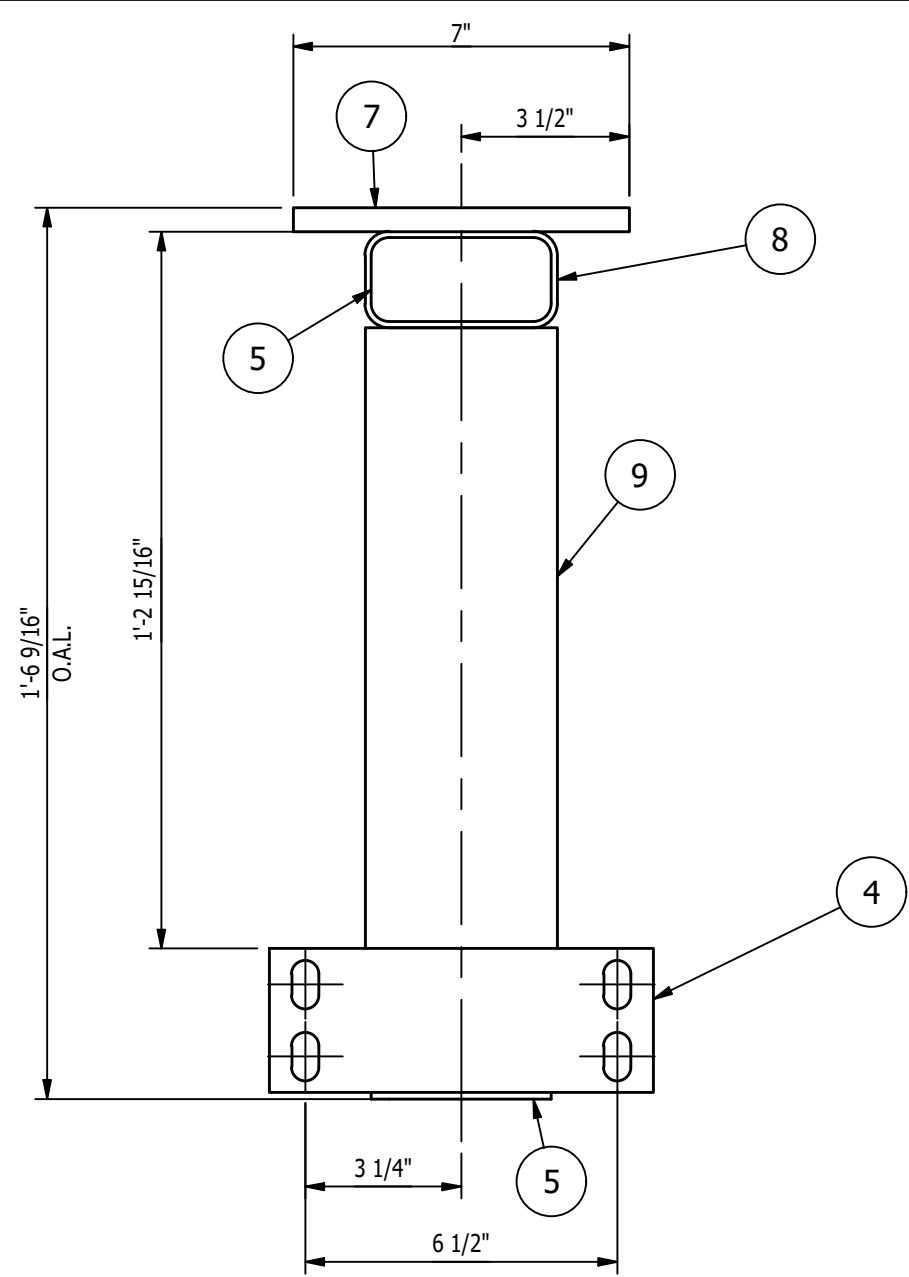
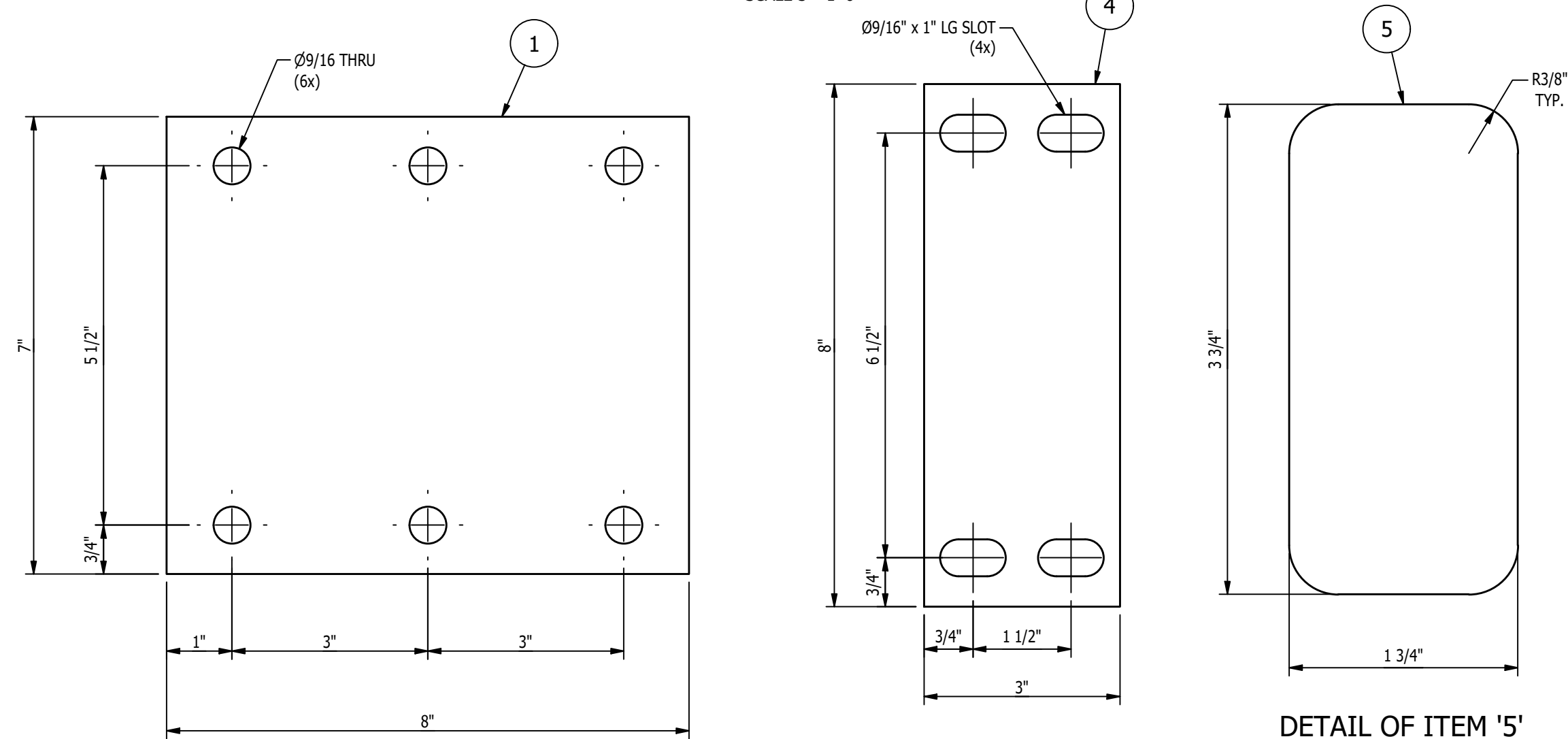
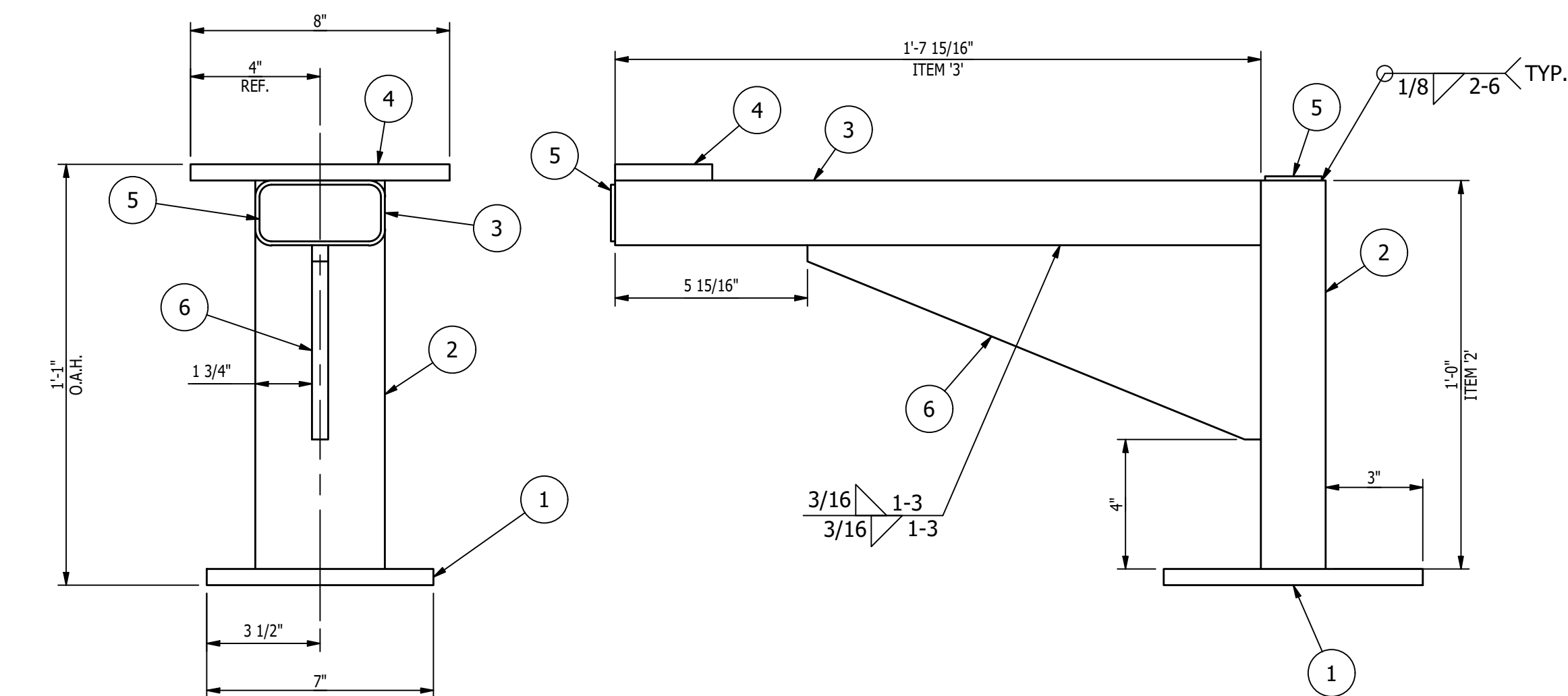
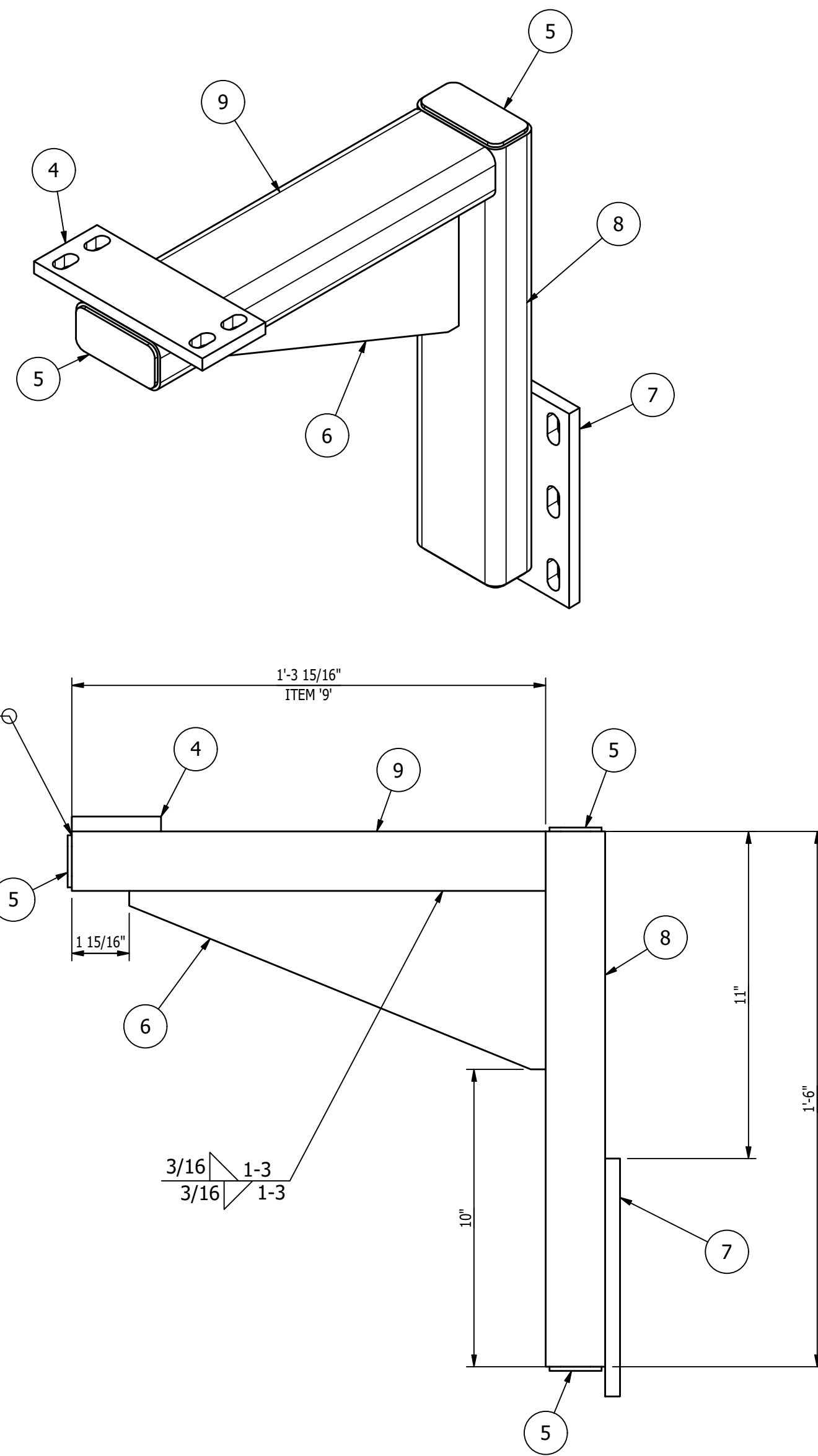


MK-D410A ~ AUX LIFT ARM WELDMENT - DRIVER SIDE
SCALE 3"=1'-0"



MK-D410B ~ AUX LIFT ARM WELDMENT - PASSENGER SIDE
SCALE 3"=1'-0"



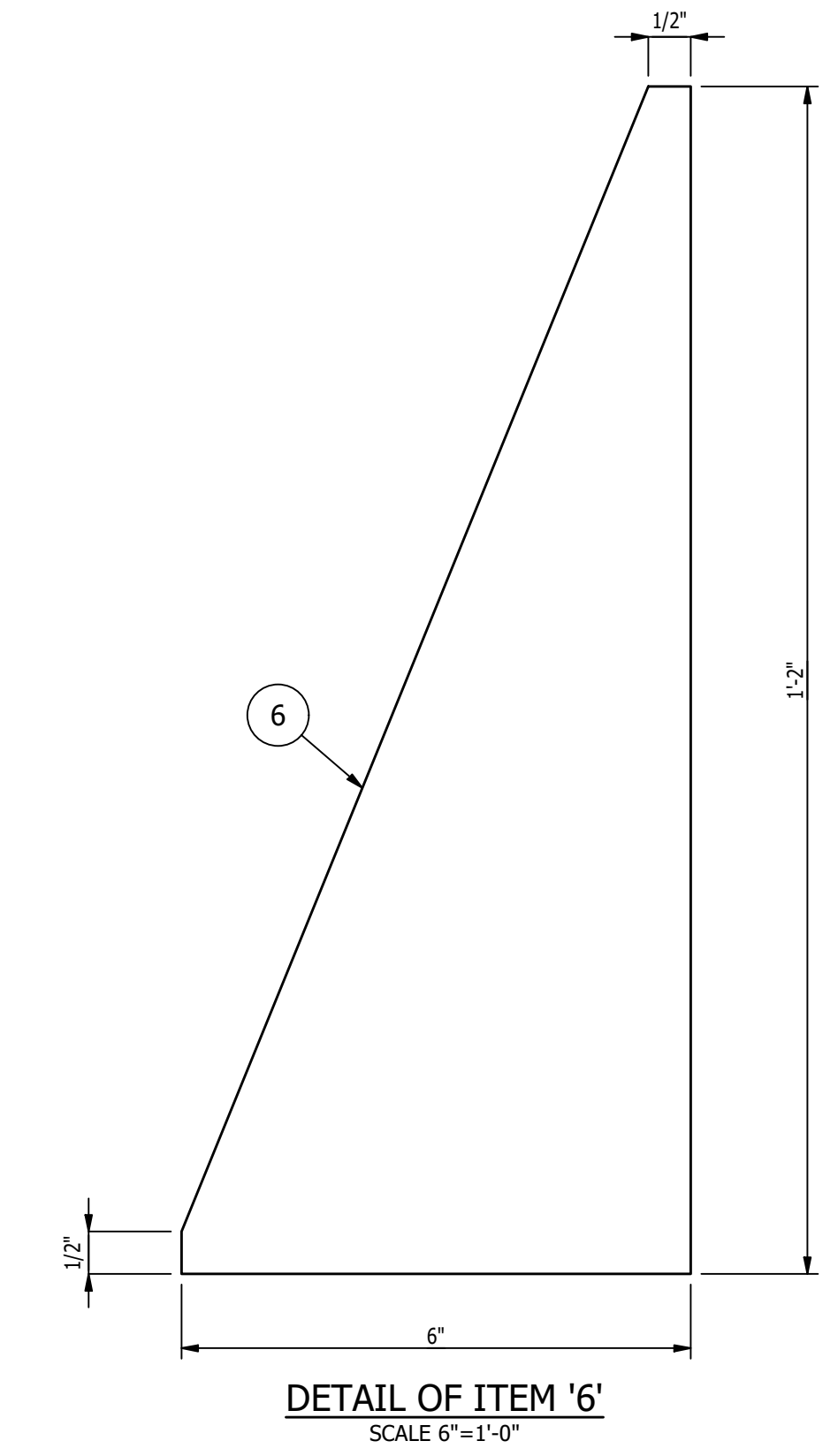
DETAIL OF ITEM '1'
SCALE 6"=1'-0"

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

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

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D410A			
1	1	BAR 1/2 x 7	8"		
2	1	A500 GR. C HSS 4 x 2 x 1/4	1'-0"		
3	1	A500 GR. C HSS 4 x 2 x 1/4	1'-7 15/16"		
4	1	BAR 1/2 x 3	8"		
5	2	SHT 10 GA x 1 3/4"	3 3/4"		
6	1	PL 1/2 x 6"	1'-2"		
		MK-D410B			
4	1	BAR 1/2 x 3	8"		
5	3	SHT 10 GA x 1 3/4"	3 3/4"		
6	1	PL 1/2 x 6"	1'-2"		
7	1	BAR 1/2 x 8	7"		
8	1	A500 GR. C HSS 4 x 2 x 1/4	1'-6"		
9	1	A500 GR. C HSS 4 x 2 x 1/4	1'-3 15/16"		



DETAIL OF ITEM '6'
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.
 9. VIBRATORY STRESS RELIEVE ALL WELDMENTS.

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

A	MC	11/15/22	FOR FABRICATION	
REV	BY	DATE	DESCRIPTION	APP

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
		3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.com		DRAWN BY:	RPM
		TITLE: P6700 CONVEYORS CAMPUS BUILDING		CHECKED BY:	CW
		CLIENT: VOLVO		DWG DATE:	10/18/22
		DRAWING No. 1875D410		REV:	A
				JOB No.:	22096

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Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D410 - 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 SLUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

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

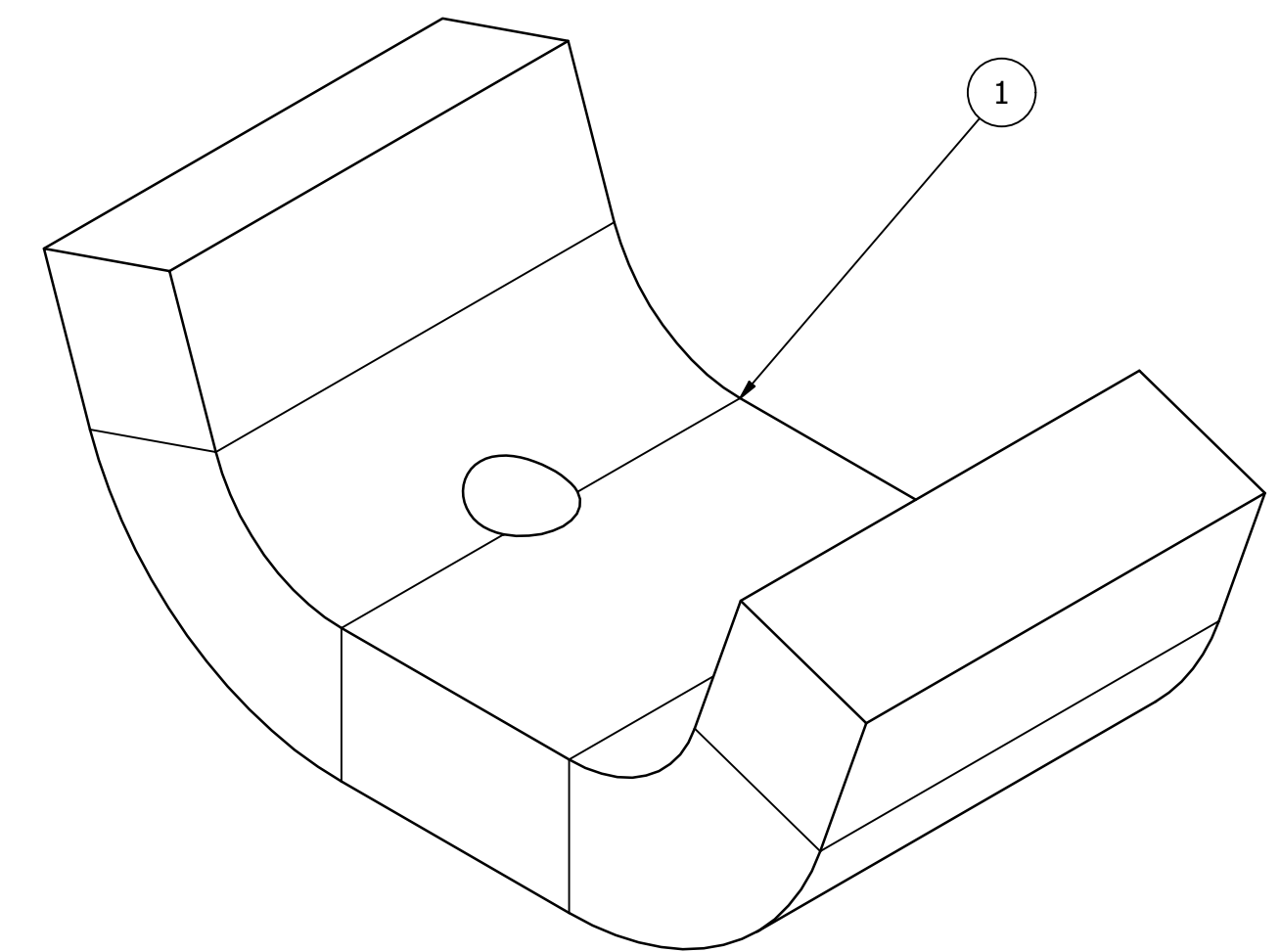
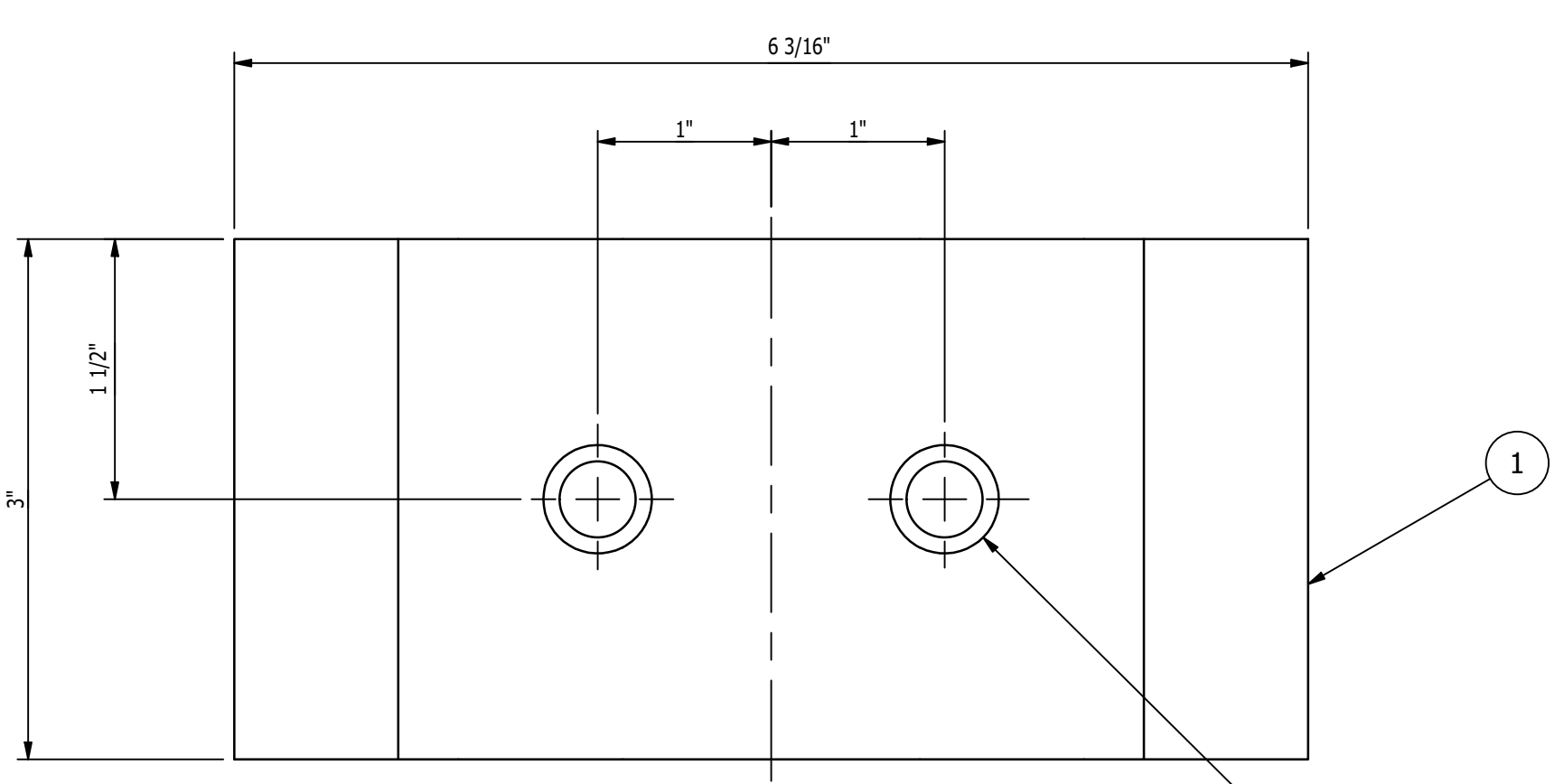
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

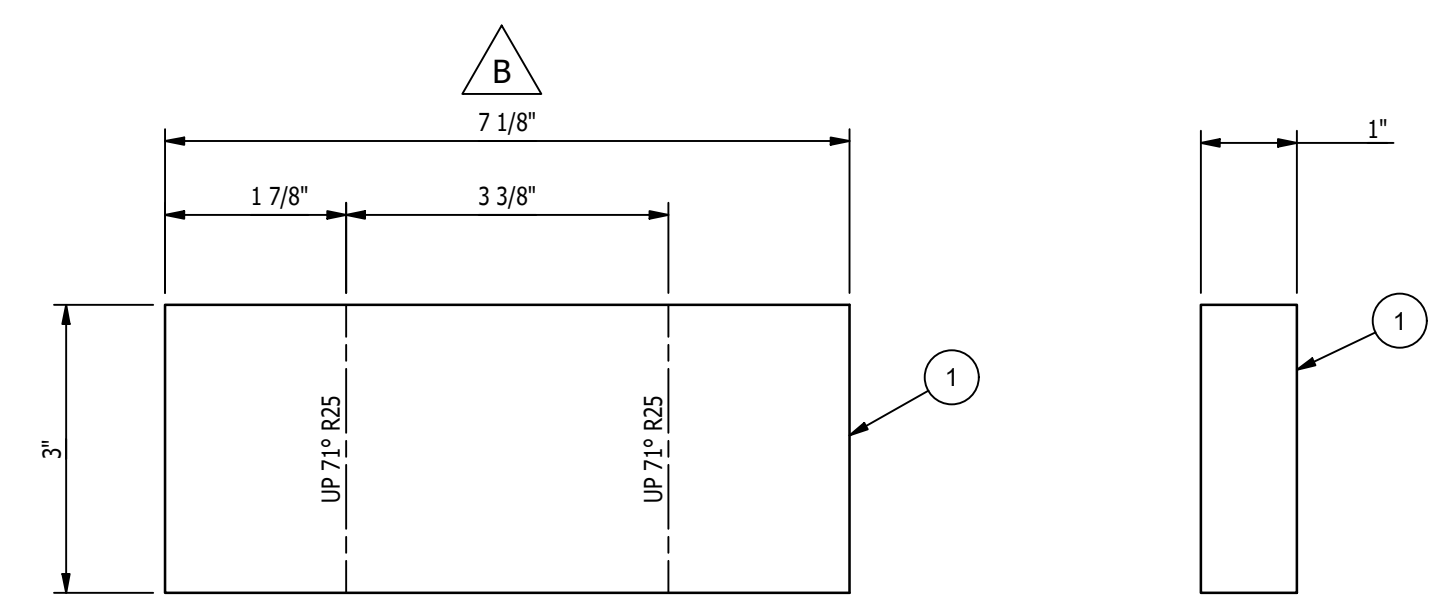
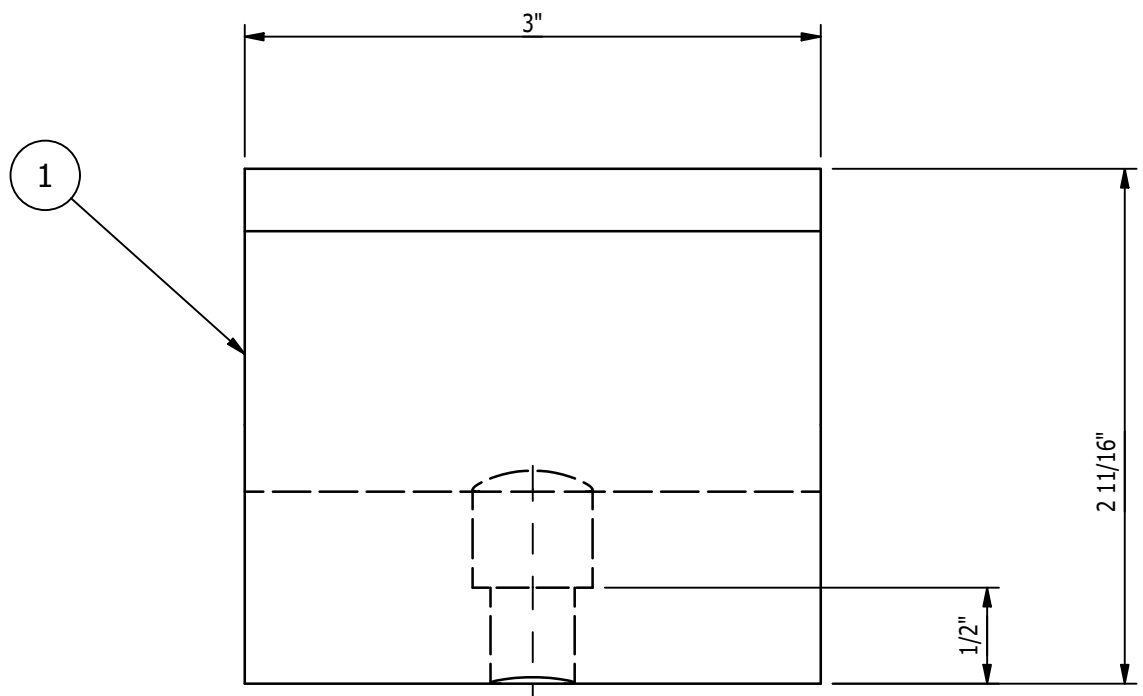
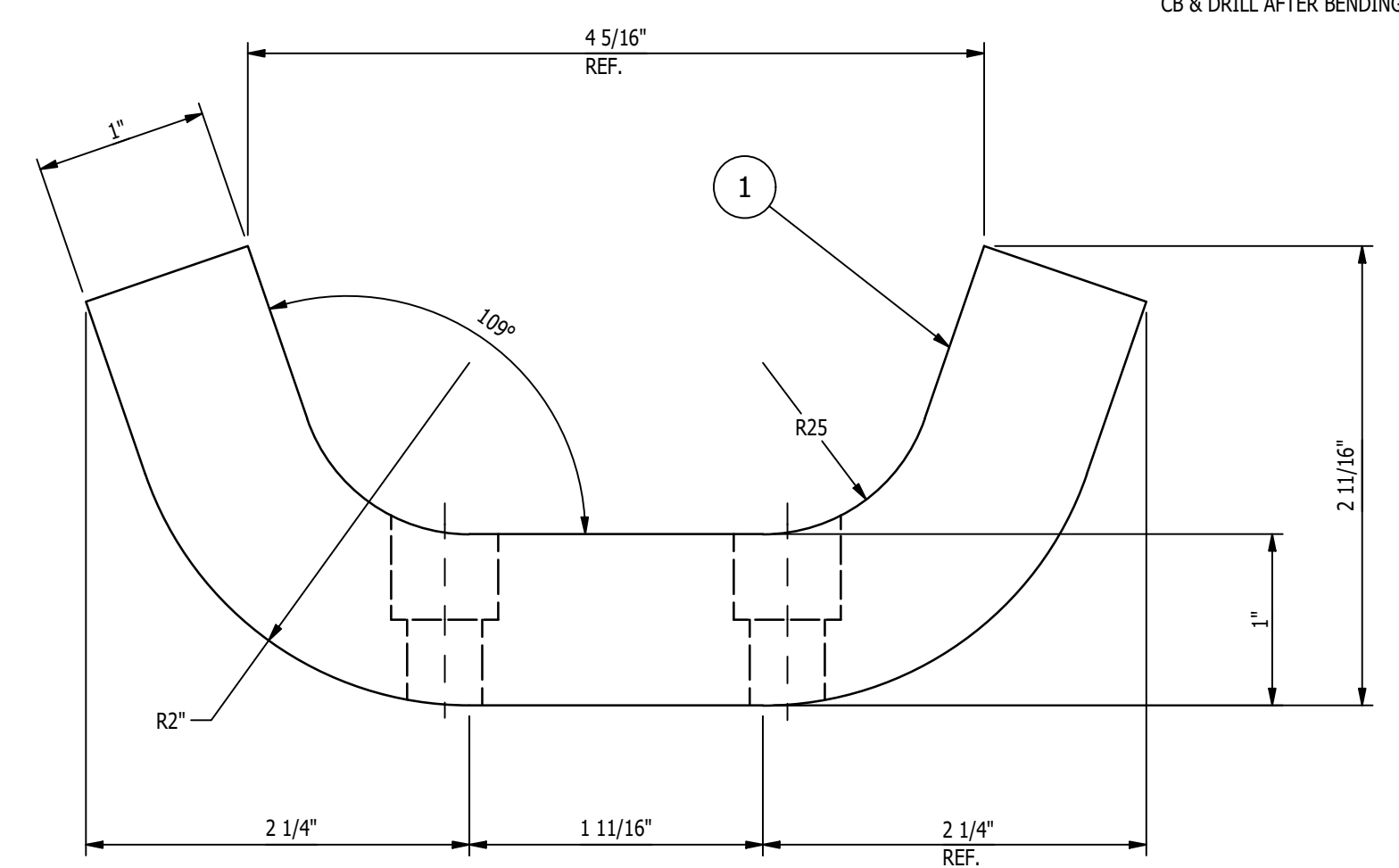
COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
B	1	MK-D411A			
	1	BAR 1" X 3" ~ 1045 STEEL	7 1/8"		
		MK-D411B			
B	2	BAR 1 x 3	8"		

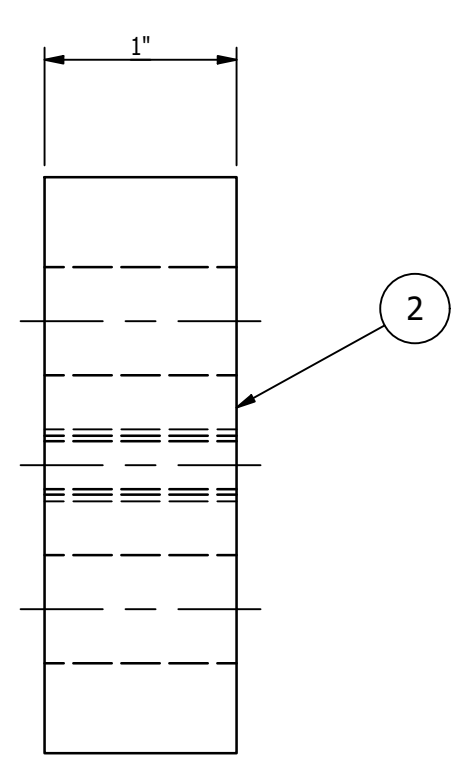
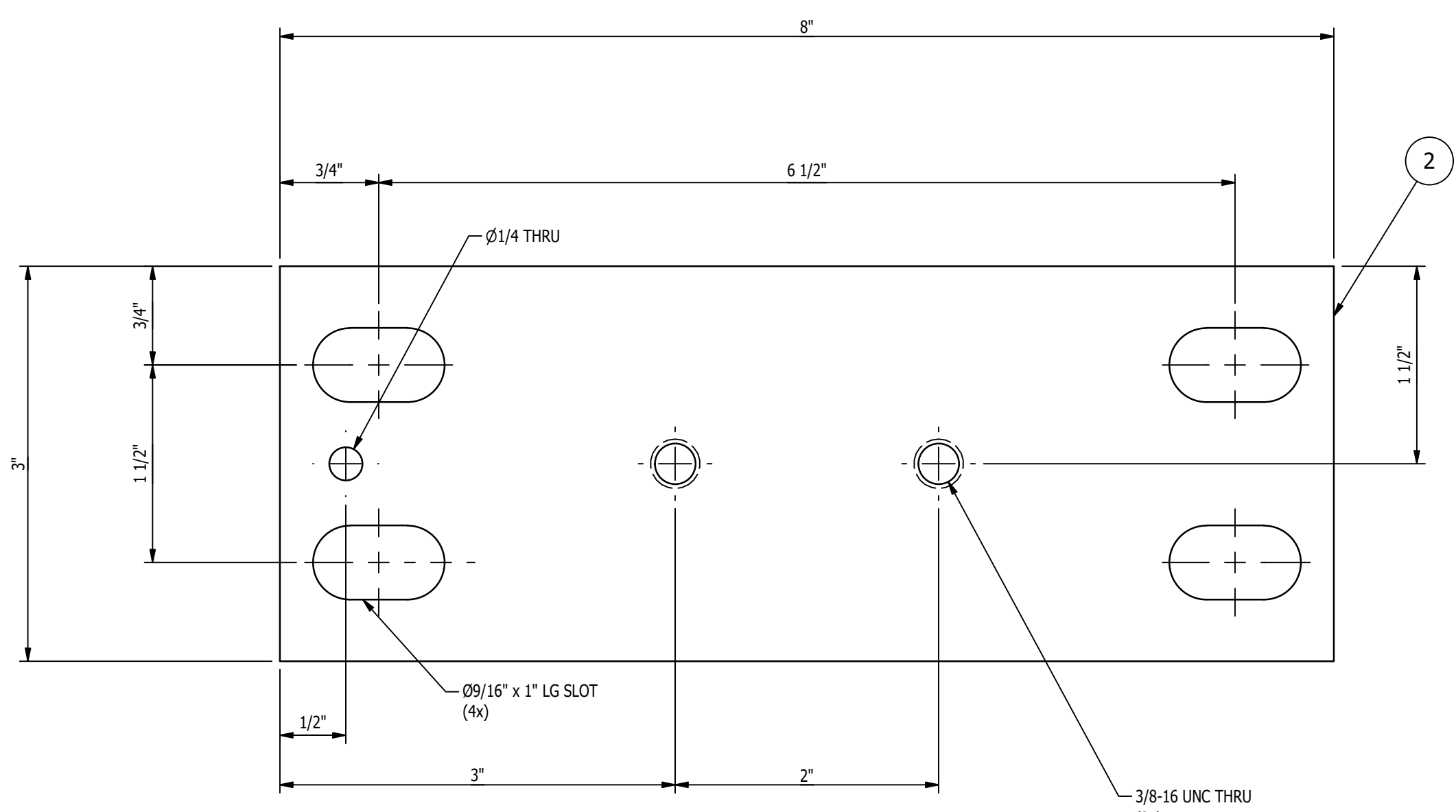


Ø7/16" THRU
CBORE Ø5/8" x 1/2" DP
(2x)
CB & DRILL AFTER BENDING



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

MK-D411A ~ AUX LIFT DETAIL
SCALE 1'-0" = 1'-0"



MK-D411B ~ AUX LIFT DETAIL MOUNTING PLATE
SCALE 1'-0" = 1'-0"

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

PAINT NOTES:
PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004 DO NOT PAINT ITEM '1'.

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	FIXED DESCRIPTION OF ITEM '2' IN BOM, SHORTENED LENGTH OF ITEM '1' BY 1 INCH	
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY	
B	MC 11/28/22 FIXED DESCRIPTION OF ITEM '2' IN BOM, SHORTENED LENGTH OF ITEM '1' BY 1 INCH
A	MC 11/15/22 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.

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Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D411

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

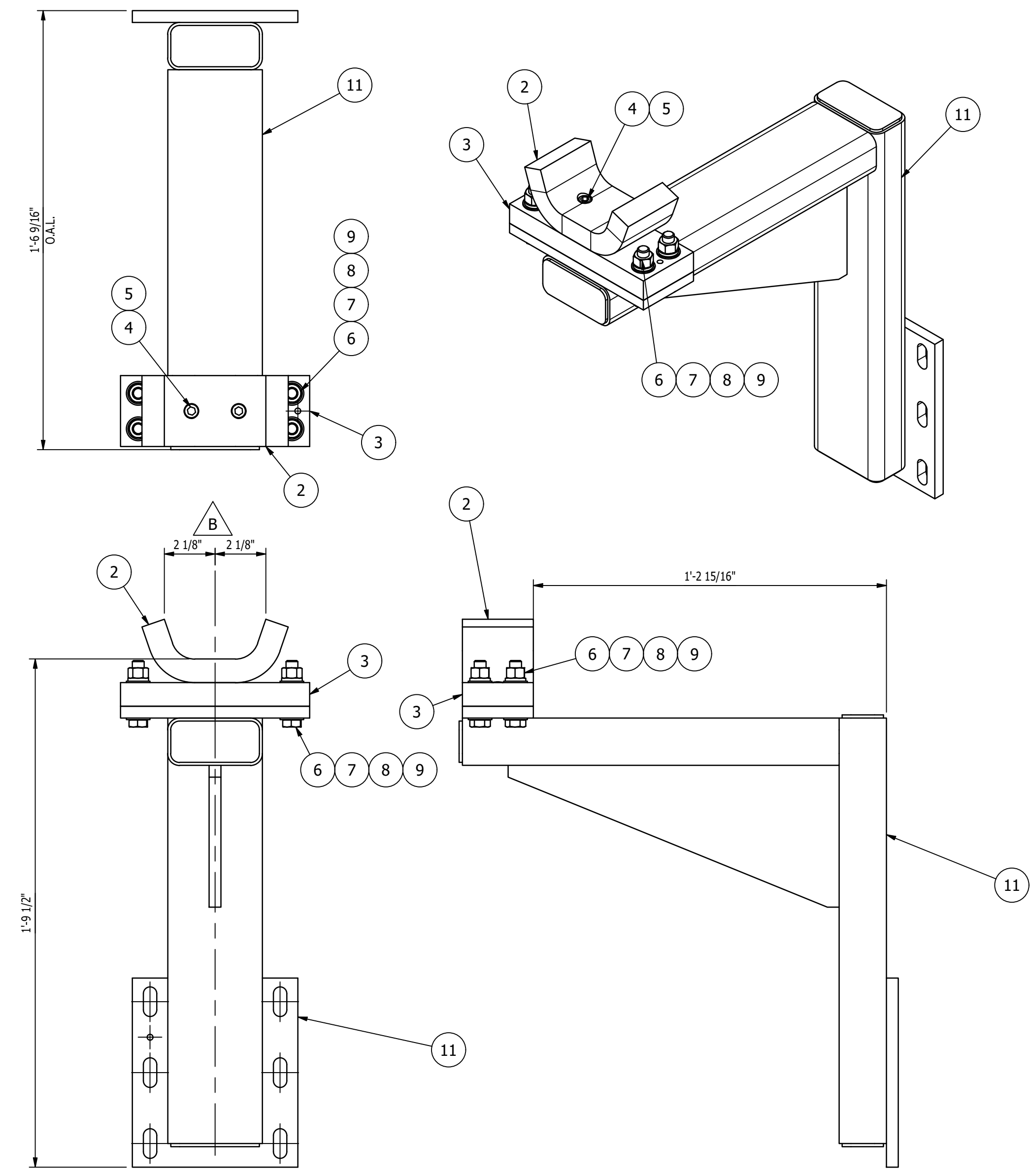
TITLE: P6700 CONVEYORS CAMPUS BUILDINGN
CLIENT: VOLVO
DRAWING No.: 1875D411

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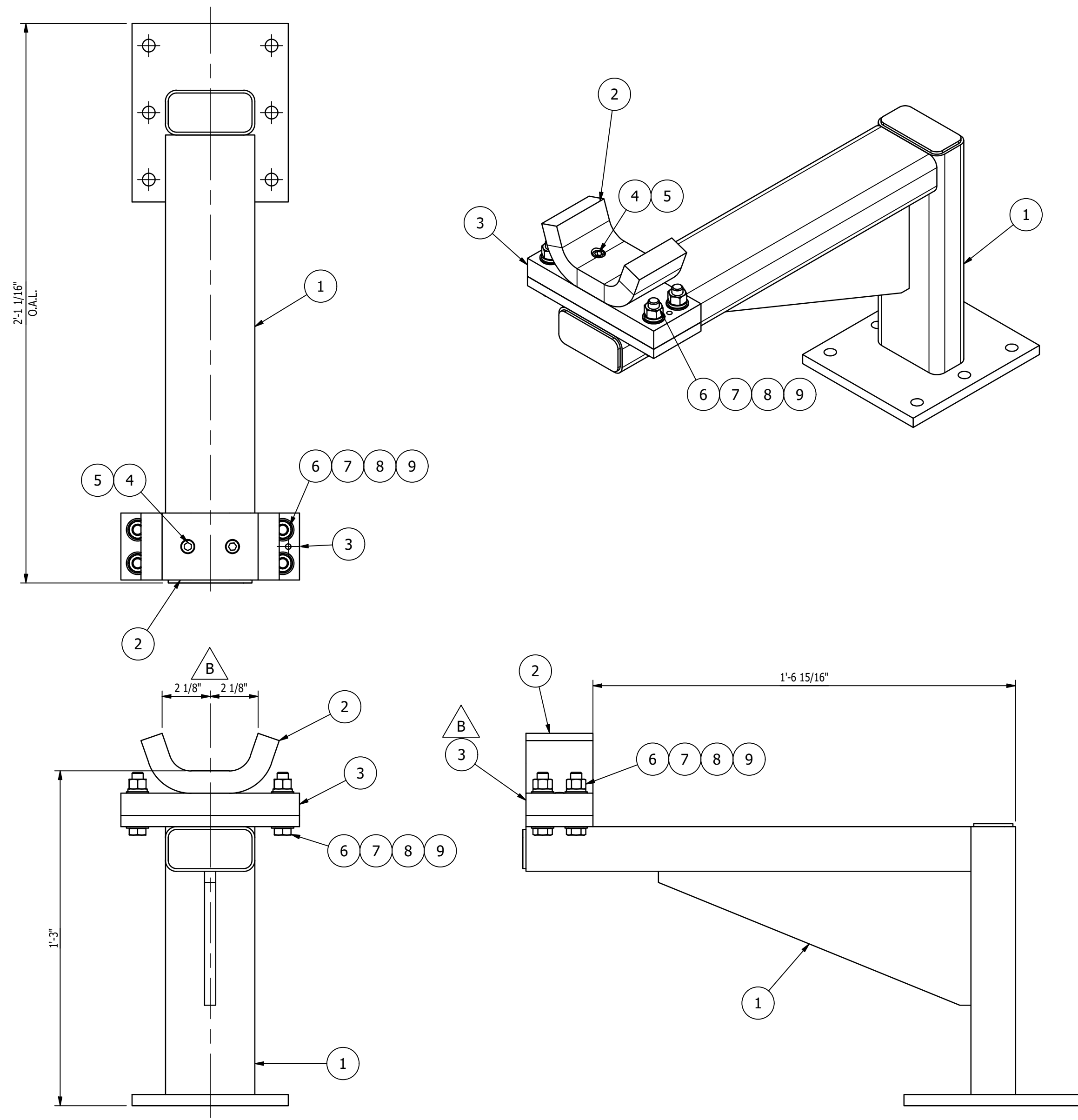
DRAWN BY: RPM
CHECKED BY: CW
DWG DATE: 8/31/2022

REV: B
JOB No.: 22096

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D412A			
1	1	MK-D410A ~ AUX LIFT ARM WELDMENT - DRIVER SIDE			
2	1	MK-D411A ~ AUX LIFT DETAIL			
3	1	MK-D411B ~ AUX LIFT DETAIL MOUNTING PLATE			
4	2	3/8 HIGH COLLAR SPRING LOCK WASHER			
5	2	3/8-16UNC x 1 1/2" LG. HEX SOCKET HEAD CAP SCREW			
6	8	1/2 TYPE B NARROW FLAT WASHER			
7	4	1/2-13UNC x 2 1/2" LG. HEX HEAD CAP SCREW			
8	4	1/2 SPRING LOCK WASHER			
9	4	1/2-13UNC HEX NUT			
		MK-D412B			
2	1	MK-D411A ~ AUX LIFT DETAIL			
3	1	MK-D411B ~ AUX LIFT DETAIL MOUNTING PLATE			
4	2	3/8 HIGH COLLAR SPRING LOCK WASHER			
5	2	3/8-16UNC x 1 1/2" LG. HEX SOCKET HEAD CAP SCREW			
6	8	1/2 TYPE B NARROW FLAT WASHER			
7	4	1/2-13UNC x 2 1/2" LG. HEX HEAD CAP SCREW			
8	4	1/2 SPRING LOCK WASHER			
9	4	1/2-13UNC HEX NUT			
11	1	MK-D410B ~ AUX LIFT ARM WELDMENT - PASSENGER SIDE			



MK-D412B ~ AUX LIFT ARM ASSEMBLY - PASSENGER SIDE
SCALE 3"=1'-0"



MK-D412A ~ AUX LIFT ARM ASSEMBLY - DRIVER SIDE
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.

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED BALLOON, UPDATED GEOMETRY PER ITEM '2'	
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY

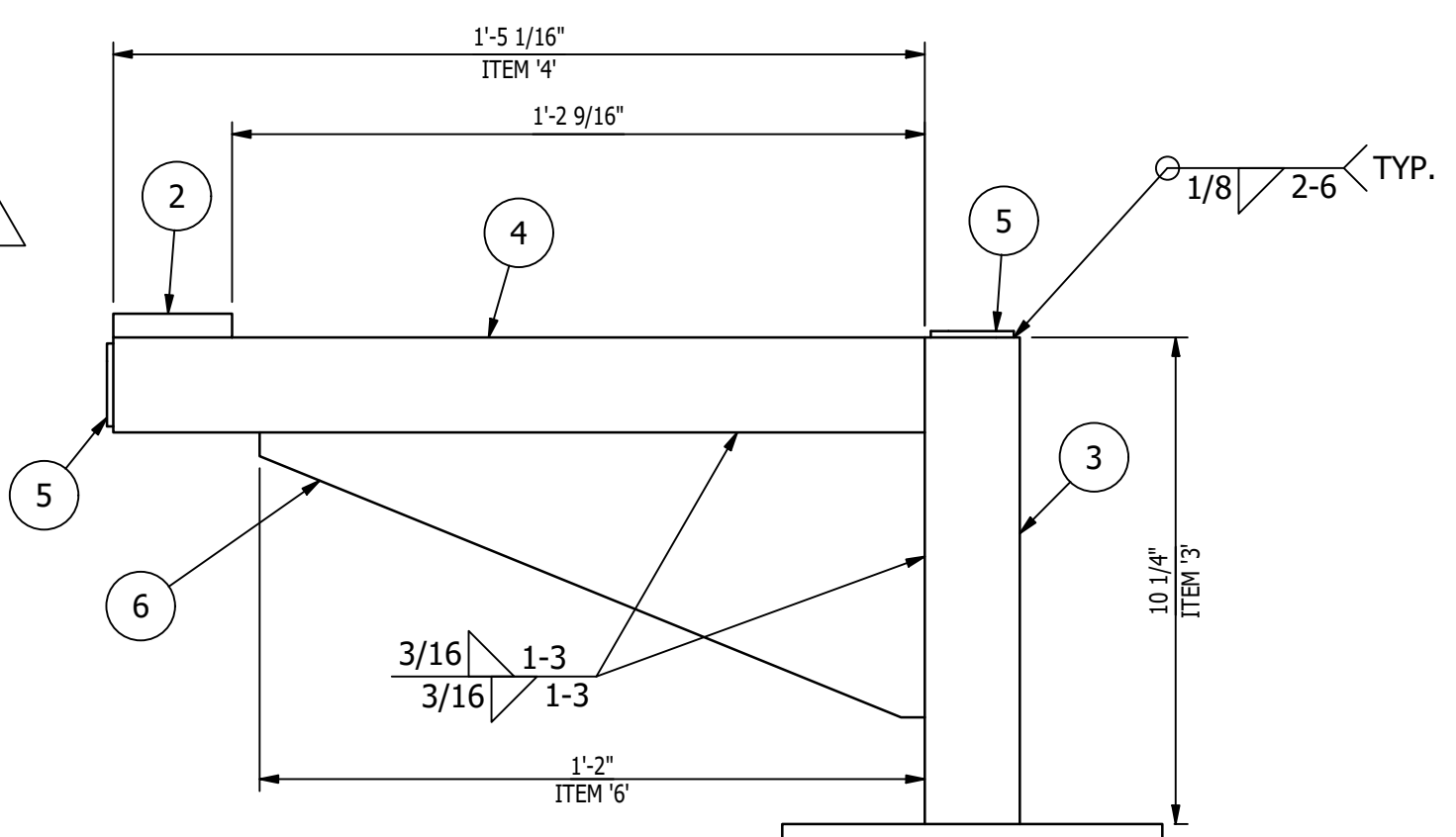
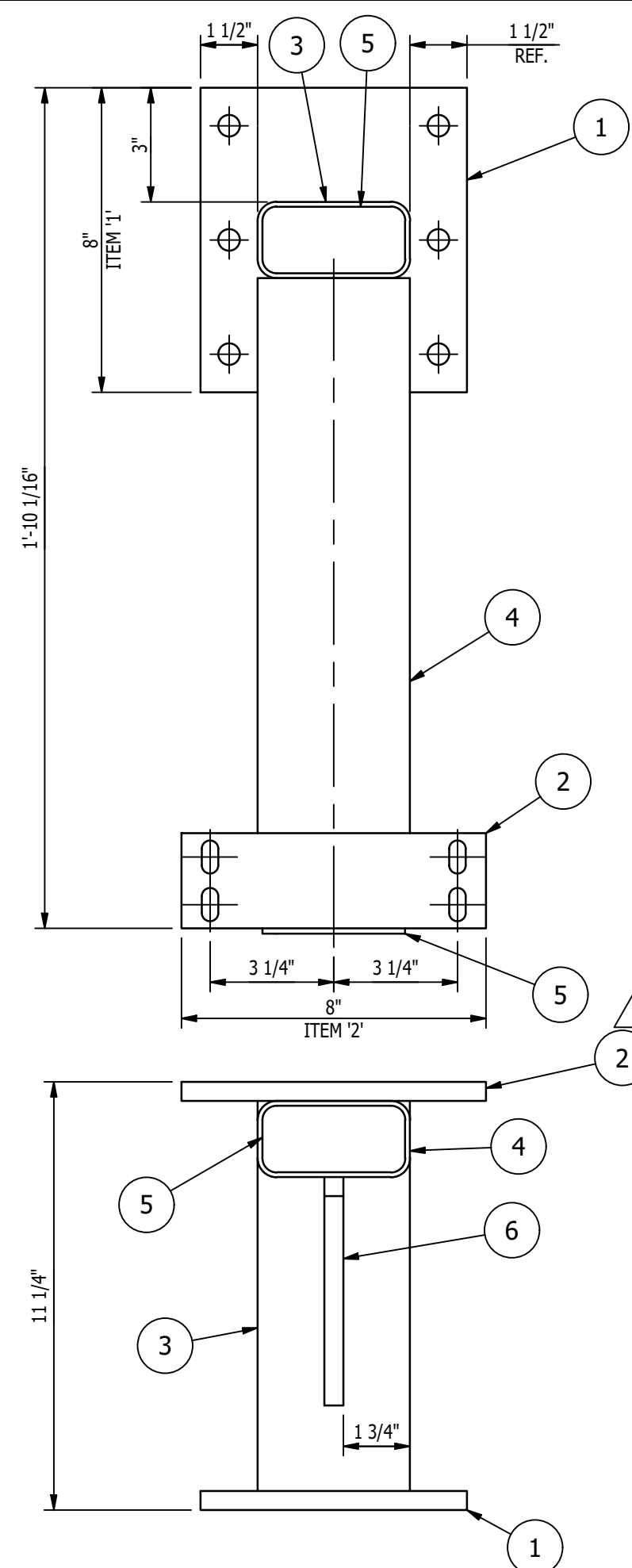
MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RPM
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D412	DWG DATE:	10/18/22
REV:	B	JOB No:	22096

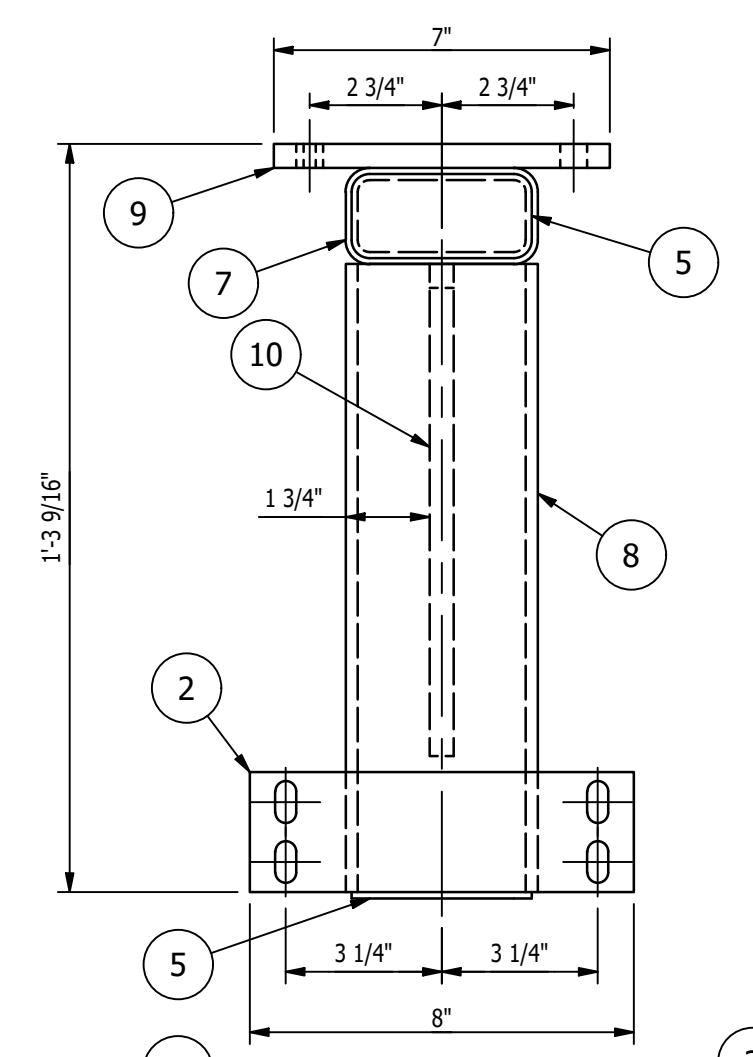
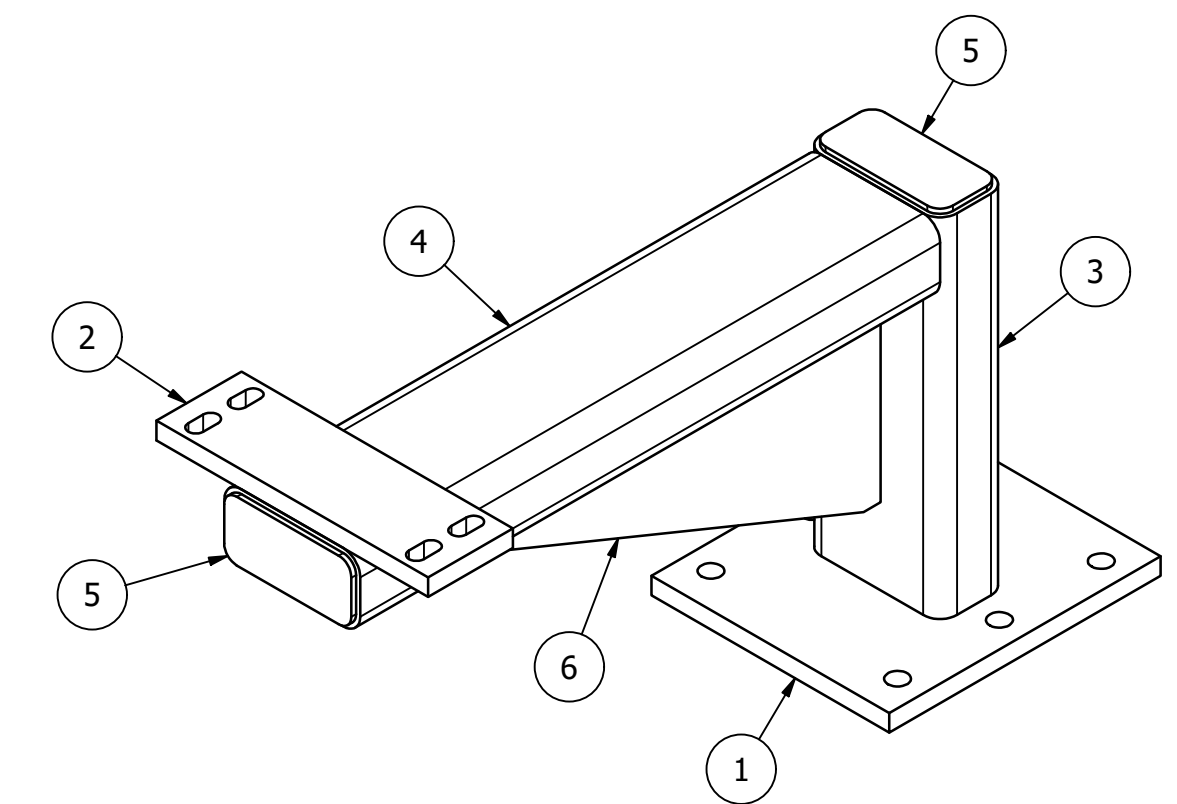
MAGNUM Consulting
41100 Quakertown Rd.
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Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

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

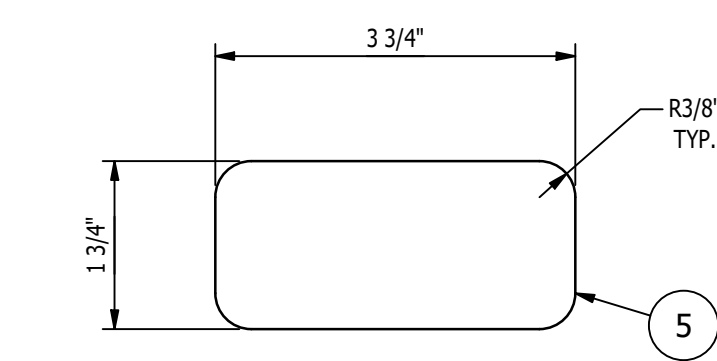
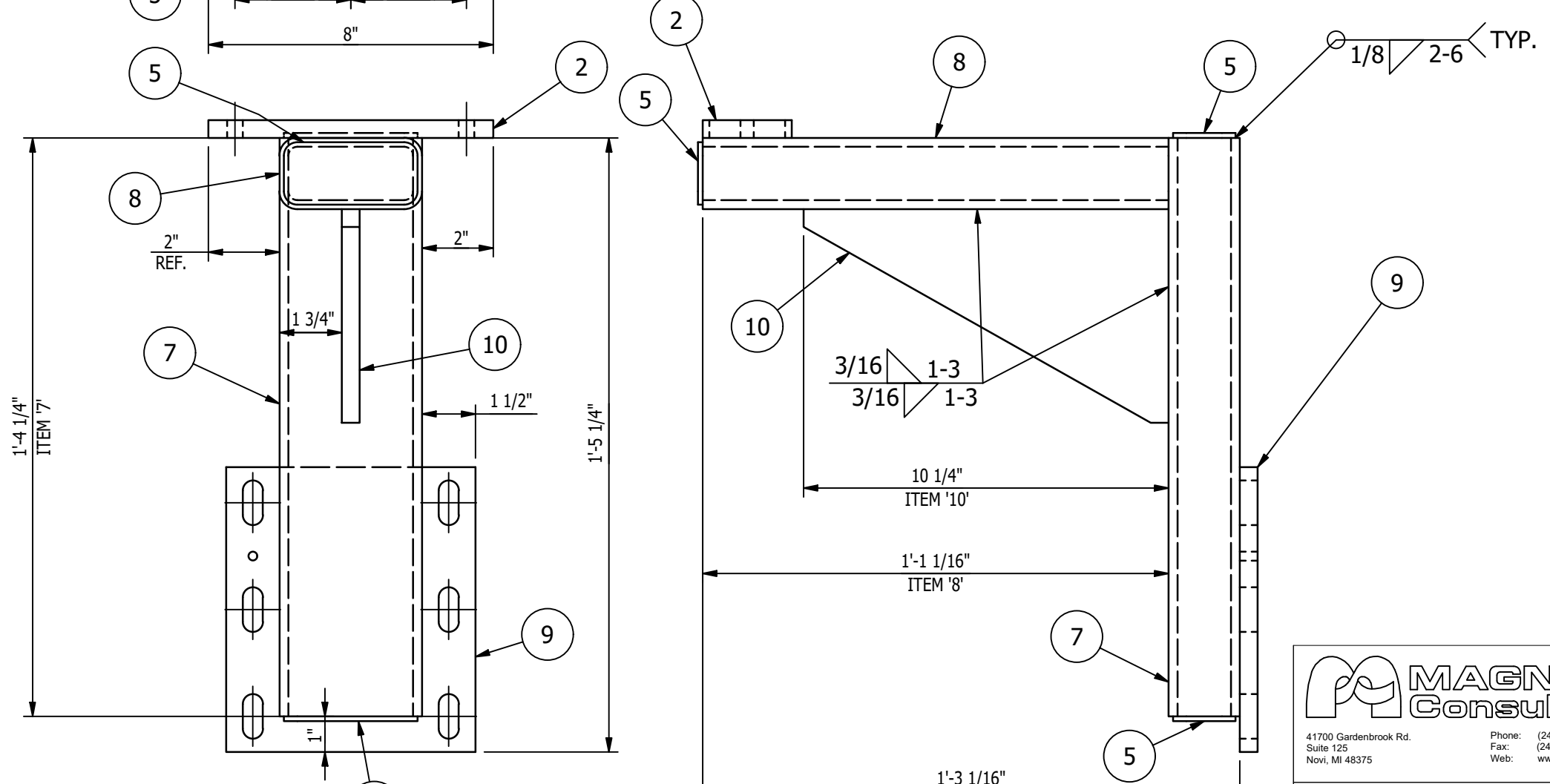
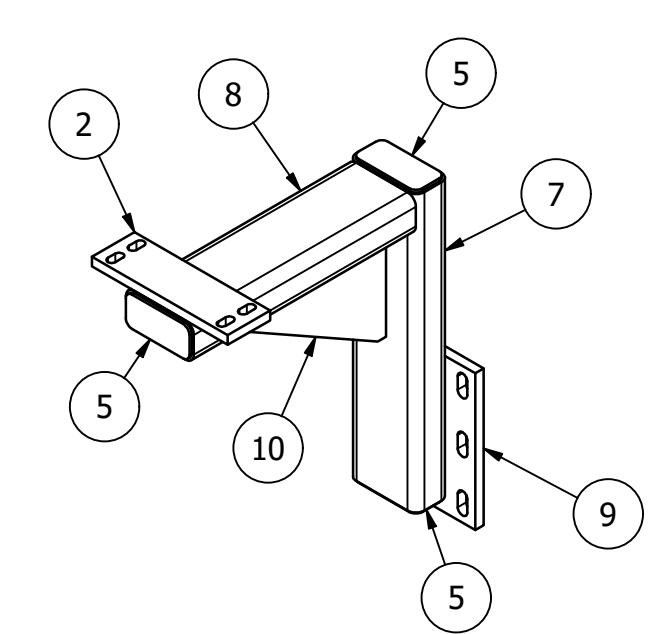
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4"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



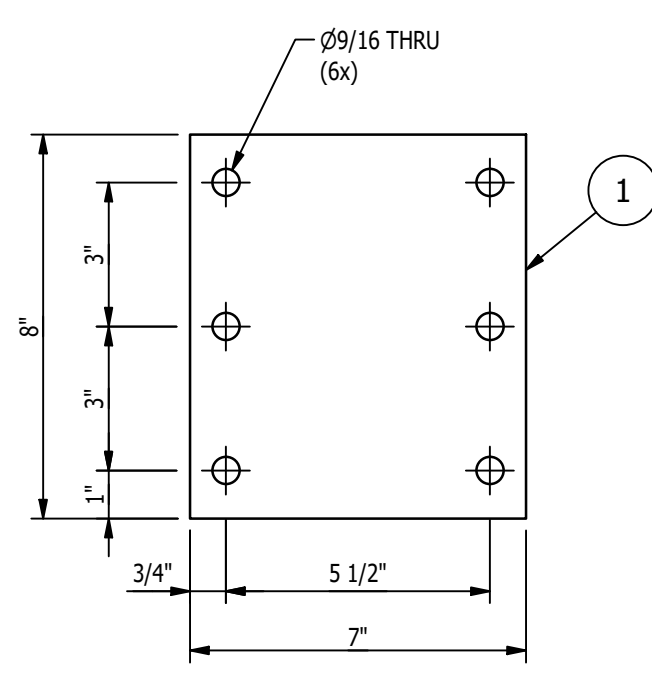
MK-D413A ~ AUX LIFT ARM
SCALE 3"=1'-0"



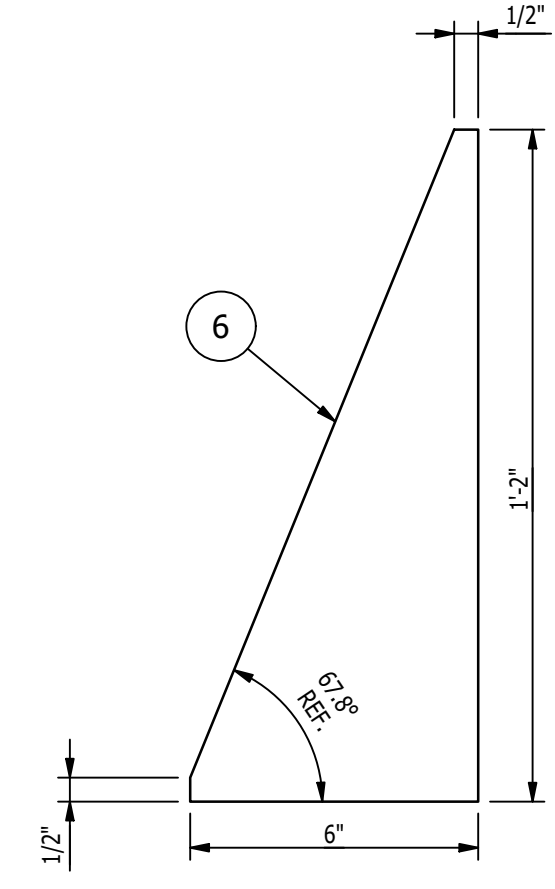
MK-D413B ~ AUX LIFT ARM
SCALE 3"=1'-0"



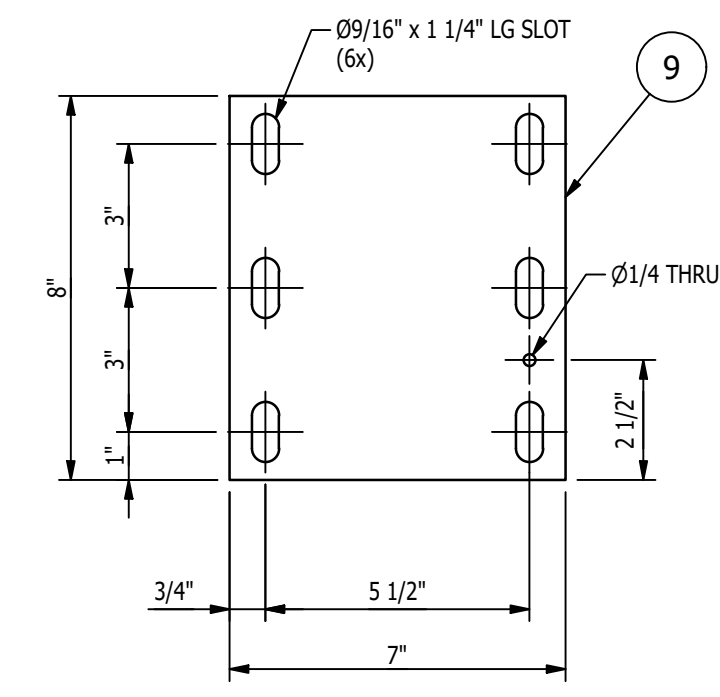
DETAIL OF ITEM '5'
SCALE 6"=1'-0"



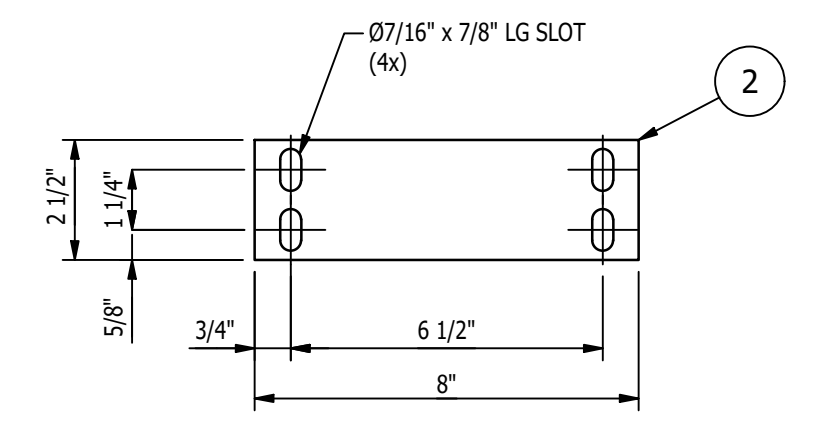
DETAIL OF ITEM '1'
SCALE 3"=1'-0"



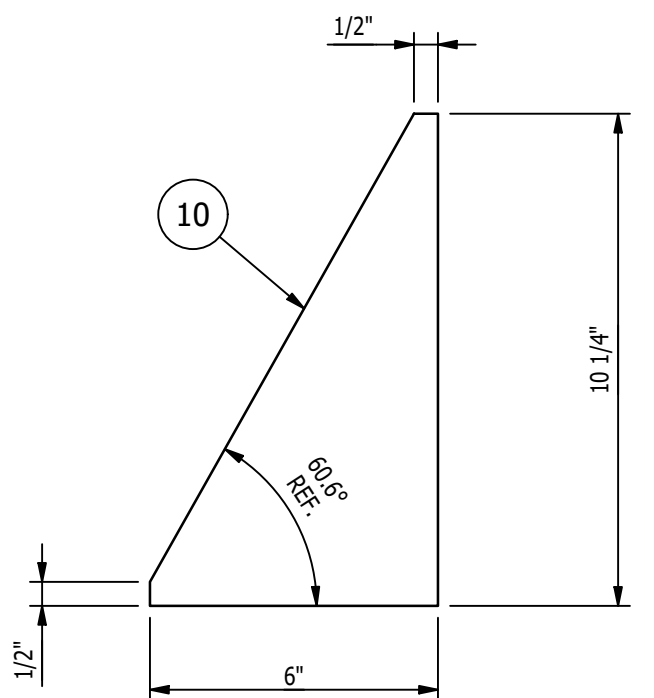
DETAIL OF ITEM '6'
SCALE 3"=1'-0"



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



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



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
MK-D413A					
1	1	BAR 1/2 x 7	8"		
2	1	BAR 1/2 x 2 1/2	8"		
3	1	HSS 4 x 2 x 1/4 (A500 GR. C)	10 1/4"		
4	1	HSS 4 x 2 x 1/4 (A500 GR. C)	1'-5 1/16"		
5	2	SHT 10 GA x 1 3/4"	3 3/4"		
6	1	PL 1/2 x 6"	1'-2"		
MK-D413B					
2	1	BAR 1/2 x 2 1/2	8"		
5	3	SHT 10 GA x 1 3/4"	3 3/4"		
7	1	HSS 4 x 2 x 1/4 (A500 GR. C)	1'-4 1/4"		
8	1	HSS 4 x 2 x 1/4 (A500 GR. C)	1'-1 1/16"		
9	1	BAR 1/2 x 8	7"		
10	1	PL 1/2 x 6"	10 1/4"		

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED BALLOON	
A	MC	11/14/22	FOR FABRICATION	

REVISION HISTORY

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 FENTON, MI 48430
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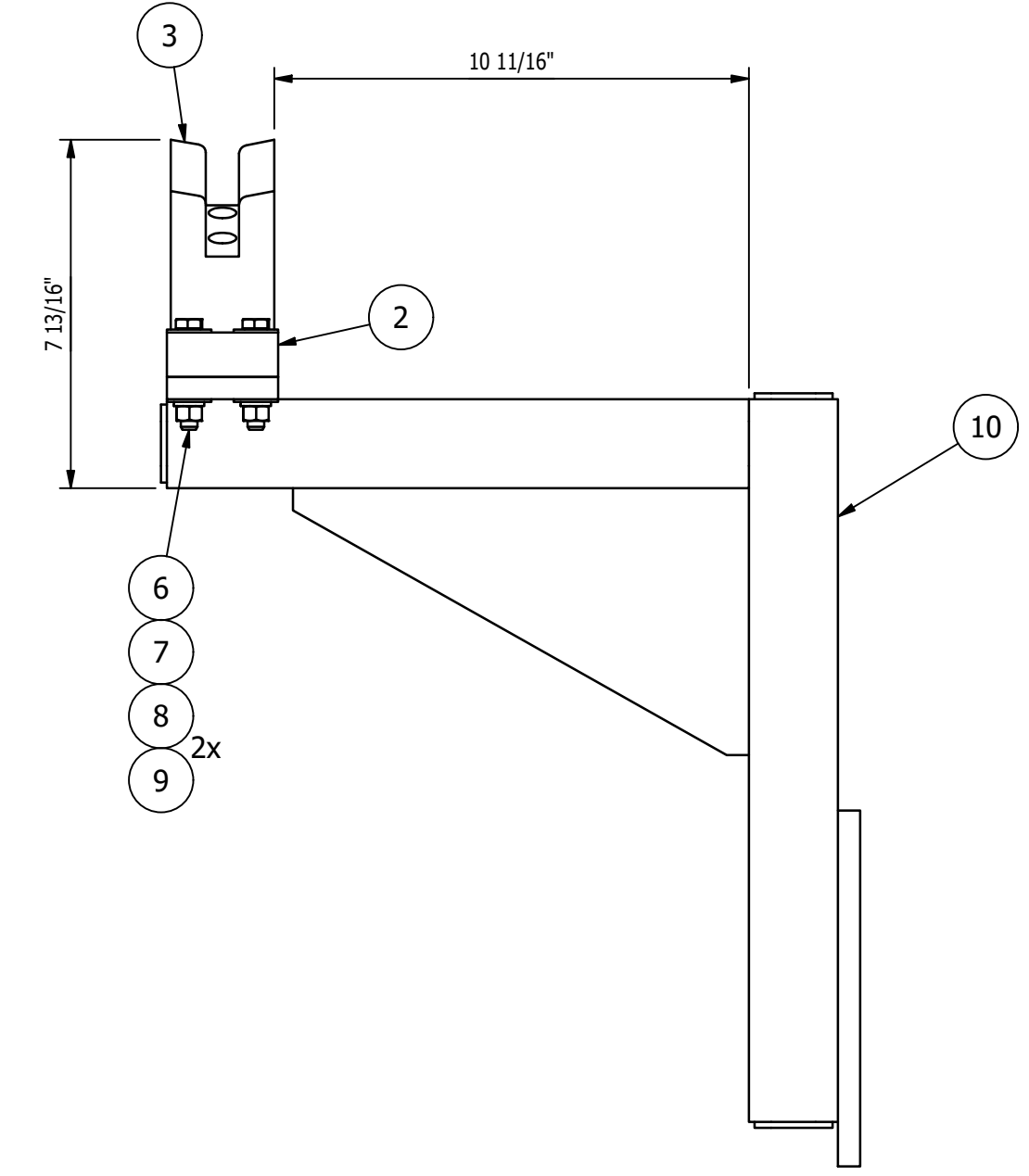
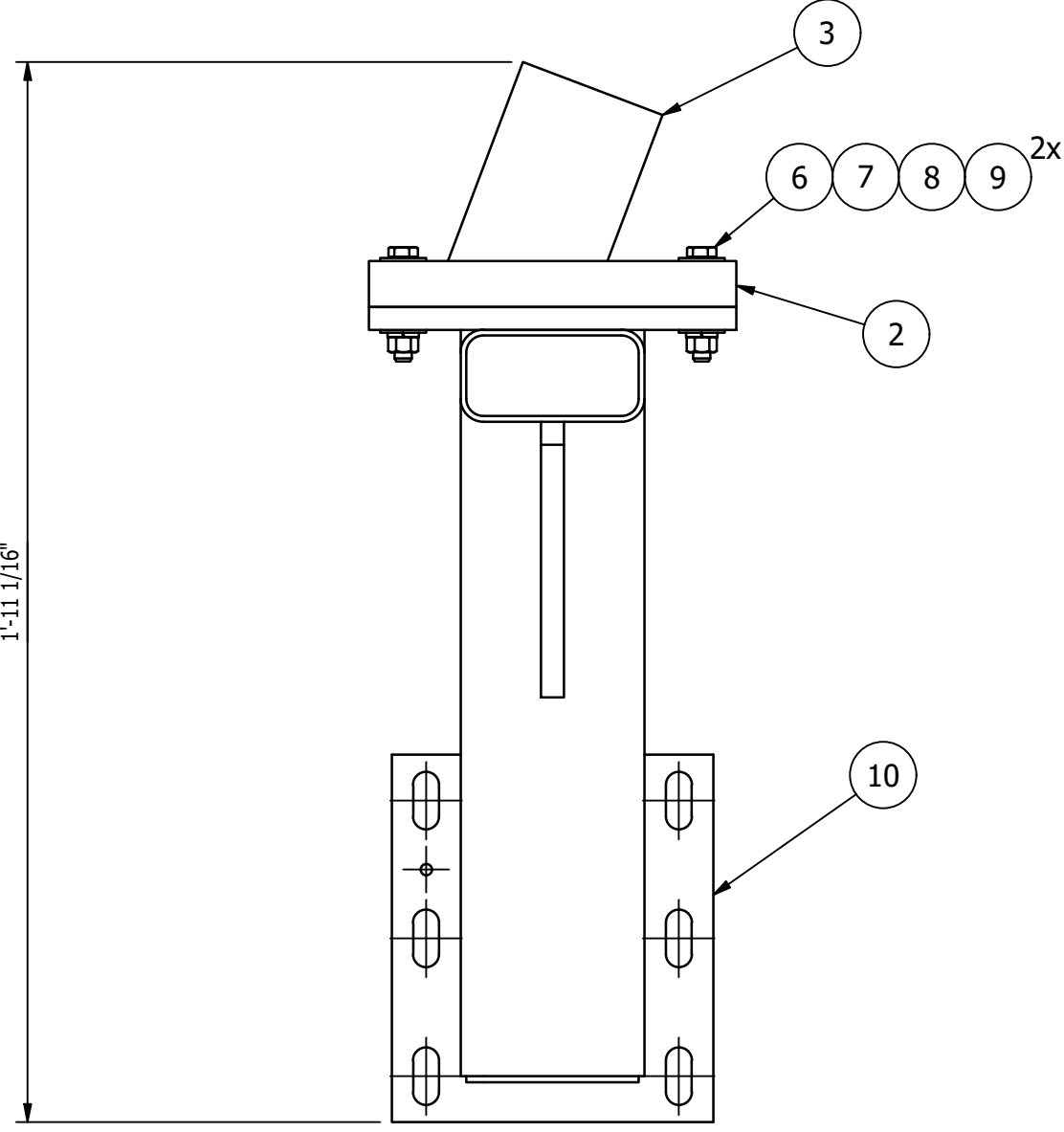
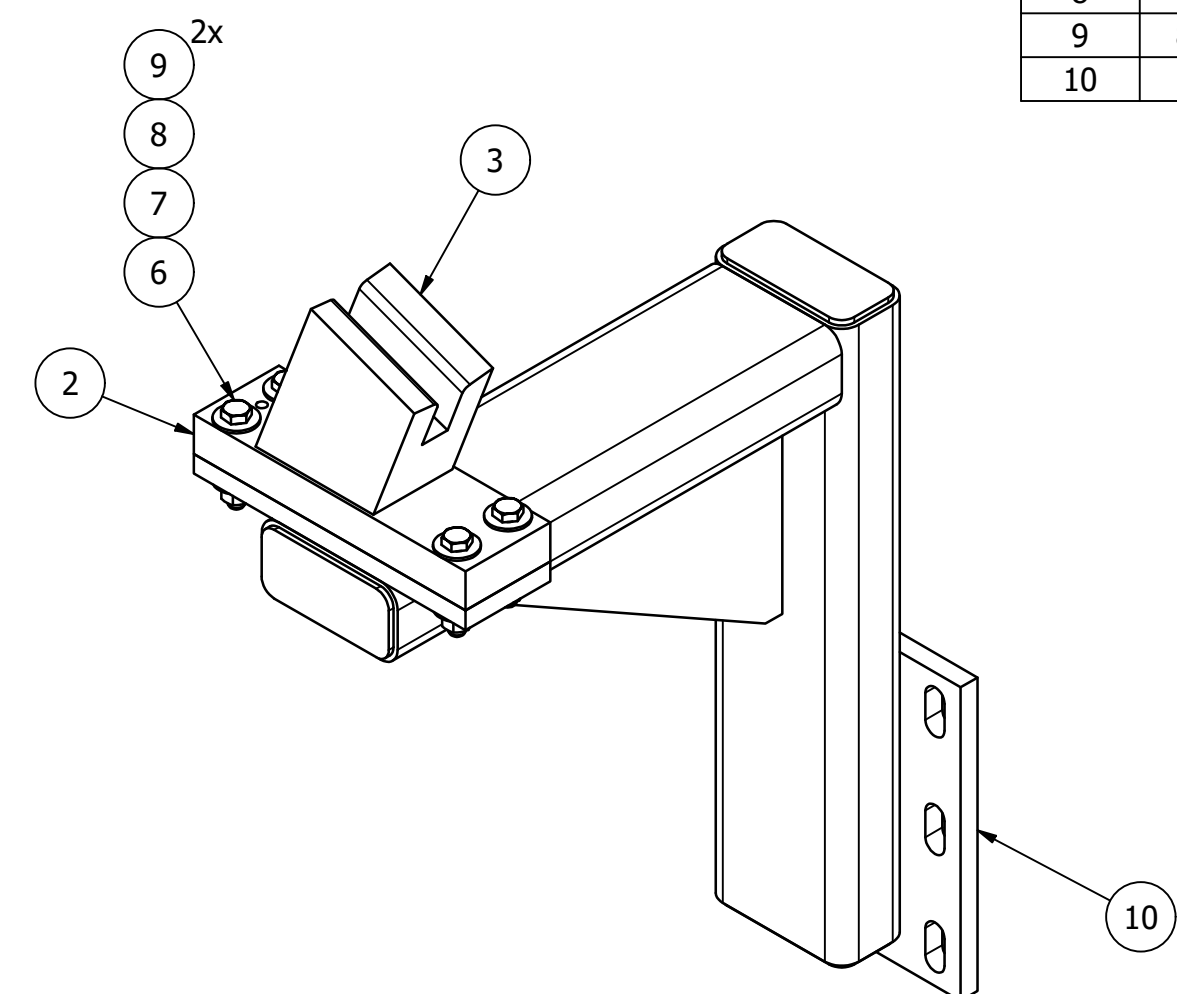
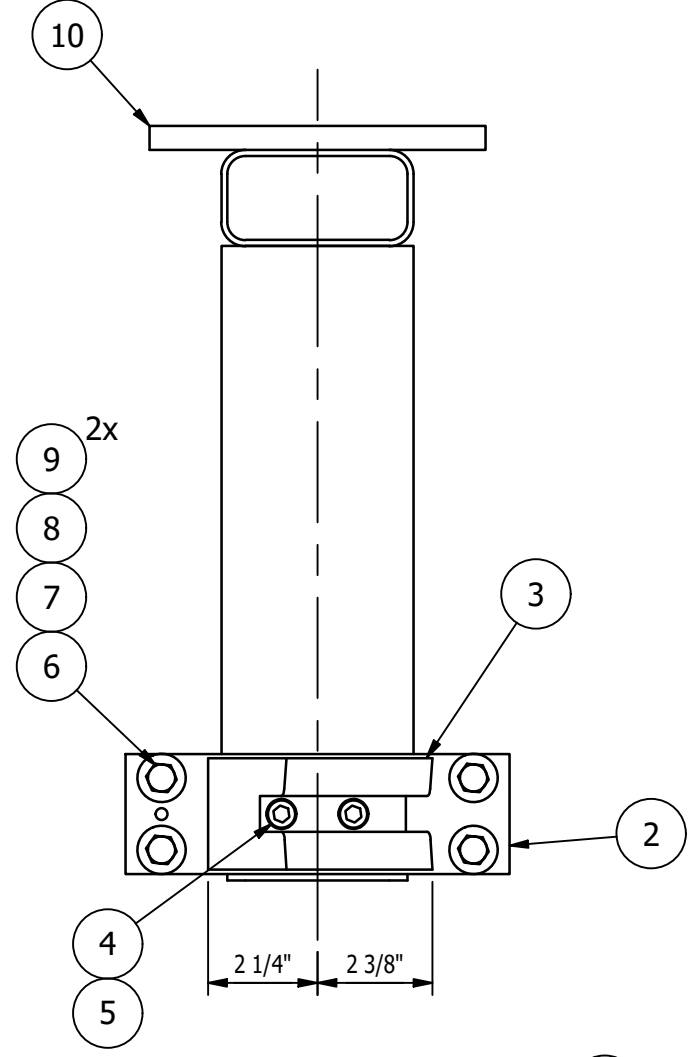
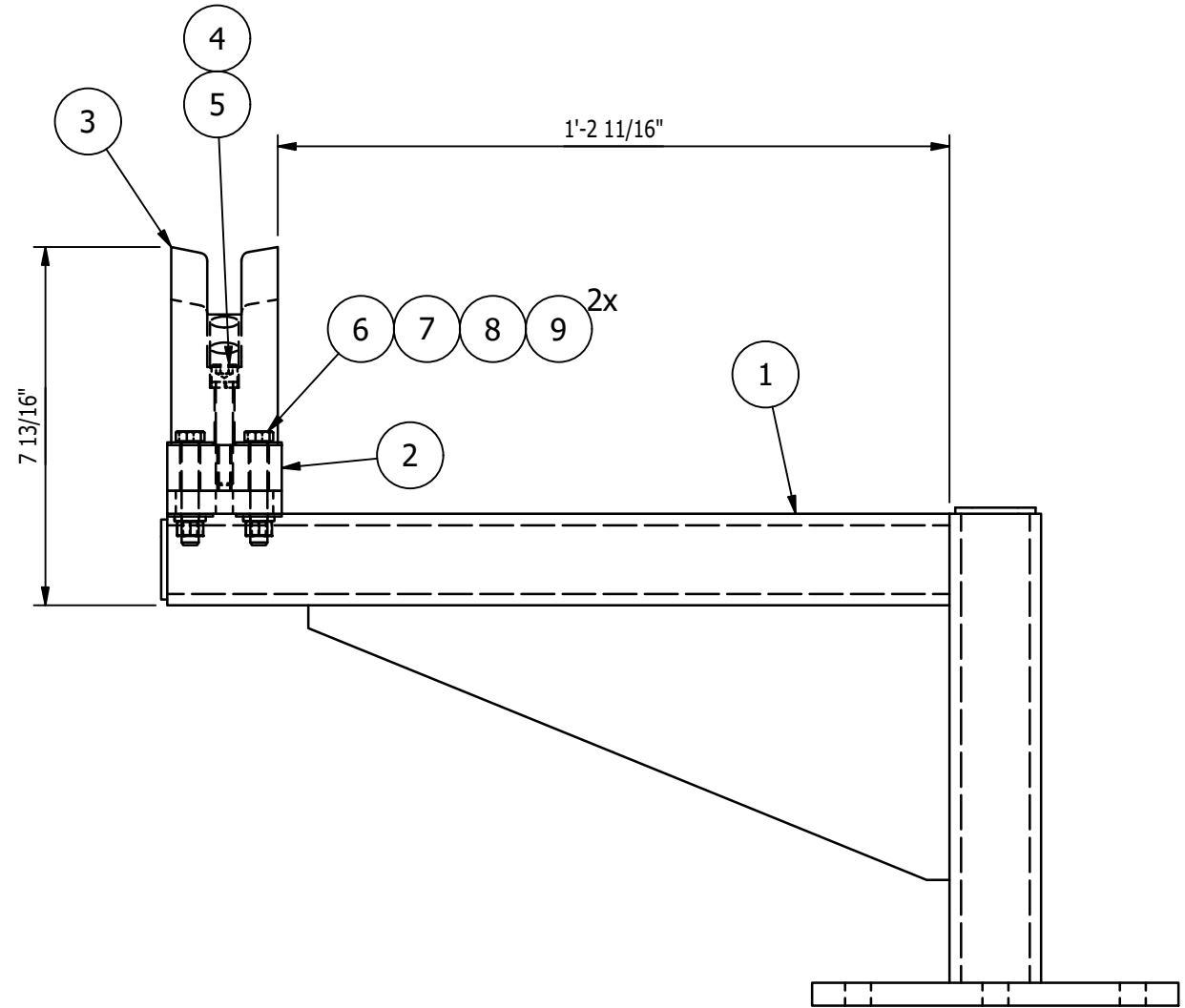
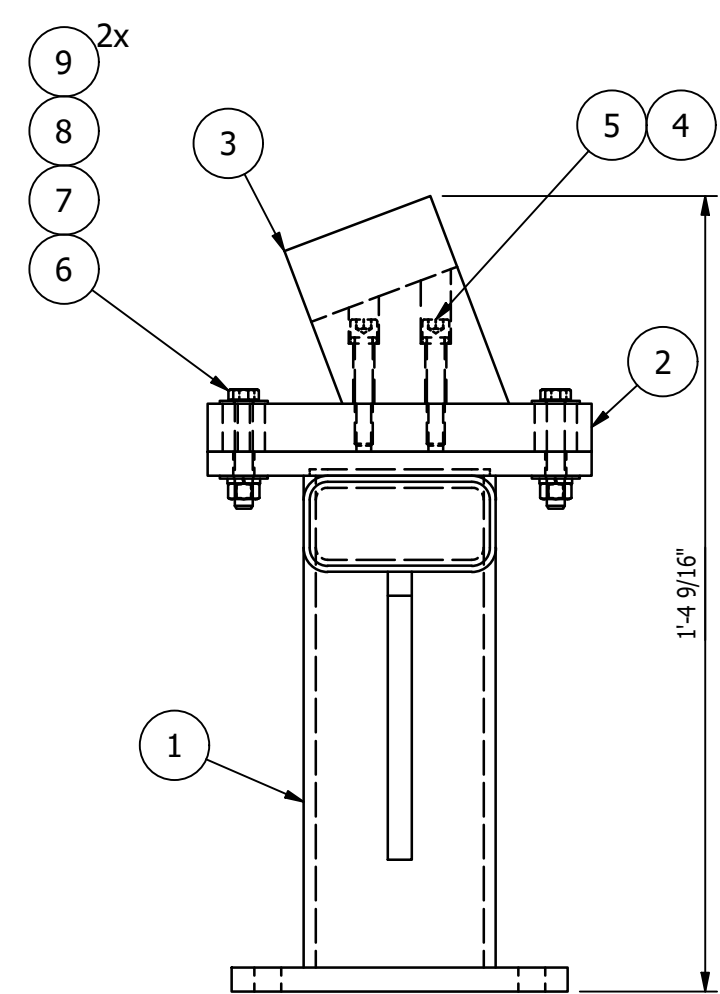
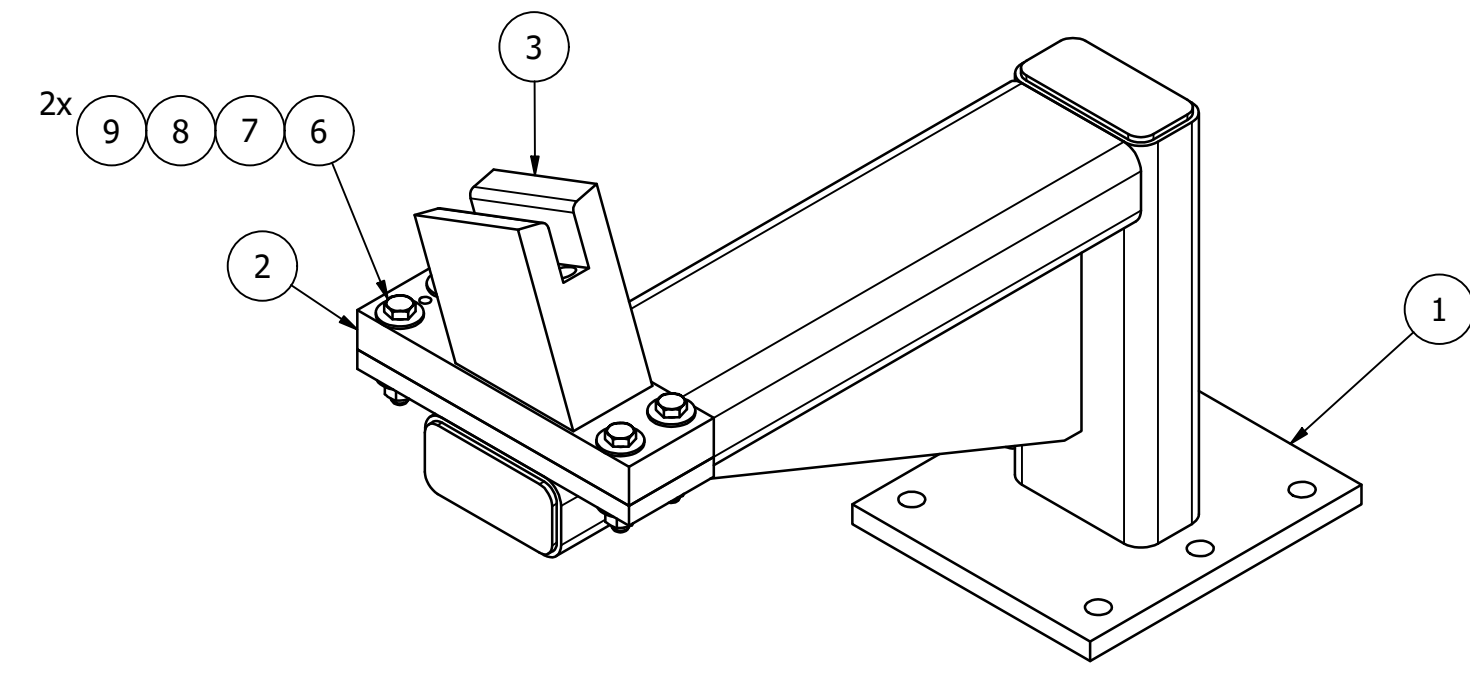
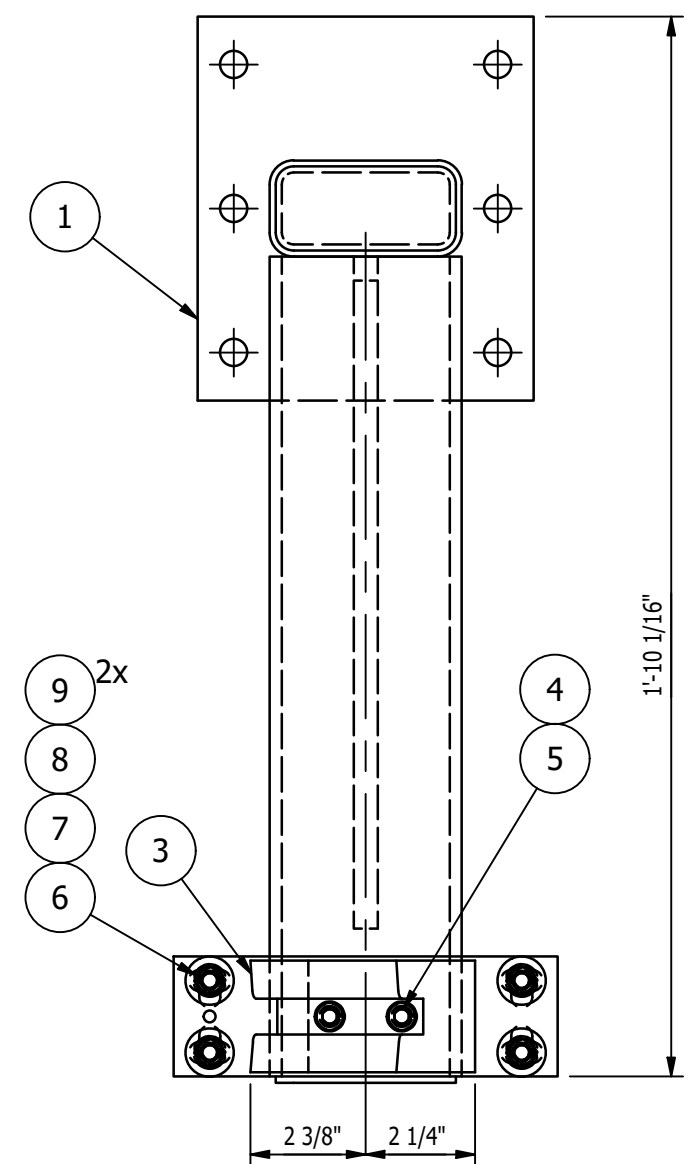
TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RPM
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D413	DWG DATE: 10/18/22
REV: B	JOB No: 22096

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

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D413 - REV B

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

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



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D414A			
1	1	MK-D413A ~ AUX LIFT ARM			
2	1	MK-D415B ~ AUX LIFT DETAIL MOUNTING PLATE			
3	1	MK-D415A ~ AUX LIFT DETAIL			
4	2	3/8 HIGH COLLAR SPRING LOCK WASHER			
5	2	3/8-16UNC x 2 1/4" LG. HEX SOCKET HEAD CAP SCREW			
6	4	3/8-16UNC x 2 1/4" LG. HEX HEAD CAP SCREW			
7	4	3/8 SPRING LOCK WASHER			
8	4	3/8-16UNC HEX NUT			
9	8	3/8 TYPE B REGULAR FLAT WASHER			
		MK-D414B			
2	1	MK-D415B ~ AUX LIFT DETAIL MOUNTING PLATE			
3	1	MK-D415A ~ AUX LIFT DETAIL			
4	2	3/8 HIGH COLLAR SPRING LOCK WASHER			
5	2	3/8-16UNC x 2 1/4" LG. HEX SOCKET HEAD CAP SCREW			
6	4	3/8-16UNC x 2 1/4" LG. HEX HEAD CAP SCREW			
7	4	3/8 SPRING LOCK WASHER			
8	4	3/8-16UNC HEX NUT			
9	8	3/8 TYPE B REGULAR FLAT WASHER			
10	1	MK-D413B ~ AUX LIFT ARM			

MK-D414A ~ AUX LIFT ARM ASSEMBLY - LH
SCALE 3"=1'-0"

MK-D414B ~ AUX LIFT ARM ASSEMBLY - RH
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.

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/14/22	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	DRAWN BY:	RPM
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D414	DWG DATE:	10/18/22
REV:	A	JOB No.:	22096

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

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

GENERAL NOTES:

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

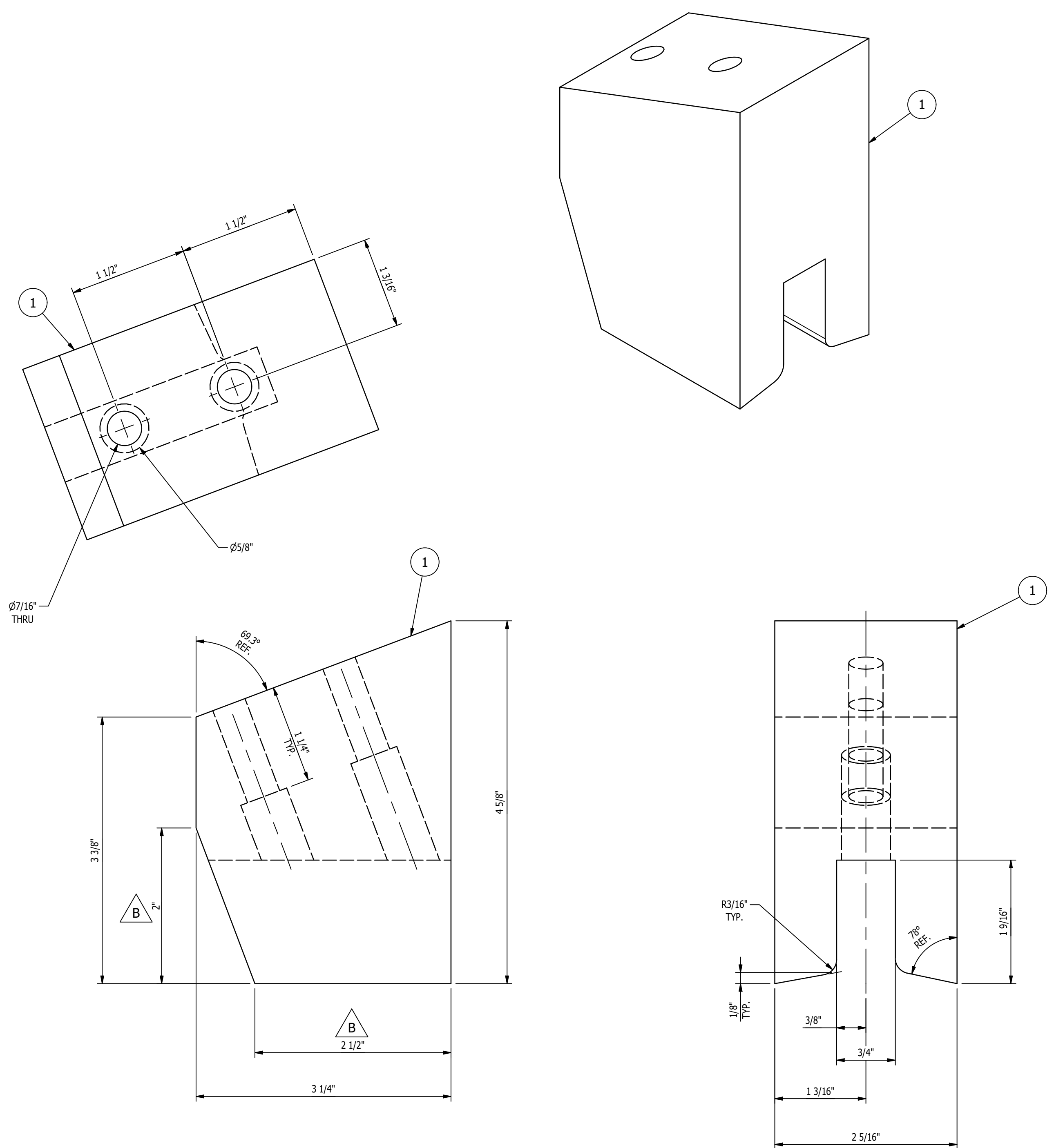
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SLUG TIGHT CONDITION, UNLESS NOTED.

