

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D400A			
1	2	MK-D402A ~ FRONT FORK DETAIL MOUNTING PLATE			
2	2	MK-D405A ~ FRONT FORK DETAIL ASSEMBLY			
3	2	MK-D407A ~ MIDDLE FORK DETAIL ASSEMBLY			
4	4	MK-D408A ~ FORK DETAIL MOUNTING PLATE			
5	1	MK-D417A ~ REAR FORK DETAIL ASSEMBLY, L.H.			
6	1	MK-D417B ~ REAR FORK DETAIL ASSEMBLY, R.H.			
7	6	MK-D419A ~ SHIM PACK			
8	2	MK-D419B ~ SHIM PACK			
9	2	MK-D419C ~ SHIM PACK			
10	1	MK-D421 ~ EUROFORK TELESCOPIC FORKS, MODEL SD200x100A		19-1	
11	24	M12x1.75 x 65mm LG. HEX CAP SCREW			
12	24	M12 SPRING LOCK WASHER			
13	24	M12 NARROW FLAT WASHER			
14	24	M12 x 1.75 HEX NUT			
17	24	3/8-16UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
18	24	3/8 SPRING LOCK WASHER			
19	24	3/8 TYPE B WIDE FLAT WASHER			
21	24	M10x1.5 x 25mm LG. HEX CAP SCREW			
22	24	M10 SPRING LOCK WASHER			
23	24	M10 REGULAR FLAT WASHER			
24	6	1/4 x 5/8 LG. SLOTTED SPRING PIN			
25	6	1/4 x 1 1/4 LG. SLOTTED SPRING PIN			
26	2	MK-D419E ~ SHIM PACK			
27	4	M8 SPRING LOCK WASHER, ZP			
28	4	M8x1.25 x 35mm LG. HEX HEAD CAP SCREW, CLASS 8.8, PLAIN			
29	1	FT1 GEARMOTOR PER MOTOR DATA SHEET		1-7	

- 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.

REV	BY	DATE	DESCRIPTION	APP
C	MC	11/28/22	ADDED ITEMS '27' THRU '29', ADDED VIEW 'B-B'	
B	MC	11/8/22	REVISED ITEMS '1' & '2', ADDED ITEM '26', QTY. ITEM '8' WAS (4), NOW (2)	
A	MC	10/21/22	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.

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.: 1875D400

REV: C

DRAWN BY: RPM
CHECKED BY: CW
DWG DATE: 8/30/22
JOB No.: 22096

MAGNUM Consulting
 41100 QuakerRoad Rd.
 Suite 125
 Novi, MI 48275

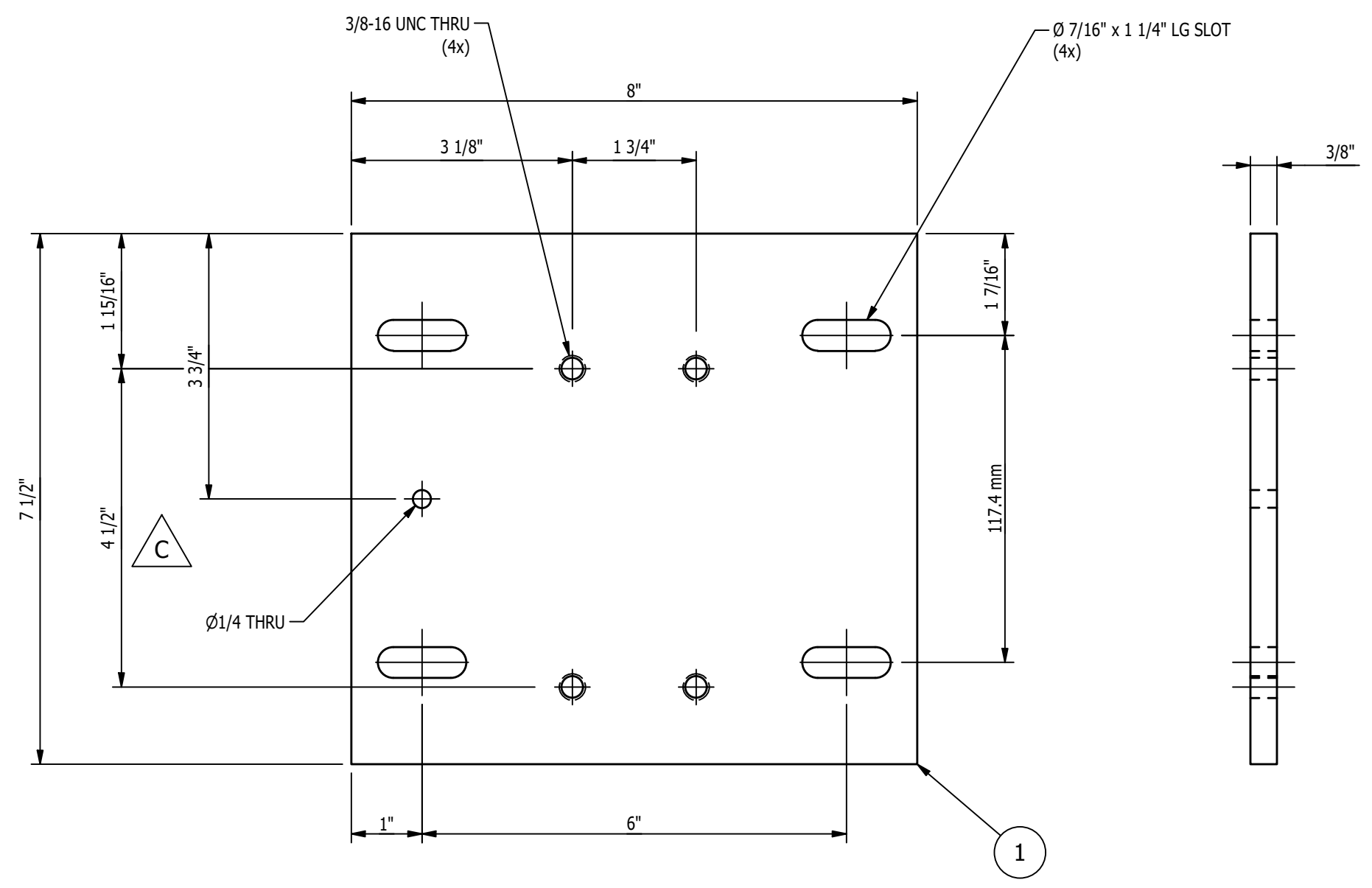
Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D400

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-D400A ~ FORK ASSEMBLY
 SCALE 1"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D402A			
1	1	BAR 3/8 x 7.5	8"		



MK-D402A ~ FRONT FORK DETAIL MOUNTING PLATE
SCALE 6"=1'-0"


SHOP NOTES:


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

PAINT NOTES:

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

REV	BY	DATE	DESCRIPTION	APP
C	MC	11/8/22	REVISED HOLE PATTERN	
B	MC	11/1/2022	UPDATED HOLE SIZE, DIM	
A	MC	10/21/22	FOR FABRICATION	

 MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		<small>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</small>
TITLE: P6700 CONVEYORS CAMPUS BUILDINGN		DRAWN BY: SGS
CLIENT: VOLVO		CHECKED BY: CW
DRAWING No. 1875D402		DWG DATE: 8/29/2022
REV: C		JOB No: 22096



41100 Charleston Rd.
Suite 125
North, MI 48175

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D402

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:

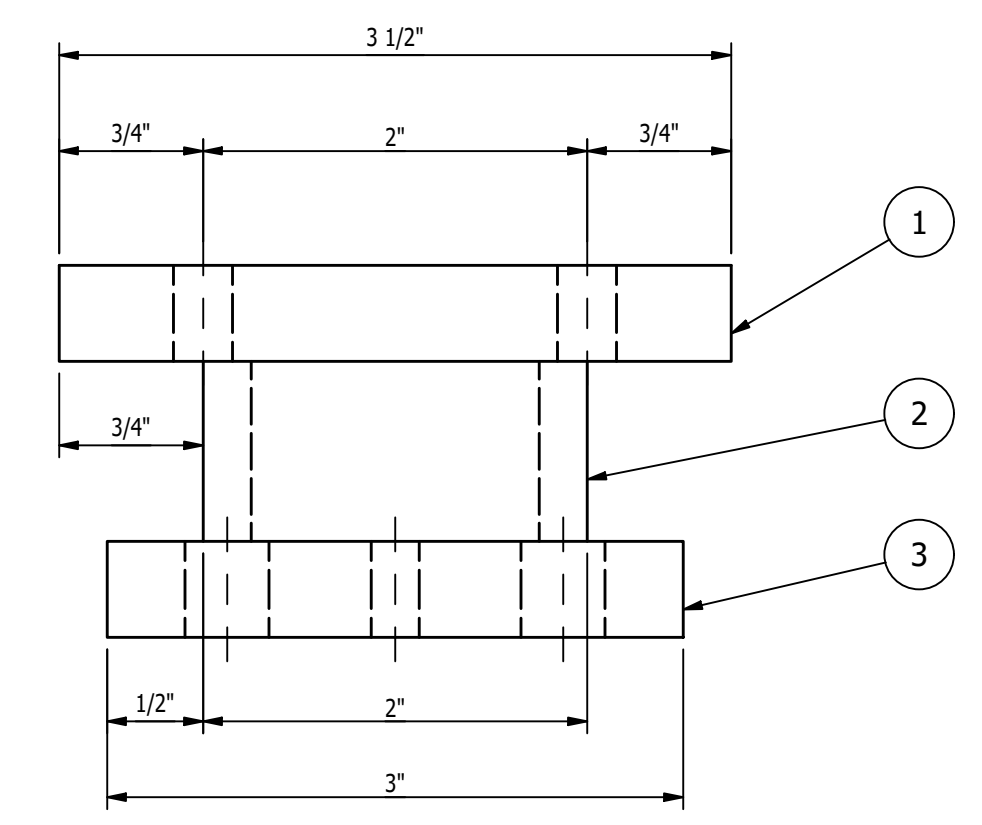
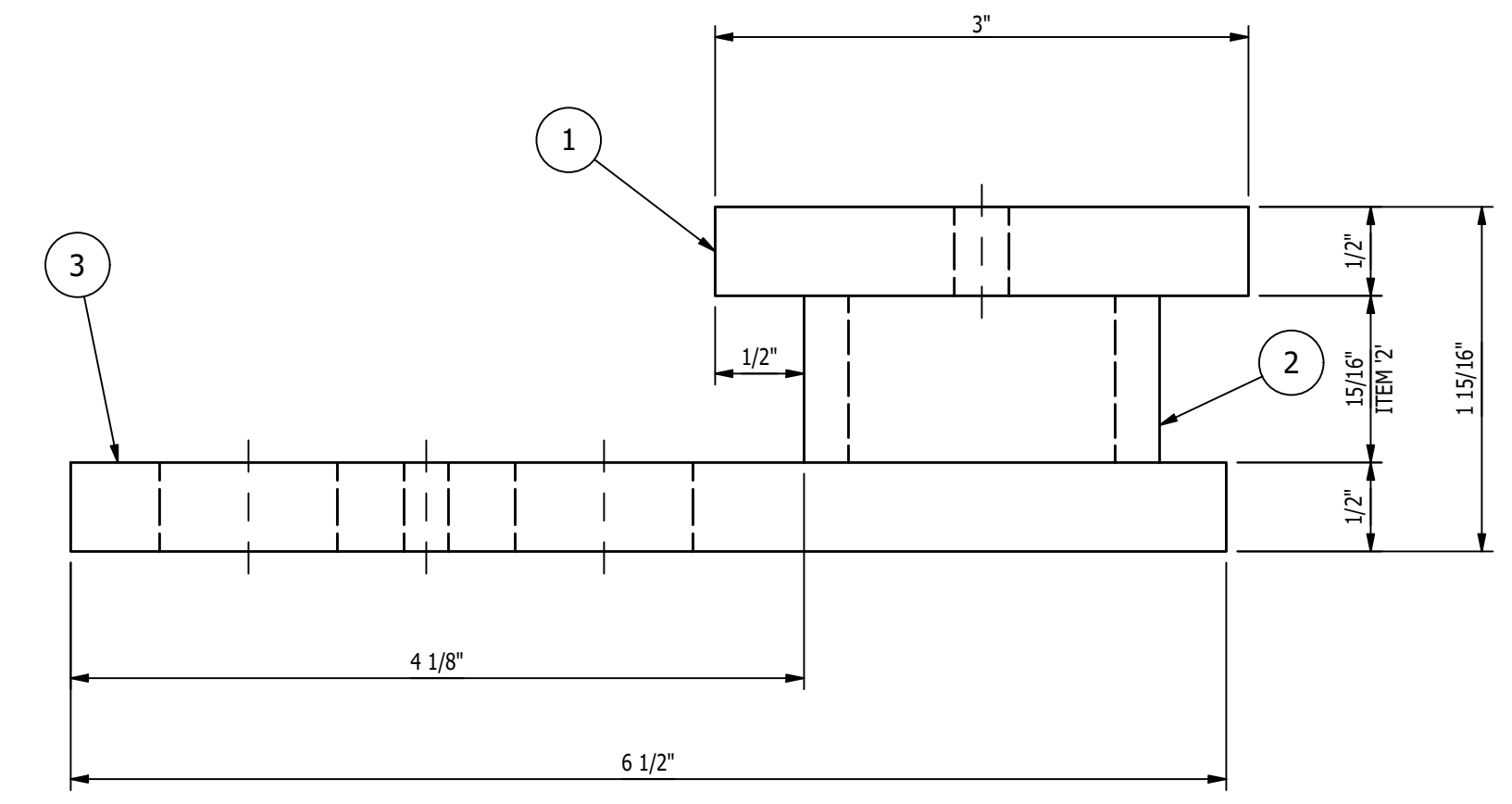
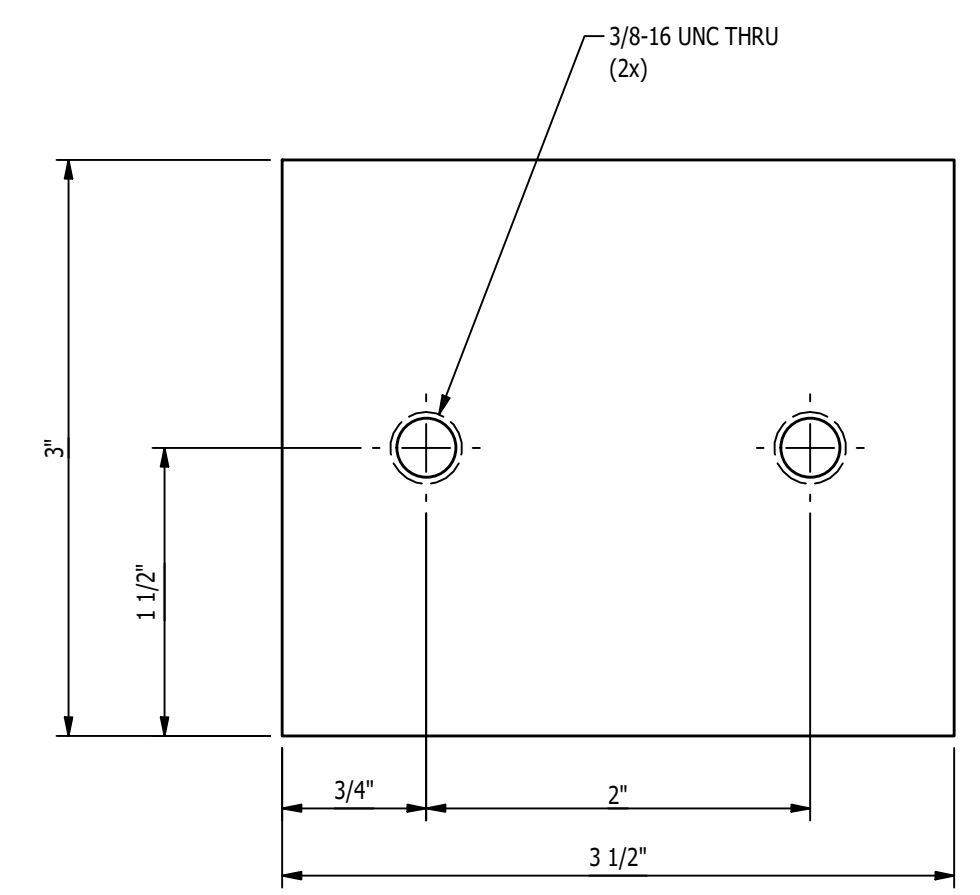
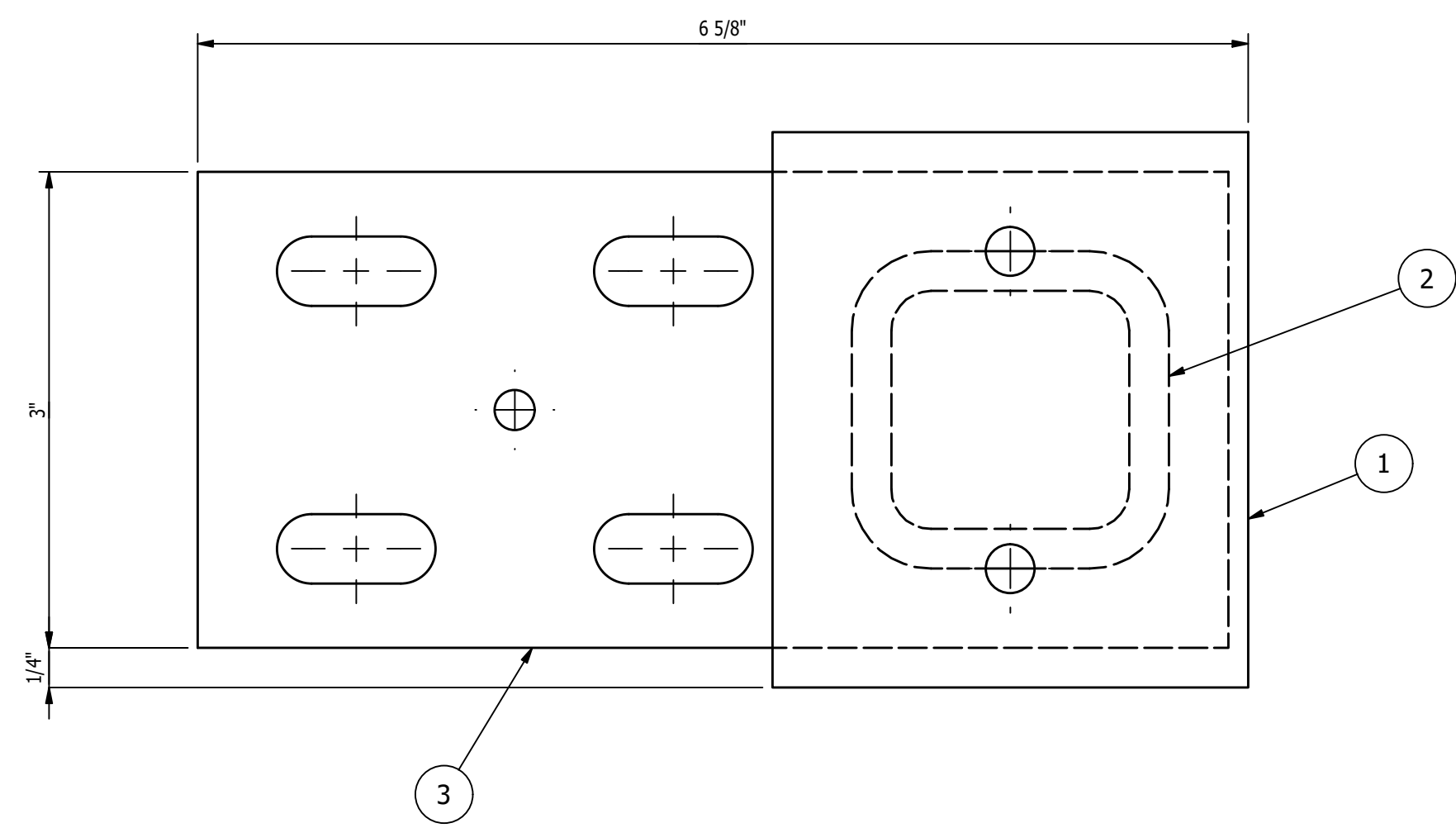
MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

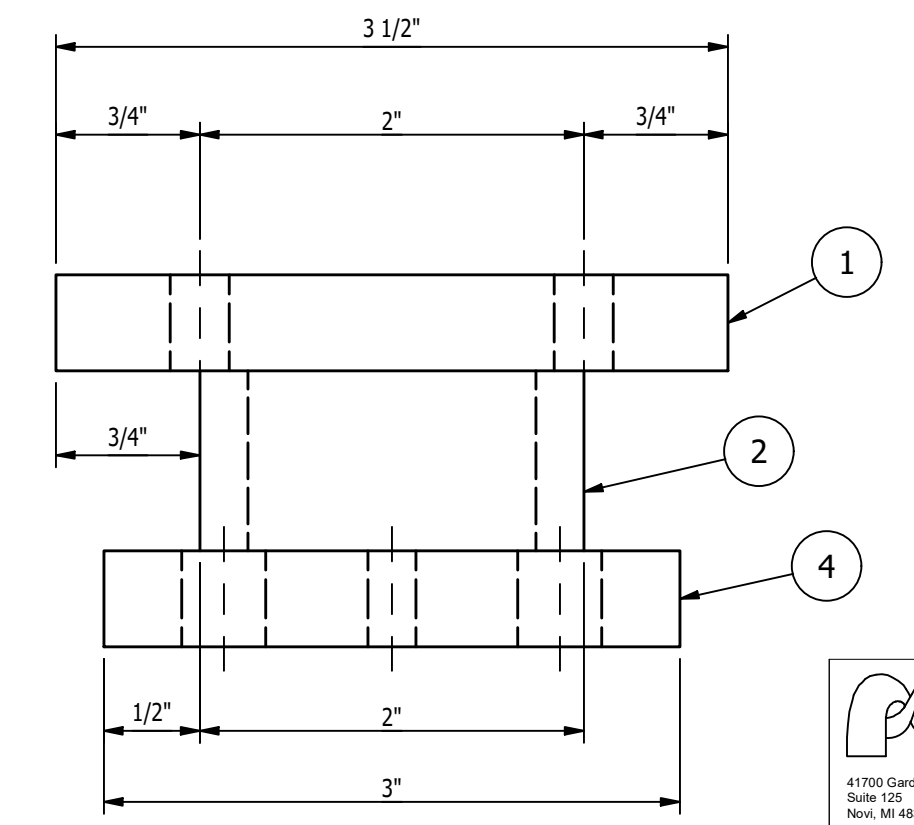
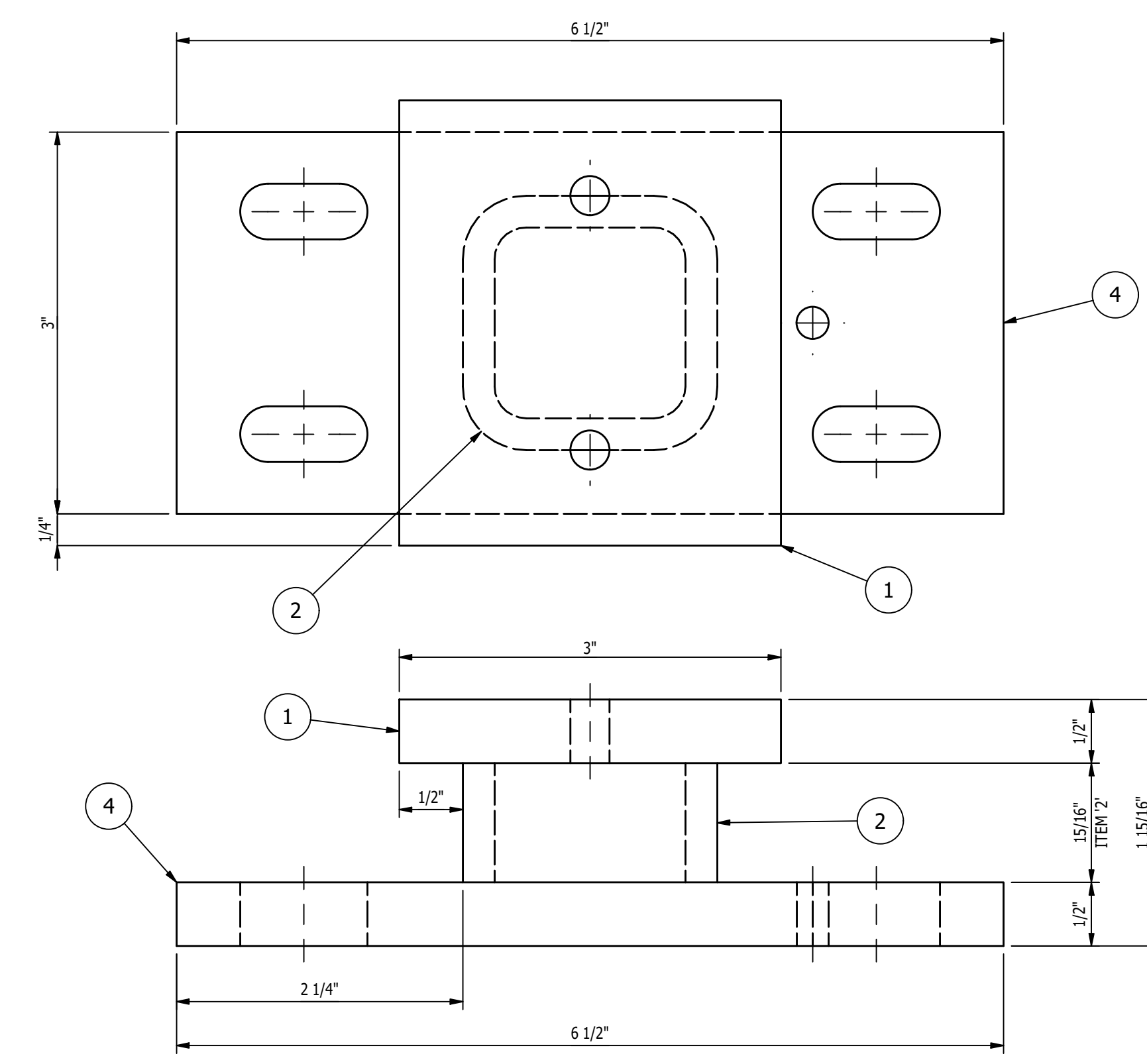
WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

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

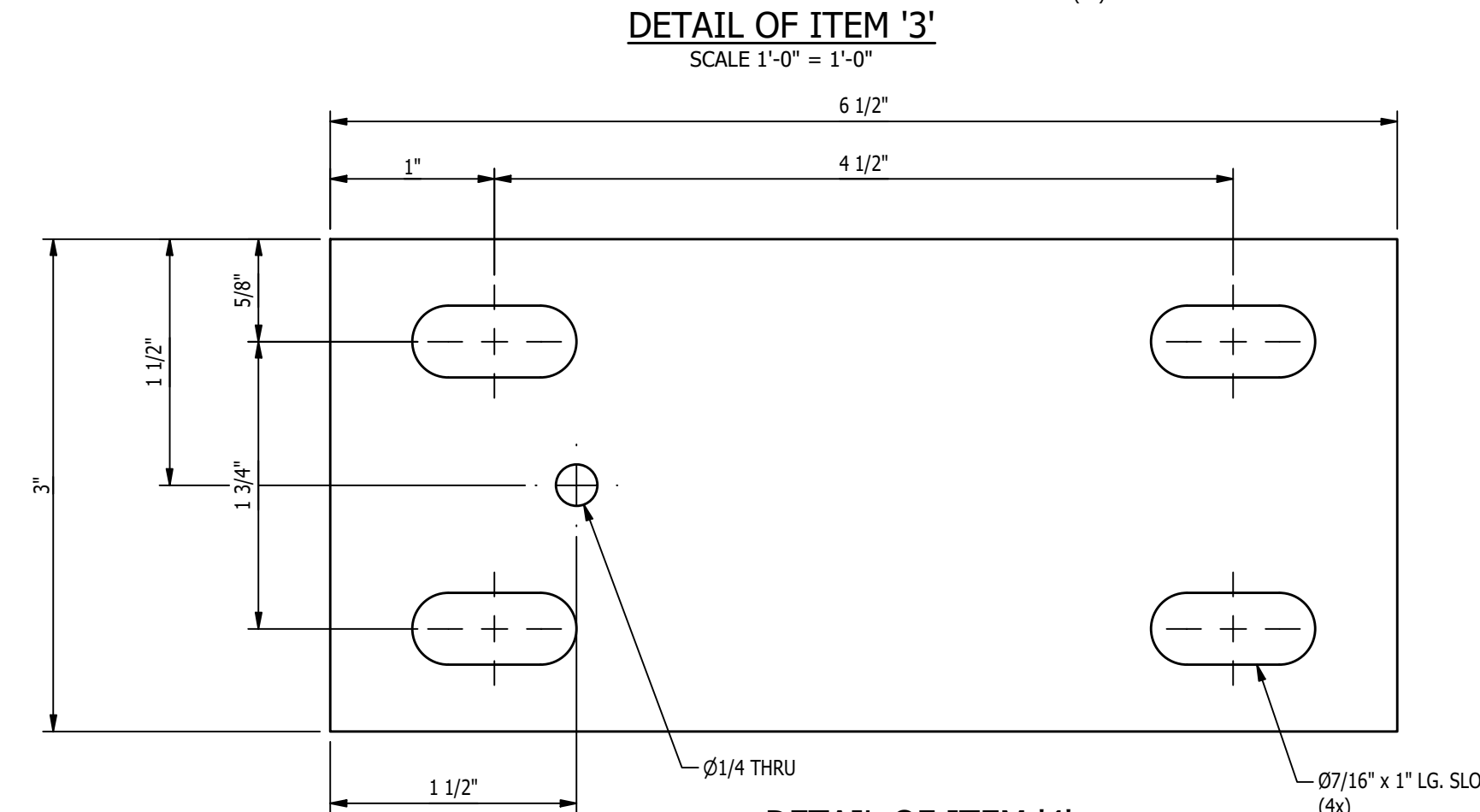
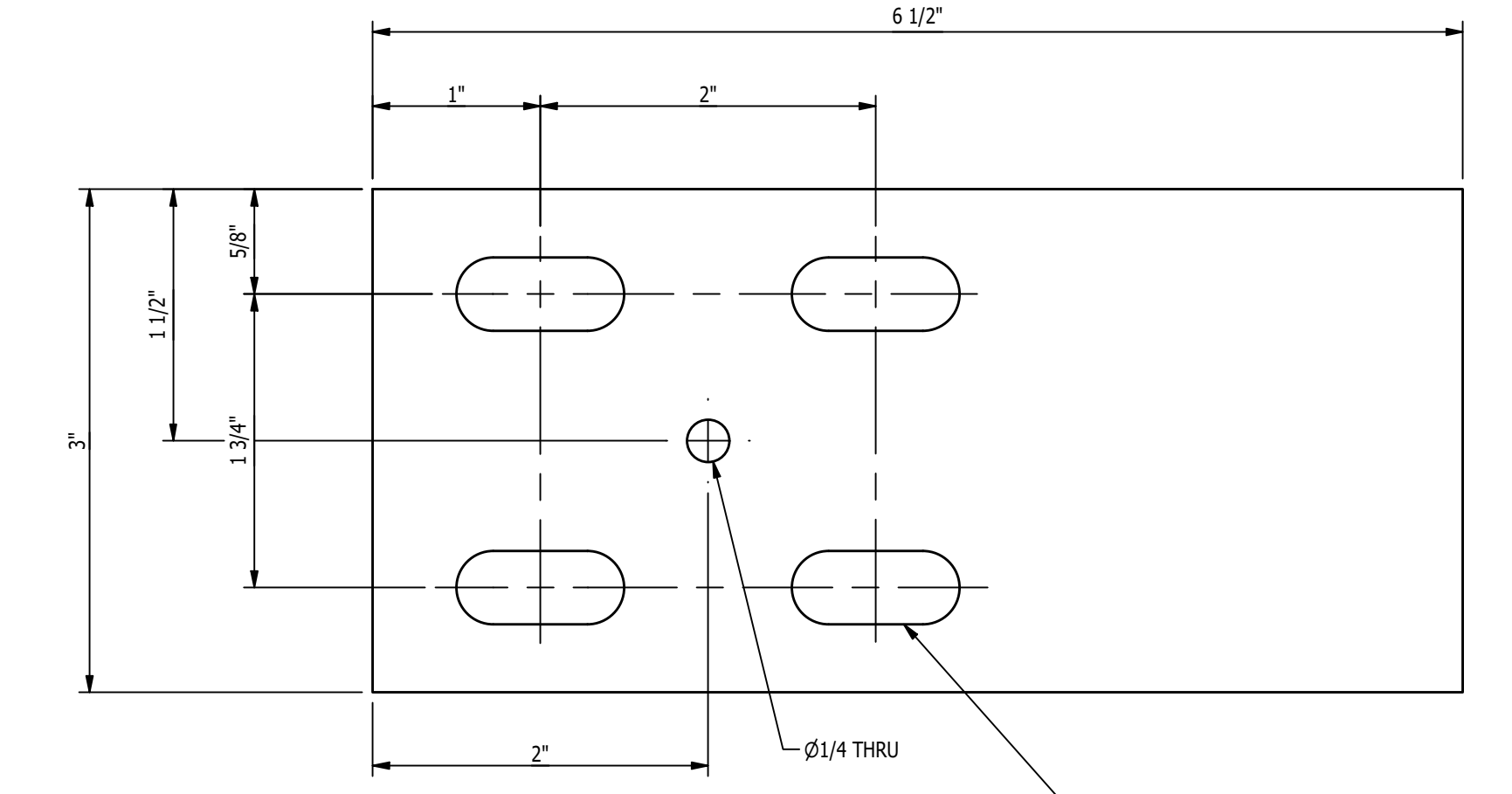


