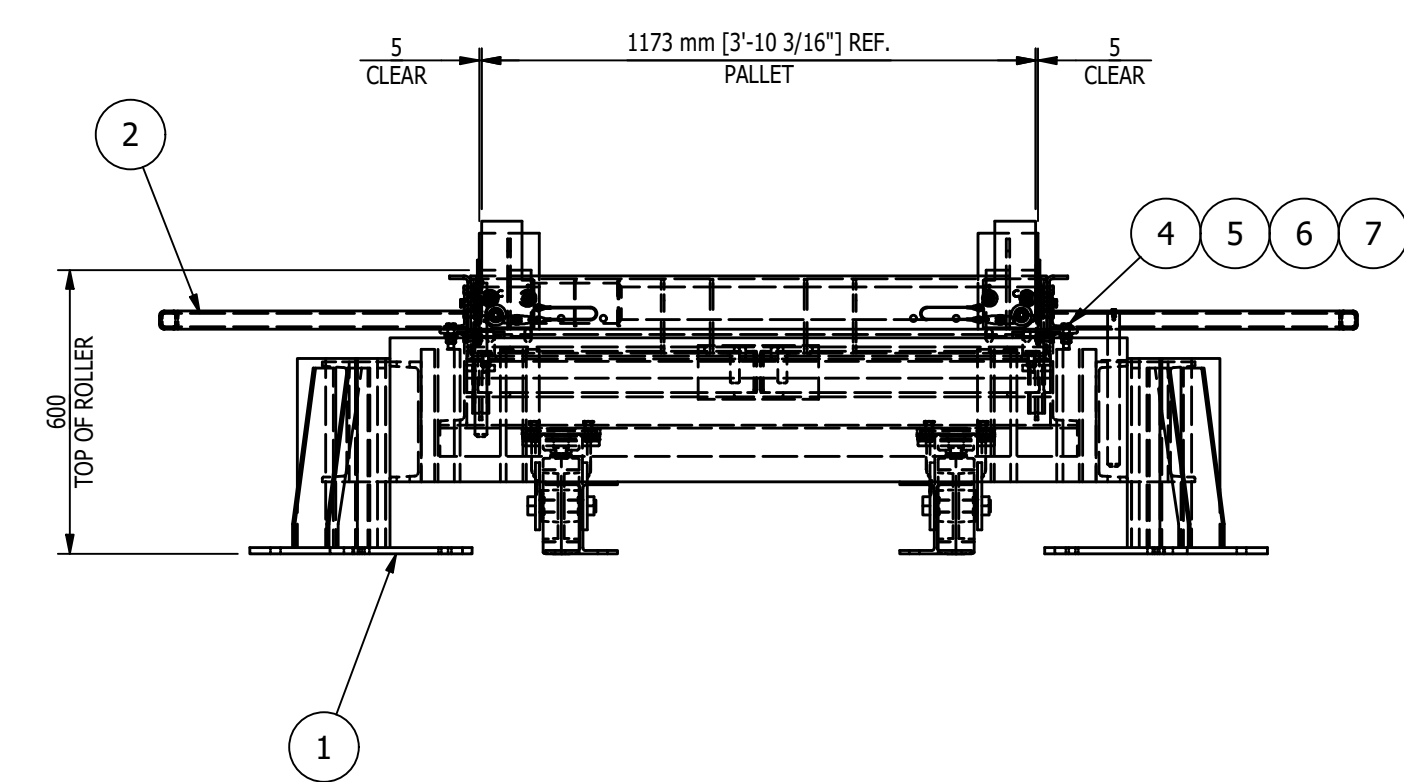
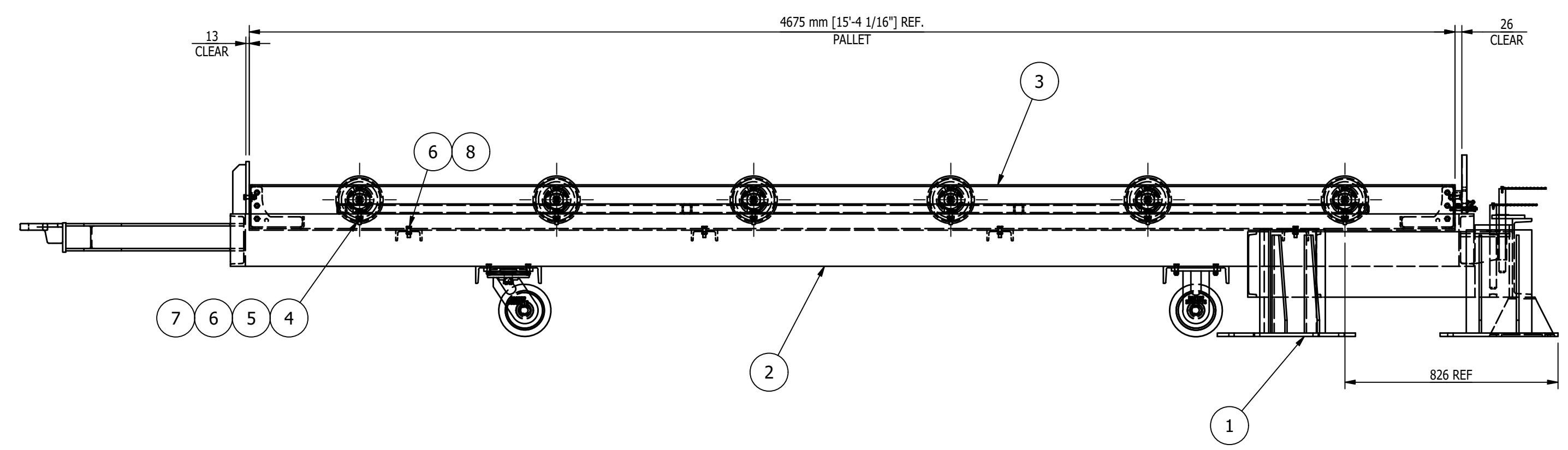
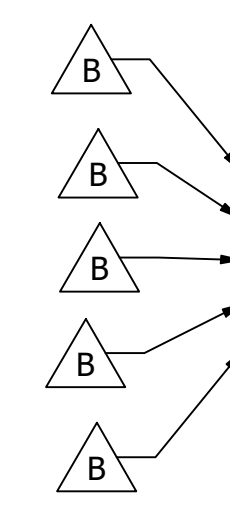


BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D700A			
1	1	MK-D706A ~ PALLET DOCKING STATION			
2	1	MK-D703A ~ PALLET PULL-OUT DOLLY			
3	1	MK-D701A ~ PALLET PULL-OUT ROLLER BED			
4	12	M12 HARDENED BEVEL WASHER			
5	24	M12 NARROW FLAT WASHER			
6	20	M12 x 1.75 STOVER LOCK NUT			
7	12	M12x1.75 x 45mm LG. HEX CAP SCREW			
8	8	M12x1.75 x 35mm LG. HEX CAP SCREW			
		TOTAL WEIGHT ~ 2854.5 lbs			



MK-D700A ~ PALLET PULL-OUT AND DOCKING STATION  
SCALE 3/4"=1'-0"

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/22	ADDED ITEMS '4', '5', '6', '7', & '8'	
A	MC	8/12/22	FOR FABRICATION	

<b>MILLER INDUSTRIES</b> 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
<b>TITLE:</b> P6700 CONVEYORS CAMPUS BUILDING <b>CLIENT:</b> VOLVO <b>DRAWING No.</b> 1875D700	<b>REV:</b> B	<b>DRAWN BY:</b> PWP <b>CHECKED BY:</b> CW <b>DWG DATE:</b> 7/5/22 <b>JOB No:</b> 22096

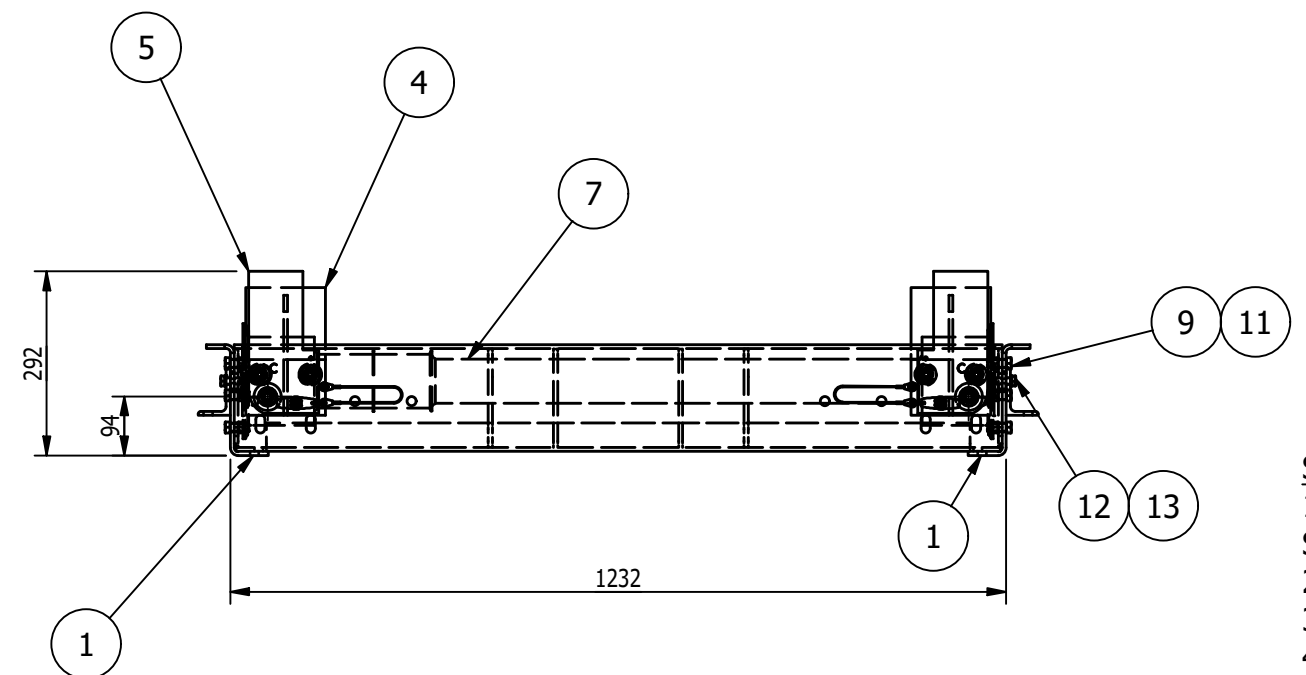
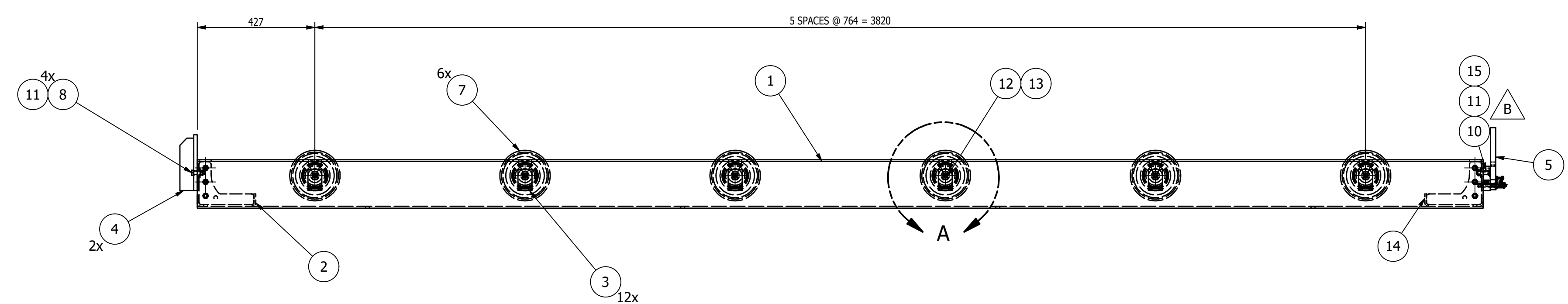
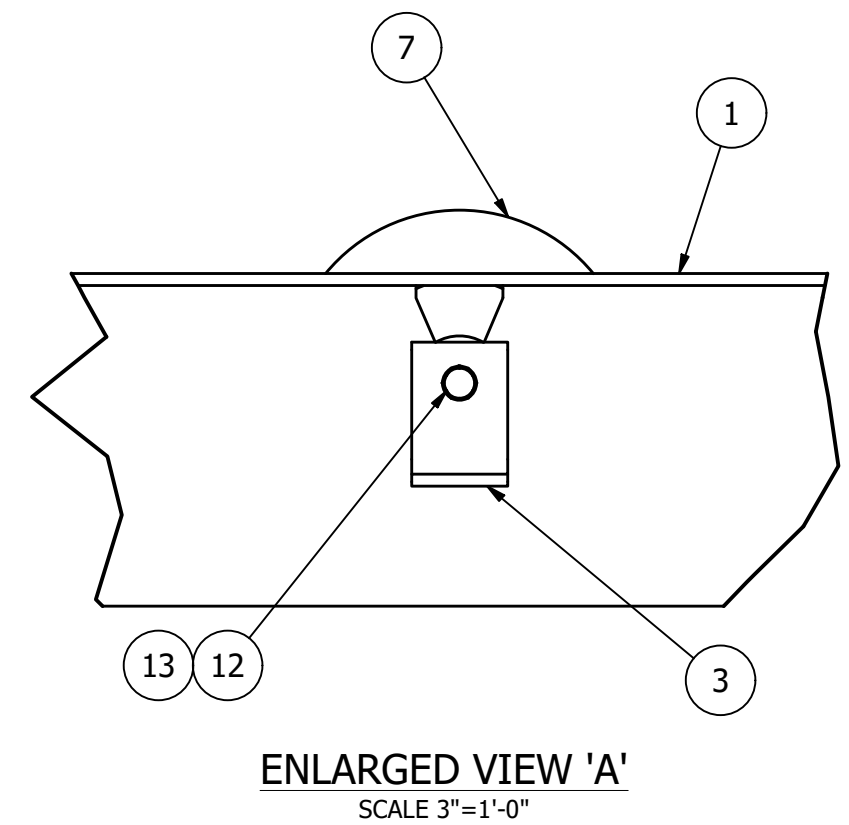
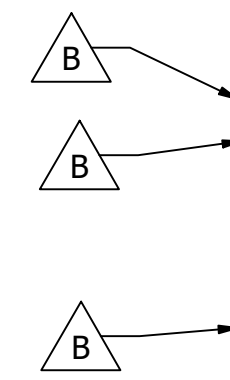
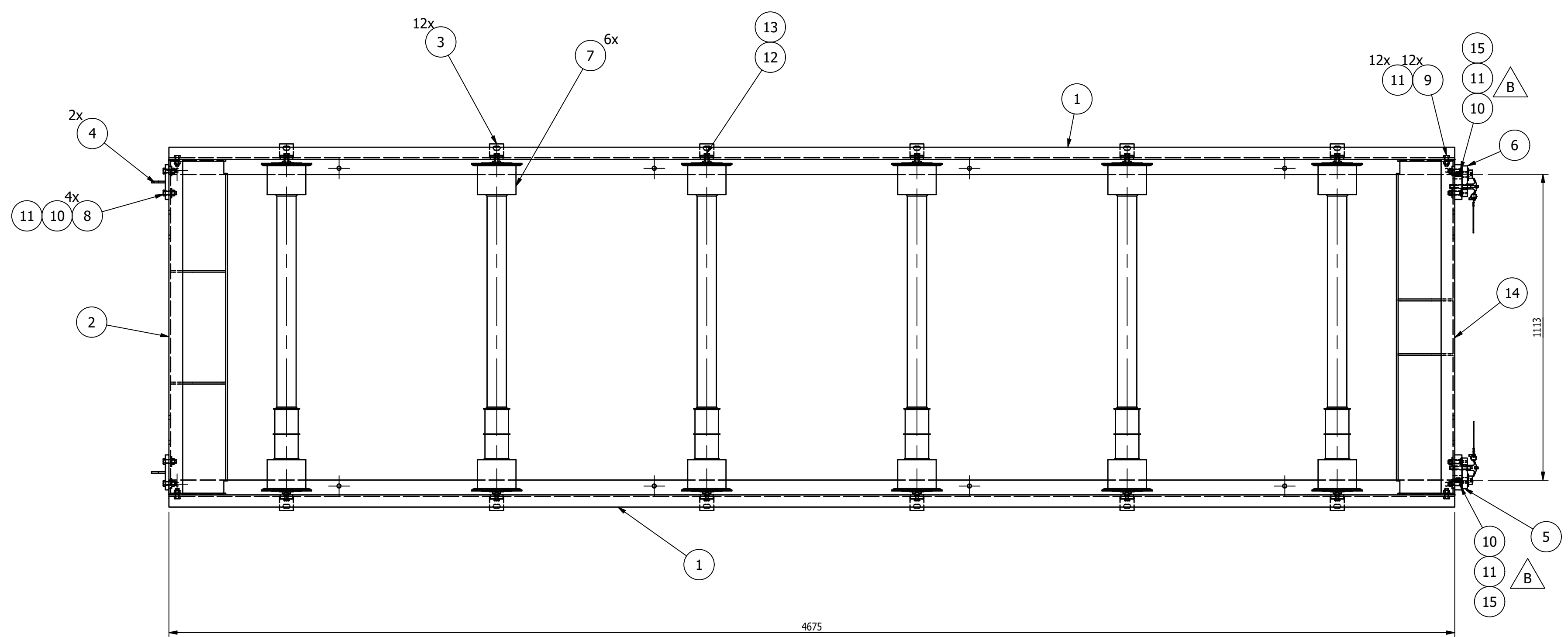
**MAGNUM CONSULTING**  
 41100 QuakerRoad Rd.  
 Suite 125  
 Novi, MI 48225  
 Phone: (248) 772-8822  
 Fax: (248) 772-8821  
 Web: www.mmagnum.com

MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 1875D700

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-D701A			
1	2	MK-D702A ~ Z-FRAME ASSEMBLY			
2	1	MK-D601A ~ END PLATE ASSEMBLY			
3	12	MK-D704A ~ ROLLER CLIP			
4	2	MK-D704B ~ FIXED PALLET STOP			
5	1	MK-D705A ~ PIVOTING PALLET/SKID STOP			
6	1	MK-D705B ~ PIVOTING PALLET/SKID STOP			
7	6	PALLET DRIVEN ROLLER, DUGOMRULLI PART NO 329638V			
8	4	M12x1.75 x 40mm LG. HEX CAP SCREW			
9	12	M12x1.75 x 30mm LG. HEX CAP SCREW			
10	8	M12 REGULAR FLAT WASHER			
11	20	M12 x 1.75 STOVER LOCK NUT			
12	12	M10x1.5 x 25mm LG. HEX CAP SCREW			
13	12	M10 SPRING LOCK WASHER			
14	1	MK-D714A ~ END PLATE ASSEMBLY			
15	4	M12x1.75 x 50mm LG. FLAT HEX SOCKET HEAD CAP SCREW			
		TOTAL WEIGHT ~ 1301.7 lbs			



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

MK-D701A ~ PALLET PULL-OUT ROLLER BED  
SCALE 1"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/22	UPDATED QUANTITIES OF ITEMS '10' & '11', ADDED ITEM '15'	
A	MC	8/12/22	FOR FABRICATION	

REVISION HISTORY

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

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D701

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

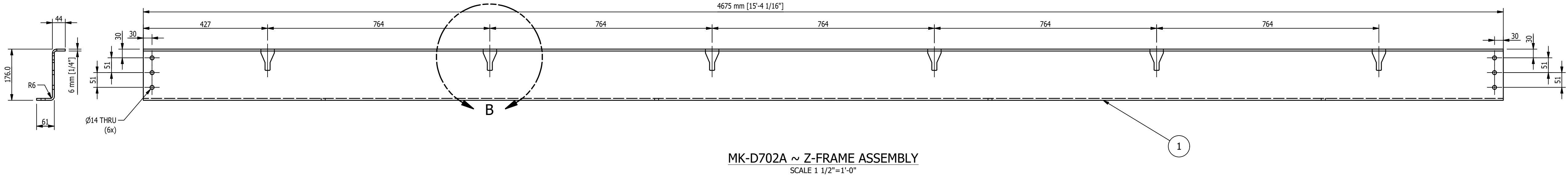
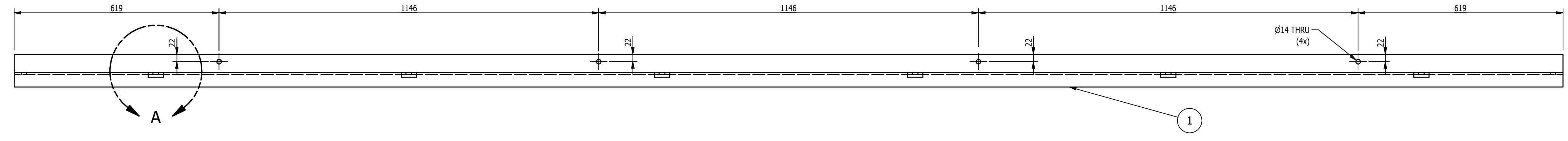
GENERAL NOTES:  
MATERIALS:  
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.  
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.  
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.  
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.  
HOLES:  
- ALL HOLES ARE 13/16" DIA. U.N.O.  
- ALL BOLTED CONNECTIONS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

**mi MILLER INDUSTRIES**  
3070 W. THOMPSON RD.  
FENTON, MI 48430  
PH: 810.373.0322 FAX: 810.373.0326  
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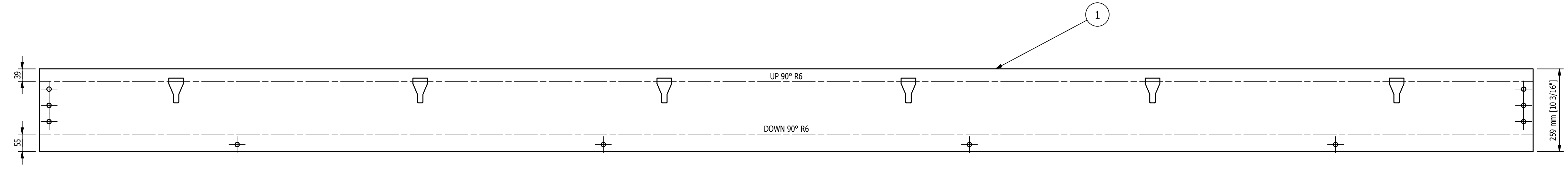
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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D701	DWG DATE:	7/18/22
		REV:	B
		JOB No:	22096

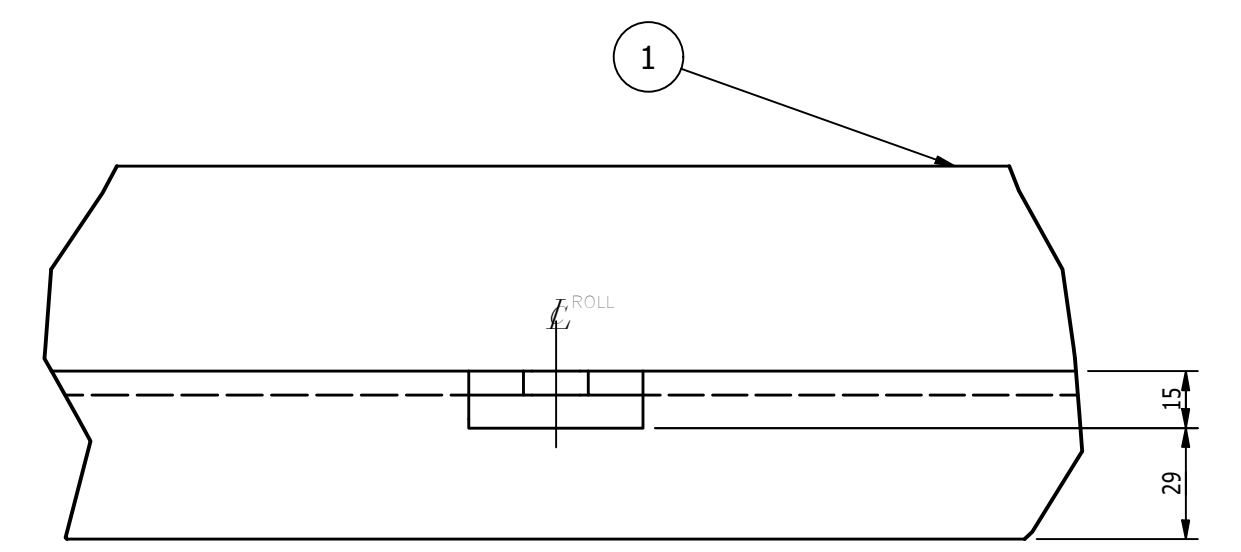
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D702A			
1	1	PL 1/4 x 10 3/16"	15'-4 1/16"		
TOTAL WEIGHT ~ 132.3 lbs					



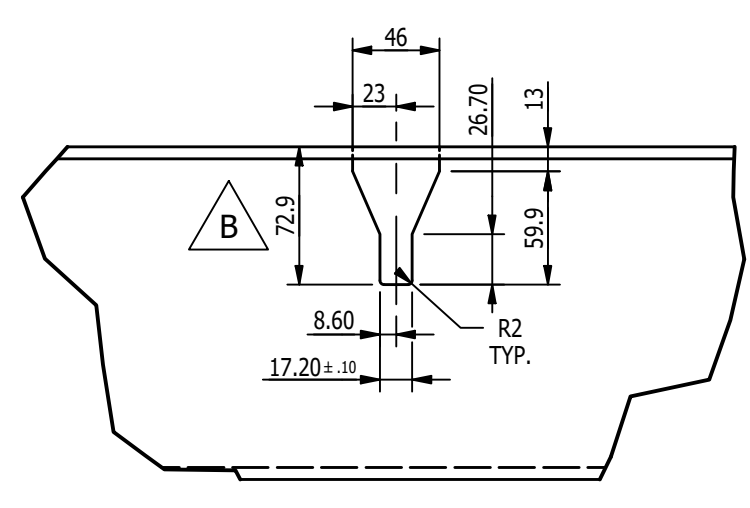
MK-D702A ~ Z-FRAME ASSEMBLY  
SCALE 1 1/2"=1'-0"



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



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



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

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/22	UPDATED SLOTS FOR ROLLER PLACEMENT	
A	MC	8/12/22	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.

COPES:

