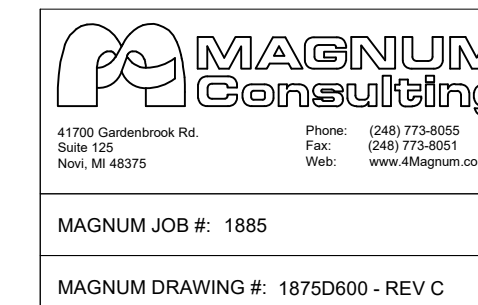


SPEED FORMULA (60HZ):

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

SHOP NOTES:

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



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
		TOTAL WEIGHT ~ 2294.9 LBS			
		MK-D600A			
1	1	MK-D001A ~ 8-ROLL SIDE FRAME ASSY - RH			
2	1	MK-D001B ~ 8 ROLL SIDE FRAME ASSY - LH			
3	2	MK-D601A ~ END PLATE ASSEMBLY			
4	4	MK-D603A ~ CROSS MEMBER WITH GUARD SUPPORT			
5	2	MK-D603B ~ CROSS MEMBER WITH GUARD SUPPORT & LOCATOR			
6	7	PALLET DRIVEN ROLLER, DUGOMRULLI PART NO 329638V			
7	1	PALLET DRIVER ROLLER, DUGOMRULLI PART NO 332192V M12			
8	6	GATES POWERGRIP GT4 BELT, 1800-8M-GT85		2-3	
9	1	GATES POWERGRIP GT4 BELT, 2000-8M-GT85		2-2	
10	1	MK-D005D ~ SHAFT SPACER			
11	14	MK-D005B ~ ROLL KEEPER			
12	1	SIEMENS RB2 GEARMOTOR (SEE MOTOR DATA LIST)		1-2	
13	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&SP #16-85-MHR		3-3	
15	1	MK-D005E ~ SHAFT SPACER			
16	1	MK-D005F ~ MOTOR END PLATE			
17	1	MK-D005C ~ BEARING PLATE			
18	1	MK-D005A ~ BEARING PLATE			
19	1	MK-D009D ~ PROX BRACKET			
20	2	MK-D602A ~ LEG ASSEMBLY			
21	8	MK-D007A ~ ADJUSTING SUPPORT			
22	8	MK-D008A ~ ANGLE BRACE			
23	1	MK-D006C ~ SKID GUIDE ROLLER - LH			
24	1	MK-D006D ~ SKID GUIDE ROLLER - RH			
25	1	MK-D009A ~ PROX BRACKET			
26	1	MK-D009B ~ PROX BRACKET			
27	1	MK-D010A ~ BELT GUARD			
28	1	MK-D010B ~ BELT GUARD			
29	1	MK-D010C ~ BELT GUARD			
30	24	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
31	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
32	8	M12x1.75 x 40mm LG. HEX CAP SCREW			
33	5	M12 SPRING LOCK WASHER			
35	111	M12 x 1.75 STOVER LOCK NUT			
36	38	M10x1.5 x 25mm LG. HEX CAP SCREW			
37	56	M12x1.75 x 35mm LG. HEX CAP SCREW			
38	16	M12 NARROW FLAT WASHER			
40	51	M12x1.75 x 30mm LG. HEX CAP SCREW			
41	2	MK-D005G ~ STATIC WHEEL BRACKET			
42	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
43	1	M12x1.75 x 45mm LG. HEX CAP SCREW			
44	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
45	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	
48	1	MK-D009C ~ PROX BRACKET			
		MK-D600B			
35	4	M12 x 1.75 STOVER LOCK NUT			
37	4	M12x1.75 x 35mm LG. HEX CAP SCREW			
38	4	M12 NARROW FLAT WASHER			
46	1	MK-D047A ~ CONTROLLER BRACKET			
47	1	MK-D600A ~ 8-ROLL ASSY			
		TOTAL WEIGHT ~ 2318.5 LBS			

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/3/2022	ADDED ITEM 48, CHANGED 600A, 600B DESCRIPTIONS	
B	MC	7-25-2022	UPDATED GEOMETRY, ADDED MK-D600B	
A	MC	7-19-2022	FOR FABRICATION	

REVISION HISTORY

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

TITLE: P6700 CONVEYORS
CAMPUS BUILDING

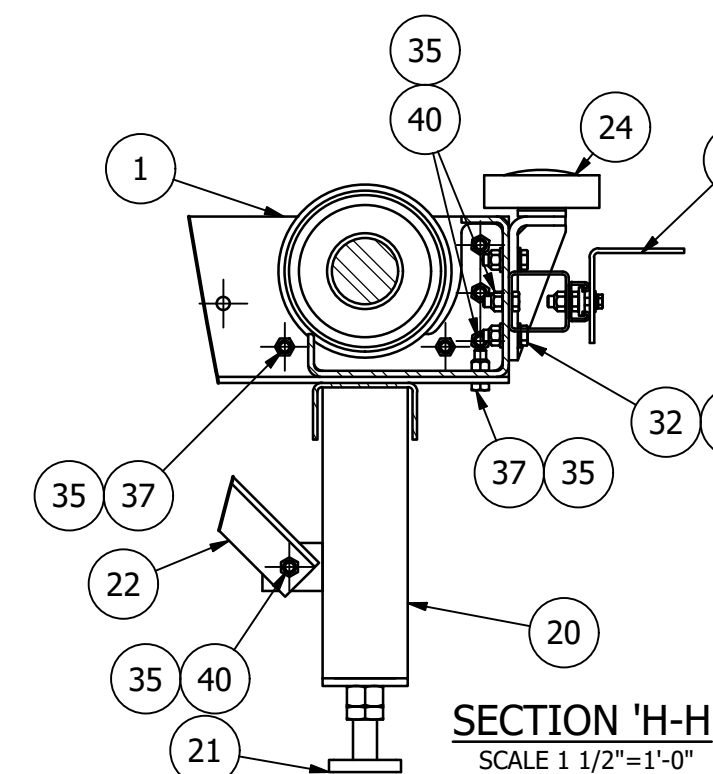
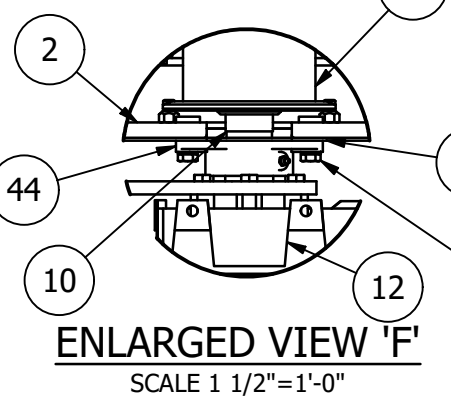
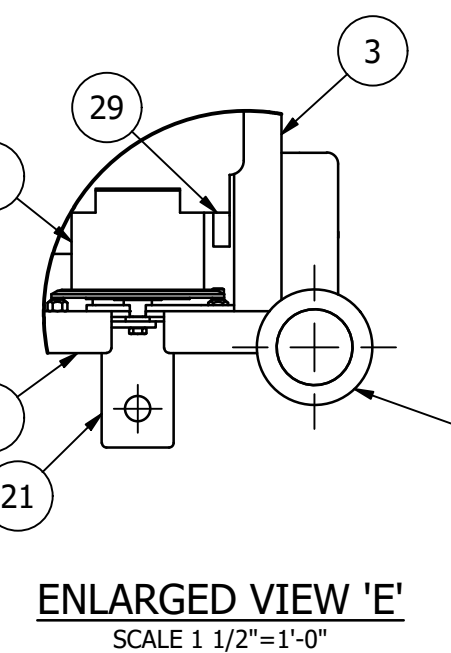
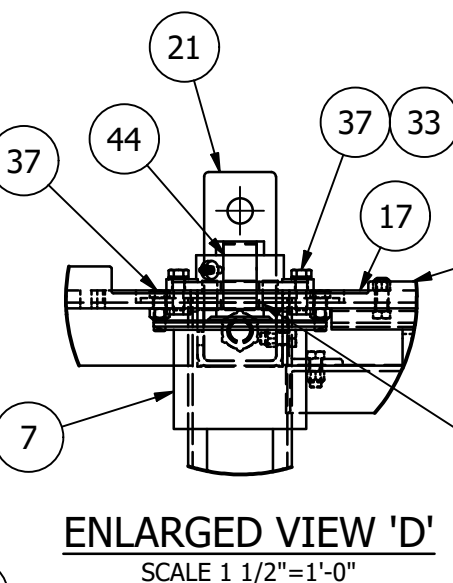
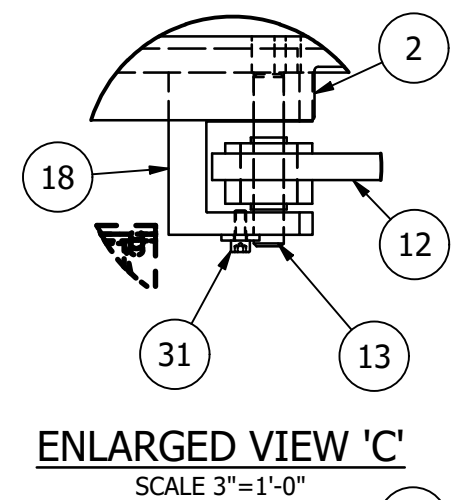
CLIENT: VOLVO

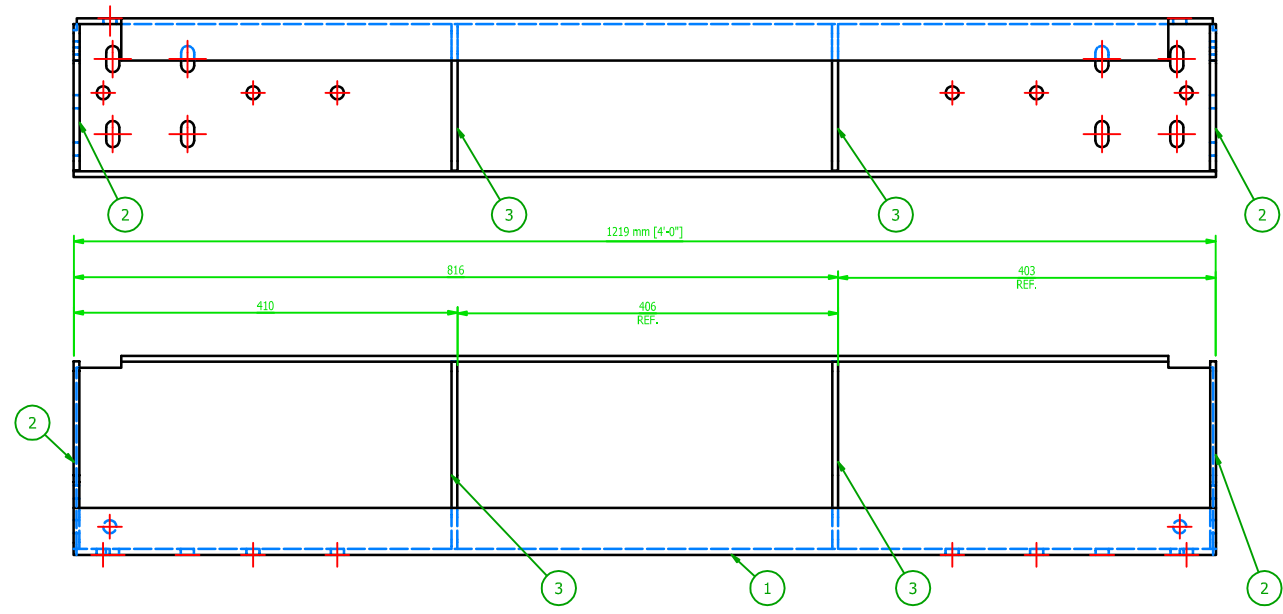
DRAWING No. 1875D600

REV: C

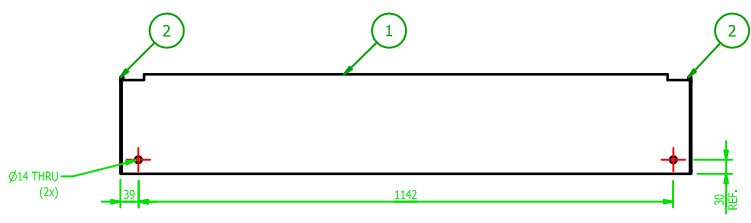
JOB No. 22096

DRAWN BY: SGS
CHECKED BY: CW
DWG DATE: 6-21-2022

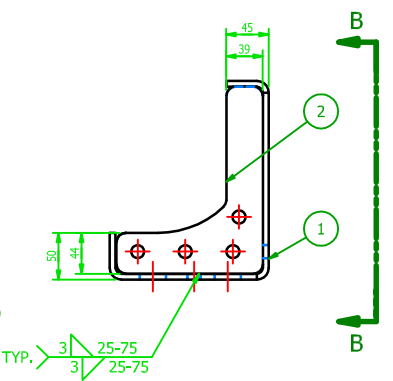




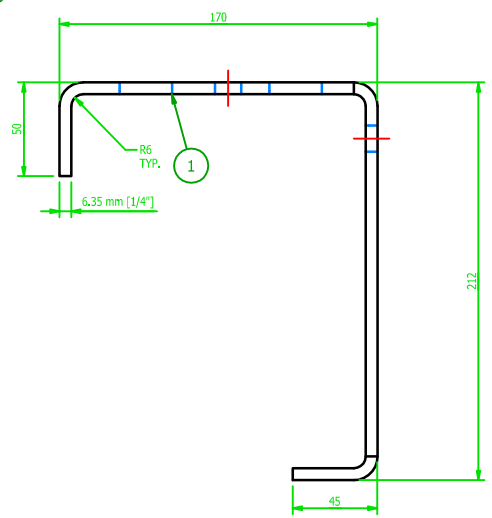
MK-D601A ~ END PLATE ASSY
SCALE 3"=1'-0"



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

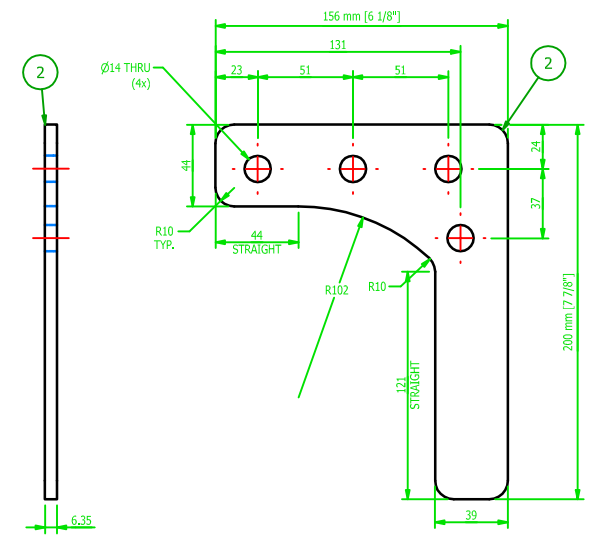


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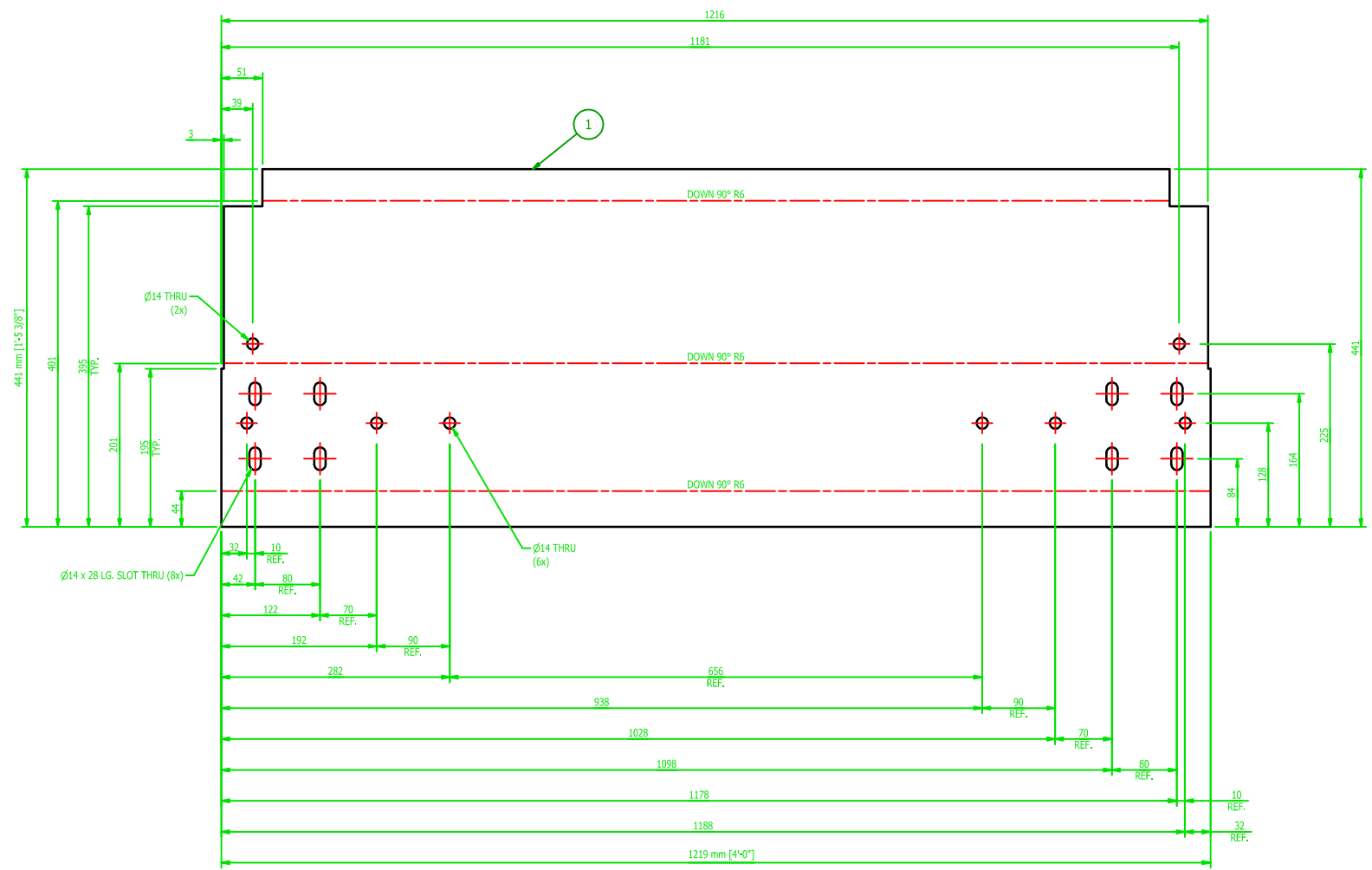


DETAIL OF ITEM '1'
SCALE 6"=1'-0"

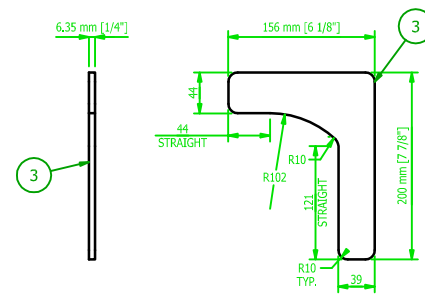
BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
1	1	MK-D601A		
1	1	PL 1/4 x 1'-5 3/8"	4'-0"	
2	2	PL 1/4 x 6 1/8"	7 7/8"	
3	2	PL 1/4 x 6 1/8"	7 7/8"	
TOTAL WEIGHT ~ 64.4 lbs				



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



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



DETAIL OF ITEM '3'
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 PER BUILD MATRIX EITHER

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

REV	BY	DATE	DESCRIPTION	APP
D	MC	9/7/22	UPDATED PAINT NOTES & DESCRIPTION OF ITEM '1', CORRECTED REVISION HISTORY LETTERING	
C	MC	8/4/2022	REVISED BOM DESCRIPTION ITEM 2	
B	MC	7/26/2022	REV BOM FOR ITEM '1'; ADDED DIMENSIONS TO DETAIL OF ITEM '2' & '3'; DIMENSIONED FLAT PATTERN FOR ITEM '1'; UPDATED PAINT NOTES	
A	MC	7/19/2022	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.

MAGNUM Consulting
41100 Gardenbrook Rd
Suite 100
Mukwonago, WI 53151
Phone: (262) 775-2000
Fax: (262) 775-2001
Web: www.magnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D601

UNLESS OTHERWISE NOTED:
XX = ±.050
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. 1875D601

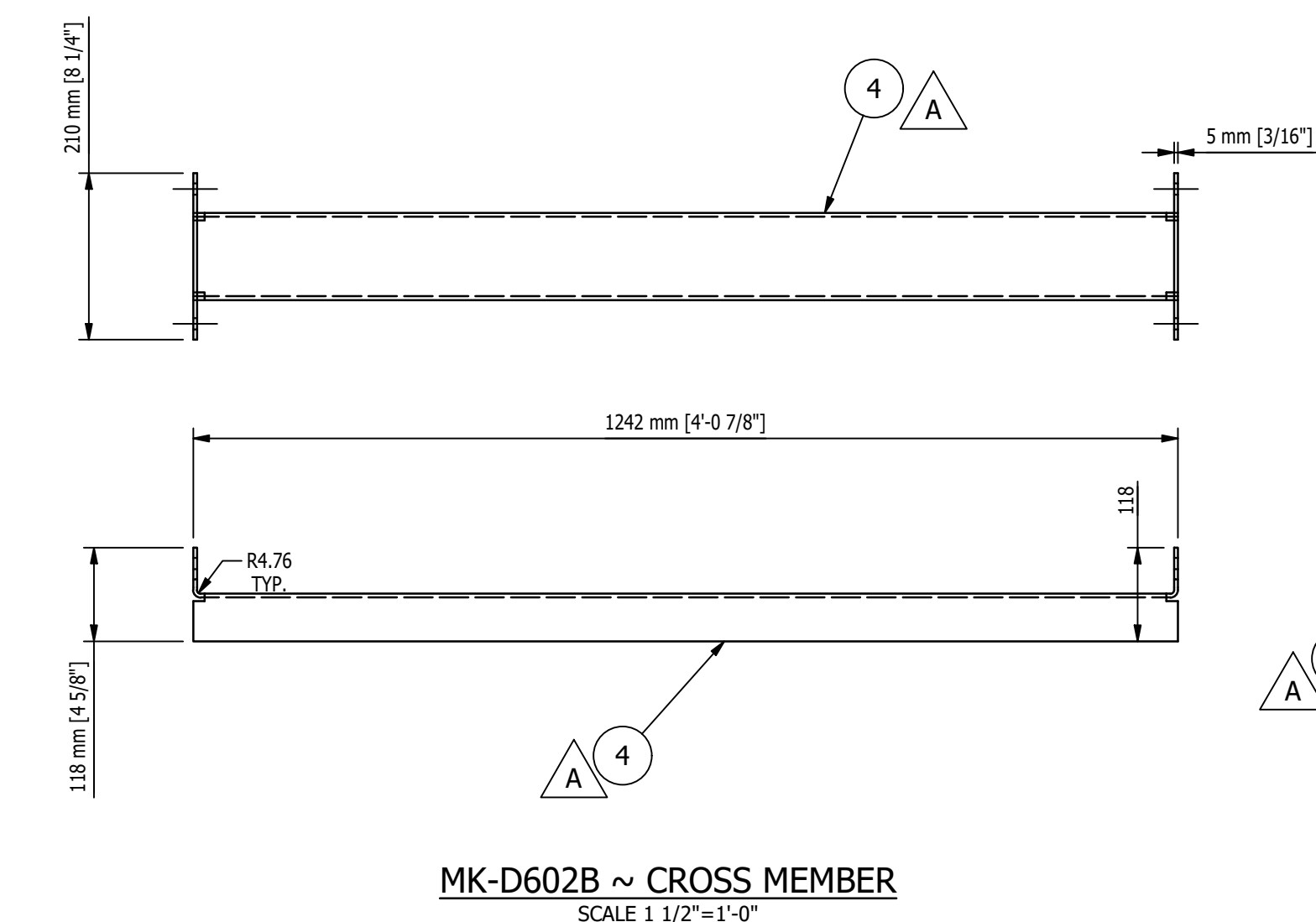
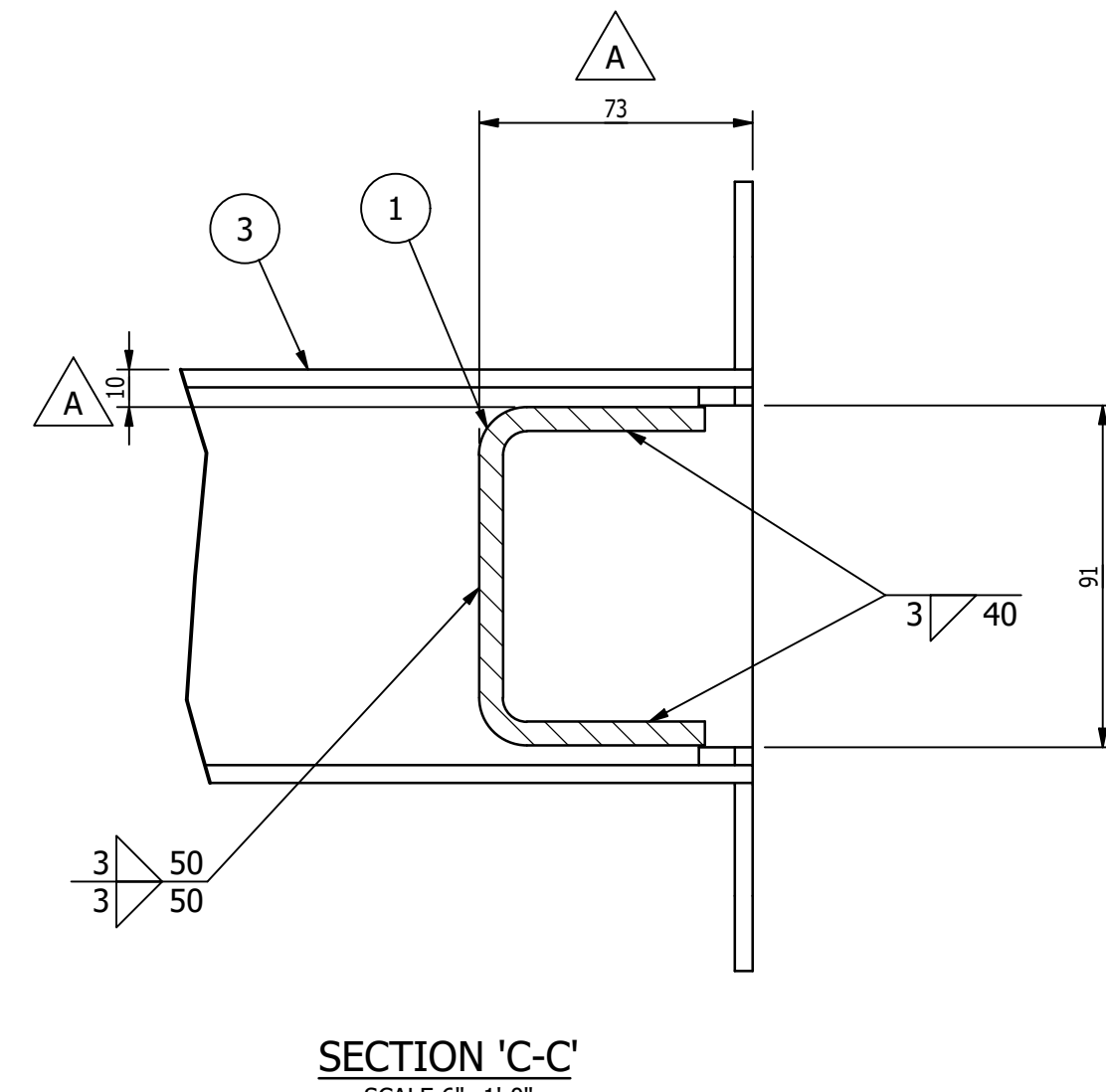
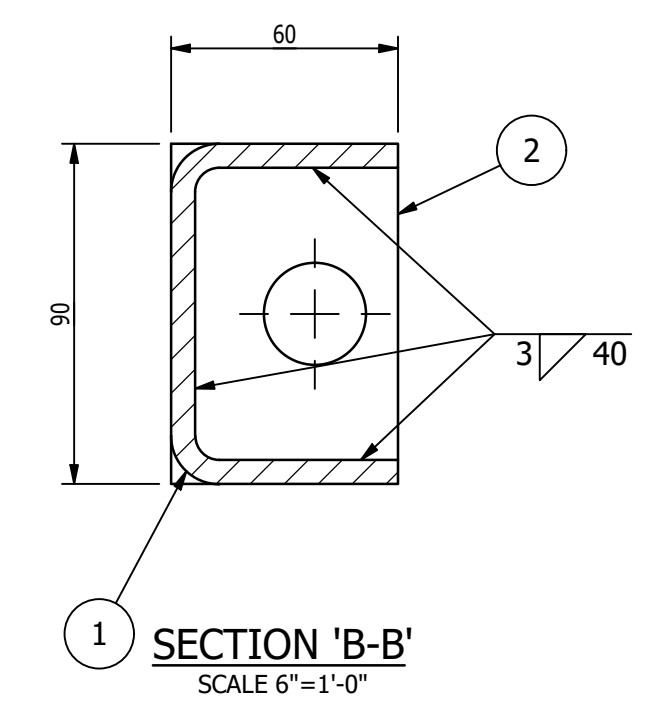
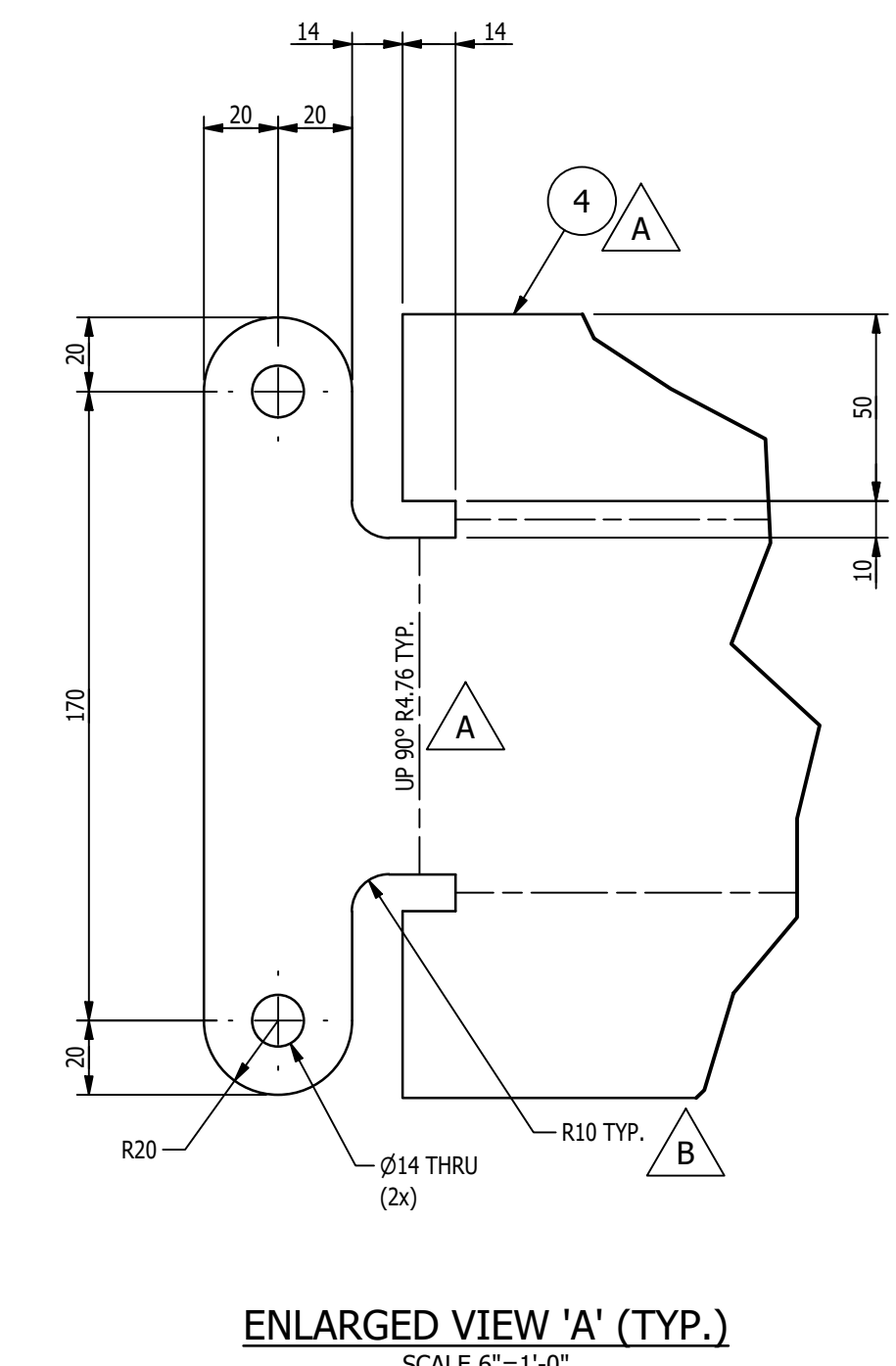
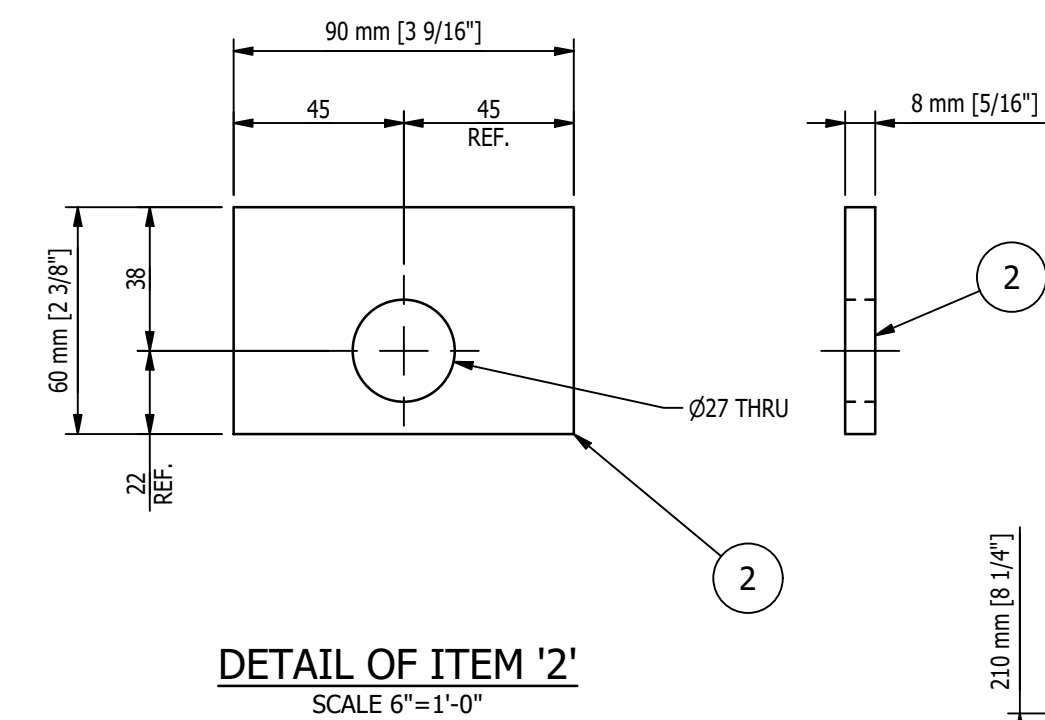
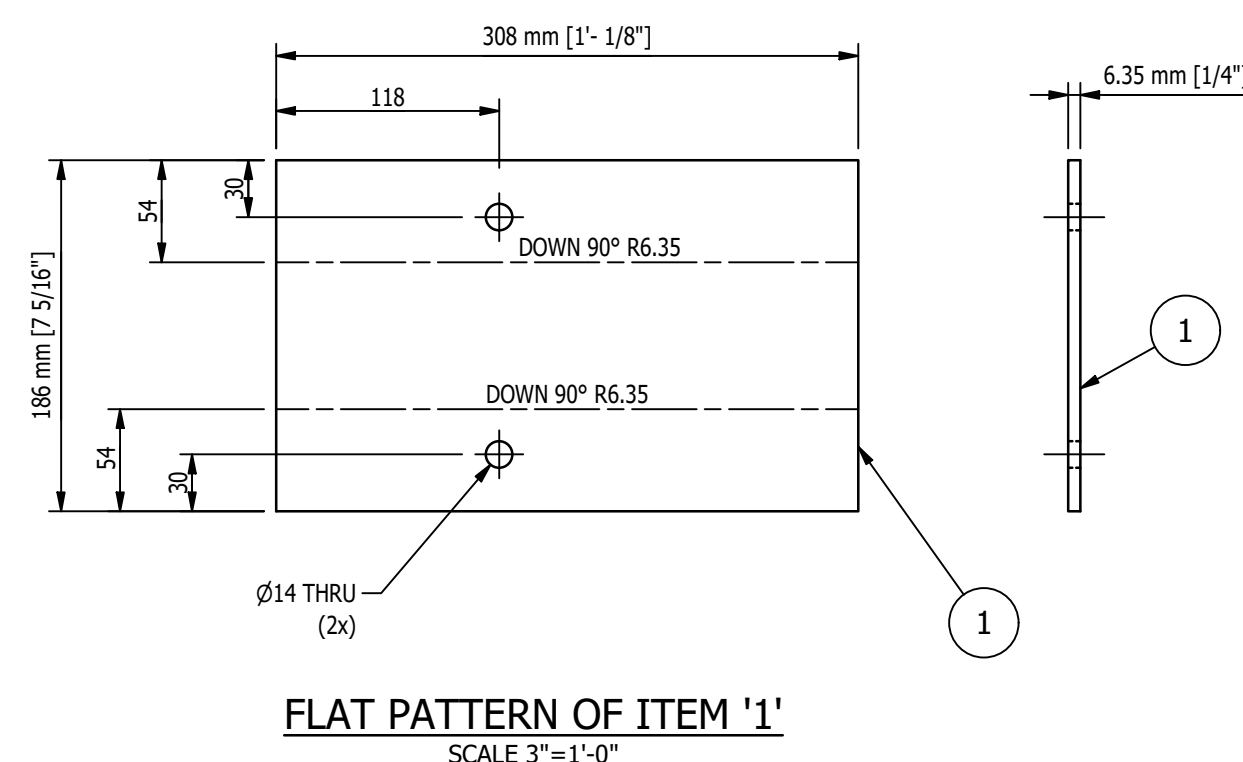
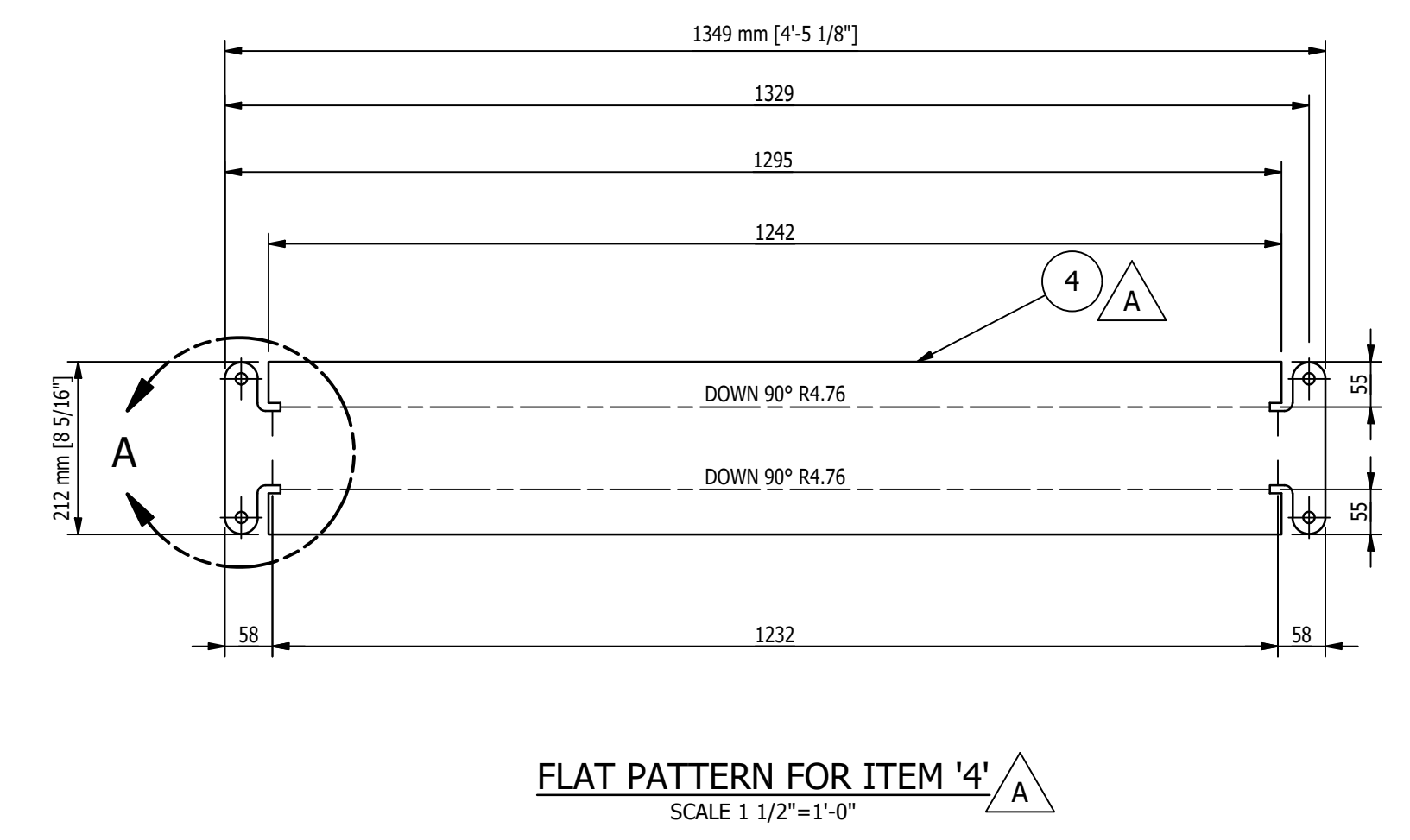
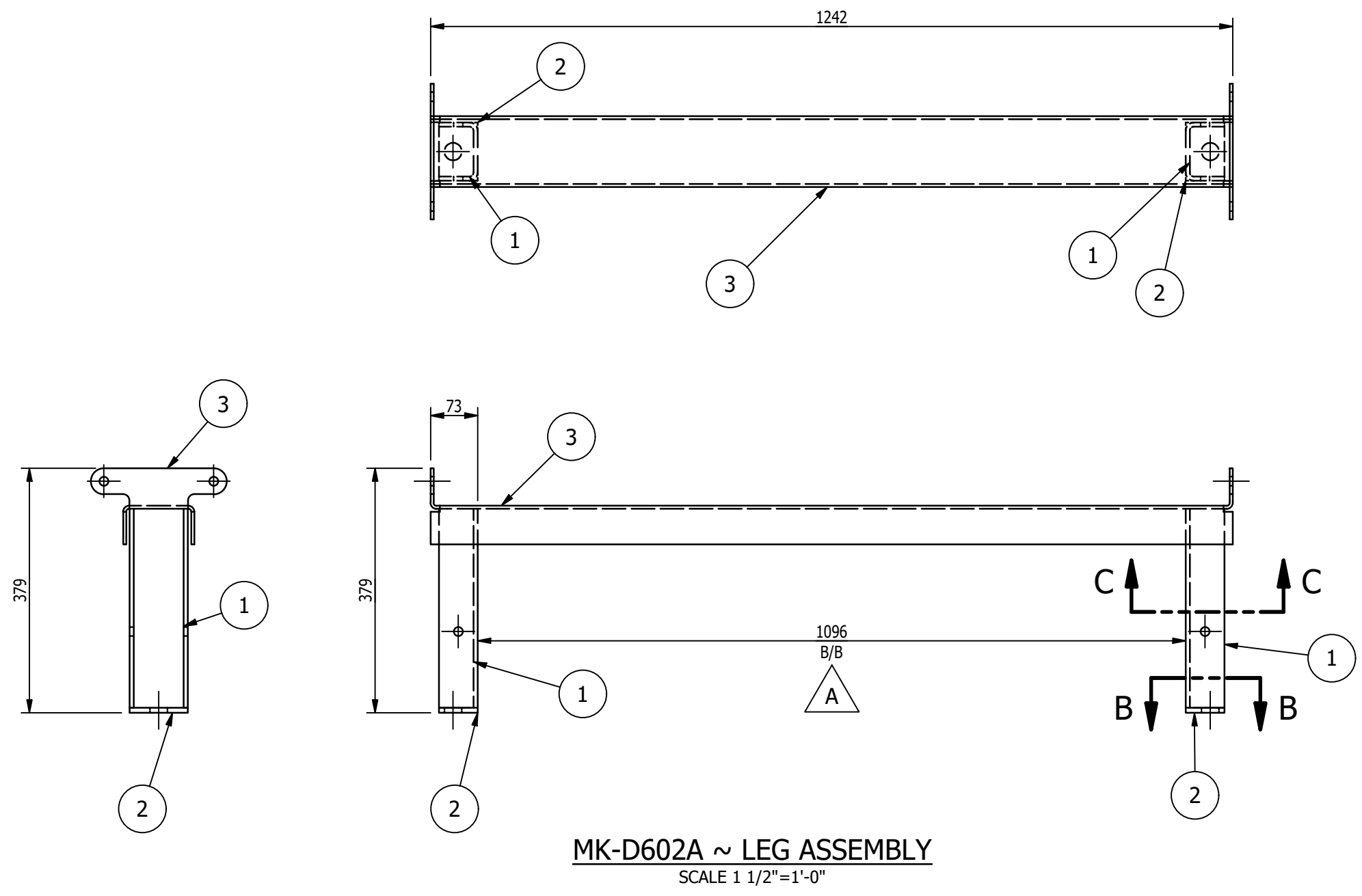
REV: D