MK-D403A ~ FRONT FORK STANCHION
SCALE 1'-0" = 1'-0"



MK-D403B ~ FRONT FORK STANCHION
SCALE 1'-0" = 1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D403A			
1	1	BAR 1/2 x 3	3 1/2"		
2	1	HSS 2 x 2 x 1/4 A500 GR. C	15/16"		
3	1	BAR 1/2 x 3	6 1/2"		
		MK-D403B			
1	1	BAR 1/2 x 3	3 1/2"		
2	1	HSS 2 x 2 x 1/4 A500 GR. C	15/16"		
4	1	BAR 1/2 x 3	6 1/2"		



- 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:**
- 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	11/8/22	ADDED MK-D403B	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY

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TITLE: P6700 CONVEYORS CAMPUS BUILDINGN	DRAWN BY: SGS
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D403	DWG DATE: 8/29/2022
REV: B	JOB No: 22096

MAGNUM Consulting
41100 Clarkston Rd. Suite 125, Novi, MI 48235
Phone: (248) 772-8822 Fax: (248) 772-8851 Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D403

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:

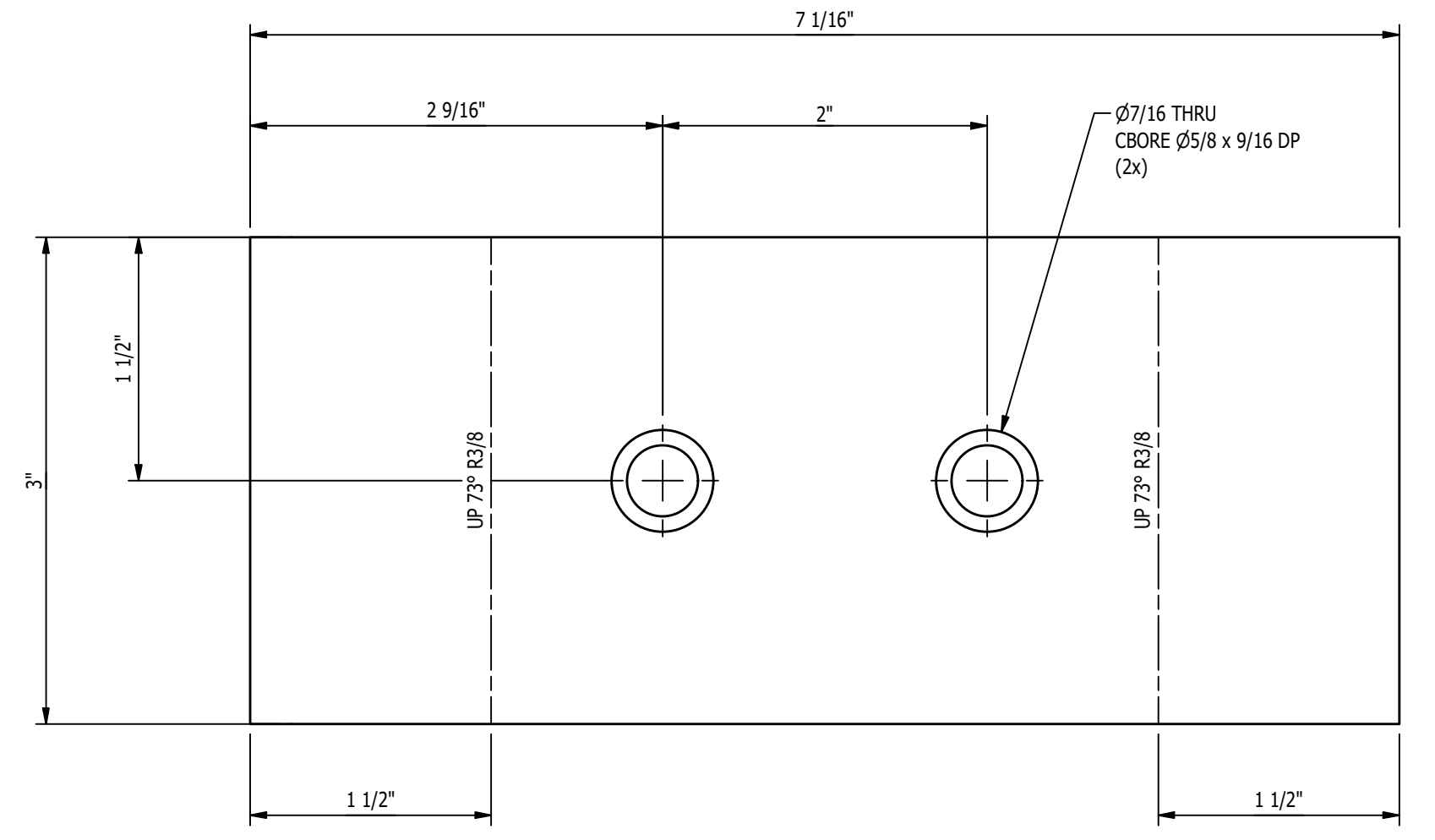
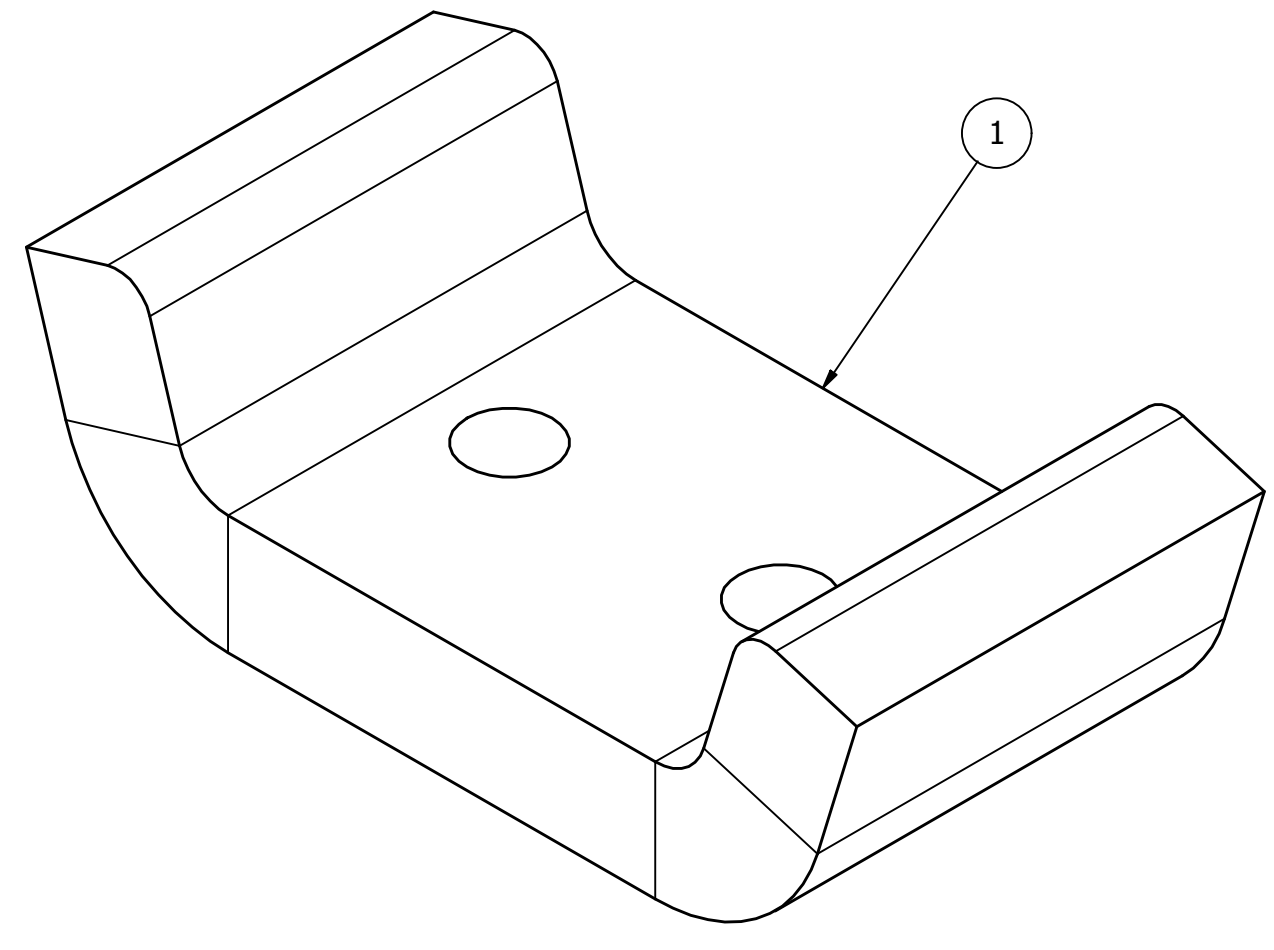
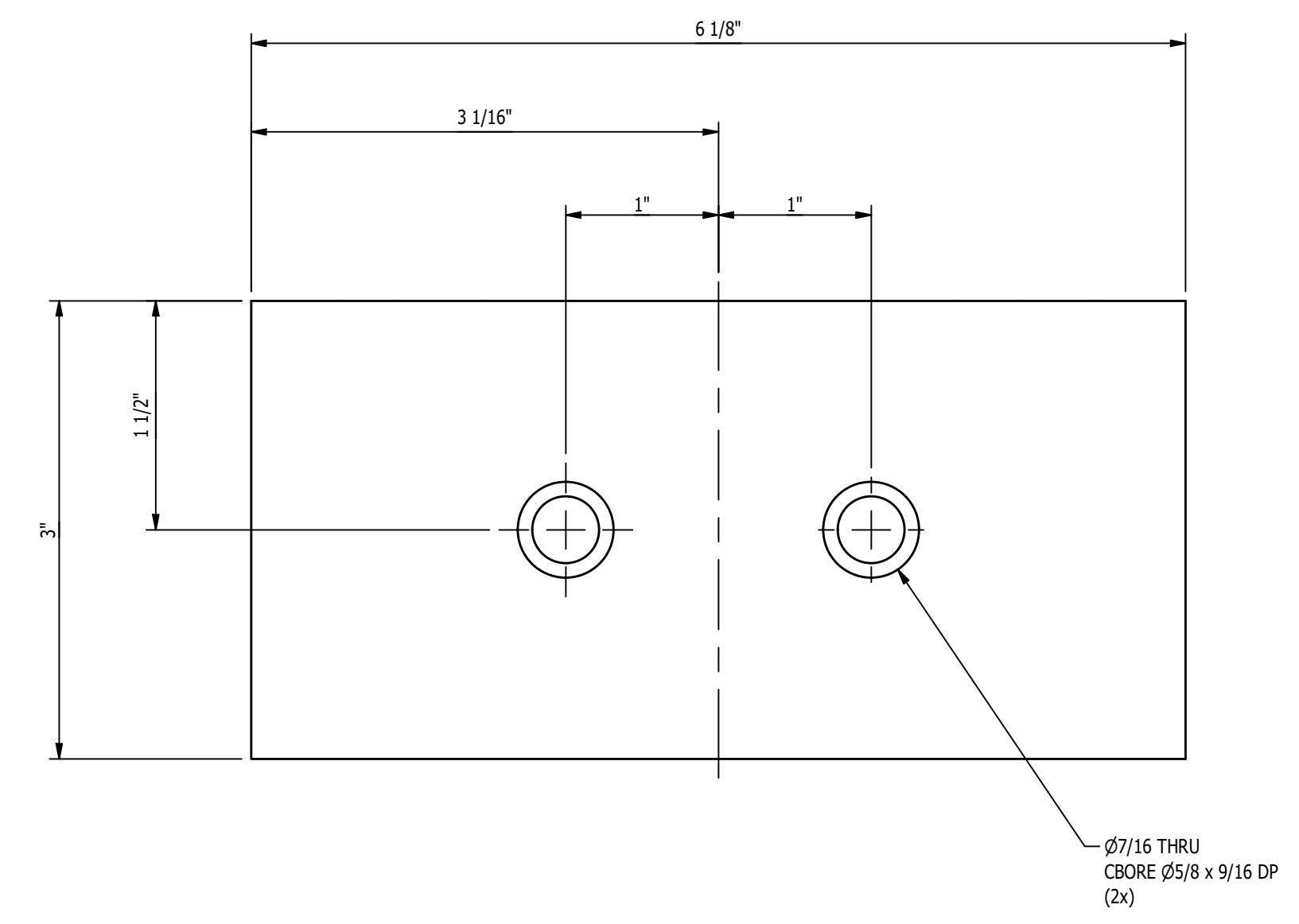
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

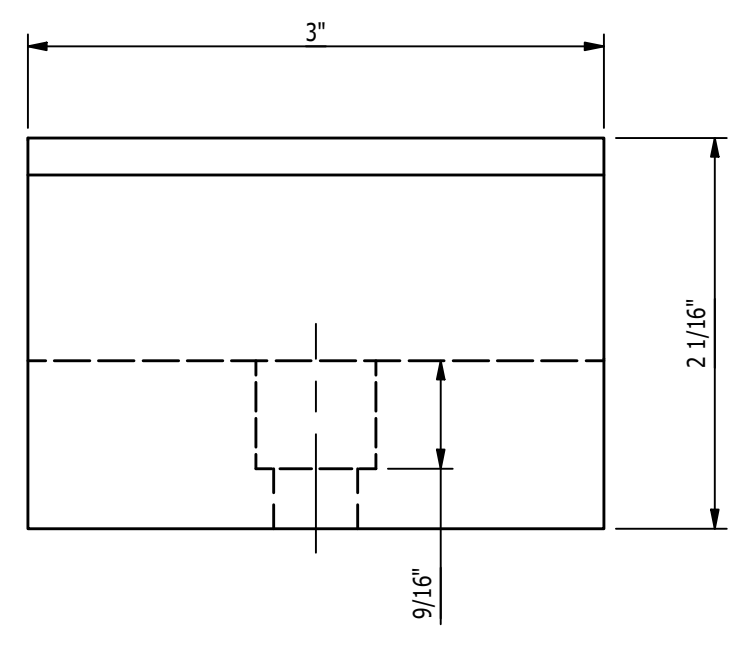
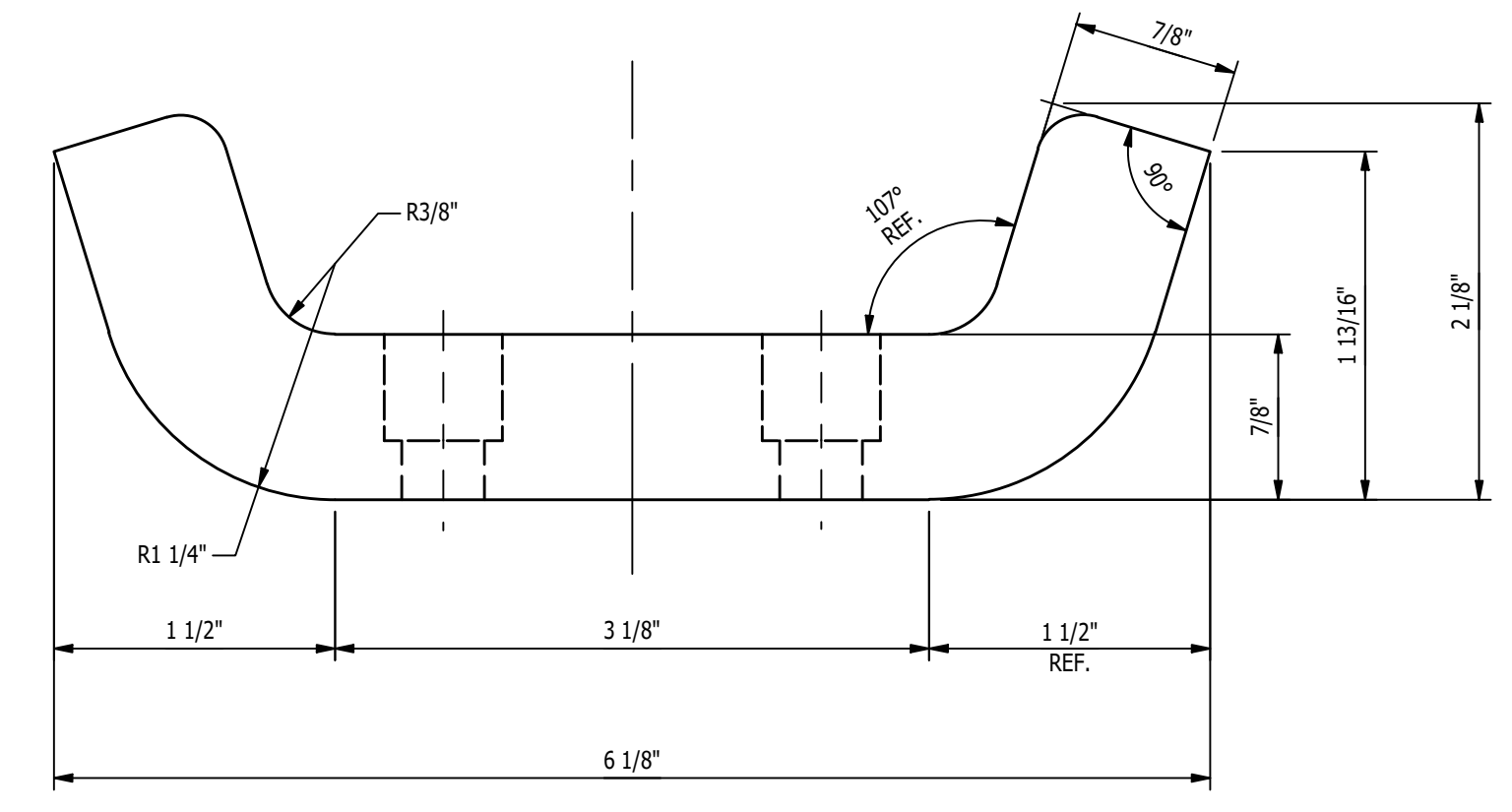
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

3:00p 11/25/2022 New Mill Drawing/General/1875D403.dwg

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D404A			
1	1	PL 7/8 x 3 ~ 1045 STEEL	7 1/16"		



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



MK-D404A ~ FRONT FORK DETAIL
SCALE 1'-0" = 1'-0"

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

PAINT NOTES:
DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
A	MC	10/21/22	FOR FABRICATION	

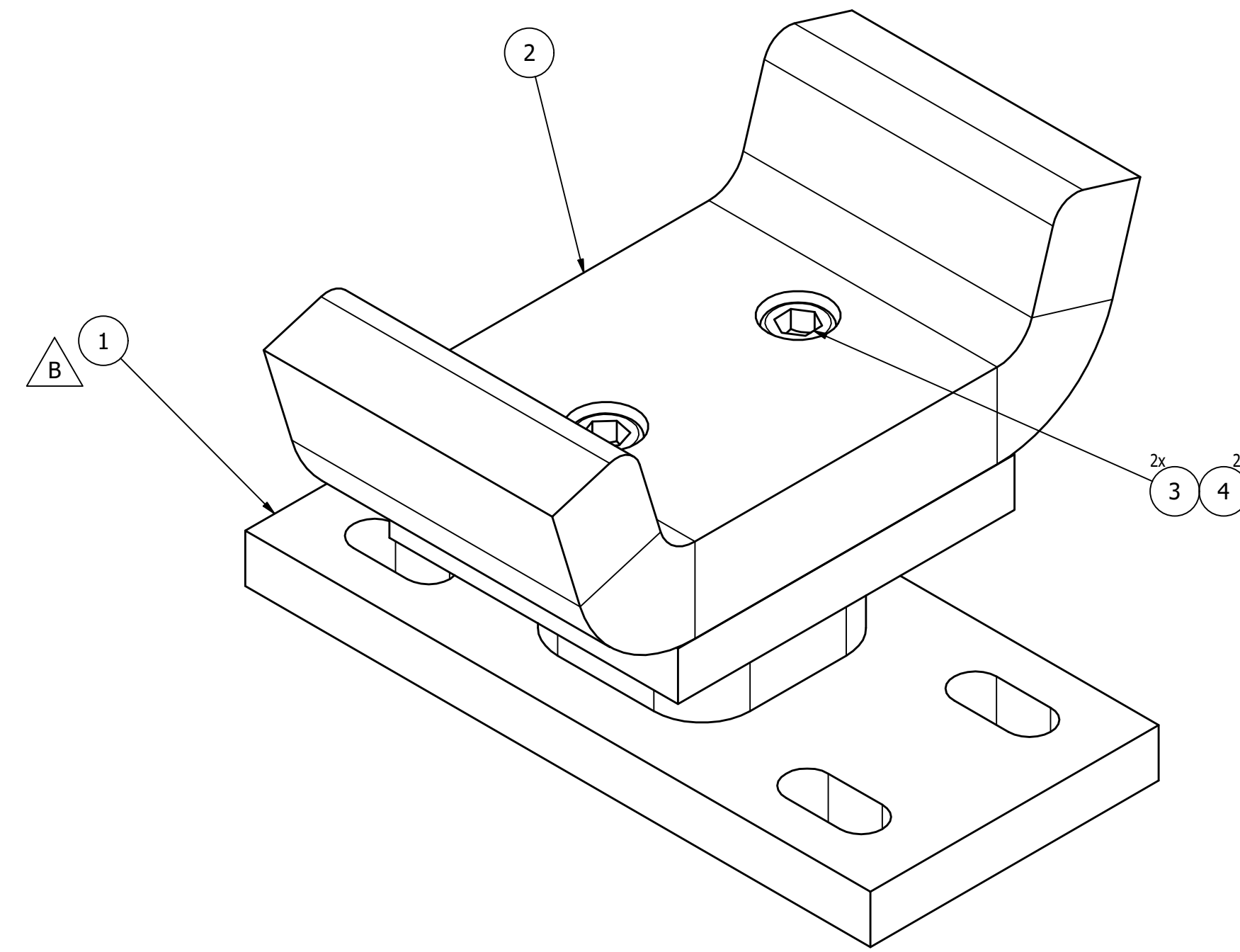
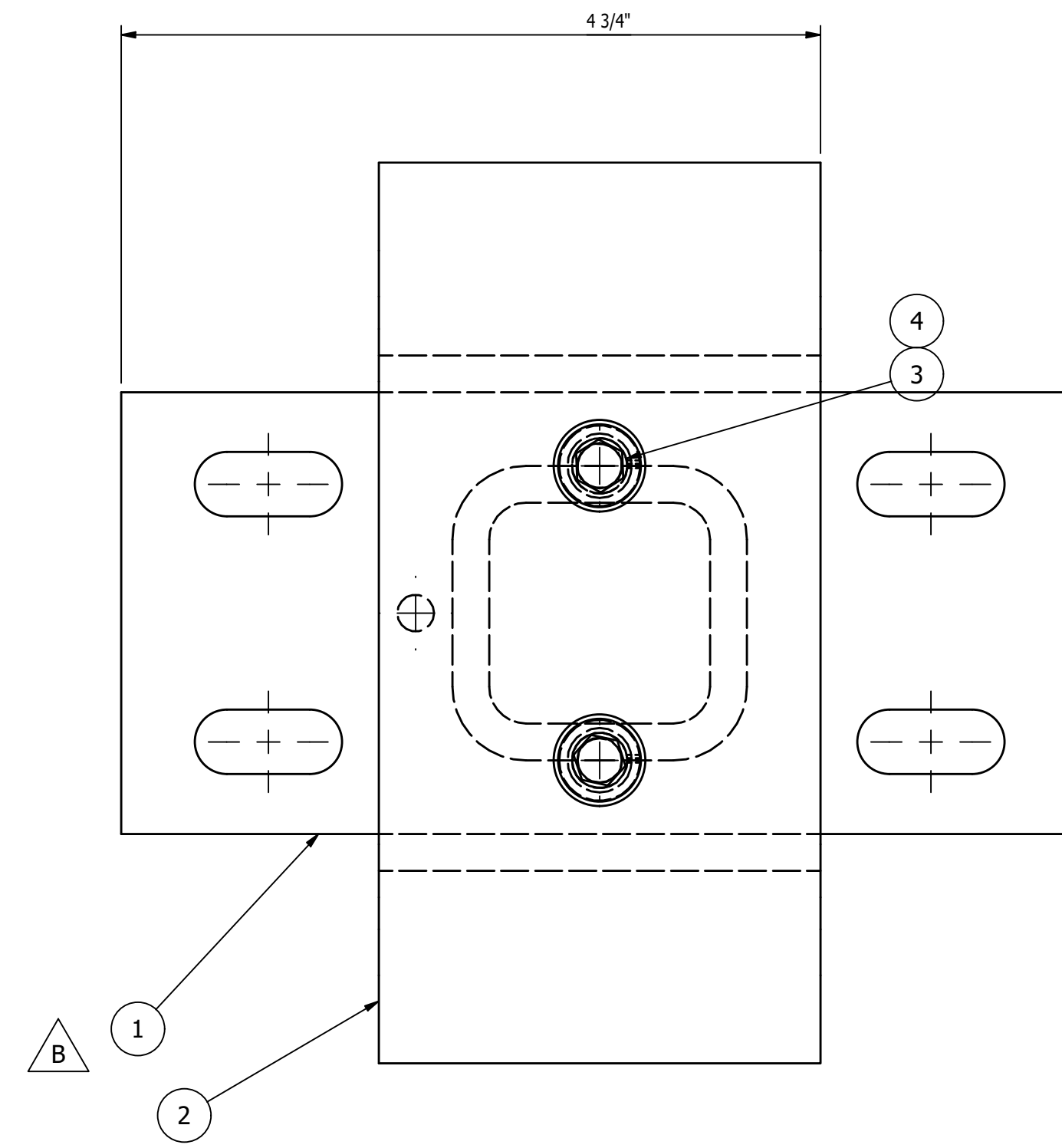
	MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
	TITLE: P6700 CONVEYORS CAMPUS BUILDINGN CLIENT: VOLVO	DRAWN BY: SGS CHECKED BY: CW DWG DATE: 8/30/2022