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

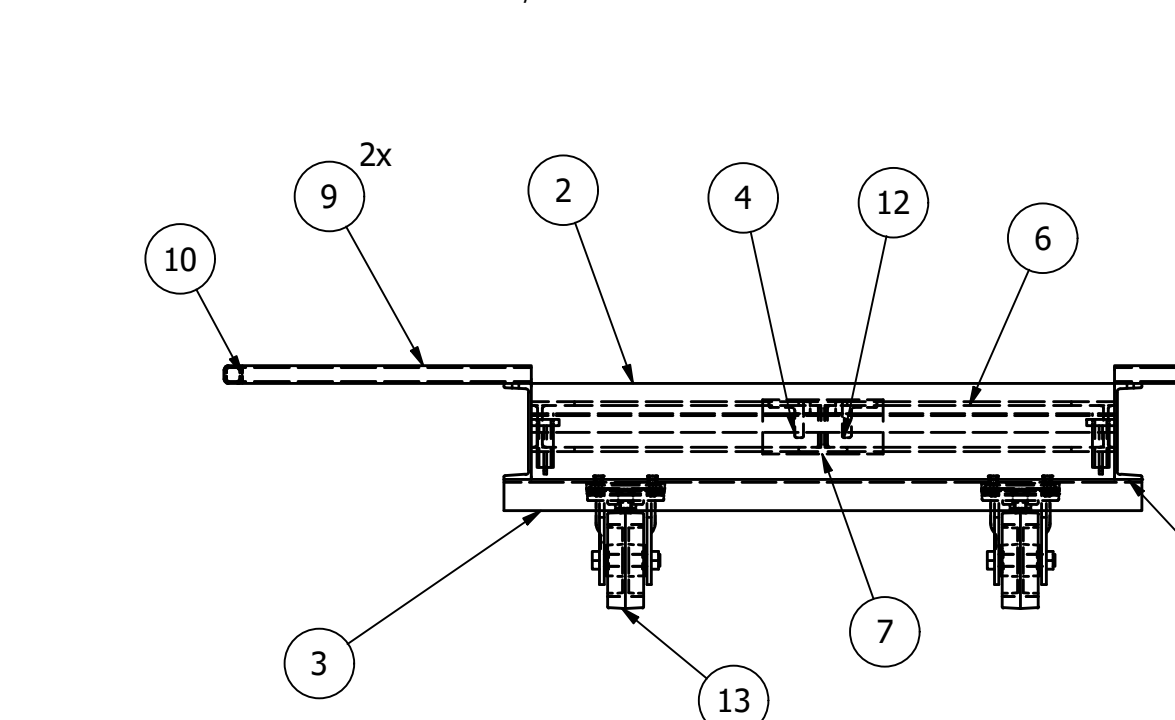
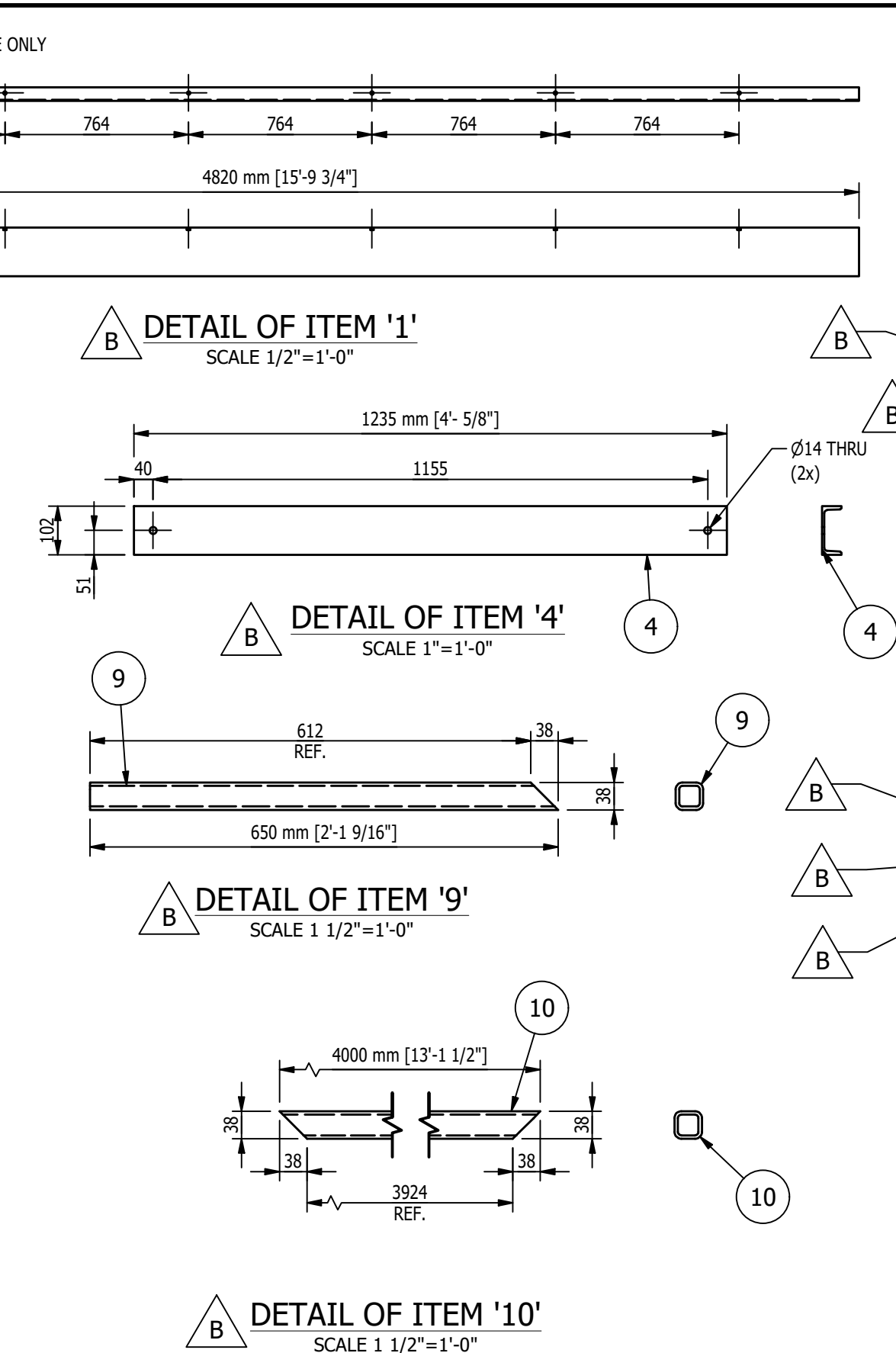
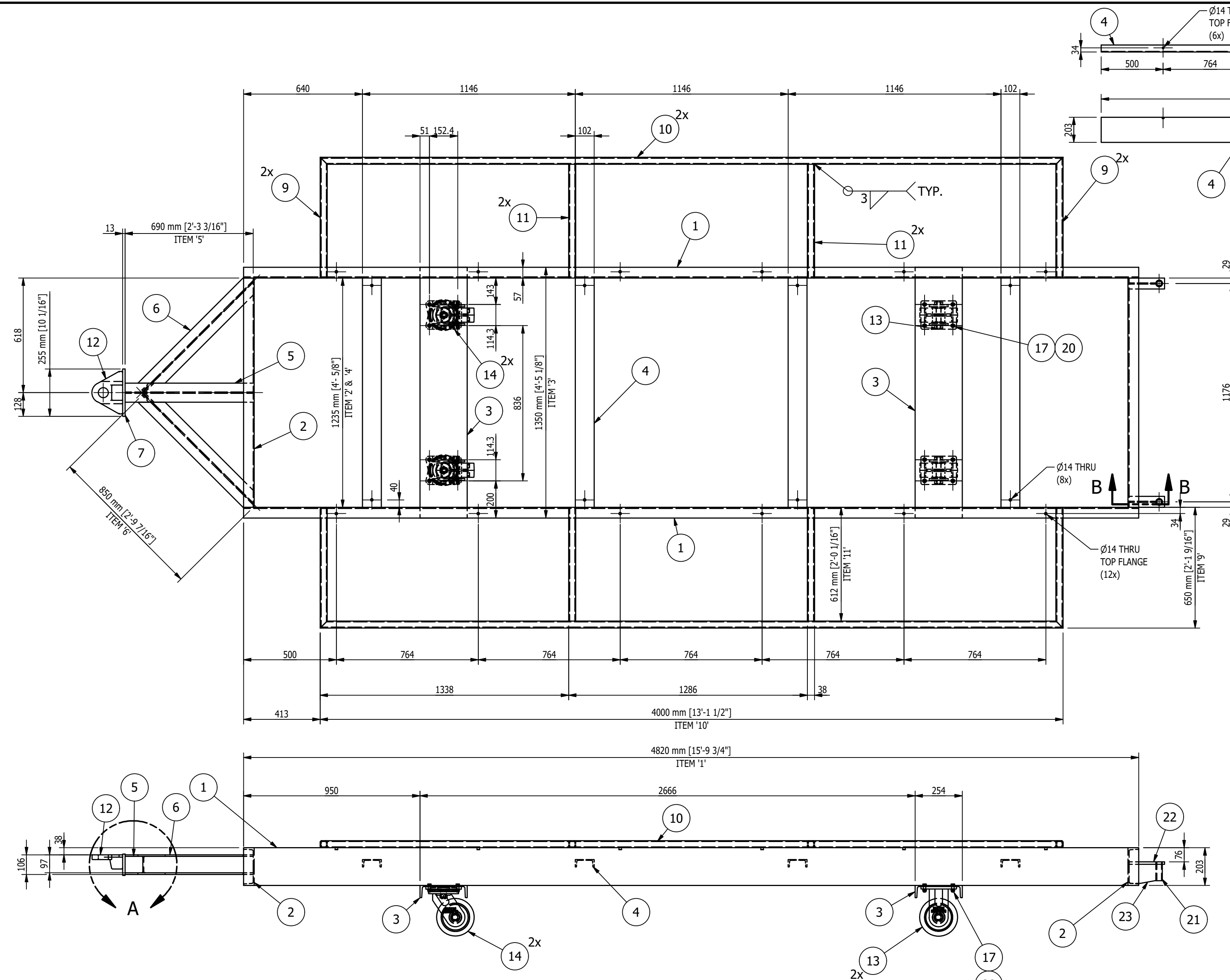
MILLER INDUSTRIES  
3070 W. THOMPSON RD.  
FENTON, MI 48430  
PH: 810.373.0322 FAX: 810.373.0326  
www.millic.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D702	DWG DATE:	7/5/2022
REV:	B	JOB No:	22096

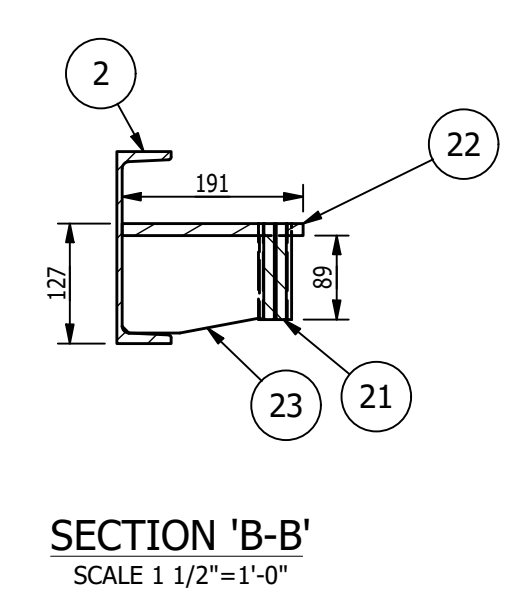
**MAGNUM Consulting**  
41703 Gardenbrook Rd  
Suite 125  
Novi, MI 48215  
Phone: (248) 775-8600  
Fax: (248) 775-8601  
Web: www.4magnum.com

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





BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D703A			
1	2	C 8 x 11.5	15'-9 3/4"		
2	2	C 8 x 11.5	4'- 5/8"		
3	2	C 10 x 15.3	4'-5 1/8"		
4	4	C 4 x 5.4	4'- 5/8"		
5	1	W 4 x 13	2'-3 3/16"		
6	2	W 4 x 13	2'-9 7/16"		
7	1	BAR 1/2 x 4 3/16	10 1/16"		
9	4	TS 1 1/2 x 1 1/2 x 3/16	2'-1 9/16"		MITER
10	2	TS 1 1/2 x 1 1/2 x 3/16	13'-1 1/2"		MITER
11	4	TS 1 1/2 x 1 1/2 x 3/16	2'- 1/16"		
12	1	TOW RING DARNELL-ROSE #CPL-01747		14-3	
13	2	RIGID CASTER, 80 SERIES CASTER STANDARDS-EXTRA HEAVY DUTY CASTERS, PRECISION TAPERED BEARING, CASTER CONCEPTS #80-08309-65-2		14-2	
14	2	SWIVEL CASTER, 80 SERIES CASTERS STANDARDS - EXTRA HEAVY DUTY CASTERS, PRECISION TAPERED BEARING, Caster Concepts #80-08309-65-1		14-1	
17	16	M12x1.75 x 35mm LG. HEX CAP SCREW			
20	16	M12 x 1.75 STOVER LOCK NUT			
21	2	TS 1 3/8 OD x 3/16 DOM	4"		
22	2	PL 1/2 x 2 5/16"	7 9/16"		
23	2	PL 1/4 x 5 3/4"	4 1/16"		
TOTAL WEIGHT ~ 999.8 lbs					



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

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

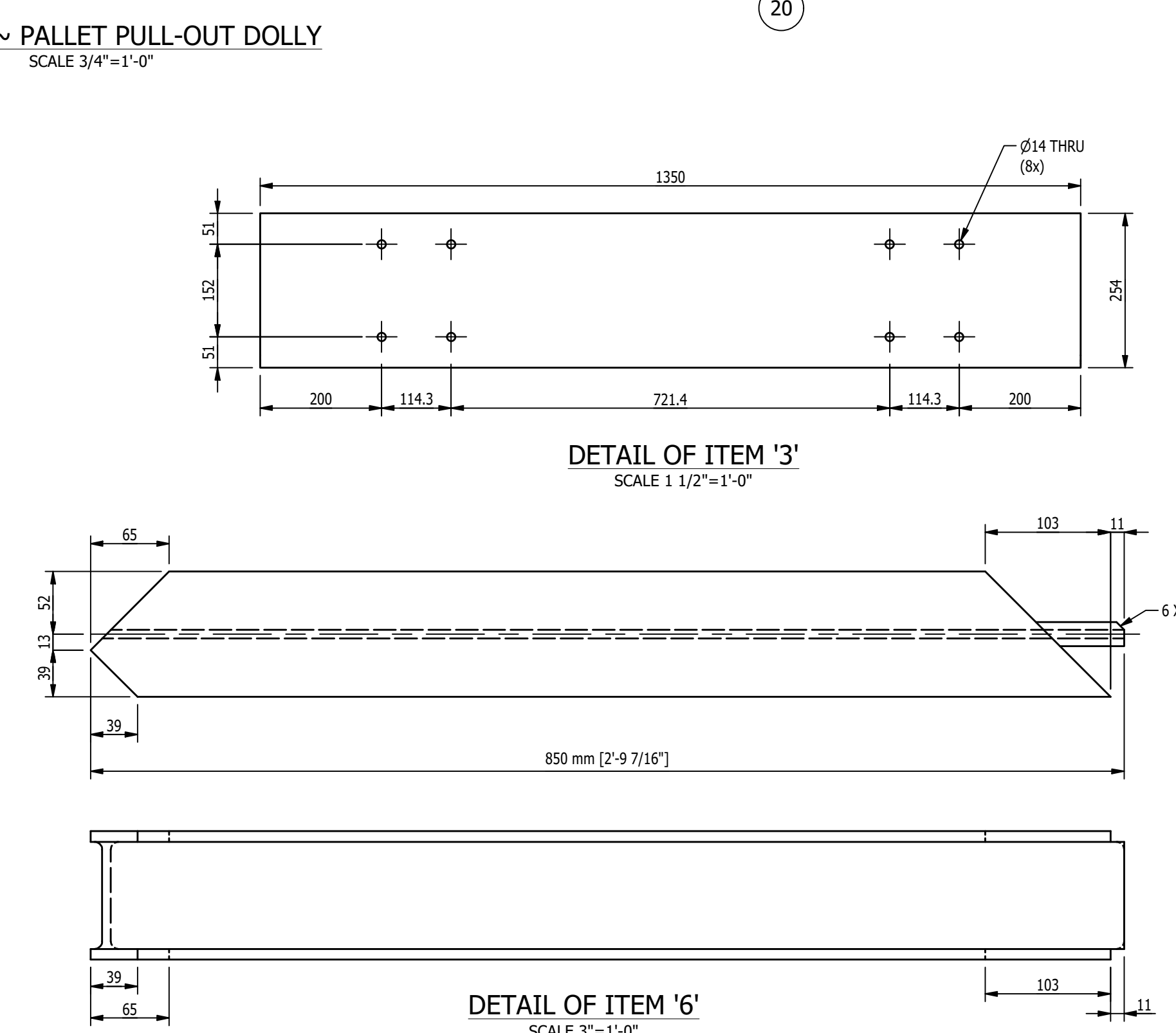
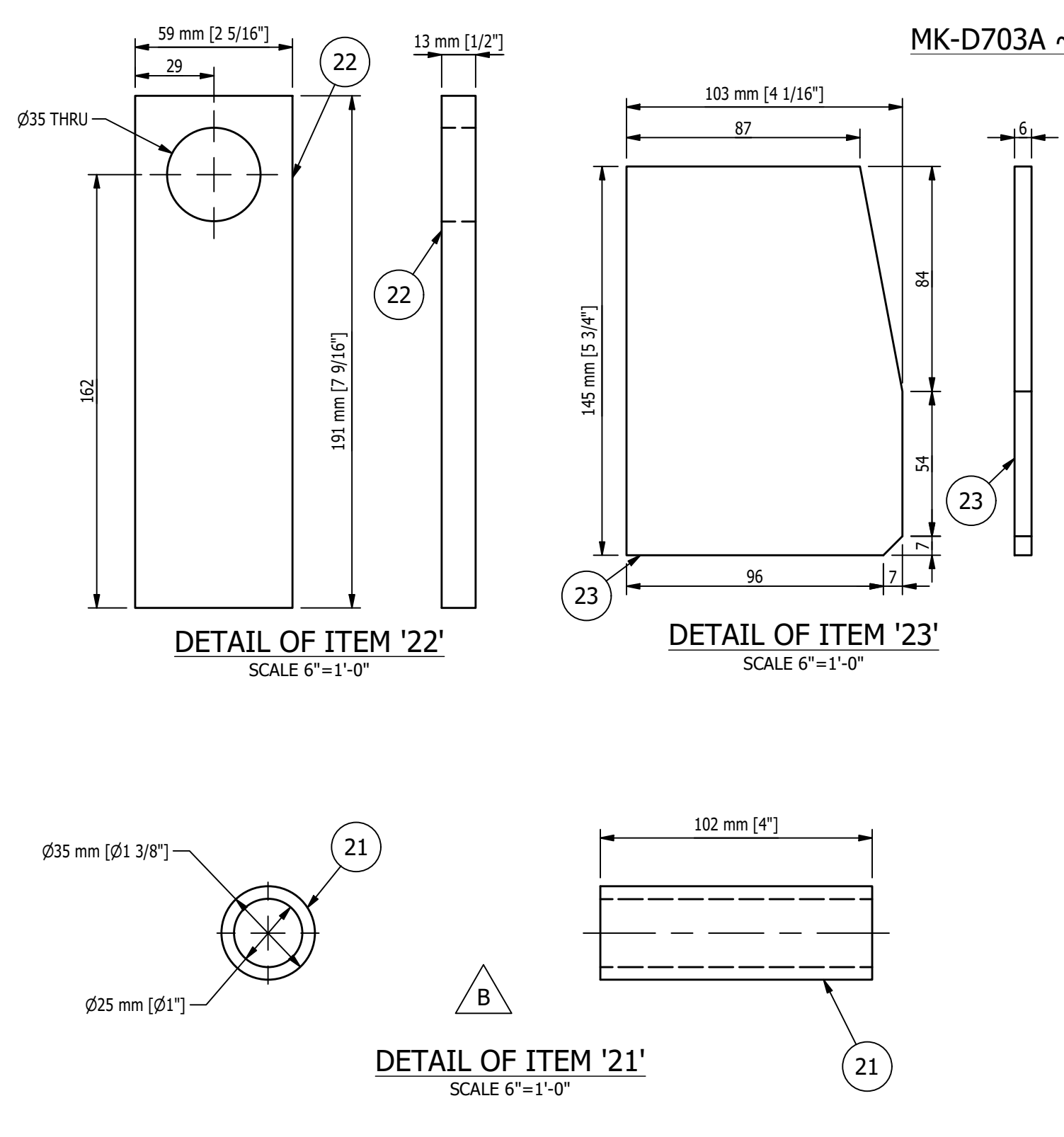
REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/22	REMOVED ITEMS '15', '16', & '19', UPDATED QUANTITIES FOR ITEMS '17' & '20', ADDED REMARKS FOR ITEMS '9' & '10', ADDED DETAILS OF ITEMS '1', '4', '9', & '10', ITEM '21' IS NOW 'TS 1 3/8 OD x 3/16 DOM', WAS 'PIPE 1 SCH. 40'	
A	MC	8/12/22	FOR FABRICATION	

**REVISION HISTORY**

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

**TITLE:** P6700 CONVEYORS CAMPUS BUILDING  
**CLIENT:** VOLVO  
**DRAWING No.:** 1875D703  
**REV:** B

**DRAWN BY:** AH  
**CHECKED BY:** CW  
**DWG DATE:** 7/29/22  
**JOB No.:** 22096



**MAGNUM CONSULTING**  
 41100 GARDENHURST RD.  
 SUITE 125  
 NILES, MI 48855  
 Phone: (248) 772-8822  
 Fax: (248) 772-8851  
 Web: www.mmagnum.com

MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 1875D703

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.

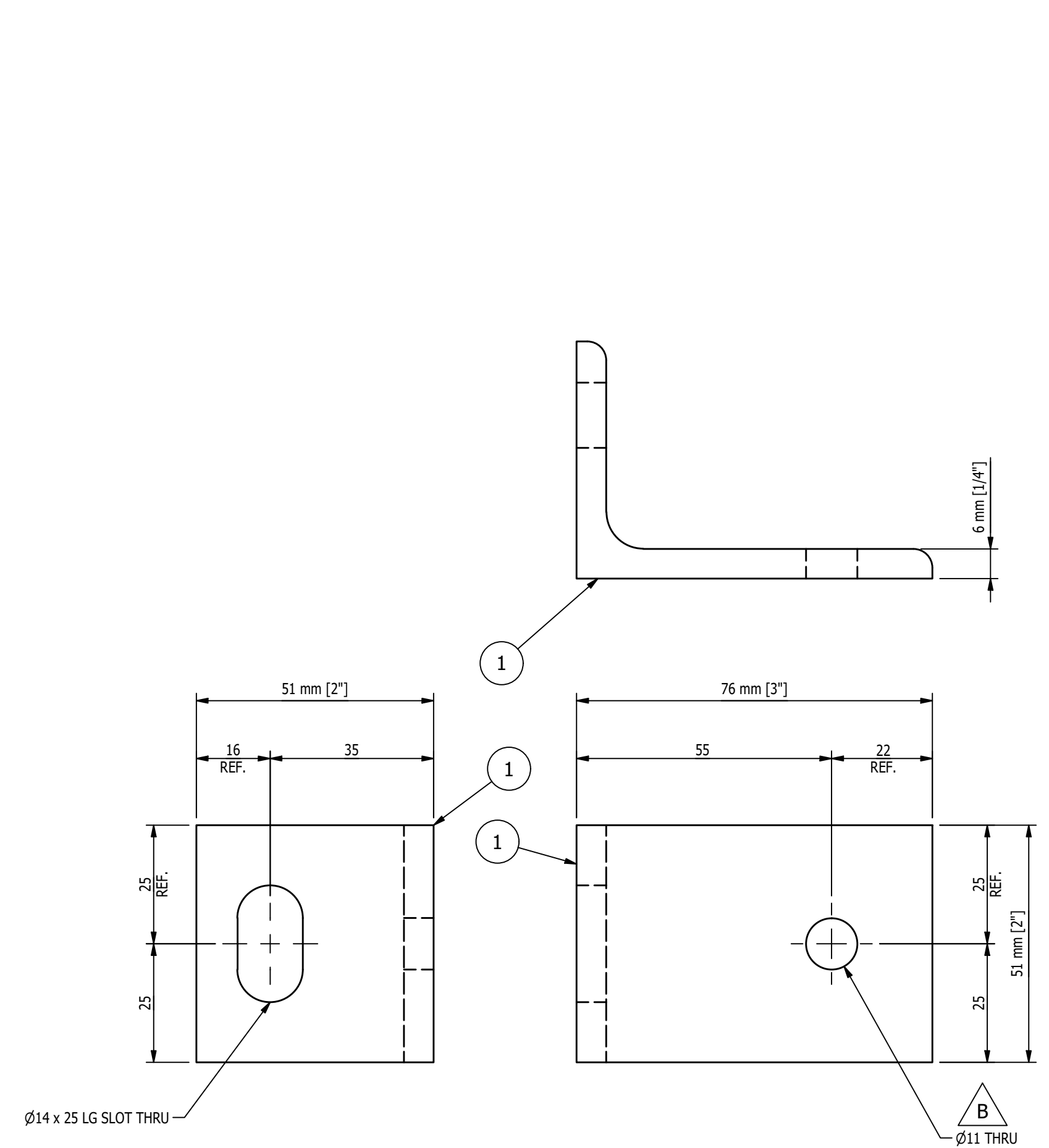
**HOLES:**  
 - ALL HOLES ARE 13/16" DIA. U.N.O.  
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

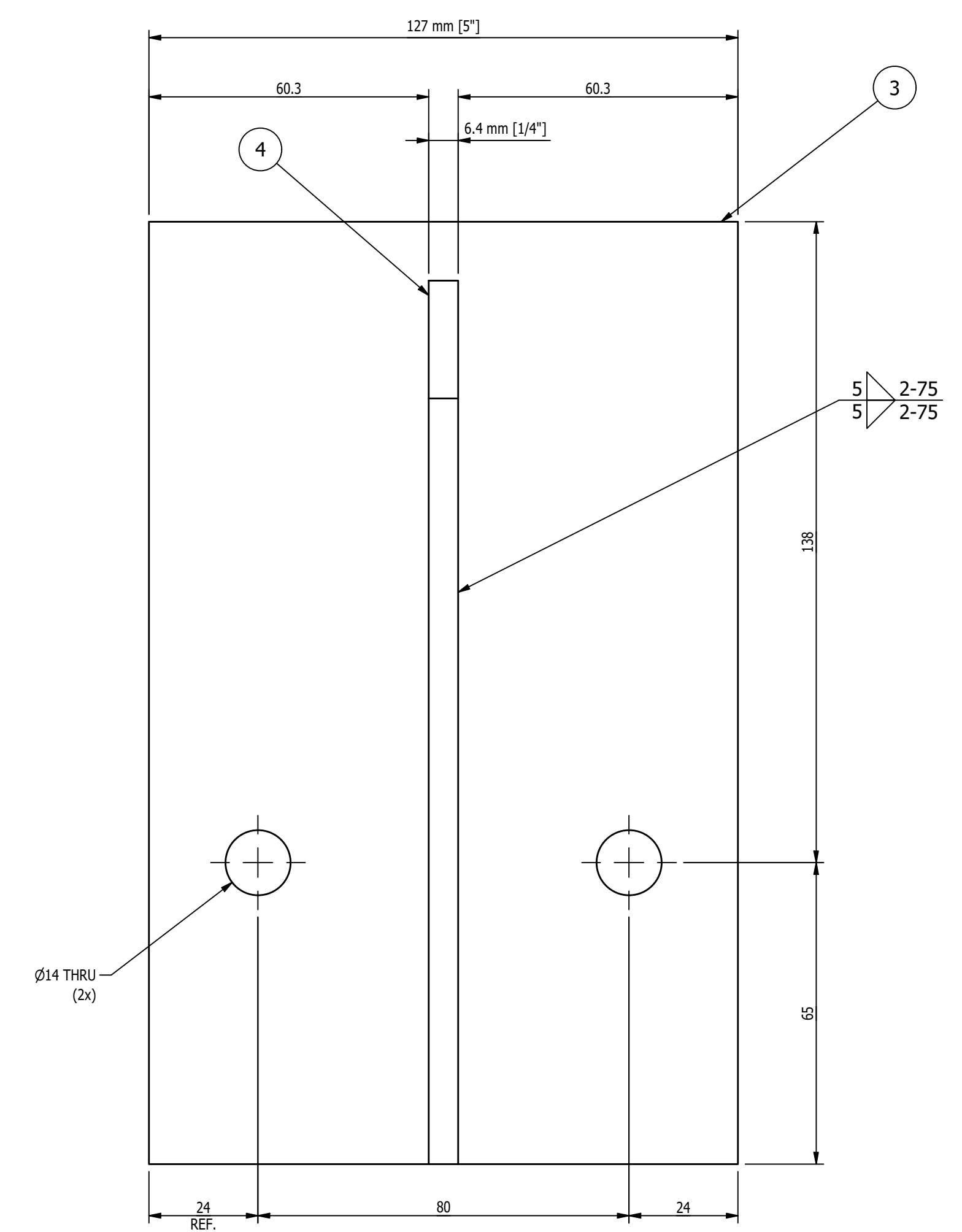
**PAINT:**  
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

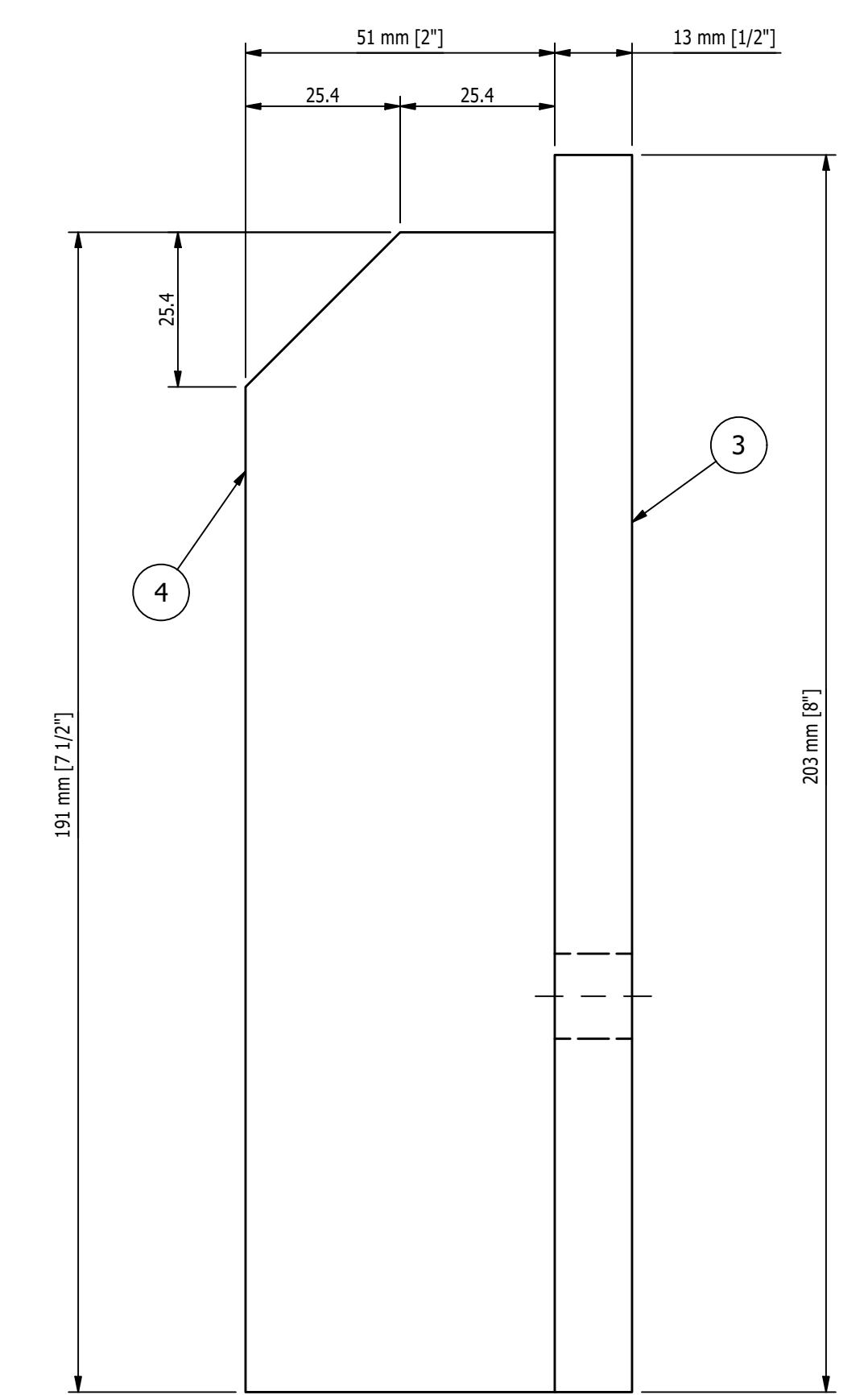
BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D704A		
1	1	L 3 x 2 x 1/4	2"	
		TOTAL WEIGHT ~ 0.6 lbs		
		MK-D704B		
3	1	PL 1/2 x 5"	8"	
4	1	PL 1/4 x 2"	7 1/2"	
		TOTAL WEIGHT ~ 6.6 lbs		



**MK-D704A ~ ROLLER CLIP**  
SCALE 1'-0" = 1'-0"



**MK-D704B ~ FIXED PALLET STOP**  
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
B	MC	9/7/22	UPDATED HOLE SIZE ON ITEM '1'	
A	MC	8/12/22	FOR FABRICATION	

	<b>MILLER INDUSTRIES</b> 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b> <b>CLIENT: VOLVO</b> <b>DRAWING No. 1875D704</b>	

	<b>MAGNUM CONSULTING</b> 41703 Gardenbrook Rd. Suite 125 Novi, MI 48215 MAGNUM JOB #: 1875 MAGNUM DRAWING #: 1875D704	Phone: (248) 775-8655 Fax: (248) 775-8651 Web: www.4Magnum.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.