JOB No: 22096

DRAWN BY: SGS
CHECKED BY: CW
DWG DATE: 6-21-2022

P6700-2022-06-21-10:59:00

BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D602A		
1	2	BAR 1/4 x 7 5/16	1'- 1/8"	
2	2	BAR 5/16 x 2 3/8	3 9/16"	
3	1	MK-D602B ~ CROSS MEMBER		
		MK-D602B		
4	1	BAR 3/16 x 8 5/16	4'-5 1/8"	



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

REV	BY	DATE	DESCRIPTION	APP
B	MC	8/4/2022	ADDED DIM	
A	MC	7/26/2022	CHANGED ITEM NUMBER OF MK-602B FROM '3' TO '4'; ADDED DIMENSIONS; CHANGED PAINT NOTE; REV ENLARGED VIEW 'A' TO TYP.	
0	MC	7/19/2022	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

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

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D602

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. 1875D602

REV: B

DRAWN BY: SGS

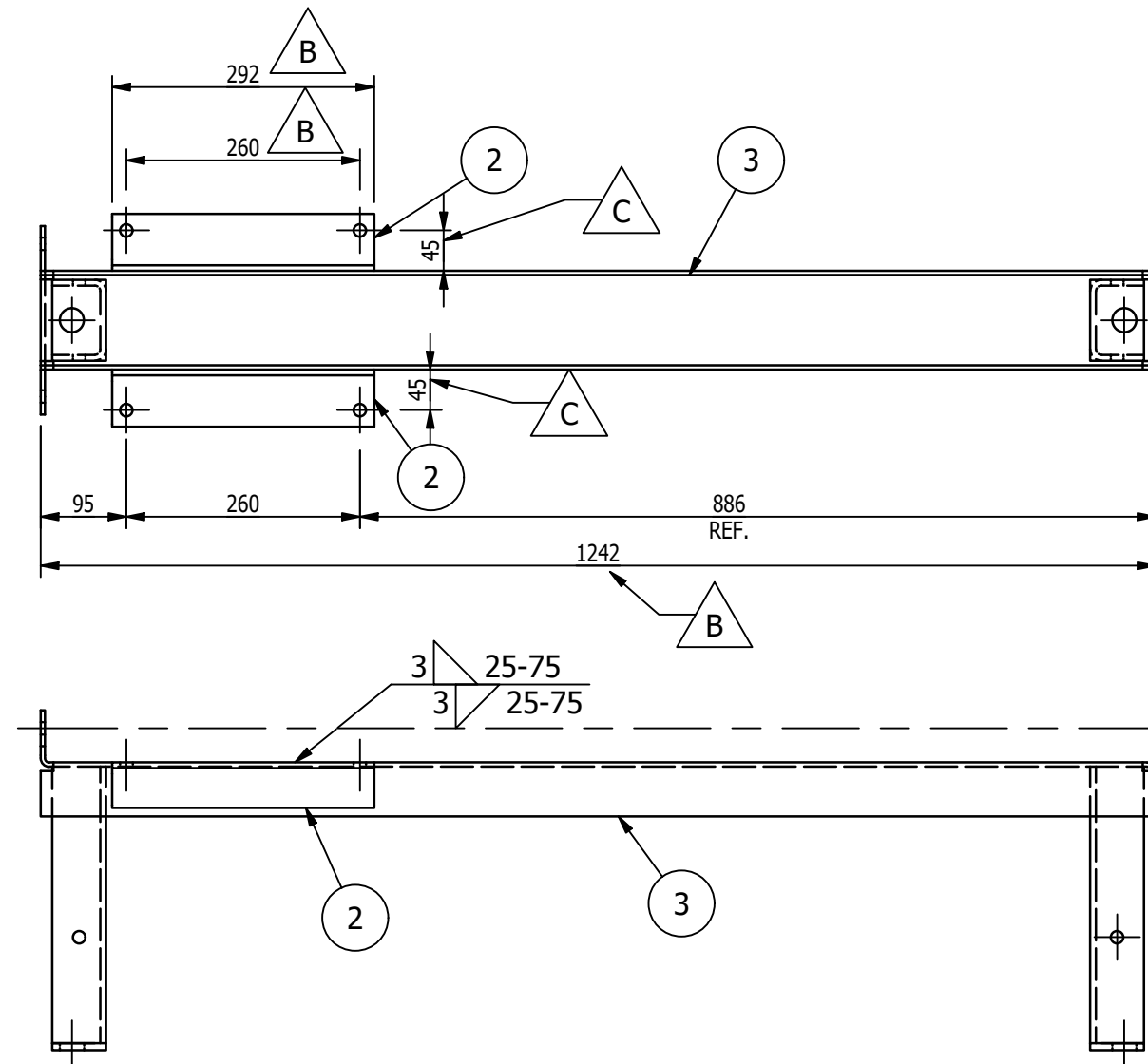
CHECKED BY: CW

DWG DATE: 6-21-2022

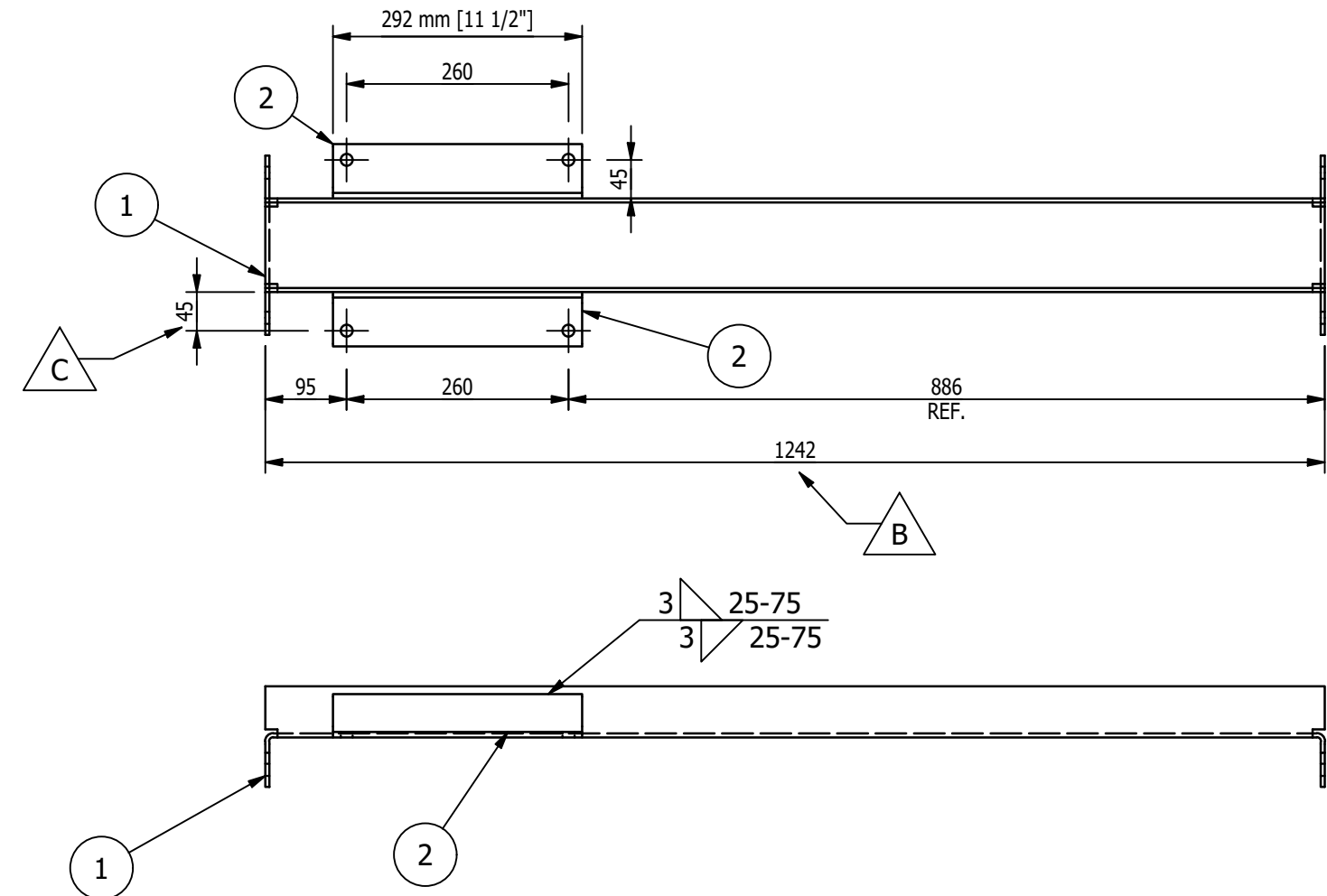
JOB No: 22096

3:00p 11/25/2022 New Job Drawings/Issued/22-08-14 6:00 Series P6B Rev03/13/2022 - REV B

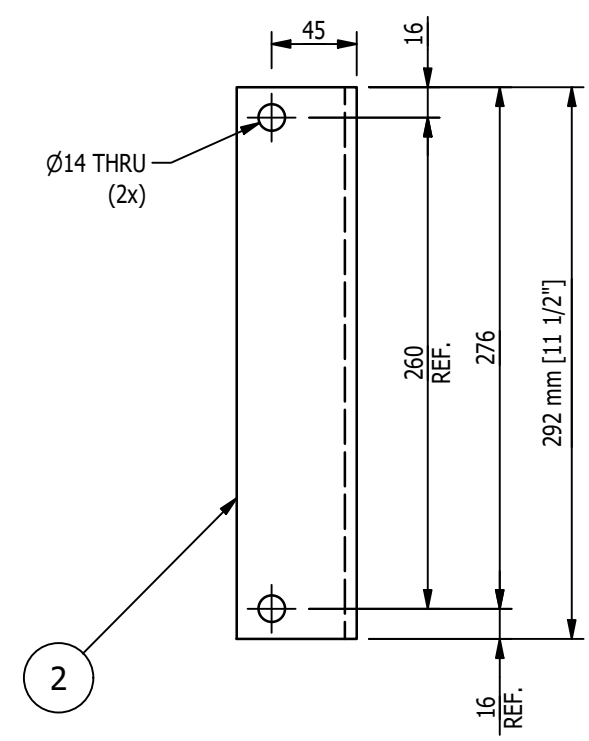
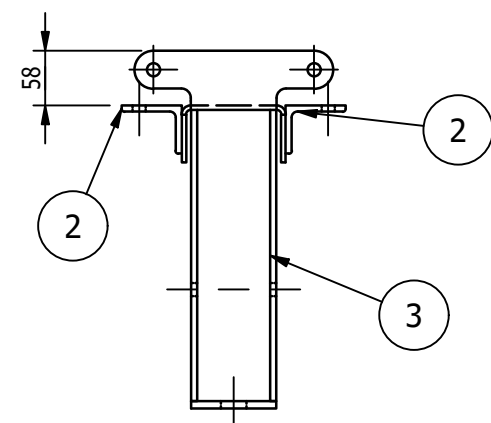
BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D603A		
1	1	MK-D602B ~ CROSS MEMBER		
2	2	L 2 1/2 x 2 x 1/4	11 1/2"	
		MK-D603B		
2	2	L 2 1/2 x 2 x 1/4	11 1/2"	
3	1	MK-D602A ~ LEG ASSEMBLY		



MK-D603B ~ CROSS MEMBER WITH GUARD SUPPORT & LOCATOR
SCALE 1 1/2"=1'-0"



MK-D603A ~ CROSS MEMBER WITH GUARD SUPPORT
SCALE 1 1/2"=1'-0"



DETAIL OF ITEM '2'
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.



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

41700 Dardickwood Rd.
Suite 125
North, MI 48135

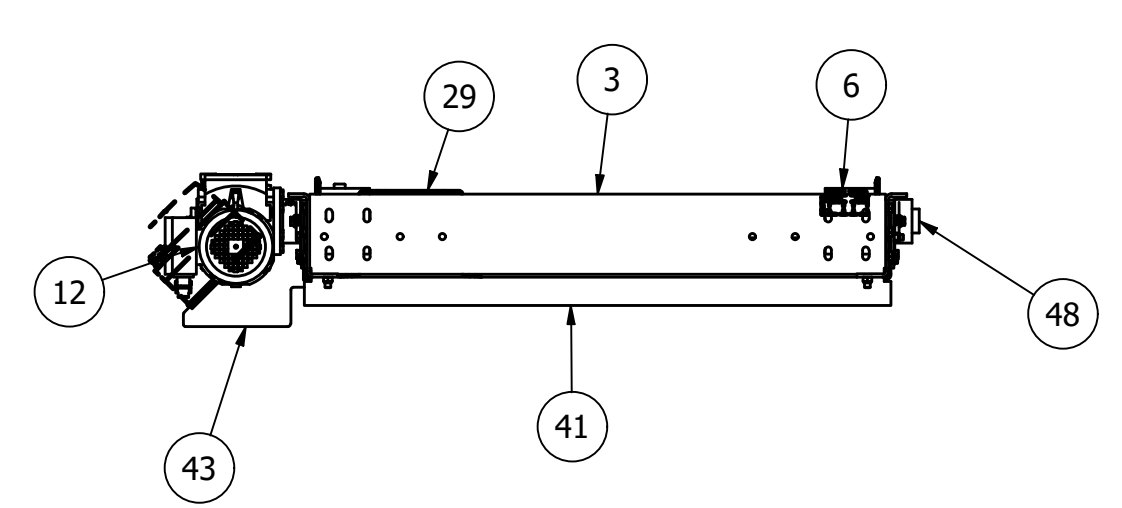
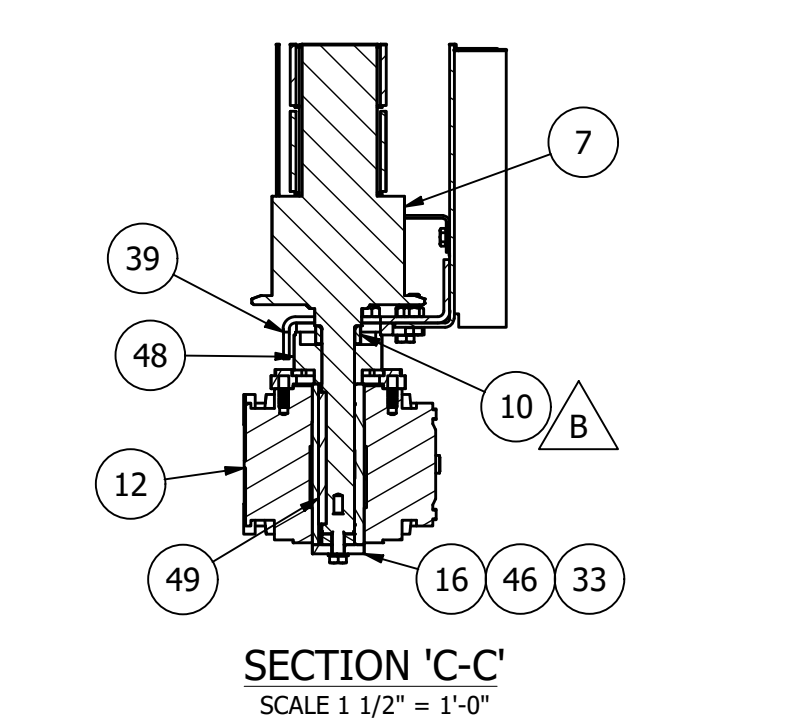
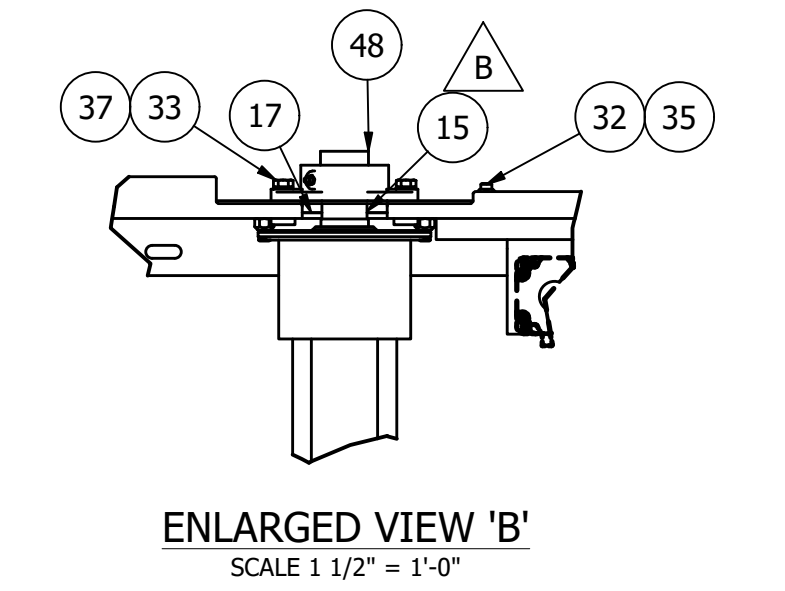
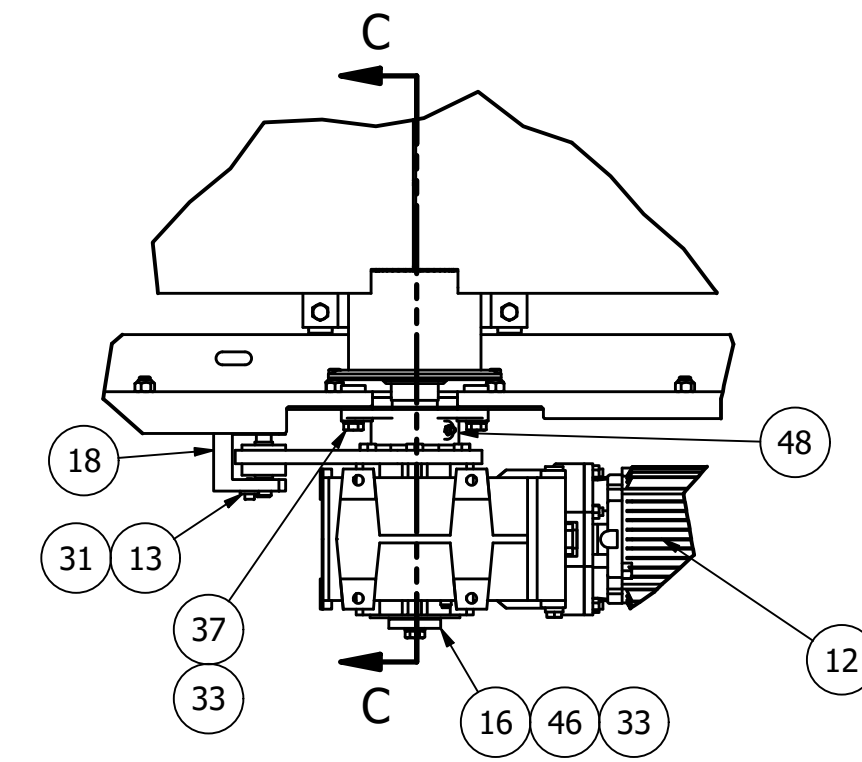
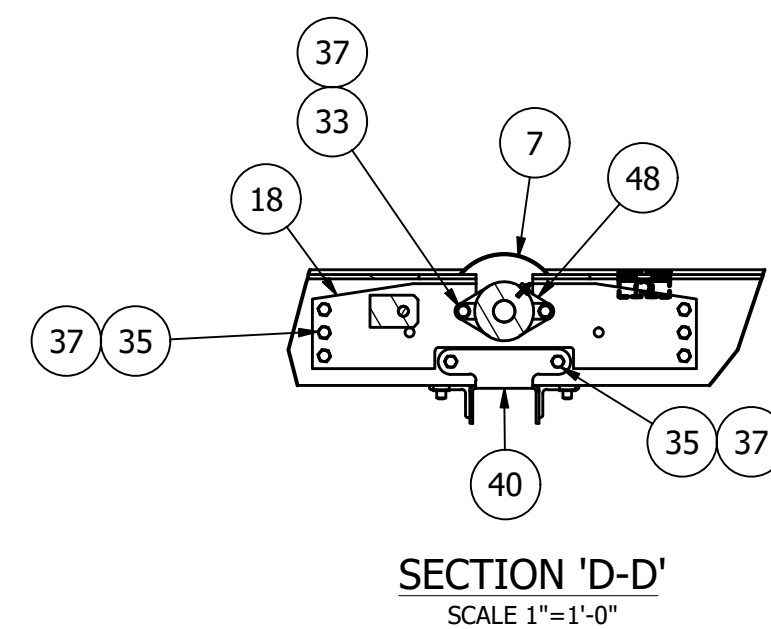
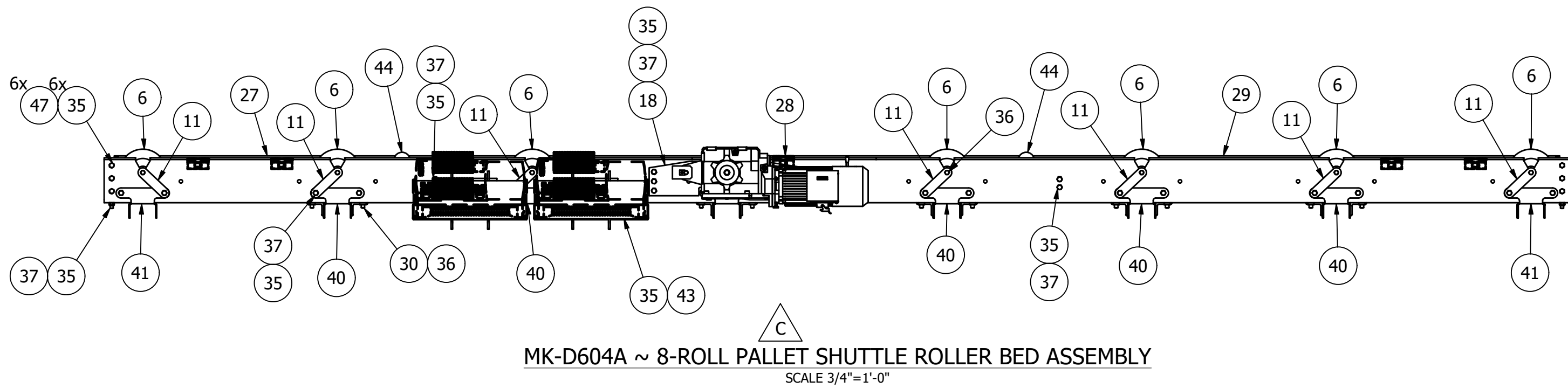
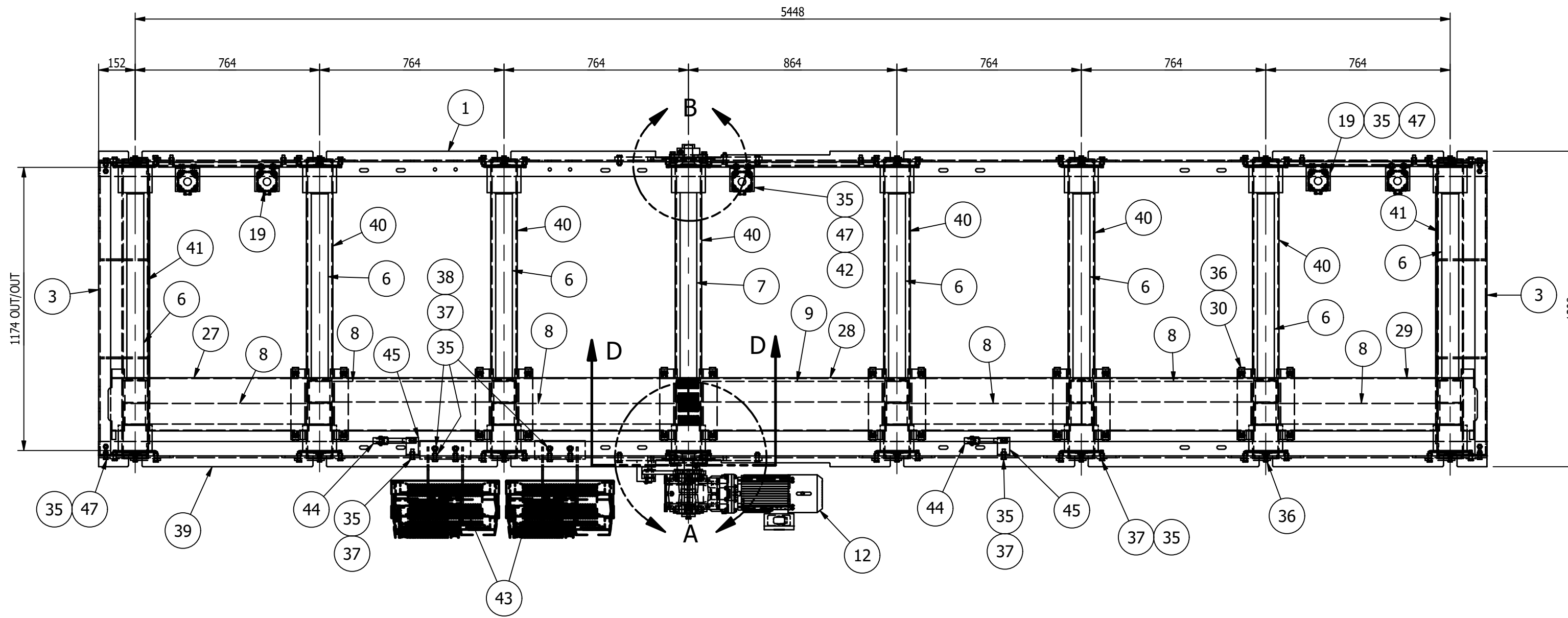
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.m4magnum.com

MAGNUM JOB #: 1885
MAGNUM DRAWING #: 1875D603 - REV C

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

REV	BY	DATE	DESCRIPTION	APP
C	MC	8/4/2022	ADDED DIM	
B	MC	7/26/2022	REVISED PAINT NOTES; ADDED DIMENSIONS	
A	MC	7/19/2022	FOR FABRICATION	

<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com</p>		<p>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</p>
<p>TITLE: P6700 CONVEYORS CAMPUS BUILDING</p>		<p>DRAWN BY: SGS</p>
<p>CLIENT: VOLVO</p>		<p>CHECKED BY: CW</p>
<p>DRAWING No. 1875D603</p>		<p>DWG DATE: 6-22-2022</p>
<p>REV: B</p>		<p>JOB No: 22096</p>



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
	1	MK-D604A			
1	1	MK-D609A ~ 8-ROLL SHUTTLE SIDE FRAME ASSY - RH			
3	2	MK-D601A ~ END PLATE ASSEMBLY			
6	7	PALLET DRIVEN ROLLER, DUGOMRULLI PART NO 329638V			
7	1	PALLET DRIVER ROLLER, DUGOMRULLI PART NO 332192V M12			
8	6	GATES POWERGRIP GT4 BELT, 1800-8M-GT85		2-3	
9	1	GATES POWERGRIP GT4 BELT, 2000-8M-GT85		2-2	
10	1	MK-D005D ~ SHAFT SPACER			
11	14	MK-D005B ~ ROLL KEEPER			
12	1	SIEMENS RB2 GERMOTOR (SEE MOTOR DATA LIST)		1-2	
13	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
15	1	MK-D005E ~ SHAFT SPACER			
16	1	MK-D005F ~ MOTOR END PLATE			
17	1	MK-D005C ~ BEARING PLATE			
18	1	MK-D005A ~ BEARING PLATE			
19	2	MK-D009D ~ PROX BRACKET			
27	1	MK-D010A ~ BELT GUARD			
28	1	MK-D010B ~ BELT GUARD			
29	1	MK-D010C ~ BELT GUARD			
30	24	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
31	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
32	1	M12x1.75 x 40mm LG. HEX CAP SCREW			
33	5	M12 SPRING LOCK WASHER			
35	77	M12 x 1.75 STOVER LOCK NUT			
36	38	M10x1.5 x 25mm LG. HEX CAP SCREW			
37	63	M12x1.75 x 35mm LG. HEX CAP SCREW			
38	8	M12 NARROW FLAT WASHER			
39	1	MK-D609B ~ 8-ROLL SHUTTLE SIDE FRAME ASSY - LH			
40	6	MK-D603A ~ CROSS MEMBER WITH GUARD SUPPORT			
41	2	MK-D602B ~ CROSS MEMBER			
42	1	MK-D009C ~ PROX BRACKET			
43	2	MK-D047A ~ CONTROLLER BRACKET			
44	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
45	2	MK-D005G ~ STATIC WHEEL BRACKET			
46	1	M12x1.75 x 45mm LG. HEX CAP SCREW			
47	17	M12x1.75 x 30mm LG. HEX CAP SCREW			
48	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
49	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	

- 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.

SPEED FORMULA (60HZ):

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

MAGNUM CONSULTING
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Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D604

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

GENERAL NOTES:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	DESCRIPTION OF MK-D604A UPDATED	
B	MC	8/30/22	ADDED BALLOONS FOR ITEMS '10' & '15'	
A	MC	8/9/22	FOR APPROVAL	

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. 1875D604

REV: C

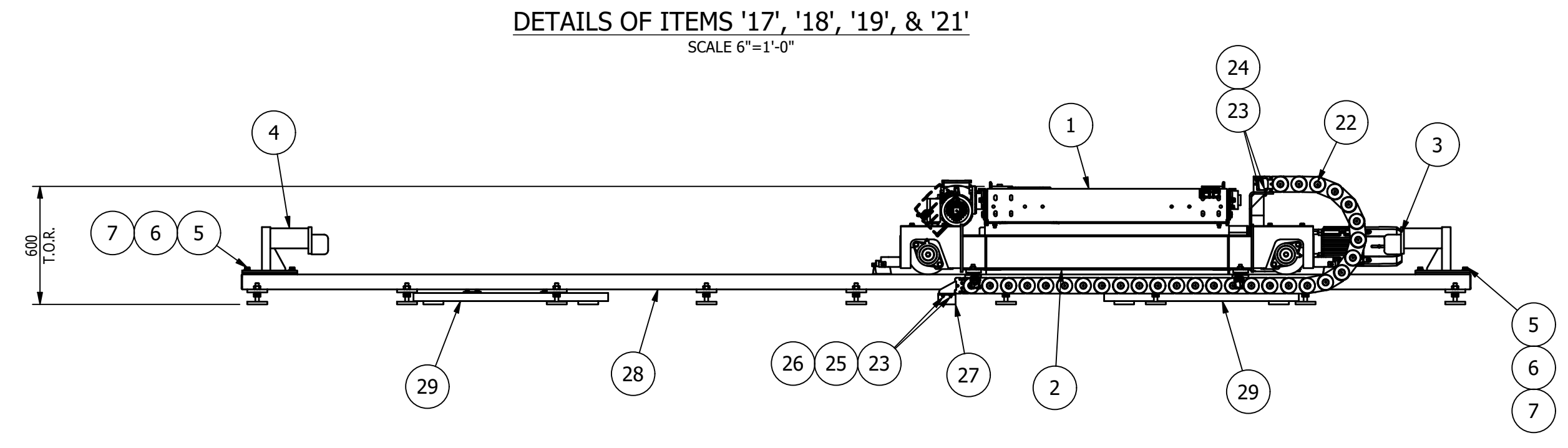
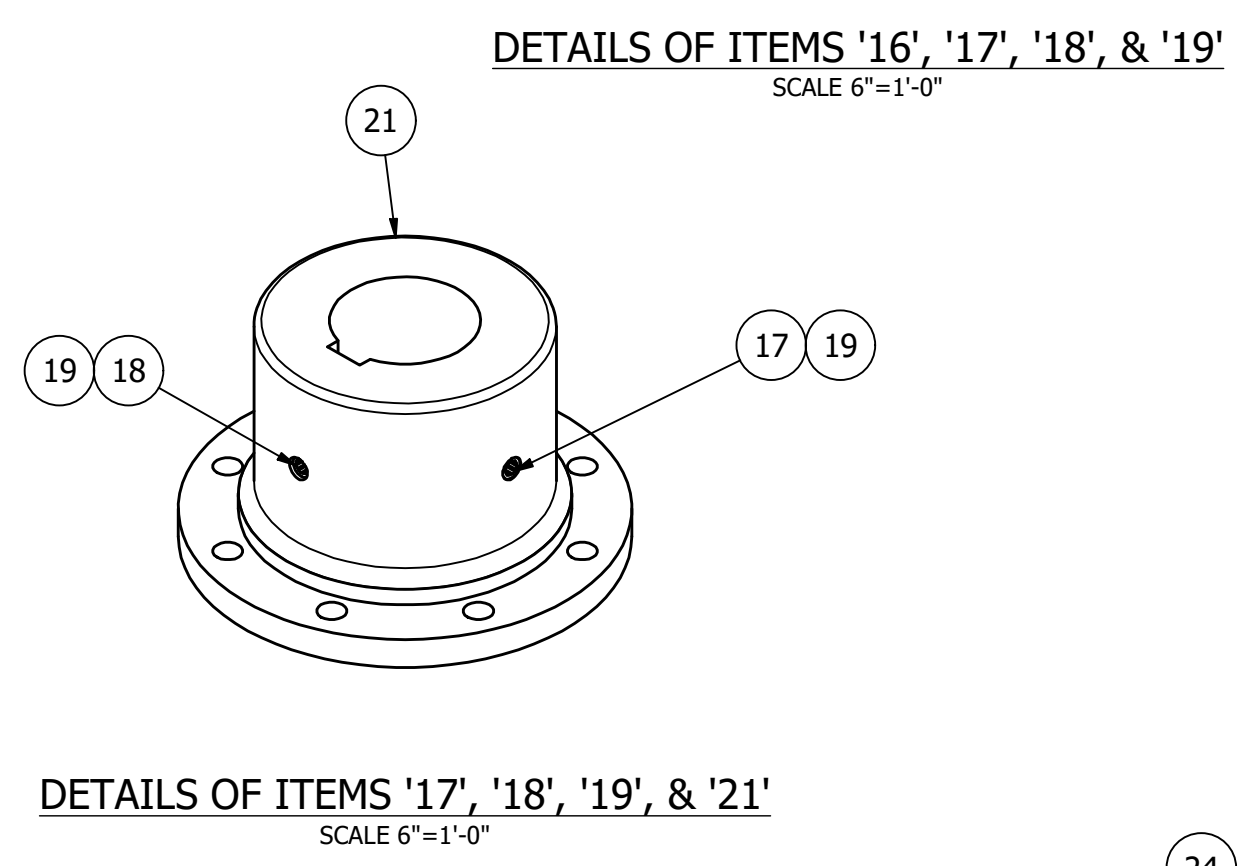
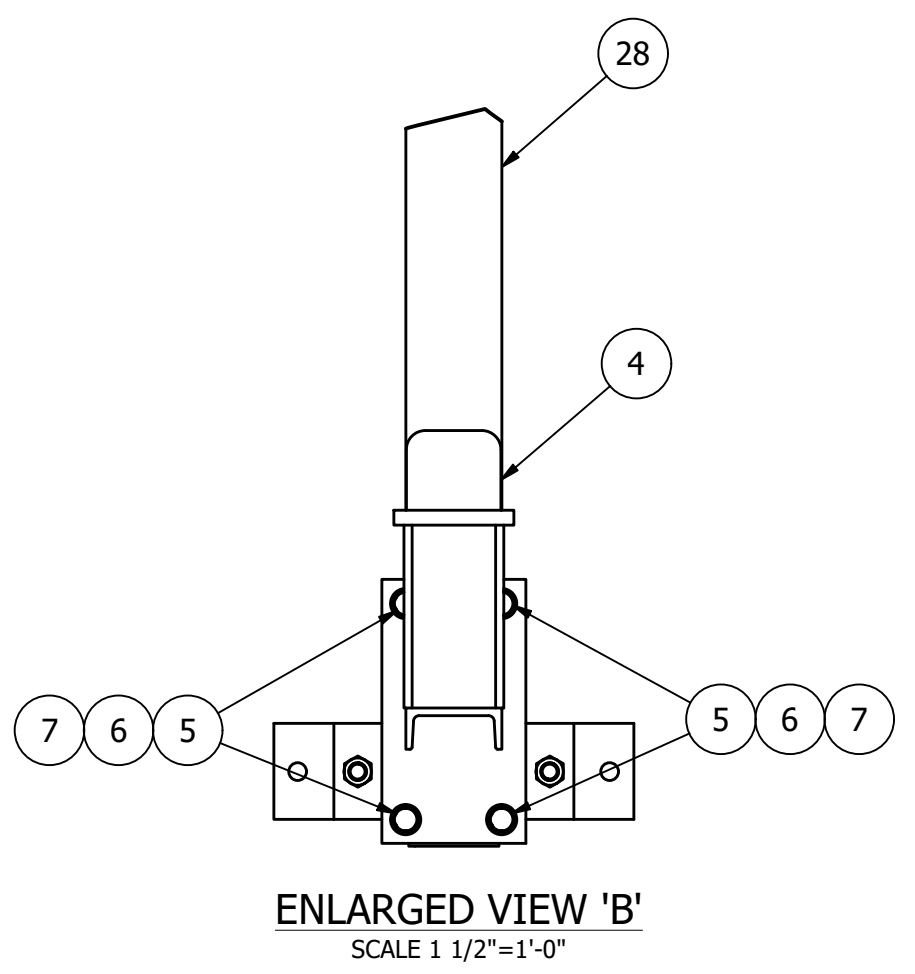
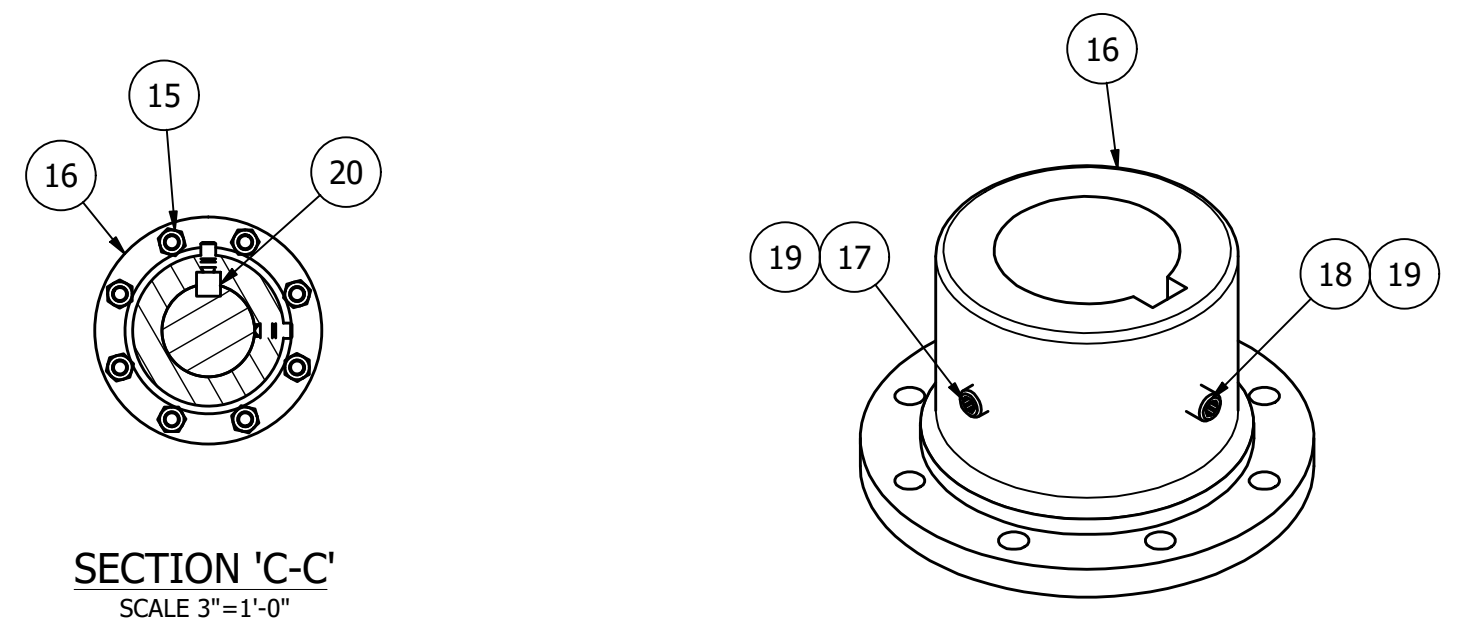
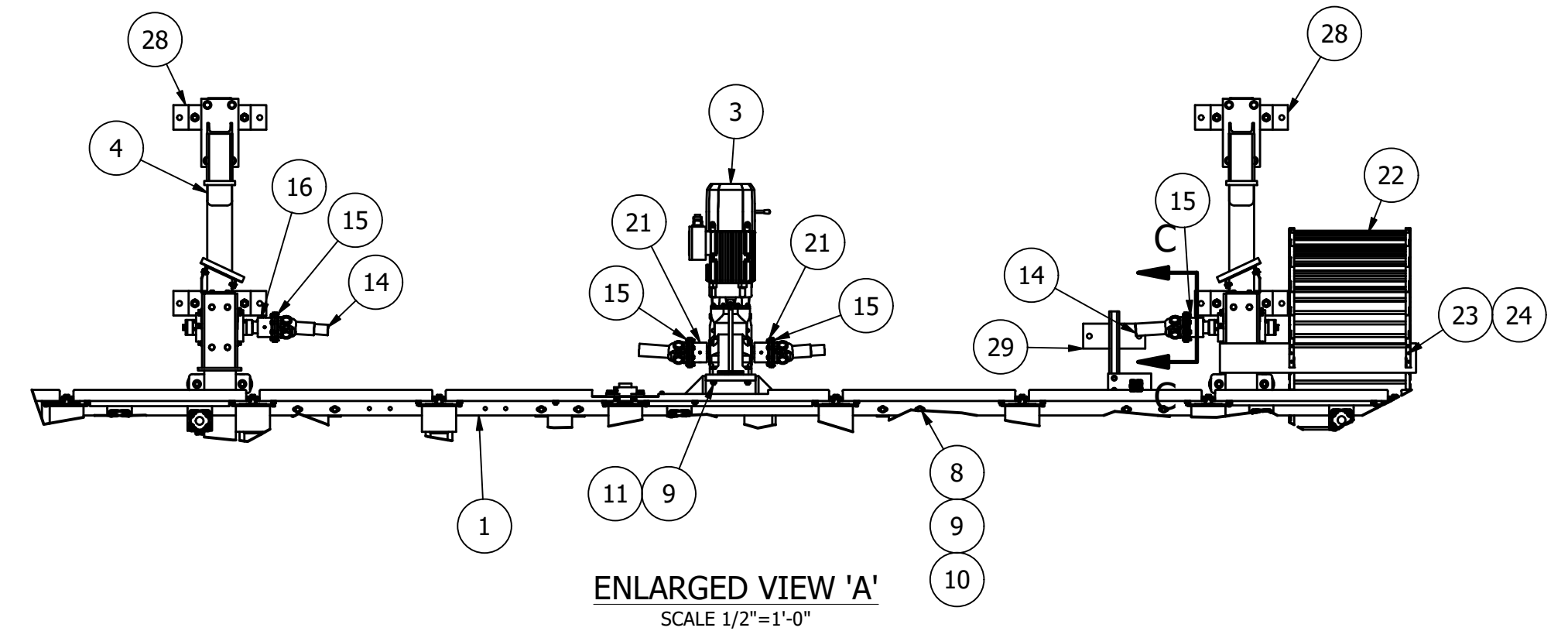
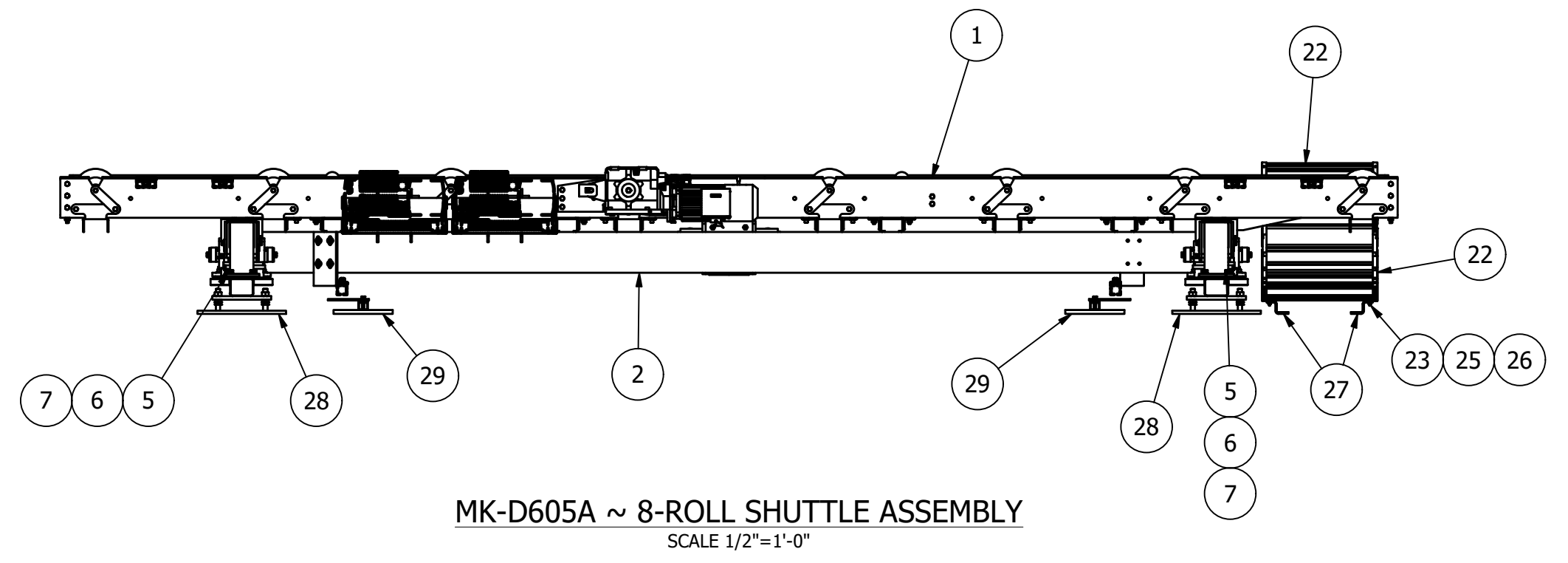
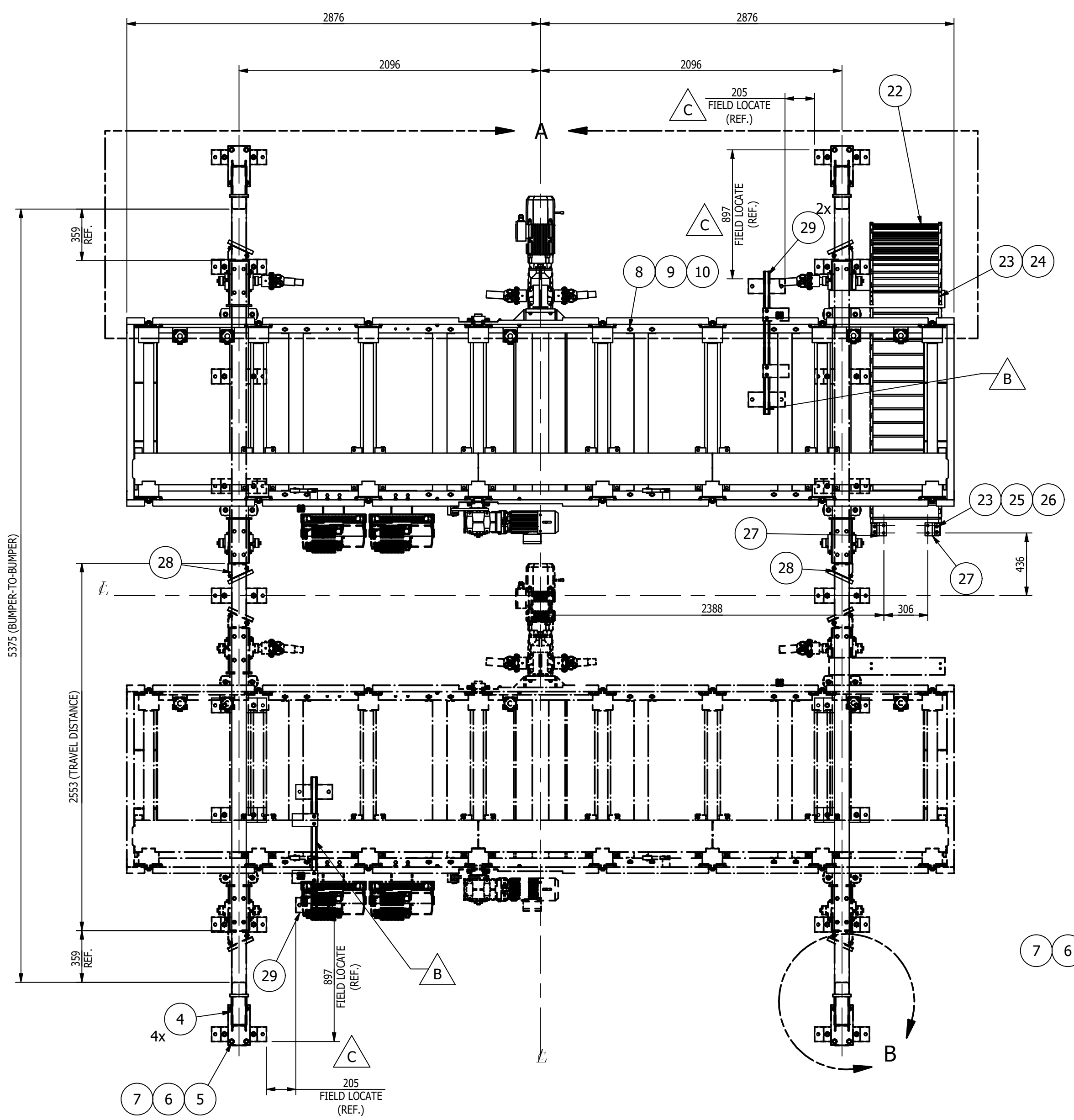
JOB No. 22096