DRAWING No. 1875D404	REV: A	JOB No: 22096
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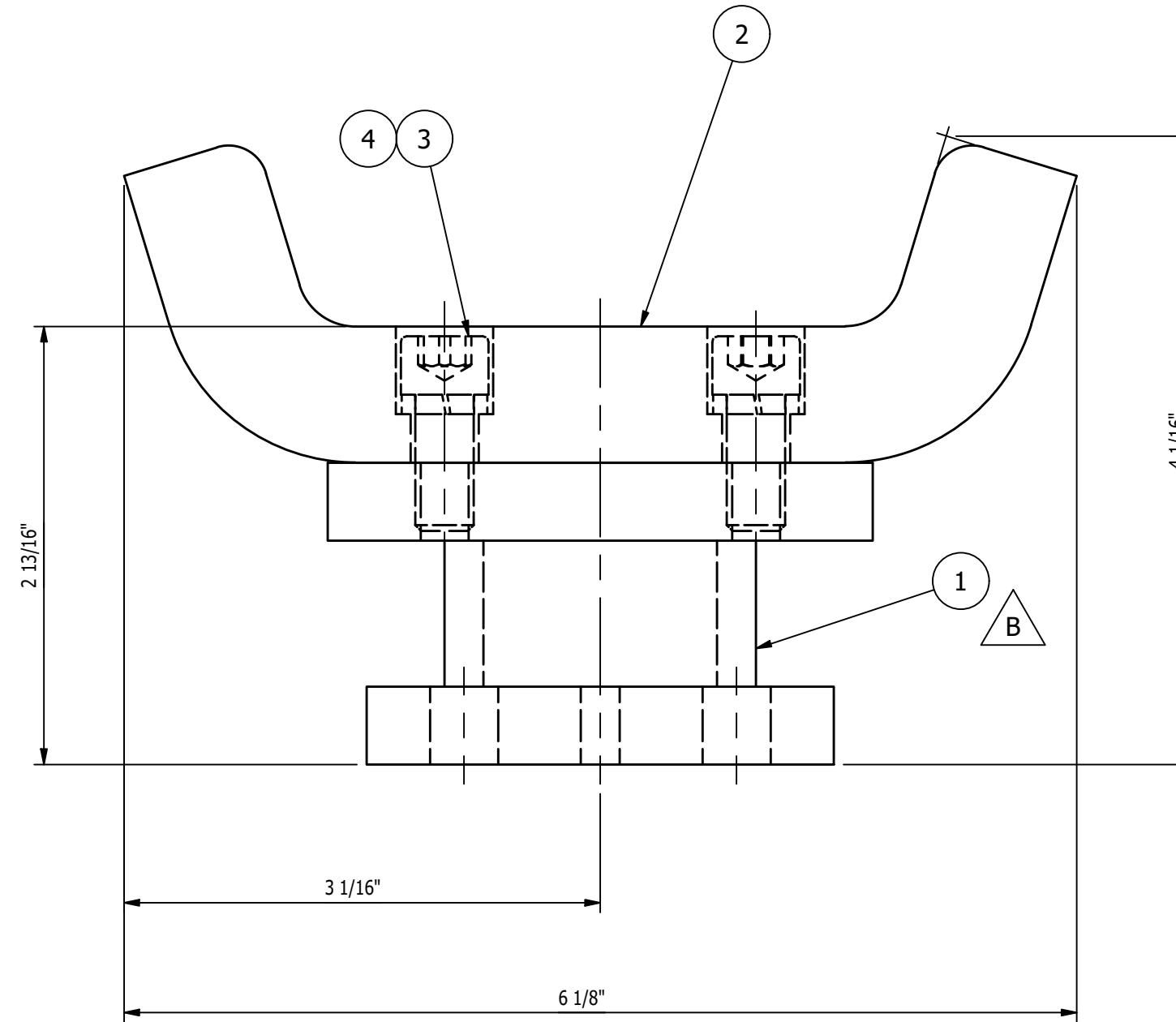
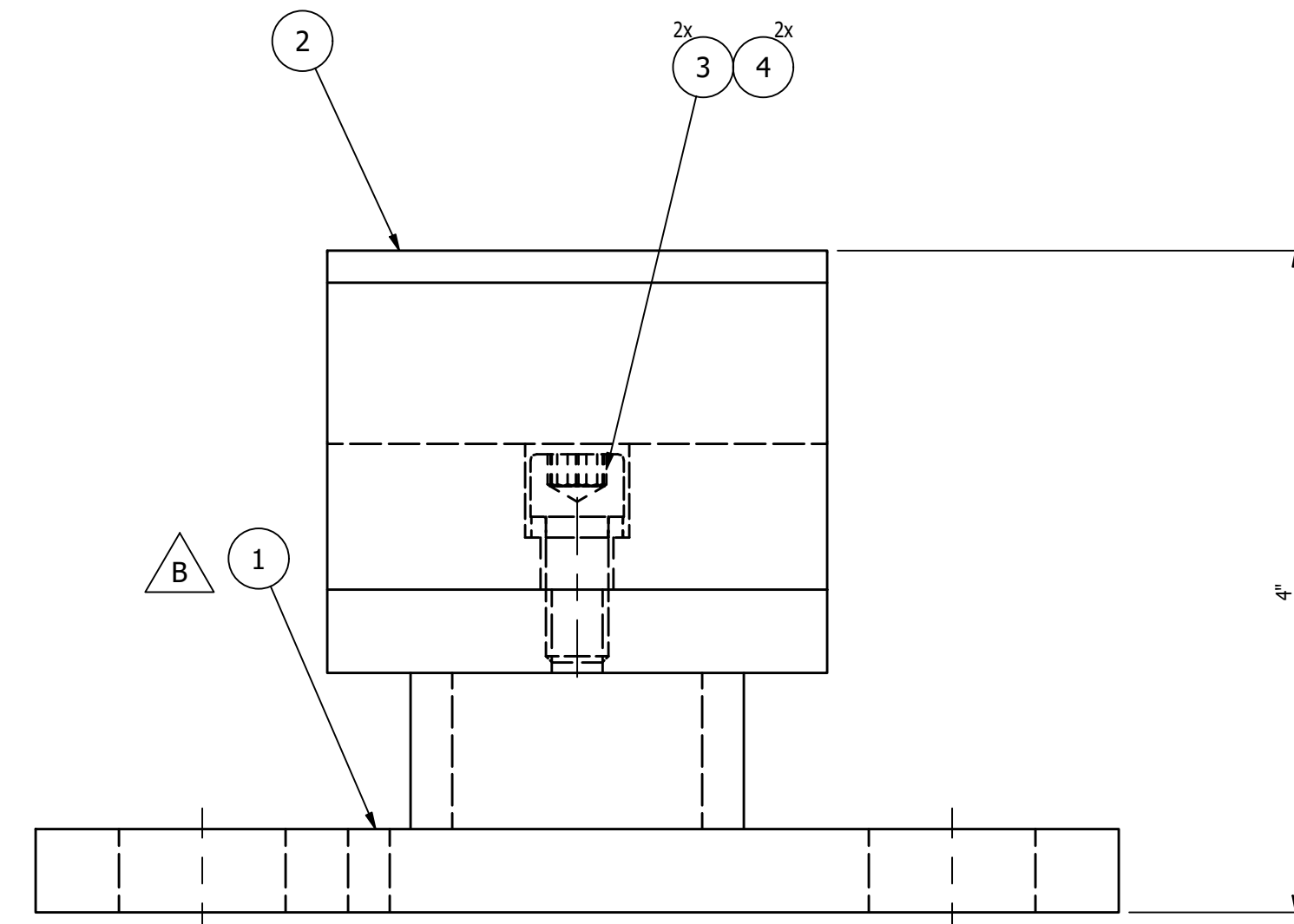
41100 Charleston Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D404

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



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D405A			
1	1	MK-D403B ~ FRONT FORK STANCHION			
2	1	MK-D404A ~ FRONT FORK DETAIL			
3	2	3/8-16UNC x 7/8\"/>			



MK-D405A ~ FRONT FORK DETAIL ASSEMBLY
SCALE 1'-0" = 1'-0"

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/8/2022	ITEM '1' WAS MK-D403A	
A	MC	10/21/22	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: SGS		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 8/30/2022		JOB No: 22096	
DRAWING No. 1875D405		REV: B			

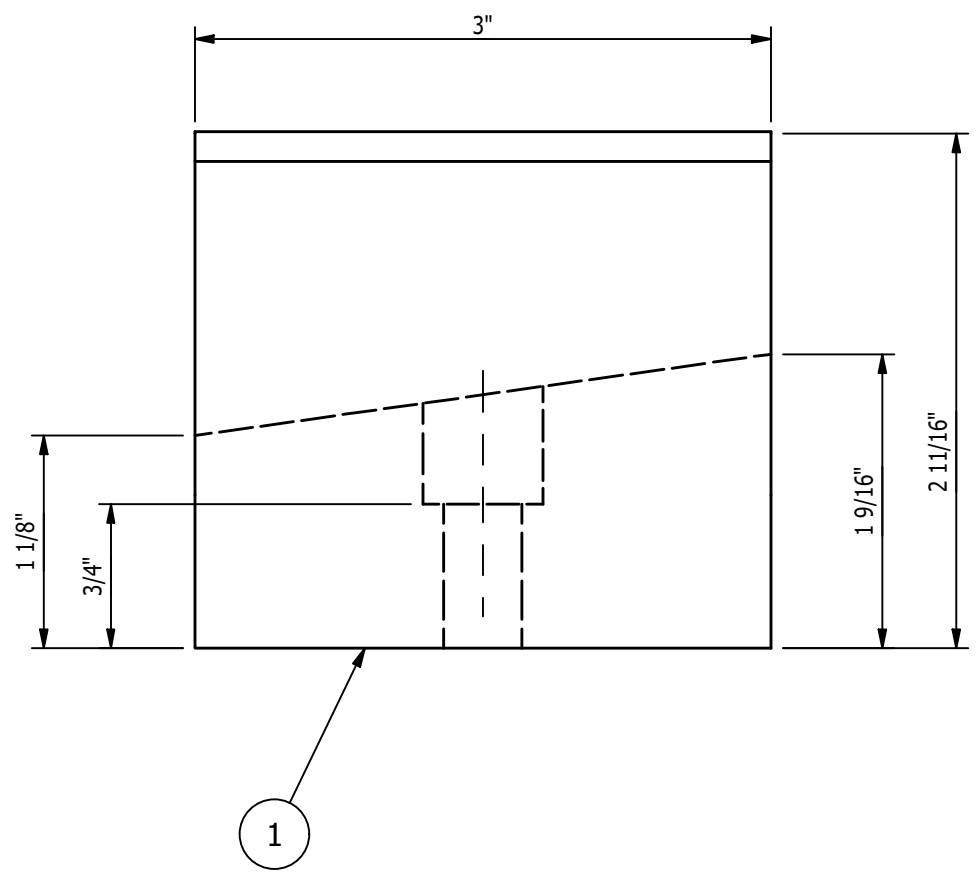
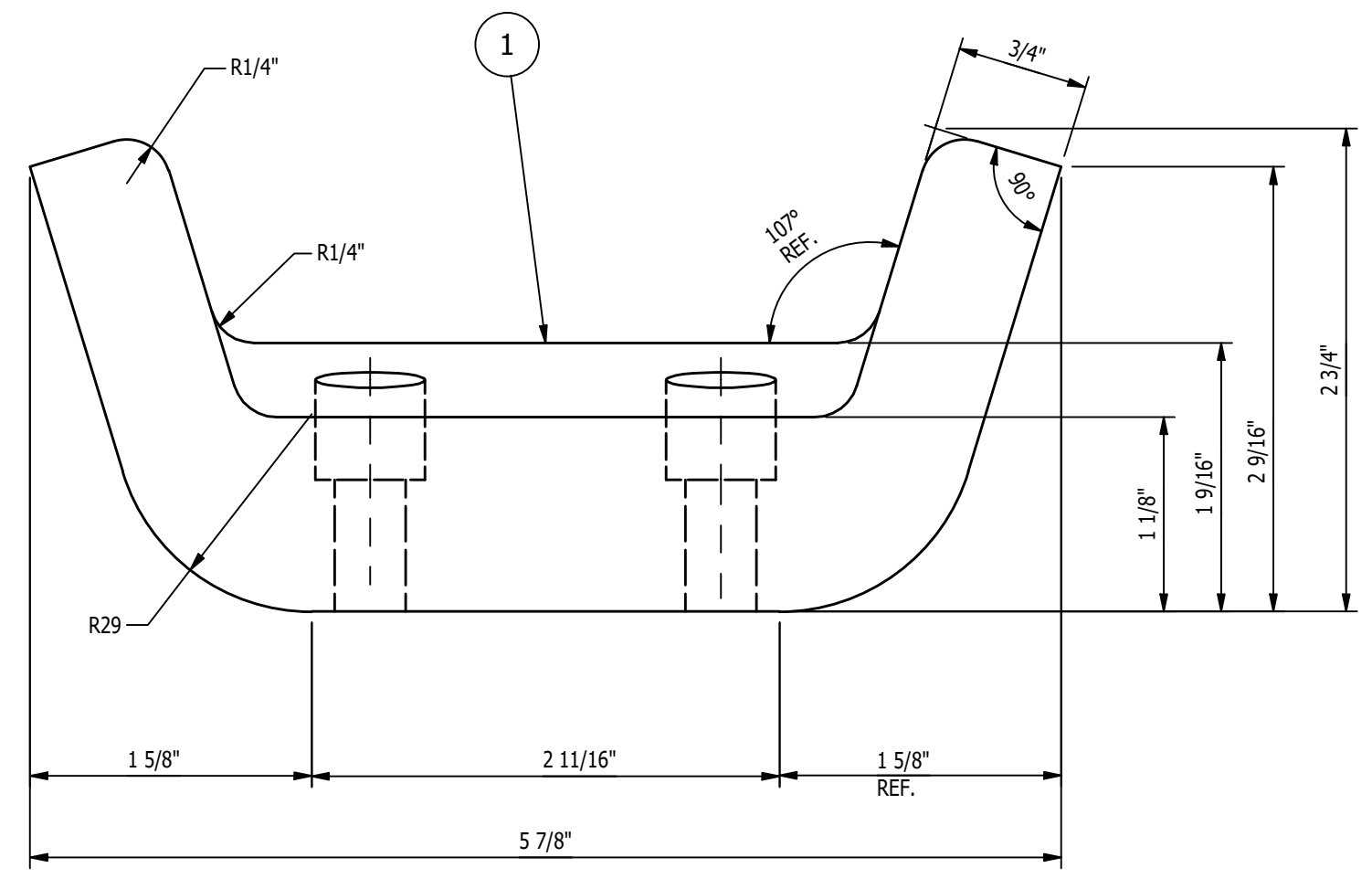
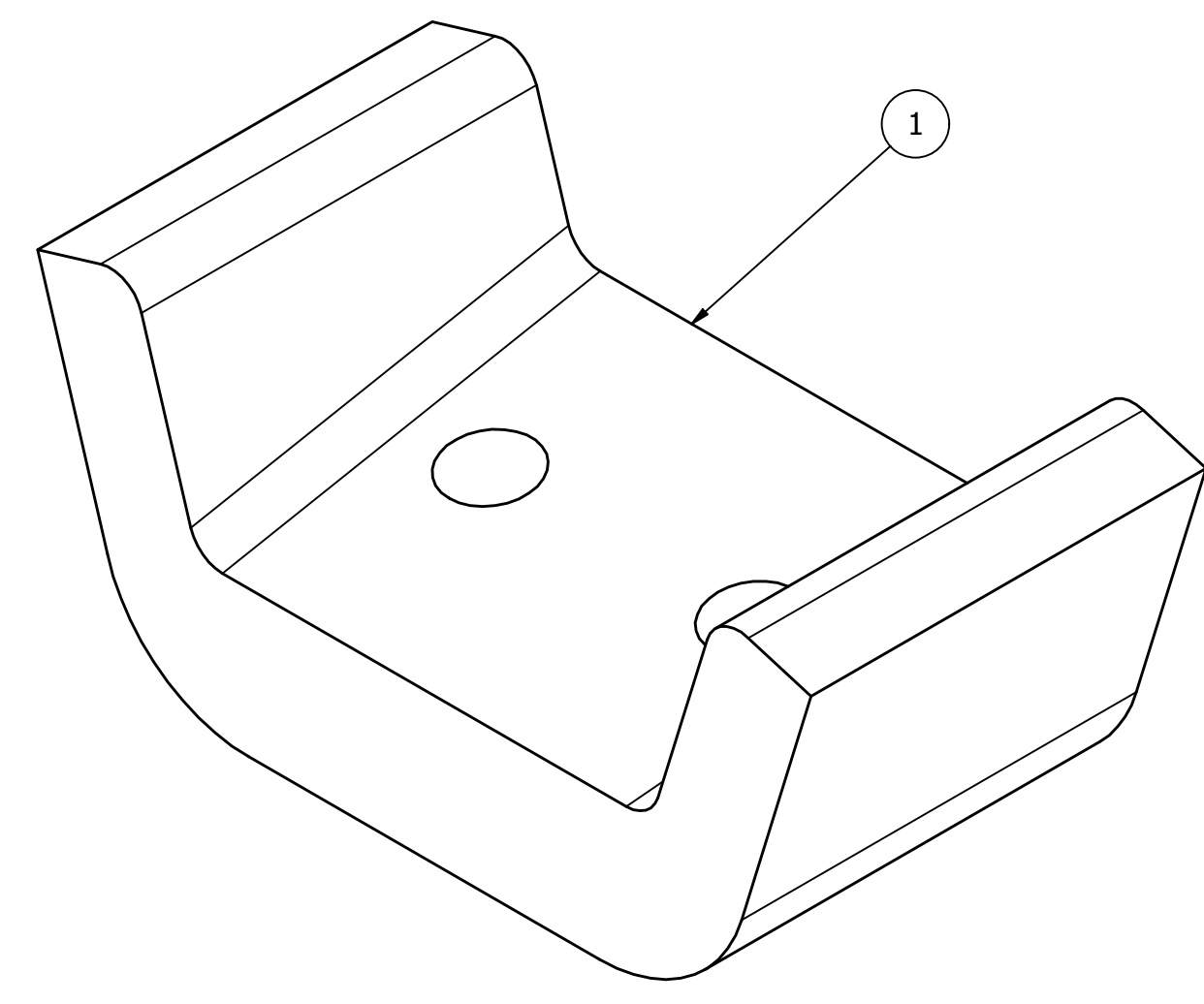
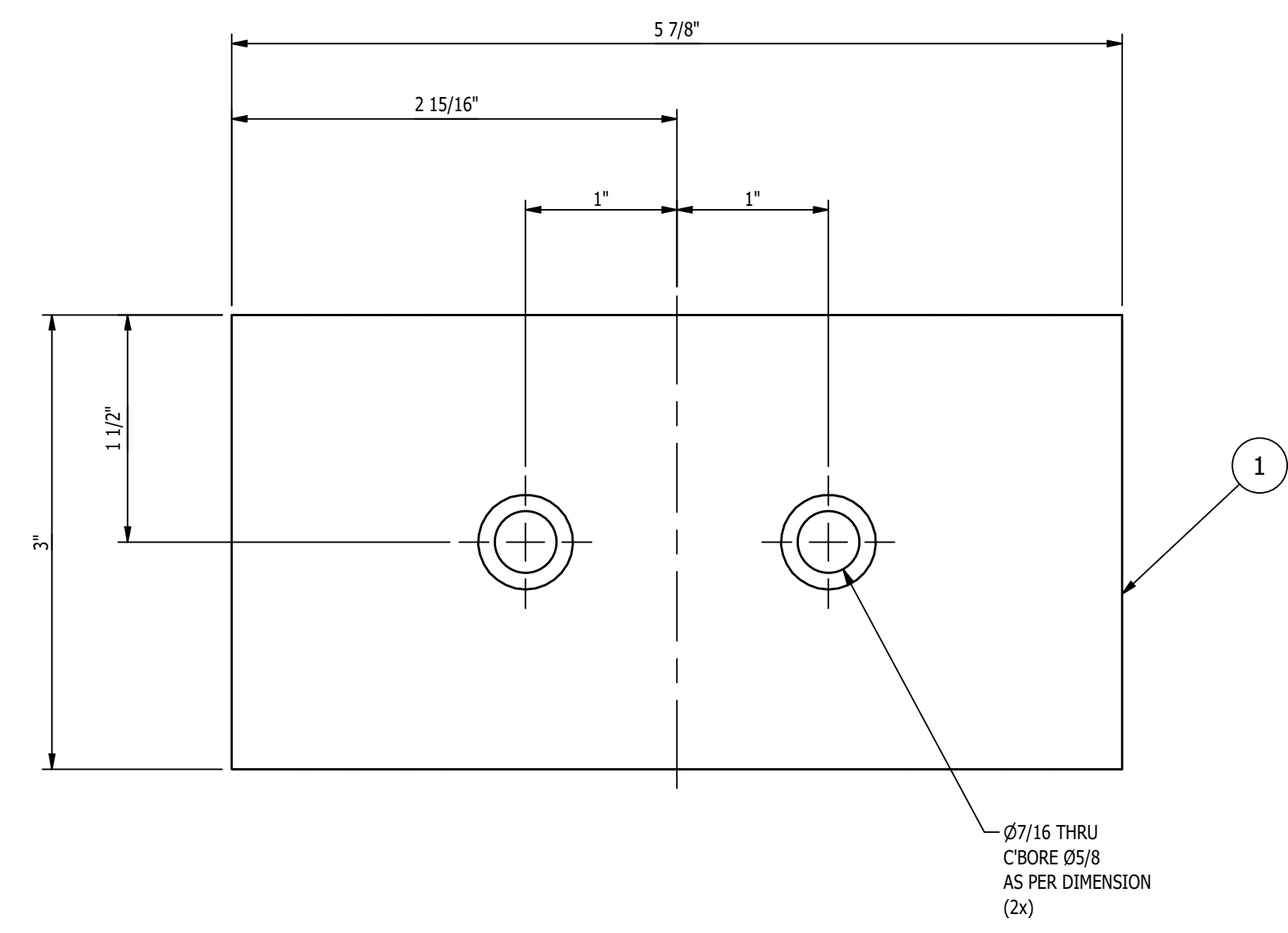
MAGNUM CONSULTING
41100 Charleston Rd.
Suite 125
Novi, MI 48165
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D405

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-D406A			
1	1	PL 3" X 3" ~ 1045 STEEL	5 7/8"		
TOTAL WEIGHT = 6.7 Lbs.					



MK-D406A ~ MIDDLE FORK DETAIL
SCALE 1'-0" = 1'-0"

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

PAINT NOTES:
DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
A	MC	10/21/22	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	
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		www.millc.com		REPRODUCTION IN PART OR	
				AS WHOLE WITHOUT THE WRITTEN	
				PERMISSION OF MILLER INDUSTRIES	
				IS PROHIBITED.	
TITLE: P6700 CONVEYORS		DRAWN BY: SGS		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 8/30/2022		JOB No: 22096	
DRAWING No. 1875D406		REV: A			

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D406

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:

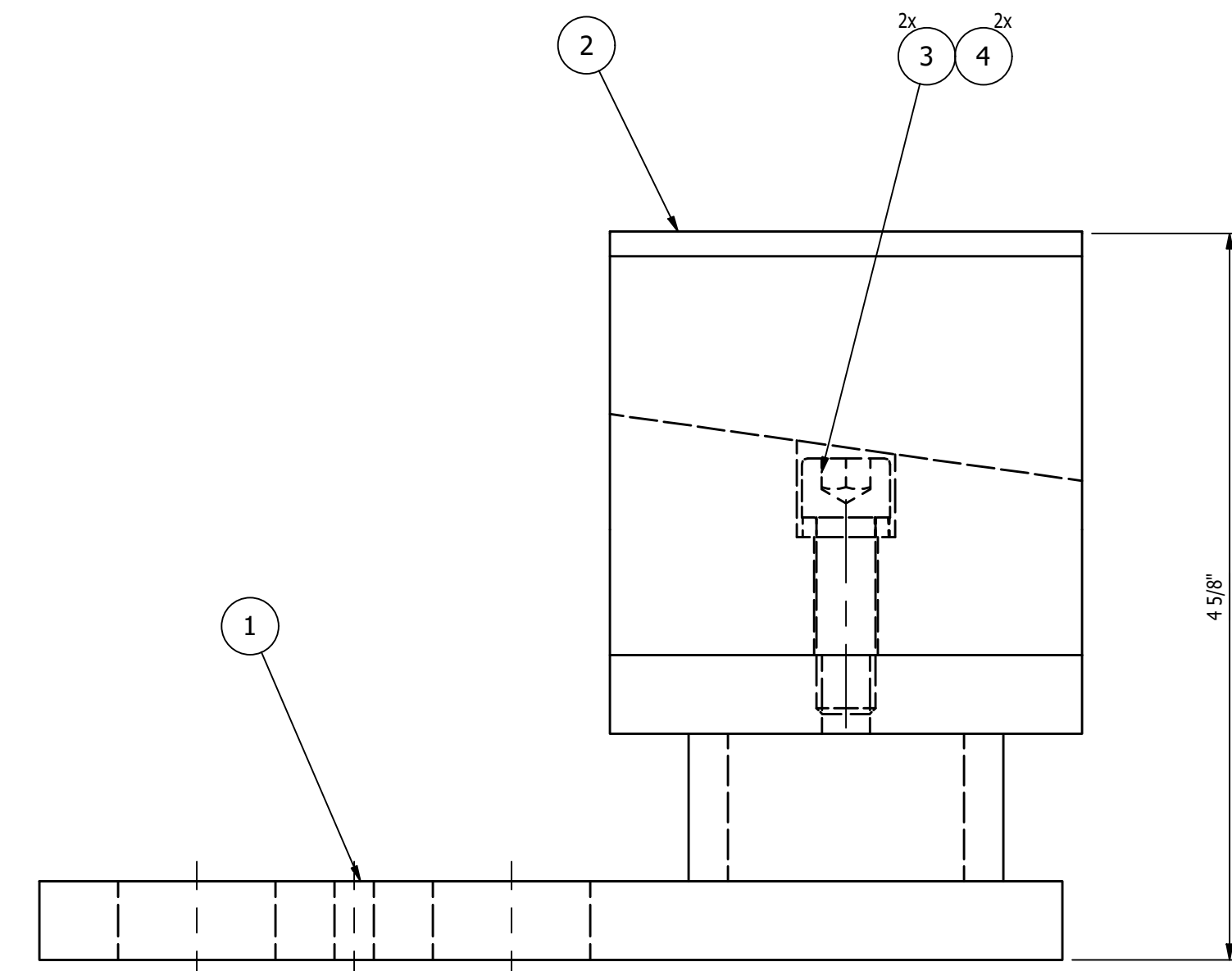
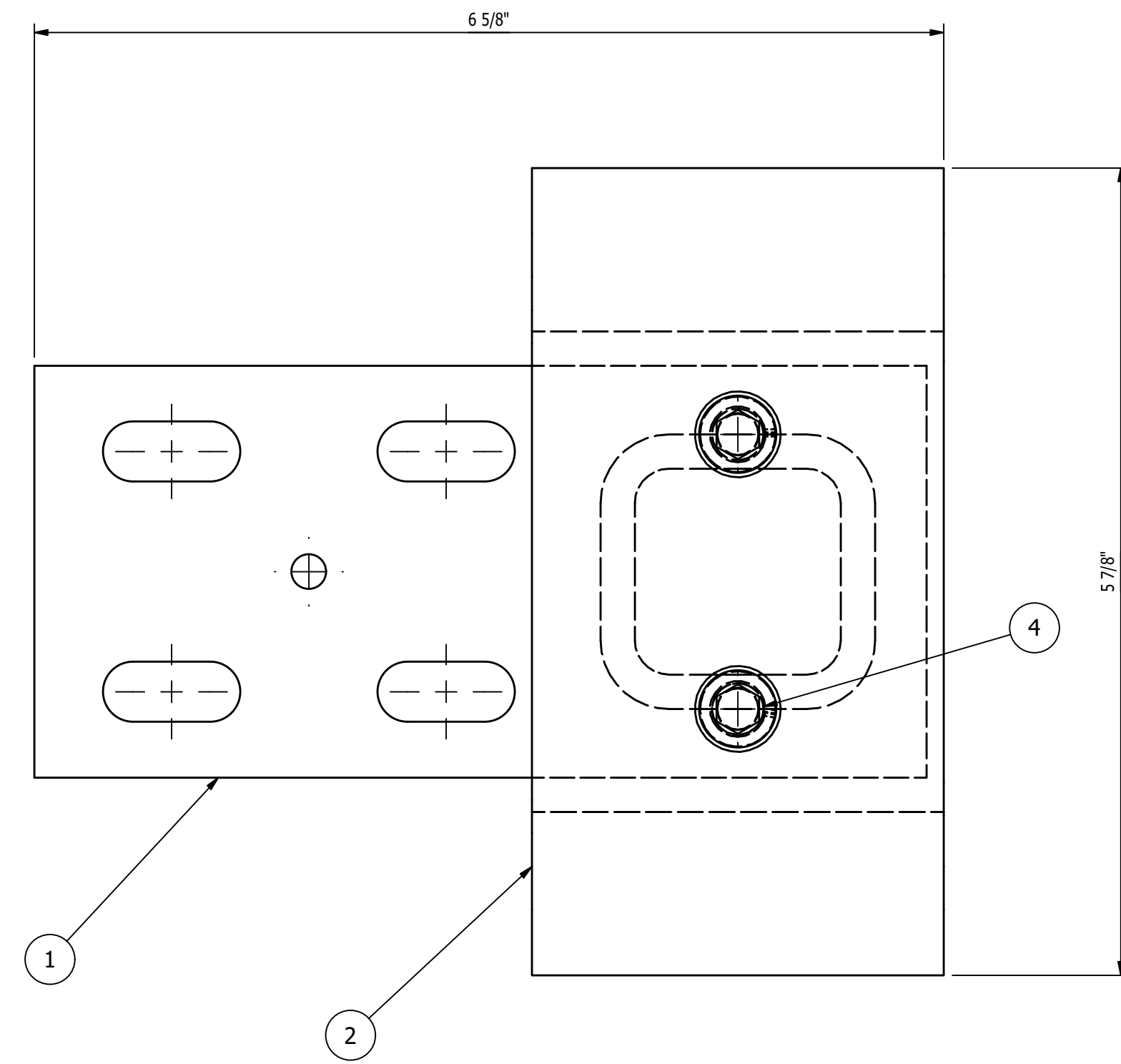
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

PAINT:

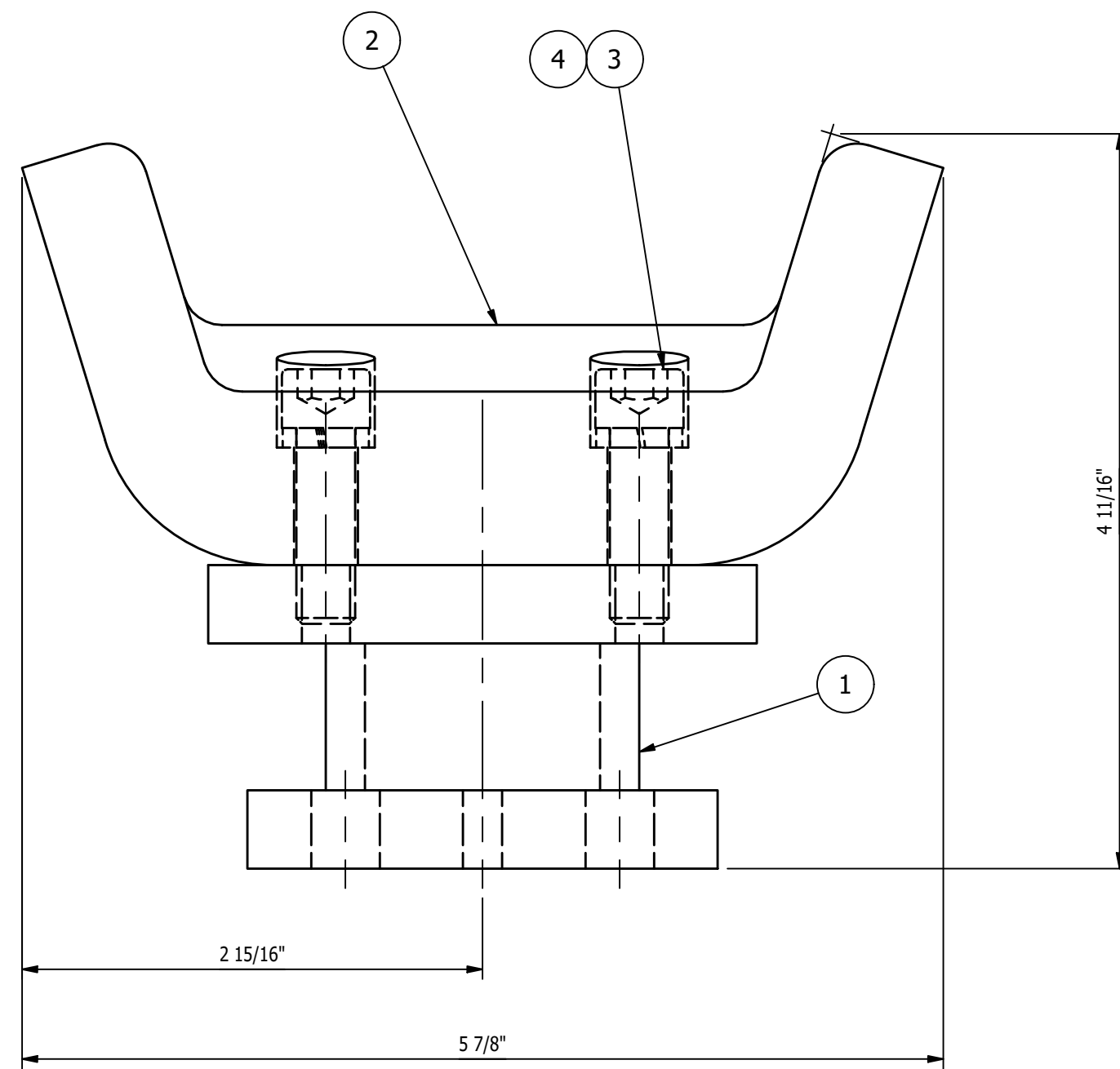
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