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

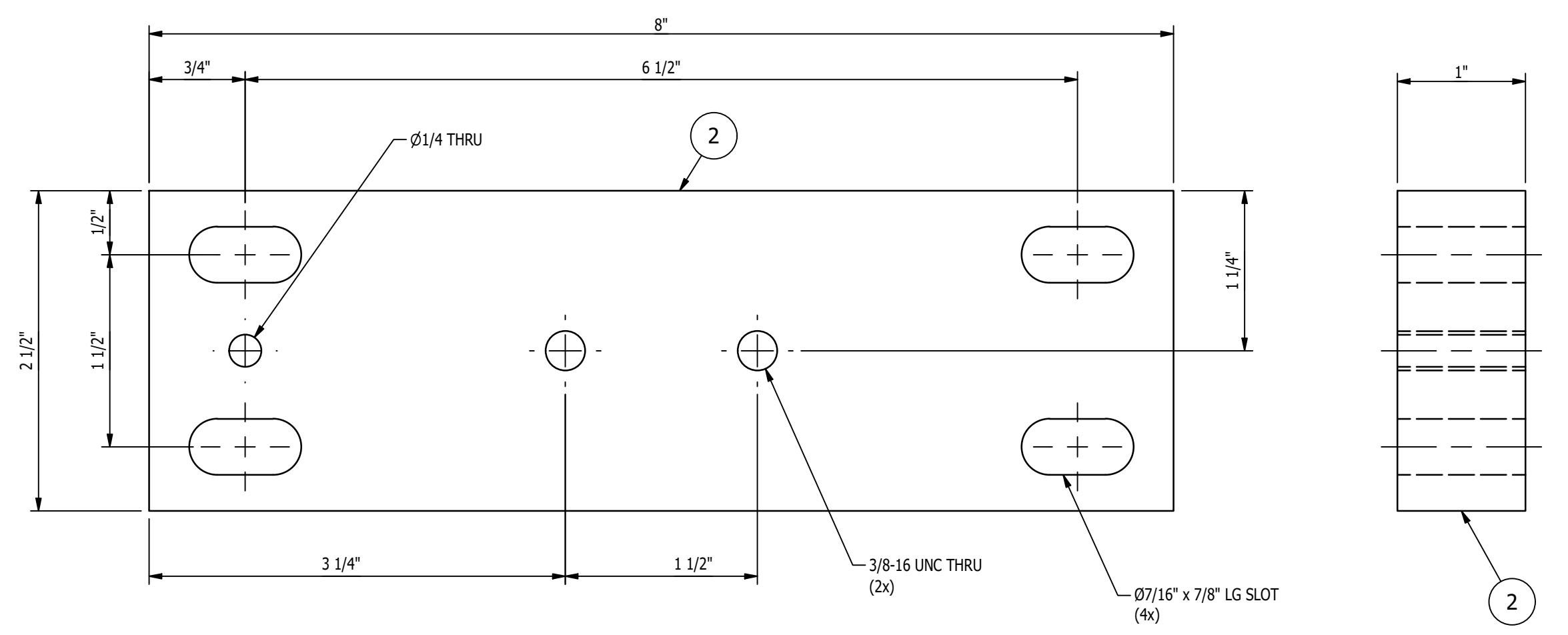
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D415A			
1	1	PL 2 5/16 x 3 1/4 (1045)	4 5/8"		
		MK-D415B			
2	1	BAR 1 x 2 1/2	8"		



MK-D415A ~ AUX LIFT DETAIL
SCALE 1'-0" = 1'-0"



MK-D415B ~ AUX LIFT DETAIL MOUNTING PLATE
SCALE 1'-0" = 1'-0"

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

PAINT NOTES:
PAINT ALL FABRICATED STEEL WITH ONE SHOP COAT OF PURE ORANGE RAL 2004
DO NOT PAINT ITEM '1'

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	UPDATED GEOMETRY OF ITEM '1'	
A	MC	11/14/22	FOR FABRICATION	

MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: RPM
CLIENT: VOLVO		CHECKED BY: CW
DRAWING No. 1875D415		DWG DATE: 10/18/22
REV: B		JOB No: 22096

MAGNUM Consulting
 4110 Quakerbrook Rd. Suite 125 West, MI 48375
 Phone: (248) 772-8822 Fax: (248) 772-8851 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D415 - REV B

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

GENERAL NOTES:

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

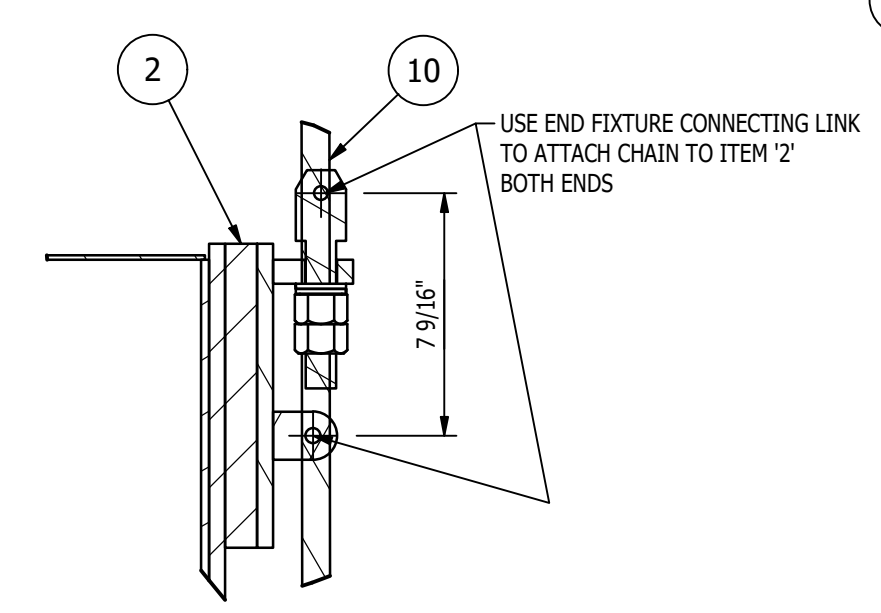
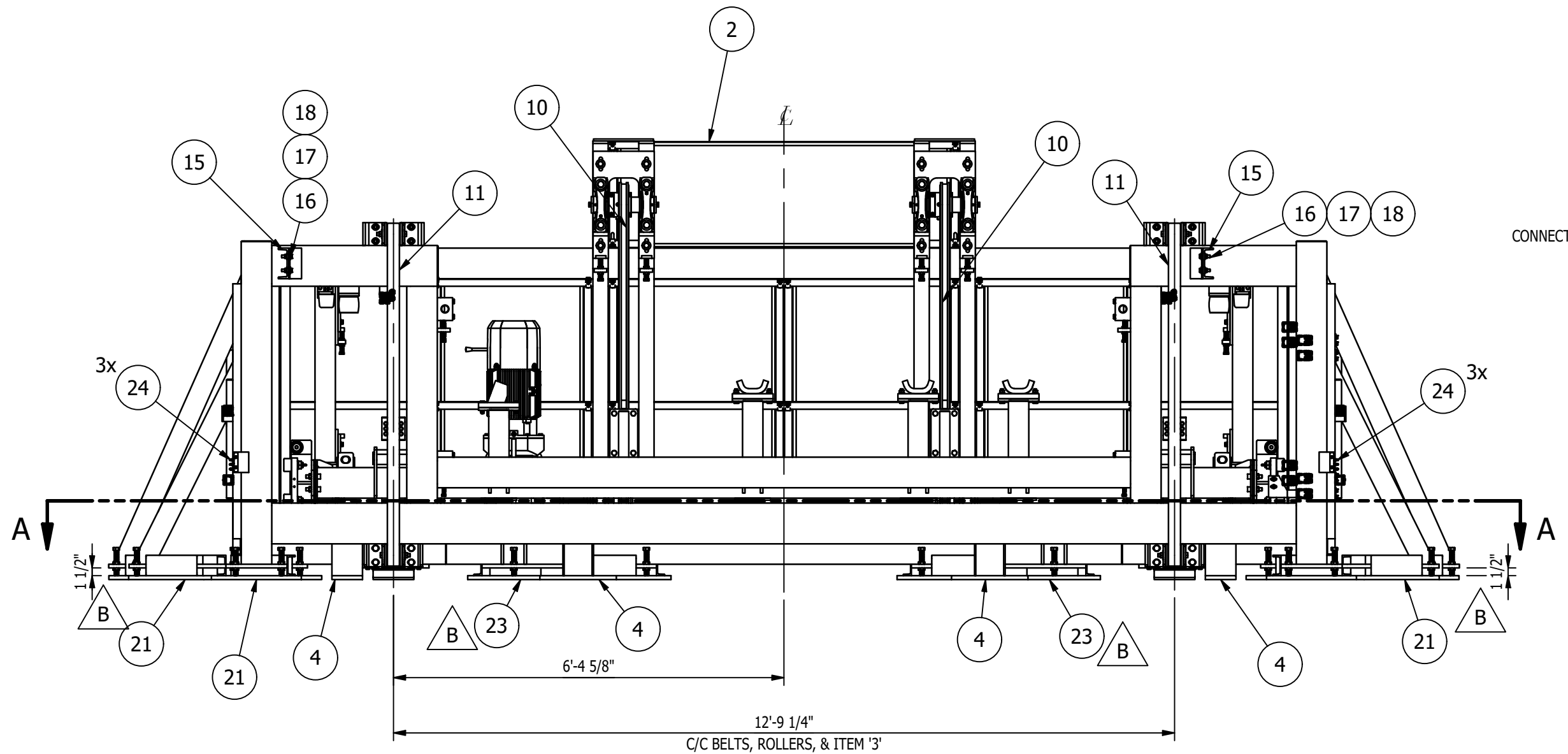
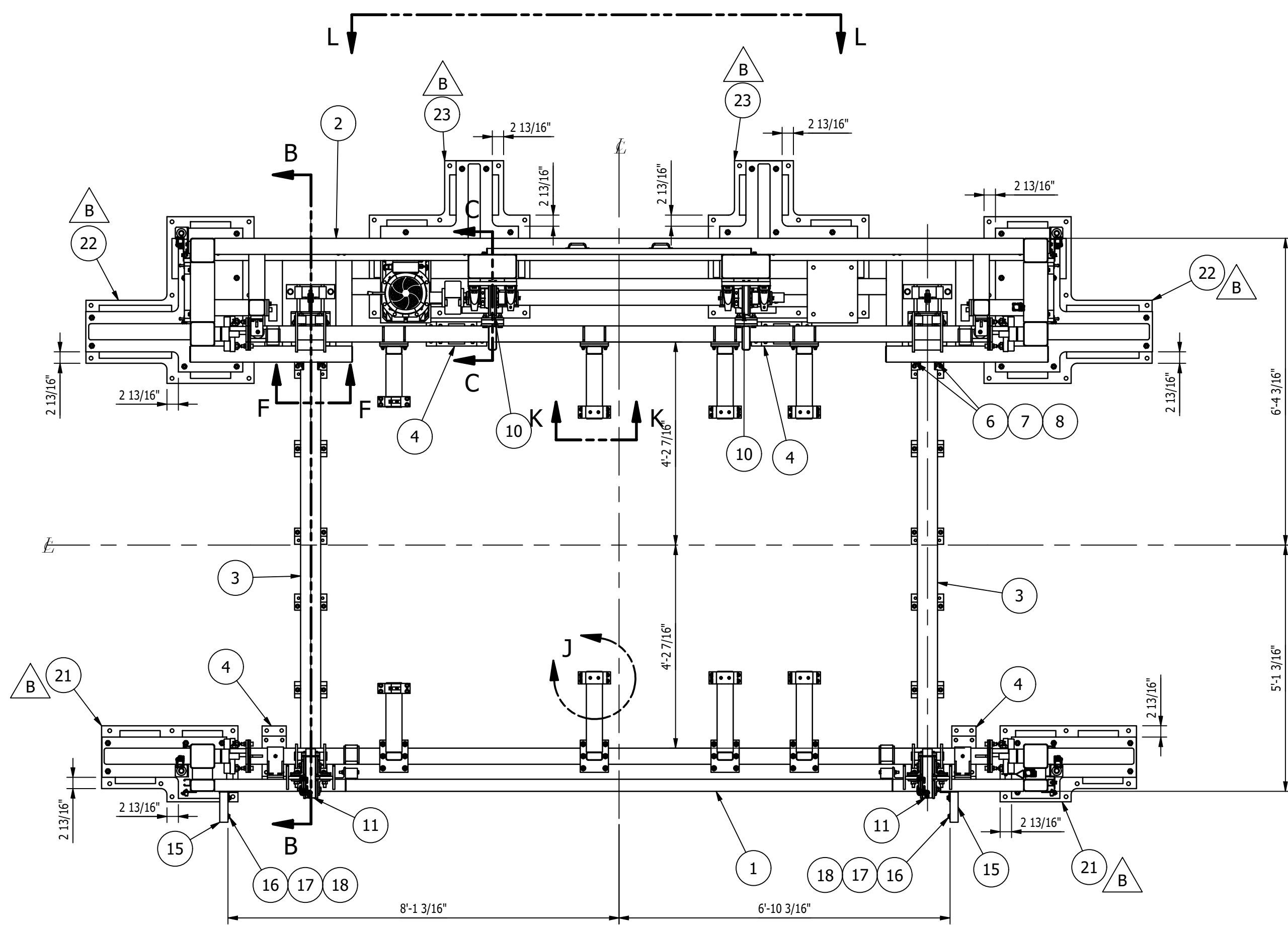
HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

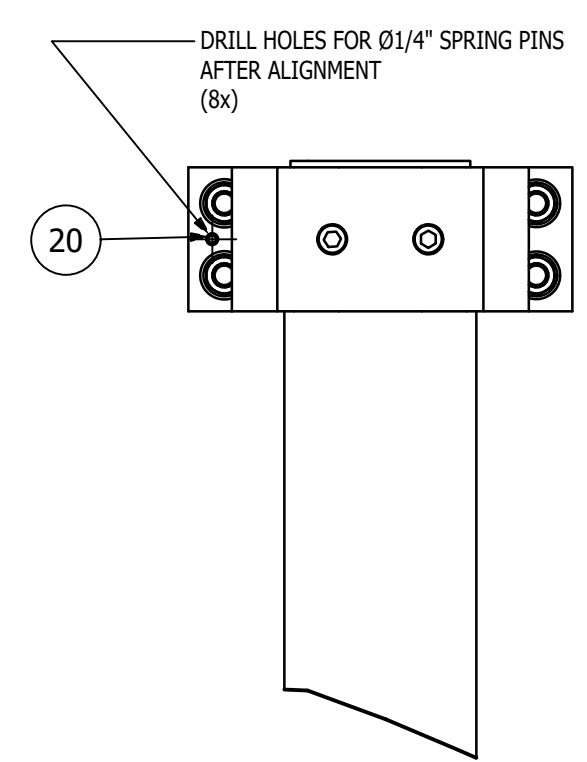
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

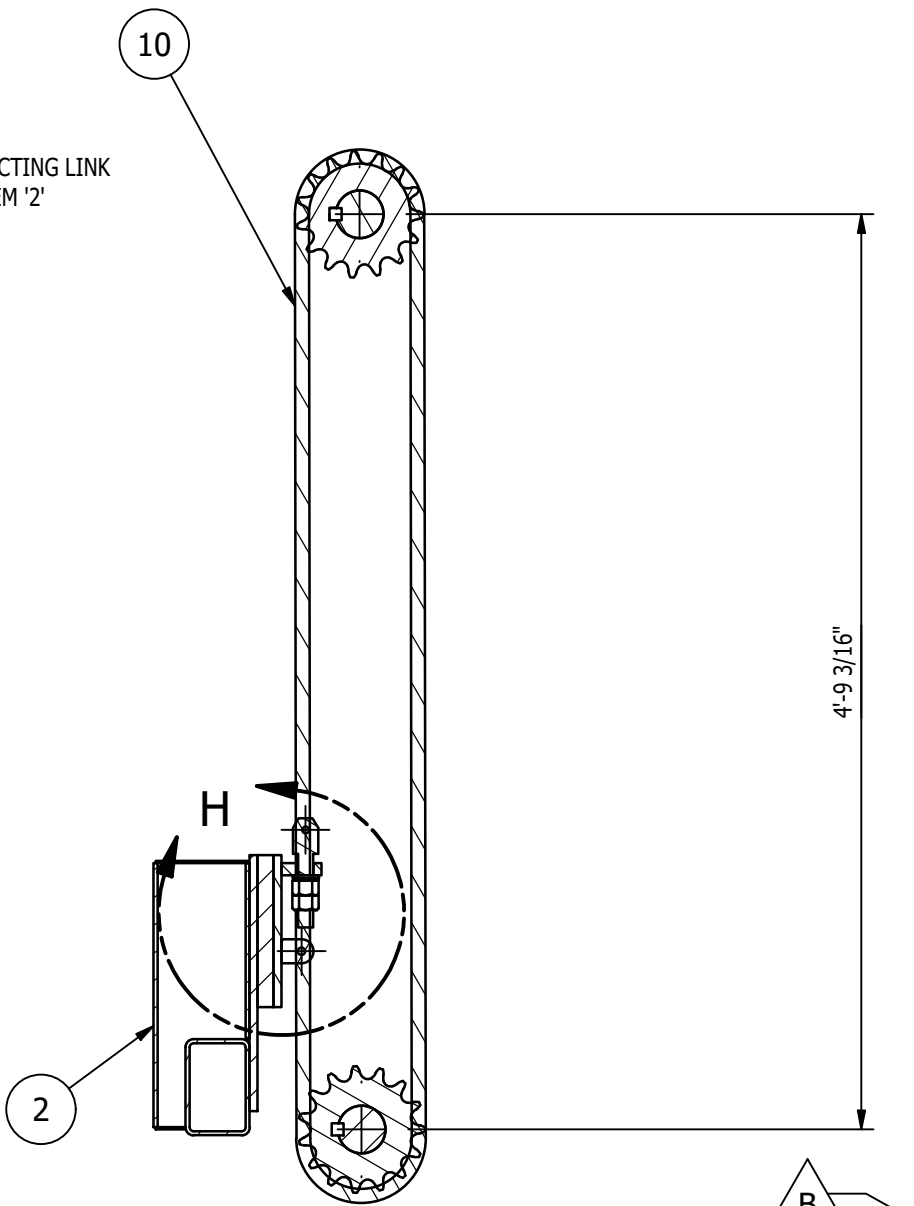
3:00p 11/28/22 New Job Drawing/Issue/22-11-28 New Lift Reqs/DWG/1875D415 - REV B.dwg



ENLARGED VIEW 'H'
SCALE 1" = 6"



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



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D470A			
2	1	MK-D471A ~ AUX LIFT DRIVER SIDE ASSEMBLY			
3	2	MK-D472A ~ AUX LIFT PASSENGER SIDE ASSEMBLY			
4	4	MK-D485A ~ BELT GUARD			
5	4	MK-D490A ~ CARRIAGE BUMPER STOP			
6	2	MK-D473B ~ BELT CLAMP			
7	8	3/8 TYPE B REGULAR FLAT WASHER			
8	8	3/8 SPRING LOCK WASHER			
9	8	3/8-16UNC x 3/4" LG. HEX HEAD CAP SCREW			
10	2	MK-D473A ~ BELT CLAMP			
11	2	TSUBAKI LAMBDA LUBE FREE RC-120 COTTER CHAIN 87 LINKS, 130.5" LENGTH		28.6	
12	2	CONTI POLYFLAT XHP BELT, 60mm WIDE x 8 METERS LONG		28-8	
13	22	C 4 x 5.4 (SHIP LOOSE)	10"		
14	4	C 4 x 5.4 (SHIP LOOSE)	1'-6"		
15	4	C 4 x 5.4 (SHIP LOOSE)	5 1/2"		
16	2	C 6 x 10.5 (SHIP LOOSE)	7 1/2"		
17	8	1/2-13UNC STOVER LOCK NUT (SHIP LOOSE)			
18	16	1/2 TYPE B REGULAR FLAT WASHER (SHIP LOOSE)			
19	8	1/2-13UNC x 1 1/2" LG. HEX HEAD CAP SCREW (SHIP LOOSE)			
20	4	1/4 x 1 LG. SLOTTED SPRING PIN			
21	8	1/4 x 1 1/2 LG. SLOTTED SPRING PIN			
22	2	MK-D481A ~ BASE PLATE			
23	2	MK-D481B ~ BASE PLATE			
24	2	MK-D481C ~ BASE PLATE			
	14	30 DEGREE ELBOW GREASE FITTING, 1/8 NPTF MALE THREAD		28-13	

- 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 ON ITEMS '12', '13', '14', & '15' ONLY
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

NOTE: TORQUE BELT CLAMP BOLTS TO 23 FT.LBS

SHEET 1 OF 2

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED ITEMS '21' THRU '24' FROM MK-D471A & MK-D472A, ADDED DIMENSIONS, ADDED VIEW 'L-L'	
A	MC	11/15/22	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>

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

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D470 - REV B

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

GENERAL NOTES:

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

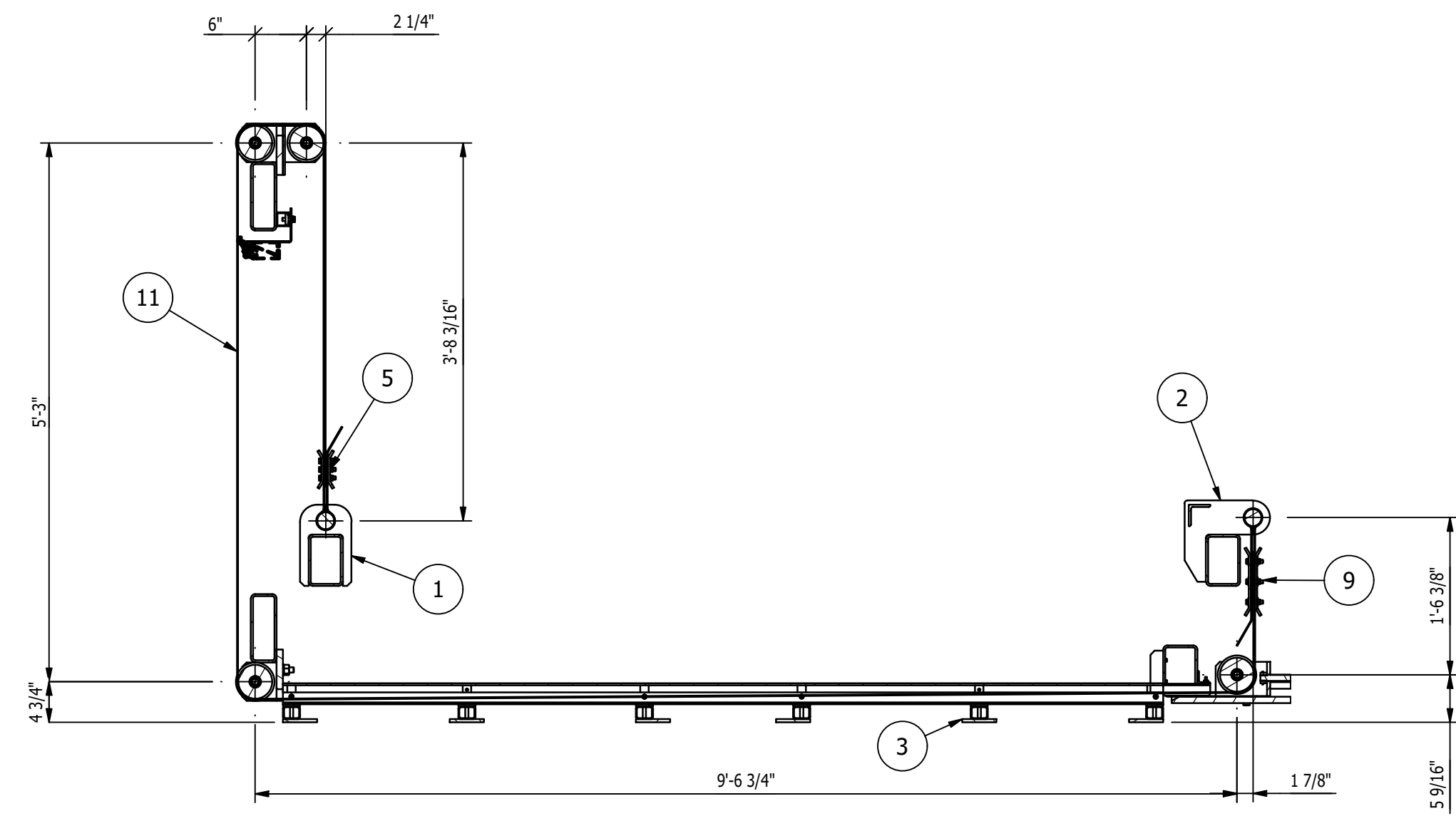
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

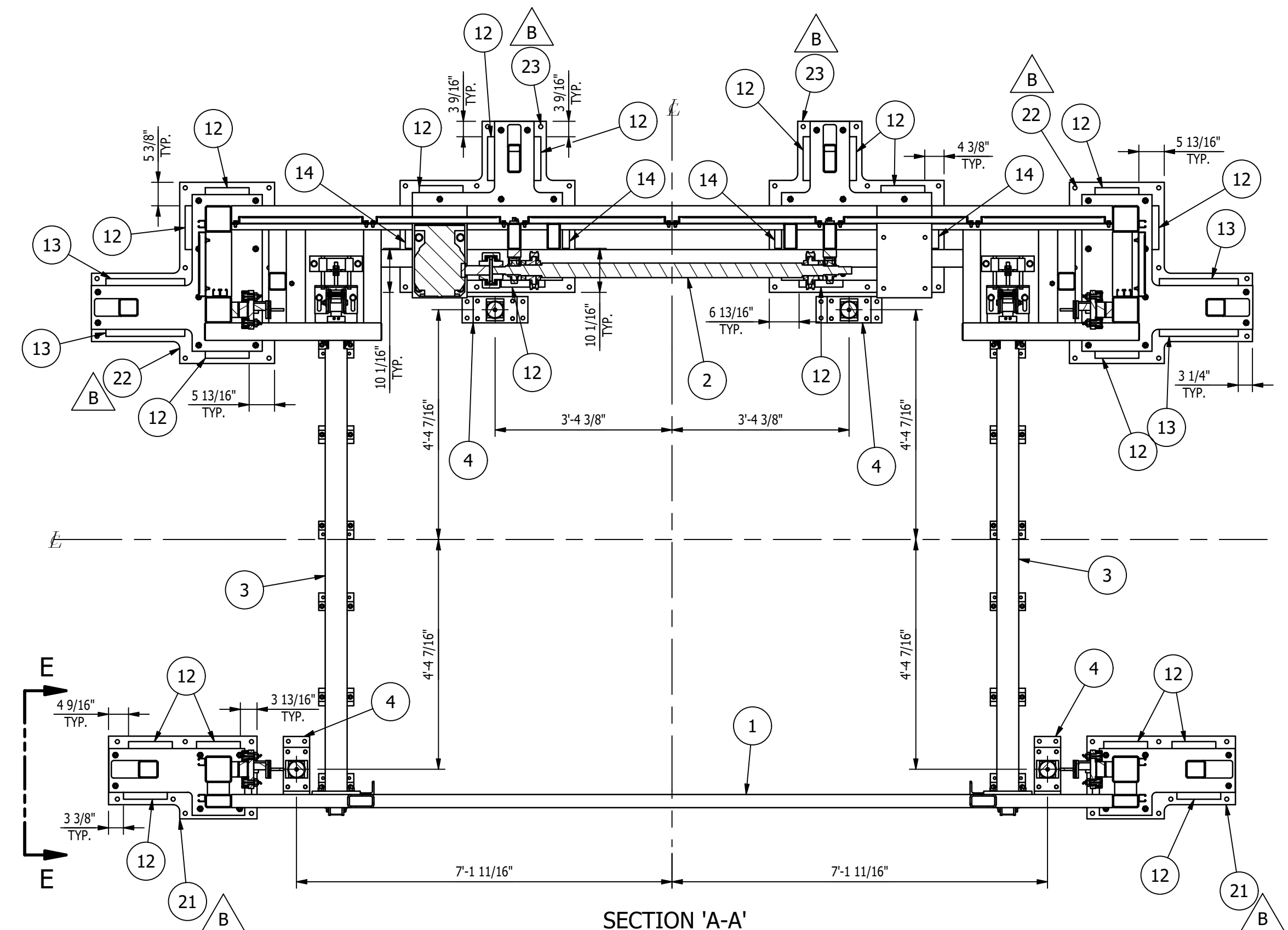
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

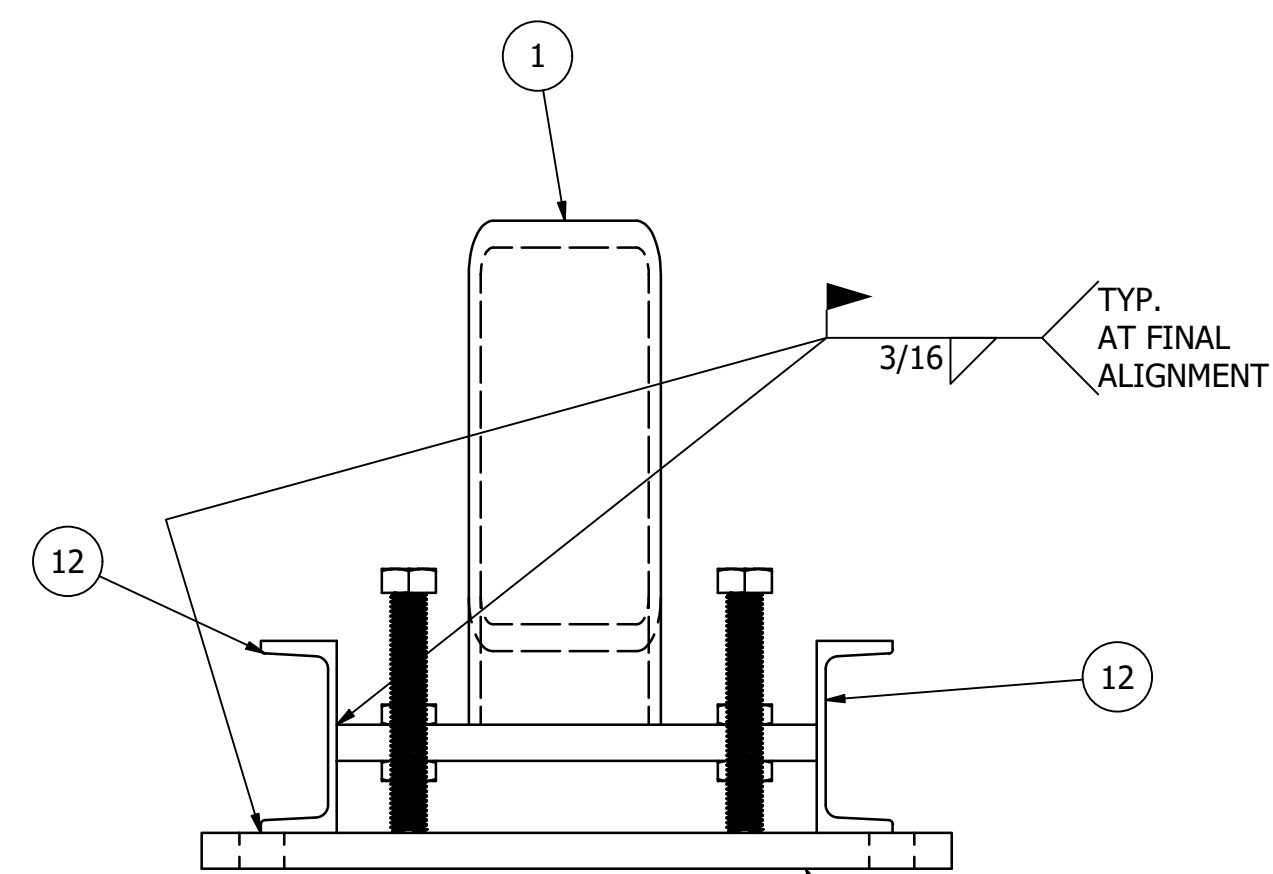
J:\2022\1875D470\1875D470.dwg (11/28/22) 11:28 AM LIT: Revs:DWG:1875D470 - REV B.dwg



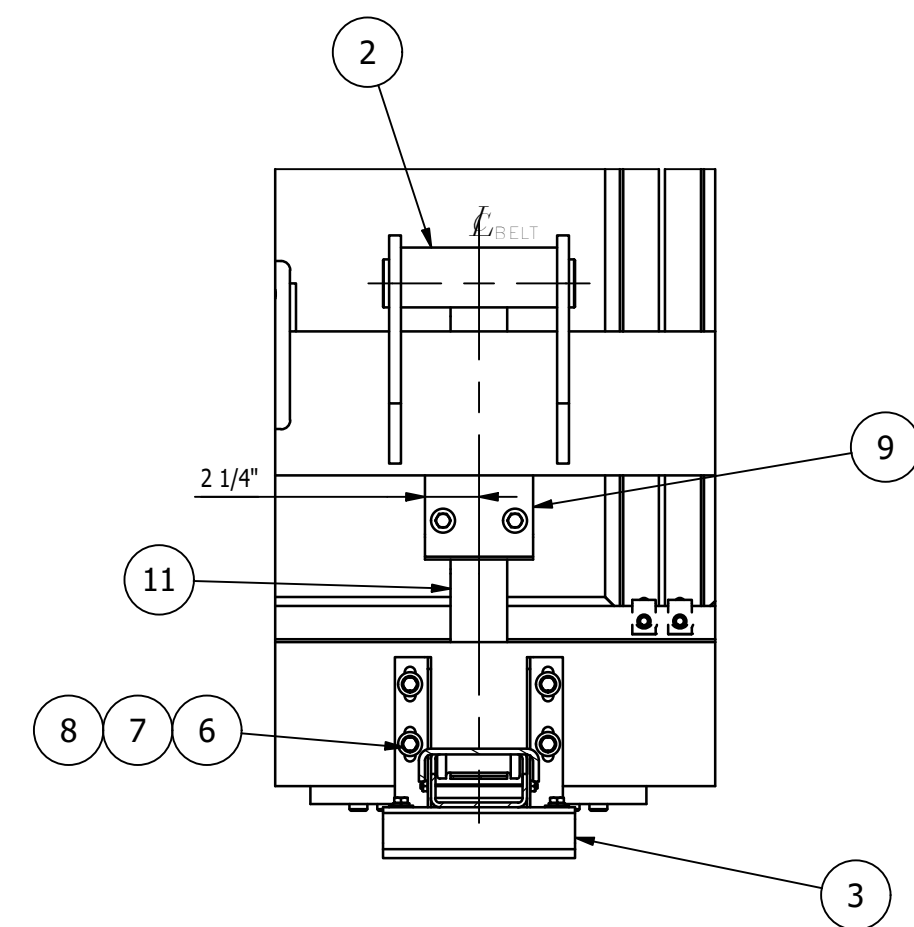
SECTION 'B-B'
SCALE 3/4"=1'-0"



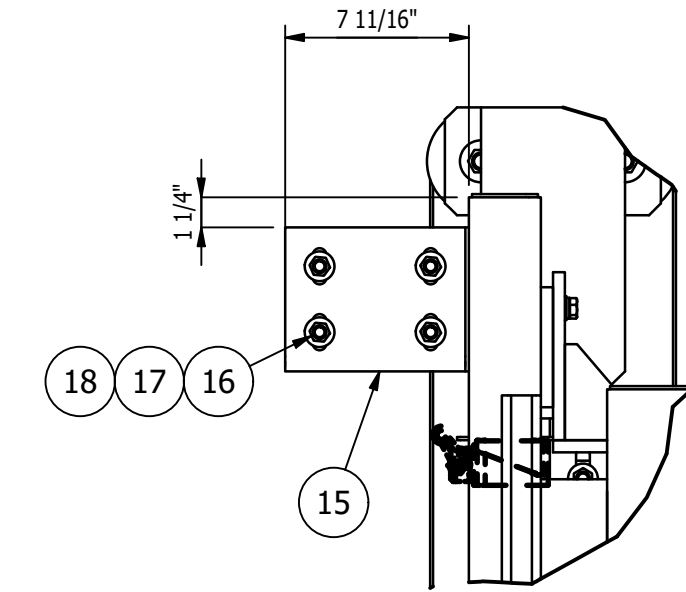
SECTION 'A-A'
SCALE 1/2"=1'-0"



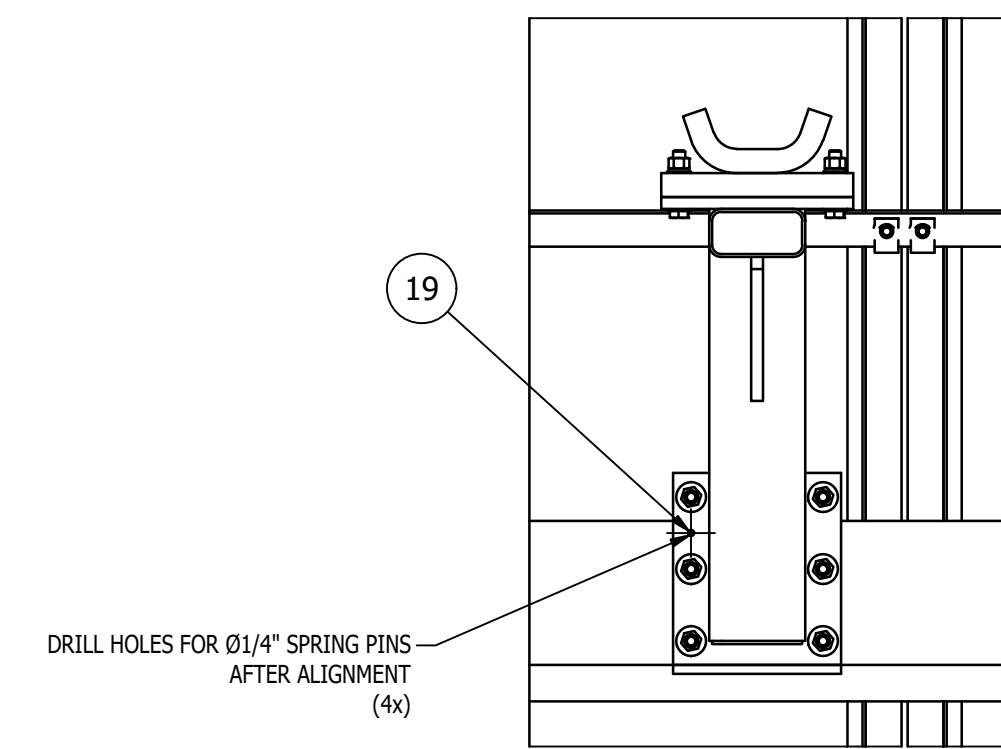
VIEW 'E-E'
SCALE 3"=1'-0"



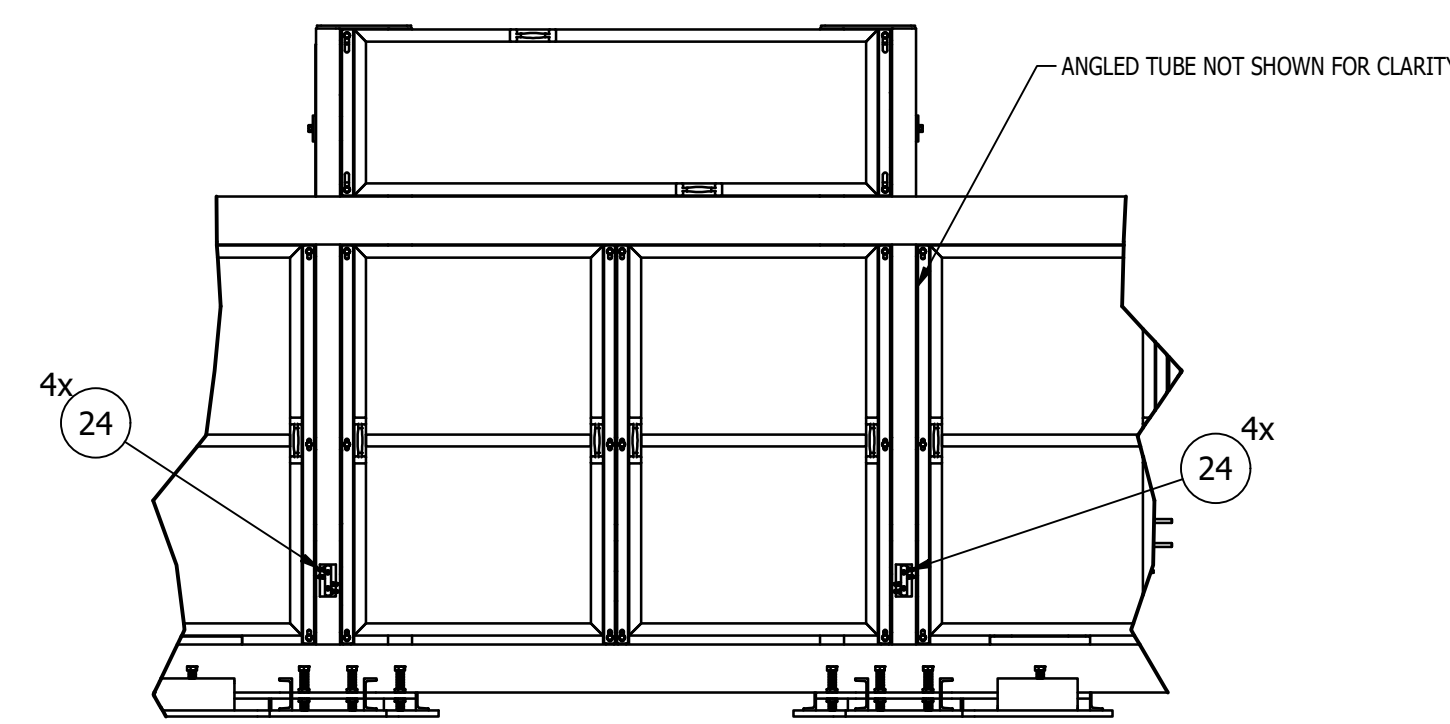
SECTION 'F-F'
SCALE 1 1/2"=1'-0"



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



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



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

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED ITEMS '21' THRU '24' FROM MK-D471A & MK-D472A, ADDED DIMENSIONS, ADDED VIEW 'L-L'	
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY

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

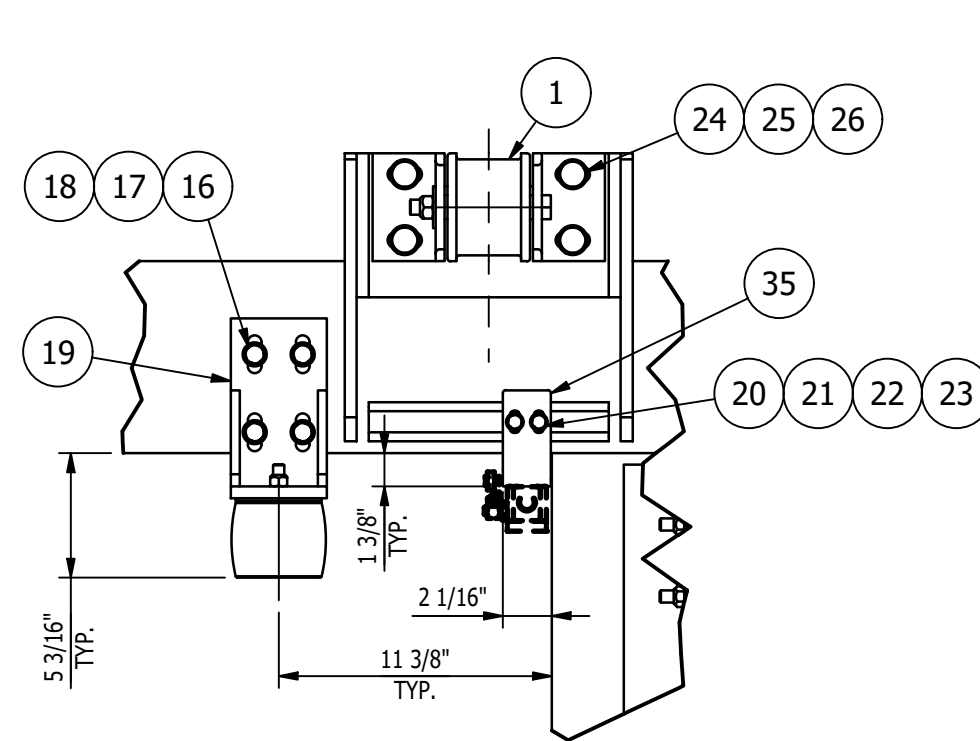
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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D470	DWG DATE:	11/8/22
REV:	B	JOB No:	22096

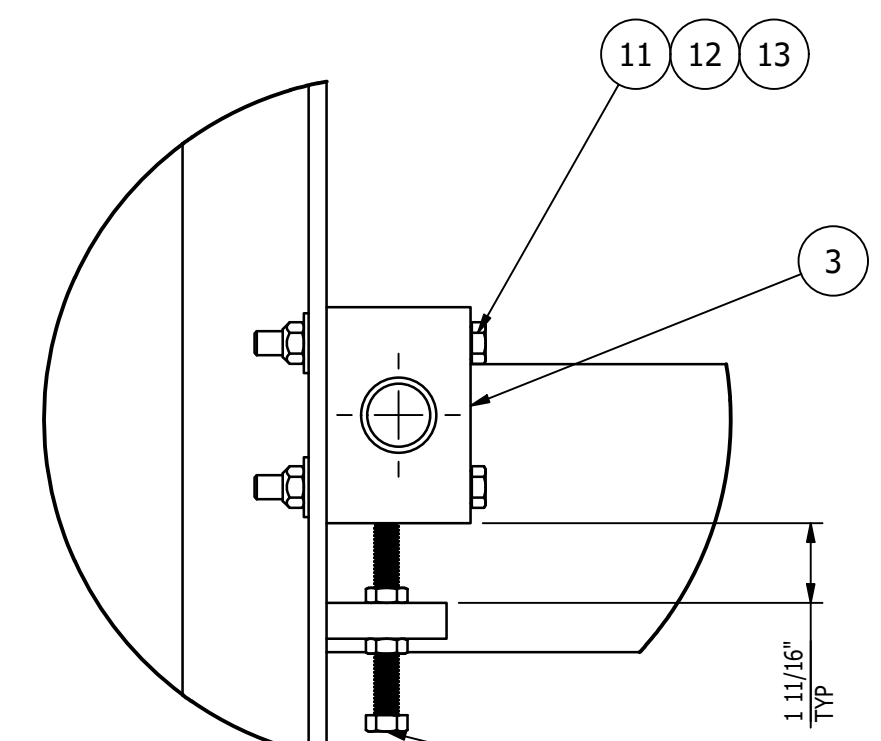
MAGNUM Consulting
41700 Gardenbrook Rd.
Suite 125
Novi, MI 48375
Phone: (248) 773-8855
Fax: (248) 773-8951
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D470 - REV B

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

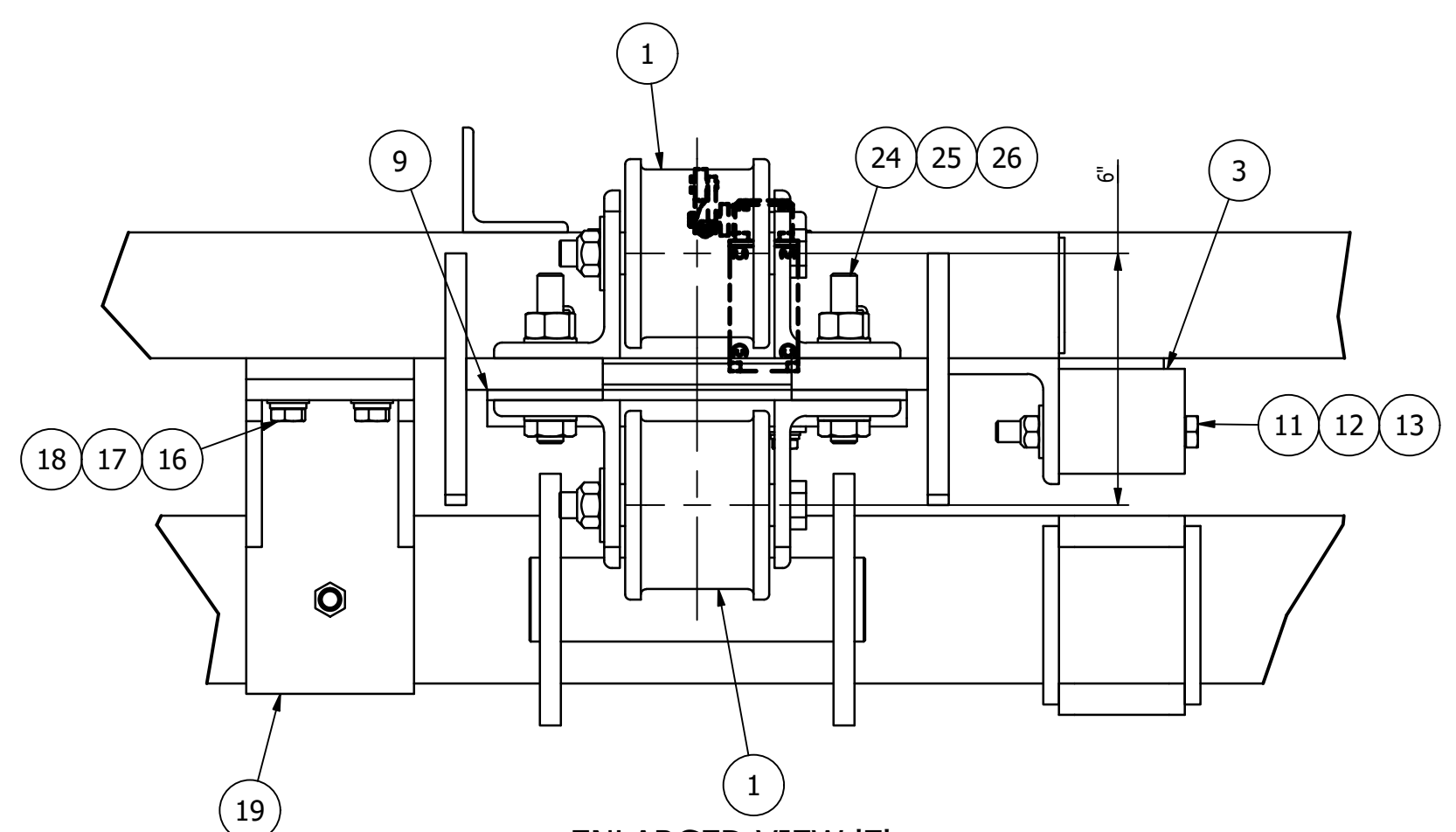
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4"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



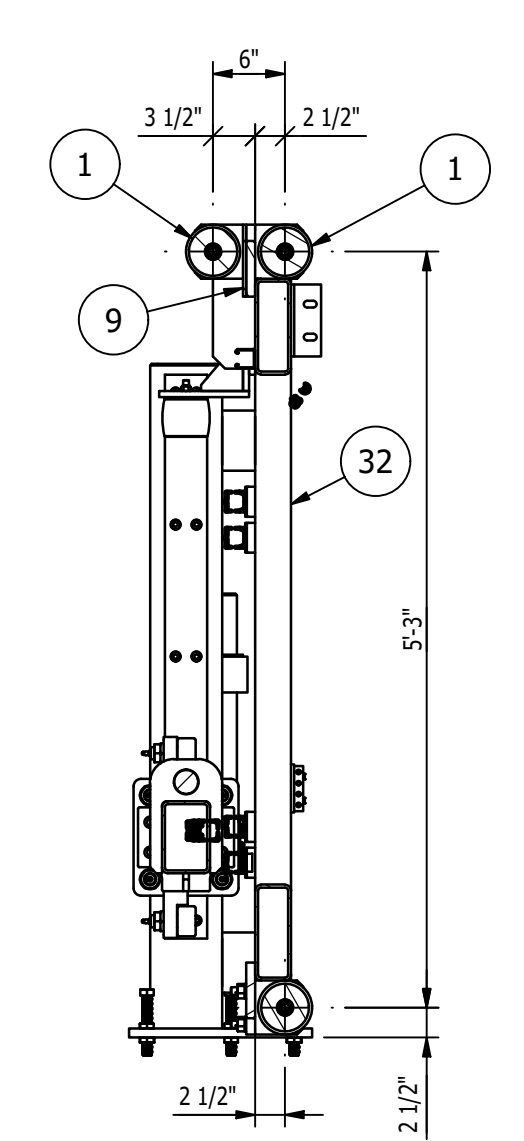
ENLARGED VIEW 'C'
SCALE 1 1/2" = 1'-0"



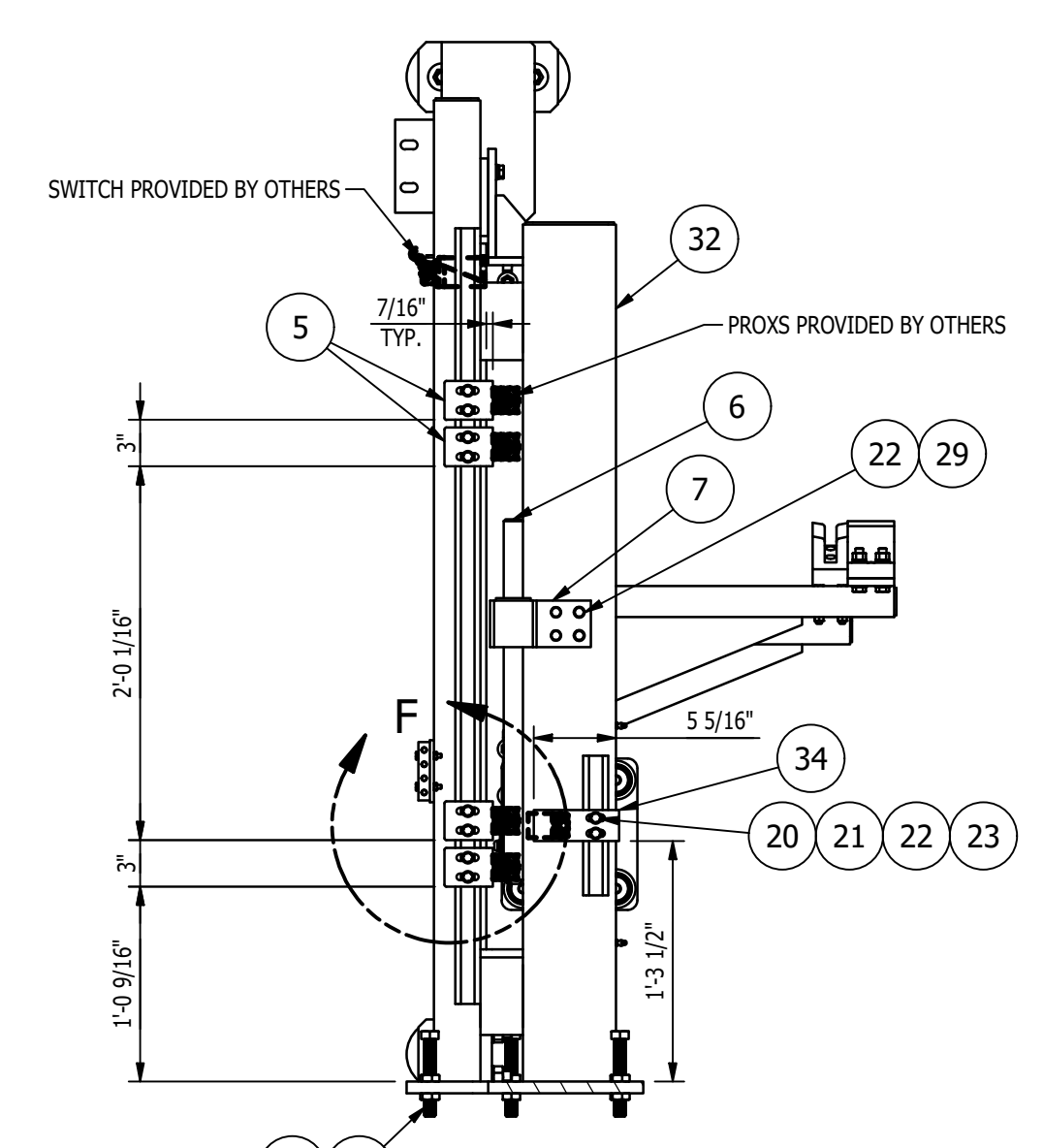
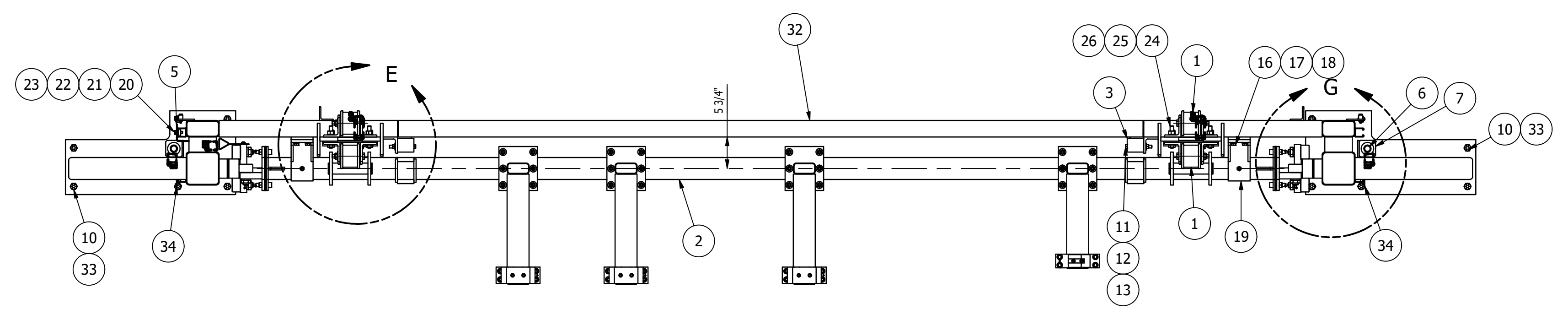
ENLARGED VIEW 'B'
SCALE 3" = 1'-0"



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

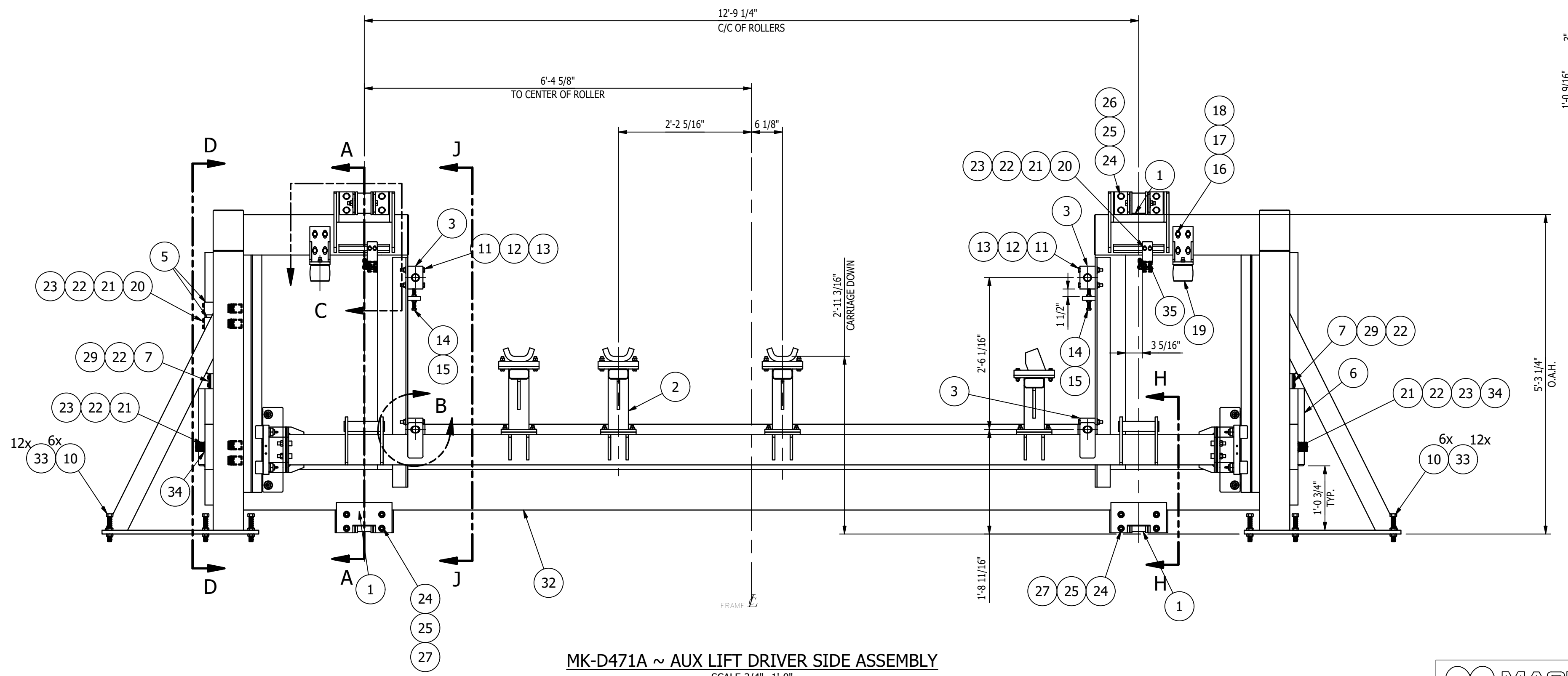


SECTION 'A-A'
SCALE 3/4" = 1'-0"



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

NOTE:
SIDE SUPPORT TUBE NOT SHOWN FOR CLARITY



MK-D471A ~ AUX LIFT DRIVER SIDE ASSEMBLY
SCALE 3/4" = 1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	6	MK-D471A ~ DRIVER SIDE BELT ROLLER ASSEMBLY			
2	1	MK-D476A ~ DRIVER SIDE CARRIAGE ASSEMBLY			
3	4	MK-D483E ~ PIN HOLDER			
5	4	MK-D489B ~ PROX BRACKET			
6	2	MK-D435D ~ LOCKOUT PIN			
7	2	MK-D483B ~ PIN HOLDER			
8	2	SAE GREASE FITTING JUNCTION BLOCK FOR 1/8" NPTF, 4 INLETS, 3 3/4" LG, SAE-14563		26-3	
9	2	MK-D483G ~ SPACER			
10	12	3/4-10UNC x 5 LG. HEX HEAD BOLT" (FULLY THREADED)			
11	8	1/2 TYPE B REGULAR FLAT WASHER			
12	8	1/2-13UNC STOVER LOCK NUT			
13	8	1/2-13UNC x 4 1/2" LG. HEX HEAD CAP SCREW			
14	8	1/2-13UNC HEX JAM NUT			
15	4	1/2-13UNC x 4 LG. HEX HEAD BOLT" (FULLY THREADED)			
16	8	1/2 TYPE B NARROW FLAT WASHER			
17	8	1/2 SPRING LOCK WASHER			
18	8	1/2-13UNC x 1" LG. HEX HEAD CAP SCREW			
19	2	MK-D490C ~ CARRIAGE BUMPER STOP			
20	16	UNISTRUT CHANNEL NUT P3008 PL, 3/8-16UNC THREAD			
21	16	3/8 TYPE B NARROW FLAT WASHER			
22	24	3/8 SPRING LOCK WASHER			
23	16	3/8-16UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
24	32	5/8 TYPE B NARROW FLAT WASHER			
25	16	5/8-11UNC ANCO LOCK NUT A194 GR. 2H			
26	8	5/8-11UNC x 3 1/2" LG. A325 HEX HEAD BOLT			
27	8	5/8-11UNC x 2 1/2" LG. A325 HEX HEAD BOLT			
29	8	3/8-16UNC x 3/4" LG. HEX HEAD CAP SCREW			
30	4	1/4-20UNC x 1 1/2" LG. HEX HEAD CAP SCREW			
31	4	1/4-20UNC STOVER LOCK NUT			
32	1	MK-D486A ~ AUX LIFT DRIVER SIDE FRAME MACHINING			
33	24	3/4-10UNC HEX JAM NUT			
34	2	MK-D489E ~ PROX BRACKET			
35	2	MK-D489F ~ PROX BRACKET			

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

SHEET 1 OF 2

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	REMOVED BASE PLATES & GREASE FITTINGS AND MOVED THEM TO DIFFERENT DRAWINGS	
A	MC	11/15/22	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.	1875D471	DWG DATE:	11/8/22
REV:	B	JOB No:	22096

MAGNUM Consulting
41700 QuakerRoad Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8889
Fax: (248) 772-8851
Web: www.mmagnum.com

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

GENERAL NOTES:

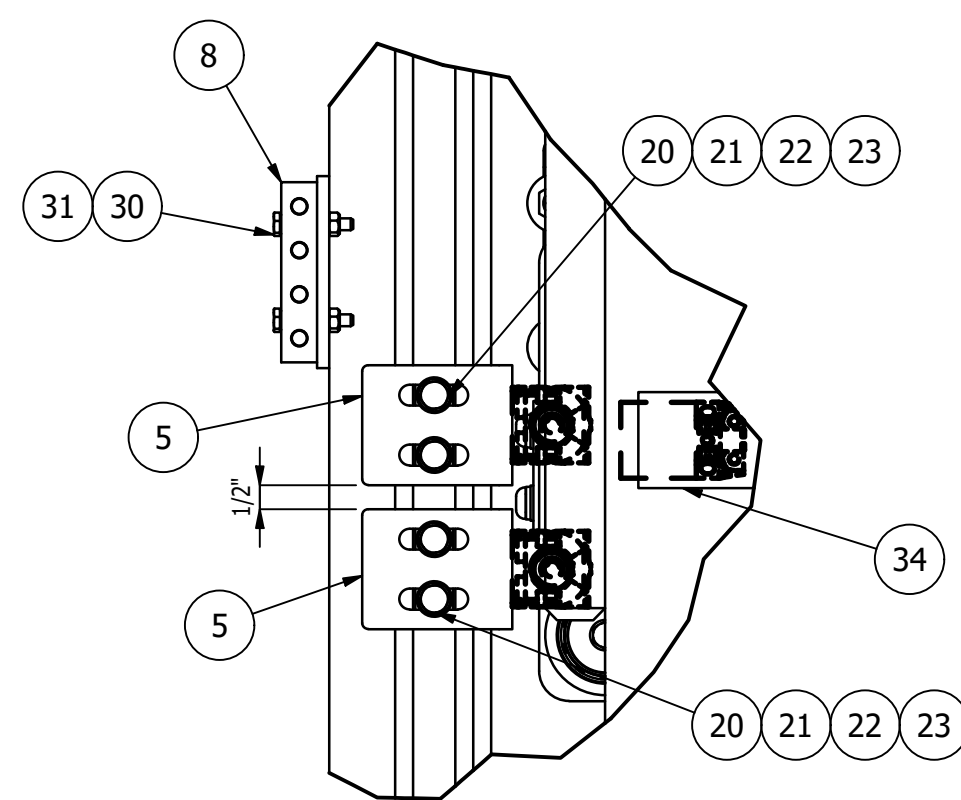
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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

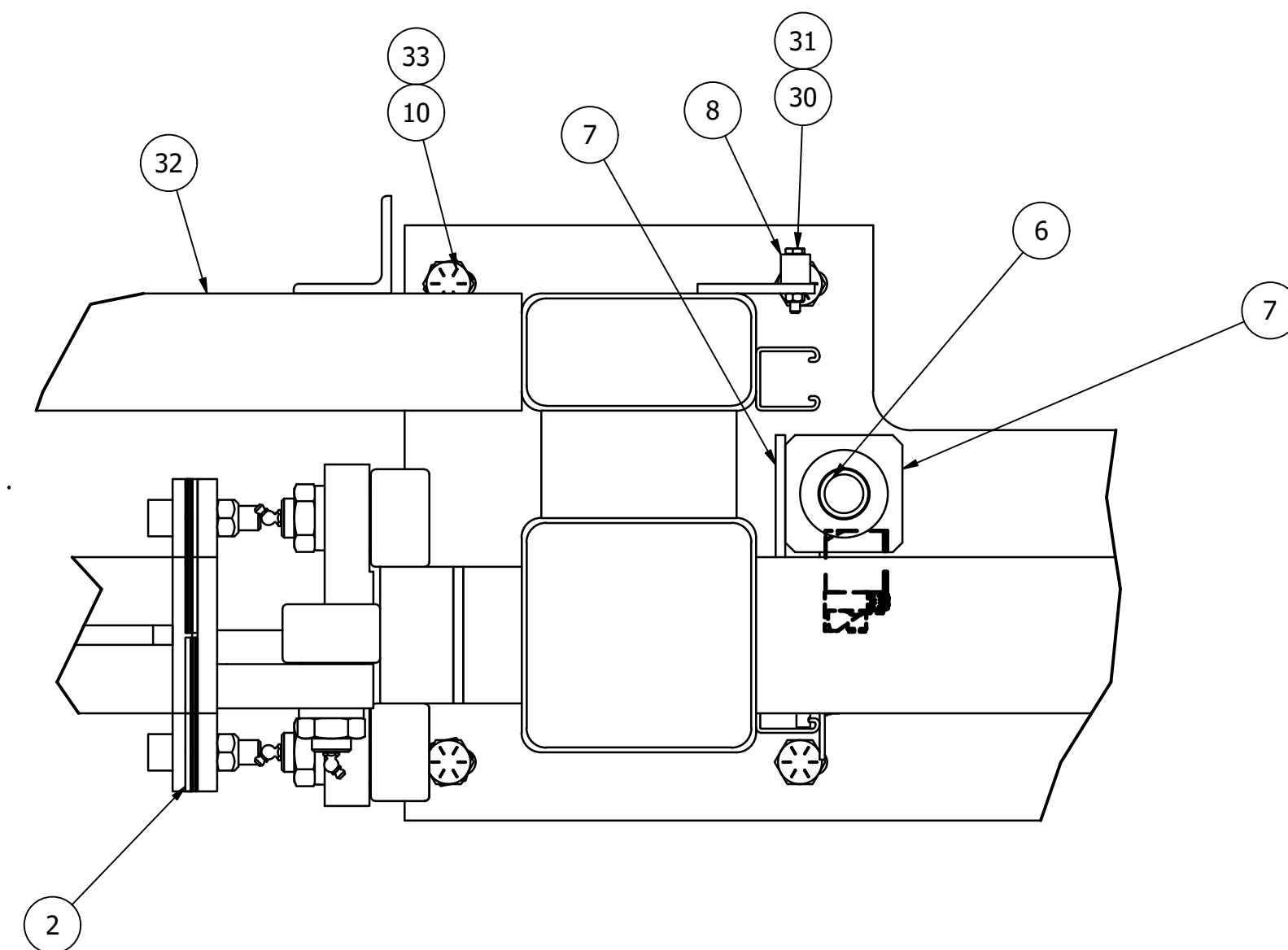
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

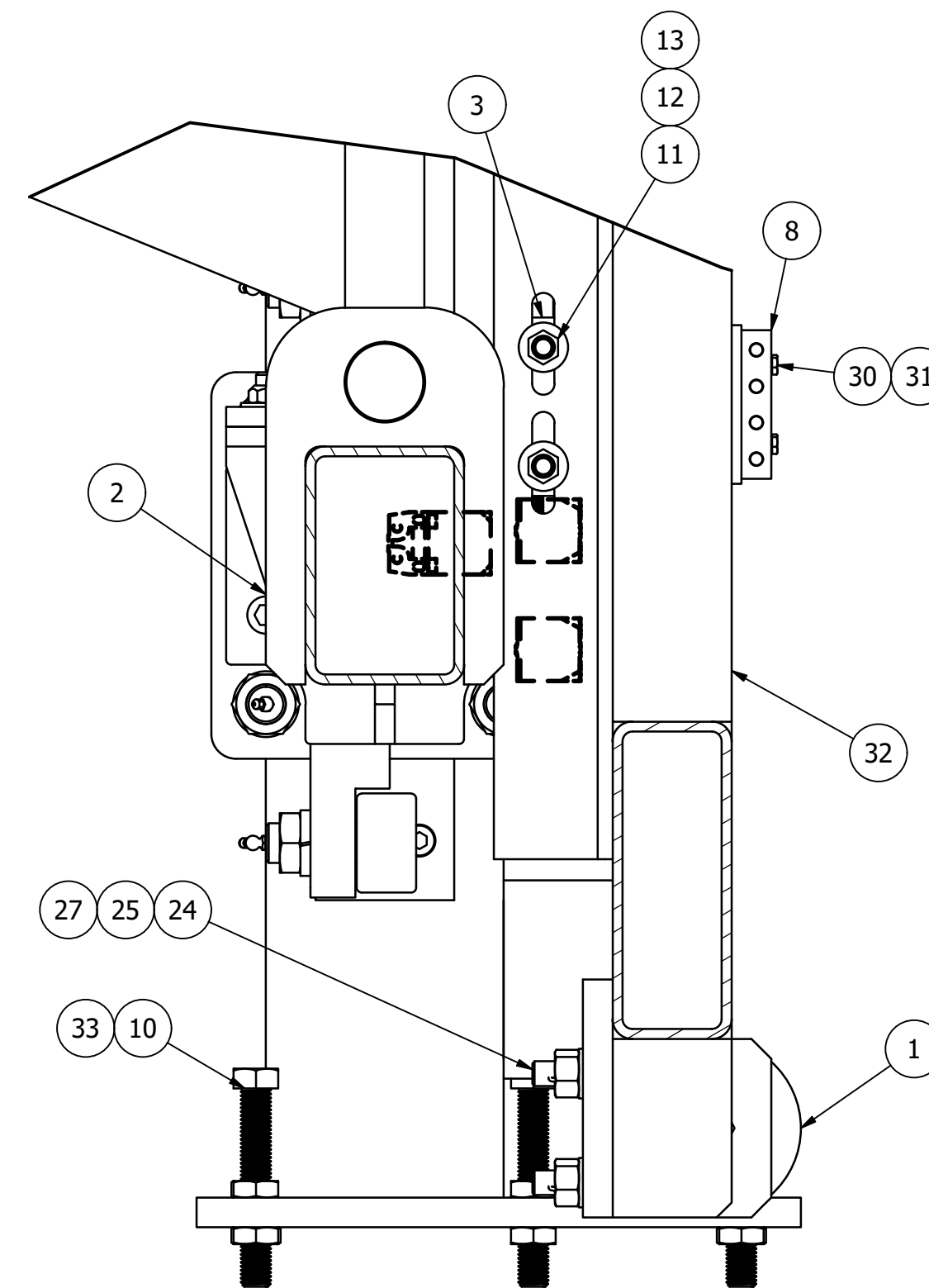
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



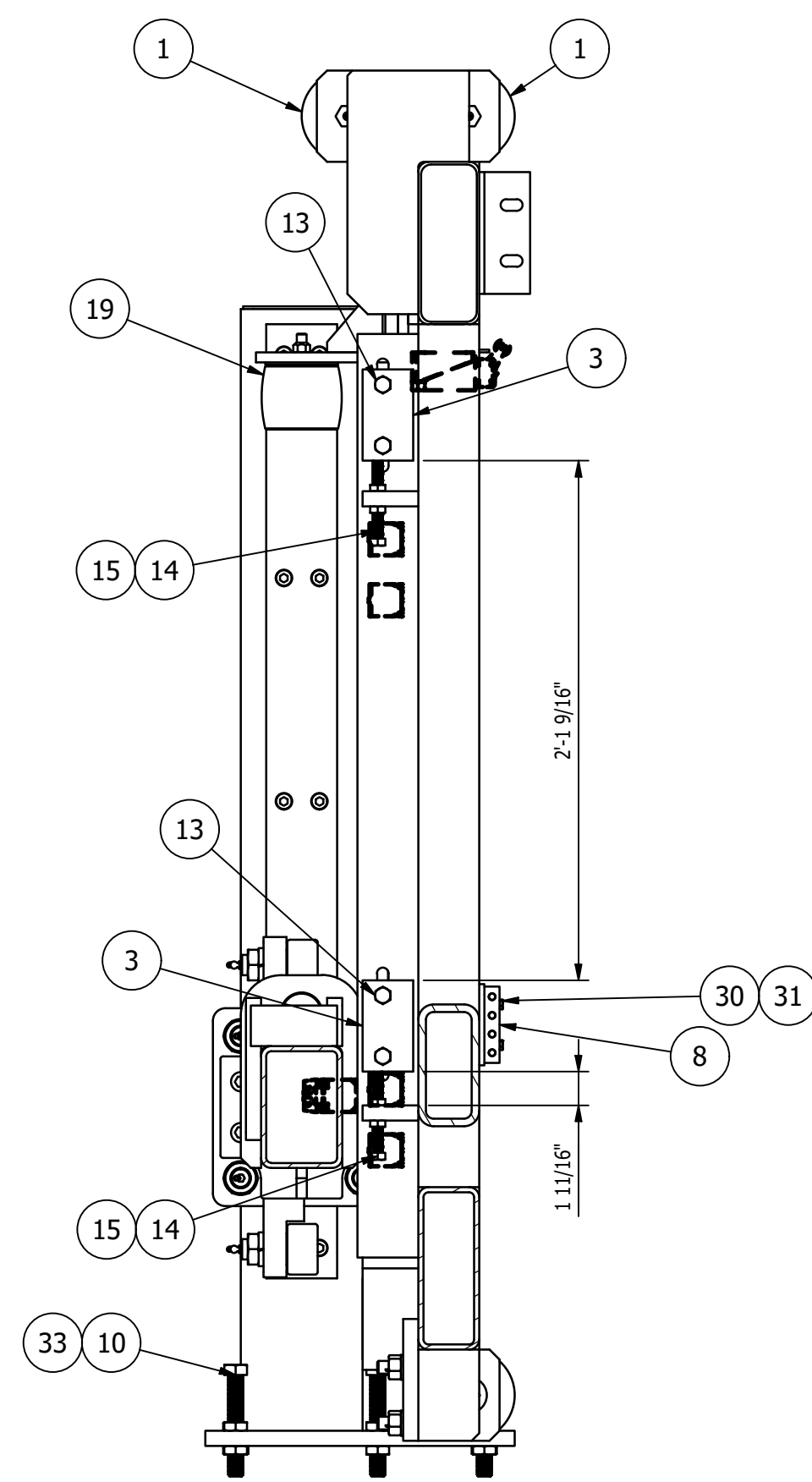
ENLARGED VIEW 'F'
SCALE 3"=1'-0"



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



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



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

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	REMOVED BASE PLATES & GREASE FITTINGS AND MOVED THEM TO DIFFERENT DRAWINGS	
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY

MAGNUM Consulting
 41700 Gardenbrook Rd. Phone: (248) 773-8555
 Suite 129 Fax: (248) 773-8551
 Novi, MI 48375 Web: www.4magnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D471 - REV B

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

GENERAL NOTES:

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

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

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

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

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

mi 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

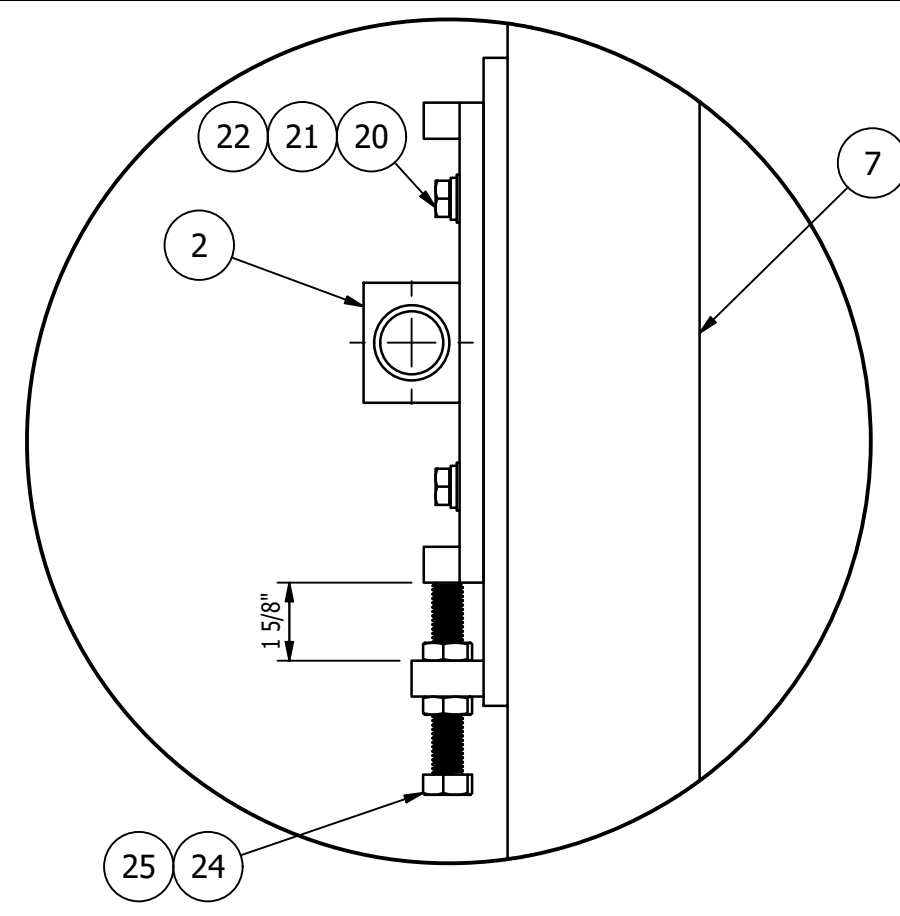
CLIENT: VOLVO

DRAWING No. 1875D471

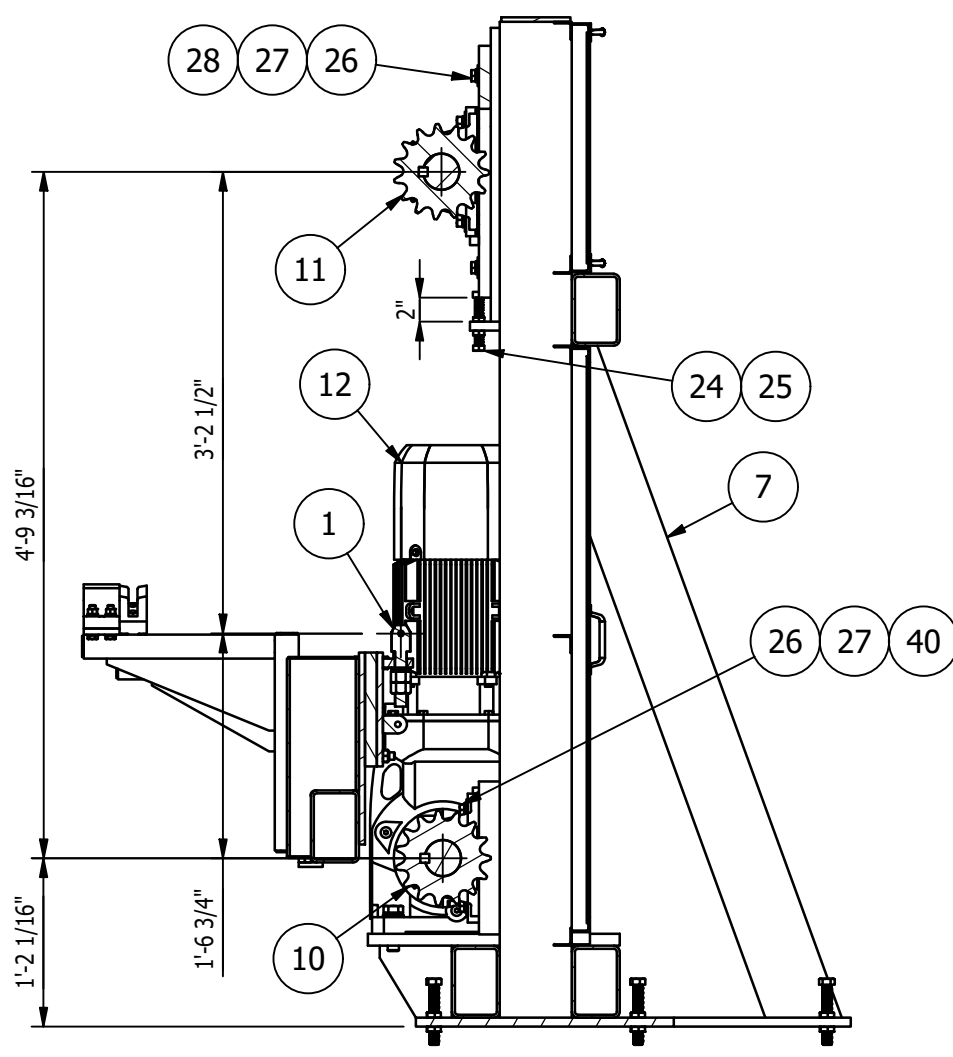
REV: B

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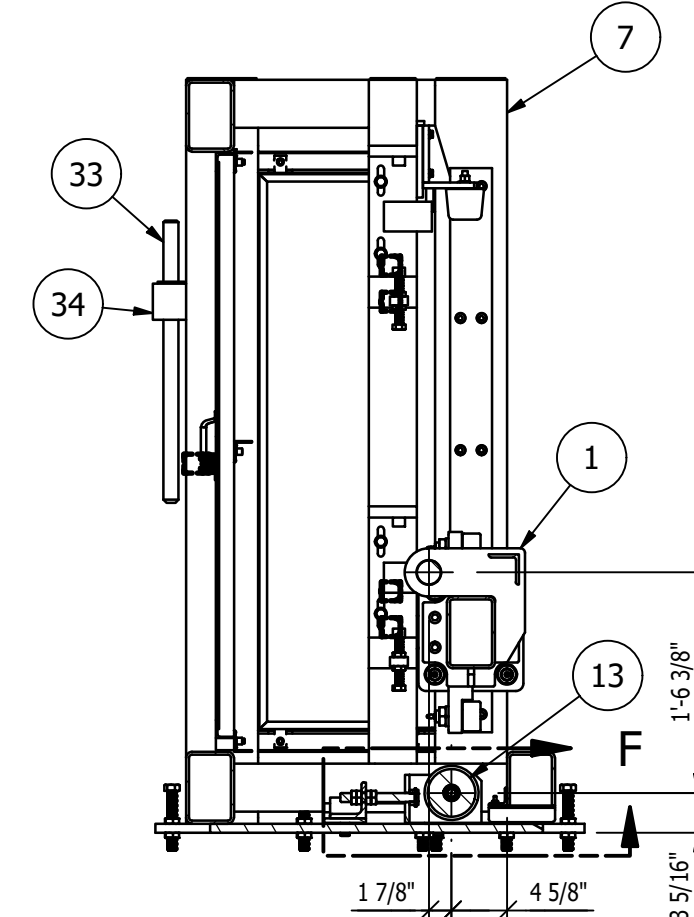
DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 11/8/22
JOB No: 22096



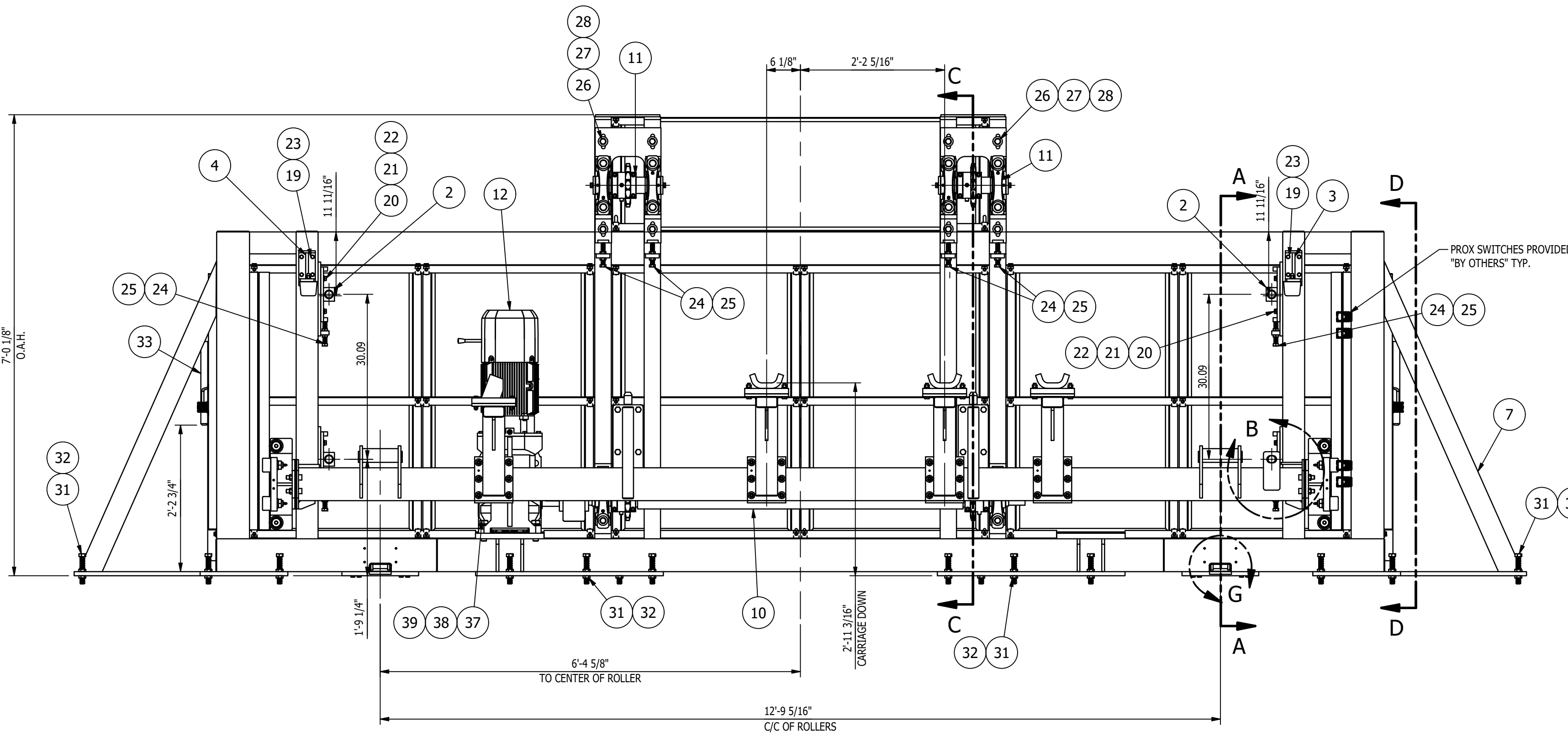
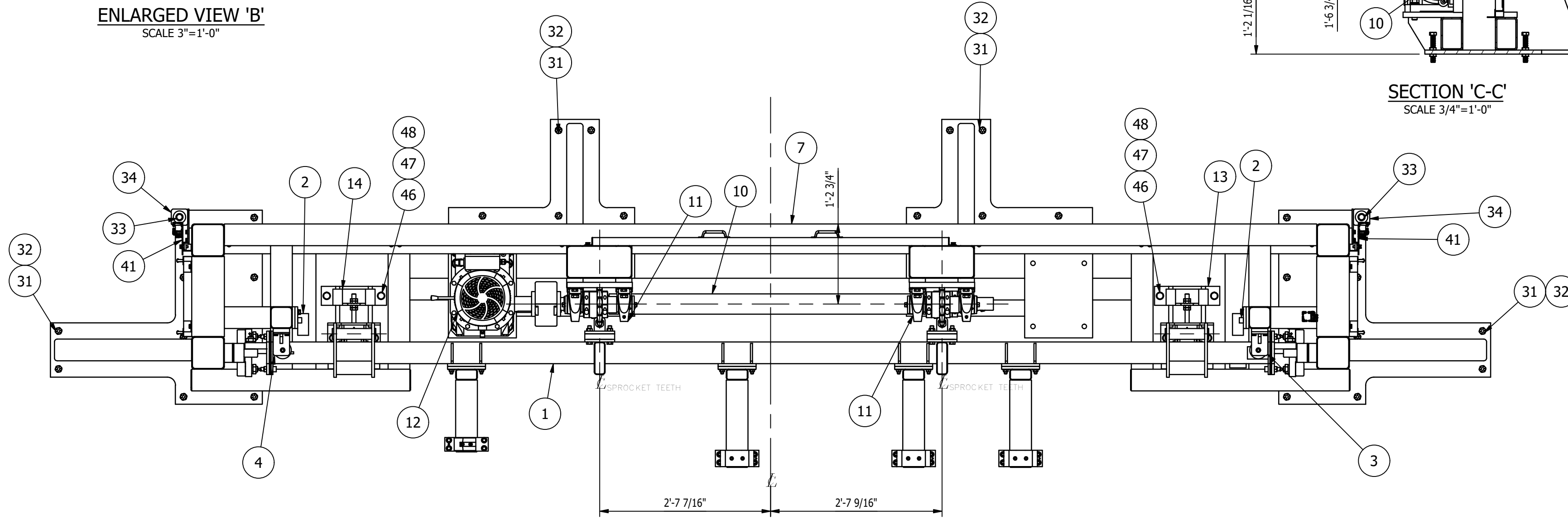
ENLARGED VIEW 'B'
SCALE 3/4"=1'-0"



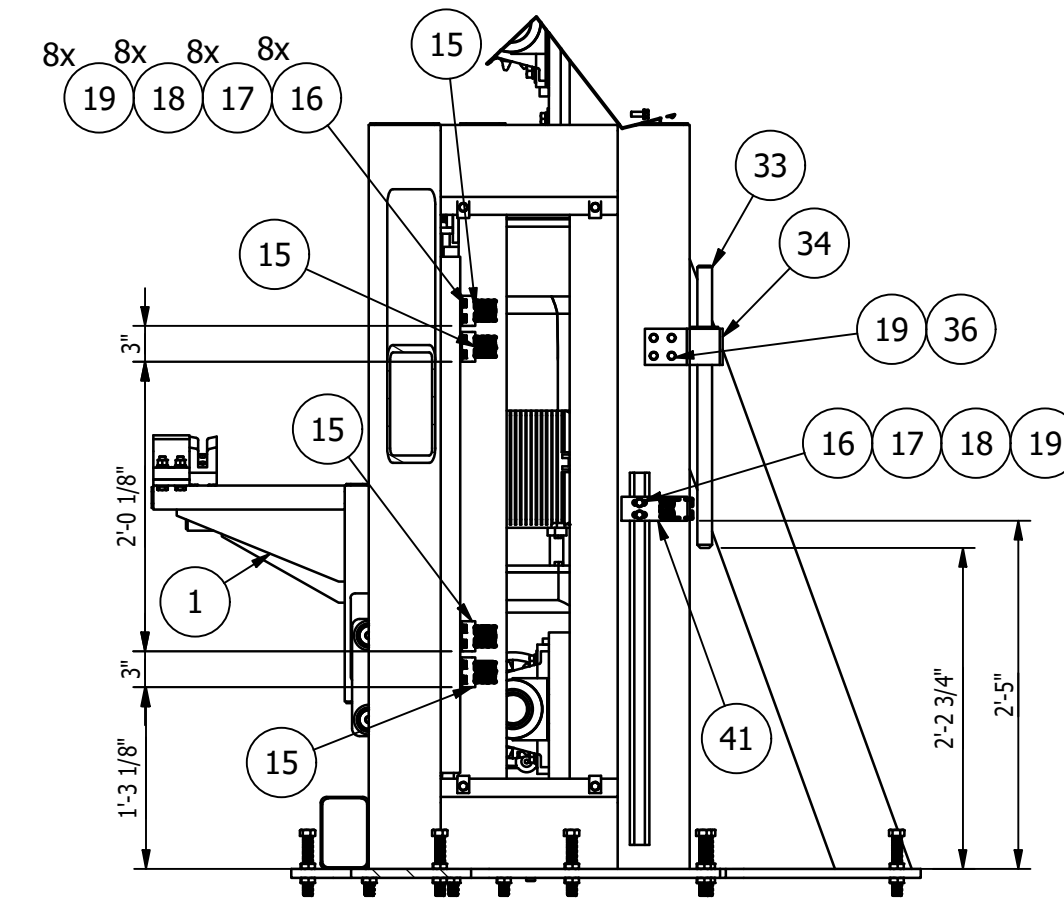
SECTION 'C-C'
SCALE 3/4"=1'-0"



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



MK-D472A ~ AUX LIFT PASSENGER SIDE ASSEMBLY
SCALE 3/4"=1'-0"



SECTION 'D-D'
SCALE 3/4"=1'-0"
D480A NOT SHOWN FOR CLARITY

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D472A			
1	1	MK-D478A ~ PASSENGER SIDE CARRIAGE ASSEMBLY			
2	4	MK-D483A ~ PIN GUIDE			
3	1	MK-D490E ~ CARRIAGE BUMPER STOP			
4	1	MK-D490H ~ CARRIAGE BUMPER STOP			
5	2	MK-D480A ~ AUX LIFT SCREEN GUARD			
6	1	MK-D480B ~ AUX LIFT SCREEN GUARD			
7	1	MK-D494A ~ AUX LIFT PASSENGER SIDE FRAME MACHINING			
8	4	MK-D480C ~ SCREEN GUARD			
9	2	MK-D480D ~ SCREEN GUARD			
10	1	MK-D492A ~ AUX LIFT SHAFT ASSEMBLY			
11	2	MK-D492B ~ IDLER SHAFT ASSY			
12	1	FT3 GEARMOTOR PER MOTOR DATA SHEET		1-9	
13	1	MK-D496A ~ BELT ROLLER - RH			
14	1	MK-D496D ~ BELT ROLLER - LH			
15	4	MK-D489C ~ PROX BRACKET			
16	12	UNISTRUT CHANNEL NUT P3008 PL, 3/8-16UNC THREAD			
17	12	3/8-16UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
18	12	3/8 TYPE B NARROW FLAT WASHER			
19	28	3/8 SPRING LOCK WASHER			
20	8	1/2 TYPE B NARROW FLAT WASHER			
21	8	1/2 SPRING LOCK WASHER			
22	8	1/2-13UNC x 1" LG. HEX HEAD CAP SCREW			
23	8	3/8-16UNC x 1" LG. HEX HEAD CAP SCREW			
24	8	5/8-11UNC x 4 LG. HEX HEAD BOLT" (FULLY THREADED)			
25	16	5/8-11UNC HEX JAM NUT			
26	12	5/8 TYPE B REGULAR FLAT WASHER			
27	12	5/8 SPRING LOCK WASHER			
28	8	5/8-11UNC x 2" LG. HEX HEAD CAP SCREW			
31	36	3/4-10UNC x 5 LG. HEX HEAD BOLT" (FULLY THREADED)			
32	72	3/4-10UNC HEX JAM NUT			
33	2	MK-D435D ~ LOCKOUT PIN			
34	2	MK-D483B ~ PIN HOLDER			
36	8	3/8-16UNC x 3/4" LG. HEX HEAD CAP SCREW			
37	4	M24x3 x 80mm LG. HEX CAP SCREW			
38	4	M24 SPRING LOCK WASHER			
39	4	M24 NARROW FLAT WASHER			
40	4	5/8-11UNC x 2 1/2" LG. HEX HEAD CAP SCREW			
41	2	MK-D489E ~ PROX BRACKET			
42	48	NO-SLIP CLIP-ON BARREL NUT-M10 X 1.5 MM ~ McMASTERCARR PART # 95210A240		3-4	
43	48	M10x1.5 x 30mm LG. HEX CAP SCREW			
44	48	M10 SPRING LOCK WASHER			
45	40	M10 NARROW FLAT WASHER			
46	8	3/4 TYPE B NARROW FLAT WASHER			
47	8	3/4 SPRING LOCK WASHER			
48	8	3/4-10UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
49	2	SAE GREASE FITTING JUNCTION BLOCK FOR 1/8" NPTF, 4 INLETS, 3 3/4" LG, SAE-14563		26-3	
50	4	1/4-20UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
52	2	MK-D495A ~ BELT GUARD			
53	2	MK-D495B ~ UHMW SHEET			
54	4	1/4-20UNC x 1" LG. FLAT HEX SOCKET HEAD CAP SCREW			
55	4	1/4-20UNC STOVER LOCK NUT			

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	MOVED BASE PLATES (ITEMS '29' & '30') & GREASE FITTINGS (ITEM 51) TO MK-D470A	
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY

MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		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.	1875D472	DWG DATE:	11/9/22
REV:	B	JOB No:	22096

MAGNUM CONSULTING

41100 Clarkston Road
Suite 125
West, MI 48375

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D472 - REV B

SHEET 1 OF 2

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

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

GENERAL NOTES:

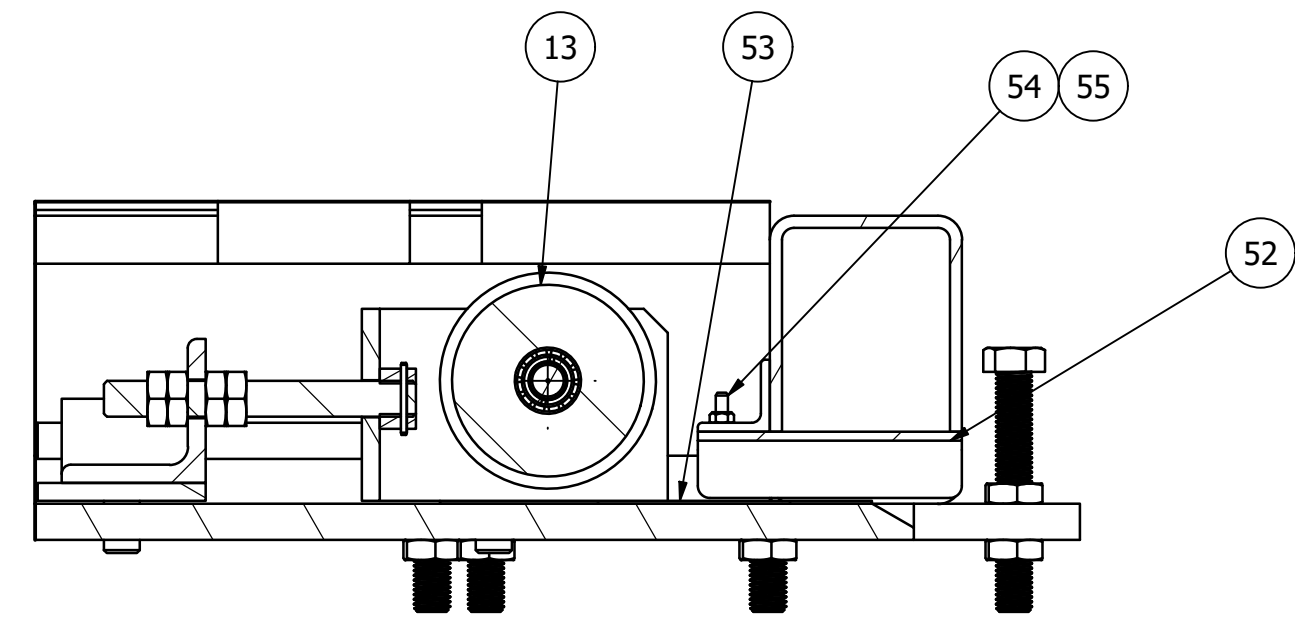
MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

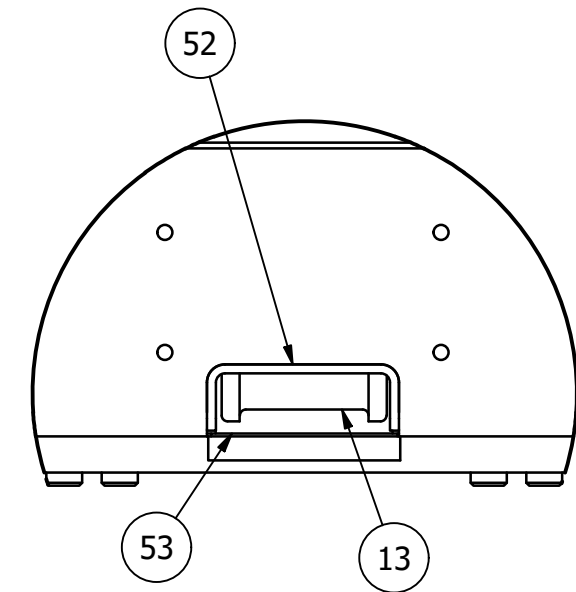
WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

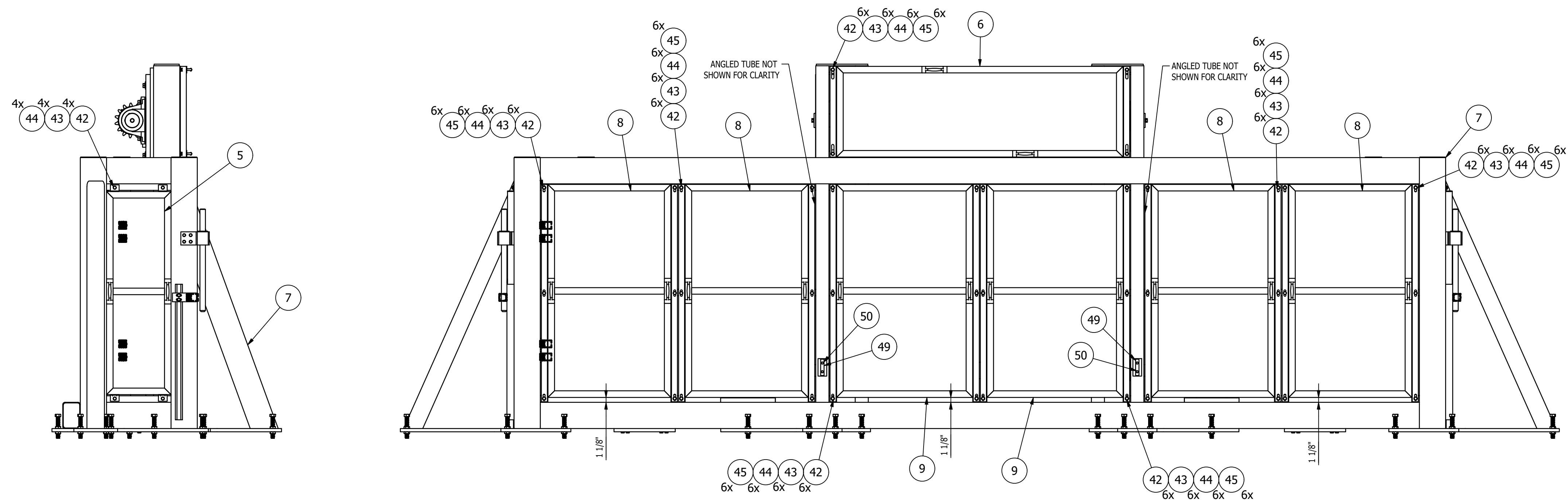
COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



