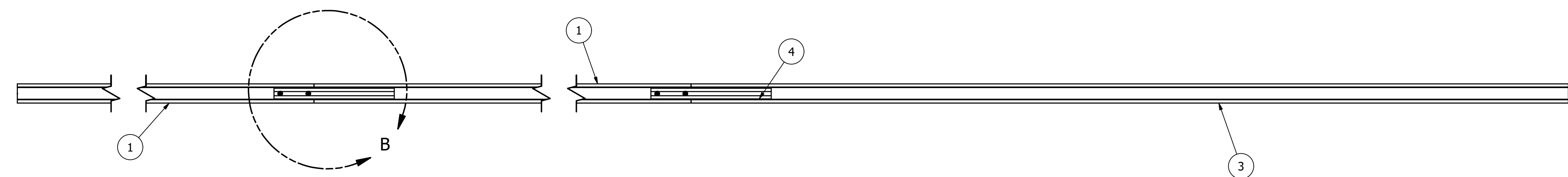
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	2	PROFILE RAIL, 2600 MM LG, PEPPERL-FUCHS PART NO. WCS3-PS1		27-1	
2	1	CODE RAIL, 6476mm LG, PEPPERL-FUCHS PART NO. WCS3-CS70-M1		27-2	
3	1	PROFILE RAIL, 1276mm LG, PEPPERL-FUCHS PART NO. WCS3-PS1		27-3	
4	2	RAIL CONNECTOR WITH (2) SELFTAPPING M3x4.5 SCREWS, PEPPERL-FUCHS PART NO. WCS3-MC1		27-4	
5	1	FIXING CORD, PEPPERL-FUCHS PART NO. WCS-MF1		27-5	



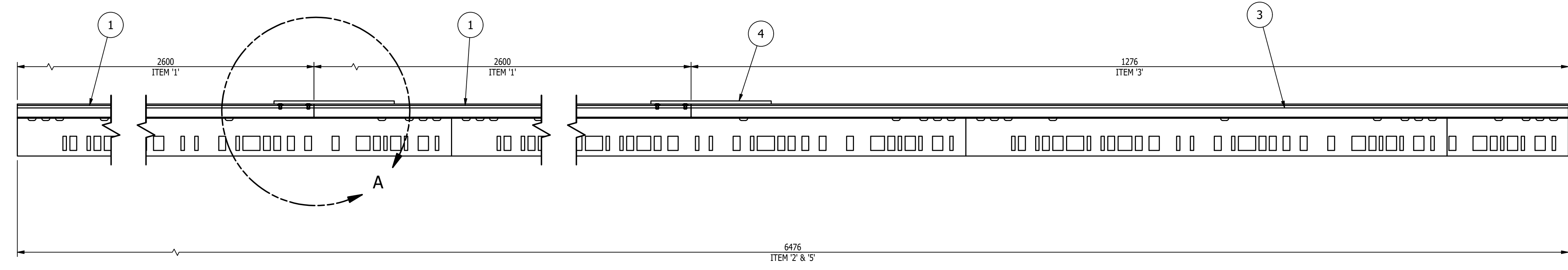
ENLARGED VIEW 'A'
SCALE 6"=1'-0"



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



END VIEW
SCALE 1'-0" = 1'-0"



MK-D382A ~ PEPPERL-FUCHS CODE RAIL ASSEMBLY
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:
DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
A	MC	10/19/22	FOR FABRICATION	

REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
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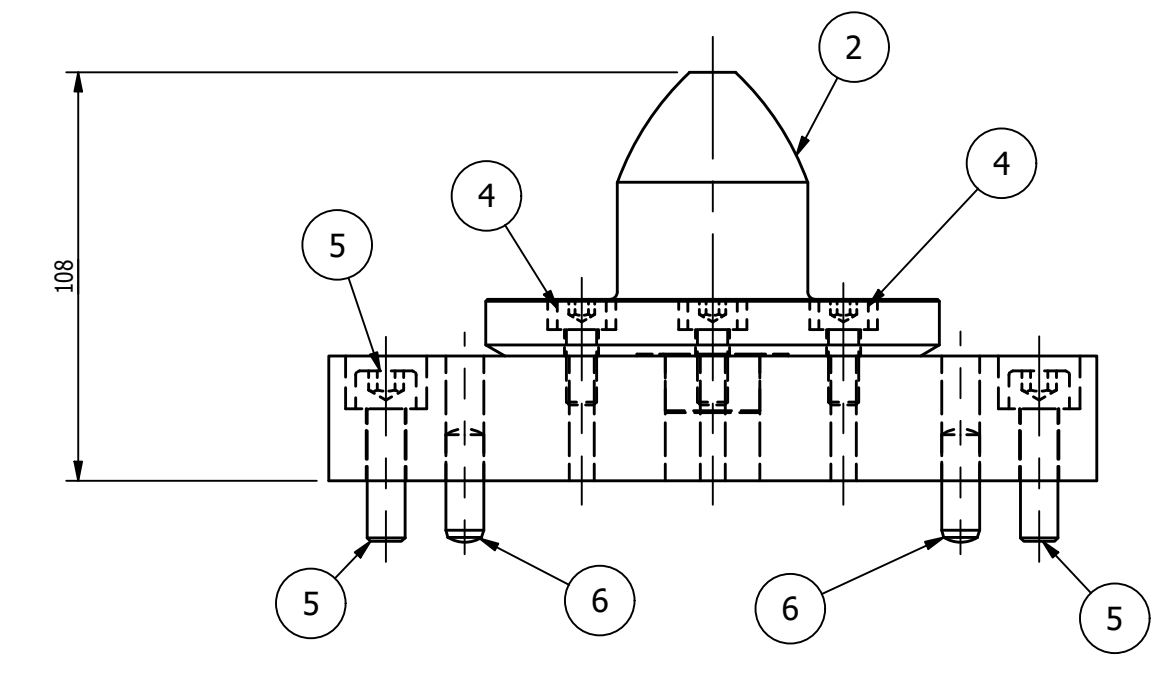
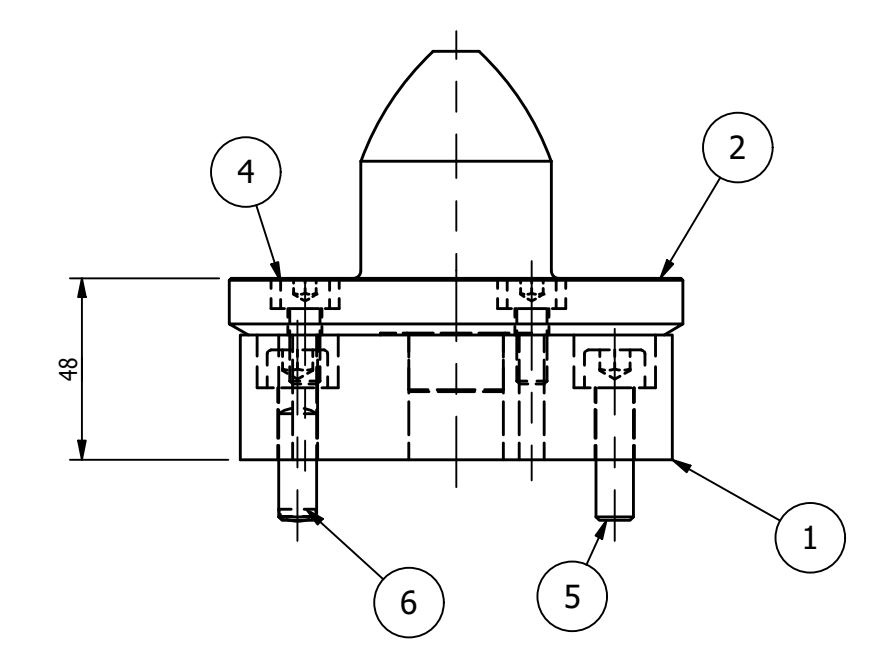
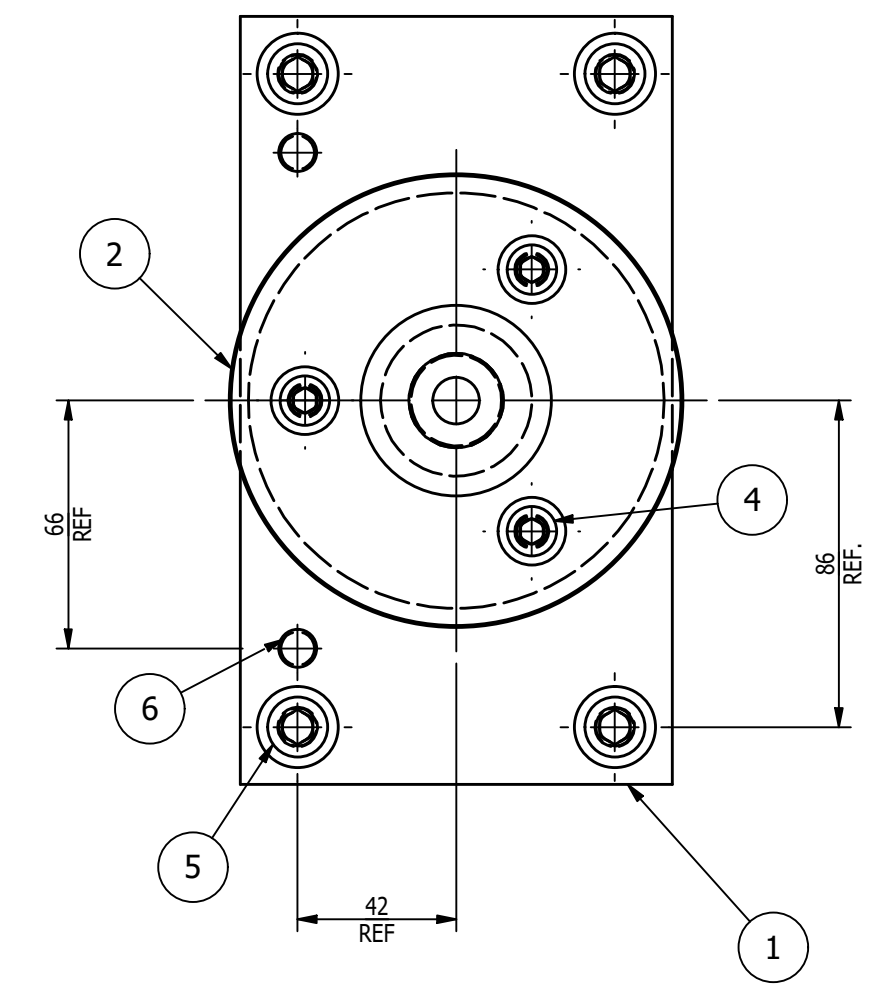
TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D382	DWG DATE: 10/21/22
REV: A	JOB No: 22096