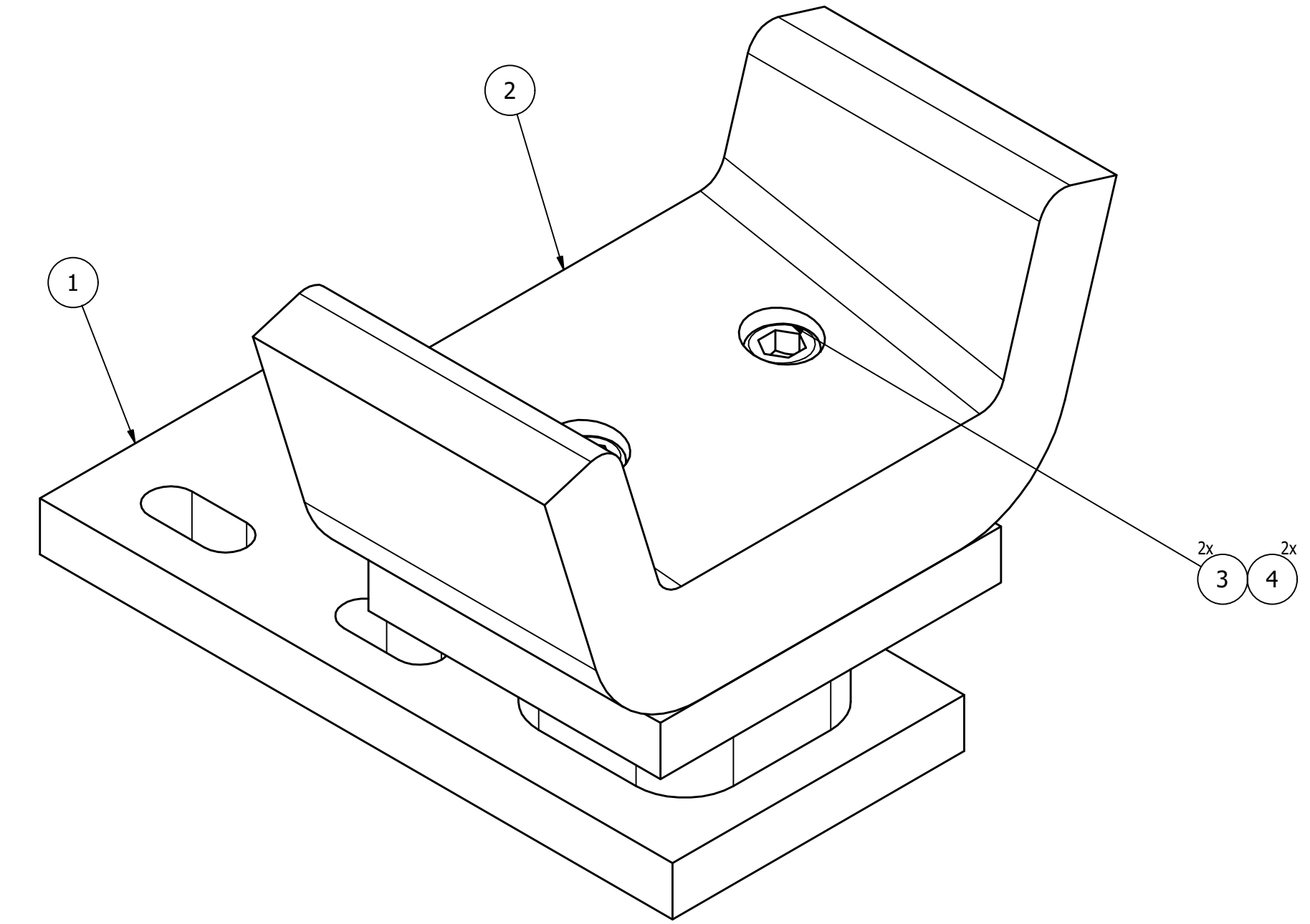
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



MK-D407A ~ MIDDLE FORK DETAIL ASSEMBLY
SCALE 1'-0" = 1'-0"



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D407A			
1	1	MK-D403A ~ FRONT FORK STANCHION			
2	1	MK-D406A ~ MIDDLE FORK DETAIL			
3	2	3/8-16UNC x 1 1/4" LG. HEX SOCKET HEAD CAP SCREW			
4	2	3/8 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
 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	10/21/22	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 BUILDINGN	DRAWN BY: SGS
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D407	DWG DATE: 8/30/2022
REV: A	JOB No: 22096

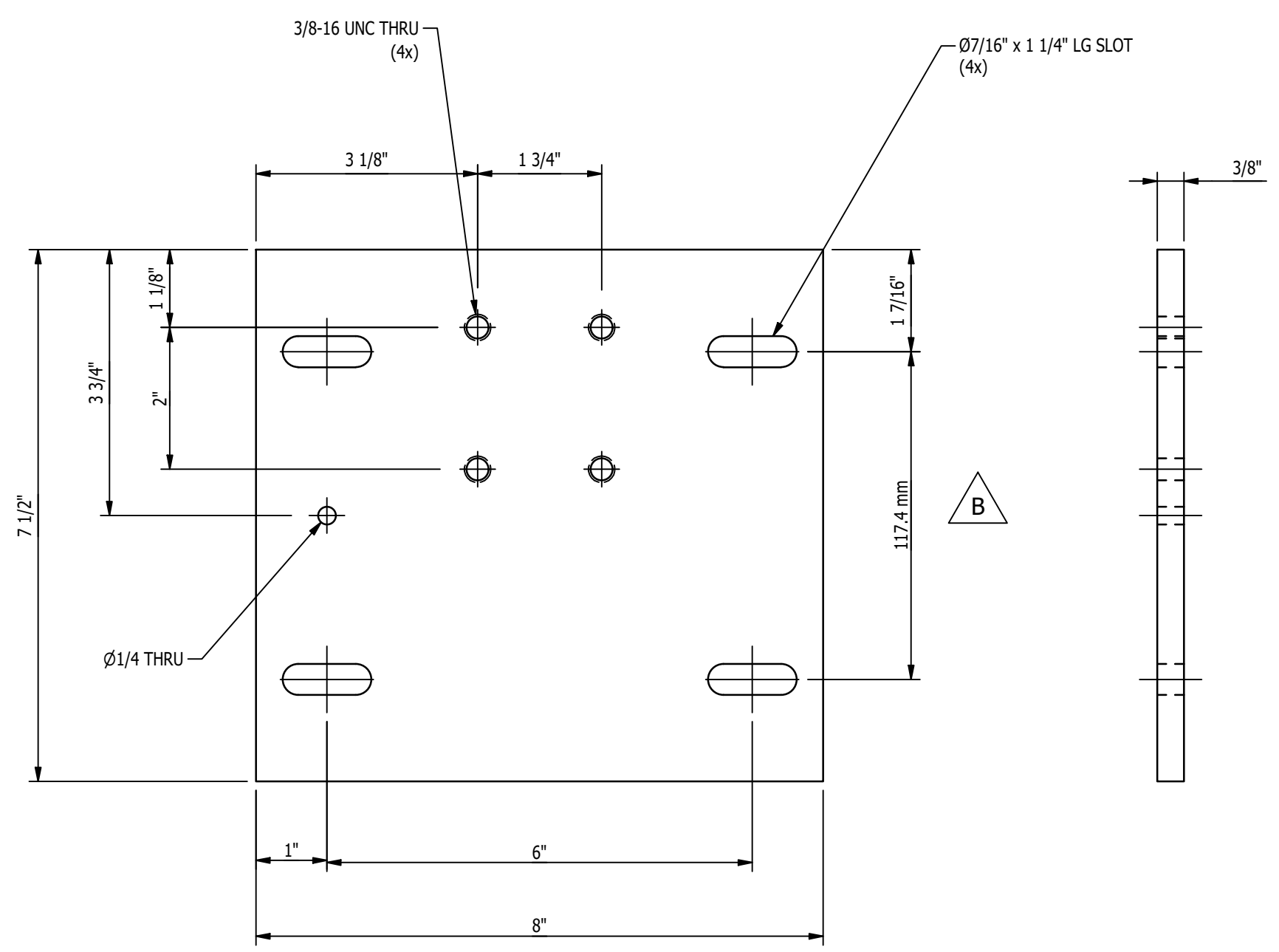
MAGNUM CONSULTING
41100 QuakerRoad Rd.
Suite 125
North, MI 48175
Phone: (248) 772-8822
Fax: (248) 772-8821
Web: www.m4magnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D407

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-D408A			
1	1	BAR 3/8 x 7 1/2	8"		



MK-D408A ~ FORK DETAIL MOUNTING PLATE
SCALE 6"=1'-0"

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/1/2022	REVISED DIM	
A	MC	10/21/22	FOR FABRICATION	

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

TITLE: P6700 CONVEYORS CAMPUS BUILDINGN		DRAWN BY: SGS CHECKED BY: CW DWG DATE: 8/30/2022
CLIENT: VOLVO		JOB No: 22096
DRAWING No. 1875D408		REV: B

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

41100 Quarkwood Rd.
Suite 125
West, MI 48375

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D408

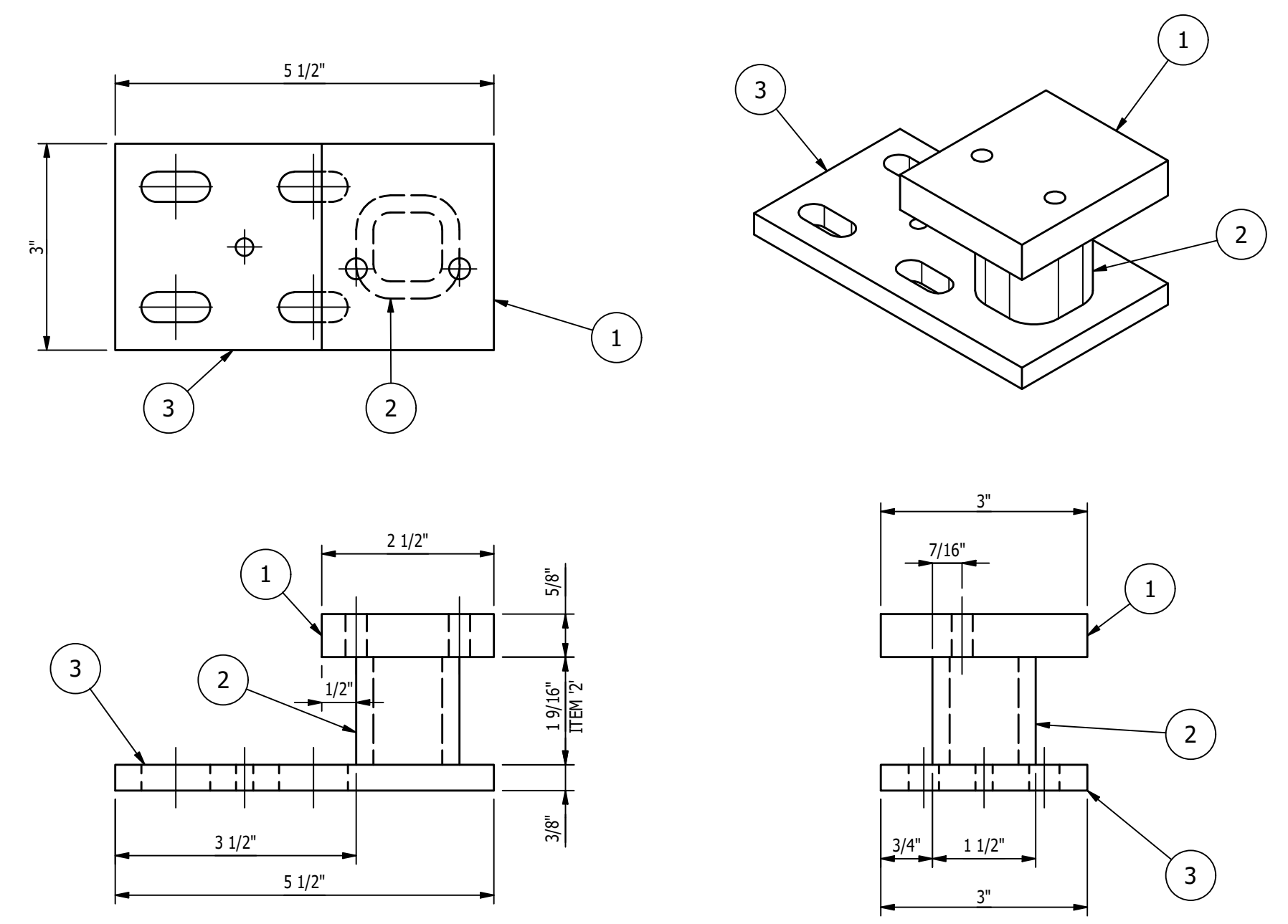
UNLESS OTHERWISE NOTED:

X = ±.060
XX = ±.030
XXX = ±.005

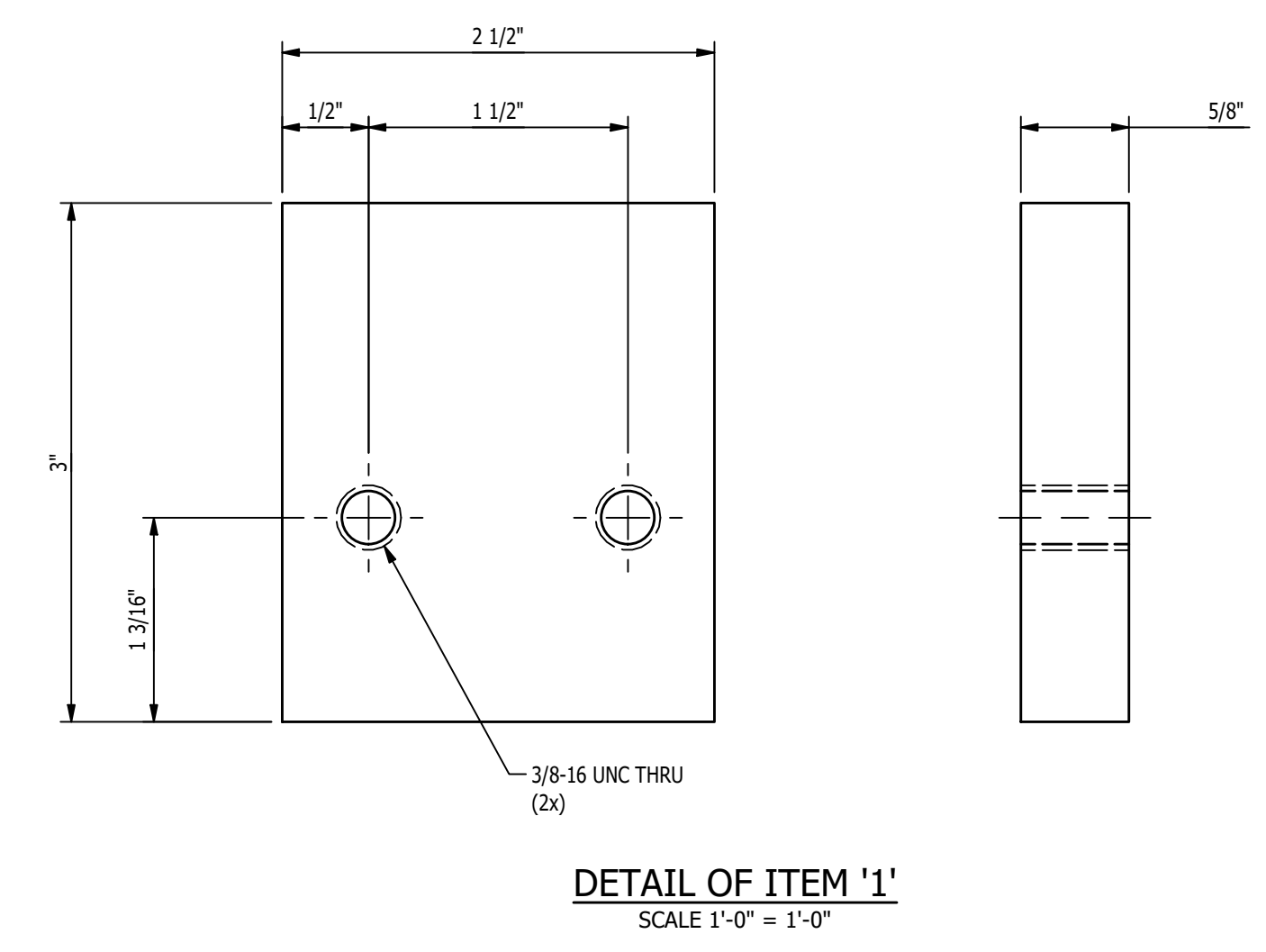
FRACTIONS = ±1/16"
ANGLES = ±1°30'

BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING

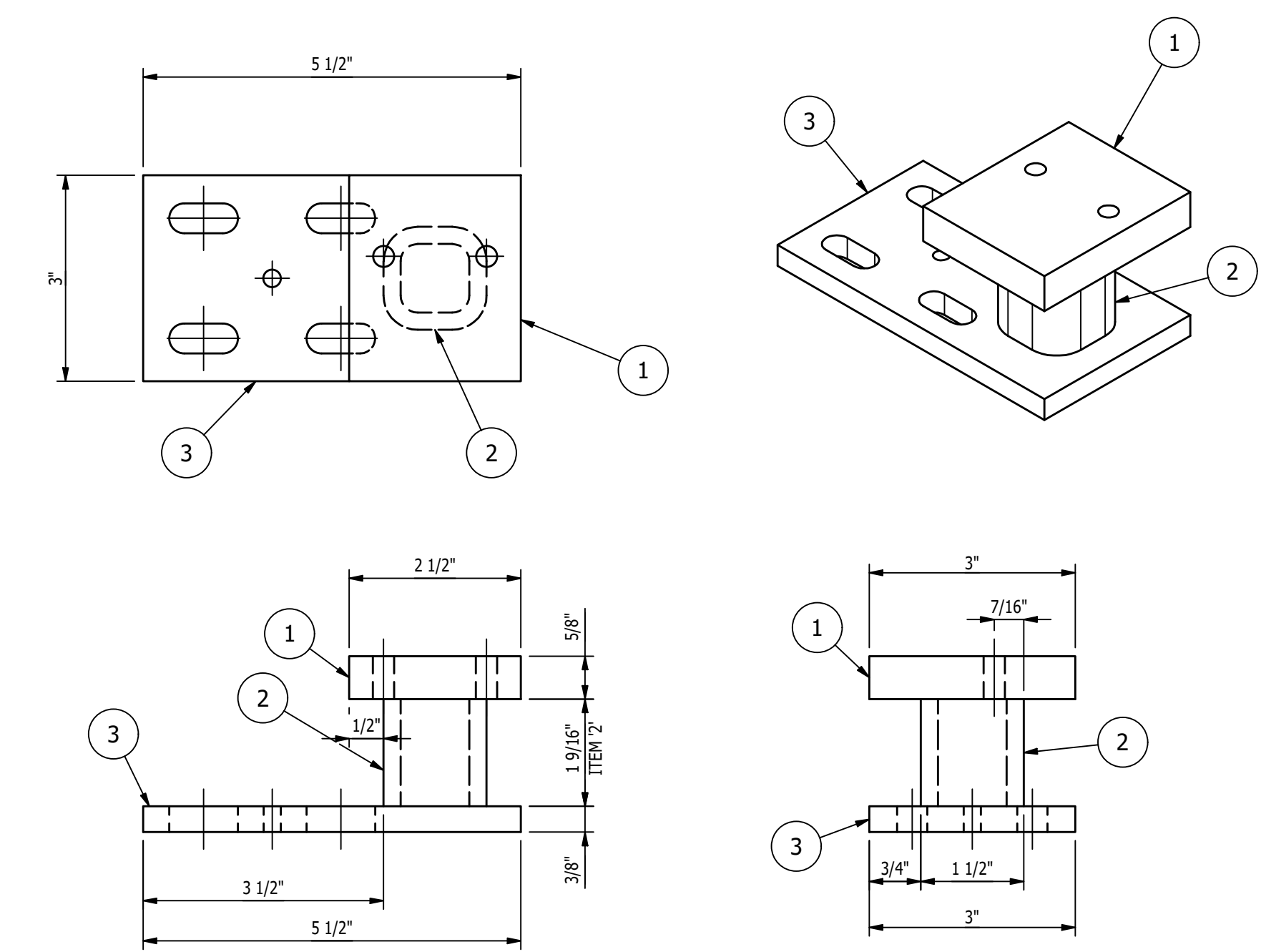
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D416A			
1	1	BAR 5/8 x 2 1/2	3"		
2	1	HSS 1 1/2 x 1 1/2 x 1/4 A500 GR. C	1 9/16"		
3	1	BAR 3/8 x 3	5 1/2"		
		MK-D416B			
1	1	BAR 5/8 x 2 1/2	3"		
2	1	HSS 1 1/2 x 1 1/2 x 1/4 A500 GR. C	1 9/16"		
3	1	BAR 3/8 x 3	5 1/2"		



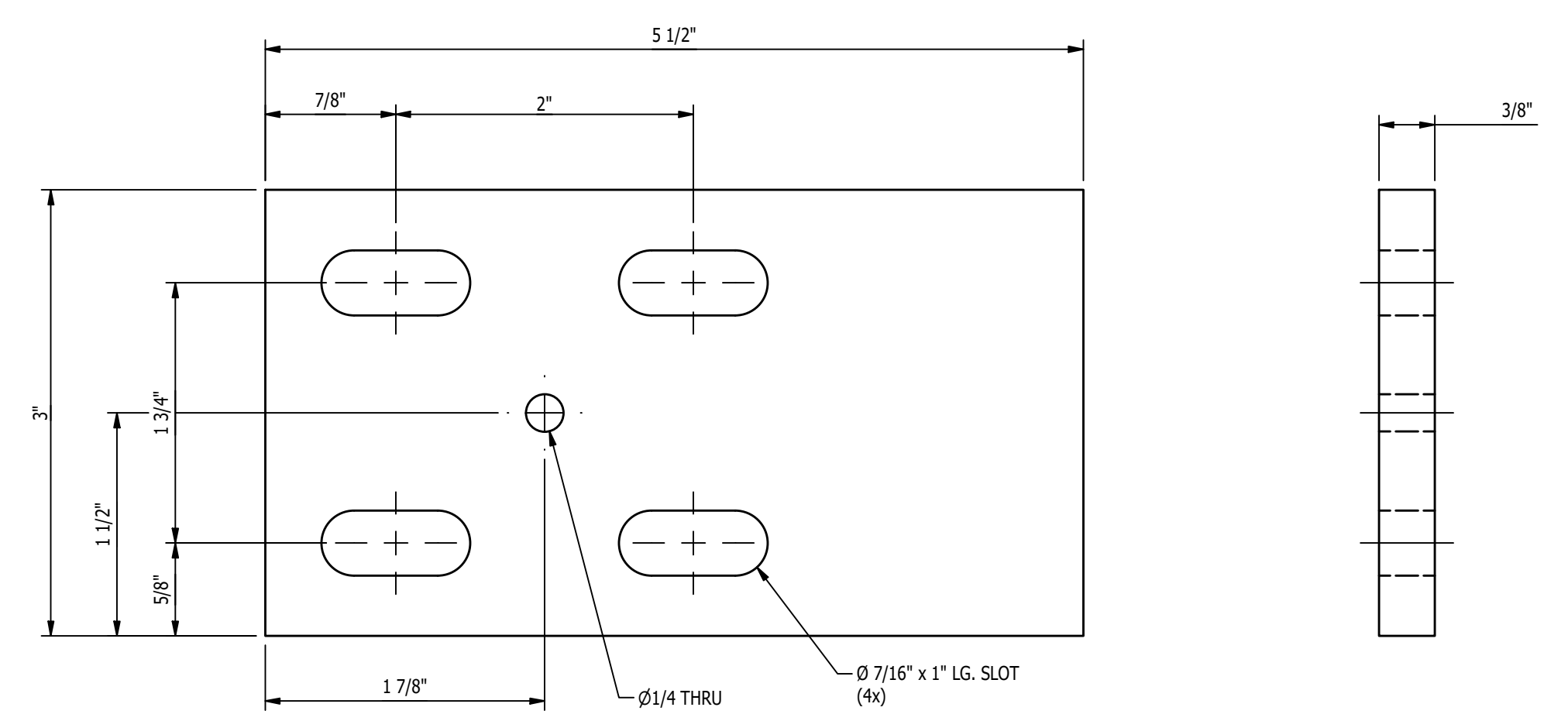
MK-D416A ~ REAR FORK DETAIL STANCHION, L.H.
SCALE 6"=1'-0"



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



MK-D416B ~ REAR FORK DETAIL STANCHION, R.H.
SCALE 6"=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.

REV	BY	DATE	DESCRIPTION	APP
A	MC	10/21/22	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.
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TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RPM
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D416	DWG DATE: 9/1/22
REV: A	JOB No: 22068

MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
North, MI 48075
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.m4magnum.com

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

GENERAL NOTES:

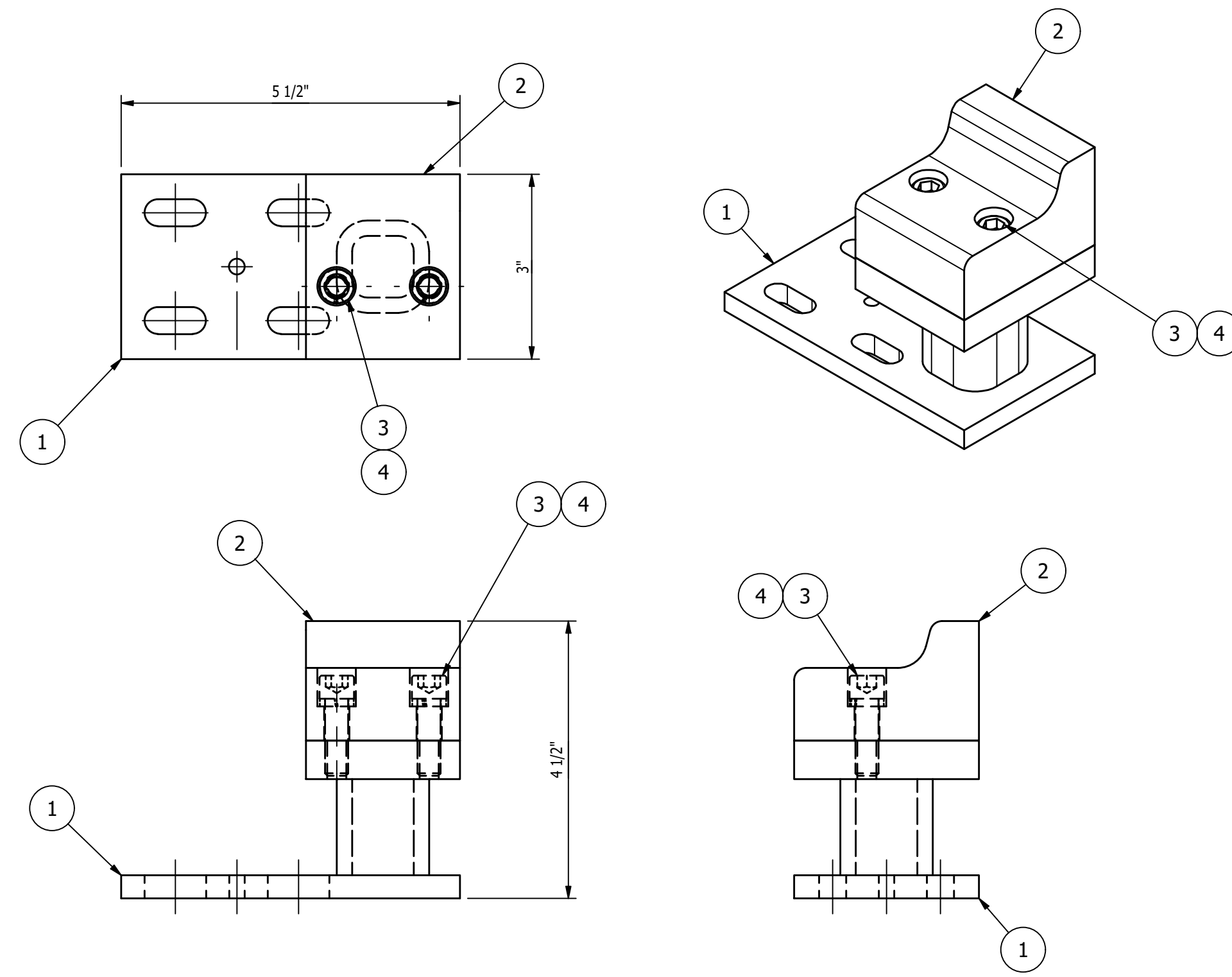
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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

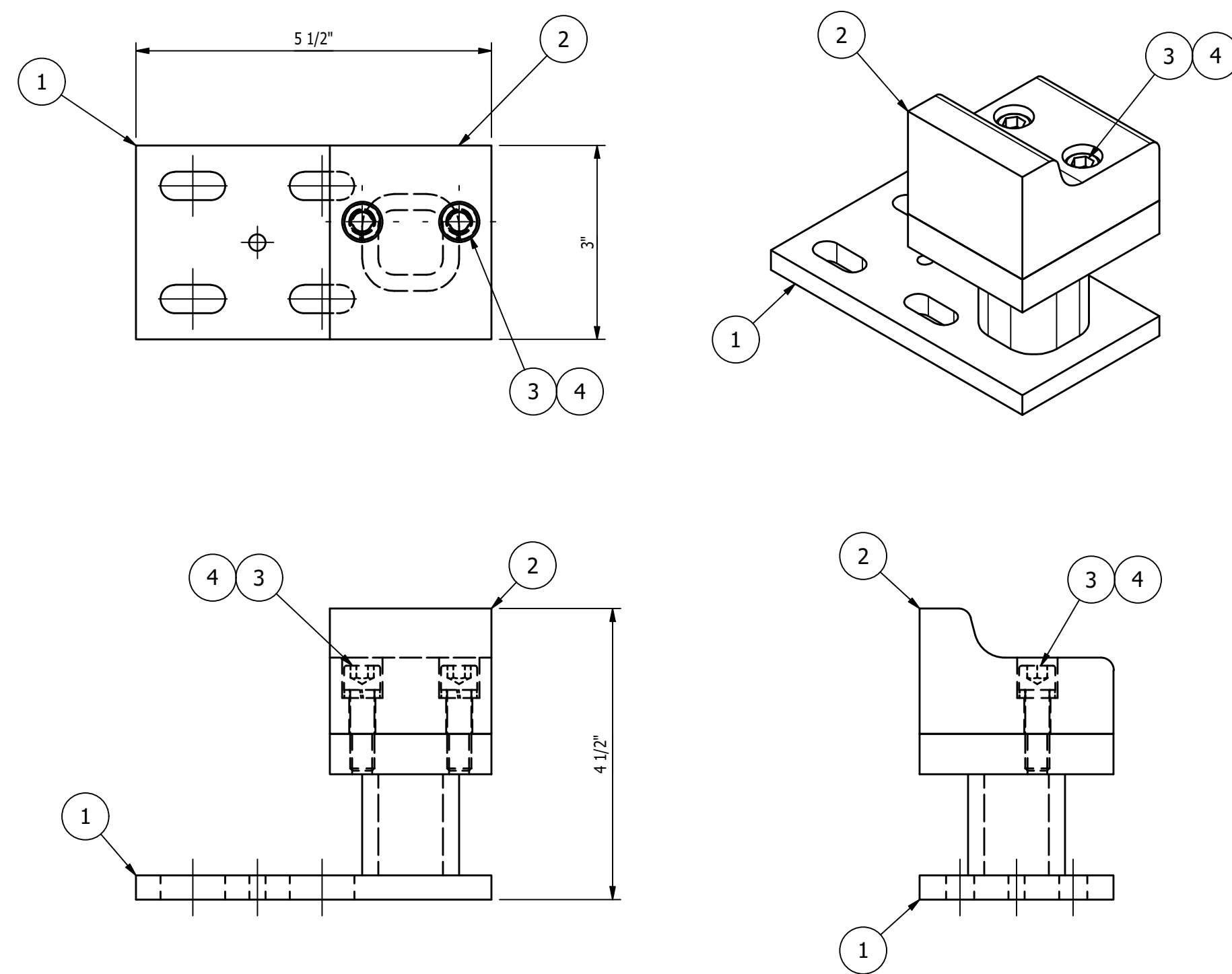
WELDS:
- ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

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

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



MK-D417A ~ REAR FORK DETAIL ASSEMBLY, L.H.
SCALE 6"=1'-0"




MK-D417B ~ REAR FORK DETAIL ASSEMBLY, R.H.
SCALE 6"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D417A			
1	1	MK-D416A ~ REAR FORK DETAIL STANCHION			
2	1	MK-D418A ~ REAR FORK DETAIL			
3	2	3/8-16UNC x 1 1/4" LG. HEX SOCKET HEAD CAP SCREW			
4	2	3/8 HIGH COLLAR SPRING LOCK WASHER			
		MK-D417B			
1	1	MK-D416B ~ REAR FORK DETAIL STANCHION			
2	1	MK-D418A ~ REAR FORK DETAIL			
3	2	3/8-16UNC x 1 1/4" LG. HEX SOCKET HEAD CAP SCREW			
4	2	3/8 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
 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	10/21/22	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.