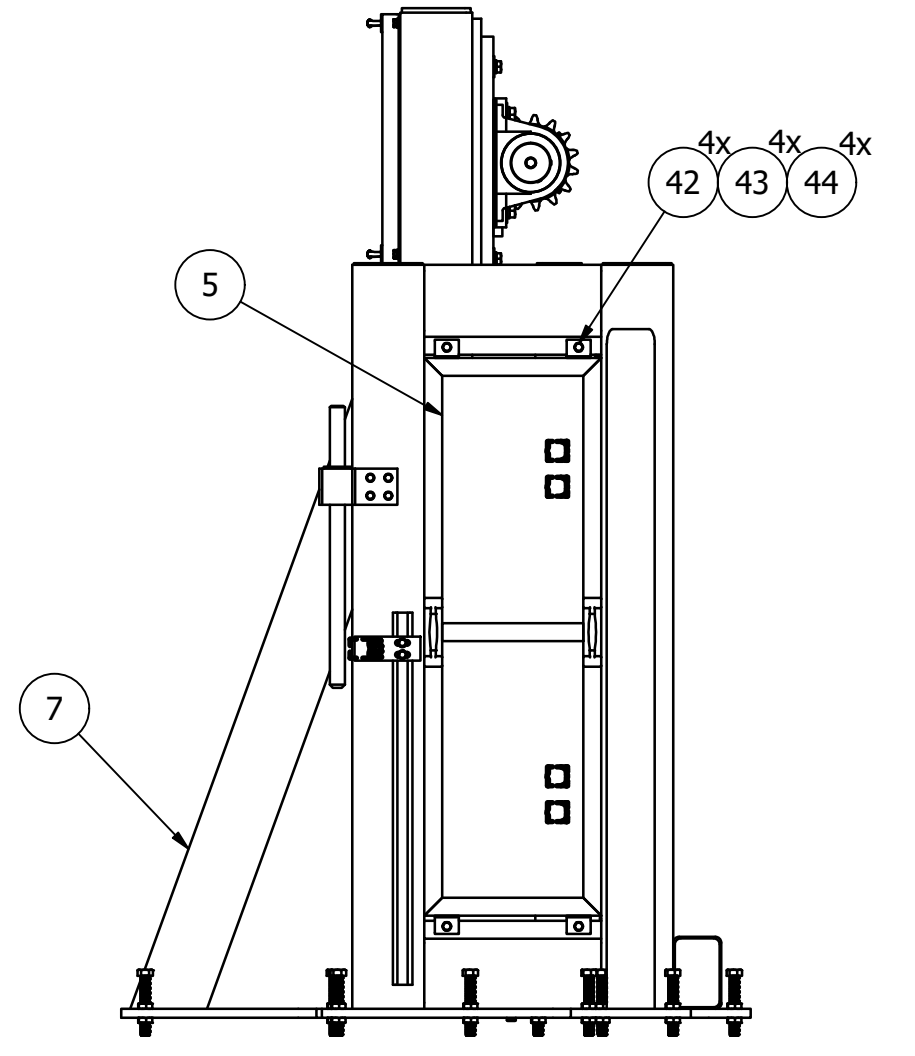
ENLARGED VIEW 'F'
SCALE 3"=1'-0"



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



MK-D472A ~ AUX LIFT PASSENGER SIDE ASSEMBLY
SCALE 3/4"=1'-0"



SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	MOVED BASE PLATES (ITEMS '29' & '30') & GREASE FITTINGS (ITEM 51) TO MK-D470A	
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING
CLIENT:	VOLVO
DRAWING No.	1875D472
REV:	B
DRAWN BY:	RJB
CHECKED BY:	CW
DWG DATE:	11/9/22
JOB No.:	22096

GENERAL NOTES:

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

HOLES:
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 - 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

41701 Gardenbrook Rd. Suite 100
 Novi, MI 48375

Phone: (248) 773-8555
 Fax: (248) 773-8551
 Web: www.48magnum.com

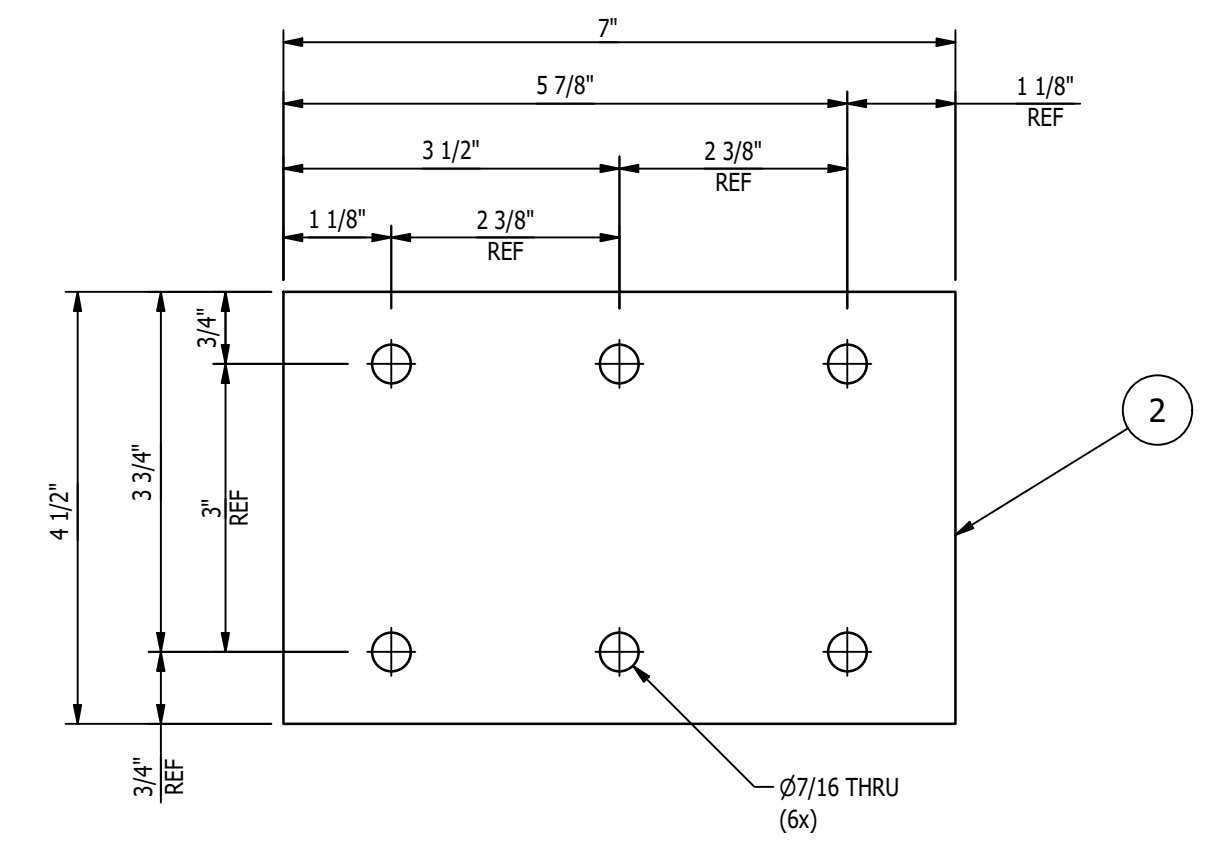
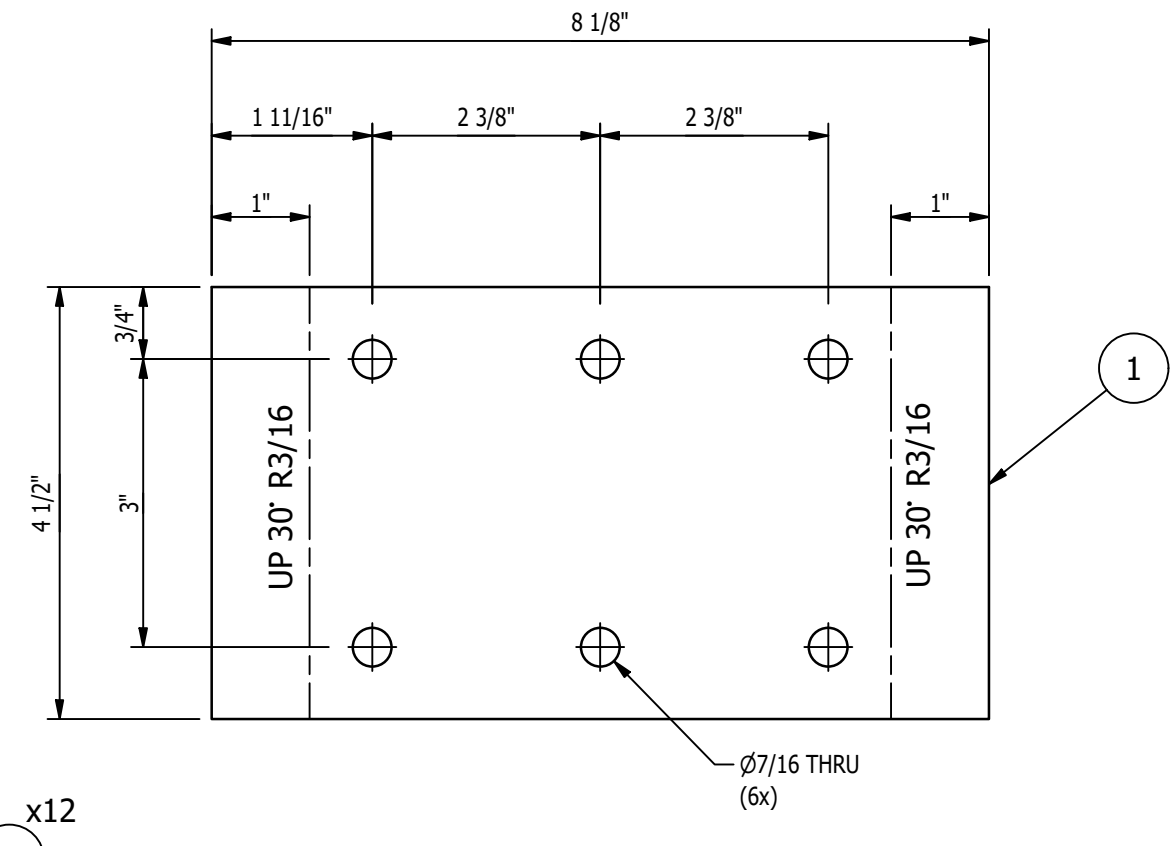
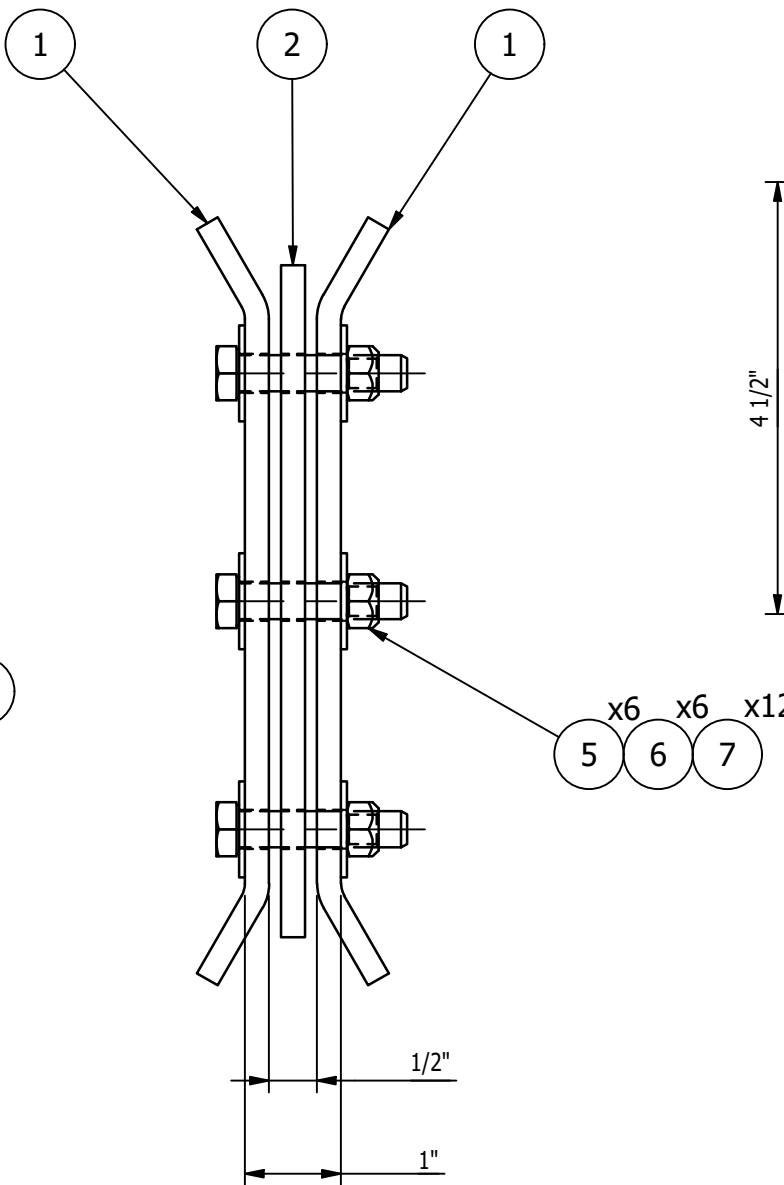
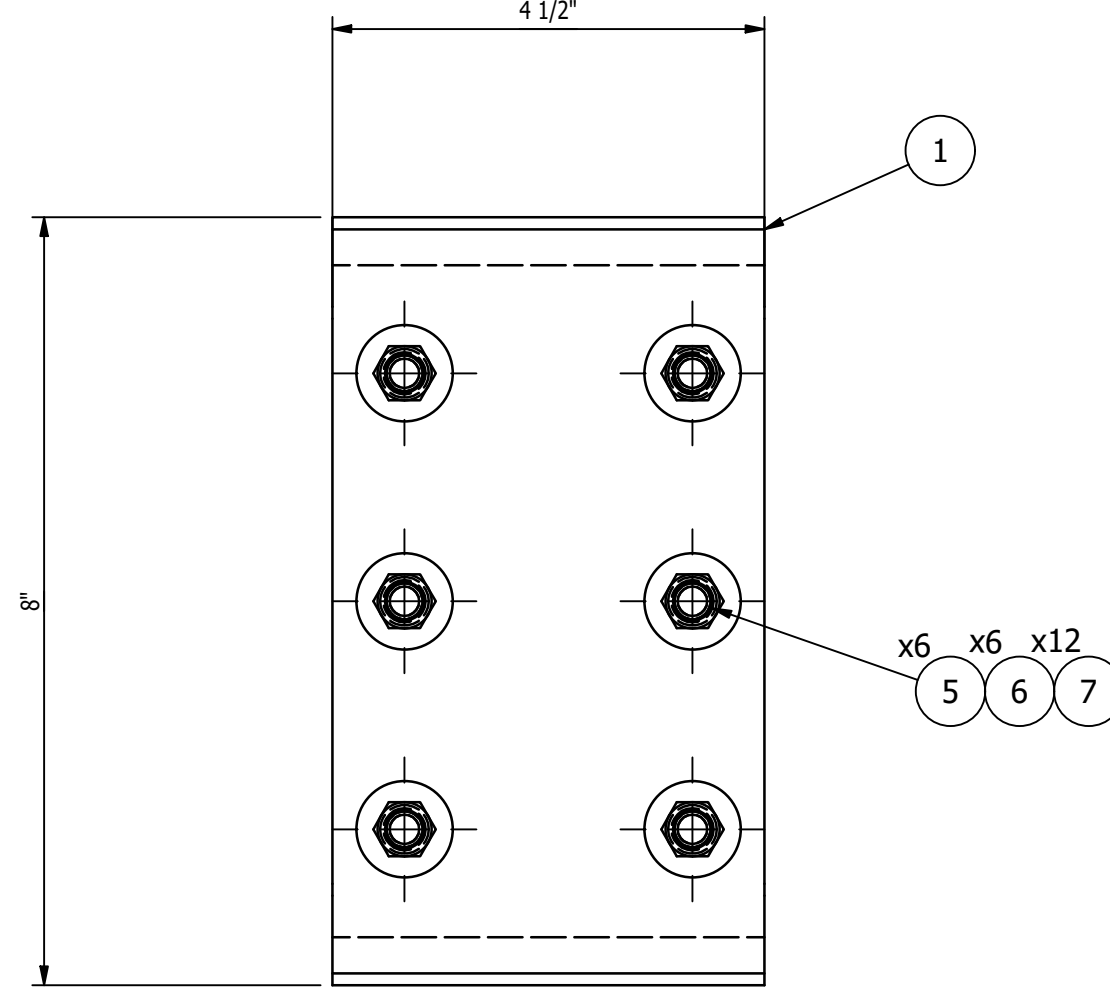
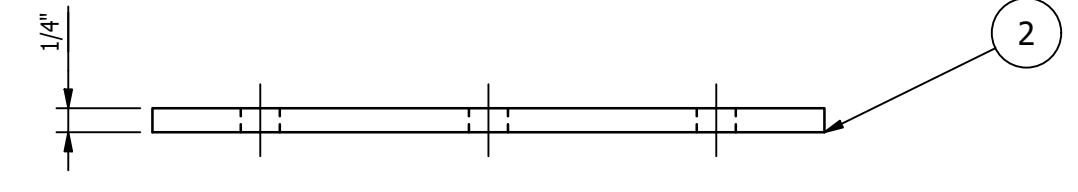
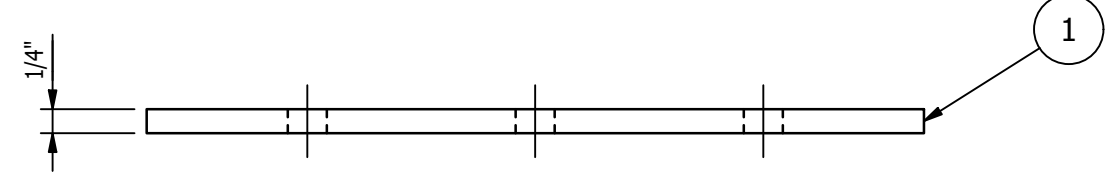
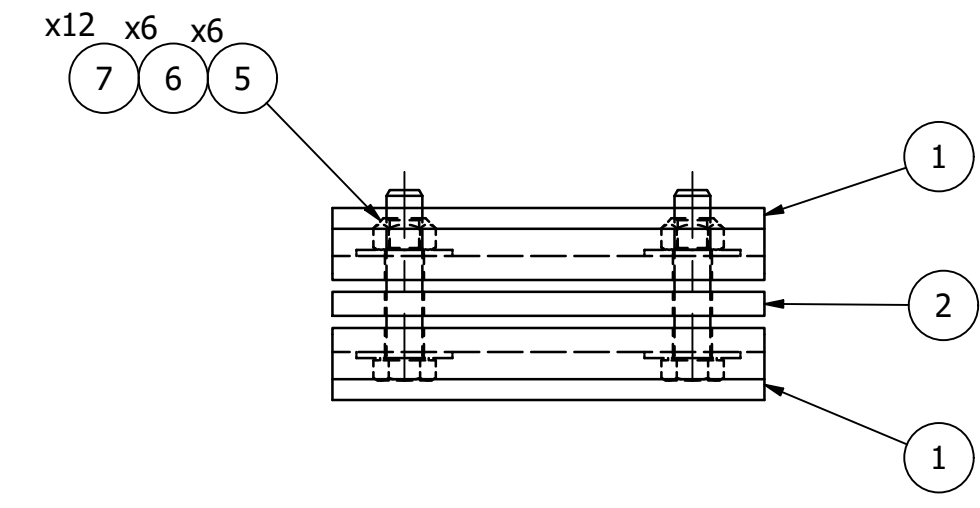
MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D472 - REV B

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

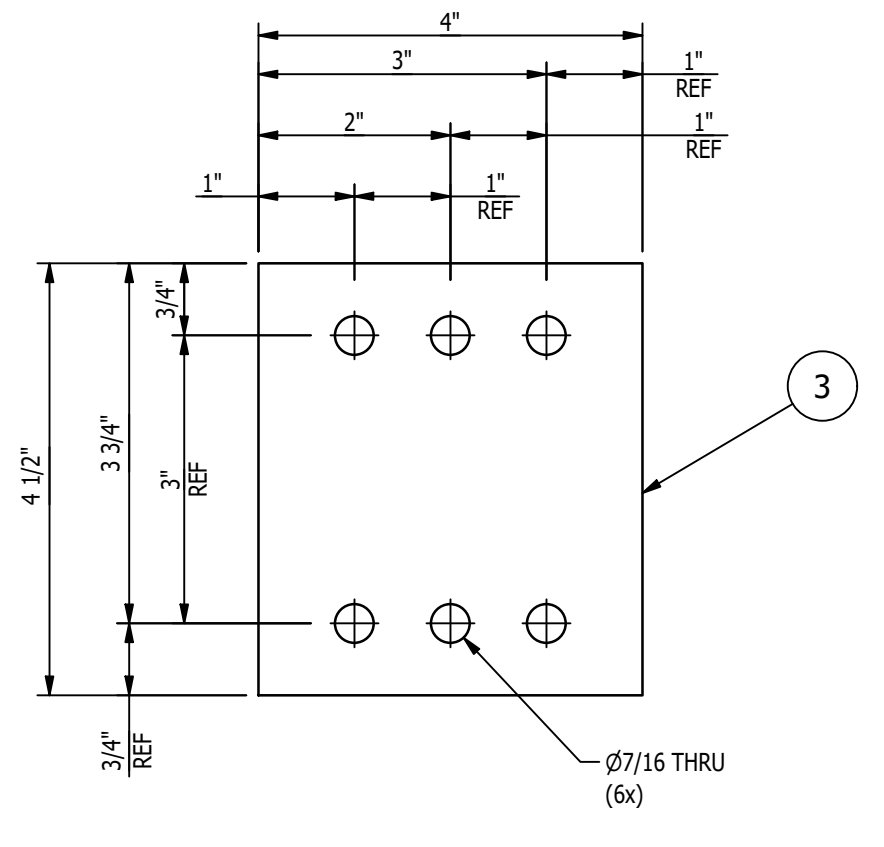
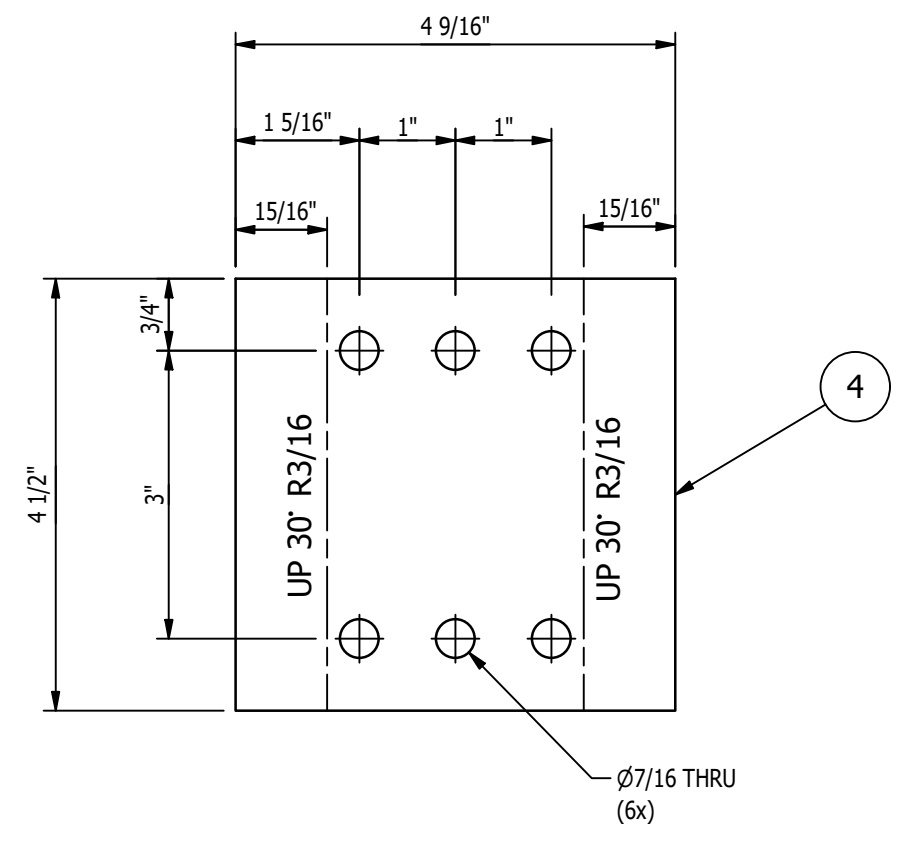
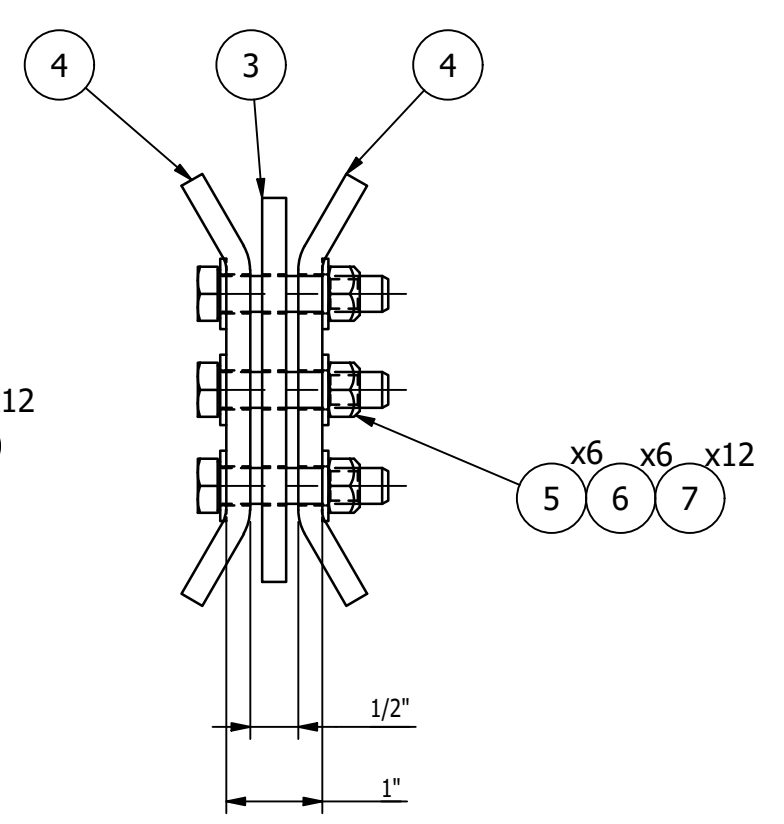
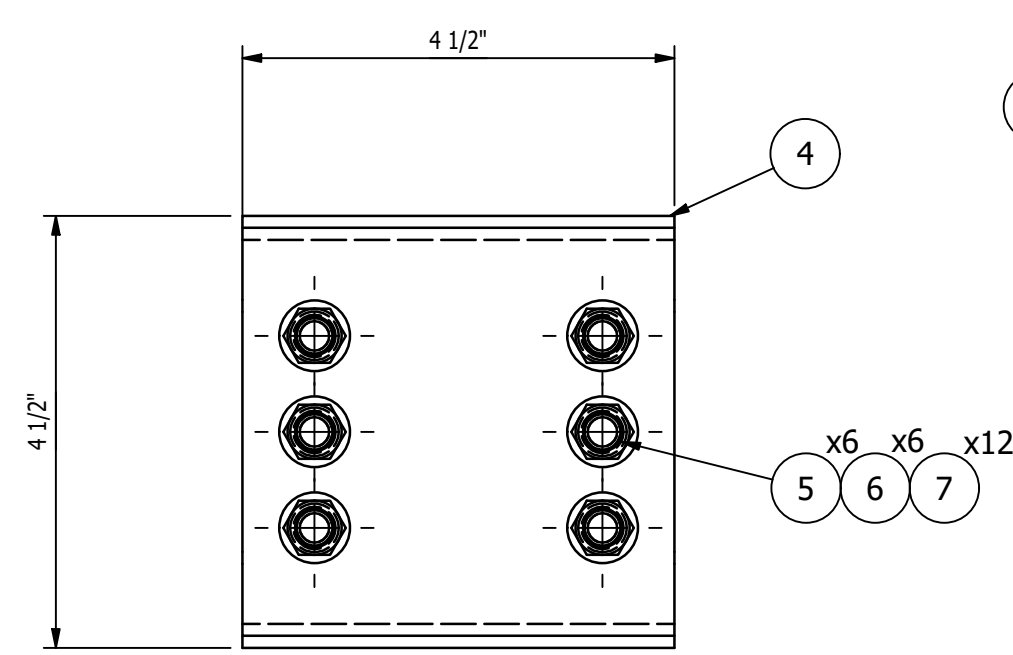
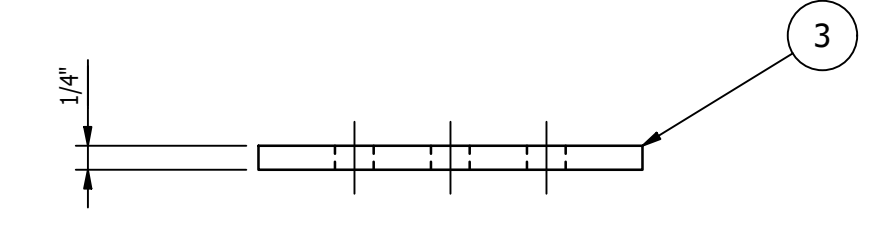
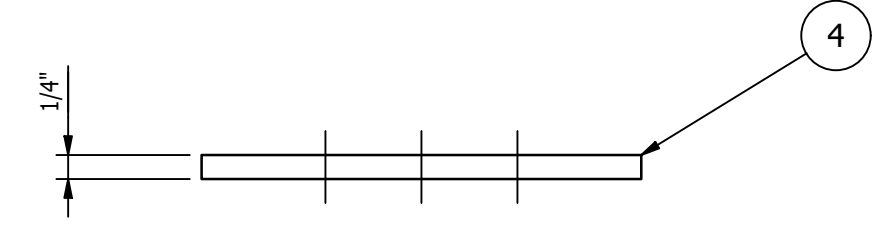
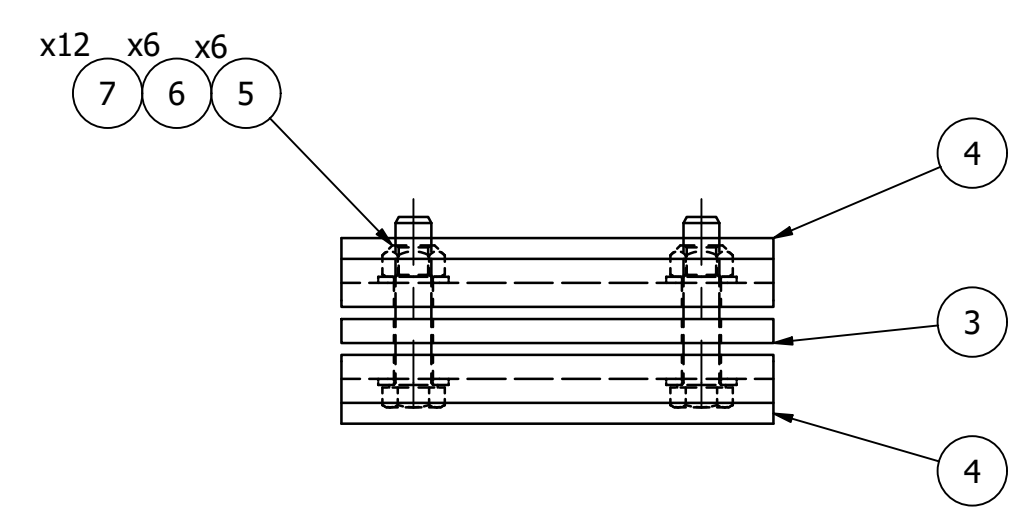
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D473A			
1	2	PL 1/4 x 4 1/2	8 1/8"		
2	1	PL 1/4 x 4 1/2"	7"		
5	6	3/8-16UNC STOVER LOCK NUT			
6	6	3/8-16UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
7	12	3/8 TYPE B REGULAR FLAT WASHER			
		MK-D473B			
3	1	PL 1/4 x 4"	4 1/2"		
4	2	PL 1/4 x 4 1/2	4 9/16"		
5	6	3/8-16UNC STOVER LOCK NUT			
6	6	3/8-16UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
7	12	3/8 TYPE B NARROW FLAT WASHER			



MK-D473A ~ BELT CLAMP
SCALE 6"=1'-0"

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

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



MK-D473B ~ BELT CLAMP
SCALE 6"=1'-0"

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

MAGNUM CONSULTING

4100 Dardickwood Rd.
Suite 125
West, MI 48375

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D473

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

FRACTIONS = ±1/16"
ANGLES = ±1°30'

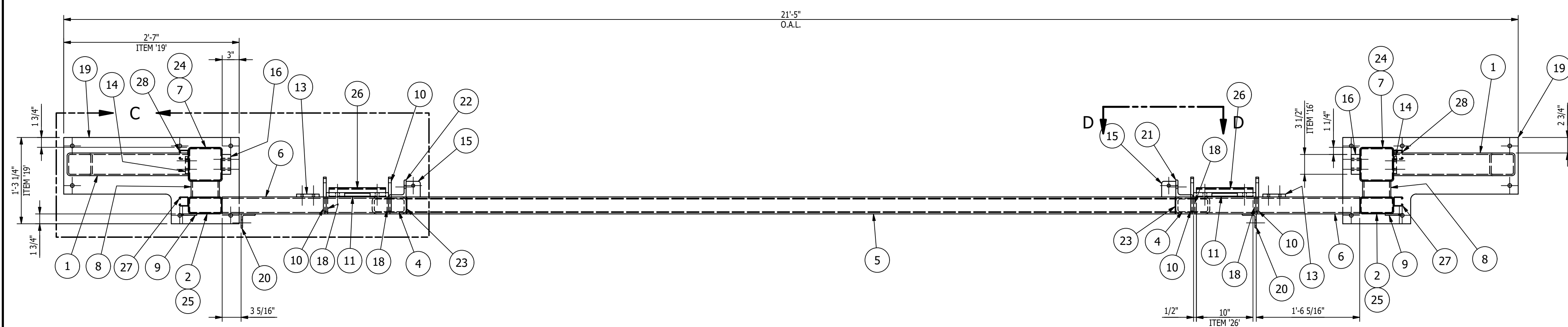
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/14/22	FOR FABRICATION	

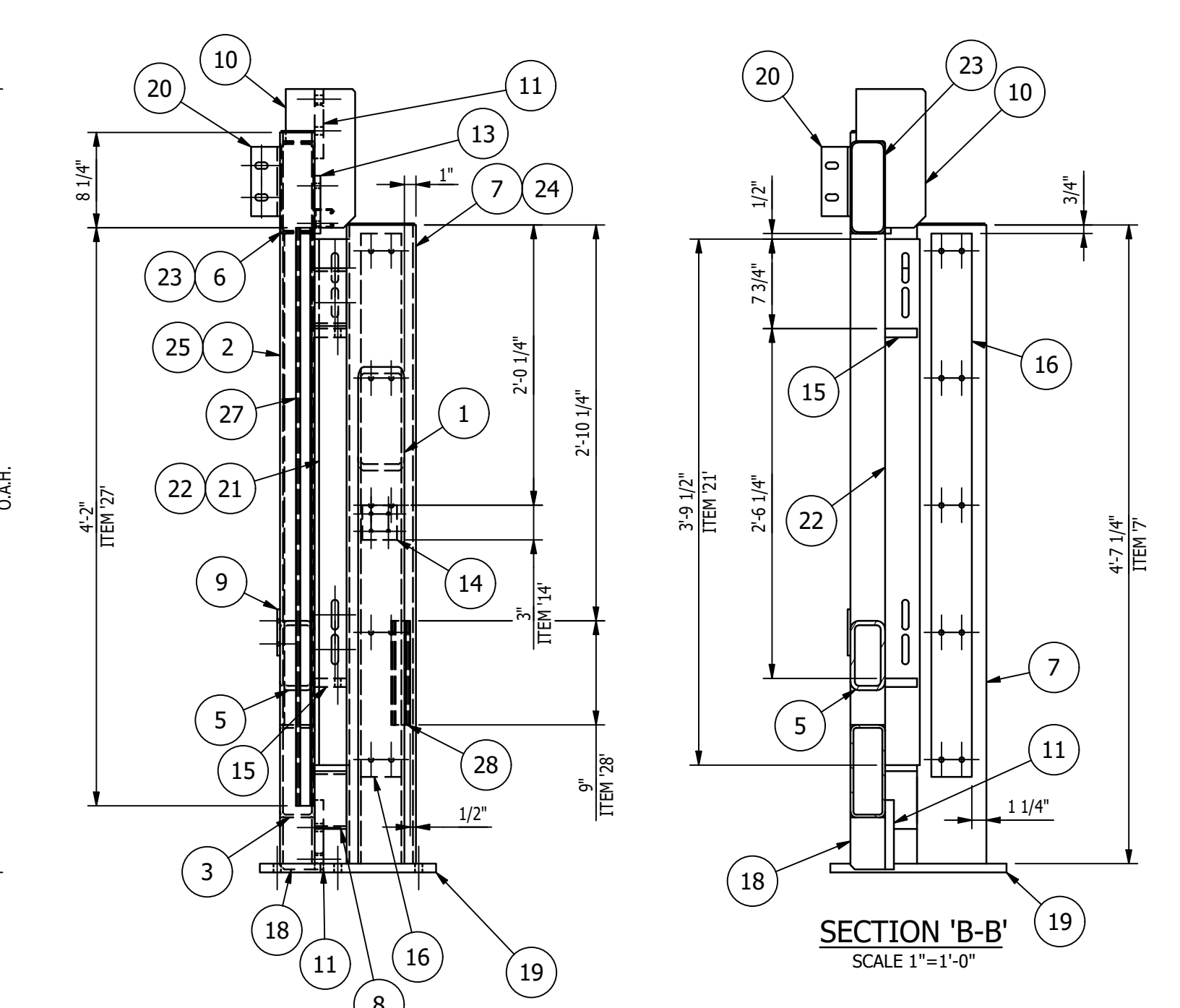
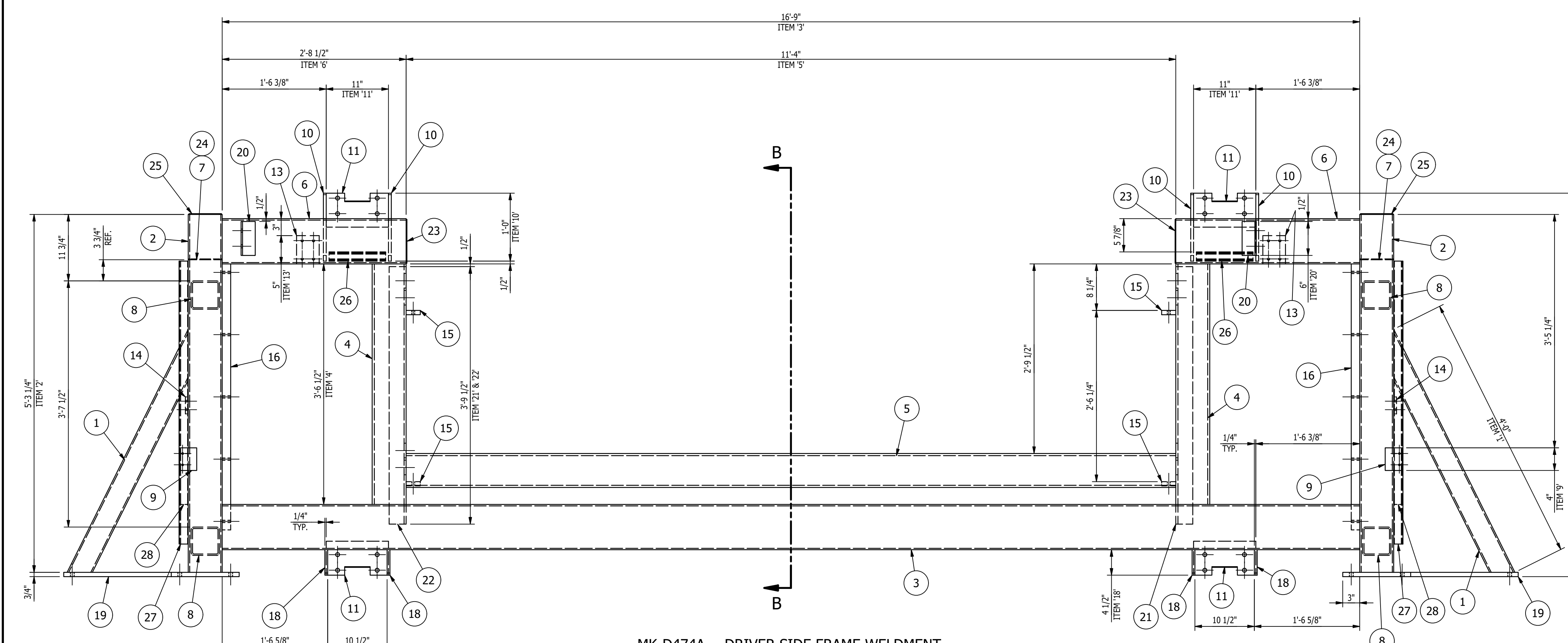
MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	BTC
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D473	DWG DATE:	11/4/22
REV:	A	JOB No:	22096

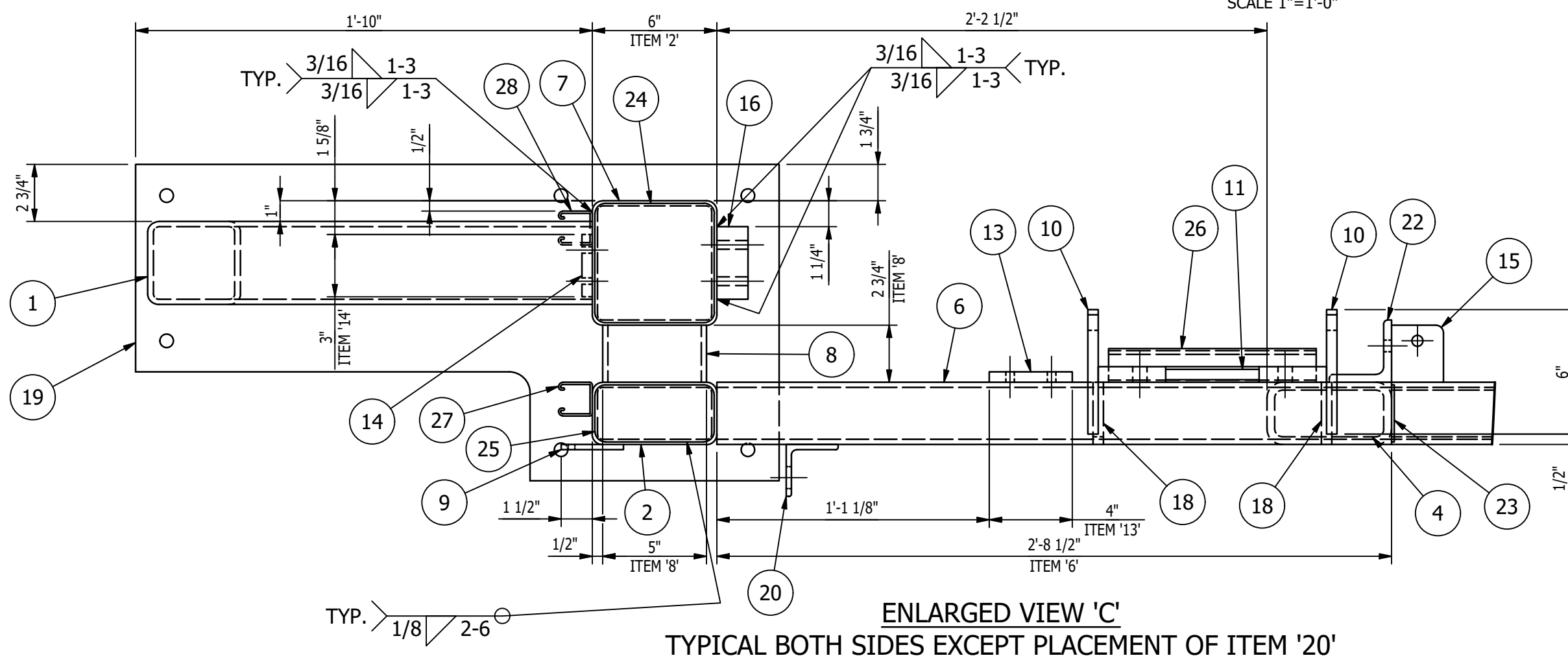
3:00p 11/15/22 New Job Drawing/Issue/22-11-15 Rev. LINDSEY/25/2473 - REV A.dwg



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D474A			
1	2	HSS 4 x 4 x 1/4 A500 GR. C	4'-0"		
2	2	HSS 6 x 3 x 1/4 A500 GR. C	5'-3 1/4"		
3	1	HSS 8 x 3 x 1/4 A500 GR. C	16'-9"		
4	2	HSS 6 x 3 x 3/8 A500 GR. C	3'-6 1/2"		
5	1	HSS 6 x 3 x 3/8 A500 GR. C	11'-4"		
6	2	HSS 8 x 3 x 1/4 A500 GR. C	2'-8 1/2"		
7	2	HSS 6 x 6 x 1/4 A500 GR. C	4'-7 1/4"		
8	4	HSS 5 x 5 x 1/4 A500 GR. C	2 3/4"		
9	2	PL 1/4 x 3"	4"		
10	4	PL 1/2 x 6"	1'-0"		
11	4	PL 3/4 x 6"	11"		
13	2	PL 1/2 x 4"	5"		
14	2	PL 1/2 x 3"	3"		
15	4	PL 3/4 x 2 1/2"	2 3/4"		
16	2	PL 1 1/2 x 3 1/2"	3'-11"		
18	4	PL 1/2 x 3"	4 1/2"		
19	2	PL 3/4 x 1'-3 1/4"	2'-7"		
20	2	L 2 1/2 x 2 1/2 x 1/4	6"		
21	1	L 3 x 3 x 3/8	3'-9 1/2"		
22	1	L 3 x 3 x 3/8	3'-9 1/2"		
23	2	SHT 10 GA x 2 3/4"	7 3/4"		
24	2	SHT 10 GA x 5 3/4"	5 3/4"		
25	2	SHT 10 GA x 2 3/4"	5 3/4"		
26	2	UNISTRUT 1-5/8" x 1-5/8" 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	10"		
27	2	UNISTRUT 1-5/8" x 1-5/8" 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	4'-2"		
28	2	UNISTRUT 1-5/8" x 1-5/8" 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	9"		



MK-D474A ~ DRIVER SIDE FRAME WELDMENT
SCALE 1"=1'-0"



ENLARGED VIEW 'C'
TYPICAL BOTH SIDES EXCEPT PLACEMENT OF ITEM '20'
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.

MAGNUM Consulting
41100 Gardswood Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D474

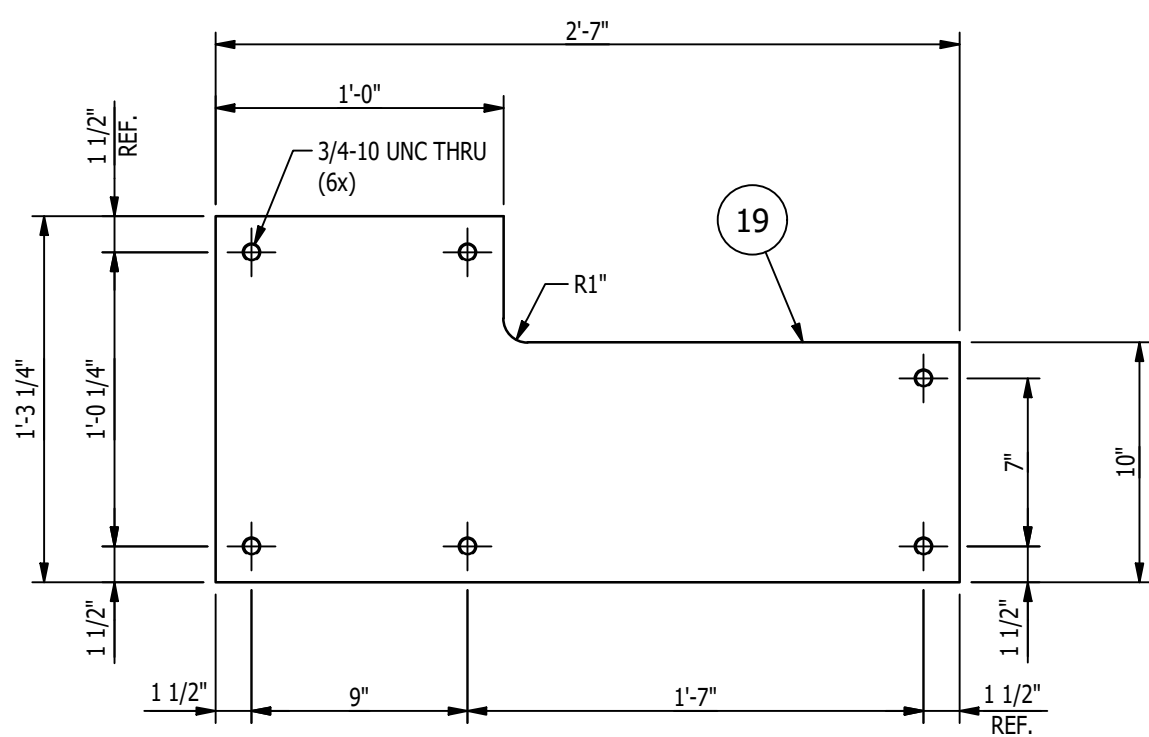
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

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

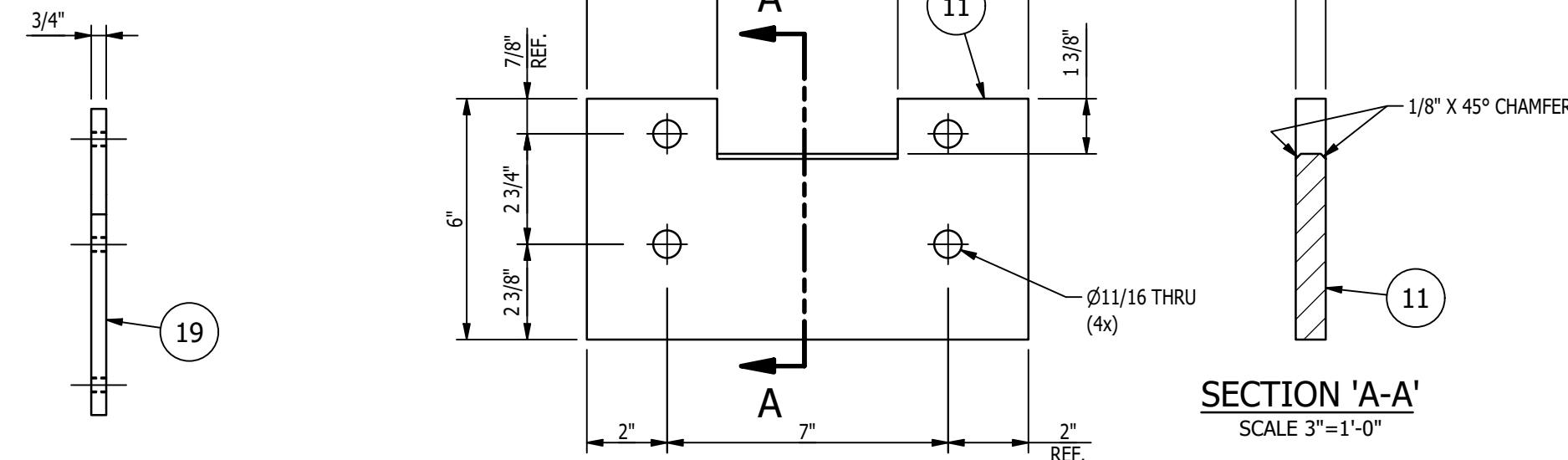
REV	BY	DATE	DESCRIPTION	APP
A	MC	11/14/22	FOR FABRICATION	

REVISION HISTORY

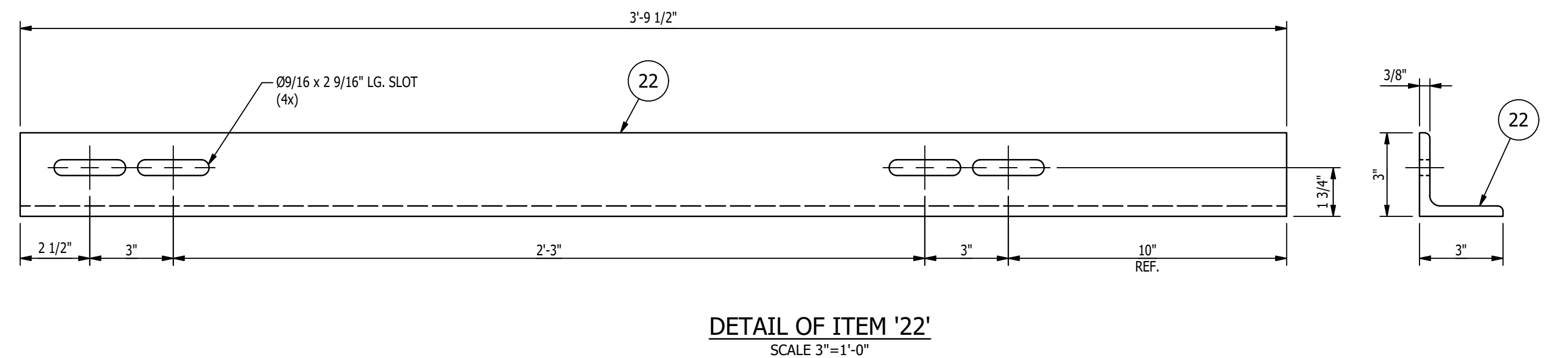
MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RPM
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D474	DWG DATE:	10/31/22
REV:	A	JOB No.:	22096



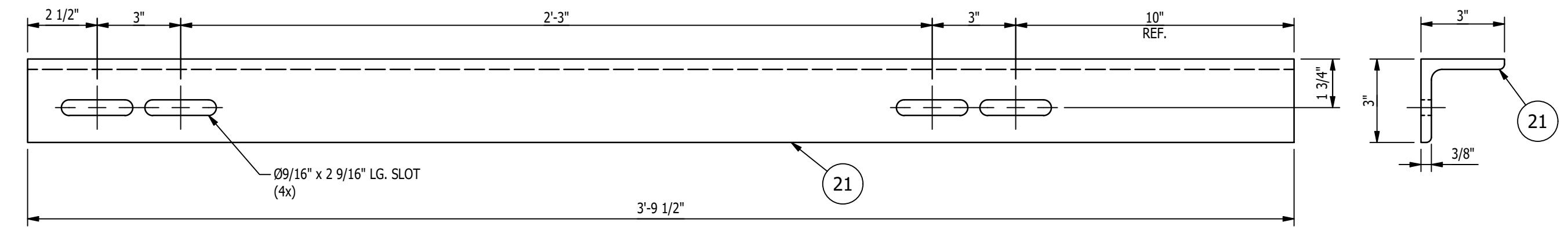
DETAIL OF ITEM '19'
SCALE 1 1/2"=1'-0"



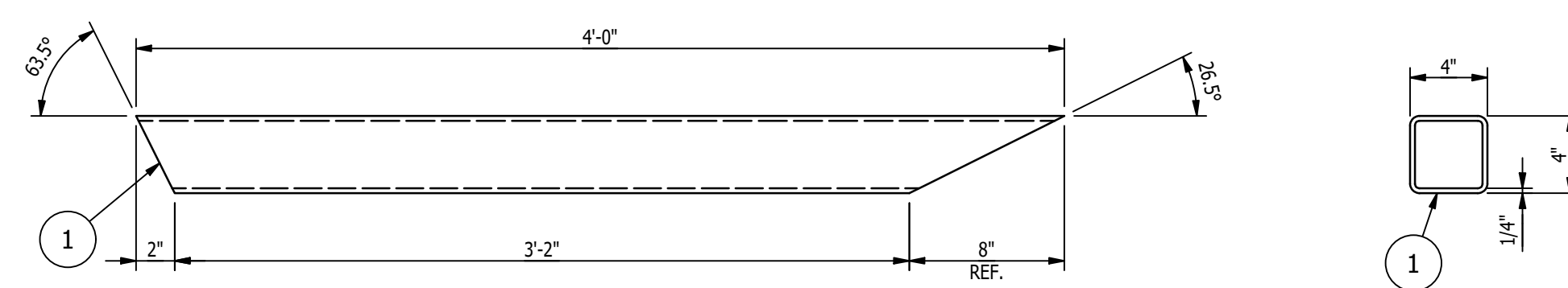
DETAIL OF ITEM '11'
SCALE 3"=1'-0"



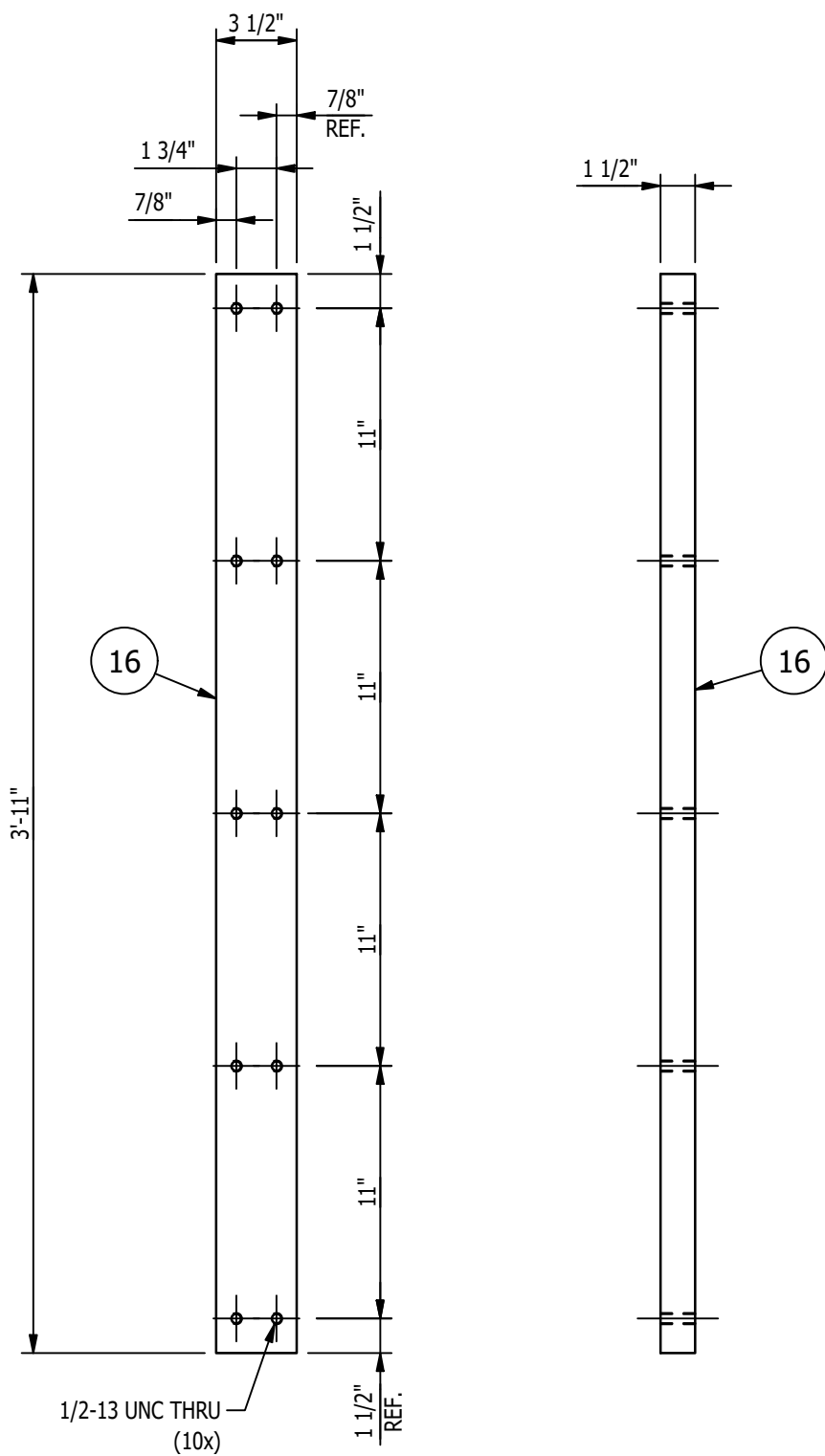
DETAIL OF ITEM '22'
SCALE 3"=1'-0"



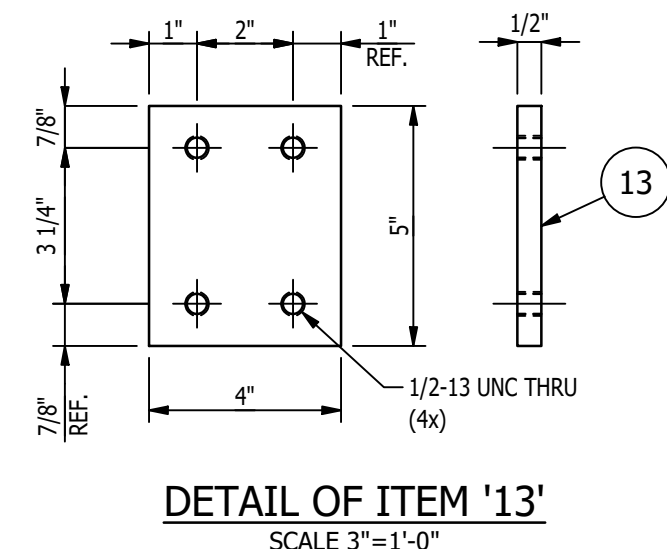
DETAIL OF ITEM '21'
SCALE 3"=1'-0"



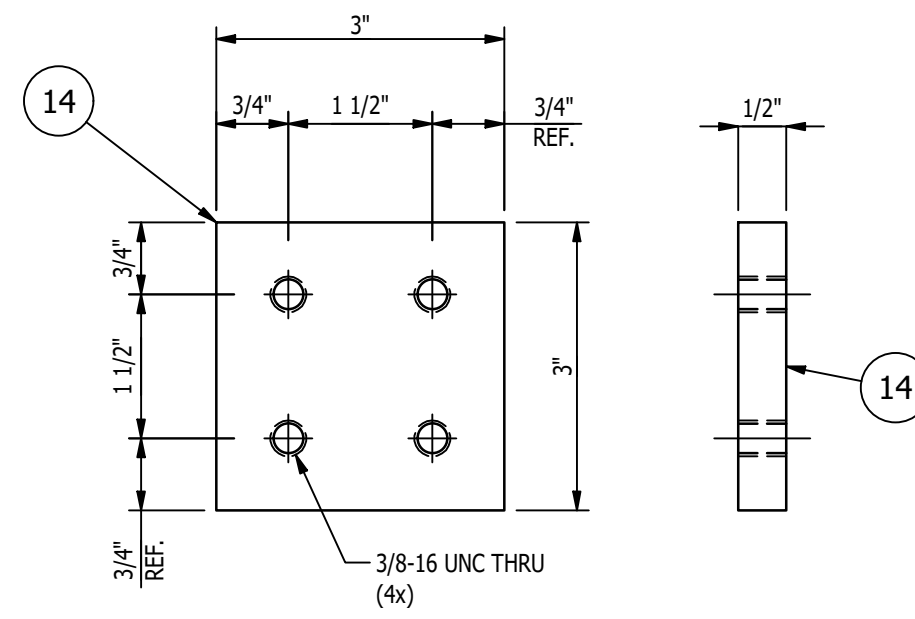
DETAIL OF ITEM '1'
SCALE 1 1/2"=1'-0"



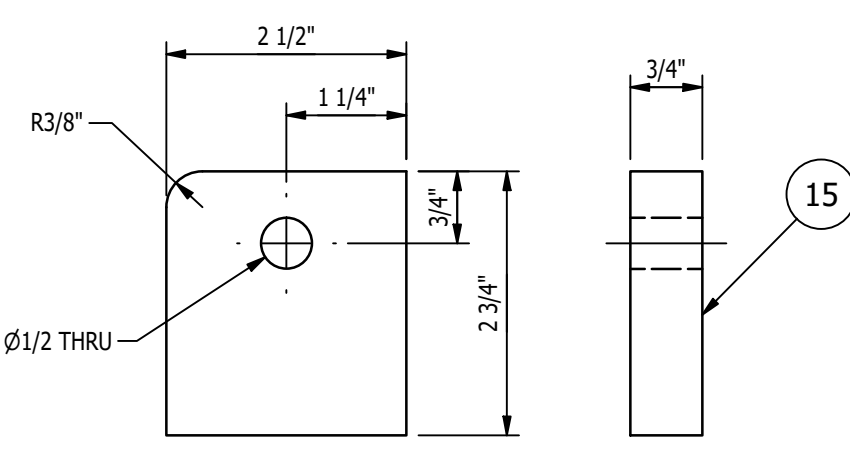
DETAIL OF ITEM '16'
SCALE 1 1/2"=1'-0"



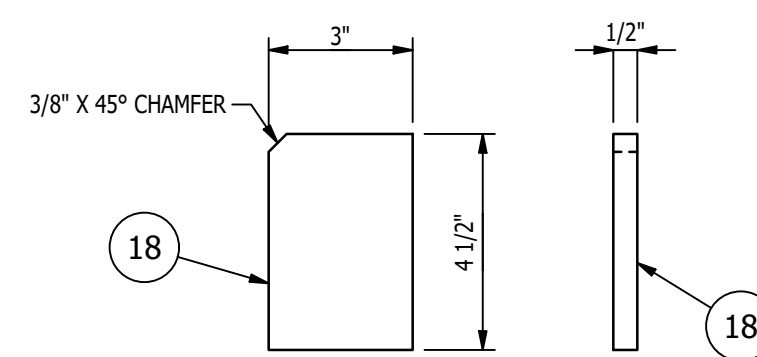
DETAIL OF ITEM '13'
SCALE 3"=1'-0"



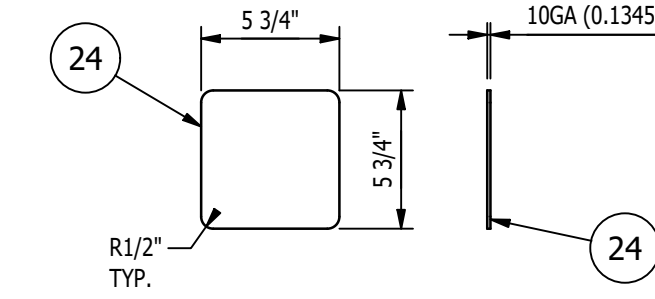
DETAIL OF ITEM '14'
SCALE 6"=1'-0"



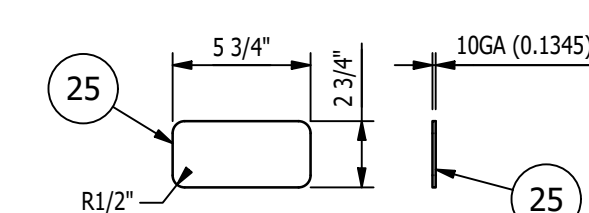
DETAIL OF ITEM '15'
SCALE 6"=1'-0"



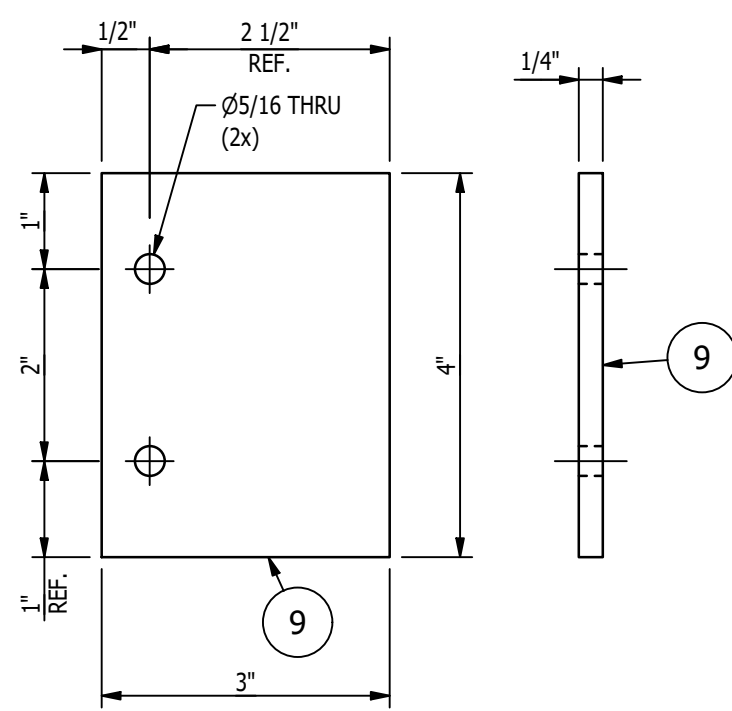
DETAIL OF ITEM '18'
SCALE 3"=1'-0"



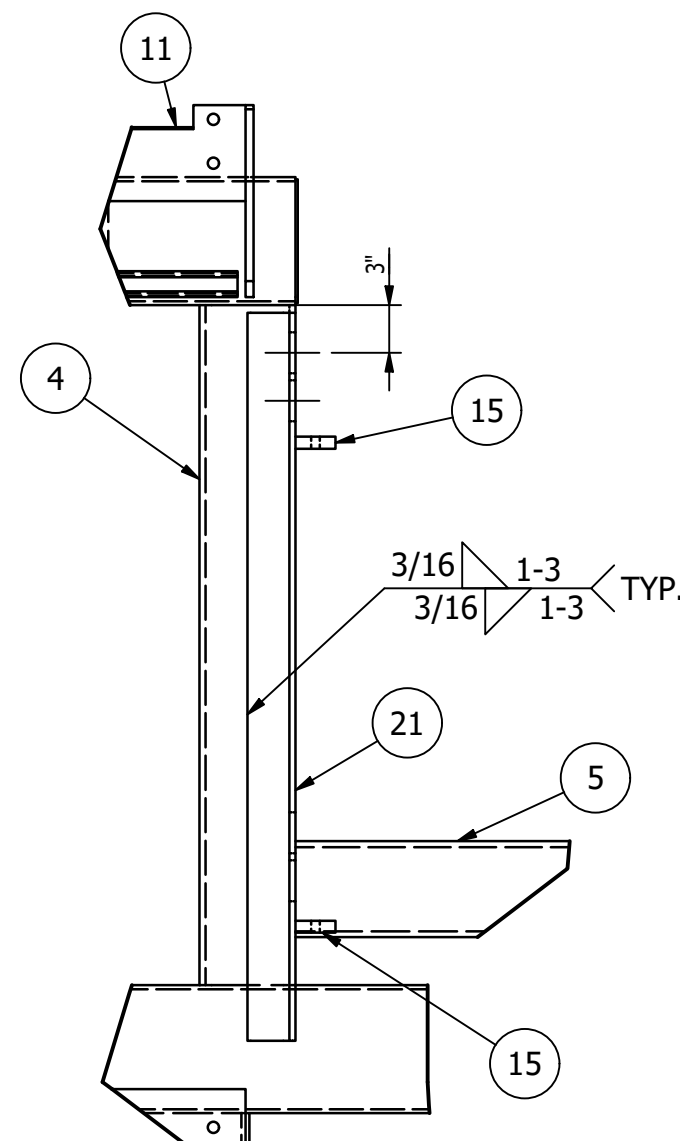
DETAIL OF ITEM '24'
SCALE 1 1/2"=1'-0"



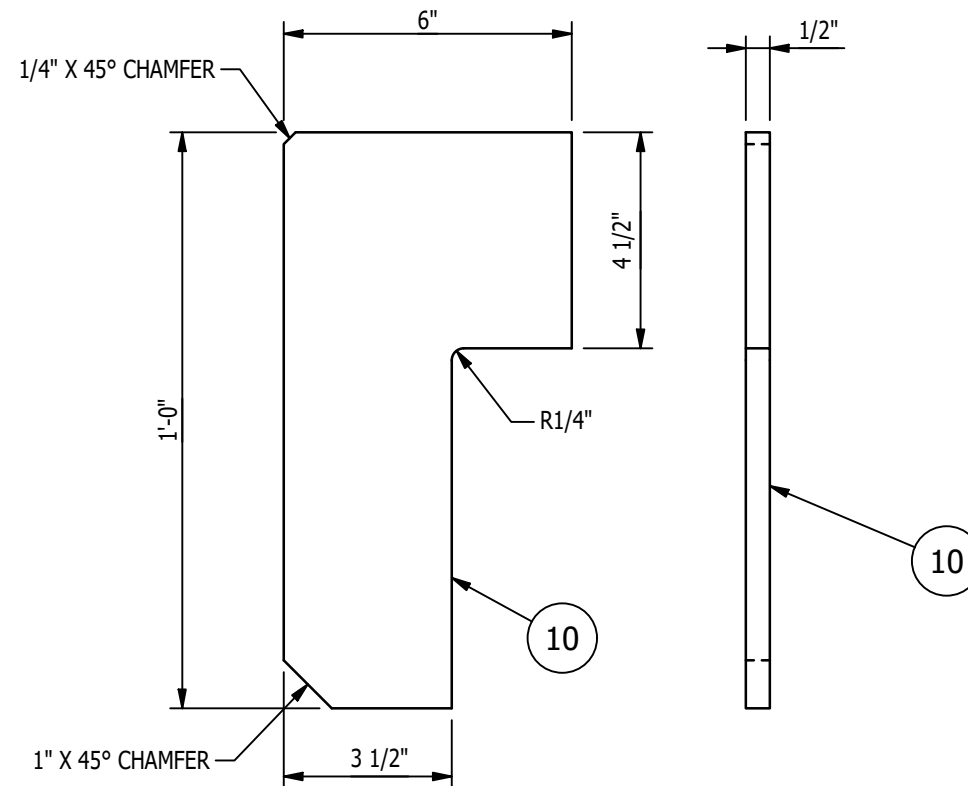
DETAIL OF ITEM '25'
SCALE 1 1/2"=1'-0"



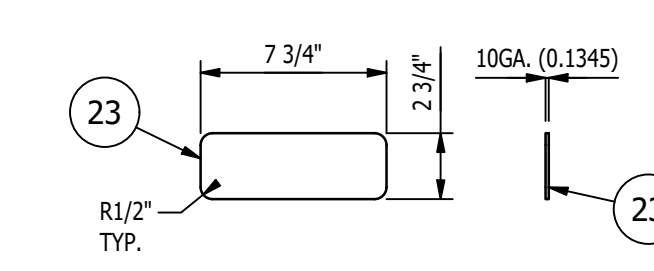
DETAIL OF ITEM '9'
SCALE 6"=1'-0"



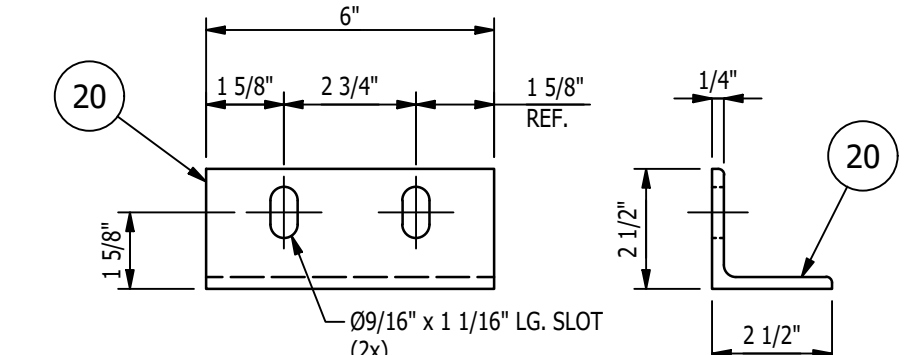
VIEW 'D-D'
SCALE 1"=1'-0"



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



DETAIL OF ITEM '23'
SCALE 1 1/2"=1'-0"



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

SHEET 2 OF 2

A	MC	11/14/22	FOR FABRICATION	
REV	BY	DATE	DESCRIPTION	APP

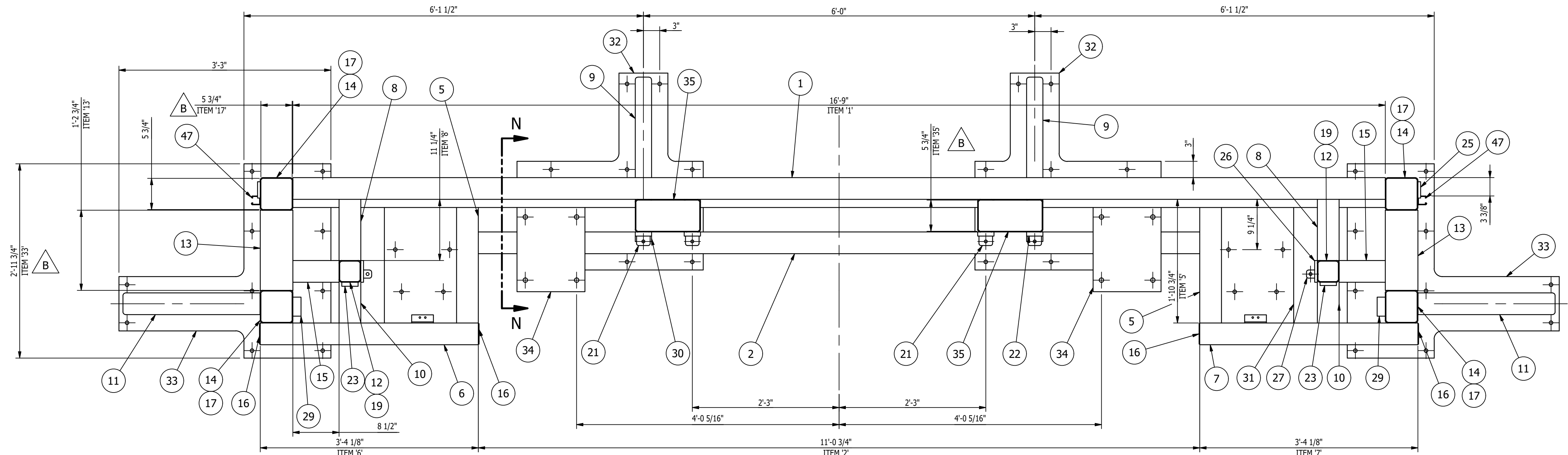
REVISION HISTORY	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING
CLIENT:	VOLVO
DRAWING No.:	1875D474
REV:	A
DRAWN BY:	RPM
CHECKED BY:	CW
DWG DATE:	10/31/22
JOB No.:	22096

MAGNUM Consulting
41700 Gortelwood Rd. Phone: (248) 773-8555
Suite 102 Fax: (248) 773-8551
Westland, MI 48185 Web: www.magnumc.com

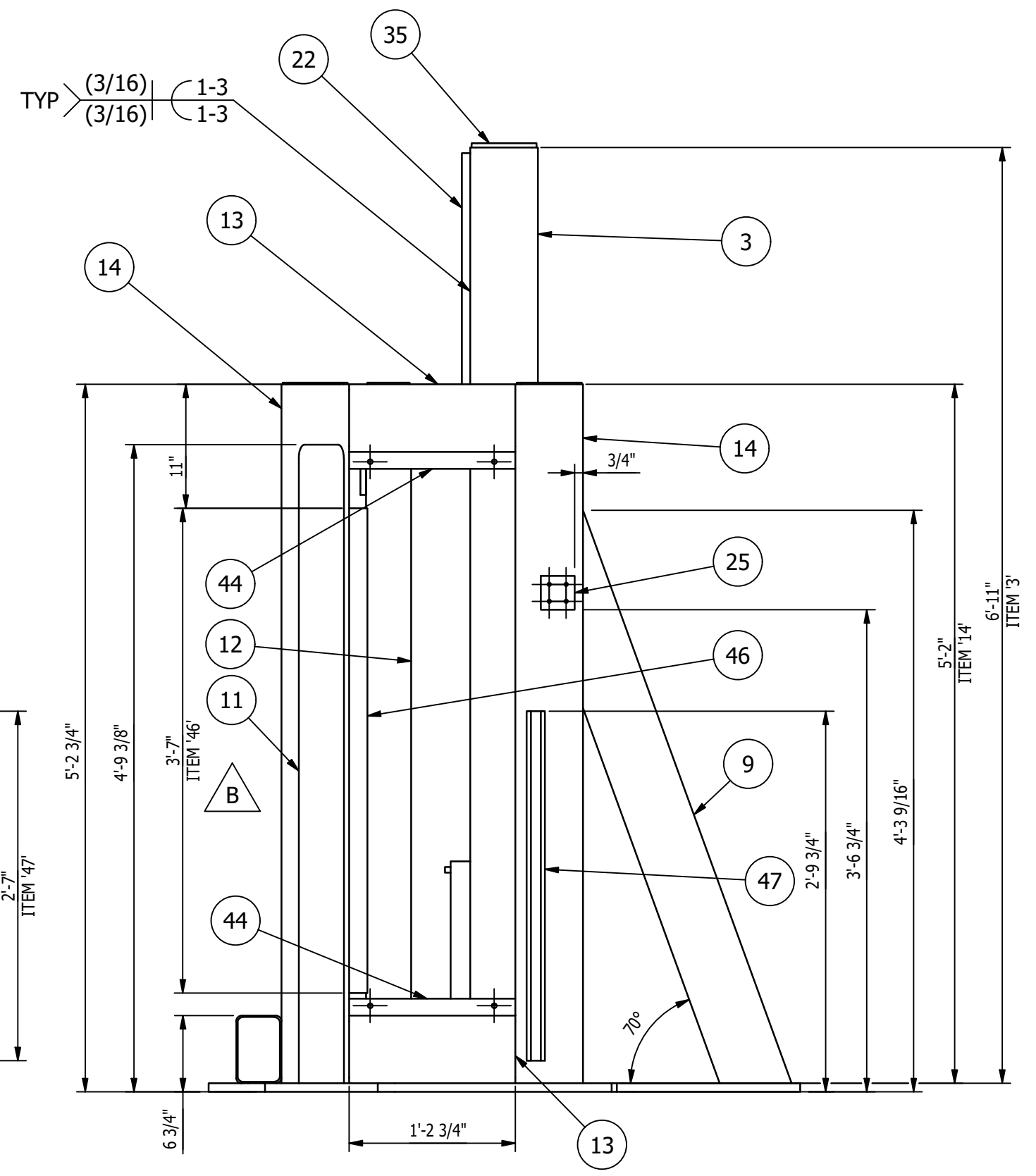
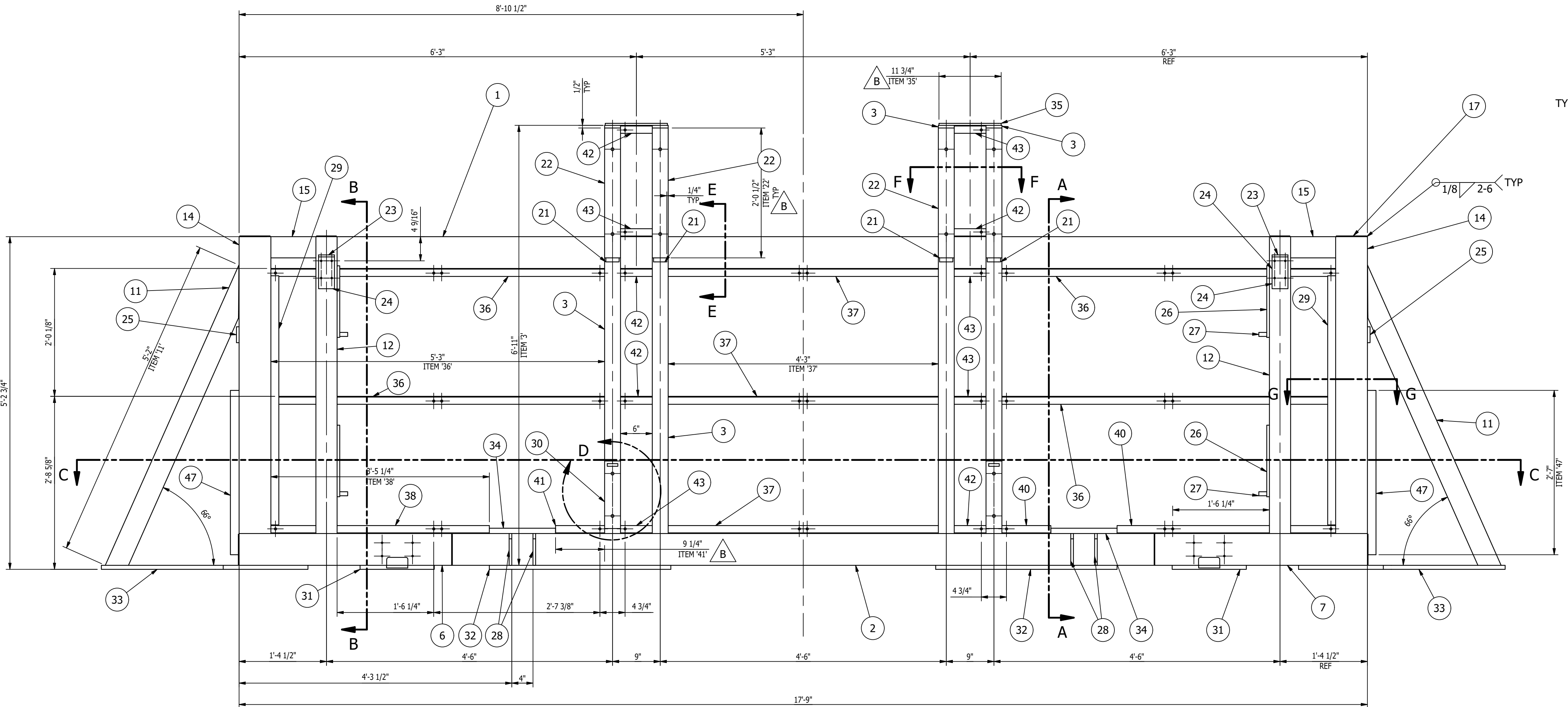
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D474

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

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



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



MK-D475A ~ PASSENGER SIDE FRAME WELDMENT
 SCALE 1"=1'-0"

SHEET 1 OF 4

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED VIEW 'P-P', CORRECTED NOTES ON DIMENSIONS	
A	MC	11/14/22	FOR FABRICATION	

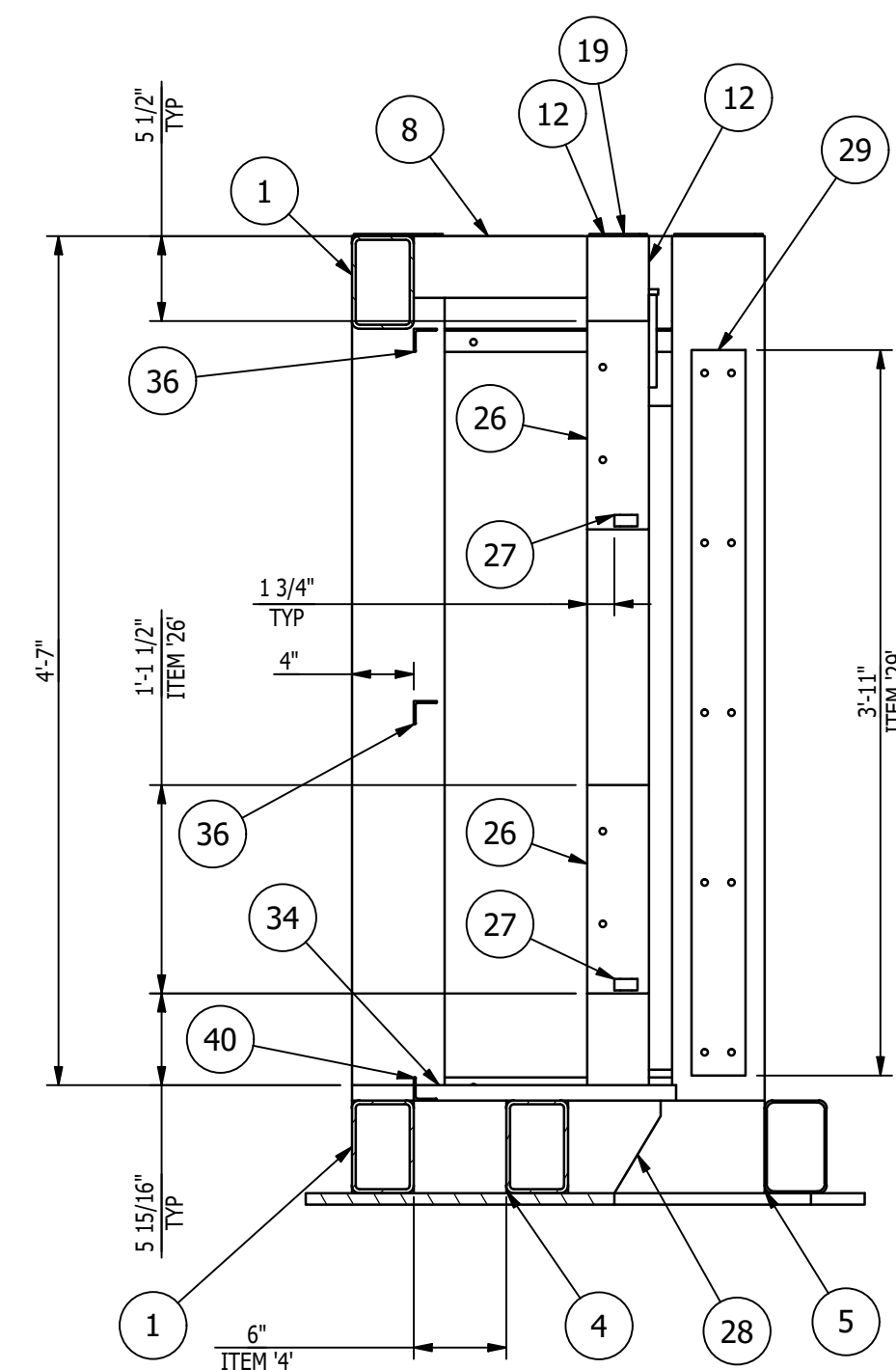
REVISION HISTORY		DRAWN BY: BTC	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	CHECKED BY:	CW
CLIENT:	VOLVO	DWG DATE:	10/31/22
DRAWING No.	1875D475	REV:	B
		JOB No:	22096

MAGNUM CONSULTING
 41100 Charleston Rd.
 Suite 125
 West, MI 48315
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D475

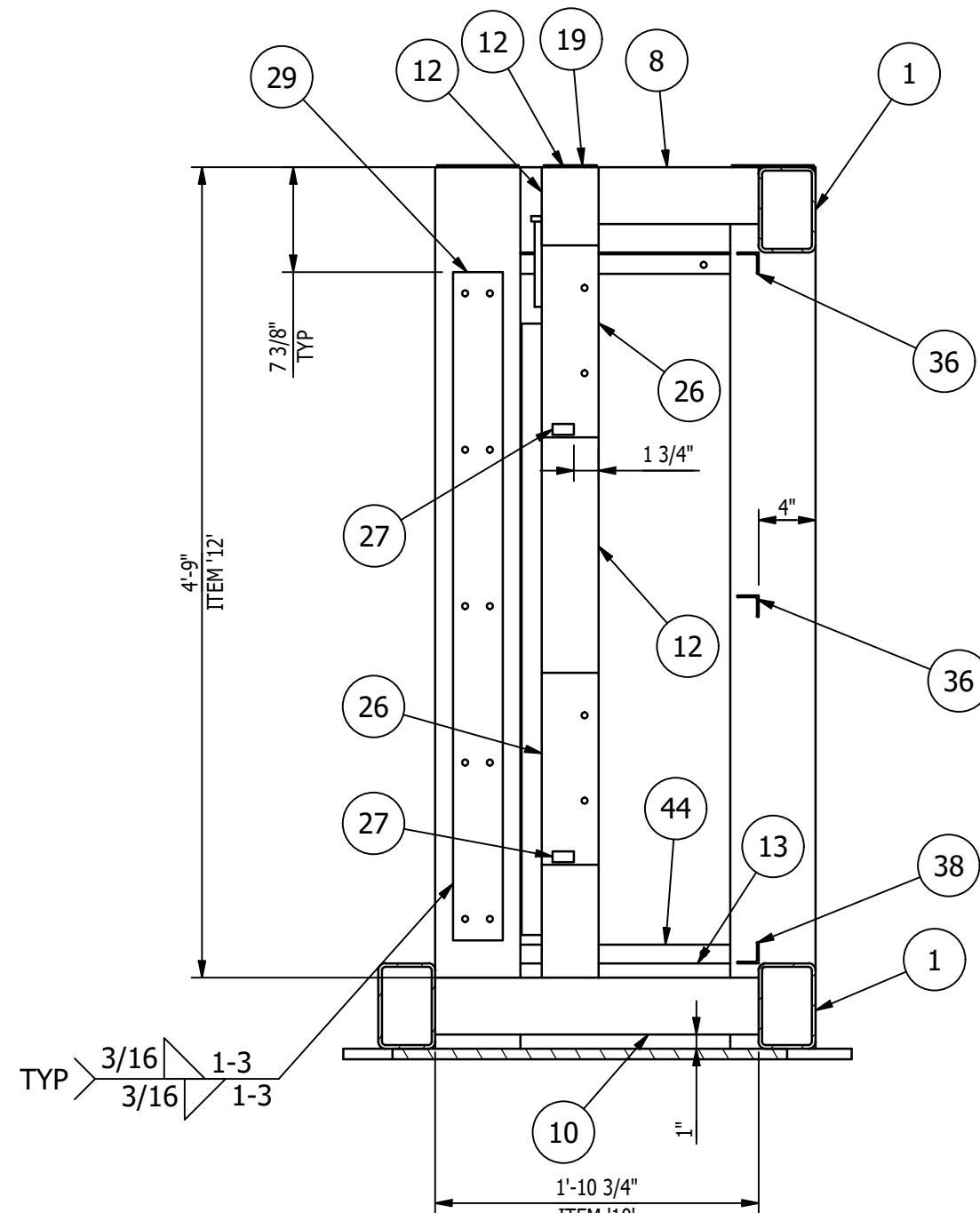
UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

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.