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

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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.

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D383A			
1	1	MK-D375A ~ 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			




MK-D383A ~ 4 WAY LOCATOR PIN 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
A	MC	8/26/2022	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		DRAWN BY: AH
CLIENT: VOLVO		CHECKED BY: JCK
DRAWING No. 1875D383		DWG DATE: 8/15/22
REV: A		JOB No: 22096

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

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D383

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.

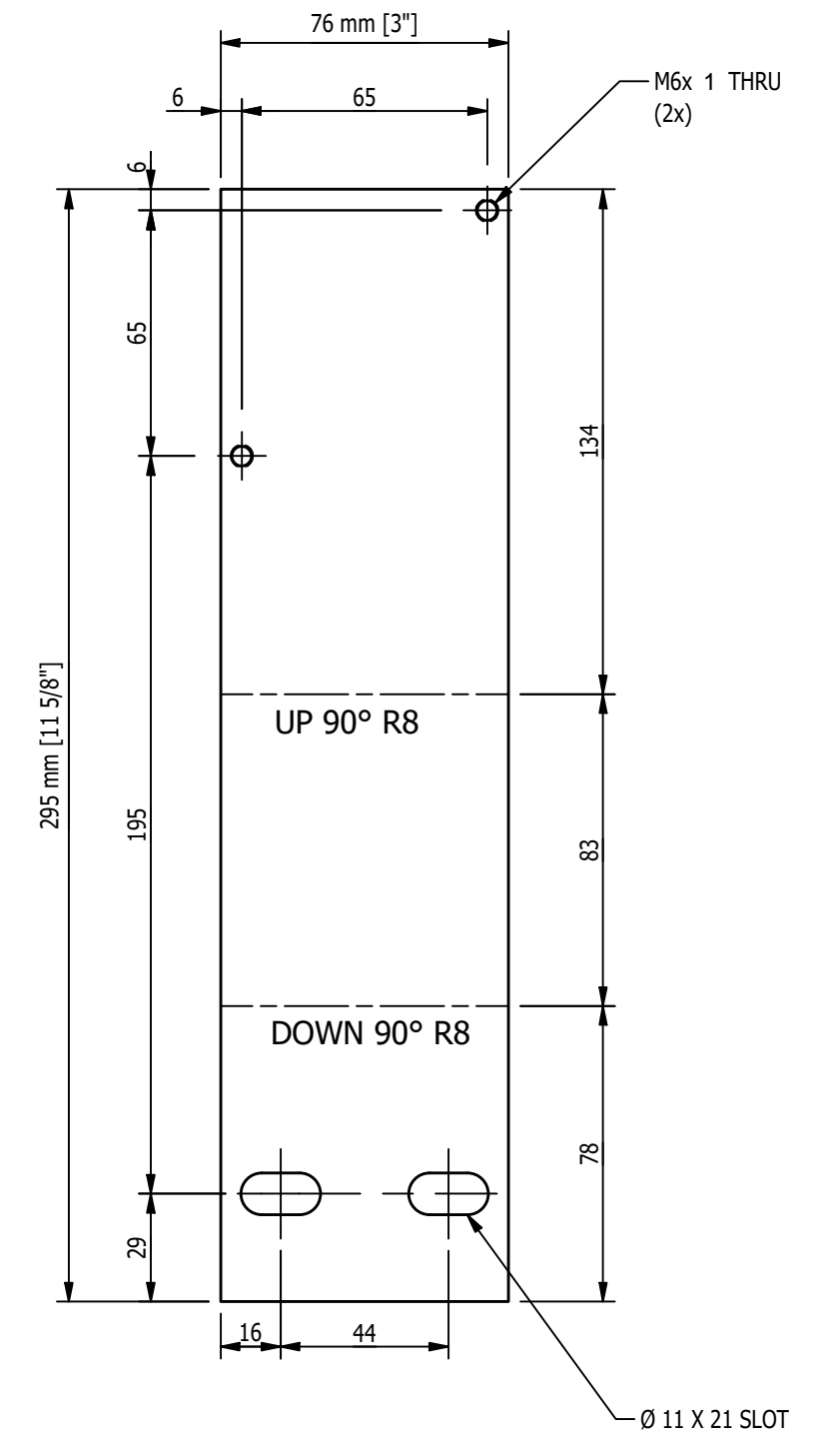
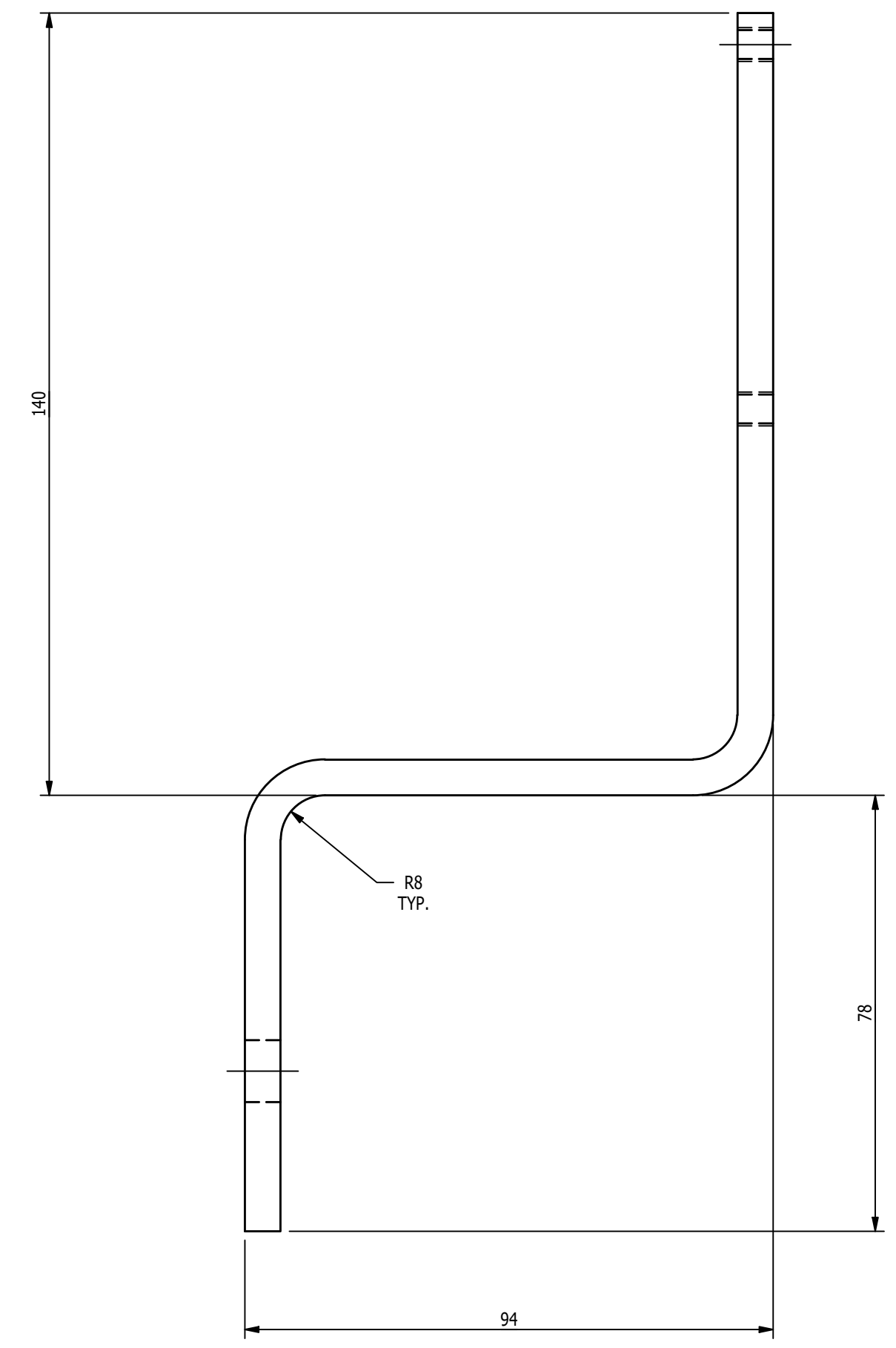
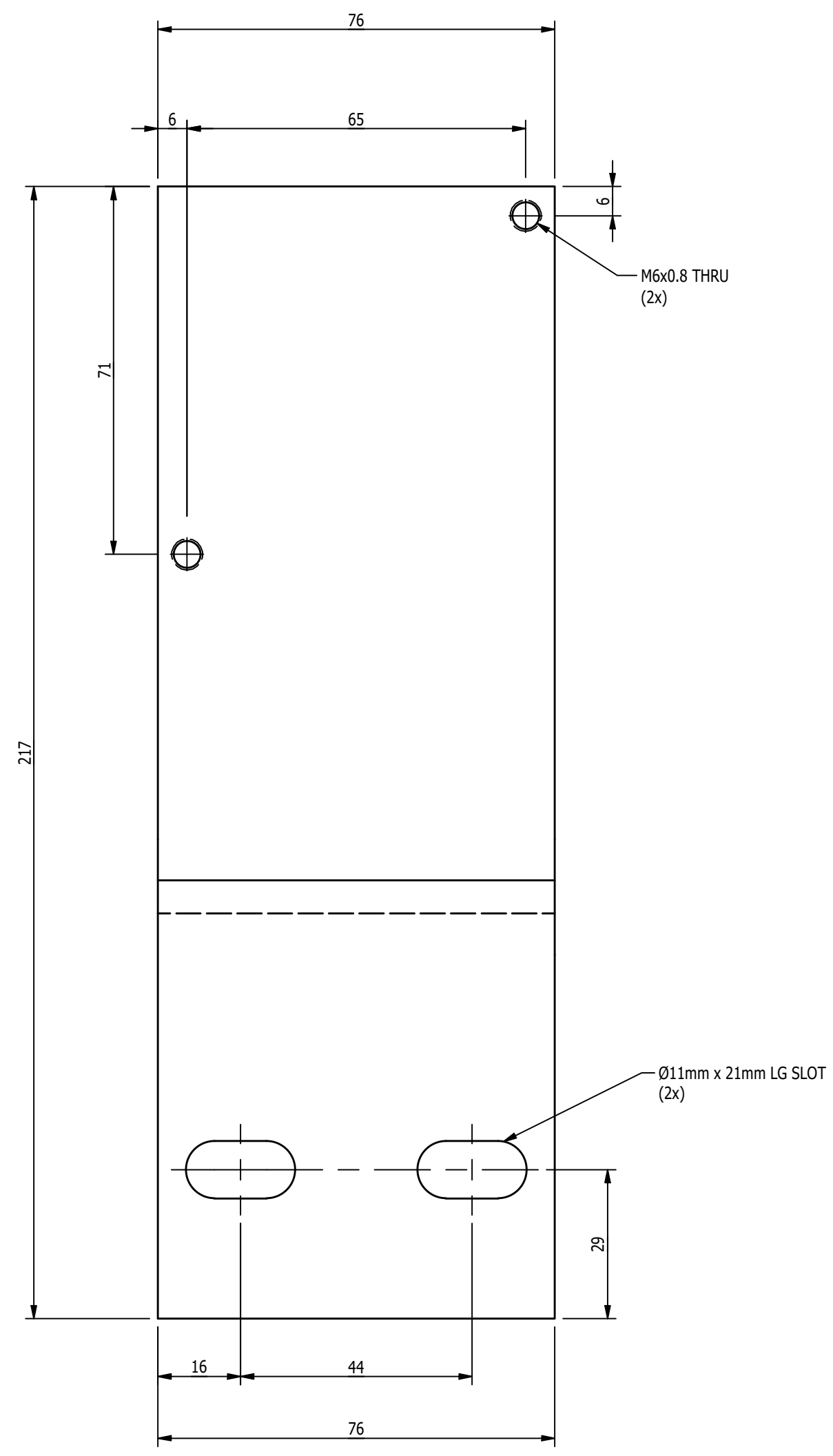
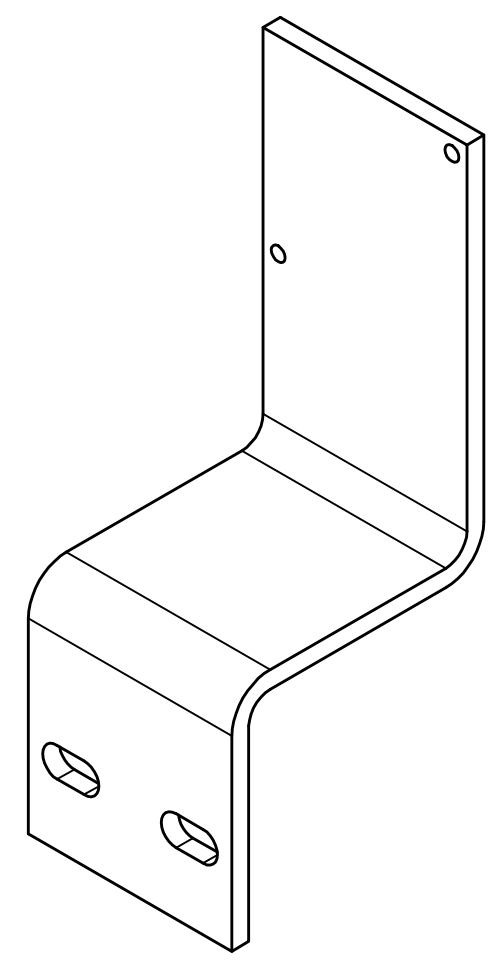
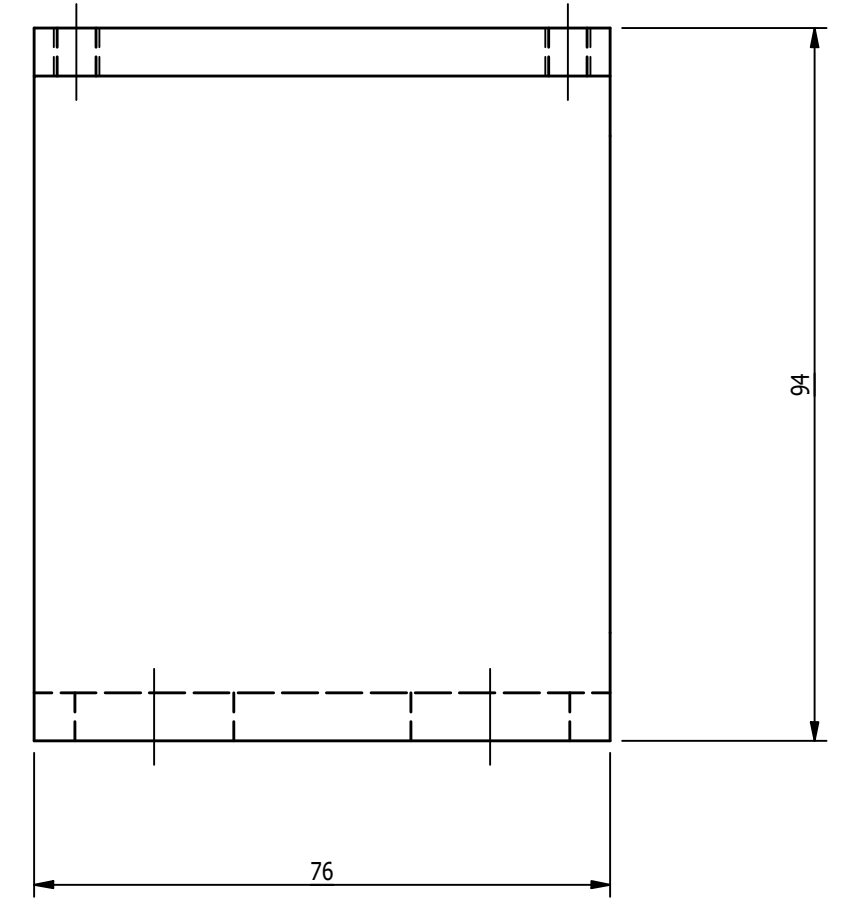
HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