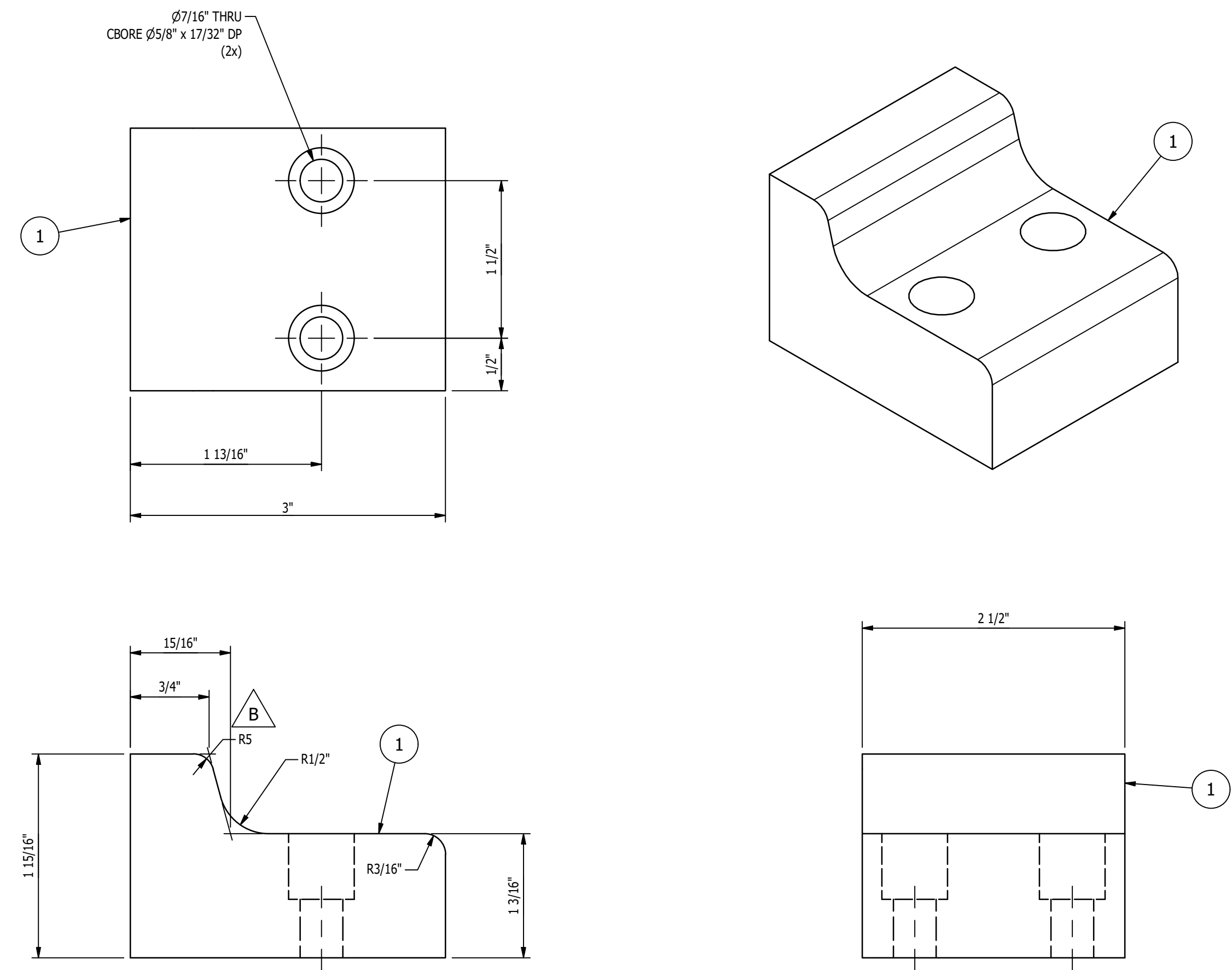
TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RPM
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D417	DWG DATE: 9/1/22
REV: A	JOB No: 22096

MAGNUM Consulting
 41100 Clarkston Rd.
 Suite 125
 Novi, MI 48275
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D417

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-D418A			
1	1	BAR 2 1/2 x 3 (1045)	1 15/16"		



MK-D418A ~ REAR FORK DETAIL
SCALE 1'-0" = 1'-0"

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

PAINT NOTES:
DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/1/2022	ADDED RADIUS	
A	MC	10/21/22	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: RPM
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D418	DWG DATE: 9/2/22
REV: B	JOB No: 22096

MAGNUM CONSULTING

41100 QuakerRoad Rd.
Suite 125
West, MI 48375

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D418

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:

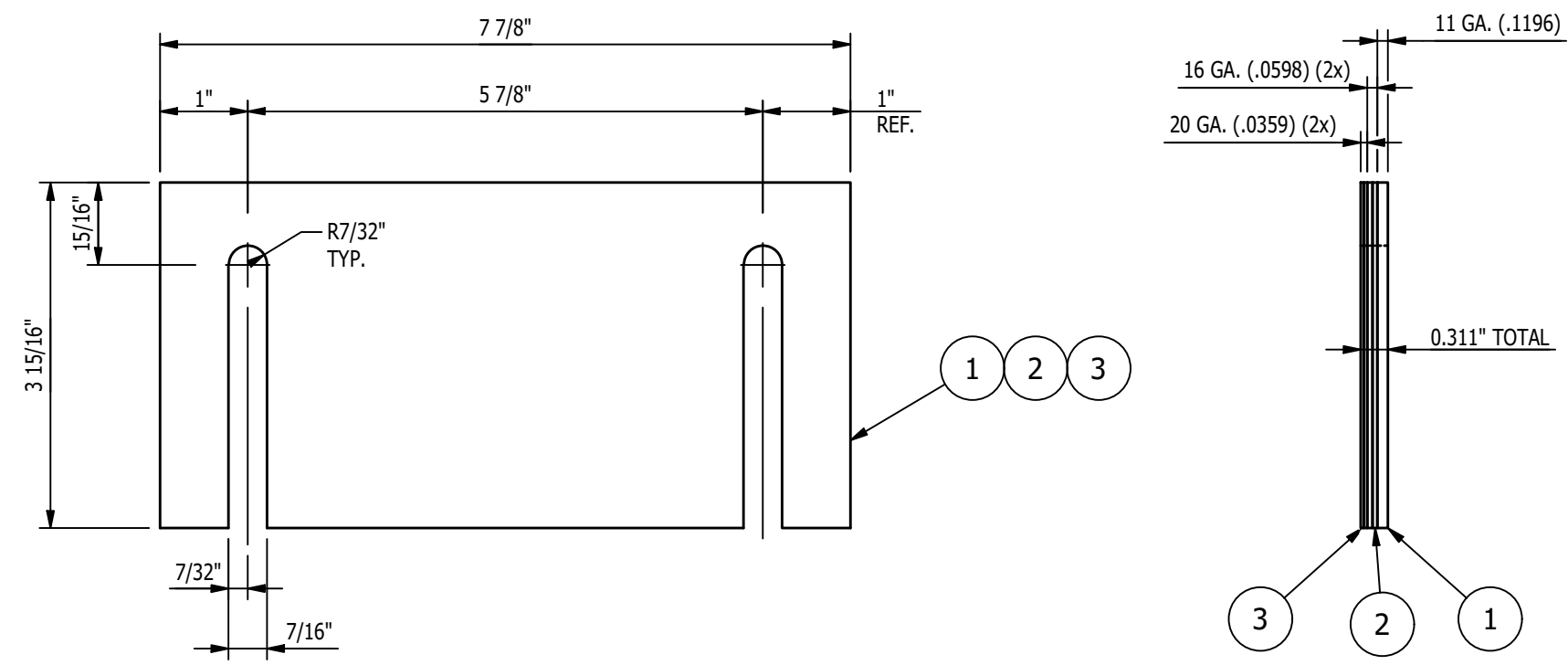
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

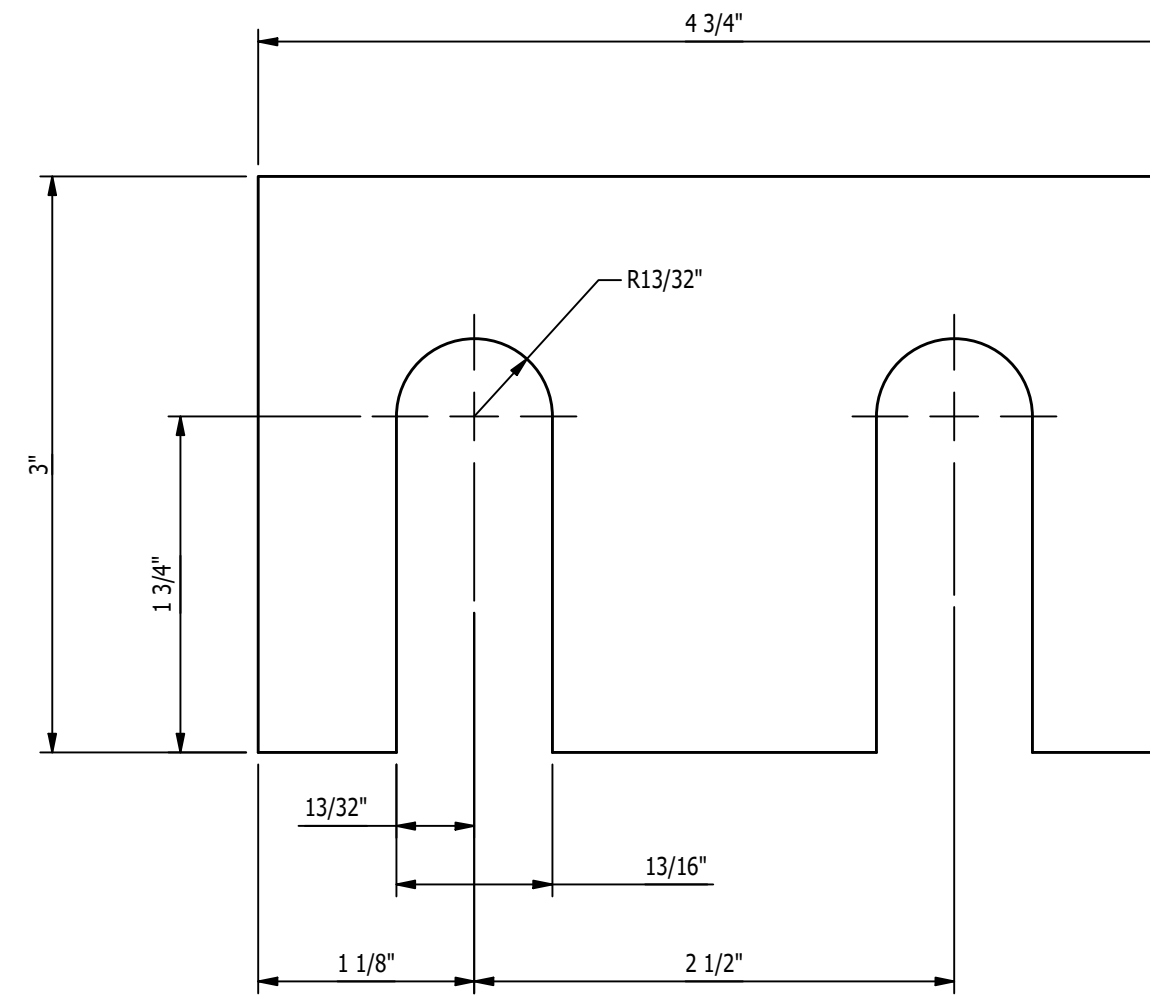
WELDS:
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

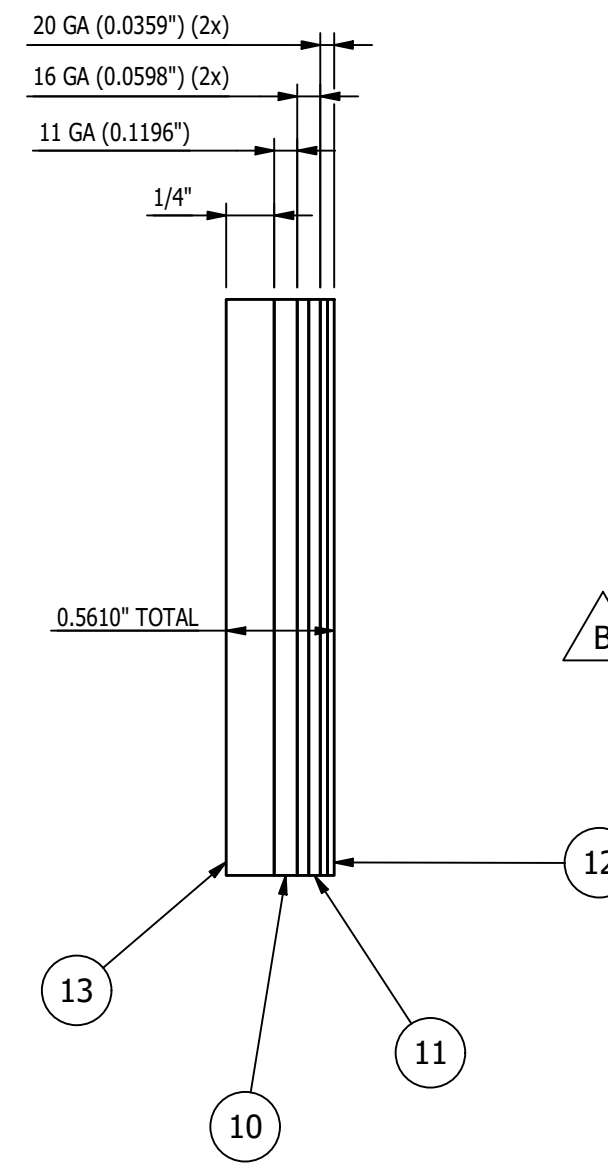
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



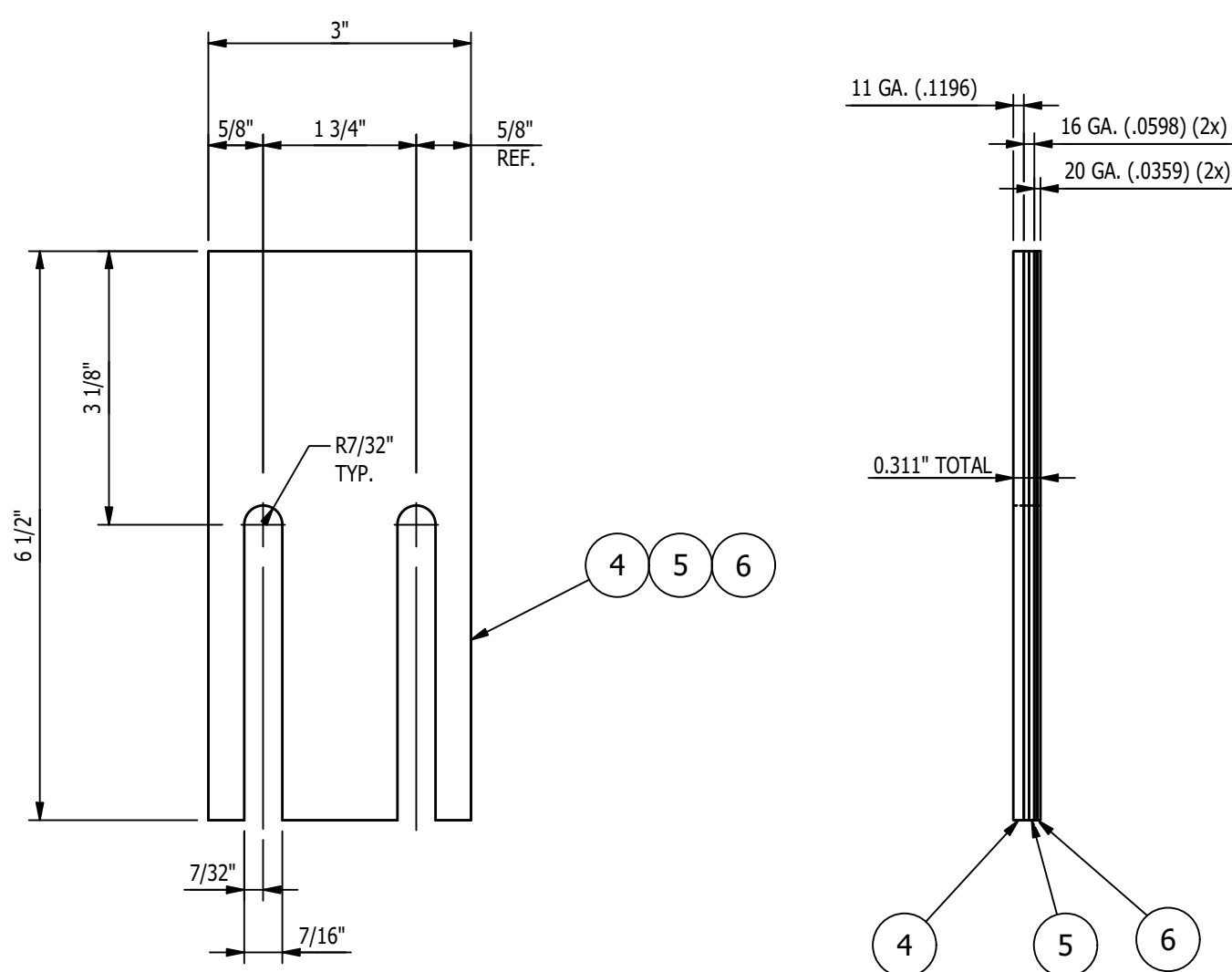
MK-D419A ~ SHIM PACK
SCALE 6"=1'-0"



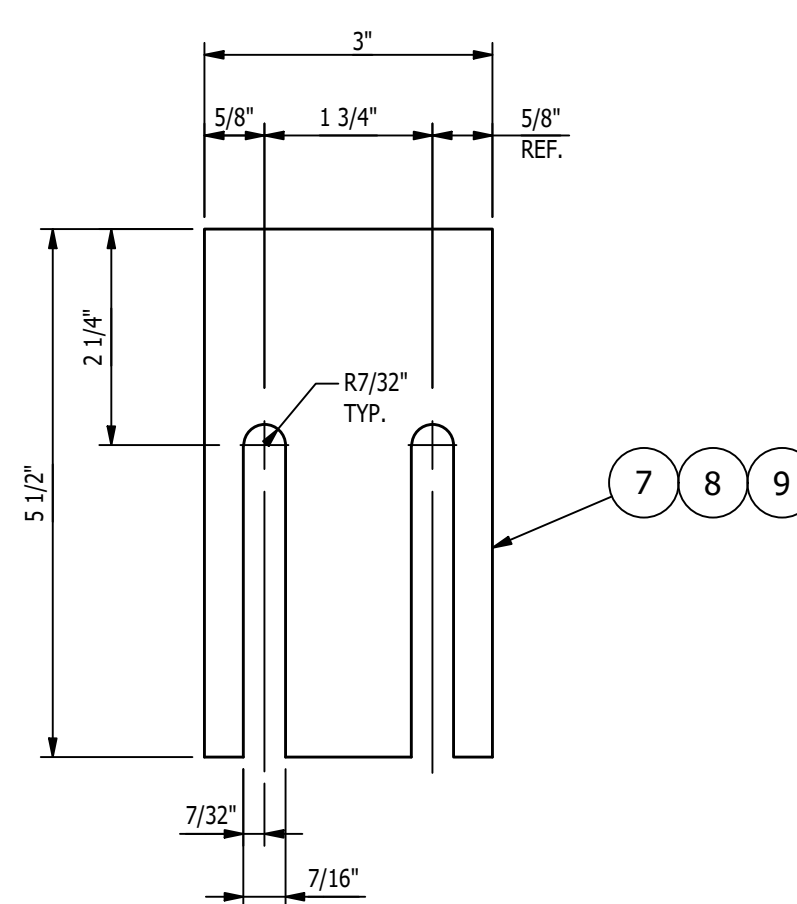
MK-D419D ~ SHIM PACK
SCALE 1'-0" = 1'-0"



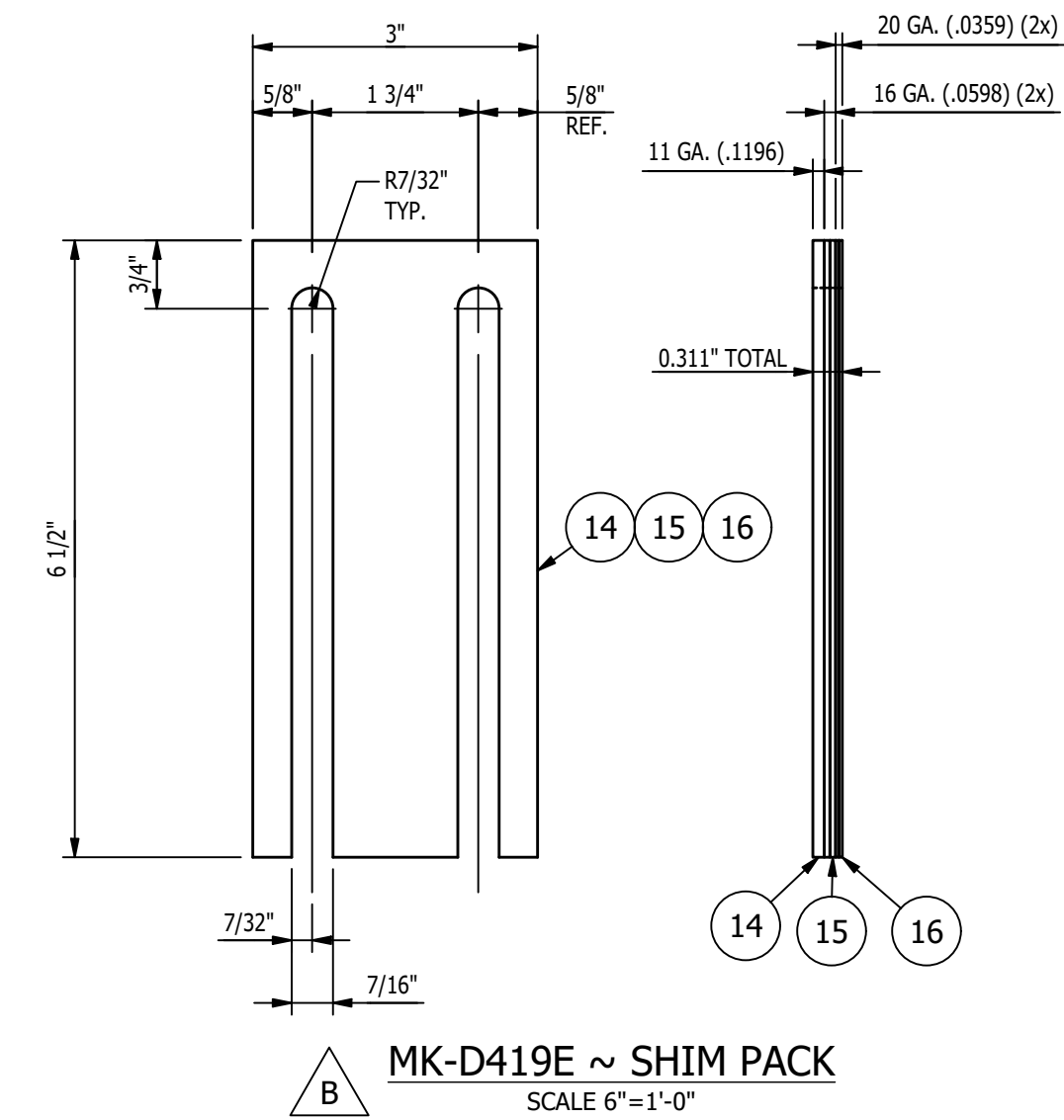
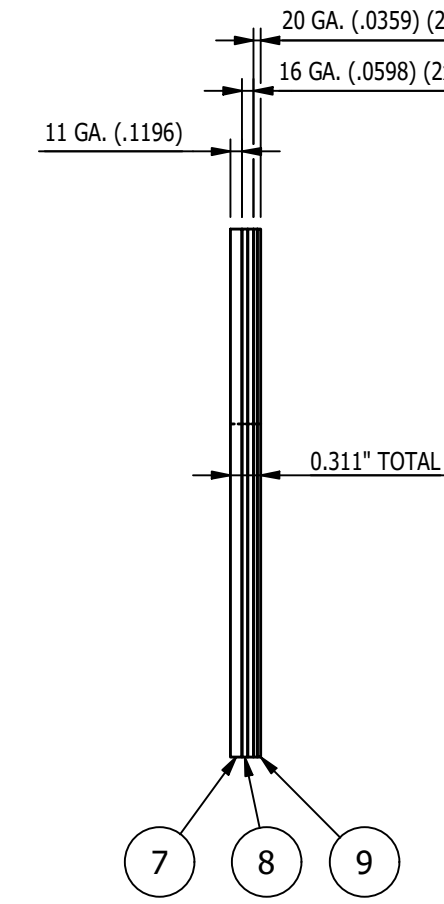
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
MK-D419A					
1	1	SHT 11 GA x 3 15/16"	7 7/8"		
2	2	SHT 16 GA x 3 15/16"	7 7/8"		
3	2	SHT 20 GA x 3 15/16"	7 7/8"		
MK-D419B					
4	1	SHT 11 GA x 3	6 1/2"		
5	2	SHT 16 GA x 3	6 1/2"		
6	2	SHT 20 GA x 3	6 1/2"		
MK-D419C					
7	1	SHT 11 GA x 3	5 1/2"		
8	2	SHT 16 GA x 3	5 1/2"		
9	2	SHT 20 GA x 3	5 1/2"		
MK-D419D					
10	1	SHT 11 GA x 3	4 3/4"		
11	2	SHT 16 GA x 3	4 3/4"		
12	2	SHT 20 GA x 3	4 3/4"		
13	1	BAR 1/4 x 3	4 3/4"		
MK-D419E					
14	1	SHT 11 GA x 3	6 1/2"		
15	2	SHT 16 GA x 3	6 1/2"		
16	2	SHT 20 GA x 3	6 1/2"		



MK-D419B ~ SHIM PACK
SCALE 6"=1'-0"



MK-D419C ~ SHIM PACK
SCALE 6"=1'-0"



MK-D419E ~ SHIM PACK
SCALE 6"=1'-0"

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

PAINT NOTES:
DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/8/22	ADDED MK-D419E	
A	MC	10/21/22	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: SGS	
CLIENT: VOLVO		CHECKED BY: CW	
DRAWING No. 1875D419		DWG DATE: 9/9/22	
REV: B		JOB No: 22096	

MAGNUM CONSULTING
41100 QuakerRoad Rd.
Suite 125
North, MI 48175
Phone: (248) 773-8833
Fax: (248) 773-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D419

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)

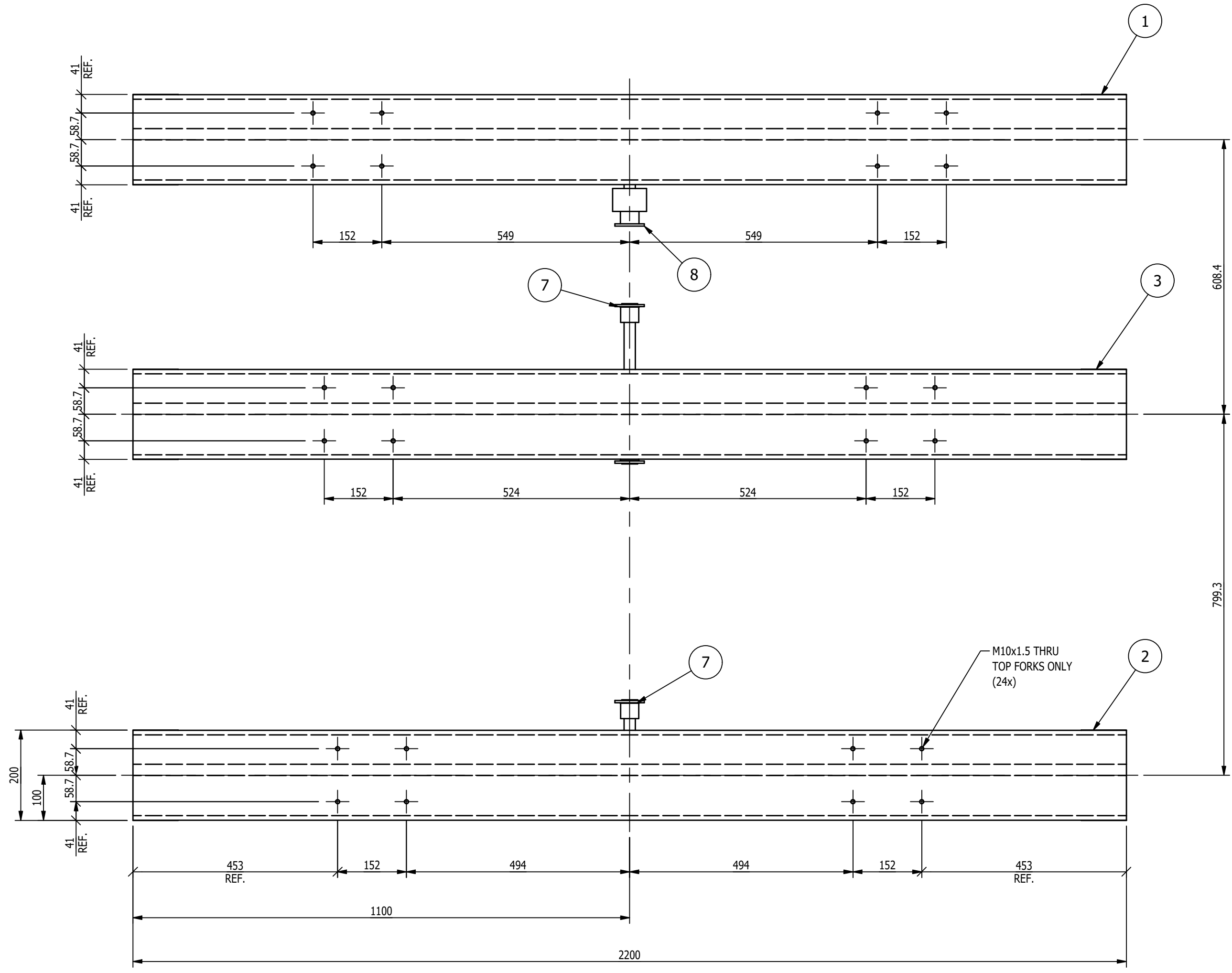
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