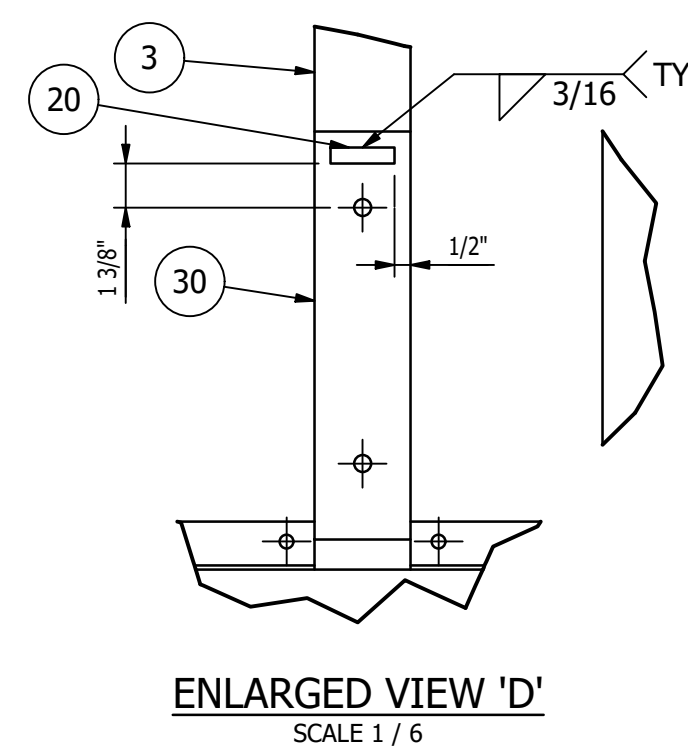
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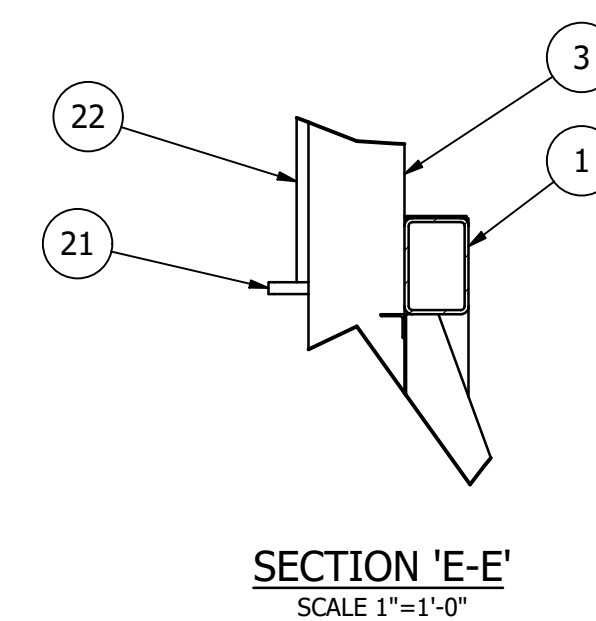
SECTION 'A-A'
SCALE 1"=1'-0"



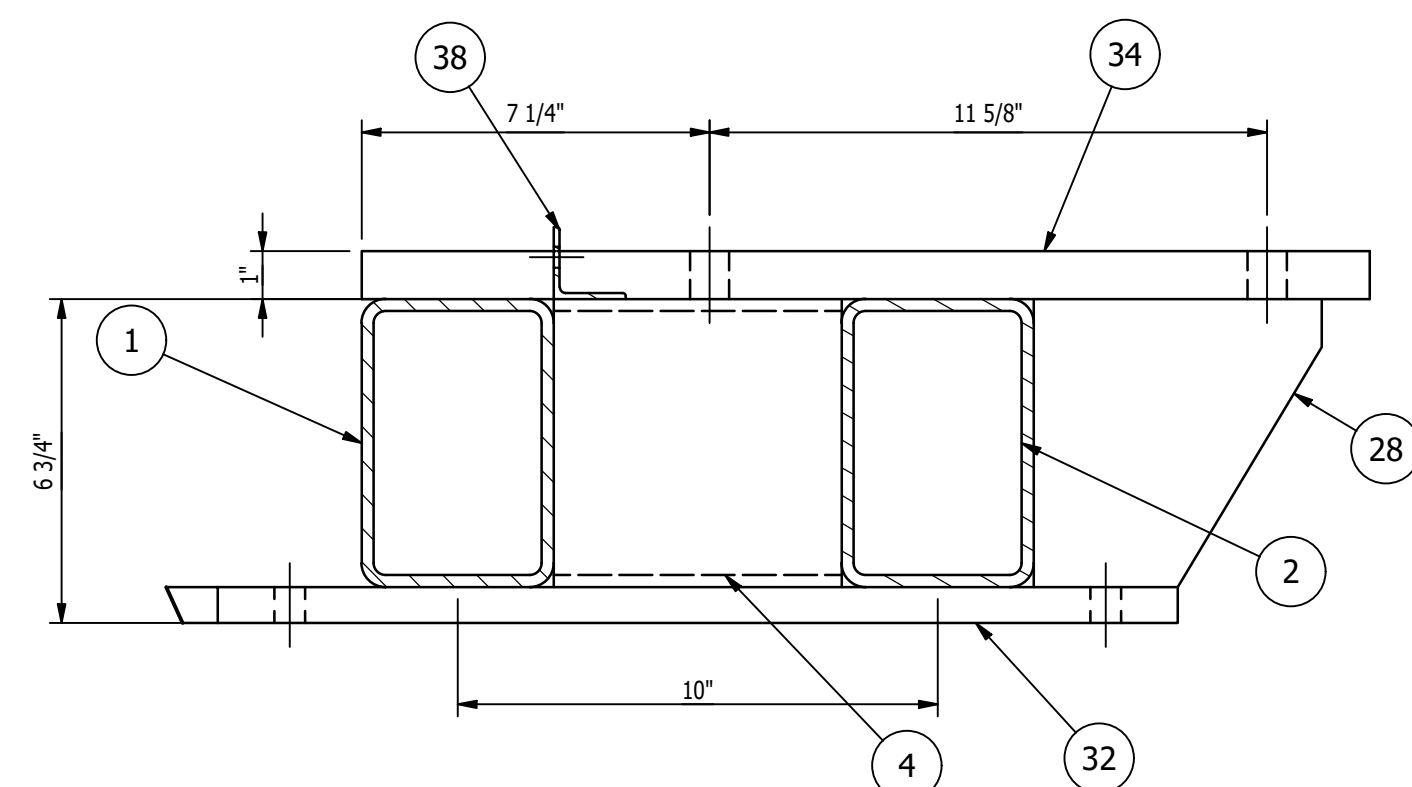
SECTION 'B-B'
SCALE 1"=1'-0"



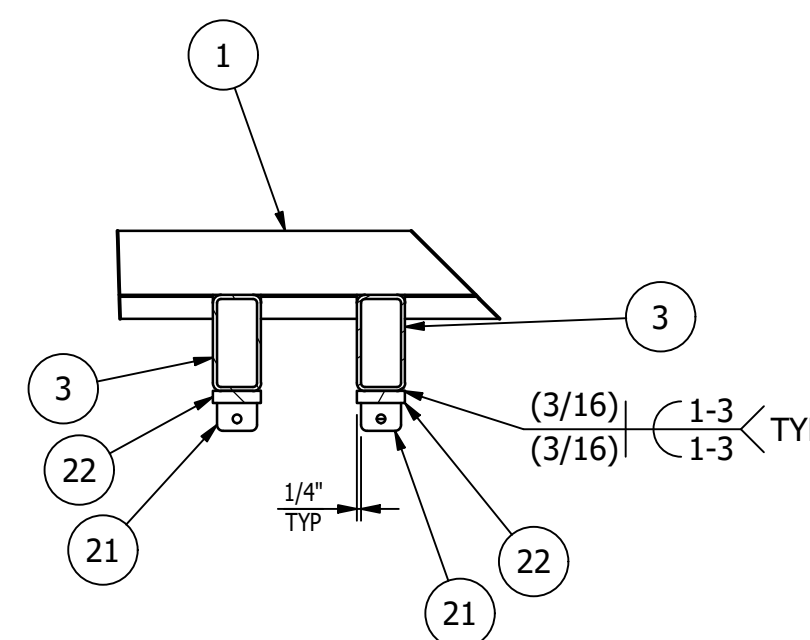
ENLARGED VIEW 'D'
SCALE 1"=1/8"



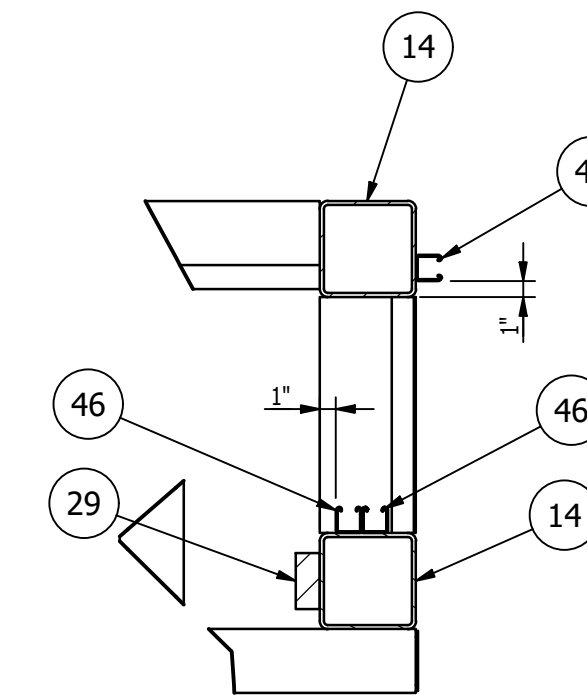
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SCALE 1"=1'-0"



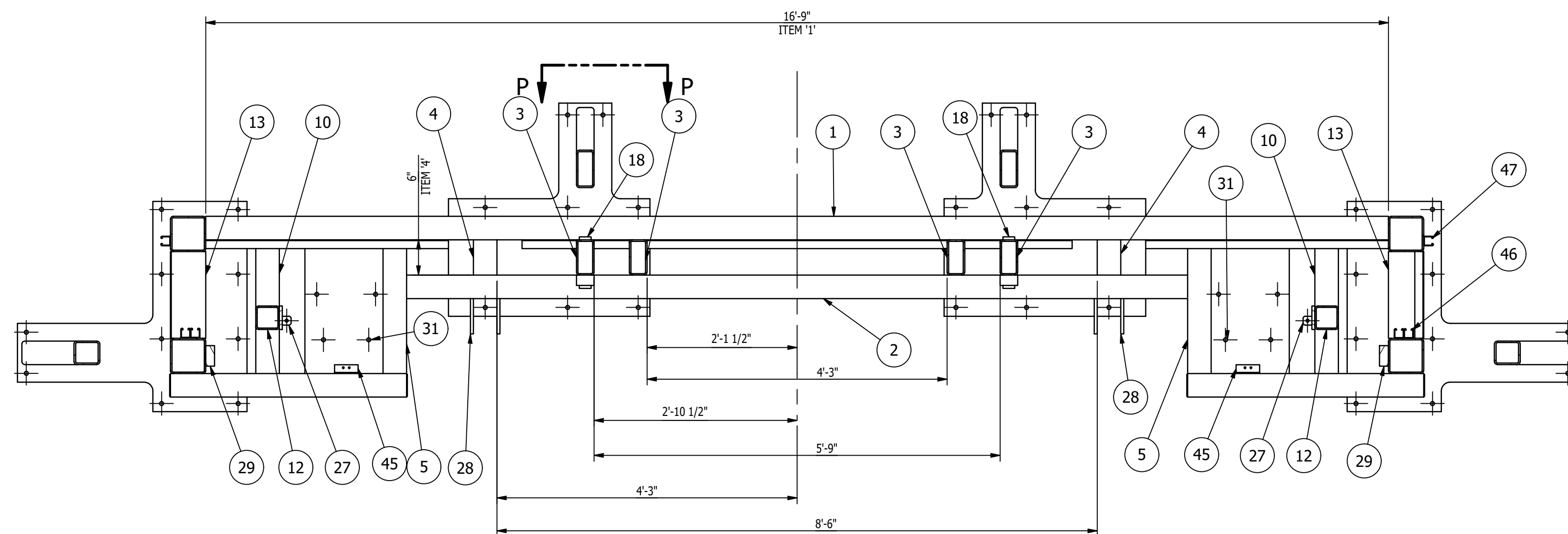
SECTION 'N-N'
SCALE 3"=1'-0"



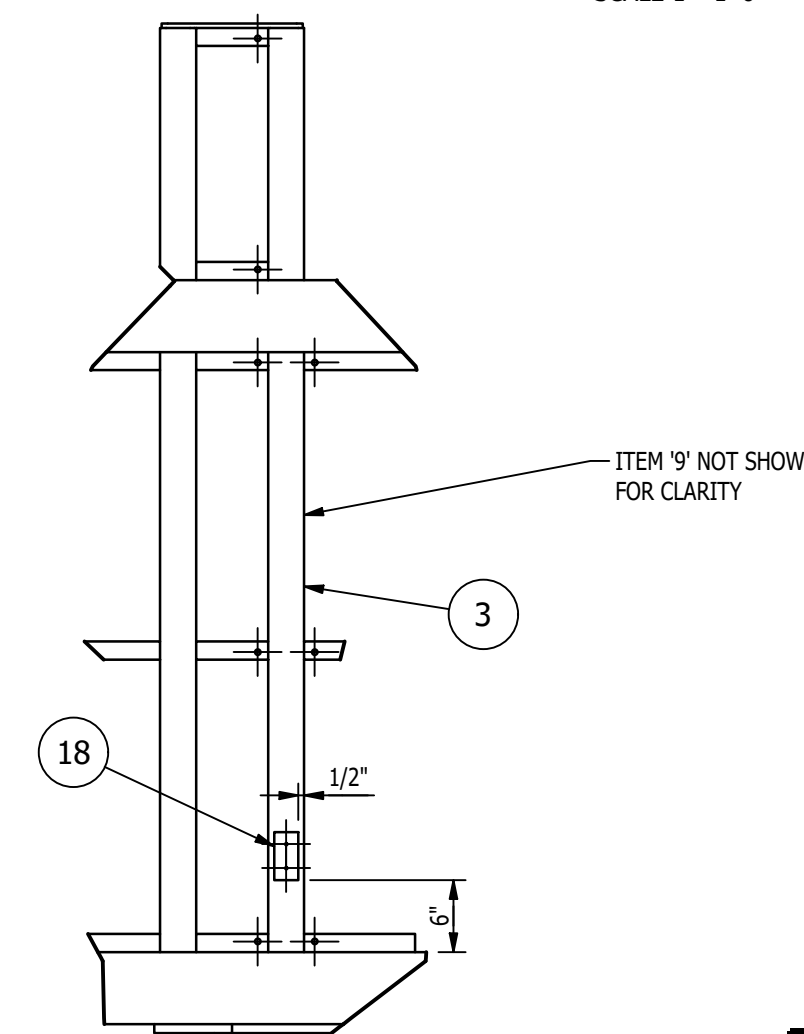
SECTION 'F-F'
SCALE 1"=1'-0"



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



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



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D475A			
1	2	HSS 6 x 4 x 1/4 A500 GR. C	16'-9"		
2	1	HSS 6 x 4 x 1/4 A500 GR. C	11'- 3/4"		
3	4	HSS 6 x 3 x 1/4 A500 GR. C	6'-11"		
4	2	HSS 6 x 4 x 1/4 A500 GR. C	6"		
5	2	HSS 6 x 4 x 1/4 A500 GR. C	1'-10 3/4"		
6	1	HSS 6 x 4 x 1/4 A500 GR. C	3'-4 1/8"		
7	1	HSS 6 x 4 x 1/4 A500 GR. C	3'-4 1/8"		
8	2	HSS 4 x 4 x 1/4 A500 GR.C	11 1/4"		
9	2	HSS 6 x 3 x 1/4 A500 GR.C	5'- 5/16"		
10	2	HSS 4 x 4 x 1/4 A500 GR.C	1'-10 3/4"		
11	2	HSS 4 x 4 x 1/4 A500 GR.C	5'-2"		
12	2	HSS 4 x 4 x 1/4 A500 GR.C	4'-9"		
13	4	HSS 6 x 6 x 1/4 A500 GR.C	1'-2 3/4"		
14	4	HSS 6 x 6 x 1/4 A500 GR.C	5'-2"		
15	2	TS 4 x 4 x 1/4	8 1/2"		
16	4	SHT 10 GA x 3 3/4"	5 3/4"		
17	4	SHT 10 GA x 5 3/4"	5 3/4"		
18	2	PL 1/2 x 2"	4"		
19	2	SHT 10 GA x 3 3/4"	3 3/4"		
20	2	SQ. BAR 1/2	2"		
21	4	BAR 3/4 x 2 1/2	2 1/2"		
22	4	BAR 3/4 x 3	2'- 1/2"		
23	2	BAR 3/8 x 3/4	3"		
24	2	BAR 1/2 x 3	6"		
25	2	BAR 1/2 x 3	3"		
26	4	BAR 1/2 x 4	1'-1 1/2"		
27	4	BAR 3/4 x 1 1/2	1 1/2"		
28	4	BAR 1/2 x 6	6"		
29	2	BAR 1 1/2 x 3 1/2	3'-11"		
30	2	PL 1 3/4 x 3"	1'- 3/4"		
31	2	PL 3/4 x 1'-2"	2'-3 3/4"		
32	2	PL 3/4 x 2'-10 1/4"	3'- 1/4"		
33	2	PL 3/4 x 2'-11 3/4"	3'-3"		
34	2	PL 1 x 1'- 1/2"	1'-9"		
35	2	PL 3/8 x 5 3/4"	11 3/4"		
36	4	L 1 1/2 x 1 1/2 x 1/8	5'-3"		
37	3	L 1 1/2 x 1 1/2 x 1/8	4'-3"		
38	1	L 1 1/2 x 1 1/2 x 1/8	3'-5 1/4"		
39	1	L 1 1/2 x 1 1/2 x 1/8	3'-5 1/4"		
40	1	L 1 1/2 x 1 1/2 x 1/8	9 1/4"		
41	1	L 1 1/2 x 1 1/2 x 1/8	9 1/4"		
42	5	L 1 1/2 x 1 1/2 x 1/8	6"		
43	5	L 1 1/2 x 1 1/2 x 1/8	6"		
44	4	L 1 1/2 x 1 1/2 x 1/8	1'-2 3/4"		
45	2	L 1 1/2 x 1 1/2 x 3/16	4"		
46	4	UNISTRUT 1-5/8" x 1-5/8" 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	3'-7"		
47	2	UNISTRUT 1-5/8" x 1-5/8" 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	2'-7"		

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED VIEW 'P-P', CORRECTED NOTES ON DIMENSIONS	
A	MC	11/14/22	FOR FABRICATION	

SHEET 2 OF 4

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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Suite 125
North, MI 48875

Phone: (248) 373-8822
Fax: (248) 373-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D475

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

mi 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. **1875D475**

REV: **B**

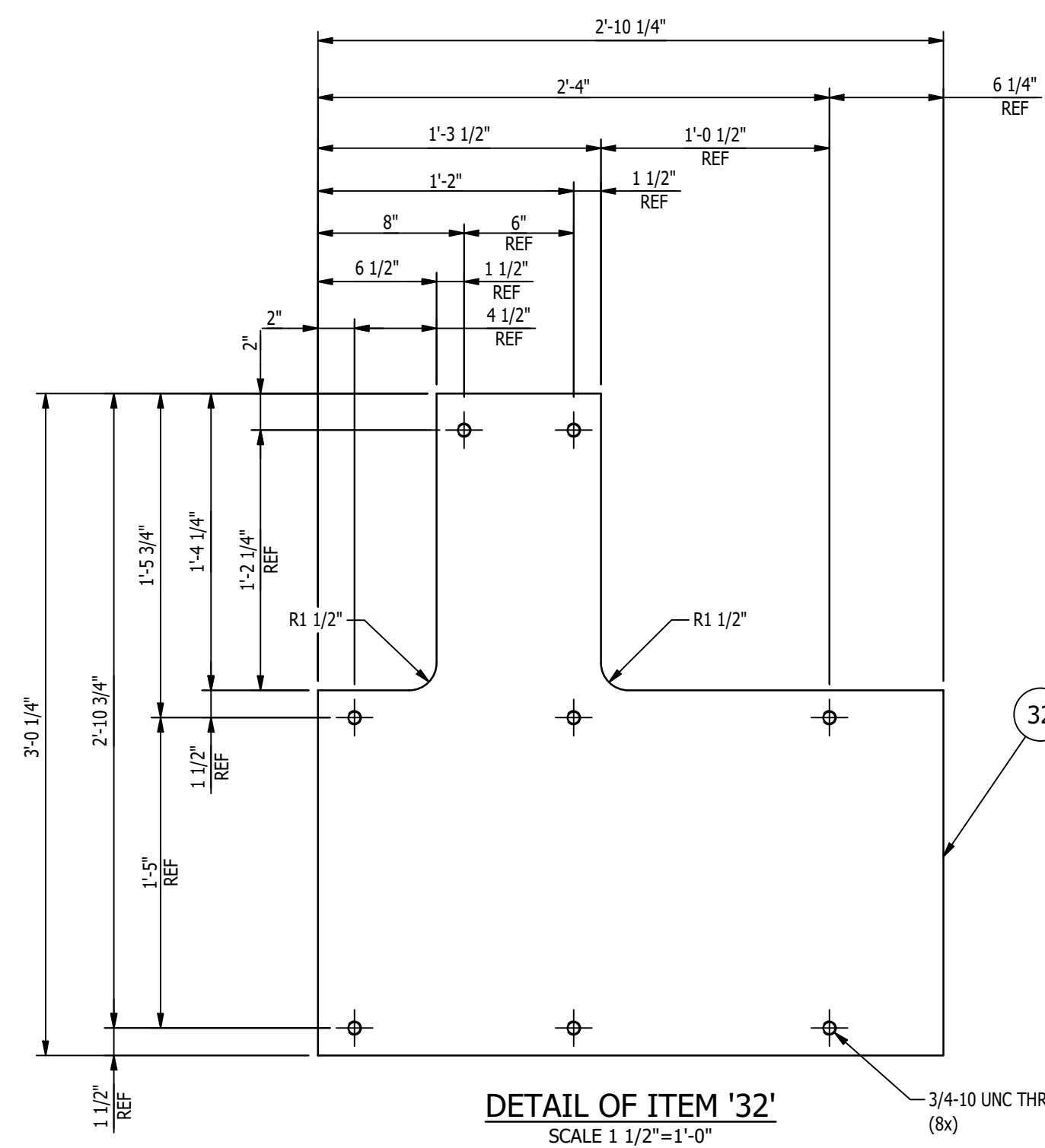
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CHECKED BY: **CW**

DWG DATE: **10/31/22**

JOB No: **22096**

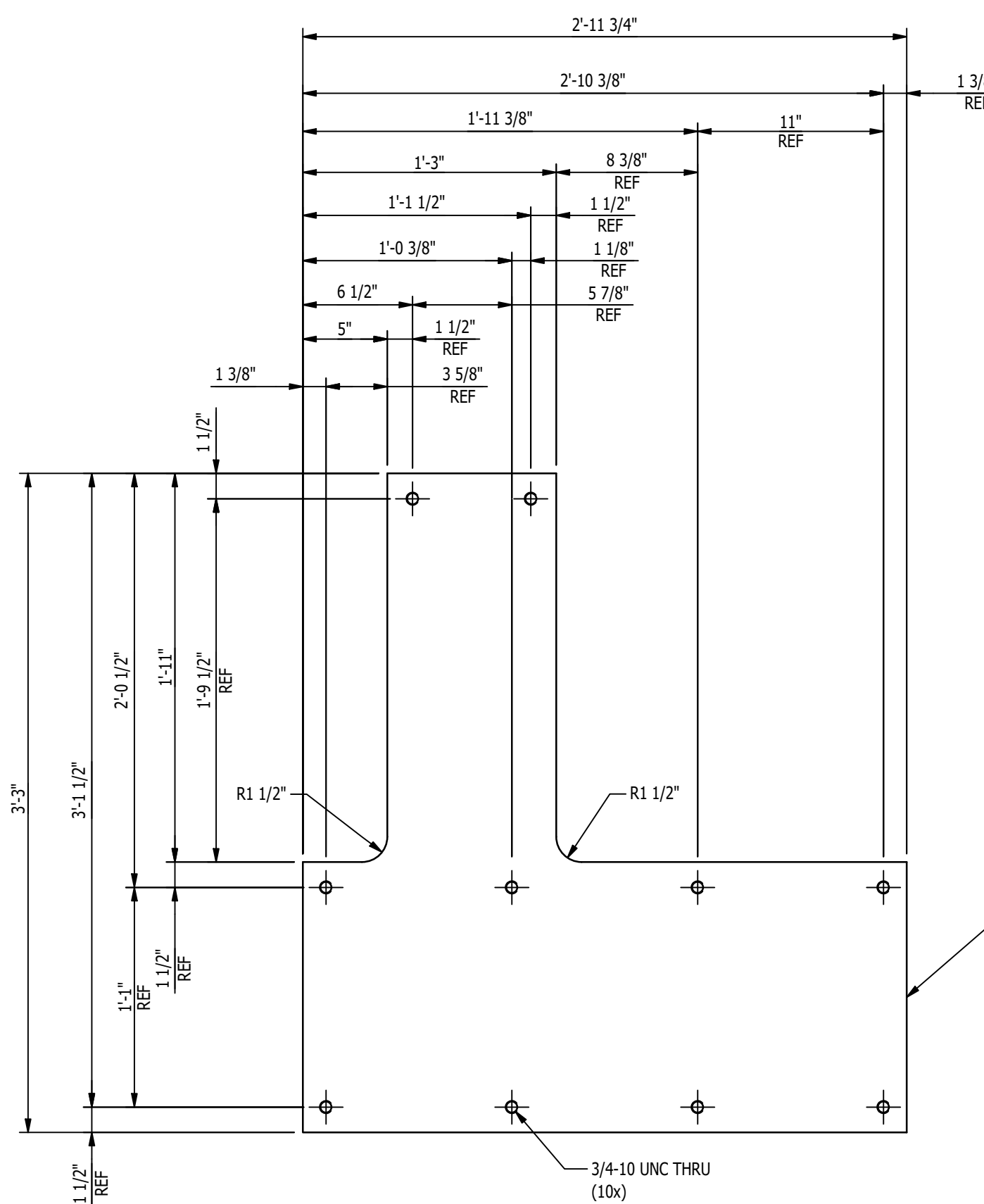
3:00 PM 11/28/2022 11:28 AM LIT Res/DWG/1875D475 - REV B.dwg



DETAIL OF ITEM '32'
SCALE 1 1/2"=1'-0"

3/4-10 UNC THRU (8x)

3/4"

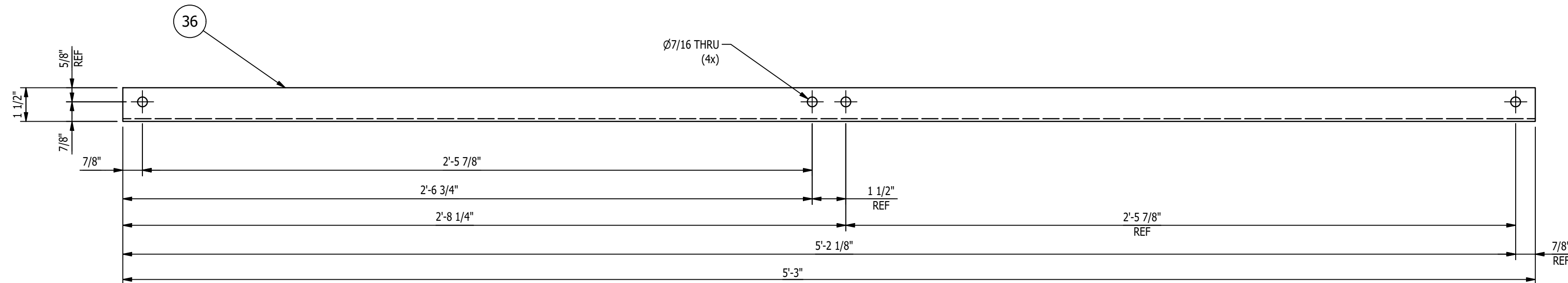


DETAIL OF ITEM '33'
SCALE 1 1/2"=1'-0"

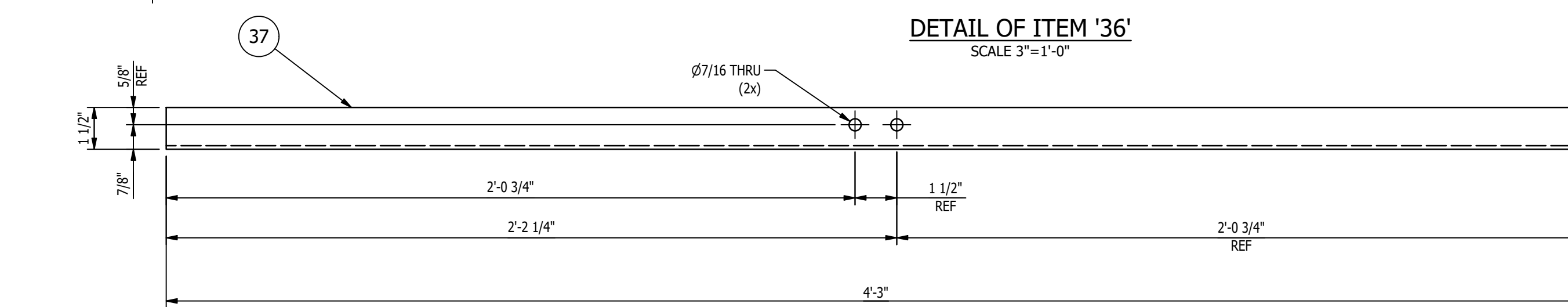
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3/4"

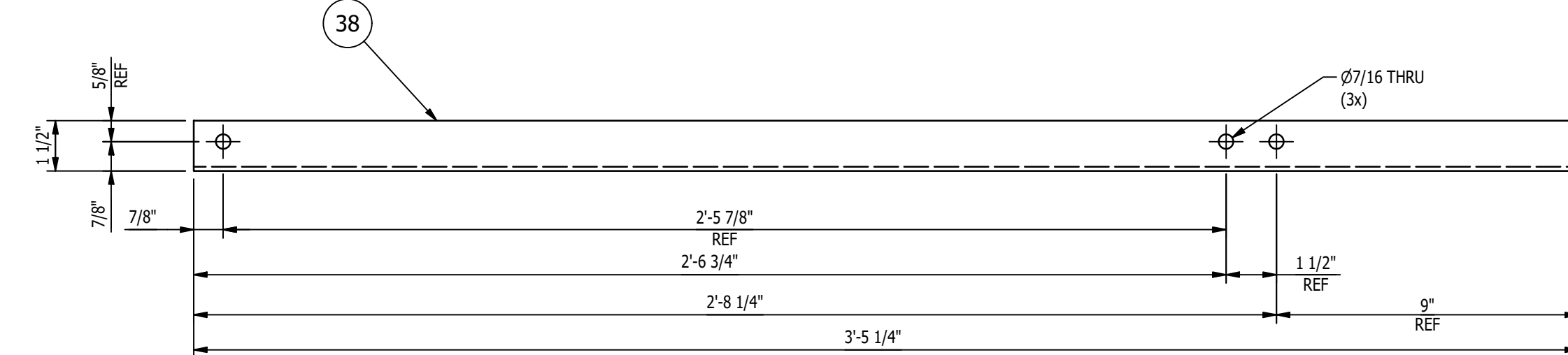
3/4"



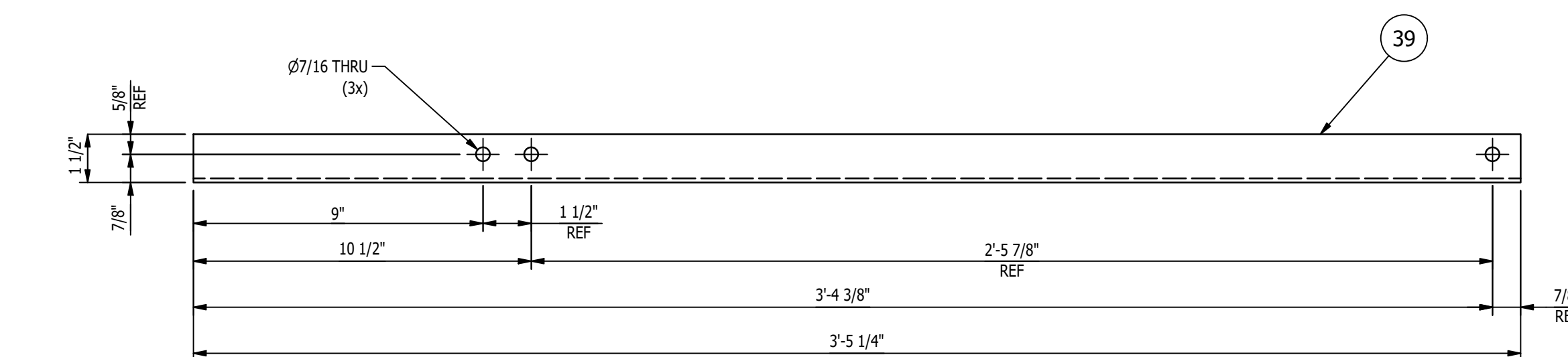
DETAIL OF ITEM '36'
SCALE 3"=1'-0"



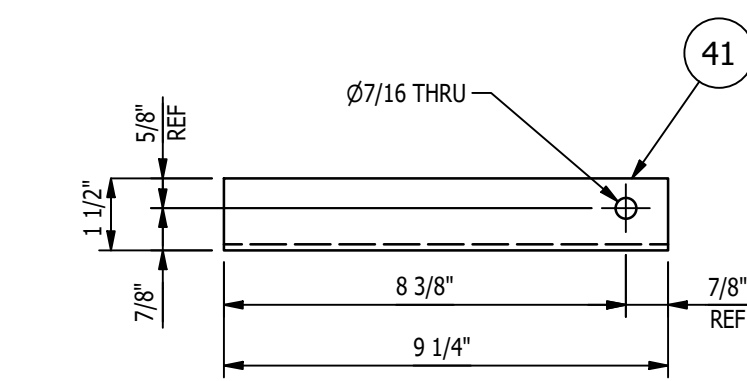
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SCALE 3"=1'-0"



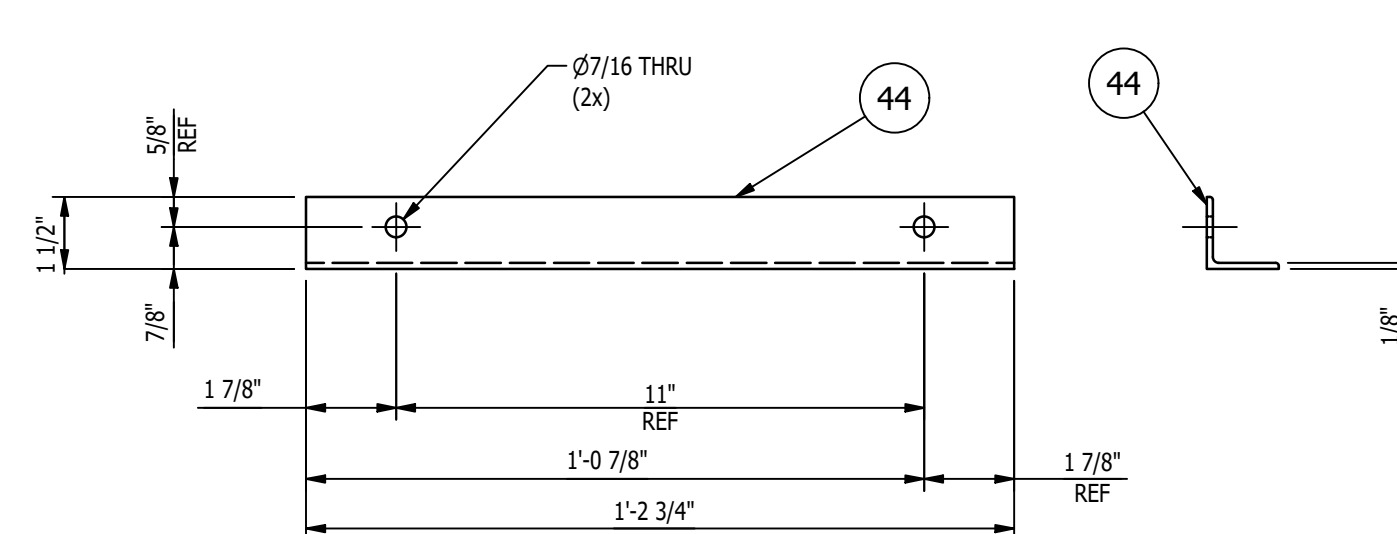
DETAIL OF ITEM '38'
SCALE 3"=1'-0"



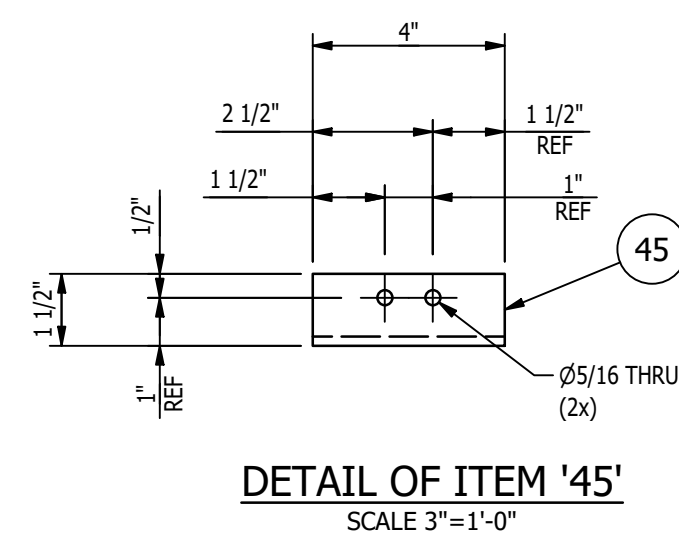
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SCALE 3"=1'-0"



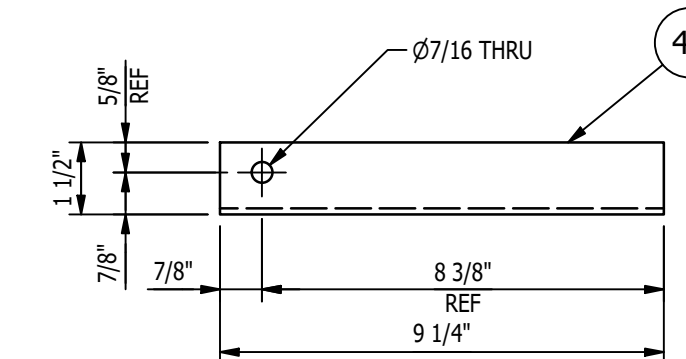
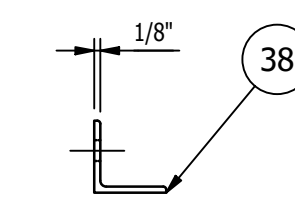
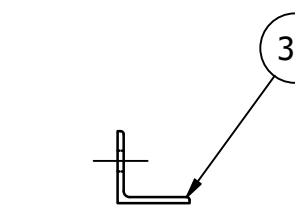
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SCALE 3"=1'-0"



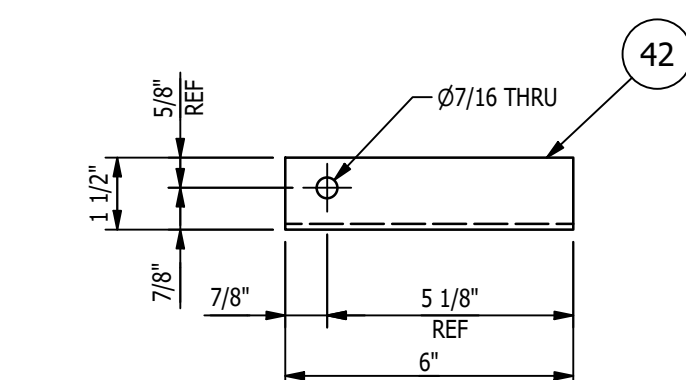
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SCALE 3"=1'-0"



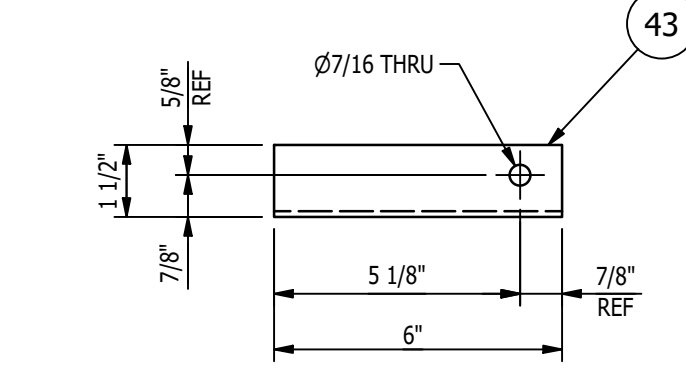
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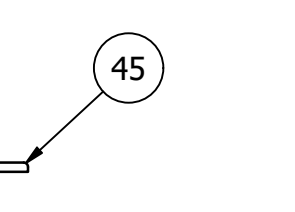
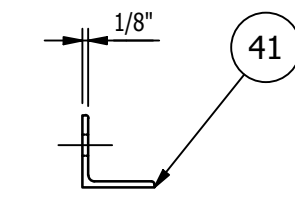
DETAIL OF ITEM '40'
SCALE 3"=1'-0"



DETAIL OF ITEM '42'
SCALE 3"=1'-0"



DETAIL OF ITEM '43'
SCALE 3"=1'-0"



SHEET 3 OF 4

GENERAL NOTES:

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 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
- HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
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- WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)
- PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
- COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

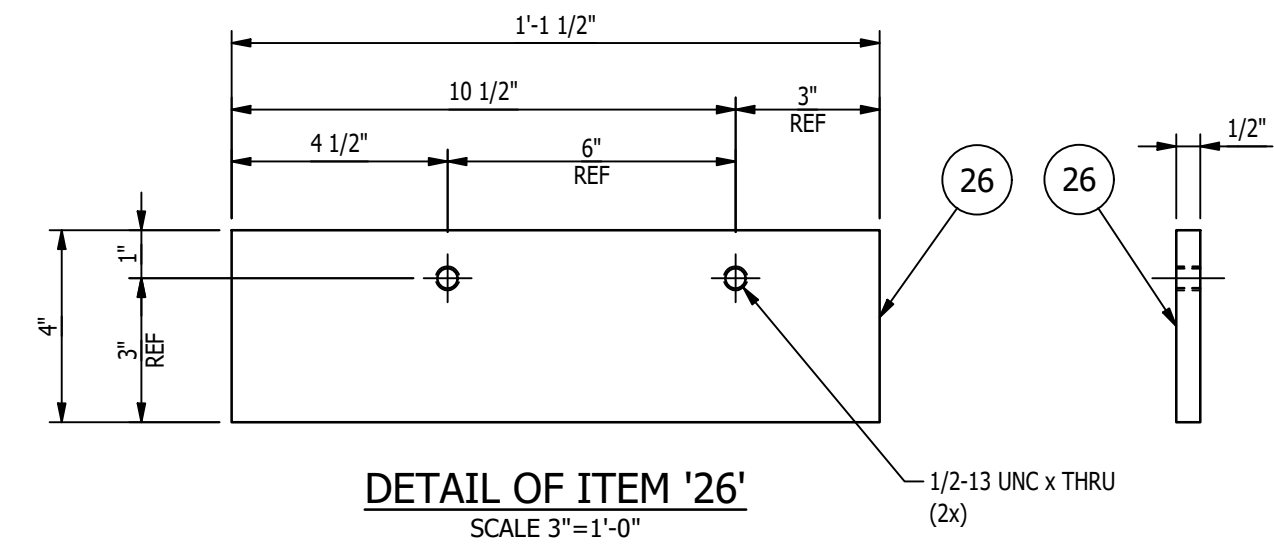
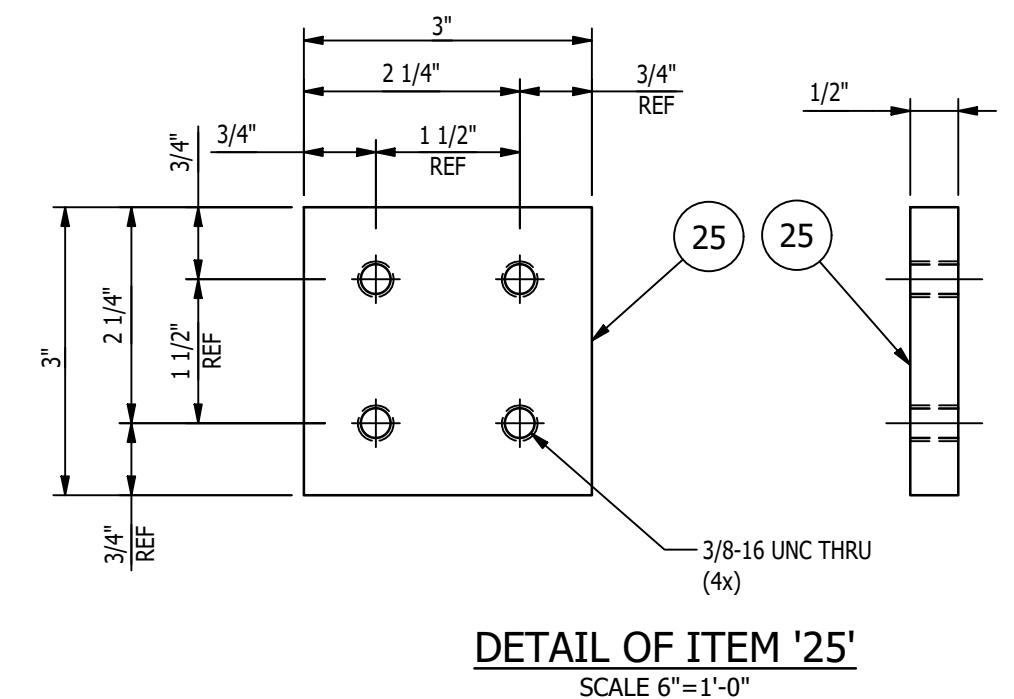
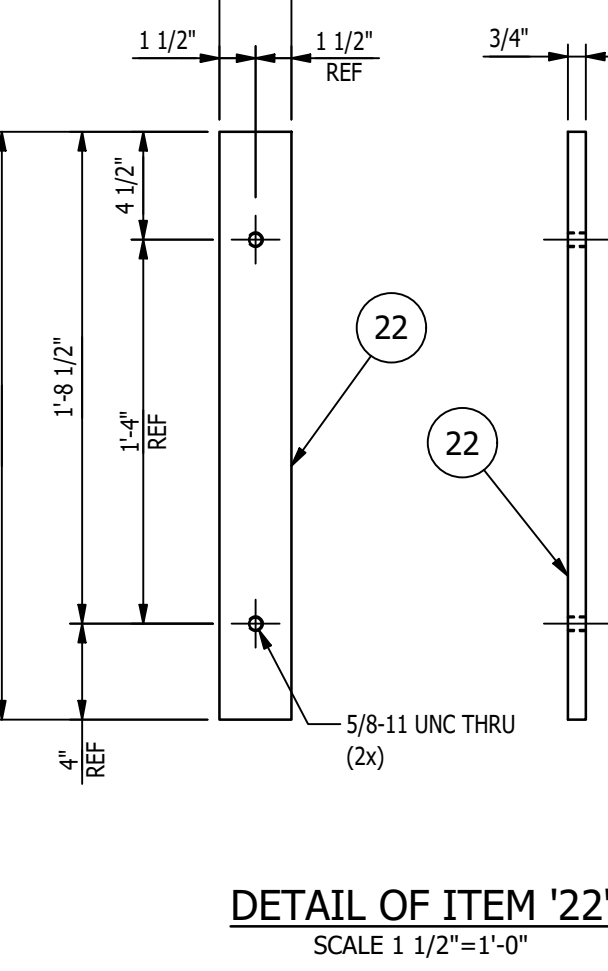
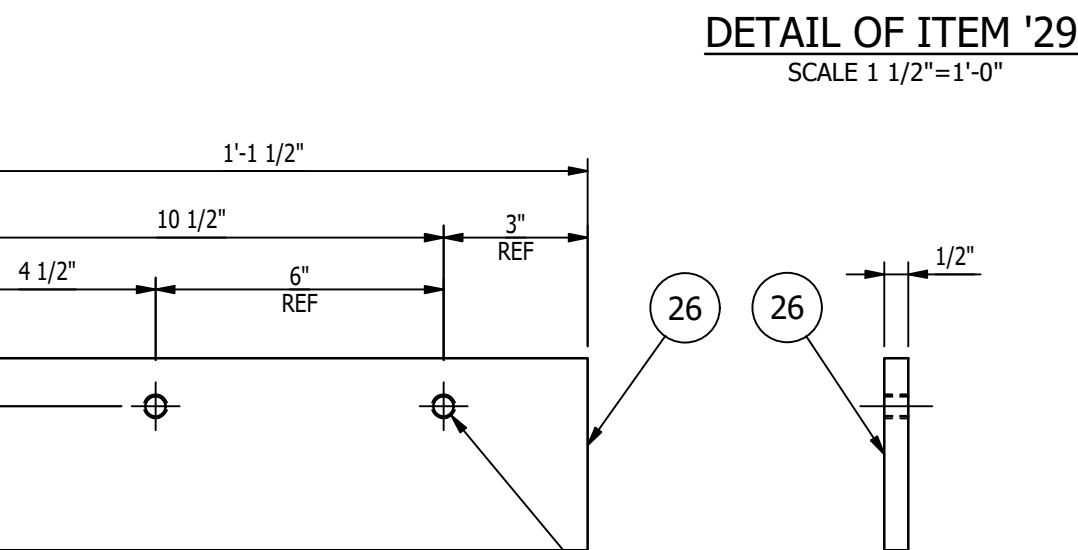
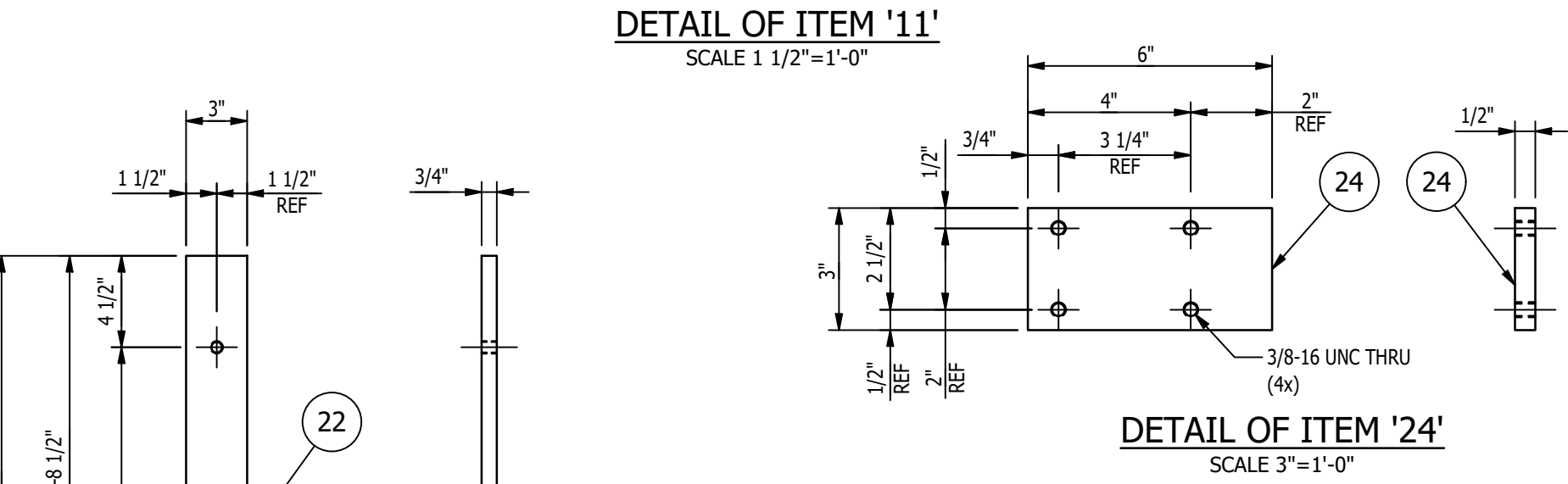
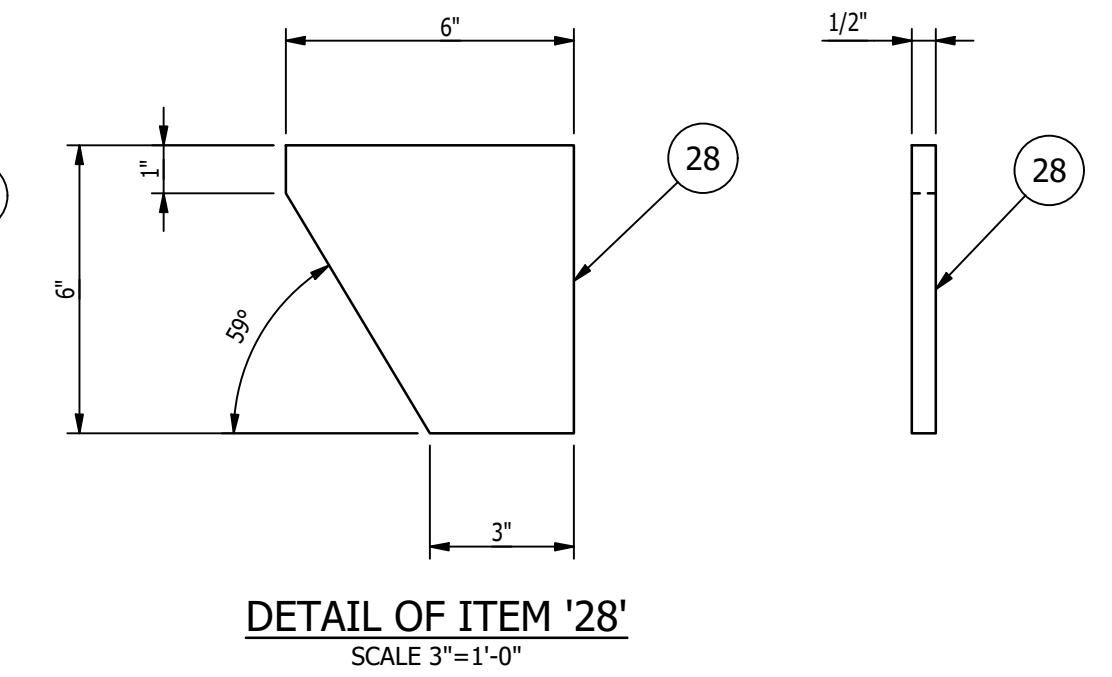
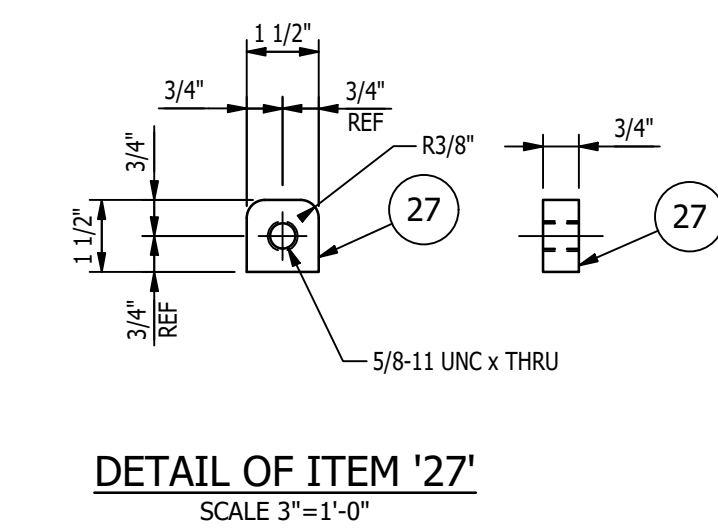
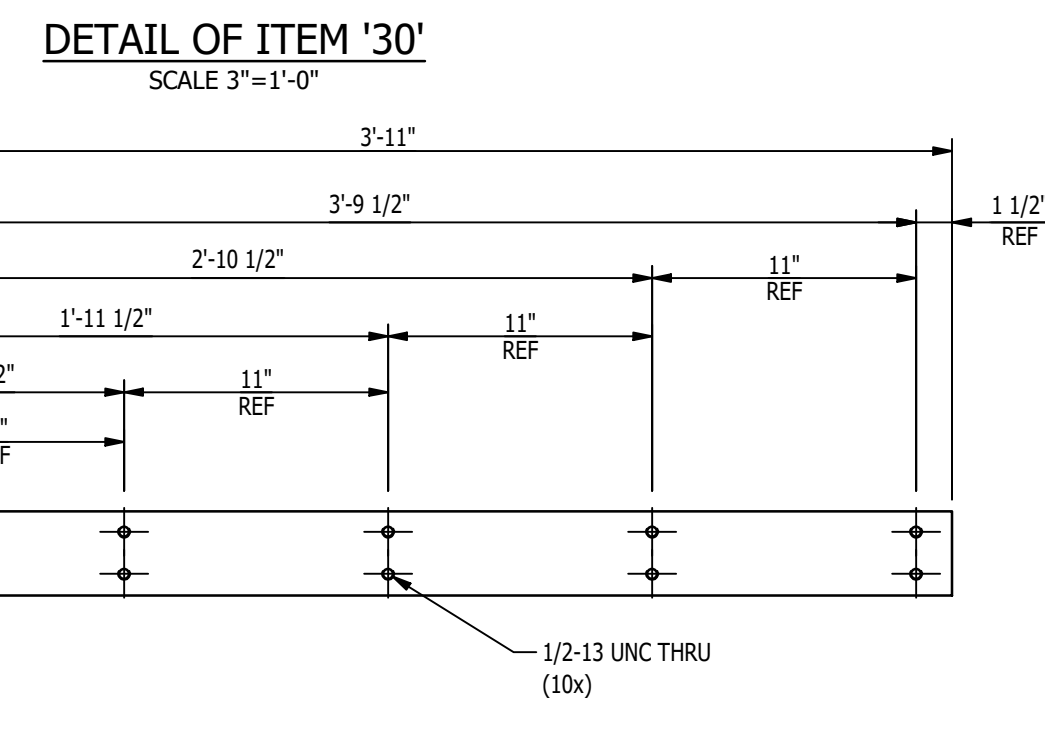
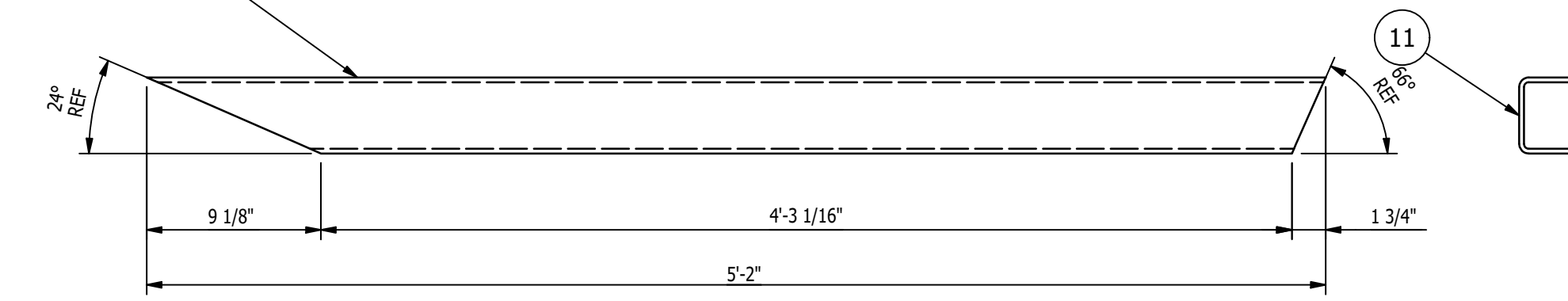
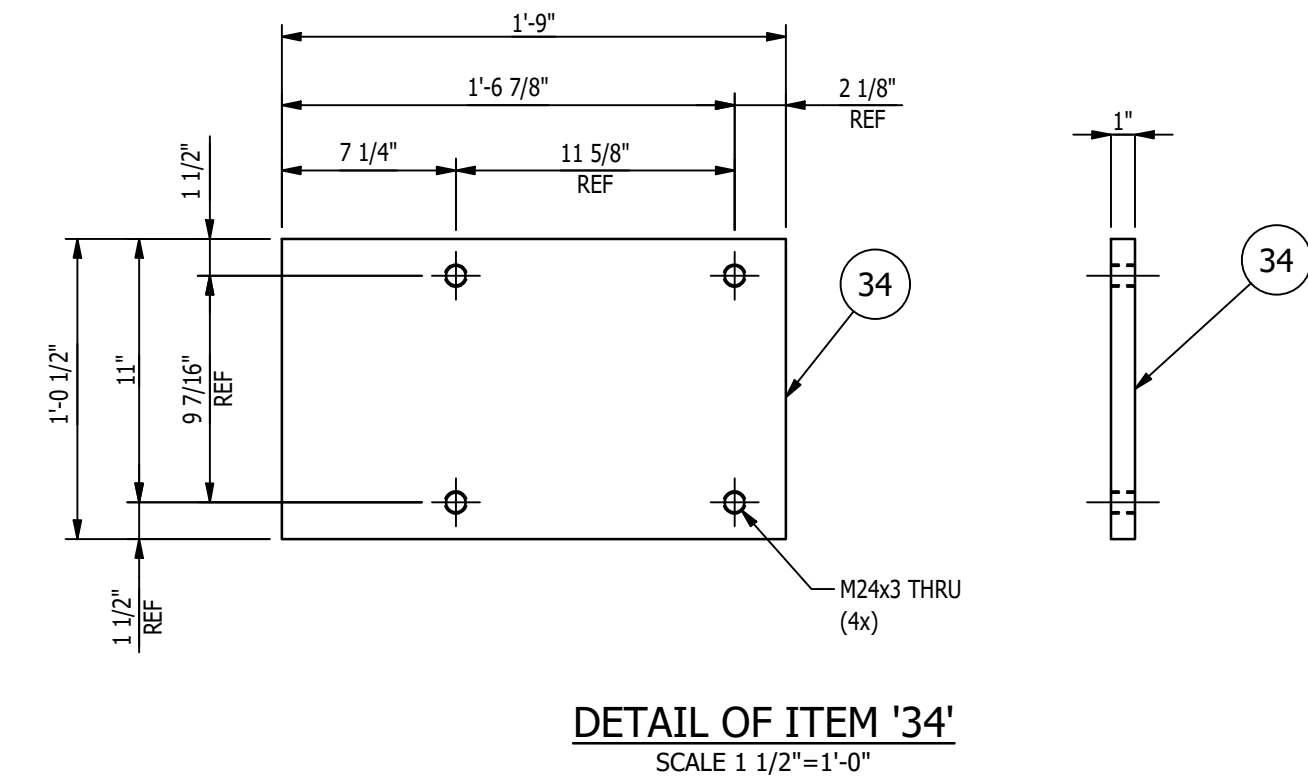
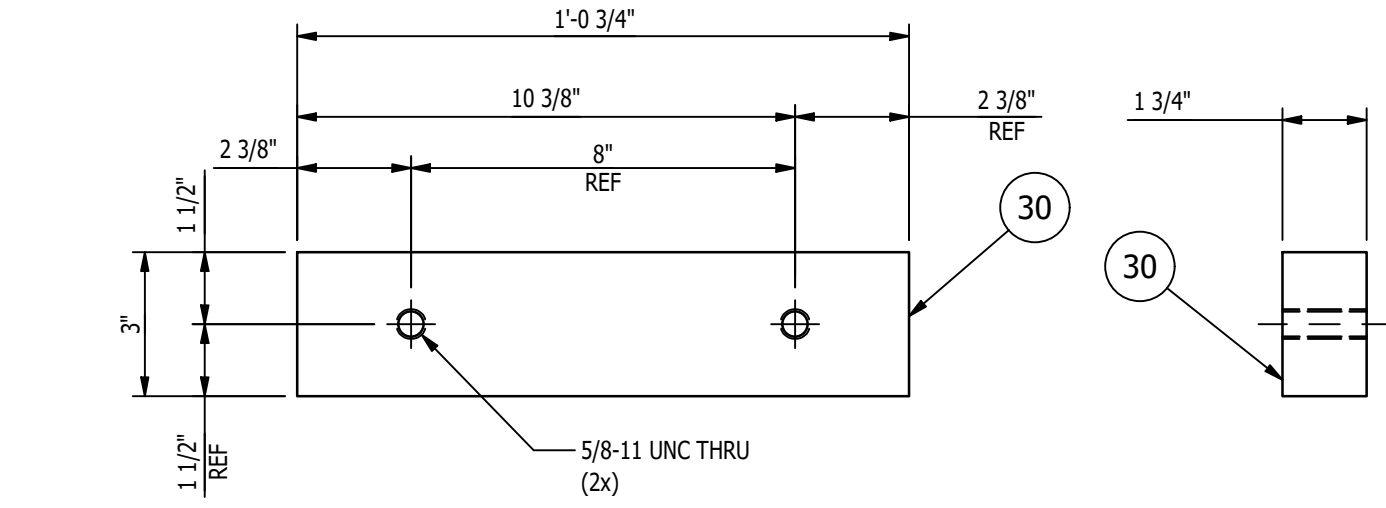
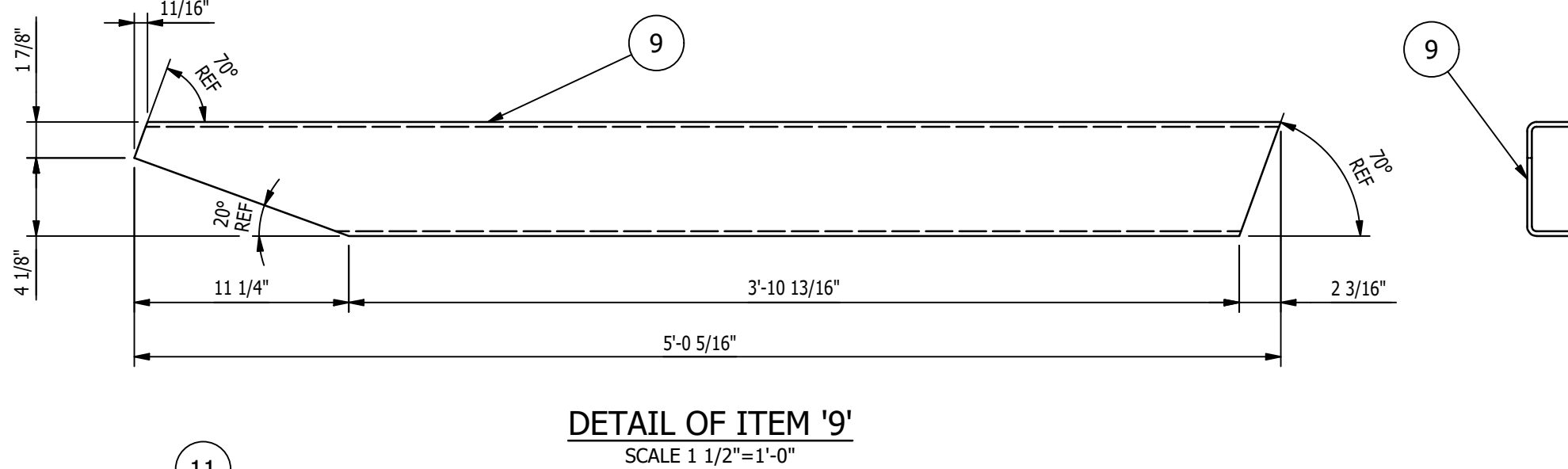
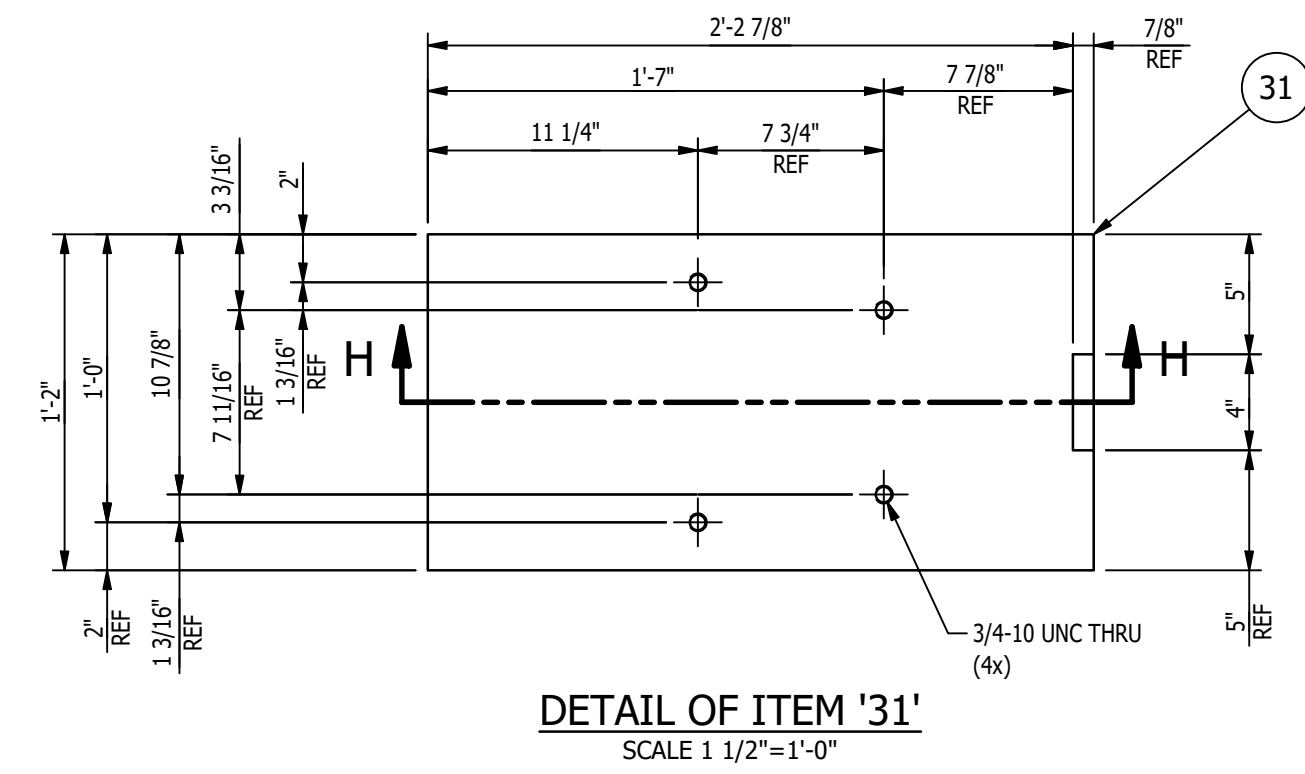
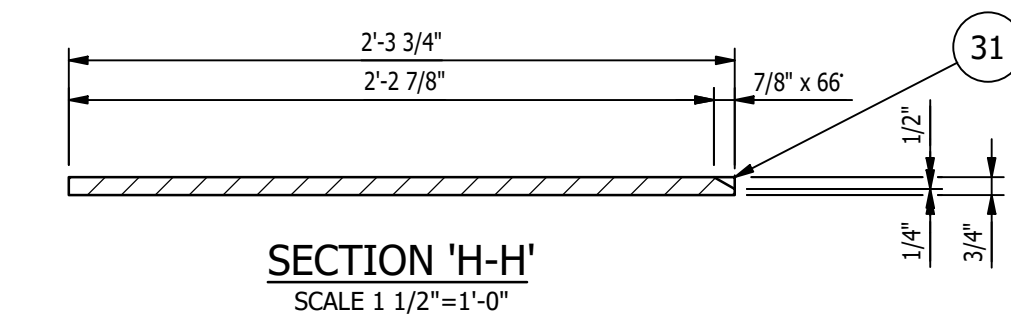
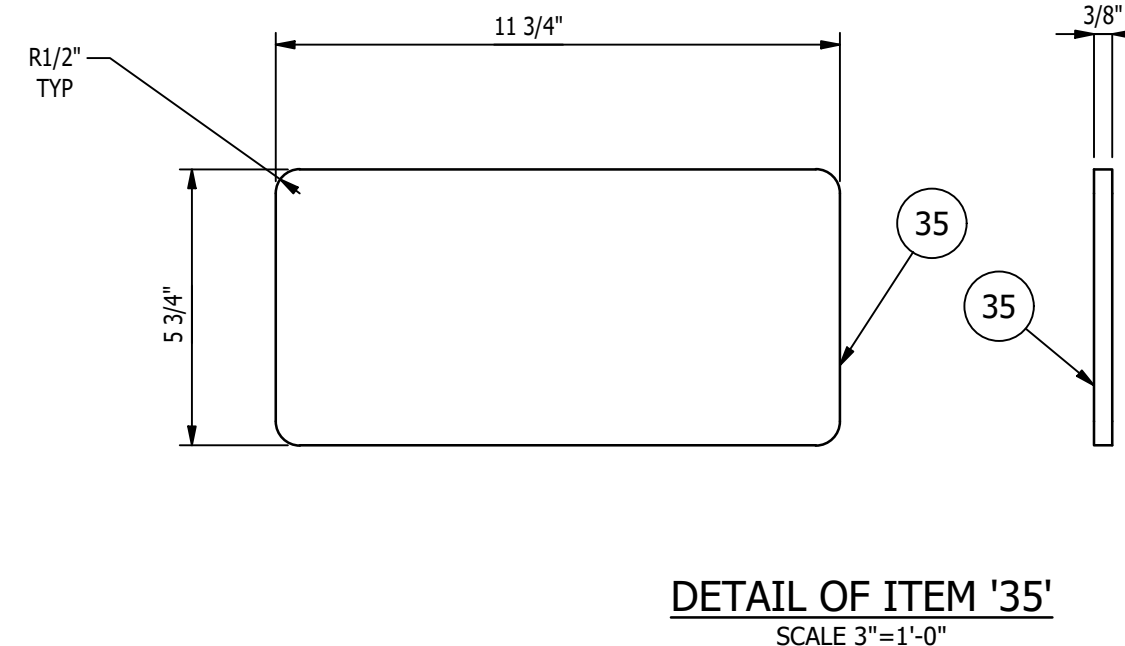
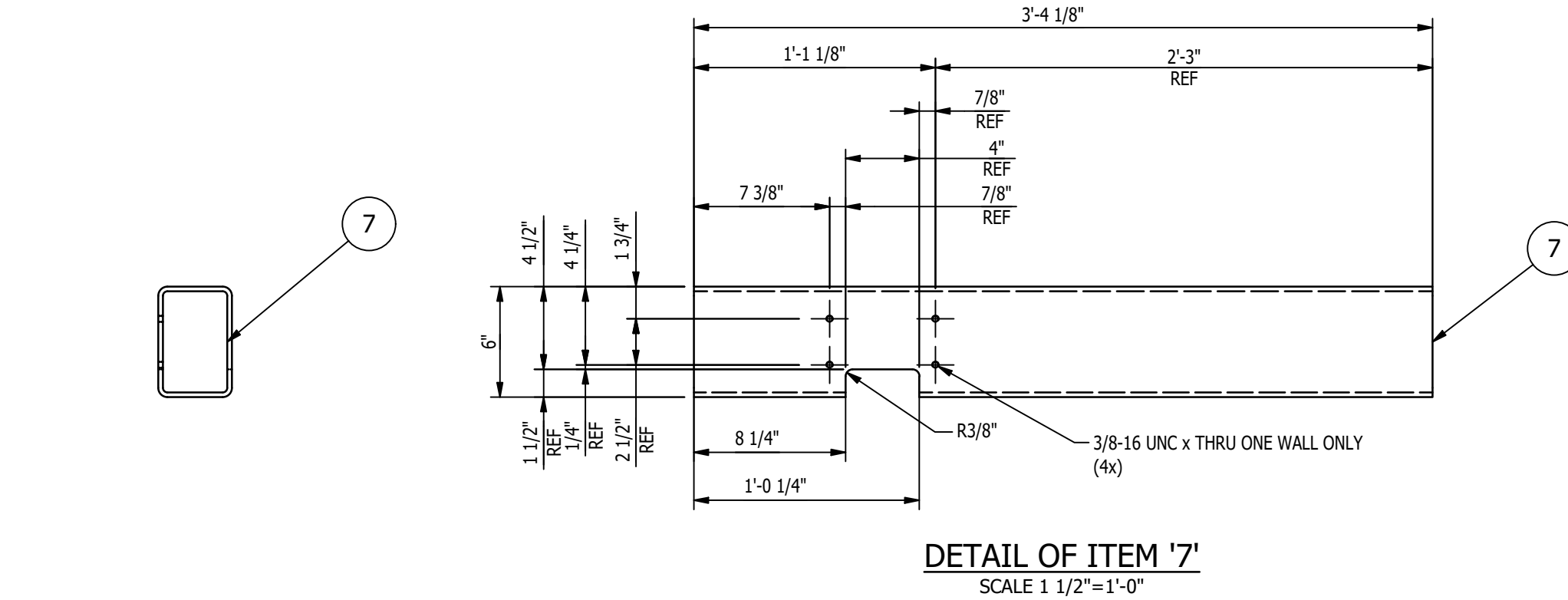
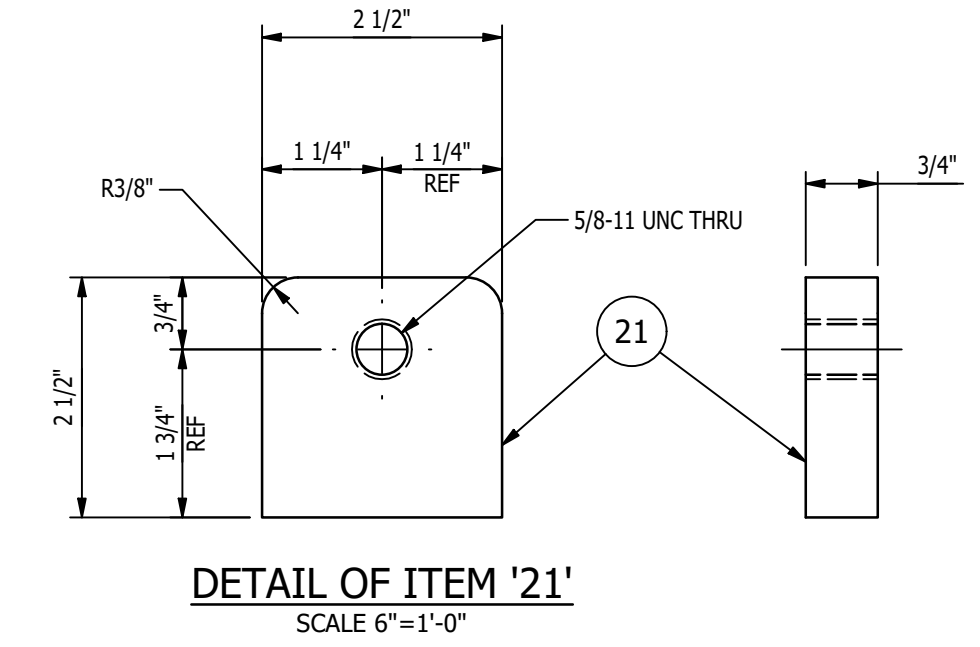
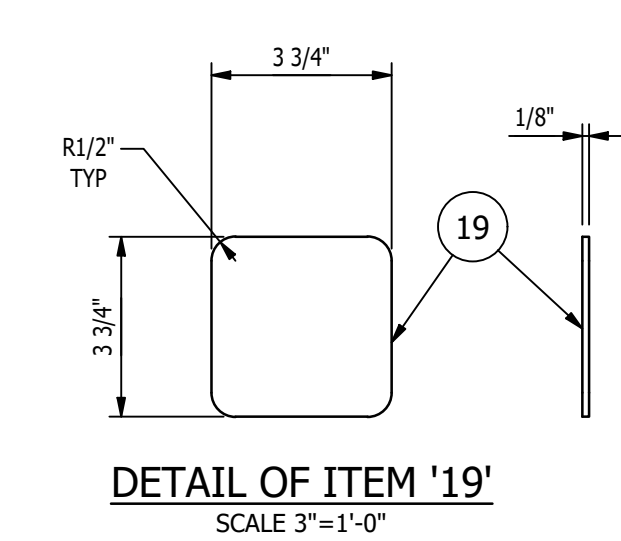
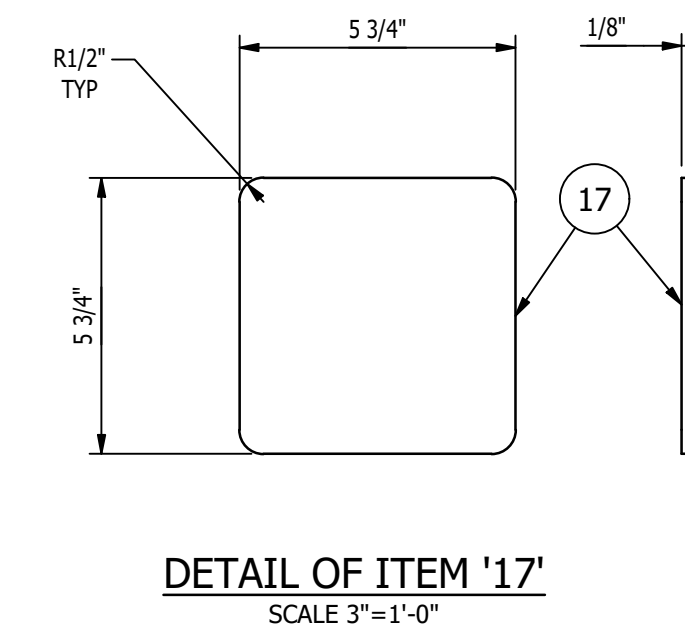
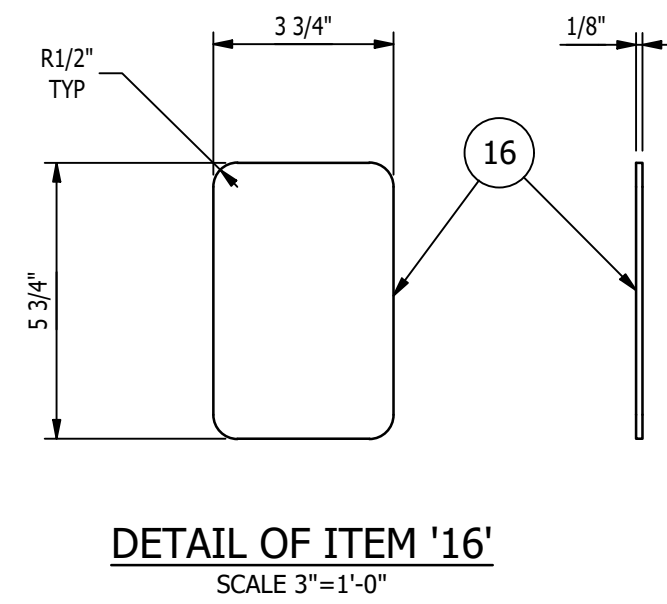
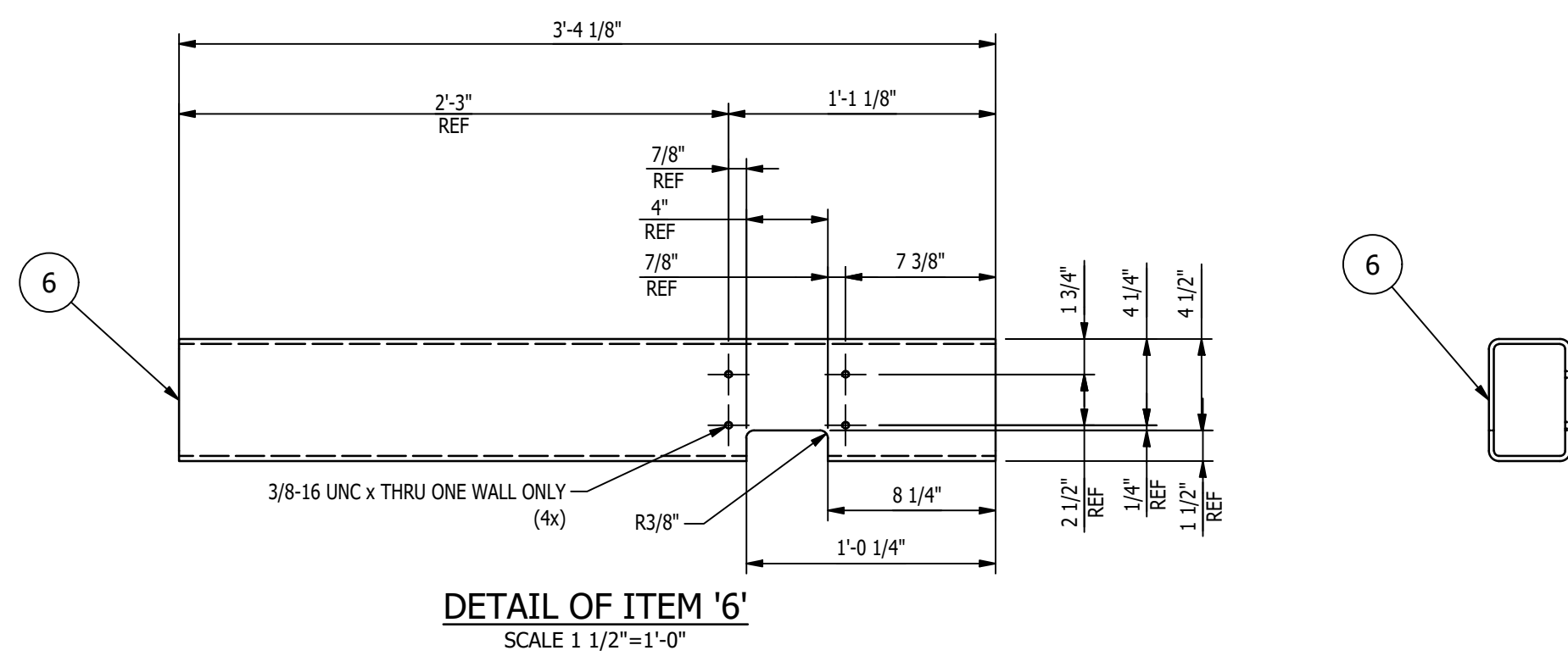
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 41100 Greenbrook Rd.
 Suite 125
 Wood, MI 48095
 Phone: (248) 773-8899
 Fax: (248) 773-8891
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D475

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED VIEW 'P-P', CORRECTED NOTES ON DIMENSIONS	
A	MC	11/14/22	FOR FABRICATION	

<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.com</p>	<p>TITLE: P6700 CONVEYORS CAMPUS BUILDING</p> <p>CLIENT: VOLVO</p> <p>DRAWING No. 1875D475</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>



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 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

SHEET 4 OF 4
 GENERAL NOTES:
 MATERIALS:
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 WELDS:
 - ALL WELDS TO BE "E70XX"; (PER AWS D1.1)
 PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
 COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED VIEW 'P-P', CORRECTED NOTES ON DIMENSIONS	
A	MC	11/14/22	FOR FABRICATION	

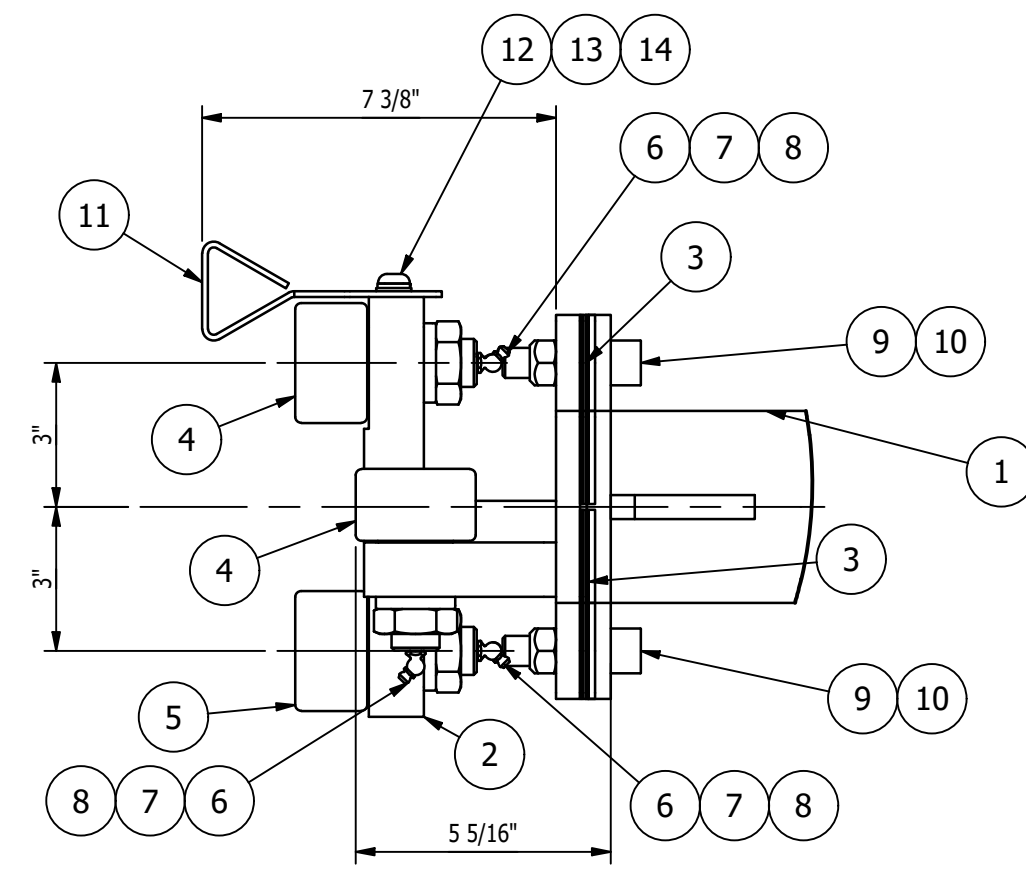
MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D475

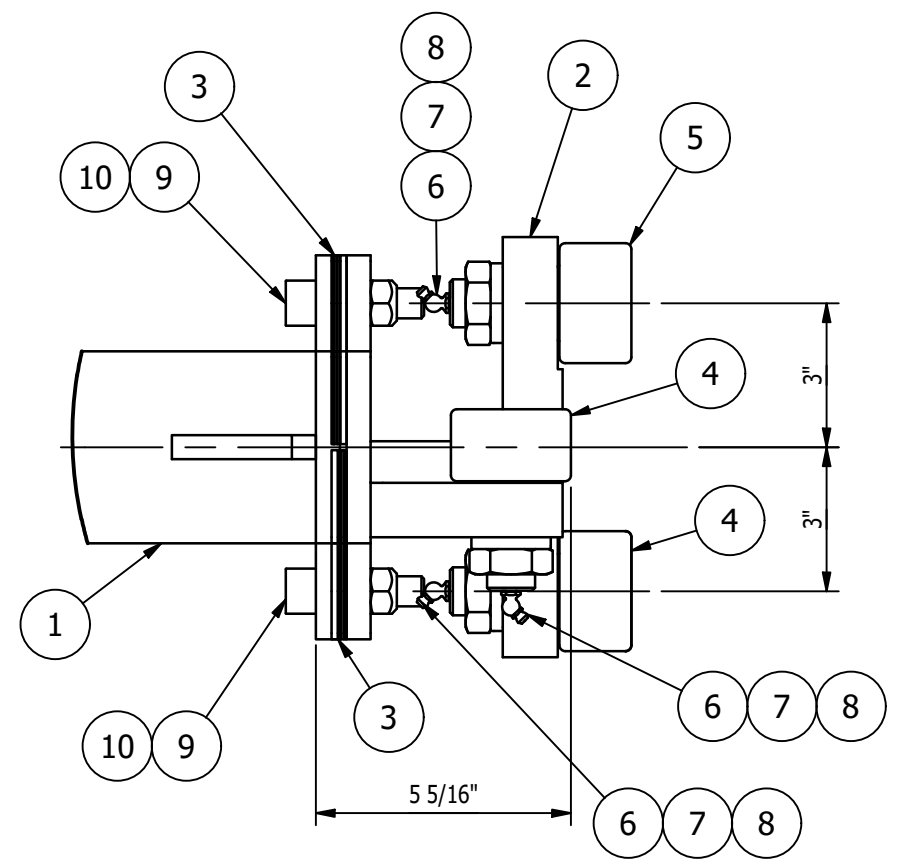
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DRAWN BY: BTC
CHECKED BY: CW
DWG DATE: 10/31/22
REV: B
JOB No: 22096

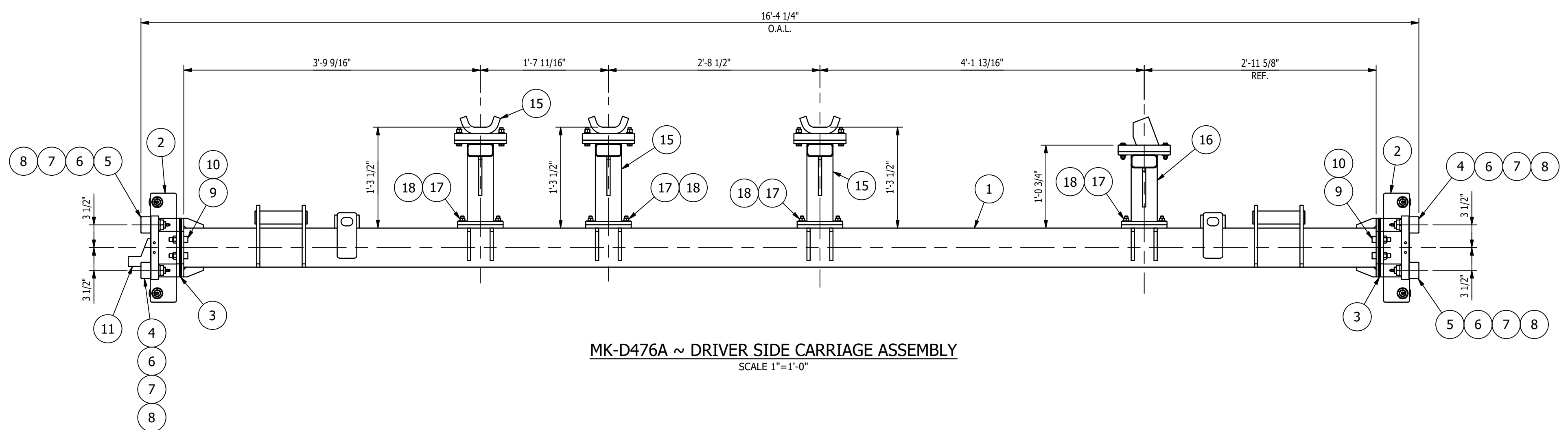
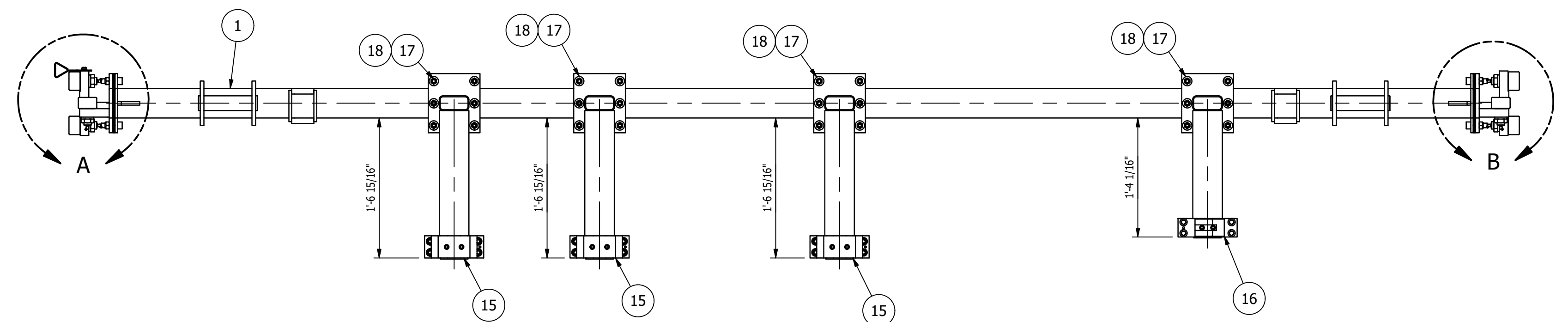
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D476A			
1	1	MK-D477A ~ AUX LIFT CARRIAGE WELDMENT ~ DRIVER SIDE			
2	2	MK-D482B ~ CAM GUIDE ROLLER MACHINING			
3	4	MK-D491A ~ SHIM PACK			
4	8	PCI CONCENTRIC PLAIN DCB ROLLER, 2.5" ROLLER OD, 1.5" ROLLER WIDTH, 1-14 UNF THREAD, PCI PART NO. PDC-2.50-R		25-9	
5	4	PCI ECCENTRIC PLAIN DCB ROLLER, 2.5" ROLLER OD, 1.5" ROLLER WIDTH, 1-14 UNF THREAD, PCI PART NO. PDCE-2.50-R		25-10	
6	12	1-14UNS HEX JAM NUT			
7	12	1 SPRING LOCK WASHER			
8	12	GREASE FITTING, 45 DEG ELBOW, 1/4" DRIVE FITTING		26-8	
9	8	5/8-11UNC x 2 1/4" LG. HEX SOCKET HEAD CAP SCREW			
10	8	5/8-11UNC STOVER LOCK NUT			
11	1	MK-D489A ~ PROX BRACKET			
12	2	3/8 TYPE B NARROW FLAT WASHER			
13	2	3/8 SPRING LOCK WASHER			
14	2	3/8-16UNC x 3/4" LG. BUTTON HEX SOCKET HEAD CAP SCREW			
15	3	MK-D412A ~ AUX LIFT ARM ASSEMBLY - DRIVER SIDE			
16	1	MK-D414A ~ AUX LIFT ARM ASSEMBLY - LH			
17	24	1/2 TYPE B REGULAR FLAT WASHER			
18	24	1/2-13UNC STOVER LOCK NUT			



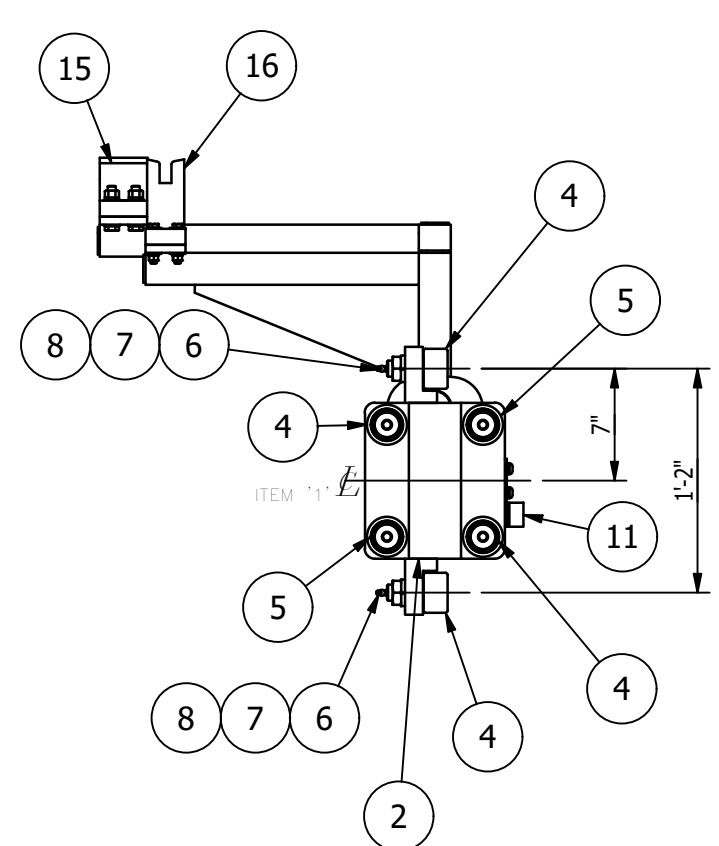
ENLARGED VIEW 'A'
SCALE 3"=1'-0"



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



MK-D476A ~ DRIVER SIDE CARRIAGE ASSEMBLY
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	11/28/22	UPDATED GEOMETRY PER ITEMS '15' & '16'	
A	MC	11/15/22	FOR FABRICATION	

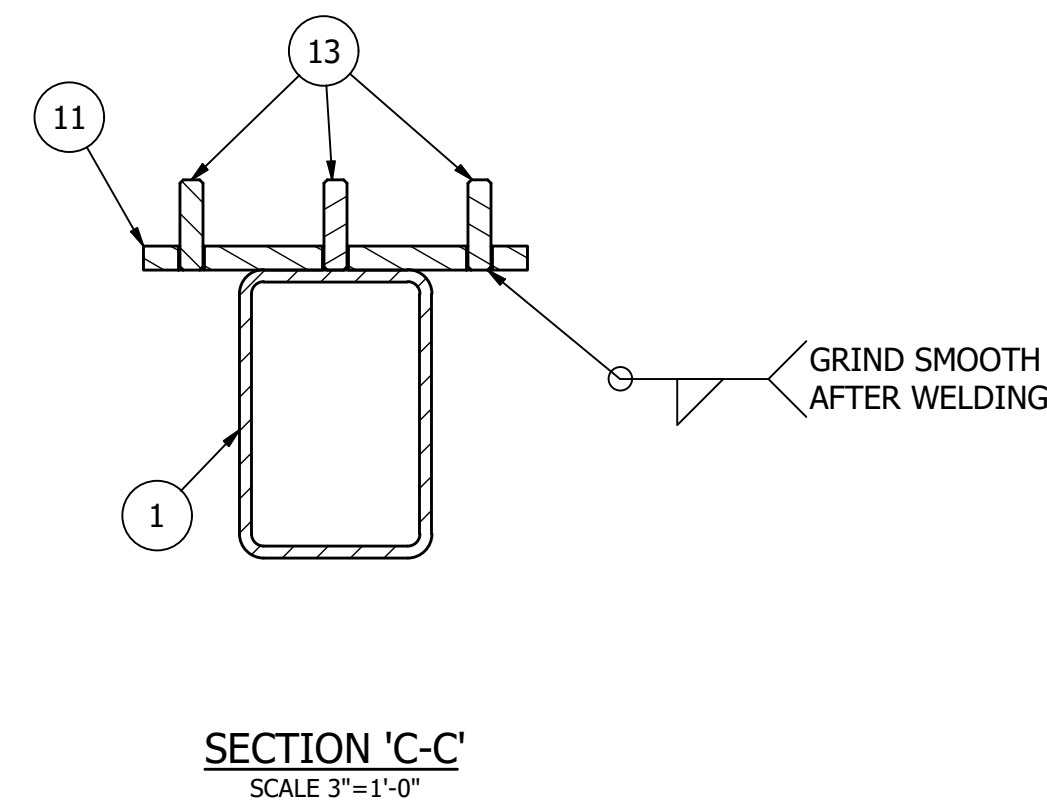
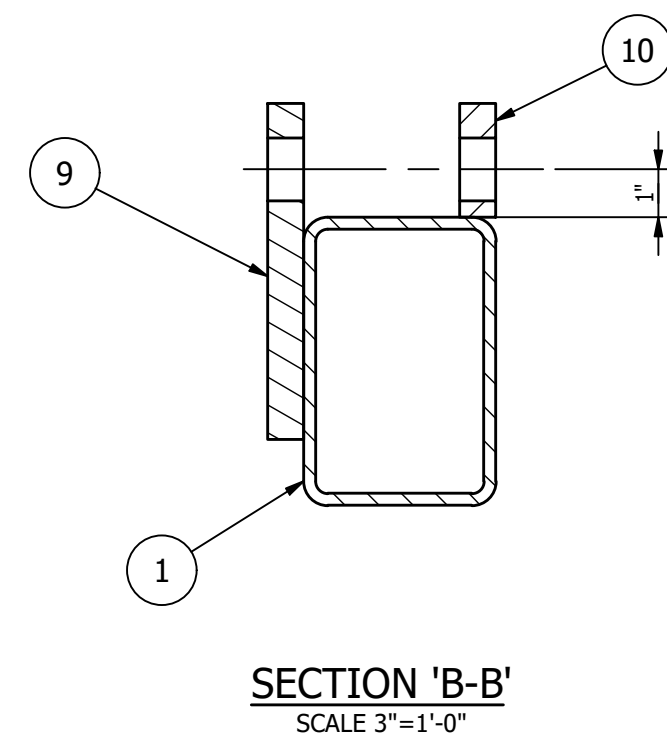
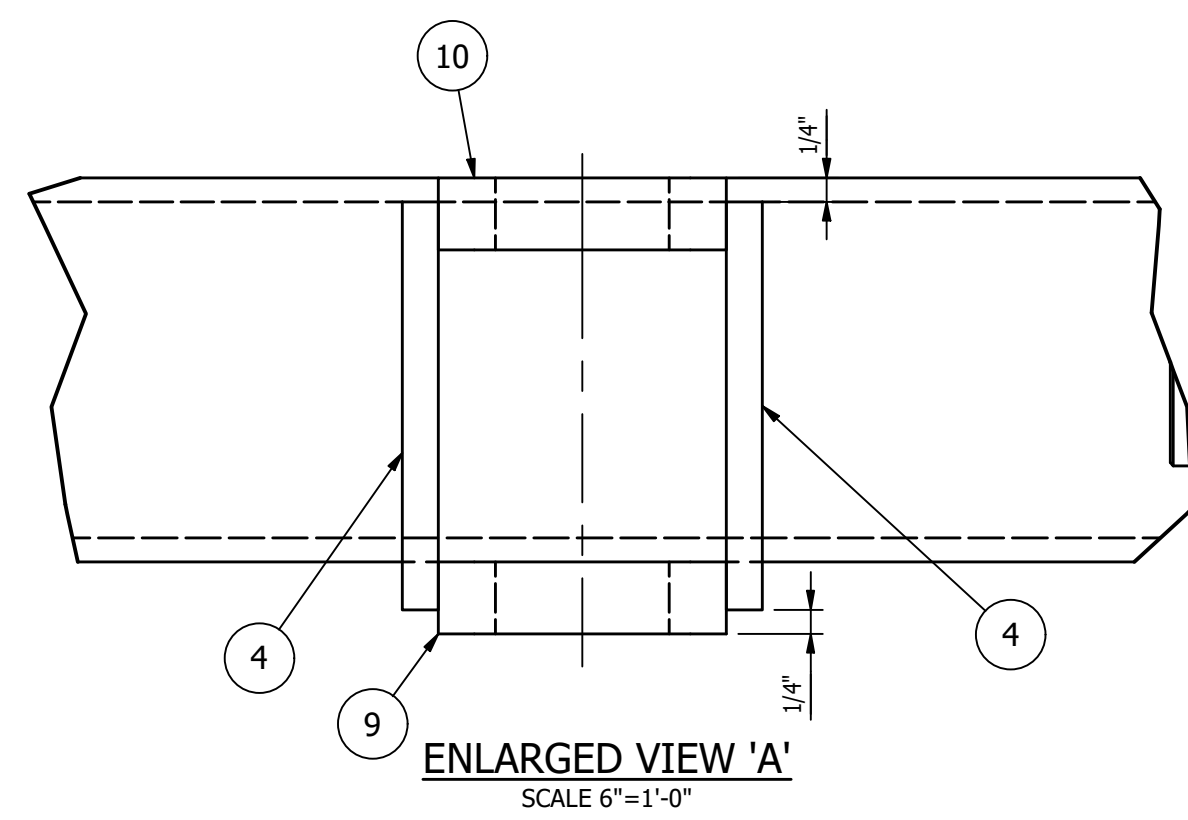
REVISION HISTORY		DRAWN BY: RJB	
MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		CHECKED BY: CW	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DWG DATE: 11/8/22	
CLIENT: VOLVO		JOB No: 22096	
DRAWING No. 1875D476		REV: B	

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Suite 125
West, MI 48375
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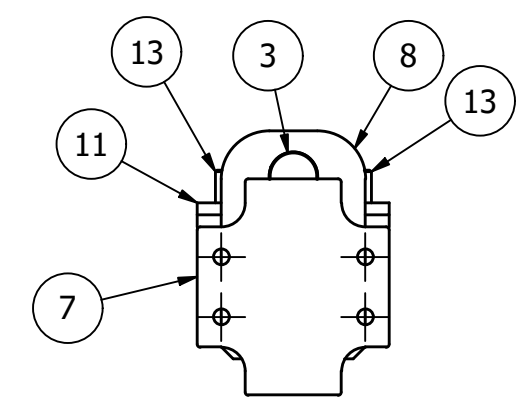
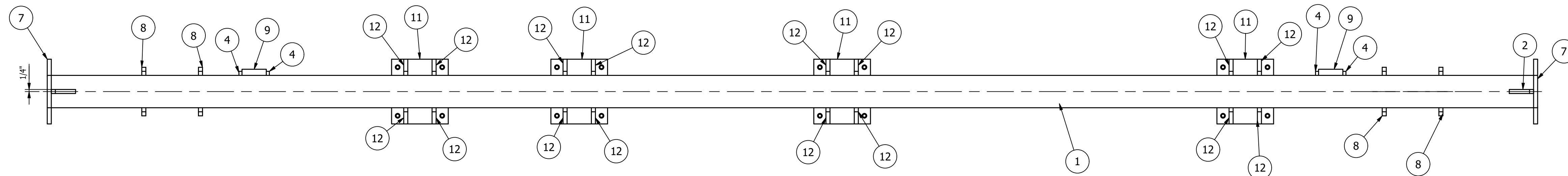
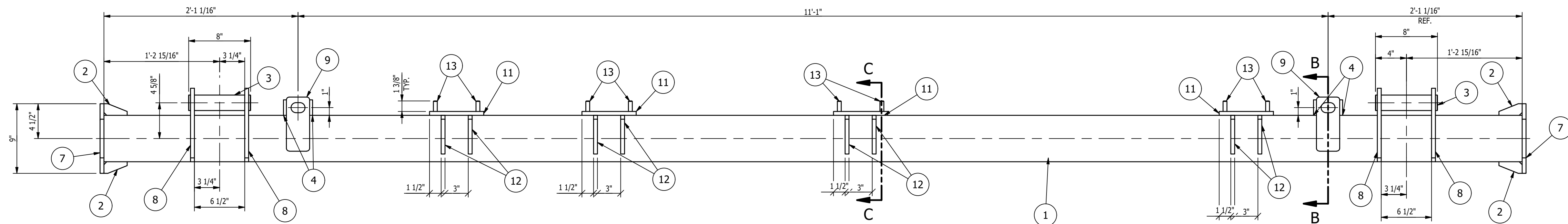
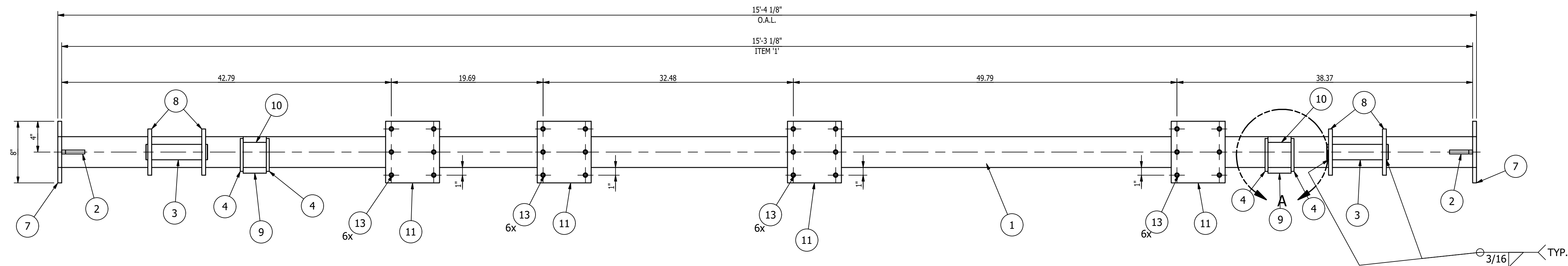
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D476 - REV B

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COPIES:
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BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D477A			
1	1	HSS 6 x 4 x 1/4 A500 GR. C	15'-3 1/8"		
2	4	PL 1/2 x 1 1/2	3"		
3	2	BAR Ø2	8"		
4	4	BAR 3/8 x 2	4 1/4"		
7	2	BAR 1/2 x 8	9"		
8	4	PL 1/2 x 6"	9 1/2"		
9	2	PL 3/4 x 3"	7"		
10	2	PL 3/4 x 2 3/8"	3"		
11	4	BAR 1/2 x 7	8"		
12	16	BAR 1/2 x 2	5"		
13	24	THD. ROD 1/2-13UNC	1 7/8"		



SHOP NOTES:

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

PAINT NOTES:

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

DO NOT PAINT ITEM '3'

SHEET 1 OF 2

MK-D477A ~ AUX LIFT CARRIAGE WELDMENT ~ DRIVER SIDE
SCALE 1 1/2"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/15/22	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>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. 1875D477</p>		<p>DWG DATE: 10/20/22</p>
<p>REV: A</p>		<p>JOB No: 22096</p>

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41100 Clarkston Rd.
Suite 125
North, MI 48075

Phone: (248) 373-8889
Fax: (248) 373-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D477 - 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:

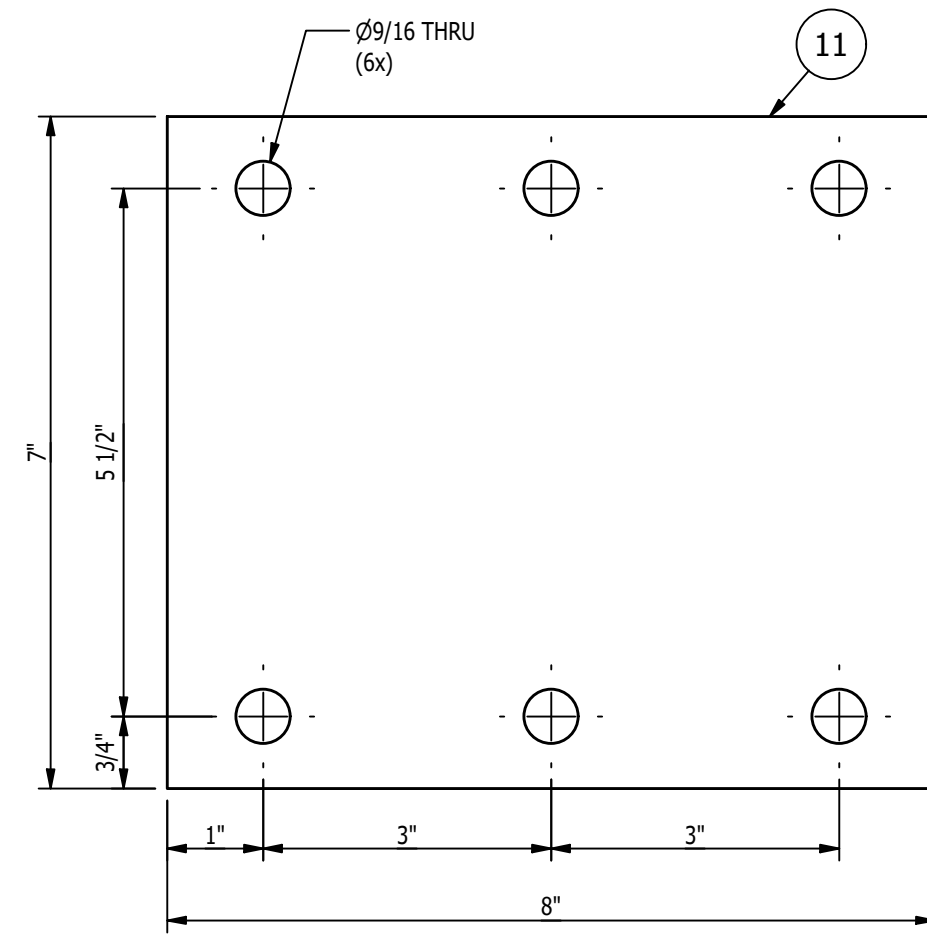
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

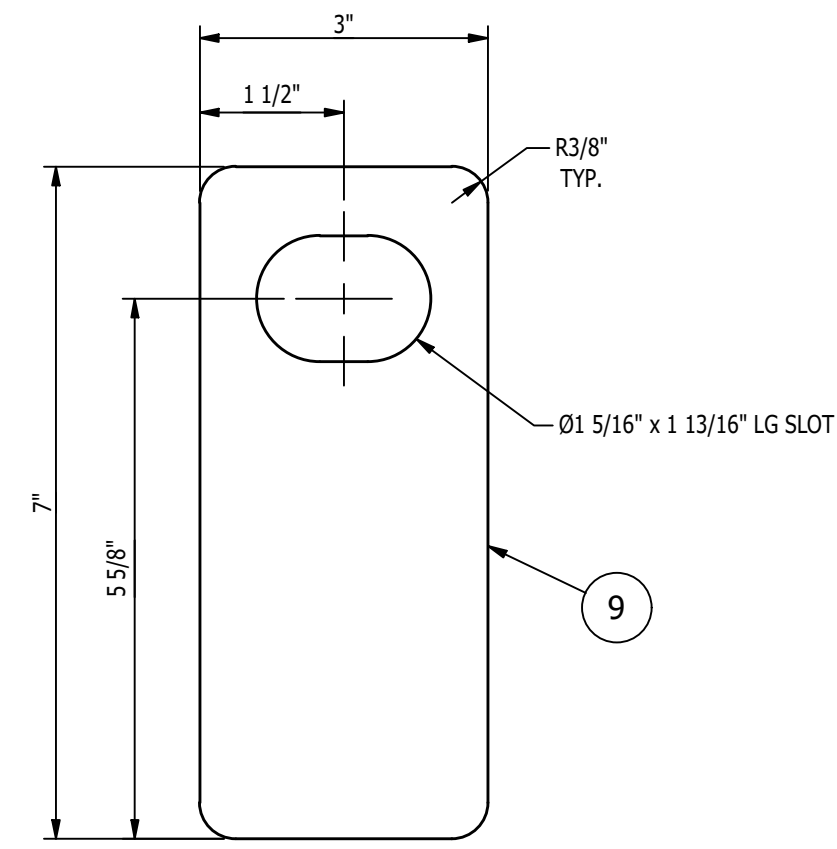
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

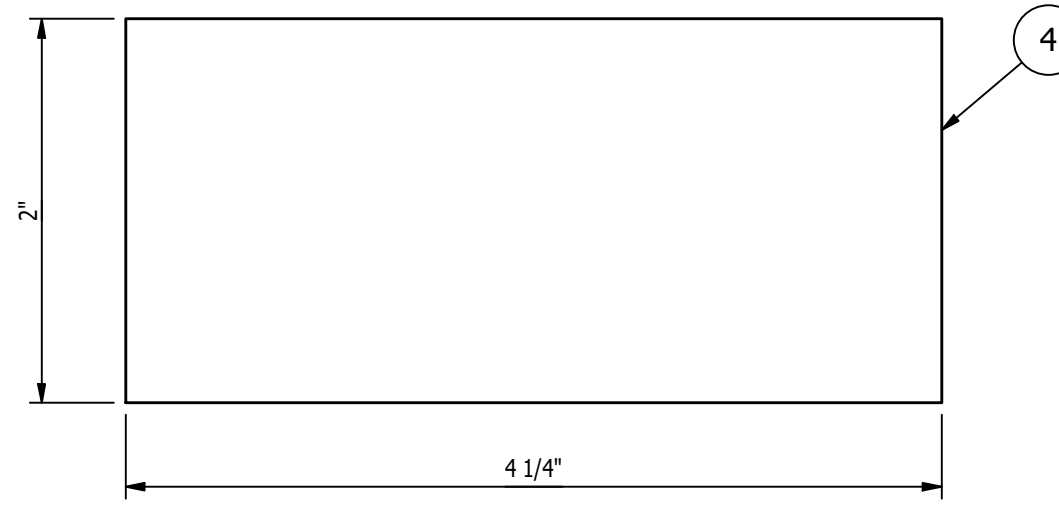
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



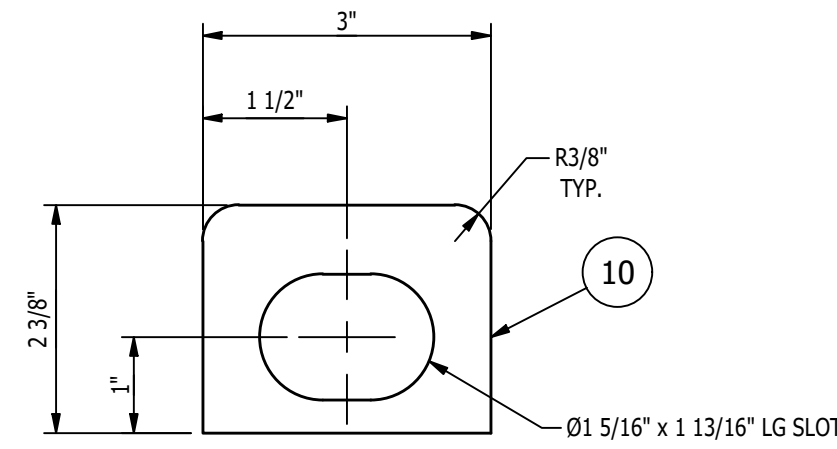
DETAIL OF ITEM '11'
SCALE 6"=1'-0"



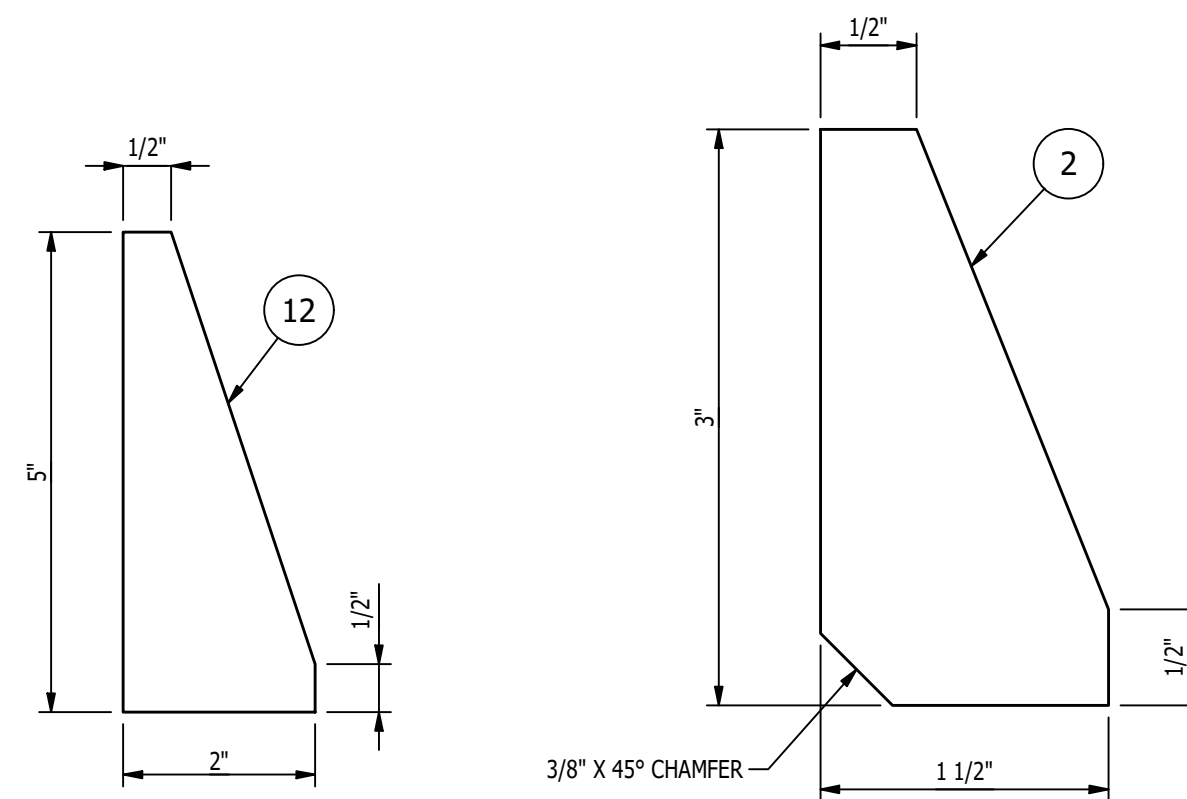
DETAIL OF ITEM '9'
SCALE 6"=1'-0"