DRAWN BY: RJB

CHECKED BY: CW

DWG DATE: 7/1/22

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BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D605A			
1	1	MK-D604A ~ 8-ROLL PALLET SHUTTLE ROLLER BED ASSEMBLY			
2	1	MK-D608A ~ SHUTTLE BASE FRAME ASSEMBLY			
3	1	SH1 GEARMOTER PER MOTOR DATA SHEET		1-3	
4	4	MK-D044A ~ SHUTTLE BUMPER			
5	16	5/8-11UNC x 1" LG. HEX HEAD CAP SCREW			
6	16	5/8 SPRING LOCK WASHER			
7	16	5/8 TYPE B NARROW FLAT WASHER			
8	32	M12 NARROW FLAT WASHER			
9	20	M12 x 1.75 STOVER LOCK NUT			
10	16	M12x1.75 x 35mm LG. HEX CAP SCREW			
11	4	M12x1.75 x 65mm LG. HEX CAP SCREW			
14	2	ELBE UJOINT TUBE TYPE STD EXT N=36, S=1682, X=40, FL=120 8X8MM CNT, PART NO. 0.110.101.6148		15-2	
15	32	M8x1.25x26MM, ELBE BOLT KIT (16 EA), 120 8X8 FLANGE, PART NO. 0.112.192.001		15-3	
16	2	ELBE, 120 8X8 SLF COMPANION FLANGE, BORE 1.937", KEYWAY 0.50 OAL=3", (2) M8 SET SCREWS, PART NO. 1.112.240.6031		15-8	
17	4	ELBE CONE POINT M8x1.25x10MM #90194, PART NO. 1.000.925.6011		15-5	
18	4	ELBE CUP POINT M8x1.25x5MM			
19	8	ELBE OVAL POINT M8x1.25x10MM		15-6	
20	2	1/2 x 1/2 x 3 LG. SQ. KEYSTOCK			
21	2	ELBE, 120 8X8 SLF COMPANION FLANGE, BORE 40H7, KEYWAY 12P9 2SS M8, (2) M8 SET SCREWS, PART NO. 1.112.240.6001		15-7	
22	1	3119 mm TRAVEL KABELSCHLEPP Katrak, MK-MC0950-18.00"-RMS-260 X 28 LINKS + FAA-MU		18-4	
23	8	M6 x 1 STOVER LOCK NUT			
24	4	M6x1 x 30mm LG. HEX SOCKET HEAD CAP SCREW			
25	8	M6 REGULAR FLAT WASHER			
26	4	M6x1 x 25mm LG. HEX CAP SCREW			
27	2	MK-D054A ~ CATRACK SUPPORT BRACKET			
28	2	MK-D606A ~ SHUTTLE TRACK			
29	2	MK-D057A ~ SHUTTLE PROX TARGET			
		TOTAL WEIGHT ~ 4450.1 LBS			

SHOP NOTES:

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

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

SPEED FORMULA SHUTTLE (60HZ):

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

SPEED FORMULA ROLL BED (60HZ):

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

SHEET 1 OF 2

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	UPDATED DIMENSIONS	
B	MC	8/31/22	ADDED ITEM '29', ADDED SHEET 2 & MK-D605B. UPDATED GEOMETRY PER ITEM '28'	
A	MC	8/9/22	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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 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millc.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D605	DWG DATE:	7/1/22
REV:	C	JOB No.:	22096

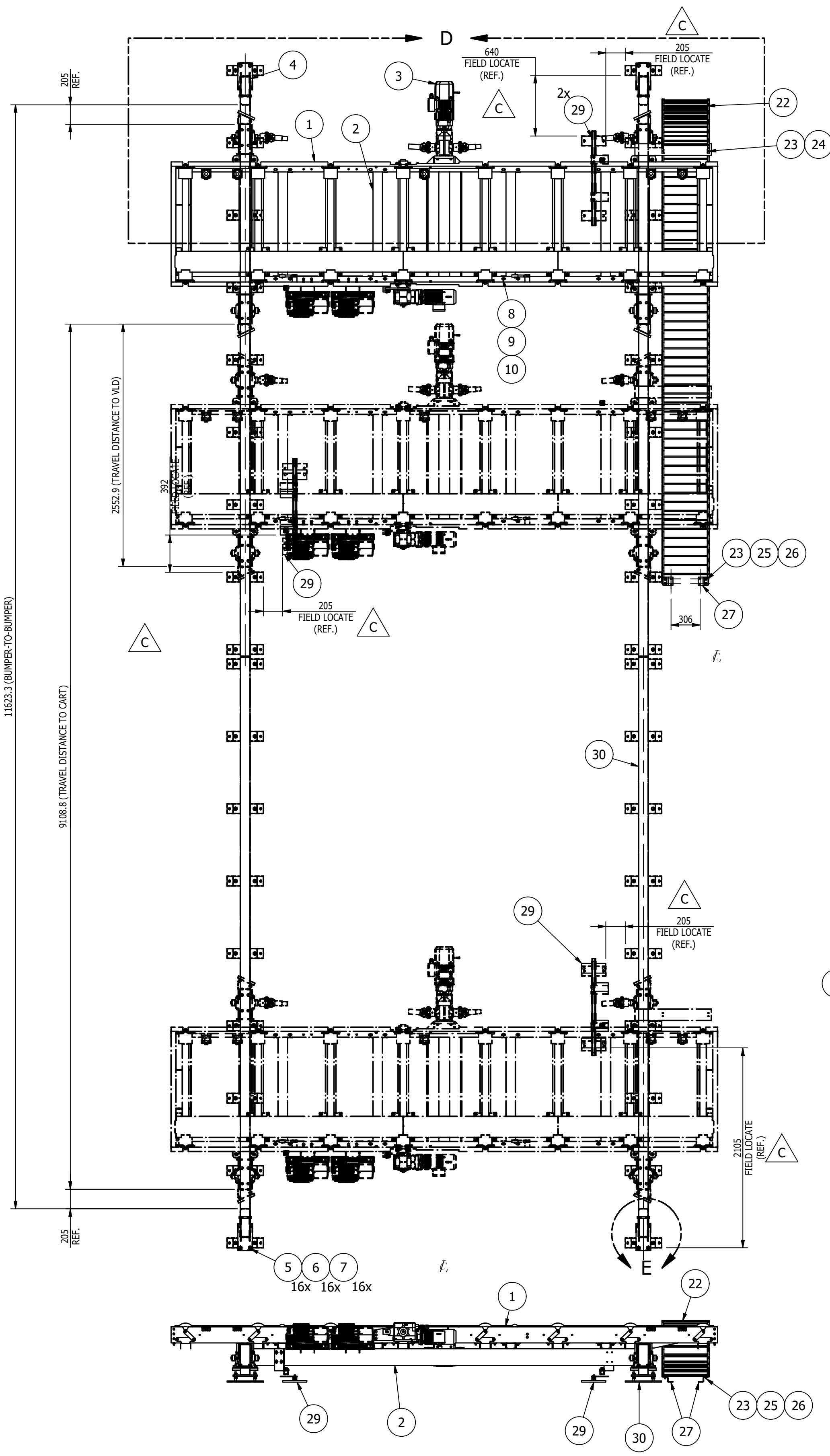
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 41100 QuakerRoad Rd.
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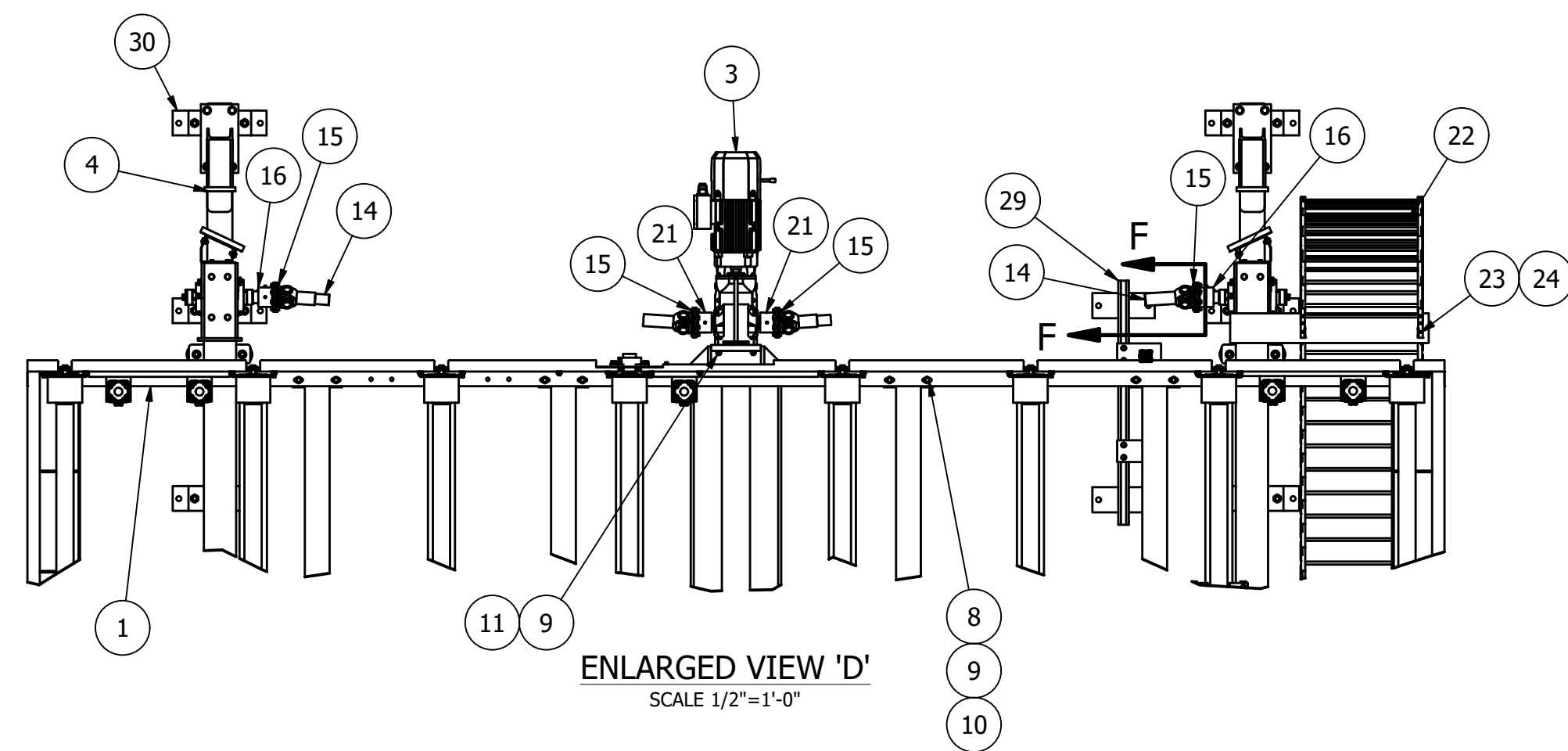
MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D605

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

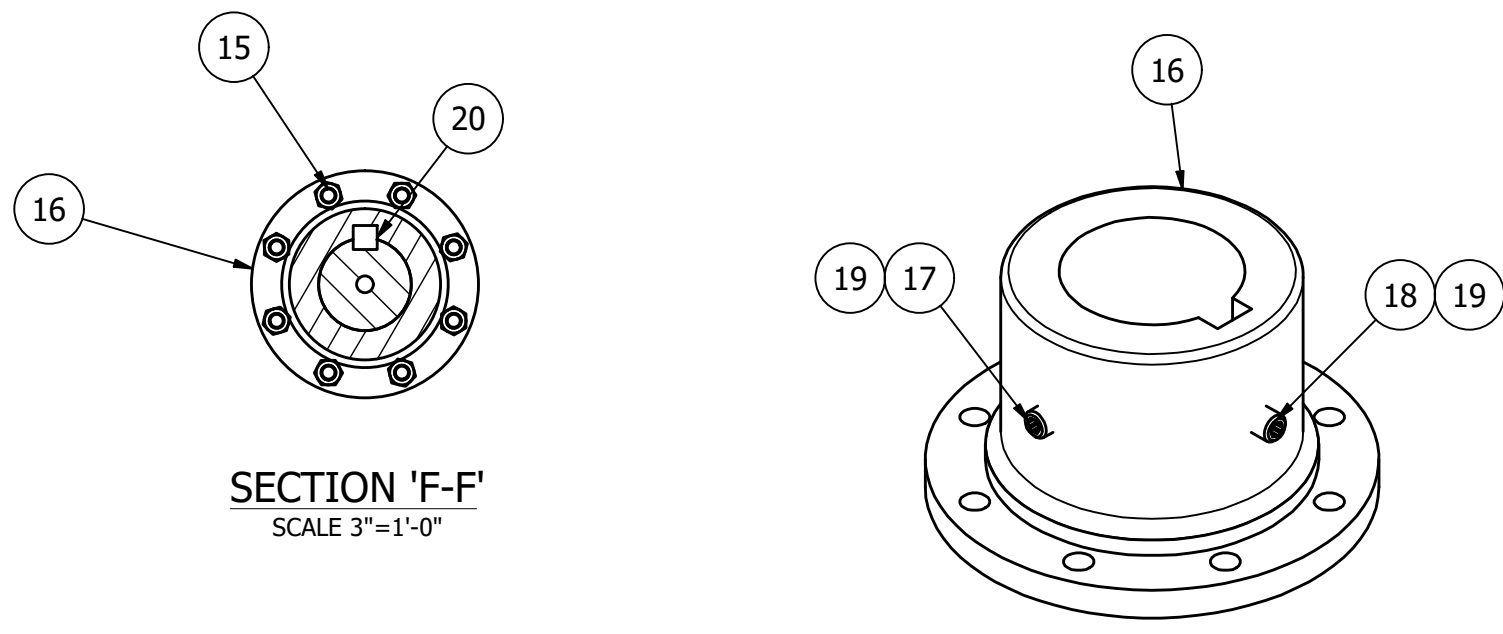
REVISION HISTORY



MK-D605B ~ 8-ROLL SHUTTLE ASSEMBLY
SCALE 3/8"=1'-0"

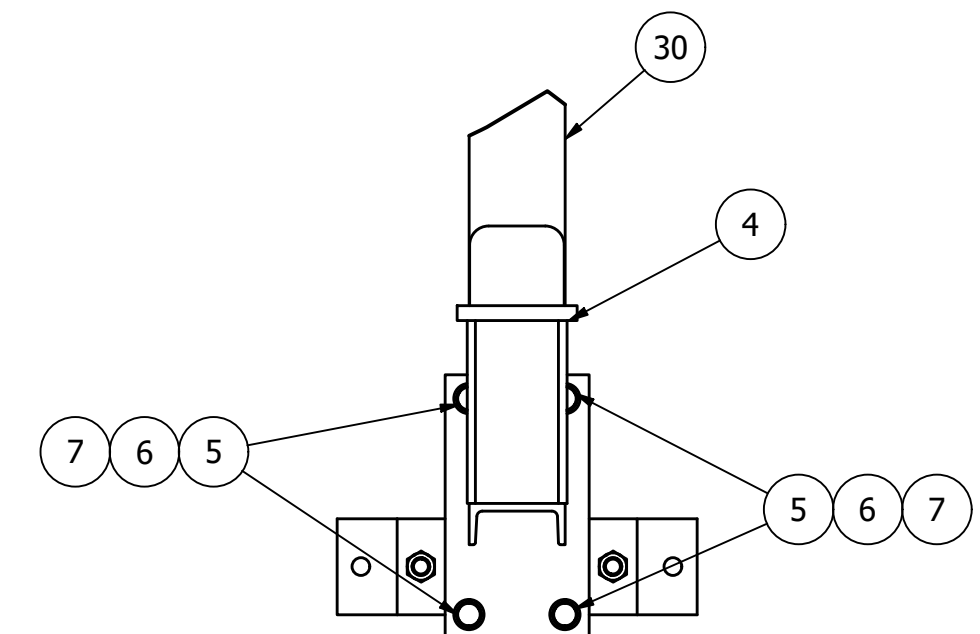


ENLARGED VIEW 'D'
SCALE 1/2"=1'-0"

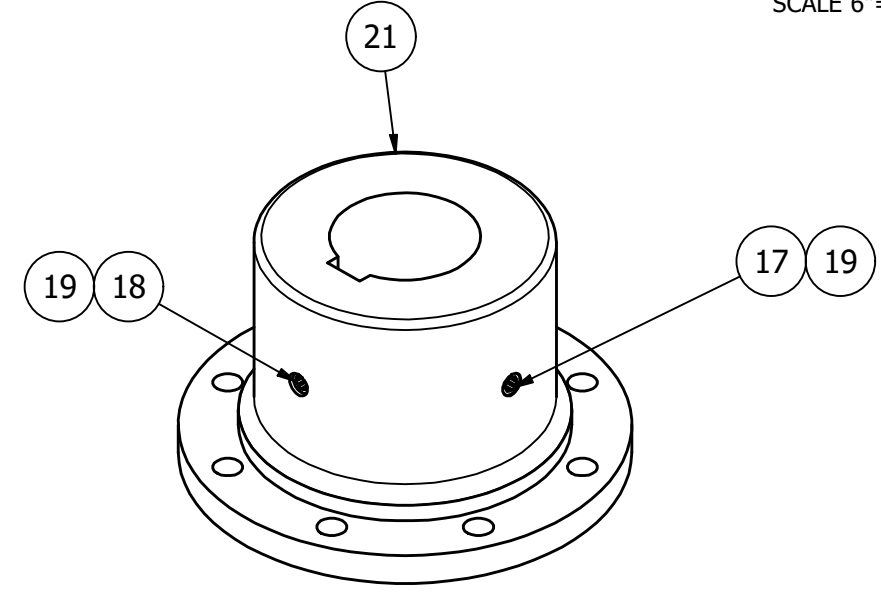


SECTION 'F-F'
SCALE 3"=1'-0"

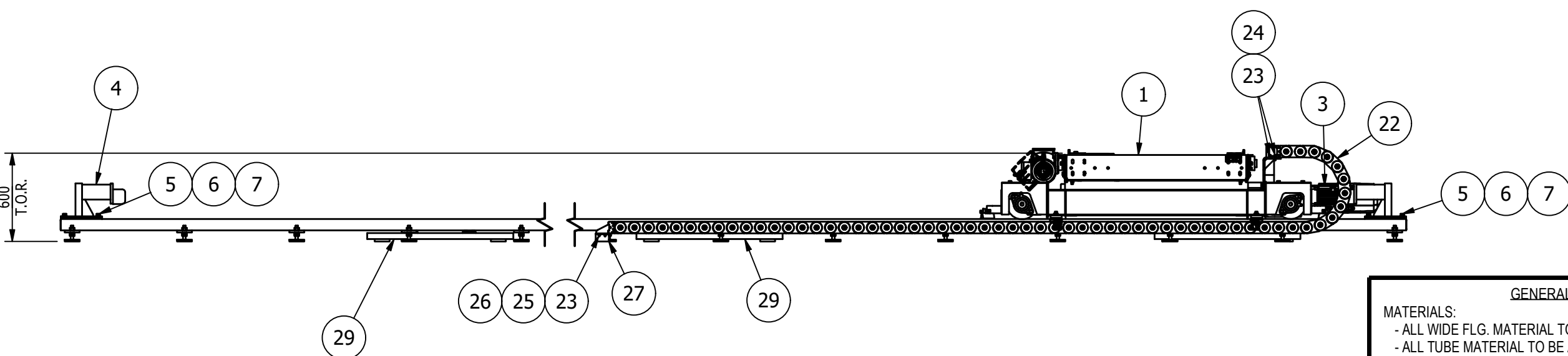
DETAILS OF ITEMS '16', '17', '18', & '19'
SCALE 6"=1'-0"



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



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



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D605B			
1	1	MK-D604A ~ 8-ROLL PALLET SHUTTLE ROLLER BED ASSEMBLY			
2	1	MK-D608A ~ SHUTTLE BASE FRAME ASSEMBLY			
3	1	SH1 GEARMOTER PER MOTOR DATA SHEET		1-3	
4	4	MK-D044A ~ SHUTTLE BUMPER			
5	16	5/8-11UNC x 1" LG. HEX HEAD CAP SCREW			
6	16	5/8 SPRING LOCK WASHER			
7	16	5/8 TYPE B NARROW FLAT WASHER			
8	32	M12 NARROW FLAT WASHER			
9	20	M12 x 1.75 STOVER LOCK NUT			
10	16	M12x1.75 x 35mm LG. HEX CAP SCREW			
11	4	M12x1.75 x 65mm LG. HEX CAP SCREW			
14	2	ELBE UJOINT TUBE TYPE STD EXT N=36, S=1682, X=40, FL=120 8X8MM CNT, PART NO. 0.110.101.6148		15-2	
15	32	M8x1.25x26MM, ELBE BOLT KIT (16 EA), 120 8X8 FLANGE, PART NO. 0.112.192.001		15-3	
16	2	ELBE, 120 8X8 SLF COMPANION FLANGE, BORE 1.937", KEYWAY 0.50 OAL=3", (2) M8 SET SCREWS, PART NO. 1.112.240.6031		15-8	
17	4	ELBE CONE POINT M8x1.25x10MM #90194, PART NO. 1.000.925.6011		15-5	
18	4	ELBE CUP POINT M8x1.25x5MM			
19	8	ELBE OVAL POINT M8x1.25x10MM		15-6	
20	2	1/2 x 1/2 x 3 LG. SQ. KEYSTOCK			
21	2	ELBE, 120 8X8 SLF COMPANION FLANGE, BORE 40H7, KEYWAY 12P9 2SS M8, (2) M8 SET SCREWS, PART NO. 1.112.240.6001		15-7	
22	1	9110 mm TRAVEL KABELSCHLEPP Katrak, MK-MC0950-18.00"-RMS-260 X 60 LINKS + FAA-MU		21-1	
23	8	M6 x 1 STOVER LOCK NUT			
24	4	M6x1 x 30mm LG. HEX SOCKET HEAD CAP SCREW			
25	8	M6 REGULAR FLAT WASHER			
26	4	M6x1 x 25mm LG. HEX CAP SCREW			
27	2	MK-D054A ~ CATRACK SUPPORT BRACKET			
29	3	MK-D057A ~ SHUTTLE PROX TARGET			
30	2	MK-D616A ~ SHUTTLE TRACK			

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

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

SPEED FORMULA SHUTTLE (60HZ):

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

SPEED FORMULA ROLL BED (60HZ):

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

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	UPDATED DIMENSIONS	
B	MC	8/31/22	ADDED ITEM '29', ADDED SHEET 2 & MK-D605B. UPDATED GEOMETRY PER ITEM '28'	
A	MC	8/9/22	FOR FABRICATION	

<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com</p>		<p>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</p>
<p>TITLE: P6700 CONVEYORS CAMPUS BUILDING</p>		<p>DRAWN BY: RJB</p>
<p>CLIENT: VOLVO</p>		<p>CHECKED BY: CW</p>
<p>DRAWING No. 1875D605</p>		<p>DWG DATE: 7/1/22</p>
<p>REV: C</p>		<p>JOB No: 22096</p>

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MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D605

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

GENERAL NOTES:

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

HOLES:

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

WELDS:

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

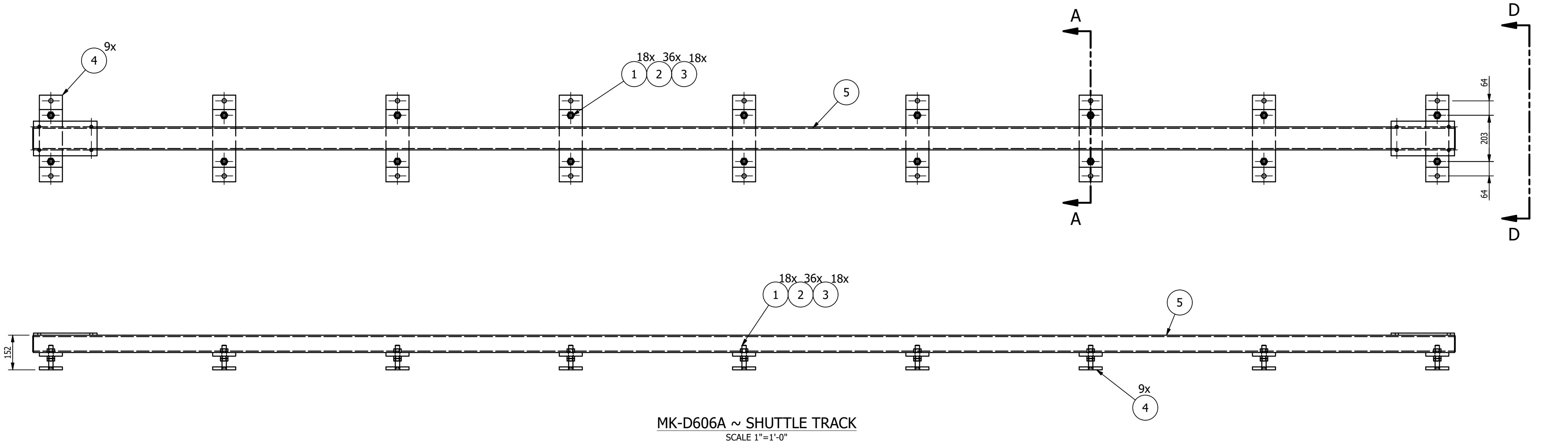
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

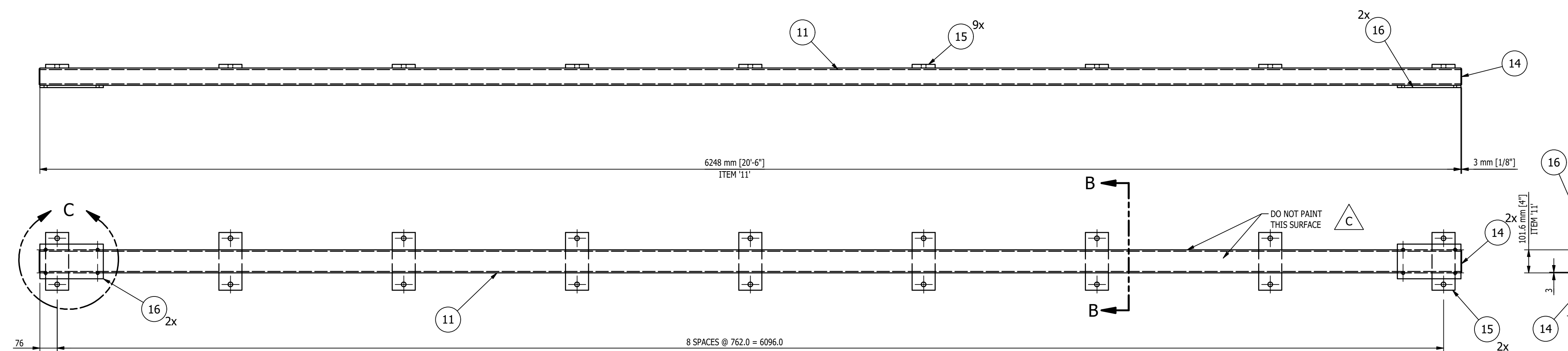
COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D606A			
1	18	THD. ROD 3/4-10UNC	4"		
2	36	3/4-10UNC HEX JAM NUT			
3	18	3/4-10UNC HEX NUT			
4	9	MK-D043D ~ FOOT PLATE			
5	1	MK-D606B ~ SHUTTLE TRACK WELDMENT			
		MK-D606B			
11	1	TS 4 x 3 x 1/4	20'-6"		
14	2	PL 1/8 x 2 3/4"	3 3/4"		
15	9	MK-D043E ~ LOWER WELDMENT PLATE			
16	2	MK-D043F ~ UPPER WELDMENT PLATE			



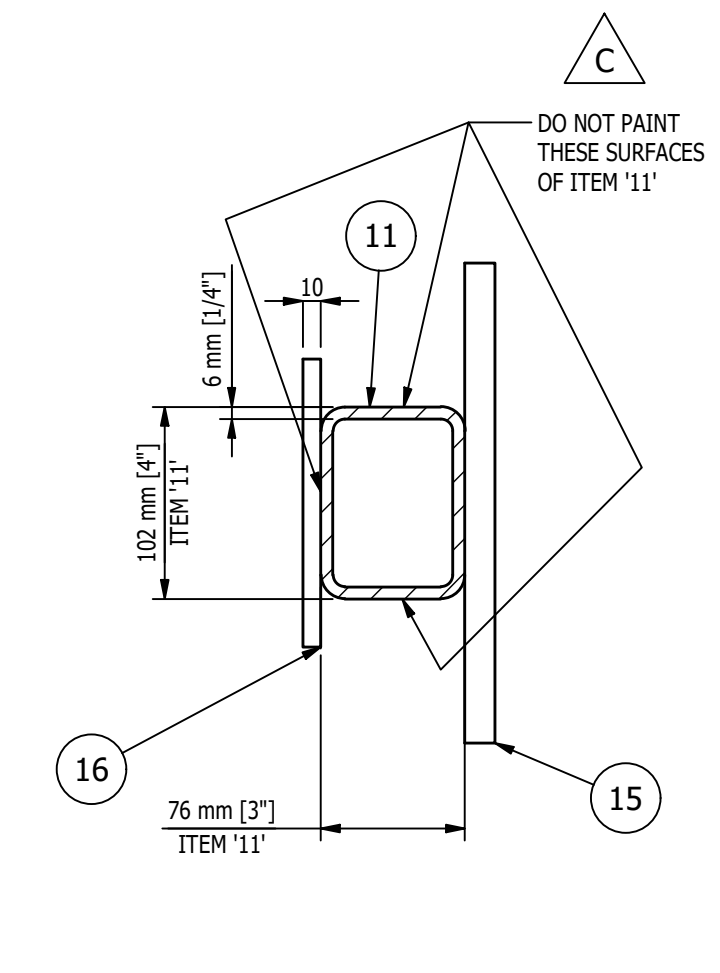
MK-D606A ~ SHUTTLE TRACK
SCALE 1"=1'-0"



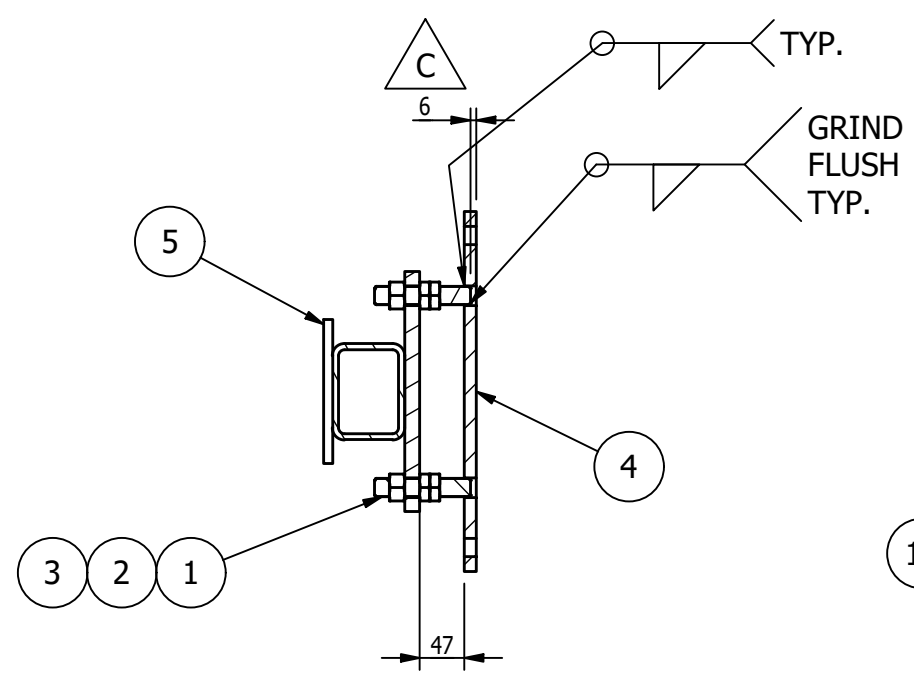
MK-D606B ~ SHUTTLE TRACK WELDMENT
SCALE 1"=1'-0"

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

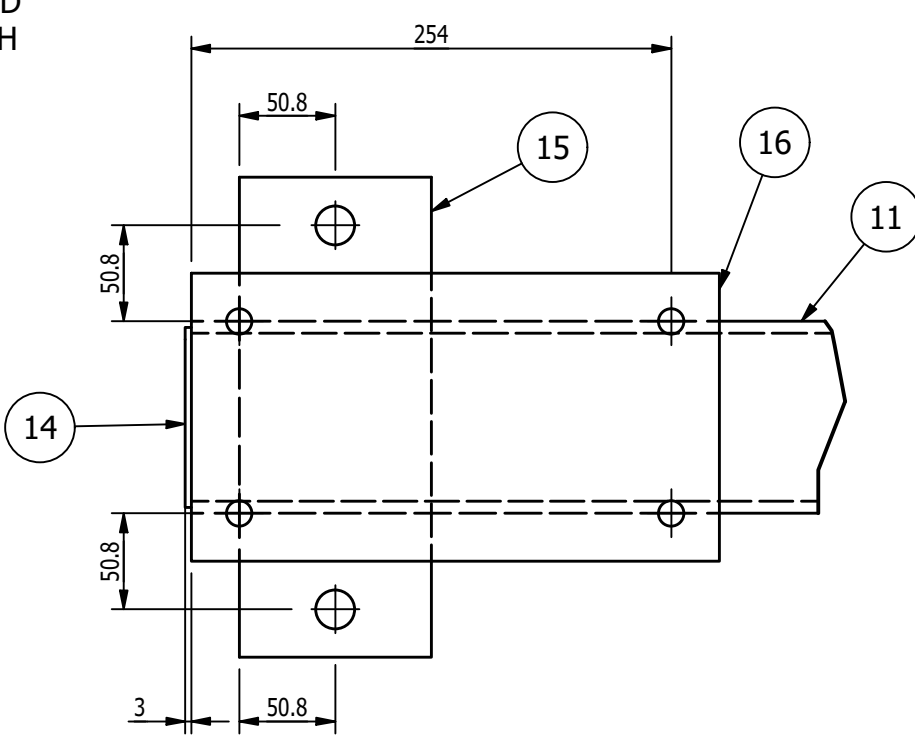
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL
 - ONE SHOP COAT OF LIGHT GREY RAL 7035
 - DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.
 - DO NOT PAINT TOP OR SIDES OF TRACK



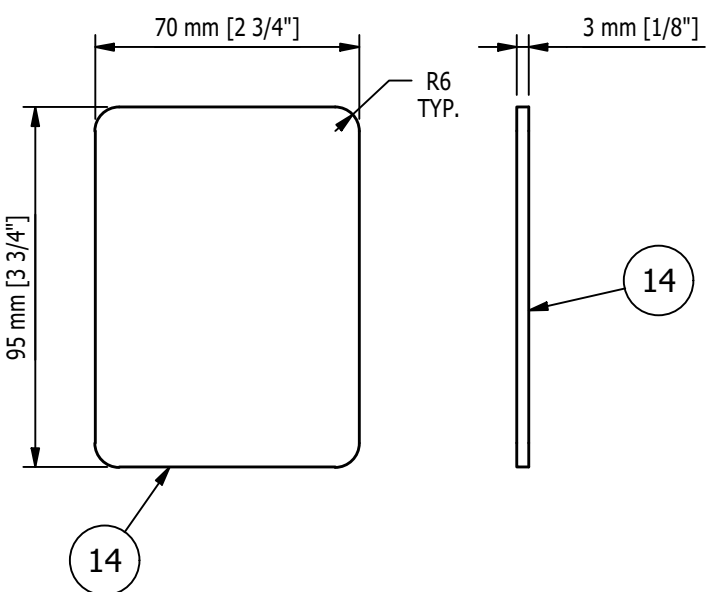
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SCALE 3"=1'-0"



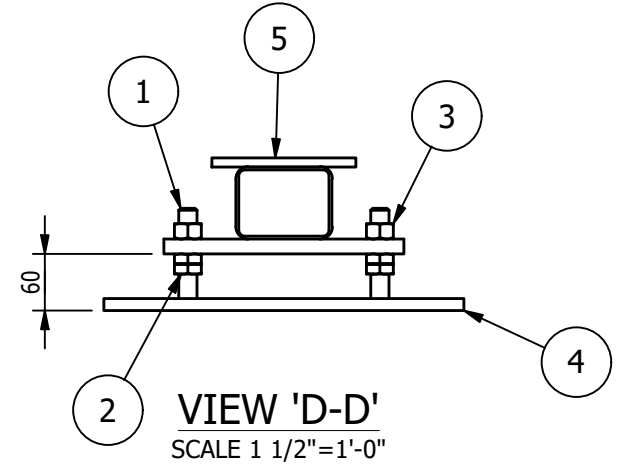
SECTION 'A-A'
SCALE 1 1/2"=1'-0"



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



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



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

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	UPDATED PAINT, WELD NOTES, & DIMENSIONS	
B	MC	8/26/22	REMOVED ITEMS '6', '7', '8', '9', '10', '12', & '13'	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY