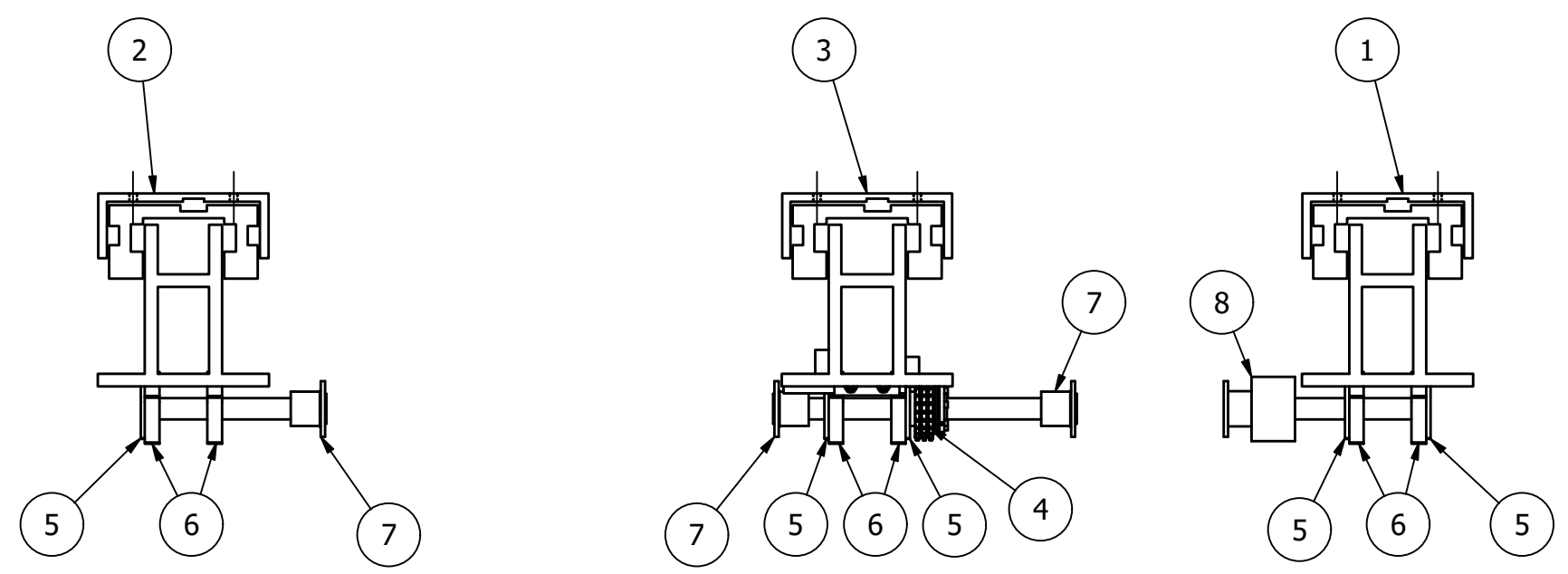
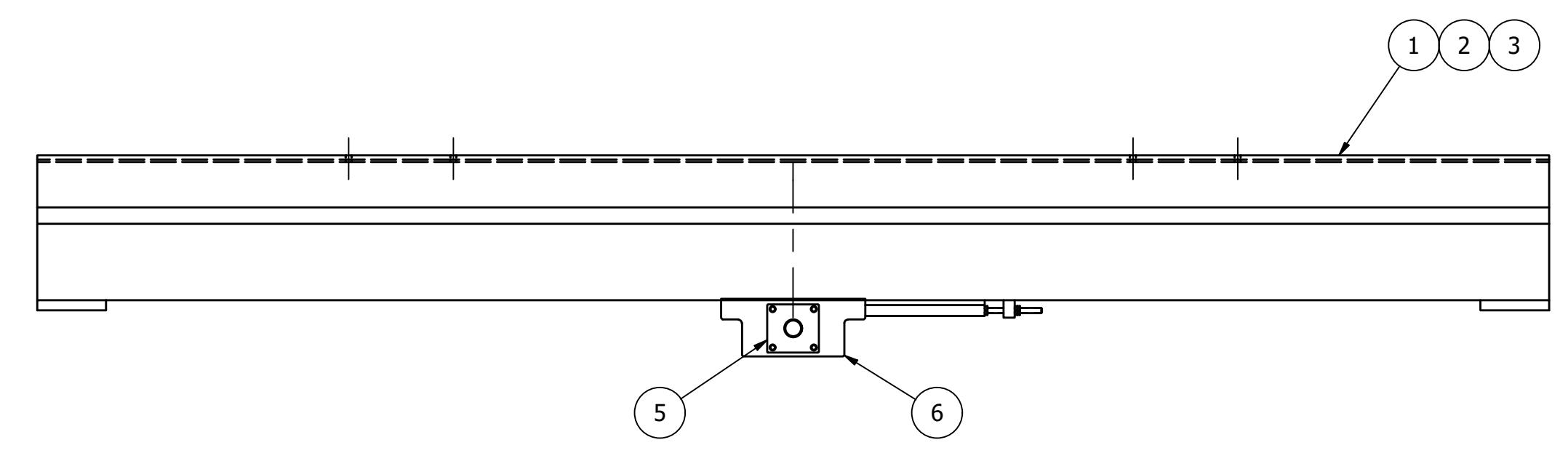
COPIES:

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D421			
1	1	Eurofork SA200x100A ~ FRONT FORK			
2	1	Eurofork SA200x100A ~ REAR FORK			
3	1	Eurofork SA200x100A ~ MIDDLE FORK			
4	1	DRIVE SPROCKRT			
5	5	Flange Bearing			
6	6	Pillow Block			
7	3	Elbe Companion Flange			
8	1	Shaft Coupling			
		TOTAL WEIGHT			



NOTE:
THIS DRAWING IS FOR SIZE & LOCATION OF HOLES FOR MOUNTING OF DETAILS ONLY



MK-D421 ~ EUROFORK TELESCOPIC FORKS, MODEL SD200x100A
SCALE 1 1/2"=1'-0"

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	9/9/2022	FOR FABRICATION	

MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: SGS
CLIENT: VOLVO		CHECKED BY: CW
DRAWING No. 1875D421		DWG DATE: 9/9/2022
REV: A		JOB No: 22096

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

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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:

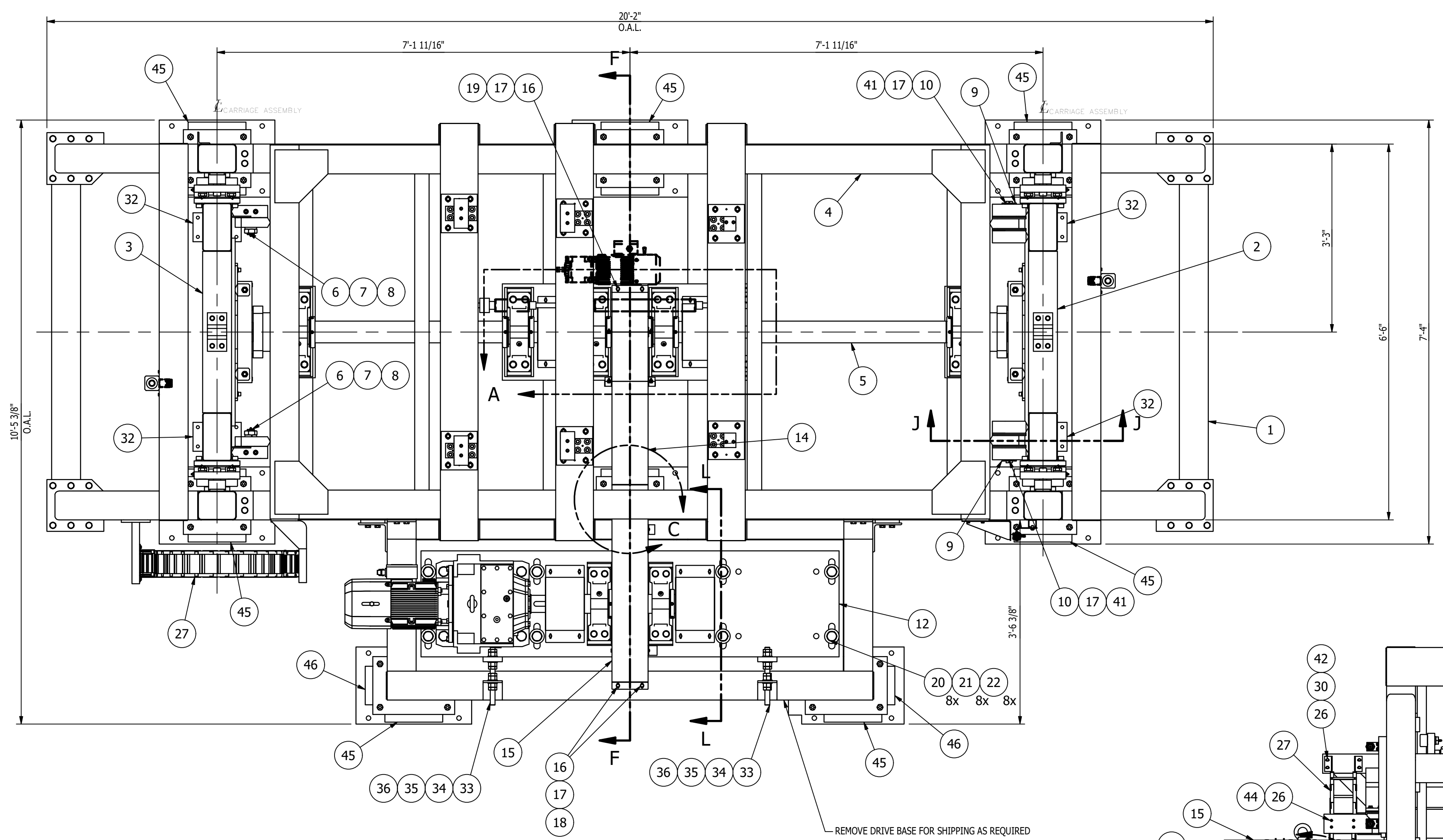
MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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 SLUG TIGHT CONDITION, UNLESS NOTED.

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

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

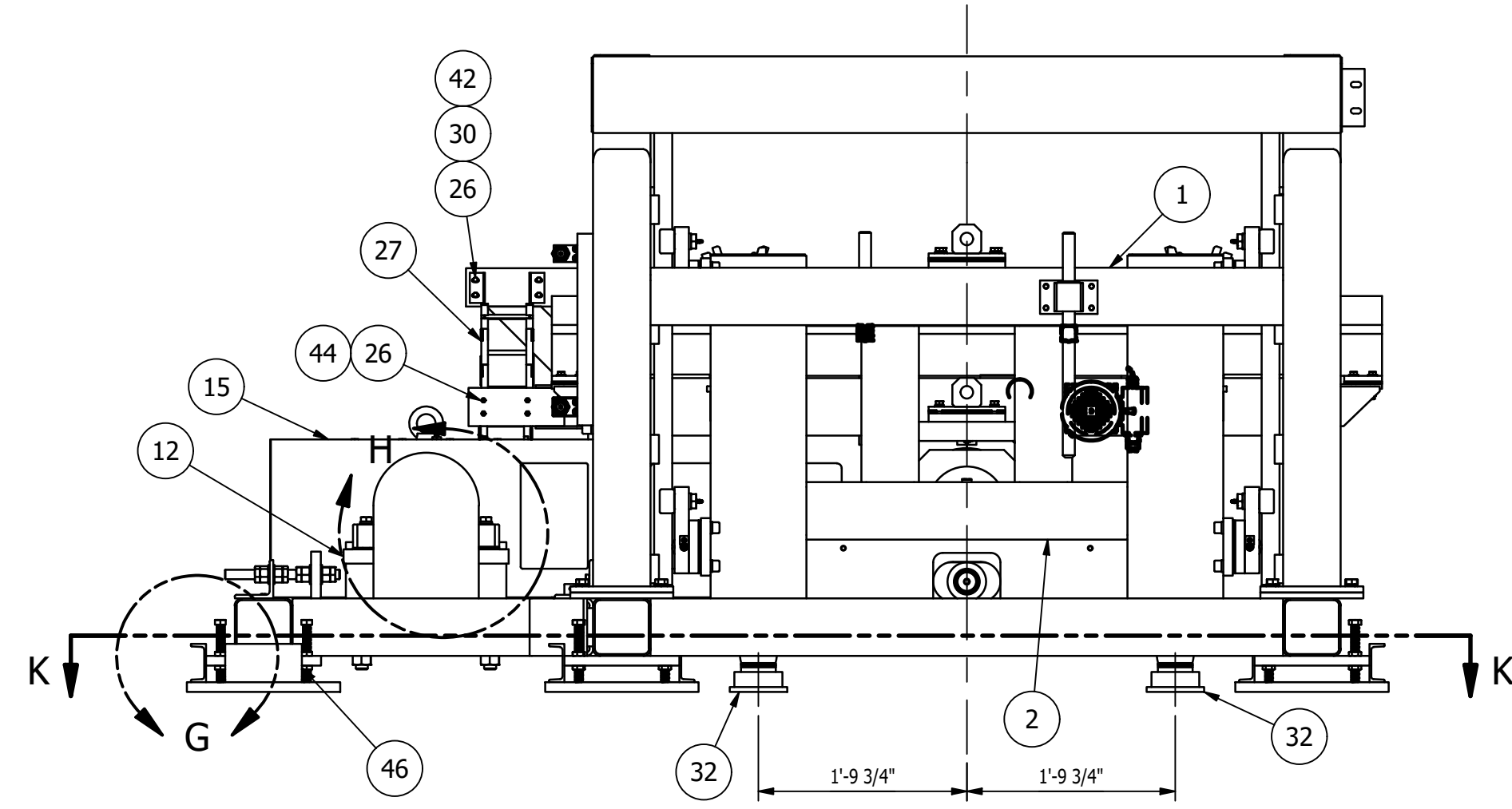
COPIES:
 - ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



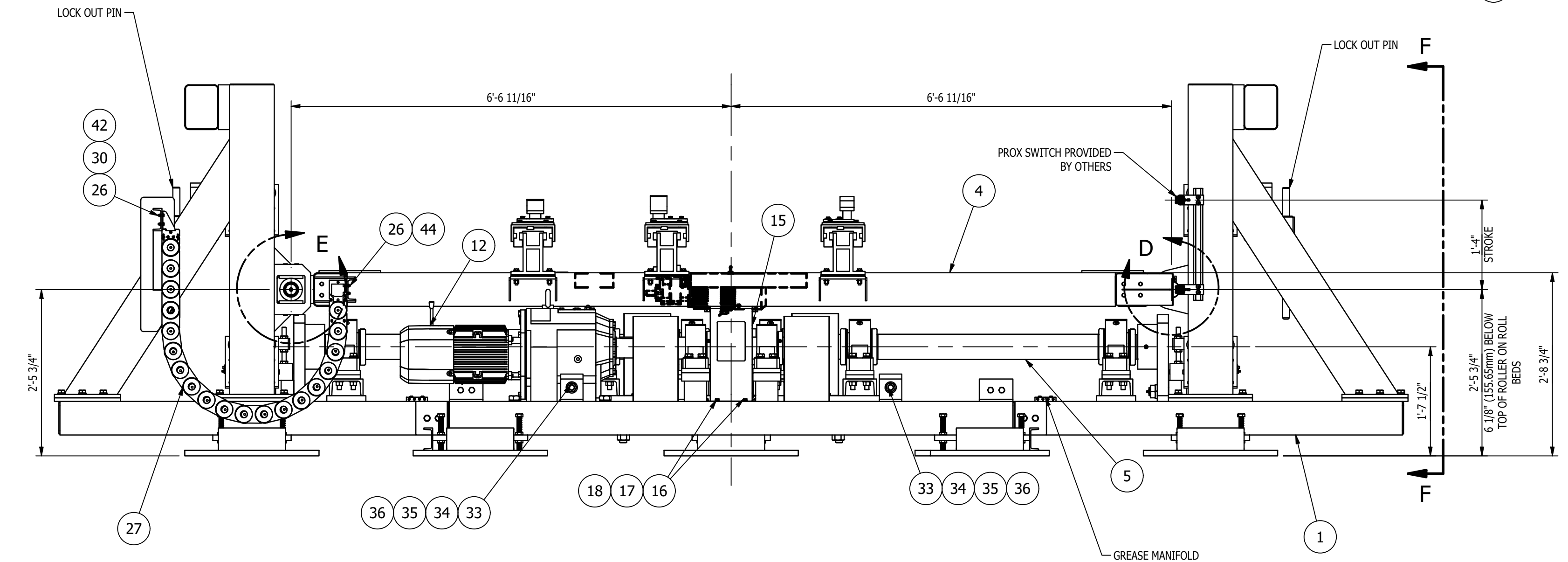
FORK TRAVEL SPEED:
30.50 m/min = 98.4-164 fpm

AVERAGE LIFT SPEED:
 $1770 \times \frac{1}{12} \times \frac{15}{20} \times \frac{16}{12} \times 2 = 28.8 \text{ fpm}$

LIFT TIME:
 $\frac{60}{28.8} \times \frac{16}{12} = 2.78 \text{ s}$



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



MK-D4300 ~ FORK TRANSFER ASSEMBLY
SCALE 3/4"=1'-0"

- SHOP NOTES:**
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
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 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.

WEIGHT OF MOTOR BASE FRAME = 1462 LBS
WEIGHT OF REMAINDER = 14935 LBS

SHEET 1 OF 2

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D430A			
1	1	MK-D431A ~ BASE FRAME ASSEMBLY			
2	1	MK-D439A ~ LIFT CARRIAGE END ASSEMBLY			
3	1	MK-D439B ~ LIFT CARRIAGE END ASSEMBLY			
4	1	MK-D443A ~ MOVING FRAME ASSEMBLY			
5	1	MK-D444A ~ LIFT SHAFT ASSEMBLY			
6	2	PCI PLAIN XR STUD ROLLER, 4" ROLLER OD, 2.25" ROLLER WIDTH, 1 1/2-12 UNF THREAD, PCI PART NO. PXR-4.00-R		25-8	
7	2	1 1/2 SPRING LOCK WASHER			
8	2	1 1/2-12UNF HEX JAM NUT			
9	2	MK-D440A ~ CONNECTION PIN			
10	2	MK-D440F ~ KEEPER PLATE			
11	1	RC-140-3 THREE STAND COTTER ROLLER CHAIN, 82 CHAIN LINKS, 143.5" LG INCLUDING 1 CONNECTION LINK		26-7	
12	1	MK-D436A ~ LIFT MOTOR BASE ASSEMBLY			
13	12	MK-D419D ~ SHIM PACK			
14	1	MK-D446C ~ CHAIN GUARD			
15	1	MK-D446D ~ CHAIN GUARD			
16	8	3/8 TYPE B NARROW FLAT WASHER			
17	12	3/8 SPRING LOCK WASHER			
18	6	3/8-16UNC x 3/4" LG. HEX HEAD CAP SCREW			
19	2	3/8-16UNC x 1 1/2" LG. HEX HEAD CAP SCREW			
20	8	1 1/4 TYPE B REGULAR FLAT WASHER			
21	8	1 1/4 SPRING LOCK WASHER			
22	8	1 1/4-7UNC x 5" LG. HEX HEAD CAP SCREW			
23	1	MK-D446F ~ CHAIN GUARD			
24	1	MK-D446E ~ CHAIN GUARD			
25	4	1/4-20UNC x 3/4" LG. HEX HEAD CAP SCREW			
26	12	1/4-20UNC STOVER LOCK NUT			
27	1	1574 MM TRAVEL KABELSCHLEPP CATRACK, MC0950-4.00"-RMS-380 X 18 LINKS + FAA/MU		26-1	
28	2	MK-D446G ~ COUPLING GUARD			
29	8	1/4-20UNC x 1" LG. HEX HEAD CAP SCREW			
30	12	1/4 TYPE B NARROW FLAT WASHER			
31	8	1/4 SPRING LOCK WASHER			
32	4	MK-D317A ~ PALLET BUMPER STOP			
33	8	1 TYPE A NARROW FLAT WASHER			
34	8	1-8UNC HEX NUT			
35	8	1-8UNC HEX JAM NUT			
36	2	THD. ROD 1-8UNC	1'-0"		
37	24	3/4 SPRING LOCK WASHER			
38	48	3/4 TYPE A NARROW FLAT WASHER			
39	24	3/4-10UNC HEX NUT			
40	24	3/4-10UNC x 6" LG. HEX HEAD BOLT			
41	4	3/8-16UNC x 1" LG. HEX SOCKET HEAD CAP SCREW			
42	4	1/4-20UNC x 7/8" LG. HEX HEAD CAP SCREW			
44	4	1/4-20UNC x 1" LG. HEX SOCKET HEAD CAP SCREW			
45	14	C 4 x 5.4 (SHIP LOOSE)	1'-0"		
46	2	C 4 x 5.4 (SHIP LOOSE)	8"		
47	16	SQ. BAR 3/4	5"		
48	1	MK-D453A ~ DRIP PAN			
49	1	MK-D453B ~ DRIP PAN			
50	1	MK-D453C ~ DRIP PAN			
51	2	MK-D453D ~ DRIP PAN END COVER			
52	6	1/4-20UNC x 7/8" LG. BUTTON HEX SOCKET HEAD CAP SCREW, PLAIN			
53	6	1/4-20UNC HEX NUT, GR-5, PLAIN			
54	3	1/4 FLAT WASHER, PLAIN			

REV	BY	DATE	DESCRIPTION	APP
D	MC	11/18/22	ADDED ITEMS '48' THRU '54', ADDED SECTION 'L-L'	
C	MC	11/8/22	UPDATED GEOMETRY PER ITEMS '1' & '4'	
B	MC	10/31/22	UPDATED GEOMETRY PER ITEM '1', ITEM '11' NOW HAS 82 LINKS WAS 80, ITEM '44' NOW 1/4-20UNC x 1", WAS M6x30mm	
A	MC	10/21/22	FOR FABRICATION	

GENERAL NOTES:

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

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

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

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

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

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. 1875D430

REV: D

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 10/18/22
JOB No: 22096

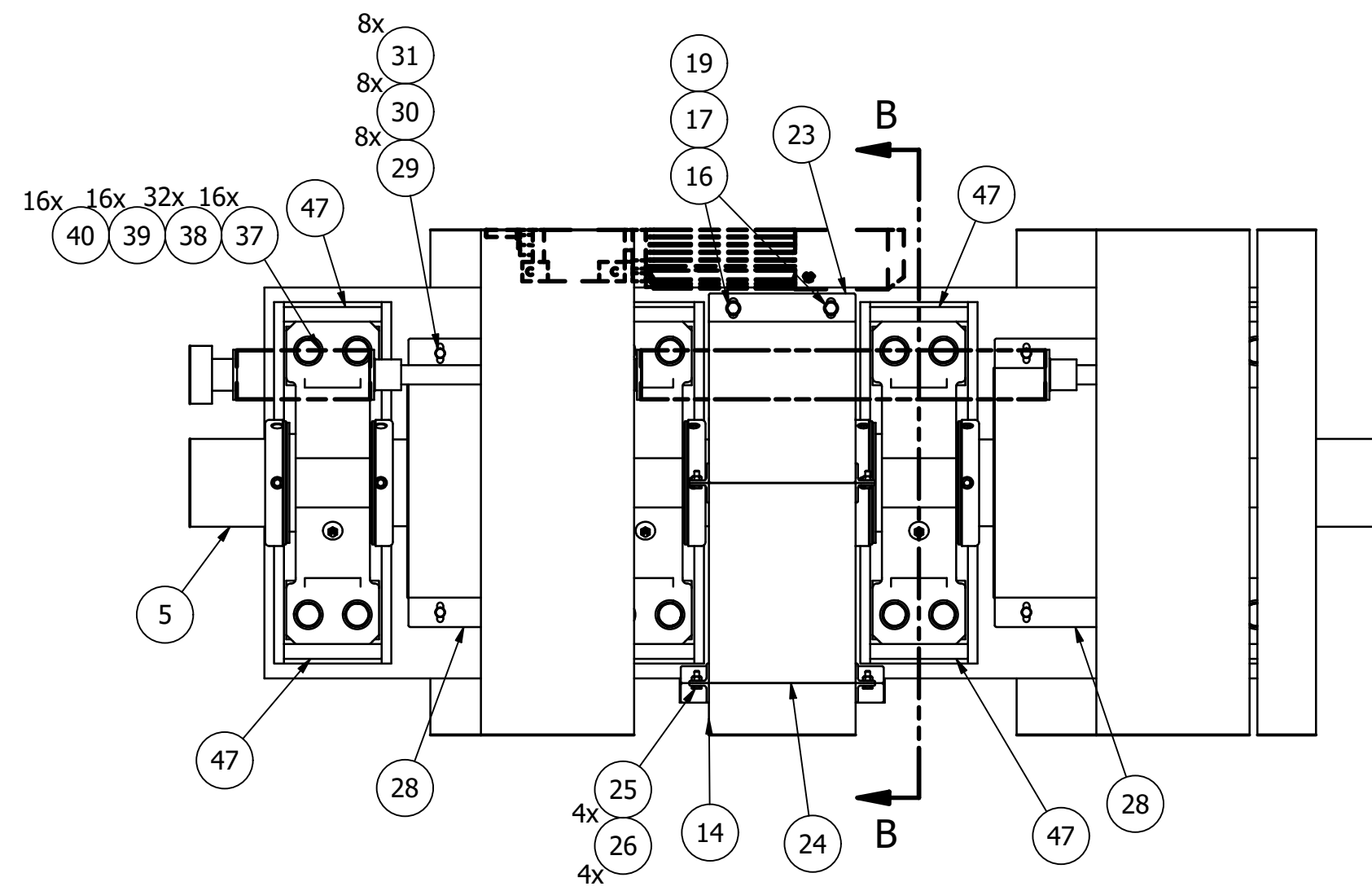
PAINT NOTES:
PAINT ITEMS 45 & 46
ONE SHOP COAT OF LIGHT GREY RAL 7035
DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
North, MI 48065

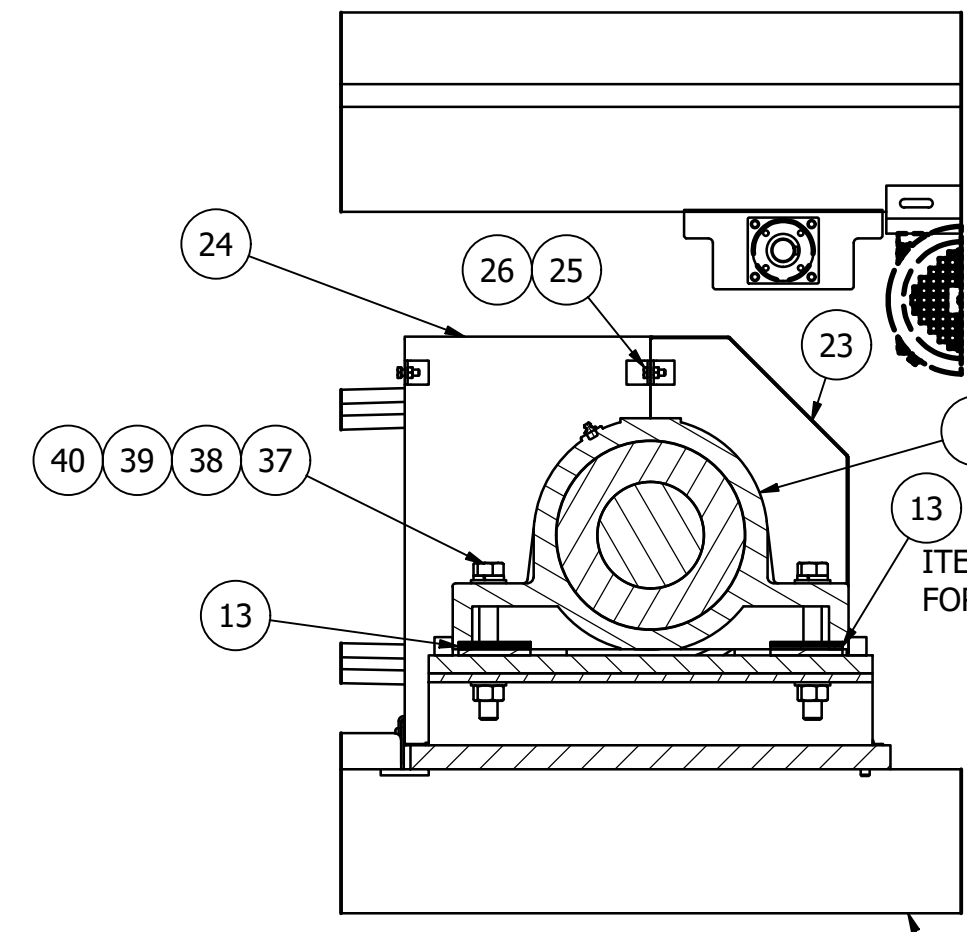
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D430 - REV D

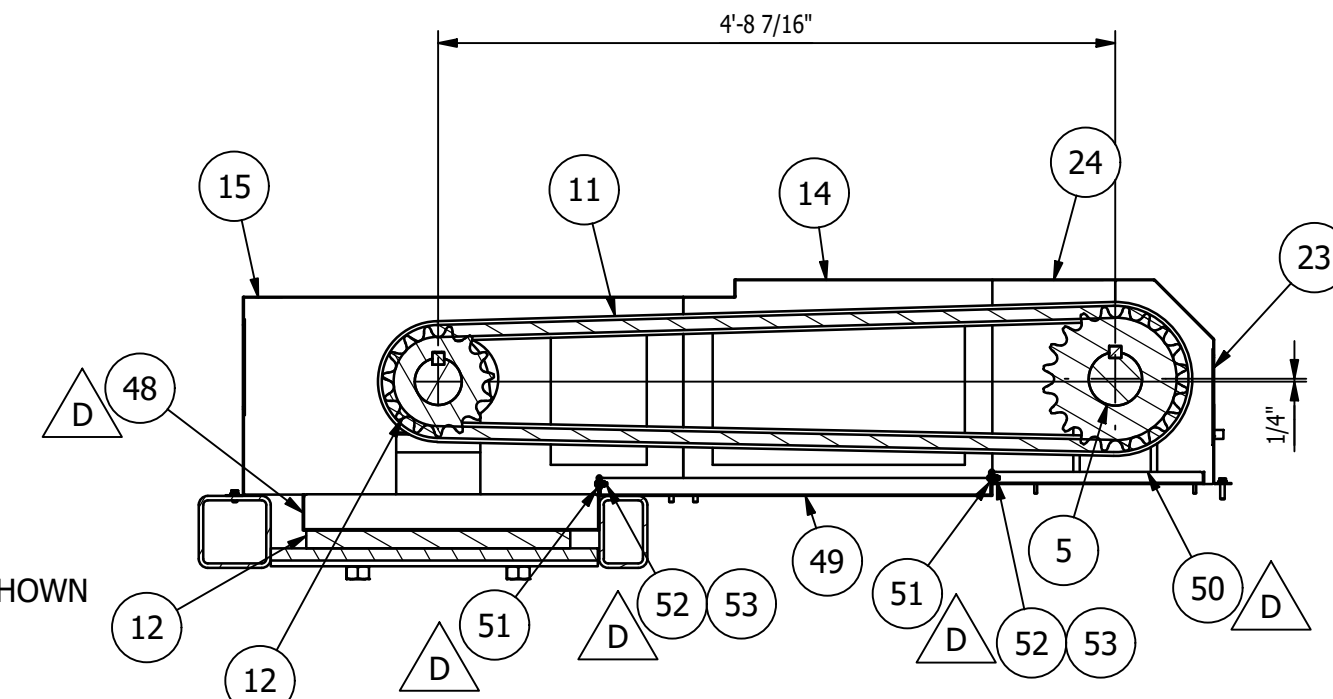
UNLESS OTHERWISE NOTED:
X = ±.060
XX = ±.030
XXX = ±.005
FRACTIONS = ±1/16"
ANGLES = ±1°00'
BREAK ALL SHARP EDGES
DEBURR ALL HOLES
DO NOT SCALE DRAWING