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

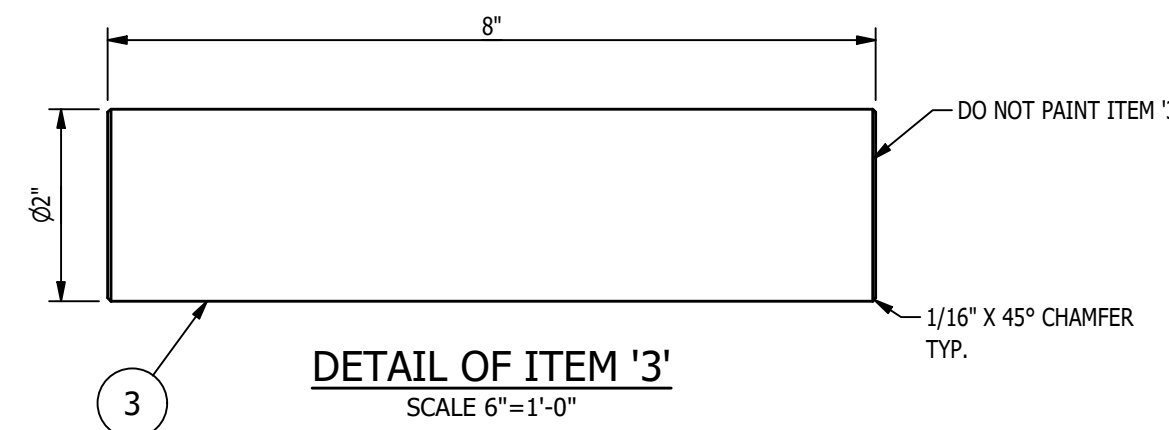


DETAIL OF ITEM '10'
SCALE 6"=1'-0"

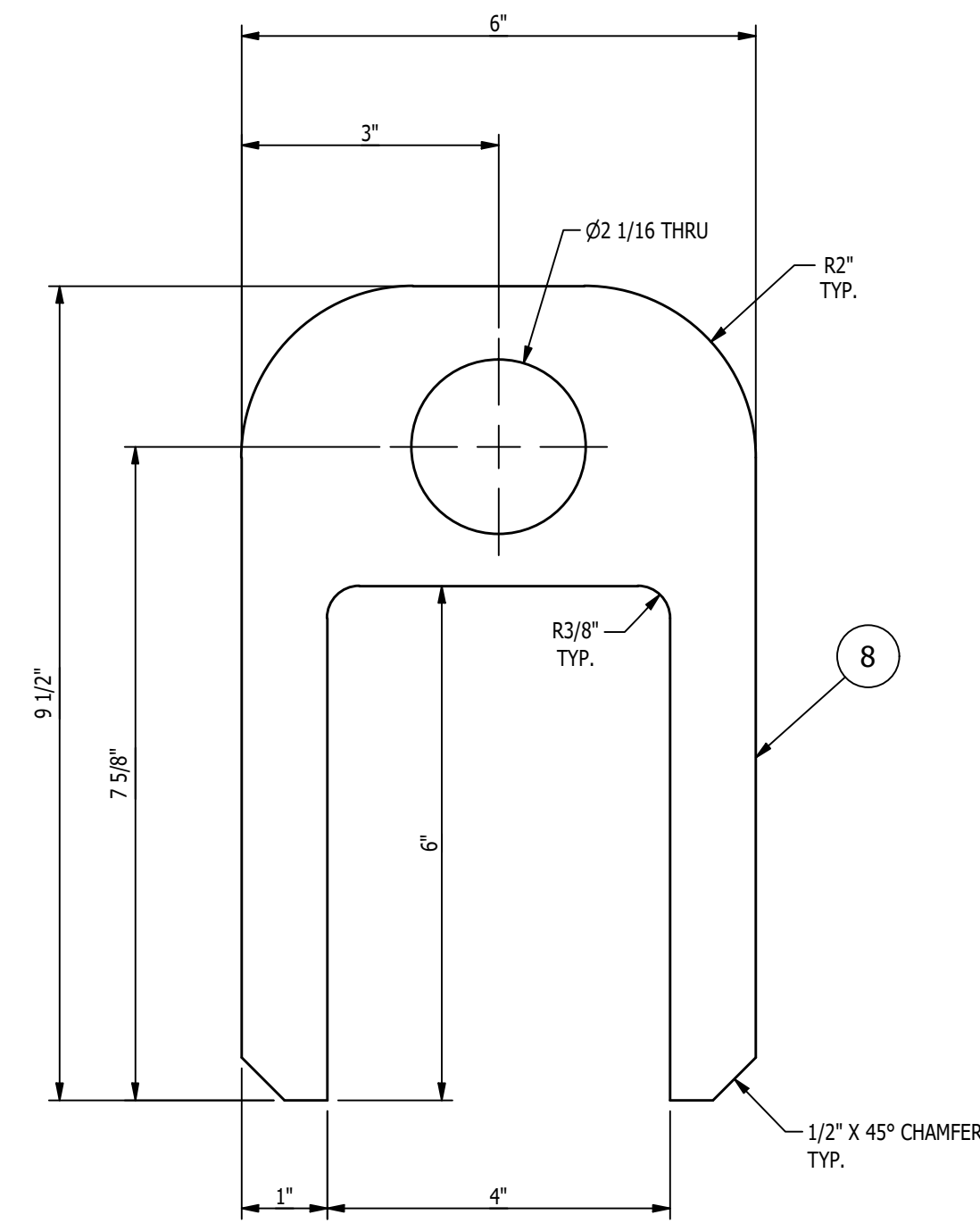


DETAIL OF ITEM '12'
SCALE 6"=1'-0"

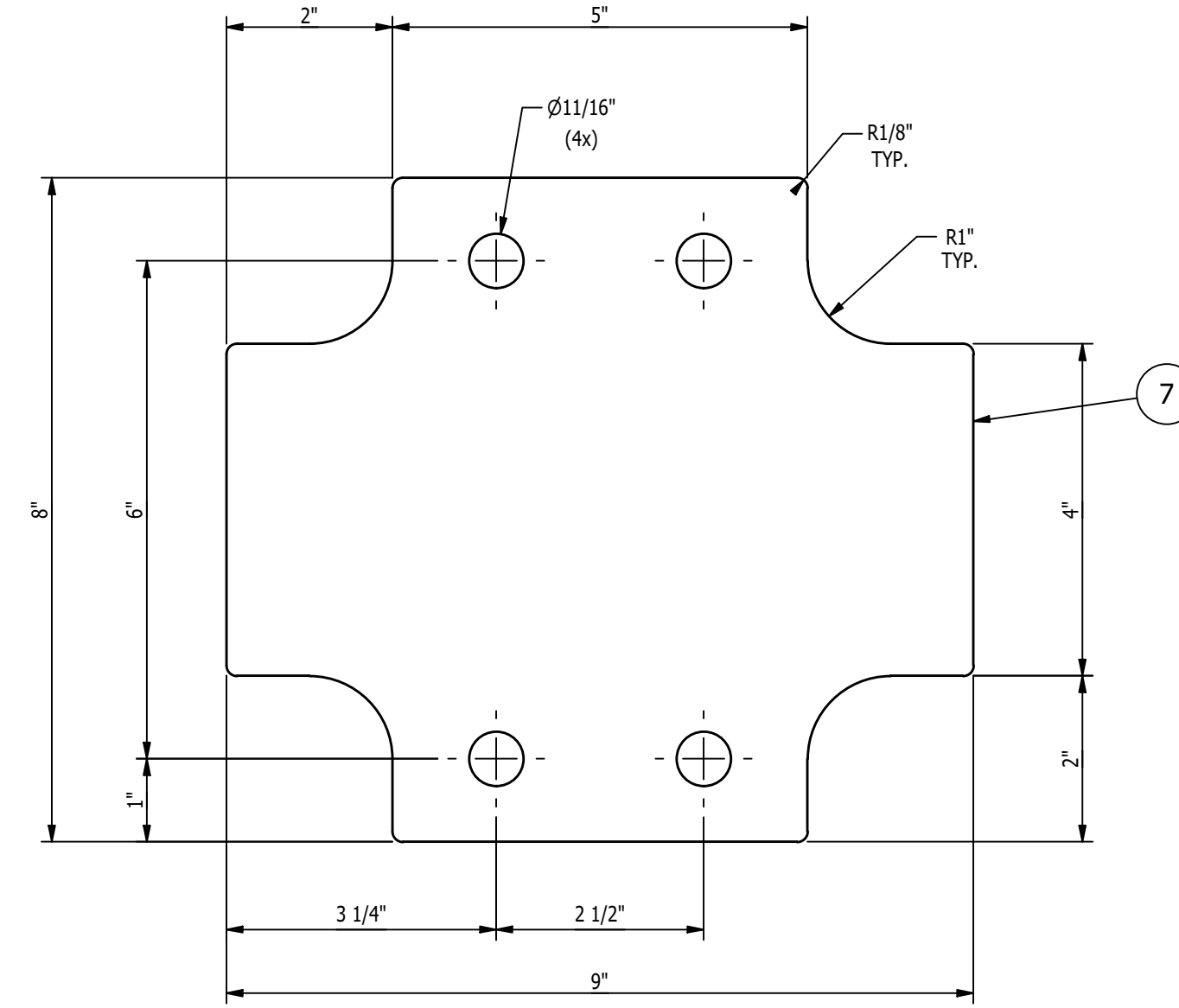
DETAIL OF ITEM '2'
SCALE 1'-0" = 1'-0"



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



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



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

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING
CLIENT:	VOLVO
DRAWING No.	1875D477
REV:	A
DRAWN BY:	RJB
CHECKED BY:	CW
DWG DATE:	10/20/22
JOB No:	22096

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

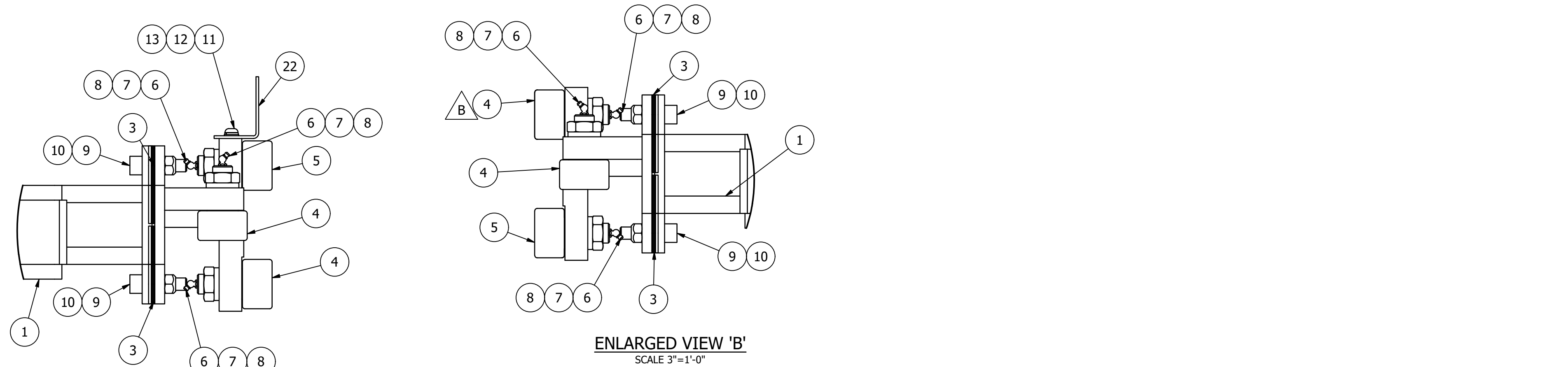
MAGNUM Consulting

41701 Gardenbrook Rd
Suite 125
Novi, MI 48375

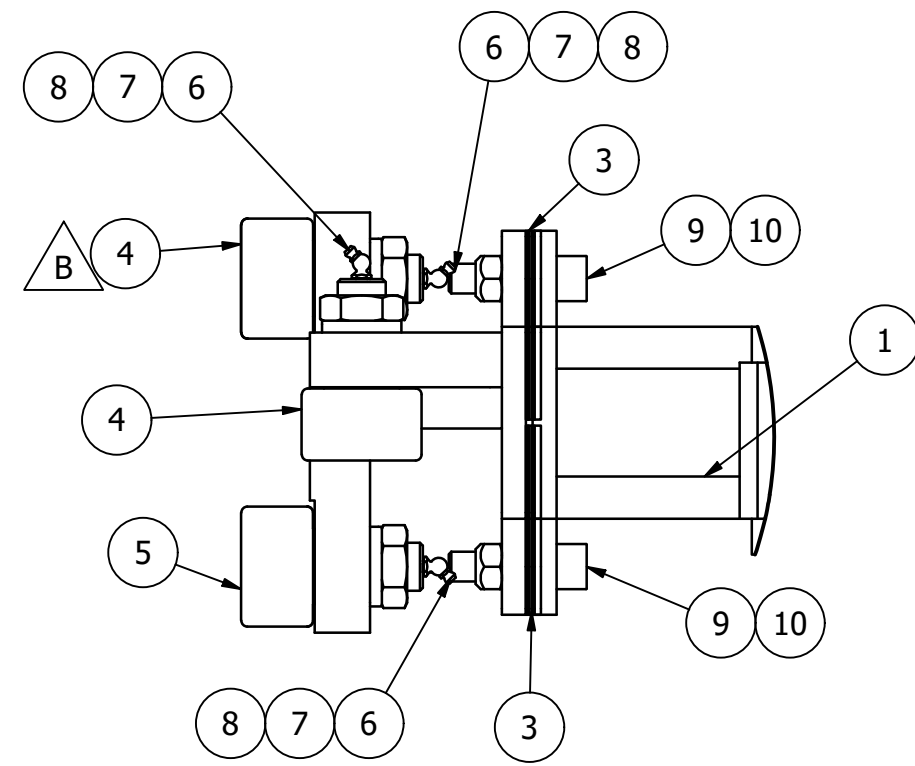
Phone: (248) 773-8000
Fax: (248) 773-8001
Web: www.magnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D477 - REV A

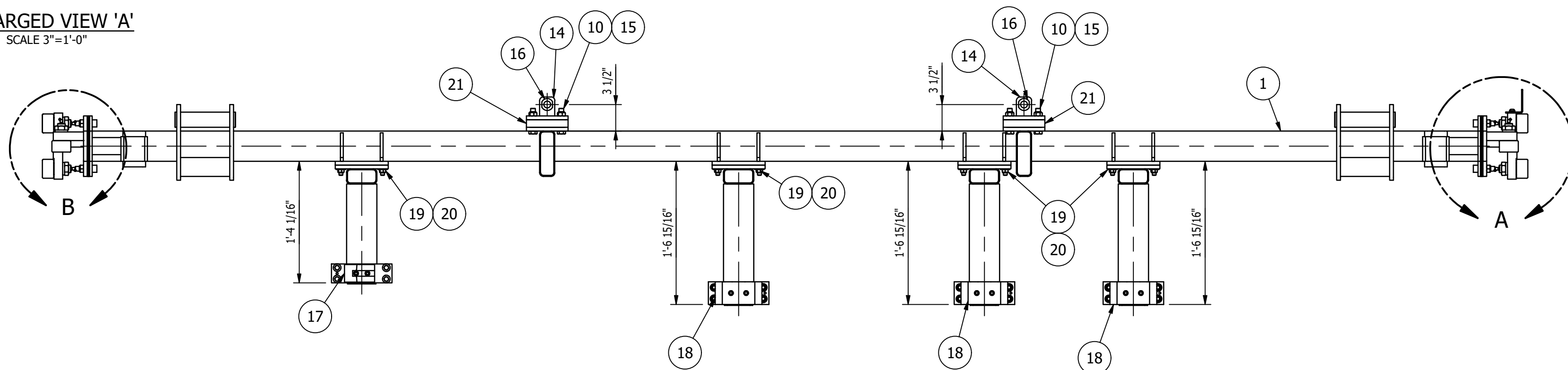
UNLESS OTHERWISE NOTED:
.X = ±.060
.XX = ±.030
.XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



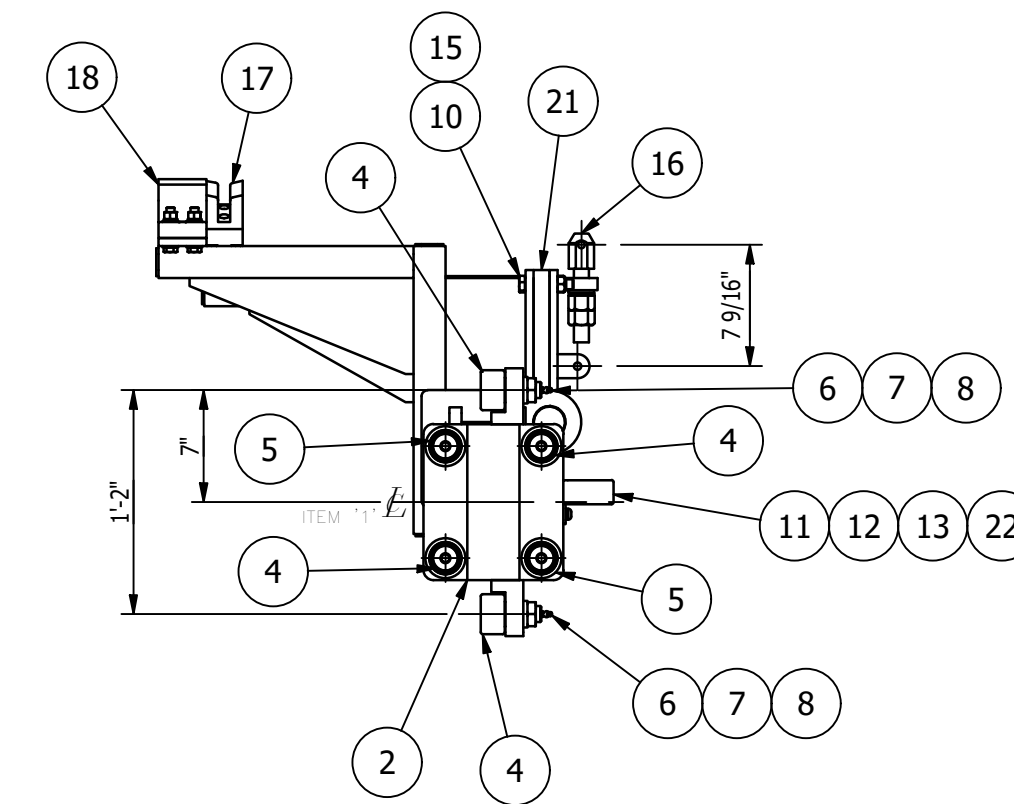
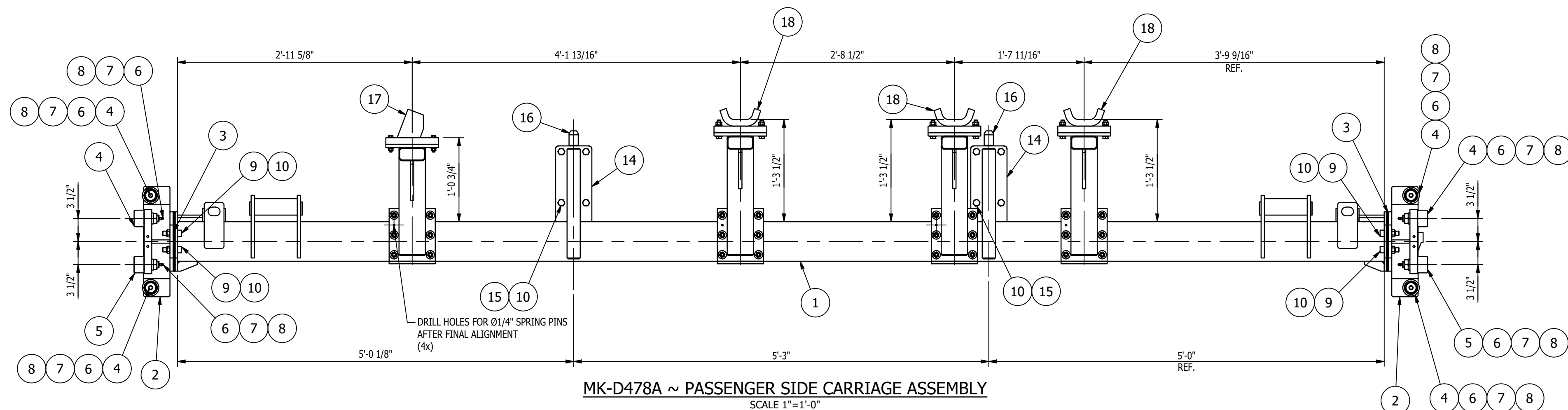
ENLARGED VIEW 'A'
SCALE 3"=1'-0"



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



MK-D478A ~ PASSENGER SIDE CARRIAGE ASSEMBLY
SCALE 1"=1'-0"



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D478A ~ AUX LIFT CARRIAGE WELDMENT ~ PASSENGER SIDE			
2	2	MK-D482B ~ CAM GUIDE ROLLER MACHINING			
3	4	MK-D491A ~ SHIM PACK			
4	8	PCI CONCENTRIC PLAIN DCB ROLLER, 2.5" ROLLER OD, 1.5" ROLLER WIDTH, 1-14 UNF THREAD, PCI PART NO. PDC-2.50-R		25-9	
5	4	PCI ECCENTRIC PLAIN DCB ROLLER, 2.5" ROLLER OD, 1.5" ROLLER WIDTH, 1-14 UNF THREAD, PCI PART NO. PDCE-2.50-R		25-10	
6	12	1-14UNS HEX JAM NUT			
7	12	1 SPRING LOCK WASHER			
8	12	GREASE FITTING, 45 DEG ELBOW, 1/4" DRIVE FITTING		26-8	
9	8	5/8-11UNC x 2 1/4" LG. HEX SOCKET HEAD CAP SCREW			
10	16	5/8-11UNC STOVER LOCK NUT			
11	2	3/8 TYPE B NARROW FLAT WASHER			
12	2	3/8 SPRING LOCK WASHER			
13	2	3/8-16UNC x 3/4" LG. BUTTON HEX SOCKET HEAD CAP SCREW			
14	2	MK-D484A ~ CHAIN BRACKET			
15	8	5/8-11UNC x 3" LG. HEX HEAD CAP SCREW			
16	2	TSUBAKI END BOLT, PART NO. RS120EB		28-12	
17	1	MK-D414B ~ AUX LIFT ARM ASSEMBLY - RH			
18	3	MK-D412B ~ AUX LIFT ARM ASSEMBLY - PASSENGER SIDE			
19	24	1/2 TYPE B REGULAR FLAT WASHER			
20	24	1/2-13UNC STOVER LOCK NUT			
21	2	MK-D484B ~ SPACER			
22	1	MK-D489D ~ PROX BRACKET			

- 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	11/28/22	CORRECTED BALLOON NUMBER ON ENLARGED VIEW 'B', UPDATED GEOMETRY PER ITEMS '17' & '18'	
A	MC	11/8/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY:	
		RJB	
		CHECKED BY:	CW
		DWG DATE:	11/8/22
		DRAWING No.	1875D478
		REV:	B
		JOB No.:	22096

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

MAGNUM CONSULTING

41100 Charleston Rd
Suite 125
North, MI 48135

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D478 - REV B

UNLESS OTHERWISE NOTED:

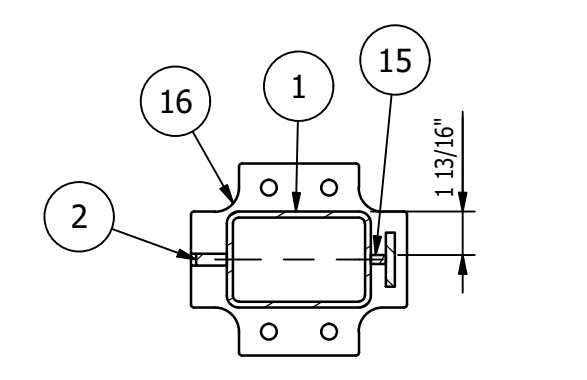
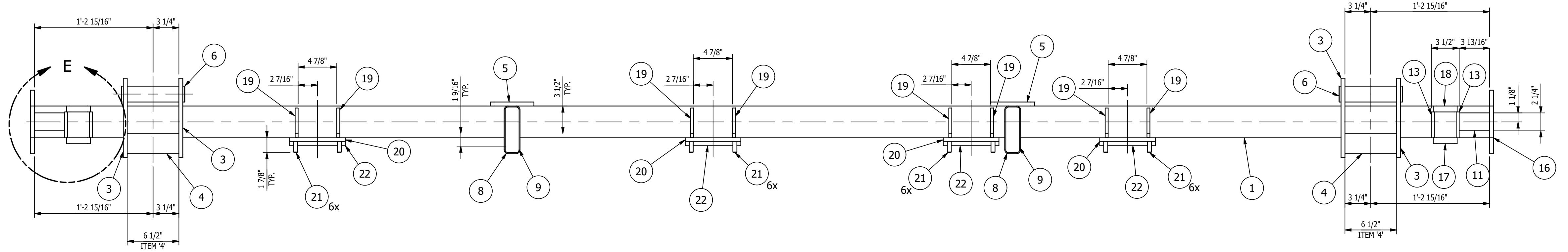
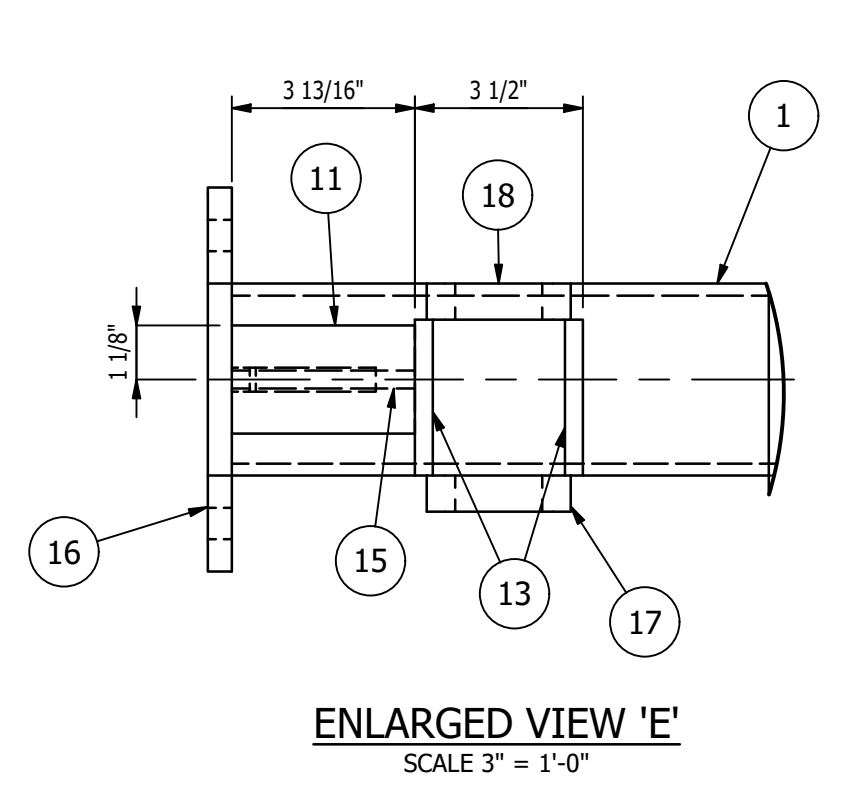
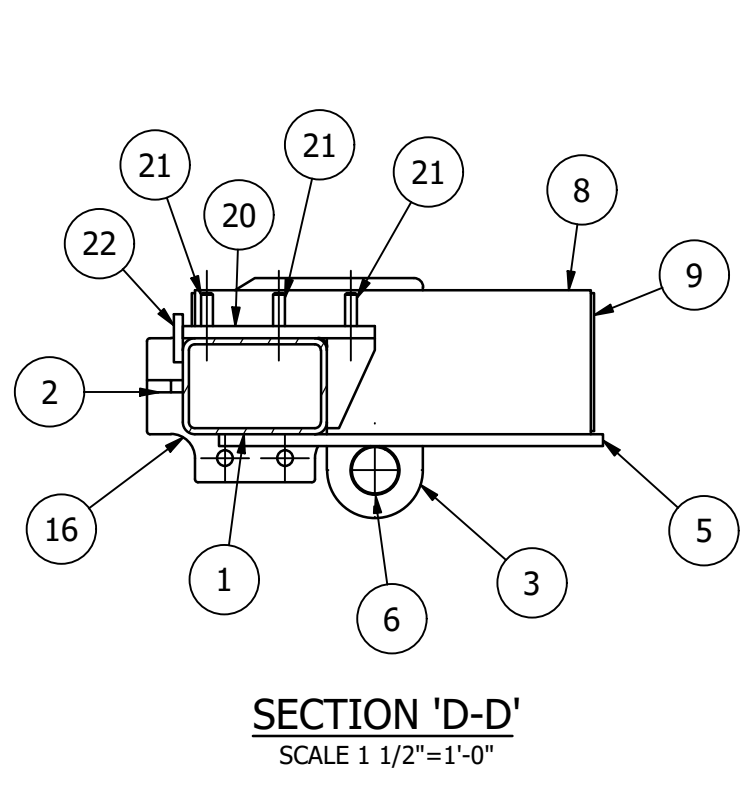
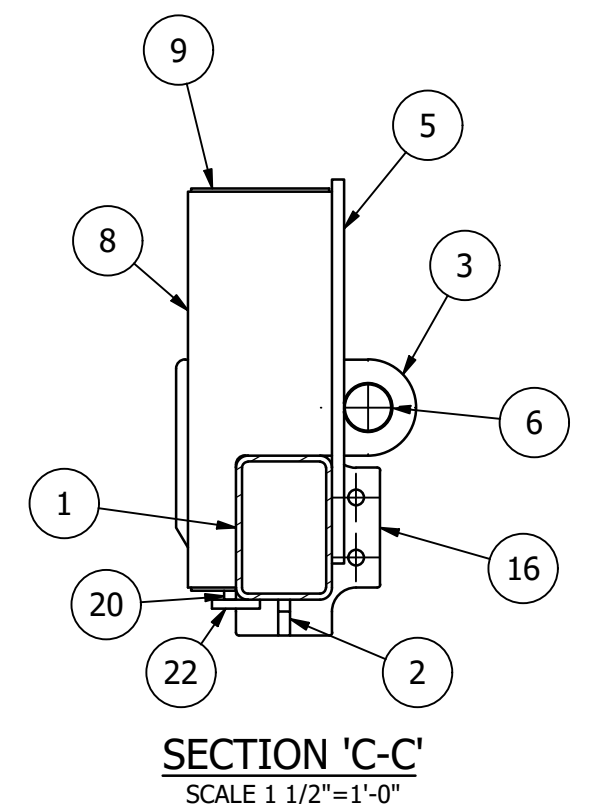
X = ±.060
XX = ±.030
XXX = ±.005

FRACTIONS = ±1/16"
ANGLES = ±1°30'

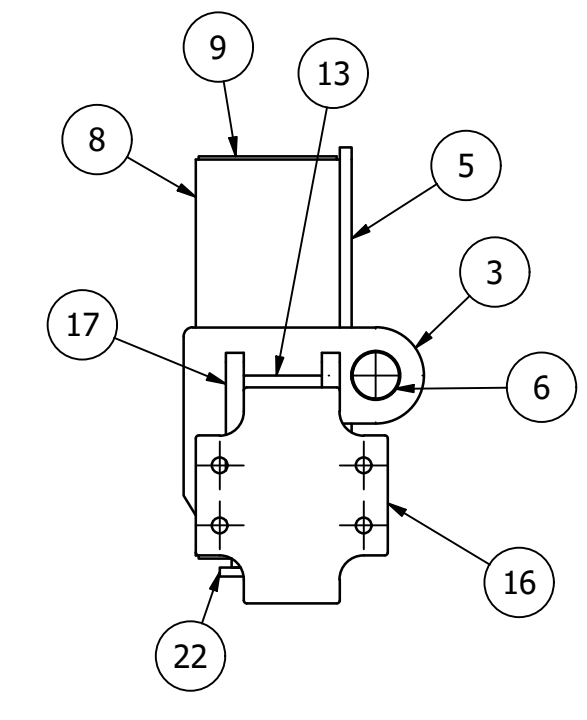
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

3:00p 11/28/22 11:28 AM LIT: Revs/DWG/1875D478 - REV B.dwg

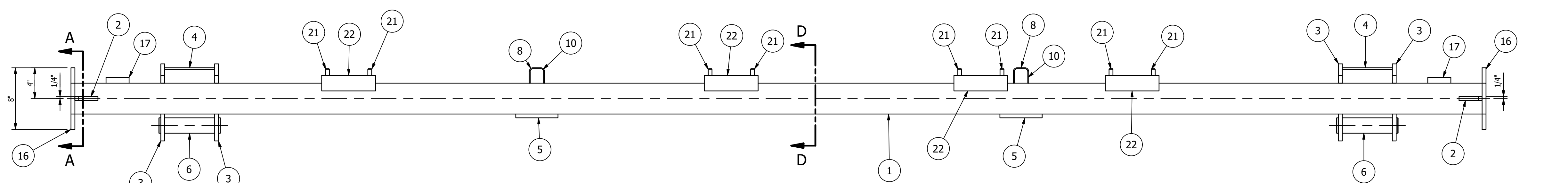
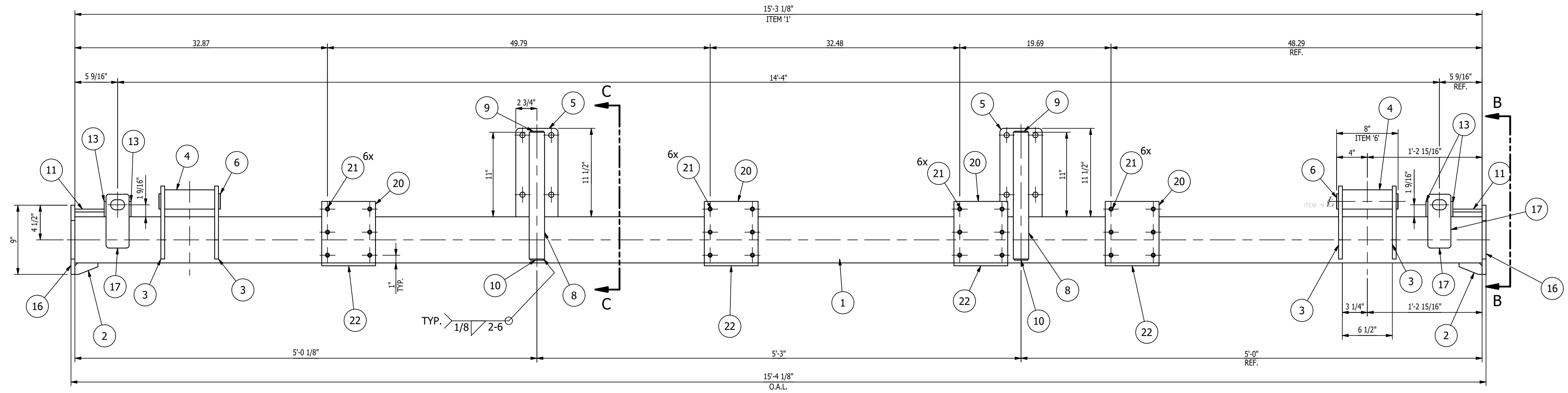
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D479A			
1	1	HSS 6 x 4 x 1/4 A500 GR. C	15'-3 1/8"		
2	2	BAR 1/2 x 1 1/2	3"		
3	4	PL 1/2 x 9 1/2	10"		
4	2	L 2 1/2 x 2 1/2	6 1/2"		
5	2	PL 1/2 x 5 1/2"	1'-4"		
6	2	BAR Ø2	8"		
8	2	HSS 2 x 6 x 1/4 A500 GR. C	1'-4 1/2"		
9	2	SHT 10 GA x 1 3/4	5 3/4"		
10	2	SHT 10 GA x 1 3/4	1 7/8"		
11	2	PL 3/8 x 2 1/4	3 13/16"		
13	4	PL 3/8 x 2"	3 1/4"		
15	2	PL 3/8 x 5/8	3 13/16"		
16	2	BAR 1/2 x 8	9"		
17	2	PL 3/4 x 3"	7"		
18	2	PL 3/4 x 3"	2 15/16"		
19	8	PL 3/8 x 2	3 3/4"		
20	4	BAR 1/2 x 7	8"		
21	24	THD. ROD 1/2-13UNC	1 7/8"		
22	4	BAR 3/8 x 2	7"		



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



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



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

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

DO NOT PAINT ITEM '6'
SHEET 1 OF 2

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	REMOVED EXTRA DIMENSIONS, UPDATED DESCRIPTION OF ITEM '8' IN BOM, REMOVED DETAIL OF ITEM '7'	
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY

B	MC	11/28/22	REMOVED EXTRA DIMENSIONS, UPDATED DESCRIPTION OF ITEM '8' IN BOM, REMOVED DETAIL OF ITEM '7'	
A	MC	11/15/22	FOR FABRICATION	

MK-D479A ~ AUX LIFT CARRIAGE WELDMENT ~ PASSENGER SIDE
SCALE 1 1/2"=1'-0"

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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:

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

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

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

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

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

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

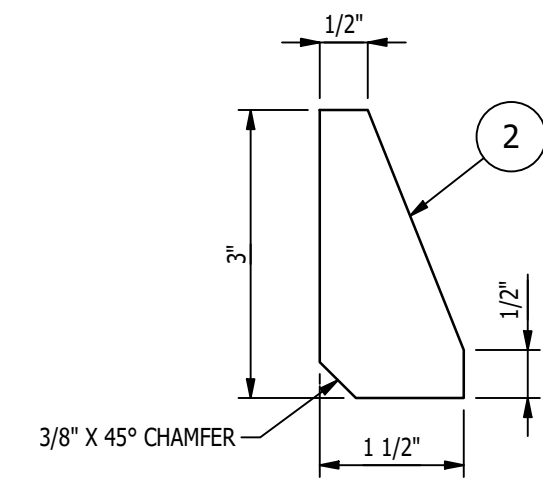
TITLE: P6700 CONVEYORS
CAMPUS BUILDING

CLIENT: VOLVO

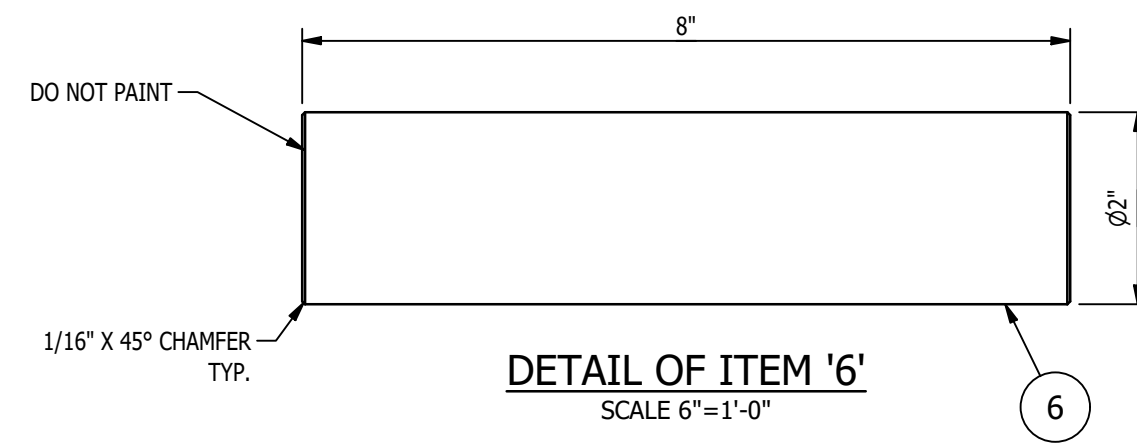
DRAWING No. 1875D479

REV: A

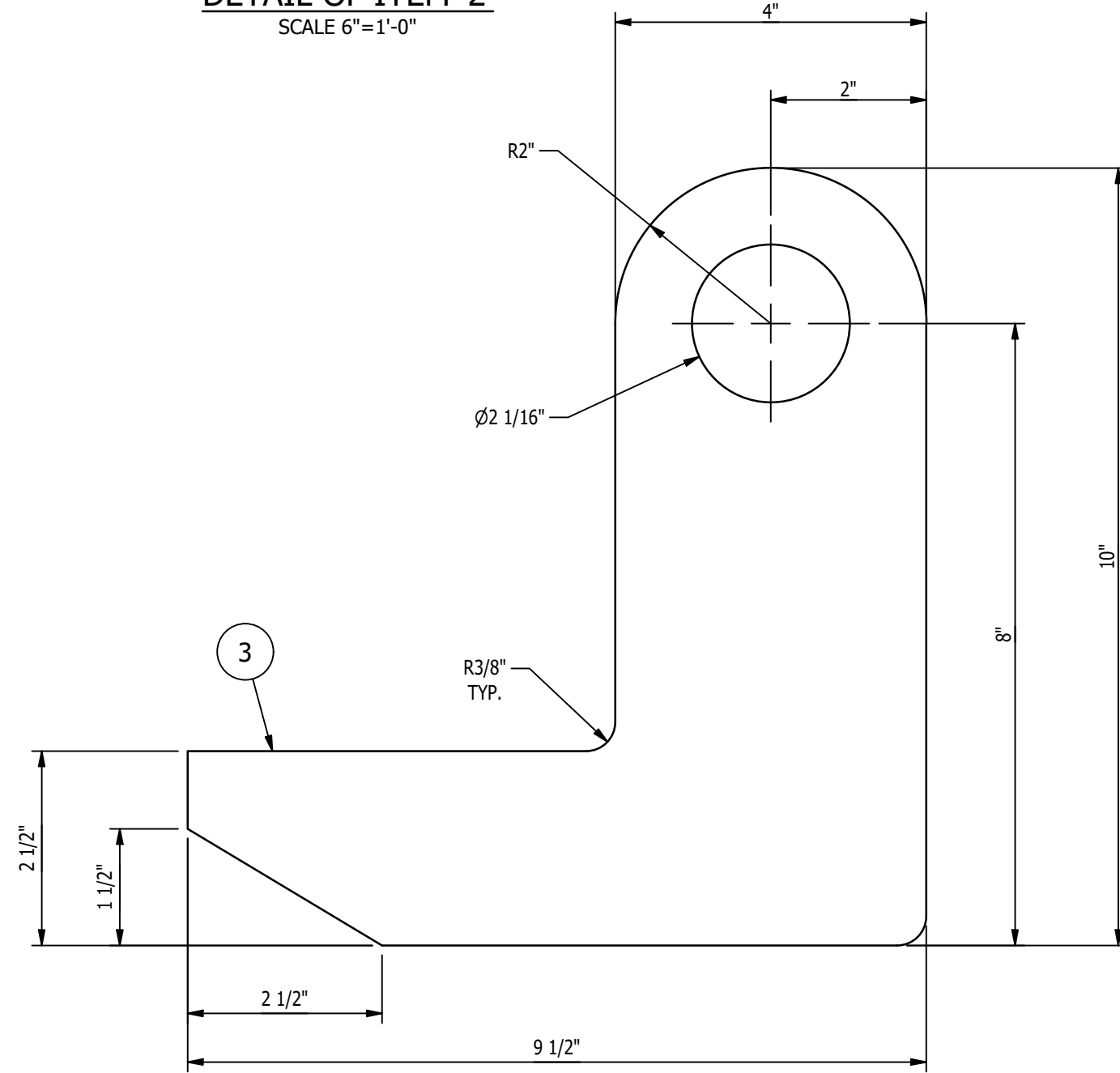
DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 10/20/22
JOB No.: 22096



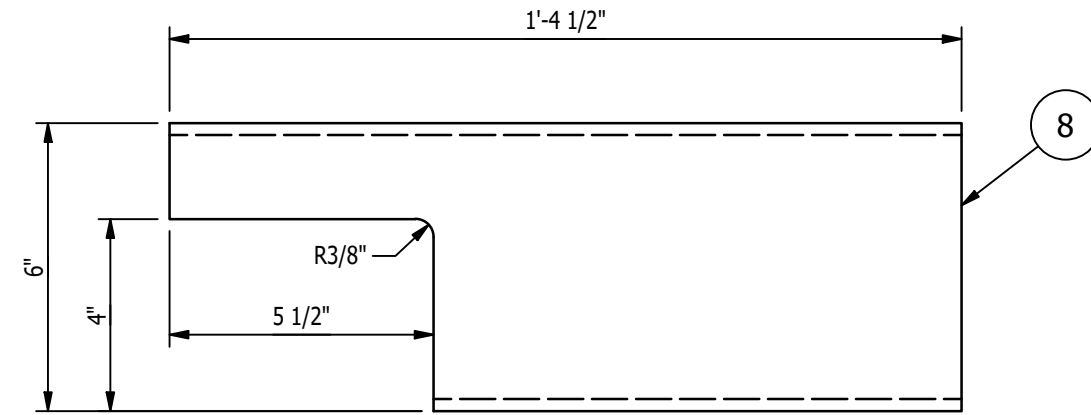
DETAIL OF ITEM '2'
SCALE 6"=1'-0"



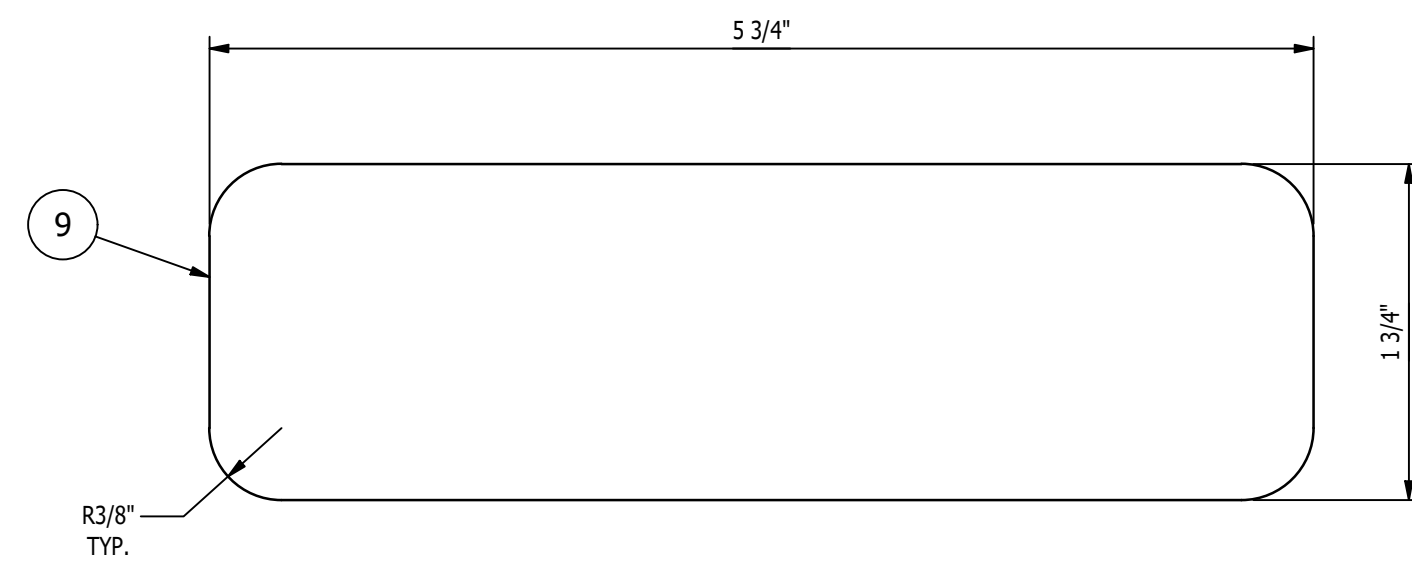
DETAIL OF ITEM '6'
SCALE 6"=1'-0"



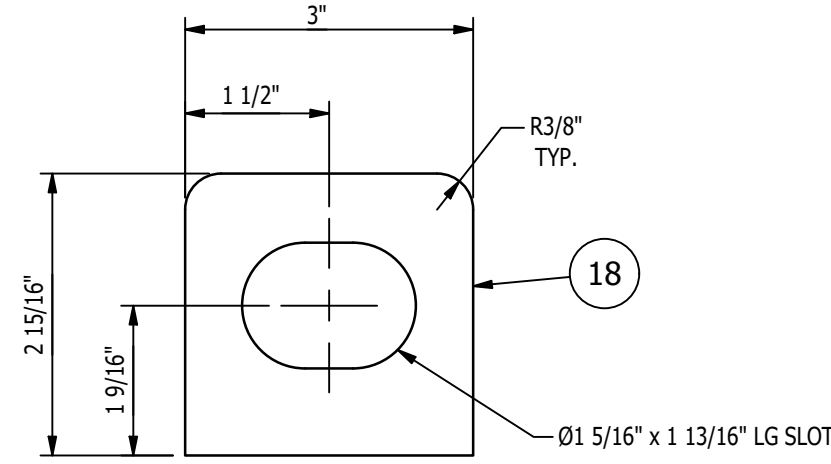
DETAIL OF ITEM '3'
SCALE 6"=1'-0"



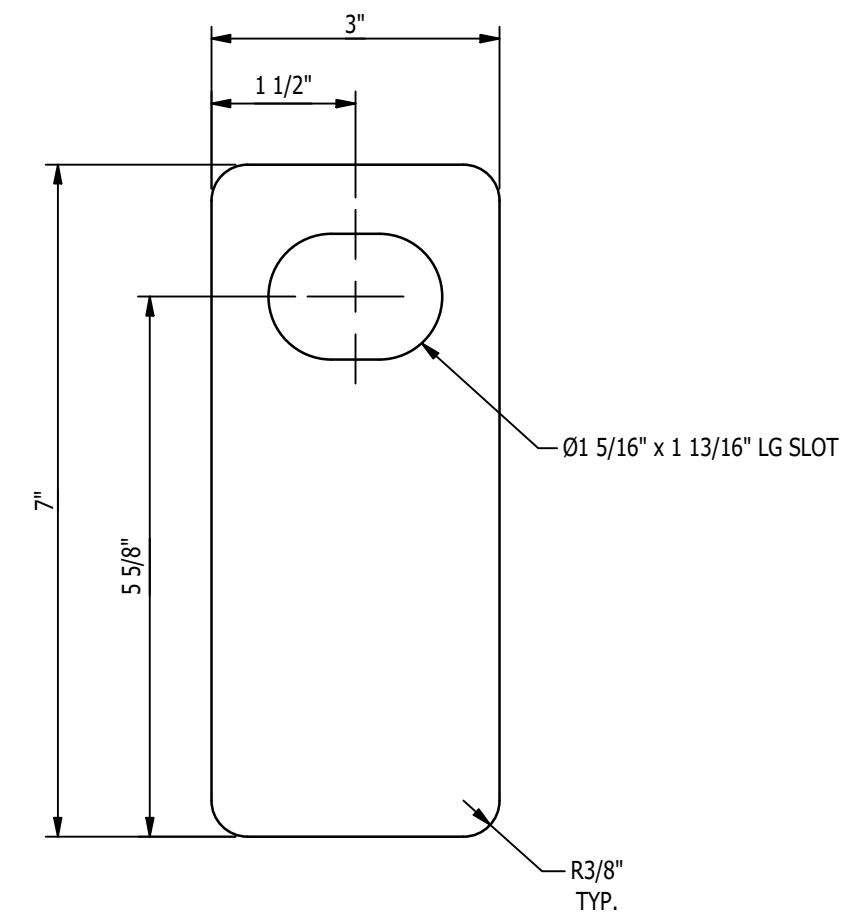
DETAIL OF ITEM '8'
SCALE 3"=1'-0"



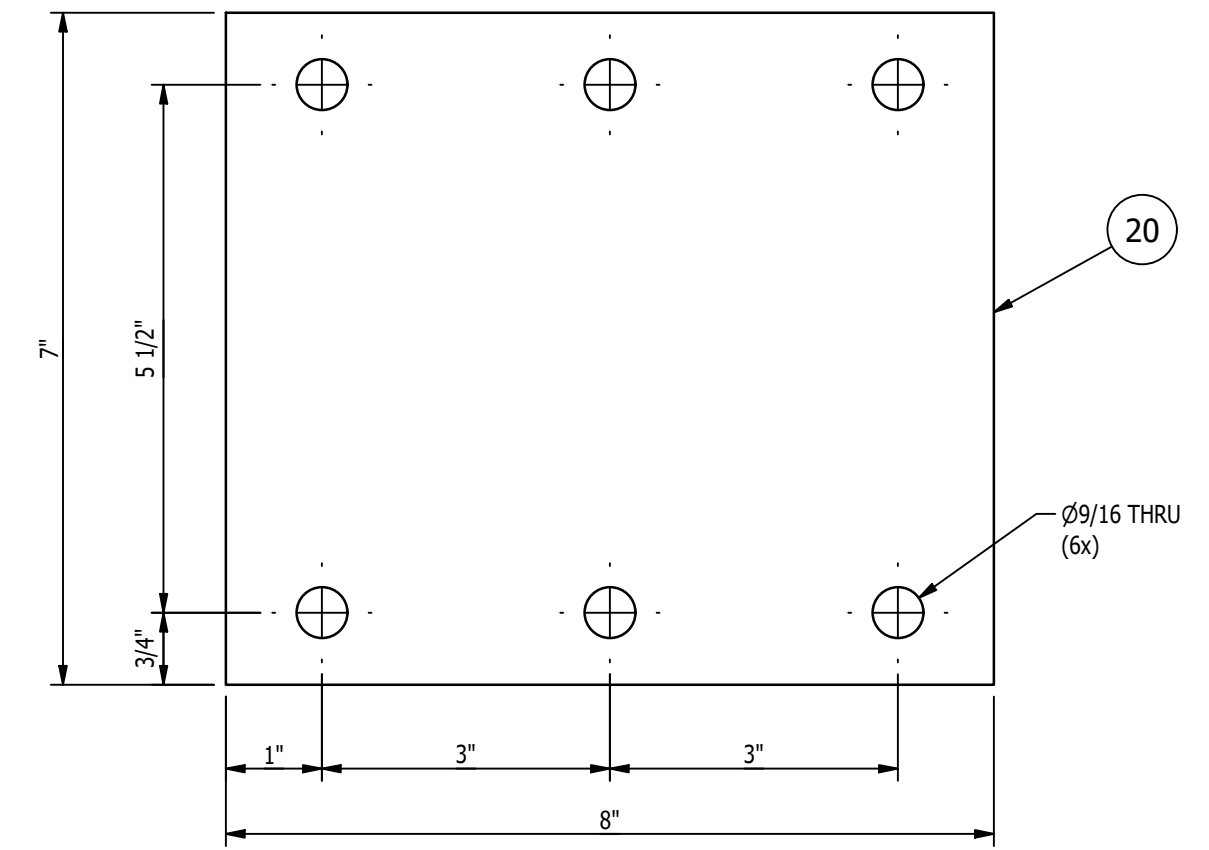
DETAIL OF ITEM '9'
SCALE 1"=1'-0"



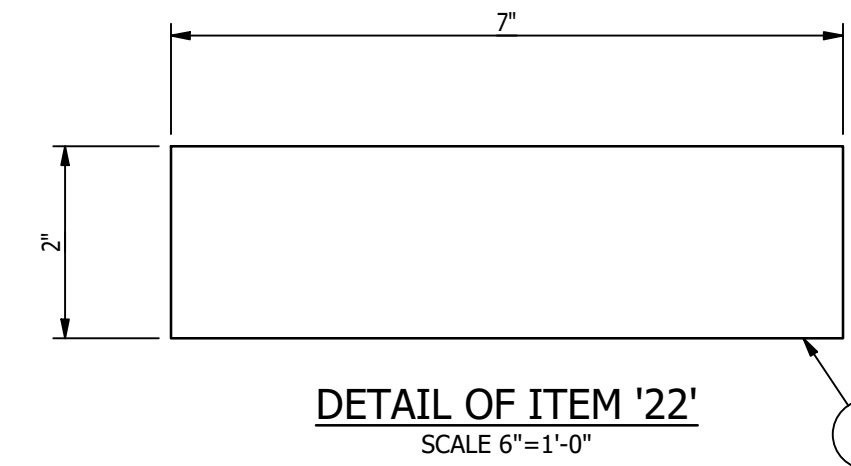
DETAIL OF ITEM '18'
SCALE 6"=1'-0"



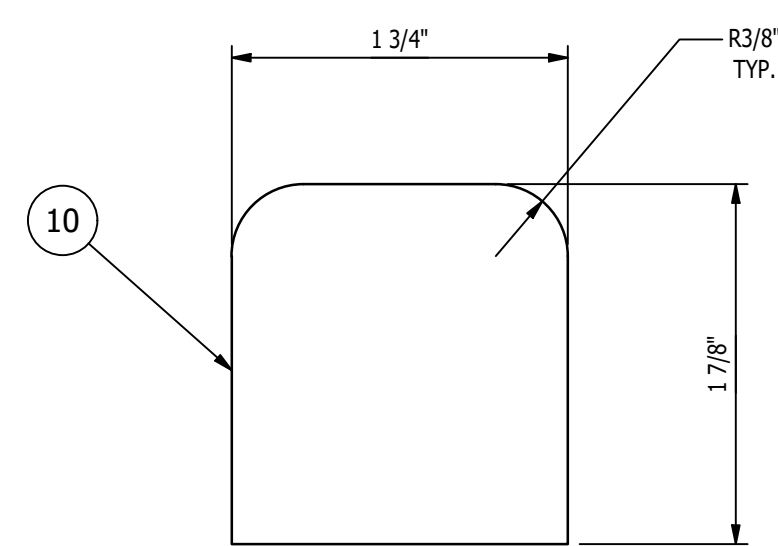
DETAIL OF ITEM '17'
SCALE 6"=1'-0"



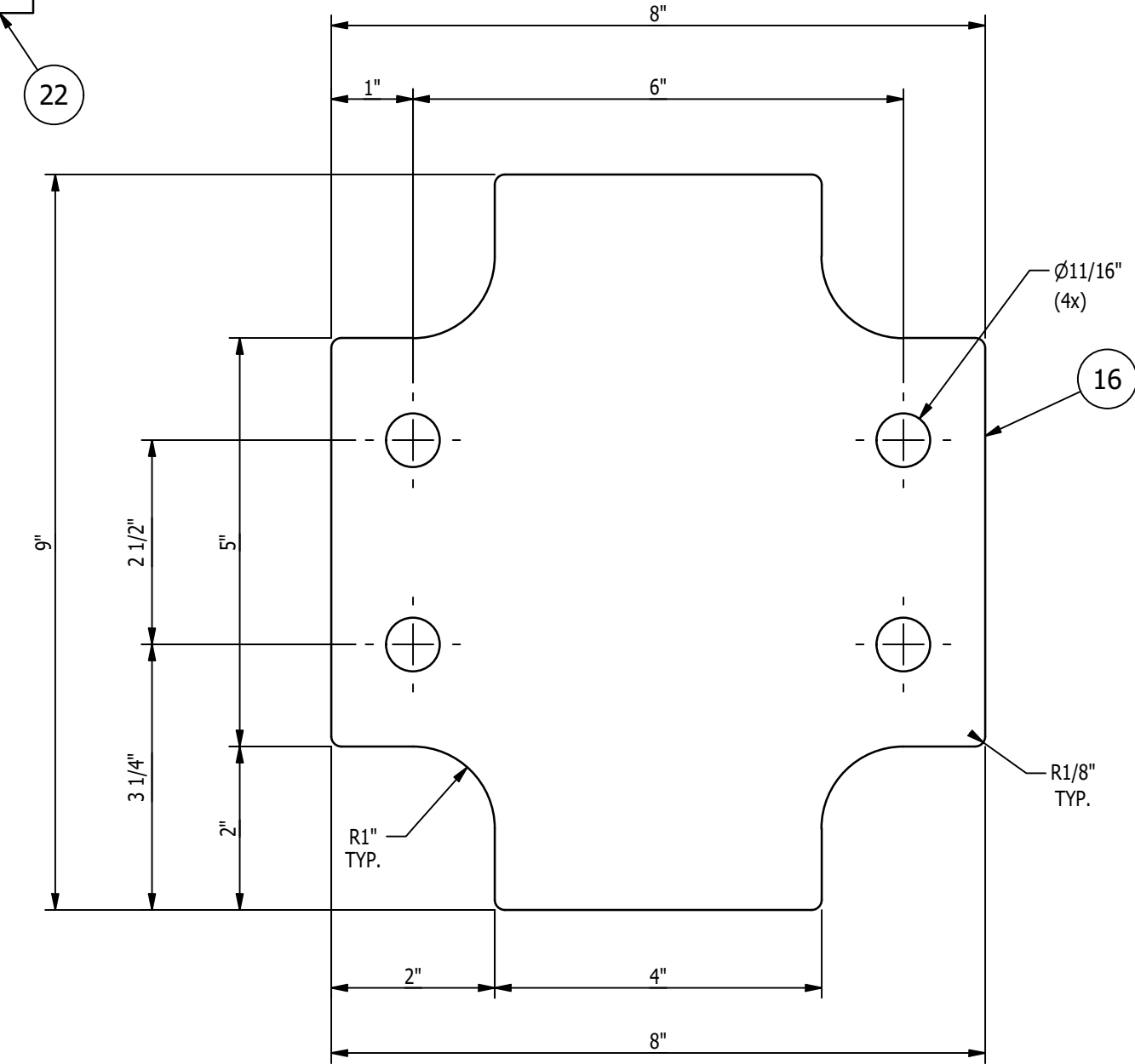
DETAIL OF ITEM '20'
SCALE 6"=1'-0"



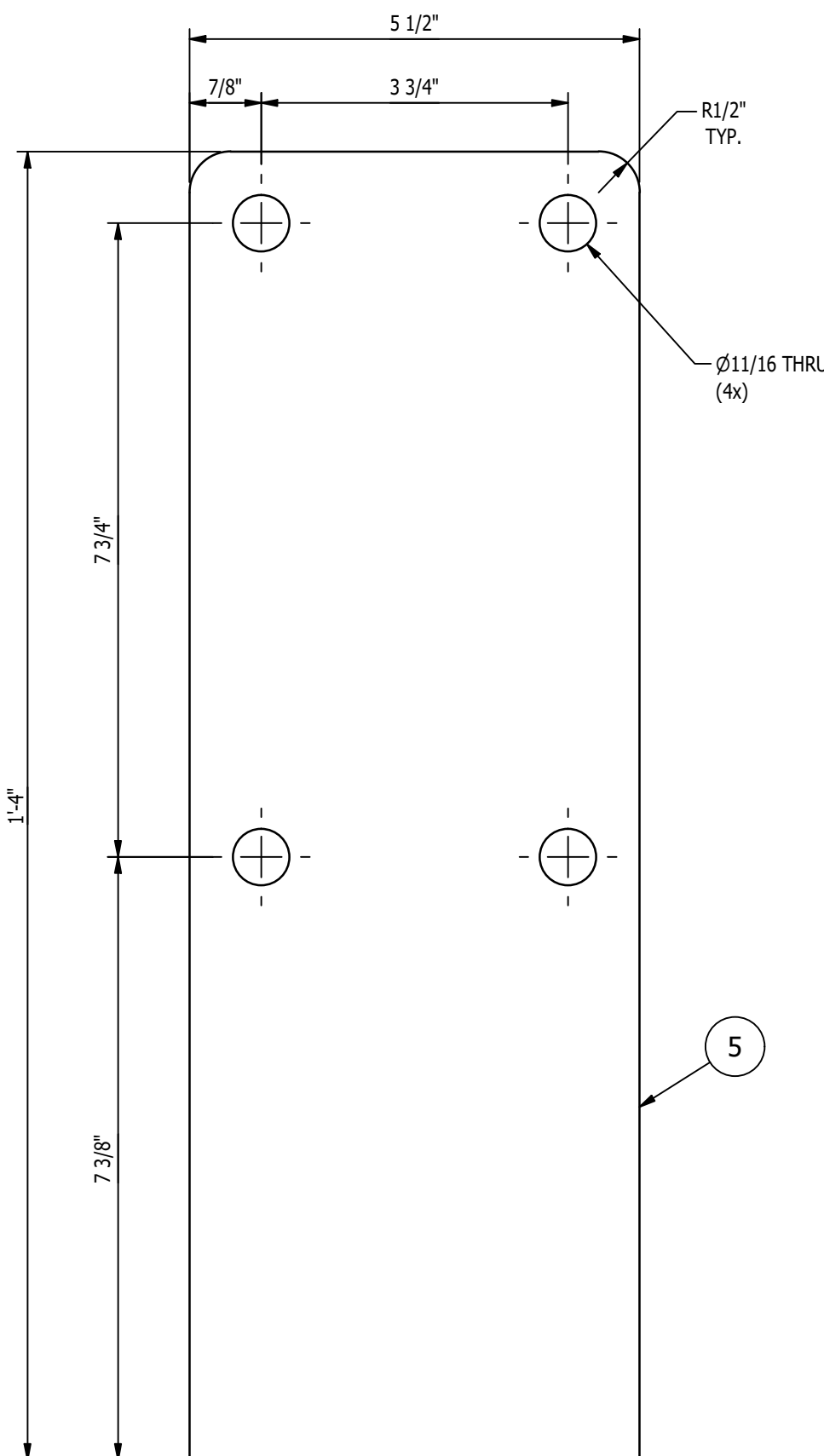
DETAIL OF ITEM '22'
SCALE 6"=1'-0"



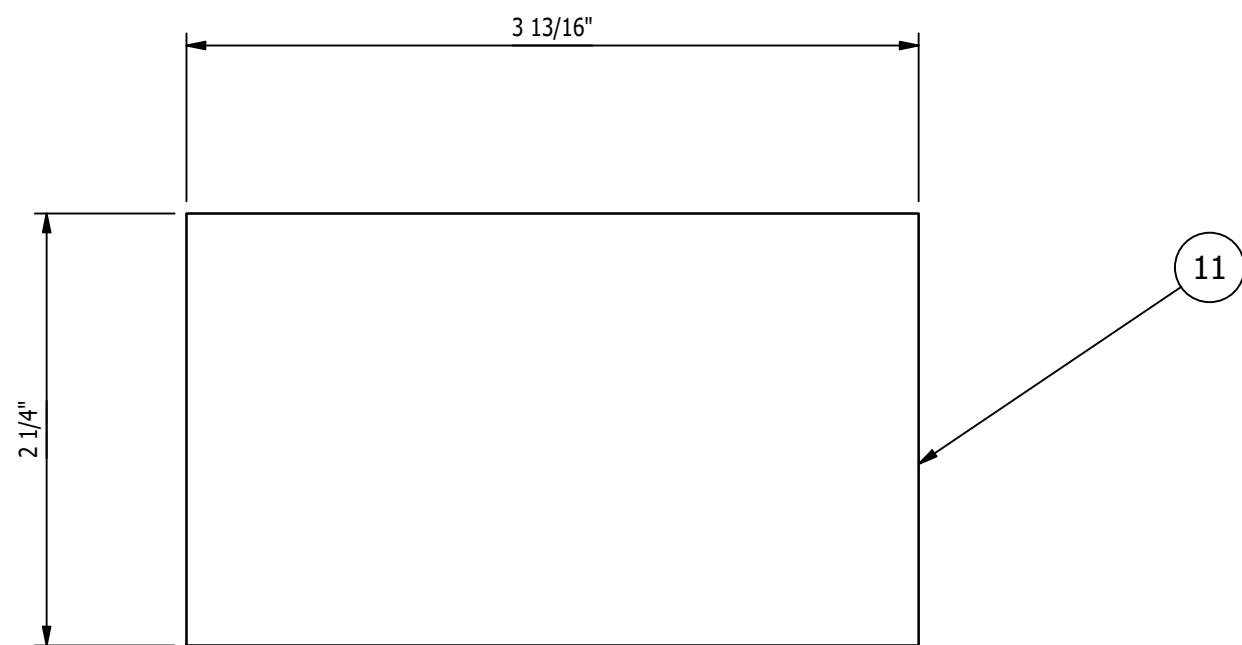
DETAIL OF ITEM '10'
SCALE 1"=1'-0"



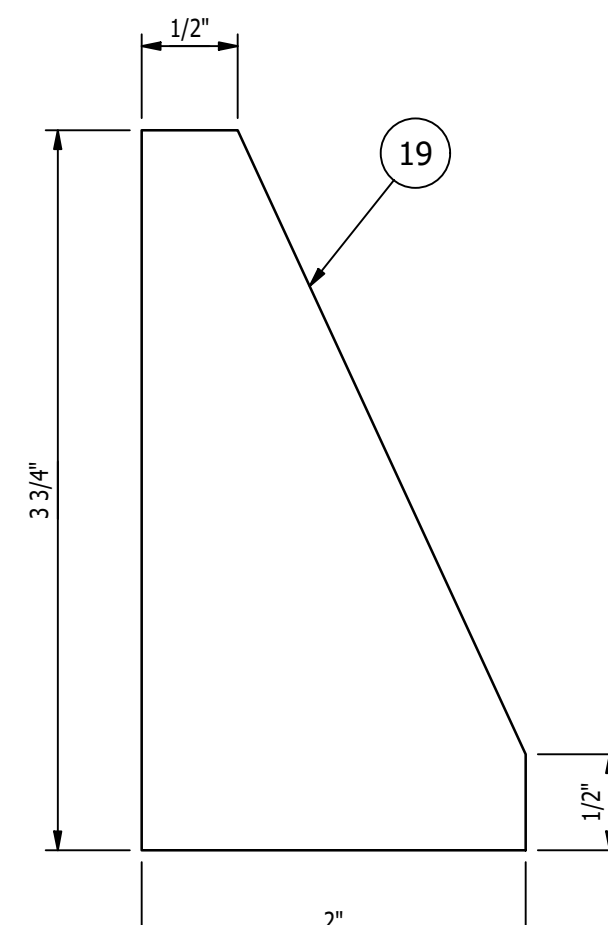
DETAIL OF ITEM '16'
SCALE 6"=1'-0"



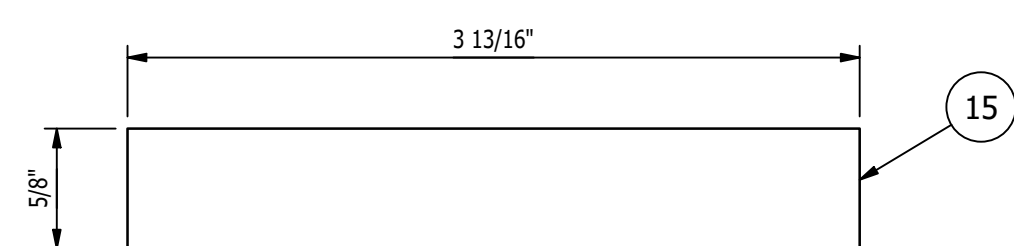
DETAIL OF ITEM '5'
SCALE 6"=1'-0"



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



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



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

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	REMOVED EXTRA DIMENSIONS, UPDATED DESCRIPTION OF ITEM '8' IN BOM, REMOVED DETAIL OF ITEM '7'	
A	MC	11/15/22	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.



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 www.milic.com

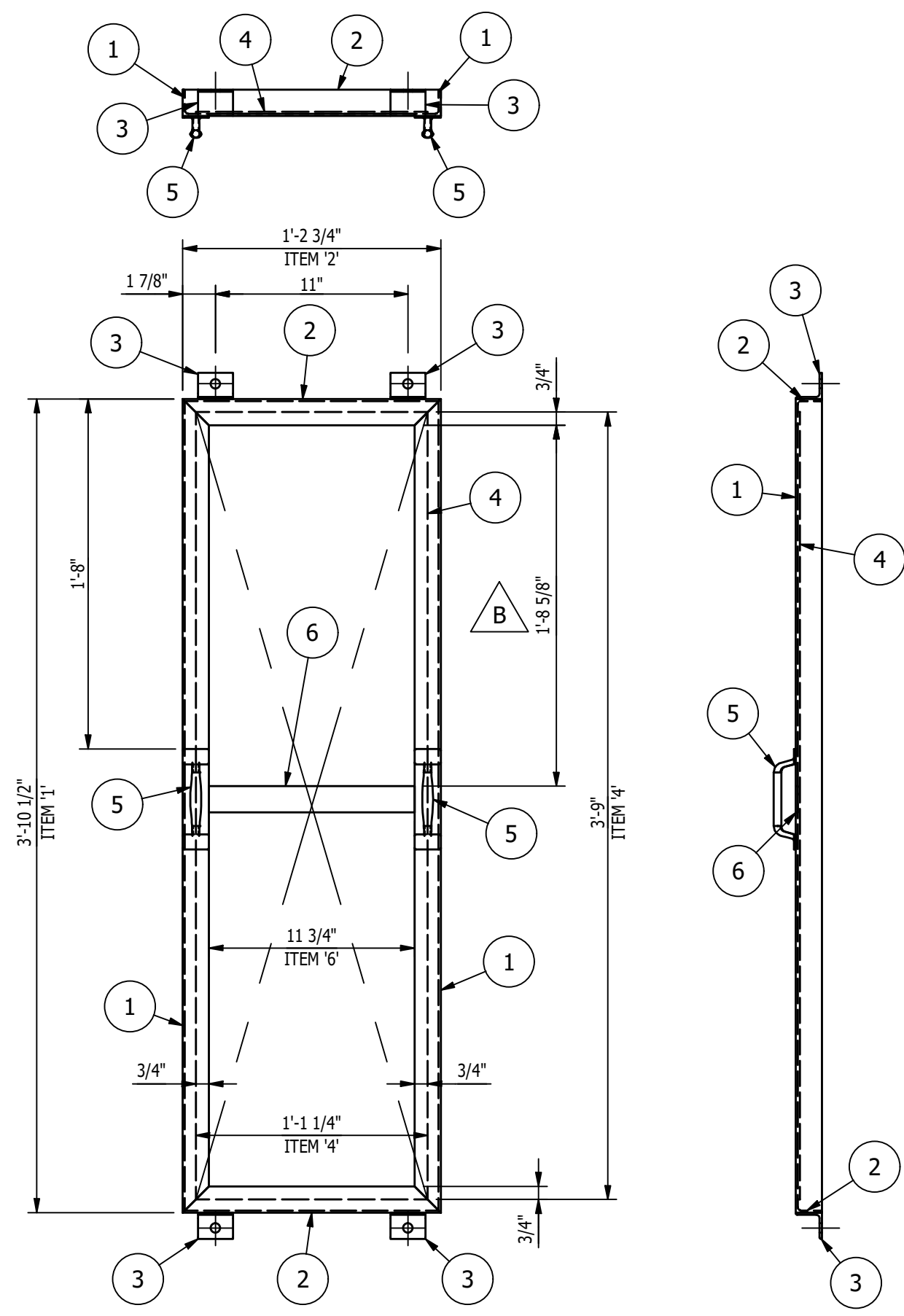
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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D479	DWG DATE:	10/20/22
REV:	B	JOB No.:	22096

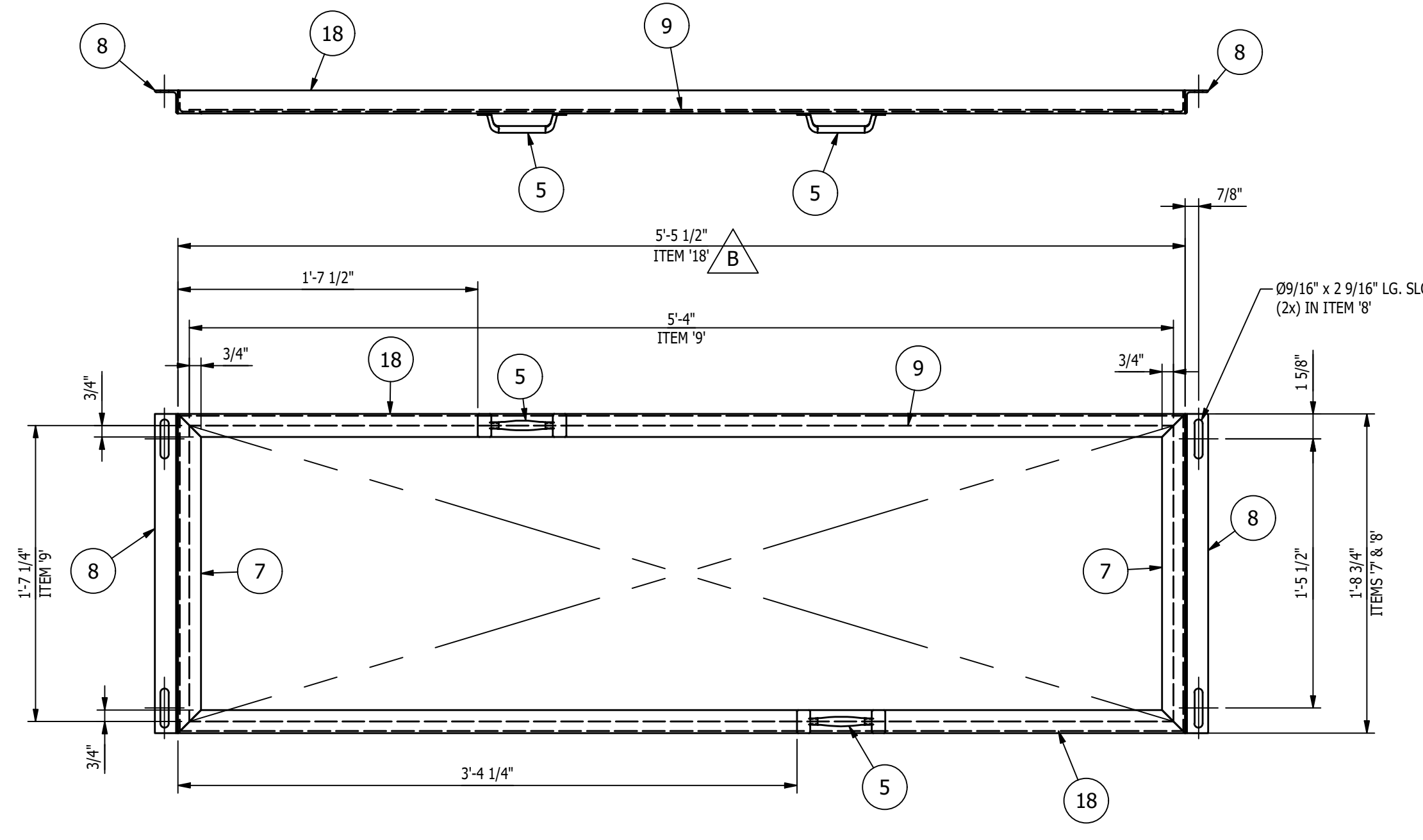
MAGNUM Consulting
 41700 Gardenbrook Rd. Phone: (248) 773-8929
 Suite 105 Fax: (248) 773-8921
 Novi, MI 48375 Web: www.48magnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D479 - 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

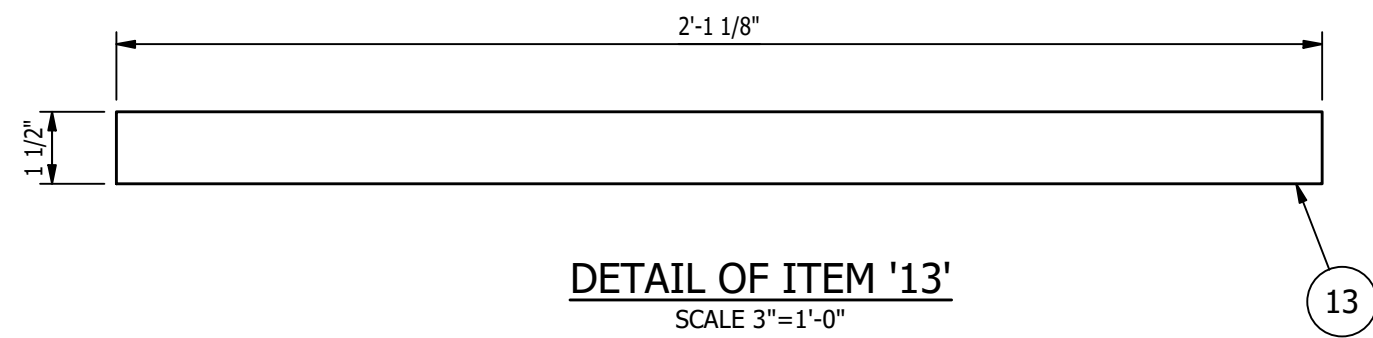
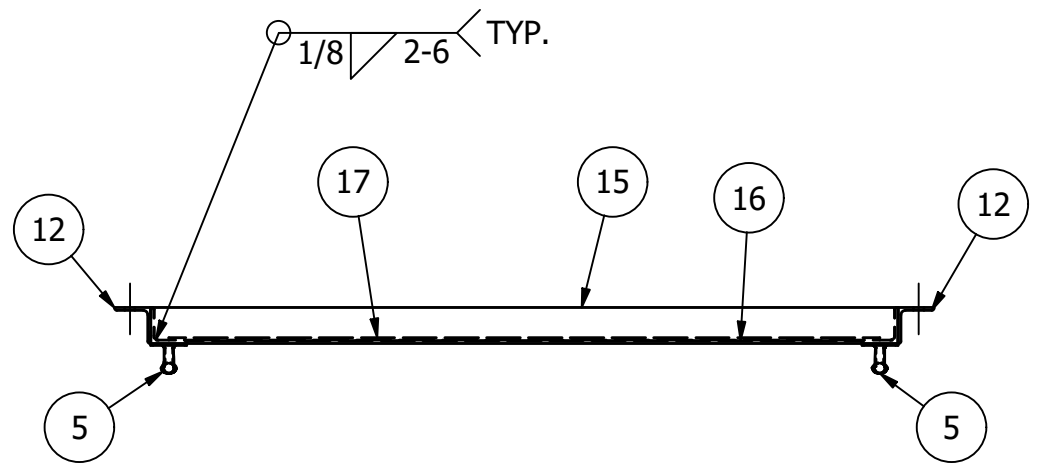


MK-D480A ~ GUARD
SCALE 1 1/2"=1'-0"

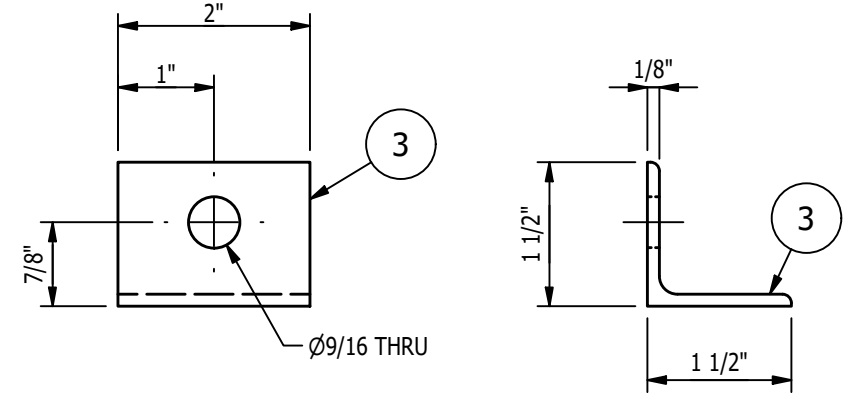


MK-D480B ~ GUARD
SCALE 1 1/2"=1'-0"

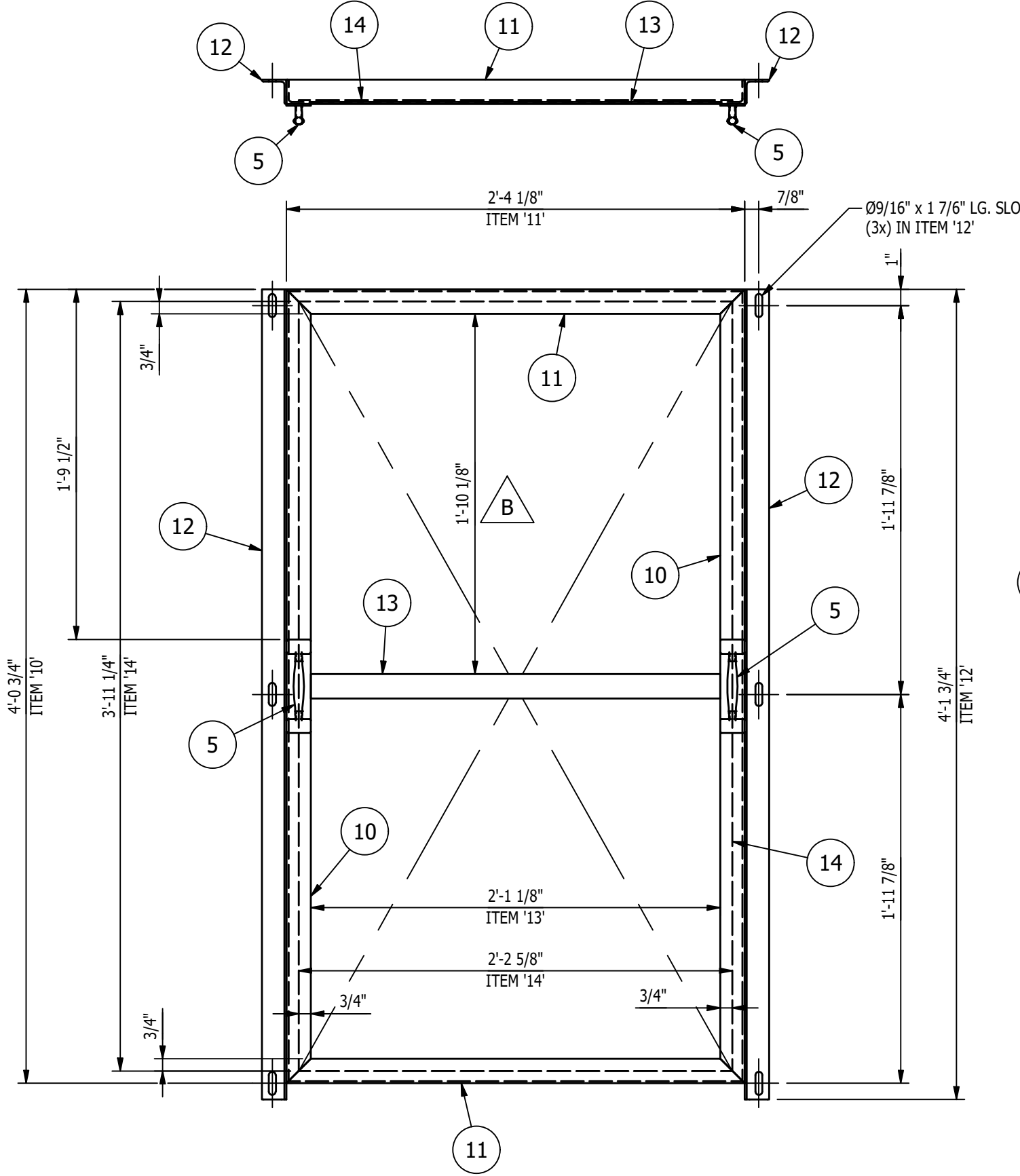
DETAIL OF ITEM '16'
SCALE 3"=1'-0"



DETAIL OF ITEM '13'
SCALE 3"=1'-0"

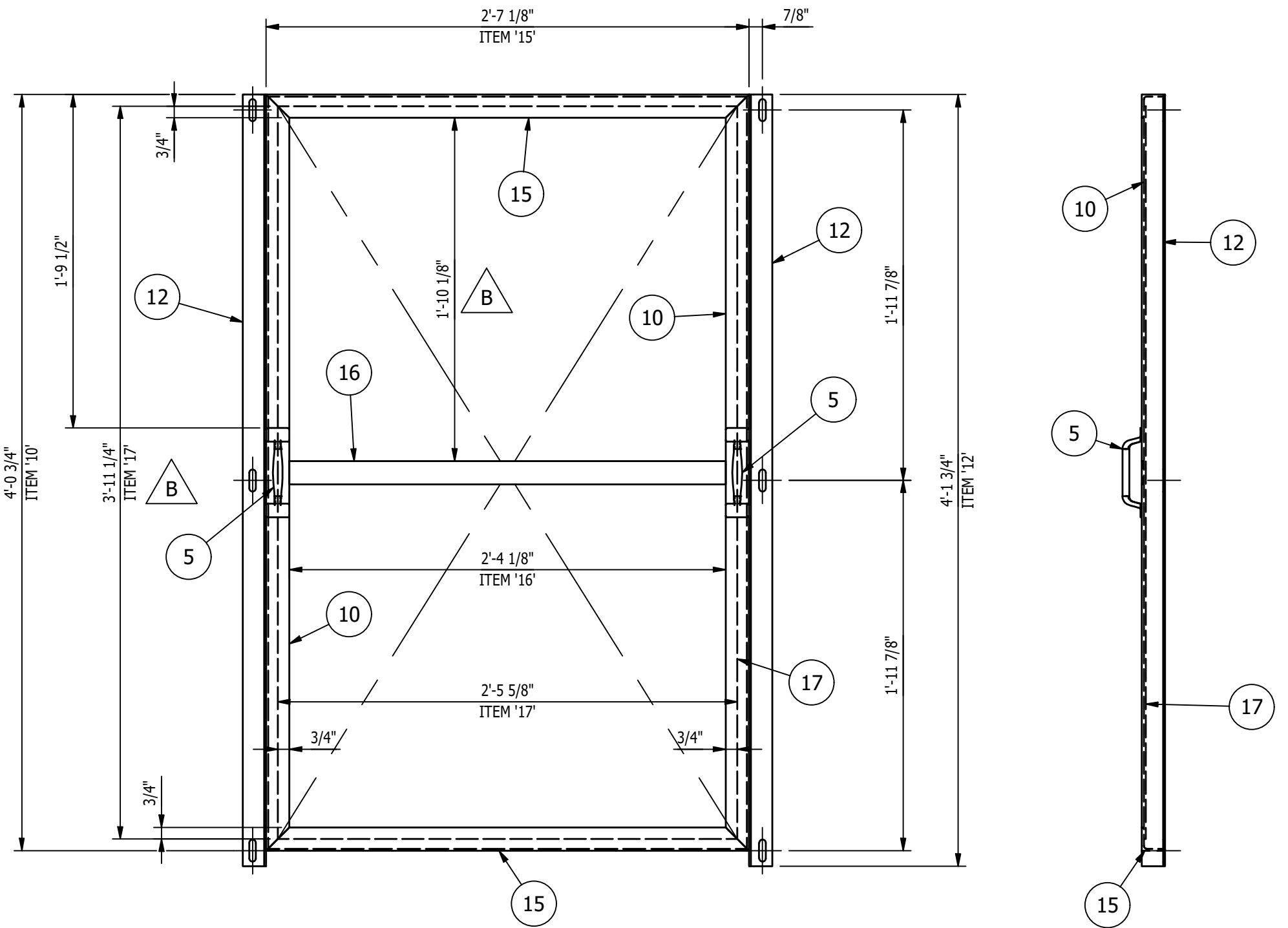


DETAIL OF ITEM '3'
SCALE 6"=1'-0"



MK-D480C ~ GUARD
SCALE 1 1/2"=1'-0"

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



MK-D480D ~ GUARD
SCALE 1 1/2"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	2	MK-D480A			
1	2	L 1 1/2 x 1 1/2 x 1/8 (MITER BOTH ENDS)	3'-10 1/2"		
2	2	L 1 1/2 x 1 1/2 x 1/8 (MITER BOTH ENDS)	1'-2 3/4"		
3	4	L 1 1/2 x 1 1/2 x 1/8	2"		
4	1	EXP MTL, 1/2-#13 x 13 1/4	3'-9"		
5	2	WELD-ON OVAL GRIP PULL HANDLE, McMASTER-CARR #1650A100 OR EQUIV.		28-14	
6	1	SHT 11 GA x 1 1/2"	11 3/4"		
MK-D480B					
5	2	WELD-ON OVAL GRIP PULL HANDLE, McMASTER-CARR #1650A100 OR EQUIV.		28-14	
7	2	L 1 1/2 x 1 1/2 x 1/8 (MITER BOTH ENDS)	1'-8 3/4"		
8	2	L 1 1/2 x 1 1/2 x 1/8	1'-8 3/4"		
9	1	EXP MTL, 1/2-#13 x 19 1/4	5'-4"		
18	2	L 1 1/2 x 1 1/2 x 1/8 (MITER BOTH ENDS)	5'-5 1/2"		
MK-D480C					
5	2	WELD-ON OVAL GRIP PULL HANDLE, McMASTER-CARR #1650A100 OR EQUIV.		28-14	
10	2	L 1 1/2 x 1 1/2 x 1/8 (MITER BOTH ENDS)	4'-3 3/4"		
11	2	L 1 1/2 x 1 1/2 x 1/8 (MITER BOTH ENDS)	2'-4 1/8"		
12	2	L 1 1/2 x 1 1/2 x 1/8	4'-1 3/4"		
13	1	SHT 11 GA x 1 1/2"	2'-1 1/8"		
14	1	EXP MTL, 1/2-#13 x 26 5/8	3'-11 1/4"		
MK-D480D					
5	2	WELD-ON OVAL GRIP PULL HANDLE, McMASTER-CARR #1650A100 OR EQUIV.		28-14	
10	2	L 1 1/2 x 1 1/2 x 1/8 (MITER BOTH ENDS)	4'-3 3/4"		
12	2	L 1 1/2 x 1 1/2 x 1/8	4'-1 3/4"		
15	2	L 1 1/2 x 1 1/2 x 1/8 (MITER BOTH ENDS)	2'-7 1/8"		
16	1	SHT 11 GA x 1 1/2"	2'-4 1/8"		
17	1	EXP MTL, 1/2-#13 x 2'-5 5/8"	3'-11 1/4"		

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

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

B	MC	11/28/22	ITEM '6' ON MK-D480B IS NOW ITEM '18', UPDATED DESCRIPTIONS OF ITEMS '3' & '15' ON BOM, ADDED NOT TO DIMENSION ON MK-D480D, ADDED DIMENSIONS	
A	MC	11/14/22	FOR FABRICATION	
REV	BY	DATE	DESCRIPTION	APP
REVISION HISTORY				

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 Suite 125
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 Fax: (770) 447-8801
 Web: www.mmagnum.com

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

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

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 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
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TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D480

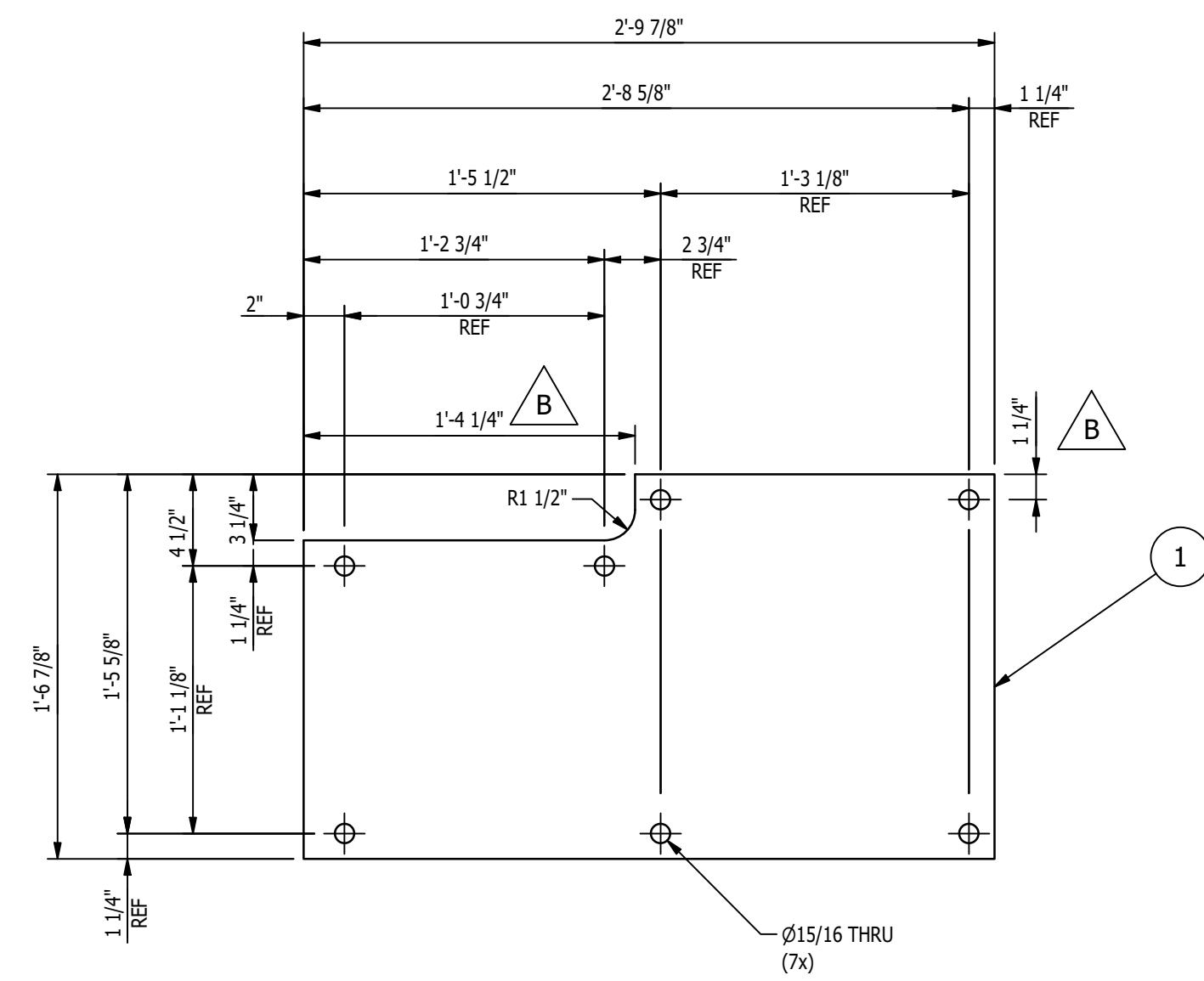
REV: B

DRAWN BY: RPM

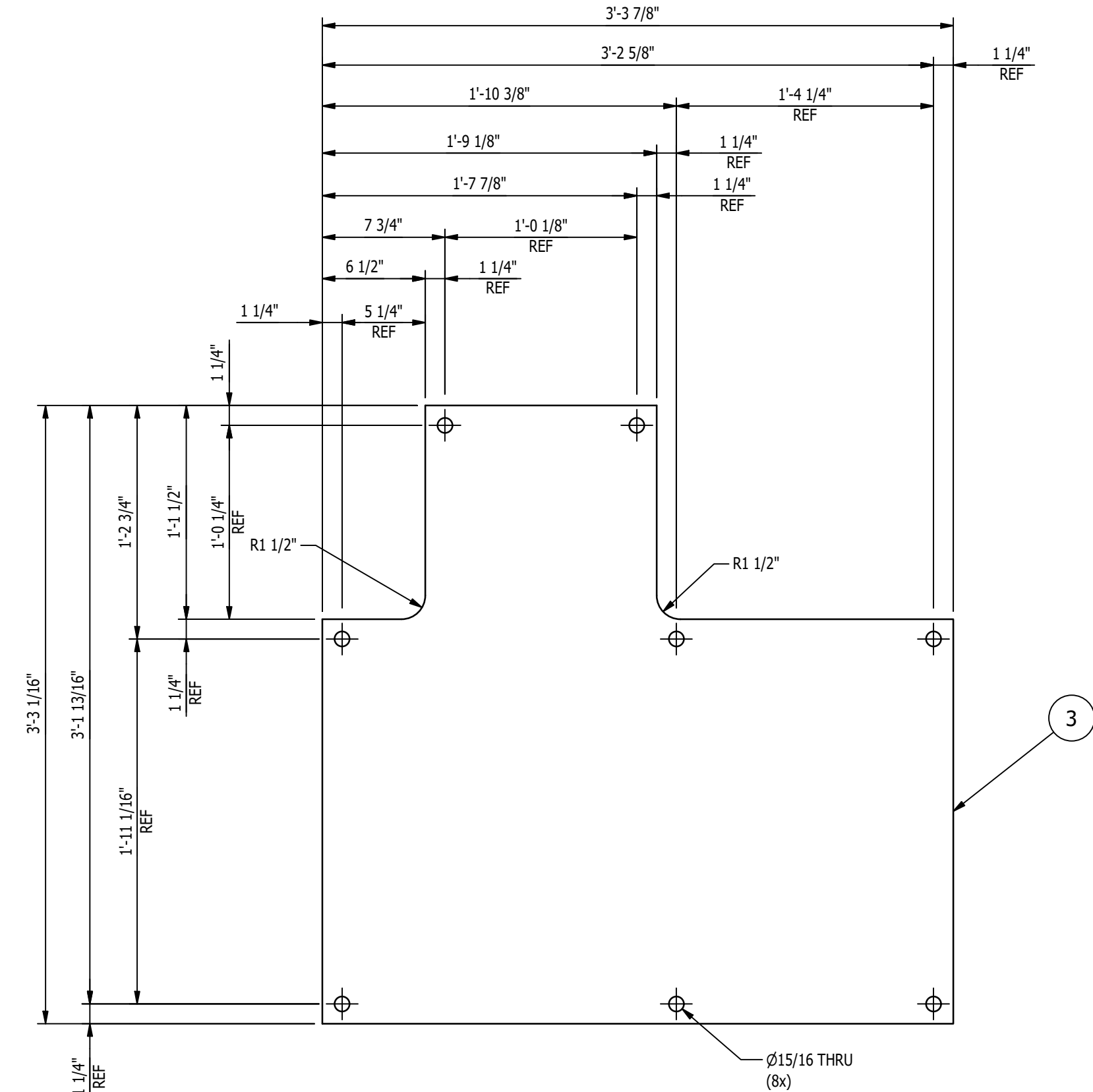
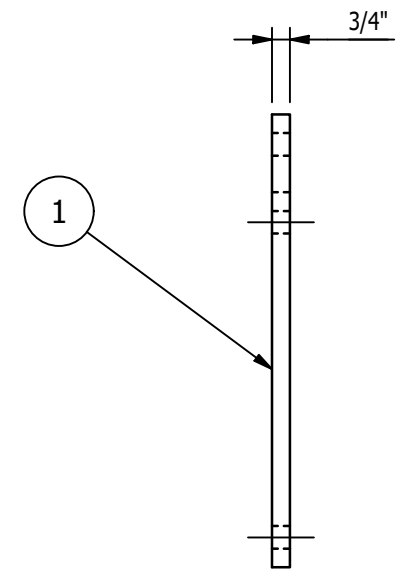
CHECKED BY: CW

DWG DATE: 11/10/22

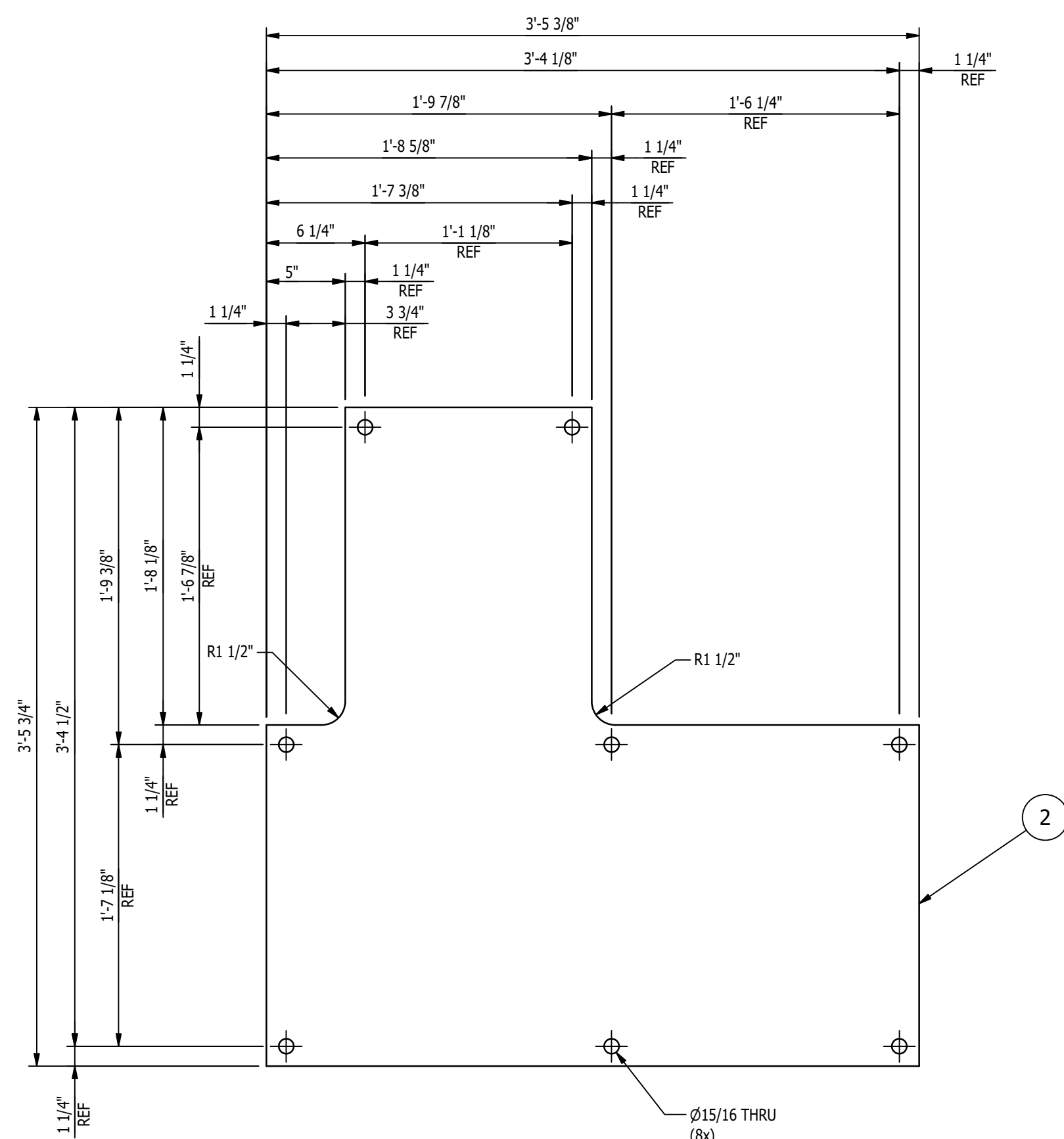
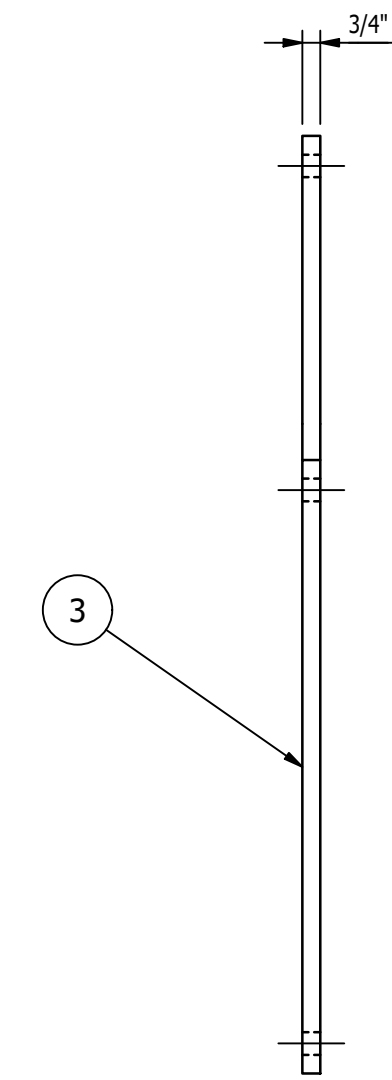
JOB No: 22096



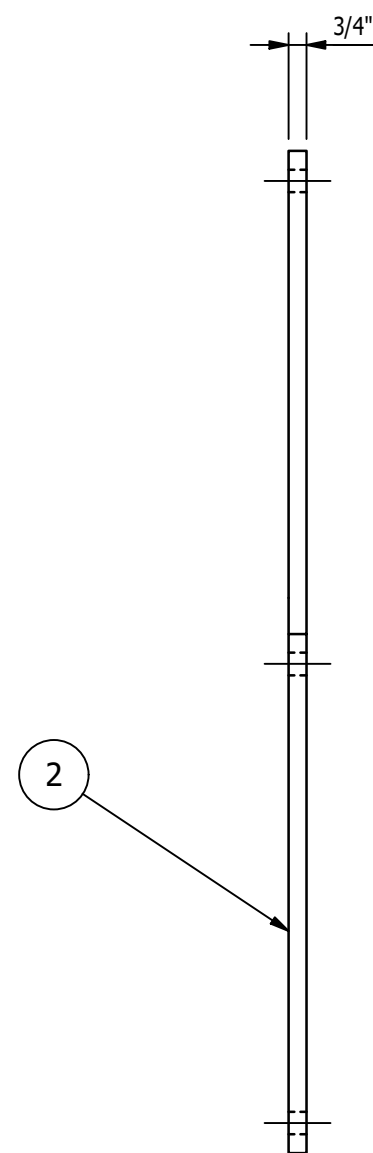
MK-D481A ~ BASE PLATE
SCALE 1 1/2"=1'-0"



MK-D481C ~ BASE PLATE
SCALE 1 1/2"=1'-0"



MK-D481B ~ BASE PLATE
SCALE 1 1/2"=1'-0"



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D481A			
1	1	PL 3/4 x 1'-6 7/8"	2'-9 7/8"		
		MK-D481B			
2	1	PL 3/4 x 3'-5 3/4"	3'-5 3/8"		
		MK-D481C			
3	1	PL 3/4 x 3'-3 1/16"	3'-3 7/8"		

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED DIMENSIONS	
A	MC	11/14/22	FOR FABRICATION	

REVISION HISTORY	
B	MC 11/28/22 ADDED DIMENSIONS
A	MC 11/14/22 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 SNIUG TIGHT CONDITION, UNLESS NOTED.