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

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. 1875D606

REV: C

JOB No: 22096

DRAWN BY: RJB

CHECKED BY: CW

DWG DATE: 7/1/22

MAGNUM CONSULTING

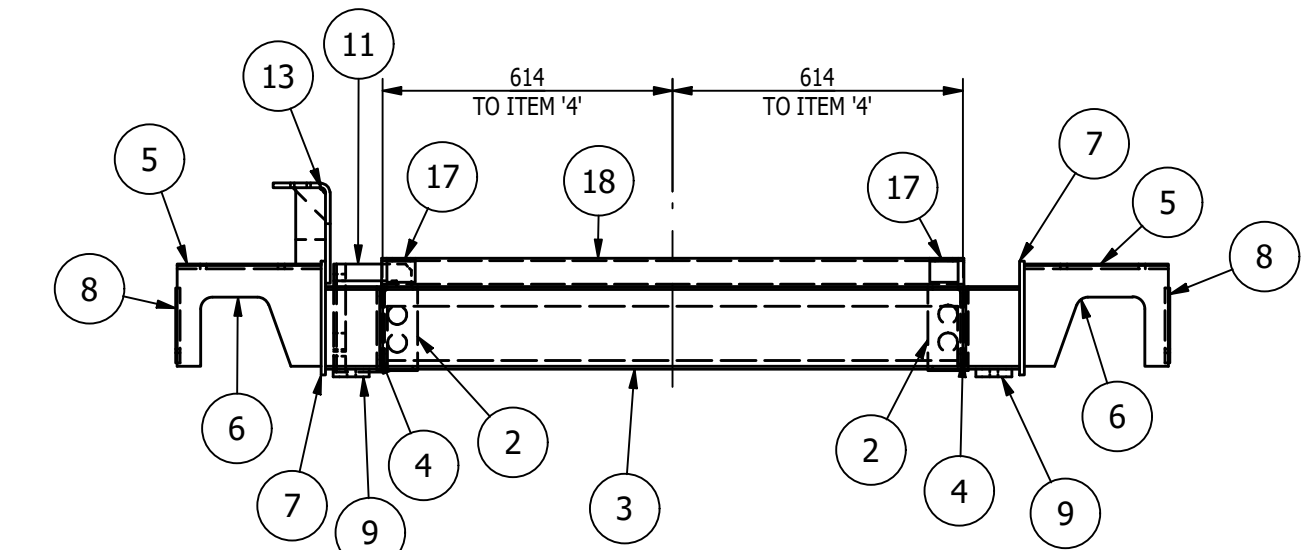
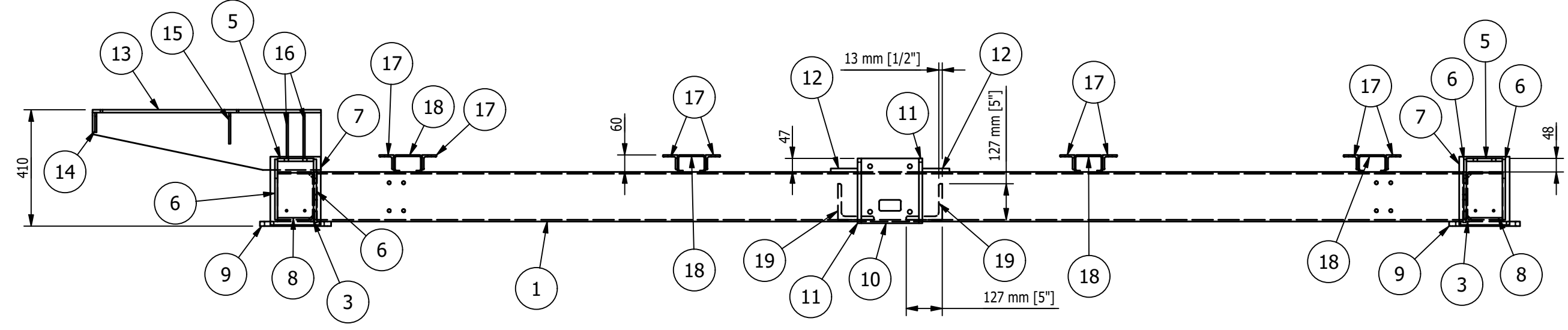
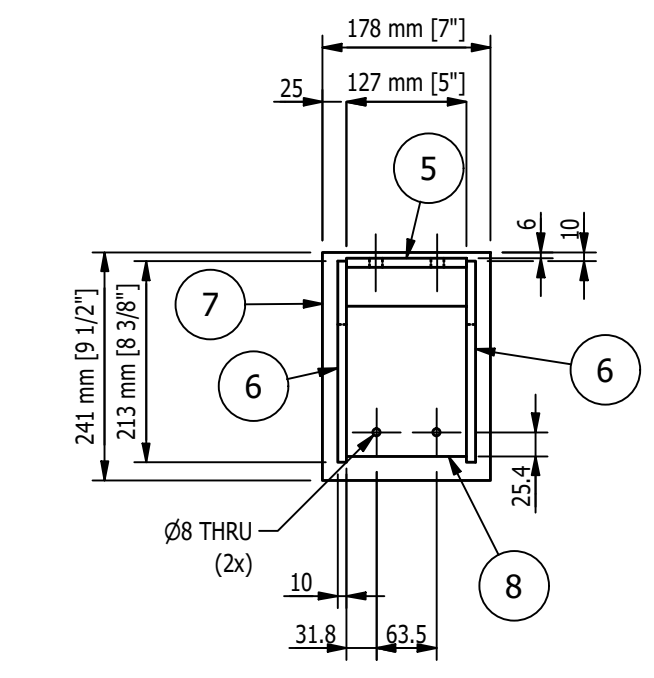
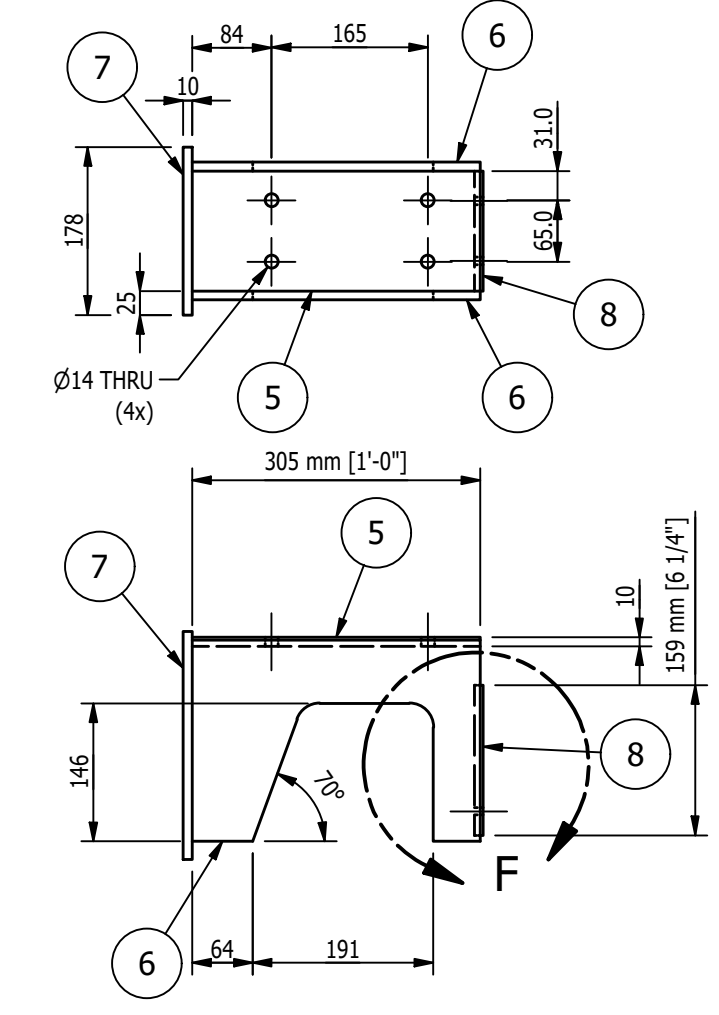
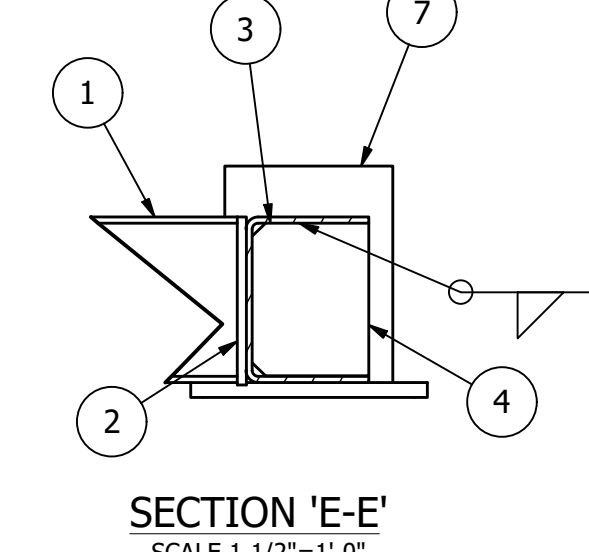
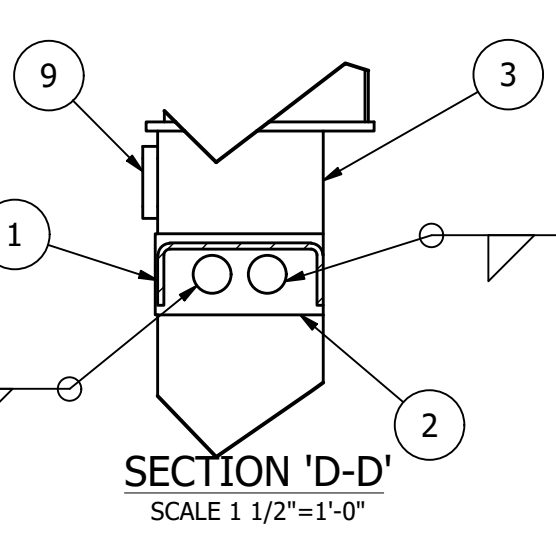
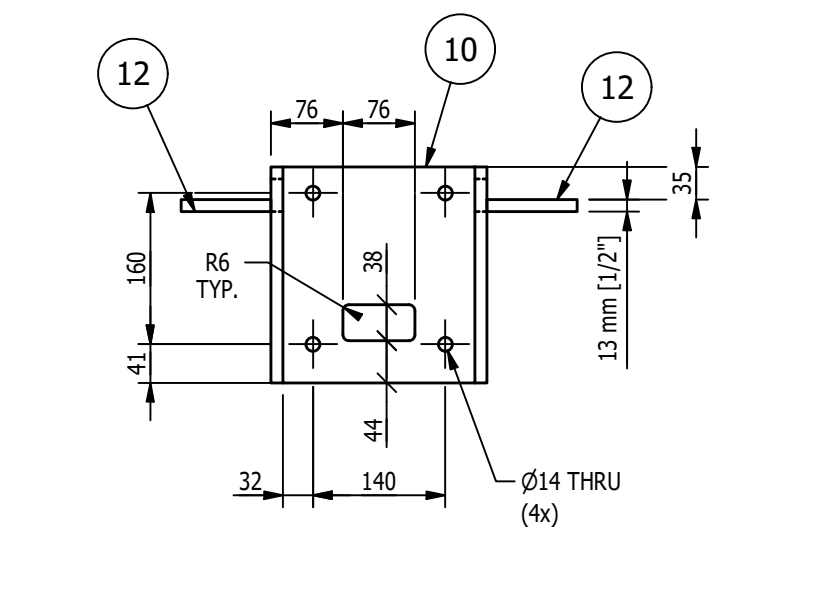
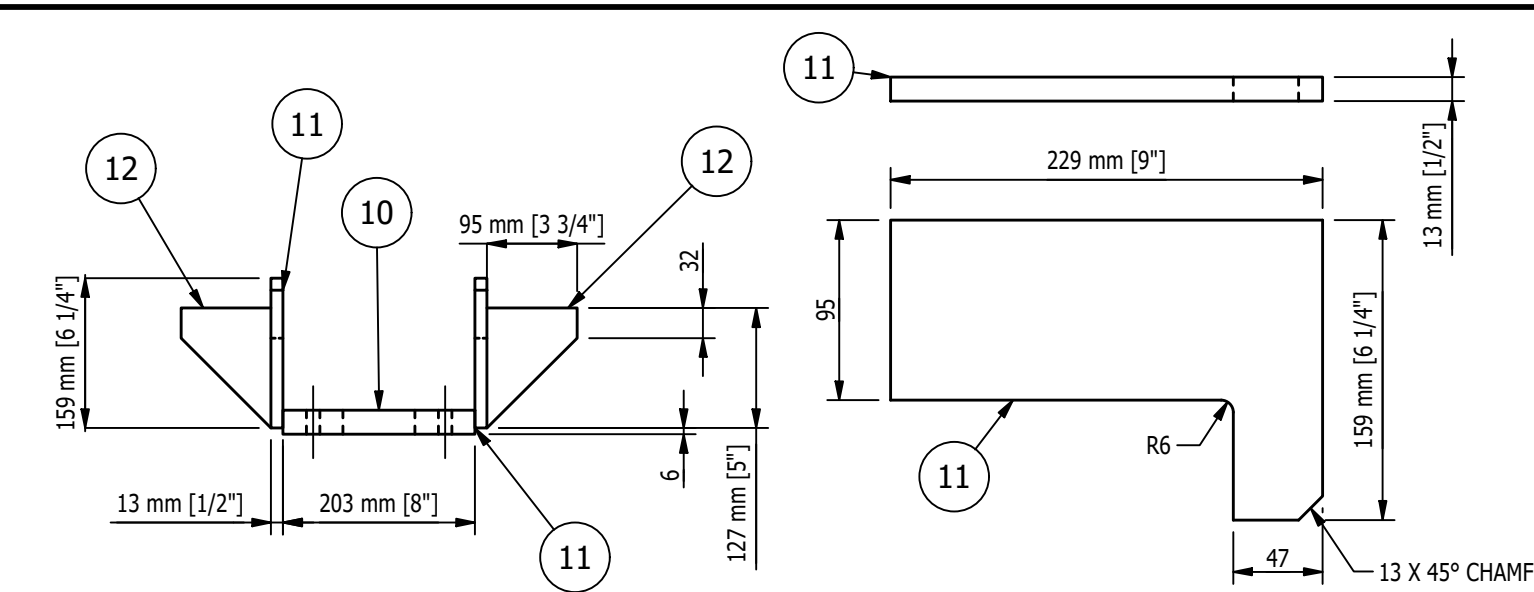
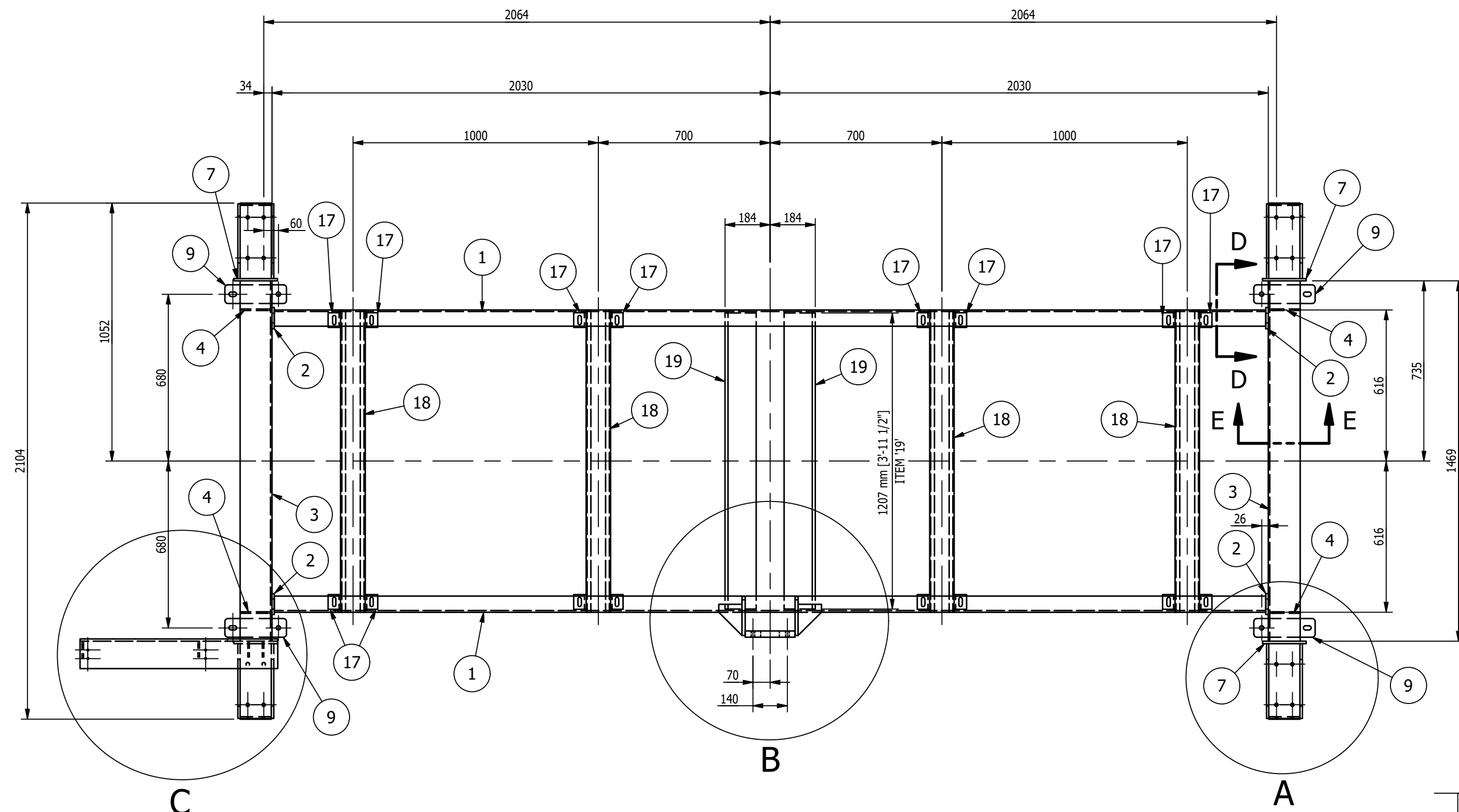
41100 QuakerRoad Rd.
Suite 125
North, MI 48215

Phone: (248) 372-8822
Fax: (248) 372-8821
Web: www.mmagnum.com

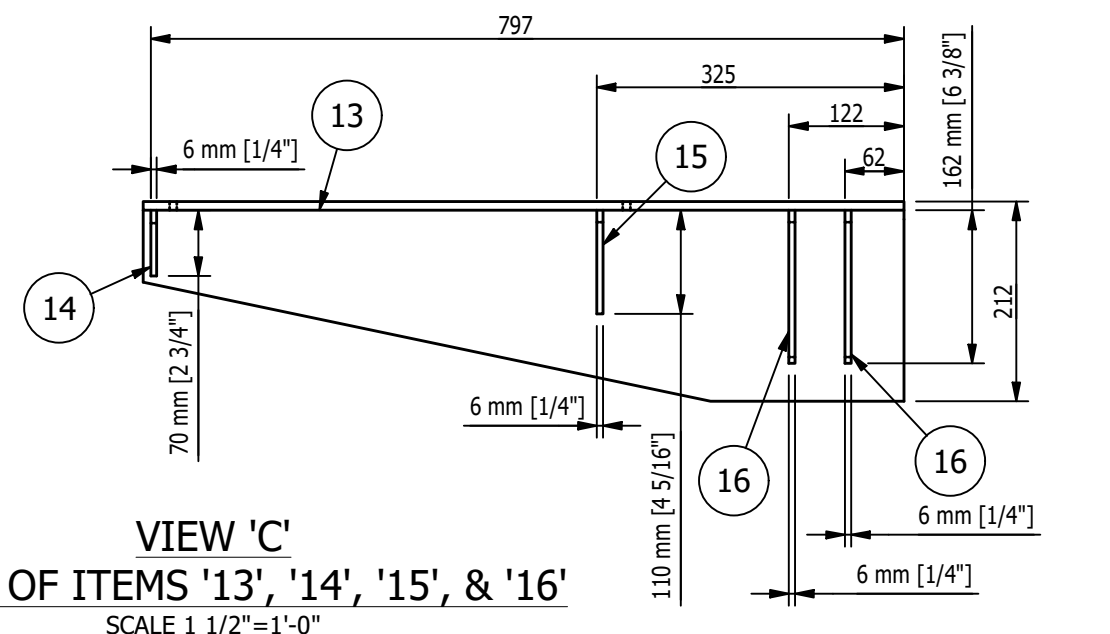
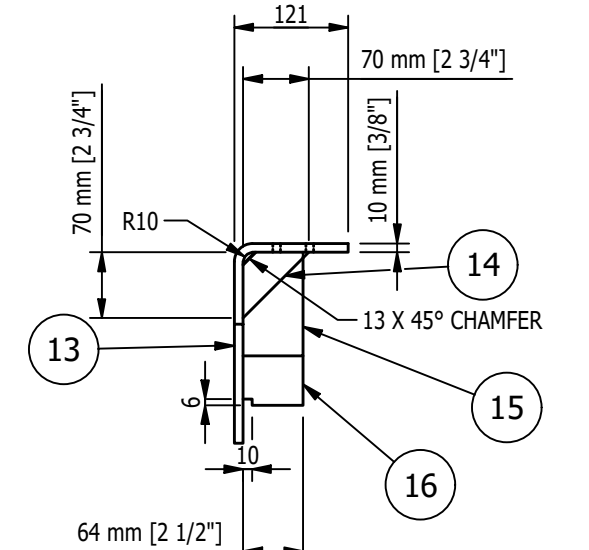
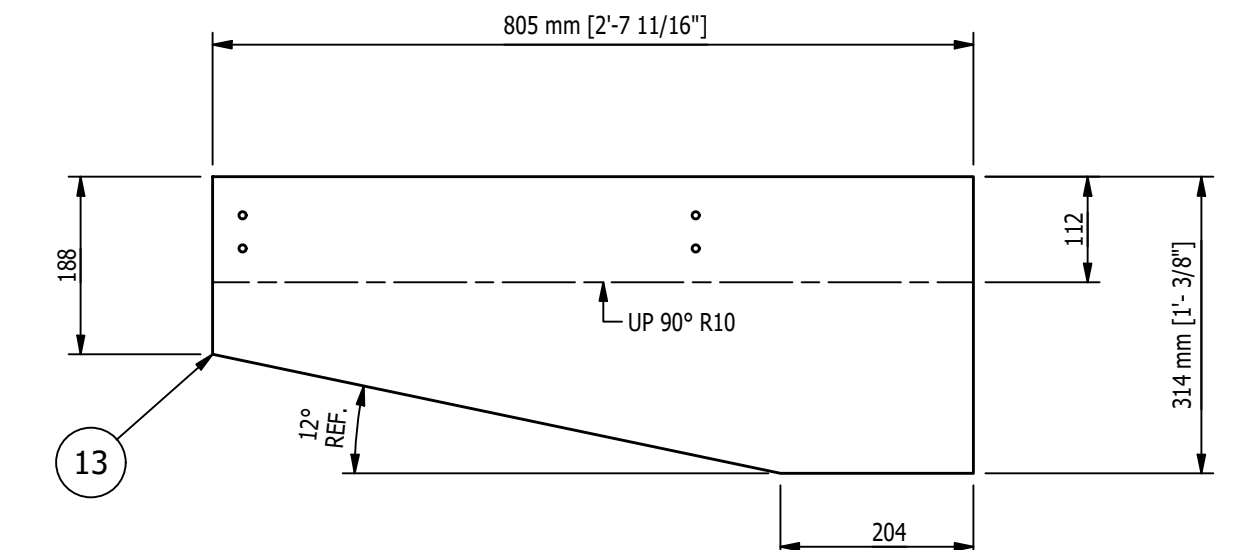
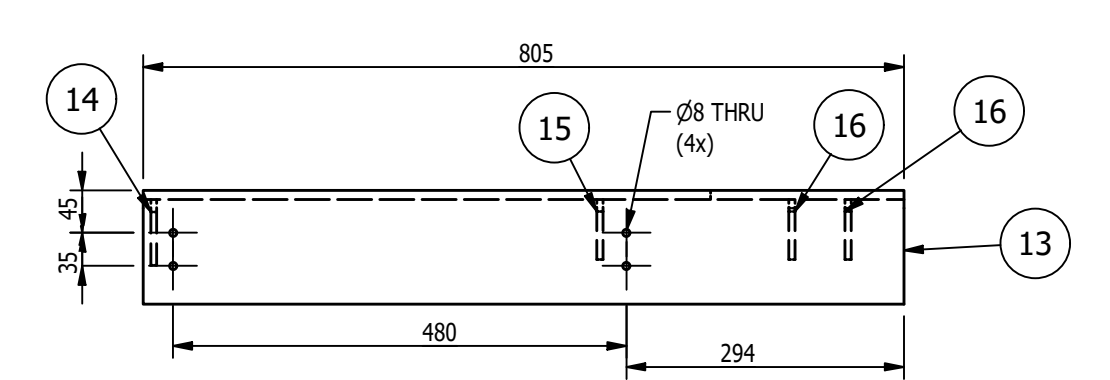
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D606

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

3:00p 11/25/2022 New Mill Drawing/Details/1875D606.dwg



MK-D607A ~ SHUTTLE BASE FRAME WELDMENT
SCALE 3/4\"/>



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D607A			
1	2	BAR 1/4 x 11 1/8	13'-3 1/16"		
2	4	PL 3/8 x 3 3/8	7"		
3	2	BAR 1/4 x 16 3/16	4'-9 13/16"		
4	4	PL 1/4 x 4 7/8	6 3/8"		
5	4	BAR 3/8 x 5	1'-0"		
6	8	BAR 3/8 x 12	8 3/8"		
7	4	BAR 3/8 x 7	9 1/2"		
8	4	BAR 3/8 x 5	6 1/4"		
9	4	BAR 5/8 x 3	9 7/8"		
10	1	BAR 1 x 8	9"		
11	2	BAR 1/2 x 9	6 1/4"		
12	2	BAR 1/2 x 3 3/4	5"		
13	1	BAR 3/8 x 12 3/8	2'-7 11/16"		
14	1	PL 1/4 x 1 9/16	3 7/8"		
15	1	PL 1/4 x 2 1/2	4 5/16"		
16	2	PL 1/4 x 2 1/2	6 3/8"		
17	16	L 2 x 2 x 1/4	2 3/8"		
18	4	BAR 3/16 x 8 15/16	4'-1 1/2"		
19	2	L 5 x 5 x 1/2	3'-11 1/2"		

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

SHEET 1 OF 3

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	ADDED 4 HOLES & DIMENSIONS TO ITEM '1', CORRECTED NAME OF ENLARGED VIEW 'F'	
B	MC	8/30/22	ADDED DIMENSIONS TO FLAT PATTERN OF ITEM '1'	
A	MC	8/9/22	FOR FABRICATION	
REVISION HISTORY				

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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	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D607	DWG DATE:	7/1/22
REV:	C	JOB No.:	22096

MAGNUM Consulting
41100 Clarkston Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D607

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.

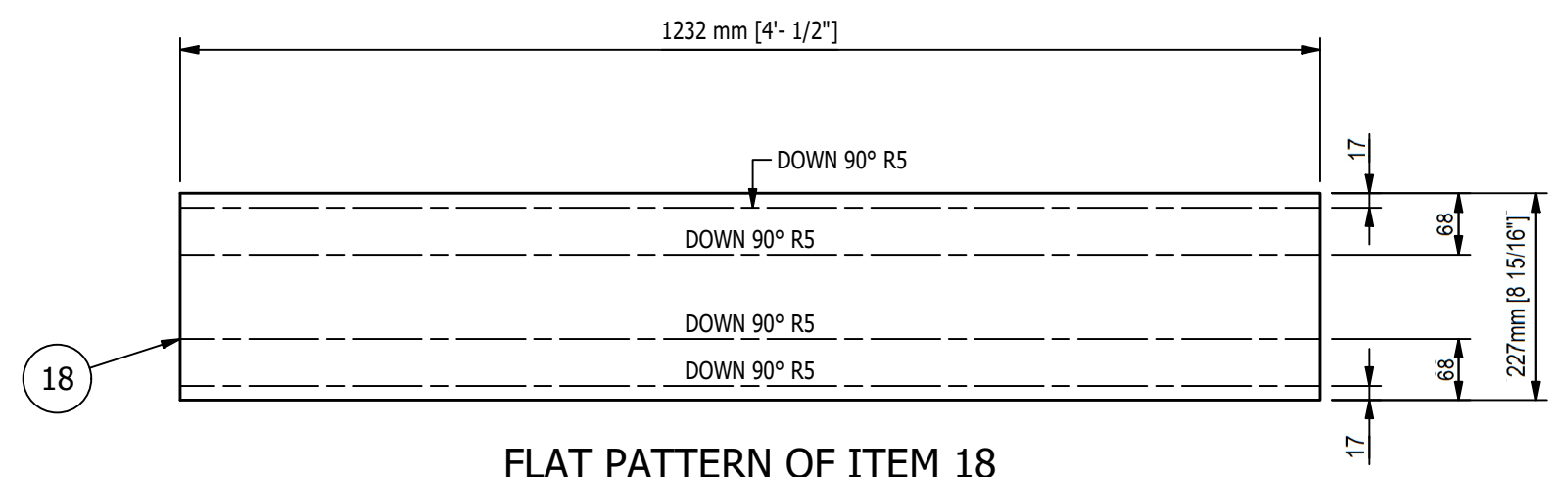
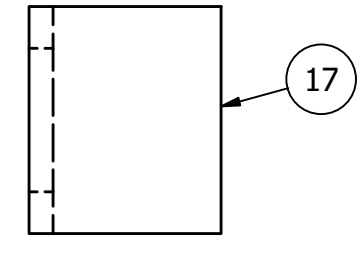
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

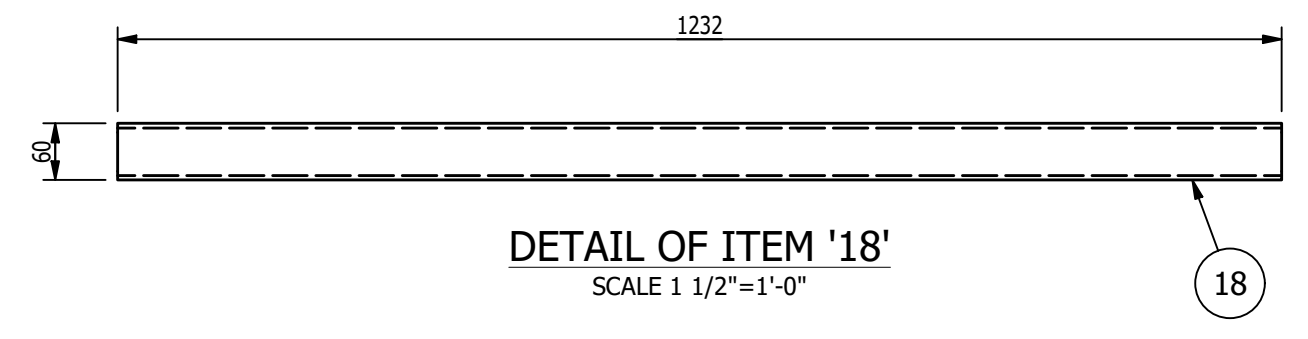
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

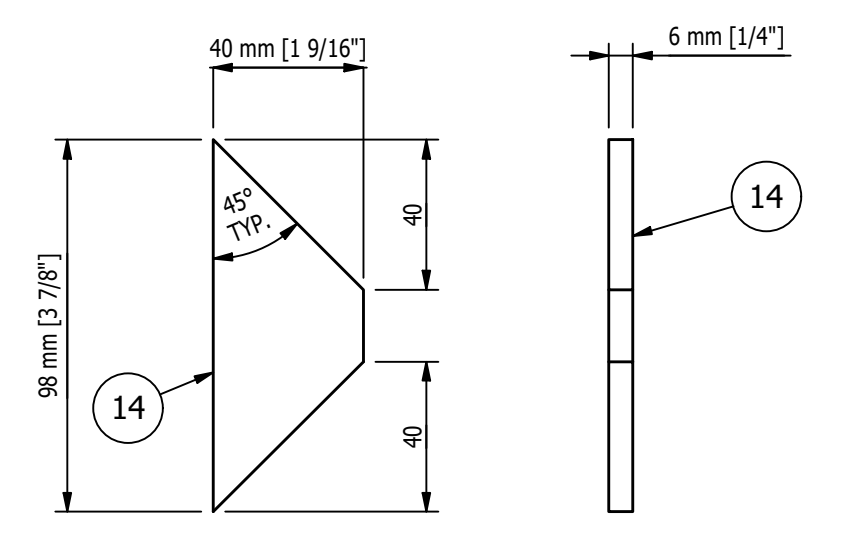
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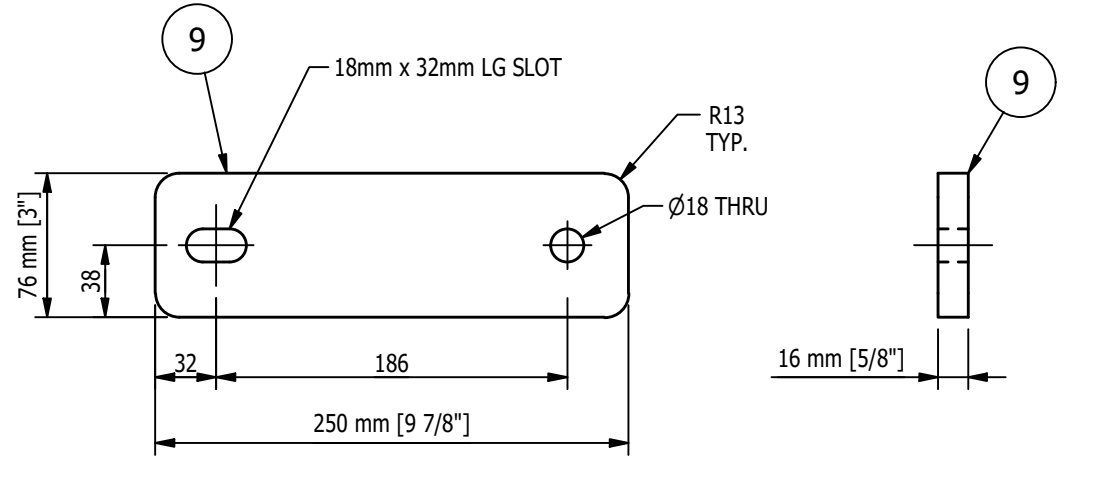
FLAT PATTERN OF ITEM 18
SCALE 1 1/2"=1'-0"



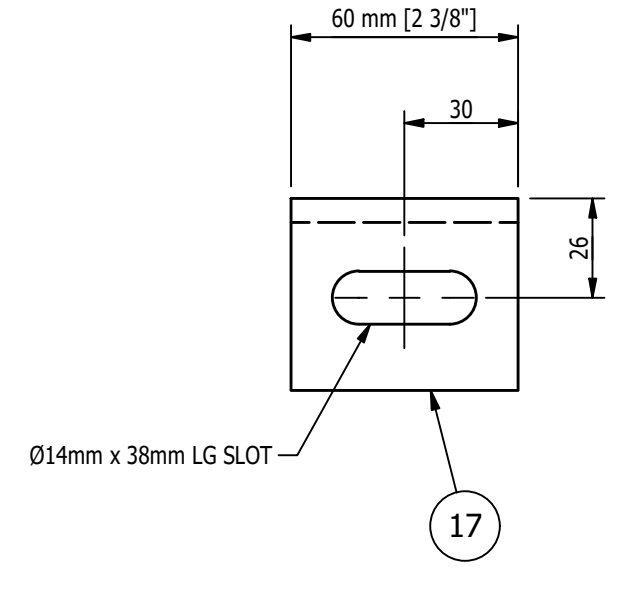
DETAIL OF ITEM '18'
SCALE 1 1/2"=1'-0"



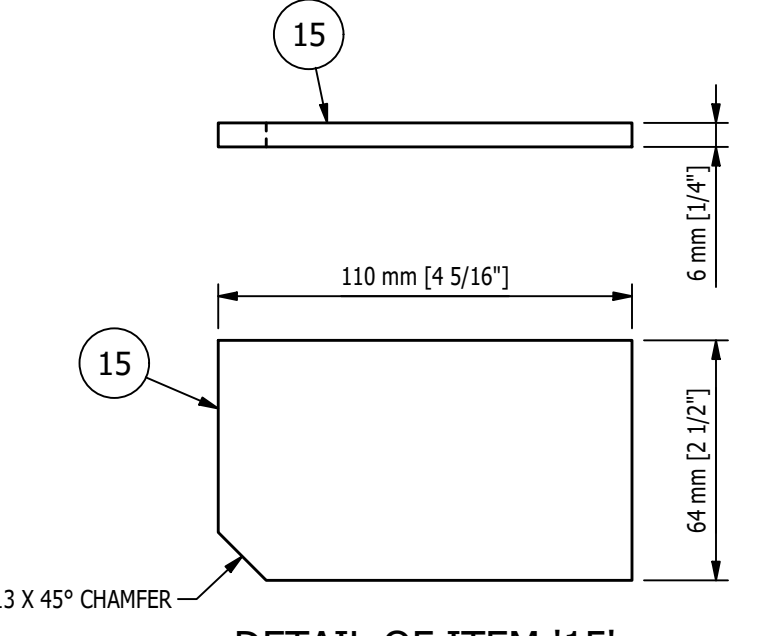
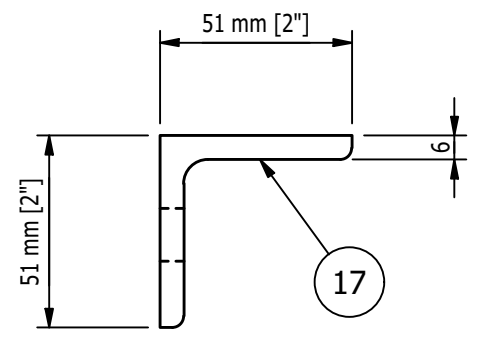
DETAIL OF ITEM '14'
SCALE 6"=1'-0"



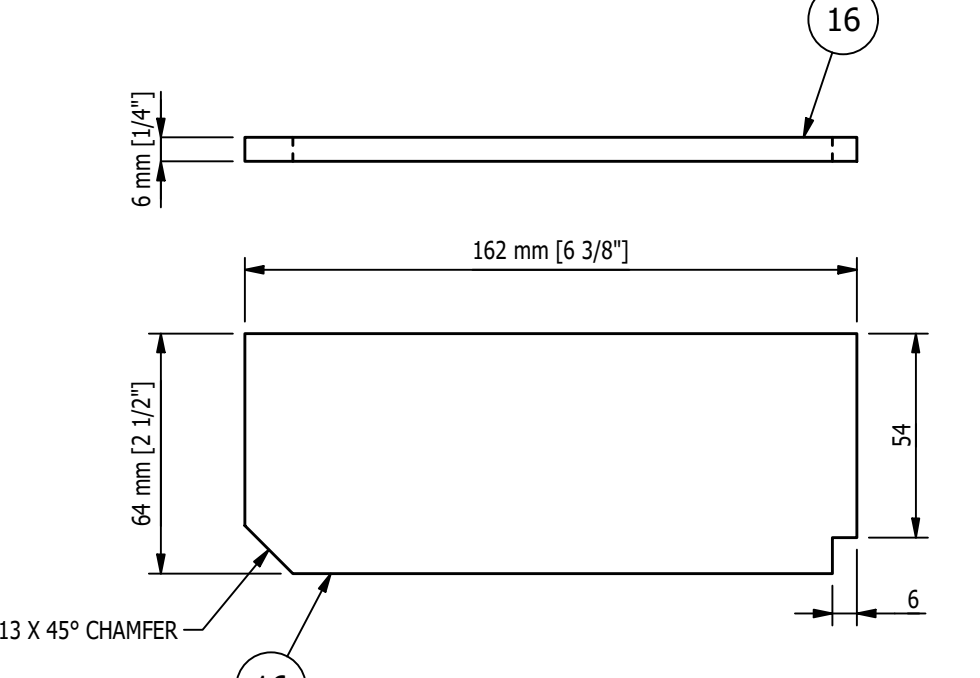
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SCALE 3"=1'-0"



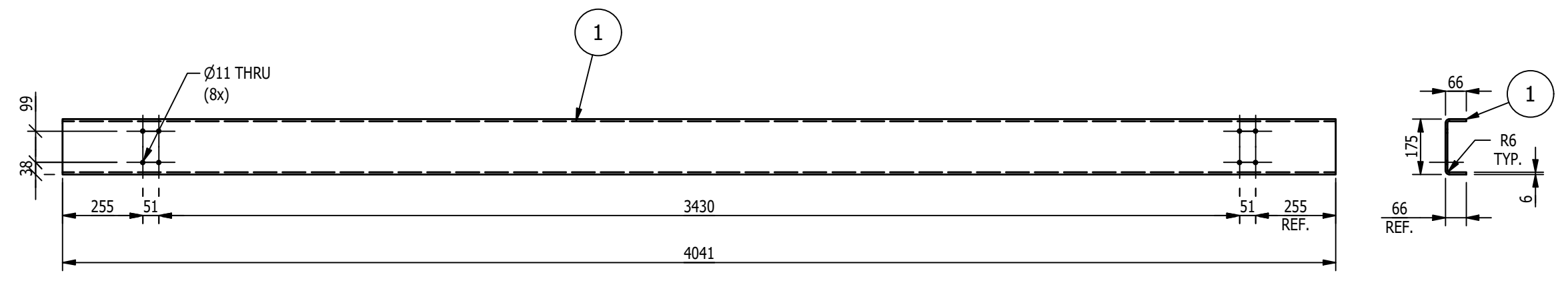
DETAIL OF ITEM '17'
SCALE 6"=1'-0"



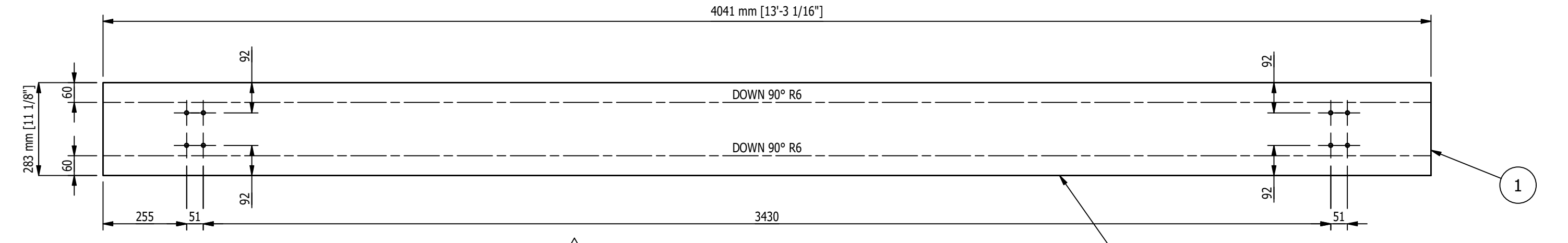
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SCALE 6"=1'-0"



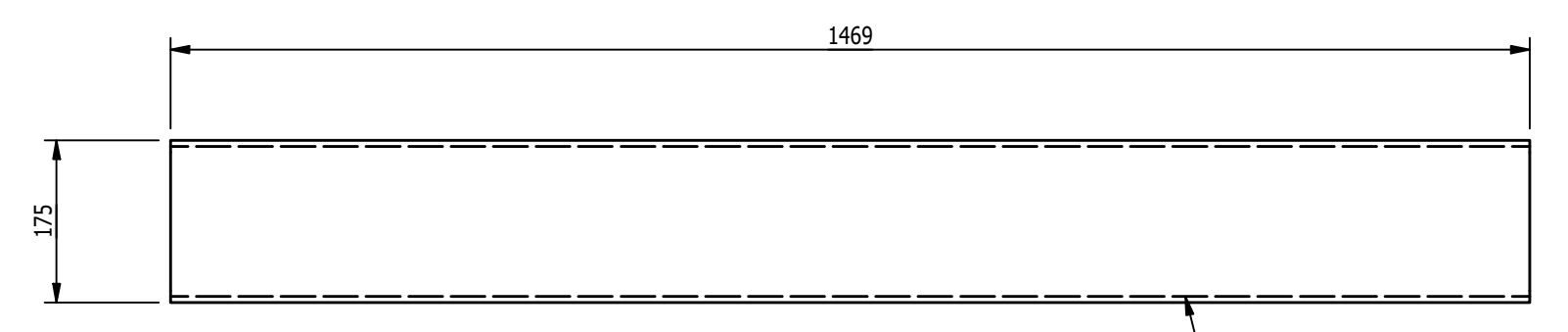
DETAIL OF ITEM '16'
SCALE 6"=1'-0"



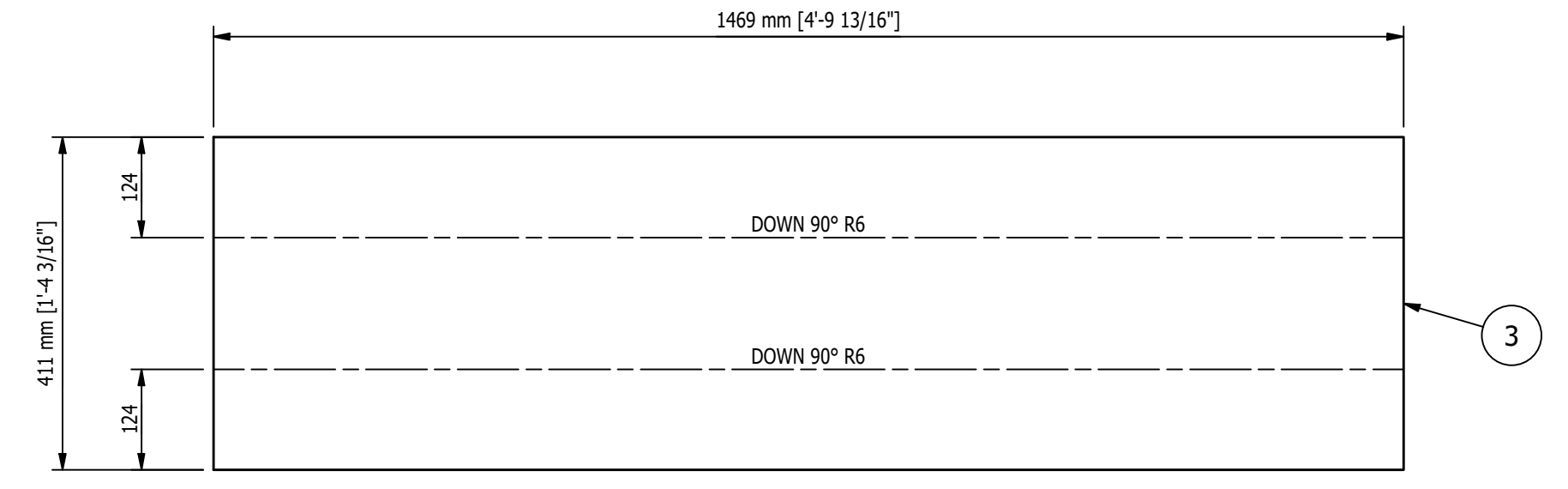
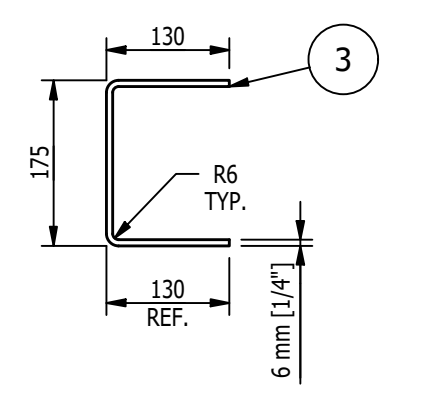
DETAIL OF ITEM '1'
SCALE 3/4"=1'-0"



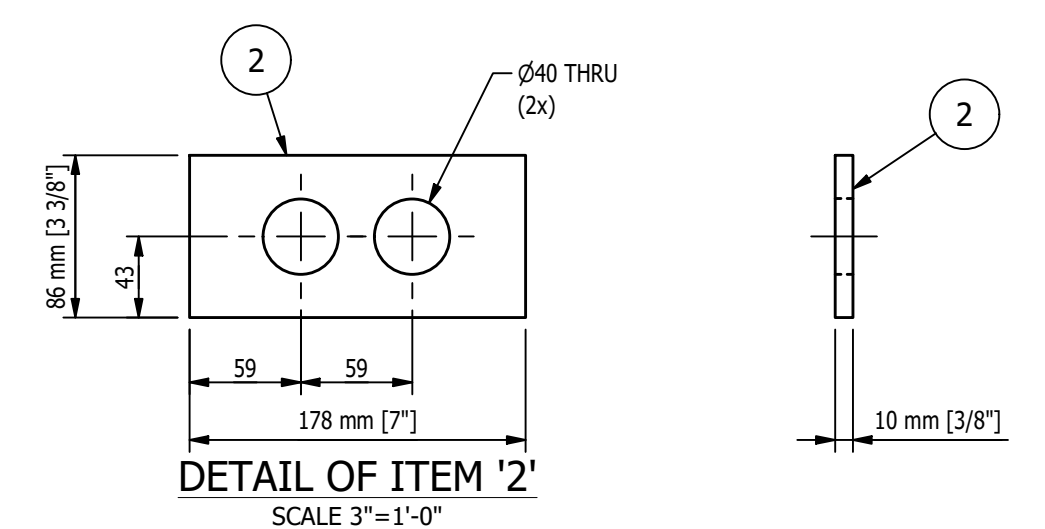
FLAT PATTERN OF ITEM '1'
SCALE 1"=1'-0"



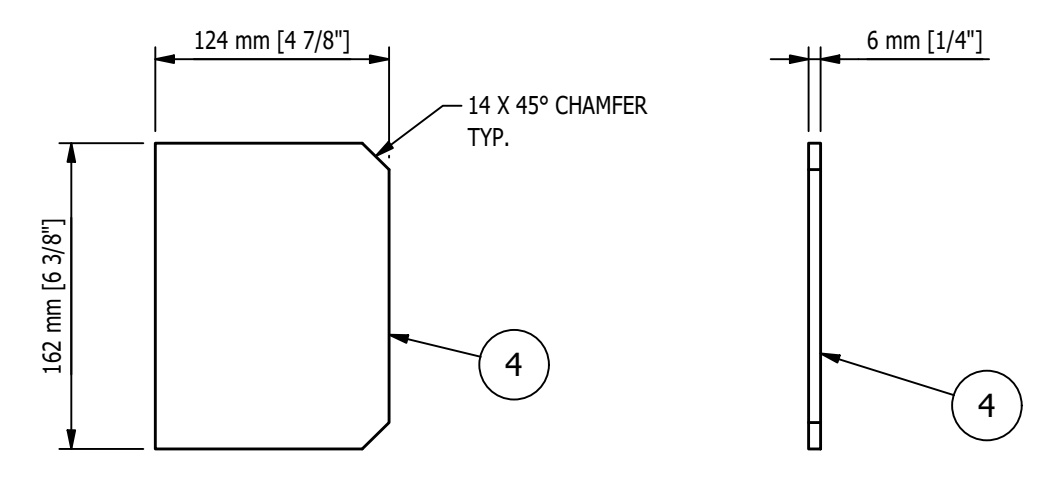
DETAIL OF ITEM '3'
SCALE 1 1/2"=1'-0"



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



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



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

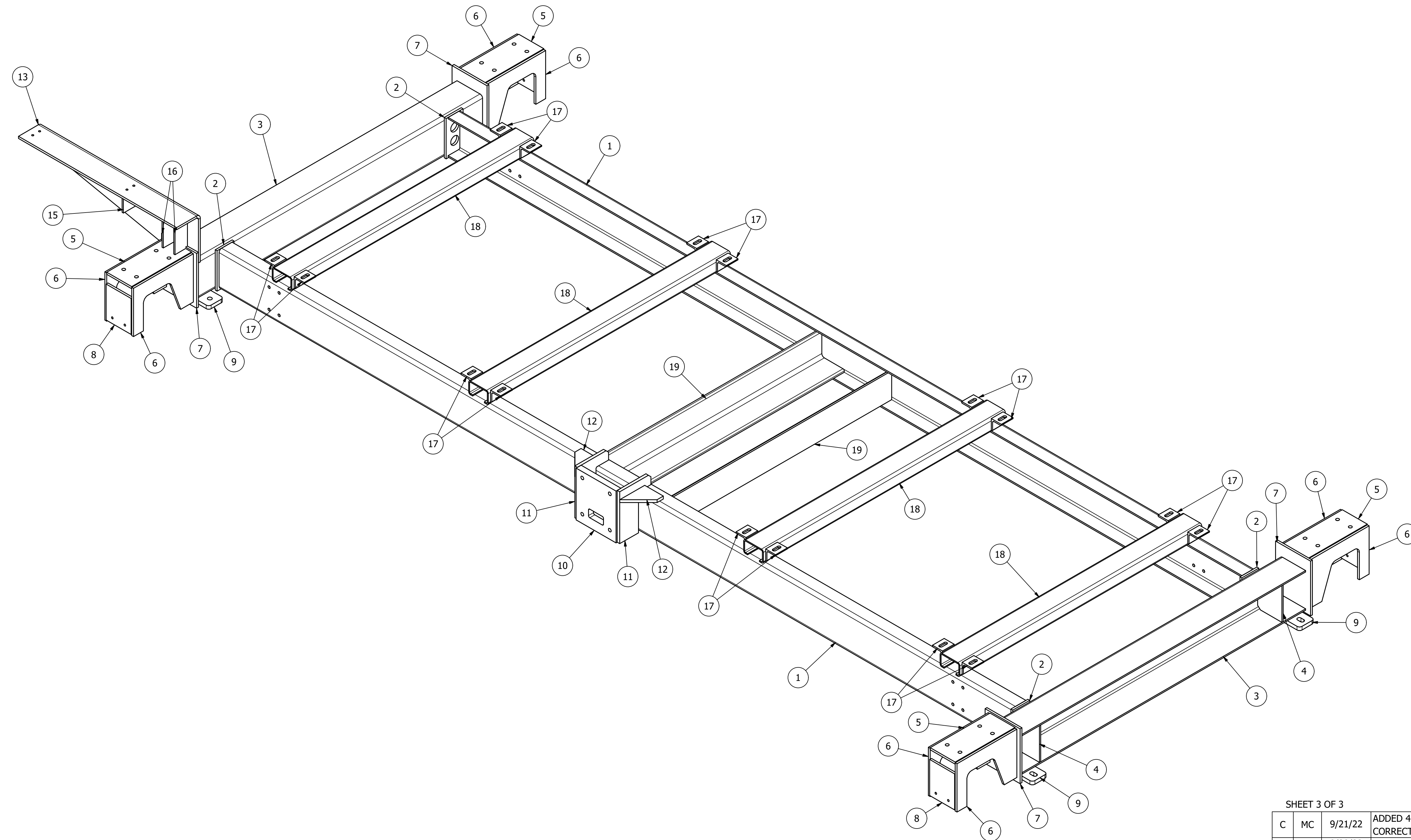
UNLESS OTHERWISE NOTED:
X = ±.060
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XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 1/16" 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.