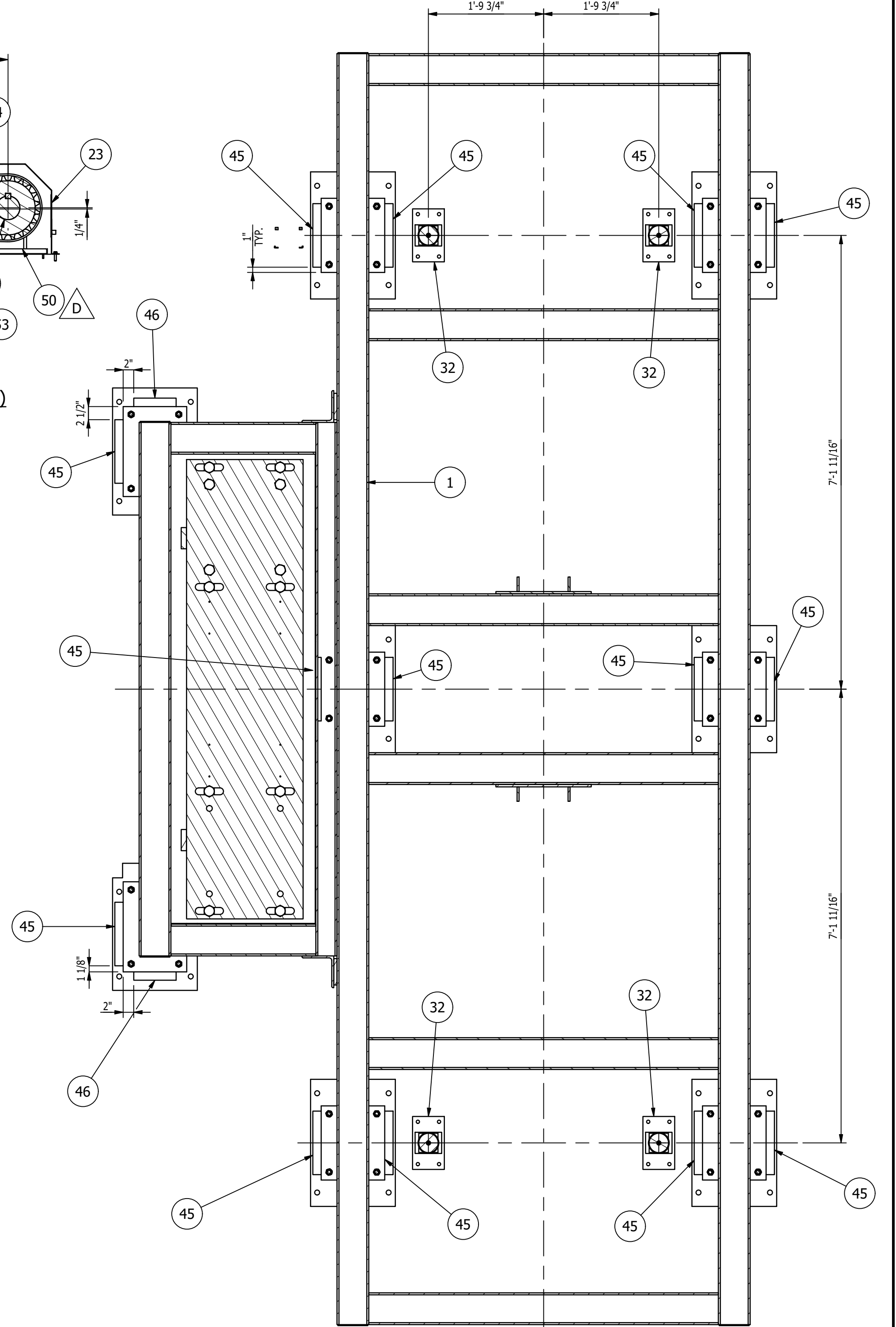
ENLARGED VIEW 'A'
SCALE 1 1/2" = 1'-0"



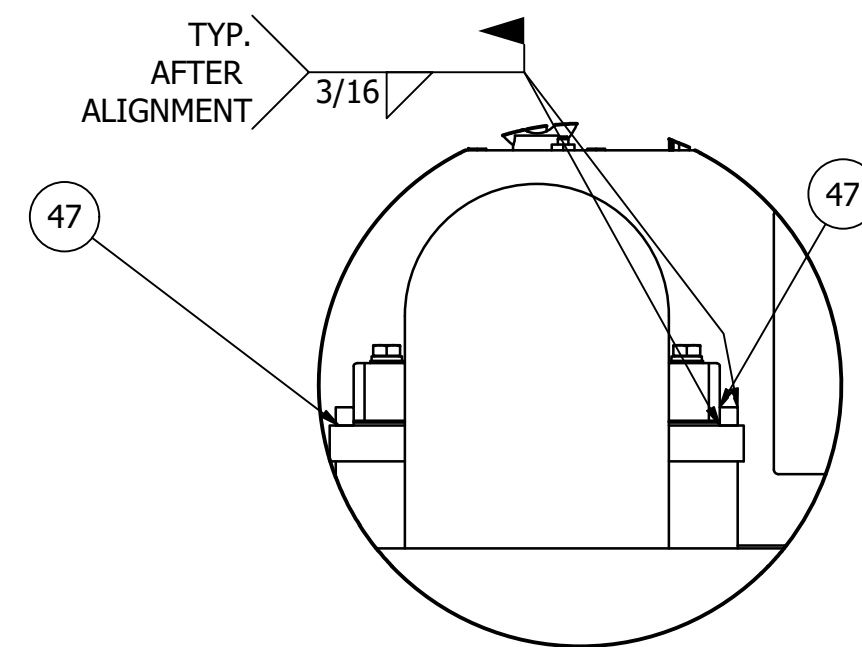
SECTION 'B-B'
SCALE 1 1/2" = 1'-0"



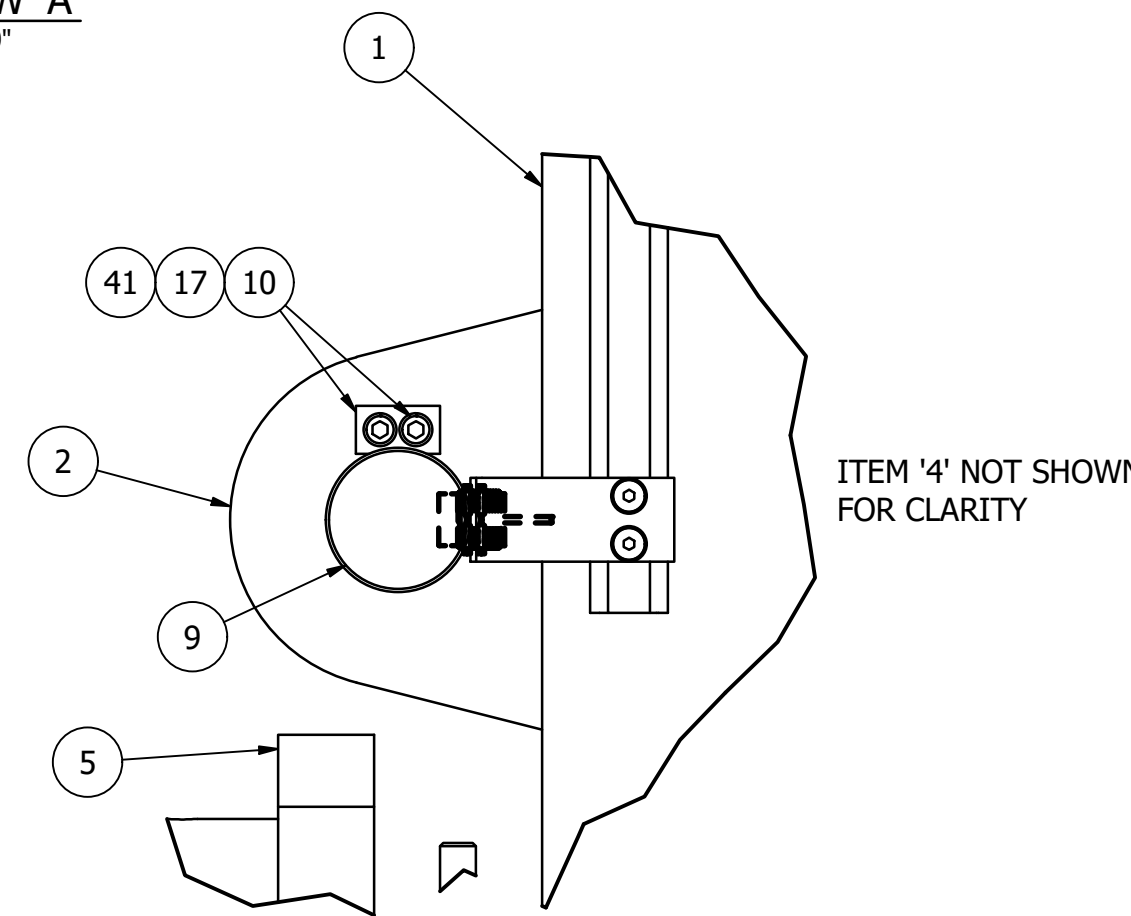
SECTION 'F-F'
(SPROCKETS, CHAIN, GUARDS, & DRIP PAN)
SCALE 3/4" = 1'-0"



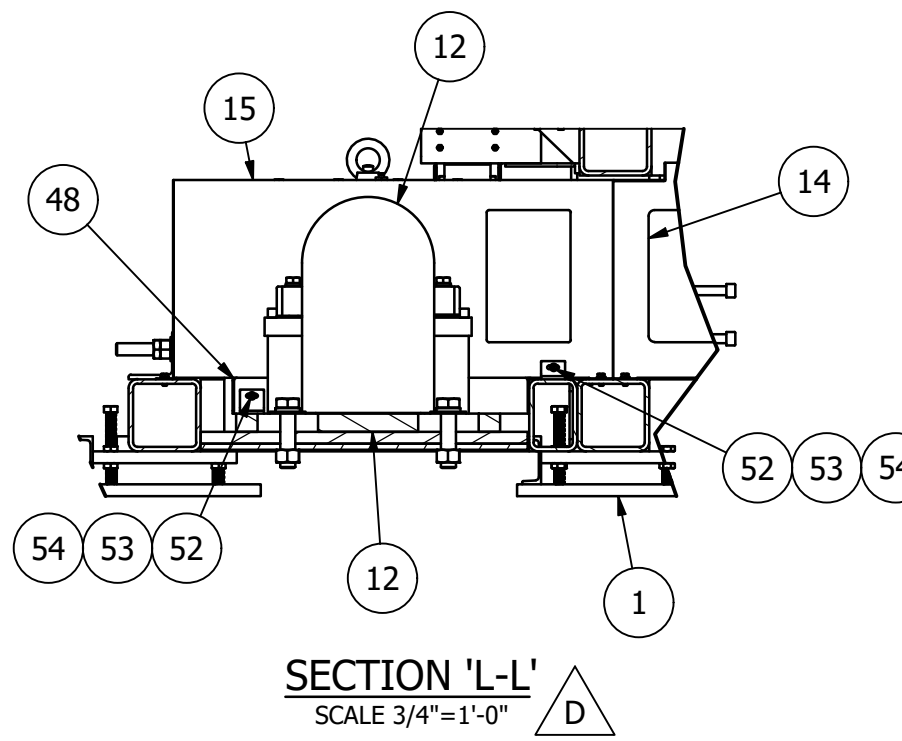
SECTION 'K-K'
SCALE 3/4" = 1'-0"



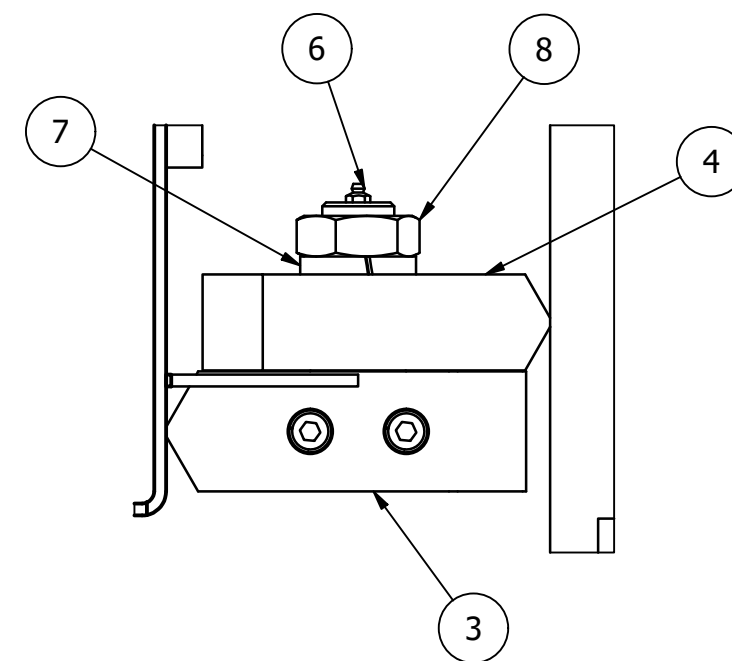
ENLARGED VIEW 'H'
SCALE 1 1/2" = 1'-0"



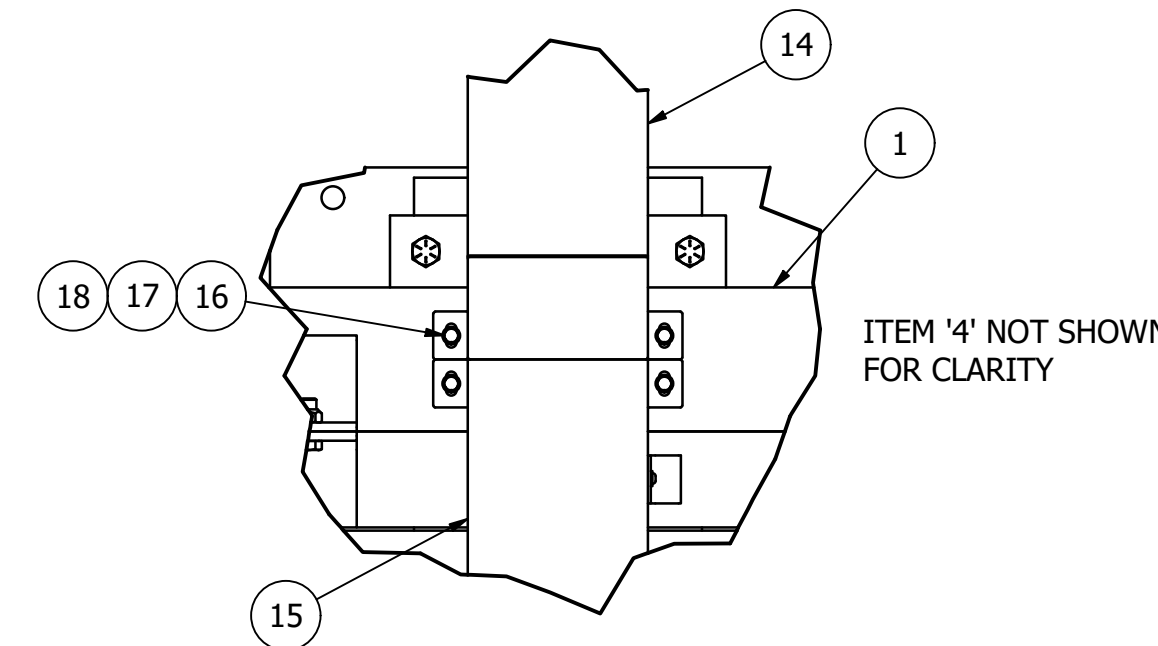
ENLARGED VIEW 'D'
SCALE 3" = 1'-0"



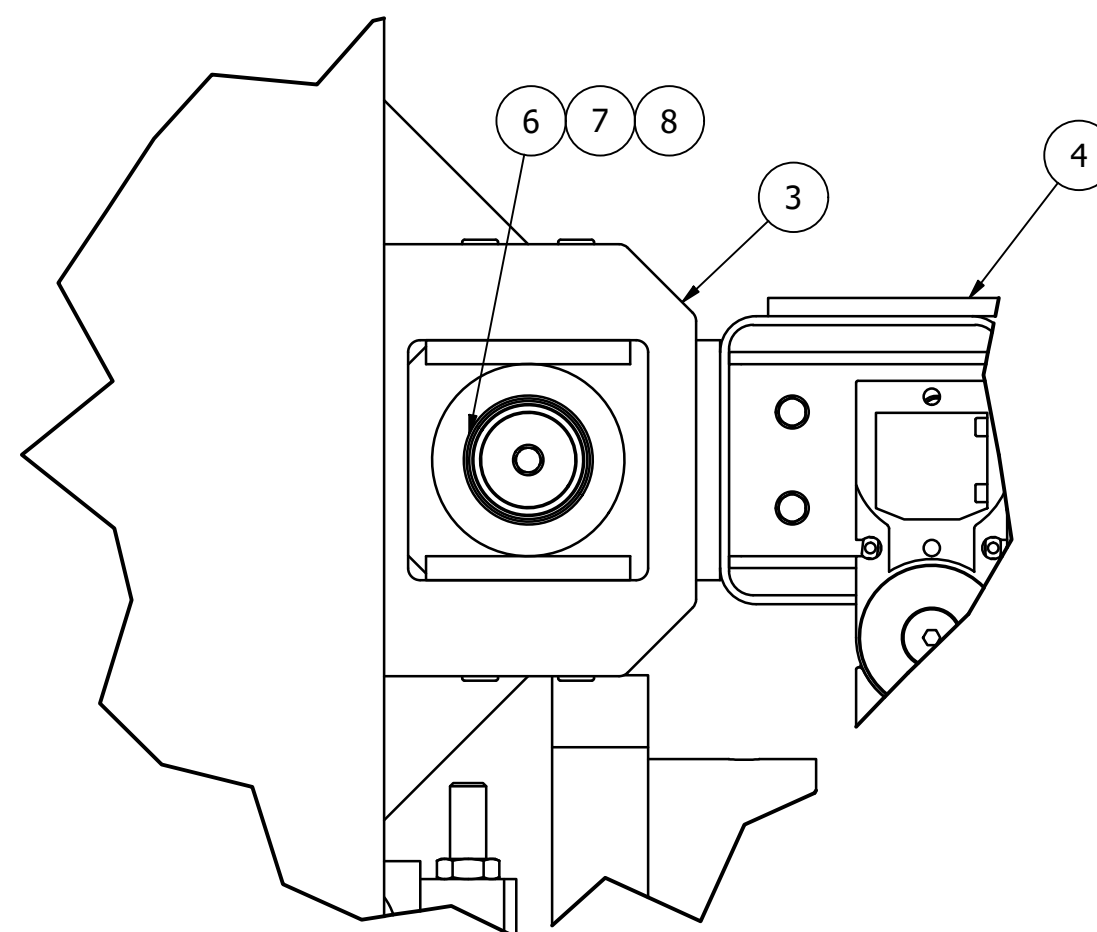
SECTION 'L-L'
SCALE 3/4" = 1'-0"



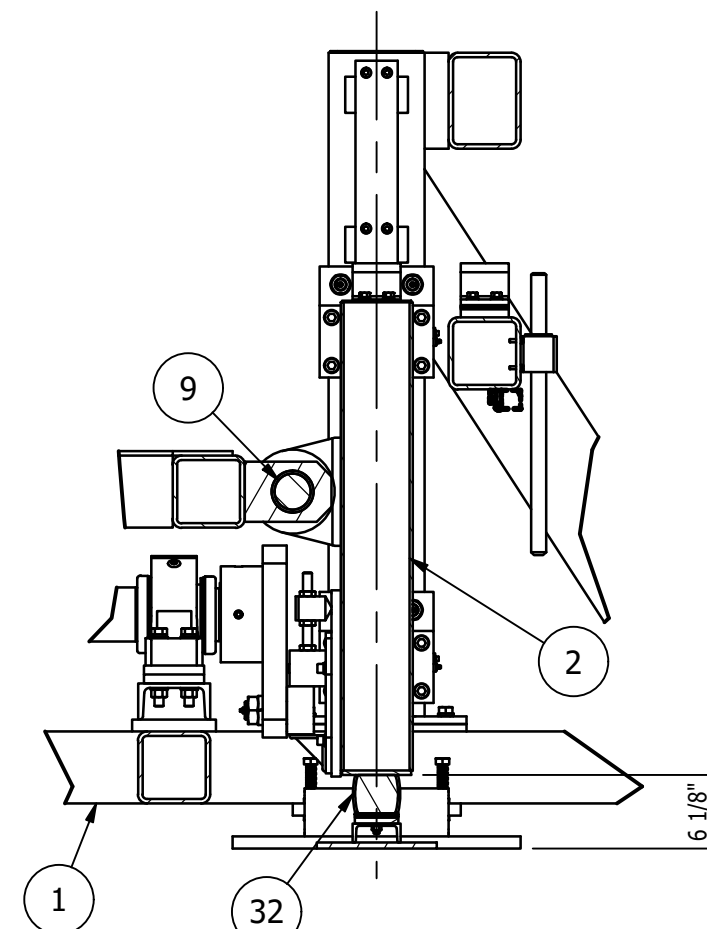
ENLARGED VIEW 'C'
SCALE 1 1/2" = 1'-0"



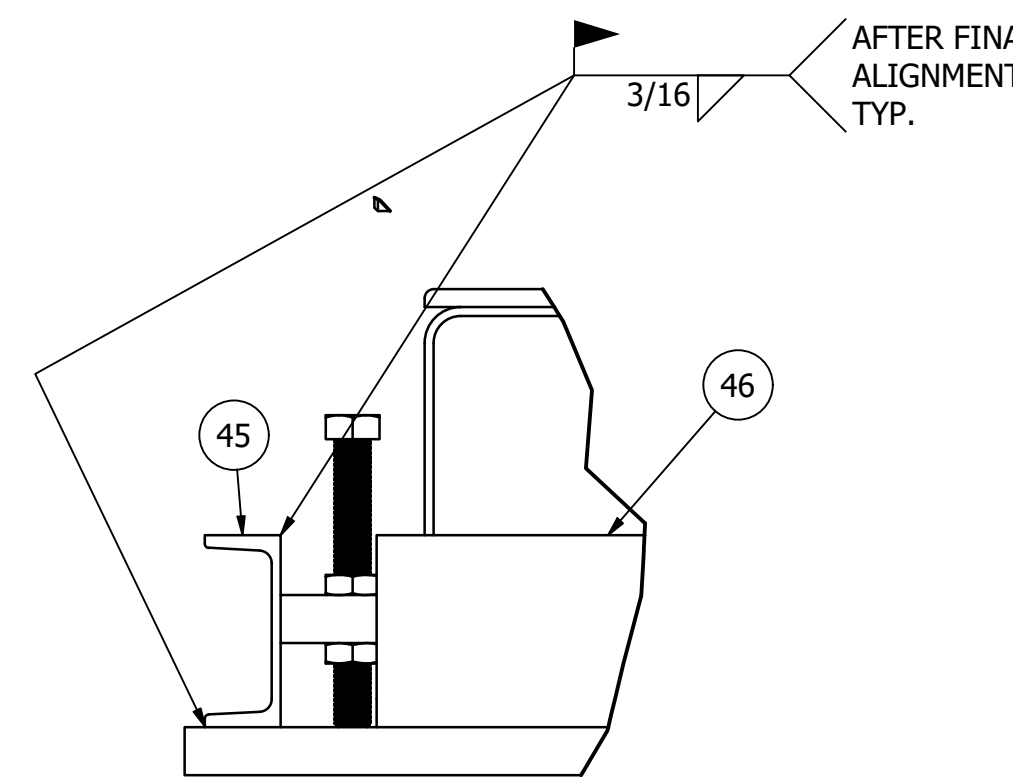
ENLARGED VIEW 'E'
SCALE 1 1/2" = 1'-0"



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



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



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

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
D	MC	11/18/22	ADDED ITEMS '48' THRU '54', ADDED SECTION 'L-L'	
C	MC	11/8/22	UPDATED GEOMETRY PER ITEMS '1' & '4'	
B	MC	10/31/22	UPDATED GEOMETRY PER ITEM '1', ITEM '11' NOW HAS 82 LINKS WAS 80, ITEM '44' NOW 1/4-20UNC x 1", WAS M6x30mm	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A892-GR50 U.N.O.
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 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 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:
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 COPIES:
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MILLER INDUSTRIES
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 PH: 810.373.0322 FAX: 810.373.0326
 www.milic.com

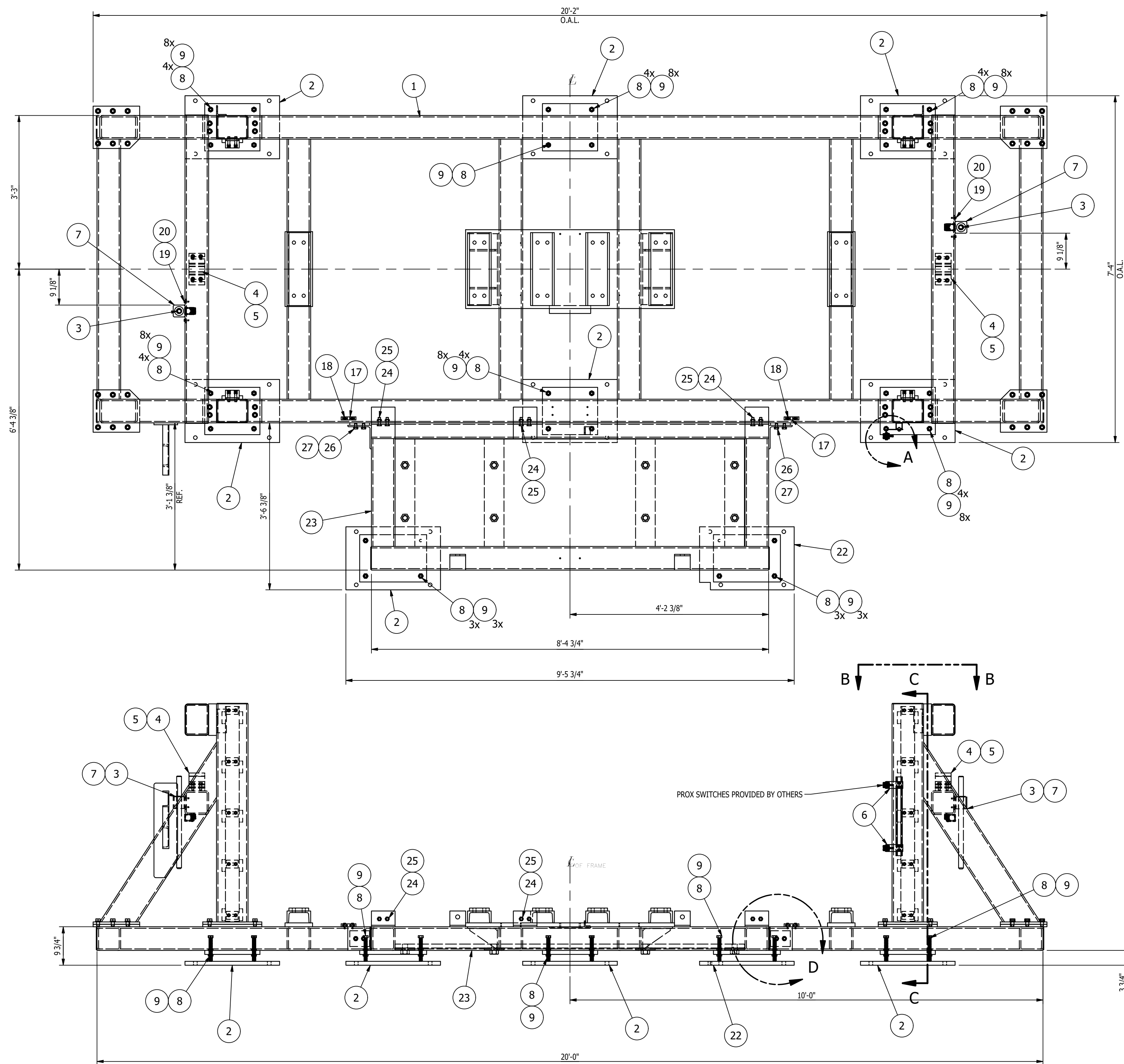
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TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D430	DWG DATE:	10/18/22
REV:	D	JOB No:	22096



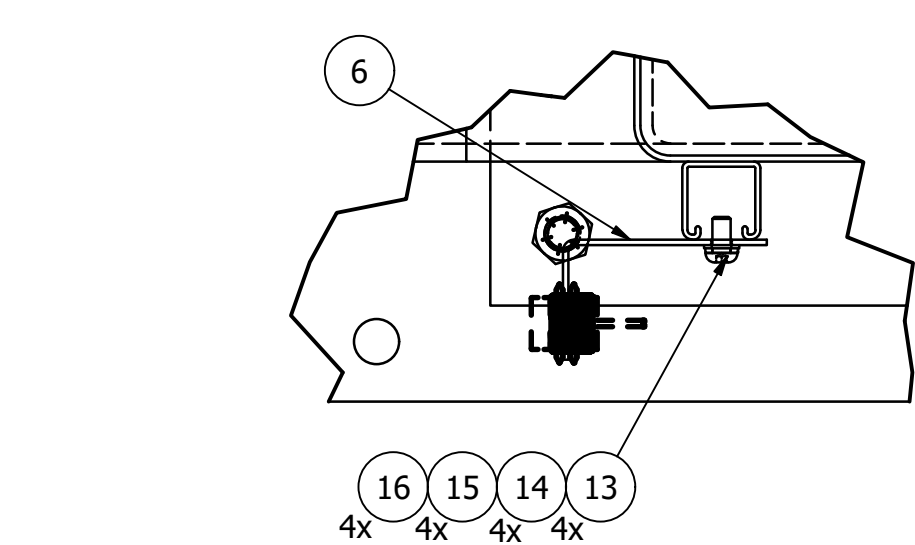
MAGNUM CONSULTING
 41100 Gardenbrook Rd.
 Suite 125
 Novi, MI 48375
 Phone: (248) 773-8055
 Fax: (248) 773-8051
 Web: www.4magnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D430 - REV D

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

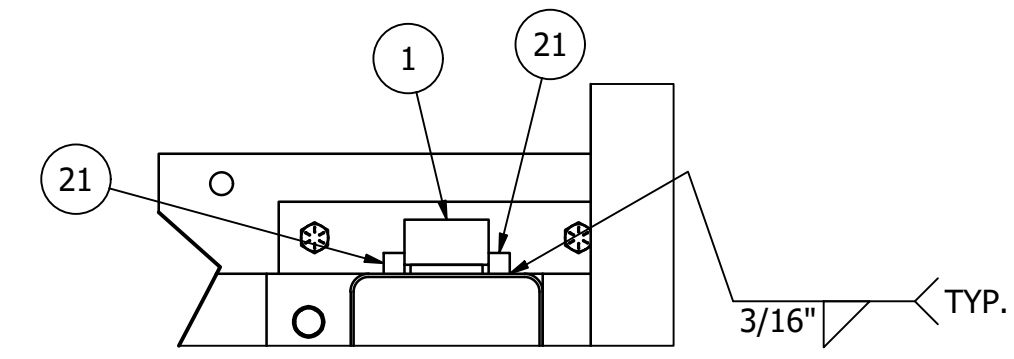


MK-D431A ~ BASE FRAME ASSEMBLY
SCALE 3/4"=1'-0"