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

MAGNUM Consulting

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

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D481

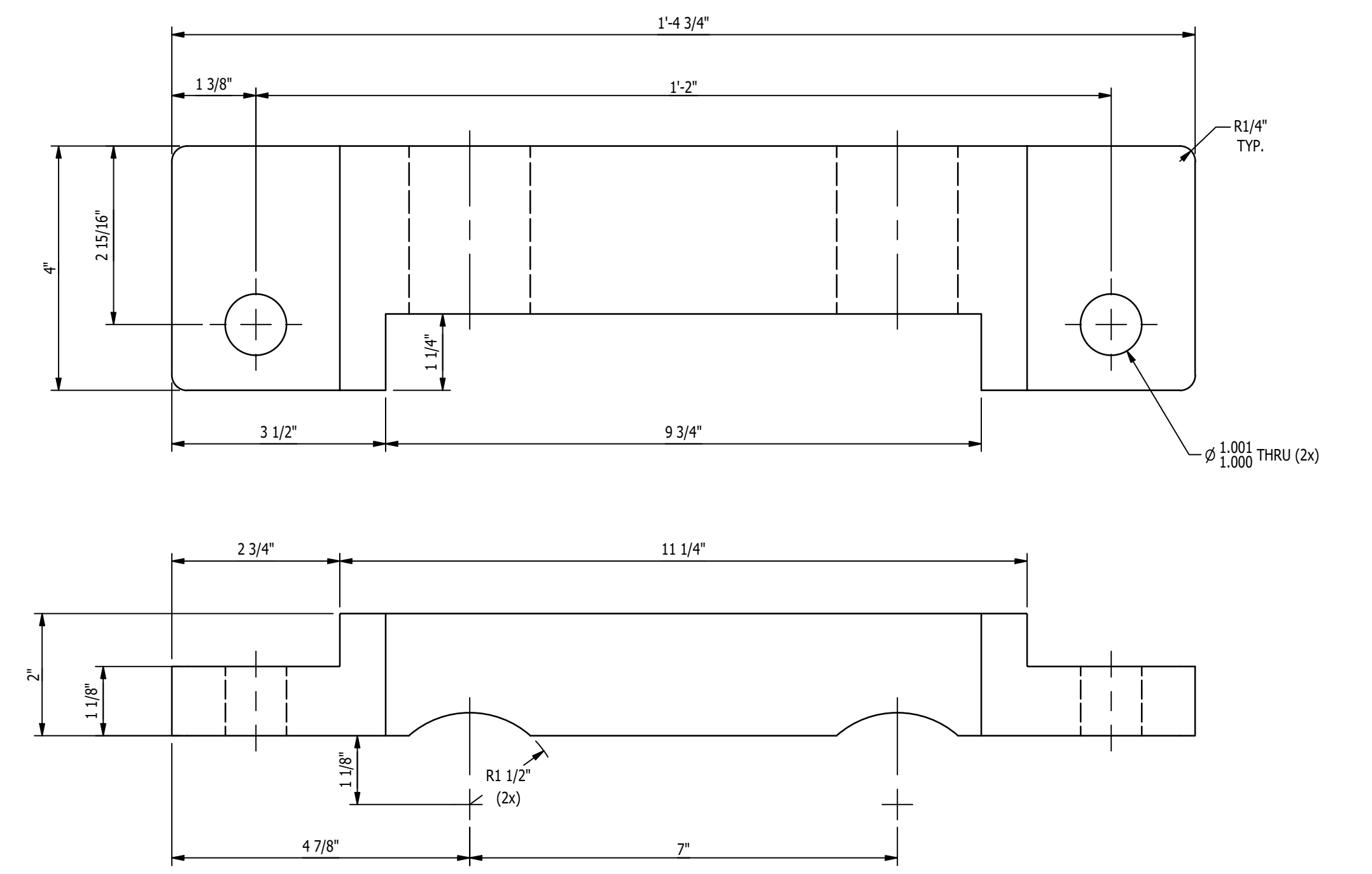
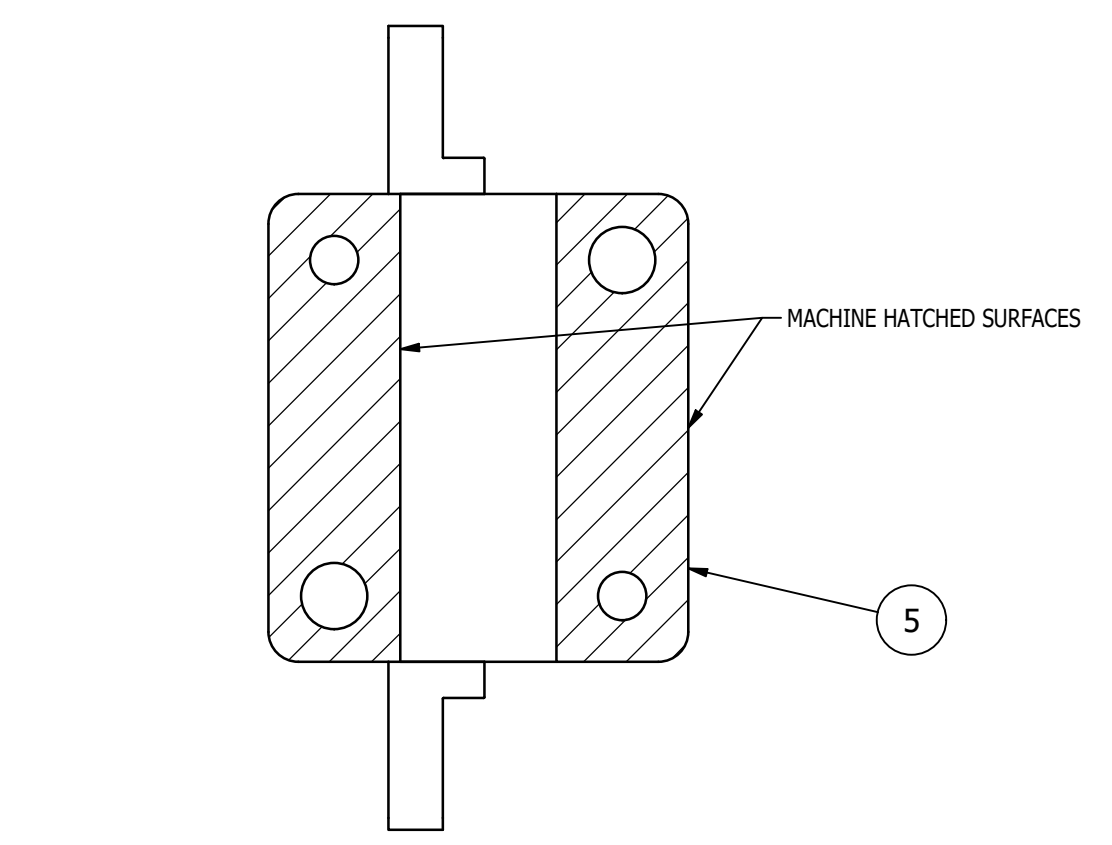
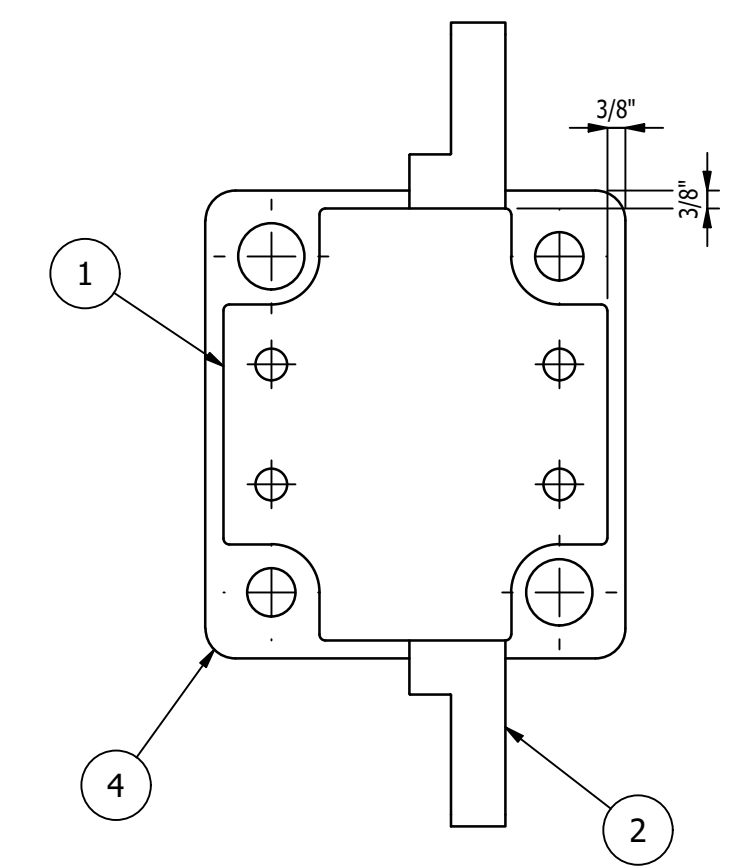
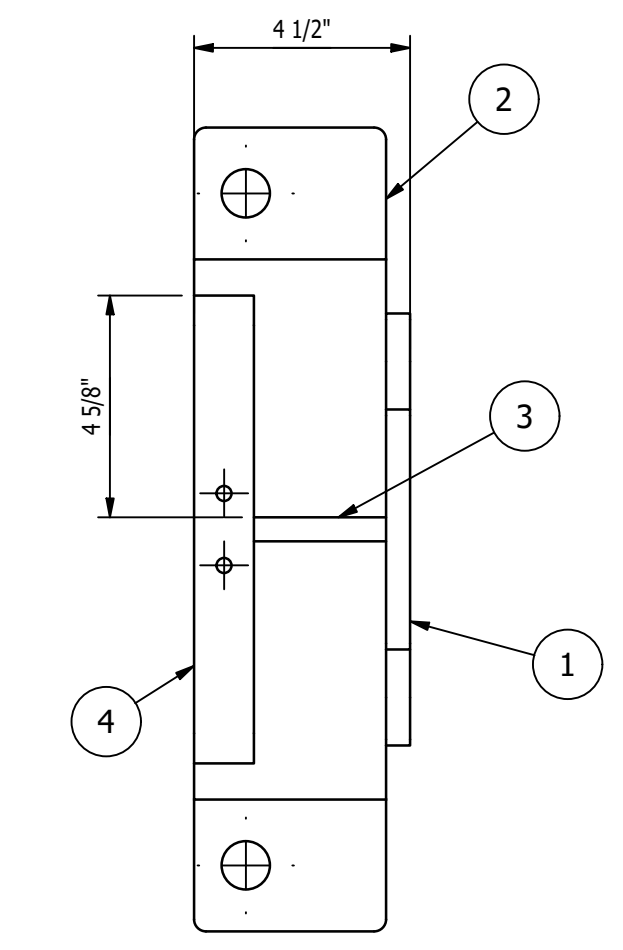
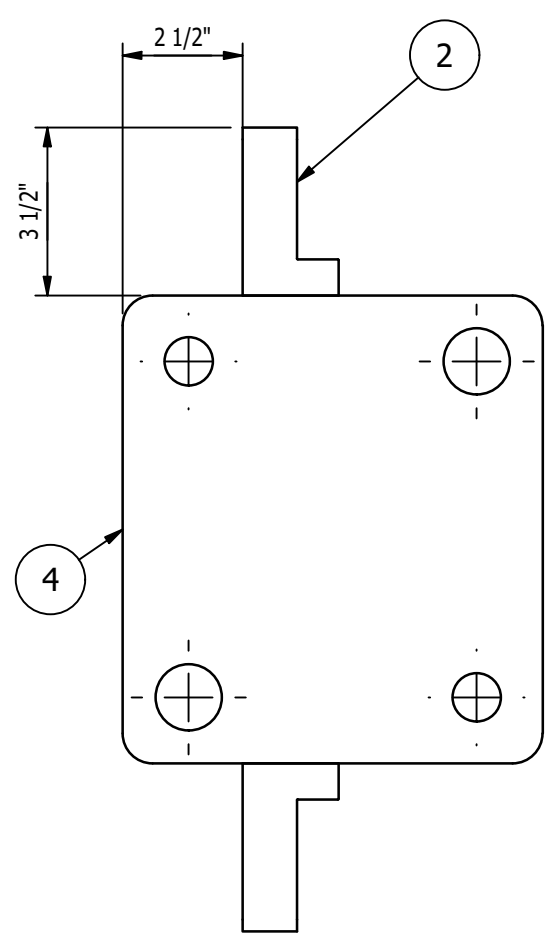
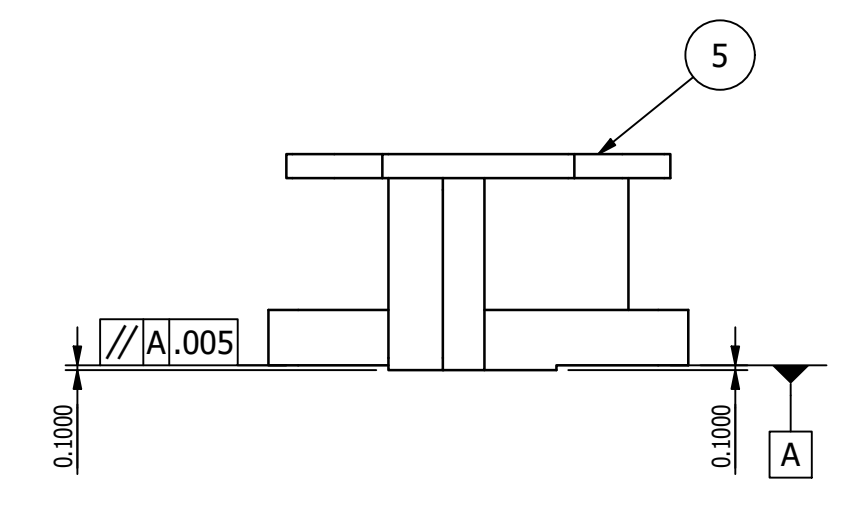
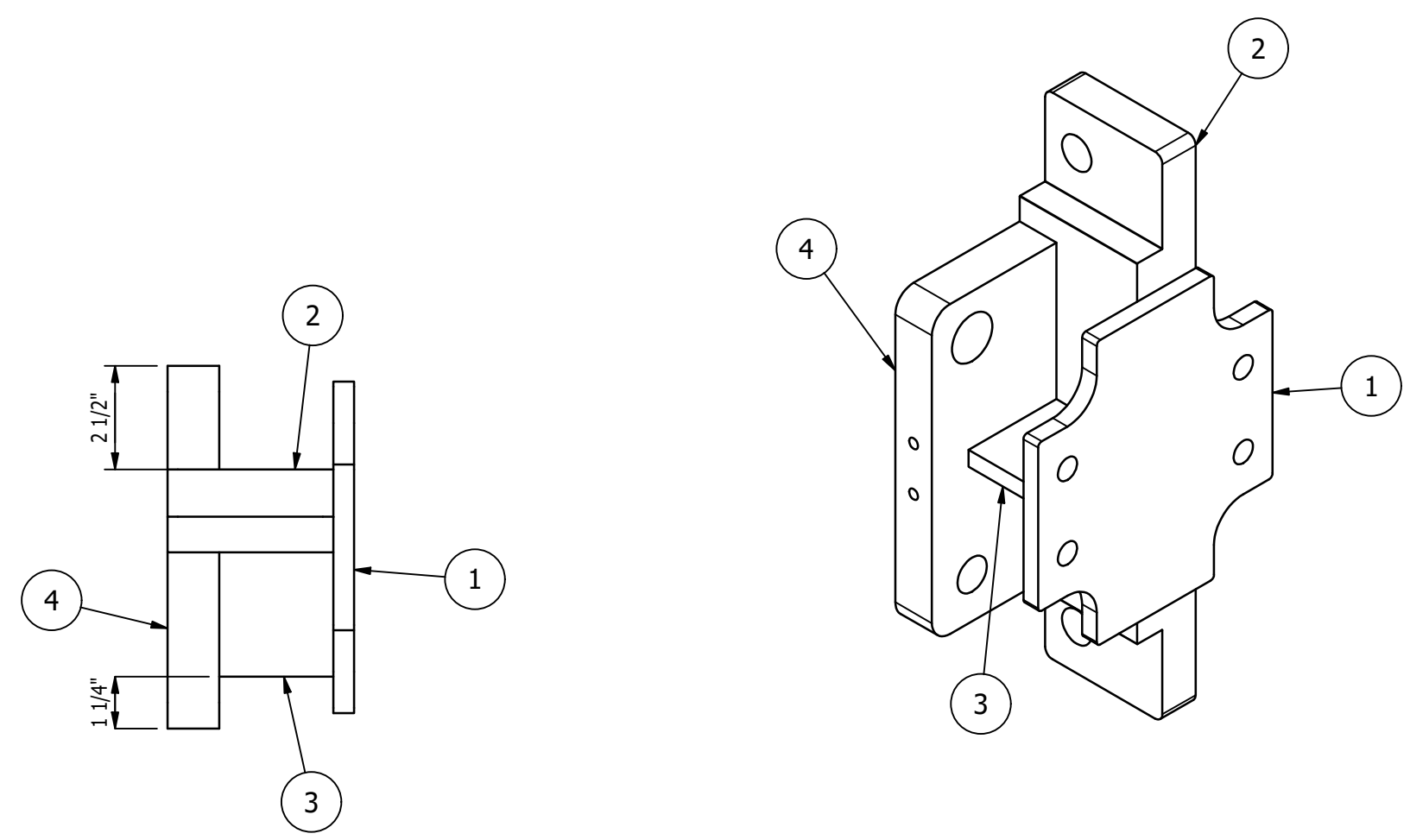
UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

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 3070 W. THOMPSON RD.
 FENTON, MI 48430
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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	BTC
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D481	DWG DATE:	11/2/22
REV:	B	JOB No:	22096

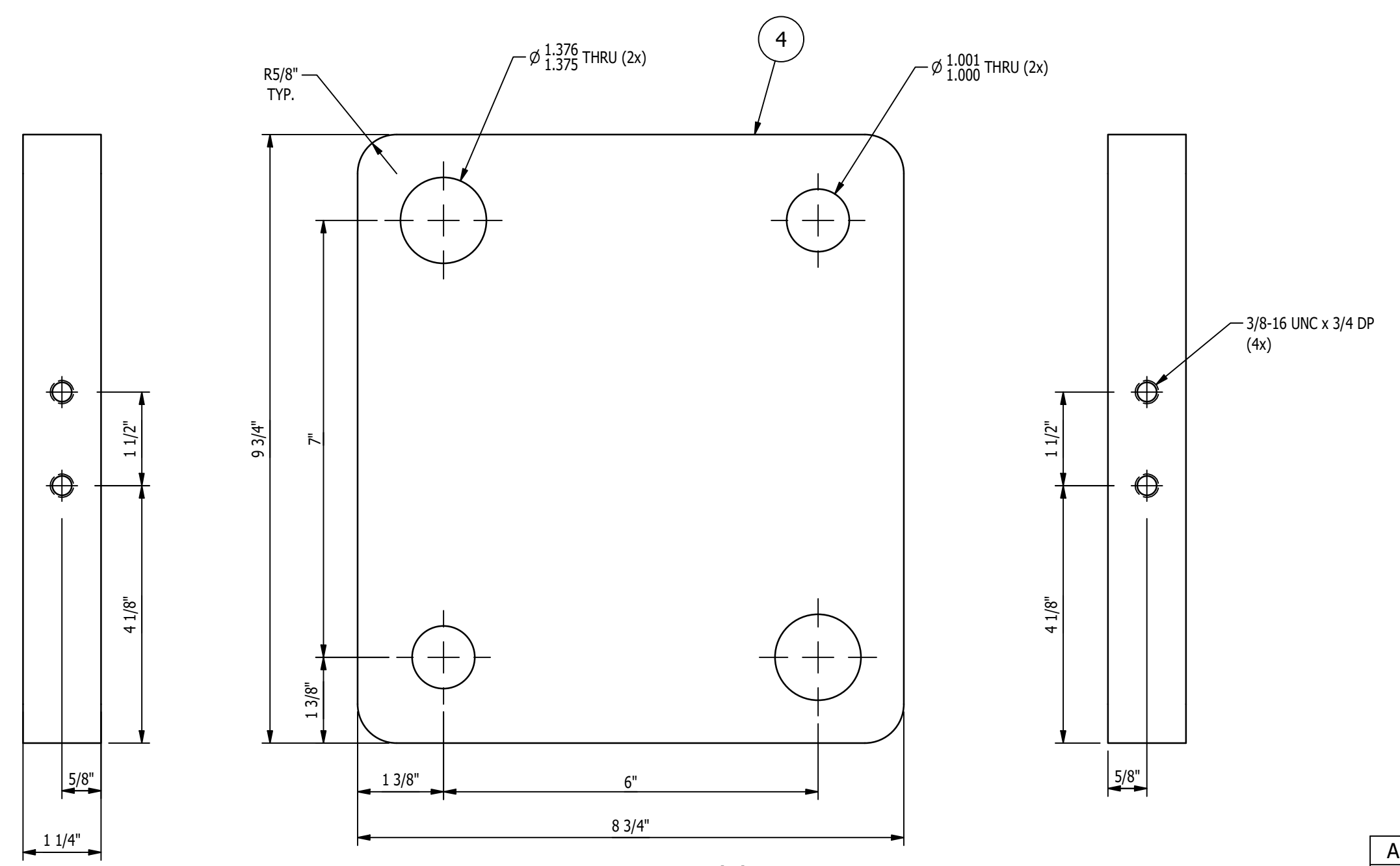
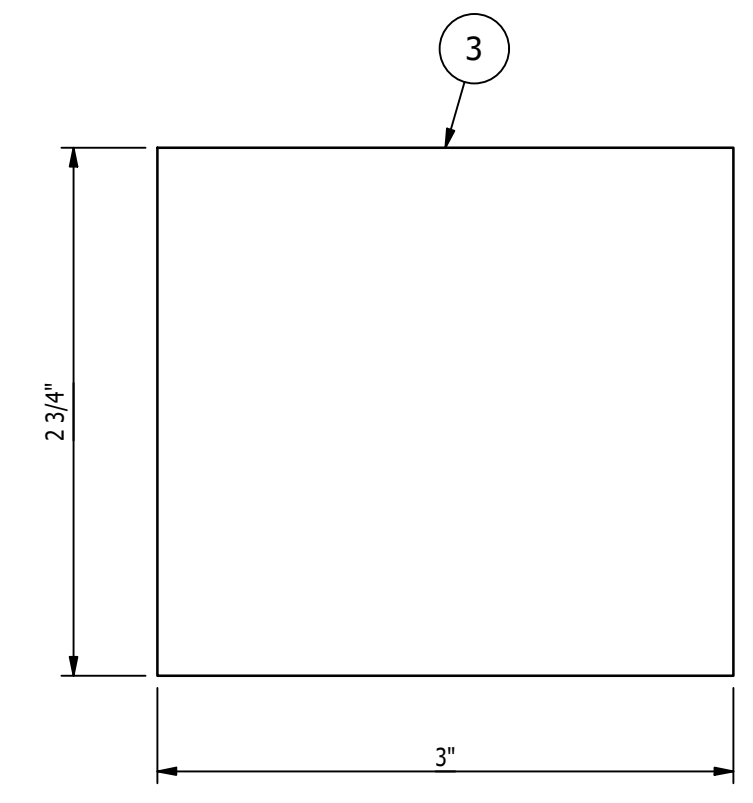
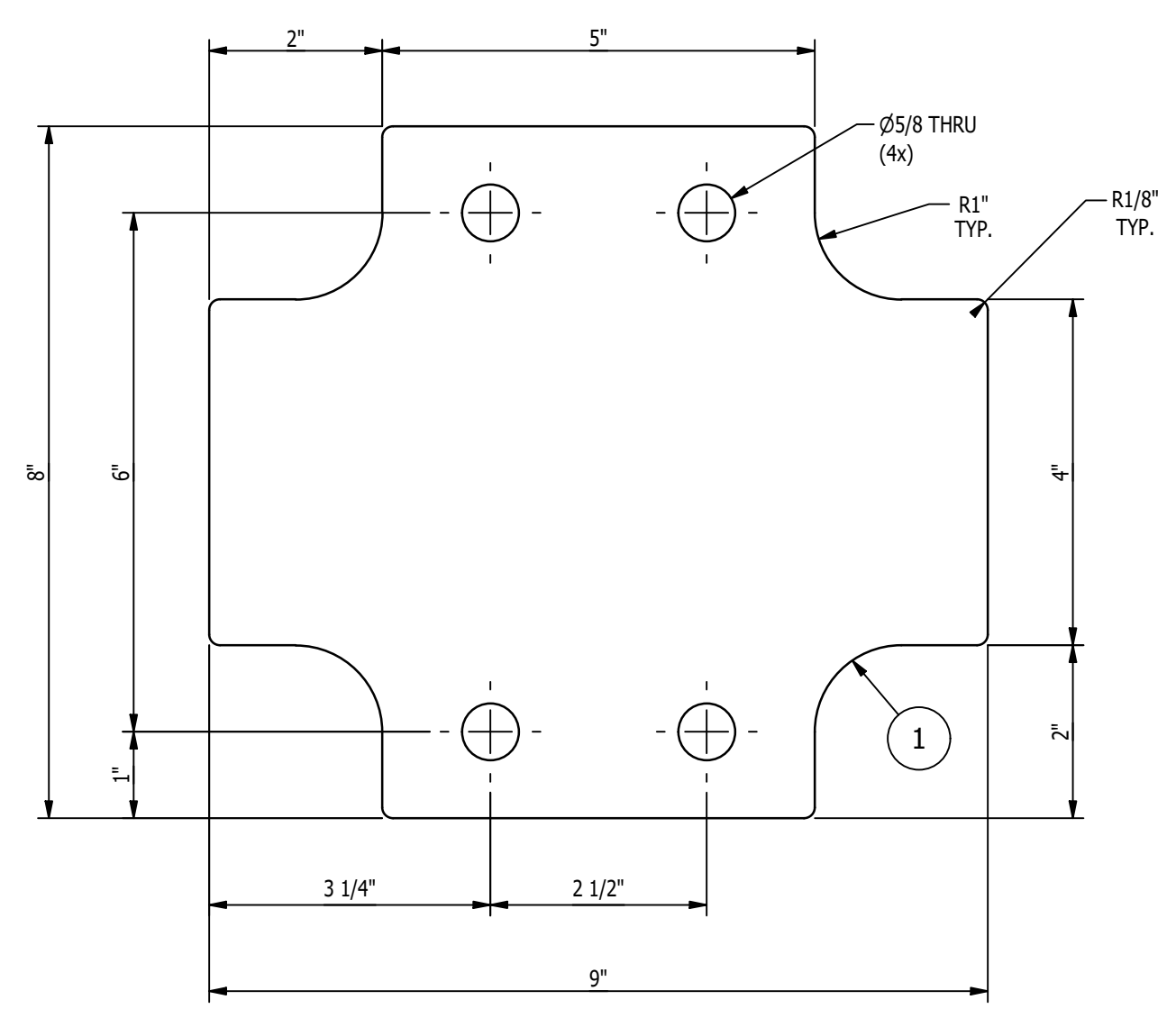
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D482A			
1	1	PL 1/2 x 8"	9"		
2	1	PL 2 x 4"	1'-4 3/4"		
3	1	PL 1/2 x 2 3/4"	3"		
4	1	PL 1 1/4 x 8 3/4"	9 3/4"		
5	1	MK-D482B			
5	1	MK-D482A ~ CAM GUIDE ROLLER WELDMENT			



MK-D482A ~ CAM GUIDE ROLLER WELDMENT
SCALE 3"=1'-0"

MK-D482B ~ CAM GUIDE ROLLER MACHINING
SCALE 3"=1'-0"

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



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

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

DETAIL OF ITEM '4'
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	MC	DATE	DESCRIPTION	APP
A		MC	11/15/22	FOR FABRICATION	

REVISION HISTORY

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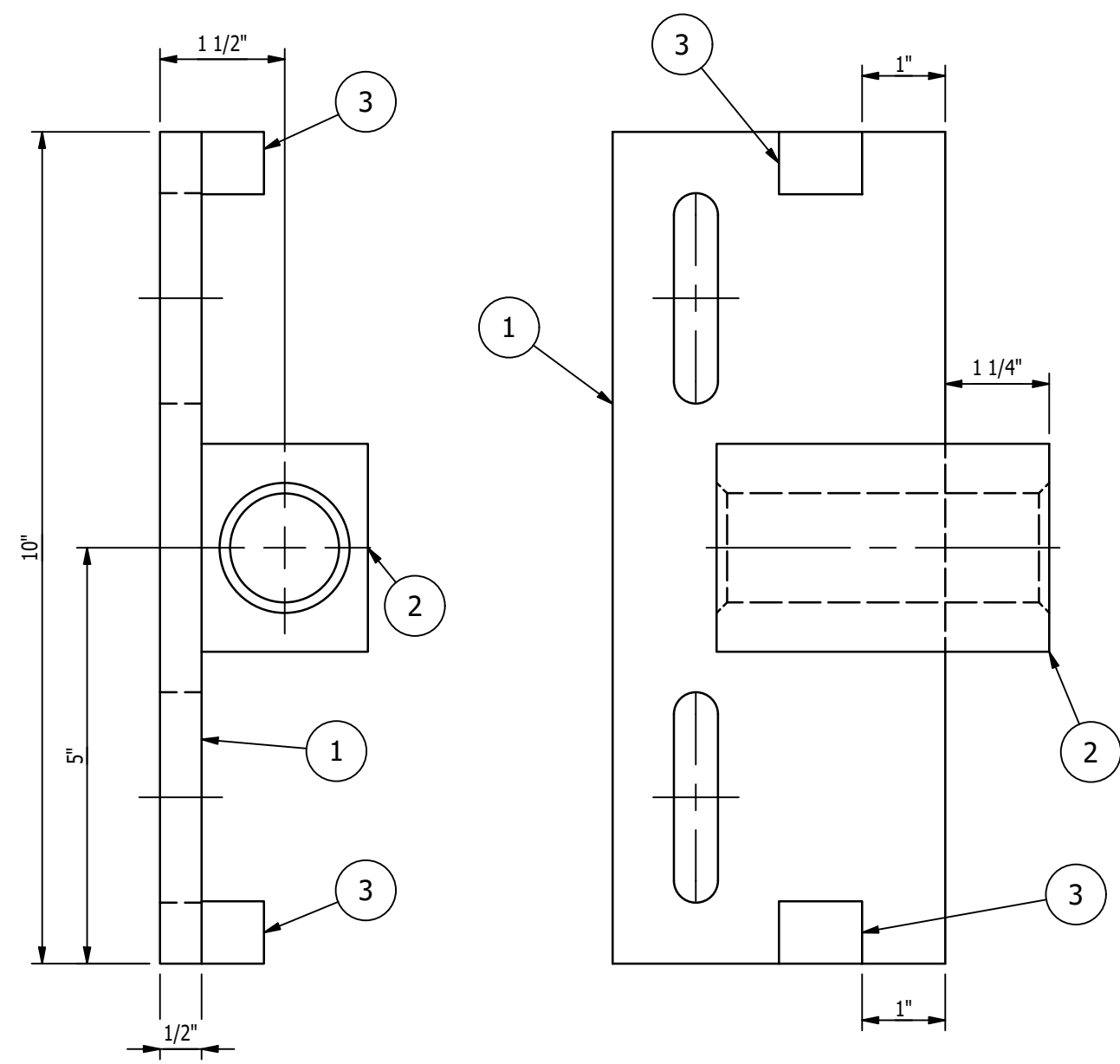
TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No.: 1875D482	DWG DATE: 11/8/22
REV: A	JOB No.: 22096

MAGNUM CONSULTING
 41700 Gardsborough Rd.
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 Fax: (248) 772-8851
 Web: www.m4magnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D482 - REV A

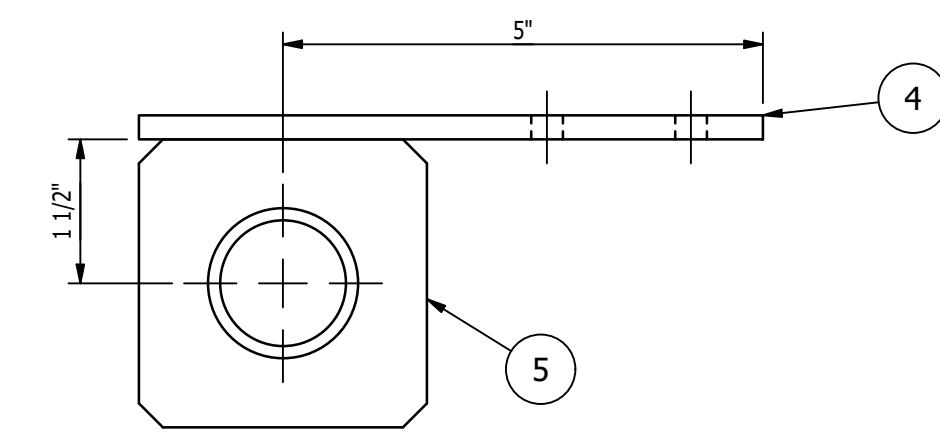
UNLESS OTHERWISE NOTED:
 X = ±.060
 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

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 SLUG TIGHT CONDITION, UNLESS NOTED.
WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

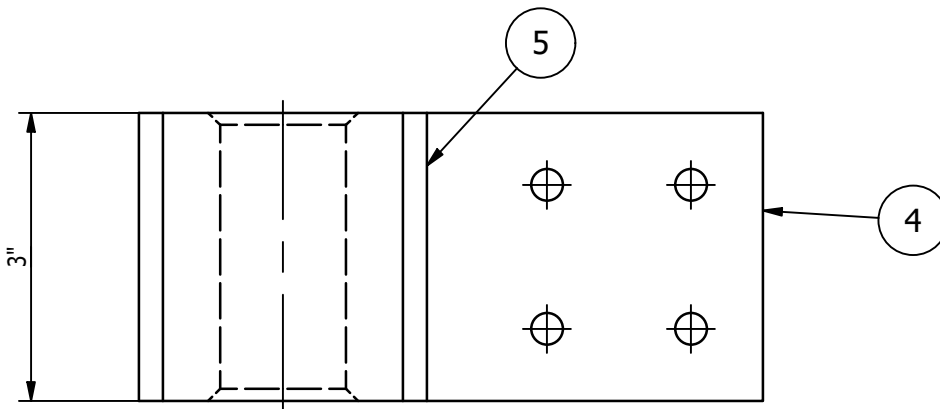


MK-D483A ~ PIN GUIDE
SCALE 6"=1'-0"

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

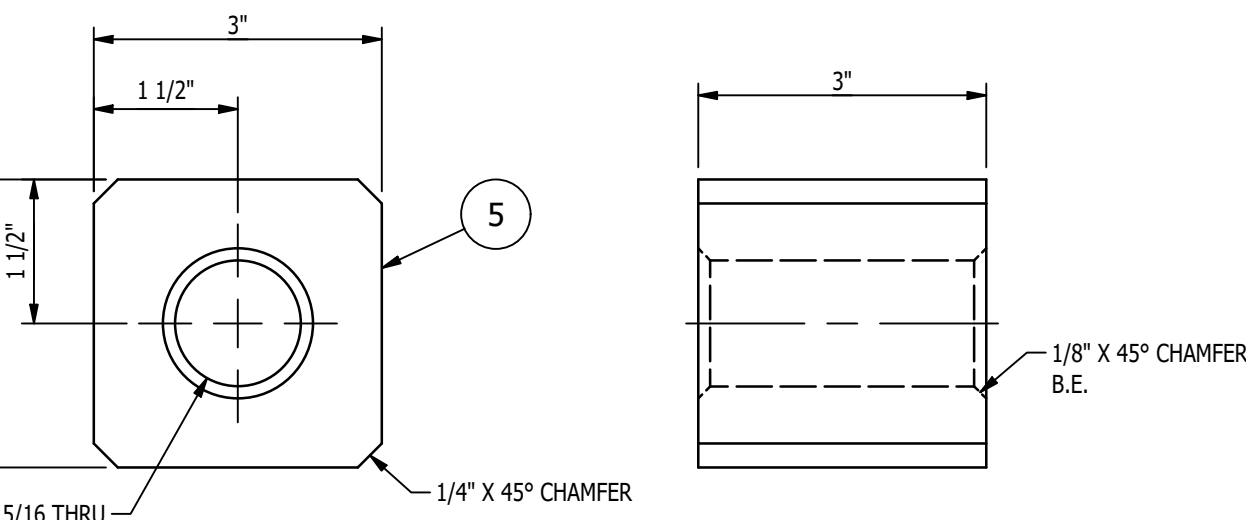


MK-D483B ~ PIN HOLDER
SCALE 6"=1'-0"

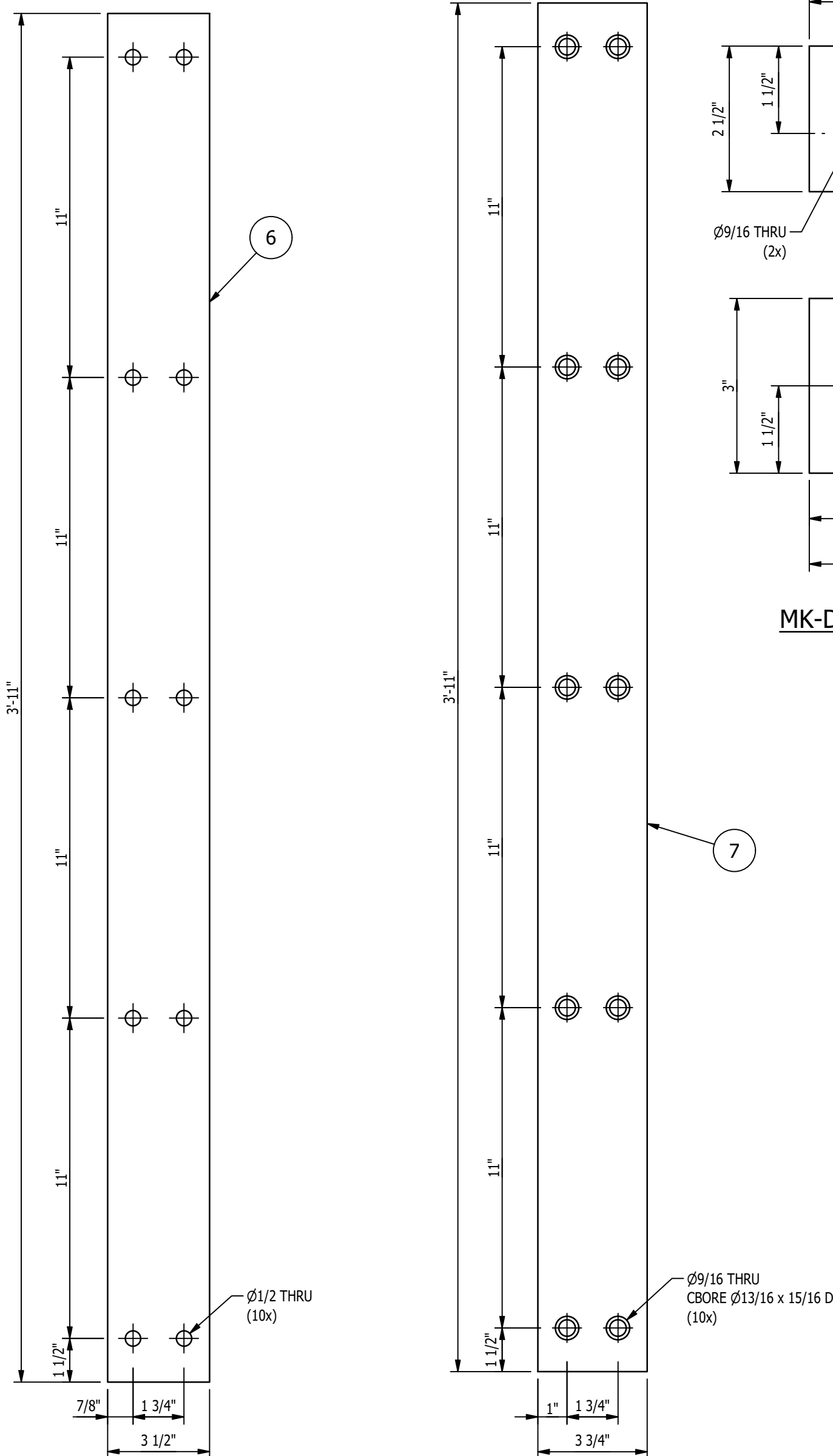


MK-D483C ~ GUIDE BAR SPACER
SCALE 3"=1'-0"

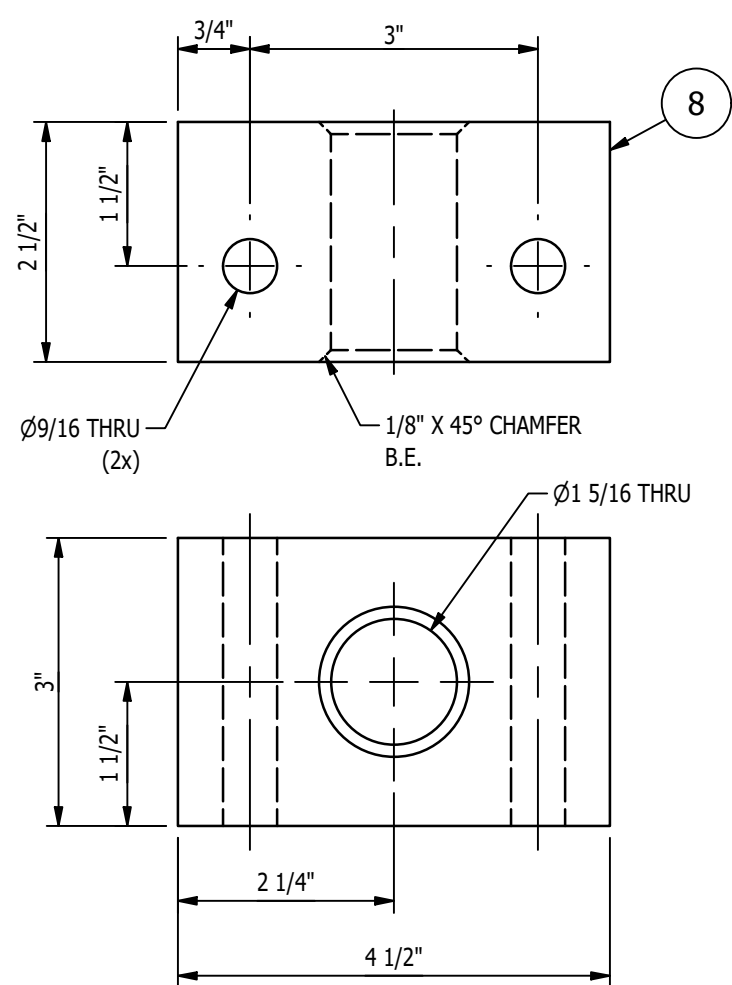
MK-D483D ~ GUIDE BAR
SCALE 3"=1'-0"



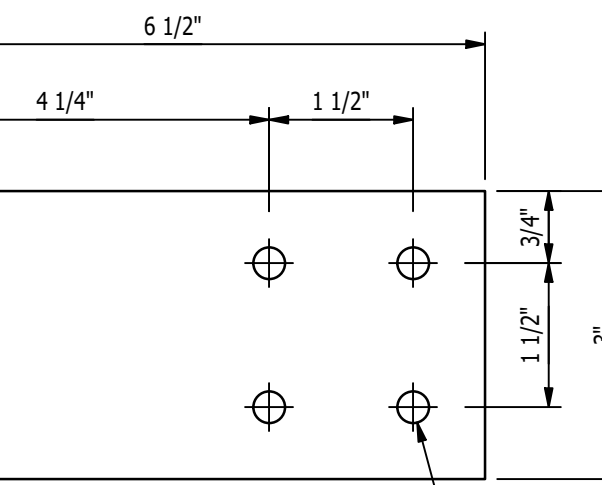
DETAIL OF ITEM '5'
SCALE 6"=1'-0"



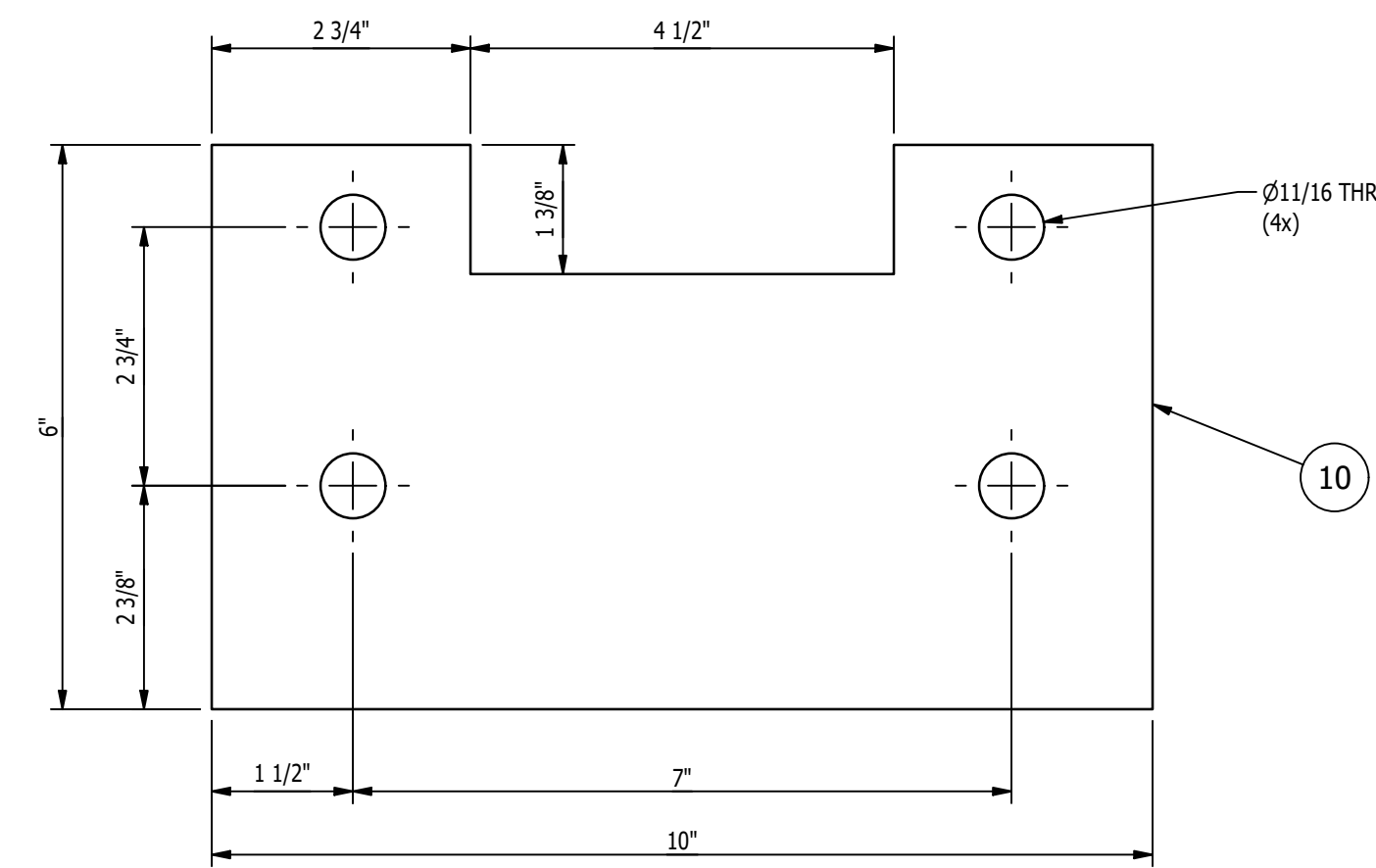
DETAIL OF ITEM '1'
SCALE 6"=1'-0"



MK-D483E ~ PIN HOLDER
SCALE 6"=1'-0"



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



MK-D483G ~ SPACER
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D483A			
1	1	BAR 1/2 x 4	10"		
2	1	BAR 2 x 2 1/2	4"		
3	2	SQ. BAR 3/4	1"		
		MK-D483B			
4	1	PL 1/4 x 3"	6 1/2"		
5	1	SQ. BAR 3 (A36)	3"		
		MK-D483C			
6	1	PL 1/4 x 3 1/2"	3'-11"		
		MK-D483D			
7	1	PL 2 x 3 3/4" (AR 400)	3'-11"		
		MK-D483E			
8	1	PL 3 x 2 1/2"	4 1/2"		
		MK-D483G			
10	1	PL 1/4 x 6"	10"		

- 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.

A	MC	11/15/22	FOR FABRICATION	
REV	BY	DATE	DESCRIPTION	APP
REVISION HISTORY				

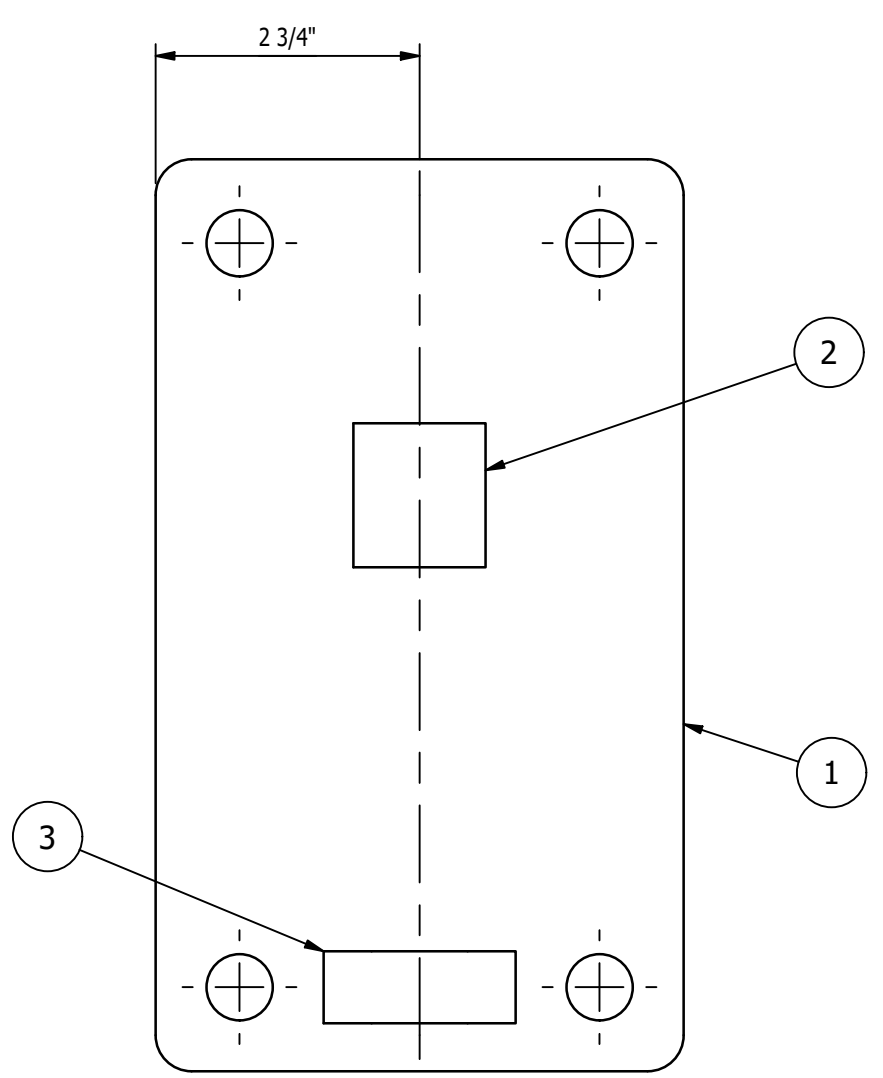
MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D483	DWG DATE: 10/26/2
REV: A	JOB No: 22096

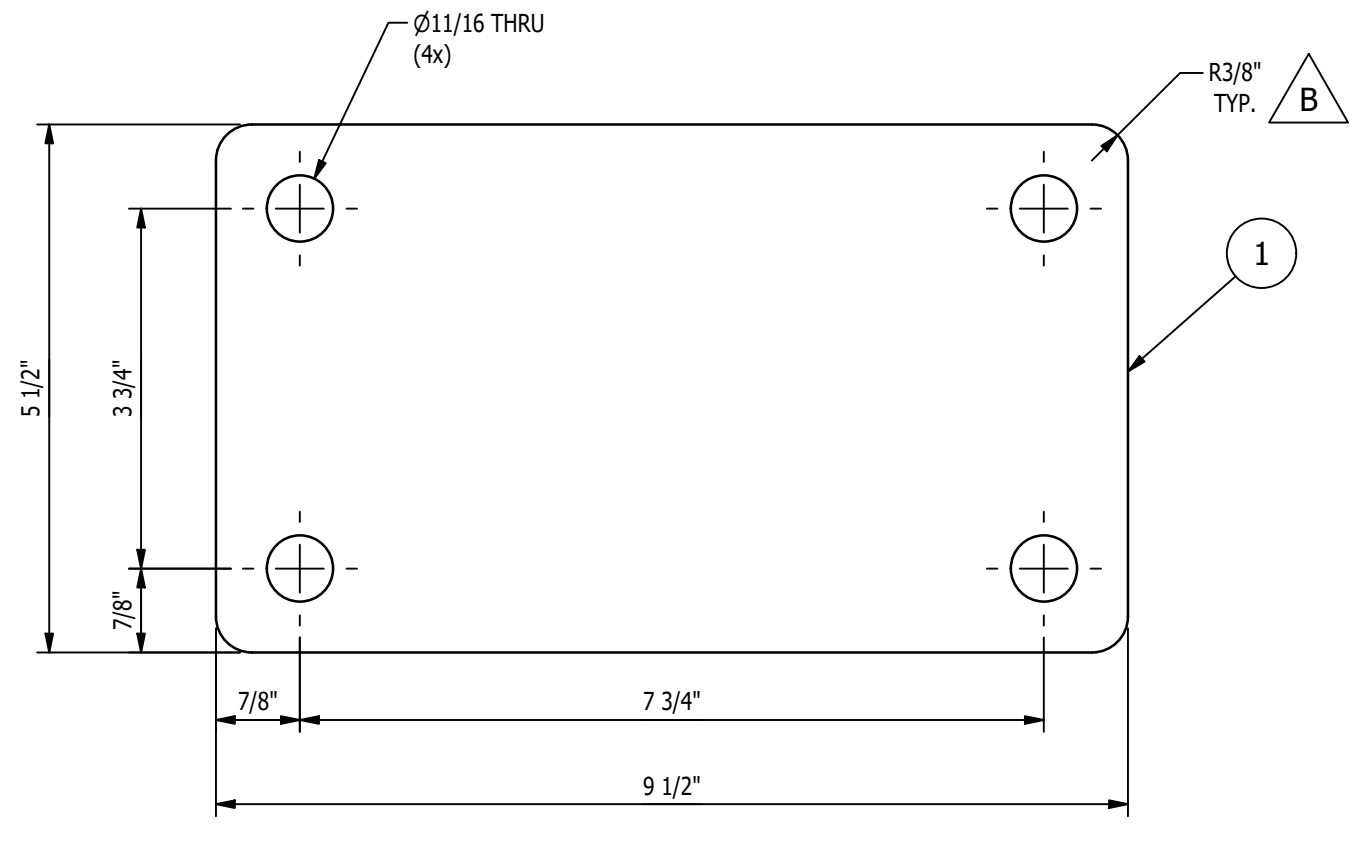
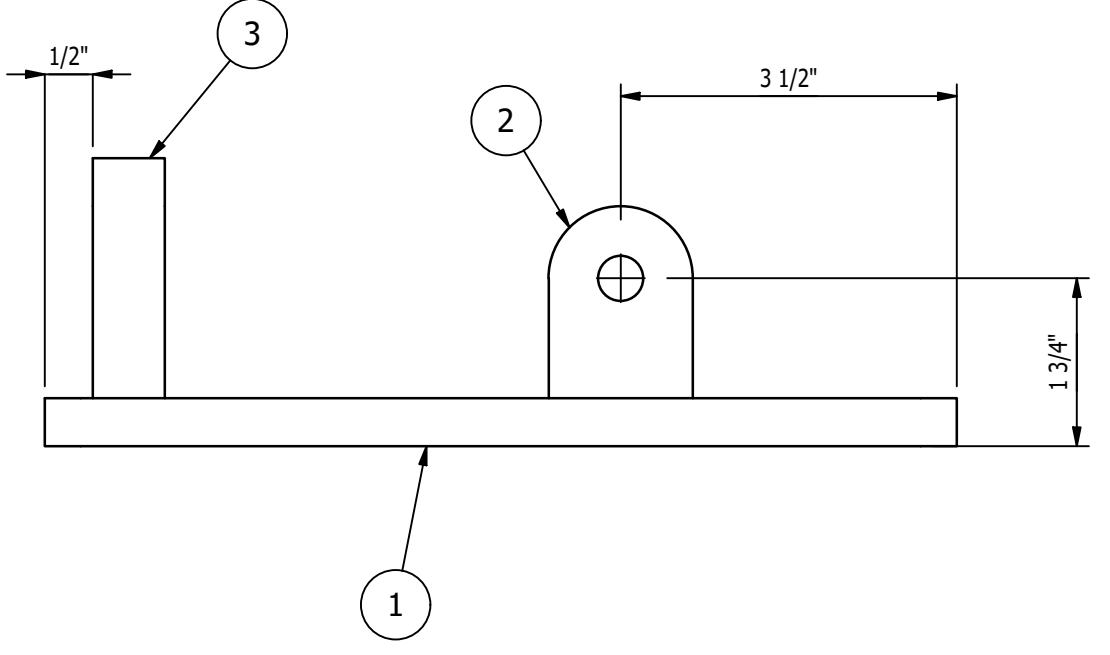
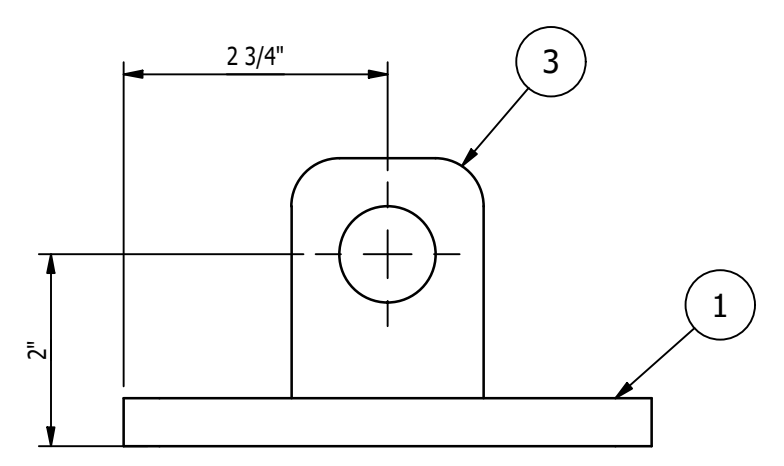
MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
North, MI 48315
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D483 - REV A

- 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.

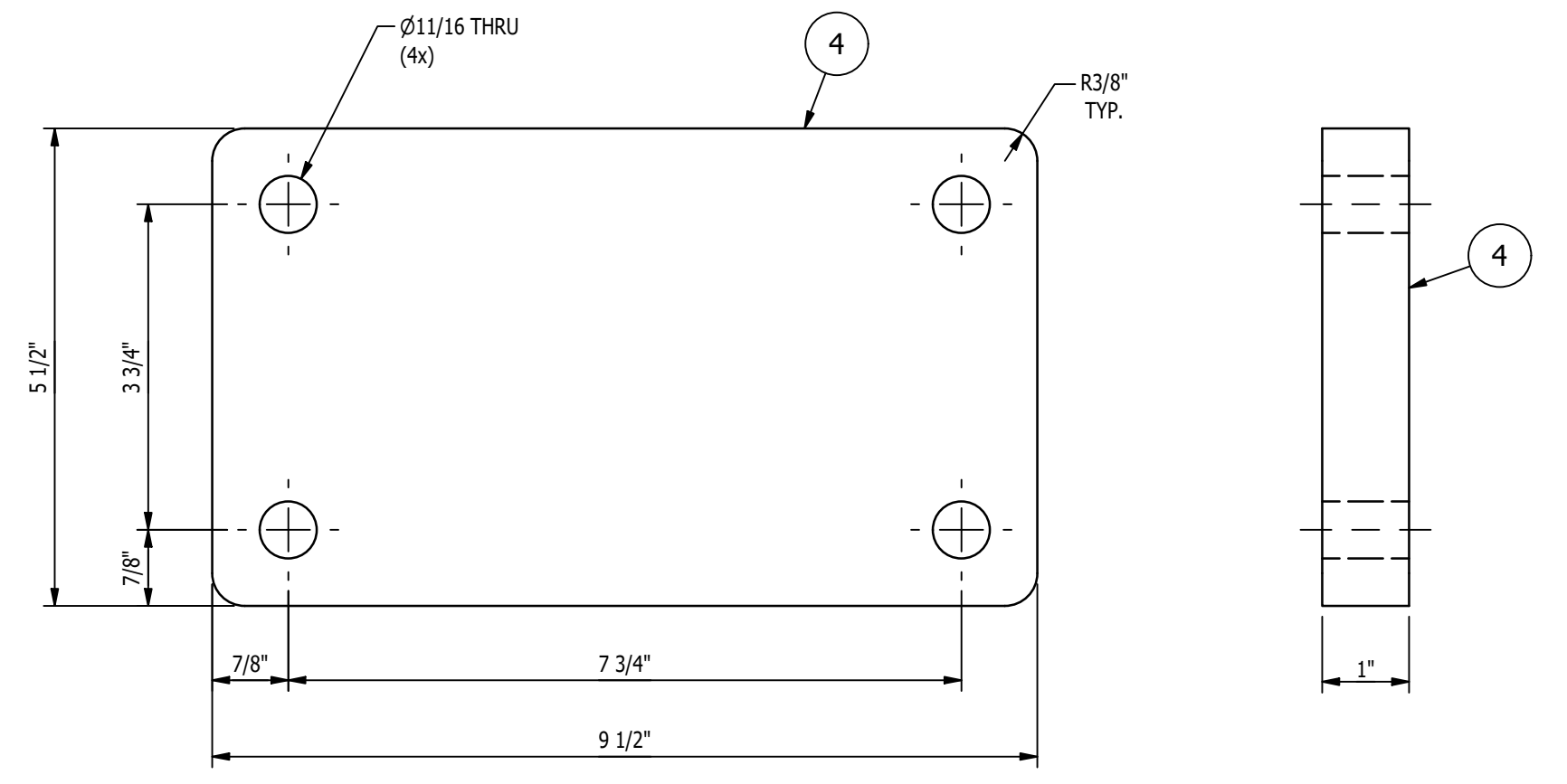
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D484A			
1	1	PL 1/2 x 5 1/2"	9 1/2"		
2	1	PL 1 3/8 x 1 1/2" (1045)	2"		
3	1	PL 3/4 x 2" (1045)	2 1/2"		
		MK-D484B			
4	1	BAR 1 x 5 1/2"	9 1/2"		



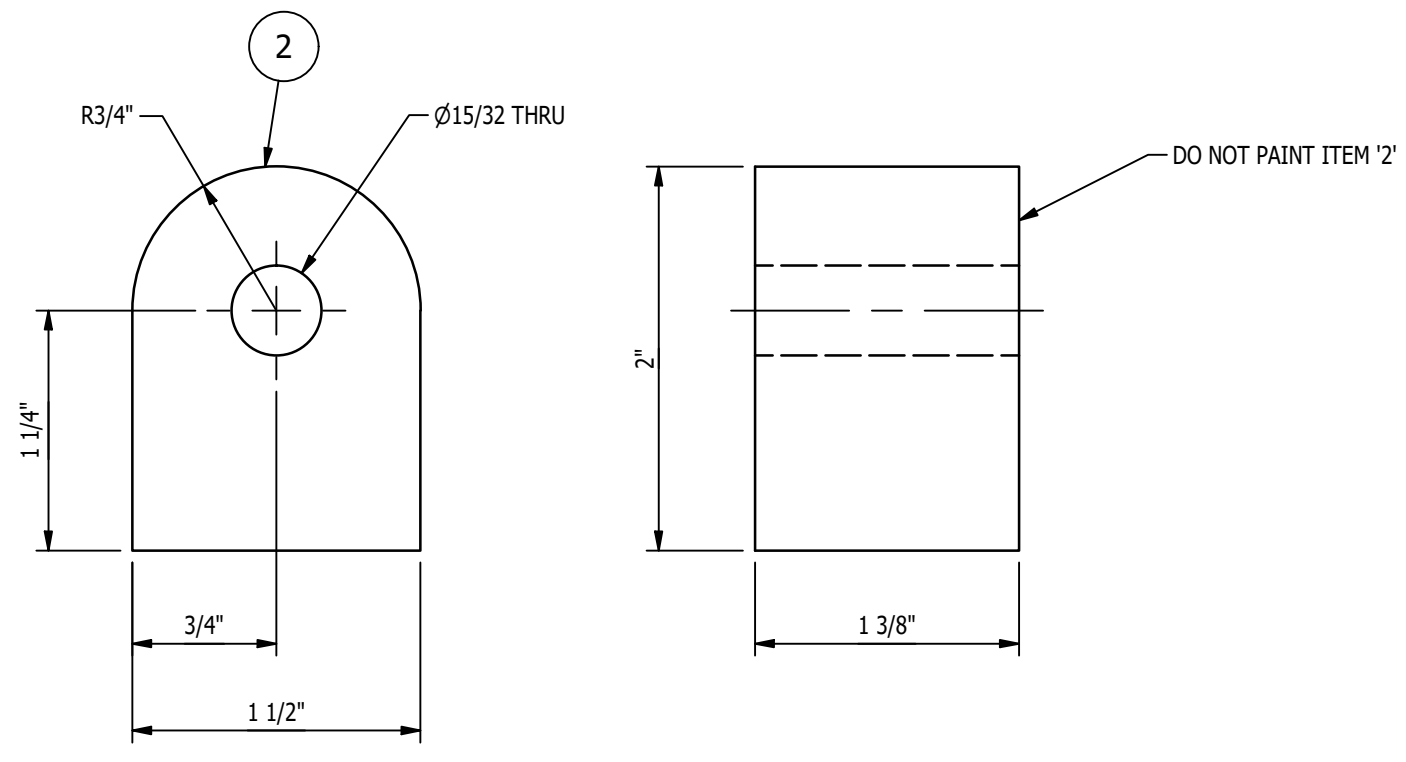
MK-D484A ~ CHAIN BRACKET
SCALE 6"=1'-0"



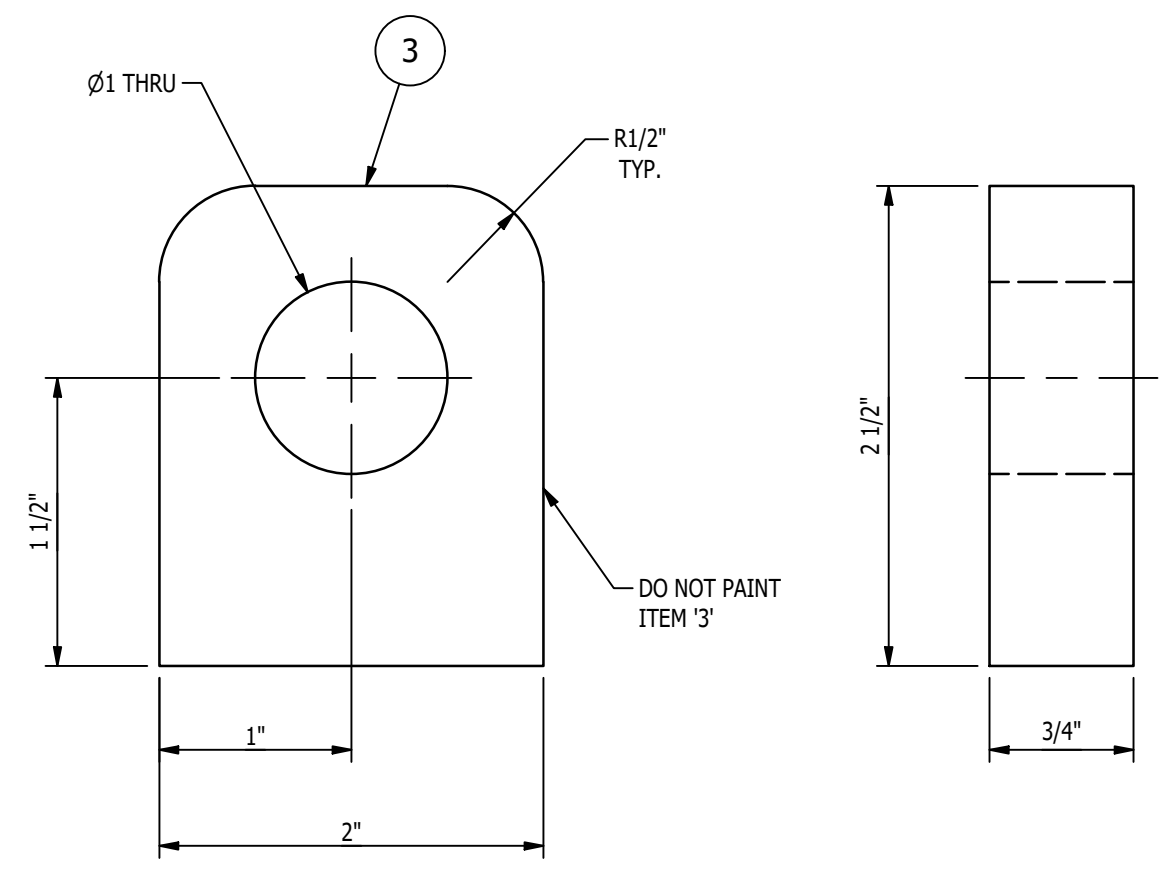
DETAIL OF ITEM '1'
SCALE 6"=1'-0"



MK-D484B ~ SPACER
SCALE 6"=1'-0"



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



DETAIL OF ITEM '3'
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.
- DO NOT PAINT ITEMS '2' & '3'

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED DIMENSION	
A	MC	11/14/22	FOR FABRICATION	

REVISION HISTORY	
B	MC 11/28/22 ADDED DIMENSION
A	MC 11/14/22 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.

41100 QuakerRoad Rd.
Suite 125
North, MI 48315

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D484 - REV B

UNLESS OTHERWISE NOTED:

X = ±.060
XX = ±.030
XXX = ±.005

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

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

TITLE: P6700 CONVEYORS
CAMPUS BUILDING

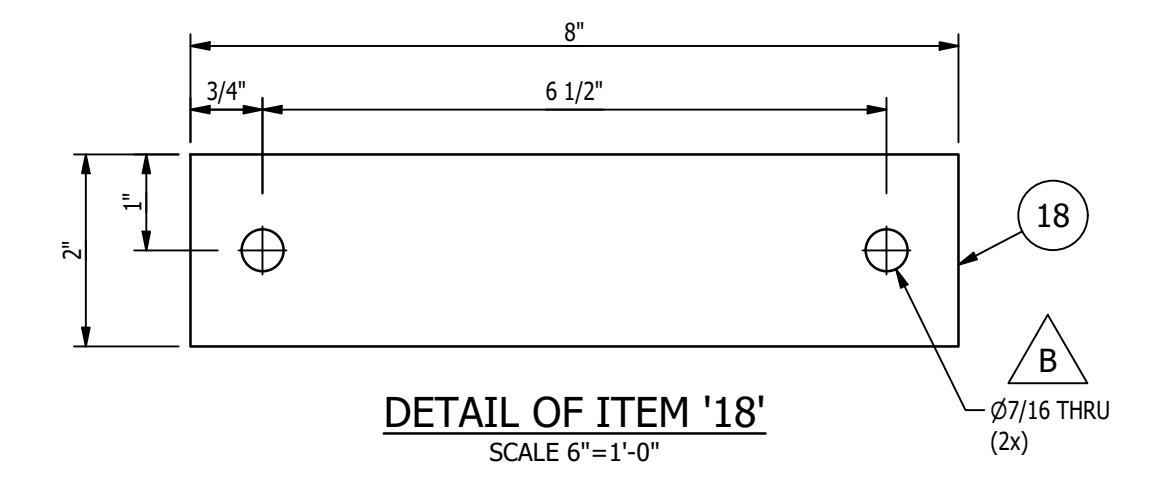
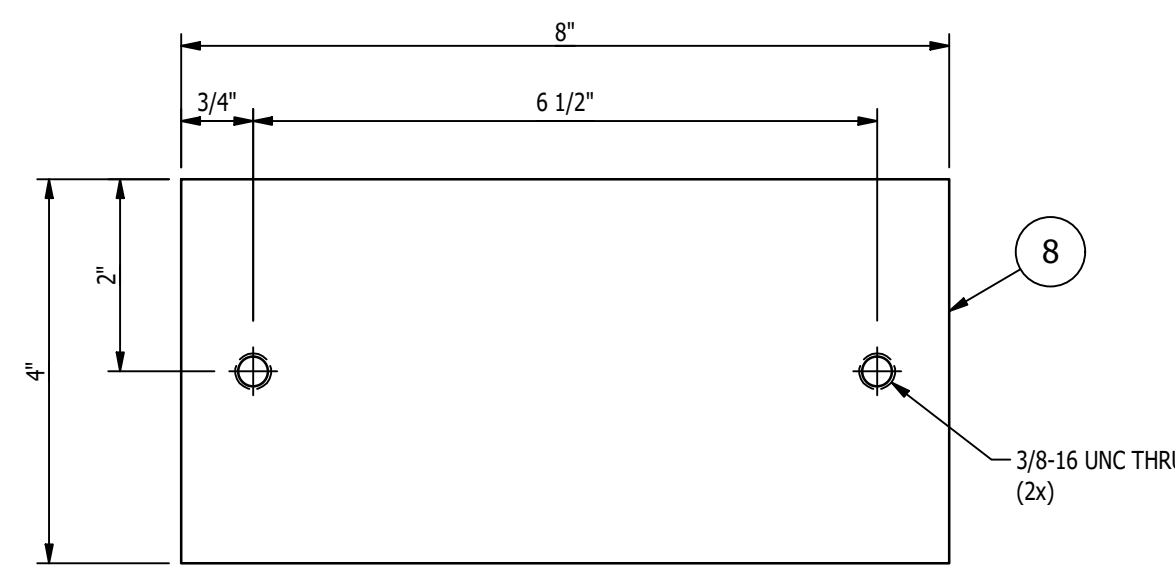
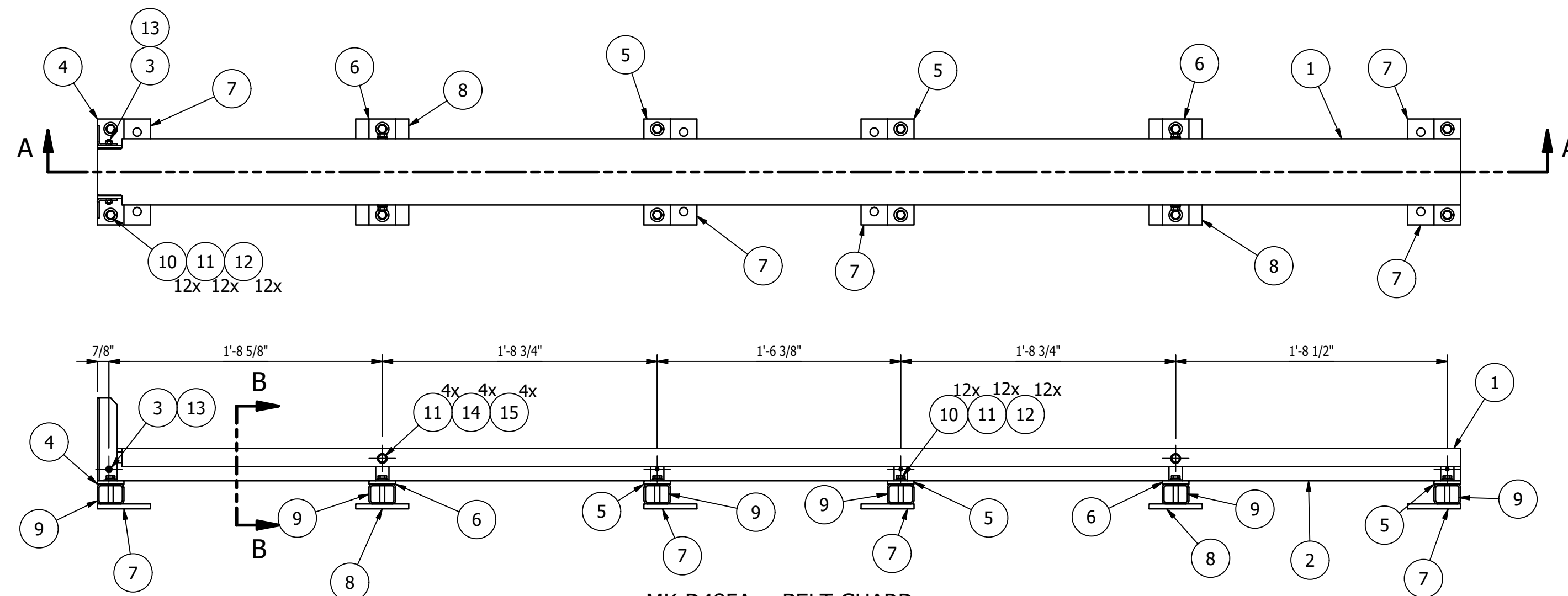
CLIENT: VOLVO

DRAWING No.: 1875D484

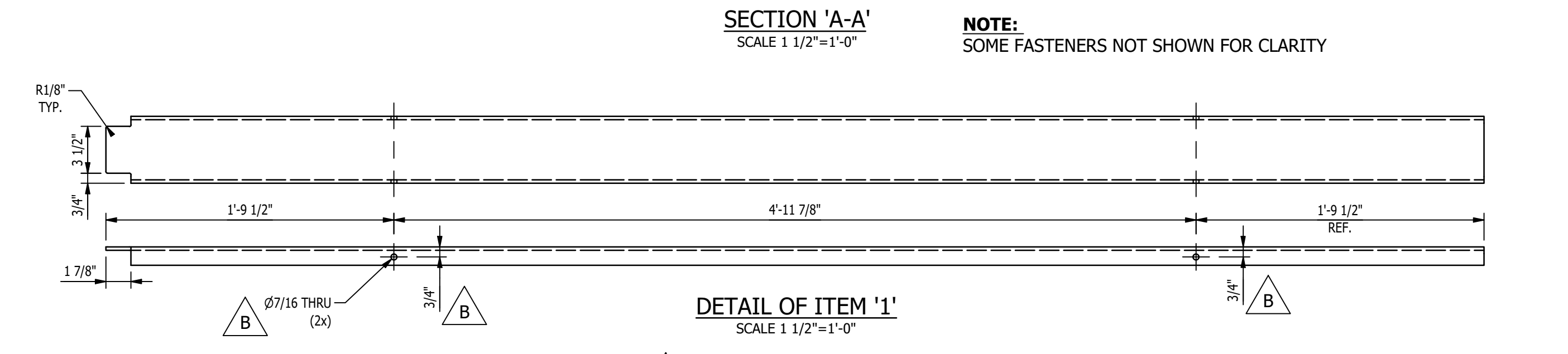
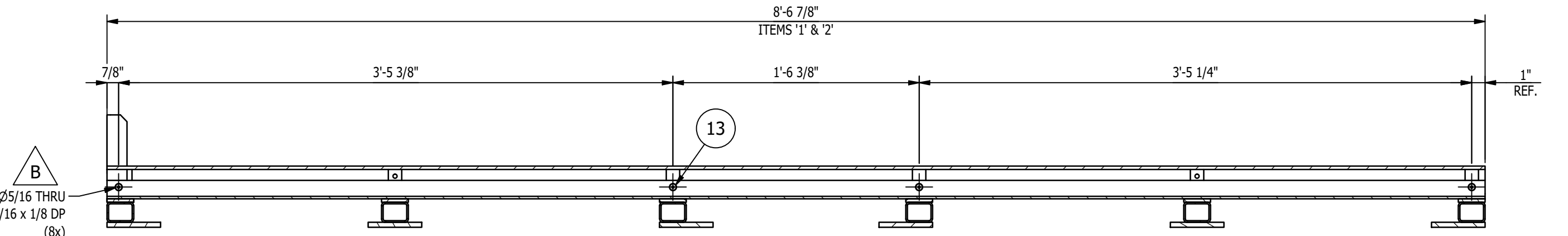
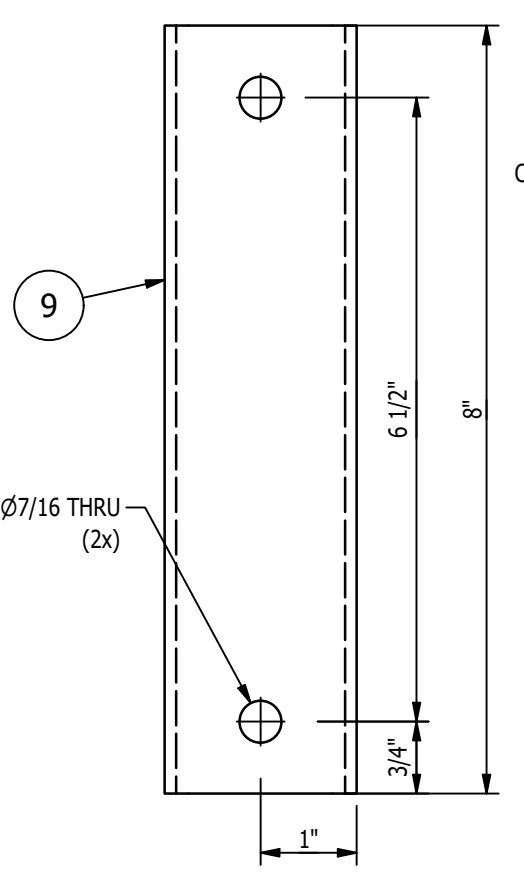
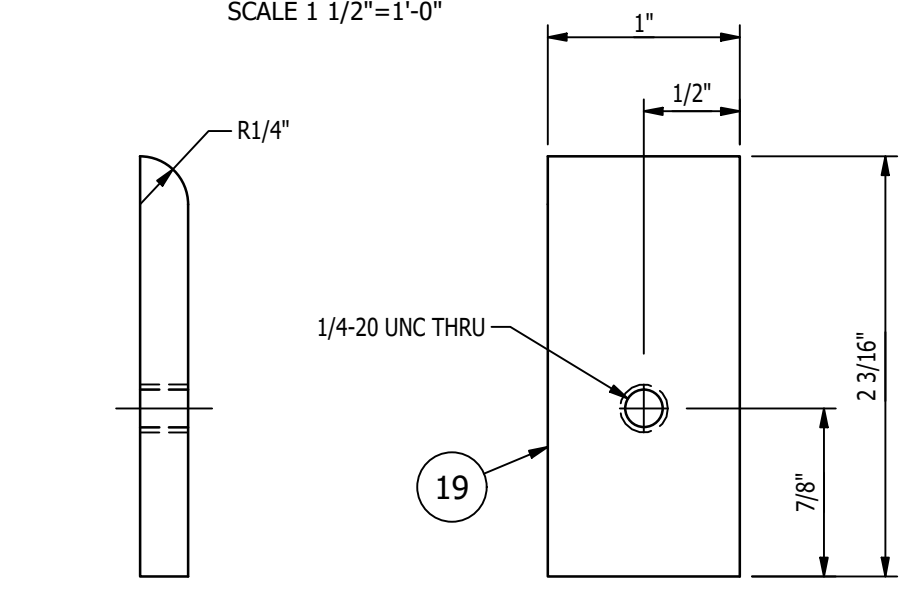
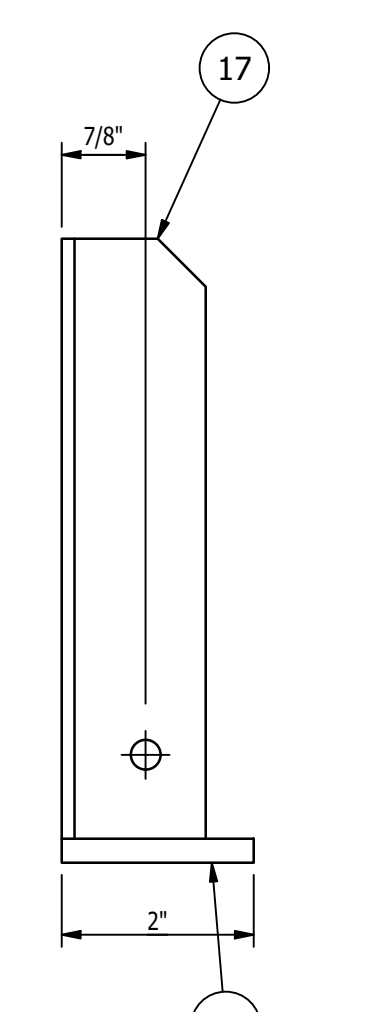
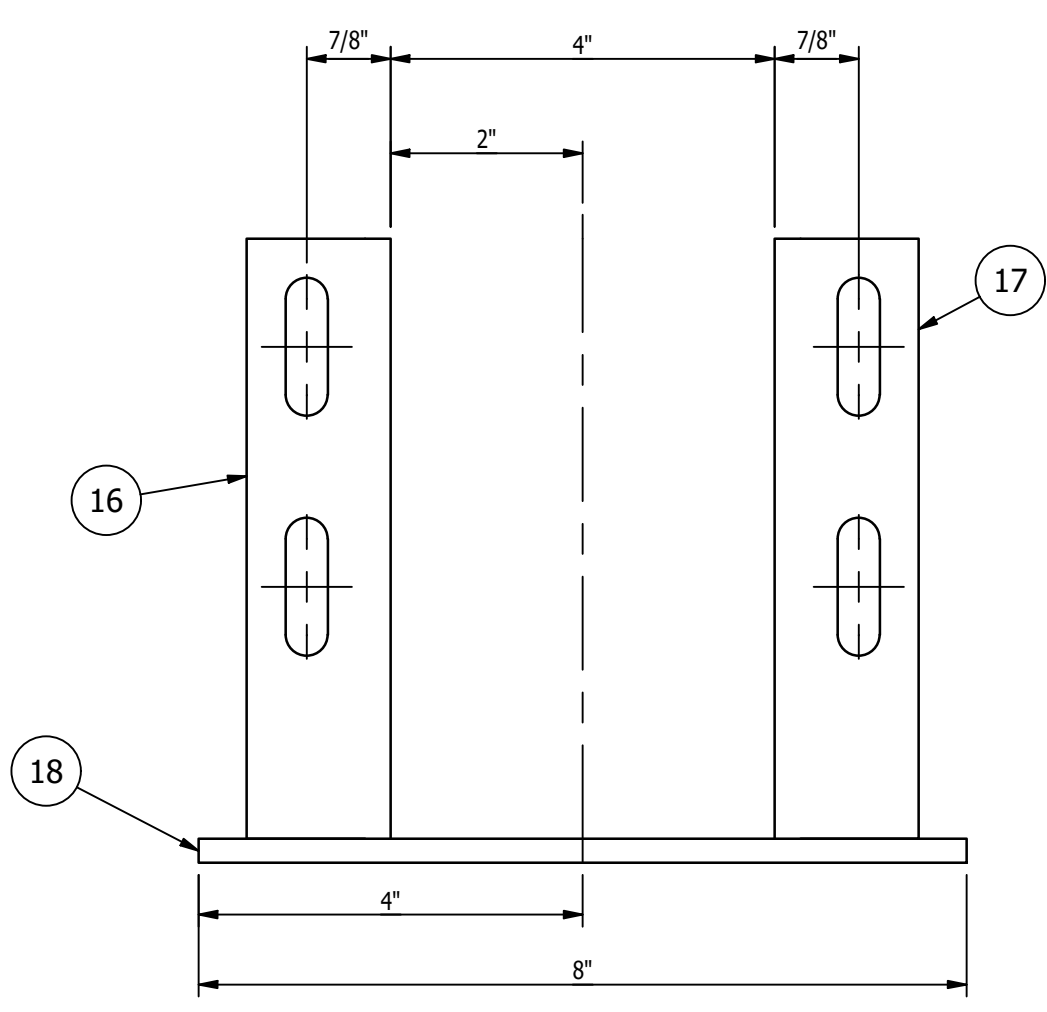
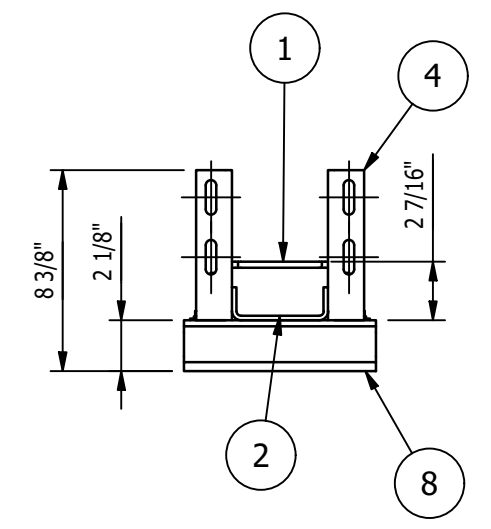
REV: B

JOB No.: 22096

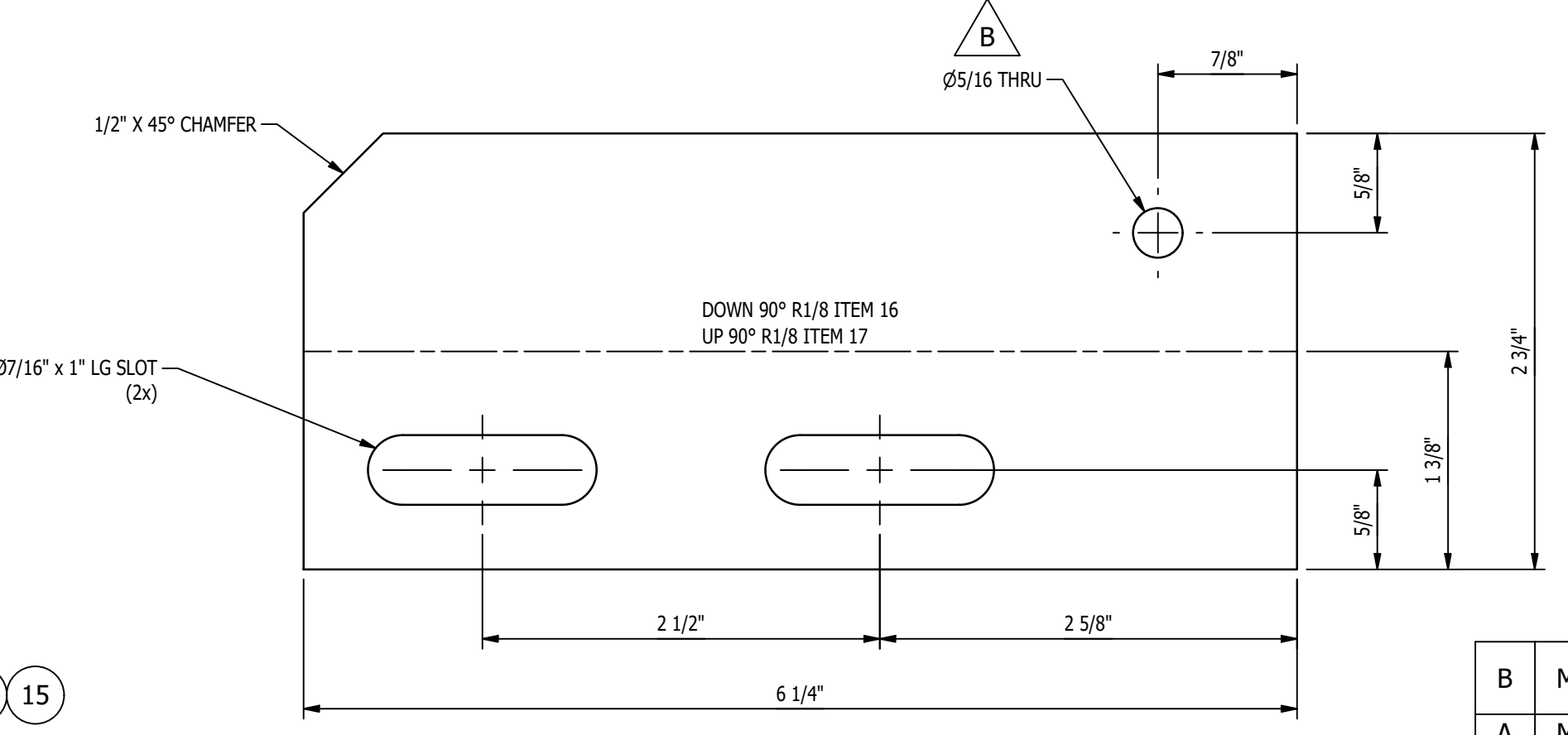
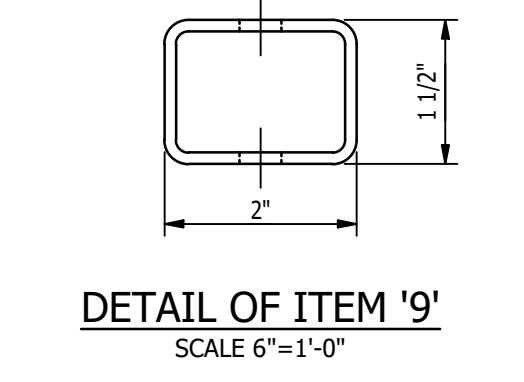
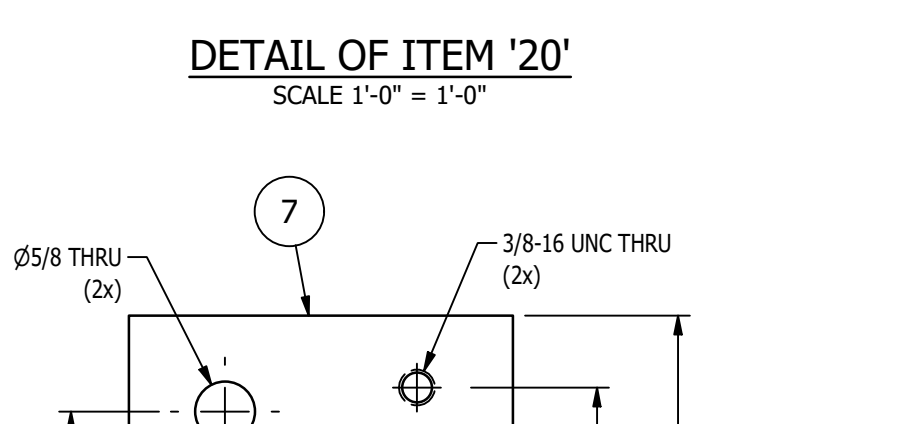
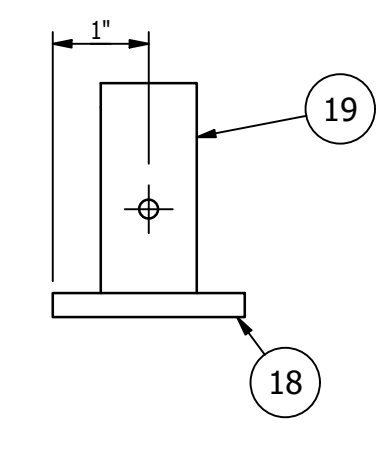
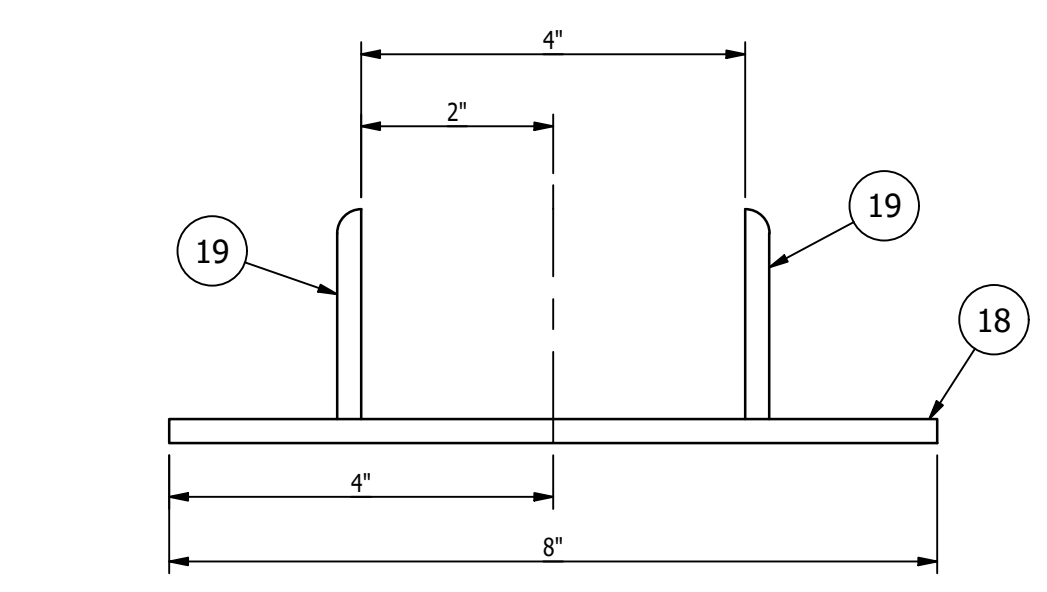
DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 10/24/22



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D485A			
1	1	FIBERGLASS C5 x 1.375 x 0.25	8'-6 7/8"		
2	1	FIBERGLASS C4 x 1.375 x 0.1875	8'-6 7/8"		
3	2	1/4-20UNC STOVER LOCK NUT			
4	1	MK-D485B ~ SUPPORT BRACKET			
5	3	MK-D485C ~ SUPPORT BRACKET			
6	2	MK-D485D ~ SUPPORT BRACKET			
7	4	PL 3/8 x 4"	8"		
8	2	PL 3/8 x 4"	8"		
9	6	HSS 2 x 1 1/2 x 11GA (A513 GR. C)	8"		
10	12	3/8 TYPE B REGULAR FLAT WASHER			
11	16	3/8 SPRING LOCK WASHER			
12	12	3/8-16UNC x 2 1/4" LG. HEX HEAD CAP SCREW			
13	8	1/4-20UNC x 5/8" LG. FLAT HEX SOCKET HEAD CAP SCREW			
14	4	3/8-16UNC x 5/8" LG. HEX HEAD CAP SCREW			
15	4	3/8 TYPE B NARROW FLAT WASHER			
		MK-D485B			
16	1	SHT 10 GA x 2 3/4	6 1/4"		
17	1	SHT 10 GA x 2 3/4	6 1/4"		
18	1	PL 1/4 x 2"	8"		
		MK-D485C			
18	1	PL 1/4 x 2"	8"		
19	2	PL 1/4 x 1"	2 3/16"		
		MK-D485D			
18	1	PL 1/4 x 2"	8"		
20	2	PL 1/4 x 1"	2 3/16"		



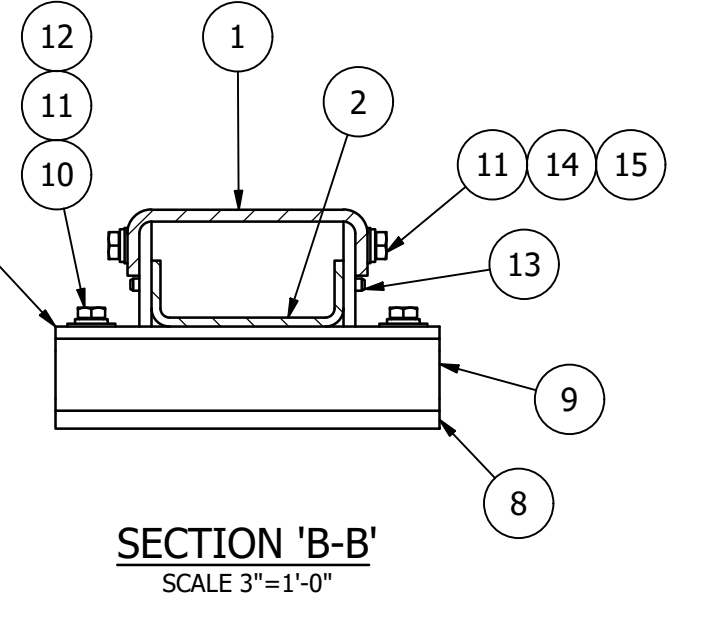
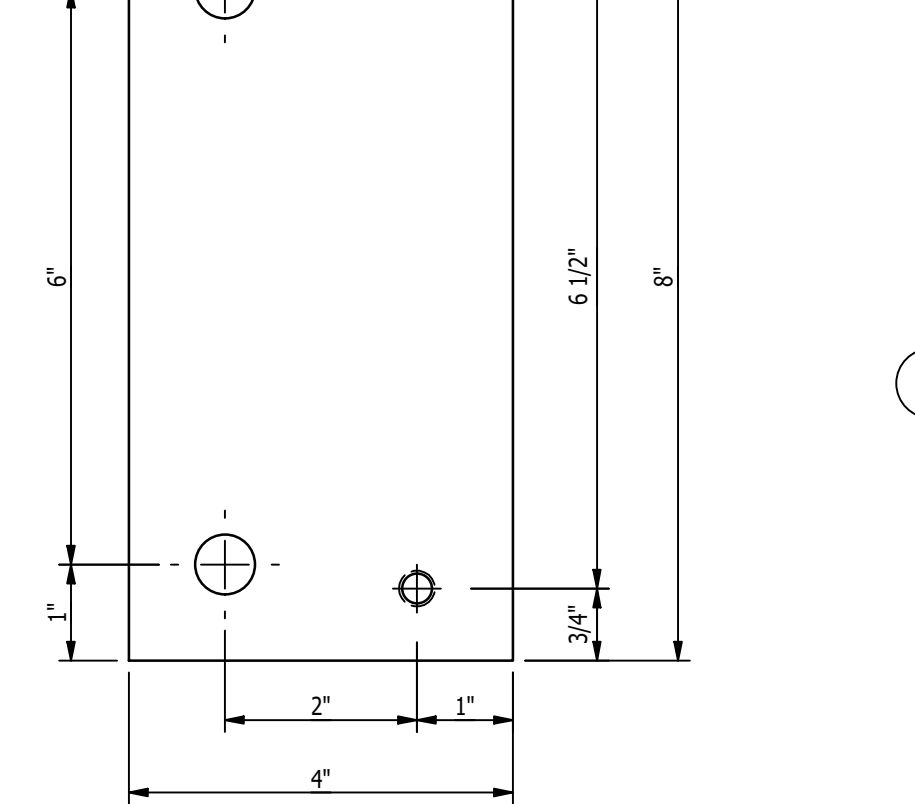
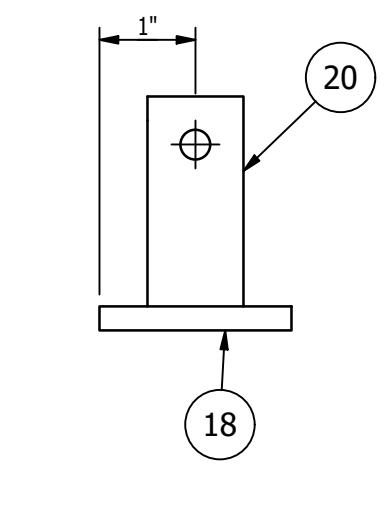
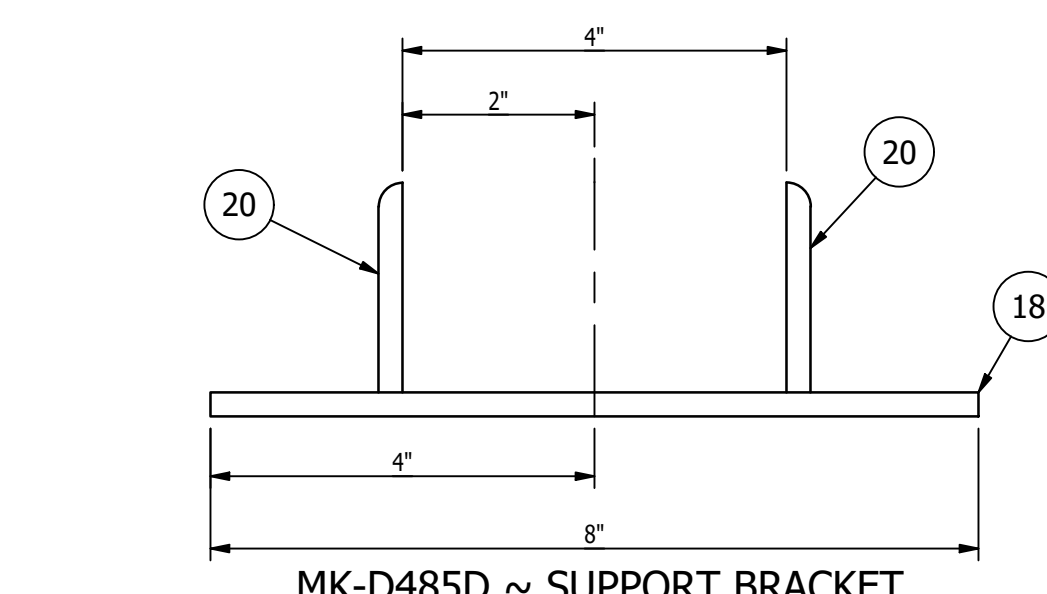
NOTE:
SOME FASTENERS NOT SHOWN FOR CLARITY



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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	UPDATED HOLE SIZE ON ITEM '2', '16', '17', & '18', ADDED DIMENSIONS TO ITEM '1'	
A	MC	11/15/22	FOR FABRICATION	



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

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

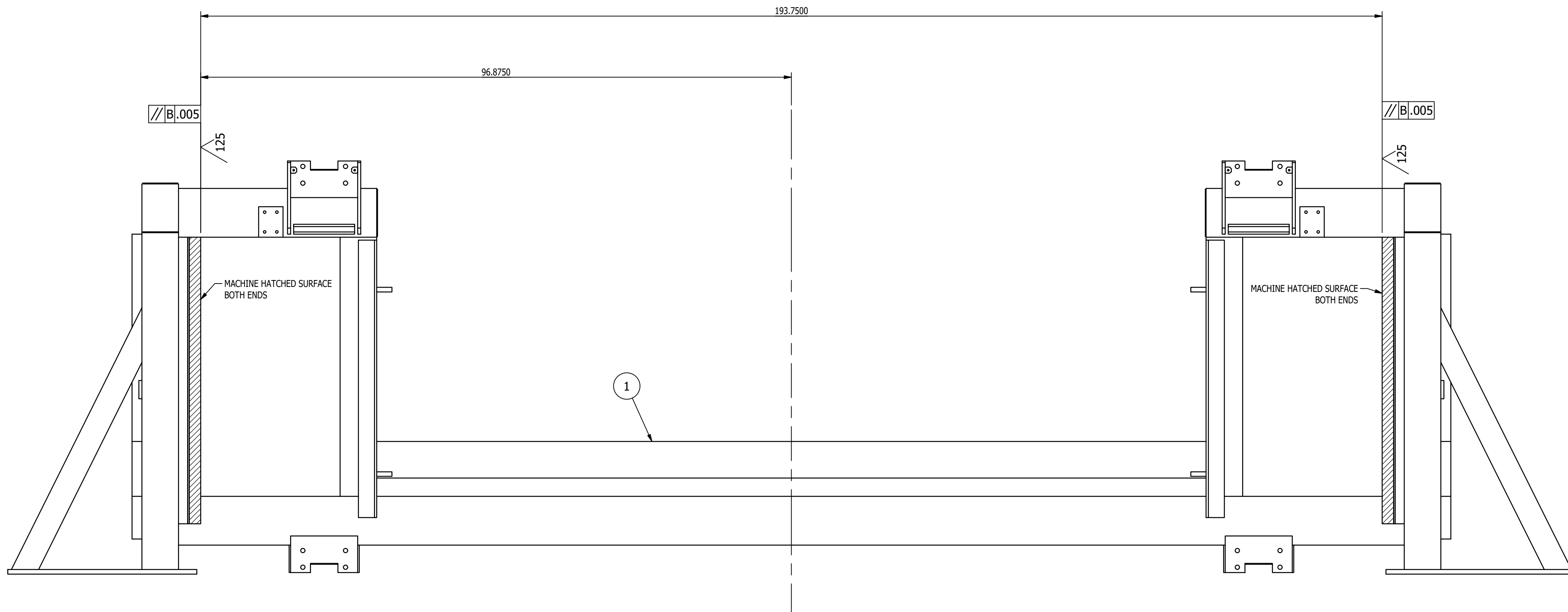
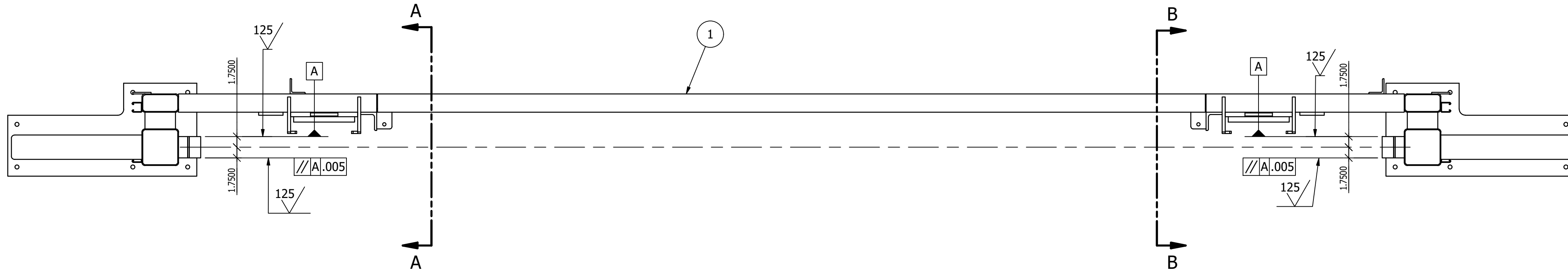
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4"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