**COPES:**

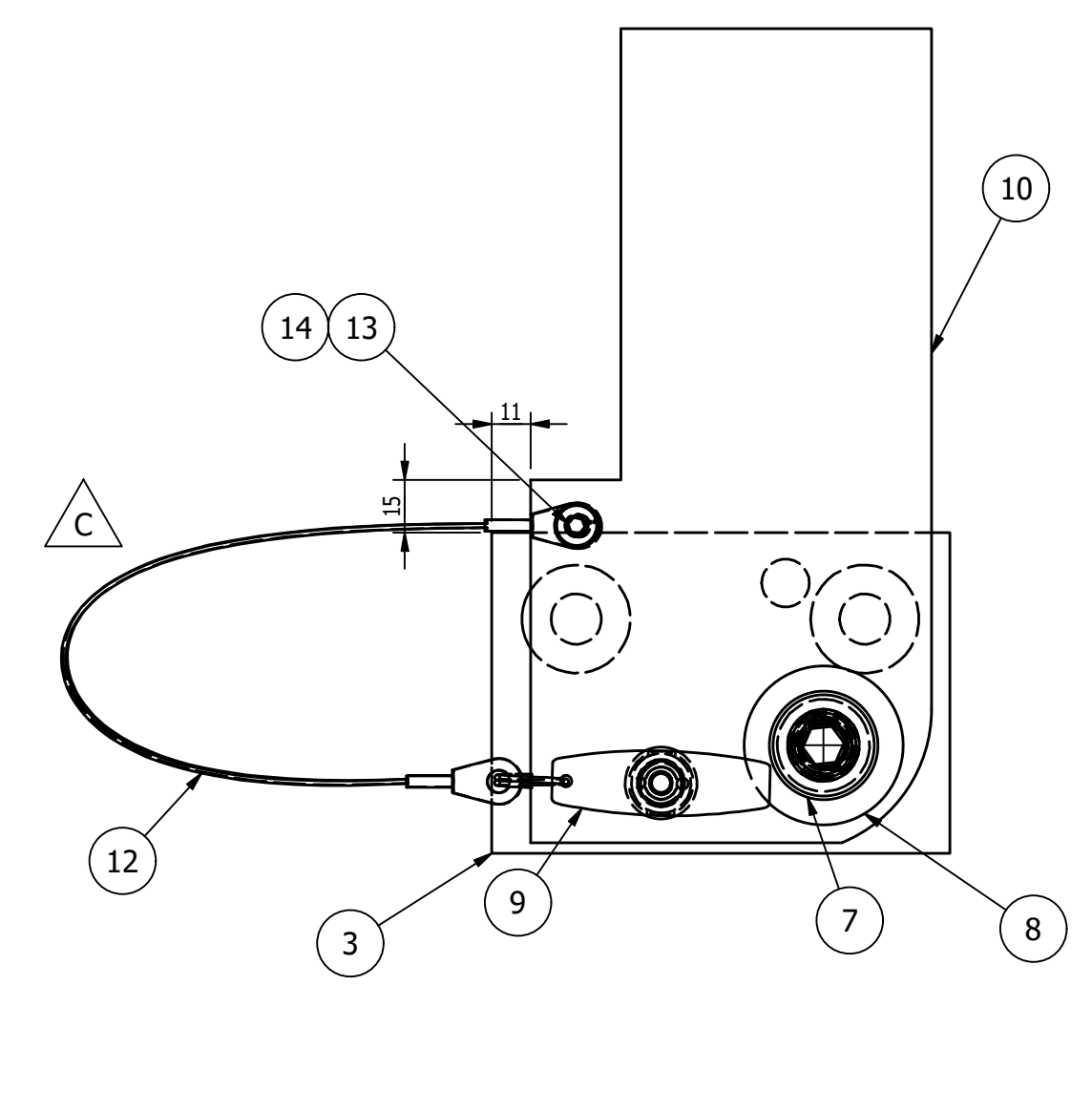
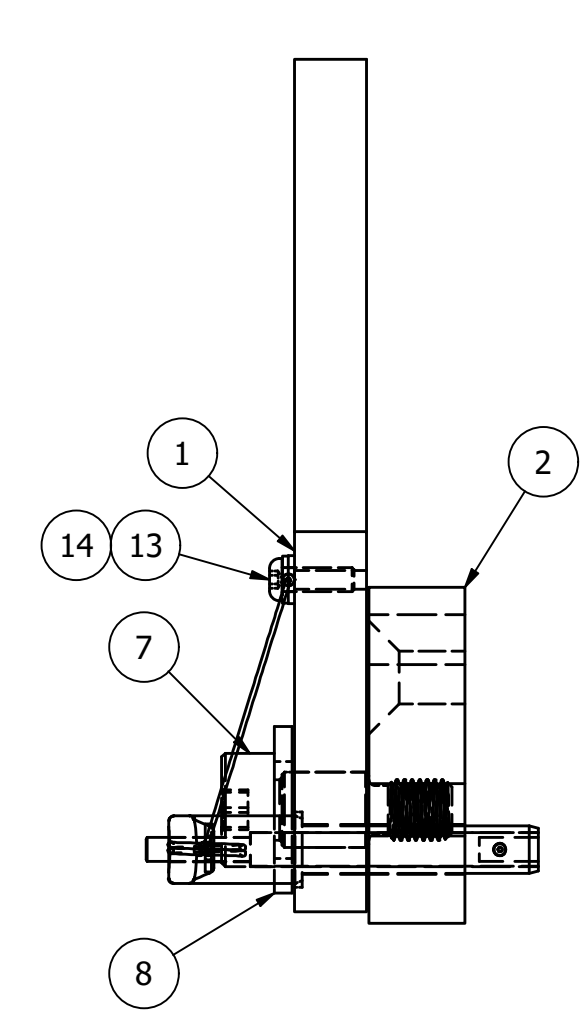
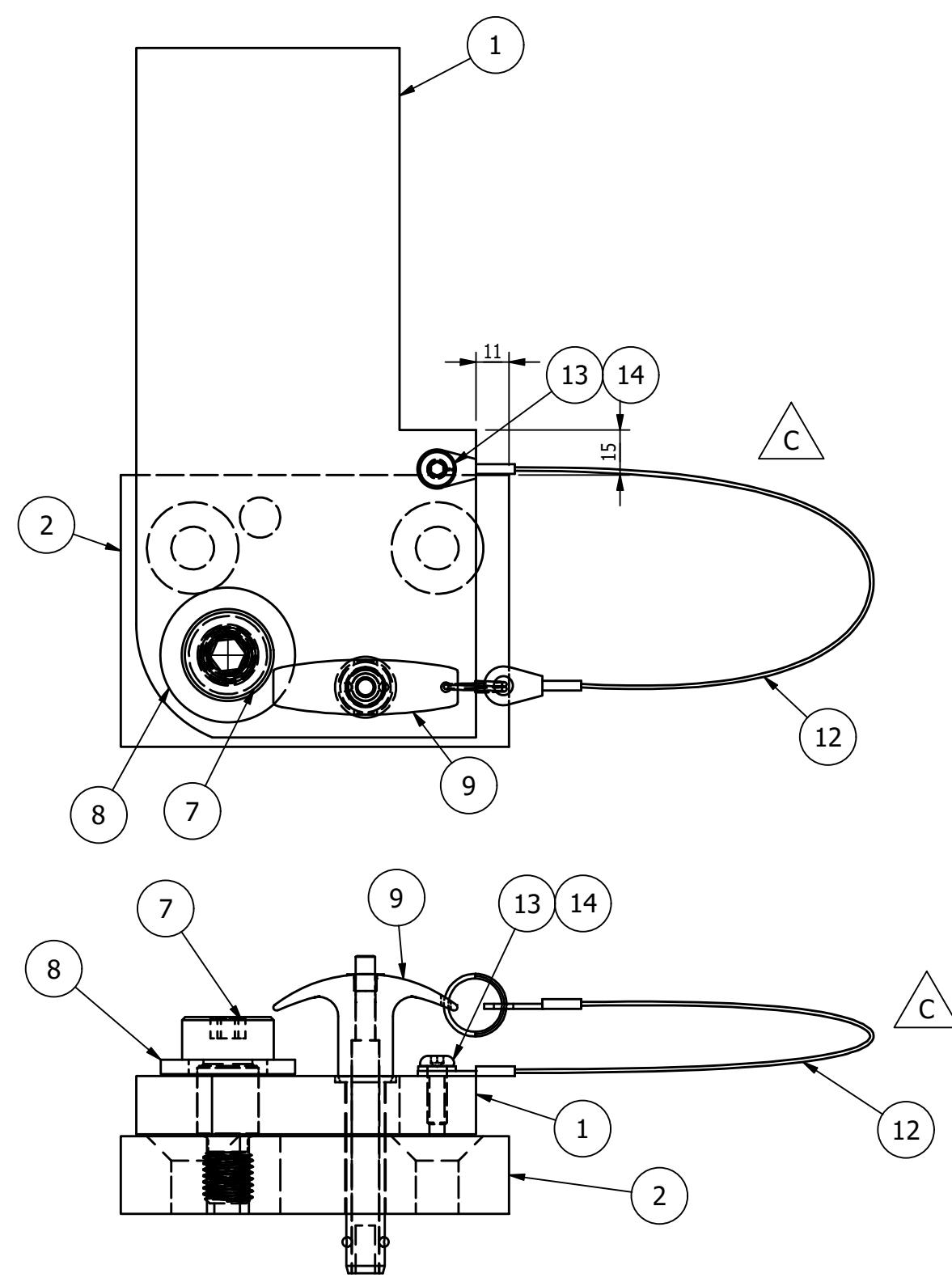
- ALL REINTRANT CUTS TO BE A MIN 1/2" RADIUS U.N.O.

<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b> <b>CLIENT: VOLVO</b> <b>DRAWING No. 1875D704</b>	<b>REV: B</b>	<b>DRAWN BY: AH</b> <b>CHECKED BY: CW</b> <b>DWG DATE: 7/5/2022</b> <b>JOB No: 22096</b>
--	---------------	---

3:00p 11/25/2022 New Job Drawing/Details/1875D704.dwg

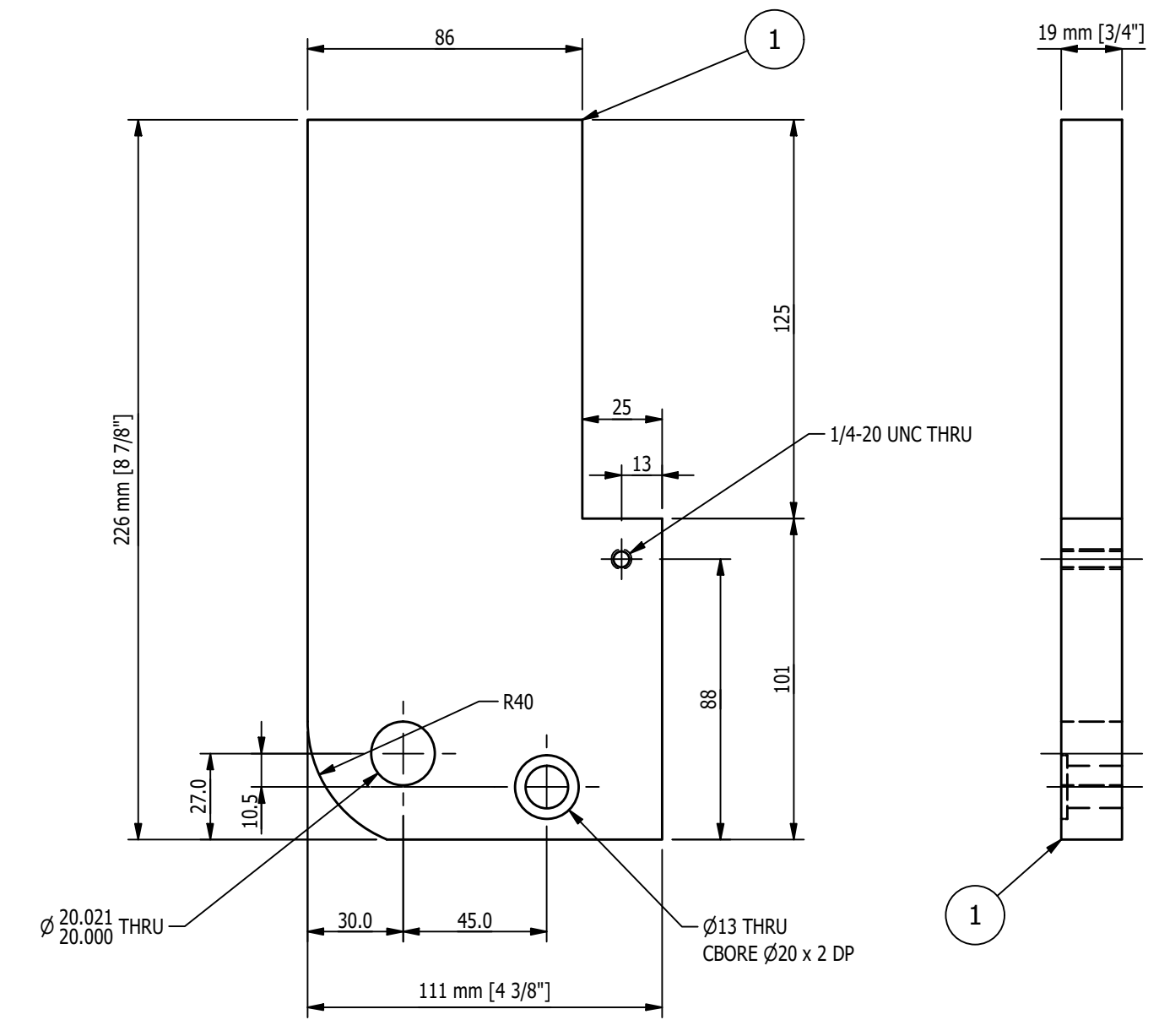


BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D705A			
1	1	PL 3/4 x 4 3/8" (CRS)	8 7/8"		
2	1	PL 1 x 3 1/2"	5"		
7	1	SOCKET HEAD SHOULDER SCREW, $\phi 20\text{mm}$ x 25mm LG, M16x2 x 20mm LG.		13-1	
8	1	M24 NARROW FLAT WASHER			
9	1	T-HANDLE LOCKING QUICK-RELEASE PIN, ORANGE, MCMaster-CARR 94268A700		13-3	
12	1	GALVANIZED STEEL LANYARD, 12" LG EYE-TO-EYE, MCMaster CARR PART NO. 30645T139		22-1	
13	1	1/4-28UNF x 3/4" LG. BUTTON HEX SOCKET HEAD CAP SCREW			
14	1	1/4 SPRING LOCK WASHER			
		MK-D705B			
3	1	PL 1 x 3 1/2"	5"		
7	1	SOCKET HEAD SHOULDER SCREW, $\phi 20\text{mm}$ x 25mm LG, M16x2 x 20mm LG.		13-1	
8	1	M24 NARROW FLAT WASHER			
9	1	T-HANDLE LOCKING QUICK-RELEASE PIN, ORANGE, MCMaster-CARR 94268A700		13-3	
10	1	PL 3/4 x 4 3/8"	8 7/8"		
12	1	GALVANIZED STEEL LANYARD, 12" LG EYE-TO-EYE, MCMaster CARR PART NO. 30645T139		22-1	
13	1	1/4-28UNF x 3/4" LG. BUTTON HEX SOCKET HEAD CAP SCREW			
14	1	1/4 SPRING LOCK WASHER			

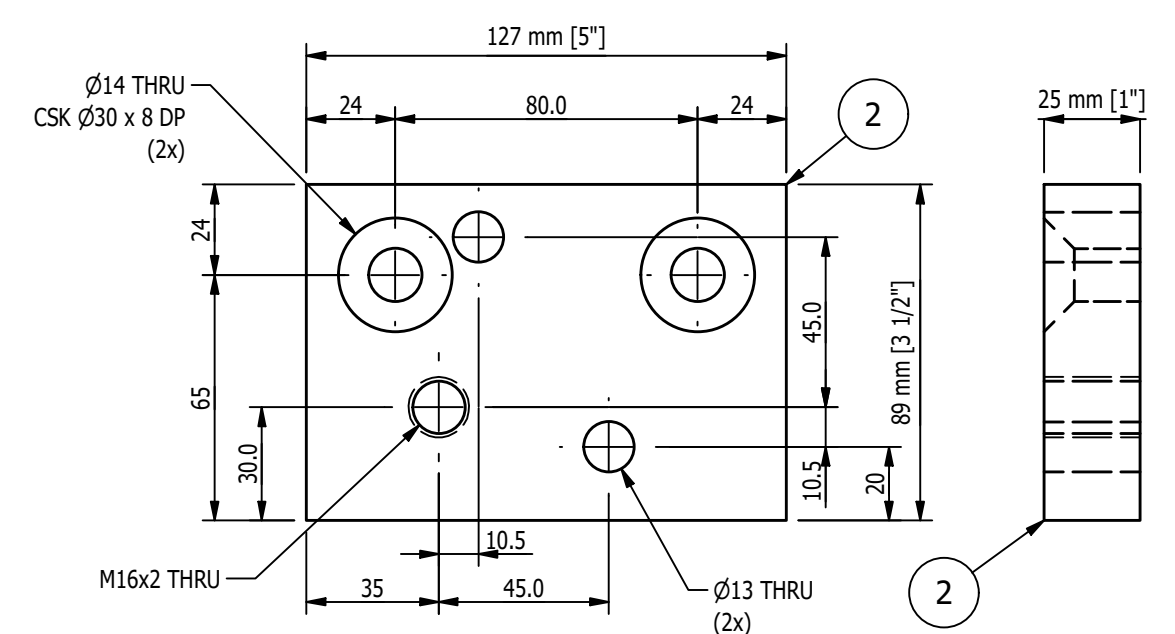


MK-D705A ~ PIVOTING PALLET/SKID STOP  
SCALE 6"=1'-0"

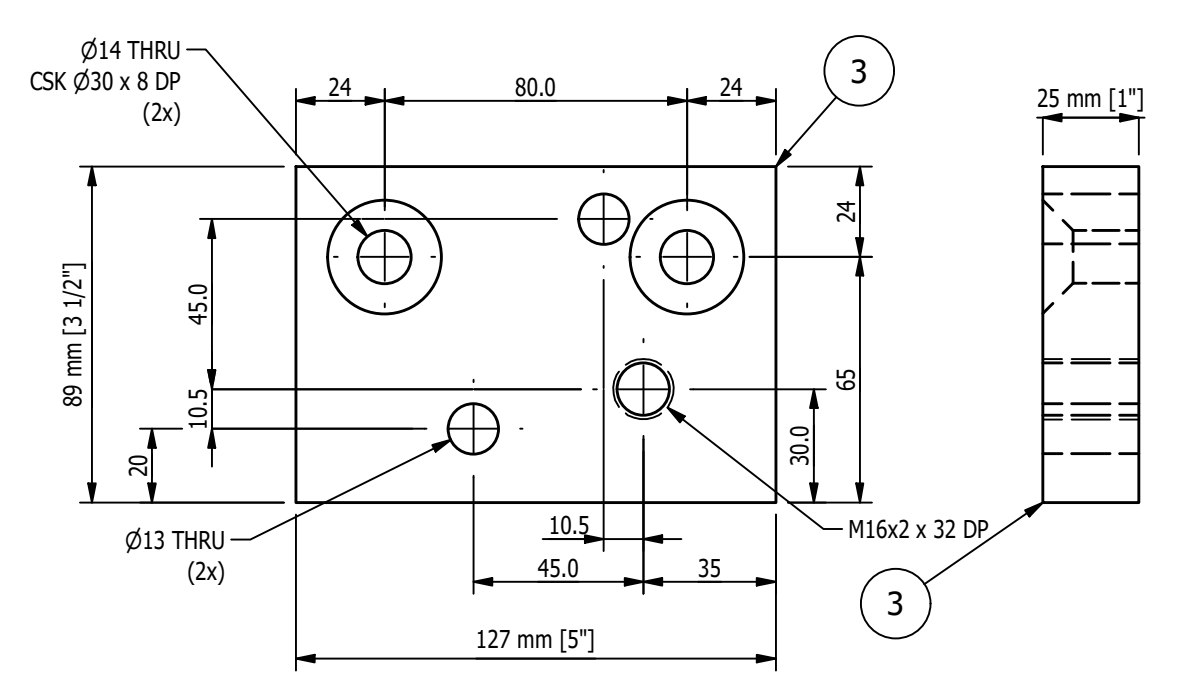
MK-D705B ~ PIVOTING PALLET/SKID STOP  
SCALE 6"=1'-0"



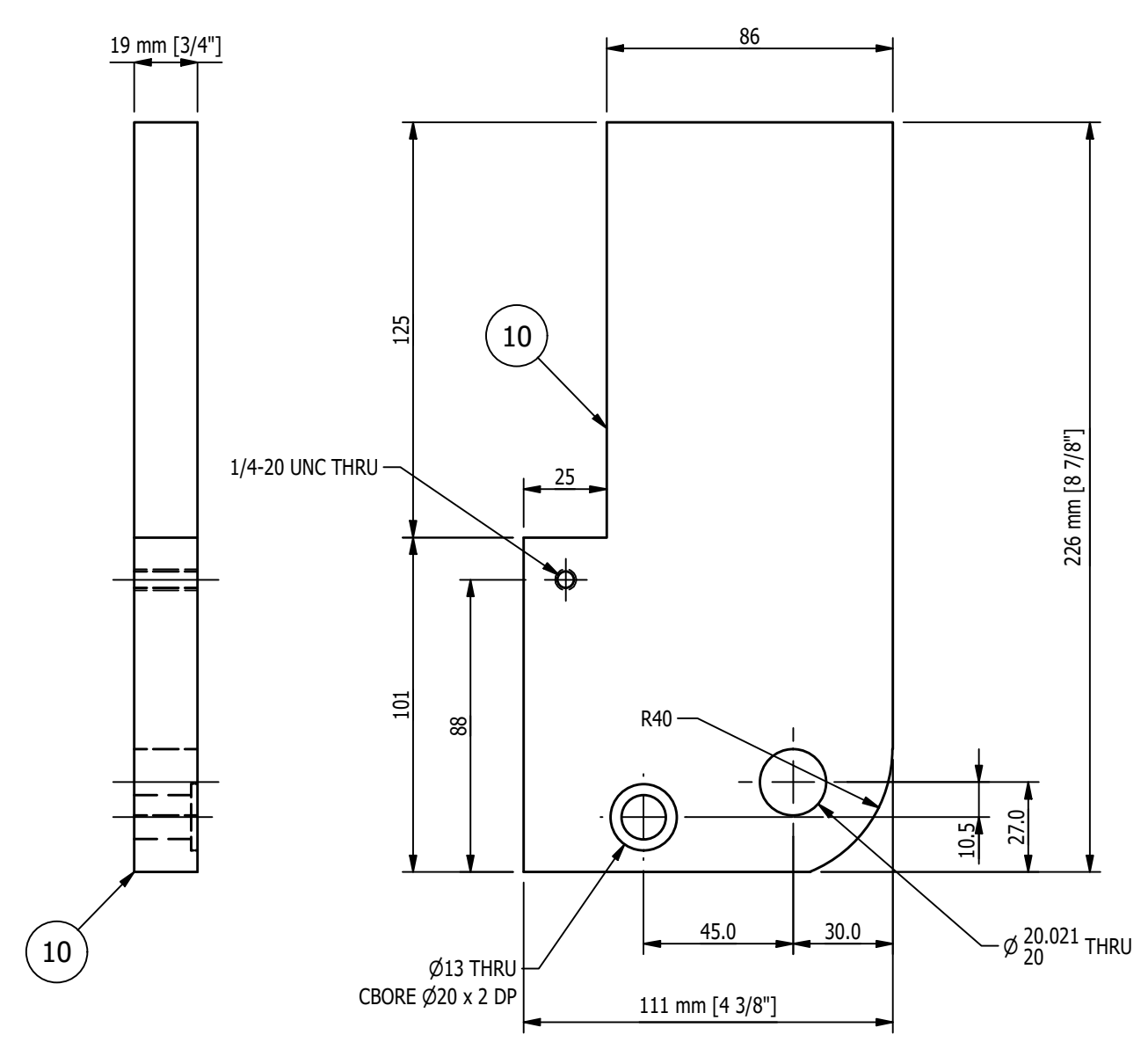
DETAIL OF ITEM '1'  
SCALE 6"=1'-0"



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



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



DETAIL OF ITEM '10'  
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 OR PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
C	MC	9/23/2022	REVISED DESCRIPTION AND VIEWS OF ITEM 12	
B	MC	9/7/22	REMOVED ITEMS '4', '5', '6', & '11'. ADDED ITEM '12', '13', & '14'. ADDED HOLES TO ITEM '1' & '10'	
A	MC	8/12/22	FOR FABRICATION	

REVISION HISTORY

**MAGNUM Consulting**  
41701 Gardenbrook Rd  
Suite 125  
Novi, MI 48215  
Phone: (248) 775-8655  
Fax: (248) 775-8651  
Web: www.4Magnum.com

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D705

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**

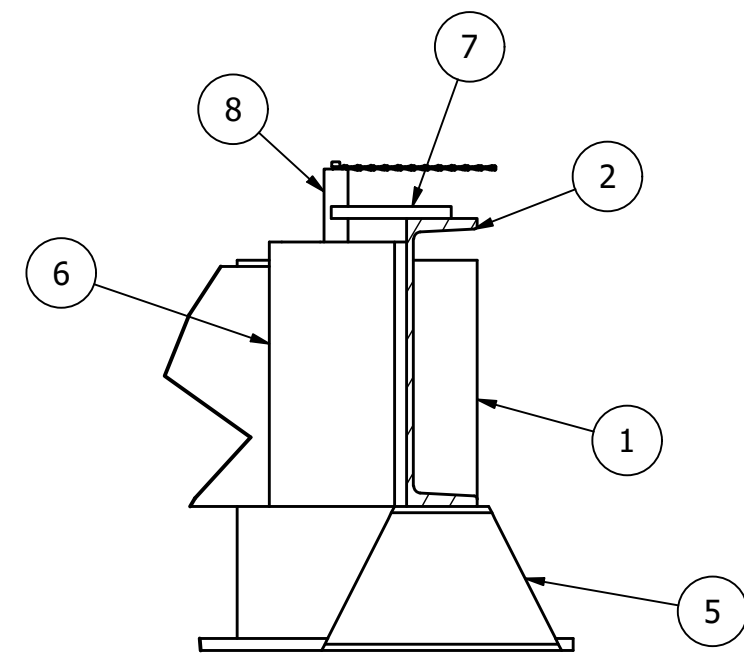
**CLIENT: VOLVO**

**DRAWING No. 1875D705**

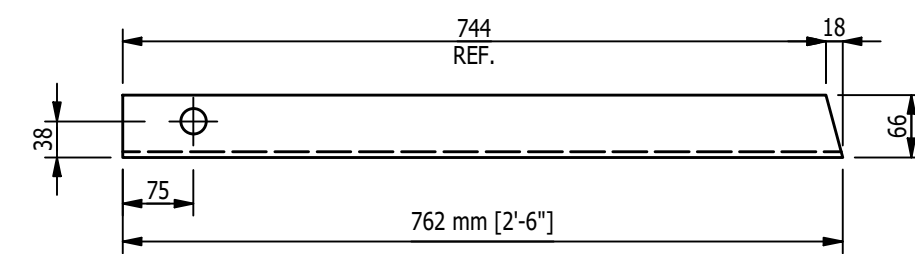
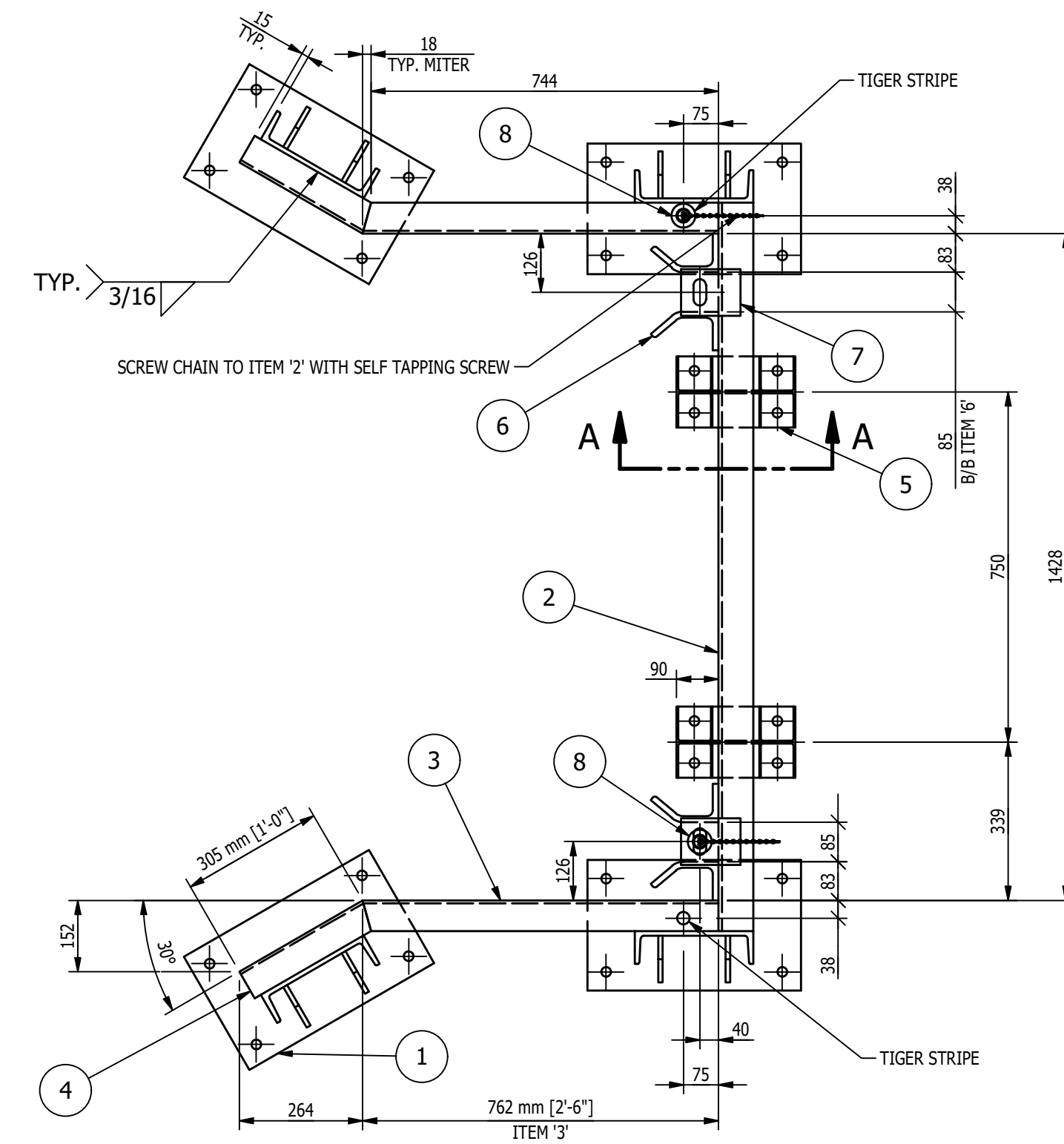
**REV: C**

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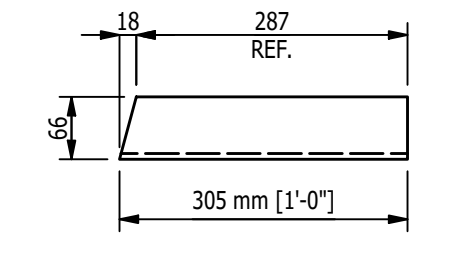
**DRAWN BY: AH**  
**CHECKED BY: PWP**  
**DWG DATE: 7/5/2022**  
**JOB No: 22096**



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

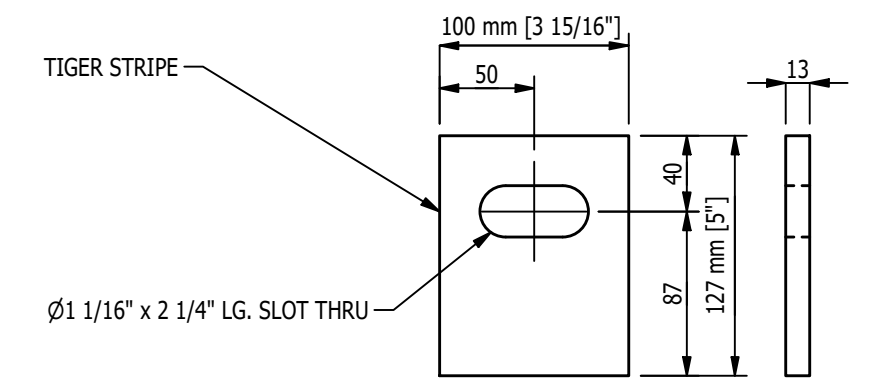


DETAIL OF ITEM '3'  
SCALE 1 1/2"=1'-0"