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-D384A			
1	1	BAR 1/4 x 3	11 5/8"		
TOTAL WEIGHT = 2.4 Lbs					



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

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

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

MK-D384A ~ RF CODE READER BKT
SCALE 1'-0" = 1'-0"

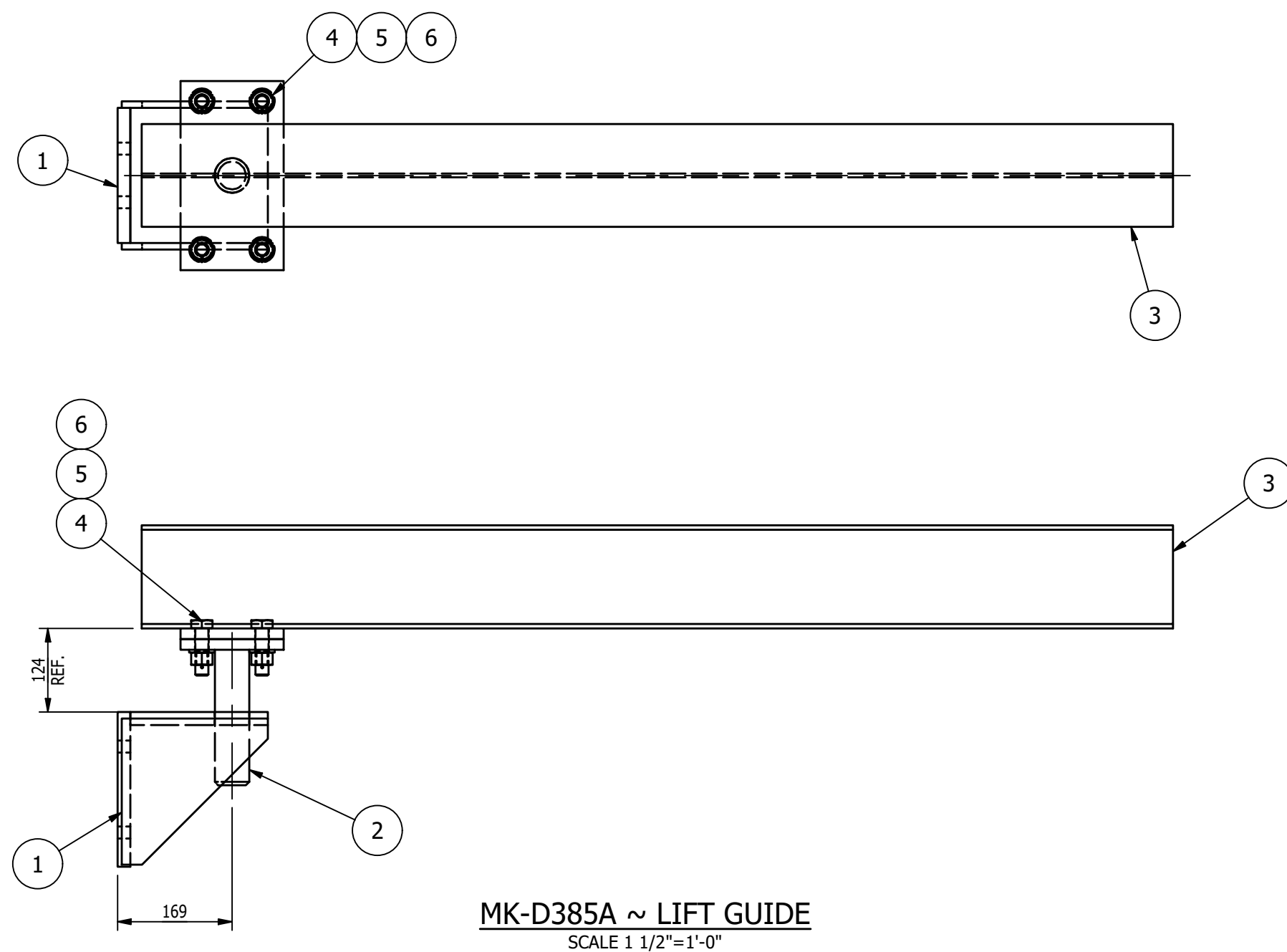
MAGNUM CONSULTING
41100 Charleston Rd. Suite 125, Norwalk, MI 48275
Phone: (248) 373-8833 Fax: (248) 373-8851 Web: www.milic.com

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XXX = ±.005
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ANGLES = ±1°30'
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DEBURR ALL HOLES
DO NOT SCALE DRAWING