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
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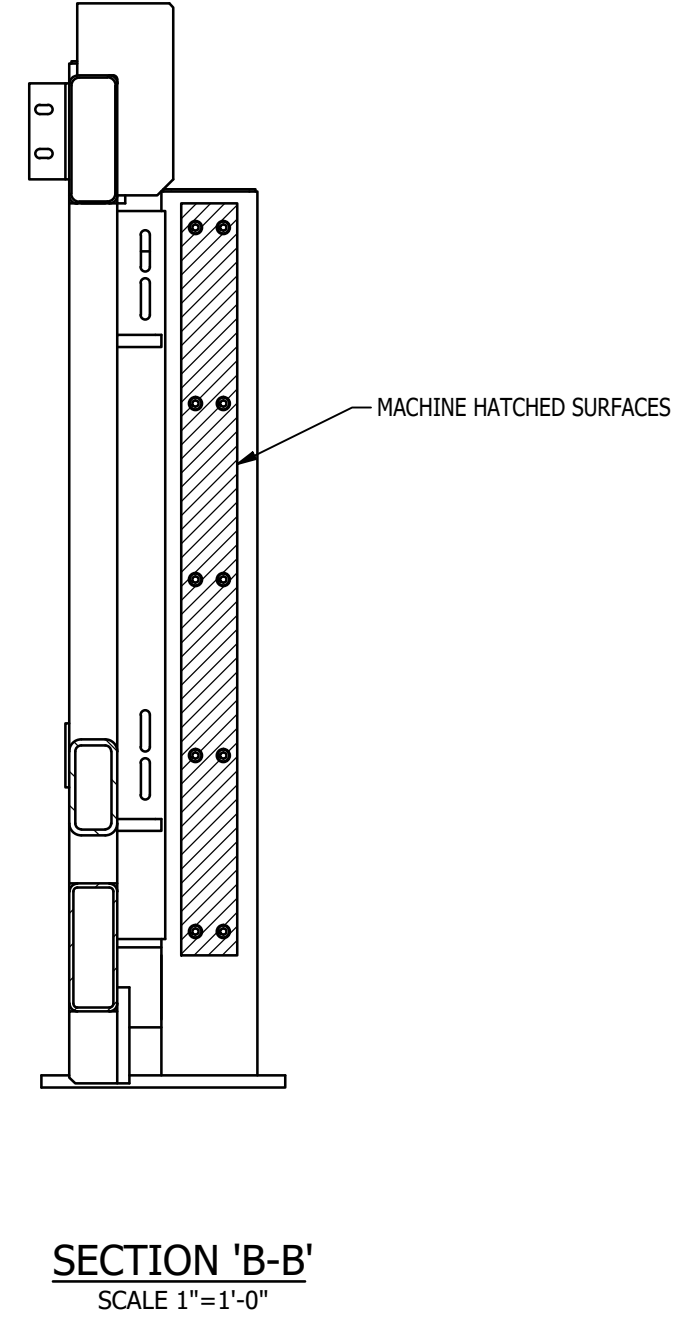
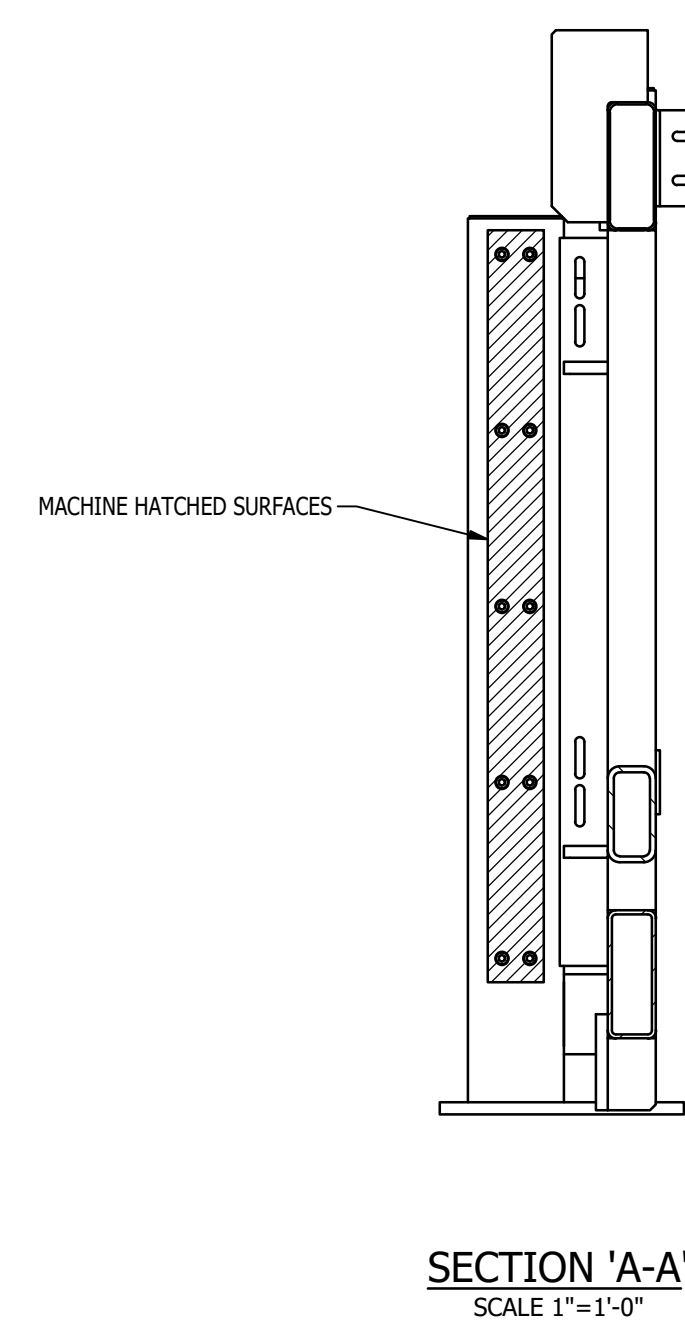
TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No.: 1875D485
REV: B
JOB No.: 22096

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 11/4/22
JOB No.: 22096

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D486A			
1	1	MK-D487A ~ AUX LIFT DRIVER SIDE ASSEMBLY (BEFORE MACHINING)			



MK-D486A ~ AUX LIFT DRIVER SIDE FRAME MACHINING
SCALE 1"=1'-0"



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

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
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TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D486	DWG DATE: 11/8/22
REV: A	JOB No: 22096

MAGNUM CONSULTING
4170 Clarkston Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D486 - 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 A892-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

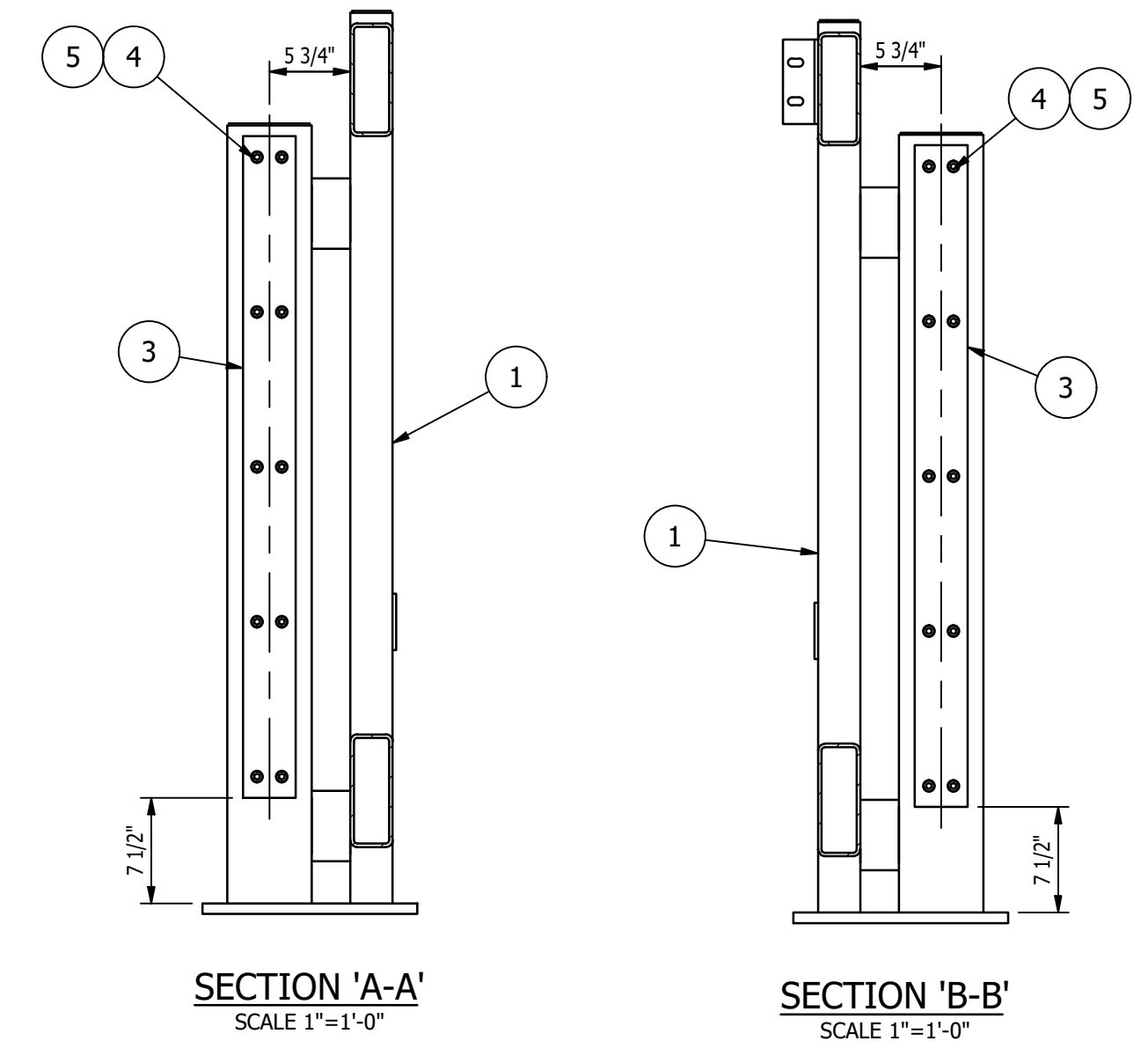
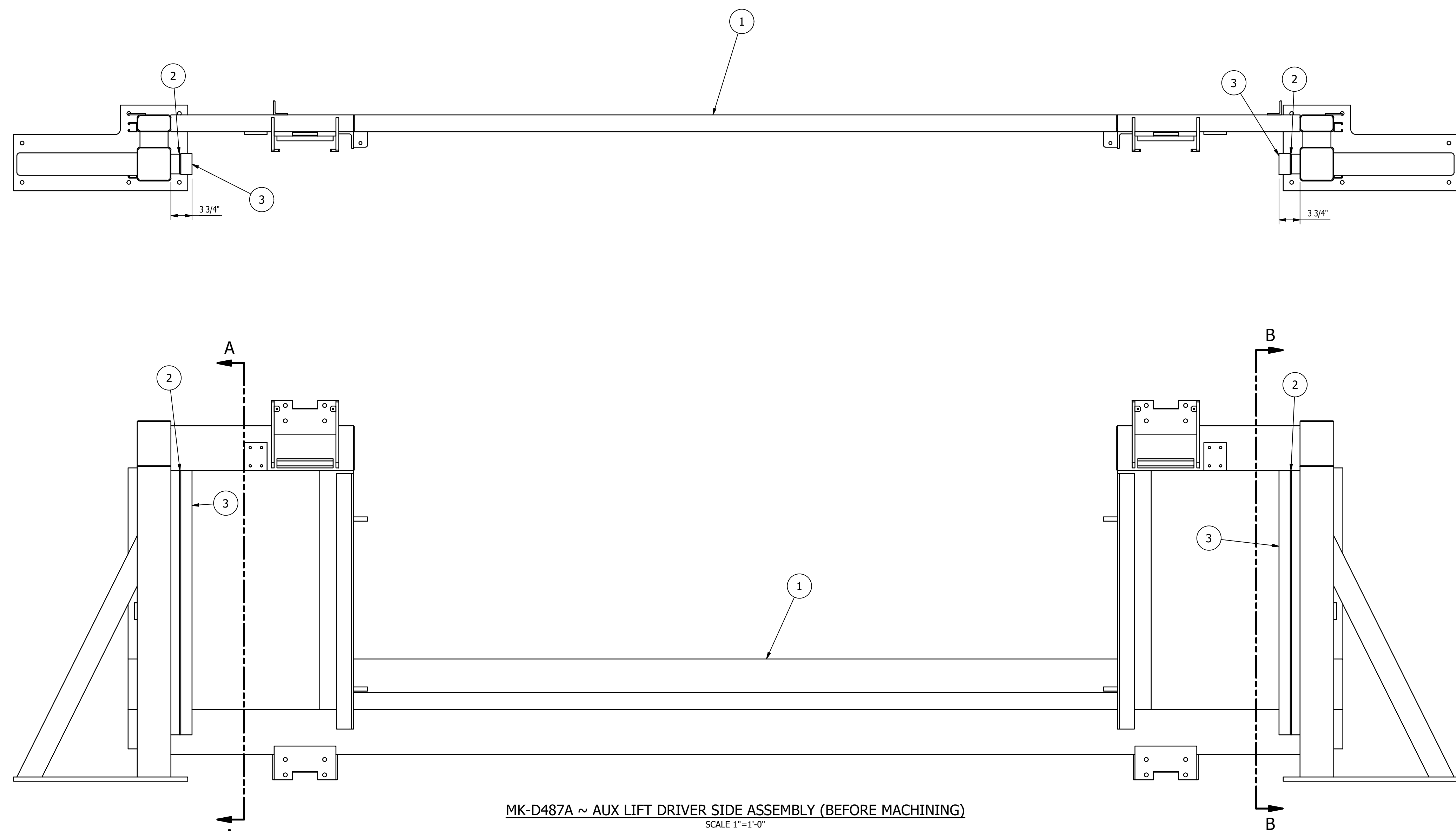
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

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

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D487A ~ DRIVER SIDE FRAME WELDMENT			
2	2	MK-D483C ~ GUIDE BAR SPACER			
3	2	MK-D483D ~ GUIDE BAR			
4	20	1/2-13UNC x 2 3/4" LG. HEX SOCKET HEAD CAP SCREW			
5	20	1/2 HIGH COLLAR SPRING LOCK WASHER			



- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS ARE TO BE CLEAN AND NEAT IN APPEARANCE
 3. REMOVE ALL EXPOSED SHARP EDGES AND BURRS
 4. ALL STEEL TO BE ASTM A-36 UNLESS OTHERWISE SPECIFIED
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 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-D487A ~ AUX LIFT DRIVER SIDE ASSEMBLY (BEFORE MACHINING)
SCALE 1"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: RJB	
MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		CHECKED BY: CW DWG DATE: 11/8/22	
TITLE: P6700 CONVEYORS CAMPUS BUILDING CLIENT: VOLVO		JOB No: 22096	
DRAWING No. 1875D487		REV: A	

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

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

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

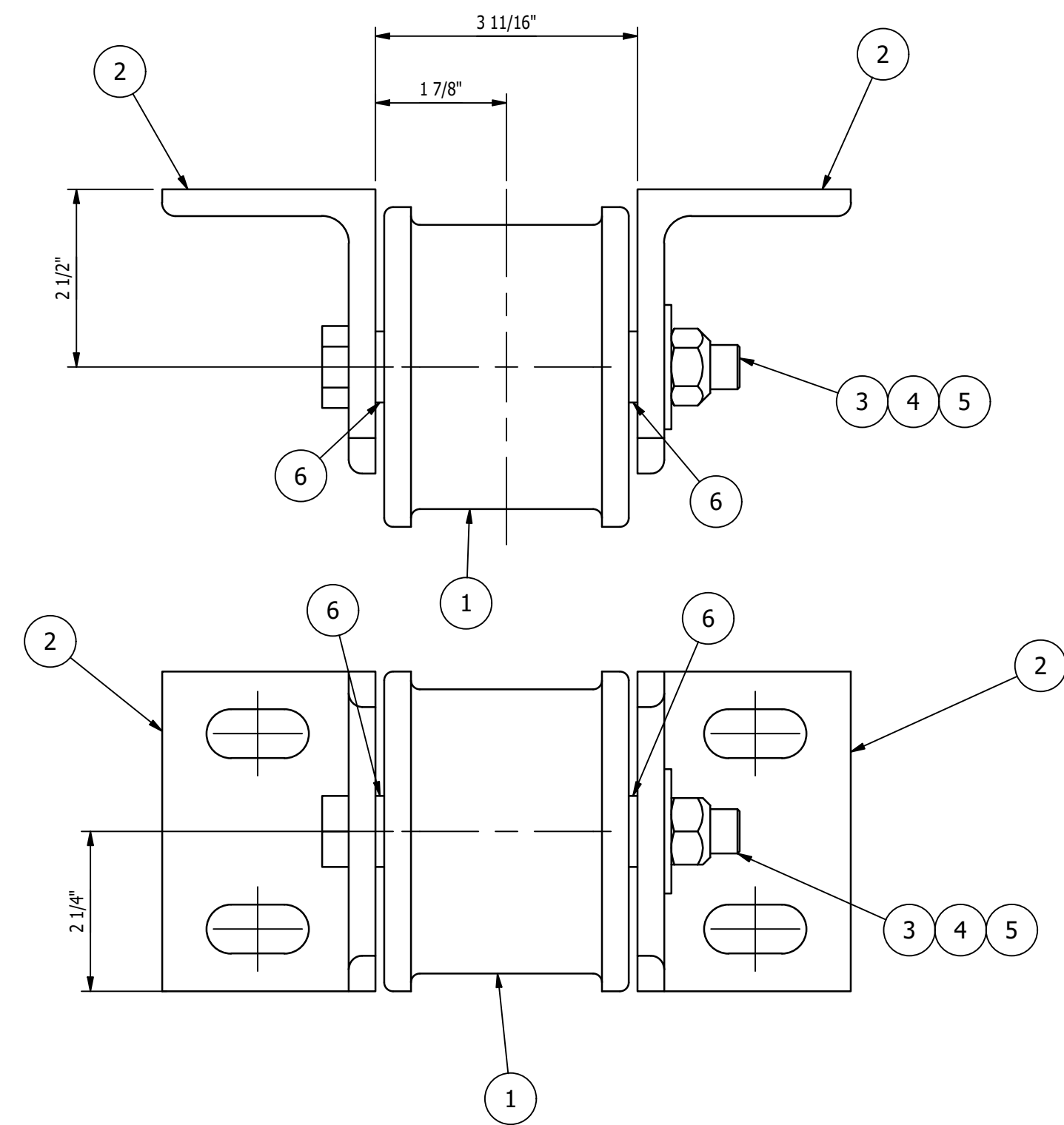
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

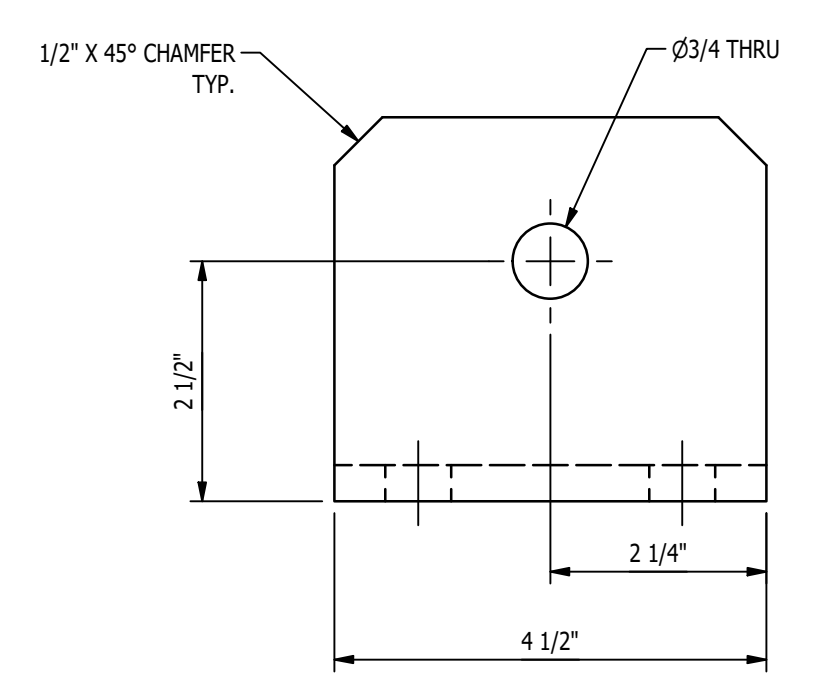
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

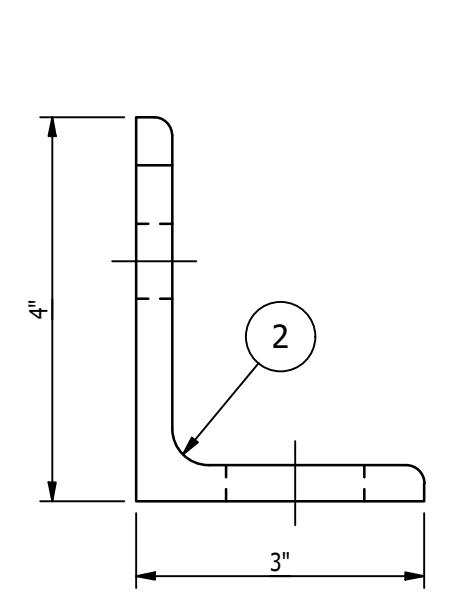
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



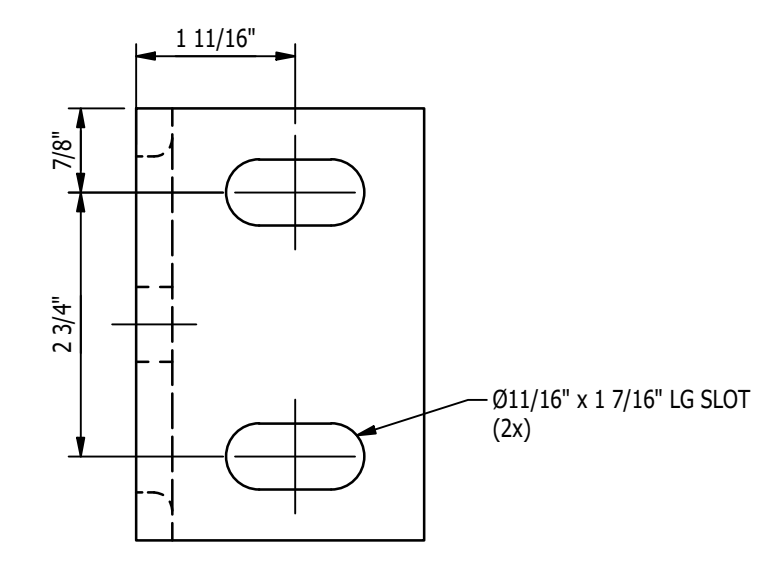
MK-D488A ~ DRIVER SIDE BELT ROLLER ASSEMBLY
SCALE 6"=1'-0"



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

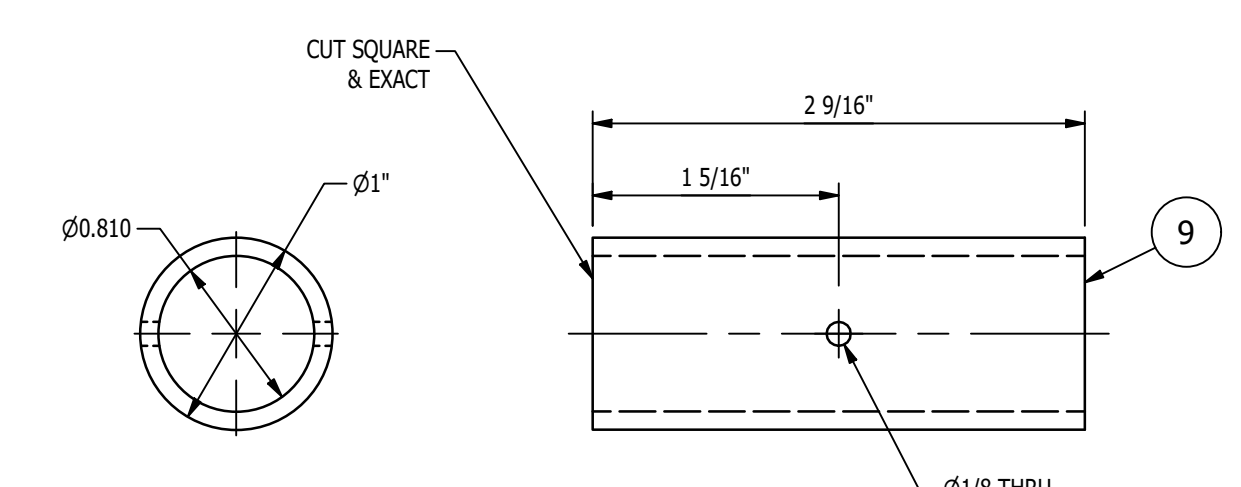


DETAIL OF ITEM '6'
SCALE 1'-0" = 1'-0"

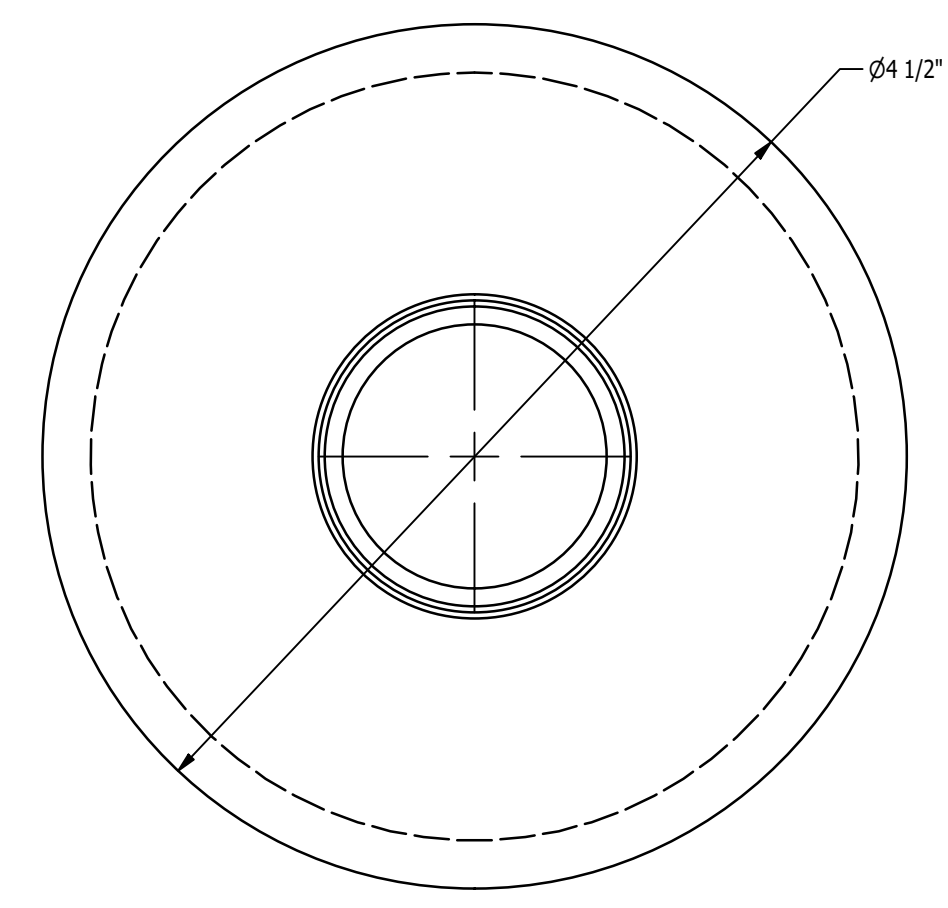


DETAIL OF ITEM '2'
SCALE 6"=1'-0"

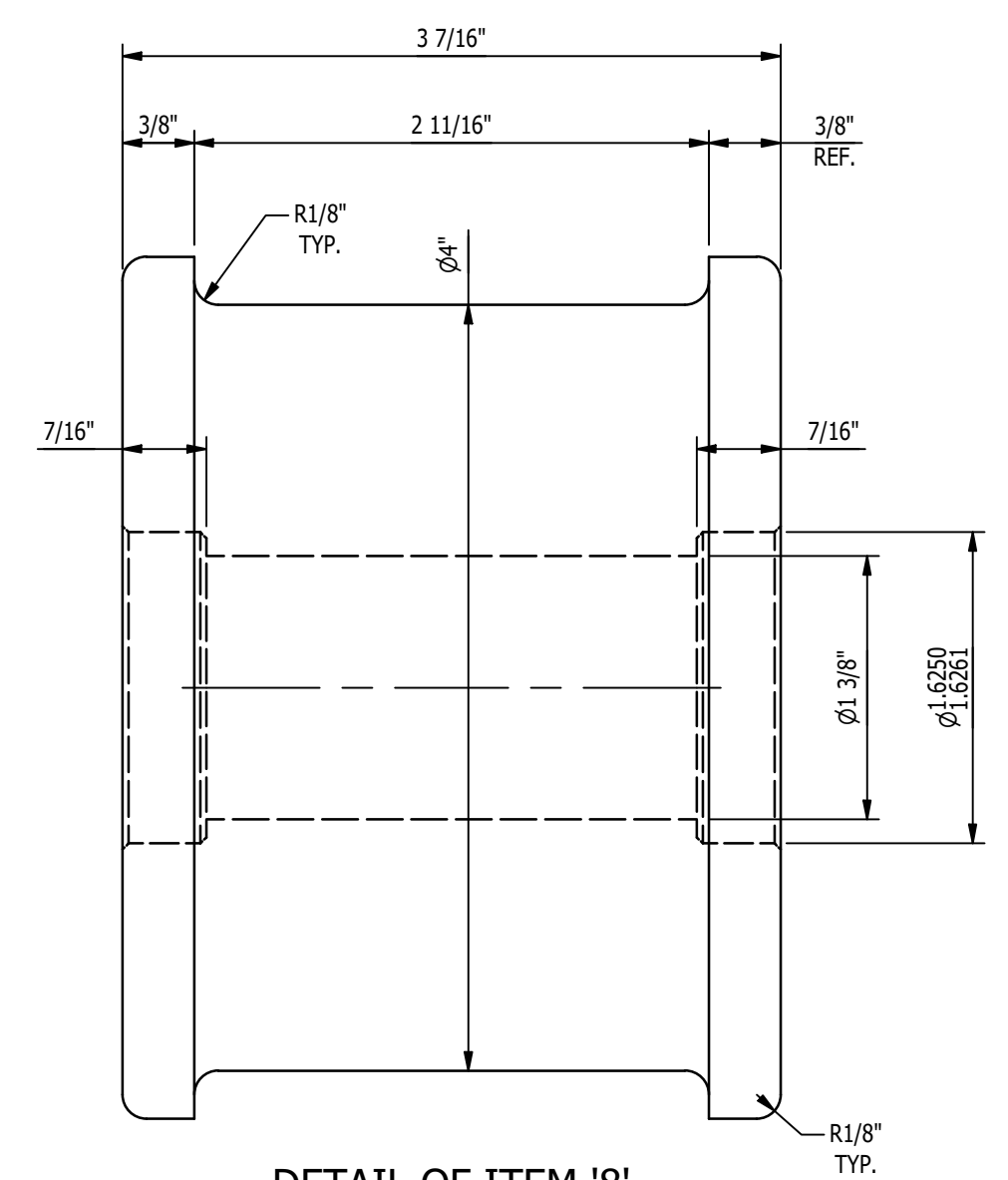
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D488A			
1	1	MK-D488B ~ ROLLER			
2	2	L 4 x 3 x 3/8	4 1/2"		
3	1	MK-D488C ~ ROLLER SHAFT			
4	1	5/8 TYPE B REGULAR FLAT WASHER			
5	1	5/8-11UNC STOVER LOCK NUT			
6	2	PL 1/8 x 1	1/8"		
		MK-D488B			
7	2	RBI BEARINGS, R12, 3/4" BORE, 7/16" WIDTH, SHIELD ONE SIDE ONLY		28-9	
8	1	BAR 4 1/2 OD	3 7/16"		
9	1	TS 1 OD x 13 GA DOM	2 9/16"		
		MK-D488C			
10	1	BAR 1 1/8 x 1 1/8 (1045)	5 7/8"		



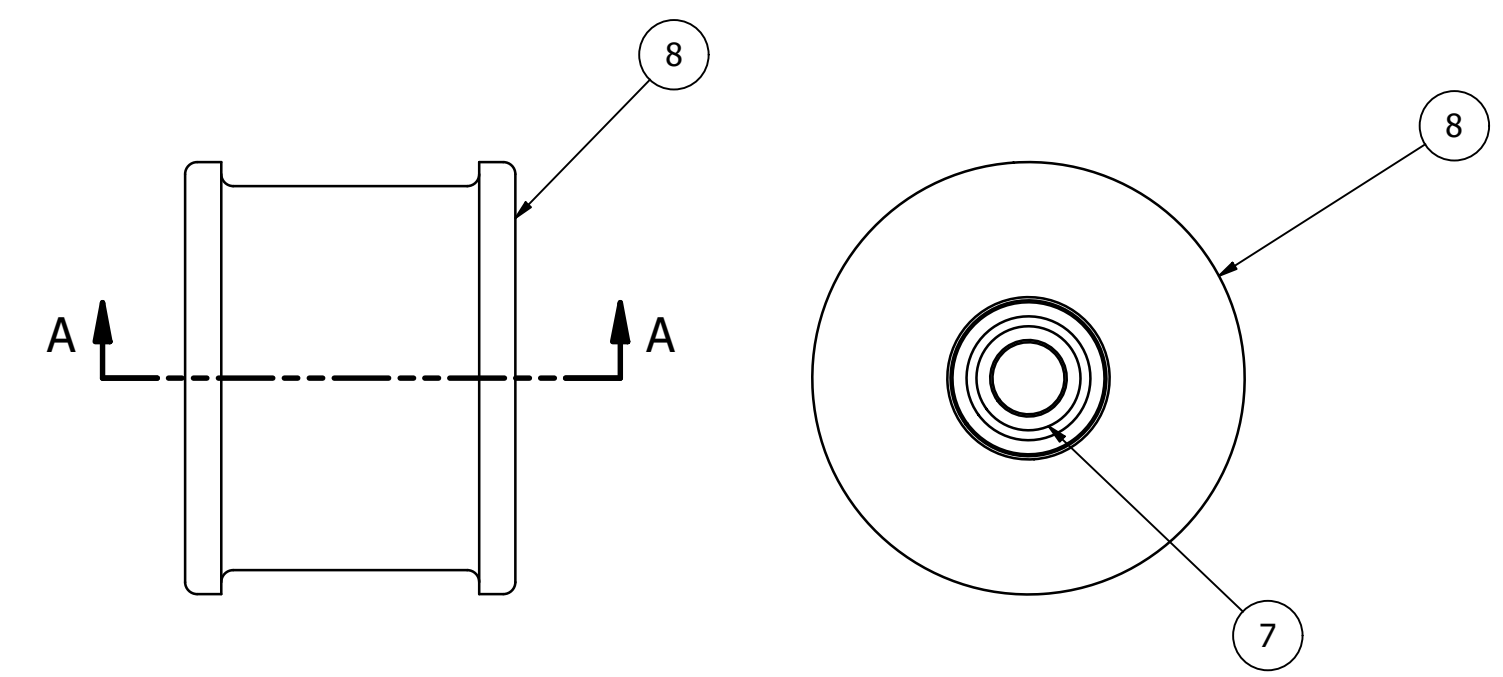
DETAIL OF ITEM '9'
SCALE 1'-0" = 1'-0"



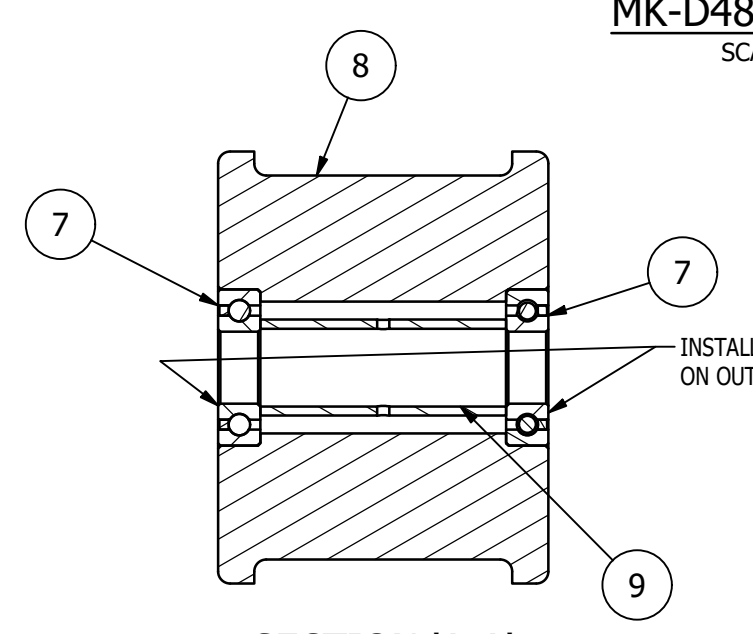
MK-D488C ~ ROLLER SHAFT
SCALE 1'-0" = 1'-0"



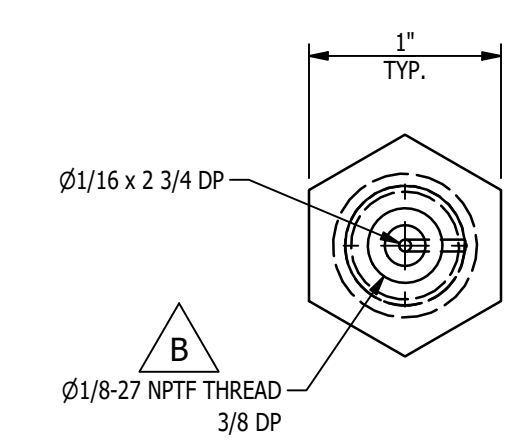
DETAIL OF ITEM '8'
SCALE 1'-0" = 1'-0"



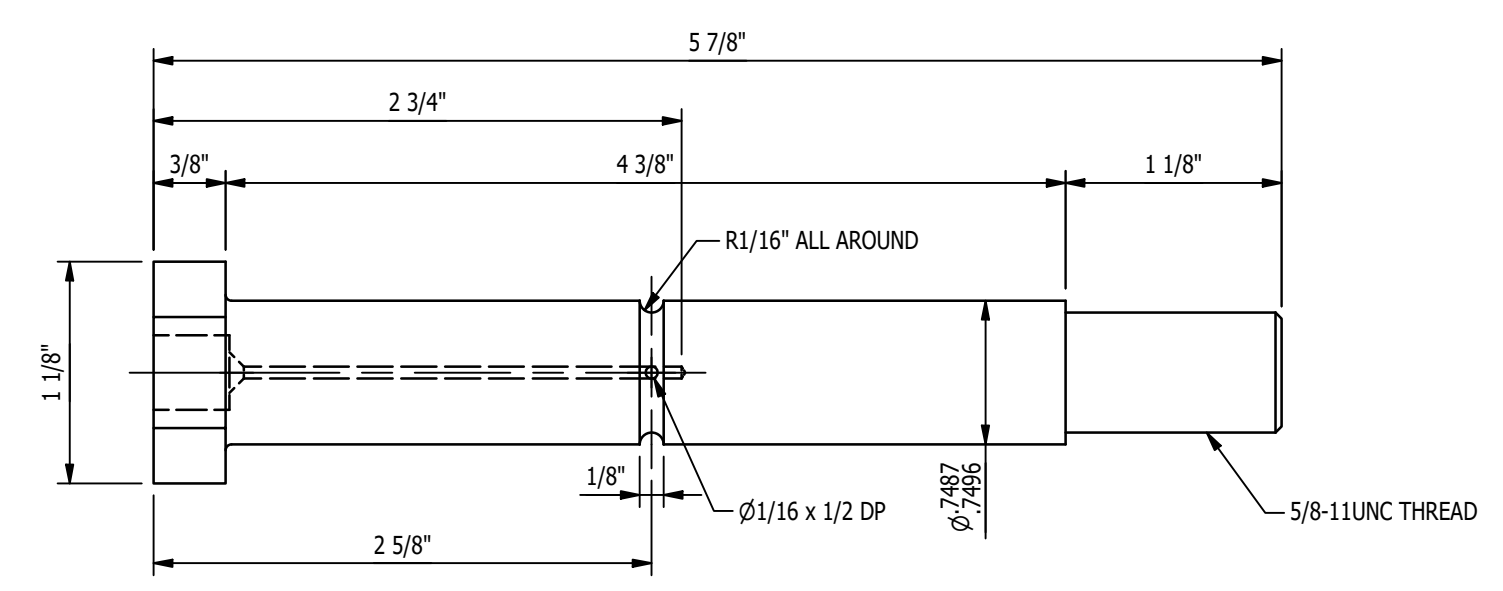
MK-D488B ~ ROLLER
SCALE 6"=1'-0"



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



DETAIL OF ITEM '3'



MK-D488C ~ ROLLER SHAFT
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 ITEM '2' ONLY
 - ONE SHOP COAT OF LIGHT GREY RAL 7035
 - DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	UPDATED THREAD SIZE ON ITEM '3', WAS 1/4-28 NPTF	
A	MC	11/15/22	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.millic.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: RJB		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 11/7/22		JOB No: 22096	
DRAWING No. 1875D488		REV: B			

MAGNUM CONSULTING
41100 Dardickwood Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D488 - REV B

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

GENERAL NOTES:

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

HOLES:

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

WELDS:

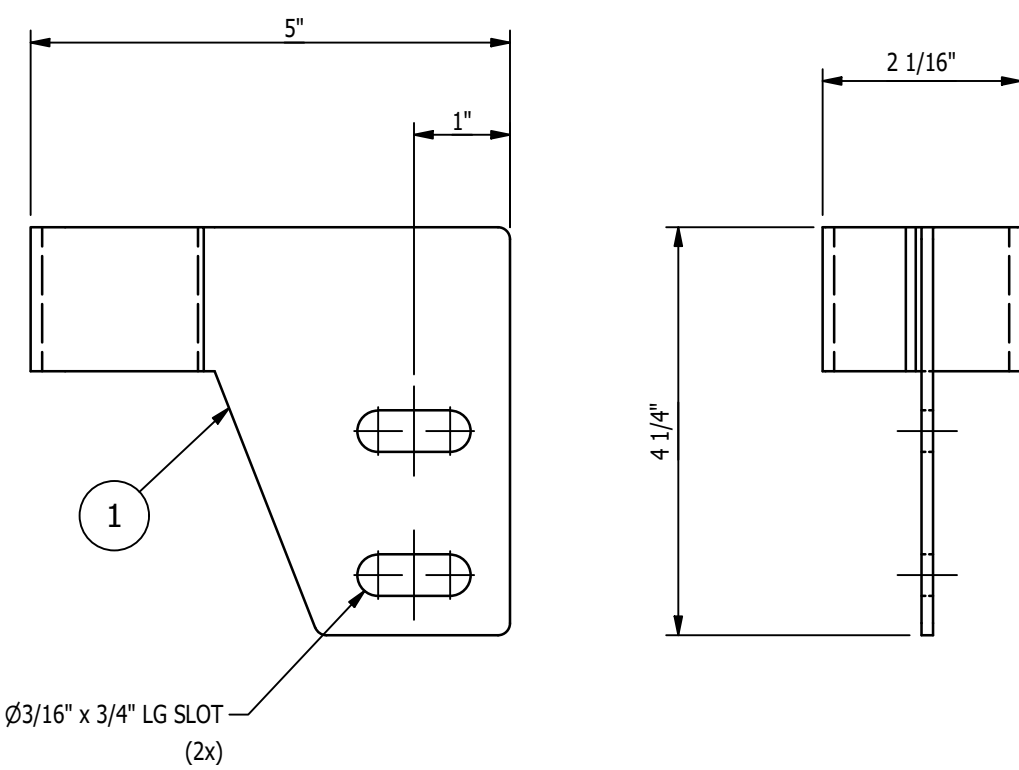
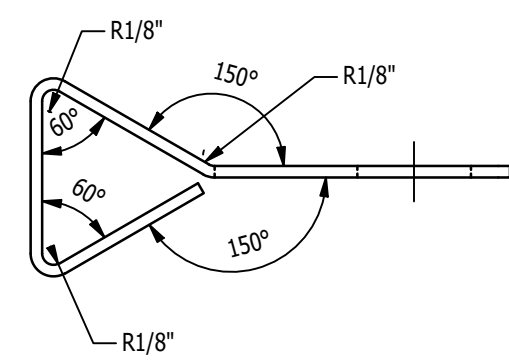
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:

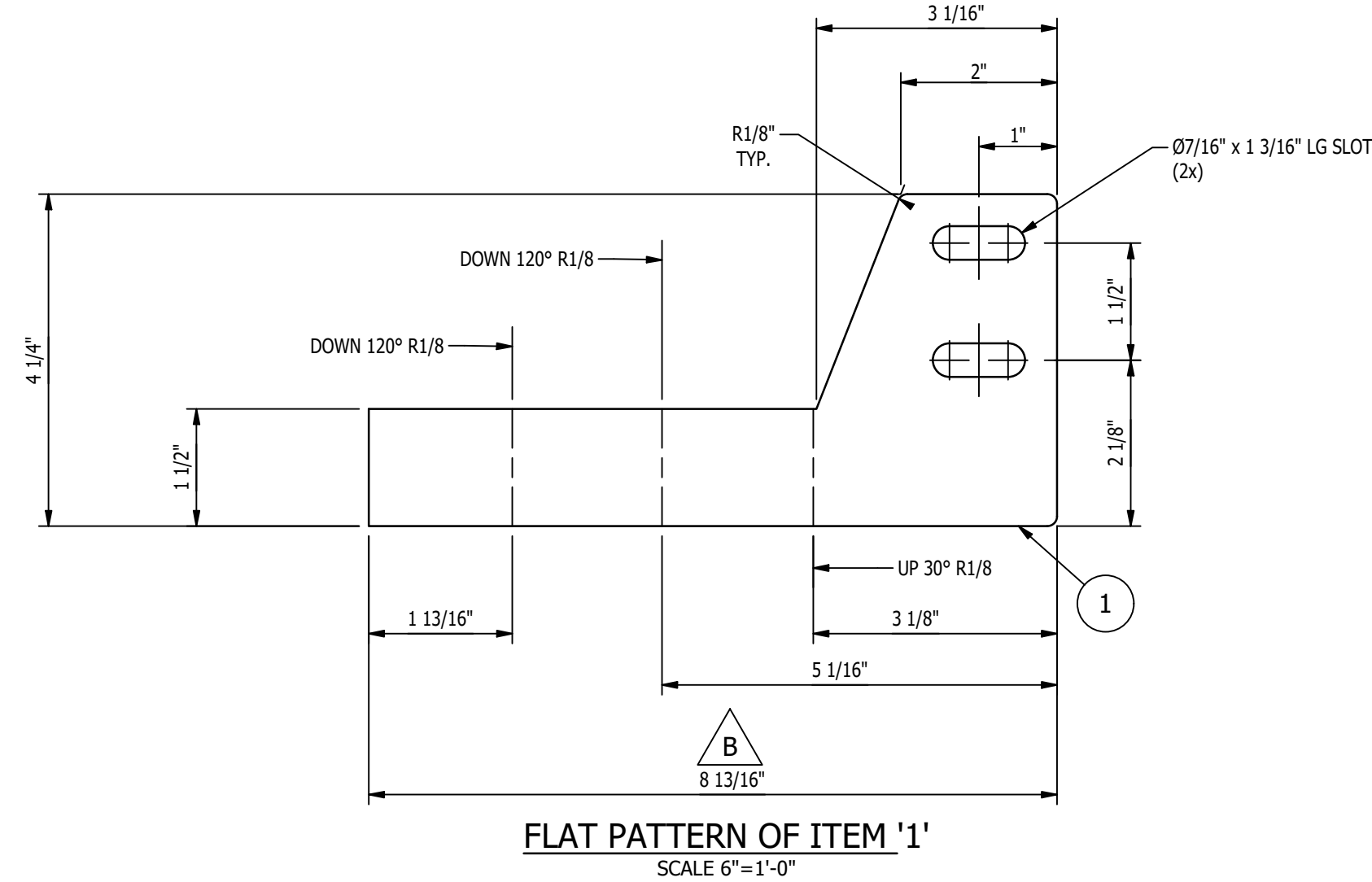
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

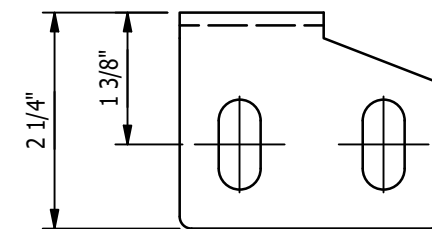
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



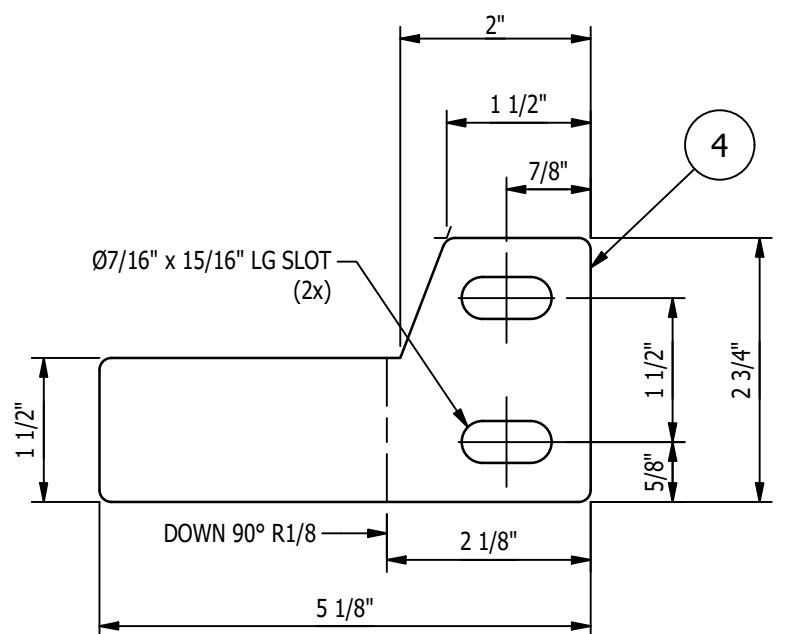
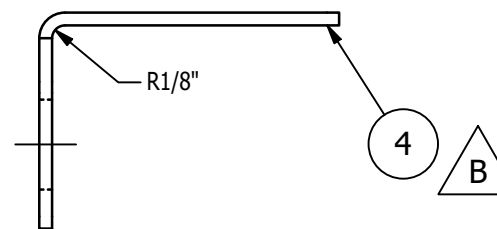
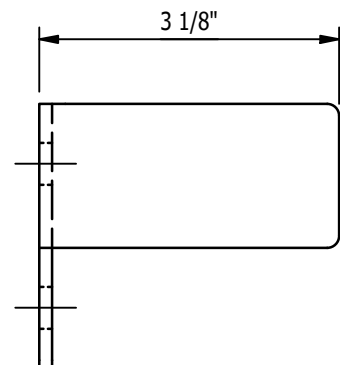
MK-D489A ~ PROX BRACKET
SCALE 6"=1'-0"



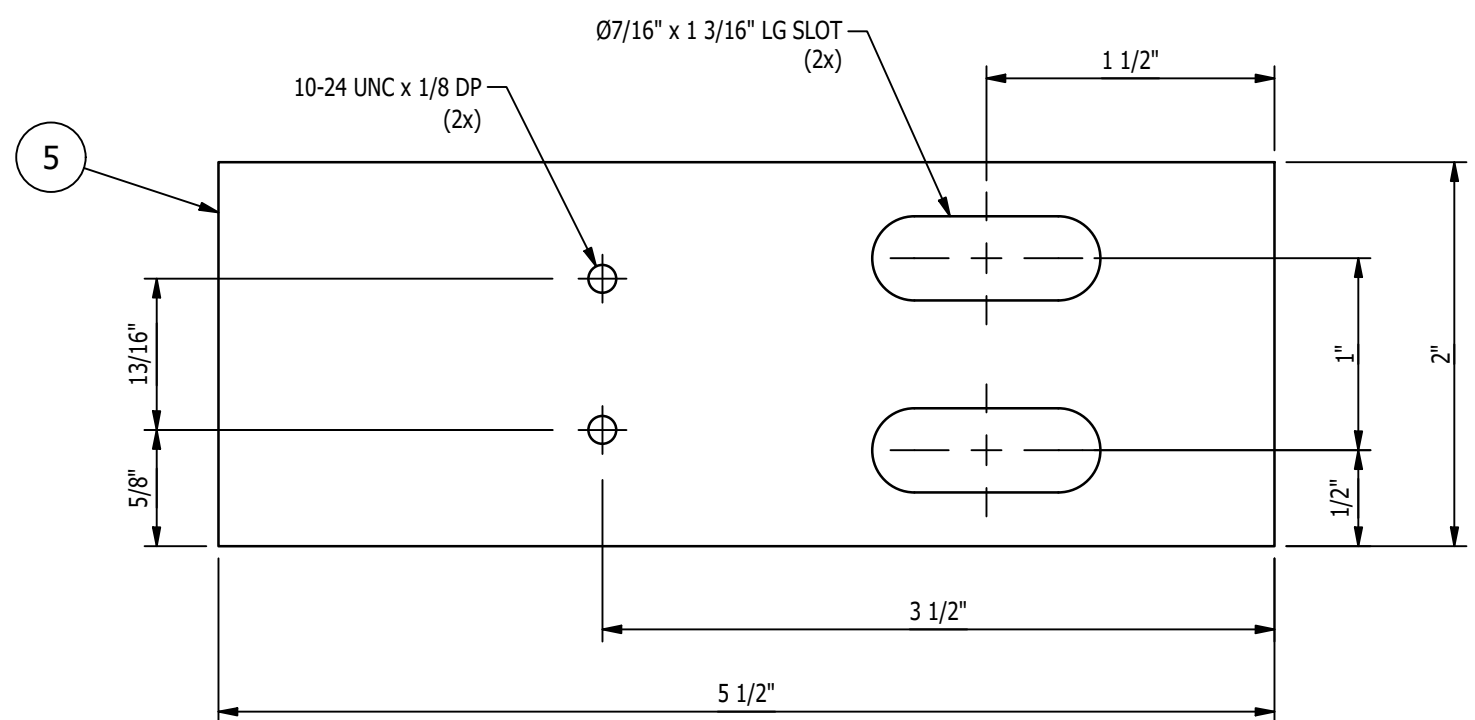
FLAT PATTERN OF ITEM '1'
SCALE 6"=1'-0"



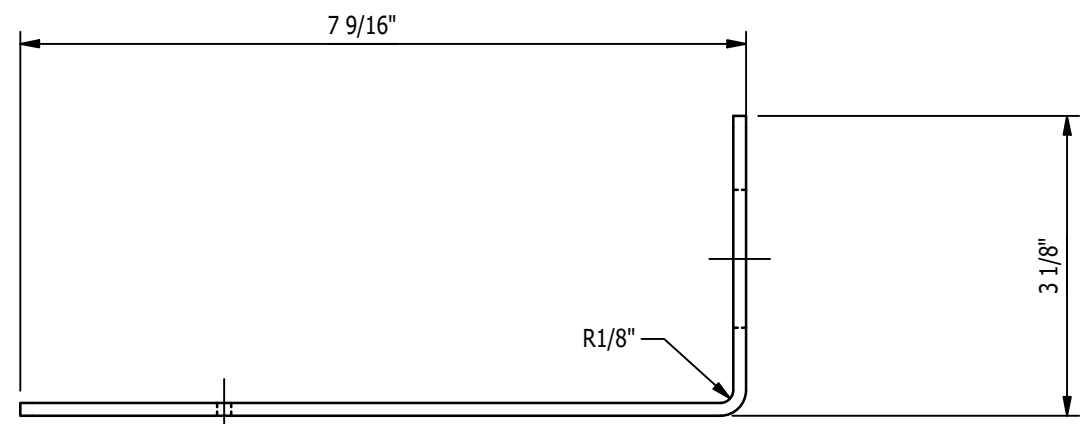
MK-D489D ~ PROX BRACKET
SCALE 6"=1'-0"



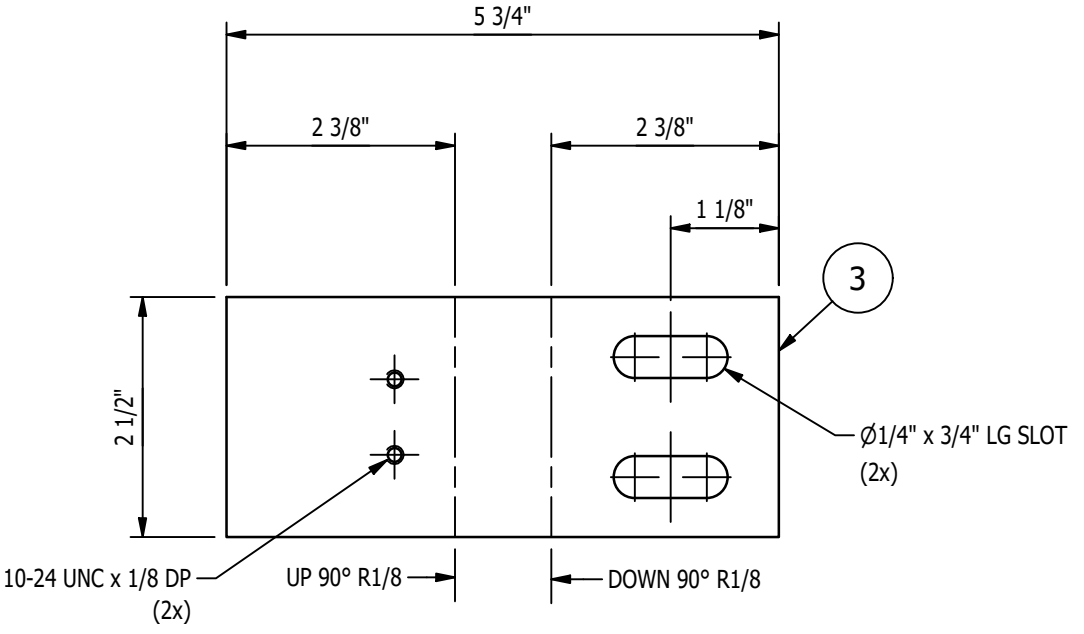
DETAIL OF ITEM '4'
SCALE 6"=1'-0"



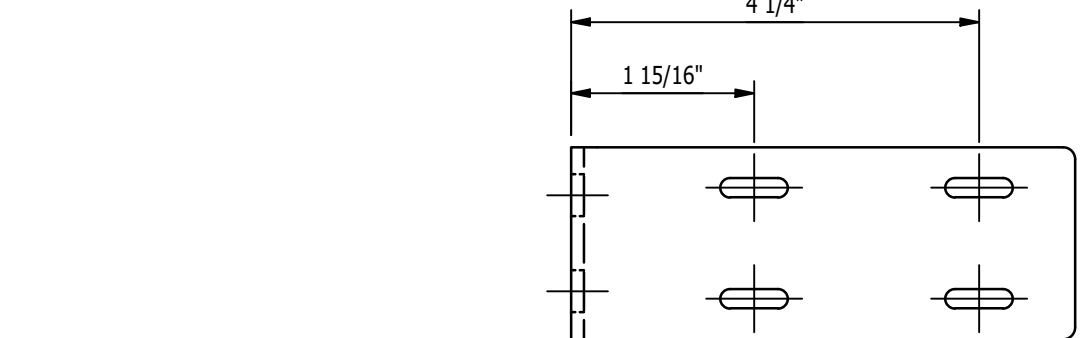
MK-D489E ~ PROX BRACKET
SCALE 1'-0"=1'-0"



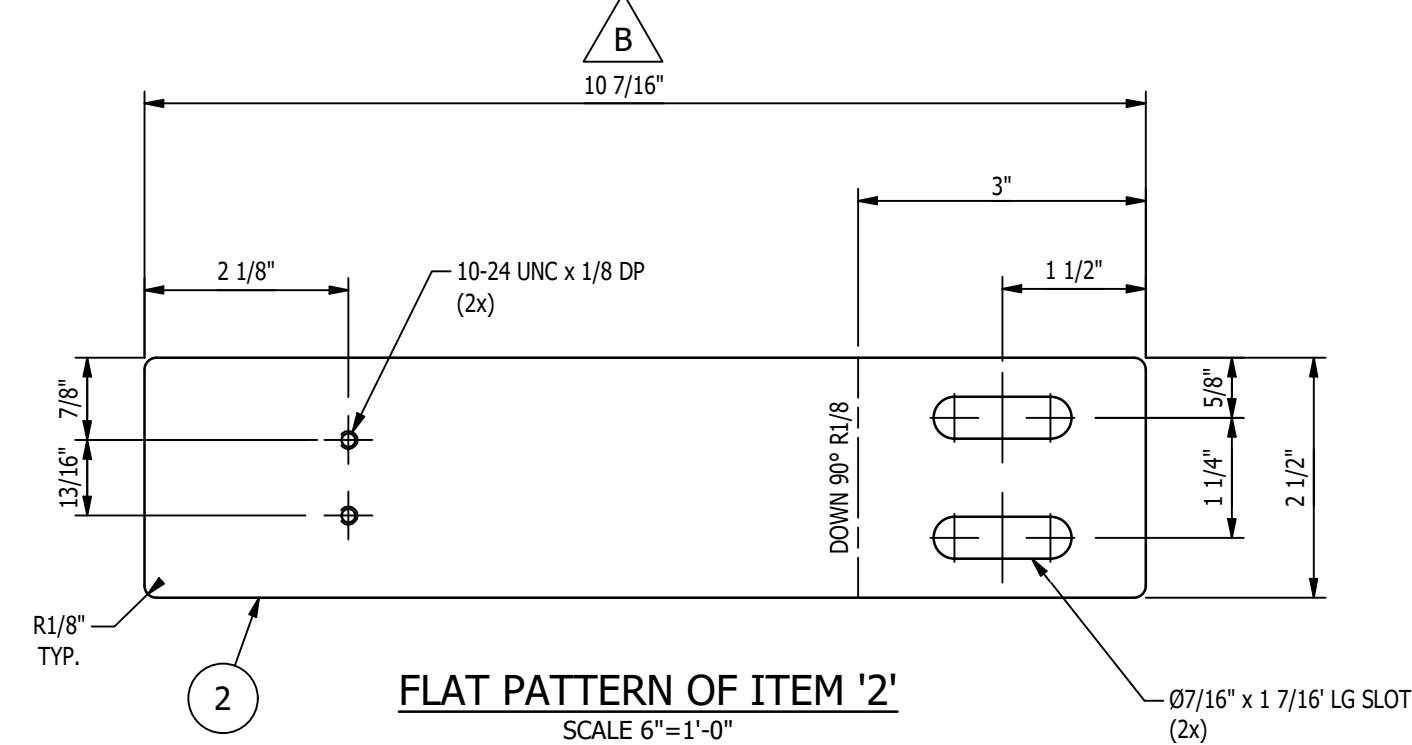
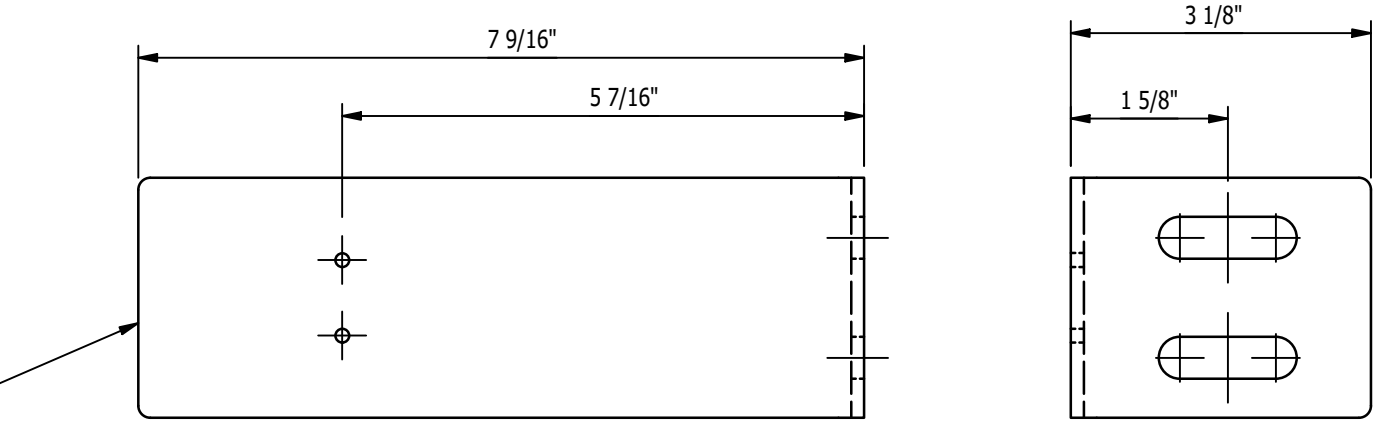
MK-D489B ~ PROX BRACKET
SCALE 6"=1'-0"



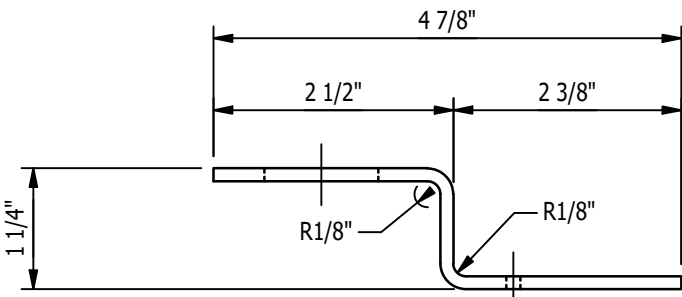
DETAIL OF ITEM '3'
SCALE 6"=1'-0"



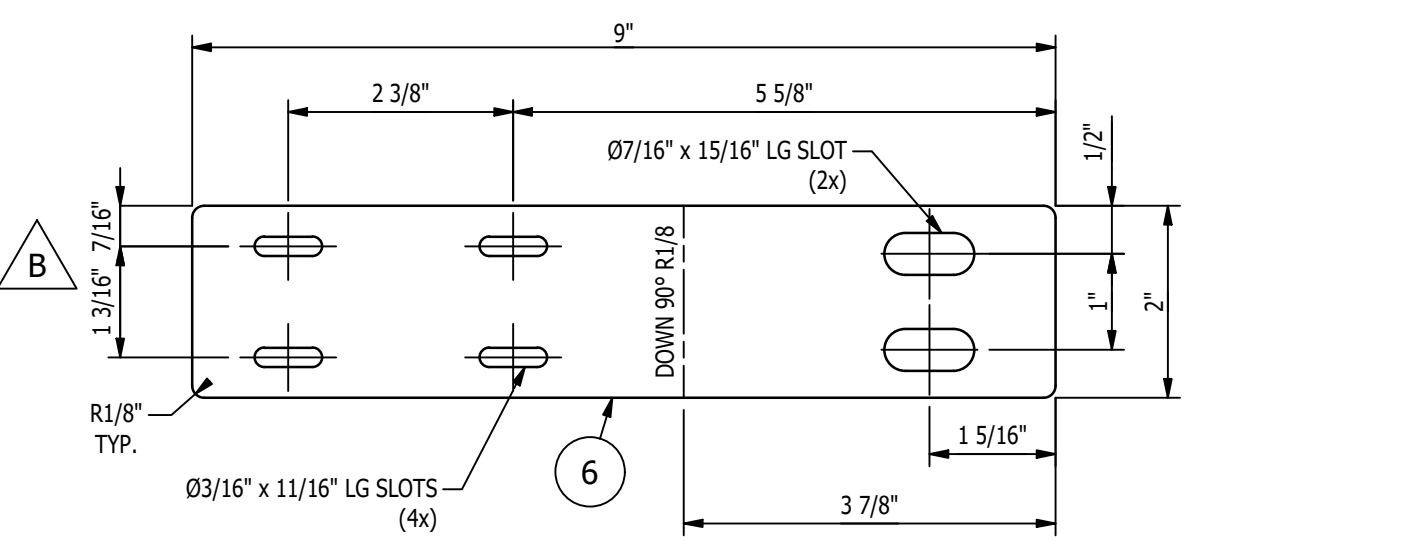
MK-D489F ~ PROX BRACKET
SCALE 6"=1'-0"



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



MK-D489C ~ PROX BRACKET
SCALE 6"=1'-0"



FLAT PATTERN OF '6'
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 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	11/28/22	ADDED BALLOON TO MK-D489D AND ADDED DIMENSIONS TO FLAT PATTERN OF ITEM '6', UPDATED LENGTH OF ITEM '1', UPDATED LENGTH OF ITEM '2'	
A	MC	11/14/22	FOR FABRICATION	

REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	BTC
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D489	DWG DATE:	11/4/22
REV:	B	JOB No:	22096

MAGNUM Consulting

41100 Dardickwood Rd.
Suite 125
West, MI 48375

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D489

UNLESS OTHERWISE NOTED:

X = ±.060
XX = ±.030
XXX = ±.005

FRACTIONS = ±1/16"
ANGLES = ±1°30'

BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

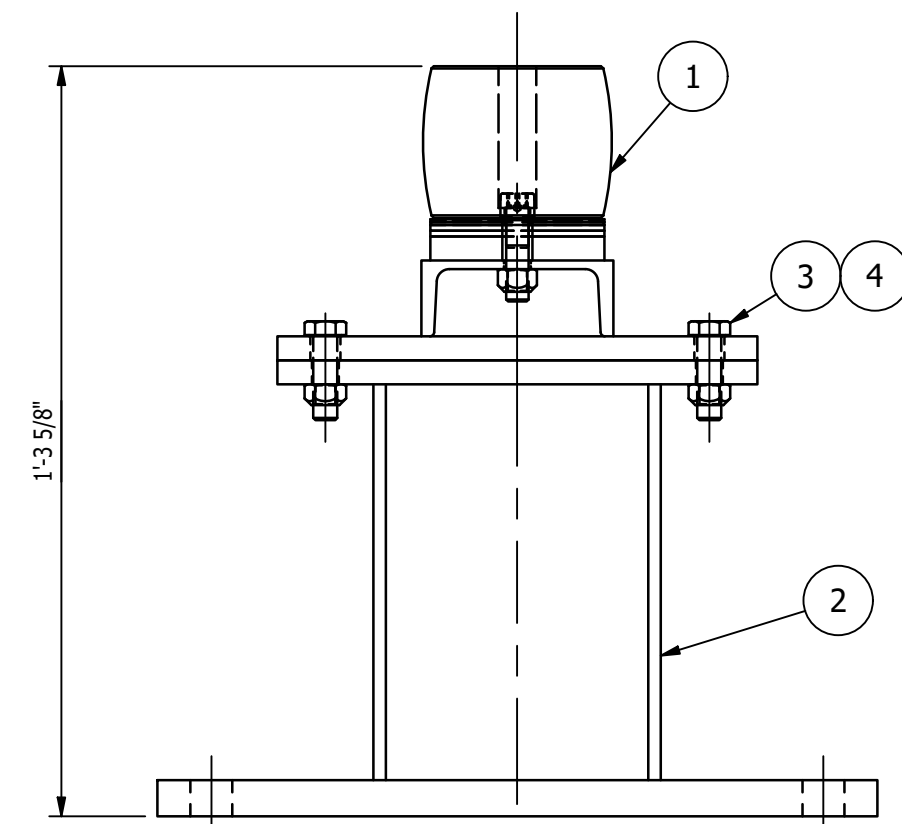
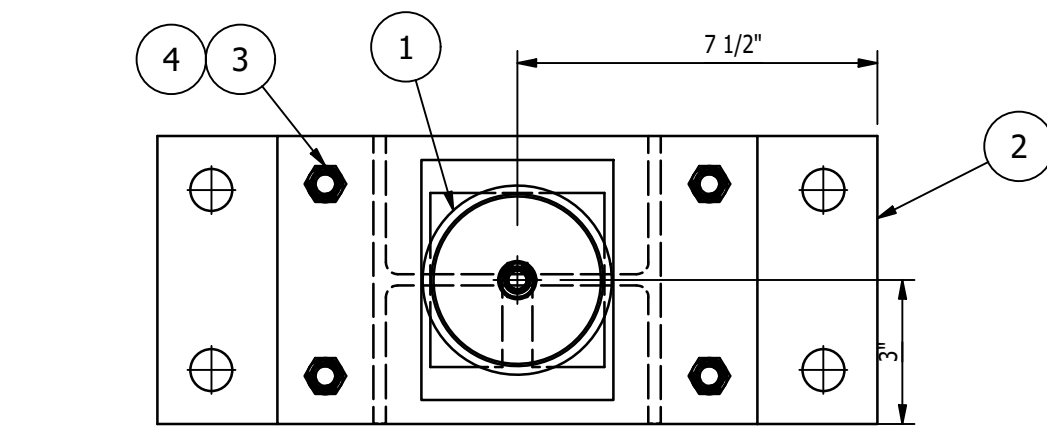
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:

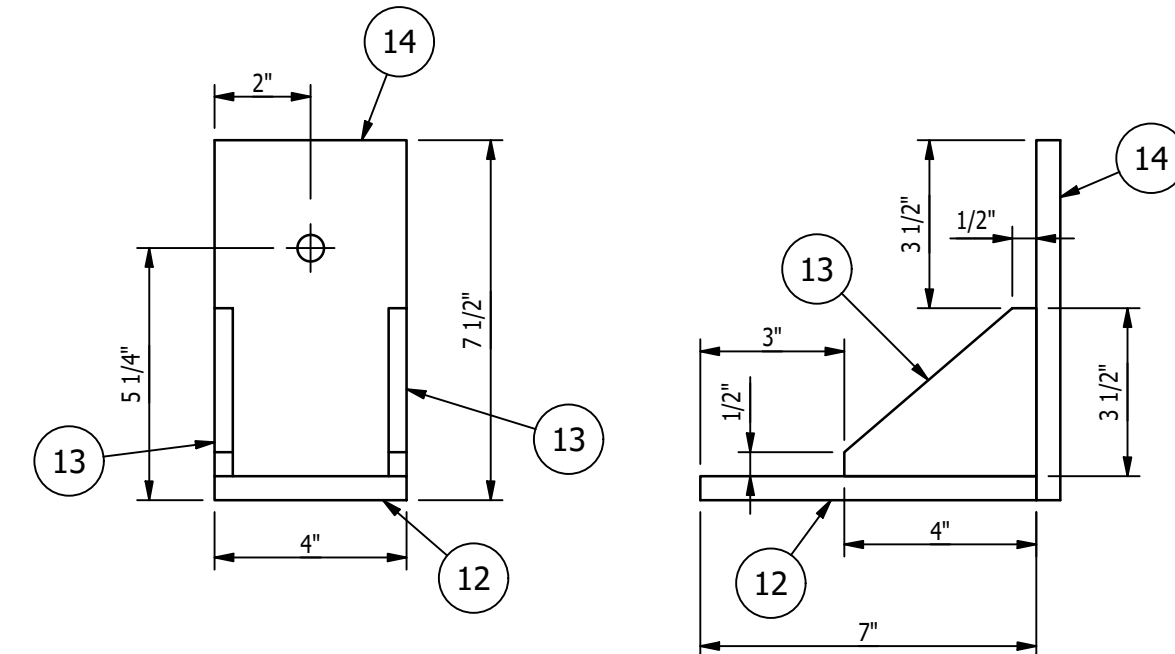
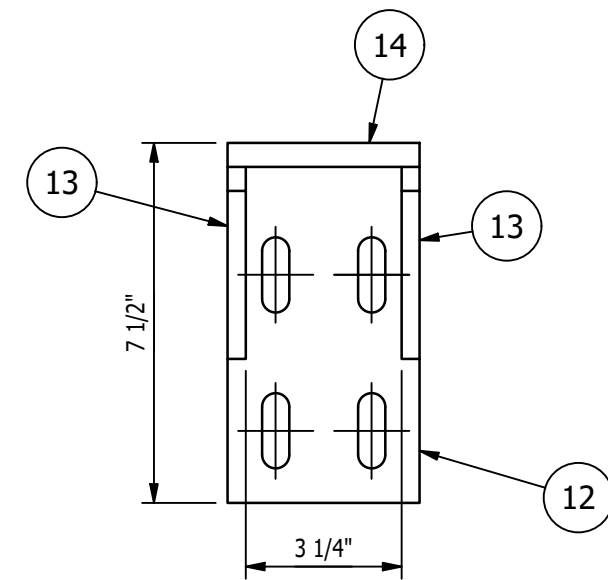
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

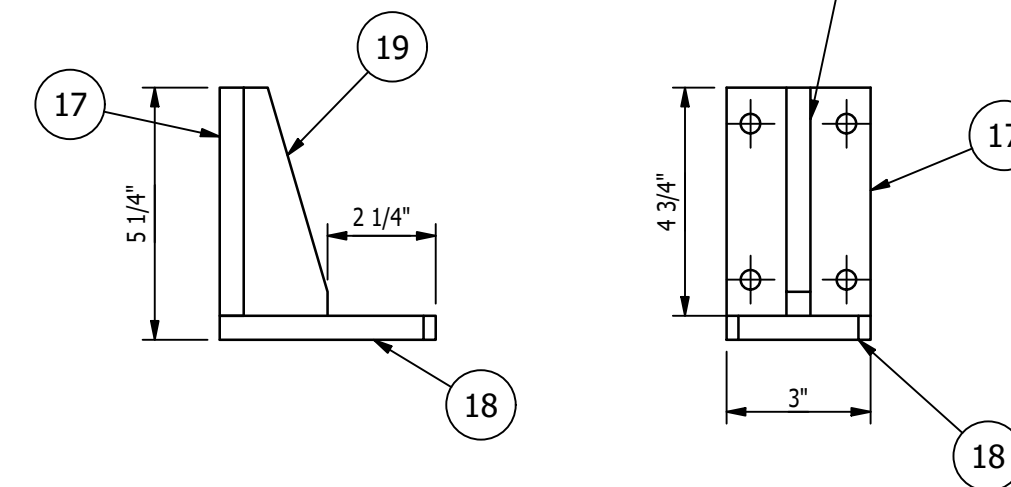
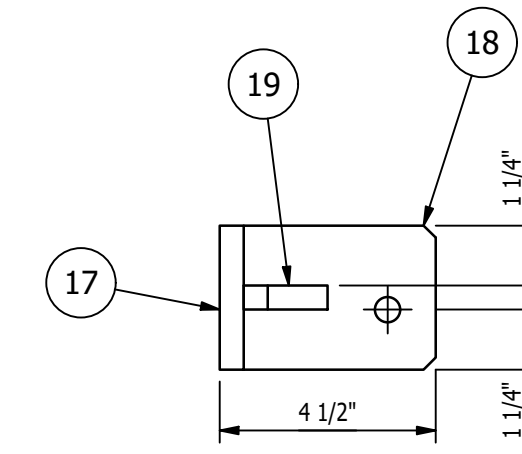
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



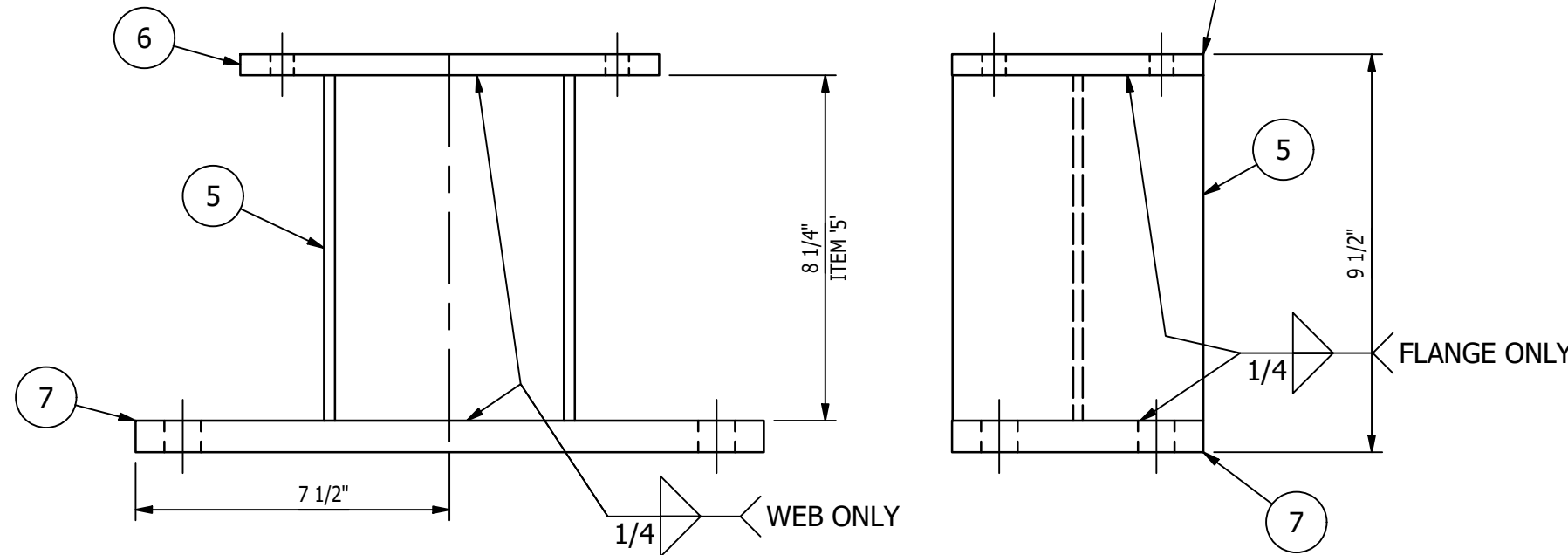
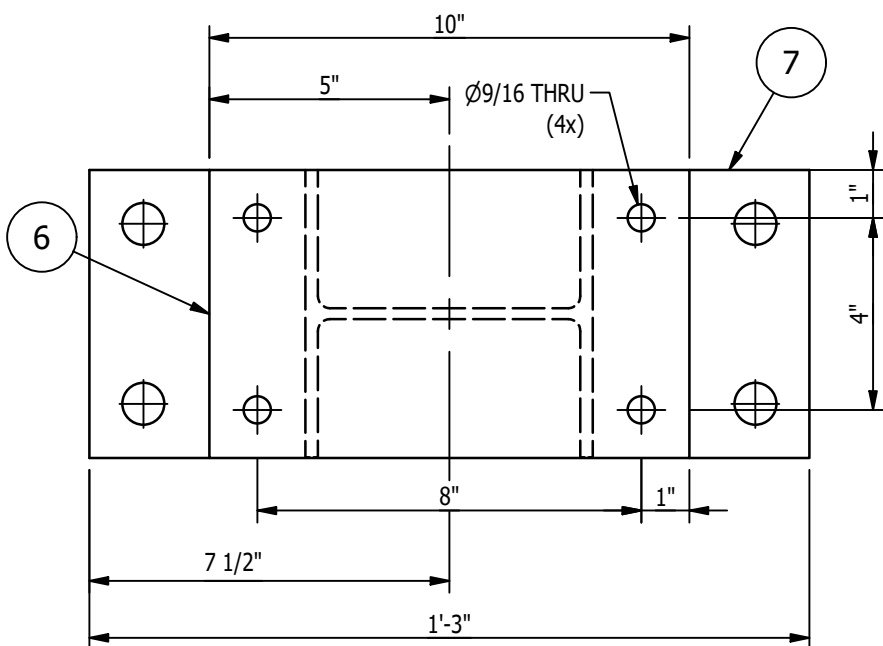
MK-D490A ~ CARRIAGE BUMPER STOP
SCALE 3"=1'-0"



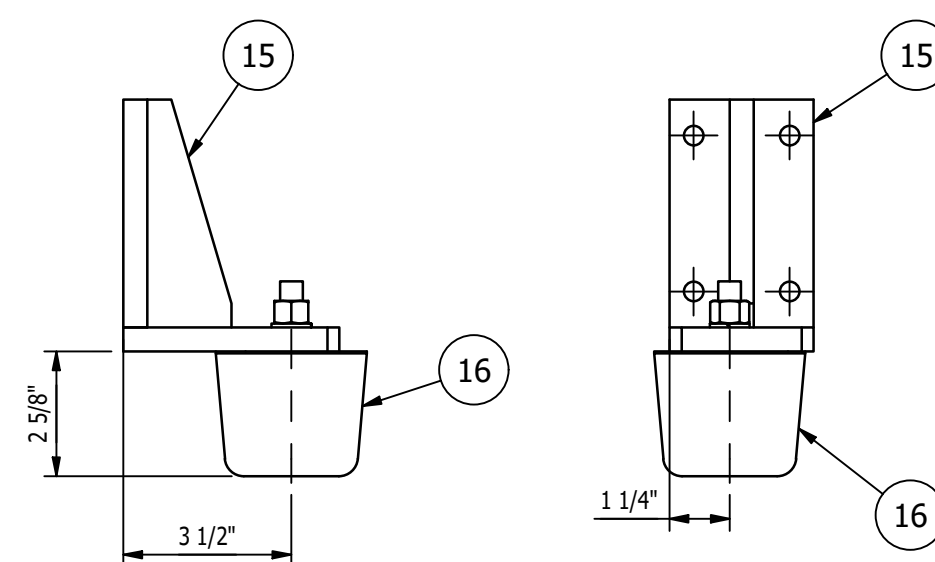
MK-D490D ~ CARRIAGE BUMPER STOP WELDMENT
SCALE 3"=1'-0"



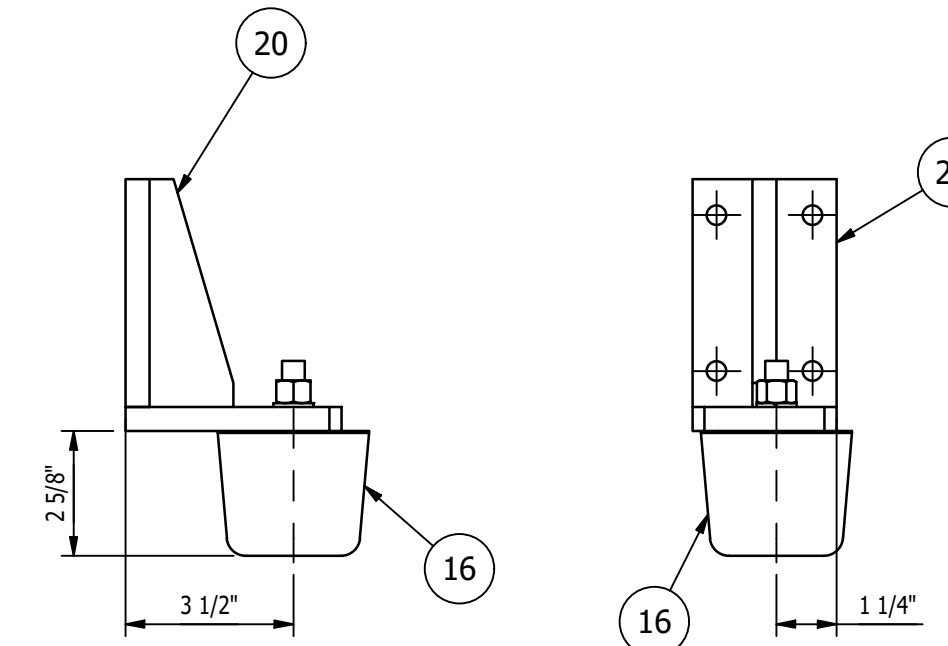
MK-D490G ~ CARRIAGE BUMPER STOP WELDMENT
SCALE 3"=1'-0"



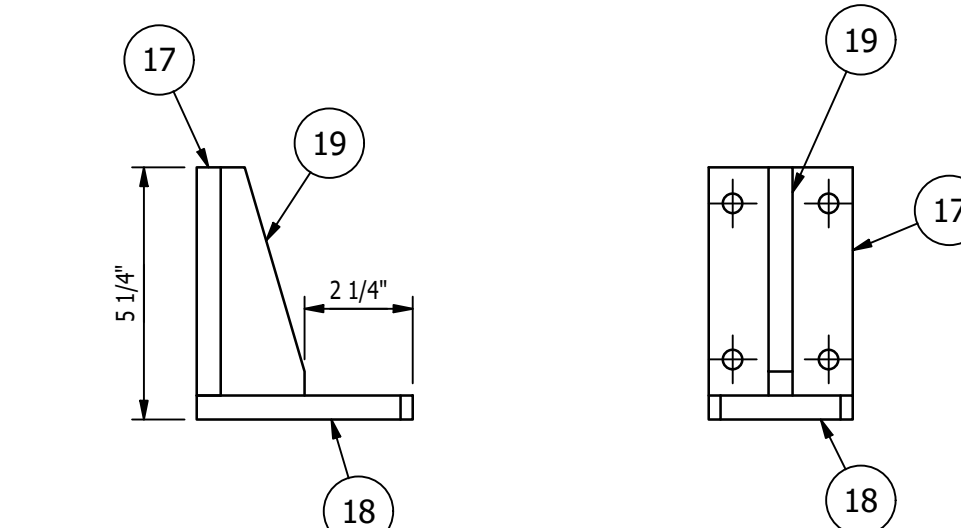
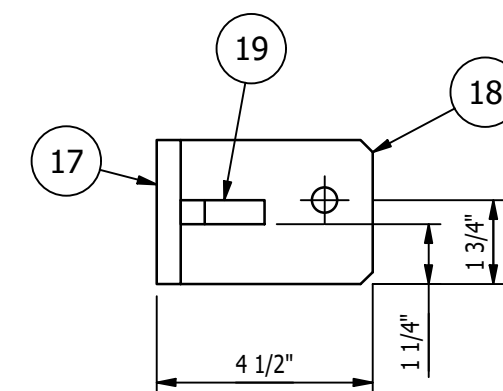
MK-D490B ~ CARRIAGE BUMPER STOP WELDMENT
SCALE 3"=1'-0"



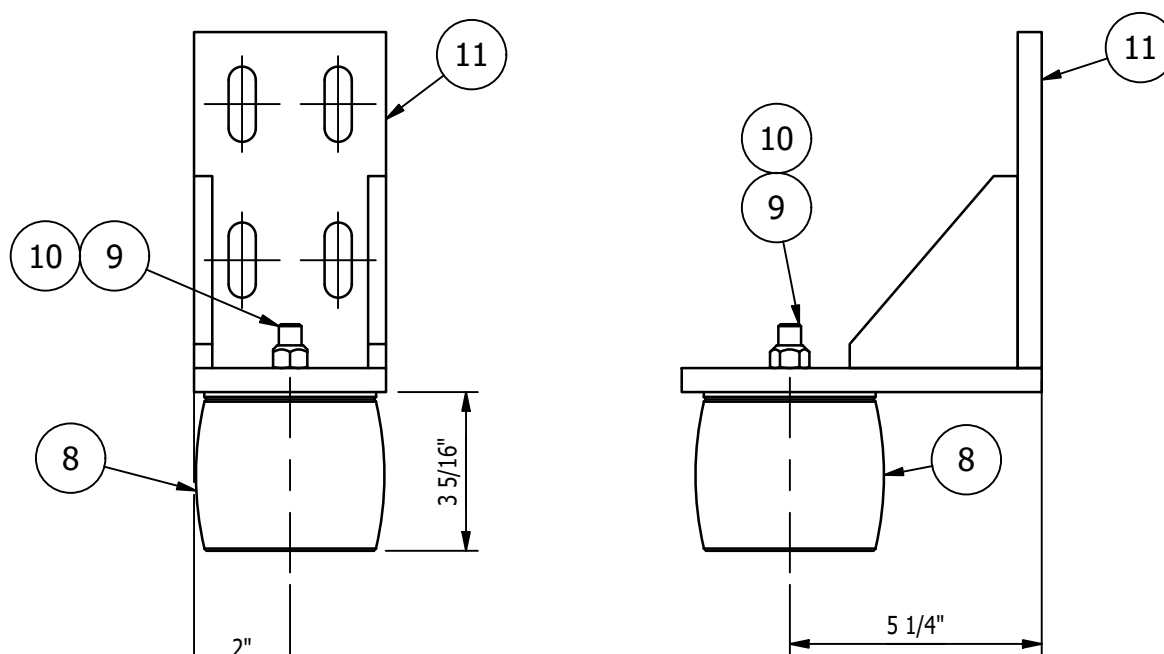
MK-D490E ~ CARRIAGE BUMPER STOP
SCALE 3"=1'-0"



MK-D490H ~ CARRIAGE BUMPER STOP
SCALE 3"=1'-0"



MK-D490F ~ CARRIAGE BUMPER STOP WELDMENT
SCALE 3"=1'-0"



MK-D490C ~ CARRIAGE BUMPER STOP
SCALE 3"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D490A			
1	1	MK-D317A ~ PALLET BUMPER STOP			
2	1	MK-D490B ~ CARRIAGE BUMPER STOP WELDMENT			
3	4	1/2-13UNC STOVER LOCK NUT			
4	4	1/2-13UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
		MK-D490B			
5	1	W 6 x 15	8 1/4"		
6	1	PL 1/2 x 6"	10"		
7	1	PL 3/4 x 6"	1'-3"		
		MK-D490C			
8	1	ACE BUMPER TC 100-59		7-24	
9	1	M12x1.75 x 45mm LG. HEX SOCKET HEAD CAP SCREW			
10	1	M12 x 1.75 STOVER LOCK NUT			
11	1	MK-D490D ~ CARRIAGE BUMPER STOP WELDMENT			
		MK-D490D			
12	1	PL 1/2 x 4"	7"		
13	2	PL 3/8 x 4"	3 1/2"		
14	1	PL 1/2 x 4"	7 1/2"		
		MK-D490E			
15	1	MK-D490G ~ CARRIAGE BUMPER STOP WELDMENT			
16	1	CONDUCTIX WAMPFLER RUBBER BUMPER WITH FASTENERS, PART NO. 017120-080N-1		28-10	
		MK-D490F			
17	1	BAR 1/2 x 3	4 3/4"		
18	1	BAR 1/2 x 3	4 1/2"		
19	1	BAR 1/2 x 1 3/4	4 3/4"		
		MK-D490G			
17	1	BAR 1/2 x 3	4 3/4"		
18	1	BAR 1/2 x 3	4 1/2"		
19	1	BAR 1/2 x 1 3/4	4 3/4"		
		MK-D490H			
16	1	CONDUCTIX WAMPFLER RUBBER BUMPER WITH FASTENERS, PART NO. 017120-080N-1		28-10	
20	1	MK-D490F ~ CARRIAGE BUMPER STOP WELDMENT			

- 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 MK-D490B, MK-D490D, MK-D490F, & MK-D490G ONE SHOP COAT OF LIGHT GREY RAL 7035 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

SHEET 1 OF 2

MAGNUM Consulting
4110 Gardenbrook Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D490 - REV A

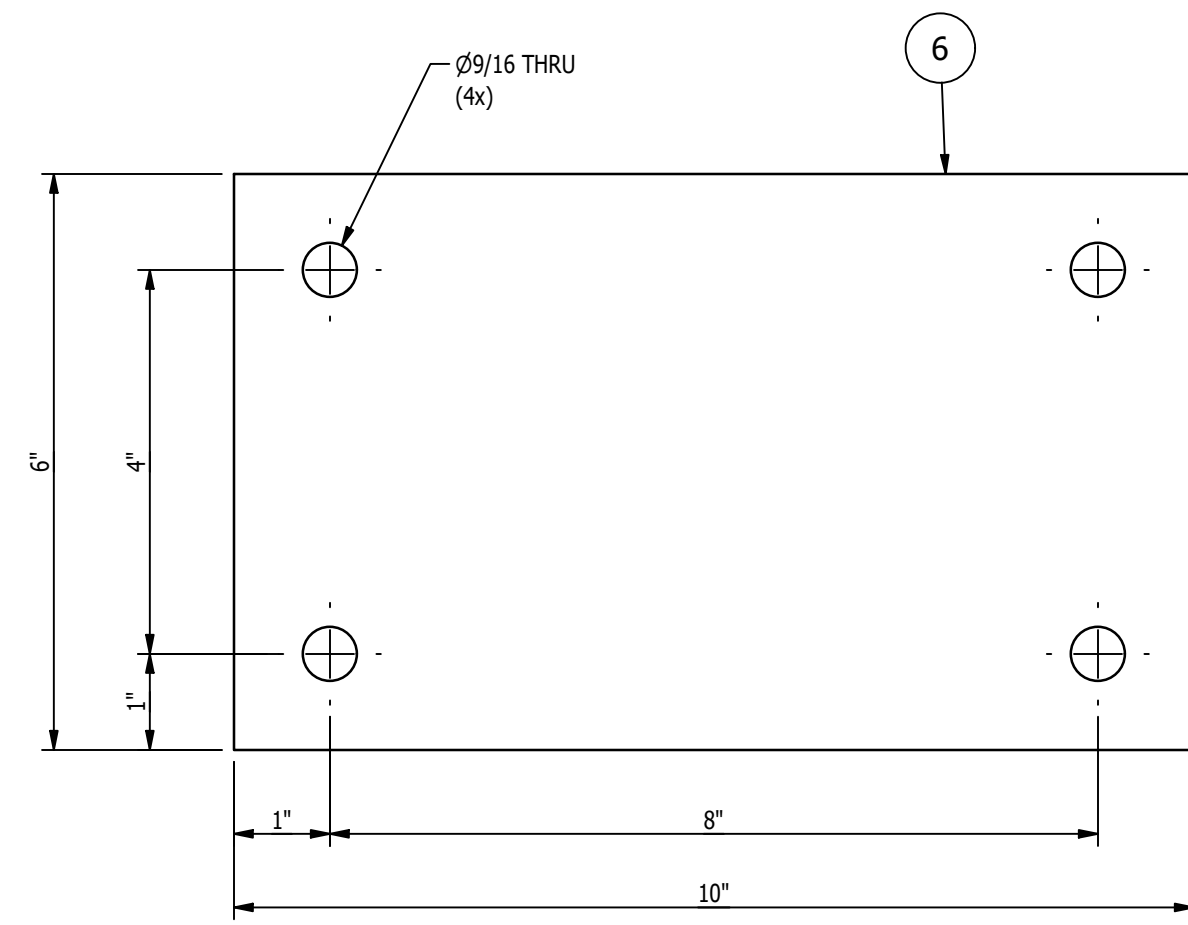
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XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

GENERAL NOTES:

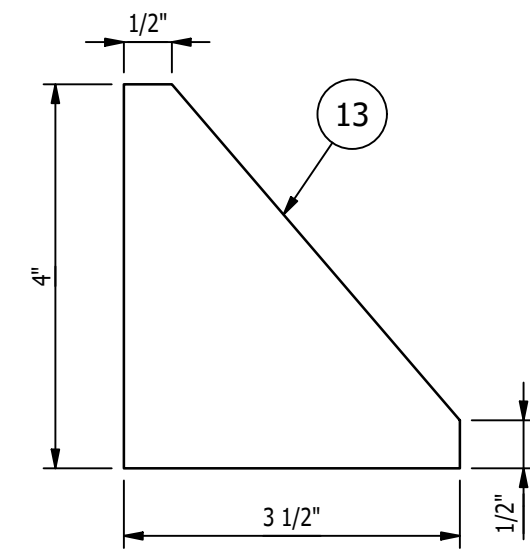
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)
- PAINT: PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
- COPIES: ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/15/22	FOR FABRICATION	
REVISION HISTORY				

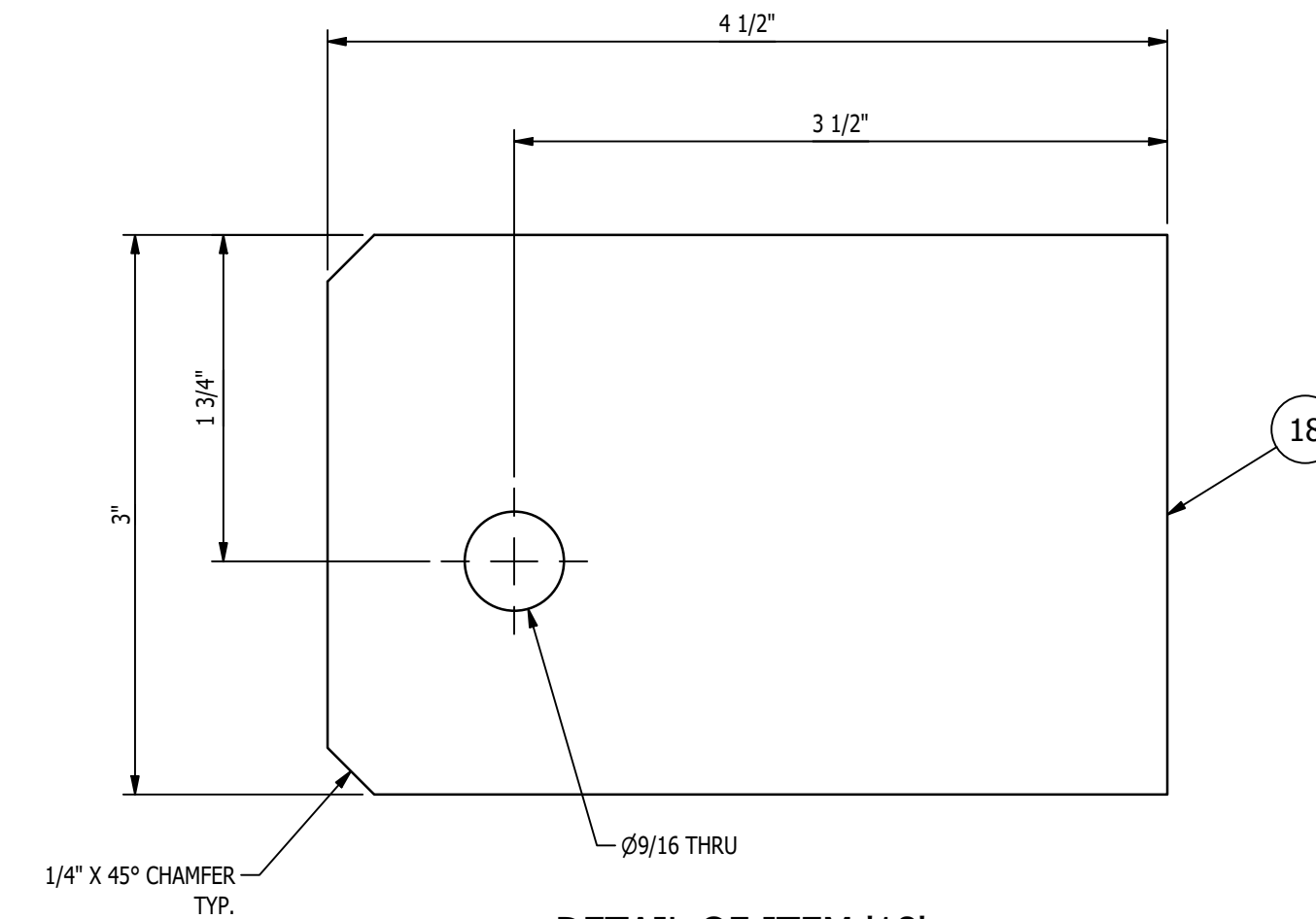
<p>MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com</p>	<p>TITLE: P6700 CONVEYORS CAMPUS BUILDING</p> <p>CLIENT: VOLVO</p> <p>DRAWING No. 1875D490</p>	<p>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</p>
<p>REV: A</p>	<p>JOB No: 22096</p>	



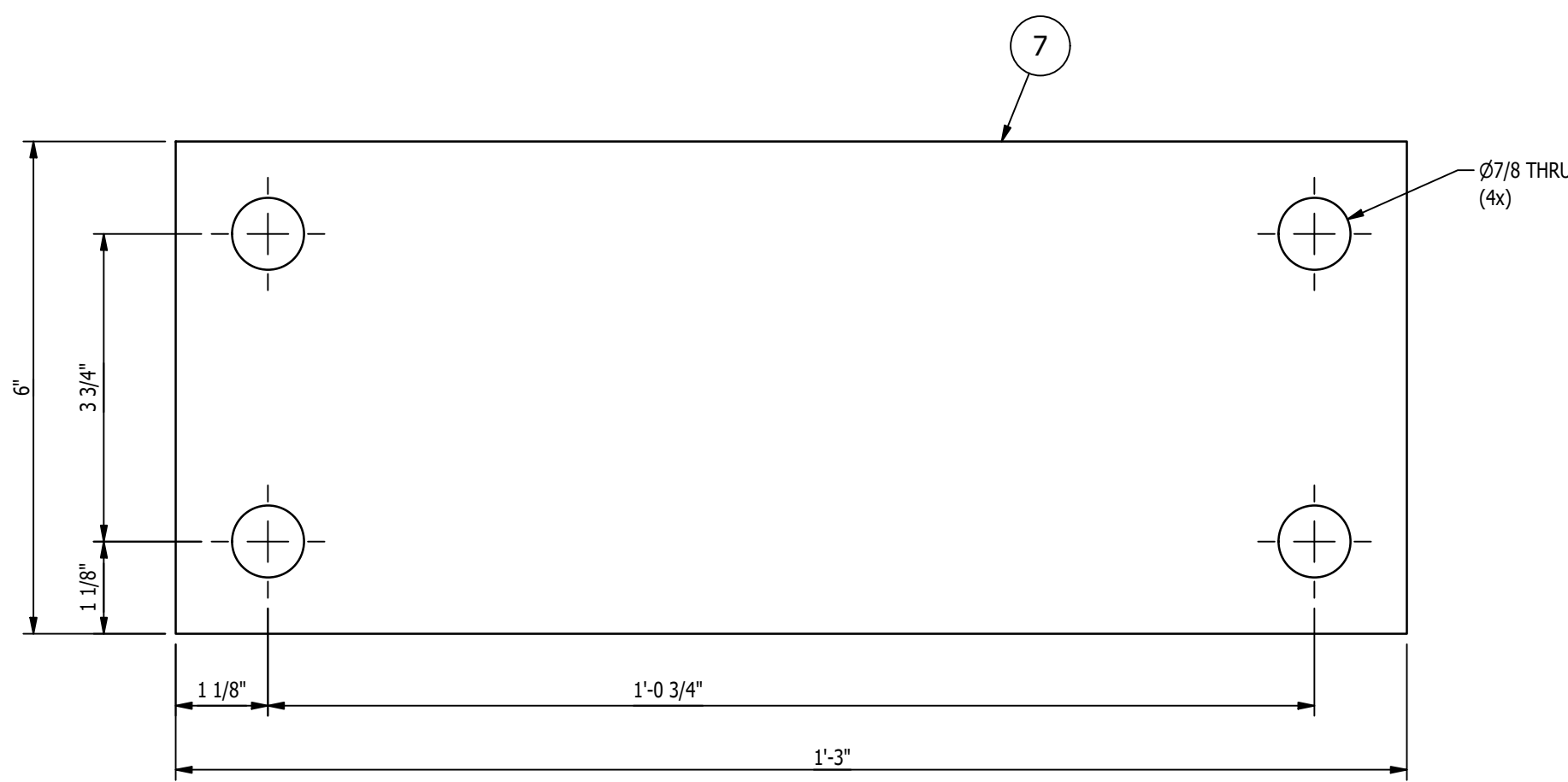
DETAIL OF ITEM '6'
SCALE 6"=1'-0"