SHEET 2 OF 3

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	ADDED 4 HOLES & DIMENSIONS TO ITEM '1', CORRECTED NAME OF ENLARGED VIEW 'F'	
B	MC	8/30/22	ADDED DIMENSIONS TO FLAT PATTERN OF ITEM '1'	
A	MC	8/9/22	FOR FABRICATION	

<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com</p>	<p>TITLE: P6700 CONVEYORS CAMPUS BUILDING</p> <p>CLIENT: VOLVO</p> <p>DRAWING No. 1875D607</p>	<p>REVISION HISTORY</p> <p>REV: C</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>DRAWN BY: RJB</p> <p>CHECKED BY: CW</p> <p>DWG DATE: 7/1/22</p> <p>JOB No: 22096</p>



SHEET 3 OF 3

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	ADDED 4 HOLES & DIMENSIONS TO ITEM '1', CORRECTED NAME OF ENLARGED VIEW 'F'	
B	MC	8/30/22	ADDED DIMENSIONS TO FLAT PATTERN OF ITEM '1'	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

UNLESS OTHERWISE NOTED:

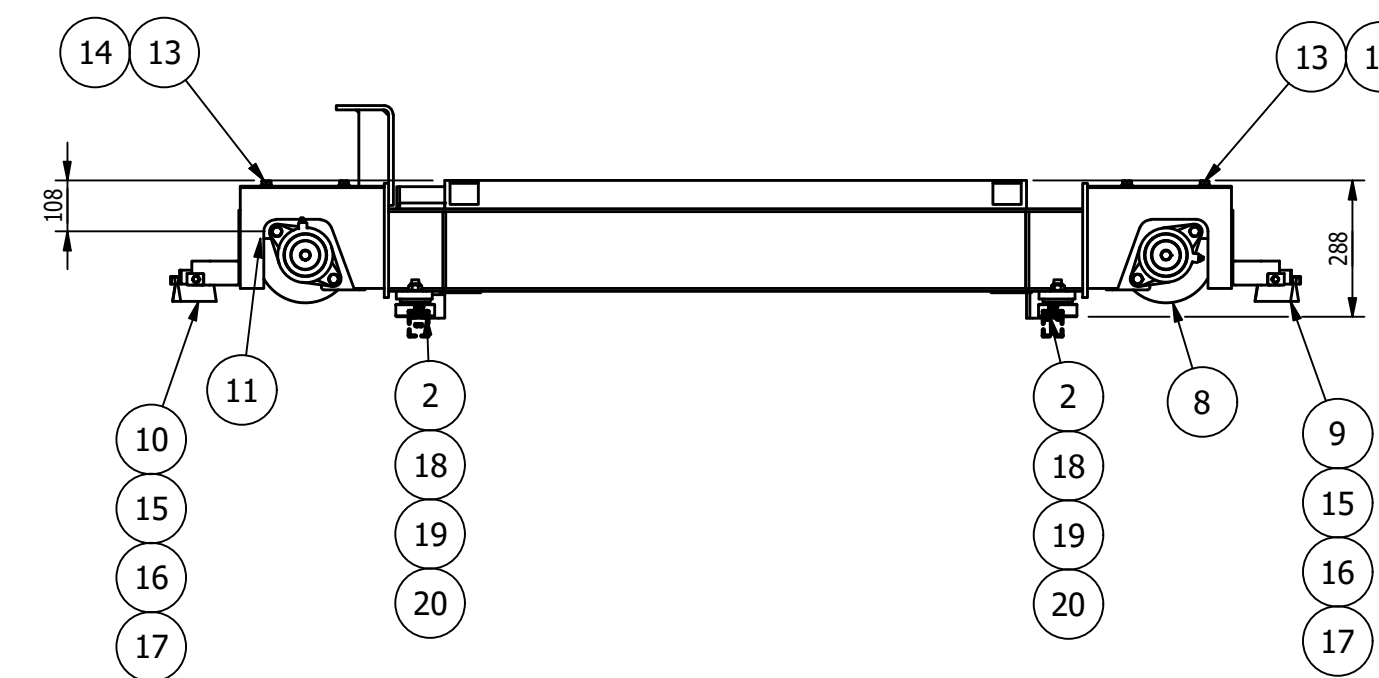
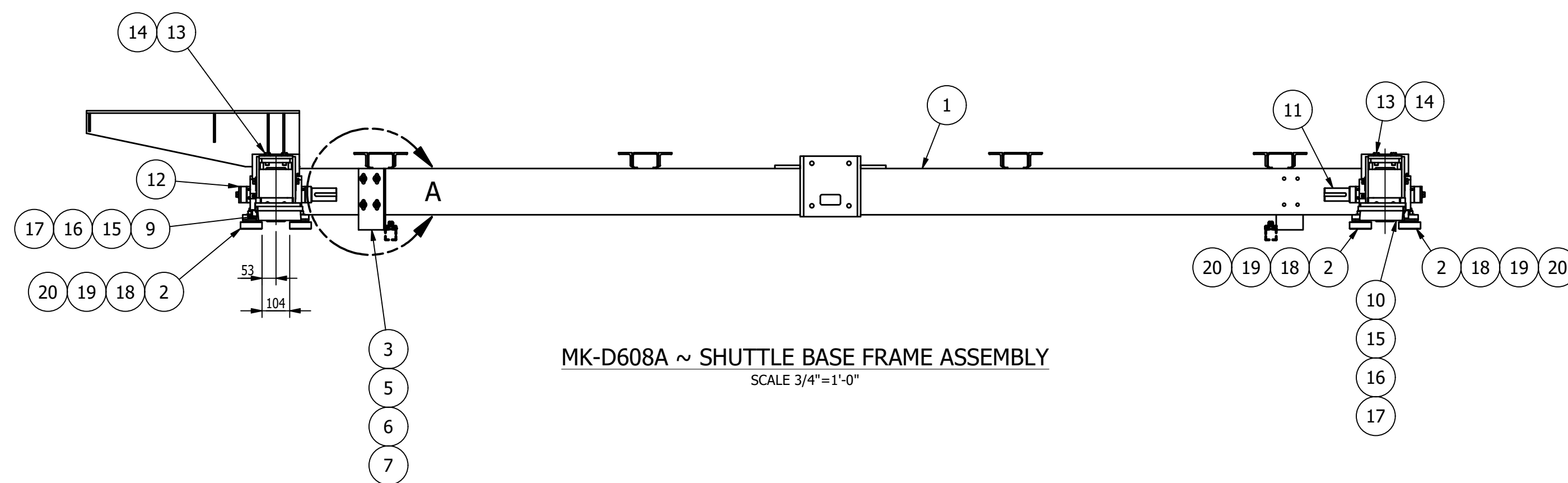
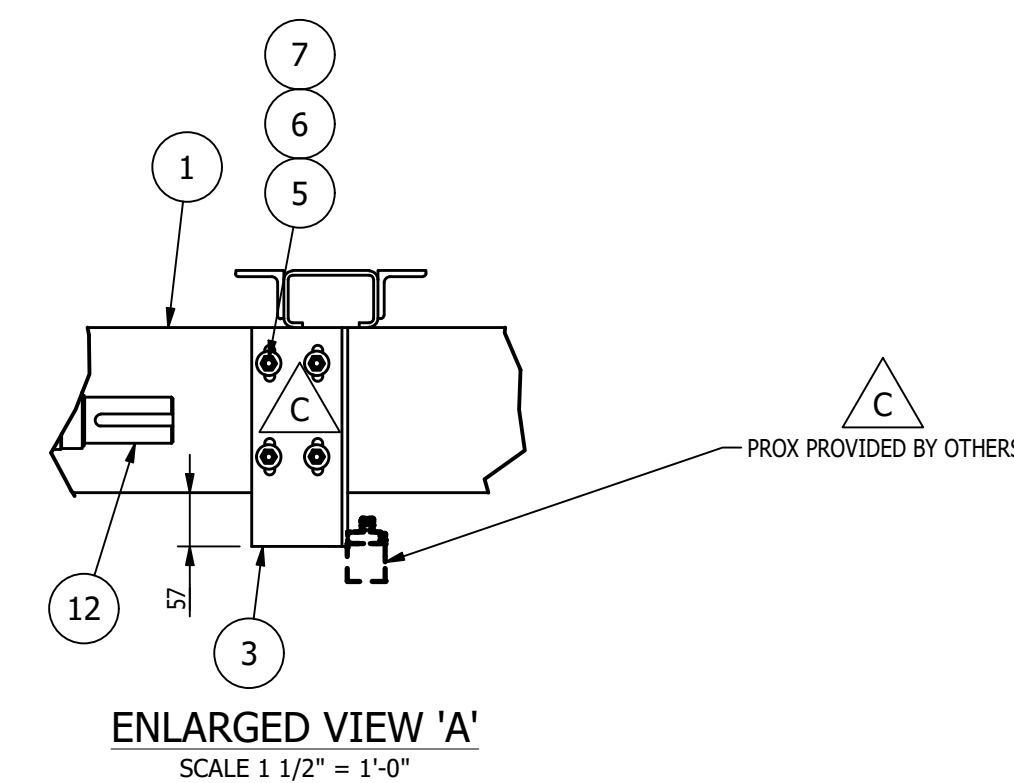
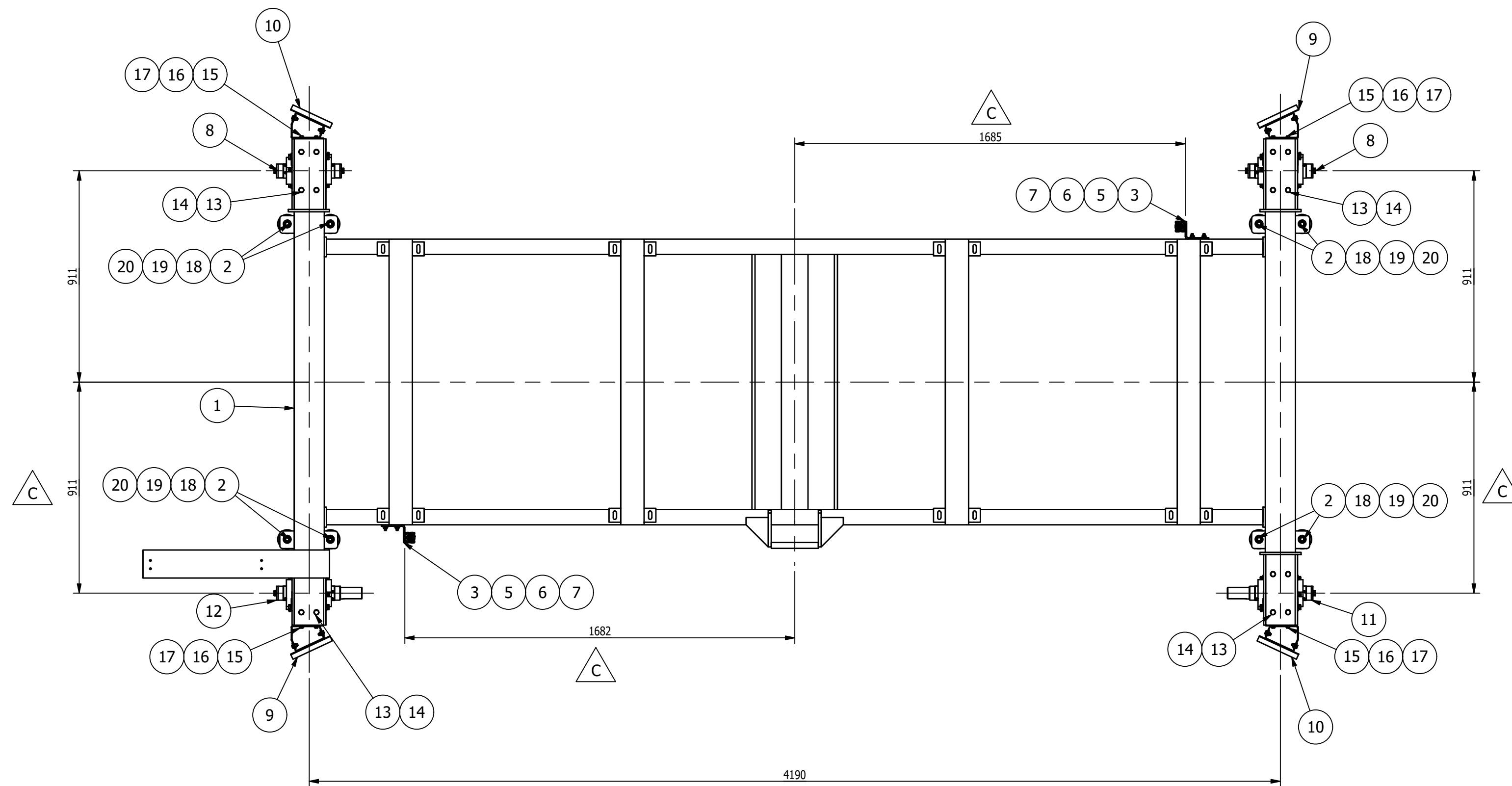
- X = ±.060
- XX = ±.030
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- FRACTIONS = ±1/16"
- ANGLES = ±1°/30'
- BREAK ALL SHARP EDGES
- DEBURR ALL HOLES
- DO NOT SCALE DRAWING



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 3070 W. THOMPSON RD.
 FENTON, MI 48430
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TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D607	DWG DATE: 7/1/22
REV: C	JOB No: 22096



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D608A			
1	1	MK-D607A ~ SHUTTLE BASE FRAME WELDMENT			
2	8	MK-D037A ~ GUIDE ROLLER SPACER			
3	2	MK-D037B ~ PROX BRACKET ANGLE			
5	8	3/8-16UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
6	16	3/8 TYPE B REGULAR FLAT WASHER			
7	8	3/8-16UNC STOVER LOCK NUT			
8	2	MK-D020A ~ IDLER WHEEL ASSEMBLY			
9	2	MK-D038A ~ SHUTTLE BRUSH ASSEMBLY - RH			
10	2	MK-D038B ~ SHUTTLE BRUSH ASSEMBLY - LH			
11	1	MK-D042A ~ SHUTTLE DRIVE WHEEL ASSEMBLY - RH			
12	1	MK-D042B ~ SHUTTLE DRIVE WHEEL ASSEMBLY - LH			
13	16	1/2 SPRING LOCK WASHER			
14	16	1/2-13UNC x 1 1/2" LG. HEX HEAD CAP SCREW			
15	8	M6 x 1 STOVER LOCK NUT			
16	8	M6 REGULAR FLAT WASHER			
17	8	M6x1 x 25mm LG. HEX CAP SCREW			
18	8	FROST STUD - TYPE GUIDED ROLLER, 3.25" DIA x 1.06" WIDE 5/8-11 THREAD, SEAL FOR LIFE, P/N: 4290000		11-1	
19	8	5/8 TYPE A NARROW FLAT WASHER			
20	8	5/8-11UNC STOVER LOCK NUT			

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

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

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/21/22	ITEM '3' LOCATION UPDATED, ADDED PROX NOTE, & QUANTITIES UPDATED: ITEM '5' NOW 8 WAS 4, ITEM '6' NOW 16 WAS 8, & ITEM '7' NOW 8 WAS 4. DESCRIPTION OF ITEM '3' UPDATED, DIMENSIONS UPDATED, ITEM '13' NOW 1/2 SPRING LOCK WASHER, ITEM '14' NOW 1/2-13 UNC x 1 1/2 LG HEX HEAD CAP SCREW	
B	MC	8/26/22	REMOVED ITEM '4', GEOMETRY UPDATED PER ITEM '3'. ITEM '17' WAS M8x1.25 x 25mm LG. HEX CAP SCREW, NOW M6x1 x 25mm LG. HEX CAP SCREW	
A	MC	8/9/22	FOR FABRICATION	

REVISION HISTORY		DESCRIPTION		APP
C		MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		
TITLE:		P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: RJB
CLIENT:		VOLVO		CHECKED BY: CW
DRAWING No.		1875D608		DWG DATE: 7/1/22
REV:		C		JOB No: 22096

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D608

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.

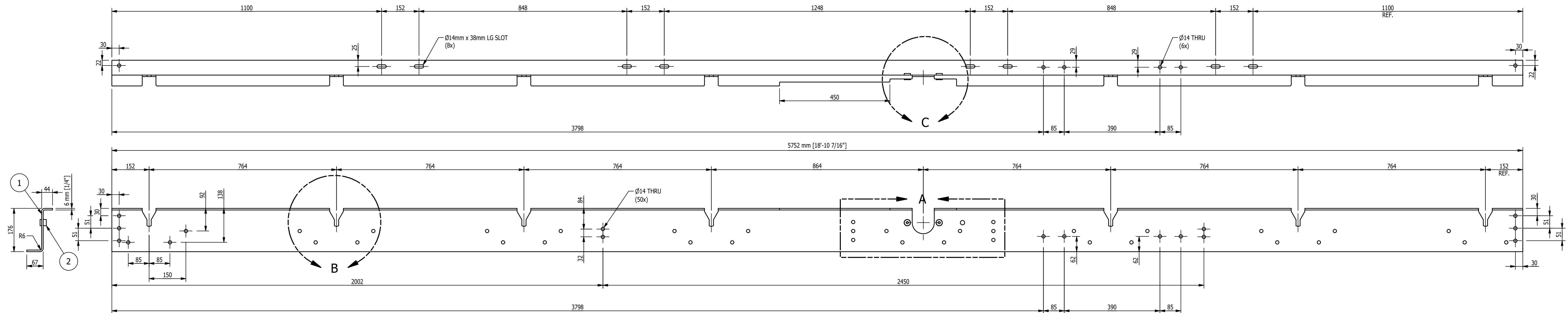
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

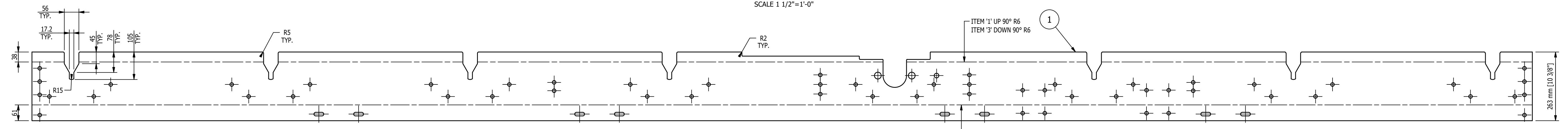
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

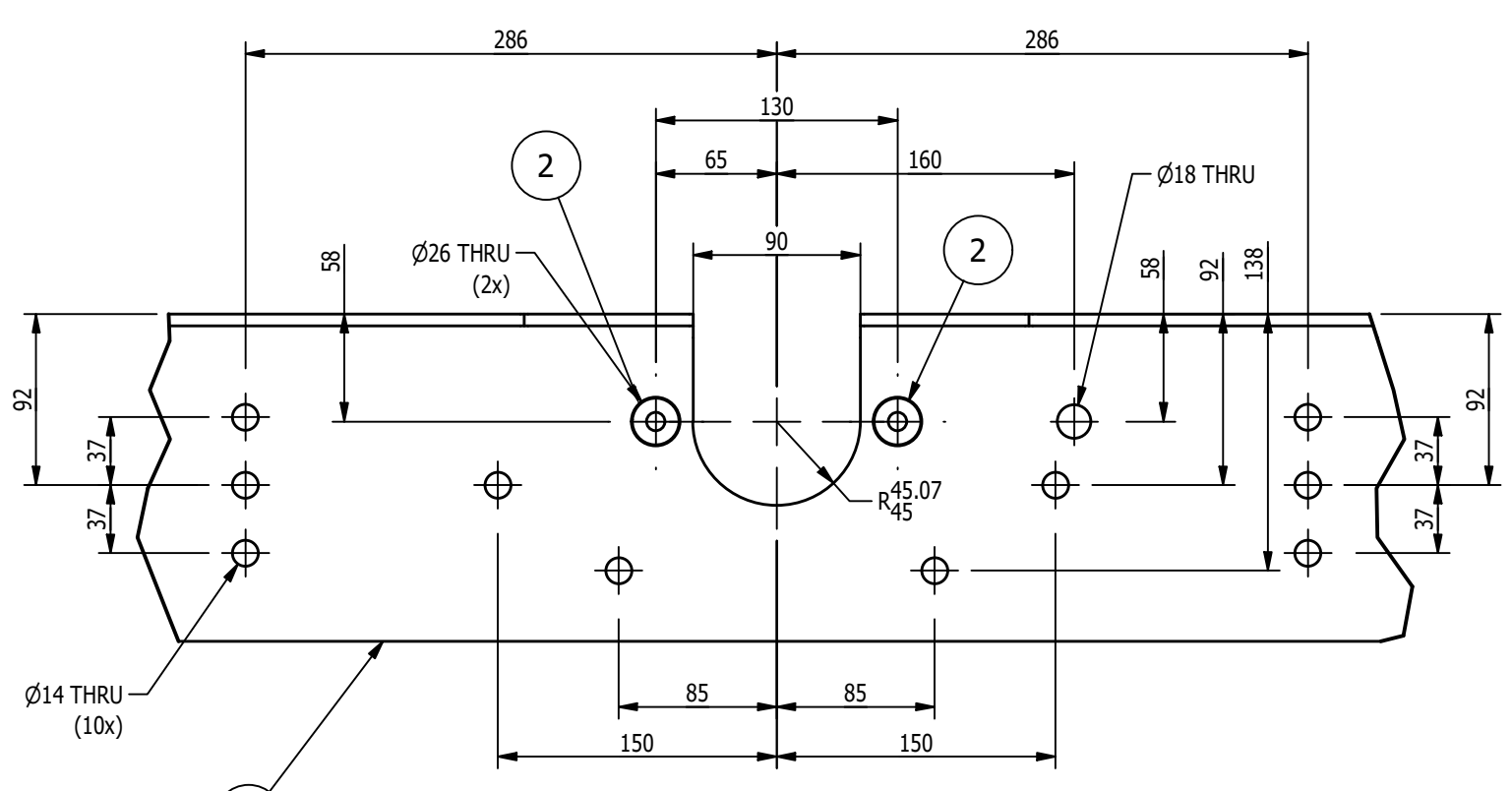
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D609A			
1	1	BAR 1/4 x 10 3/8	18'-10 7/16"		
2	2	PL 1 x 1"	1"		
		TOTAL WEIGHT ~ 163.2 lbs			
		MK-D609B			
2	2	PL 1 x 1"	1"		
3	1	BAR 1/4 x 10 3/8	18'-10 7/16"		
		TOTAL WEIGHT ~ 163.2 lbs			



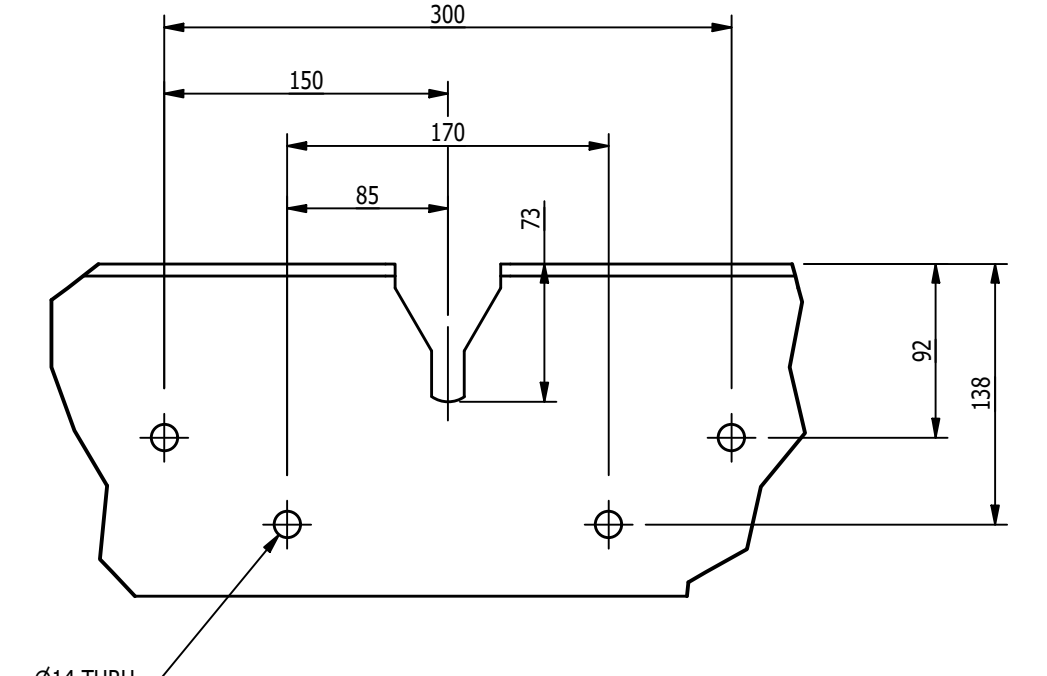
MK-D609A ~ 8-ROLL SHUTTLE SIDE FRAME ASSY - RH (SHOWN)
 MK-D609B ~ 8-ROLL SHUTTLE SIDE FRAME ASSY - LH (OPPOSITE)
 SCALE 1 1/2" = 1'-0"



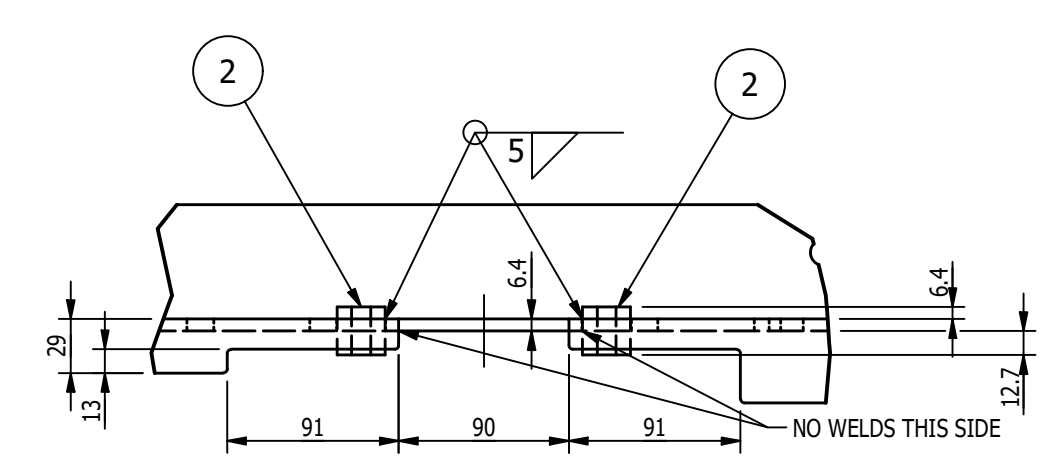
FLAT PATTERN OF ITEM '1', '3'
 SCALE 1 1/2" = 1'-0"



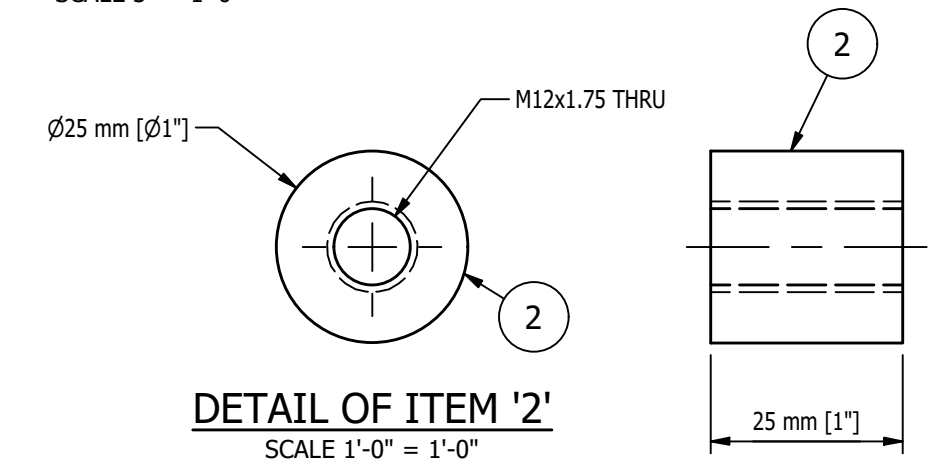
ENLARGED VIEW 'A'
 SCALE 3" = 1'-0"



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



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



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

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

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

GENERAL NOTES:

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

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

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

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

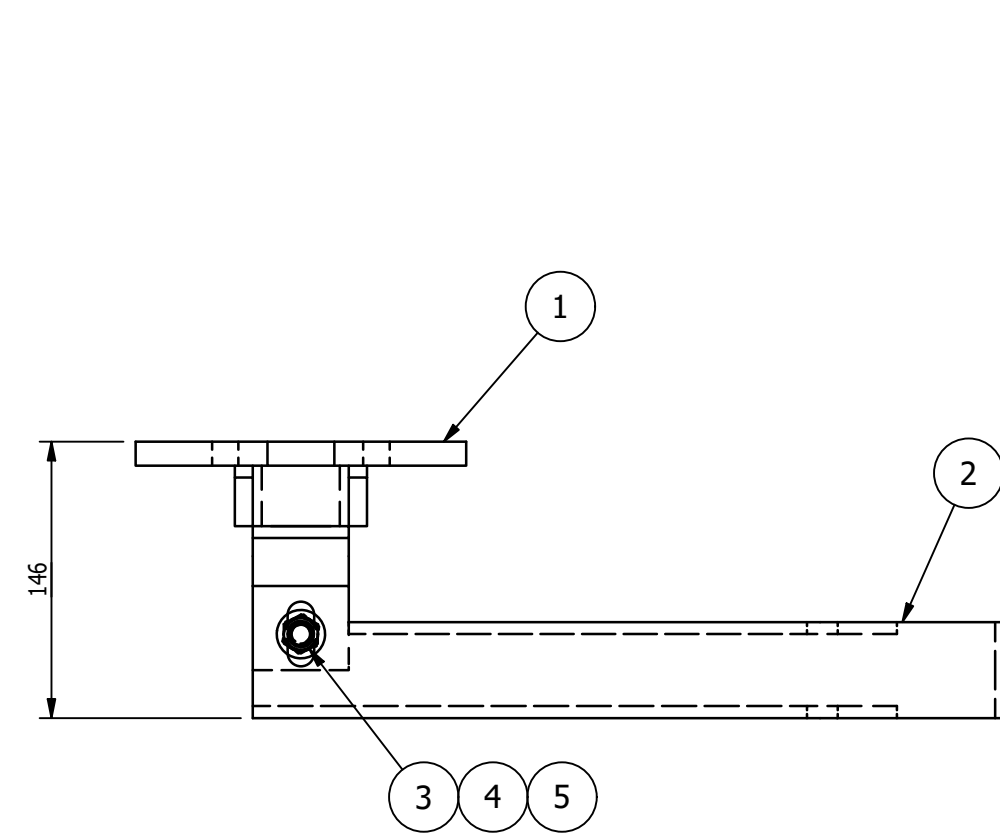
COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MAGNUM Consulting
 41100 Clarkston Road
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

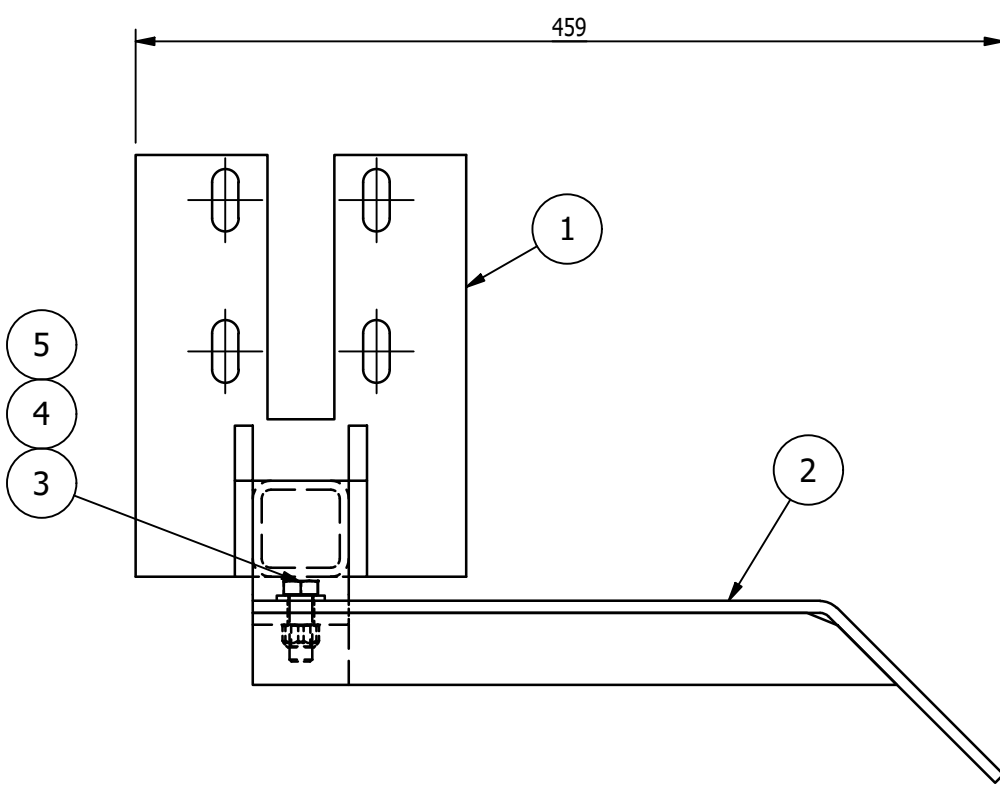
MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D609

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

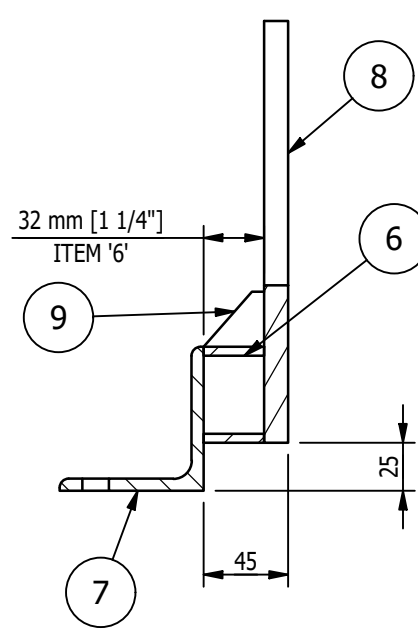
REV	MC	8/9/22	FOR FABRICATION		
REV	BY	DATE	DESCRIPTION		APP
REVISION HISTORY					
			MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.com		
TITLE:			P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: RJB
CLIENT:			VOLVO		CHECKED BY: CW
DRAWING No.			1875D609		DWG DATE: 7/1/22
REV:			A		JOB No: 22096



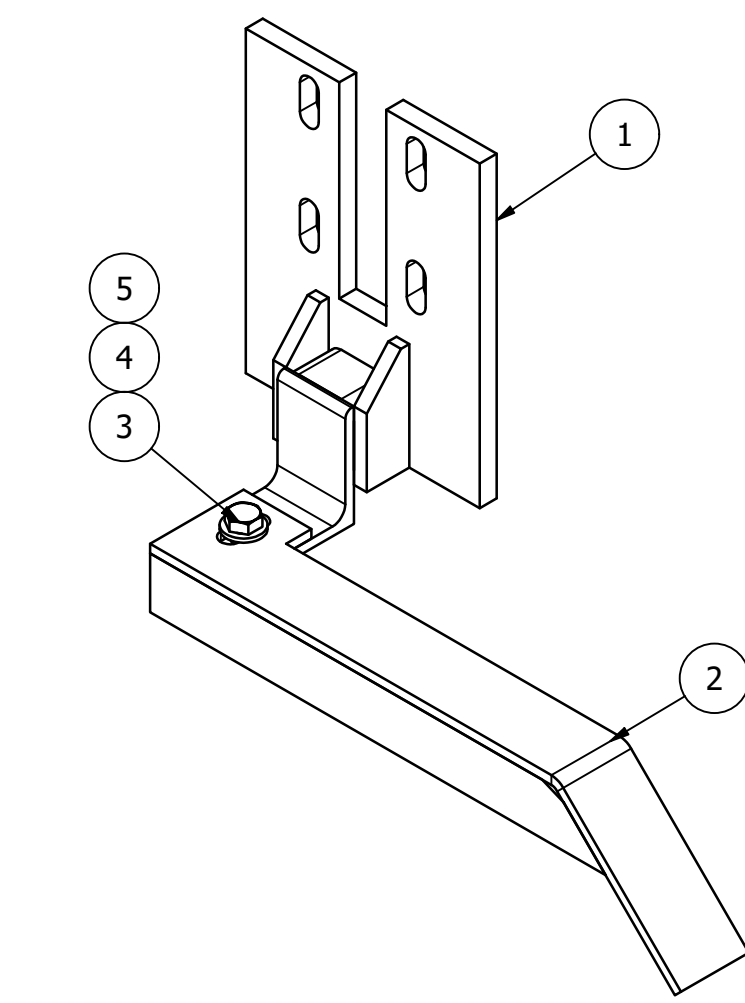
MK-D610A ~ STOP TRIGGER
SCALE 3"=1'-0"



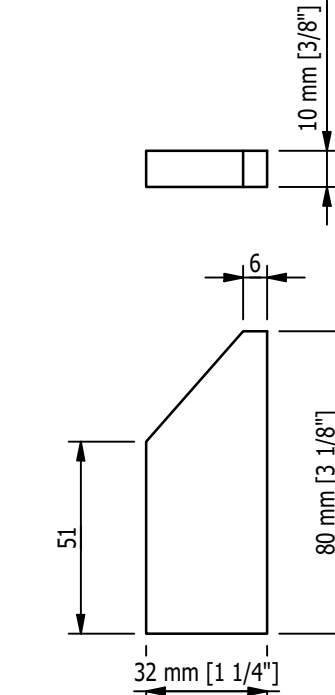
MK-D610B ~ ATTACHMENT WELDMENT
SCALE 3"=1'-0"



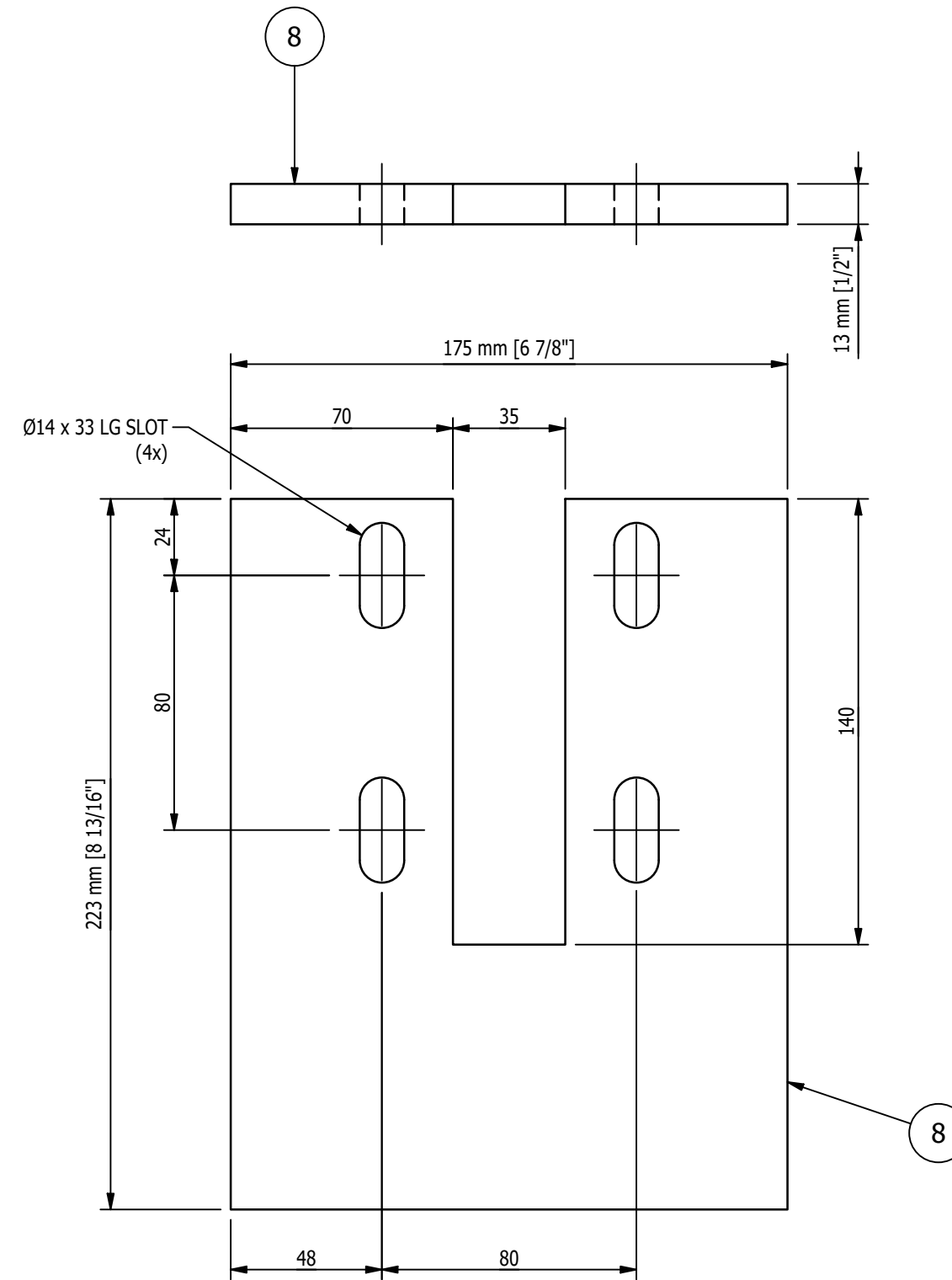
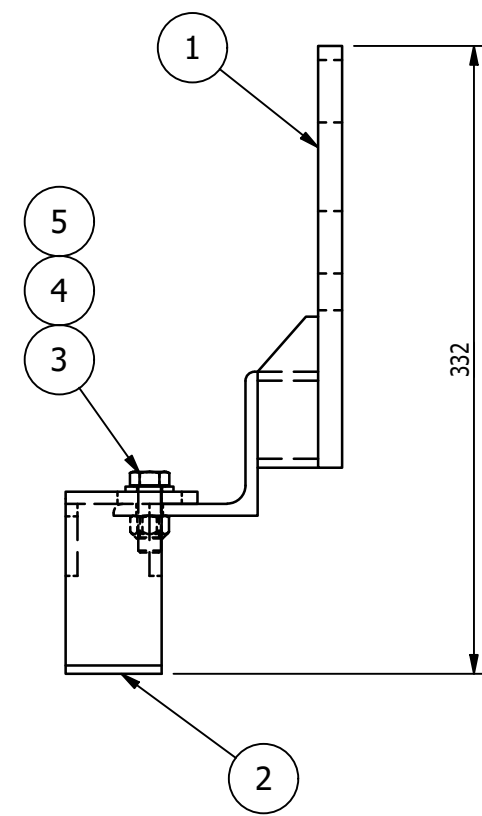
SECTION 'B-B'
SCALE 3"=1'-0"