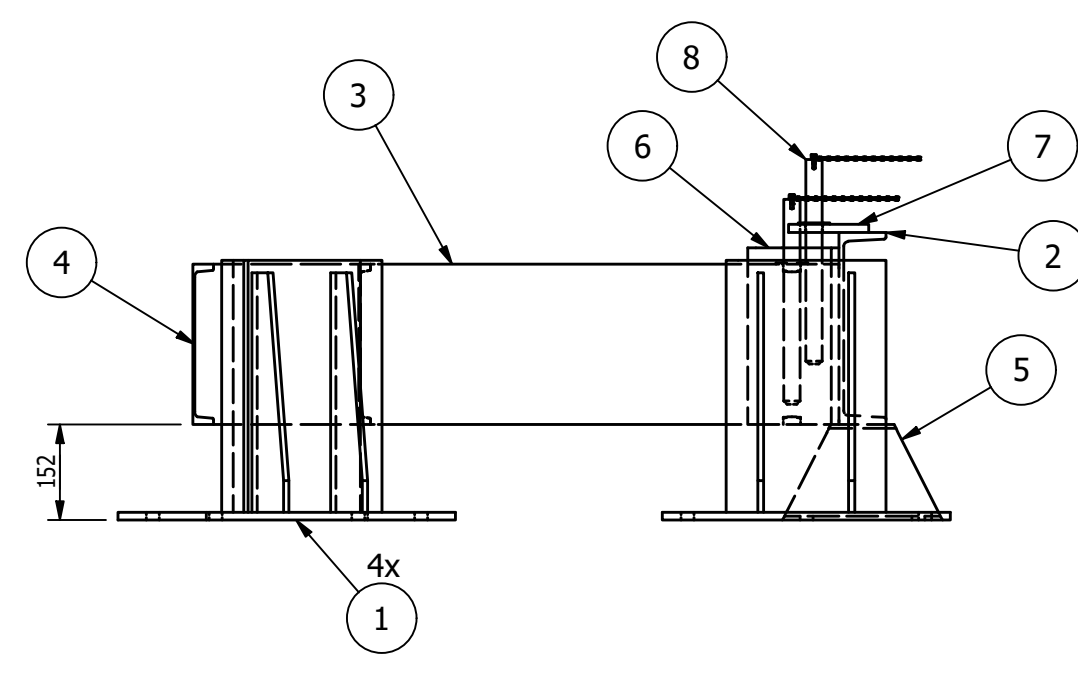
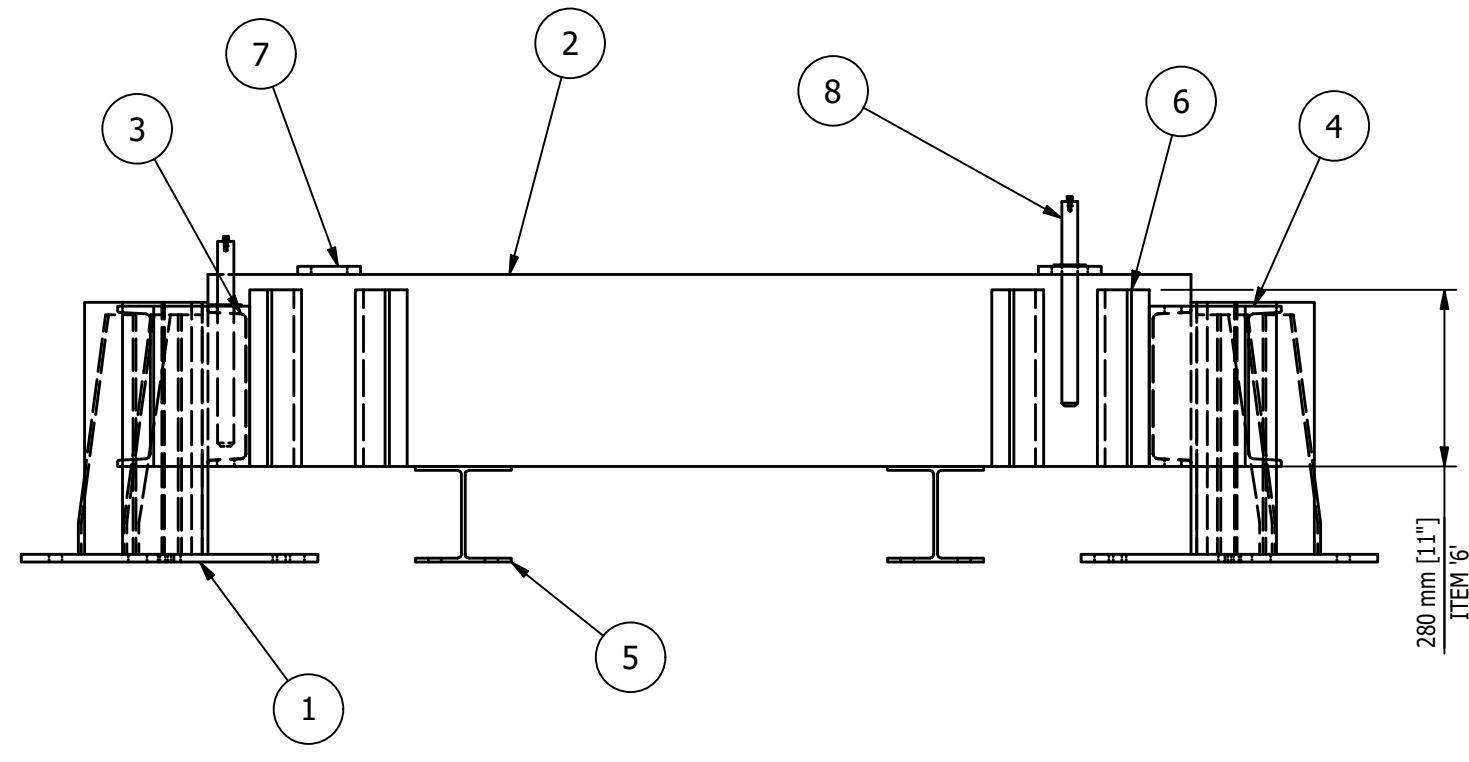


DETAIL OF ITEM '4'  
SCALE 1 1/2"=1'-0"

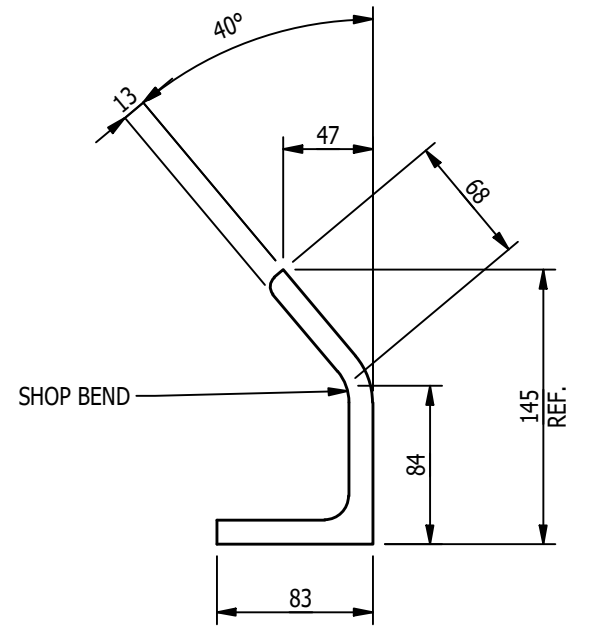
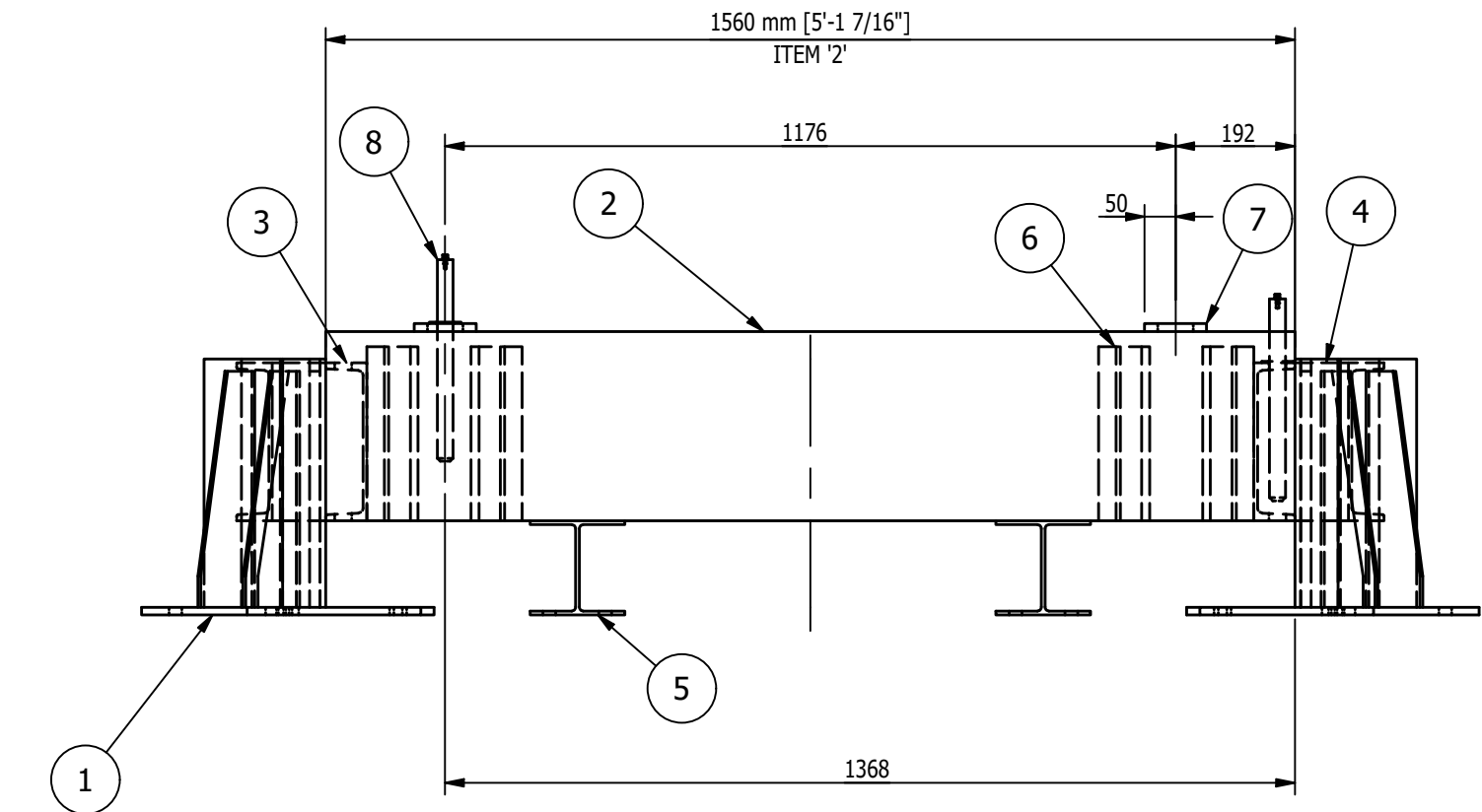
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D706A			
1	4	MK-D707A ~ LEG WELDMENT			
2	1	C 12 x 20.7	5'-1 7/16"		
3	2	C 10 x 15.3	2'-6"		MITER
4	2	C 10 x 15.3	1'-0"		MITER
5	2	W 6 x 15	10"		
6	4	L 6 x 3 1/2 x 1/2	11"		BEND
7	2	PL 1/2 x 3 15/16"	5"		
8	2	MK-D706B ~ DOCKING PIN			
TOTAL WEIGHT ~ 553.1 lbs					
		MK-D706B			
9	1	BAR Ø1 CRS	1'- 13/16"		
10	1	1 1/8 TYPE B NARROW FLAT WASHER #3607T14 (25 FT)			
11	2	SASH CHAIN, SIZE 8, McMASTER-CARR	2'-0"	14-4	
12	1	M5x0.8 x 10mm LG. HEX SOCKET HEAD CAP SCREW			
TOTAL WEIGHT ~ 2.9 lbs					



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



MK-D706A ~ PALLET DOCKING STATION  
SCALE 1"=1'-0"



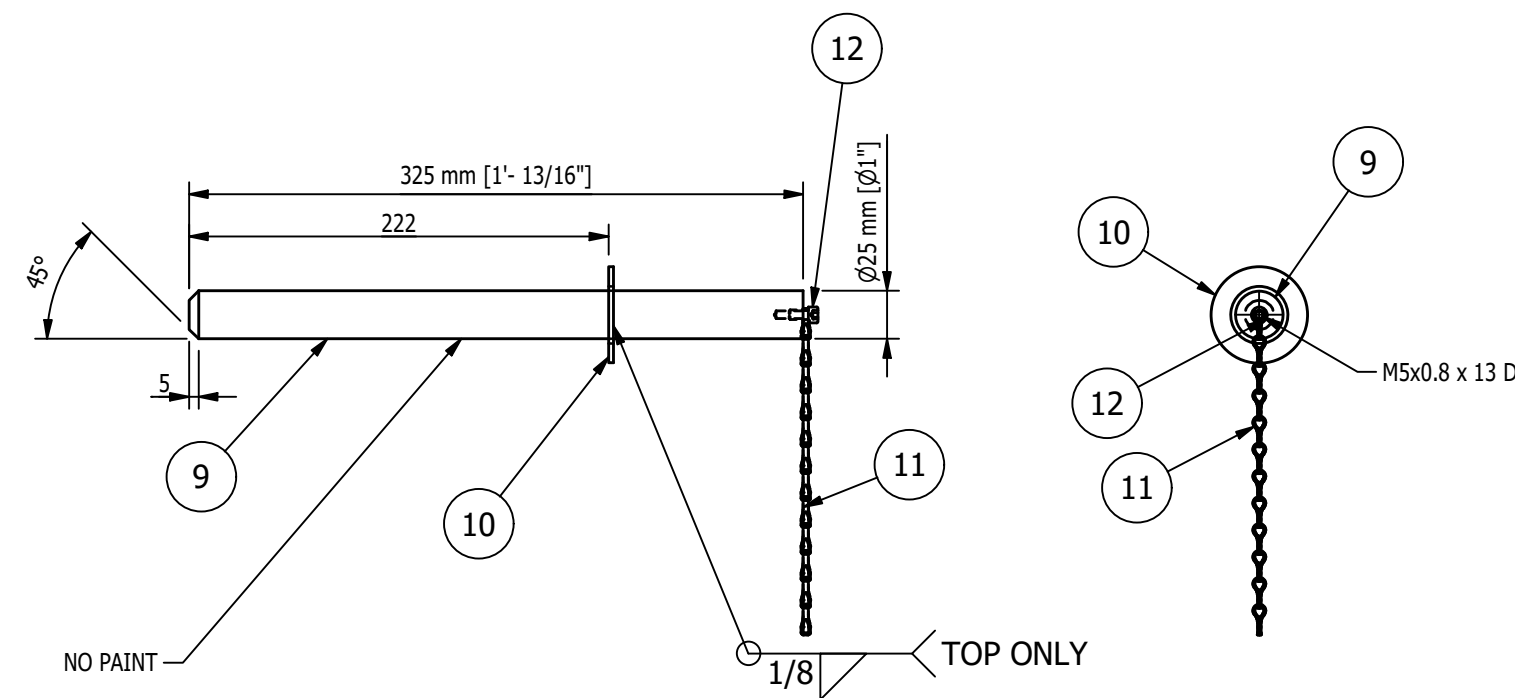
DETAIL OF ITEM '6'  
SCALE 3"=1'-0"

- 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.

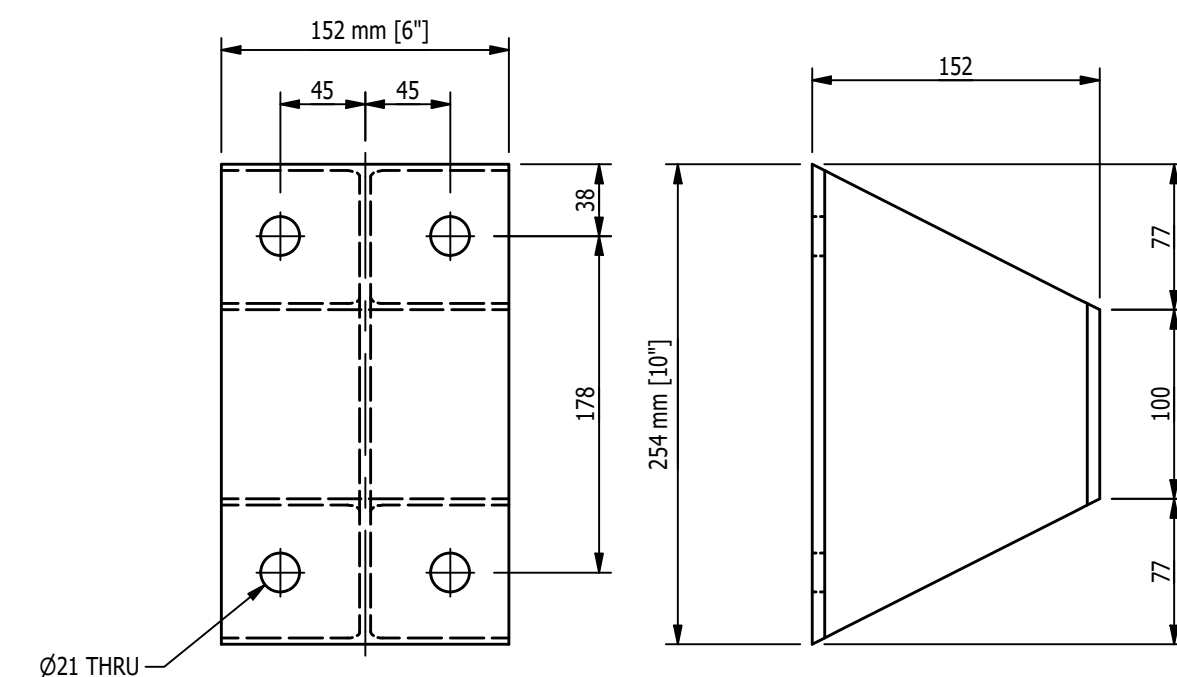
- PAINT NOTES:
- PAINT ALL FABRICATED STEEL  
ONE SHOP COAT OF LIGHT GREY RAL 7035  
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/22	ADDED DETAILS OF ITEMS '3' & '4', UPDATED DESCRIPTION OF ITEM '9', ADDED REMARKS TO ITEMS '3', '4', & '6', ADDED TIGER STRIPE LOCATION NOTES	
A	MC	8/12/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
		FENTON, MI 48430		DRAWING IS THE SOLE PROPERTY	
		PH: 810.373.0322 FAX: 810.373.0326		OF MILLER INDUSTRIES. ANY	
		www.millc.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: AH		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 7/18/22		JOB No: 22096	
DRAWING No. 1875D706		REV: B			



MK-D706B ~ DOCKING PIN  
SCALE 3"=1'-0"



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

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

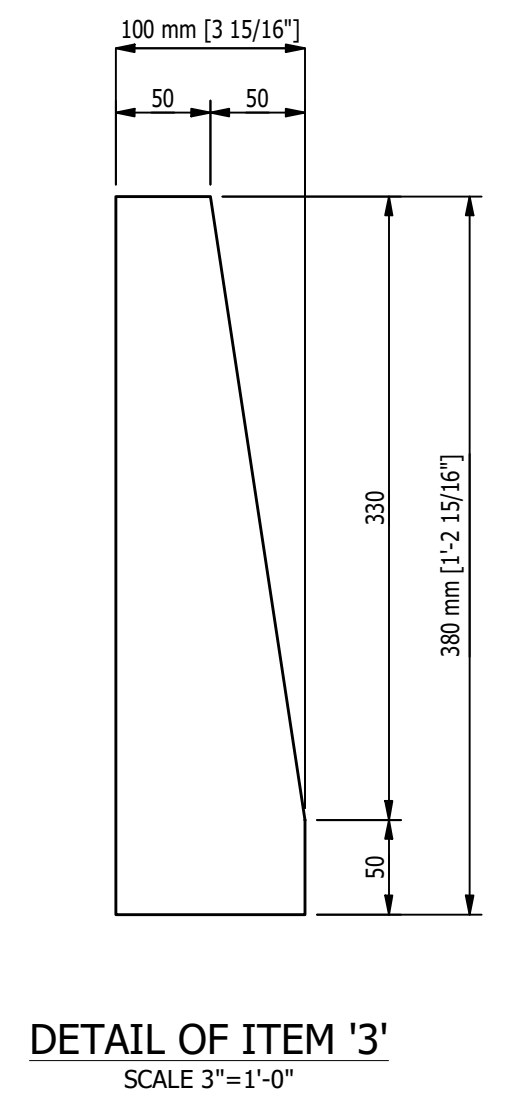
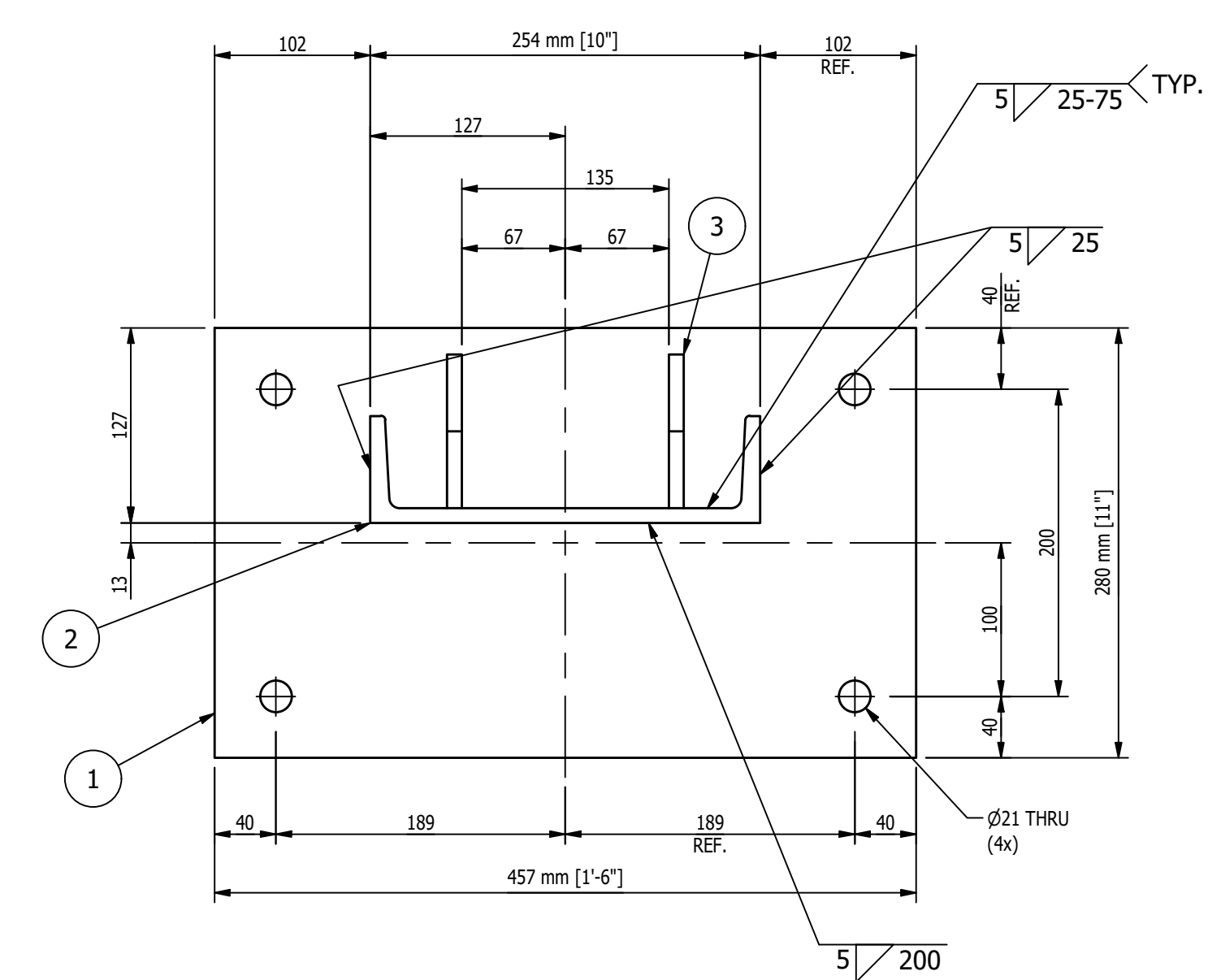
MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D706

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

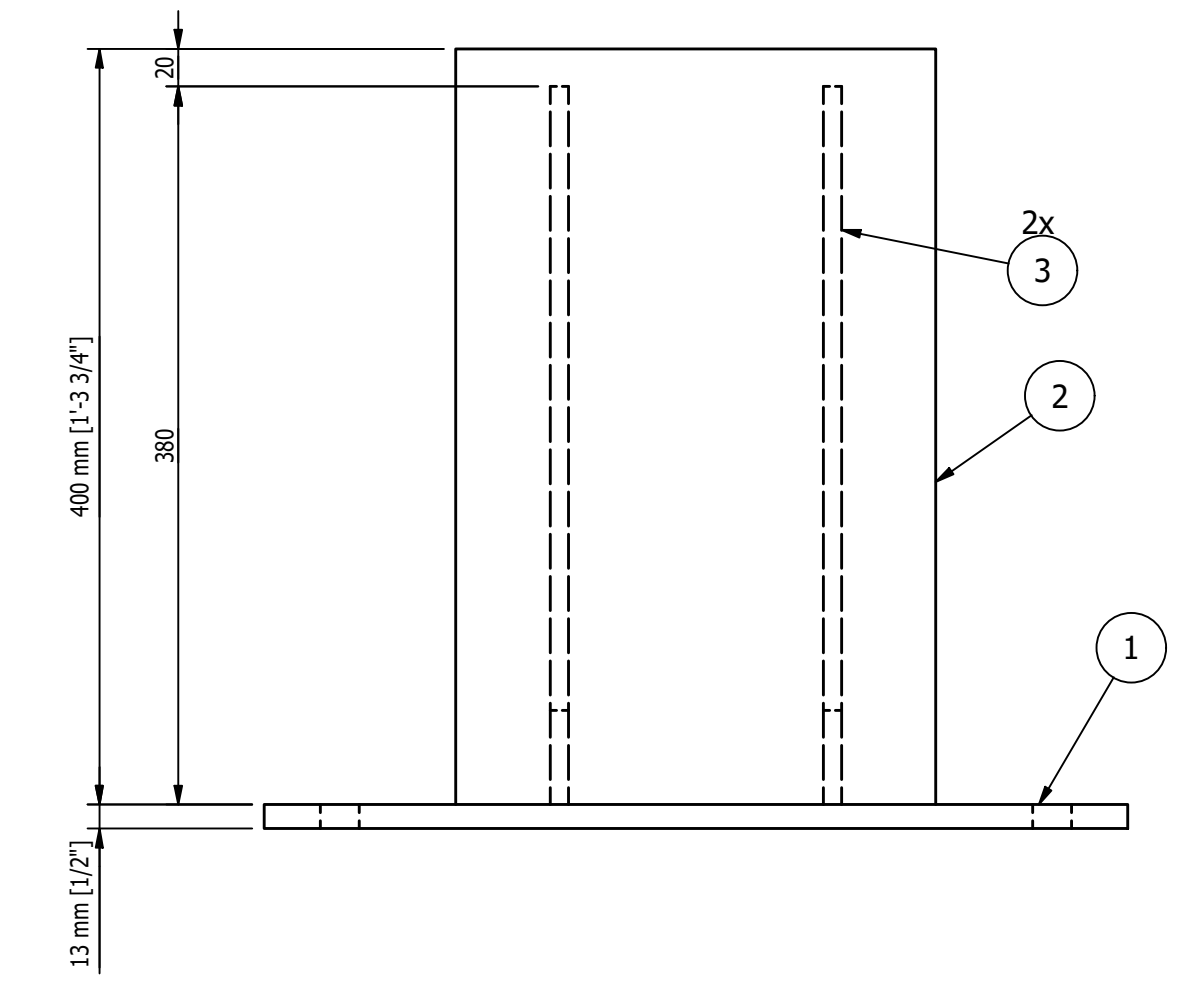
GENERAL NOTES:  
MATERIALS:  
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.  
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.  
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.  
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.  
HOLES:  
- ALL HOLES ARE 13/16" DIA. U.N.O.  
- ALL BOLTED CONNECTIONS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



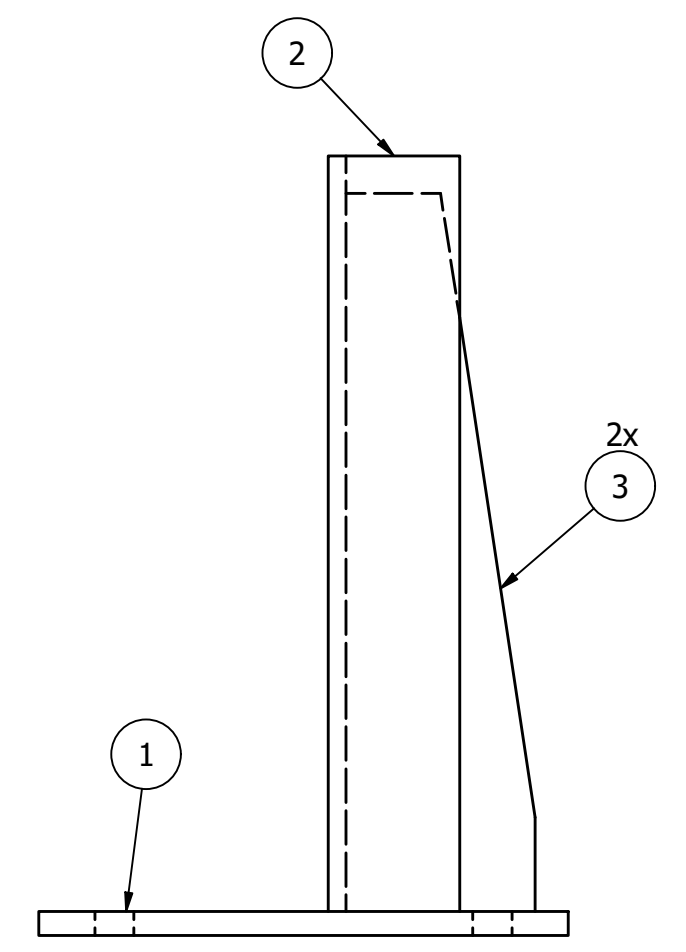
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D707A			
1	1	PL 1/2 x 11"	1'-6"		
2	1	C 10 x 20	1'-3 3/4"		
3	2	PL 3/8 x 3 15/16"	1'-2 15/16"		
TOTAL WEIGHT ~ 64 lbs					



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




MK-D707A ~ LEG WELDMENT  
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" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
  6. ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
  7. MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
  8. ALL SLOT LENGTHS ARE END TO END U.N.O.