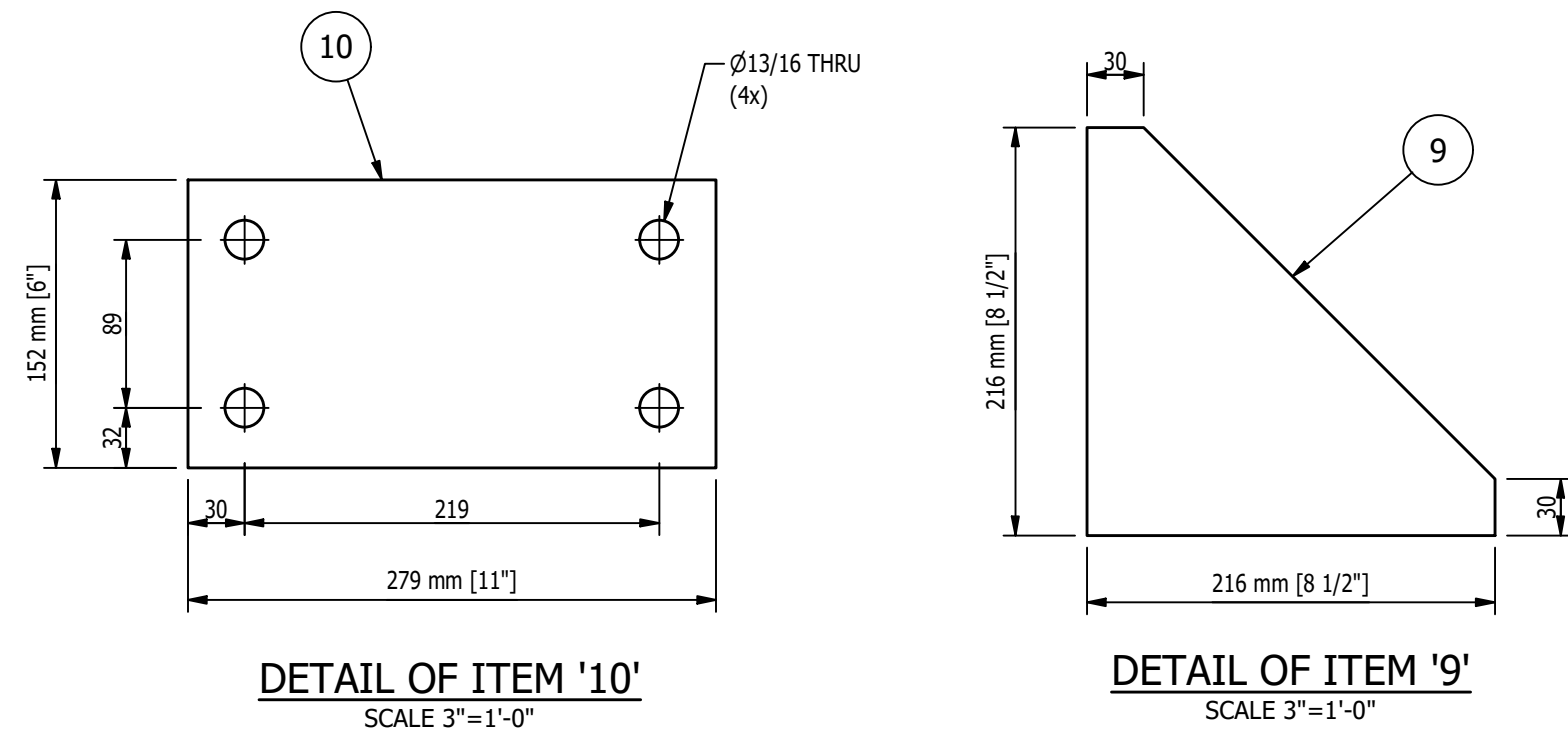
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
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HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
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WELDS:
- 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.

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/30/22	FOR FABRICATION	

MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.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: SGS	
CLIENT: VOLVO	CHECKED BY: CW	
DRAWING No. 1875D384	DWG DATE: 8-12-2022	
REV: A	JOB No: 22096	



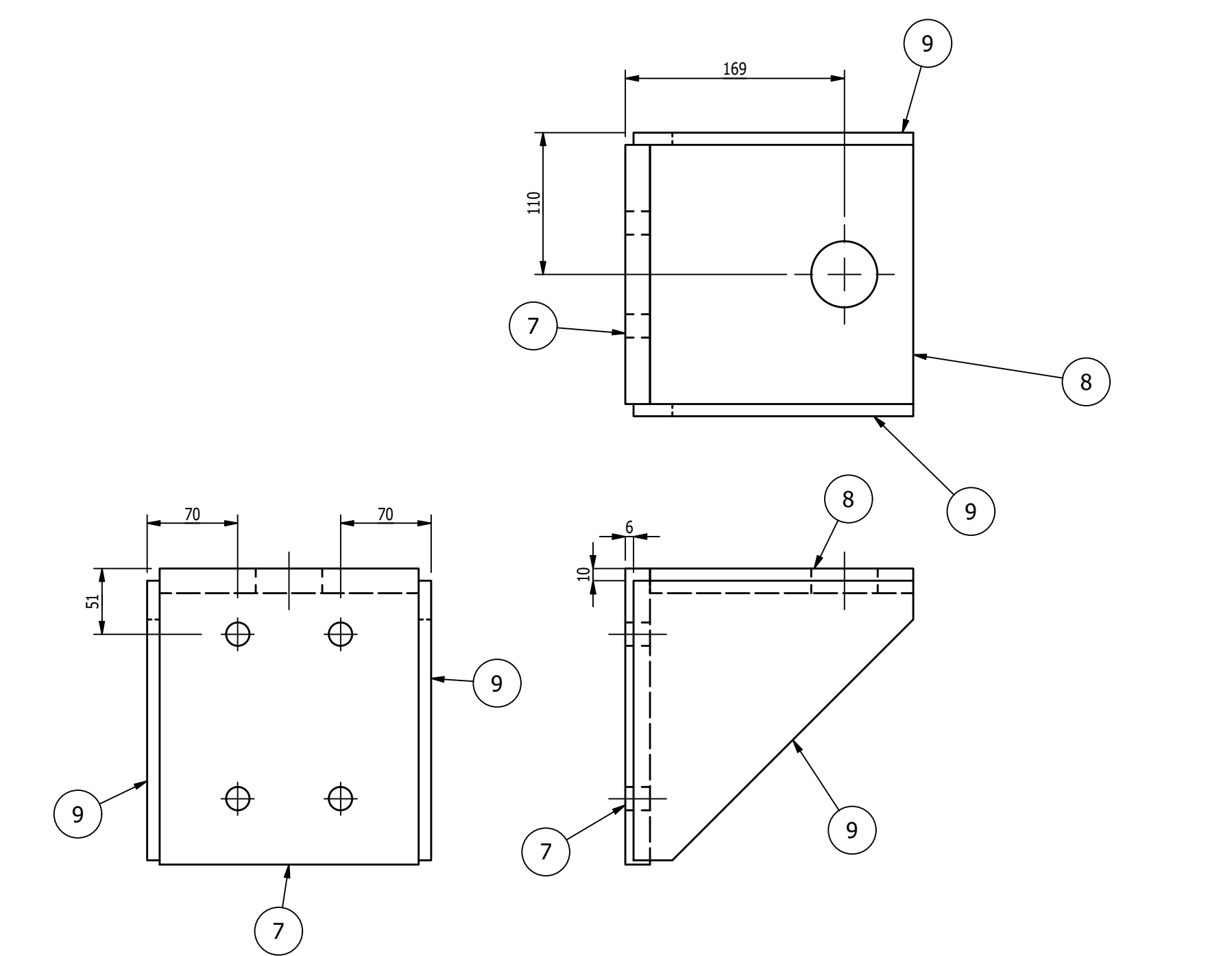
MK-D385A ~ LIFT GUIDE
SCALE 1 1/2"=1'-0"