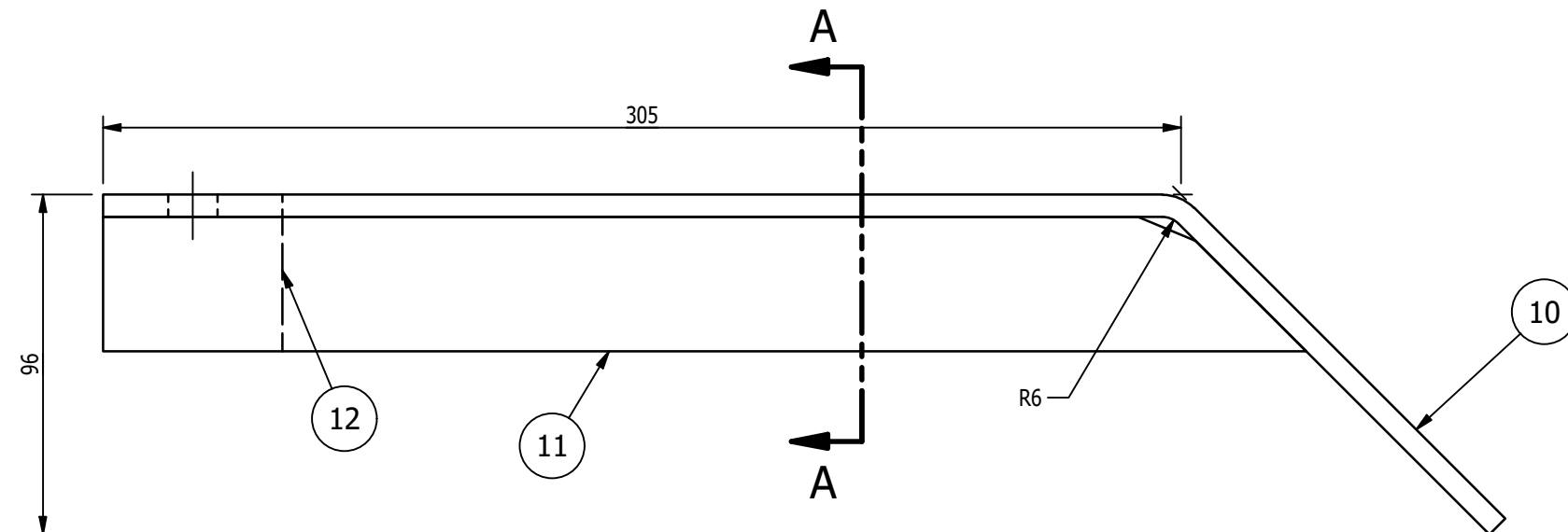
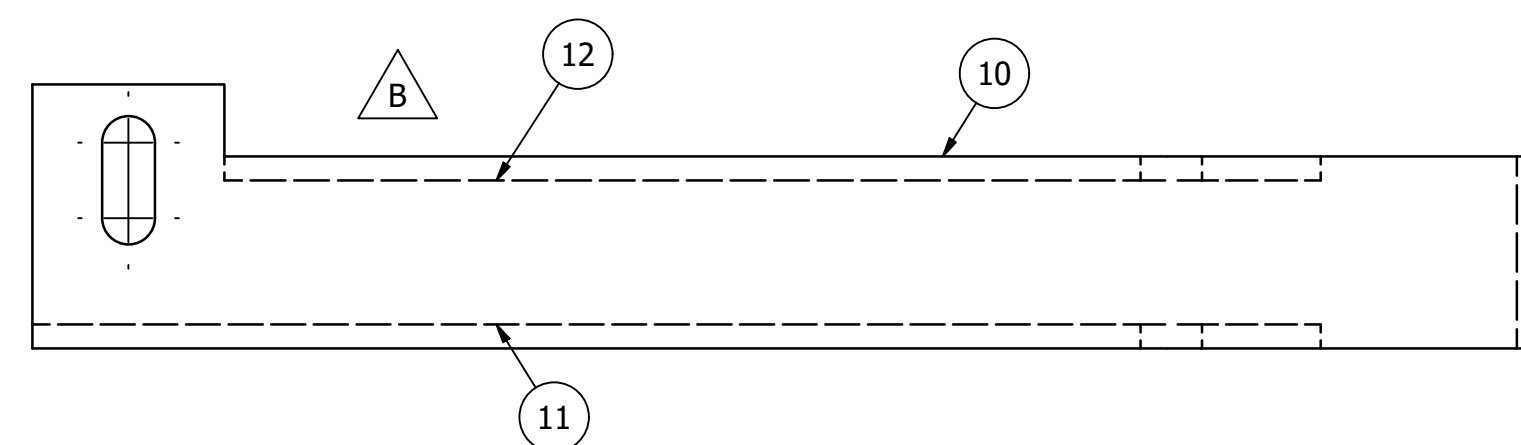
MK-D610C ~ TRIGGER RAMP
SCALE 6"=1'-0"



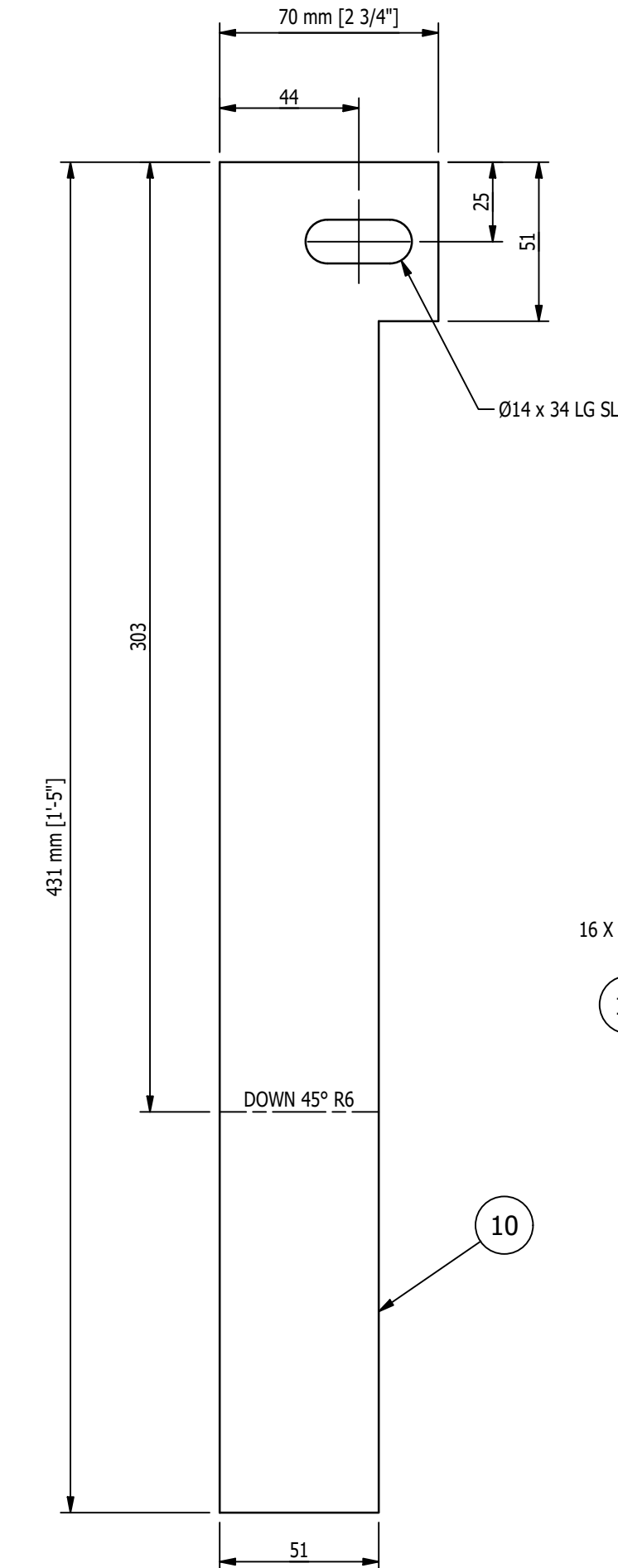
DETAIL OF ITEM '9'
SCALE 6"=1'-0"



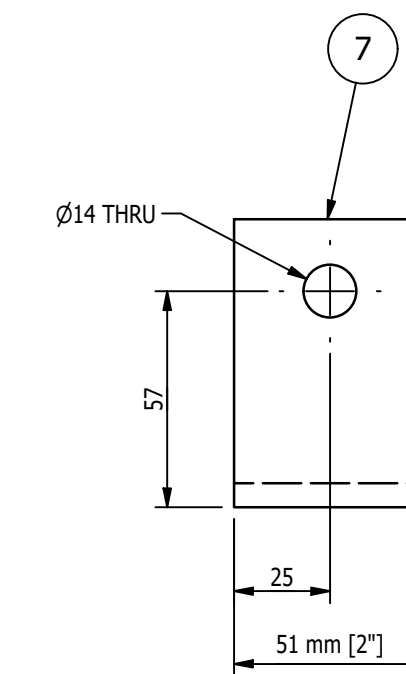
DETAIL OF ITEM '8'
SCALE 6"=1'-0"



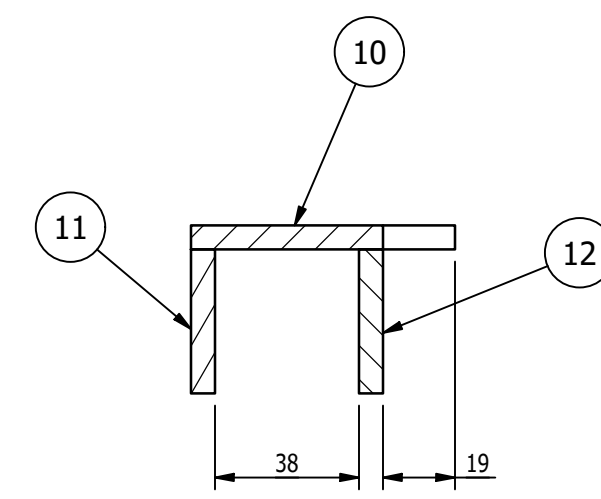
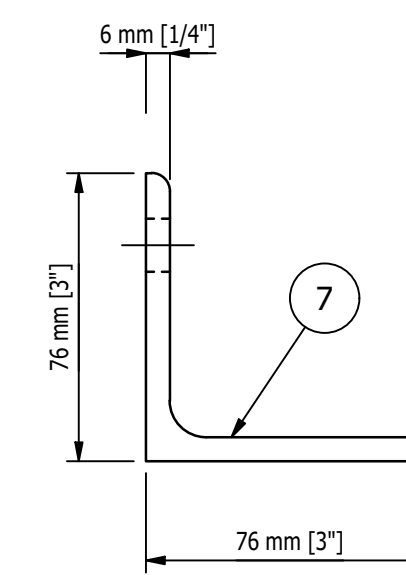
MK-D610C ~ TRIGGER RAMP
SCALE 6"=1'-0"



FLAT PATTERN OF ITEM '10'
SCALE 6"=1'-0"



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



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

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

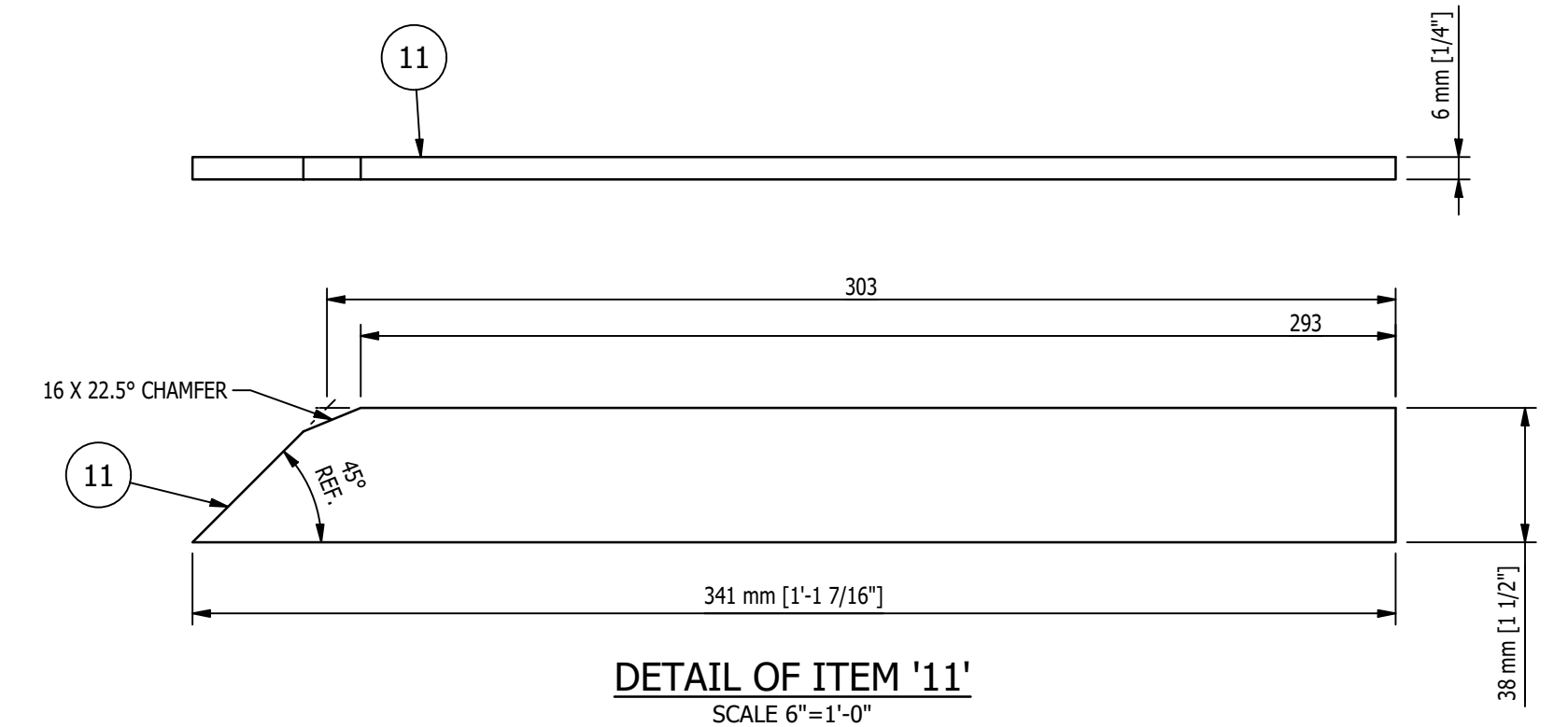
41100 Southfield Rd.
Suite 125
West, MI 48375

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

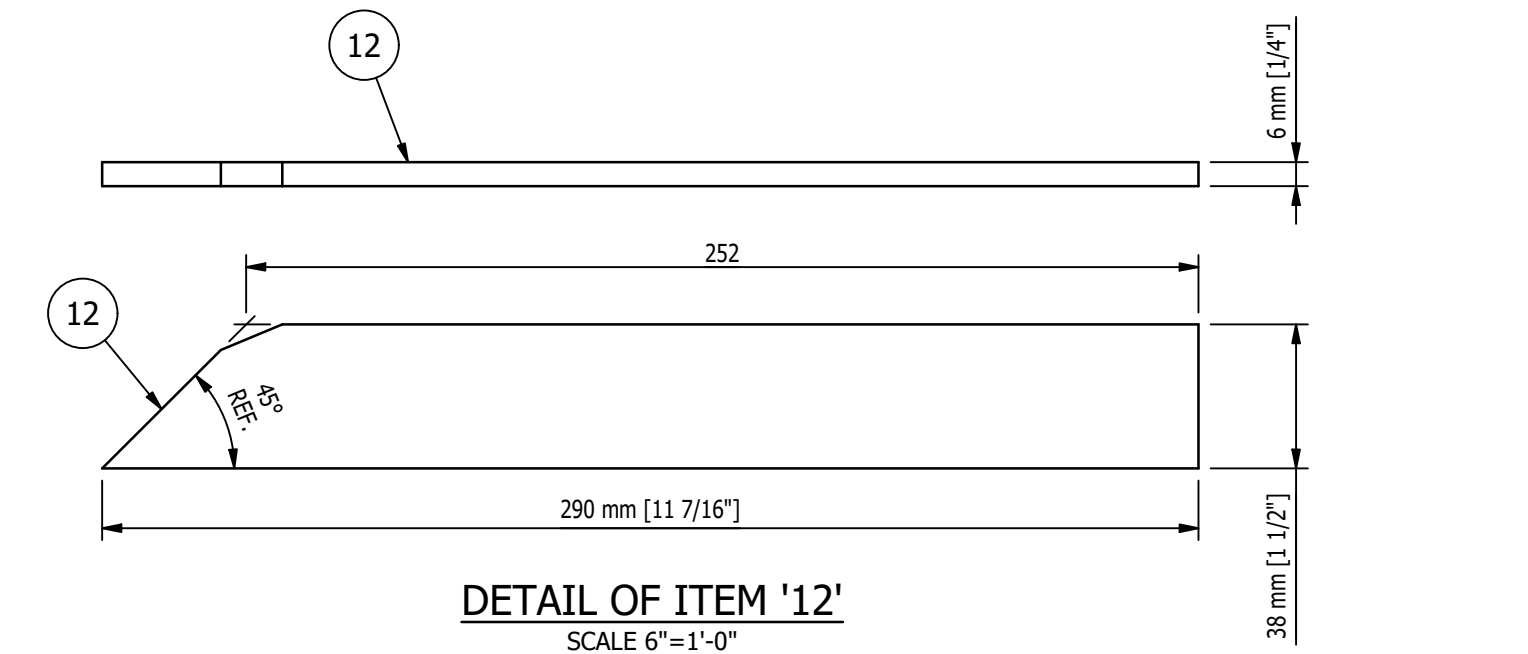
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D610 - REV B

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-D610A			
1	1	MK-D610B ~ ATTACHMENT WELDMENT			
2	1	MK-D610C ~ TRIGGER RAMP			
3	1	M12x1.75 x 35mm LG. HEX CAP SCREW			
4	1	M12 NARROW FLAT WASHER			
5	1	M12 x 1.75 STOVER LOCK NUT			
		MK-D610B			
6	1	TS 2 x 2 x 3/16	1 1/4"		
7	1	L 3 x 3 x 1/4	2"		
8	1	PL 1/2 x 6 7/8"	8 13/16"		
9	2	PL 3/8 x 1 1/4"	3 1/8"		
		MK-D610C			
10	1	PL 1/4 x 2 3/4"	1'-5"		
11	1	PL 1/4 x 1 1/2"	1'-1 7/16"		
12	1	PL 1/4 x 1 1/2"	11 7/16"		



DETAIL OF ITEM '11'
SCALE 6"=1'-0"



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

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

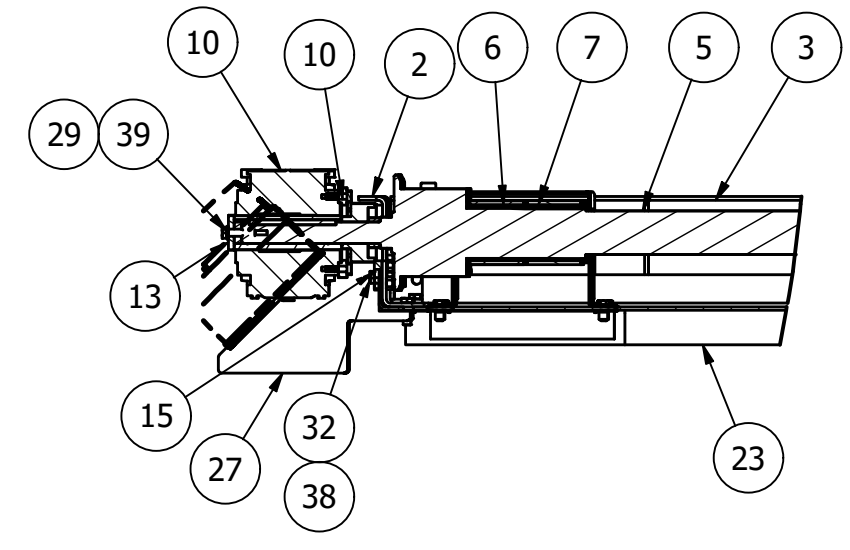
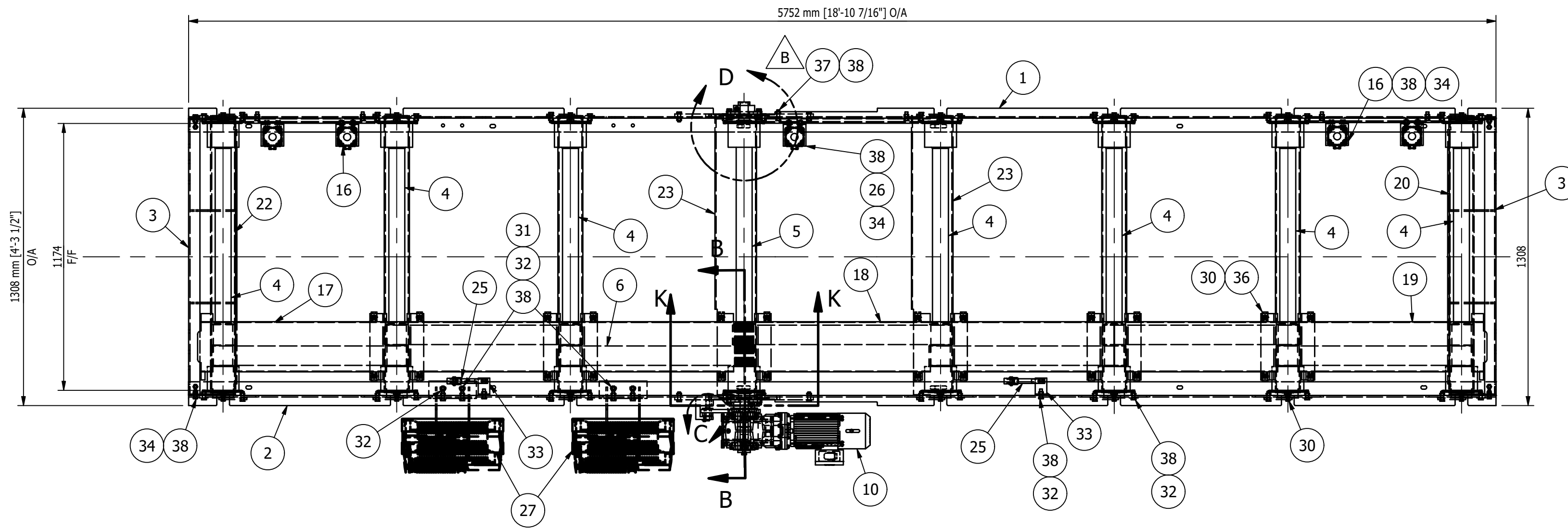
- PAINT NOTES:**
- PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
 - DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/10/22	ADDED TOP VIEW MK-D610C	
A	MC	9/16/22	FOR FABRICATION	

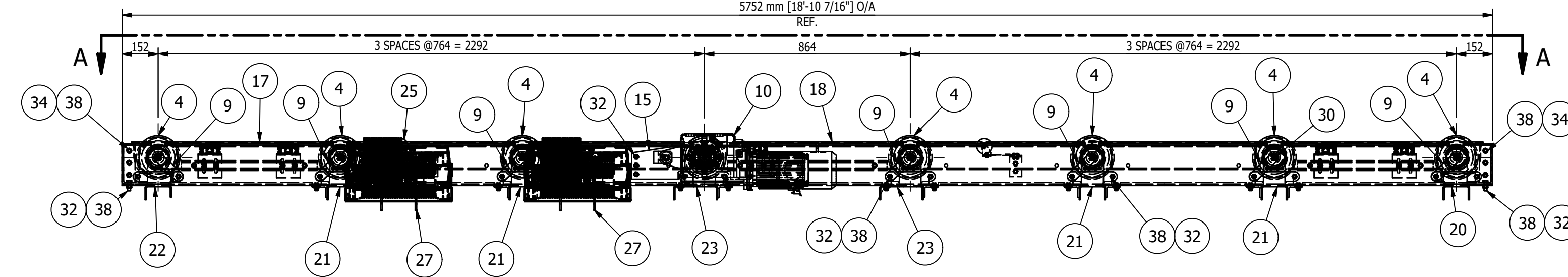
REVISION HISTORY

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

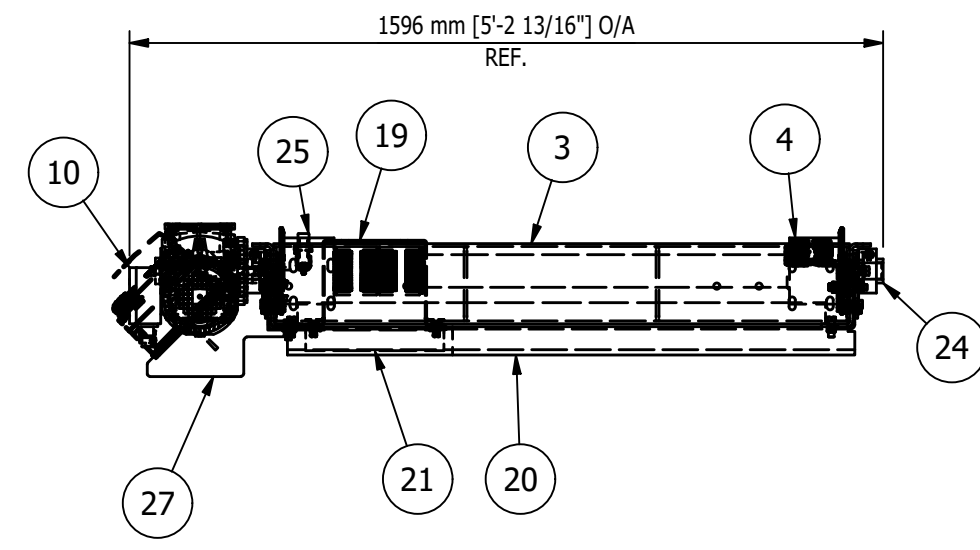
TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D610	DWG DATE: 7/29/22
REV: A	JOB No: 22096



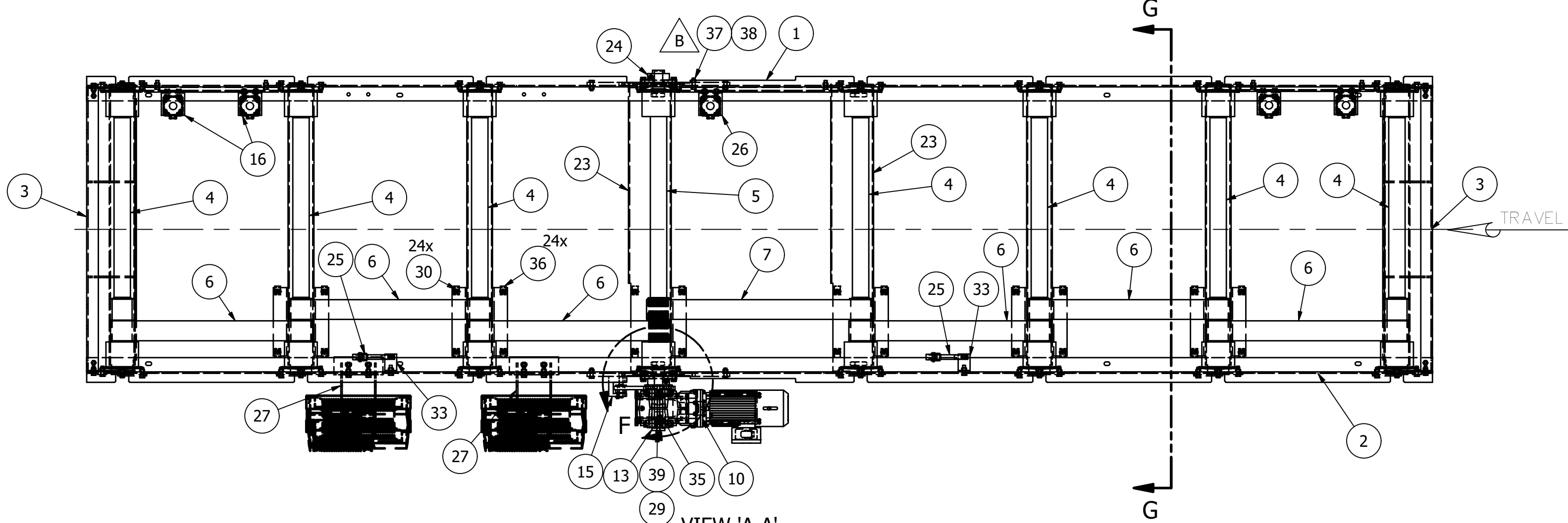
SECTION 'B-B'
SCALE 1"=1'-0"



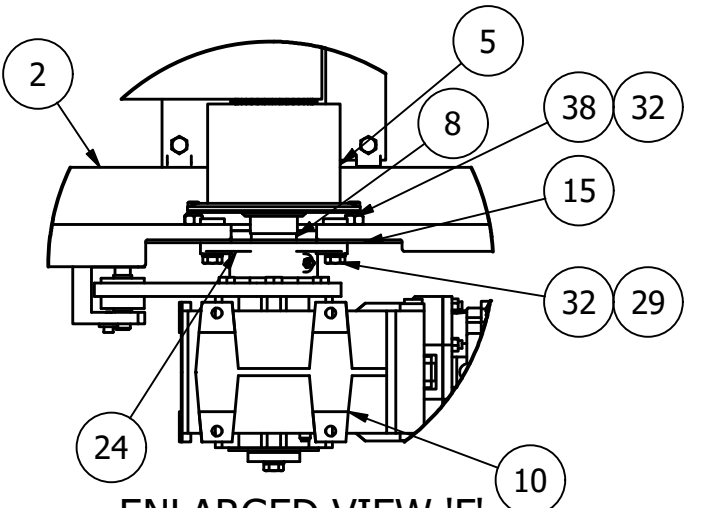
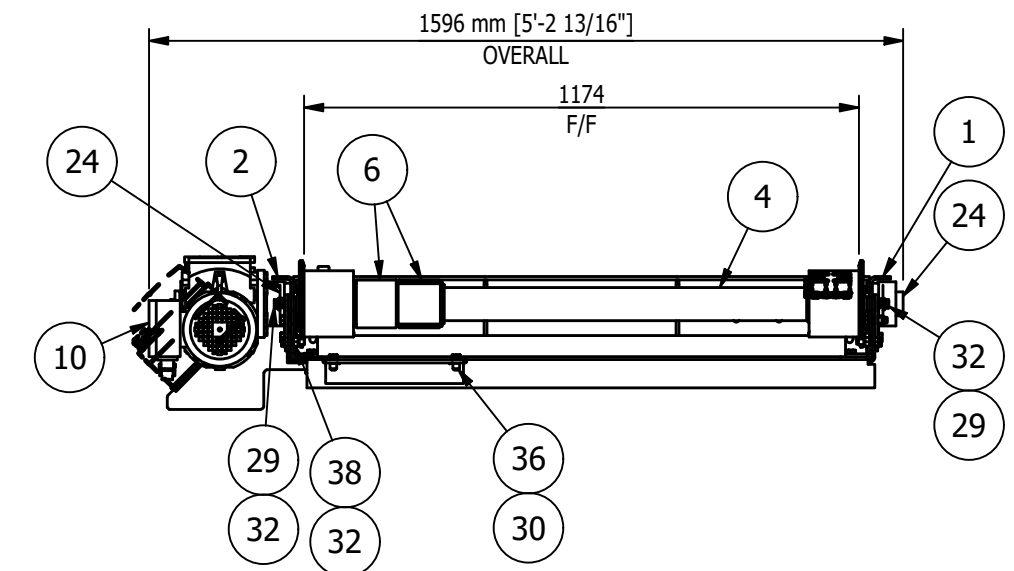
MK-D611A ~ 8-ROLL VDL ROLL BED
SCALE 3/4"=1'-0"



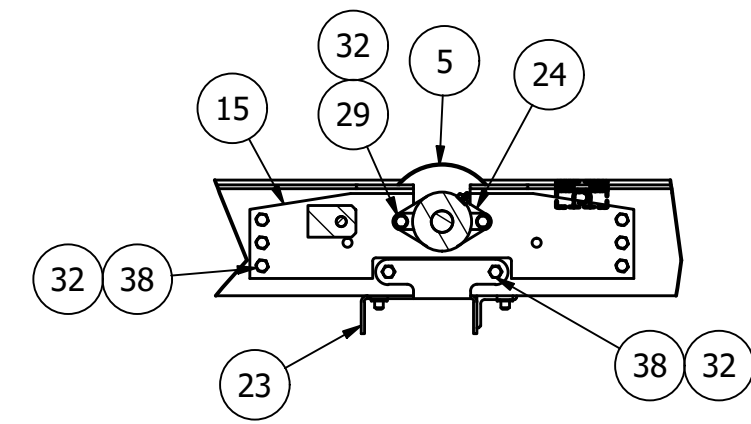
SECTION 'G-G'
SCALE 3/4"=1'-0"



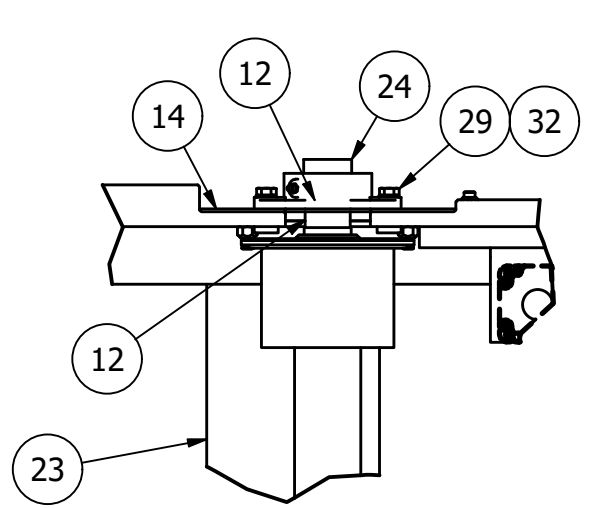
VIEW 'A-A'
(BELT COVERS REMOVED FOR CLARITY)
SCALE 3/4"=1'-0"



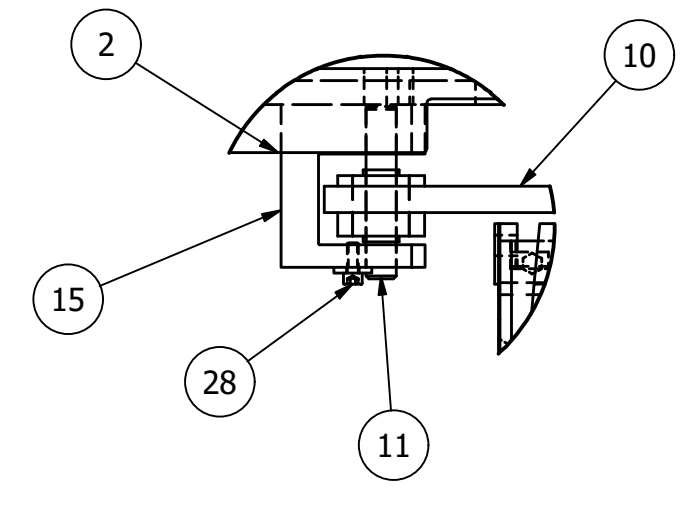
ENLARGED VIEW 'F'
SCALE 1 1/2" = 1'-0"



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



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



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
	1	MK-D611A			
1	1	MK-D612A ~ 8-ROLL VDL SIDE FRAME ASSY - RH			
2	1	MK-D612B ~ 8-ROLL VDL SIDE FRAME ASSY - LH			
3	2	MK-D601A ~ END PLATE ASSEMBLY			
4	7	PALLET DRIVEN ROLLER, DUGOMRULLI PART NO 329638V			
5	1	PALLET DRIVER ROLLER, DUGOMRULLI PART NO 332192V M12			
6	6	GATES POWERGRIP GT4 BELT, 1800-8M-GT85		2-3	
7	1	GATES POWERGRIP GT4 BELT, 2000-8M-GT85		2-2	
8	1	MK-D005D ~ SHAFT SPACER			
9	14	MK-D005B ~ ROLL KEEPER			
10	1	SIEMENS RB2 GEARMOTOR (SEE MOTOR DATA LIST)		1-2	
11	1	16 MM DIA. X 85 MM LG HEADLESS FIXTURE PIN HARDENED AND GROUND W/RETAINER ~ E&ESP #16-85-MHR		3-3	
12	1	MK-D005E ~ SHAFT SPACER			
13	1	MK-D005F ~ MOTOR END PLATE			
14	1	MK-D005C ~ BEARING PLATE			
15	1	MK-D005A ~ BEARING PLATE			
16	2	MK-D009D ~ PROX BRACKET			
17	1	MK-D010A ~ BELT GUARD			
18	1	MK-D010B ~ BELT GUARD			
19	1	MK-D010C ~ BELT GUARD			
20	1	MK-D613A ~ CROSS MEMBER			
21	4	MK-D613B ~ CROSS MEMBER WITH GUARD SUPPORT			
22	1	MK-D613C ~ CROSS MEMBER			
23	2	MK-D613D ~ CROSS MEMBER WITH GUARD SUPPORT			
24	2	PTI ~ OWFZ207X35A_35 MM SHAFT DIA., 2 BOLT FLANGE BEARING		3-1	
25	2	MK-D114A ~ STATIC WHEEL ASSEMBLY			
26	1	MK-D009C ~ PROX BRACKET			
27	2	MK-D614A ~ VDL CONTROLLER BRACKET			
28	1	M6x1 x 16mm LG. HEX SOCKET HEAD CAP SCREW			
29	5	M12 SPRING LOCK WASHER			
30	38	M10x1.5 x 25mm LG. HEX CAP SCREW			
31	8	M12 NARROW FLAT WASHER			
32	63	M12x1.75 x 35mm LG. HEX CAP SCREW			
33	2	MK-D005G ~ STATIC WHEEL BRACKET			
34	17	M12x1.75 x 30mm LG. HEX CAP SCREW			
35	1	10 x 8 x 140 LG. ROUNDED RECTANGULAR KEYSTOCK		16-1	
36	24	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
37	1	M12x1.75 x 40mm LG. HEX CAP SCREW			
38	77	M12 x 1.75 STOVER LOCK NUT			
39	1	M12x1.75 x 45mm LG. HEX CAP SCREW			

SPEED FORMULA (60HZ):

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

SHOP NOTES:

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/2022	ADDED MISSING BALLOON	
A	MC	8/26/22	FOR FABRICATION	

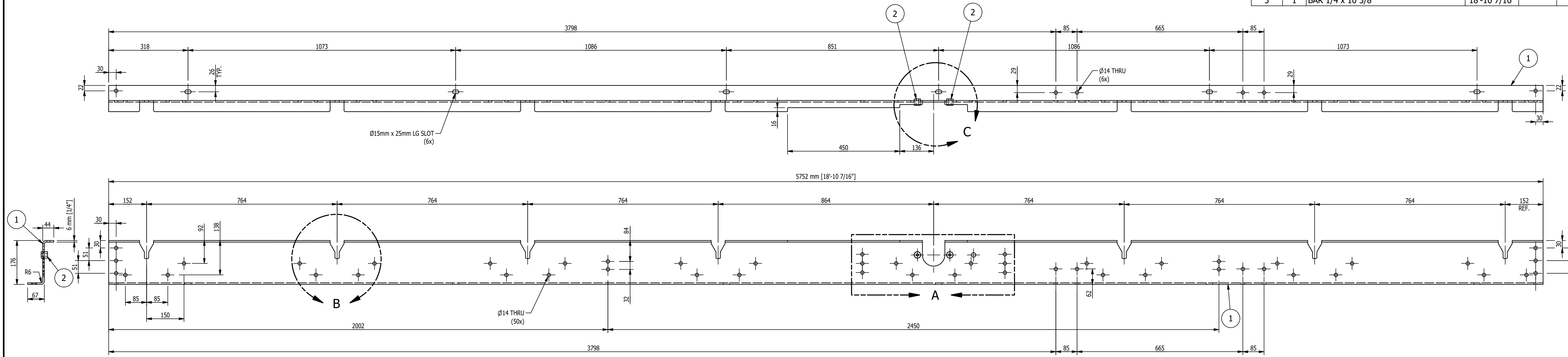
REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	<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. 1875D611 REV: B	DRAWN BY: JAC CHECKED BY: JCK DWG DATE: 8/8/2022 JOB No: 22096

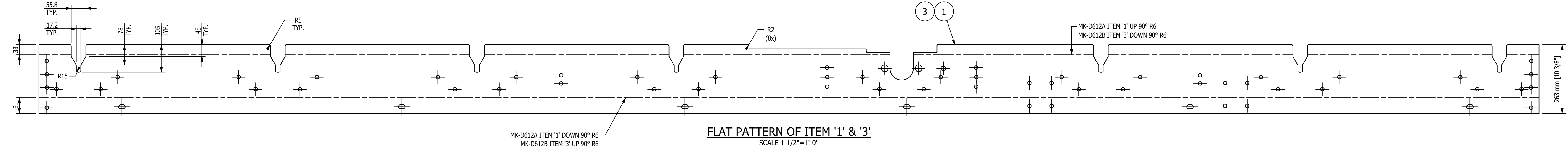
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO 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.
 COPES:
 - ALL REINTRANT CUTS TO BE A MIN 1/2" RADIUS U.N.O.