**PAINT NOTES:**  
B DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/22	UPDATED PAINT NOTES	
A	MC	8/12/22	FOR FABRICATION	

 <b>MILLER INDUSTRIES</b> 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
<b>TITLE: P6700 CONVEYORS CAMPUS BUILDING</b>		<b>DRAWN BY: AH</b>
<b>CLIENT: VOLVO</b>		<b>CHECKED BY: CW</b>
<b>DRAWING No. 1875D707</b>		<b>DWG DATE: 7/18/22</b>
<b>REV: B</b>		<b>JOB No: 22096</b>

**MAGNUM Consulting**  
 41100 QuakerRoad Rd.  
 Suite 125  
 Novi, MI 48275  
 Phone: (248) 772-8822  
 Fax: (248) 772-8851  
 Web: www.mmagnum.com  
 MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 1875D707

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)

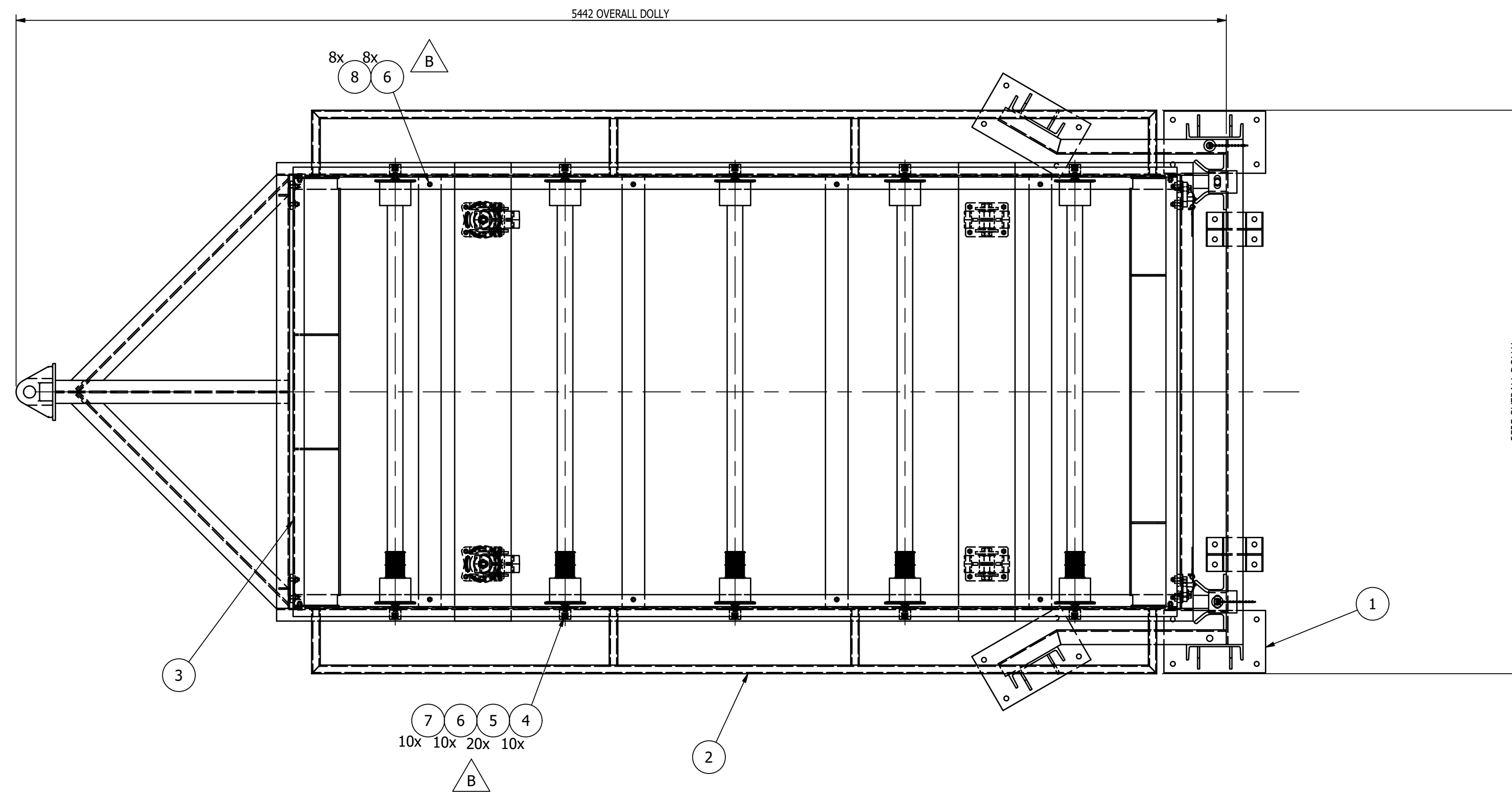
**PAINT:**

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

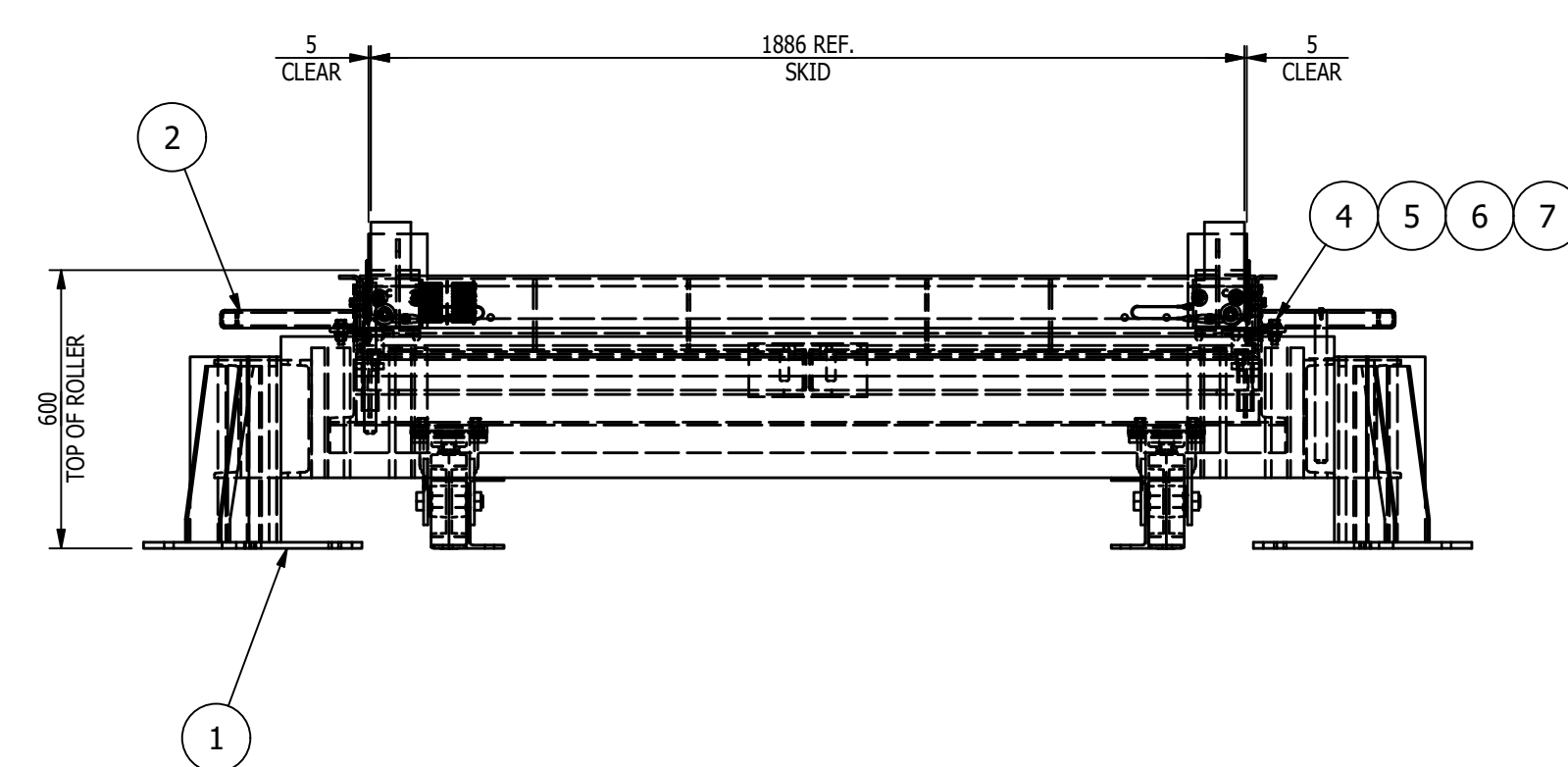
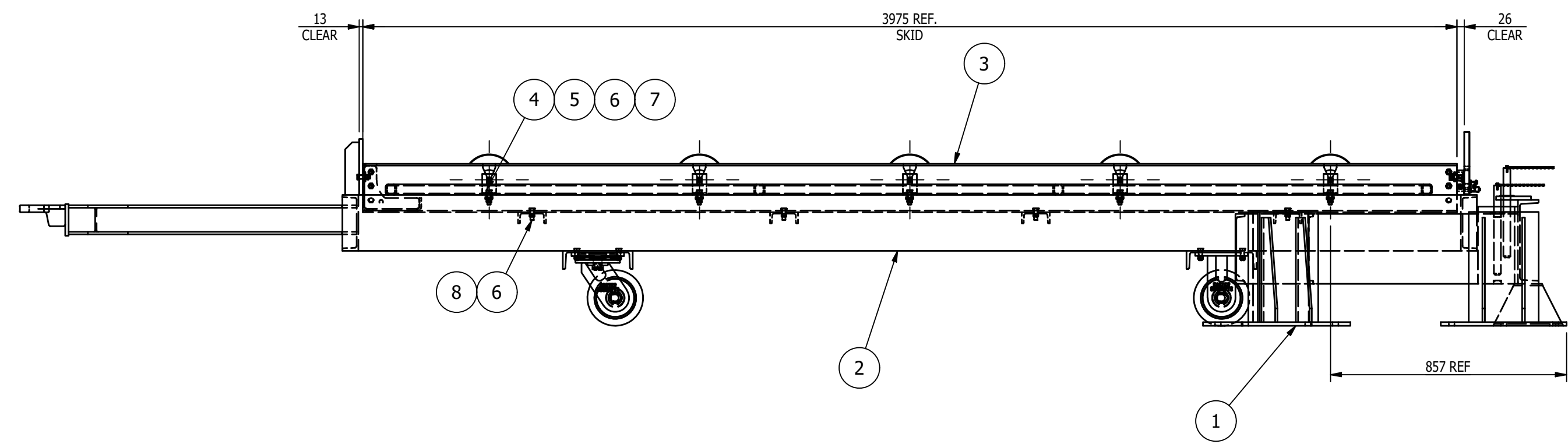
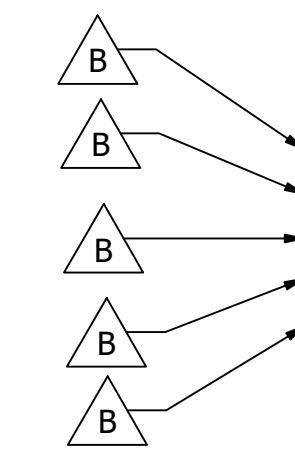
**COPIES:**

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





BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D708A			
1	1	MK-D712A ~ SKID DOCKING STATION			
2	1	MK-D711A ~ SKID PULL-OUT DOLLY			
3	1	MK-D709A ~ SKID PULL-OUT ROLLER BED			
4	10	M12 HARDENED BEVEL WASHER			
5	20	M12 NARROW FLAT WASHER			
6	18	M12 x 1.75 STOVER LOCK NUT			
7	10	M12x1.75 x 45mm LG. HEX CAP SCREW			
8	8	M12x1.75 x 35mm LG. HEX CAP SCREW			
		TOTAL WEIGHT ~ 3128.6 lbs			



MK-D708A ~ SKID PULL-OUT AND DOCKING STATION  
SCALE 3/4"=1'-0"

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/22	ADDED ITEMS '4', '5', '6', '7', & '8'	
A	MC	8/12/22	FOR FABRICATION	

**REVISION HISTORY**

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

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	PWP
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D708	DWG DATE:	7/5/22
REV:	B	JOB No.:	22096

**MAGNUM CONSULTING**  
41100 QuakerRoad Rd.  
Suite 125  
North, MI 48175

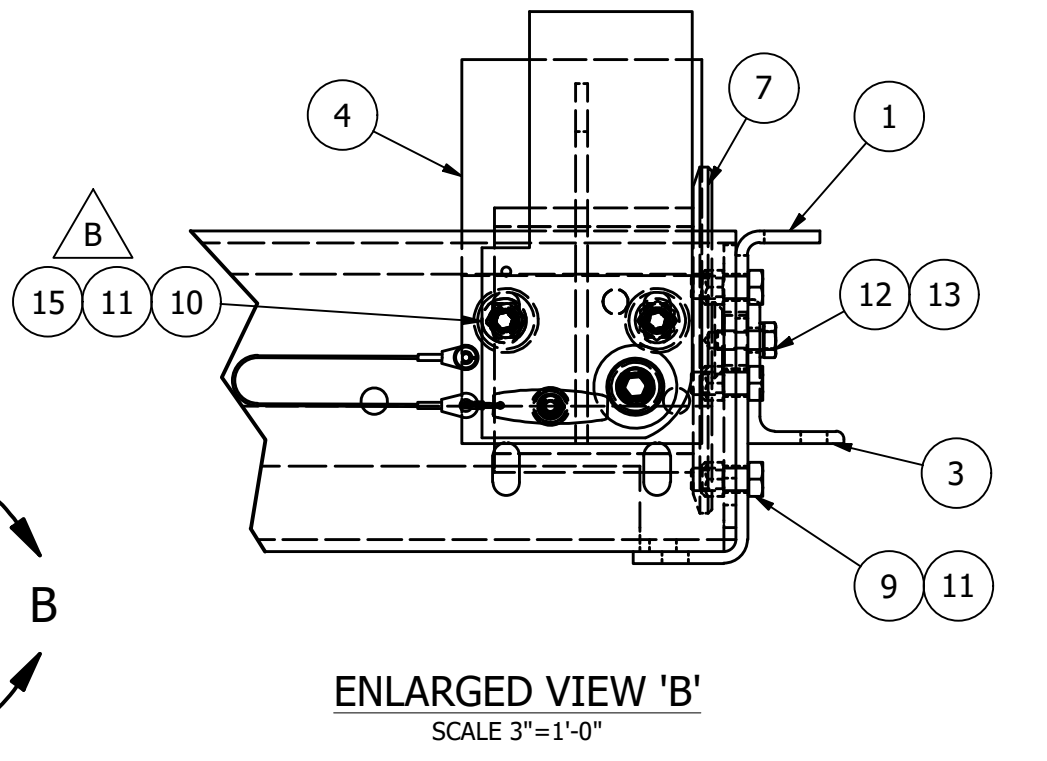
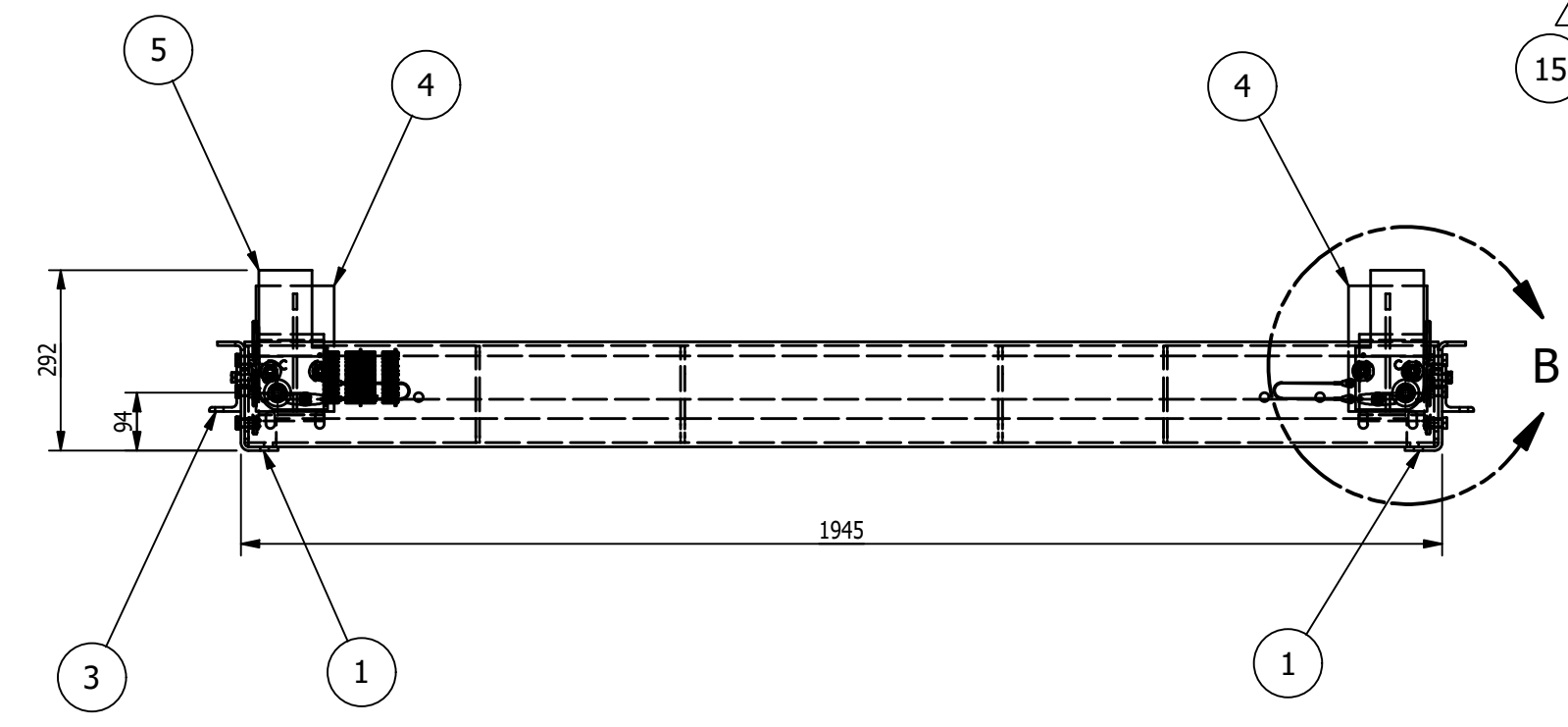
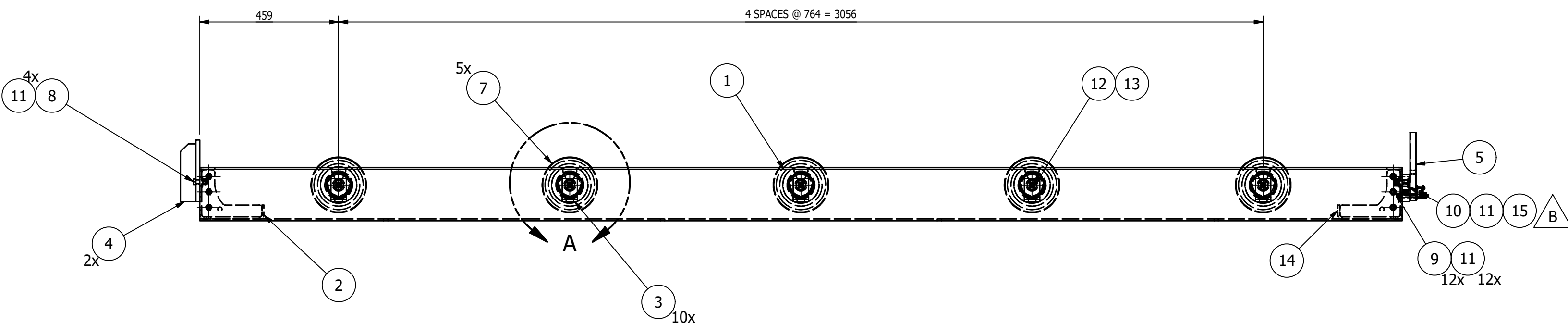
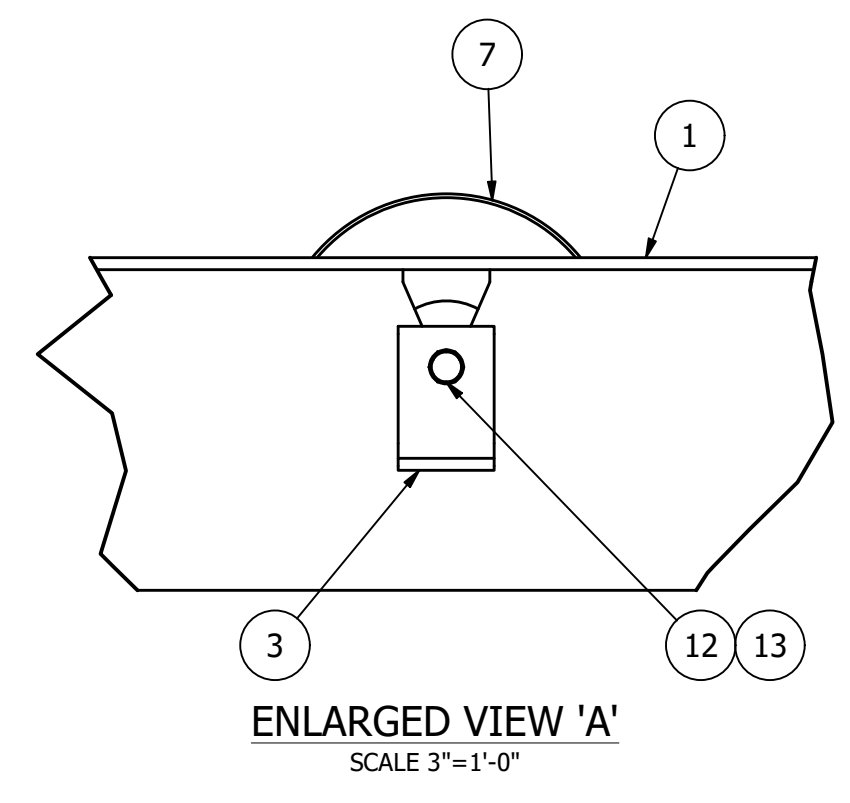
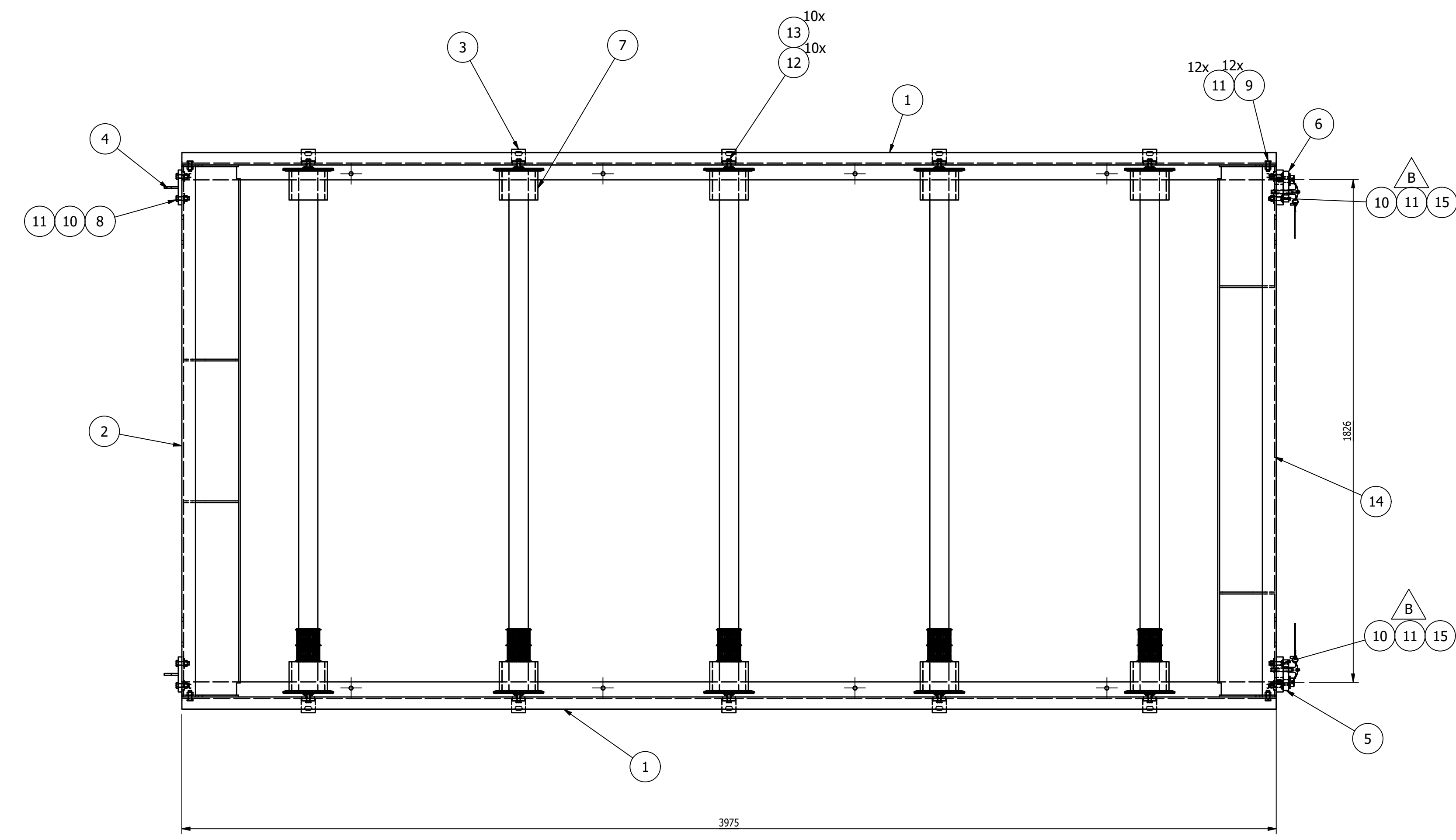
Phone: (248) 772-8855  
Fax: (248) 772-8851  
Web: www.mmagnum.com

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D708

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-D709A			
1	2	MK-D710A ~ Z-FRAME ASSEMBLY			
2	1	MK-D002A ~ END PLATE ASSEMBLY			
3	10	MK-D704A ~ ROLLER CLIP			
4	2	MK-D704B ~ FIXED PALLET STOP			
5	1	MK-D705A ~ PIVOTING PALLET/SKID STOP			
6	1	MK-D705B ~ PIVOTING PALLET/SKID STOP			
7	5	D140/70/30 Z34 HTD 8M-55 DRIVEN ROLLER POLYURETHANE COATED WHEELS, DUGOMRULLI DRIVEN ROLL, PART NO. 329A060W			
8	4	M12x1.75 x 40mm LG. HEX CAP SCREW			
9	12	M12x1.75 x 30mm LG. HEX CAP SCREW			
10	8	M12 REGULAR FLAT WASHER			
11	20	M12 x 1.75 STOVER LOCK NUT			
12	10	M10x1.5 x 25mm LG. HEX CAP SCREW			
13	10	M10 SPRING LOCK WASHER			
14	1	MK-D713A ~ END PLATE ASSEMBLY			
15	4	M12x1.75 x 50mm LG. FLAT HEX SOCKET HEAD CAP SCREW			
		TOTAL WEIGHT ~ 1378.8 lbs			



MK-D709A ~ SKID PULL-OUT ROLLER BED  
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	9/7/22	ADDED ITEM '15', QUANTITIES UPDATED FOR ITEMS '10' & '11'	
A	MC	8/12/22	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>	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	PWP
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D709	DWG DATE:	7/5/22
		REV:	B
		JOB No.:	22096

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

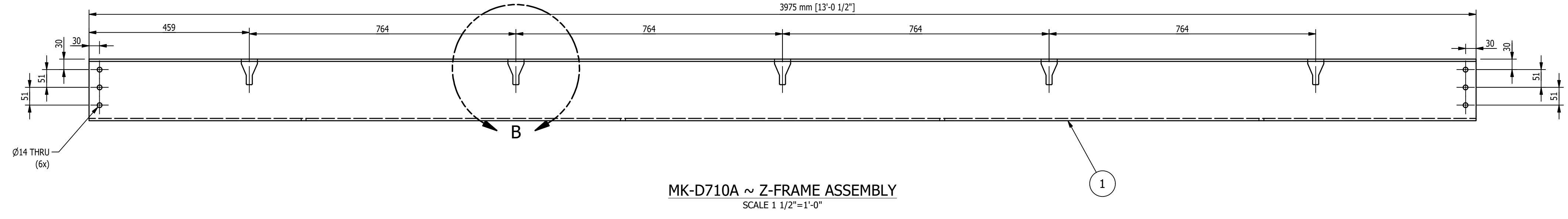
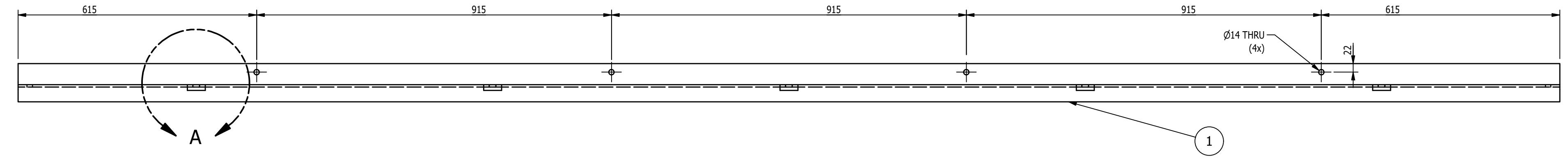
MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D709

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

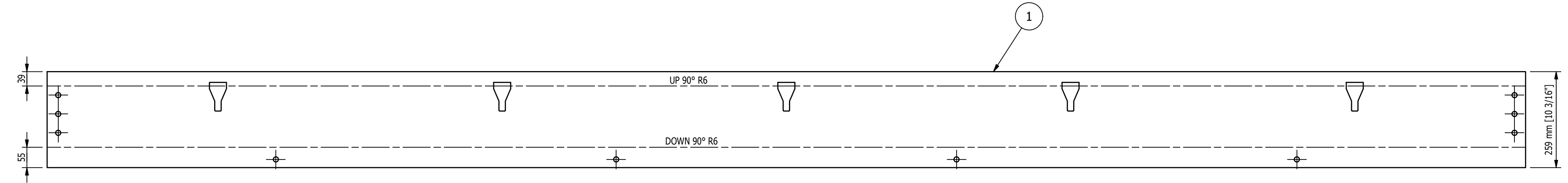
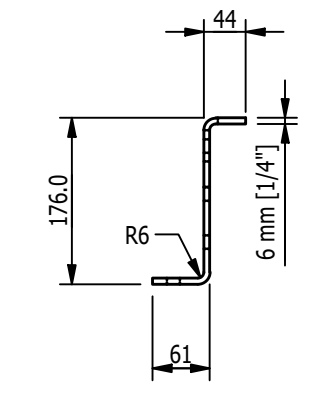
GENERAL NOTES:  
MATERIALS:  
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.  
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.  
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.  
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.  
HOLES:  
- ALL HOLES ARE 13/16" DIA. U.N.O.  
- ALL BOLTED CONNECTIONS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