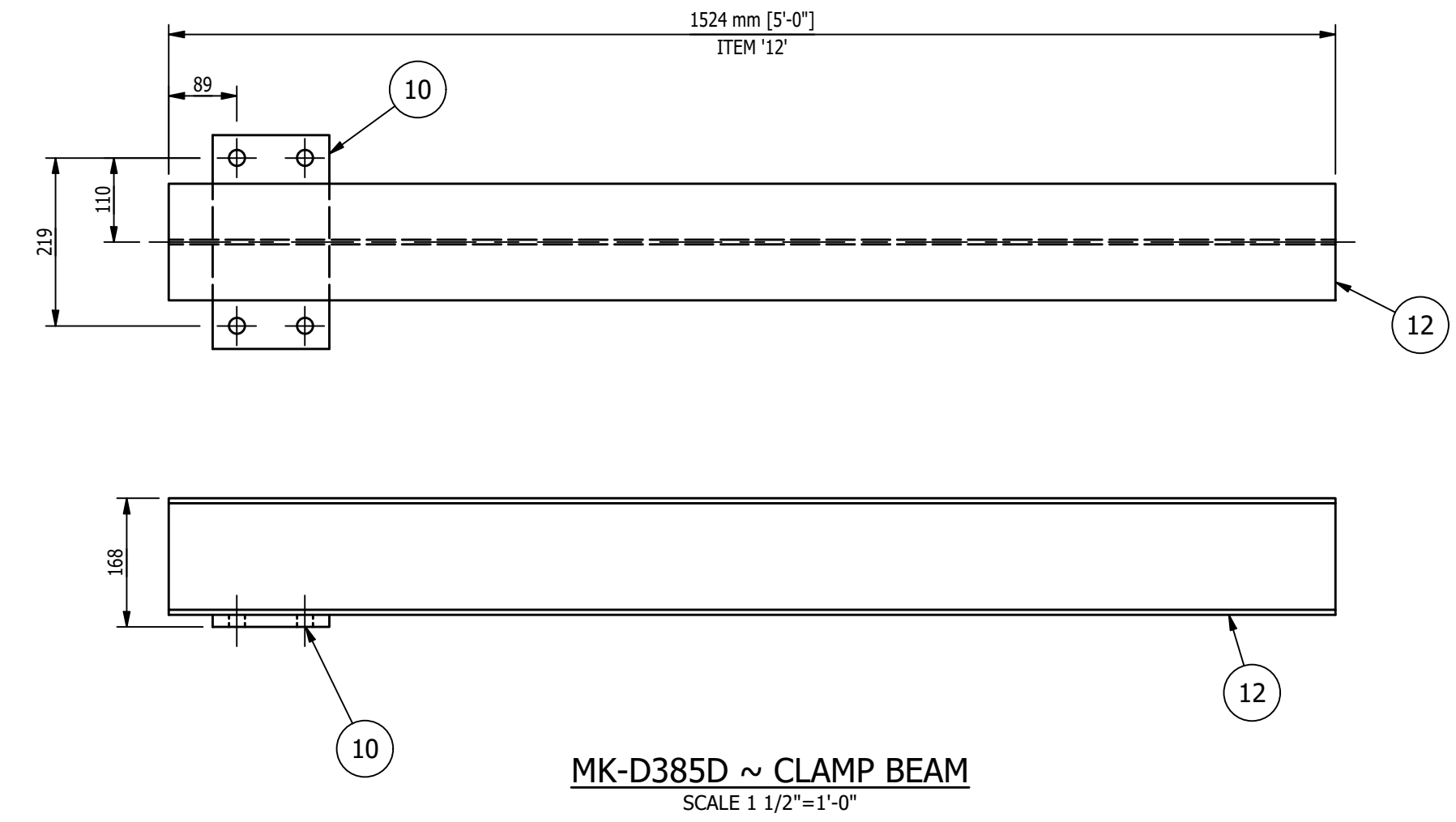
DETAIL OF ITEM '10'
SCALE 3"=1'-0"

DETAIL OF ITEM '9'
SCALE 3"=1'-0"

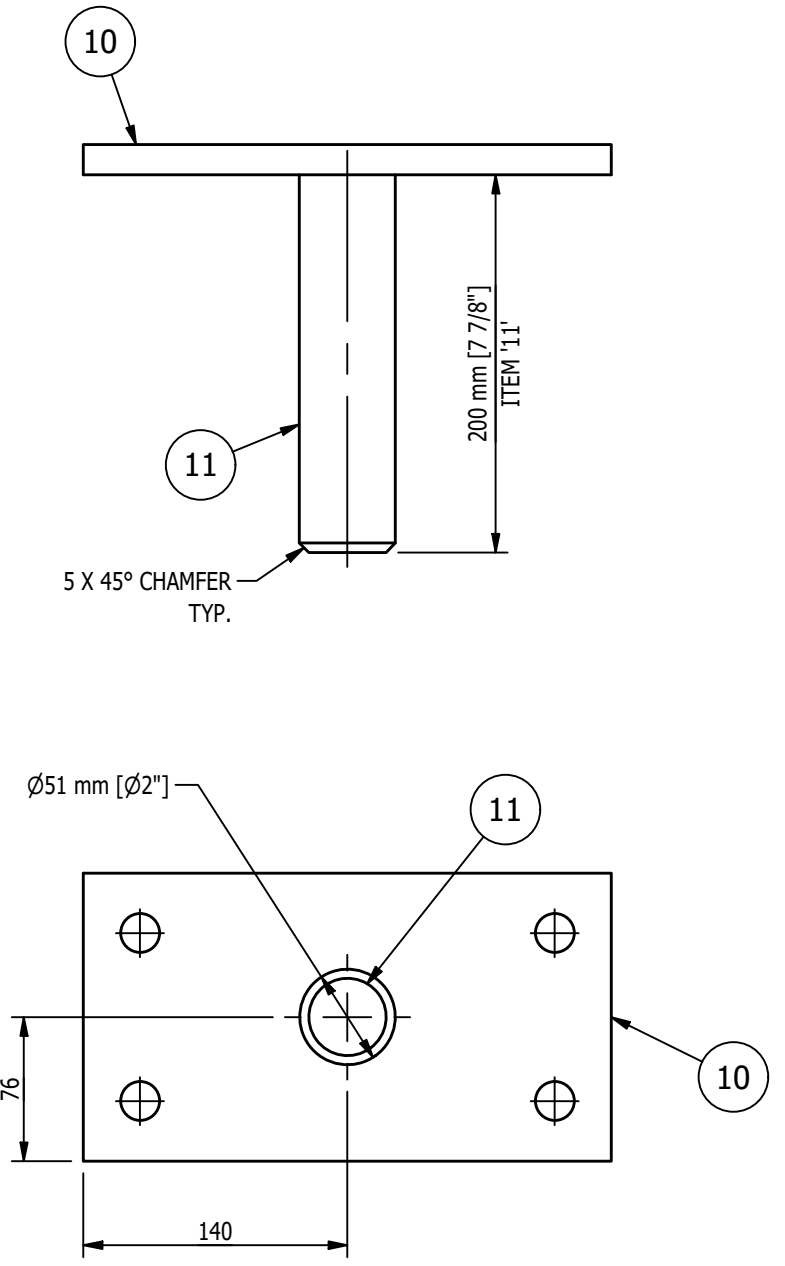
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D385A			
1	1	MK-D385B ~ BRACKET			
2	1	MK-D385C ~ CLAMP ROD			
3	1	MK-D385D ~ CLAMP BEAM			
4	4	3/4-10UNC x 2 3/4" LG. A325 HEX HEAD BOLT			
5	4	3/4-10UNC ANCO LOCK NUT A194 GR. 2H			
6	4	3/4 FLAT HARDENED WASHER F436			
		MK-D385B			
7	1	PL 3/4 x 7 7/8"	9"		
8	1	PL 3/4 x 7 7/8"	8"		
9	2	PL 3/8 x 8 1/2"	8 1/2"		
		MK-D385C			
10	1	PL 5/8 x 6"	11"		
11	1	BAR Ø2 (CRS)	7 7/8"		
		MK-D385D			
10	1	PL 5/8 x 6"	11"		
12	1	W 6 x 15	5'-0"		