 41100 QuakerRoad Rd. Suite 125 West, MI 48375 Phone: (248) 772-8833 Fax: (248) 772-8851 Web: www.mmagnum.com	UNLESS OTHERWISE NOTED: X = ±.060 XX = ±.030 XXX = ±.005 FRACTIONS = ±1/16" ANGLES = ±1°30' BREAK ALL SHARP EDGES DEBURR ALL HOLES DO NOT SCALE DRAWING
MAGNUM JOB #: 1875 MAGNUM DRAWING #: 1875D611	

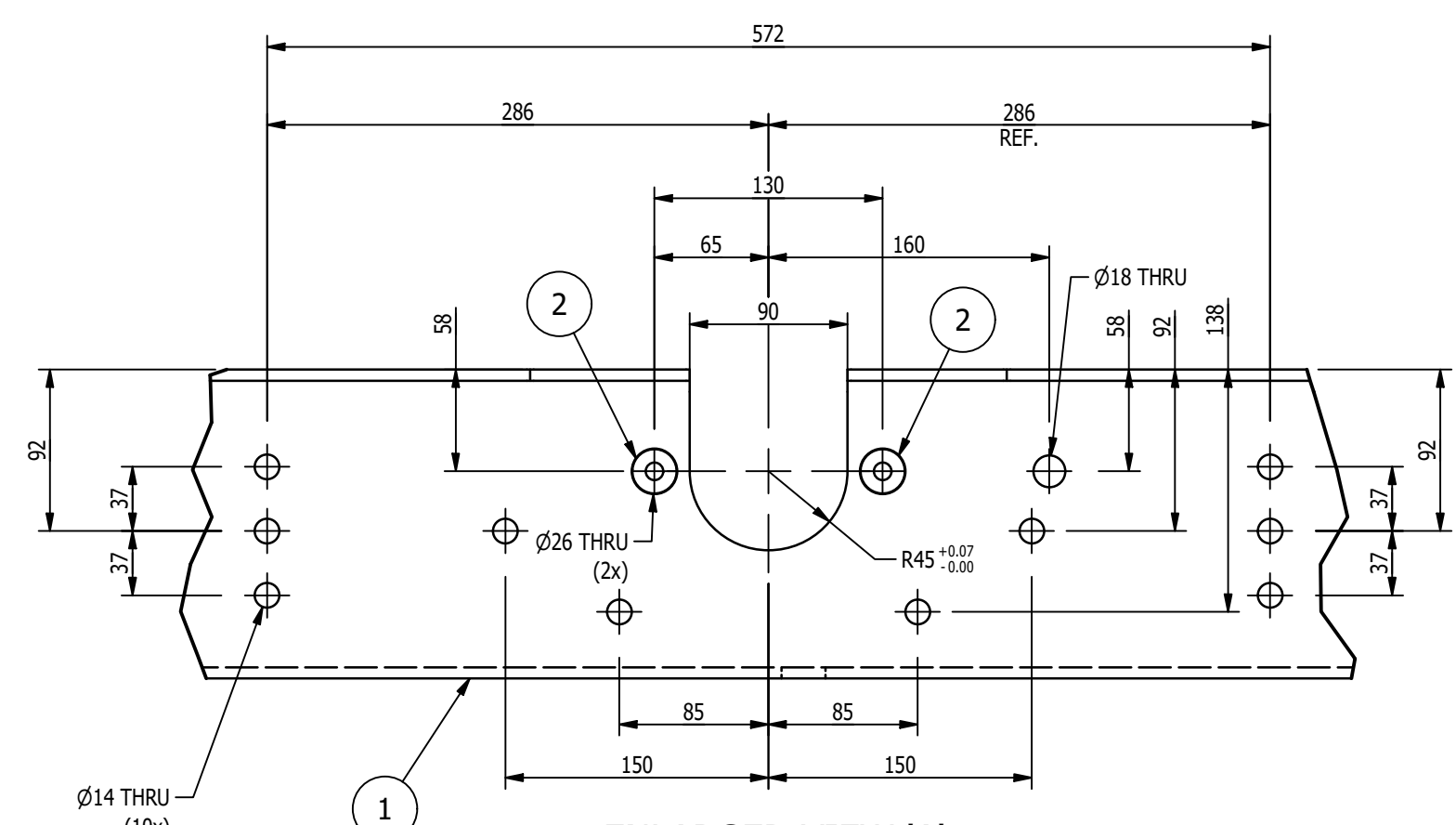
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D612A			
1	1	BAR 1/4 x 10 3/8	18'-10 7/16"		
2	2	PL 1 x 1"	1"		
		MK-D612B			
2	2	PL 1 x 1"	1"		
3	1	BAR 1/4 x 10 3/8	18'-10 7/16"		



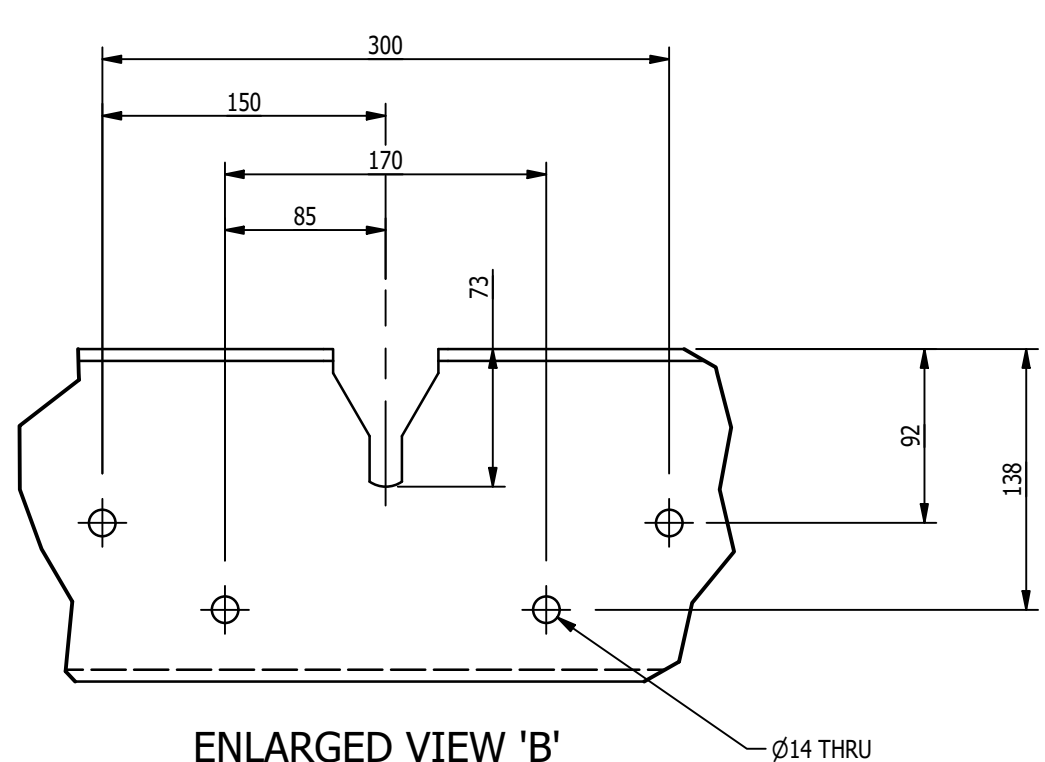
MK-D612A ~ 8-ROLL VDL SIDE FRAME ASSY - RH (SHOWN)
 MK-D612B ~ 8-ROLL VDL SIDE FRAME ASSEMBLY - LH (OPPOSITE)
 SCALE 1 1/2"=1'-0"



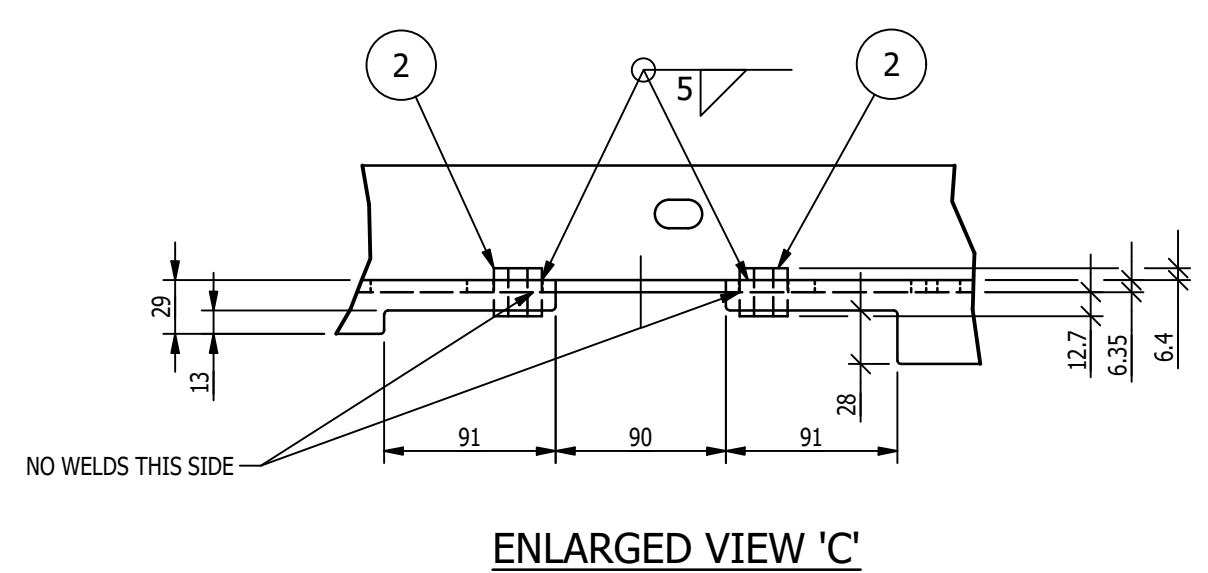
FLAT PATTERN OF ITEM '1' & '3'
 SCALE 1 1/2"=1'-0"



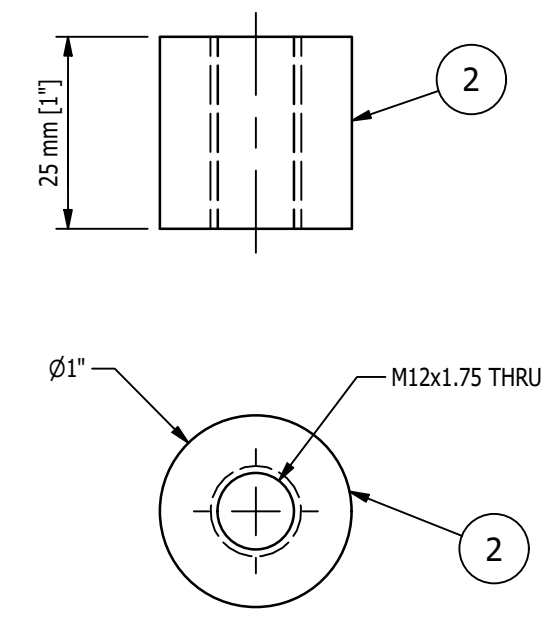
ENLARGED VIEW 'A'
 SCALE 3"=1'-0"



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



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



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

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

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

MAGNUM CONSULTING

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

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D612 - REV A

UNLESS OTHERWISE NOTED:
 X = ± 0.06
 XX = ± 0.030
 XXX = ± 0.005
 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
A	MC	8/26/22	FOR FABRICATION	

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
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 www.millc.com

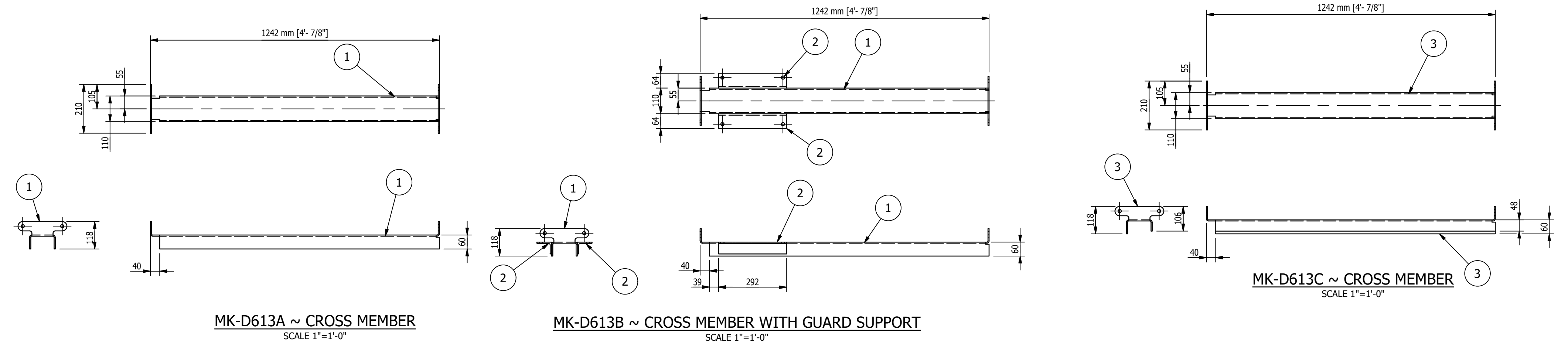
TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D612

REVISION HISTORY

REV	BY	DATE	DESCRIPTION	APP
A	MC	8/26/22	FOR FABRICATION	

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

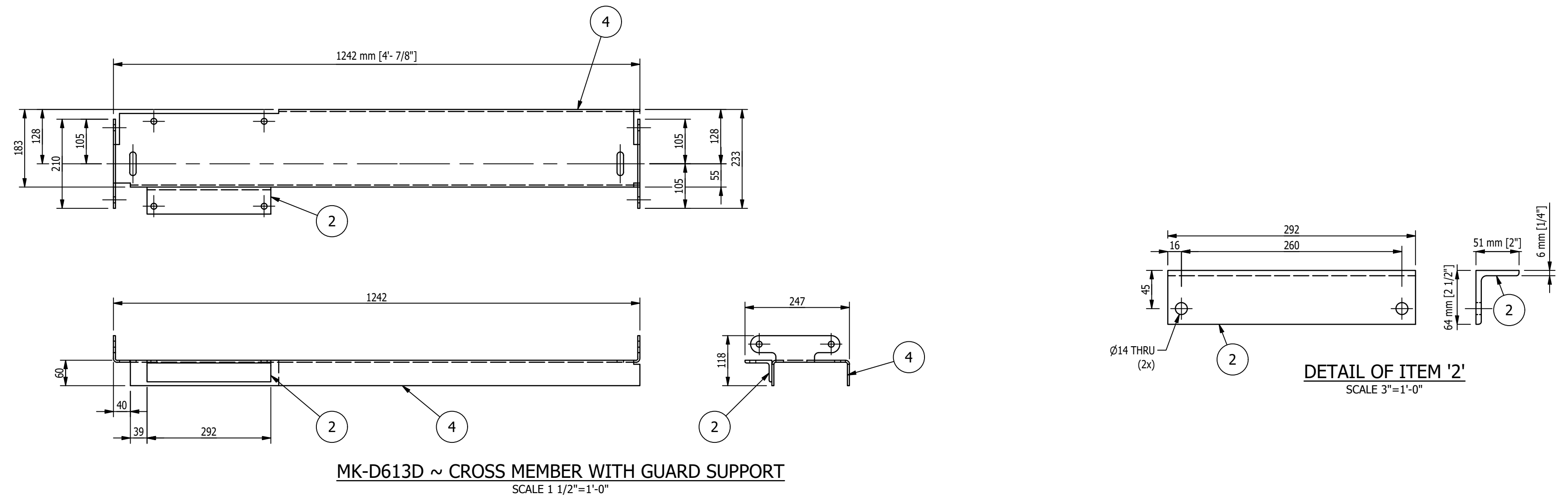
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D613A PL 3/16 x 8 5/16	4'-5 1/8"		
		MK-D613B			
1	1	PL 3/16 x 8 5/16	4'-5 1/8"		
2	2	L 2 1/2 x 2 x 1/4	11 1/2"		
		MK-D613C			
3	1	PL 3/16 x 8 5/16	4'-5 1/8"		
		MK-D613D			
2	1	L 2 1/2 x 2 x 1/4	11 1/2"		
4	1	PL 3/16 x 11 3/16	4'-5 1/8"		



MK-D613A ~ CROSS MEMBER
SCALE 1"=1'-0"

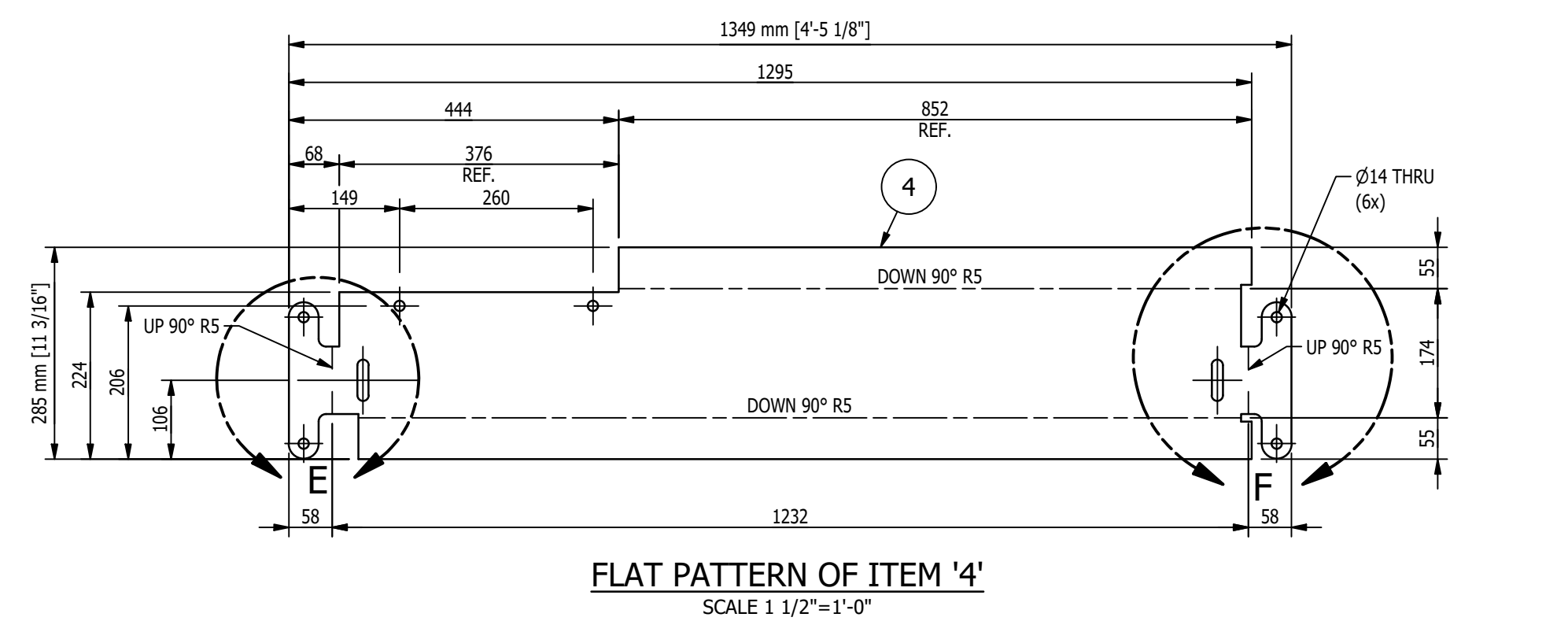
MK-D613B ~ CROSS MEMBER WITH GUARD SUPPORT
SCALE 1"=1'-0"

MK-D613C ~ CROSS MEMBER
SCALE 1"=1'-0"

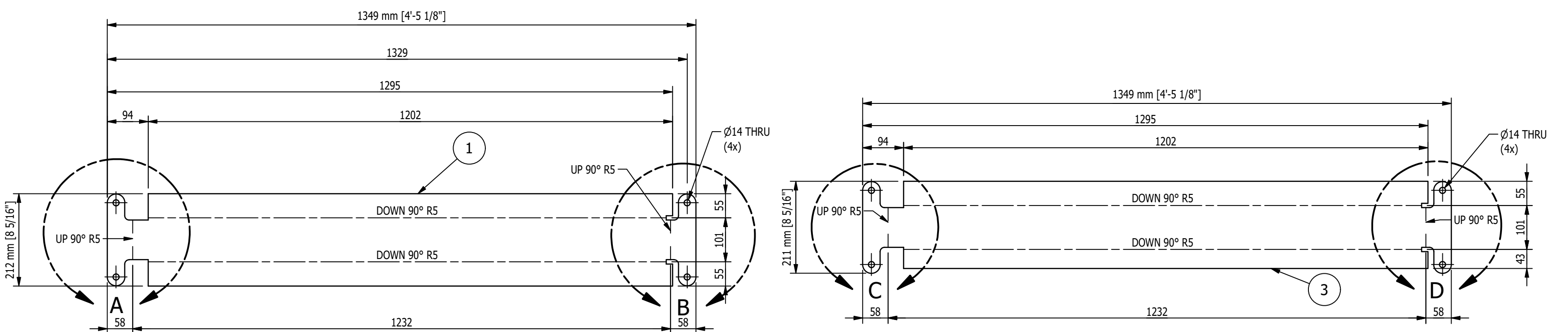


MK-D613D ~ CROSS MEMBER WITH GUARD SUPPORT
SCALE 1 1/2"=1'-0"

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

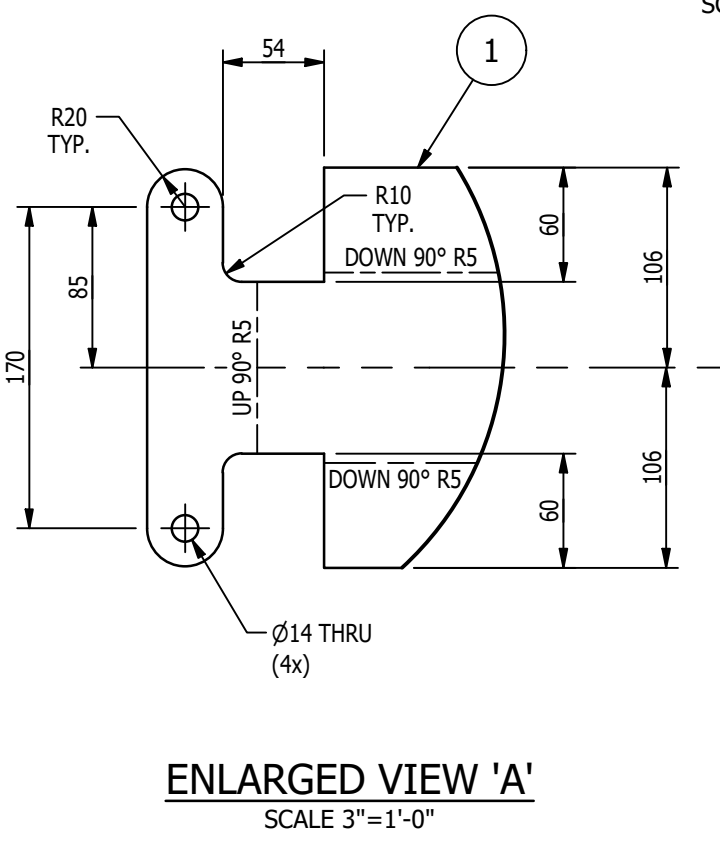


FLAT PATTERN OF ITEM '4'
SCALE 1 1/2"=1'-0"

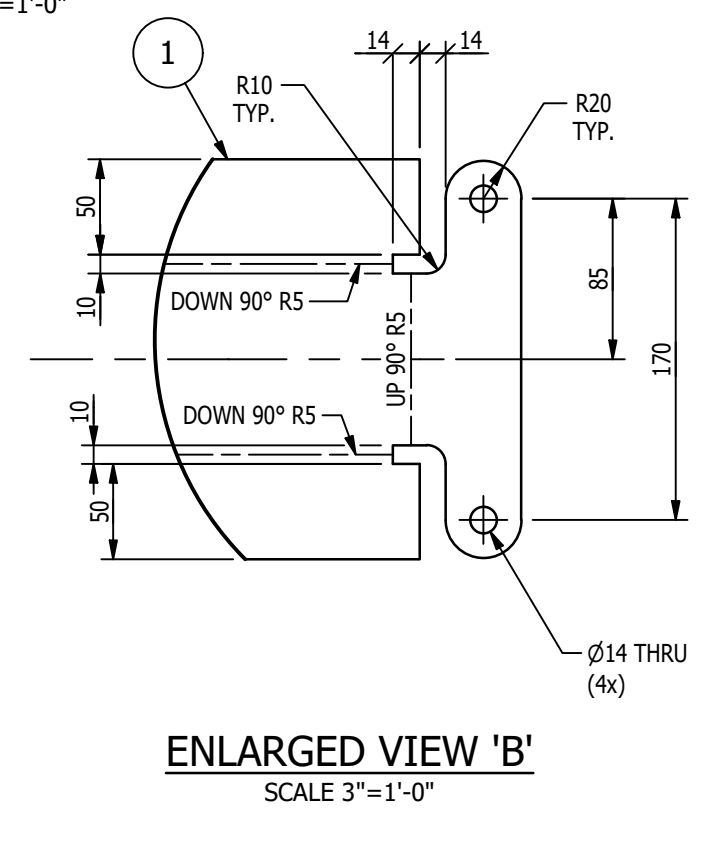


FLAT PATTERN OF ITEM '1'
SCALE 1 1/2"=1'-0"

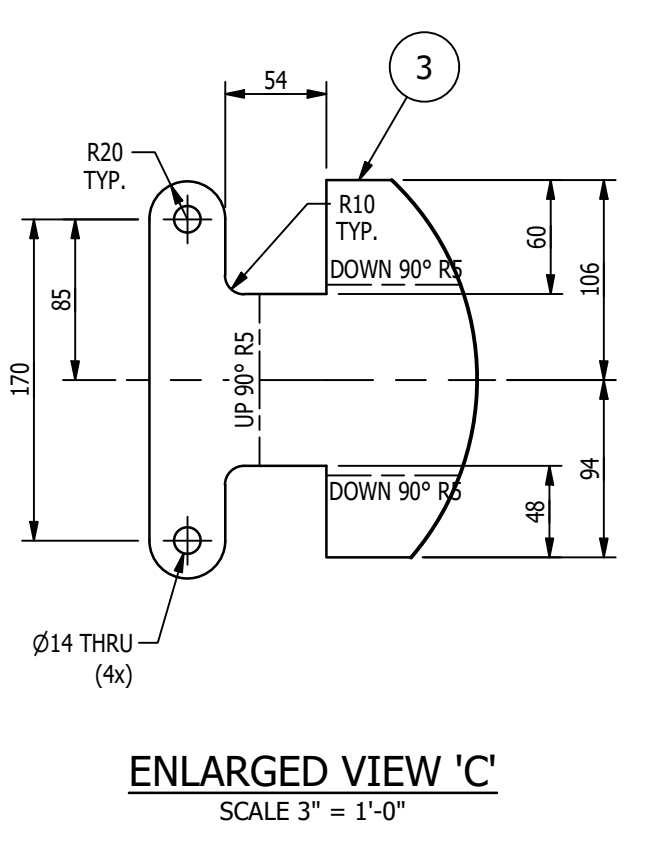
FLAT PATTERN OF ITEM '3'
SCALE 1 1/2"=1'-0"



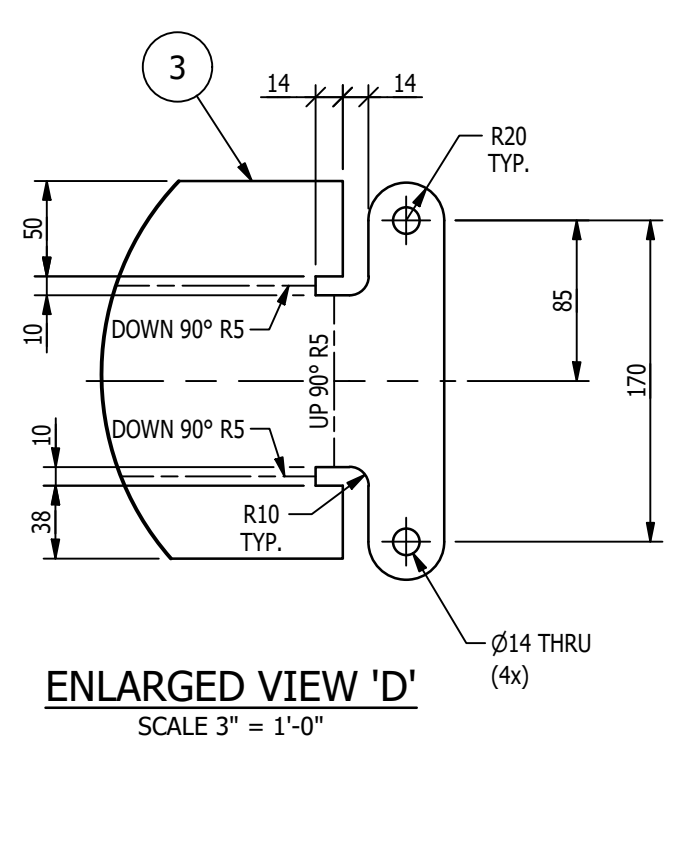
ENLARGED VIEW 'A'
SCALE 3"=1'-0"



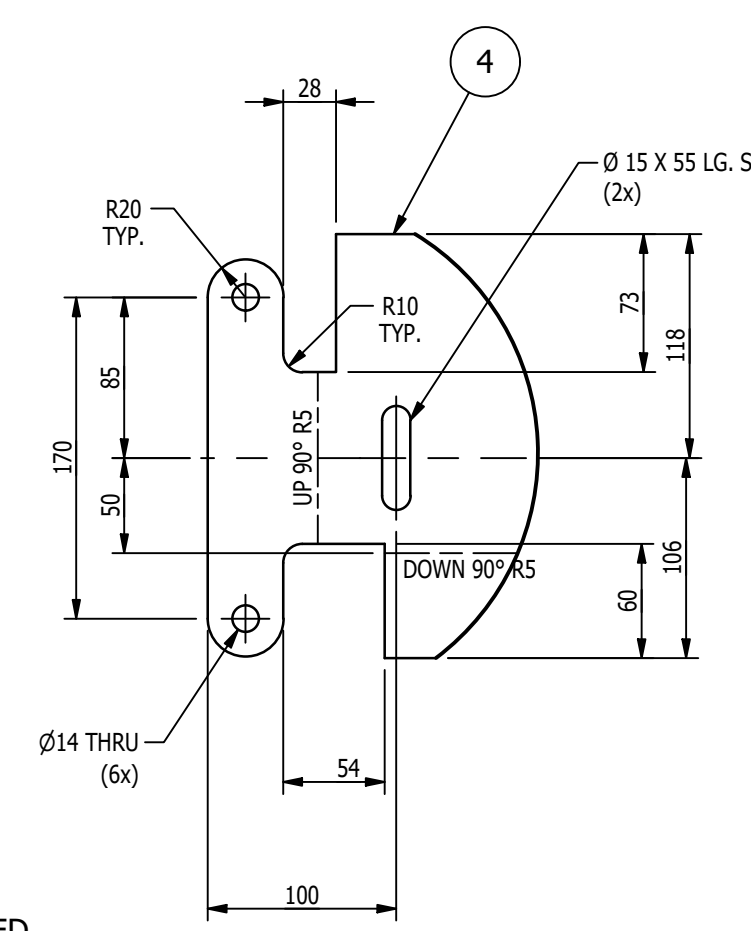
ENLARGED VIEW 'B'
SCALE 3"=1'-0"



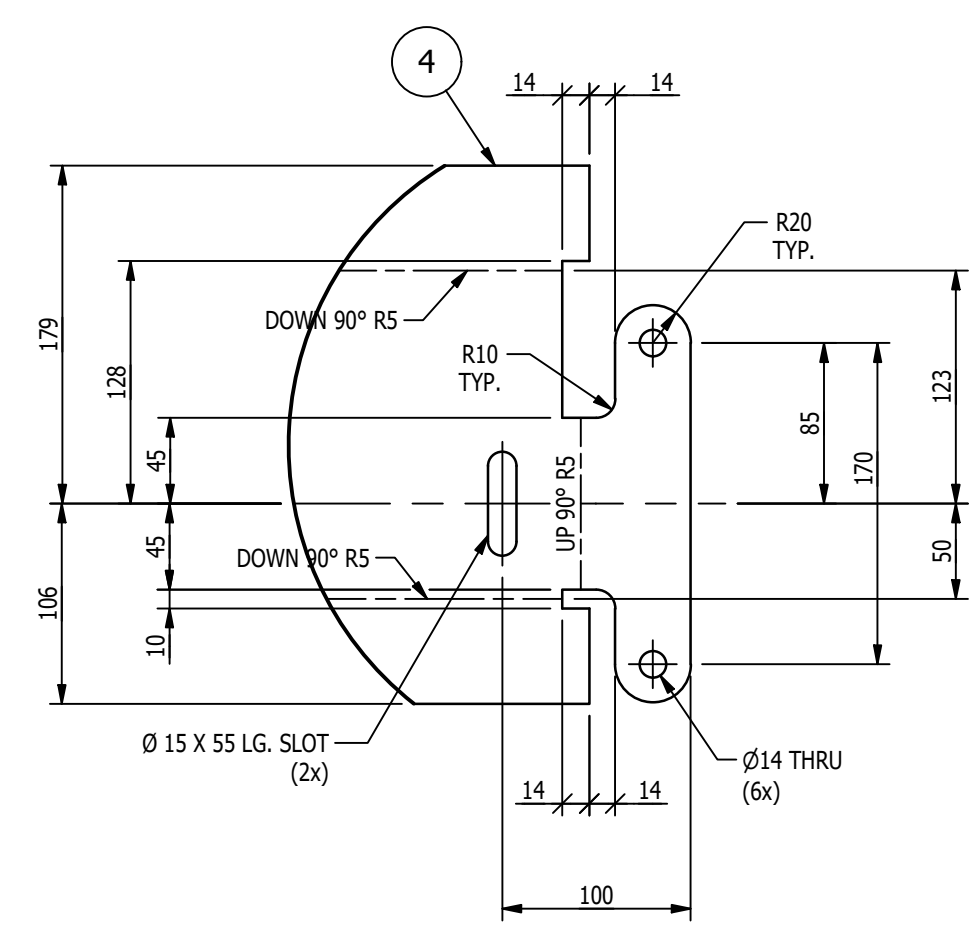
ENLARGED VIEW 'C'
SCALE 3"=1'-0"



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



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



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

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

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

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

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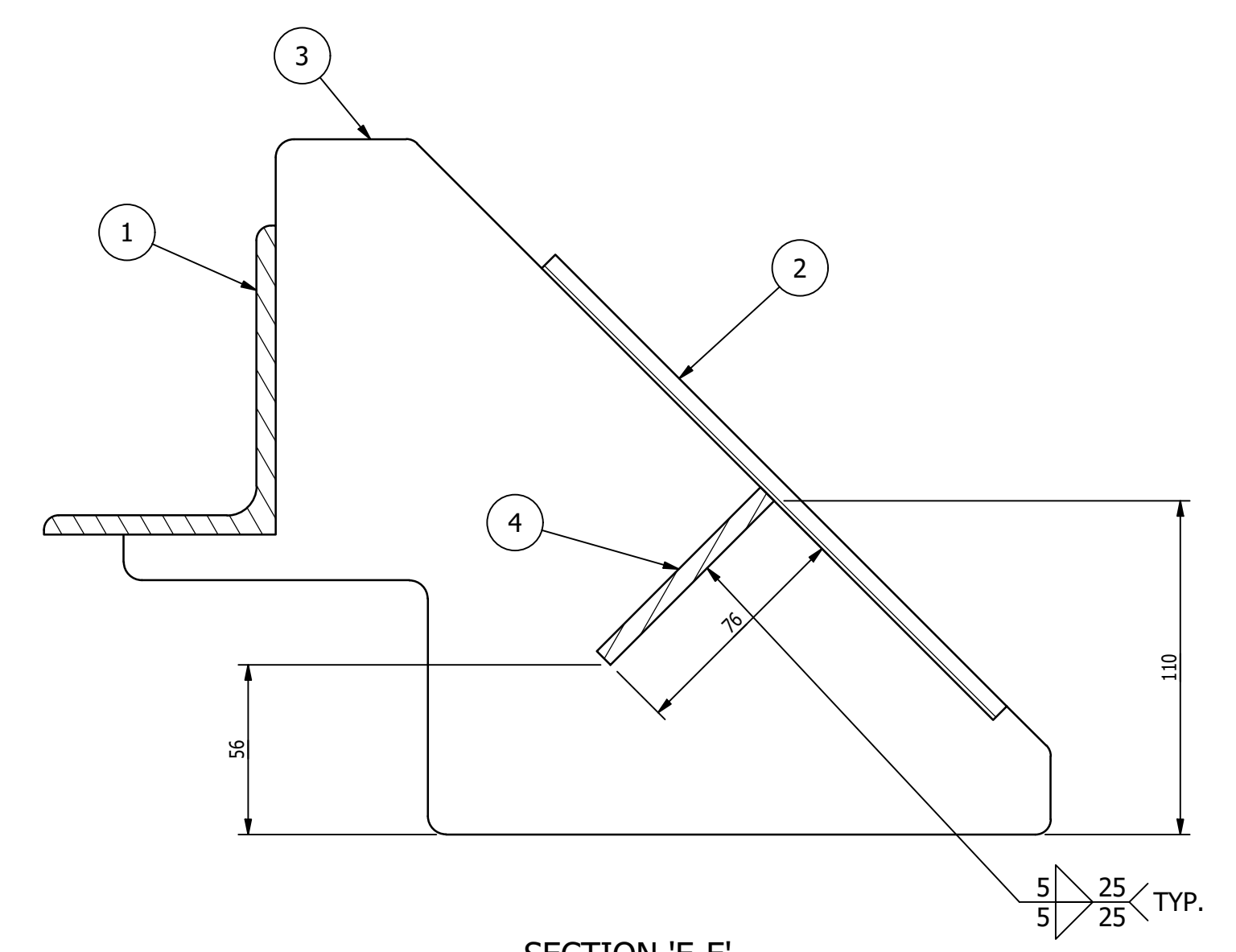
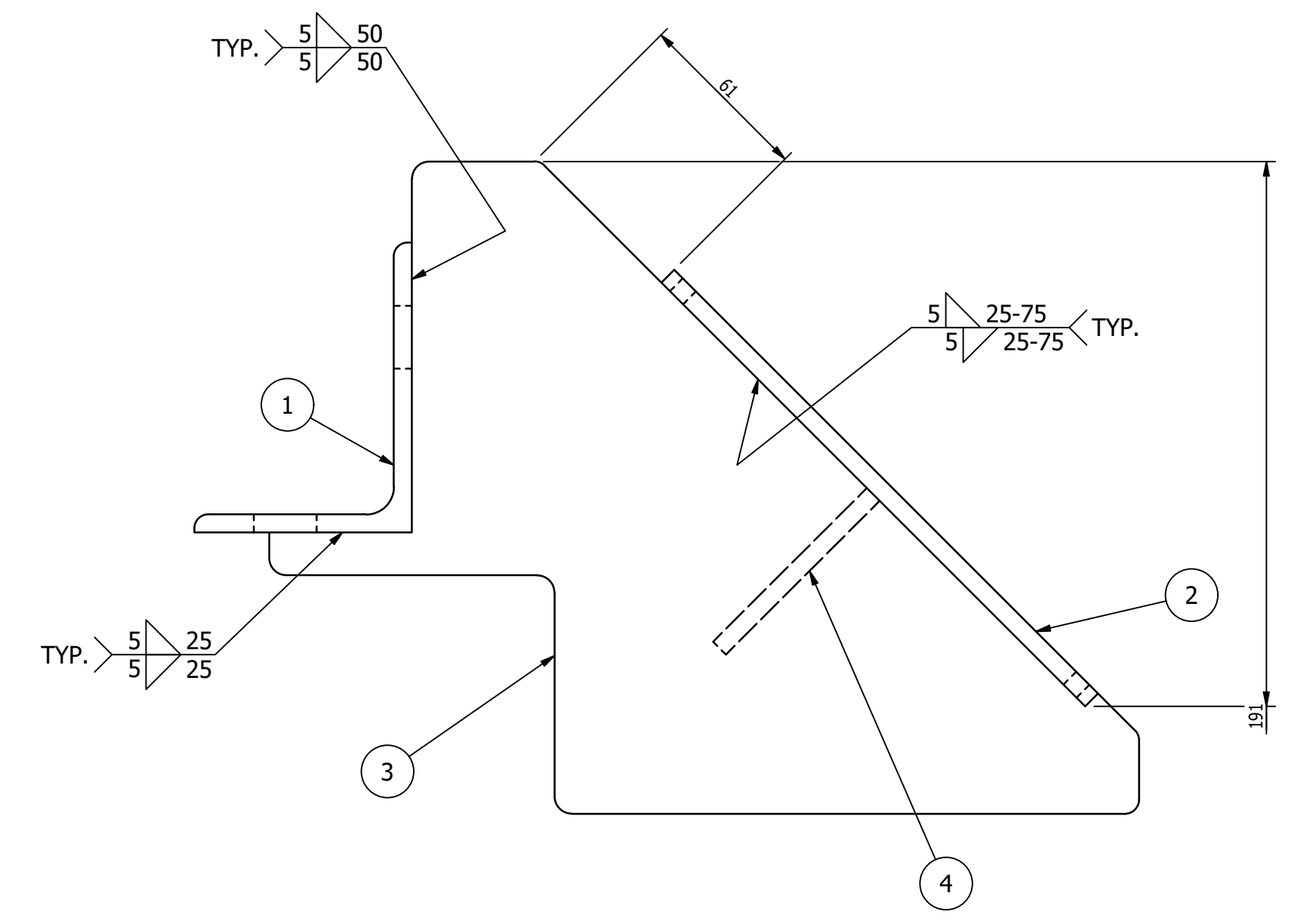
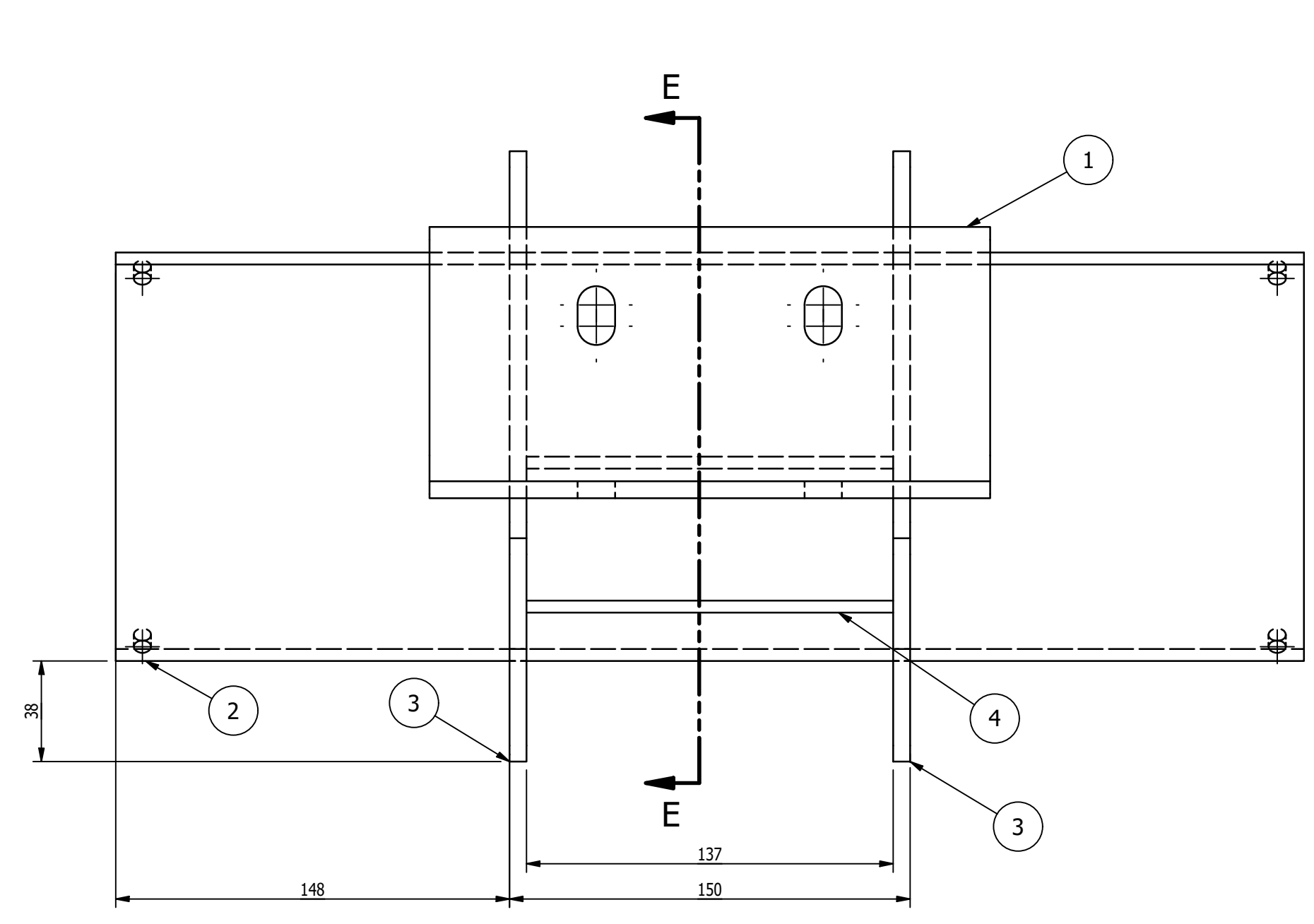
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D613 - REV A