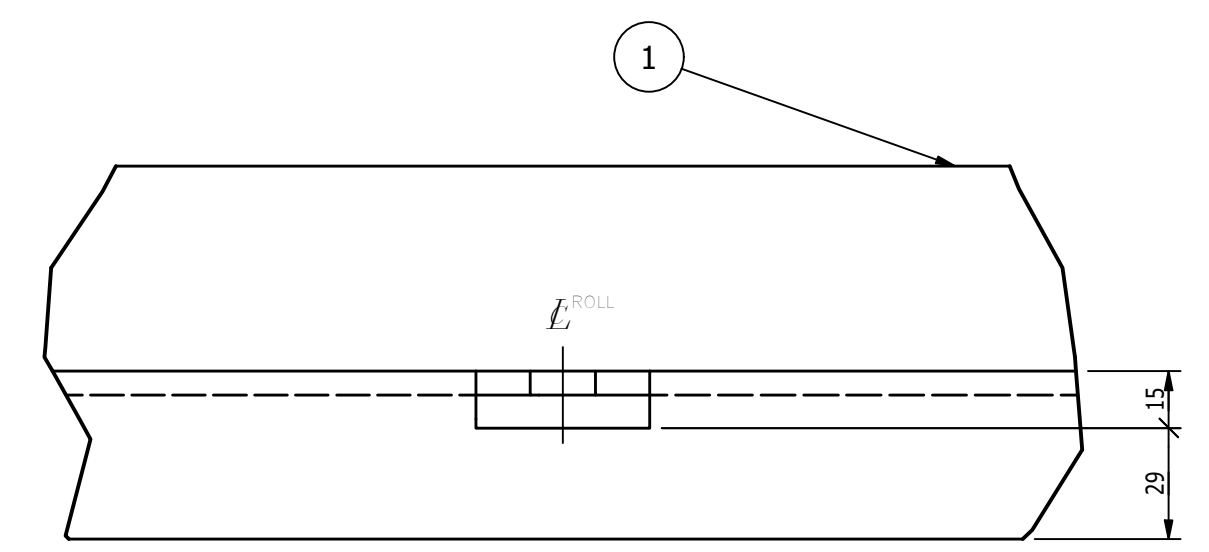
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D710A			
		PL 1/4 x 10 3/16"	13'- 1/2"		
TOTAL WEIGHT ~ 112.5 lbs					



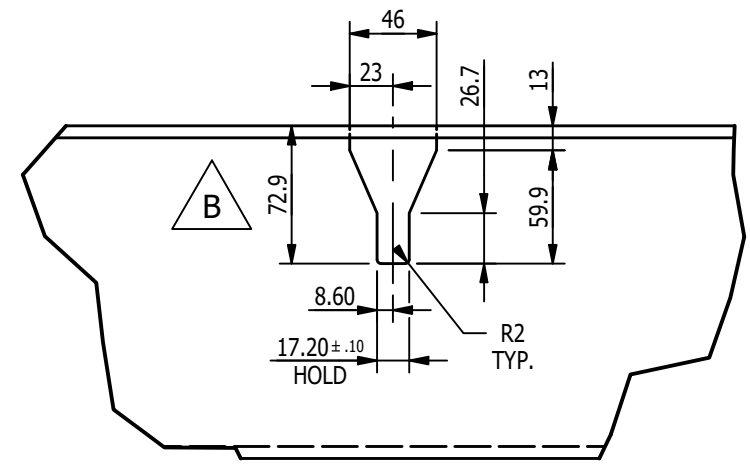
**MK-D710A ~ Z-FRAME ASSEMBLY**  
SCALE 1 1/2"=1'-0"



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



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



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

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/22	UPDATED SLOTS FOR ROLLER PLACEMENT	
A	MC	8/12/22	FOR FABRICATION	

**REVISION HISTORY**

	<b>MILLER INDUSTRIES</b> 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.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.
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<b>TITLE:</b> P6700 CONVEYORS CAMPUS BUILDING	<b>DRAWN BY:</b> PWP
<b>CLIENT:</b> VOLVO	<b>CHECKED BY:</b> CW
<b>DRAWING No.:</b> 1875D710	<b>DWG DATE:</b> 7/5/22
<b>REV:</b> B	<b>JOB No.:</b> 22096

**MAGNUM Consulting**  
41703 Gardenbrook Rd  
Suite 125  
Novi, MI 48215  
Phone: (248) 775-8655  
Fax: (248) 775-8651  
Web: www.4magnum.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:**

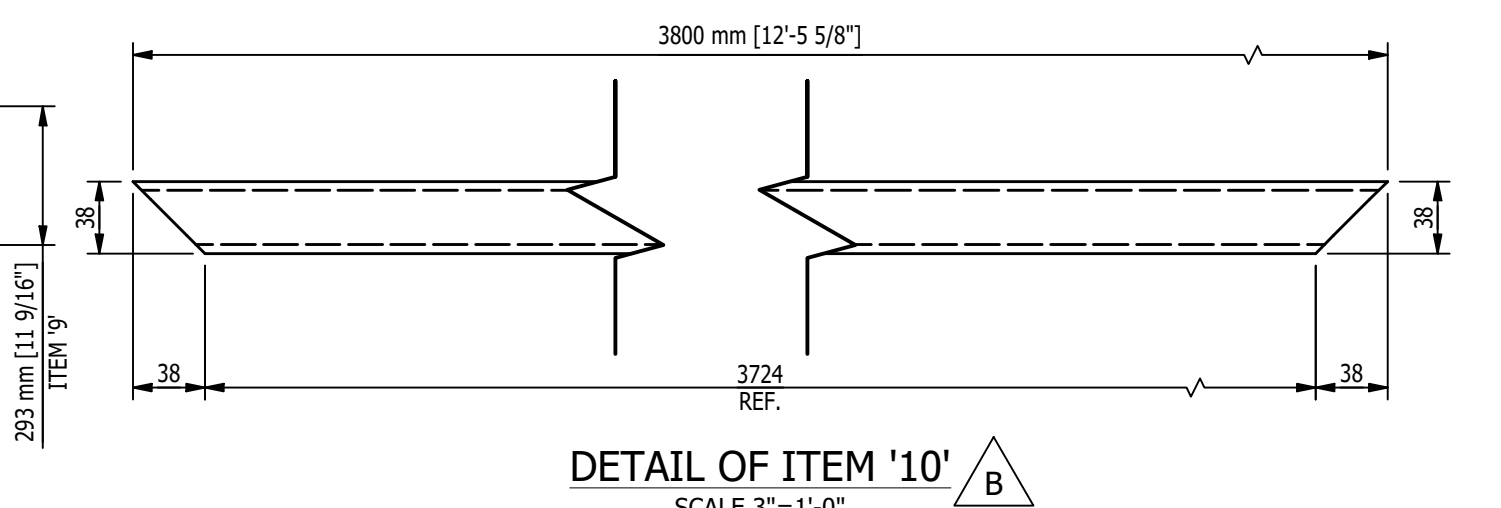
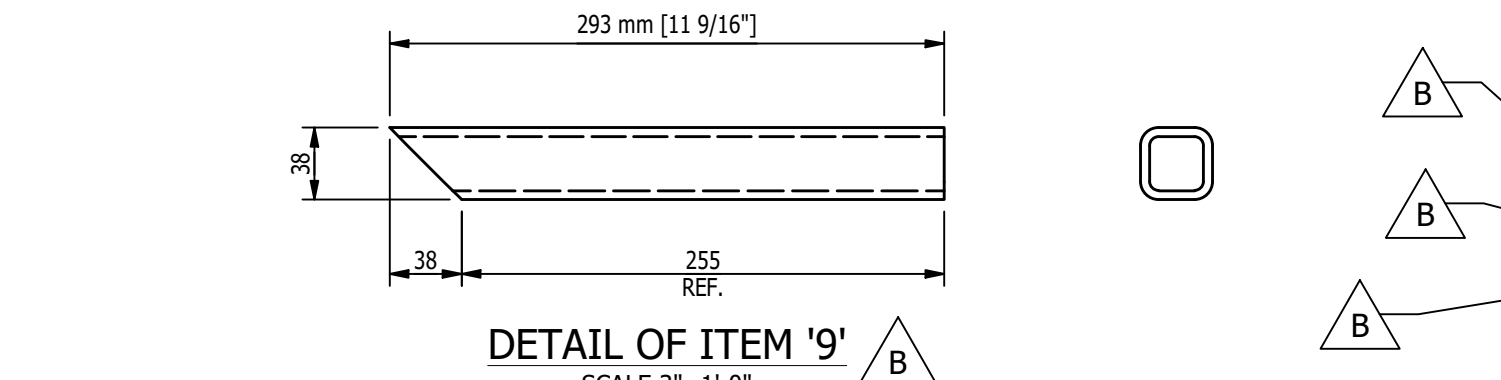
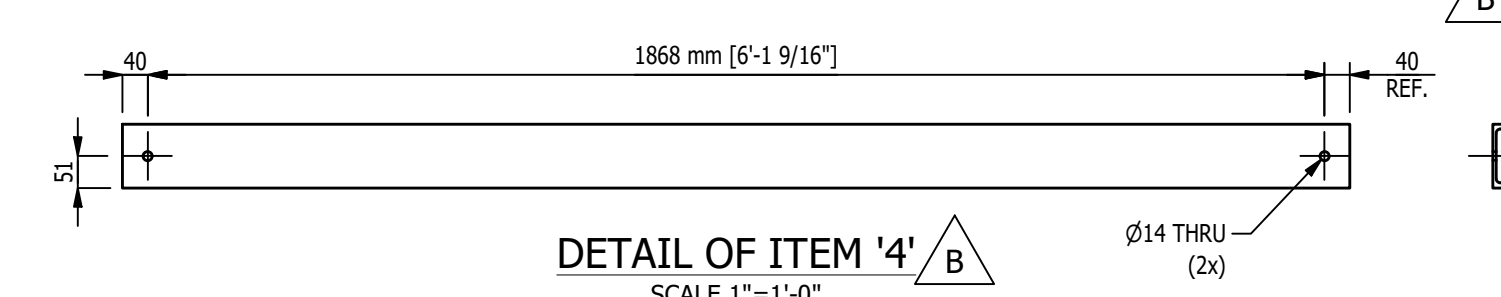
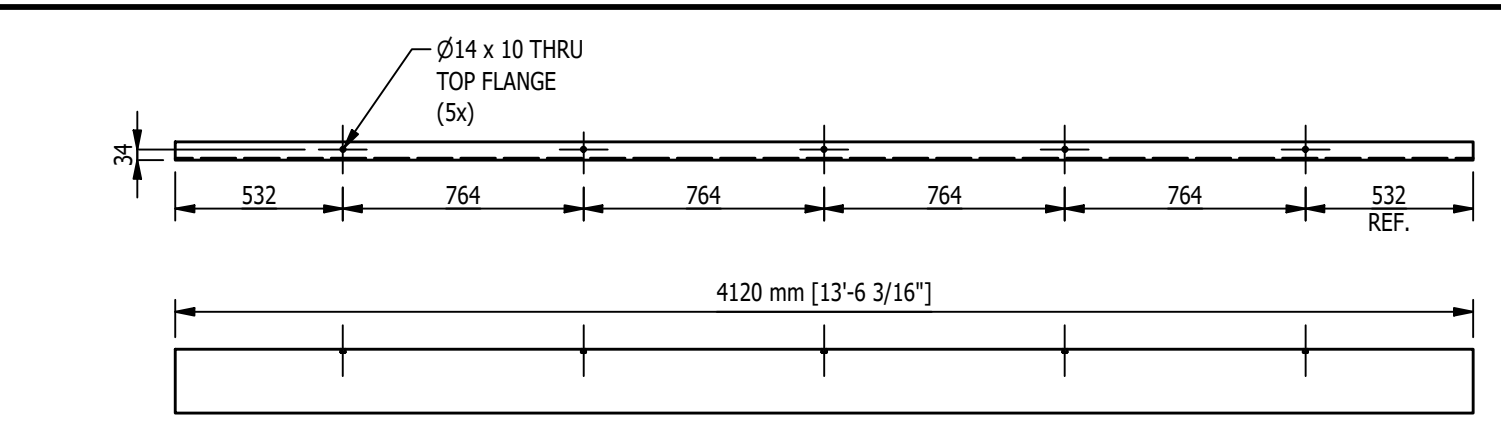
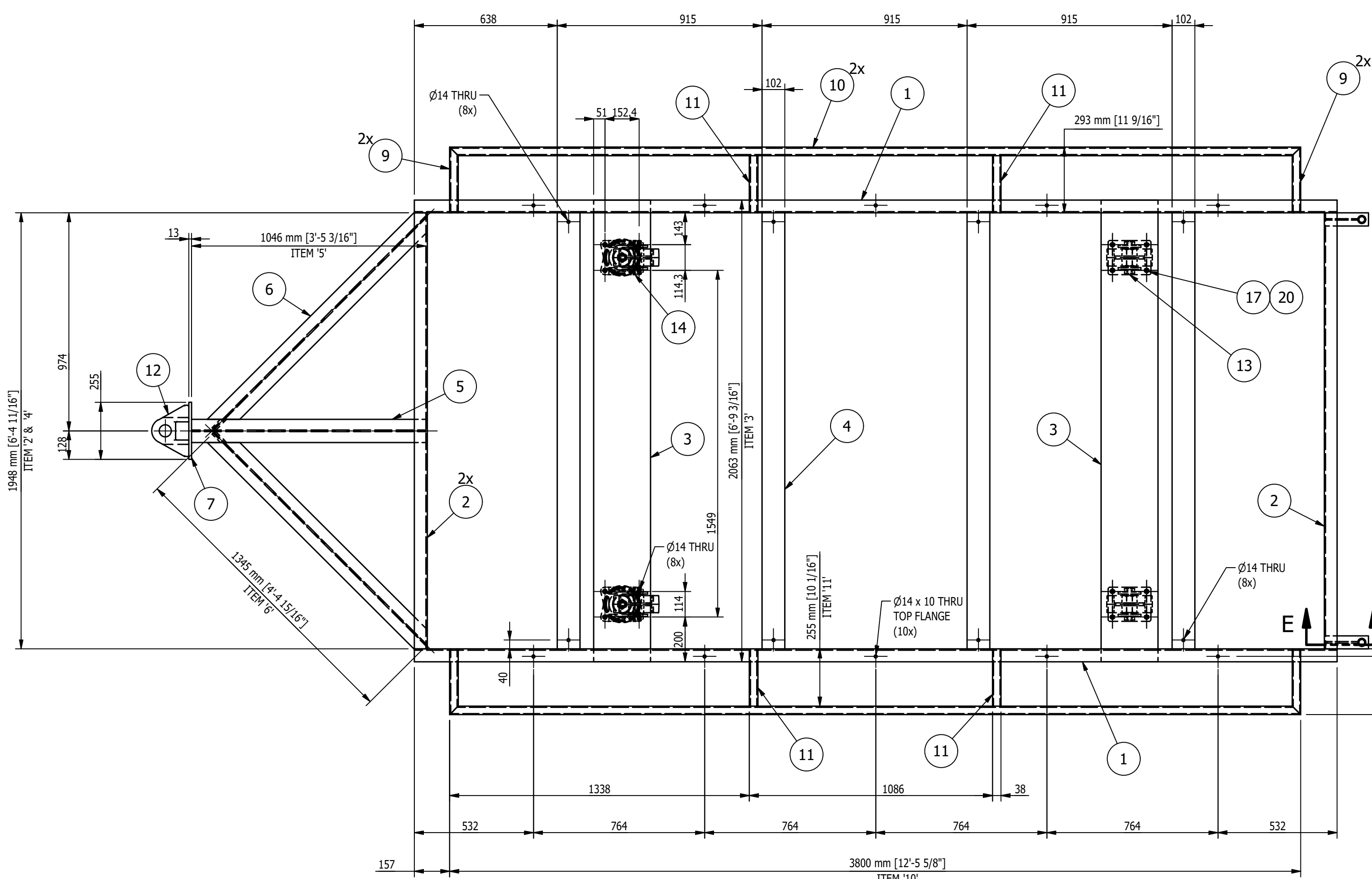
**MATERIALS:**  
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.  
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.  
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.  
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

**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.

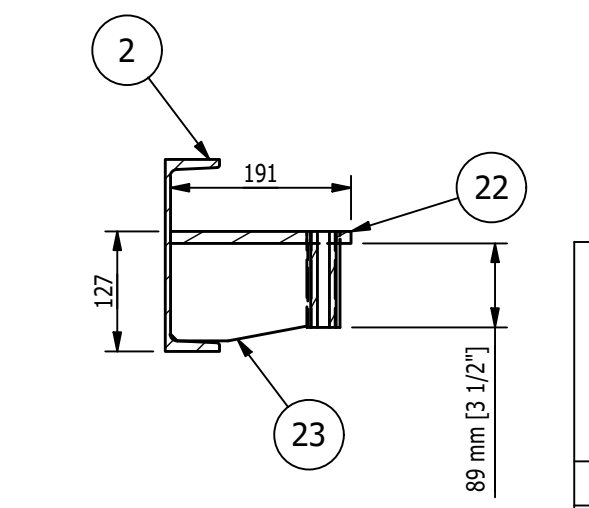
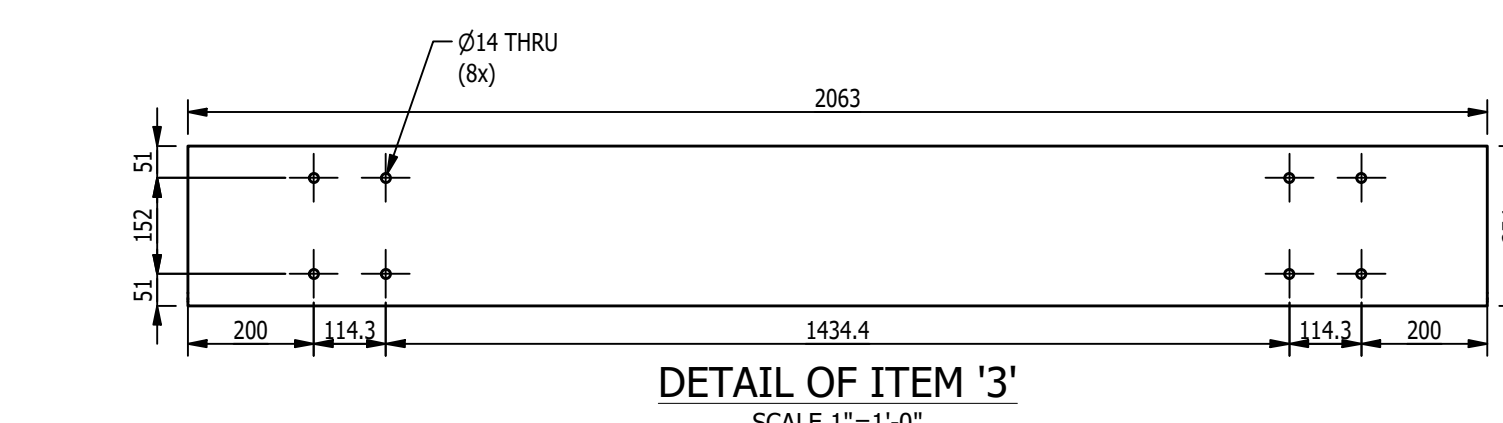
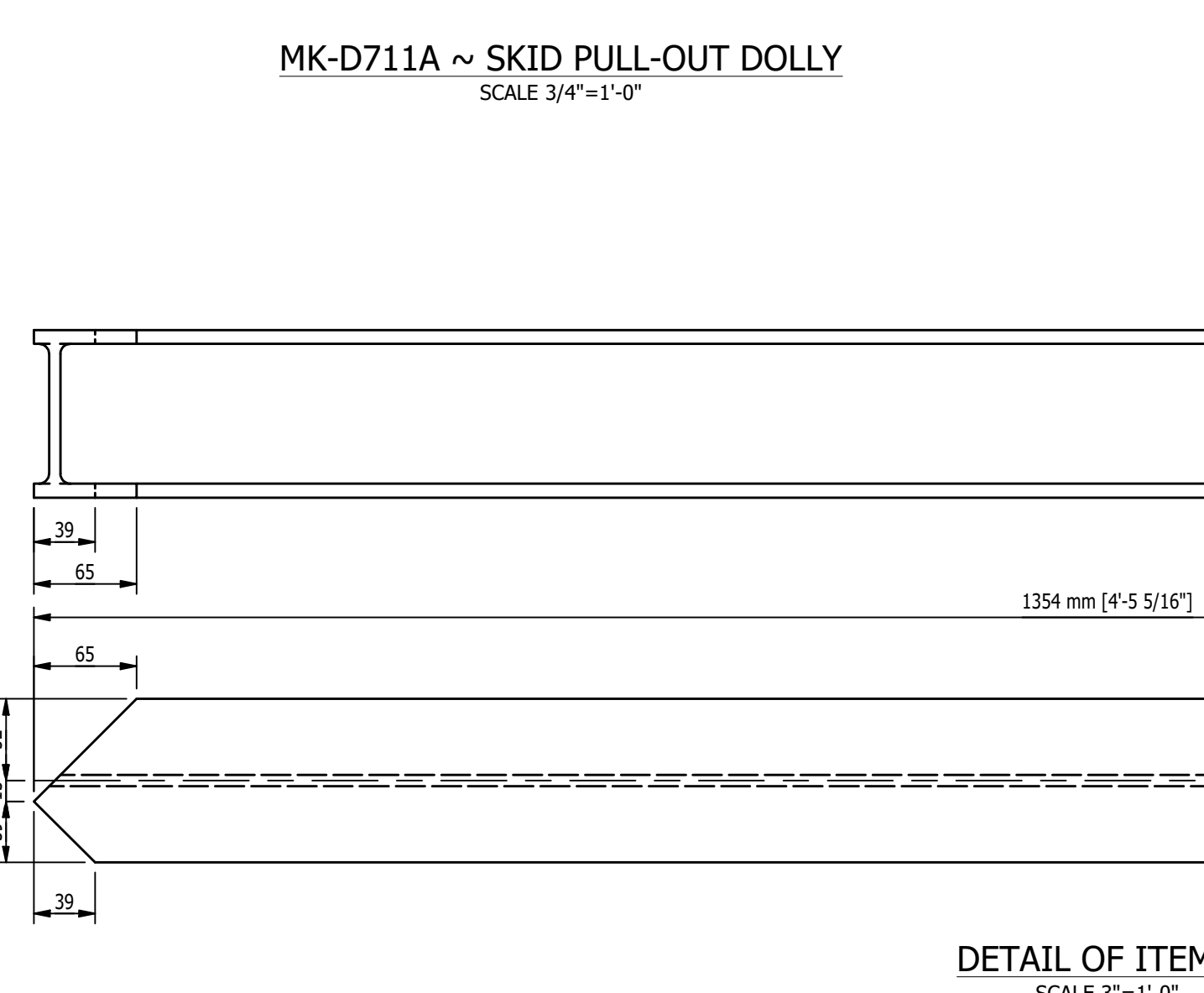
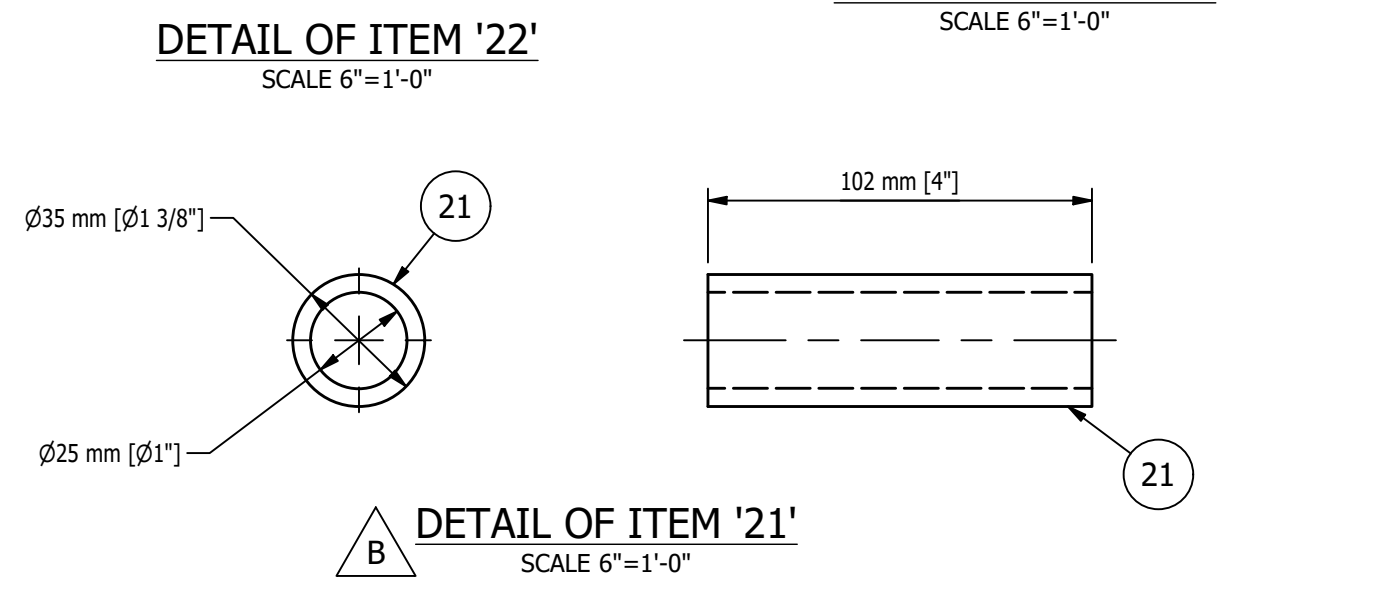
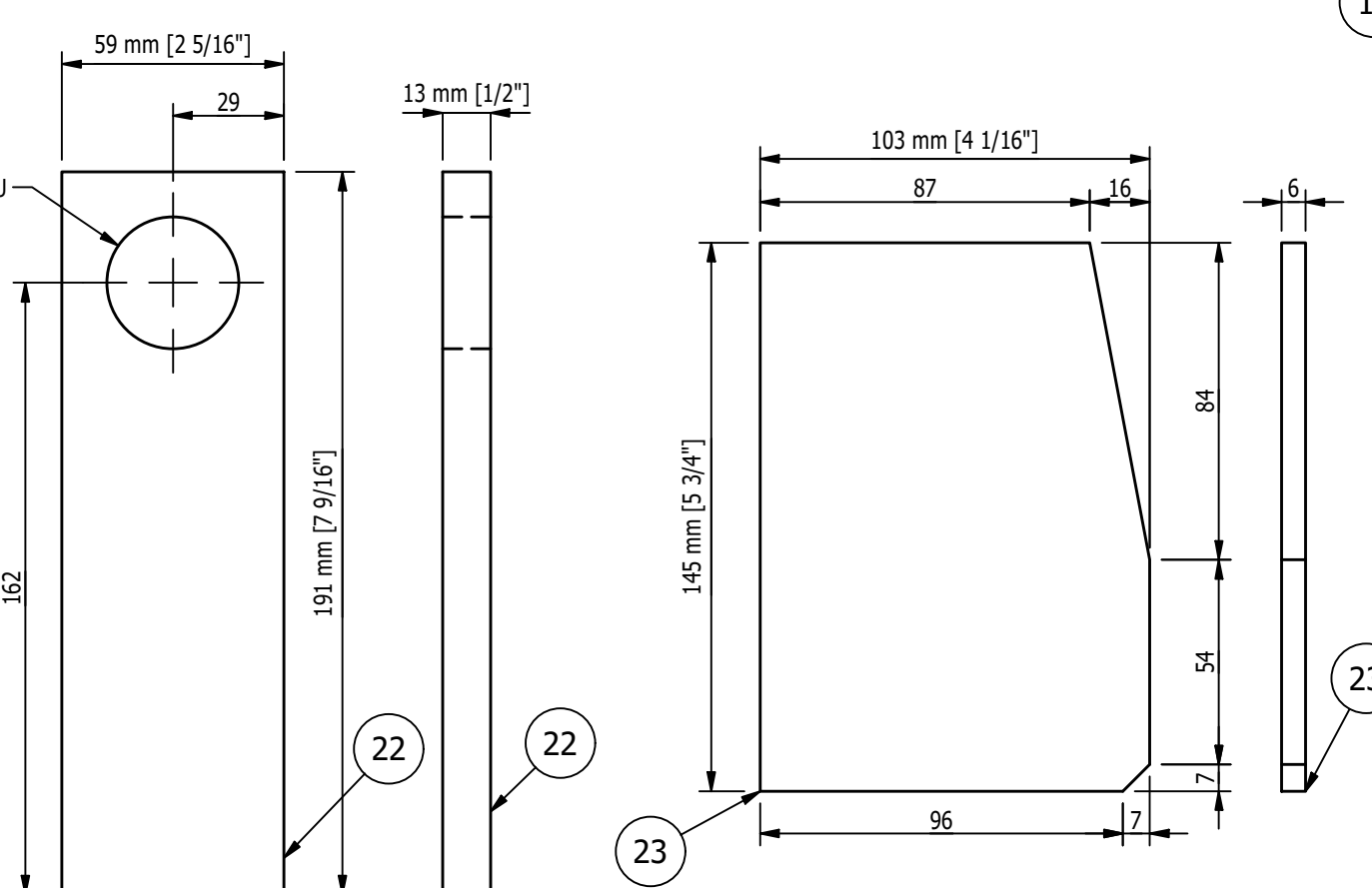
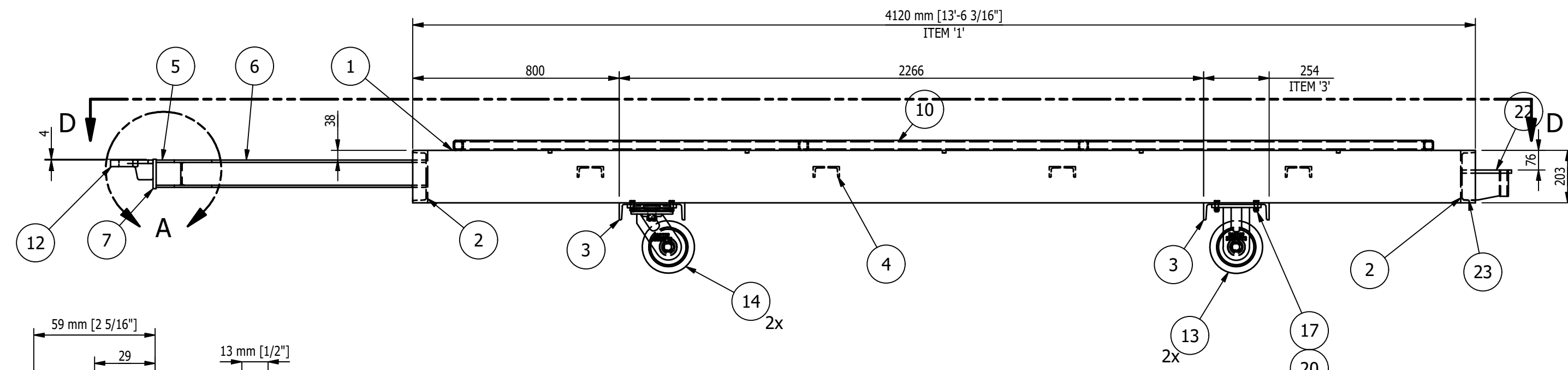
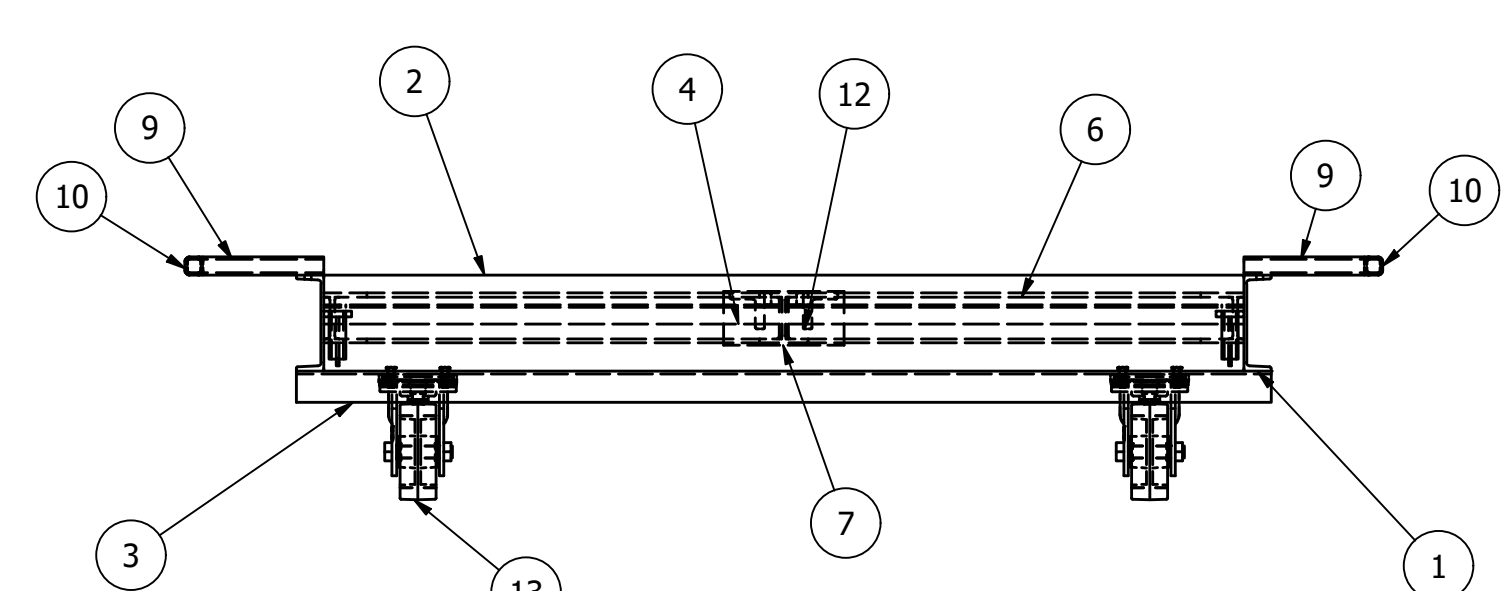
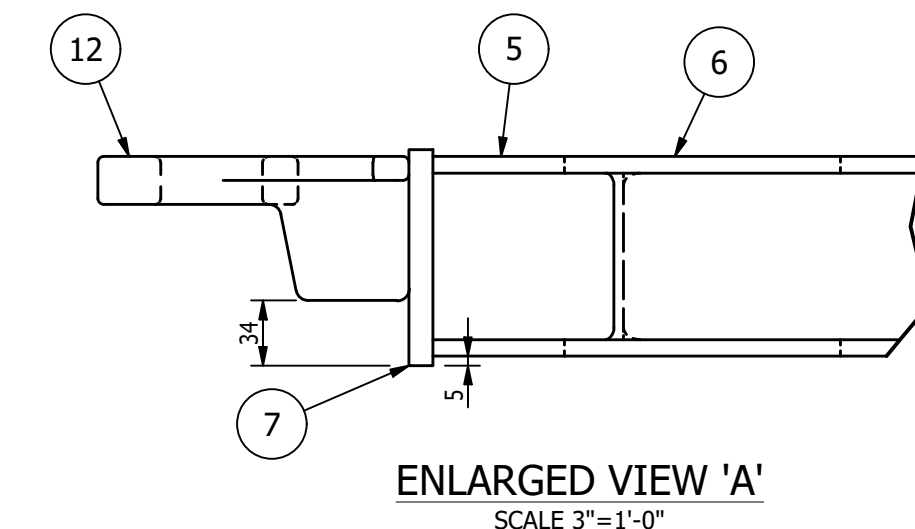
**WELDS:**  
- ALL WELDS TO BE "E70XX". (PER AWS D1.1)