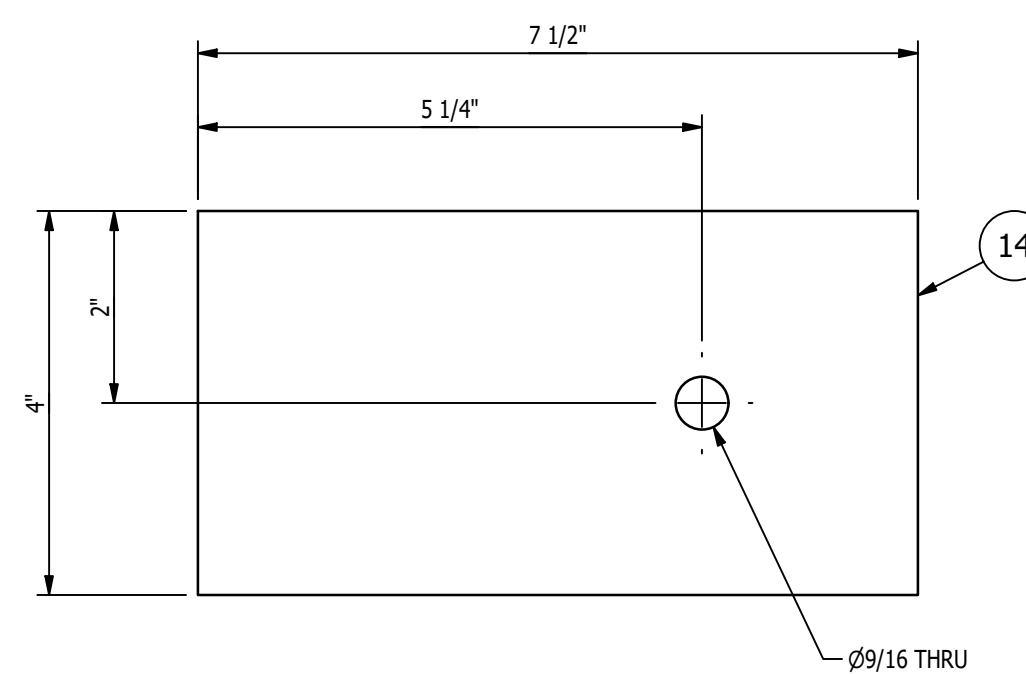
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SCALE 6"=1'-0"



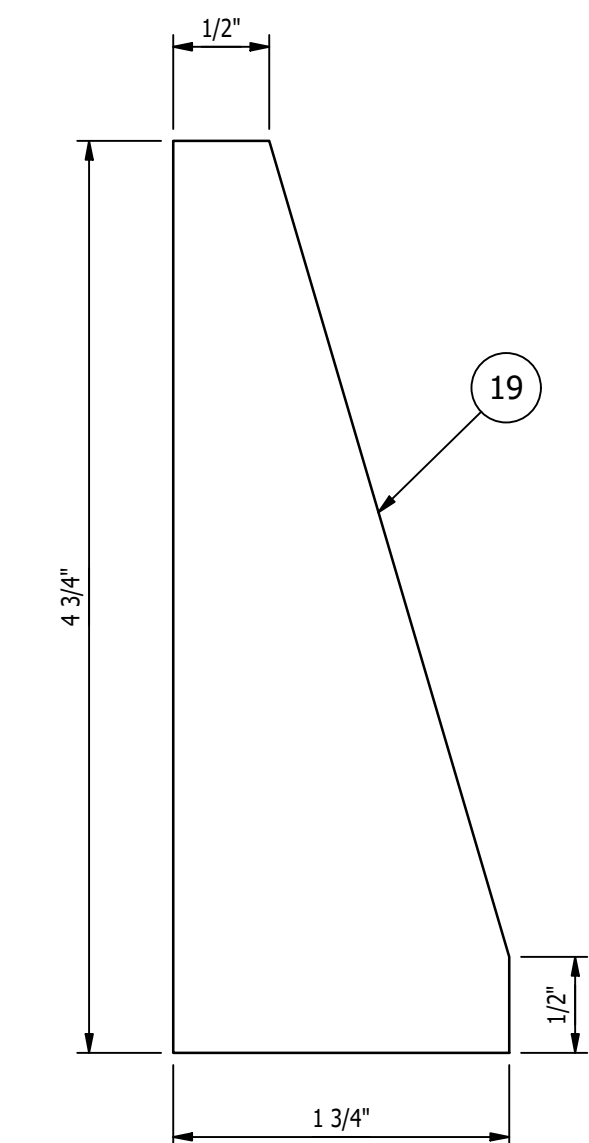
DETAIL OF ITEM '18'
SCALE 1'-0"=1'-0"



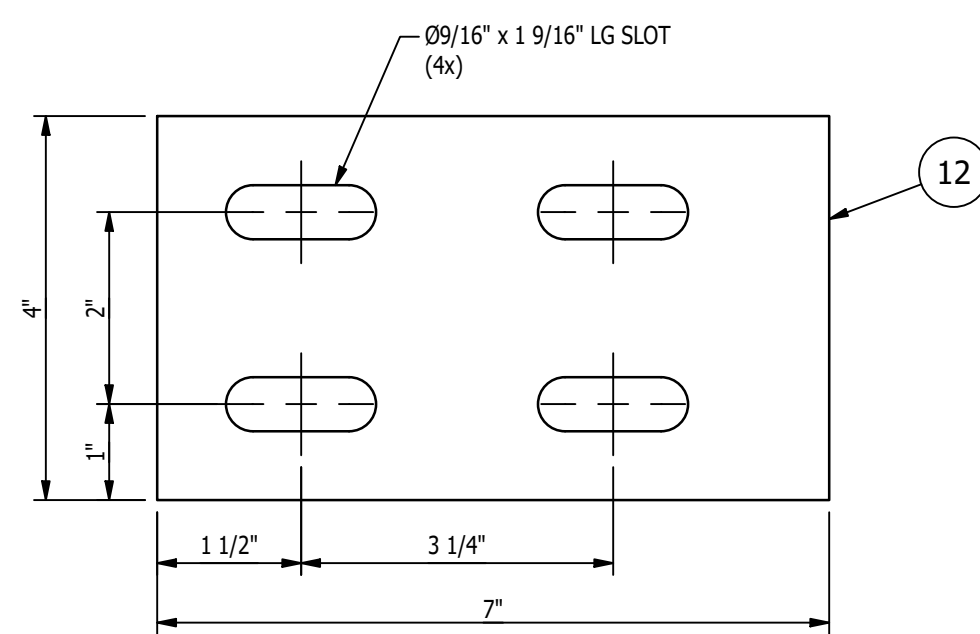
DETAIL OF ITEM '7'
SCALE 6"=1'-0"



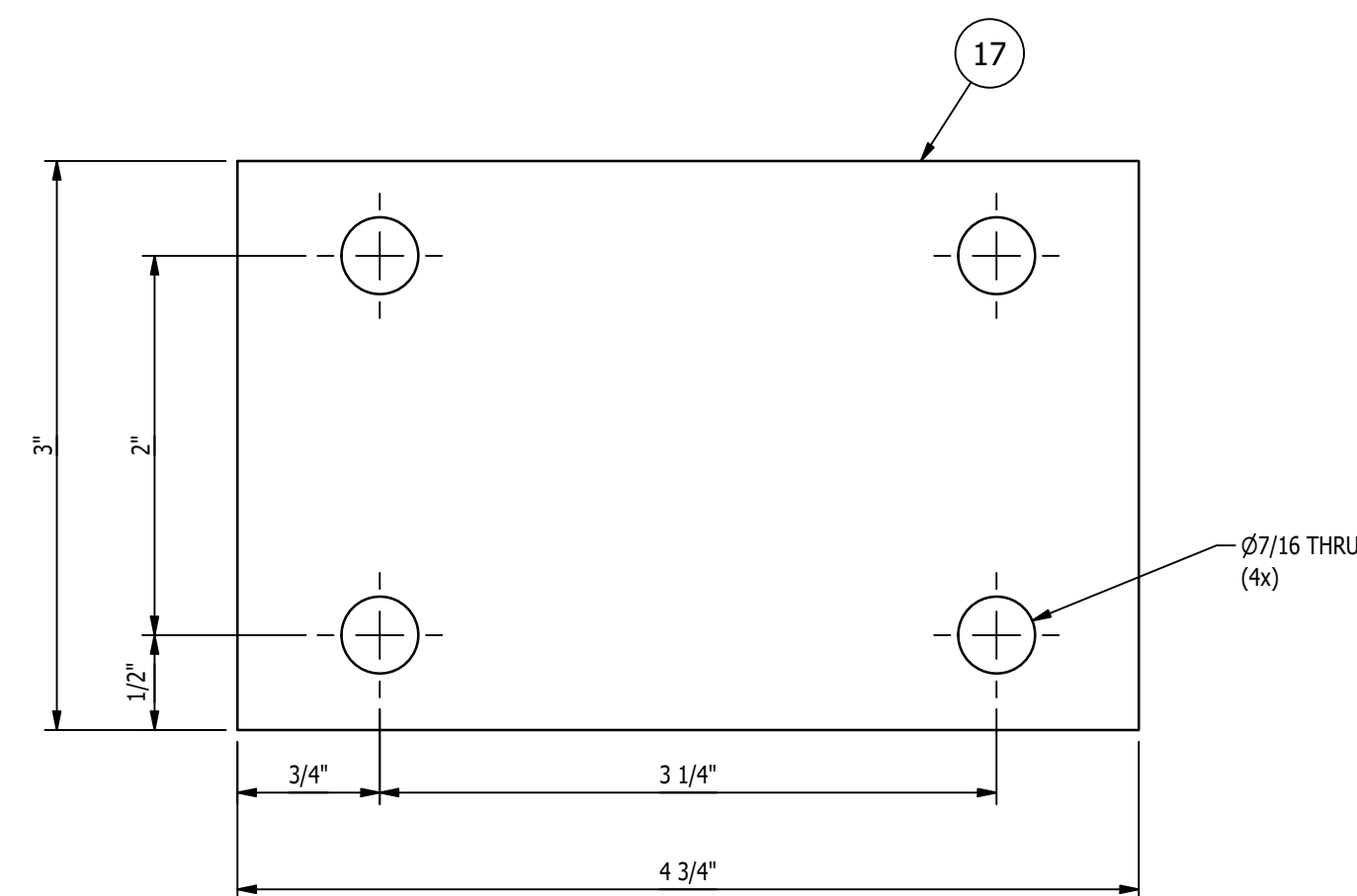
DETAIL OF ITEM '14'
SCALE 6"=1'-0"



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



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



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

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/15/22	FOR FABRICATION	

mi MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D490	DWG DATE:	11/7/22
REV:	A	JOB No:	22096

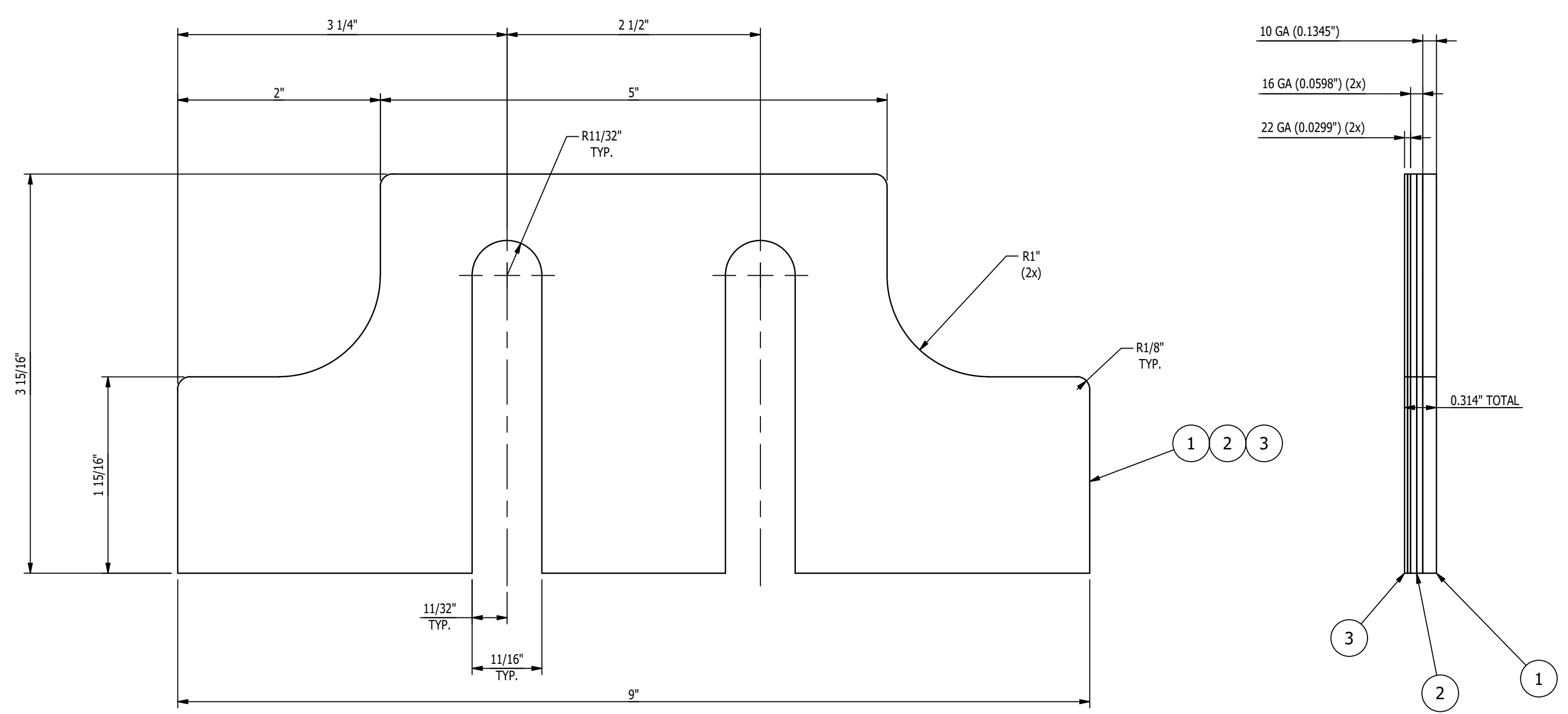
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4"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

MAGNUM Consulting
41700 Gardenbrook Rd.
Suite 125
Novi, MI 48375
Phone: (248) 773-6000
Fax: (248) 773-8051
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D490 - REV A

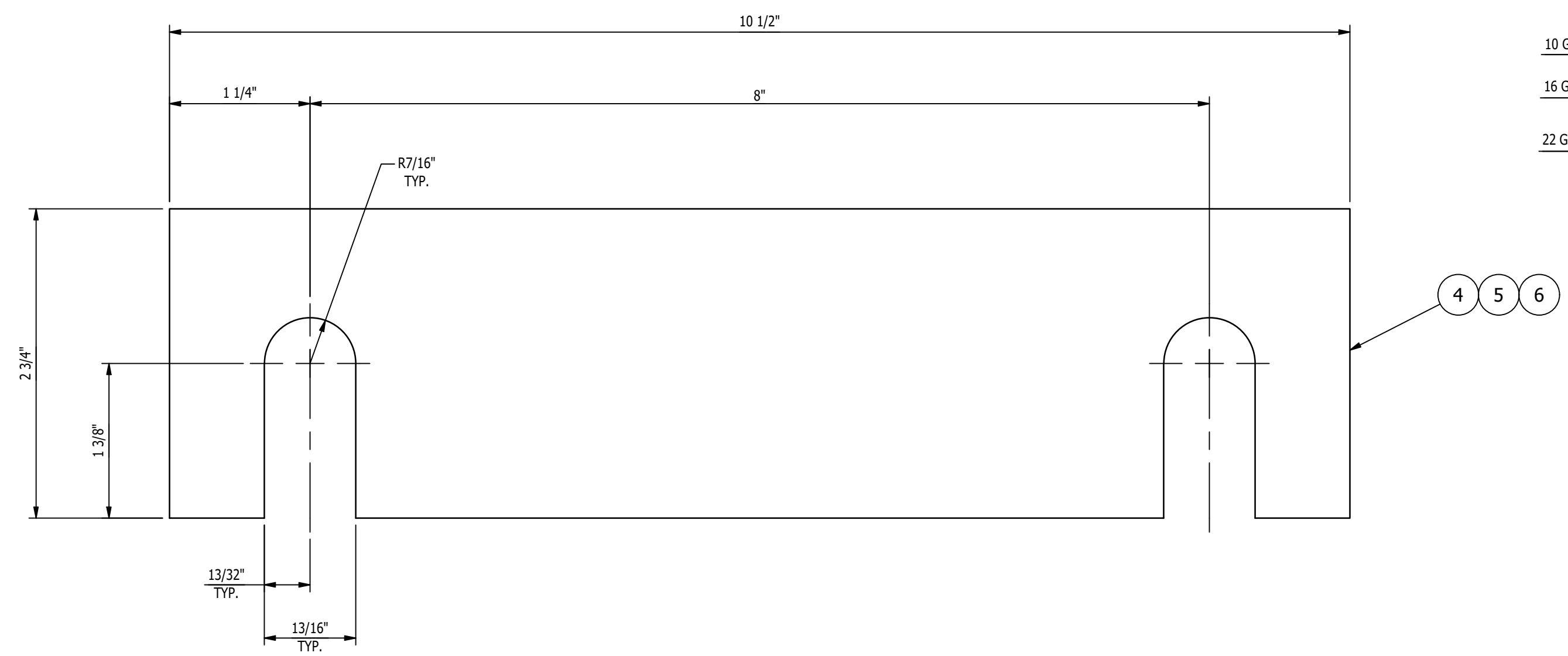
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

3:00p 11/25/22 New Job Drawing/Issue/22-11-15 Rev. LRD/MLD/ST/5096 - REV A.dwg

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
MK-D491A					
1	1	SHT 10 GA x 3 15/16	9"		
2	2	SHT 16 GA x 3 15/16	9"		
3	2	SHT 22 GA x 3 15/16	9"		
MK-D491B					
4	1	SHT 10 GA x 2 3/4	10 1/2"		
5	1	SHT 16 GA x 2 3/4	10 1/2"		
6	2	SHT 22 GA x 2 3/4	10 1/2"		



MK-D491A ~ SHIM PACK
SCALE 1'-0" = 1'-0"



MK-D491B ~ SHIM PACK
SCALE 1'-0" = 1'-0"

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

PAINT NOTES:
DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/15/22	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.millic.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: RJB		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 11/11/22		JOB No: 22096	
DRAWING No. 1875D491		REV: A			

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D491 - REV A

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:

MATERIALS:

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

HOLES:

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

WELDS:

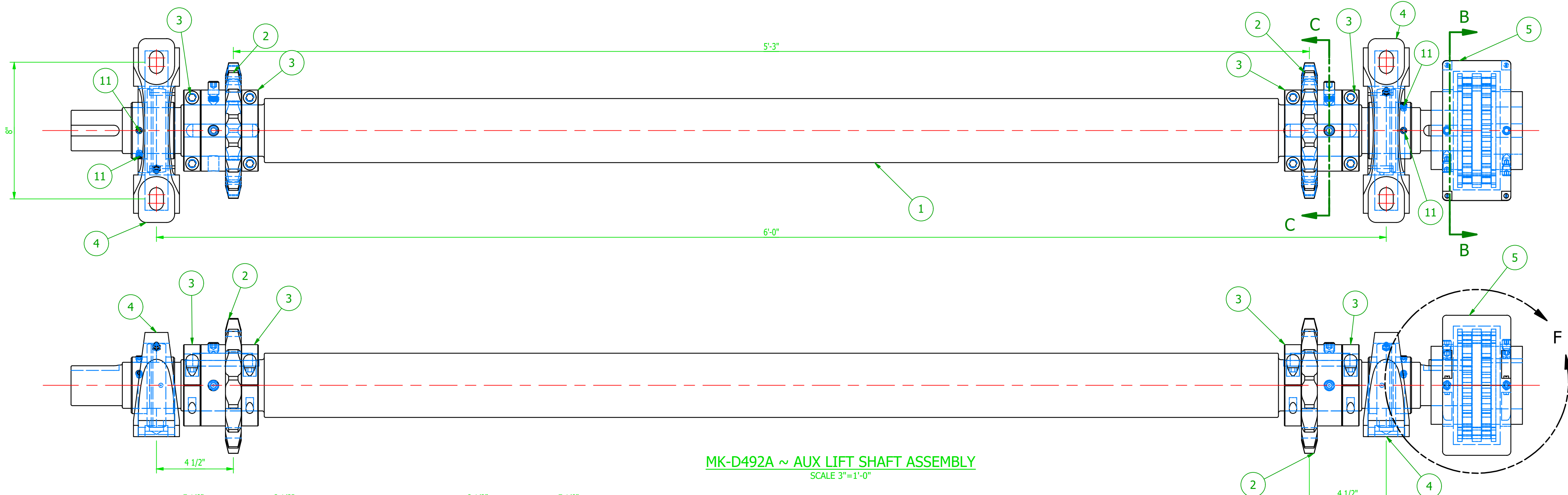
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

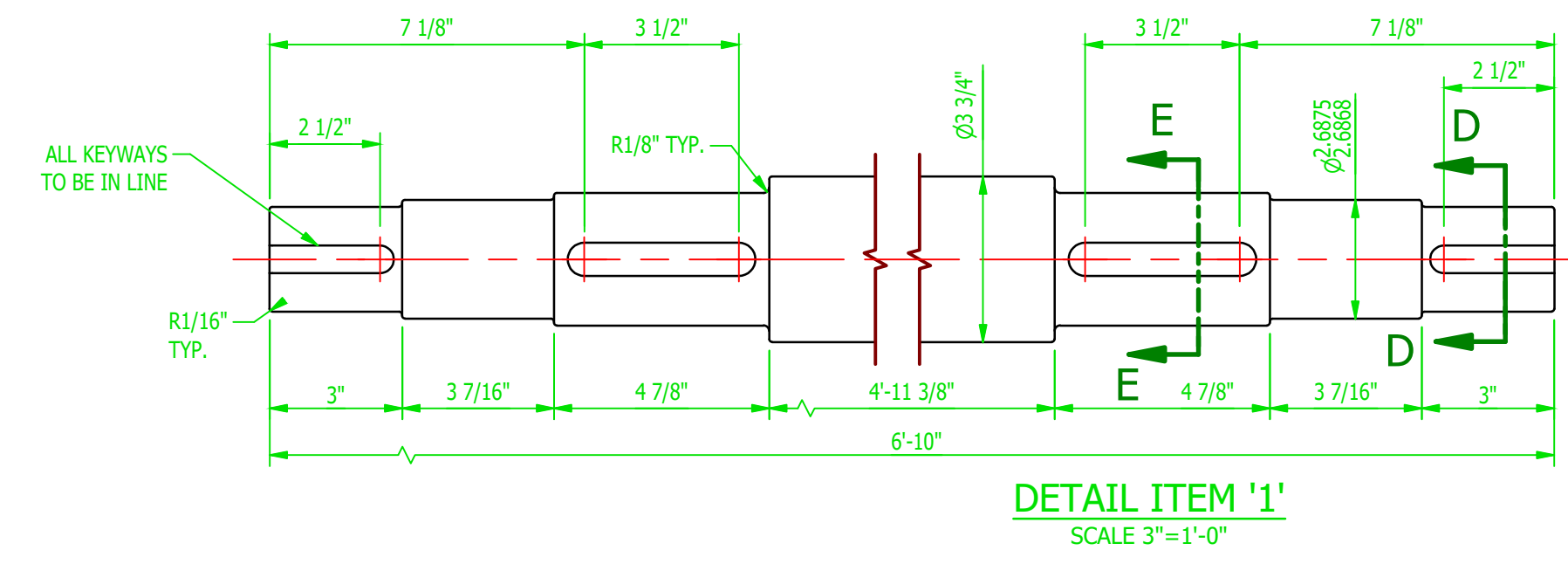
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

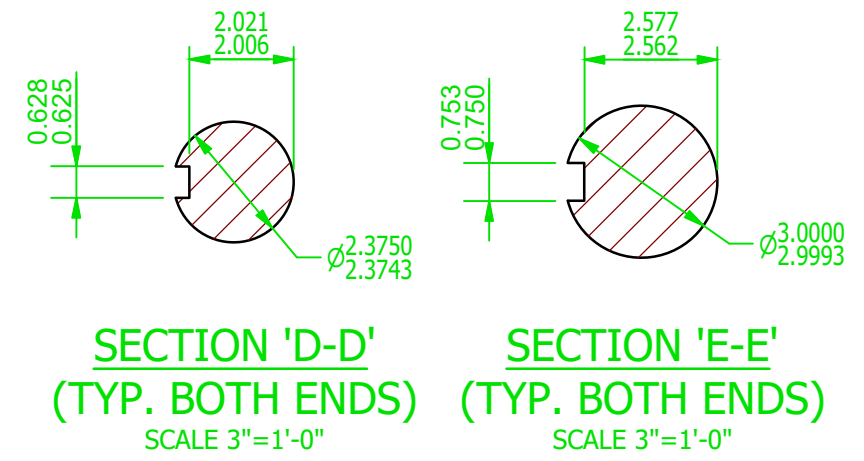
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



MK-D492A ~ AUX LIFT SHAFT ASSEMBLY
SCALE 3"=1'-0"

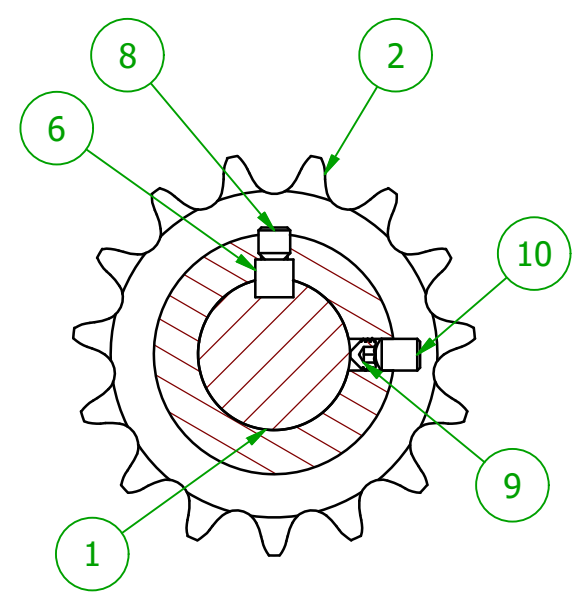


DETAIL ITEM '1'
SCALE 3"=1'-0"

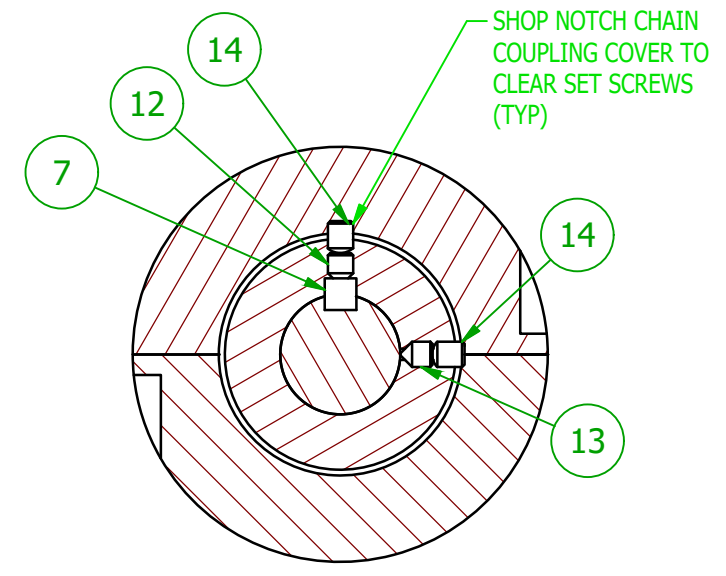


SECTION 'D-D'
(TYP. BOTH ENDS) SCALE 3"=1'-0"

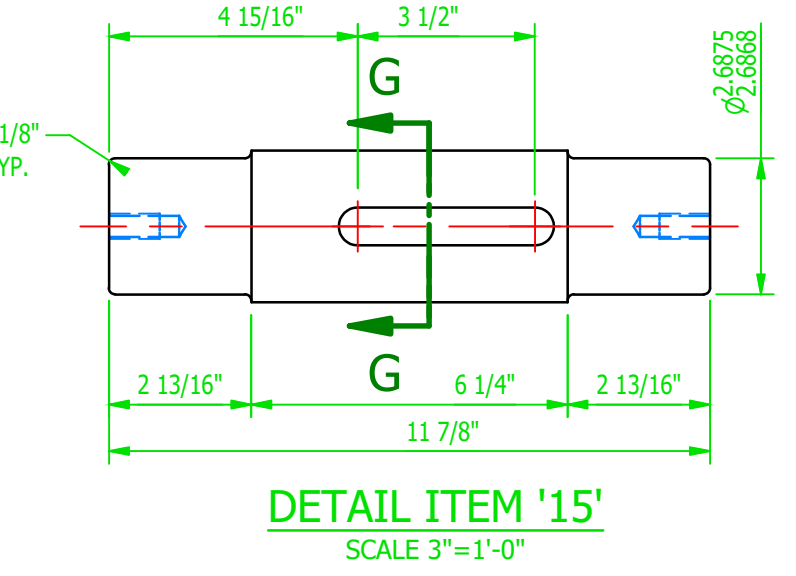
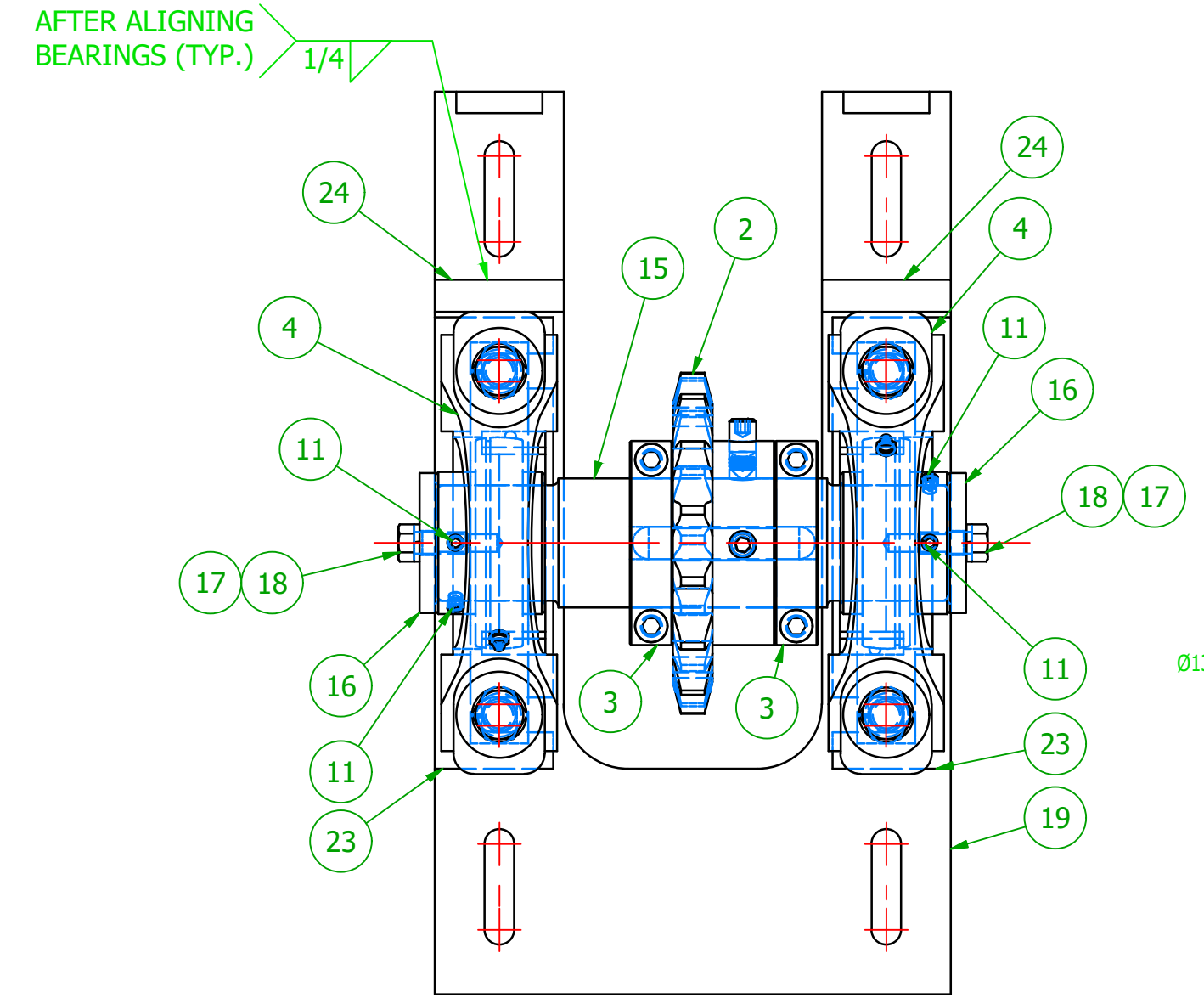
SECTION 'E-E'
(TYP. BOTH ENDS) SCALE 3"=1'-0"



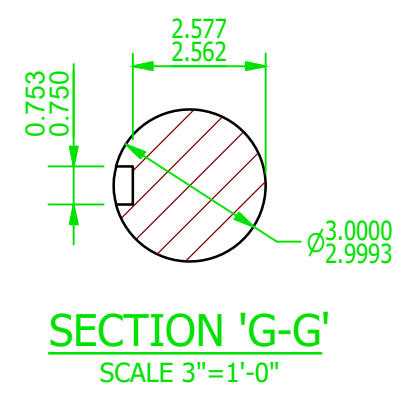
SECTION 'C-C'
SCALE 3"=1'-0"
(APPLIES AT ALL SPROCKETS)



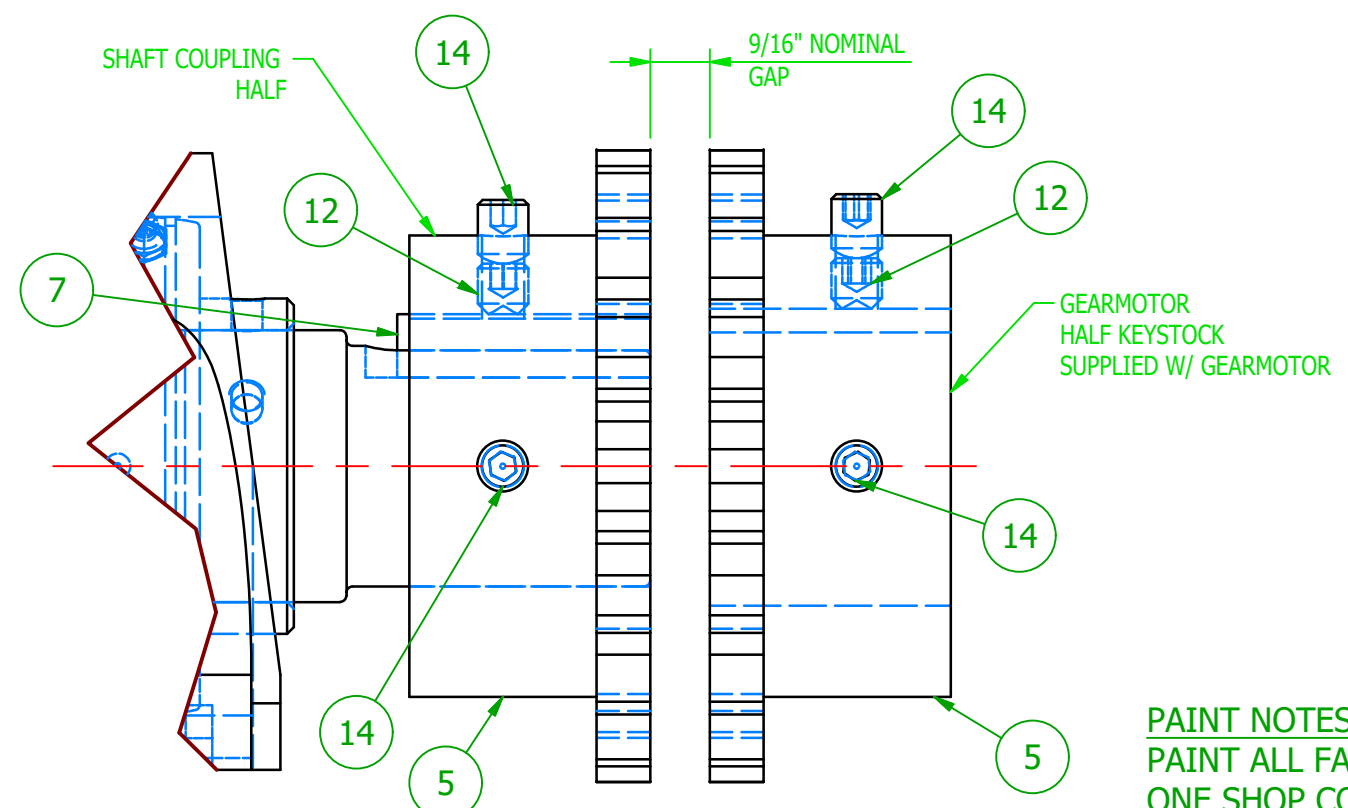
SECTION 'B-B'
SCALE 3"=1'-0"



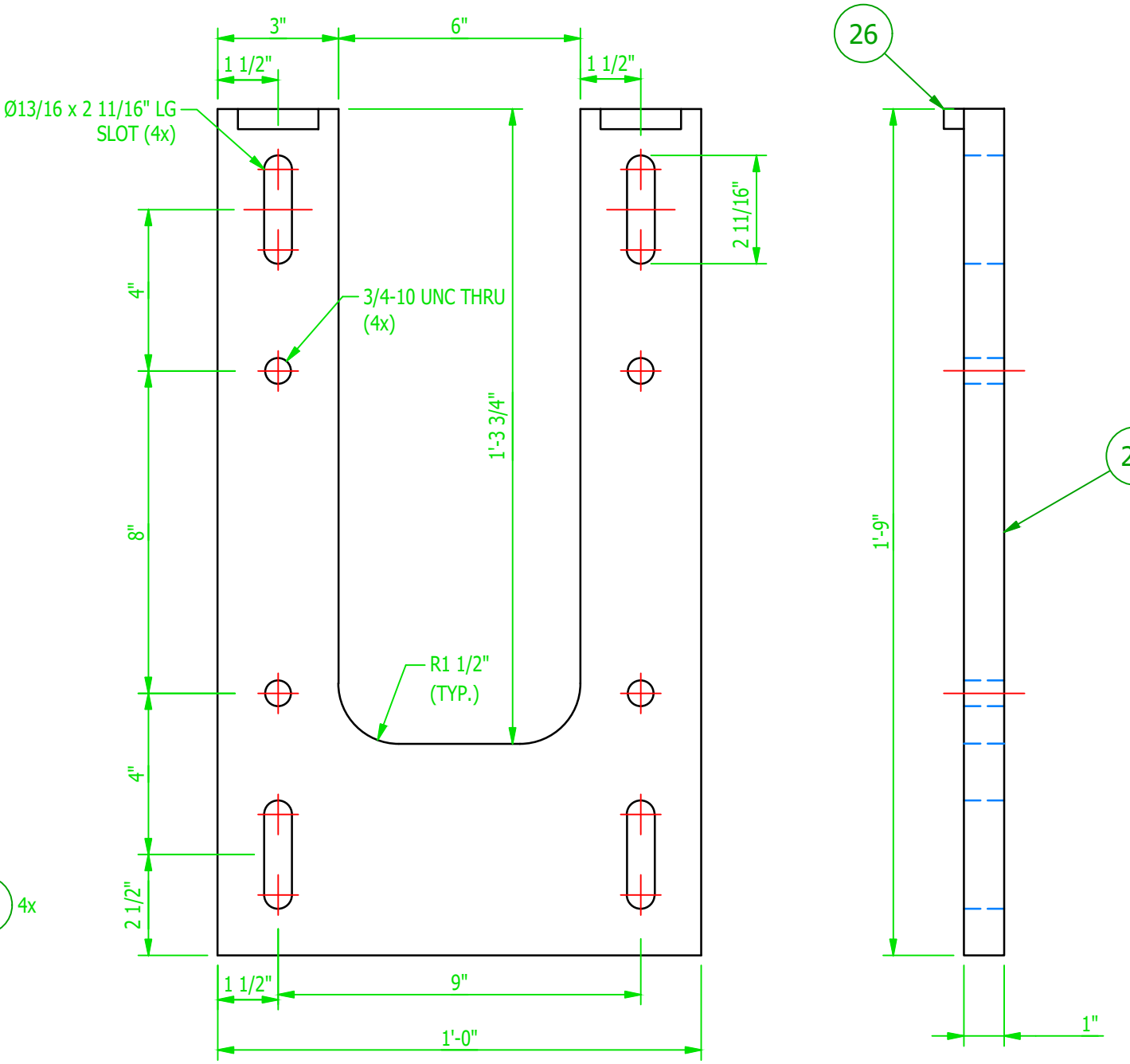
DETAIL ITEM '15'
SCALE 3"=1'-0"



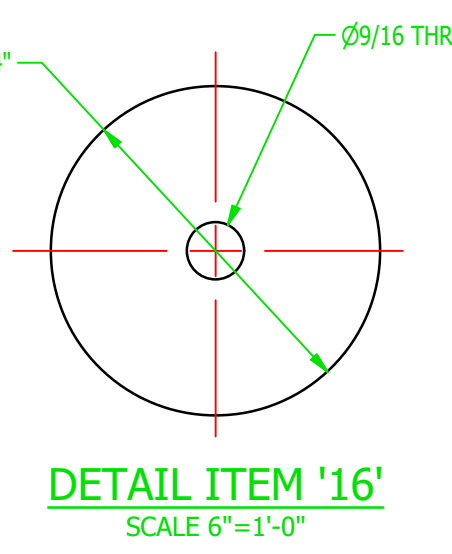
SECTION 'G-G'
SCALE 3"=1'-0"



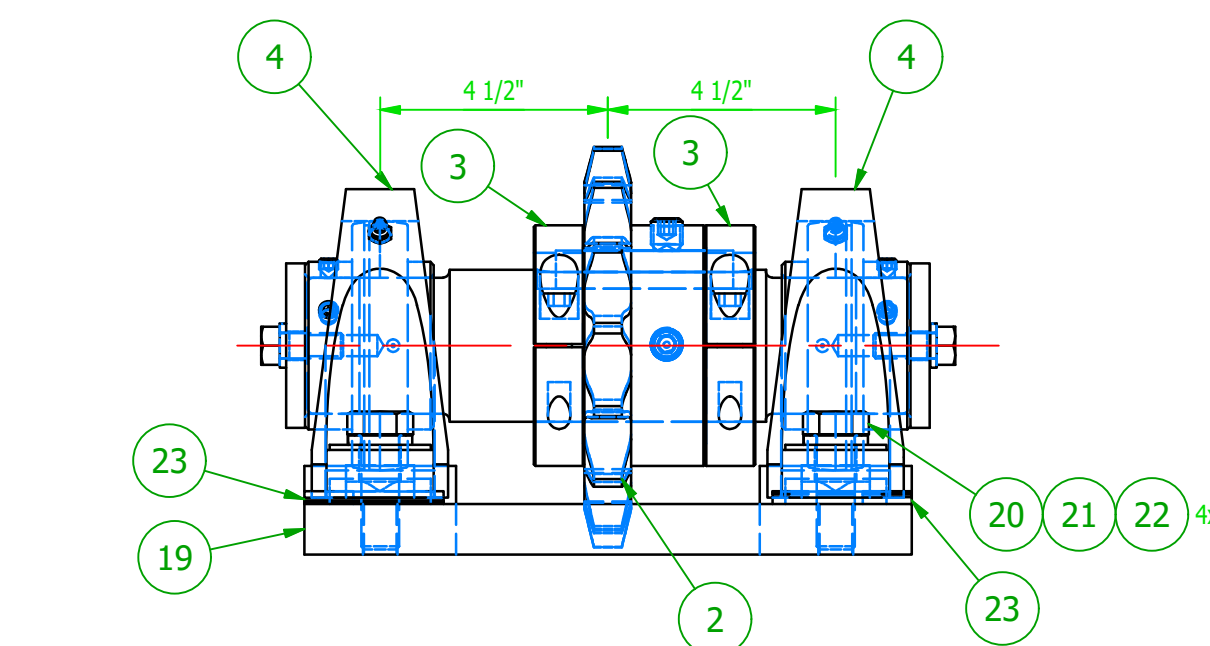
ENLARGED VIEW 'F'
SCALE 6"=1'-0"
COUPLING COVER AND CHAIN NOT SHOWN FOR CLARITY



MK-D492C ~ LIFT SHAFT PLATE ASSY
SCALE 3"=1'-0"



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



MK-D492B ~ IDLER SHAFT ASSY
SCALE 3"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D492A			
1	1	BAR Ø3 3/4 (1045 CRS)	6'-10"		
2	2	RC-120 15T SPROCKET TYPE B SS OVER KEY AND SS AT 90 DEG ~ HARD TEETH, 3" BORE		28-3	
3	4	CLAMP COLLAR WITH KEYWAY ~ STAFFORD 2L300HDK 3" DIAM		28-1	
4	2	DODGE SC PILLOWBLOCK 2 11/16 DIAM, P2B-SC-211, 123839		28-5	
5	1	DODGE 8018 CHAIN CPLG W/ 099029 COVER 2 3/8 BORE, 70MM BORE SS AT KEY AND AT 90 DEG		28-4	
6	2	3/4 x 3/4 x 3 1/2 LG. SQ. KEYSTOCK			
7	1	5/8 x 5/8 x 2 1/2 LG. SQ. KEYSTOCK			
8	2	5/8-11UNC x 5/8" LG. HEX SOCKET CUP POINT SET SCREW			
9	2	5/8-11UNC x 1/2" LG. HEX SOCKET CONE POINT SET SCREW			
10	2	5/8-11UNC x 7/8" LG. HEX SOCKET OVAL POINT SET SCREW			
11	4	3/8-16UNC x 3/8" LG. HEX SOCKET CONE POINT SET SCREW			
12	2	1/2-13UNC x 1/2" LG. HEX SOCKET CUP POINT SET SCREW			
13	2	1/2-13UNC x 5/8" LG. HEX SOCKET CONE POINT SET SCREW			
14	4	1/2-13UNC x 5/8" LG. HEX SOCKET OVAL POINT SET SCREW			
		MK-D492B			
2	1	RC-120 15T SPROCKET TYPE B SS OVER KEY AND SS AT 90 DEG ~ HARD TEETH, 3" BORE		28-3	
3	2	CLAMP COLLAR WITH KEYWAY ~ STAFFORD 2L300HDK 3" DIAM		28-1	
4	2	DODGE SC PILLOWBLOCK 2 11/16 DIAM, P2B-SC-211, 123839		28-5	
6	1	3/4 x 3/4 x 3 1/2 LG. SQ. KEYSTOCK			
8	1	5/8-11UNC x 5/8" LG. HEX SOCKET CUP POINT SET SCREW			
9	1	5/8-11UNC x 1/2" LG. HEX SOCKET CONE POINT SET SCREW			
10	1	5/8-11UNC x 7/8" LG. HEX SOCKET OVAL POINT SET SCREW			
11	4	3/8-16UNC x 3/8" LG. HEX SOCKET CONE POINT SET SCREW			
15	1	BAR Ø3" (1045 CRS)	11 7/8"		
16	2	PL 3/8 x 3 1/4"	3 1/4"		
17	2	1/2 SPRING LOCK WASHER			
18	2	1/2-13UNC x 1 1/4" LG. HEX HEAD BOLT			
19	1	MK-D492C ~ LIFT SHAFT PLATE ASSY			
20	4	3/4 TYPE B REGULAR FLAT WASHER			
21	4	3/4 SPRING LOCK WASHER			
22	4	3/4-10UNC x 2 1/4" LG. HEX HEAD CAP SCREW			
23	2	MK-D491B ~ SHIM PACK			
24	2	SQ. BAR 3/4"	3"		
		MK-D492C			
25	1	PL 1 x 1'	1'-9"		
26	2	PL 1/2 x 1/2"	2"		

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

A	MC	11/14/22	FOR FABRICATION	
REV	BY	DATE	DESCRIPTION	APP

MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
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<p>TITLE: P6700 CONVEYORS CAMPUS BUILDING</p> <p>CLIENT: VOLVO</p> <p>DRAWING No.: 1875D492</p>	<p>DRAWN BY: WOOD</p> <p>CHECKED BY:</p> <p>DWG DATE: 10/27/22</p> <p>REV: A</p> <p>JOB No.: 22096</p>
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GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

- ALL WELDS TO BE "E70XX", (PER AWS D1.1)
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.
- COPIES: - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

MAGNUM CONSULTING

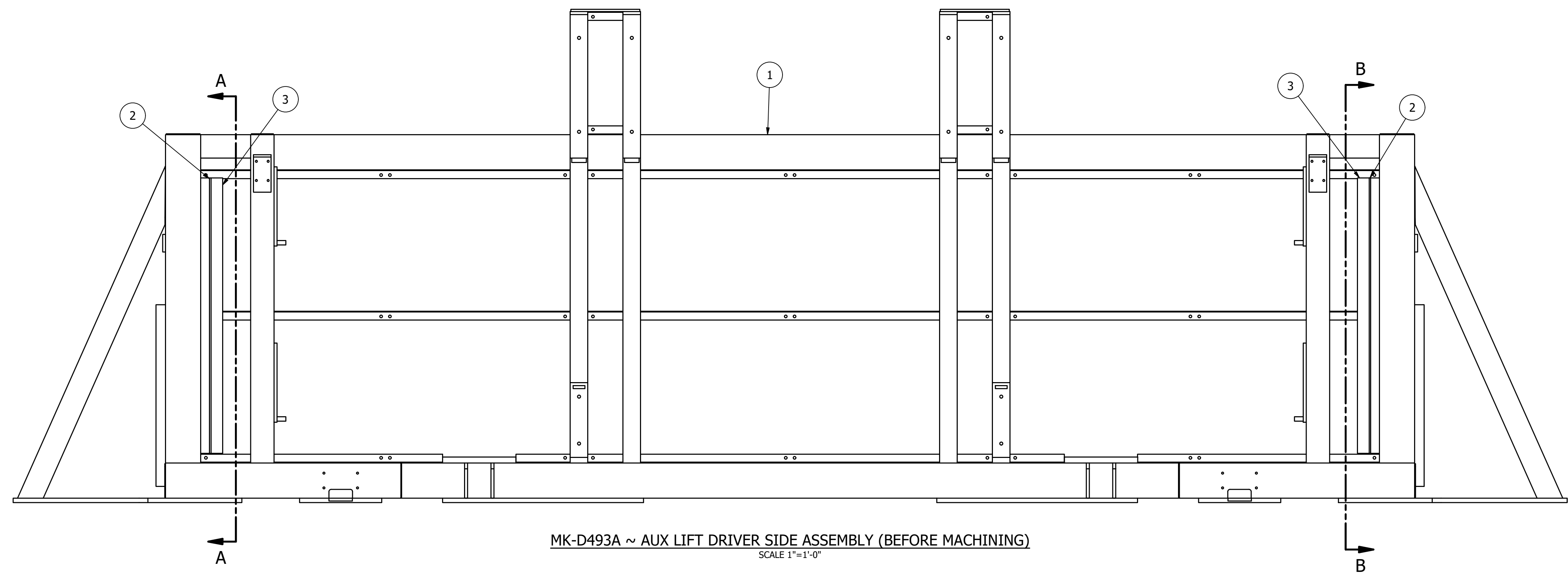
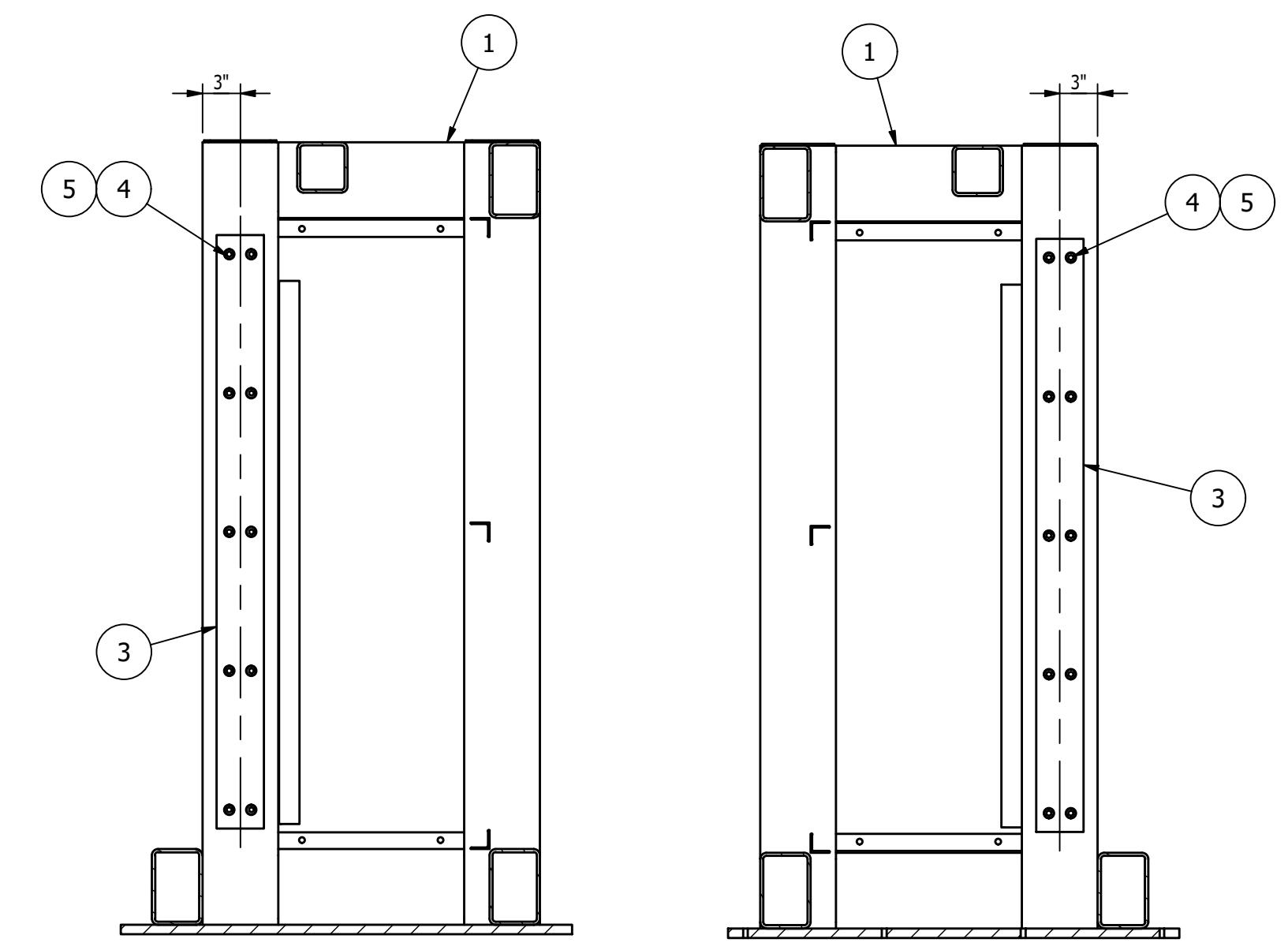
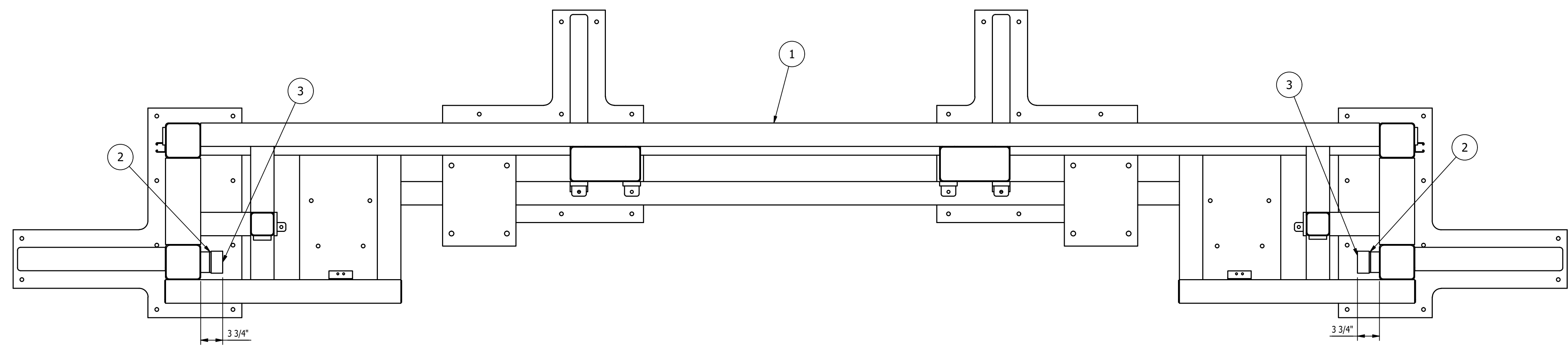
41700 Gardenbrook Rd. Fenton, MI 48430
41700 Gardenbrook Rd. Fenton, MI 48430
Phone: (481) 773-8000 Fax: (481) 773-8001
www.Magnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D492

UNLESS OTHERWISE NOTED:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D493A			
1	1	MK-D475A ~ PASSENGER SIDE FRAME WELDMENT			
2	2	MK-D483C ~ GUIDE BAR SPACER			
3	2	MK-D483D ~ GUIDE BAR			
4	20	1/2 HIGH COLLAR SPRING LOCK WASHER			
5	20	1/2-13UNC x 2 3/4" LG. HEX SOCKET HEAD CAP SCREW			



MK-D493A ~ AUX LIFT DRIVER SIDE ASSEMBLY (BEFORE MACHINING)
SCALE 1"=1'-0"

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY

	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
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TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D493	DWG DATE: 11/9/22
REV: A	JOB No: 22096

MAGNUM Consulting
41100 Charleston Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8829
Fax: (248) 772-8851
Web: www.mmagnum.com

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

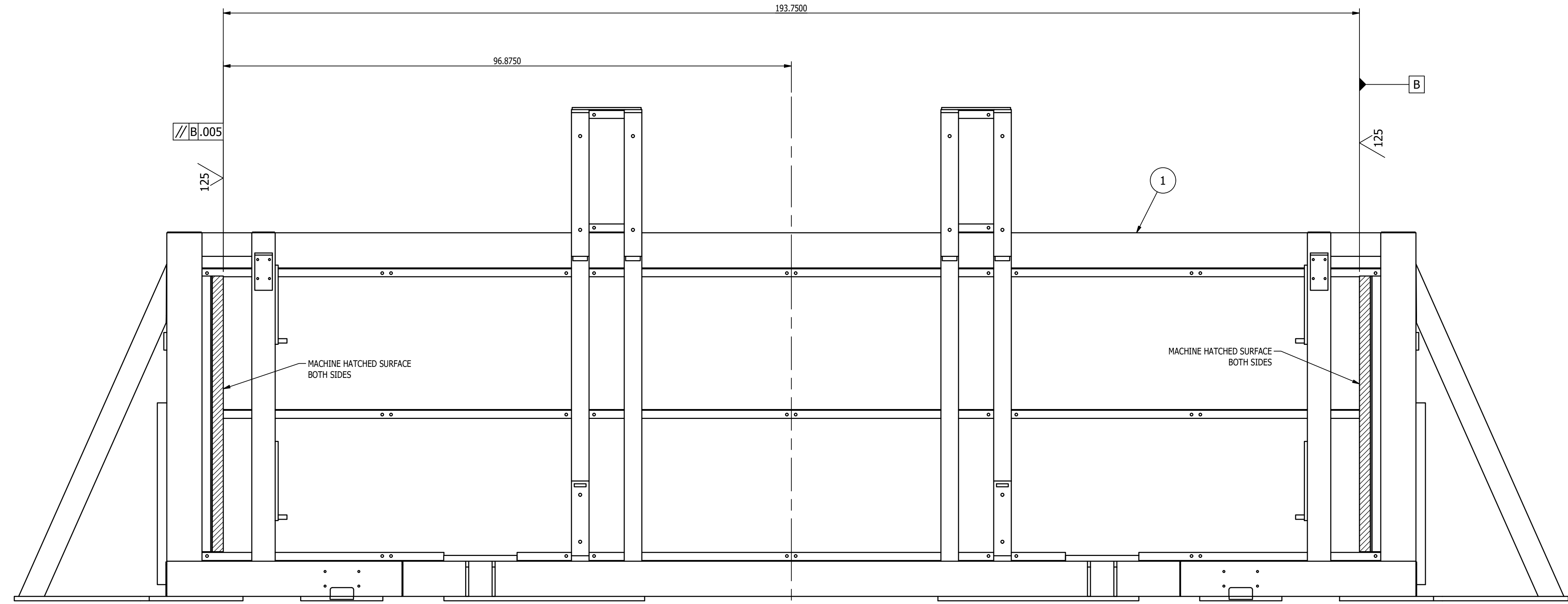
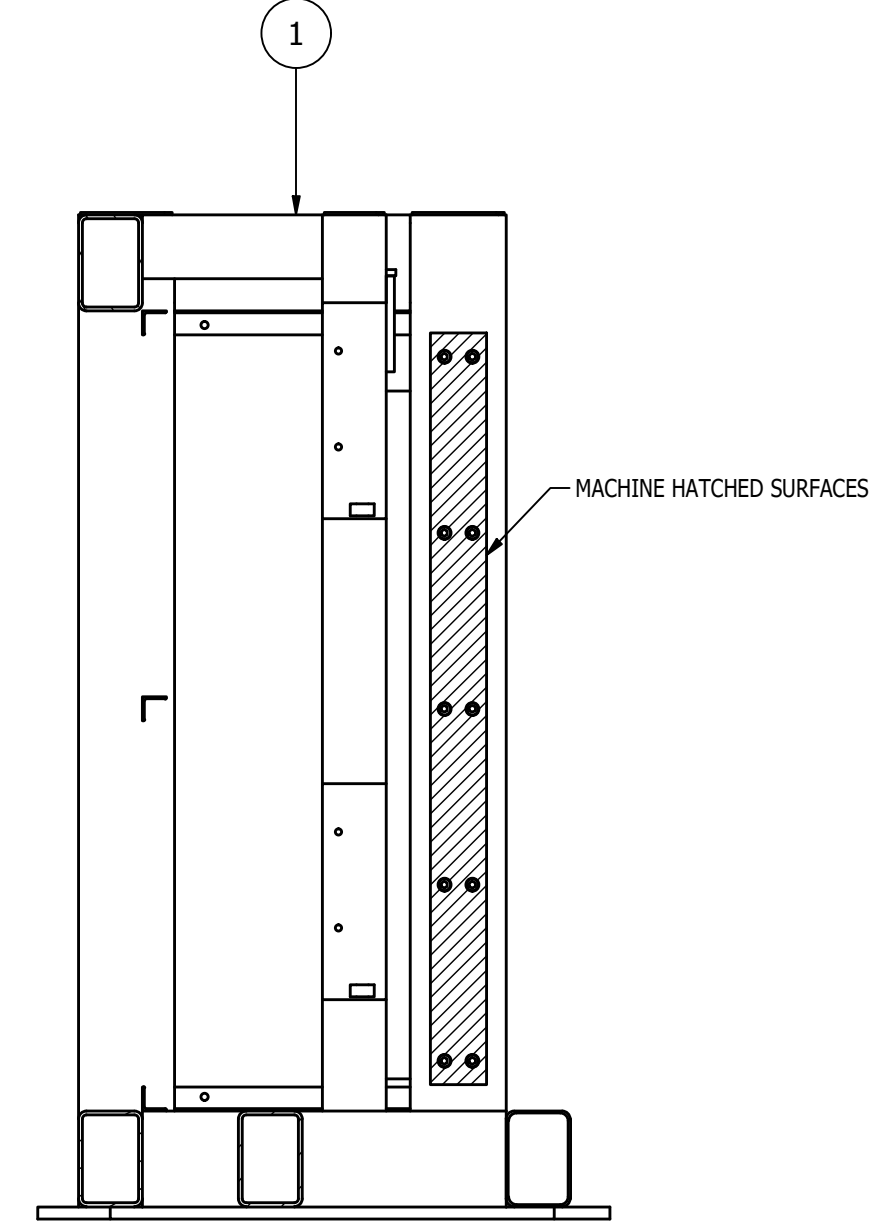
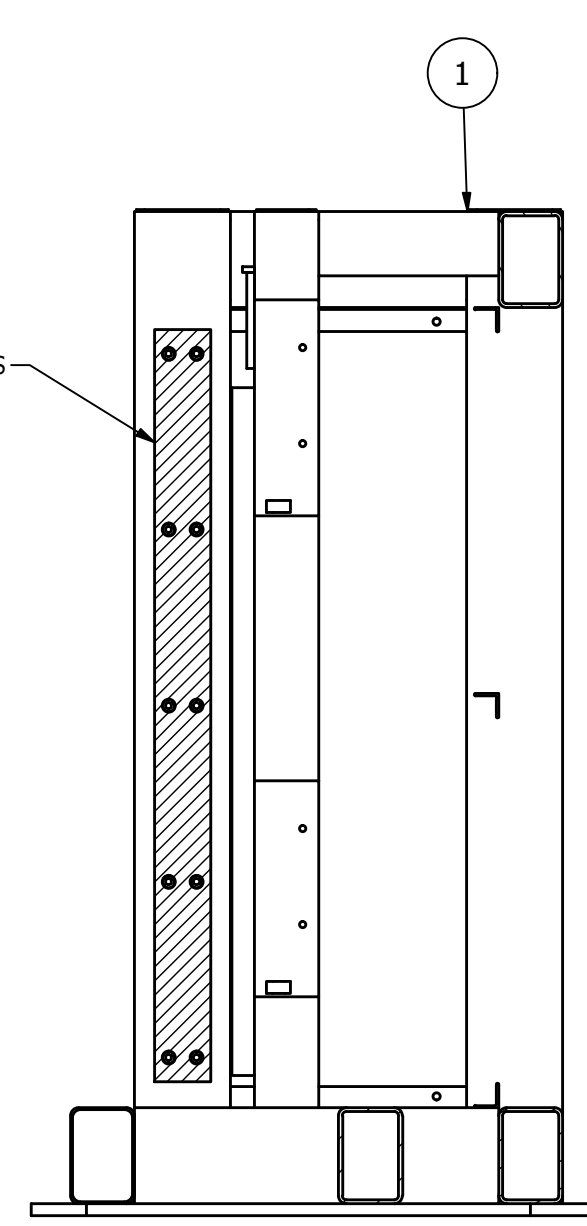
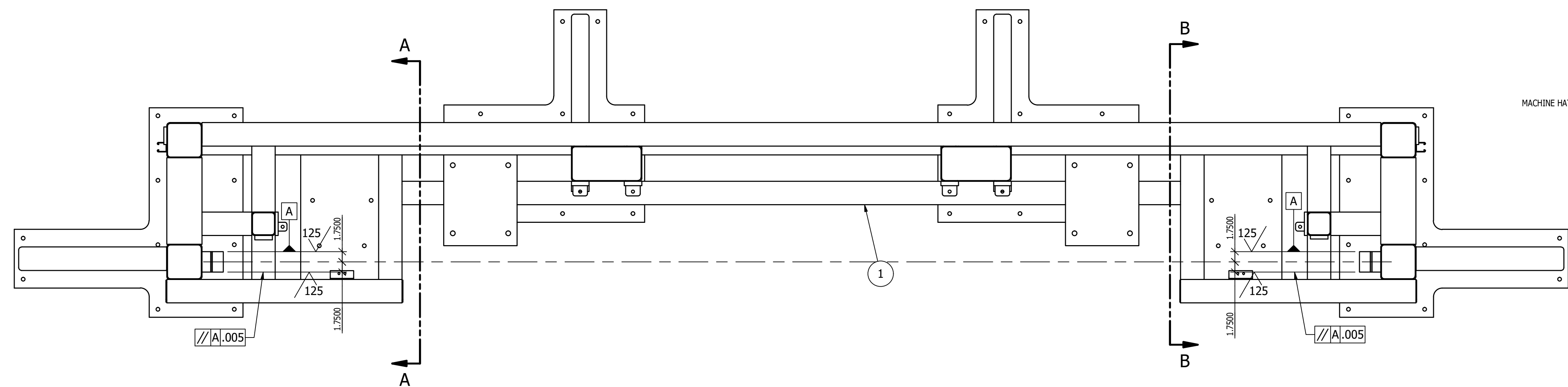
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

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

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D494A			
		MK-D493A ~ AUX LIFT DRIVER SIDE ASSEMBLY (BEFORE MACHINING)			



- 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-D494A ~ AUX LIFT PASSENGER SIDE FRAME MACHINING
SCALE 1"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: RJB	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 11/9/22	
DRAWING No. 1875D494		JOB No: 22096	
REV: A			

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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

MAGNUM CONSULTING

41100 Clarkston Rd.
Suite 125
North, MI 48075

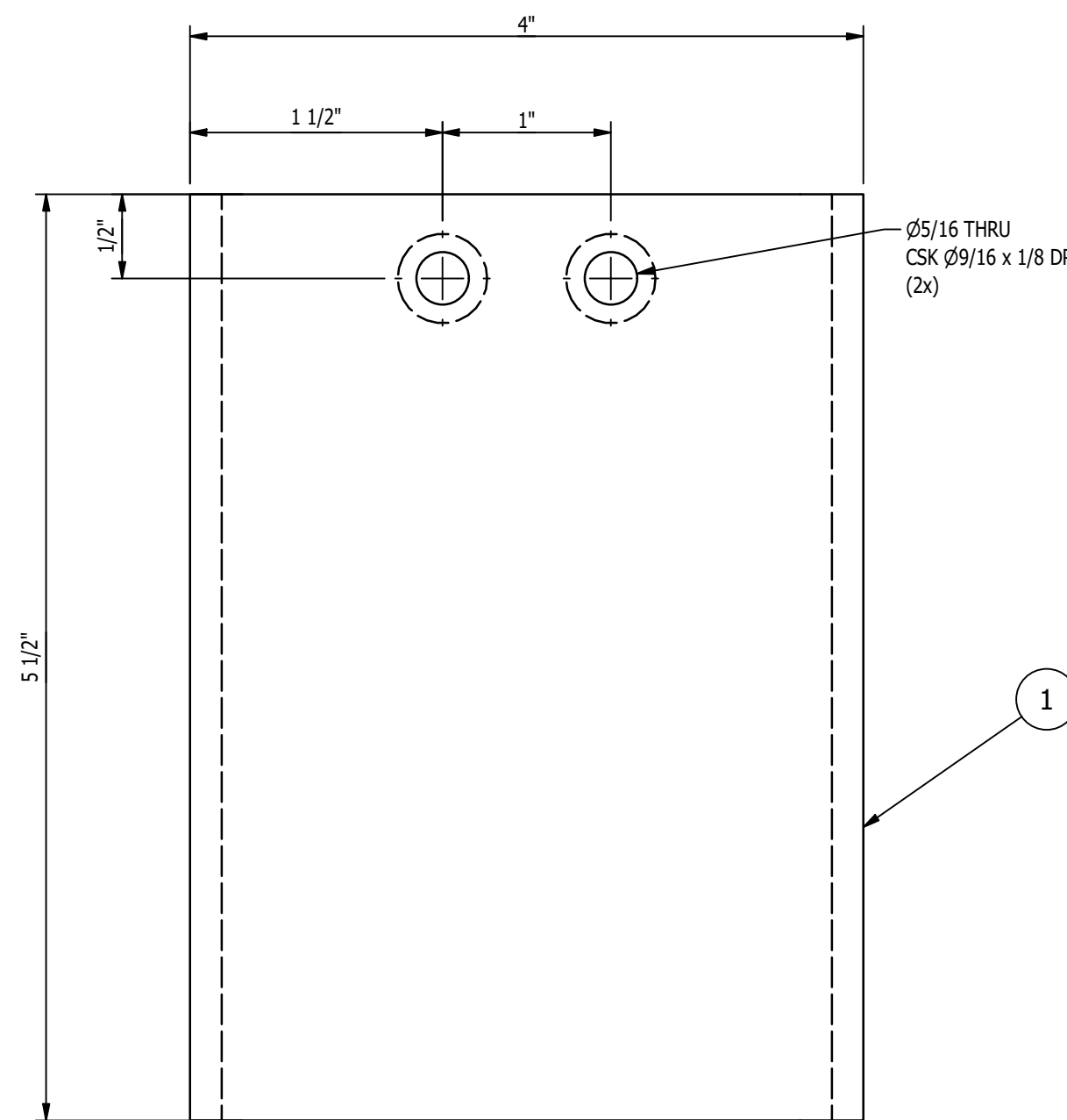
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D494 - REV A

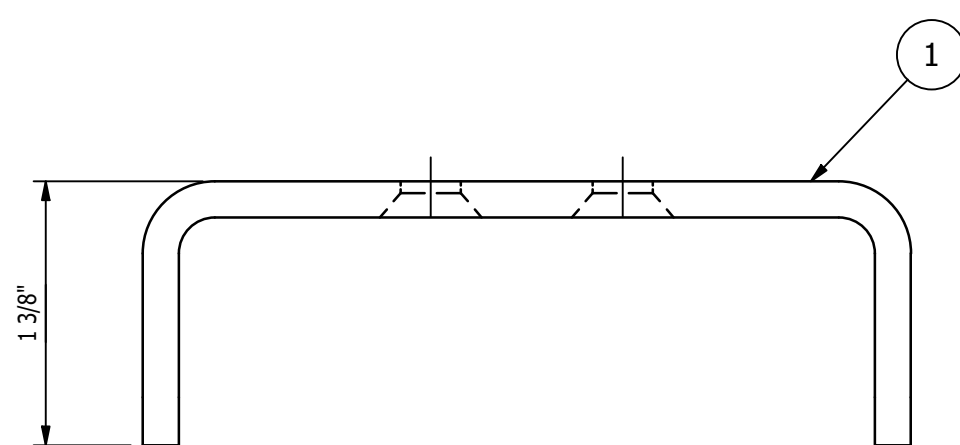
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°30'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D495A			
1	1	FIBERGLASS C4 x 1.375 x 0.1875	5 1/2"		
		MK-D495B			
2	1	UHMW SHEET 1/16 x 9	9 1/2"		

B



MK-D495A ~ BELT GUARD
SCALE 1'-0" = 1'-0"



MK-D495B ~ UHMW SHEET
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:
DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	CORRECTED LENGTH OF ITEM '1' IN BOM	
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

MATERIALS:

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

HOLES:

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

WELDS:

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

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

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



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

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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D495	DWG DATE:	11/14/22
REV:	B	JOB No:	22096

MAGNUM CONSULTING

41100 QuakerRoad Rd.
Suite 125
North, MI 48375

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Web: www.mmagnum.com

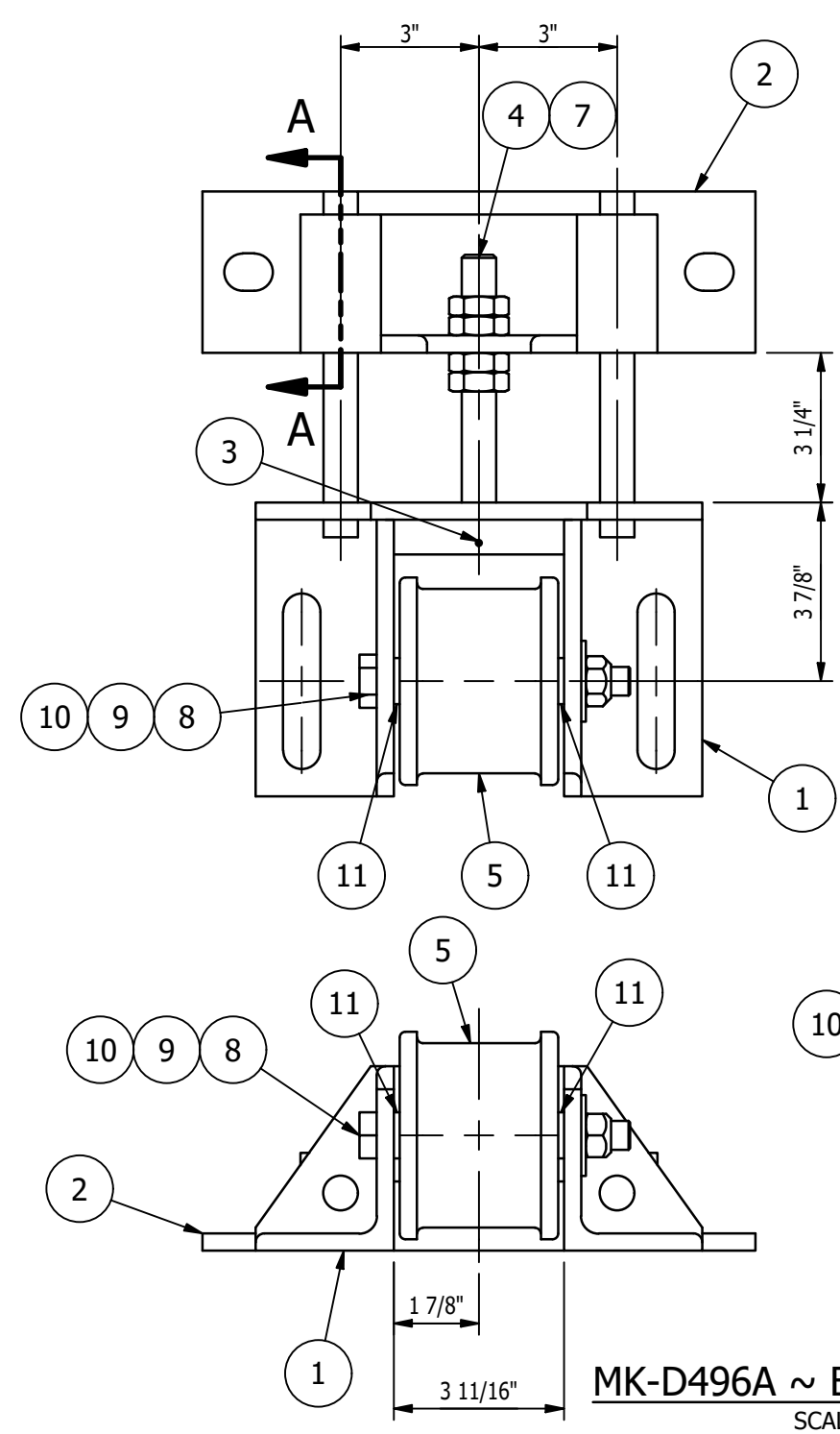
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D495 - REV B

UNLESS OTHERWISE NOTED:

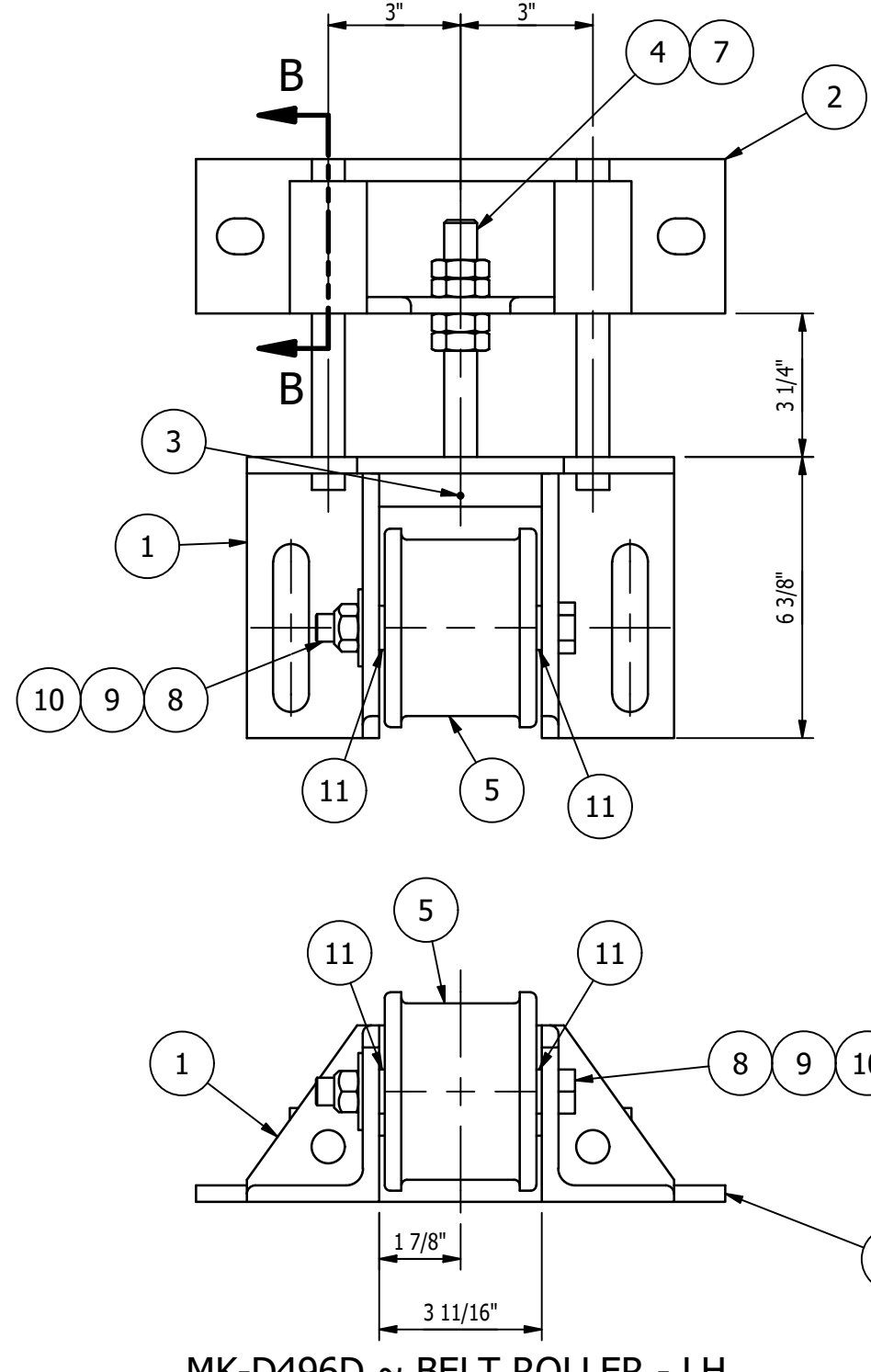
X = ±.060
XX = ±.030
XXX = ±.005

FRACTIONS = ±1/16"
ANGLES = ±1°30'

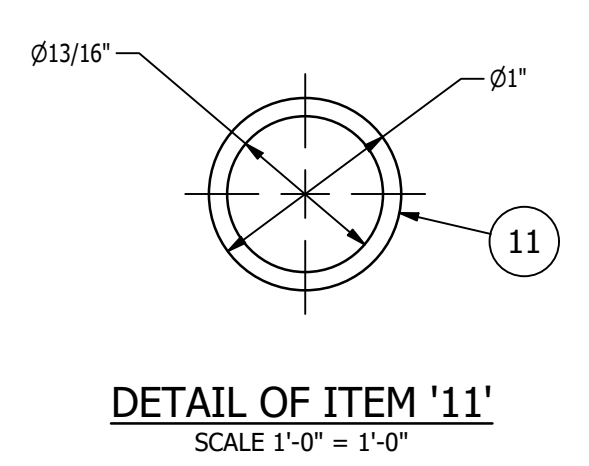
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



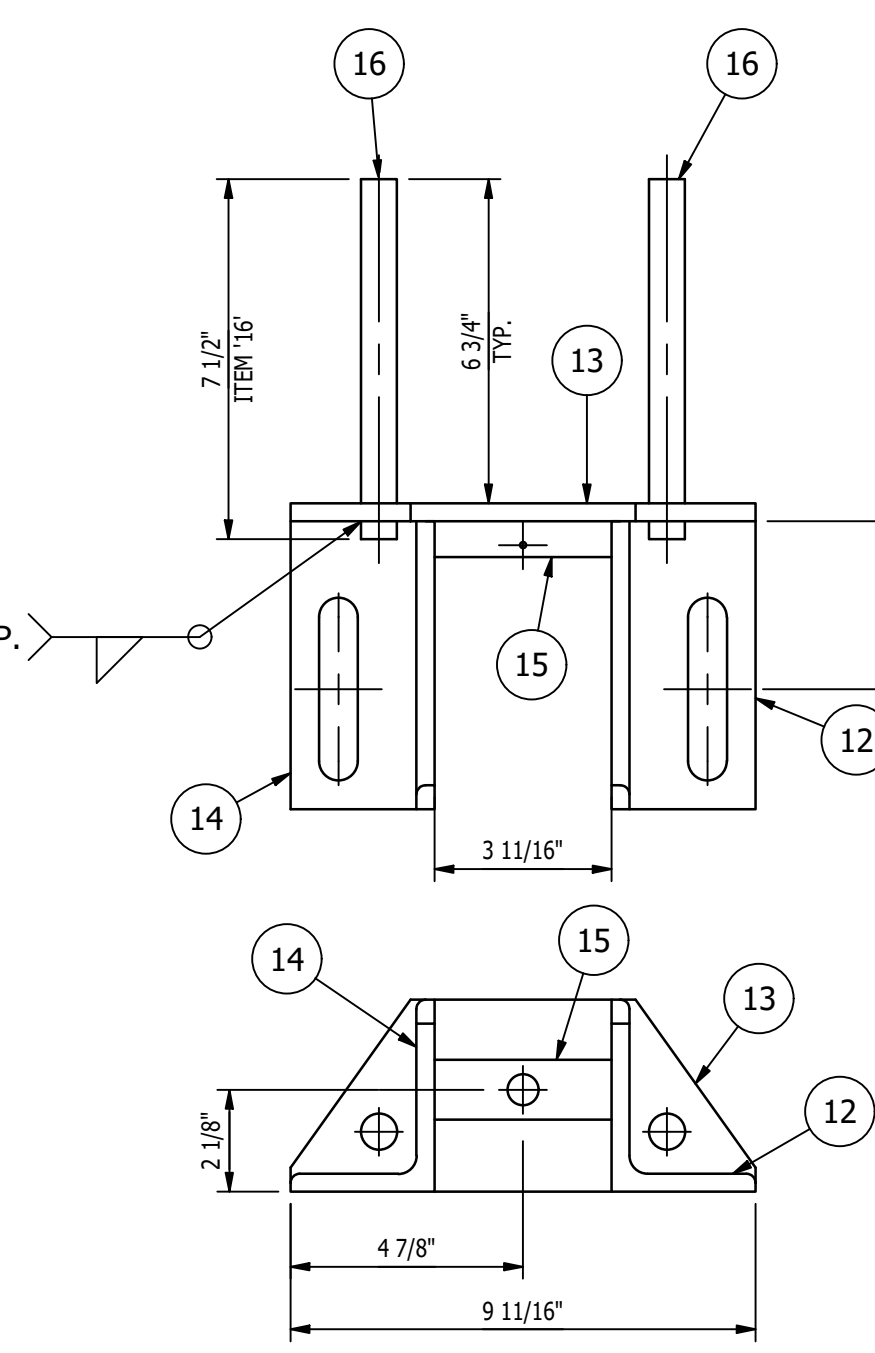
SECTION 'A-A'
SCALE 3"=1'-0"



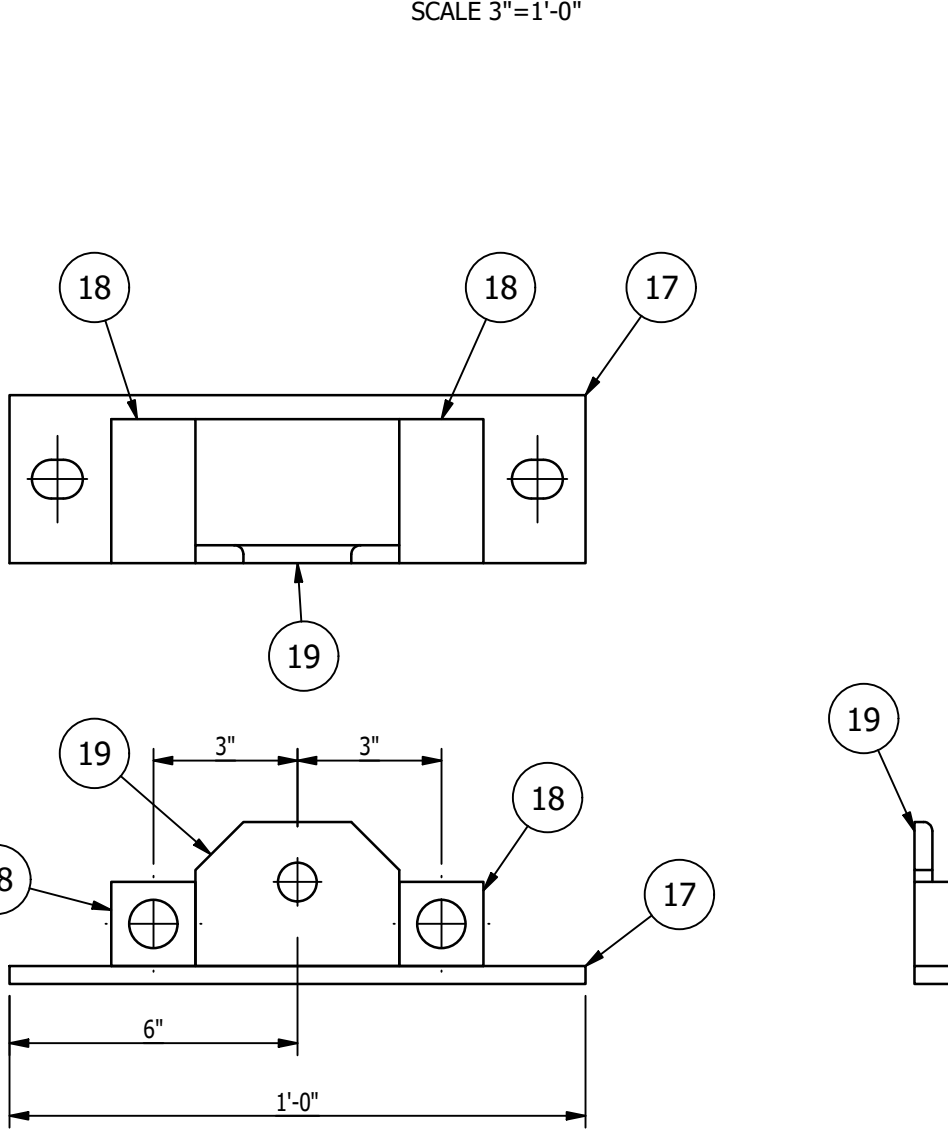
SECTION 'B-B'
SCALE 3"=1'-0"



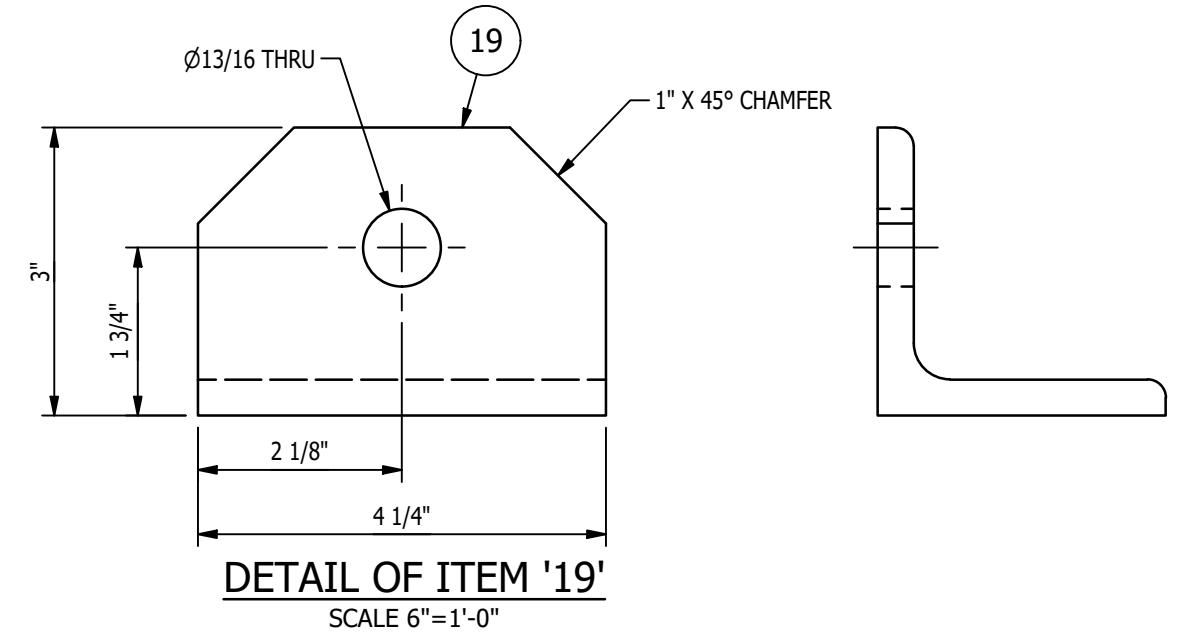
DETAIL OF ITEM '11'
SCALE 1'-0" = 1'-0"



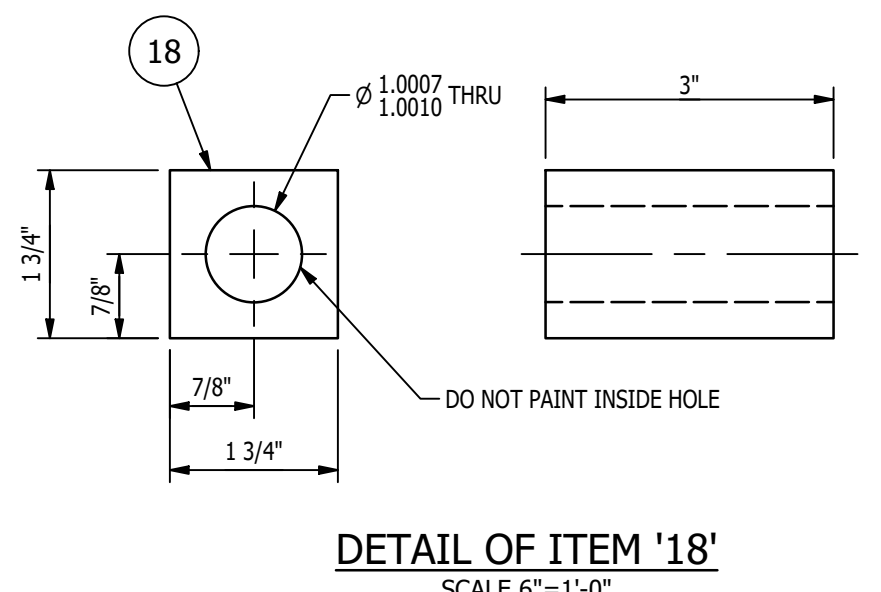
MK-D496B ~ PASSENGER SIDE BELT ROLLER WELDMENT
SCALE 3"=1'-0"



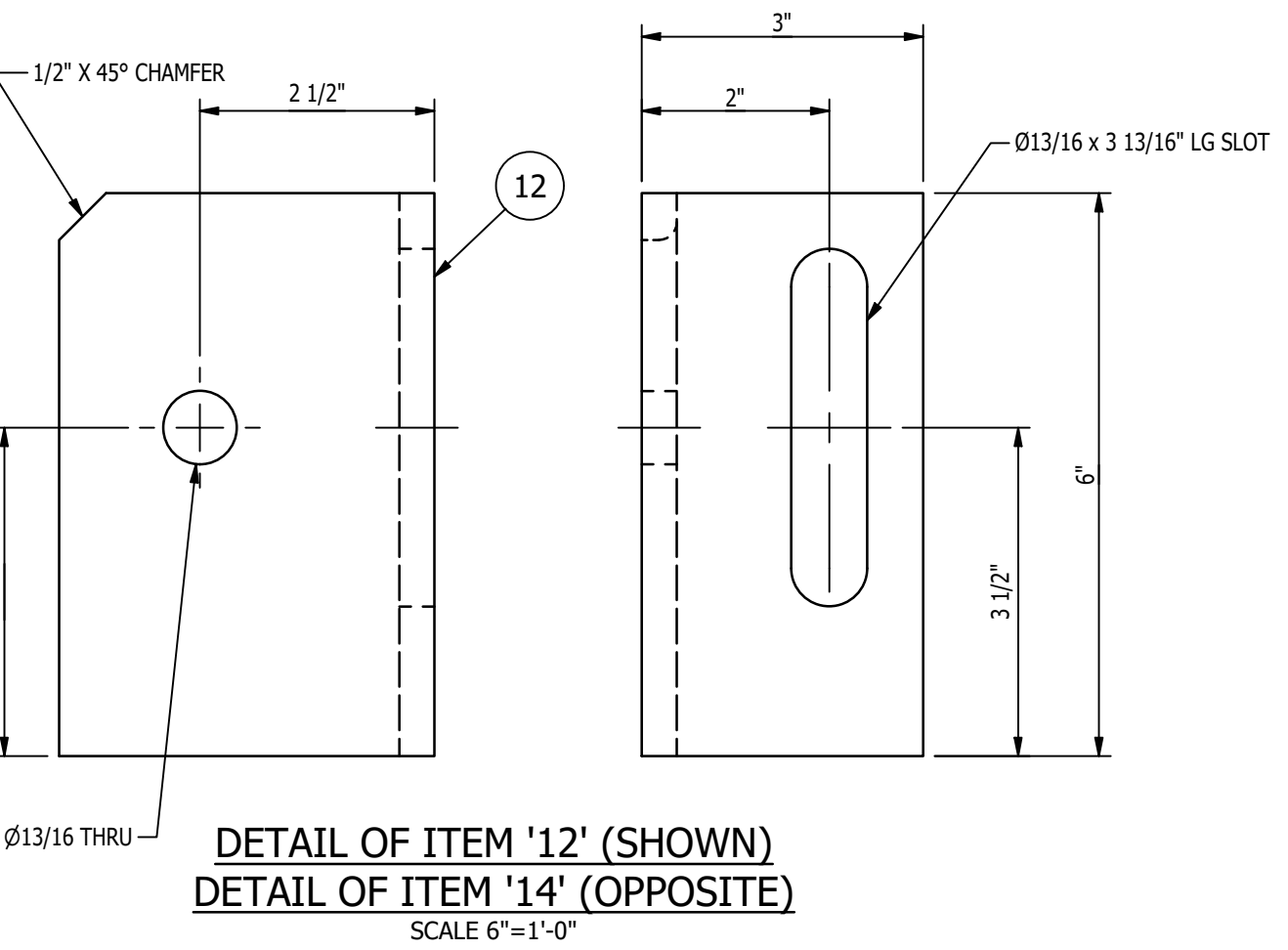
MK-D496C ~ PASSENGER SIDE BELT ROLLER ASSEMBLY
SCALE 3"=1'-0"



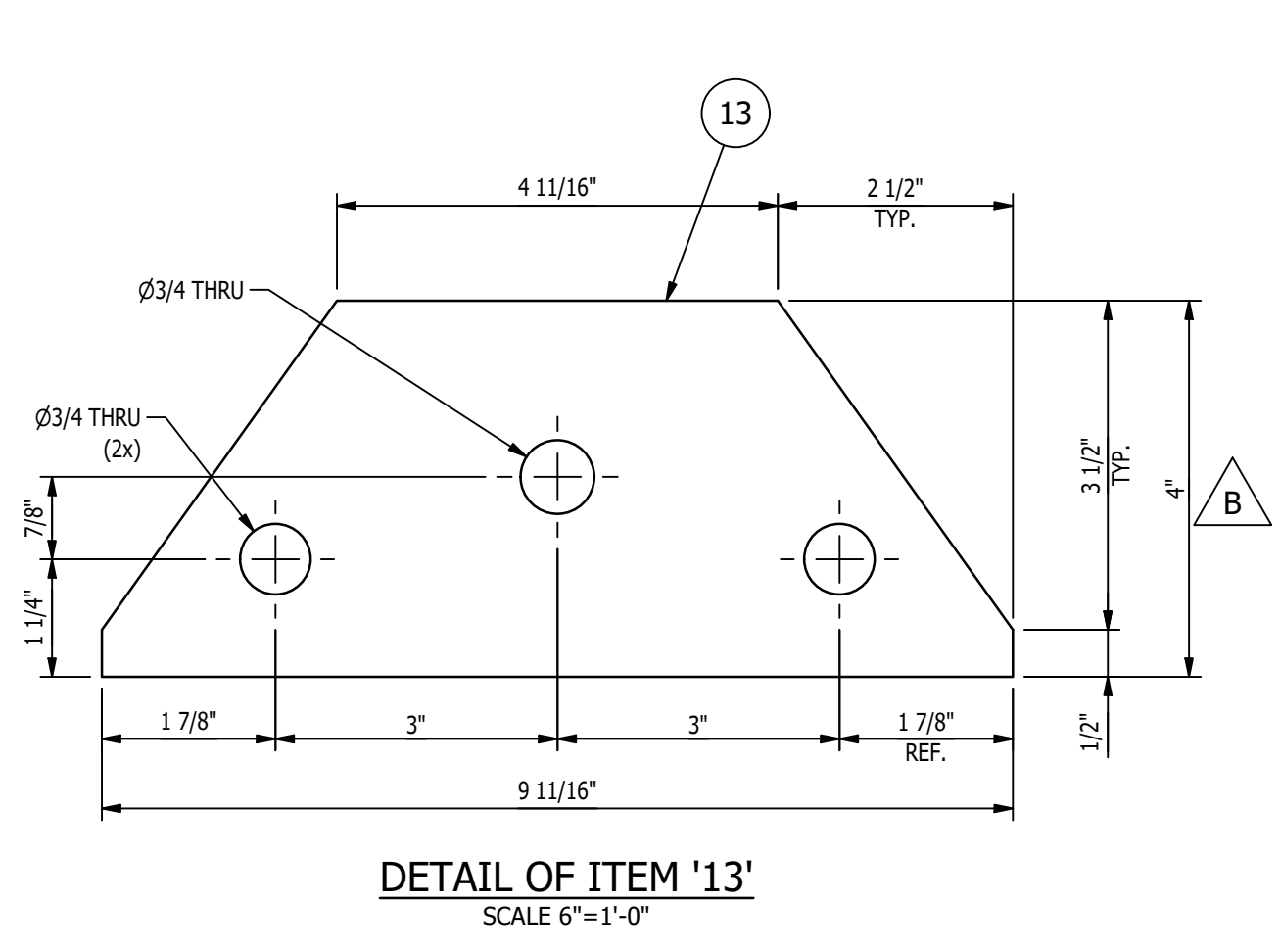
DETAIL OF ITEM '19'
SCALE 6"=1'-0"



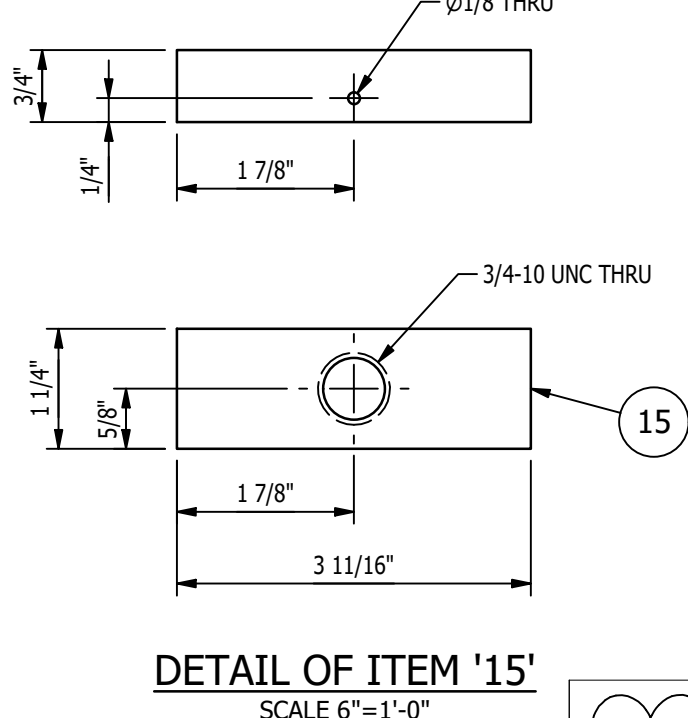
DETAIL OF ITEM '18'
SCALE 6"=1'-0"



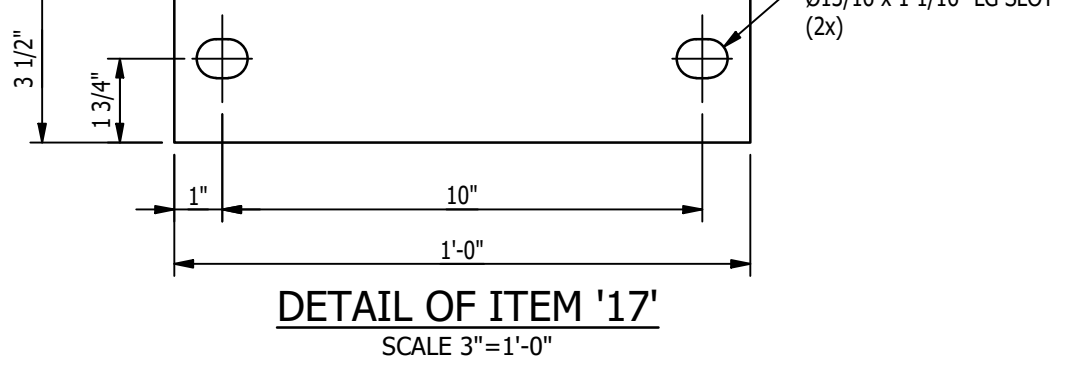
DETAIL OF ITEM '12' (SHOWN)
DETAIL OF ITEM '14' (OPPOSITE)
SCALE 6"=1'-0"



DETAIL OF ITEM '13'
SCALE 6"=1'-0"



DETAIL OF ITEM '15'
SCALE 6"=1'-0"



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D496A ~ PASSENGER SIDE BELT ROLLER WELDMENT			
2	1	MK-D496C ~ PASSENGER SIDE BELT ROLLER ASSEMBLY			
3	1	1/8 x 1 1/2 LG. SLOTTED SPRING PIN			
4	1	THD. ROD 3/4-10UNC	6 1/2"		
5	1	MK-D488B ~ ROLLER			
6	4	PRESS FIT DRILL BUSHING, 3/4 ID, 1 OD, 1 1/2 LG, MCMASTER CARR PART NO. 8491A593		28-11	
7	4	3/4-10UNC HEX JAM NUT			
8	1	5/8 TYPE B REGULAR FLAT WASHER			
9	1	MK-D488C ~ ROLLER SHAFT			
10	1	5/8-11UNC STOVER LOCK NUT			
11	2	PL 1/8 x 1	1/8"		
MK-D496B					
12	1	L 4 x 3 x 3/8	6"		
13	1	PL 3/8 x 4"	9 11/16"		
14	1	L 4 x 3 x 3/8	6"		
15	1	PL 3/4 x 1 1/4"	3 11/16"		
16	2	BAR Ø3/4 (CRS)	7 1/2"		
MK-D496C					
17	1	PL 3/8 x 3 1/2"	1'-0"		
18	2	PL 1 3/4 x 1 3/4"	3"		
19	1	L 3 x 3 x 3/8	4 1/4"		
MK-D496D					
1	1	MK-D496B ~ PASSENGER SIDE BELT ROLLER WELDMENT			
2	1	MK-D496C ~ PASSENGER SIDE BELT ROLLER ASSEMBLY			
3	1	1/8 x 1 1/2 LG. SLOTTED SPRING PIN			
4	1	THD. ROD 3/4-10UNC	6 1/2"		
5	1	MK-D488B ~ ROLLER		28-11	
6	4	PRESS FIT DRILL BUSHING, 3/4 ID, 1 OD, 1 1/2 LG, MCMASTER CARR PART NO. 8491A593			
7	4	3/4-10UNC HEX JAM NUT			
8	1	5/8 TYPE B REGULAR FLAT WASHER			
9	1	MK-D488C ~ ROLLER SHAFT			
10	1	5/8-11UNC STOVER LOCK NUT			
11	2	PL 1/8 x 1	1/8"		

- 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
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 - ALL WELDS TO BE 3/16" / 5mm MINIMUM CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
 - ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 - MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 - ALL SLOT LENGTHS ARE END TO END U.N.O.

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/28/22	ADDED DIMENSION TO ITEM '13'	
A	MC	11/15/22	FOR FABRICATION	

REVISION HISTORY

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

TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

DRAWING No. 1875D496

REV: A

JOB No. 22096

DRAWN BY: RJB

CHECKED BY: CW

DWG DATE: 11/7/22

MAGNUM CONSULTING
4110 Quakerwood Rd.
Suite 125
West, MI 48375

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D496 - REV B

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

GENERAL NOTES:

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

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

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

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

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