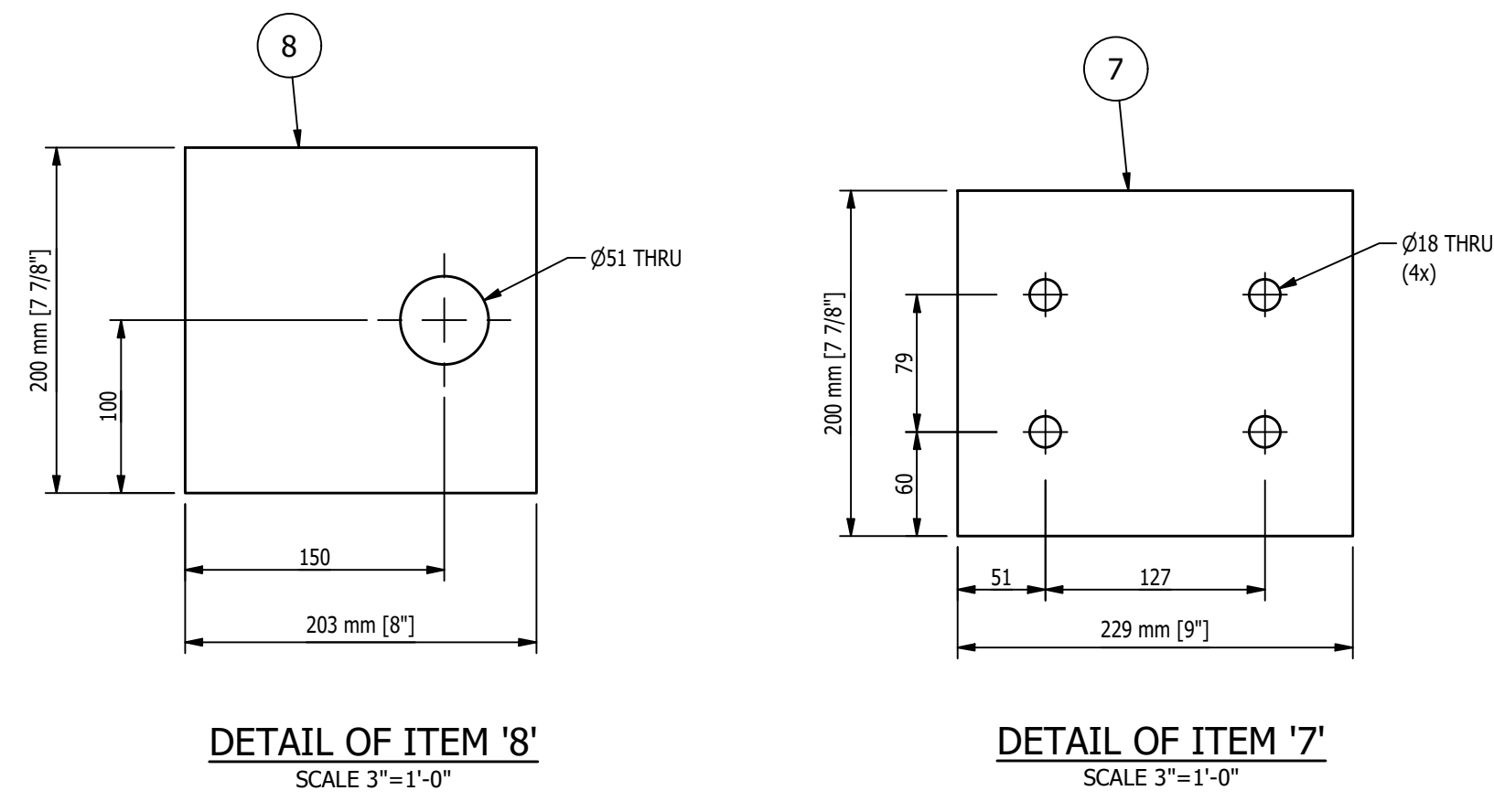
MK-D385B ~ BRACKET
SCALE 3"=1'-0"



MK-D385D ~ CLAMP BEAM
SCALE 1 1/2"=1'-0"



MK-D385C ~ CLAMP ROD
SCALE 3"=1'-0"