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

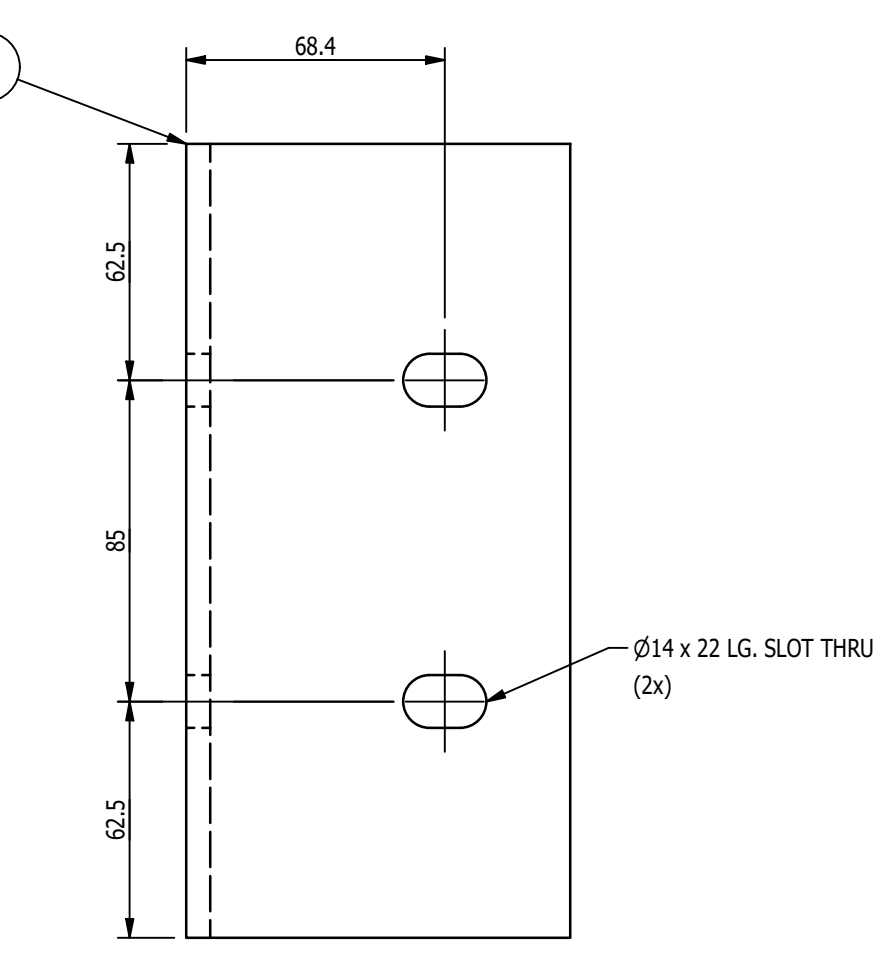
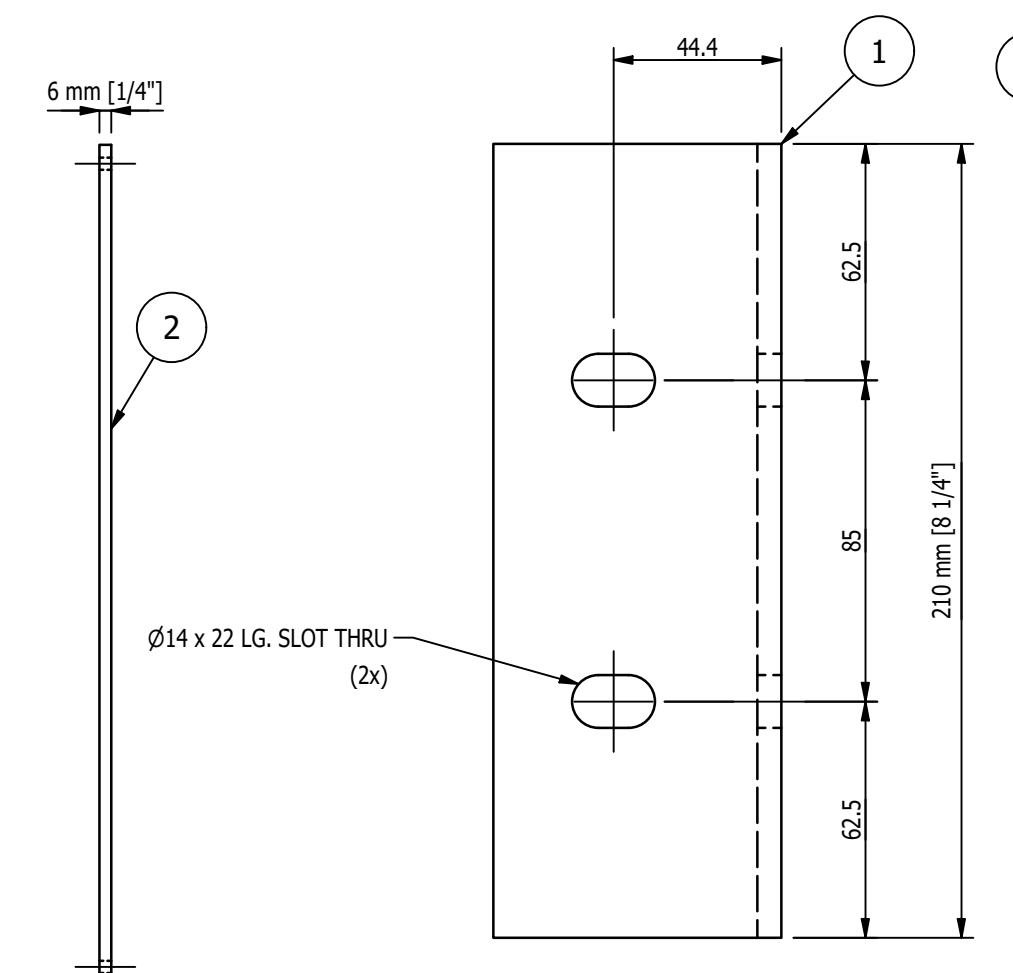
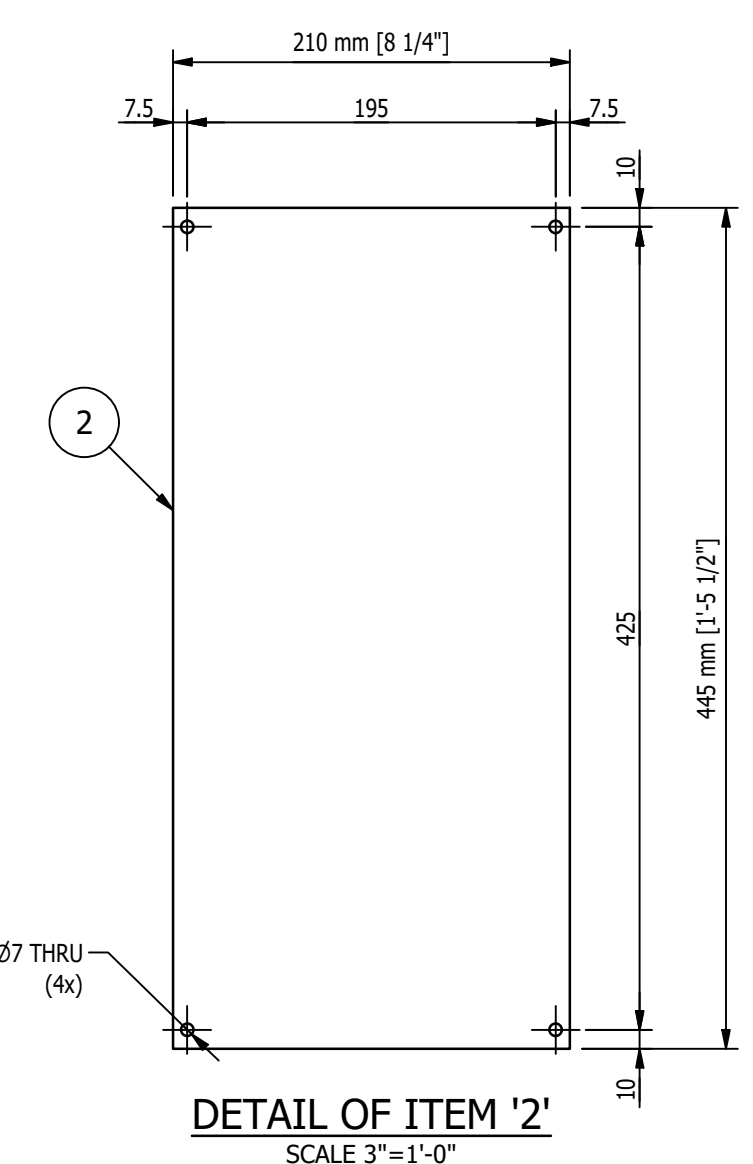
REV	BY	DATE	DESCRIPTION	APP
A	MC	8/26/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: RJB	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	CHECKED BY:	CW
CLIENT:	VOLVO	DWG DATE:	8/8/22
DRAWING No.	1875D613	REV:	A
		JOB No:	22096

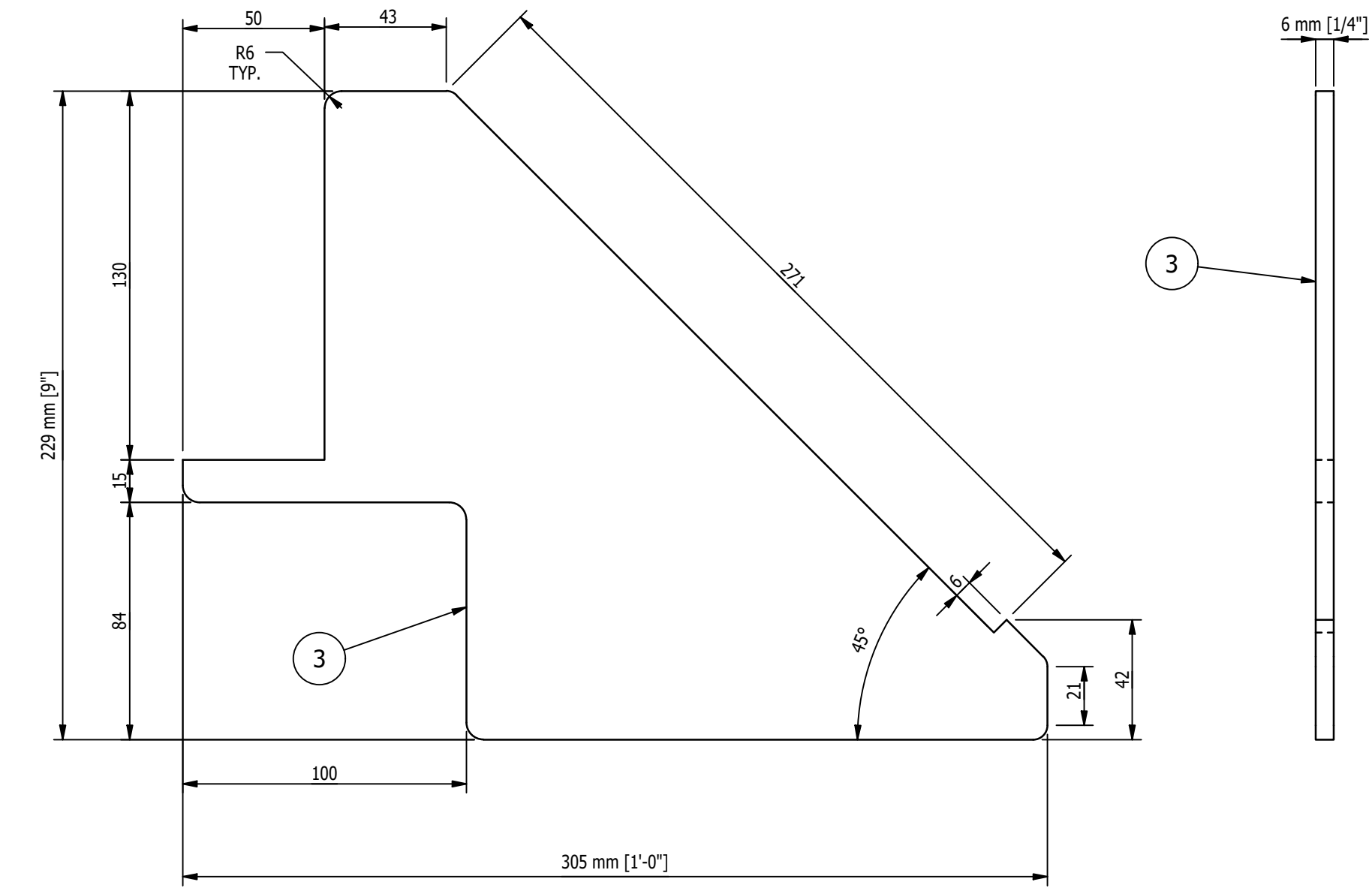
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D614A			
1	1	L 4 x 3 x 1/4	8 1/4"		
2	1	PL 1/4 x 8 1/4"	1'-5 1/2"		
3	2	PL 1/4 x 9"	1'-0"		
4	1	PL 1/4 x 3"	5 3/8"		



MK-D614A ~ VDL CONTROLLER BRACKET
SCALE 6"=1'-0"



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



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

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

MAGNUM Consulting
41100 Dardick Road
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Phone: (248) 772-8822
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MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D614 - REV A

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

GENERAL NOTES:

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

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

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

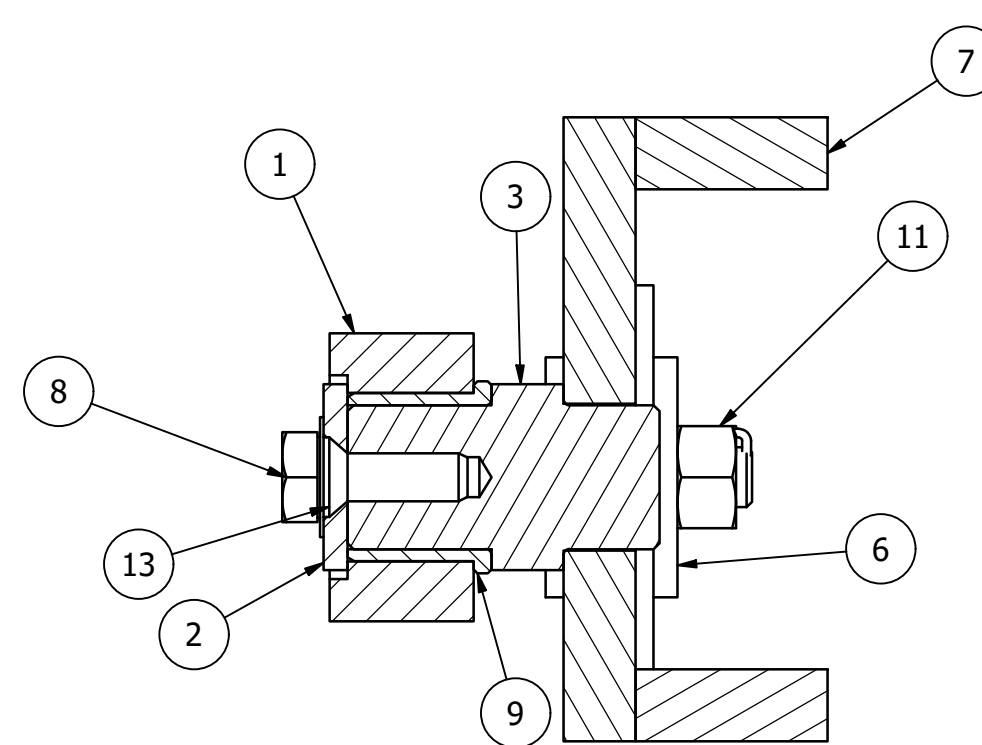
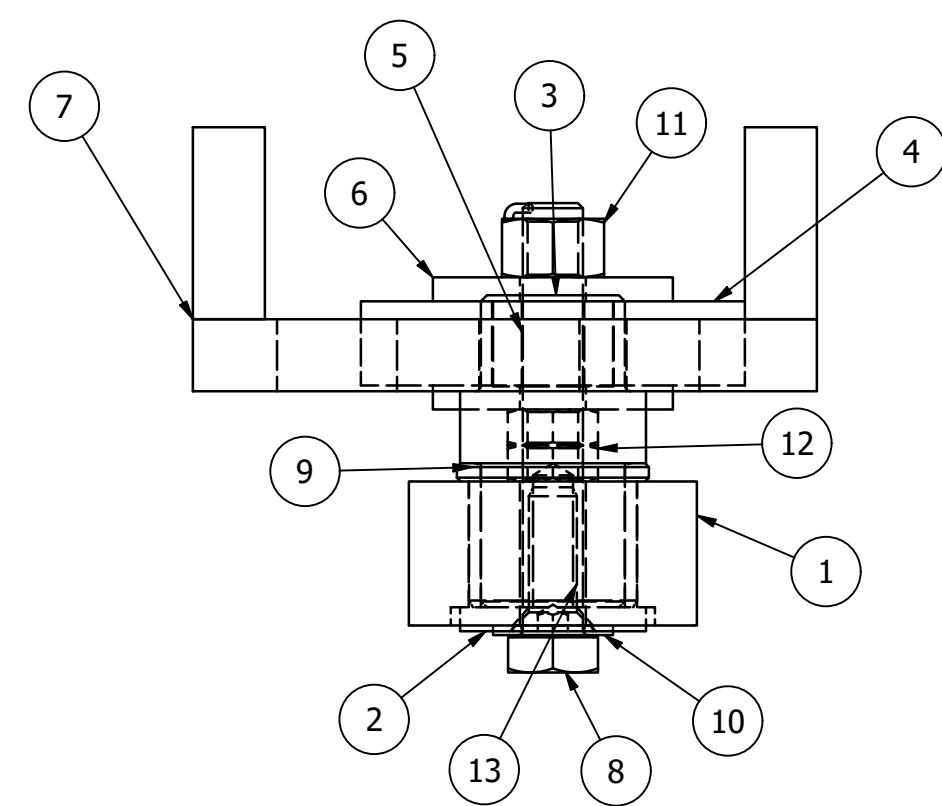
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

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

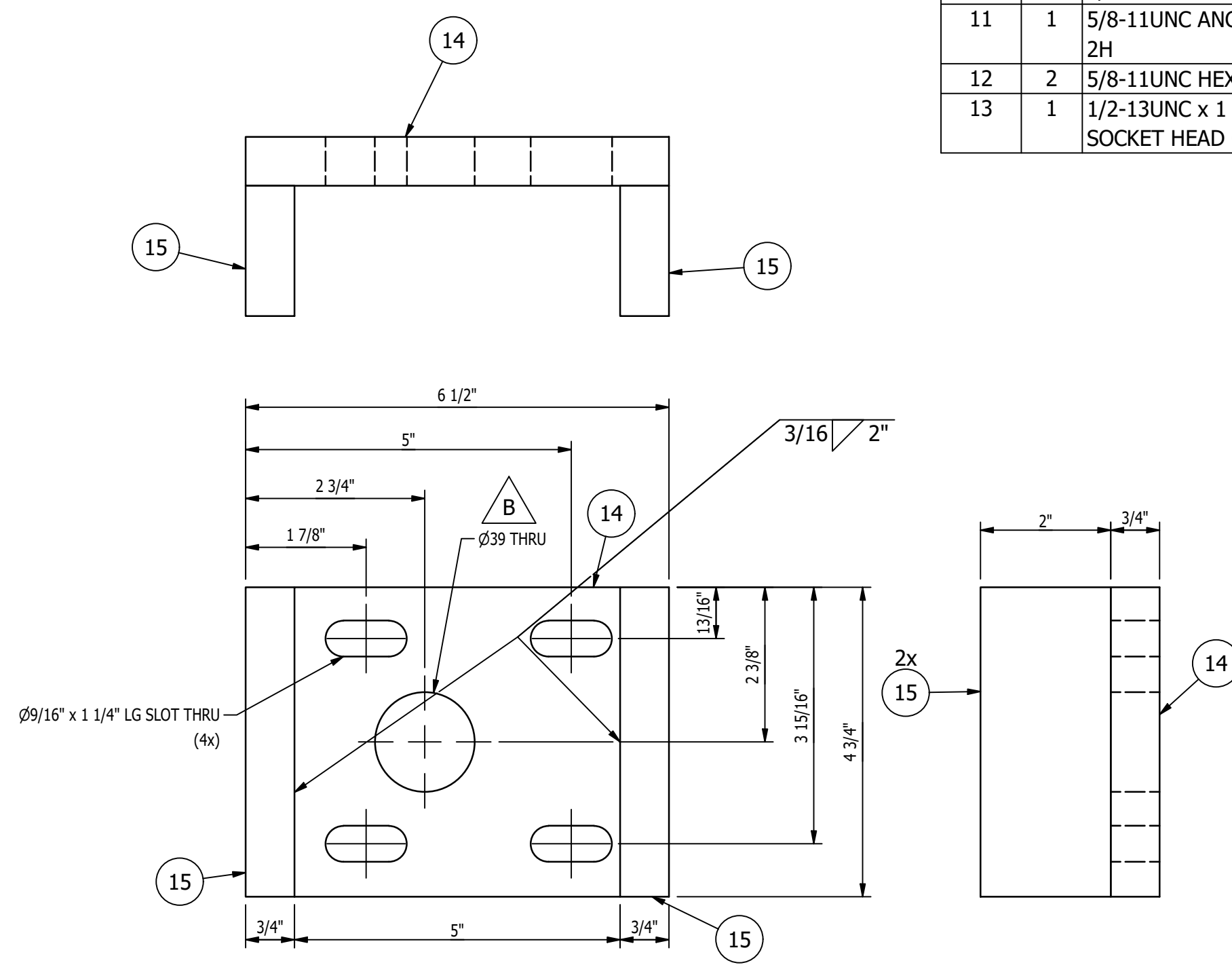
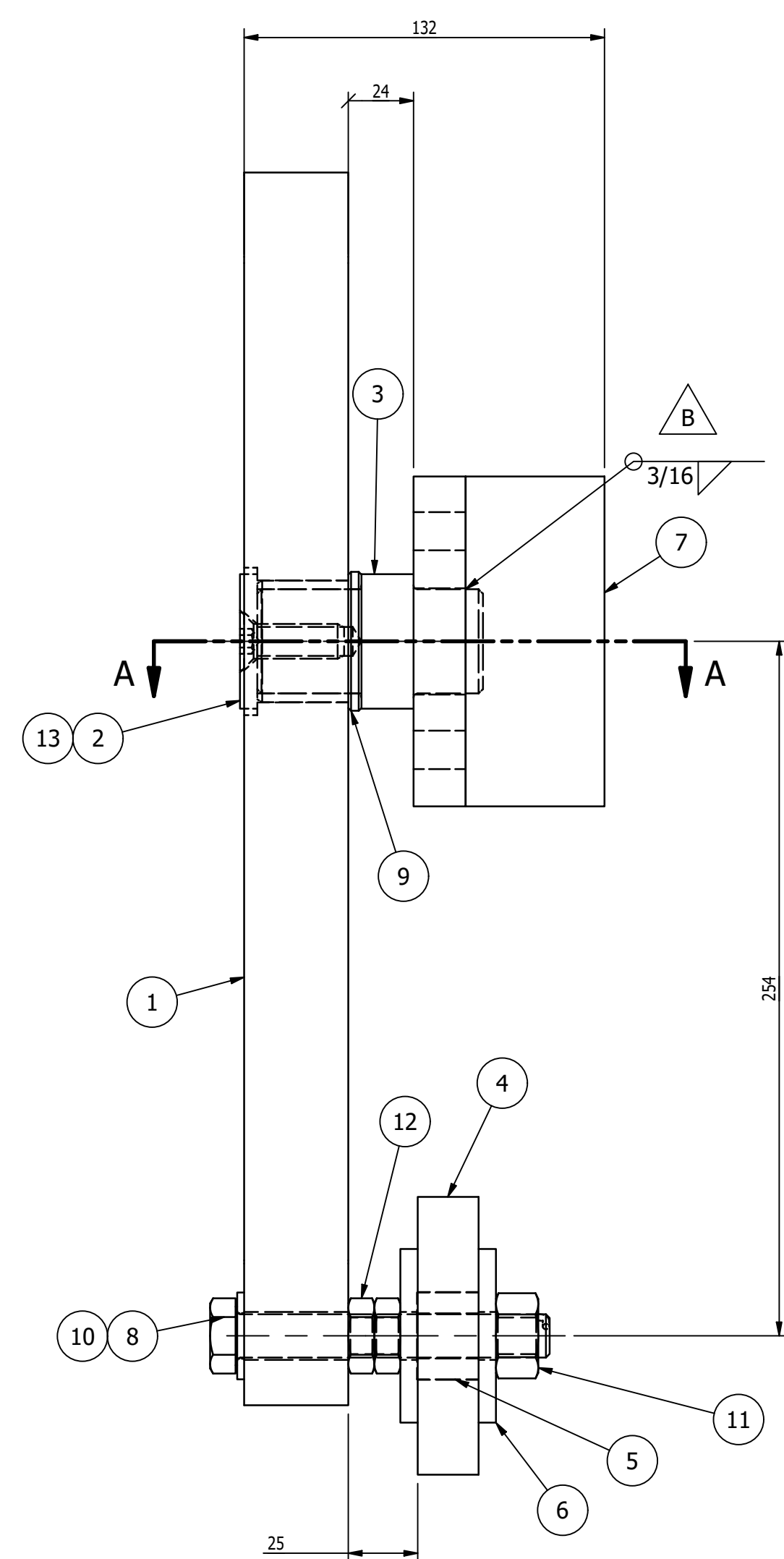
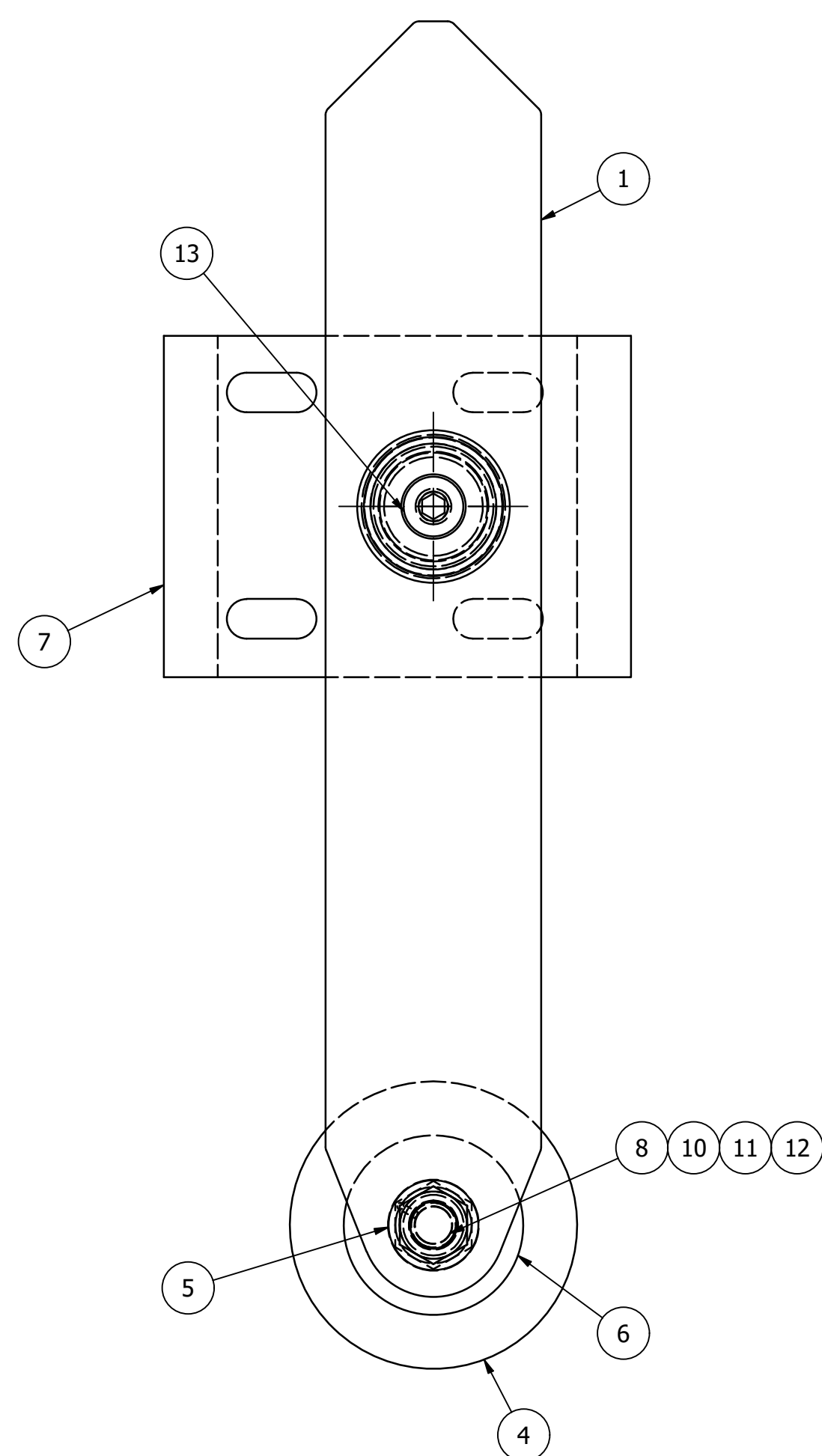
REVISION HISTORY

mi	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT:	VOLVO	CHECKED BY: CW
DRAWING No.	1875D614	DWG DATE: 8/9/22
REV:	A	JOB No: 22096



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D615A			
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-D615B ~ GRAVITY STOP WELDMENT			
8	1	5/8-11UNC x 4 1/2" LG. HEX 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 TYPE B NARROW FLAT WASHER			
11	1	5/8-11UNC ANCO LOCK NUT A194 GR. 2H			
12	2	5/8-11UNC HEX JAM NUT			
13	1	1/2-13UNC x 1 1/2" LG. FLAT HEX SOCKET HEAD CAP SCREW			
		MK-D615B			
14	1	BAR 3/4 x 6 1/2	4 3/4"		
15	2	BAR 3/4 x 2	4 3/4"		
		MK-D615C			
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-D615B ~ GRAVITY STOP WELDMENT			
8	1	5/8-11UNC x 4 1/2" LG. HEX 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 TYPE B NARROW FLAT WASHER			
11	1	5/8-11UNC ANCO LOCK NUT A194 GR. 2H			
12	2	5/8-11UNC HEX JAM NUT			
13	1	1/2-13UNC x 1 1/2" LG. FLAT HEX SOCKET HEAD CAP SCREW			



MK-D615B ~ GRAVITY STOP WELDMENT
SCALE 6"=1'-0"

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

MK-D615C ~ GRAVITY STOP ASSEMBLY - RH (SHOWN)
MK-D615A ~ GRAVITY STOP ASSEMBLY - LH (OPPOSITE)
SCALE 6"=1'-0"

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

REVISION HISTORY	
B	MC
A	MC

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

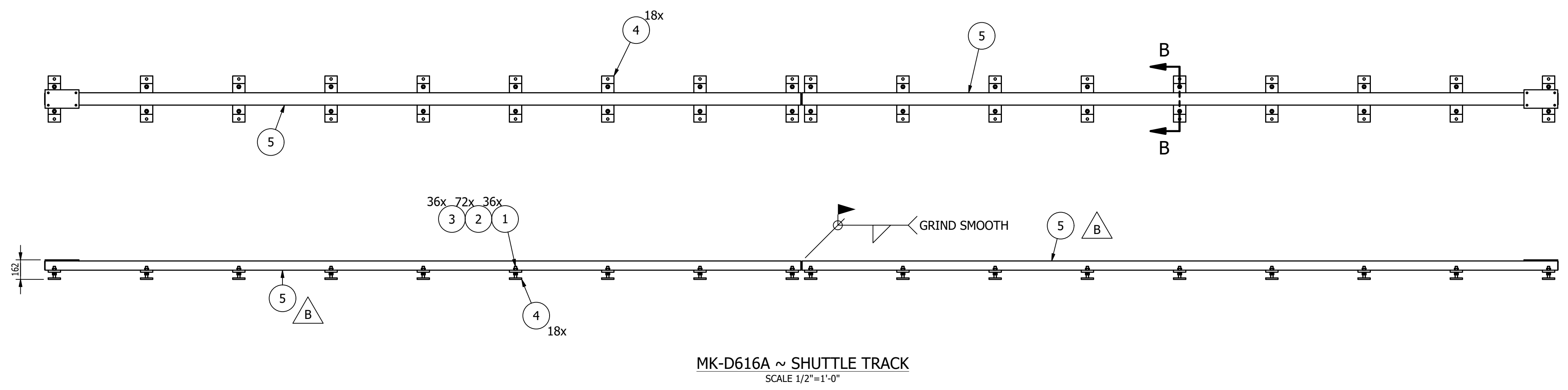
COPIES:

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

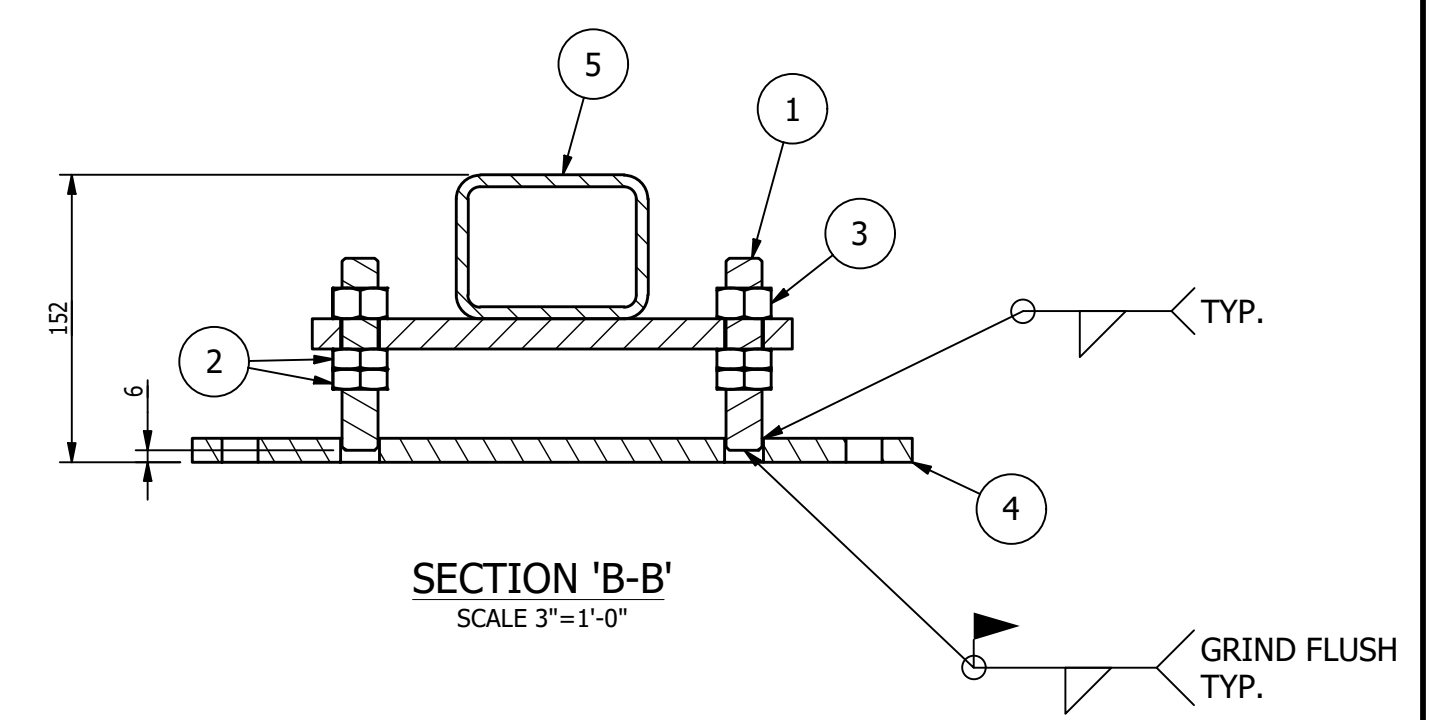
MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millc.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D615	DWG DATE:	8/15/22
REV:	B	JOB No:	22096

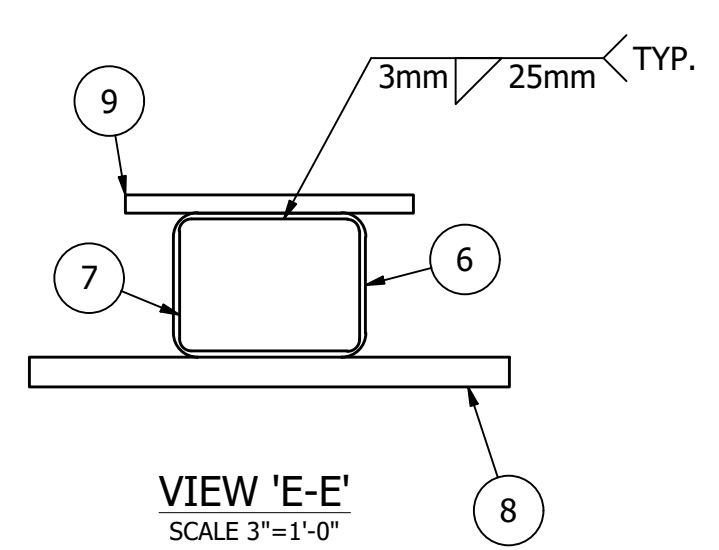
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D616A			
1	36	THD. ROD 3/4-10UNC	4"		
2	72	3/4-10UNC HEX JAM NUT			
3	36	3/4-10UNC HEX NUT			
4	18	MK-D043D ~ FOOT PLATE			
5	2	MK-D616B ~ SHUTTLE TRACK WELDMENT			
		MK-D616B			
6	1	TS 4 x 3 x 1/4	20'-6"		
7	1	PL 1/8 x 2 3/4"	3 3/4"		
8	9	MK-D043E ~ LOWER WELDMENT PLATE			
9	1	MK-D043F ~ UPPER WELDMENT PLATE			



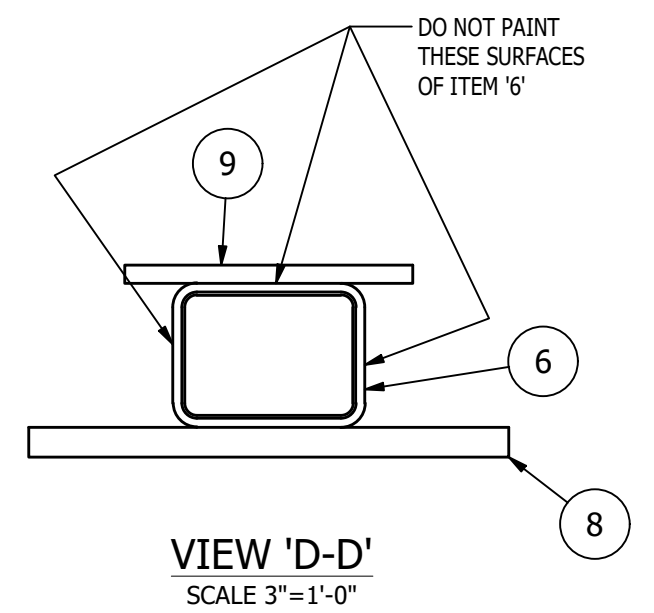
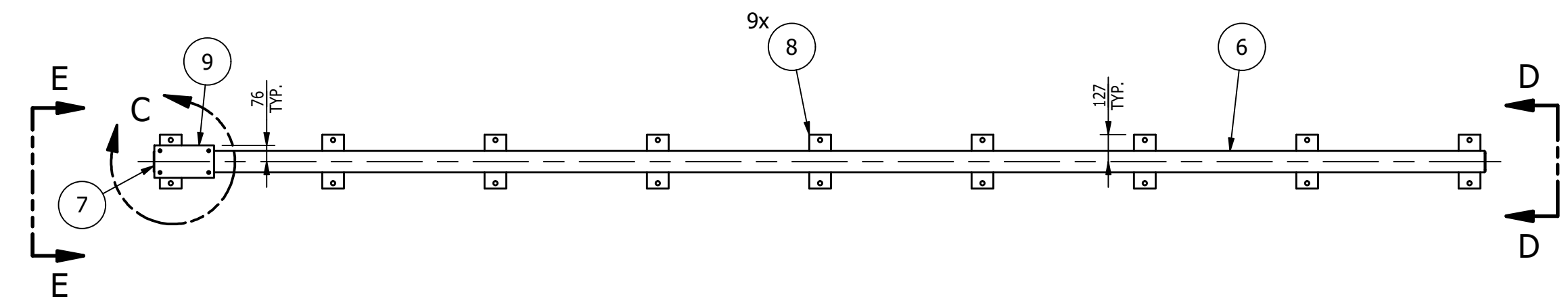
MK-D616A ~ SHUTTLE TRACK
SCALE 1/2"=1'-0"



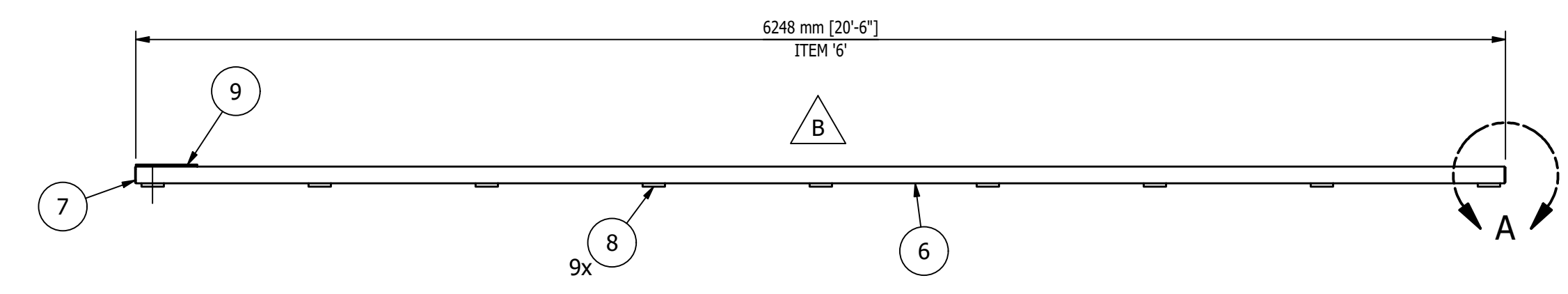
SECTION 'B-B'
SCALE 3"=1'-0"



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

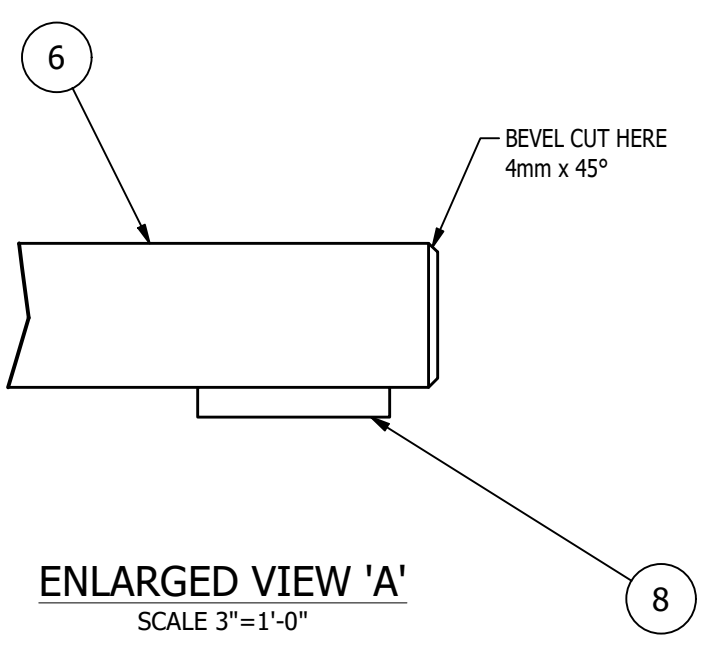


VIEW 'D-D'
SCALE 3"=1'-0"

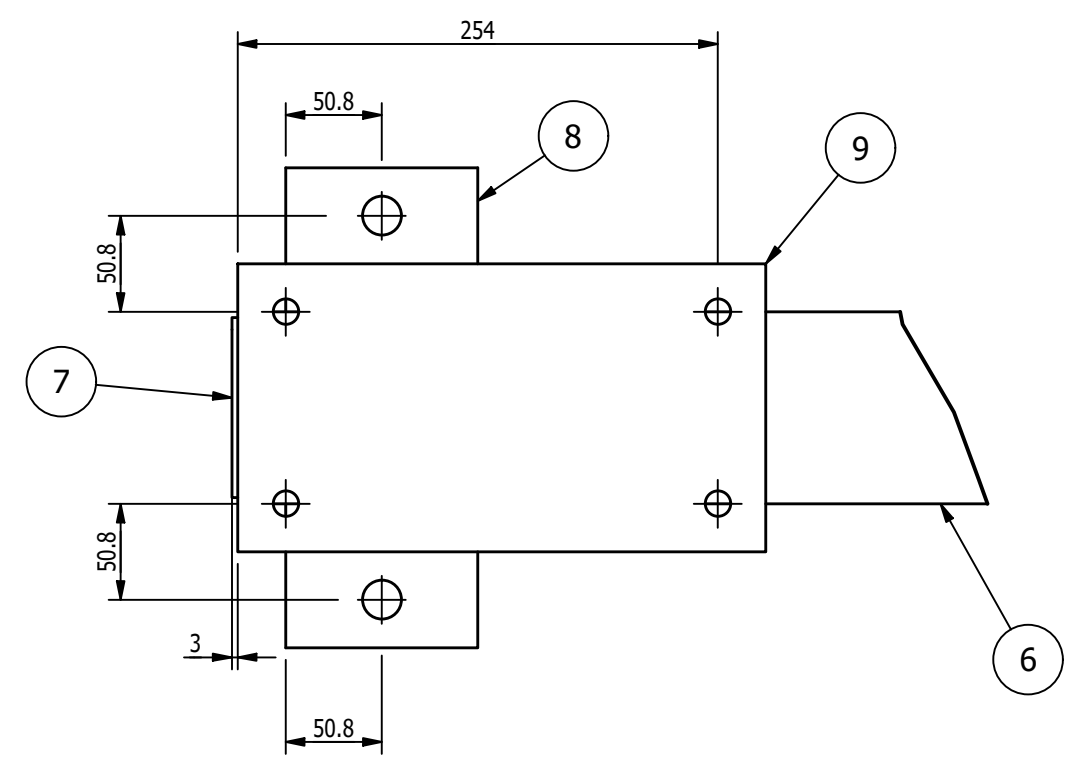


MK-D616B ~ SHUTTLE TRACK WELDMENT
SCALE 1/2"=1'-0"

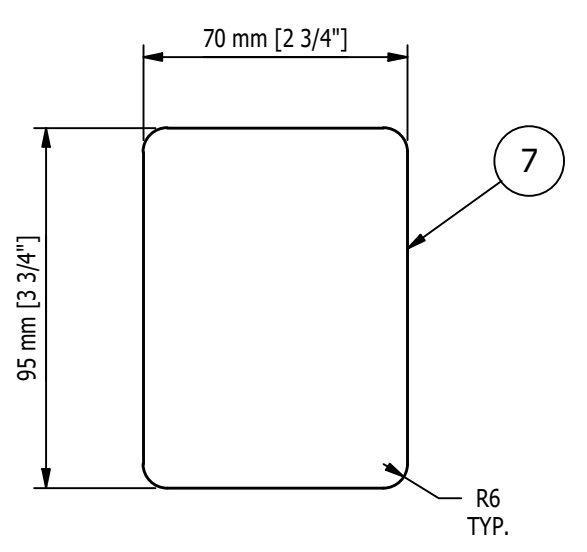
SHOP NOTES:
 1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
 5. ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE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



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



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



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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/21/22	GEOMETRY UPDATED FOR MK-D616B, QUANTITY OF ITEM '5' WAS 1 NOW 2, FASTENERS QUANTITIES UPDATED	
A	MC	8/31/22	FOR FABRICATION	

REVISION HISTORY

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

MAGNUM CONSULTING
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 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D616

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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TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No.: 1875D616
REV: B

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 8/25/22
JOB No.: 22096