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

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



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D711A			
1	2	C 8 x 11.5	13'-6 3/16"		
2	2	C 8 x 11.5	6'-4 11/16"		
3	2	C 10 x 15.3	6'-9 3/16"		
4	4	C 4 x 5.4	6'-4 11/16"		
5	1	W 4 x 13	3'-5 3/16"		
6	2	W 4 x 13	4'-5 5/16"		
7	1	BAR 1/2 x 4 1/2	10 1/16"		
9	4	TS 1 1/2 x 1 1/2 x 3/16	11 9/16"		MITER
10	2	TS 1 1/2 x 1 1/2 x 3/16	12'-5 5/8"		MITER
11	4	TS 1 1/2 x 1 1/2 x 3/16	10 1/16"		
12	1	TOW RING DARNELL-ROSE #CPL-01747		14-3	
13	2	RIGID CASTER, 80 SERIES CASTER STANDARDS-EXTRA HEAVY DUTY CASTERS, PRECISION TAPERED BEARING, CASTER CONCEPTS #80-08309-65-2		14-2	
14	2	SWIVEL CASTER, 80 SERIES CASTERS STANDARDS - EXTRA HEAVY DUTY CASTERS, PRECISION TAPERED BEARING, Caster Concepts #80-08309-65-1		14-1	
17	16	M12x1.75 x 35mm LG. HEX CAP SCREW			
20	16	M12 x 1.75 STOVER LOCK NUT			
21	2	TS 1 3/8 OD x 3/16 DOM	4"		
22	2	PL 1/2 x 2 5/16"	7 9/16"		
23	2	PL 1/4 x 5 3/4"	4 1/16"		
TOTAL WEIGHT ~ 1148.4 lbs					



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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/22	ADDED DETAILS OF ITEM '1', '4', '9', & '10'. ITEM '21' IS NOW 'TS 1 3/8 OD x 3/16 DOM' WAS PIPE 1 SCH. 40', REMOVED ITEMS '15', '16', & '19'. QUANTITIES UPDATED FOR '17' & '20'. ADDED REMARKS TO ITEMS '9' & '10'	
A	MC	8/12/22	FOR FABRICATION	

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

**TITLE:** P6700 CONVEYORS CAMPUS BUILDING  
**CLIENT:** VOLVO  
**DRAWING No.:** 1875D711  
**REV:** B

**DRAWN BY:** PWP  
**CHECKED BY:** CW  
**DWG DATE:** 7/5/22  
**JOB No.:** 22096

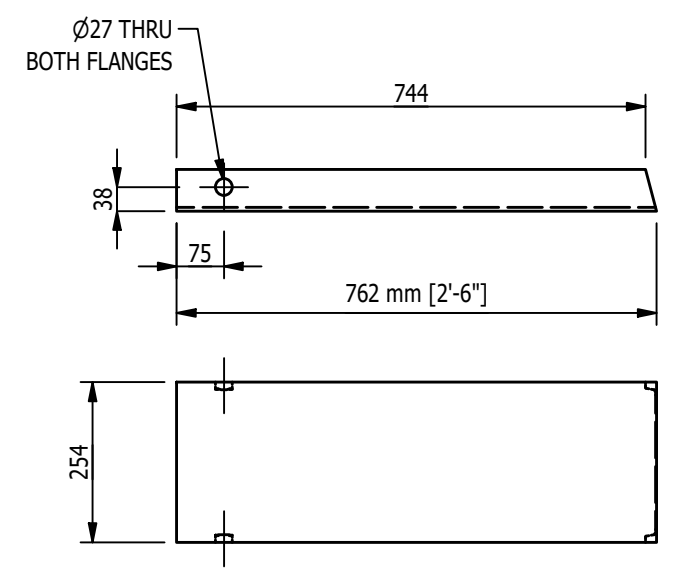
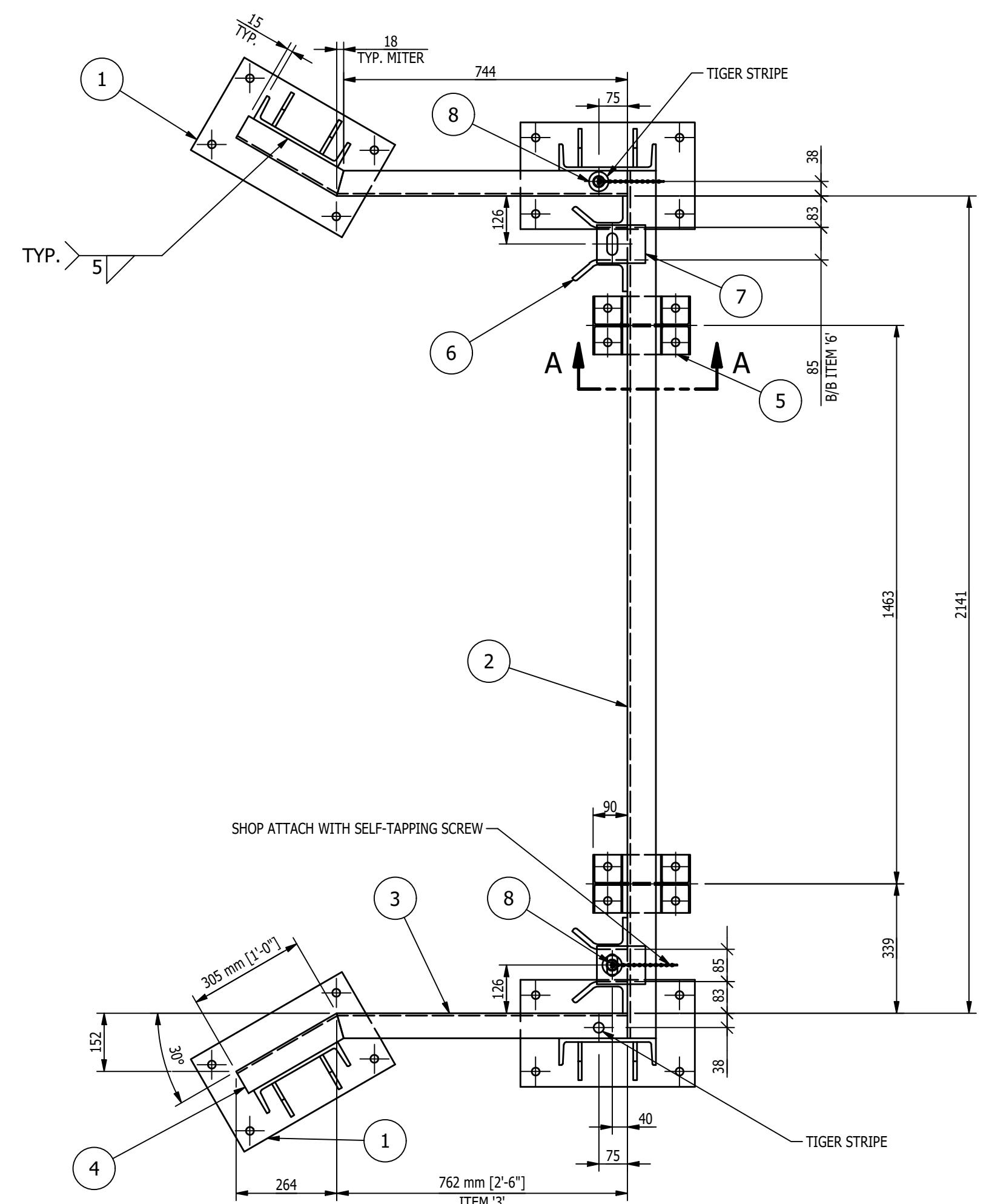
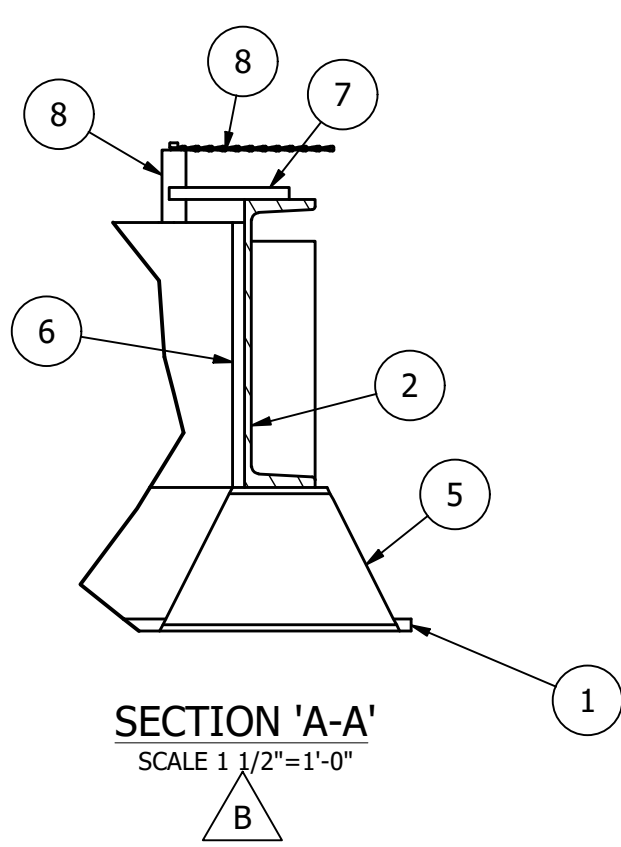
**MAGNUM Consulting**  
 41100 QuakerRoad Rd.  
 Suite 125  
 West, MI 48375  
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 Fax: (248) 772-8801  
 Web: www.mmagnum.com

MAGNUM JOB #: 1875  
 MAGNUM DRAWING #: 1875D711

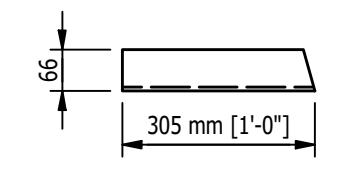
- UNLESS OTHERWISE NOTED:**
- X = ±.060
  - XX = ±.030
  - XXX = ±.005
  - FRACTIONS = ±1/16"
  - ANGLES = ±1°30'
  - BREAK ALL SHARP EDGES
  - DEBURR ALL HOLES
  - DO NOT SCALE DRAWING
- GENERAL NOTES:**
- ALL HOLES ARE 13/16" DIA. U.N.O.
  - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING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



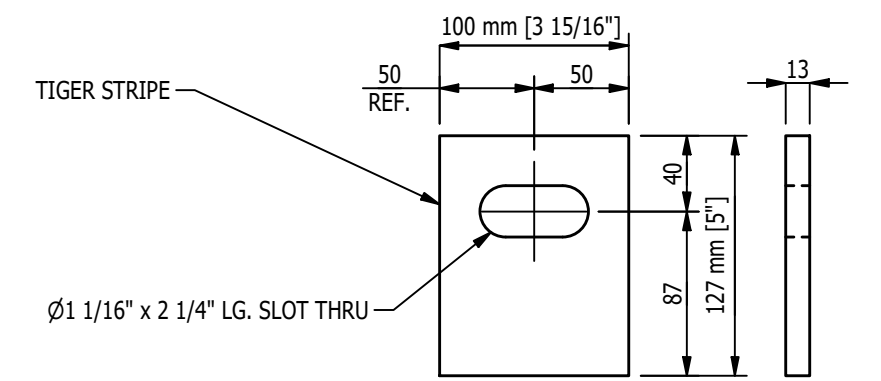
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D712A			
1	4	MK-D707A ~ LEG WELDMENT			
2	1	C 12 x 20.7	7'-5 1/2"		
3	2	C 10 x 15.3	2'-6"		MITER
4	2	C 10 x 15.3	1'-0"		MITER
5	2	W 6 x 15	10"		
6	4	L 6 x 3 1/2 x 1/2	11"		BEND
7	2	PL 1/2 x 3 15/16"	5"		
8	2	MK-D706B ~ DOCKING PIN			
		TOTAL WEIGHT ~ 601.5 lbs			



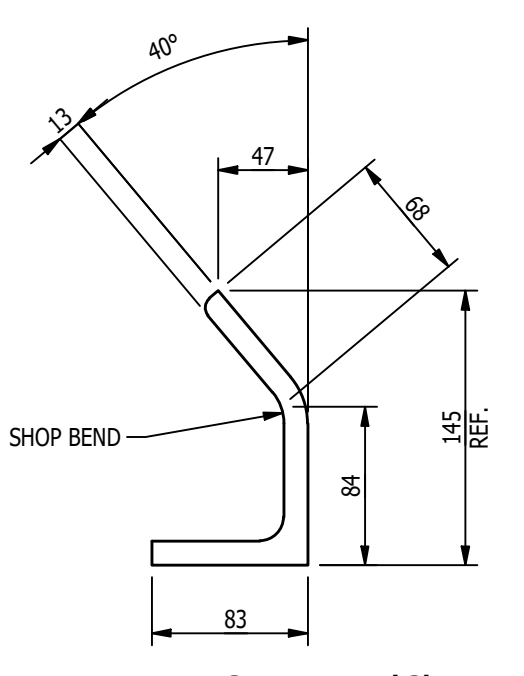
DETAIL OF ITEM '3'  
SCALE 1"=1'-0"



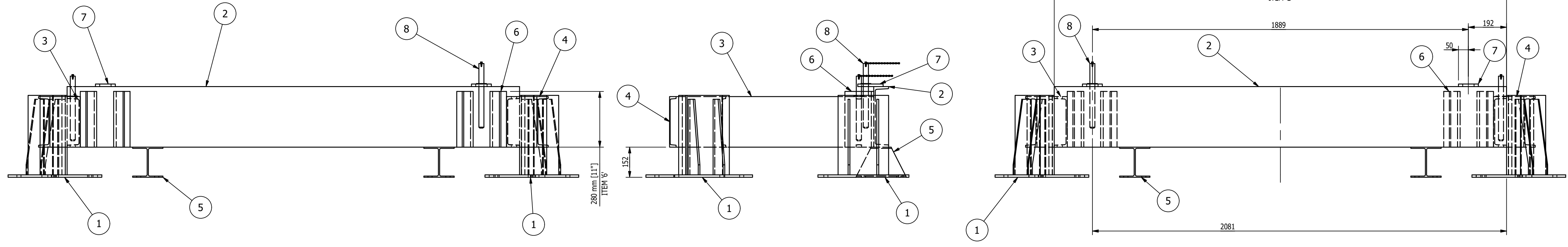
DETAIL OF ITEM '4'  
SCALE 1"=1'-0"



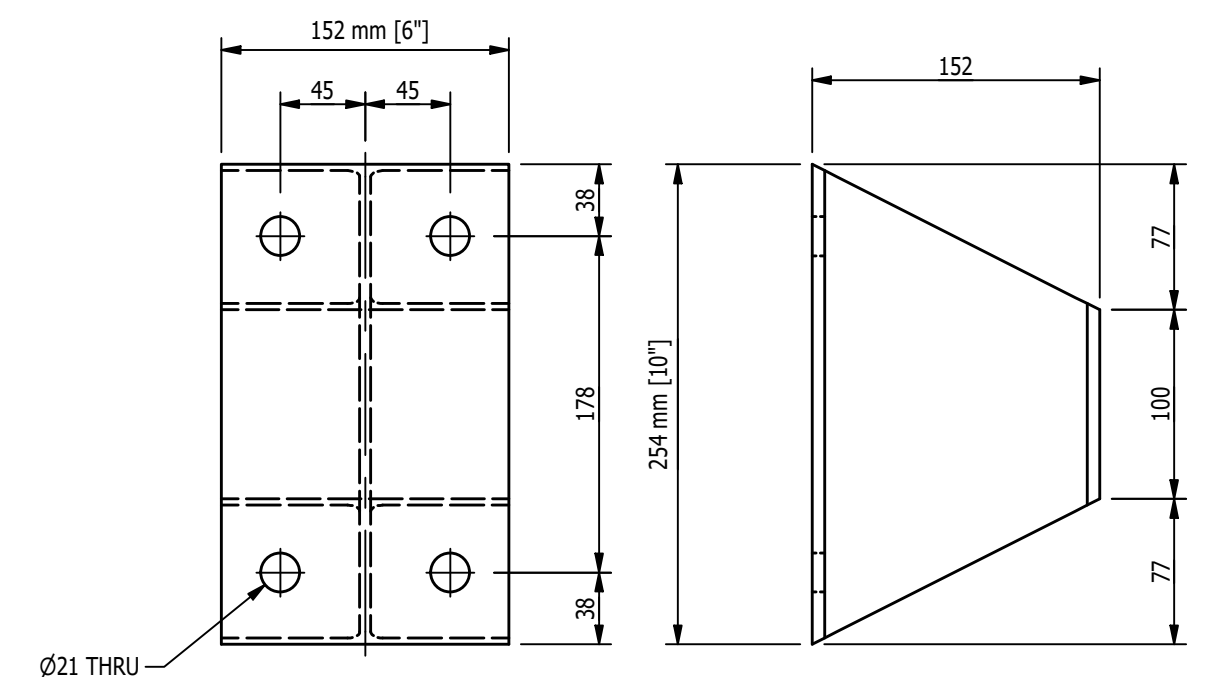
DETAIL OF ITEM '7'  
SCALE 3"=1'-0"



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



MK-D712A ~ SKID DOCKING STATION  
SCALE 1"=1'-0"



DETAIL OF ITEM '5'  
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	9/7/22	ADDED REMARKS TO B.O.M., ADDED DETAILS OF ITEM '3' AND '4', ADDED SECTION 'A-A', ADDED TIGER STRIPE LOCATION NOTES	
A	MC	8/12/22	FOR FABRICATION	

REVISION HISTORY

**GENERAL NOTES:**

**MATERIALS:**

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

**HOLES:**

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

**WELDS:**

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

**PAINT:**

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

**COPIES:**

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

**MAGNUM CONSULTING**

41100 QuakerRoad Rd.  
Suite 125  
North, MI 48125

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

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D712

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

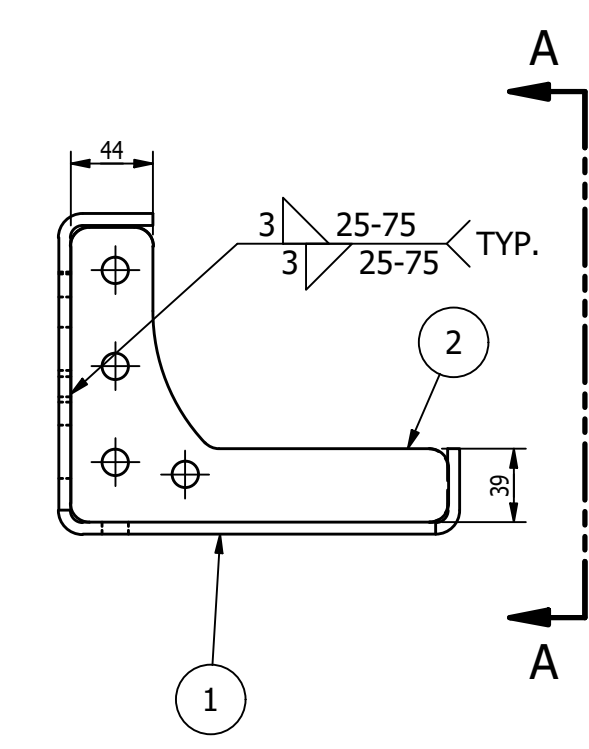
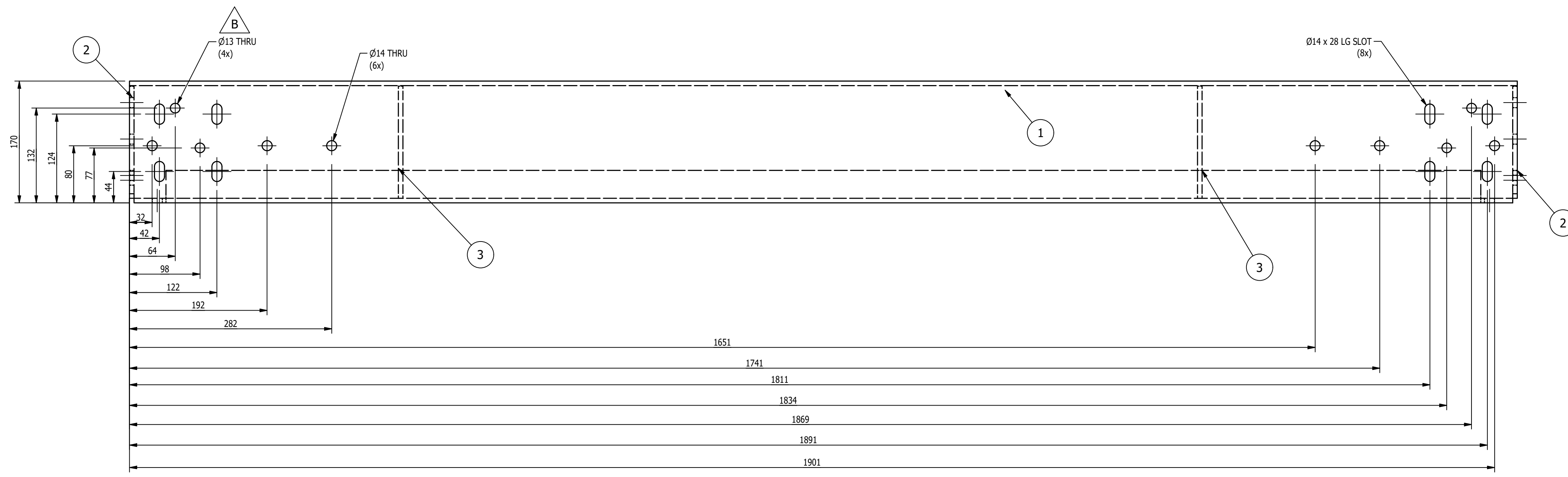
**TITLE:** P6700 CONVEYORS  
**CAMPUS BUILDING**

**CLIENT:** VOLVO

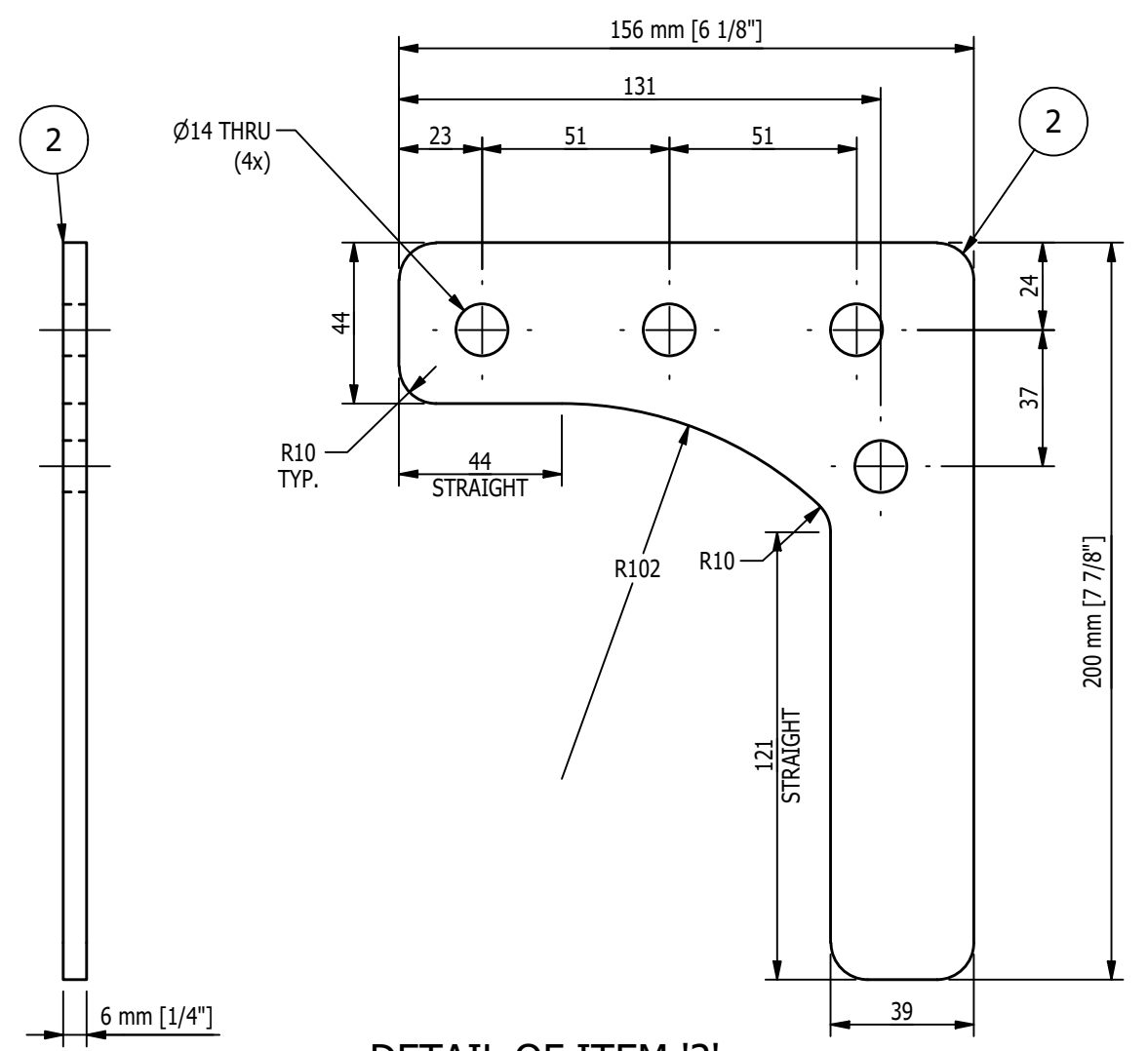
**DRAWING No.:** 1875D712

**REV:** B

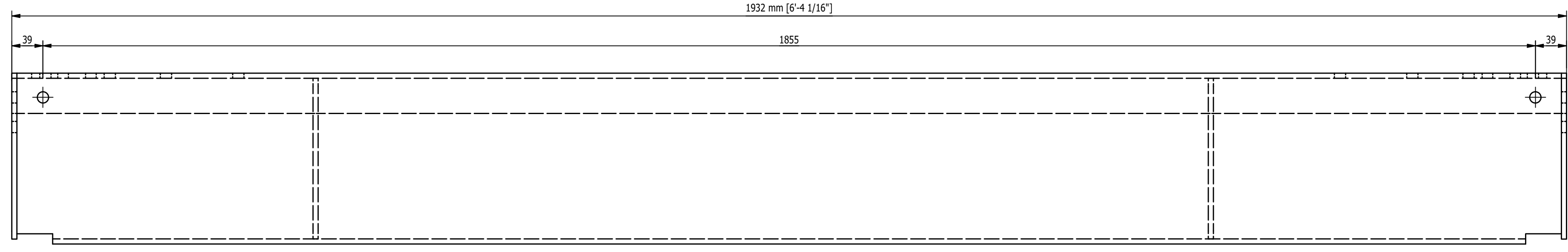
**DRAWN BY:** PWP  
**CHECKED BY:** CW  
**DWG DATE:** 7/5/22  
**JOB No.:** 22096