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

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

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

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

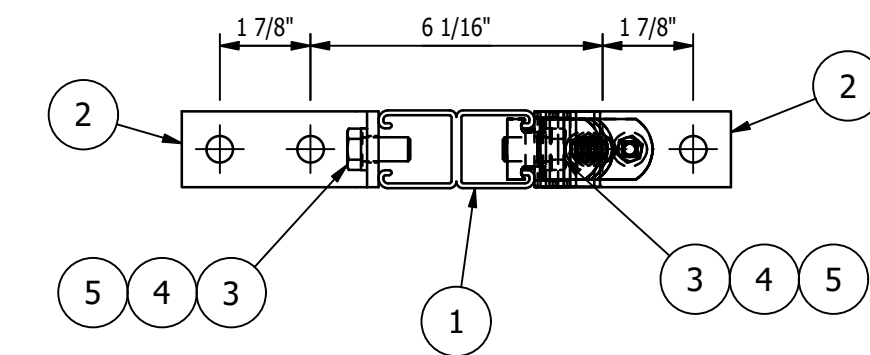
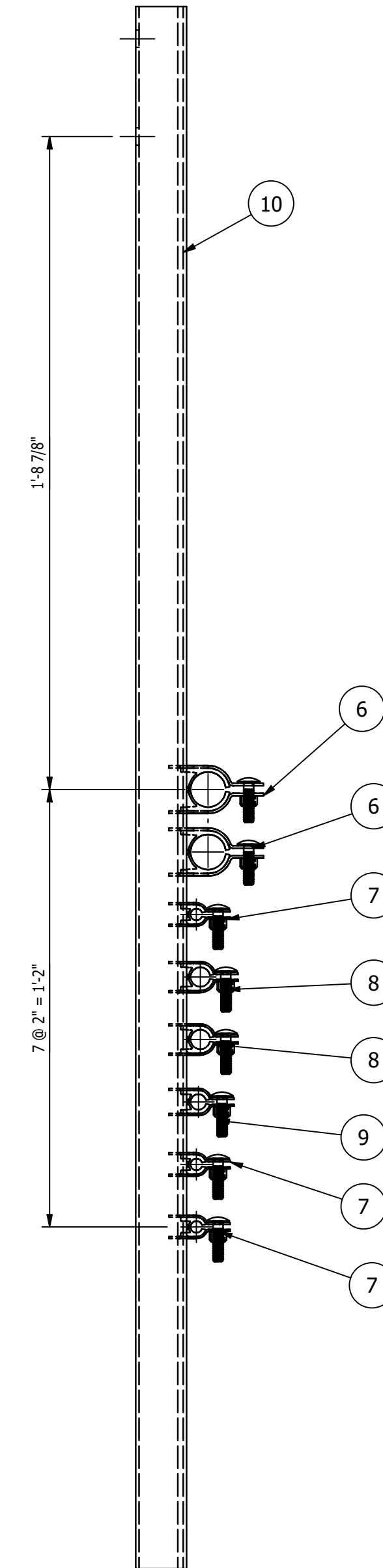
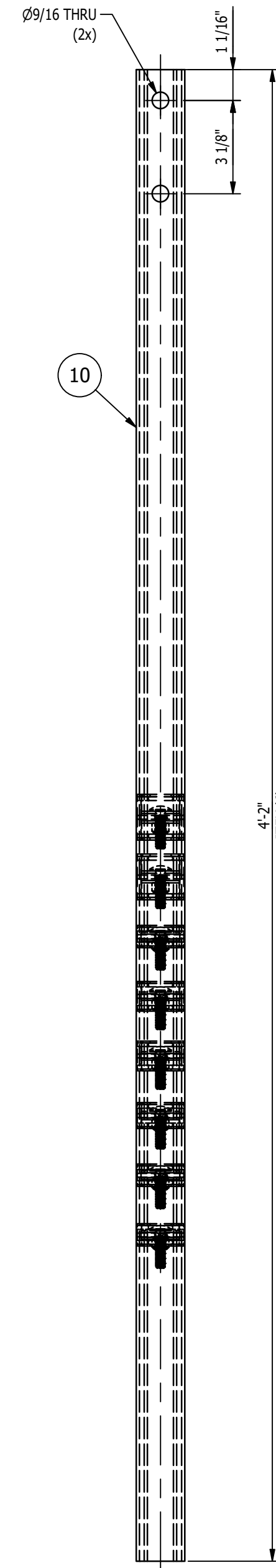
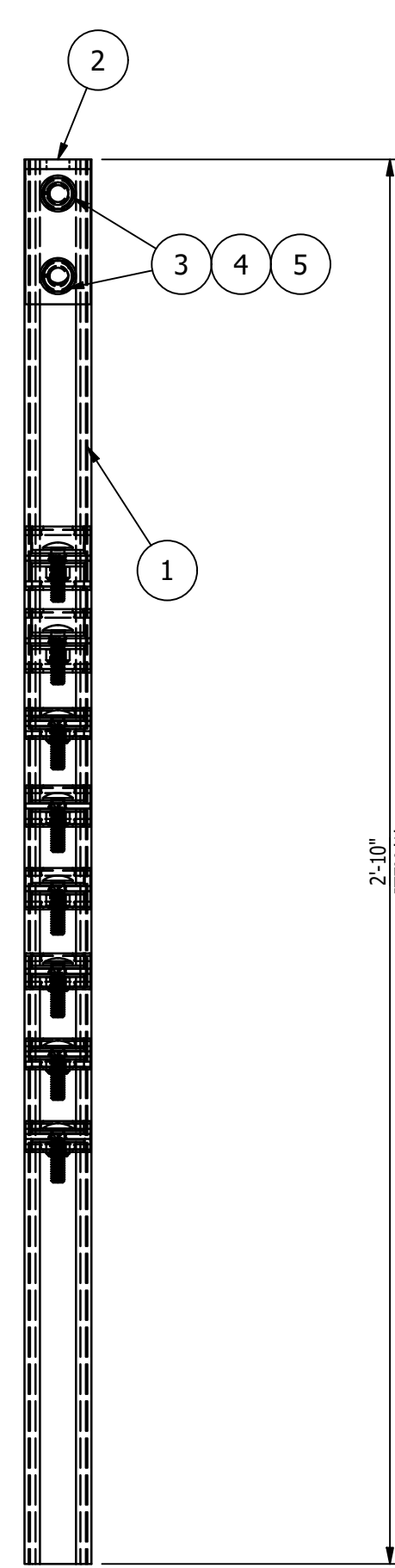
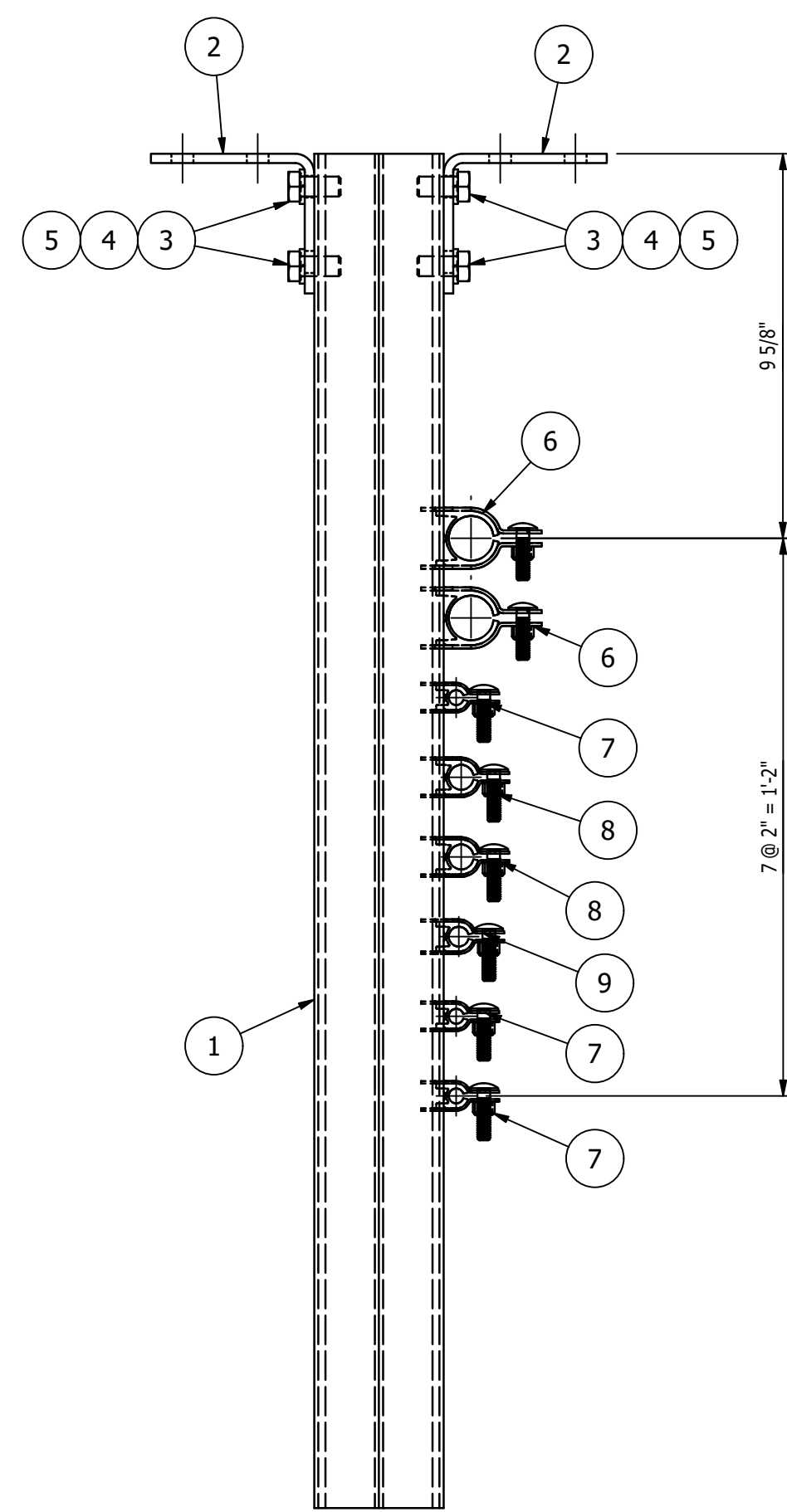
REV	BY	DATE	DESCRIPTION	APP
A	MC	10/5/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: RJB	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 10/5/22	
DRAWING No. 1875D385		JOB No. 22096	
REV: A			

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

MAGNUM CONSULTING
 41100 Clarkston Road
 Suite 125
 Novi, MI 48245
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D385

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-D386A ~ LOWER CABLE SUPPORT
SCALE 3"=1'-0"

MK-D386B ~ UPPER CABLE SUPPORT
SCALE 3"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
MK-D386A					
1	1	UNISTRUT P1000, 1-5/8" x 1-5/8", 12 GA., BACK-TO-BACK, SOLID CHANNEL	2'-10"		
2	2	UNISTRUT 1325 GR 90° ANGLE FITTINGS			
3	4	UNISTRUT 1/2-13 CHANNEL NUT WITH SPRING, PERMA-GREEN FINISH, PART NO. P1010-GR			
4	4	1/2 SPRING LOCK WASHER			
5	4	1/2-13UNC x 1" LG. HEX HEAD CAP SCREW			
6	2	HTYDRA ZORB 304SS CUSHION TUBE CLAMP 1" ~ 100100		28-1	
7	3	HTYDRA ZORB 304SS CUSHION TUBE CLAMP 1/4" ~ 100025		28-4	
8	2	HTYDRA ZORB 304SS CUSHION TUBE CLAMP 3/8" ~ 100037		28-2	
9	1	HTYDRA ZORB 304SS CUSHION TUBE CLAMP 5/16" ~ 100031		28-3	
MK-D386B					
6	2	HTYDRA ZORB 304SS CUSHION TUBE CLAMP 1" ~ 100100		28-1	
7	3	HTYDRA ZORB 304SS CUSHION TUBE CLAMP 1/4" ~ 100025		28-4	
8	2	HTYDRA ZORB 304SS CUSHION TUBE CLAMP 3/8" ~ 100037		28-2	
9	1	HTYDRA ZORB 304SS CUSHION TUBE CLAMP 5/16" ~ 100031		28-3	
10	1	UNISTRUT 1-5/8" x 1-5/8" 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	4'-2"		

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

PAINT NOTES:
DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
A	MC	10/19/22	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. 1875D386	DRAWN BY: RJB CHECKED BY: CW DWG DATE: 10/17/22 JOB No: 22096

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WELDS:

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PAINT:

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COPIES:

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