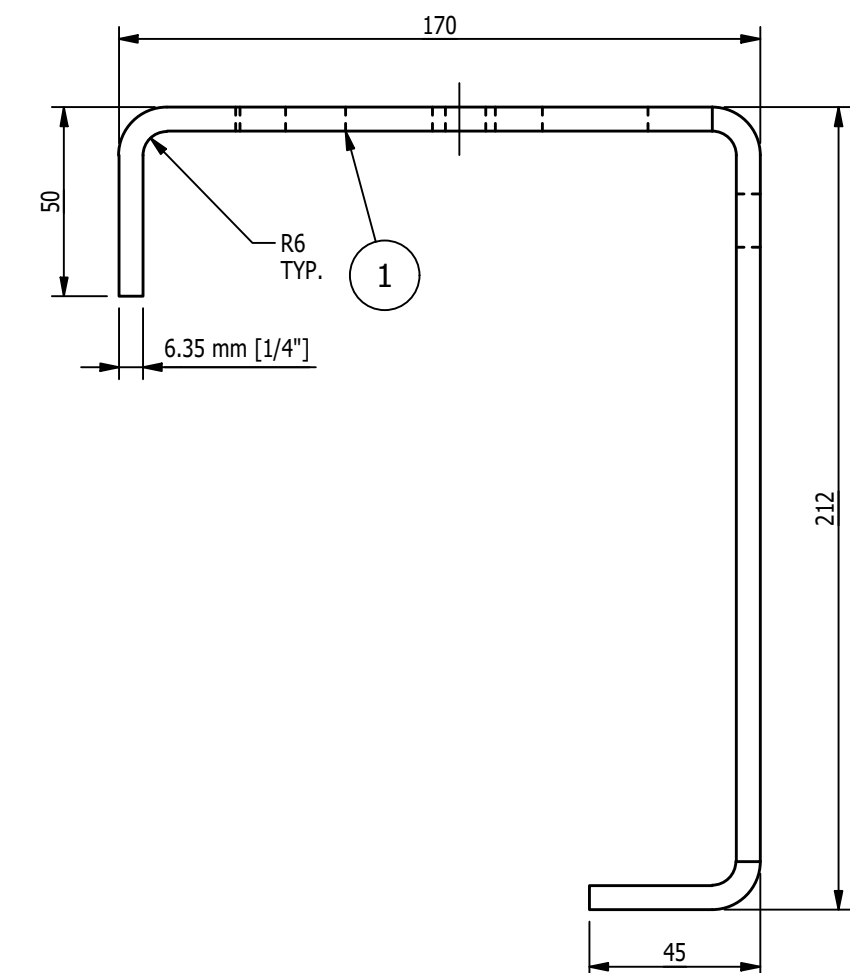
BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D713A		
1	1	PL 1/4 x 17 3/8	6'-4 1/16"	
2	2	PL 1/4 x 6 1/8	7 7/8"	
3	2	PL 1/4 x 6 1/8	7 7/8"	
TOTAL WEIGHT ~ 99.2 lbs				



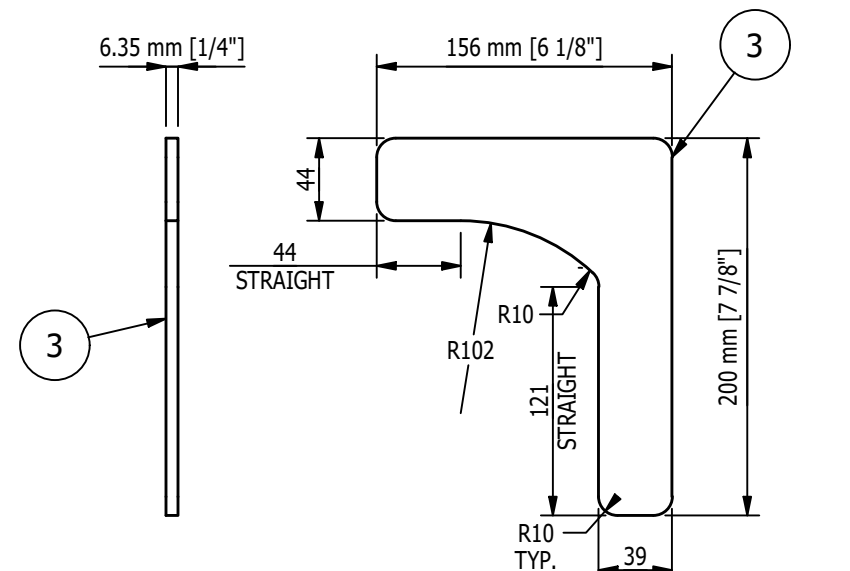
DETAIL OF ITEM '2'  
SCALE 6"=1'-0"



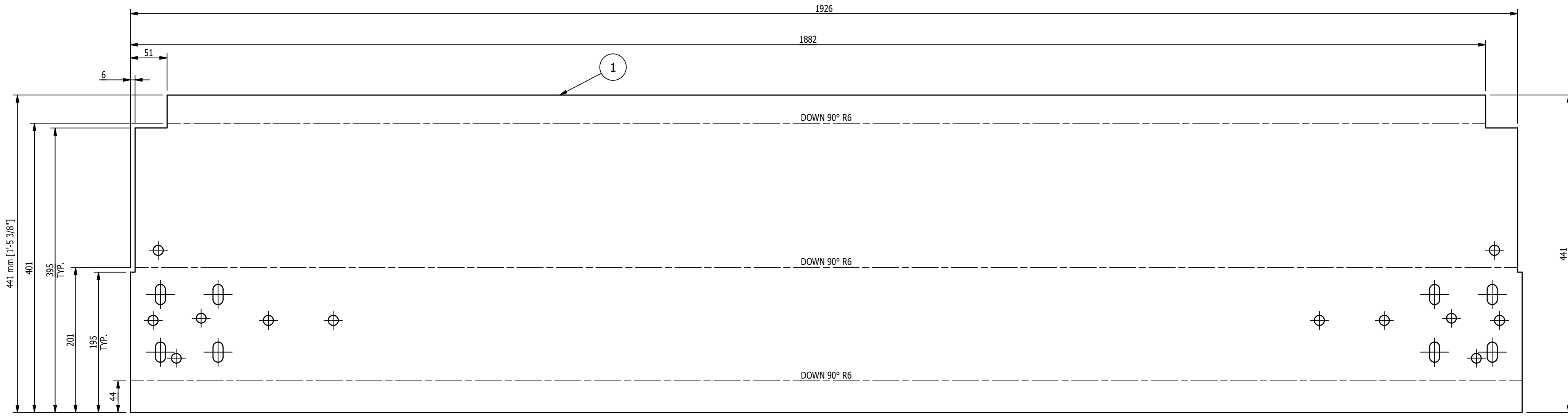
MK-D713A ~ END PLATE ASSEMBLY  
SCALE 3"=1'-0"



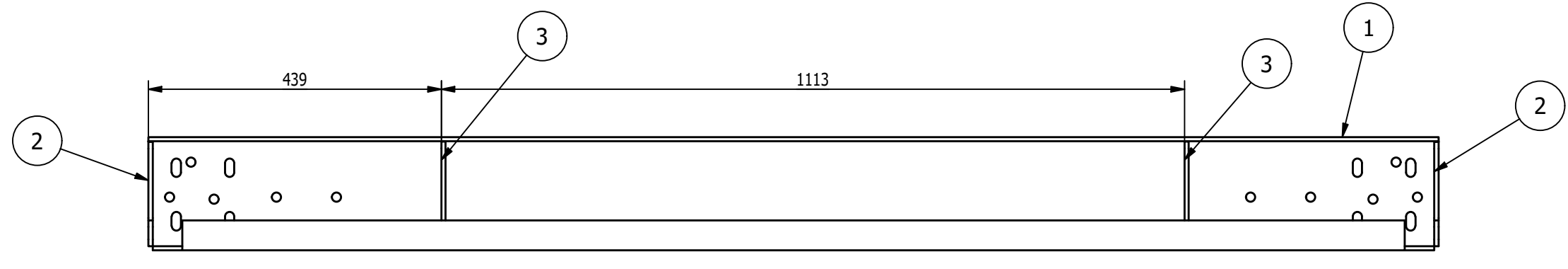
DETAIL OF ITEM '1'  
SCALE 6"=1'-0"



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



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



VIEW 'A-A'  
SCALE 1 1/2"=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 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
B	MC	9/7/22	UPDATED PAINT NOTES, UPDATED PLACEMENT OF ITEM '2', DIMENSIONS WERE REDONE, AND HOLE LOCATION UPDATED	
A	MC	8/19/22	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**

41100 Quarkwood Rd.  
Suite 125  
North, MI 48175

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

MAGNUM JOB #: 1875  
MAGNUM DRAWING #: 1875D713

UNLESS OTHERWISE NOTED:  
X = ±.060  
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FRACTIONS = ±1/16"  
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**TITLE:** P6700 CONVEYORS  
CAMPUS BUILDING

**CLIENT:** VOLVO

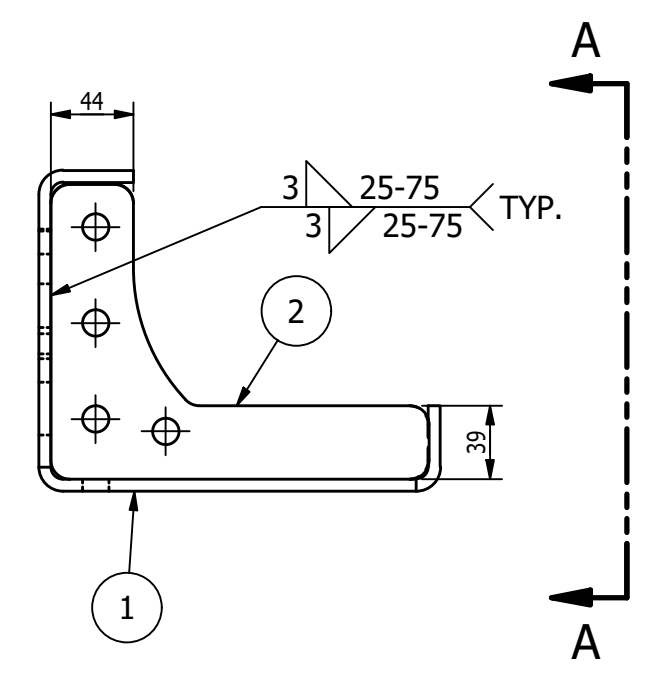
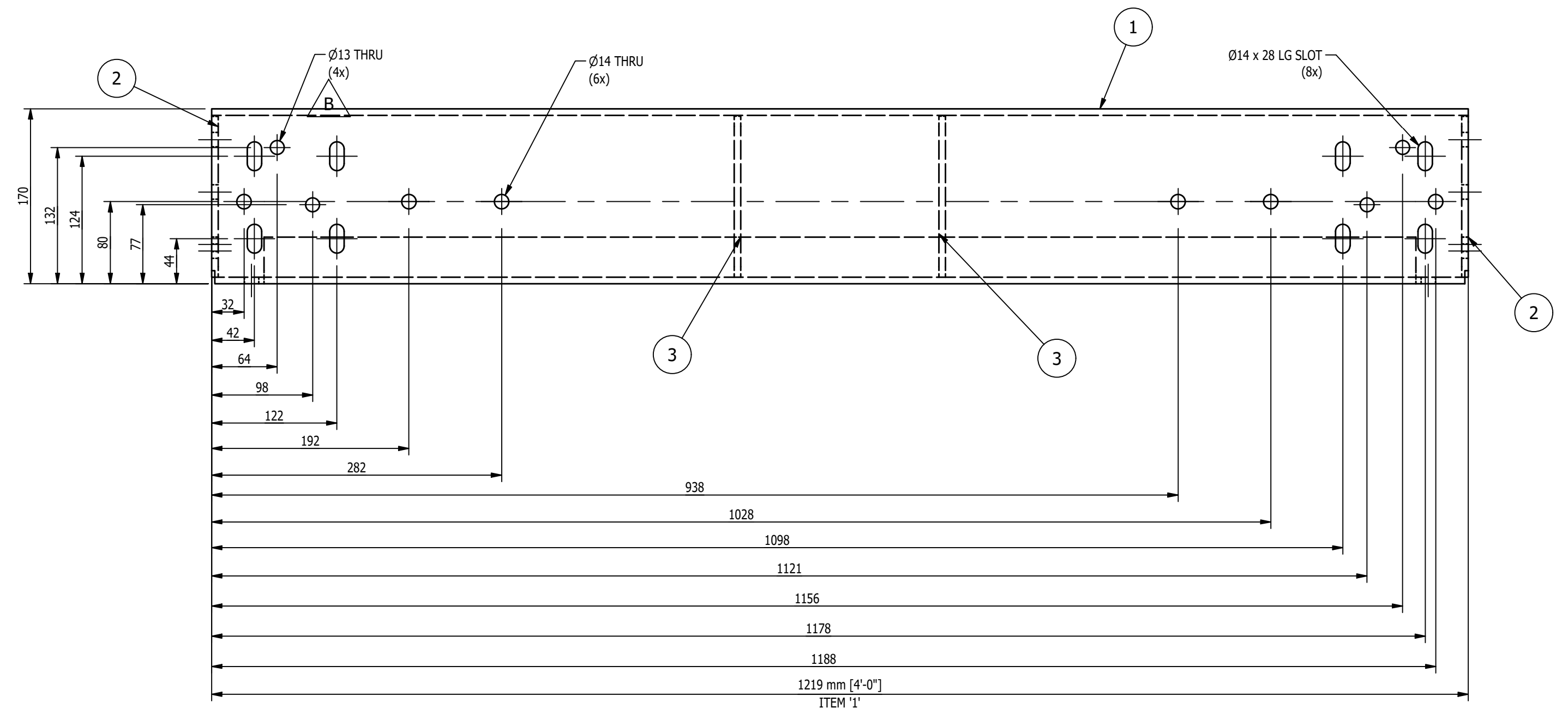
**DRAWING No.:** 1875D713

**REV:** B

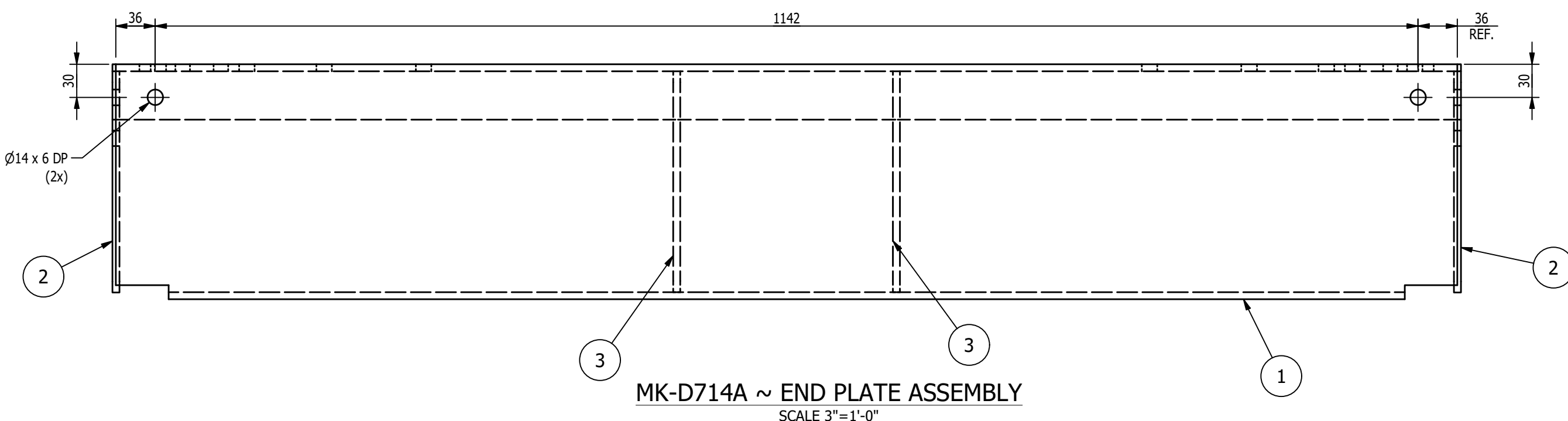
**JOB No.:** 22096

**DRAWN BY:** AH  
**CHECKED BY:** CW  
**DWG DATE:** 8/17/22

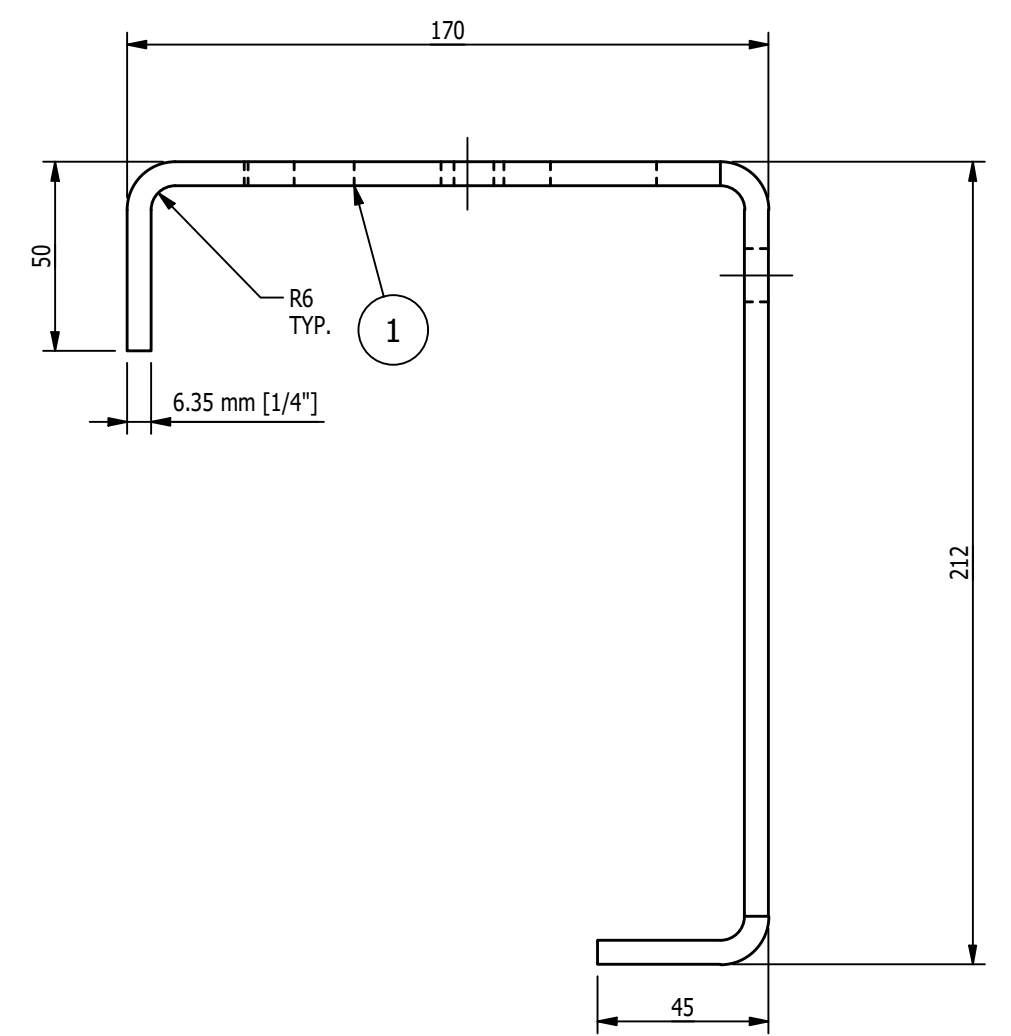




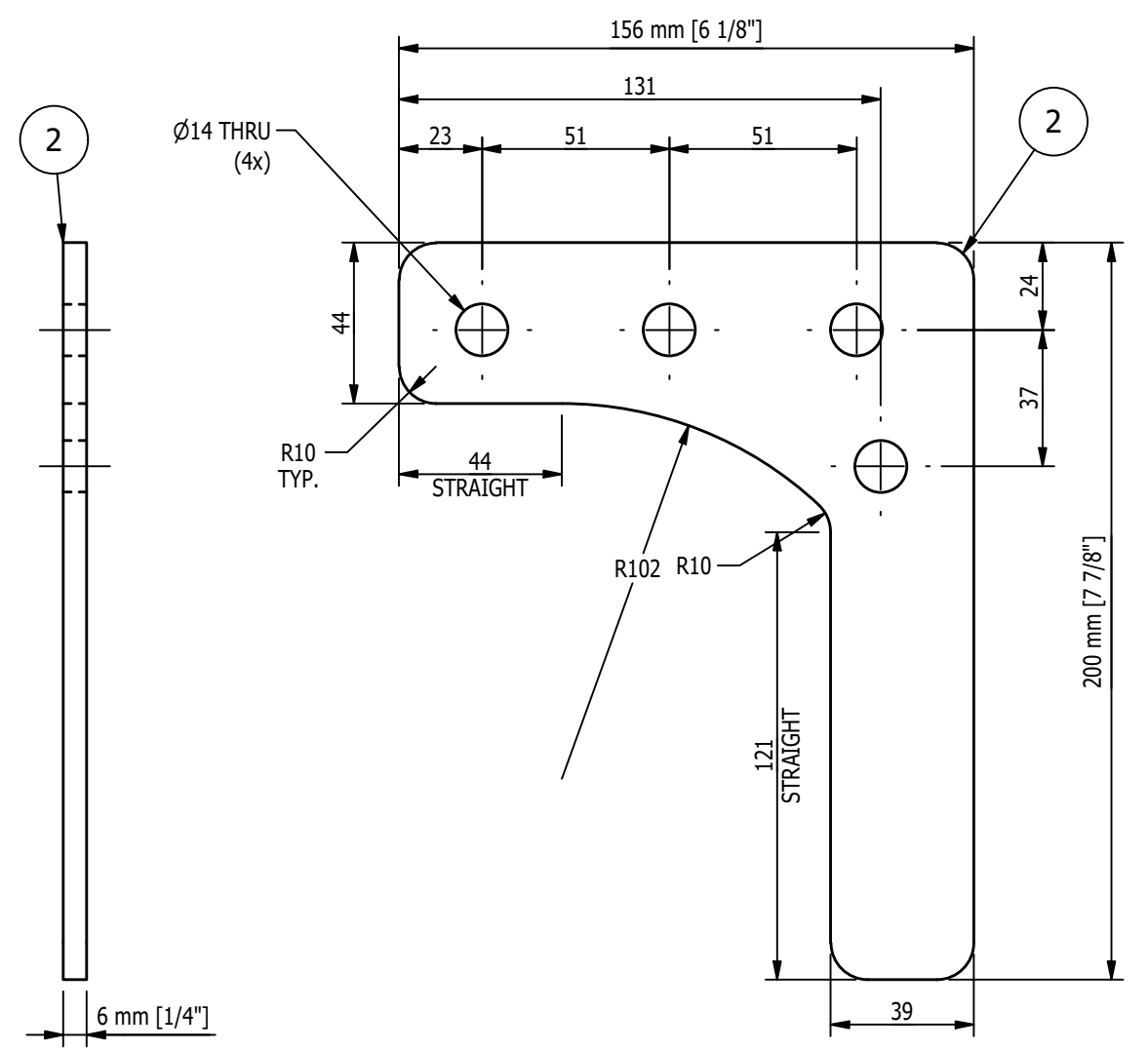
BILL OF MATERIAL				
MARK	QTY	DESCRIPTION	LENGTH	REMARKS
		MK-D714A		
1	1	PL 1/4 x 1'-5 3/8"	4'-0"	
2	2	PL 1/4 x 6 1/8	7 7/8"	
3	2	PL 1/4 x 6 1/8	7 7/8"	
TOTAL WEIGHT ~ 64.4 lbs				



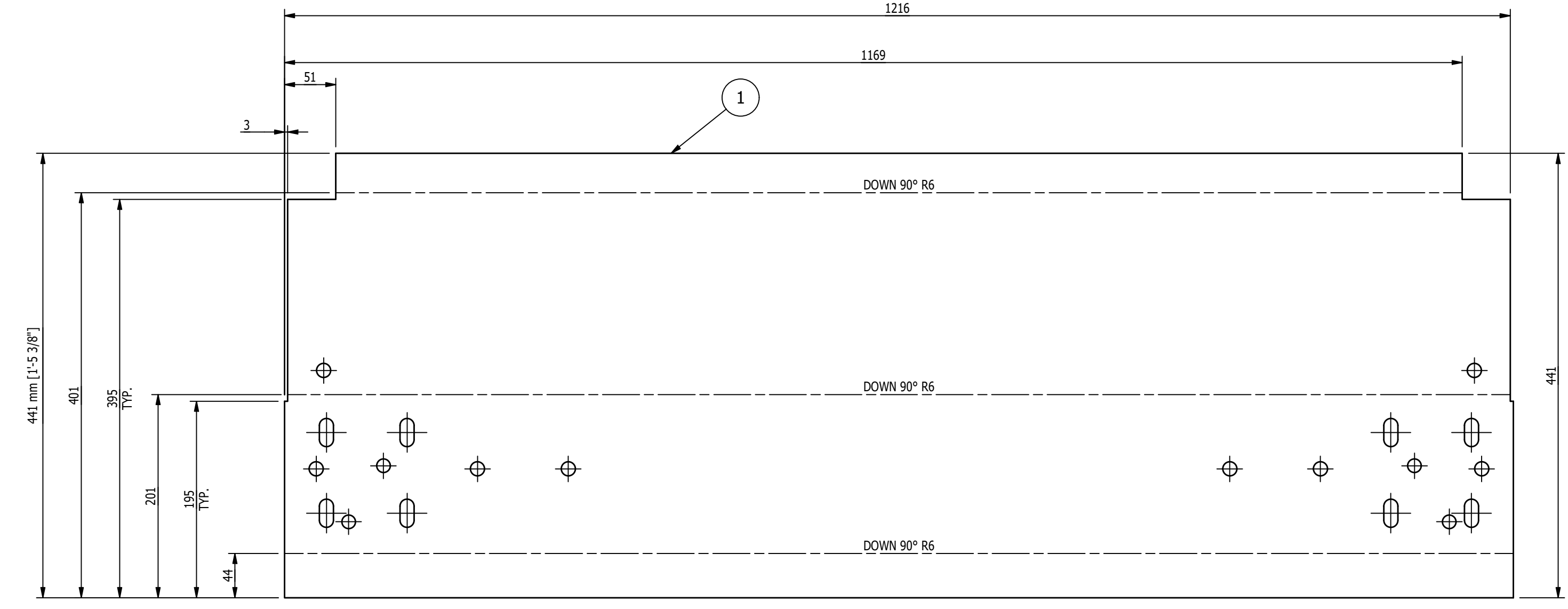
MK-D714A ~ END PLATE ASSEMBLY  
SCALE 3"=1'-0"



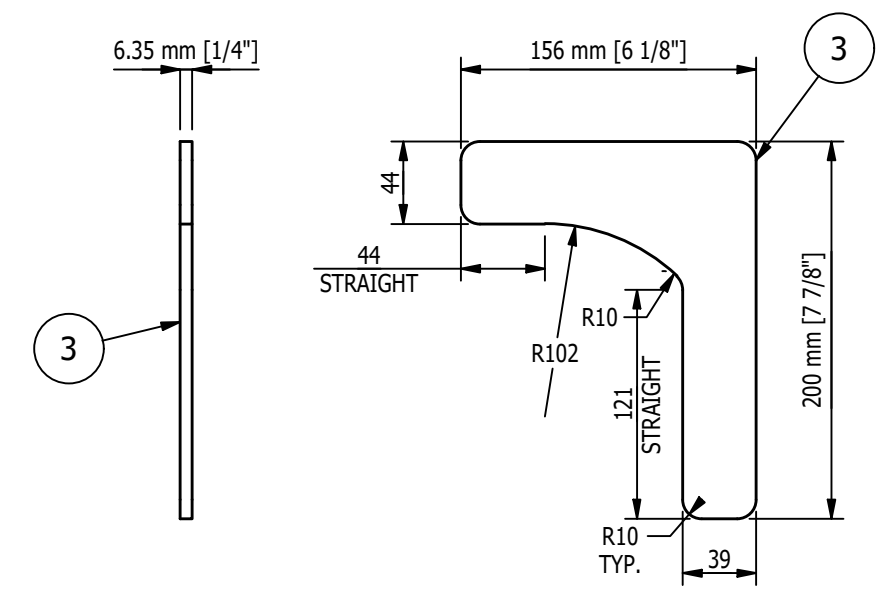
DETAIL OF ITEM '1'  
SCALE 6"=1'-0"



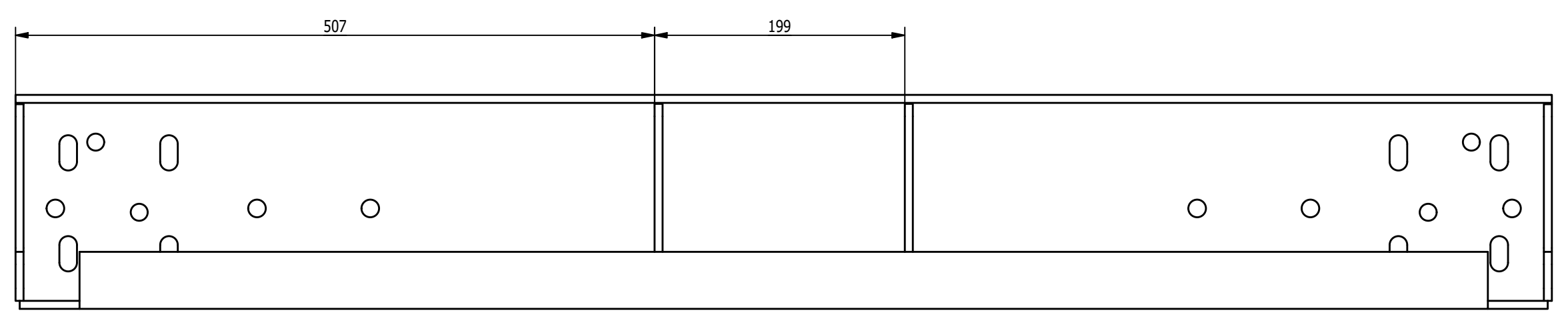
DETAIL OF ITEM '2'  
SCALE 6"=1'-0"



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



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



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

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

**PAINT NOTES:**  
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OR  
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REV	BY	DATE	DESCRIPTION	APP
B	MC	9/7/22	UPDATED PAINT NOTES, DIMENSIONS WERE REDONE, & HOLES LOCATION UPDATED	
A	MC	8/19/22	FOR FABRICATION	

REVISION HISTORY

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www.millic.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	AH
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D714	DWG DATE:	8/17/22
REV:	B	JOB No.:	22096

**MAGNUM Consulting**  
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- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
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**WELDS:**

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**PAINT:**

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**COPIES:**

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