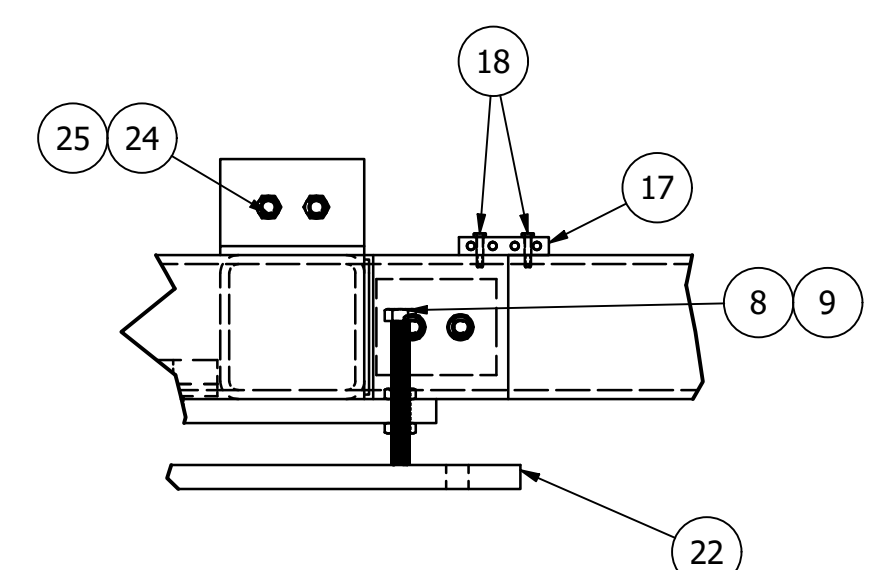
- SHOP NOTES:
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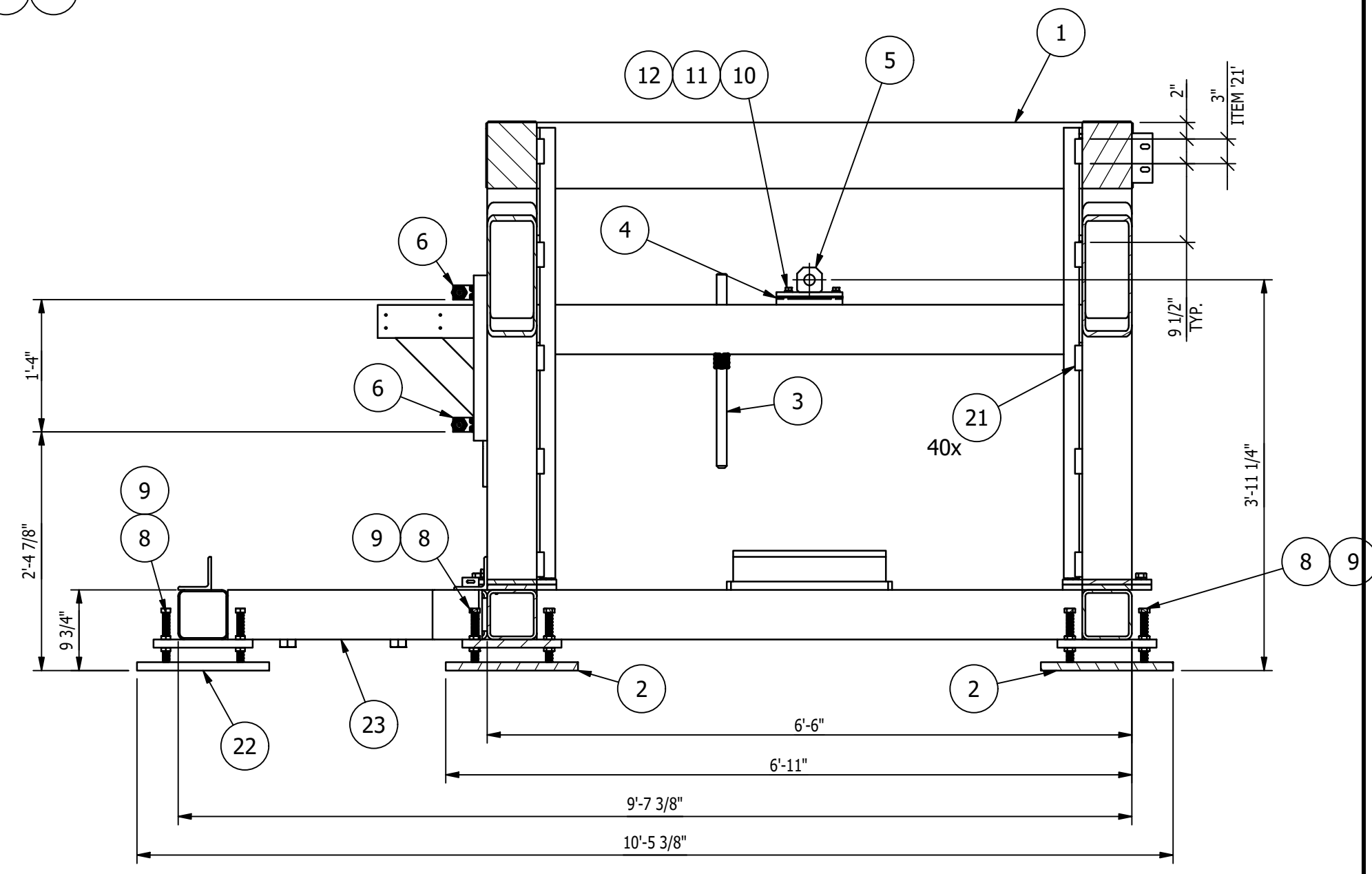
ENLARGED VIEW 'A'
SCALE 3"=1'-0"



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



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



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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D431A			
1	1	MK-D434A ~ BASE FRAME MACHINING			
2	7	MK-D435A ~ MOUNTING PAD			
3	2	MK-D435D ~ LOCKOUT PIN			
4	2	MK-D445B ~ SHIM PACK			
5	2	MK-D445A ~ LOCKING PIN BRACKET			
6	2	MK-D449B ~ PROX SWITCH BRACKET			
7	2	MK-D451A ~ PIN HOLDER			
8	30	3/4-10UNC x 6 LG. HEX HEAD BOLT" (FULLY THREADED)			
9	60	3/4-10UNC HEX JAM NUT			
10	8	1/2-13UNC x 1 1/2" LG. HEX HEAD BOLT			
11	8	1/2 SPRING LOCK WASHER			
12	8	1/2 TYPE B NARROW FLAT WASHER			
13	4	UNISTRUT CHANNEL NUT WITH SPRING, P1008, #3/8-16UNC THREAD			
14	4	3/8-16UNC x 3/4" LG. BUTTON HEX SOCKET HEAD CAP SCREW			
15	4	3/8 SPRING LOCK WASHER			
16	4	3/8 TYPE B NARROW FLAT WASHER			
17	2	SAE GREASE FITTING JUNCTION BLOCK FOR 1/8" NPTF, 4 INLETS, 3 3/4" LG, SAE-14563		26-3	
18	4	1/4-20UNC x 1 1/4" LG. HEX HEAD CAP SCREW			
19	8	1/4 SPRING LOCK WASHER			
20	8	1/4-20UNC x 1" LG. HEX HEAD CAP SCREW			
21	40	SQ. BAR 7/8 (1018)	3"		
22	1	MK-D435E ~ MOUNTING PAD			
23	1	MK-D452A ~ LIFT MOTOR BASE FRAME WELDMENT			
24	6	5/8-11UNC STOVER LOCK NUT			
25	6	5/8-11UNC x 1 3/4" LG. HEX HEAD CAP SCREW			
26	4	5/8-11UNC x 1" LG. HEX HEAD CAP SCREW			
27	4	5/8 SPRING LOCK WASHER			

WEIGHT OF BASE FRAME = 5754 LBS
WEIGHT OF MOTOR BASE FRAME WELDMENT = 1462 LBS

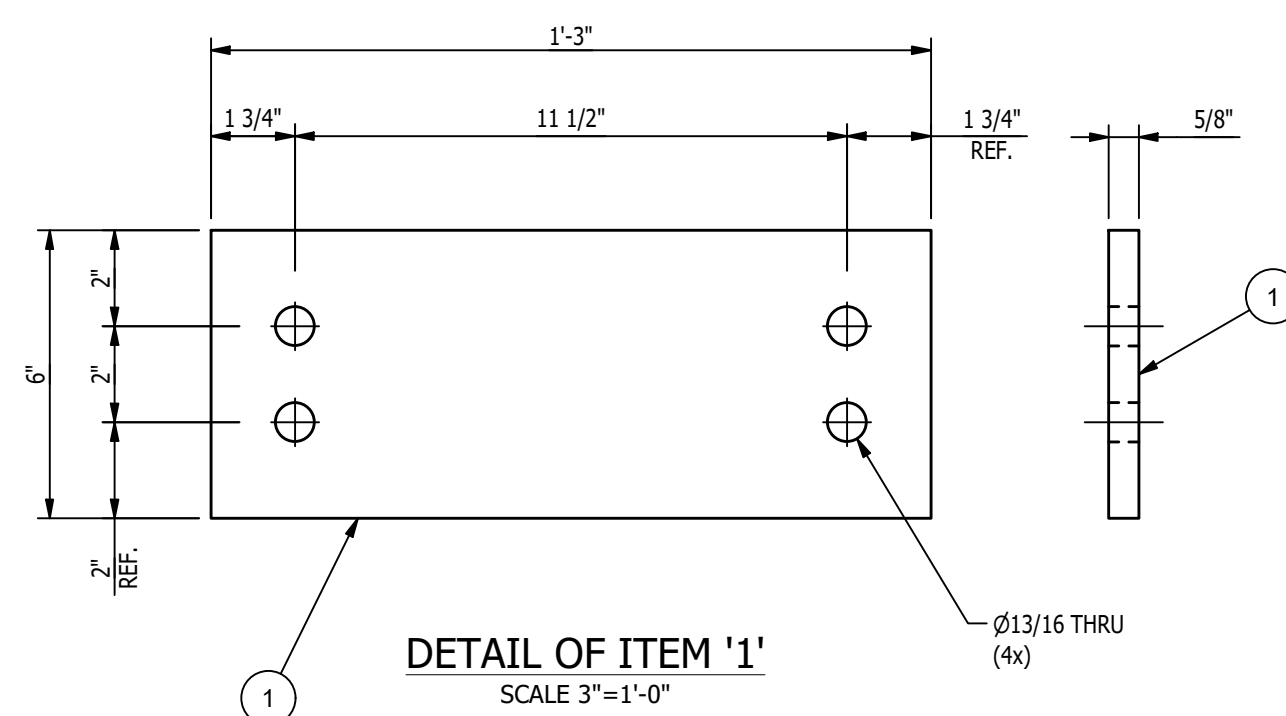
REV	BY	DATE	DESCRIPTION	APP
D	MC	11/18/22	MOVED ONE OF ITEM '17' TO OTHER SIDE OF ASSEMBLY	
C	MC	11/8/22	UPDATED GEOMETRY PER ITEM '1'	
B	MC	10/31/22	ADDED ITEMS '23' THRU '27', ADDED VIEW 'D-D', UPDATED ITEMS '13' THRU '16' TO BE 3/8 HARDWARE	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.milic.com		INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: RJB		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 10/6/22		JOB No: 22096	
DRAWING No. 1875D431		REV: D			

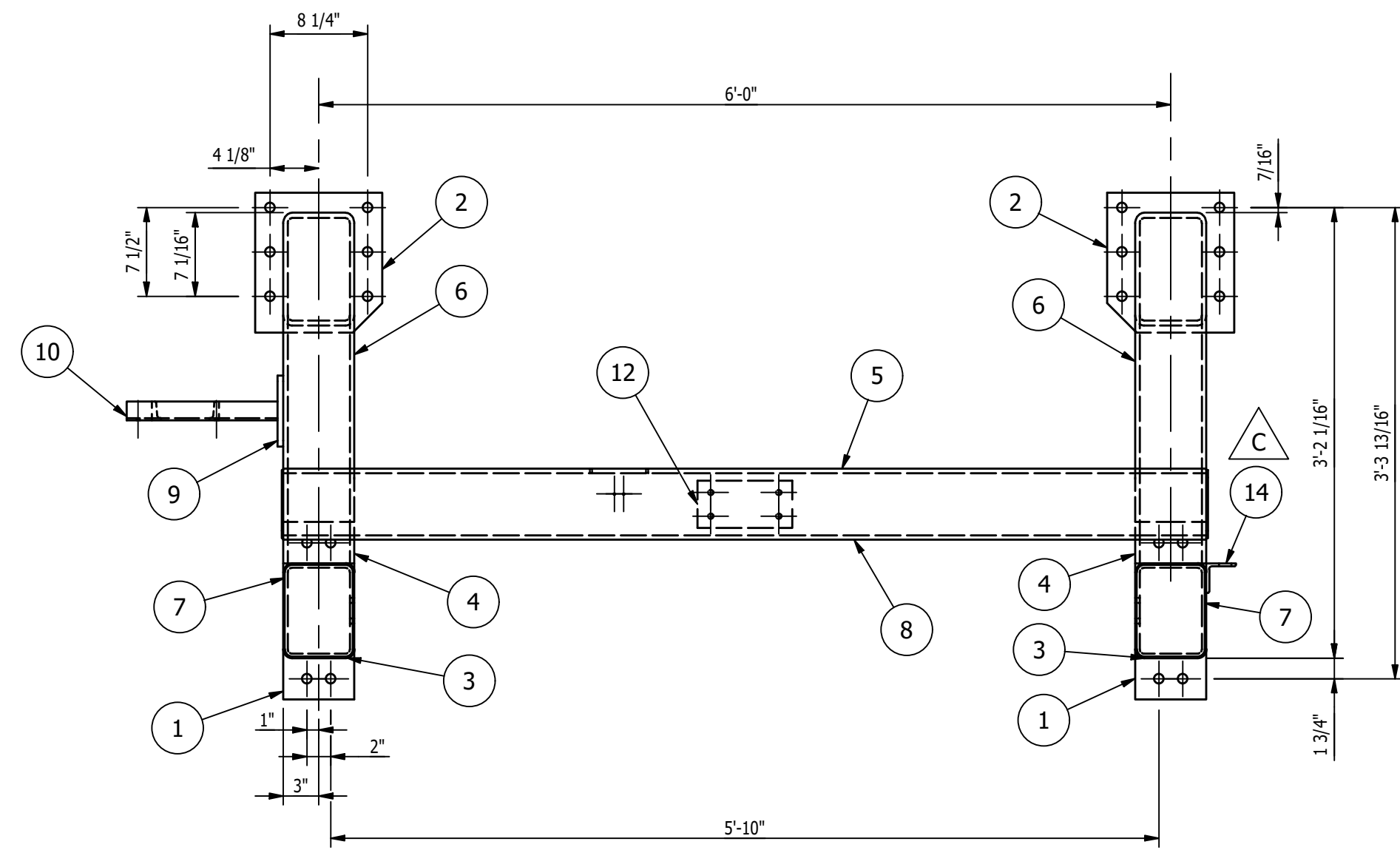
MAGNUM Consulting
41100 Quakerwood Rd.
Suite 125
West, MI 48375
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D431 - REV D

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

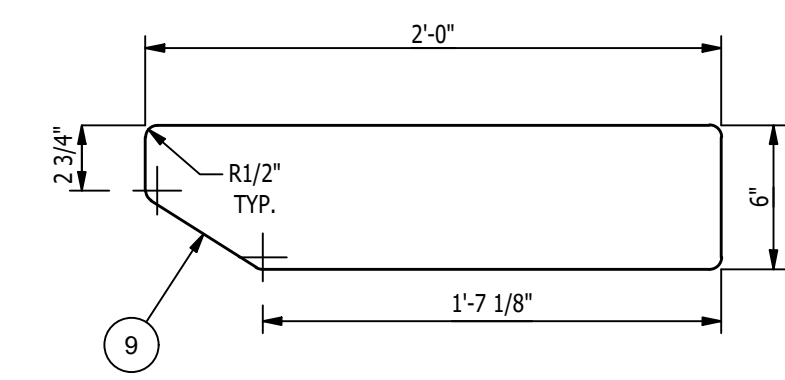
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4"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



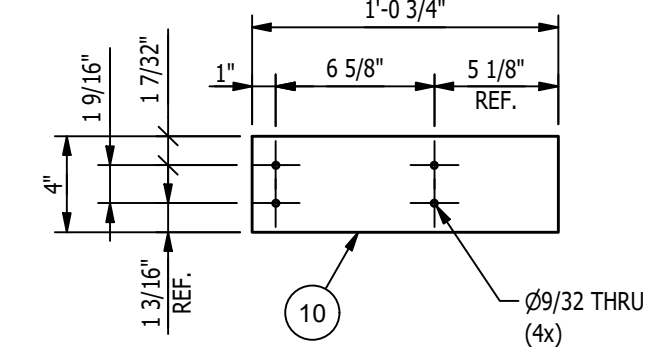
DETAIL OF ITEM '1'
SCALE 3"=1'-0"



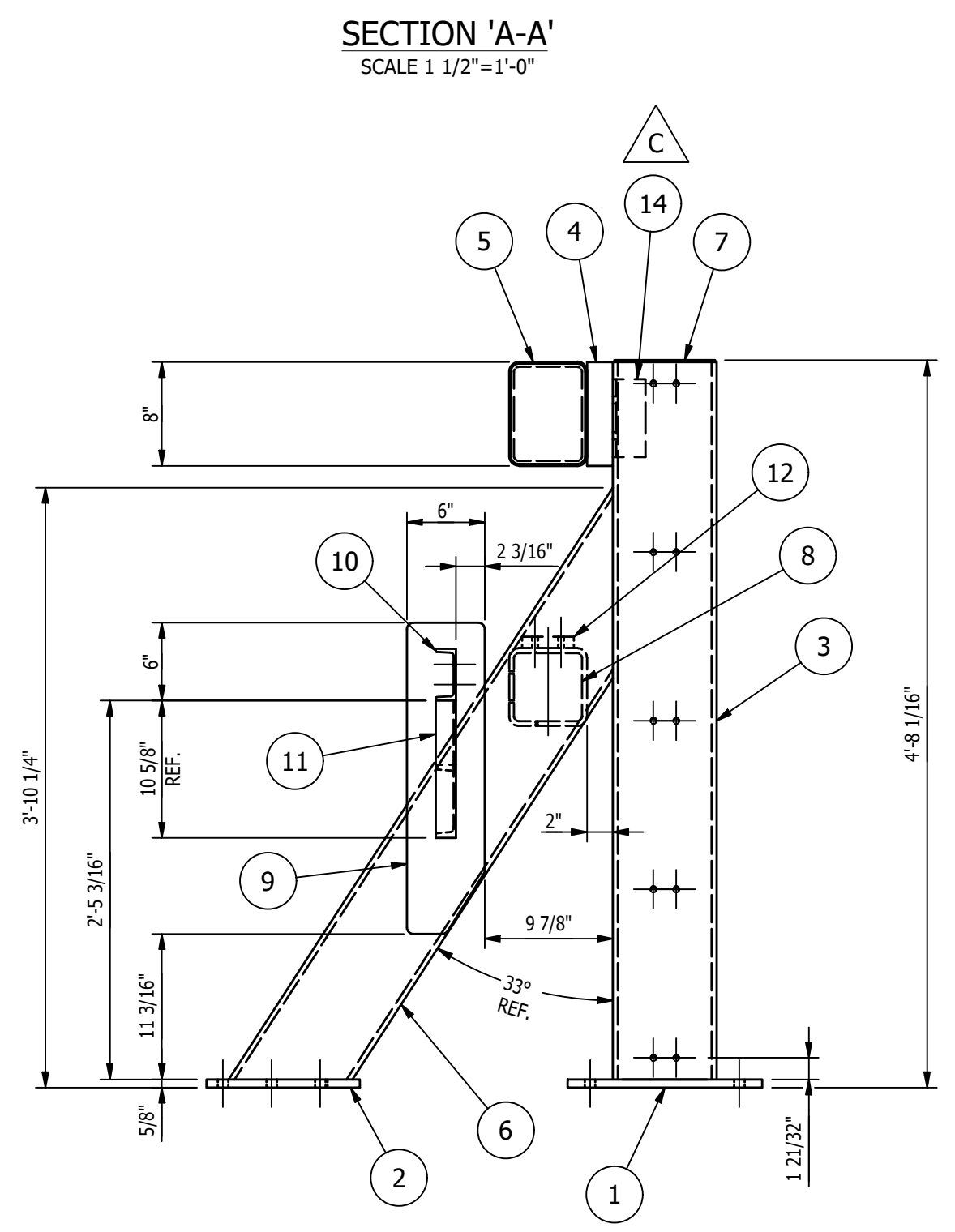
MK-D433A ~ SIDE FRAME WELDMENT
SCALE 1"=1'-0"



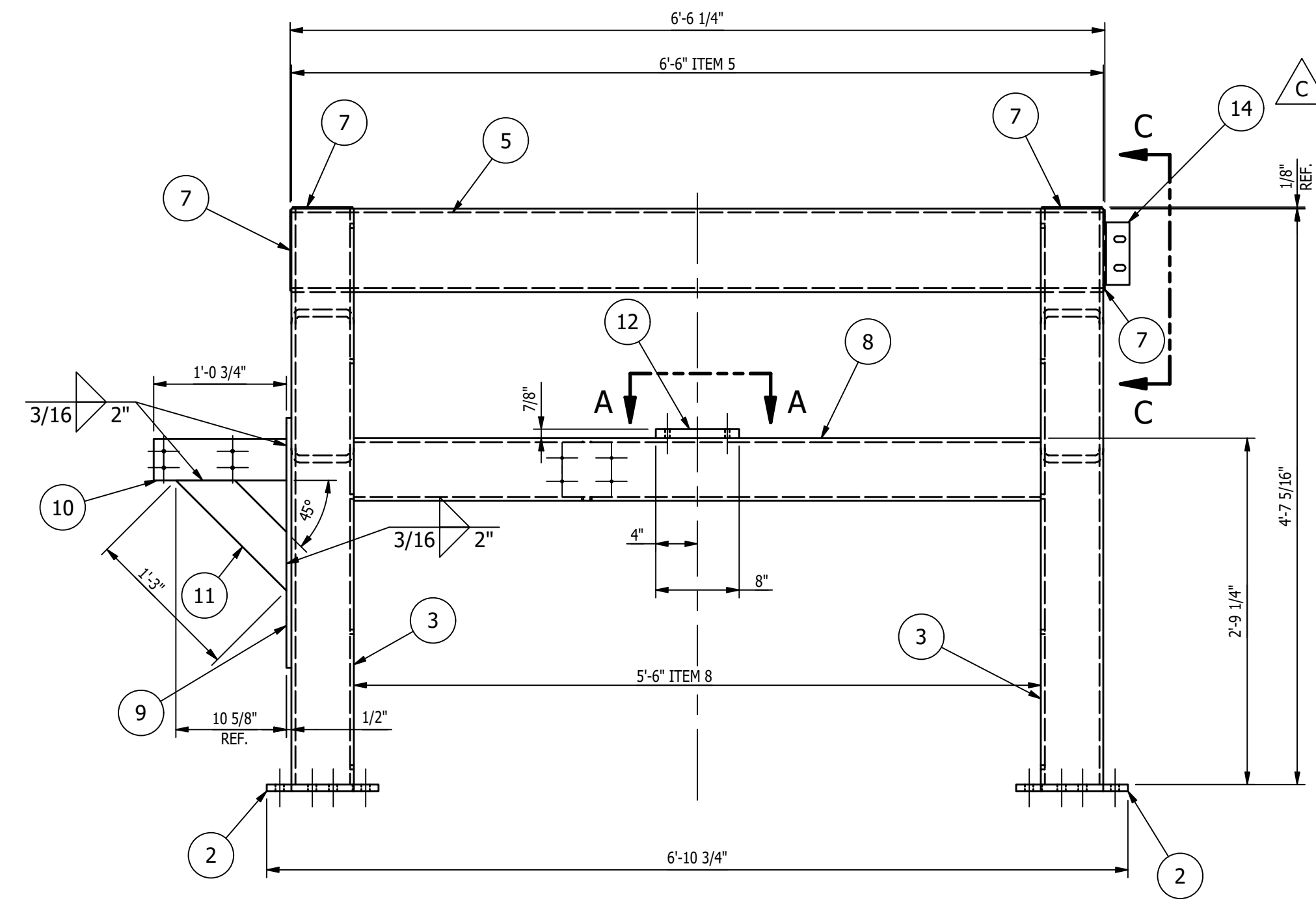
DETAIL OF ITEM '9'
SCALE 1 1/2"=1'-0"



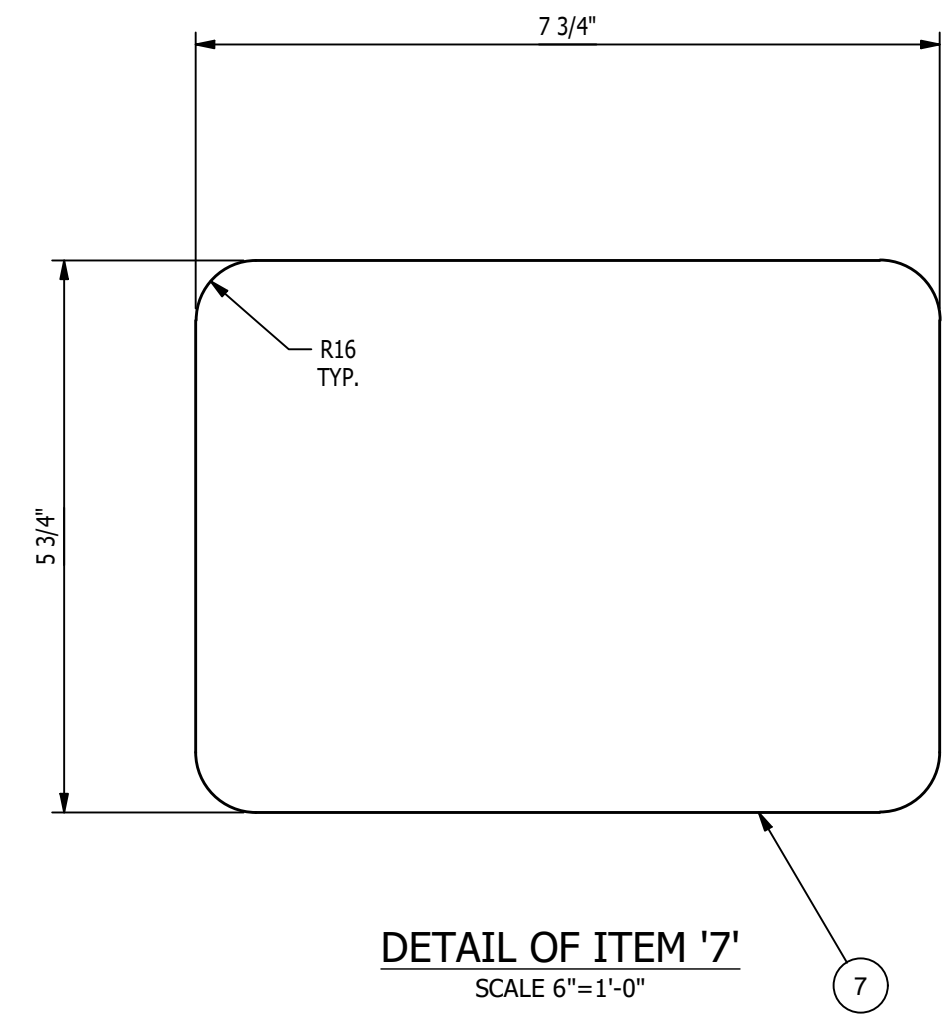
DETAIL OF ITEM '10'
SCALE 1 1/2"=1'-0"



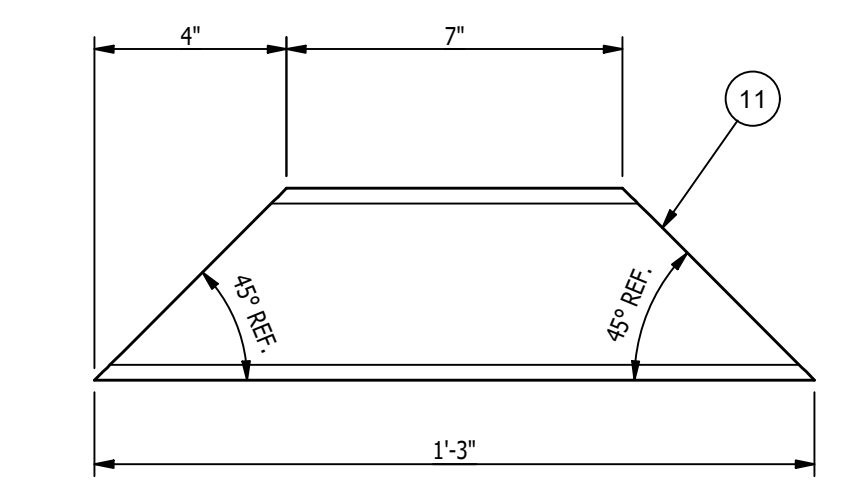
SECTION 'A-A'
SCALE 1 1/2"=1'-0"



MK-D433A ~ SIDE FRAME WELDMENT
SCALE 6"=1'-0"

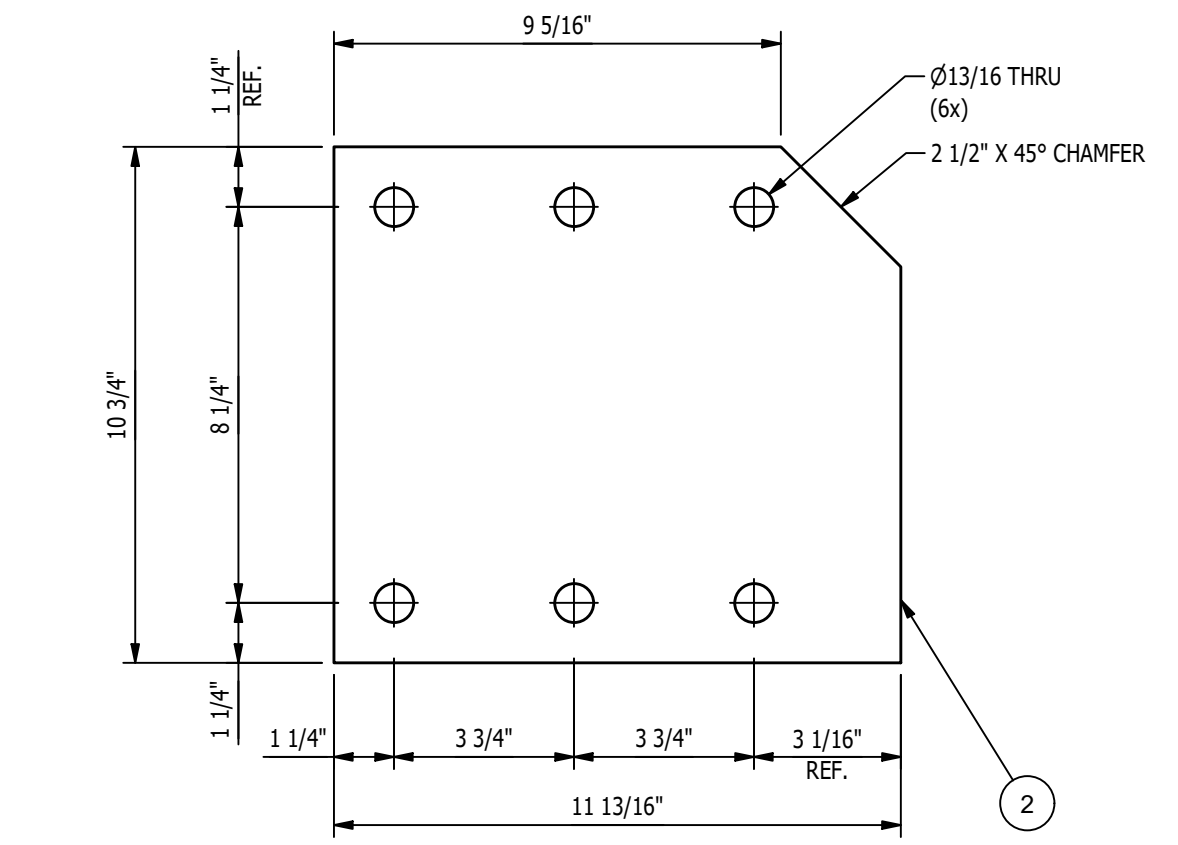


DETAIL OF ITEM '7'
SCALE 6"=1'-0"

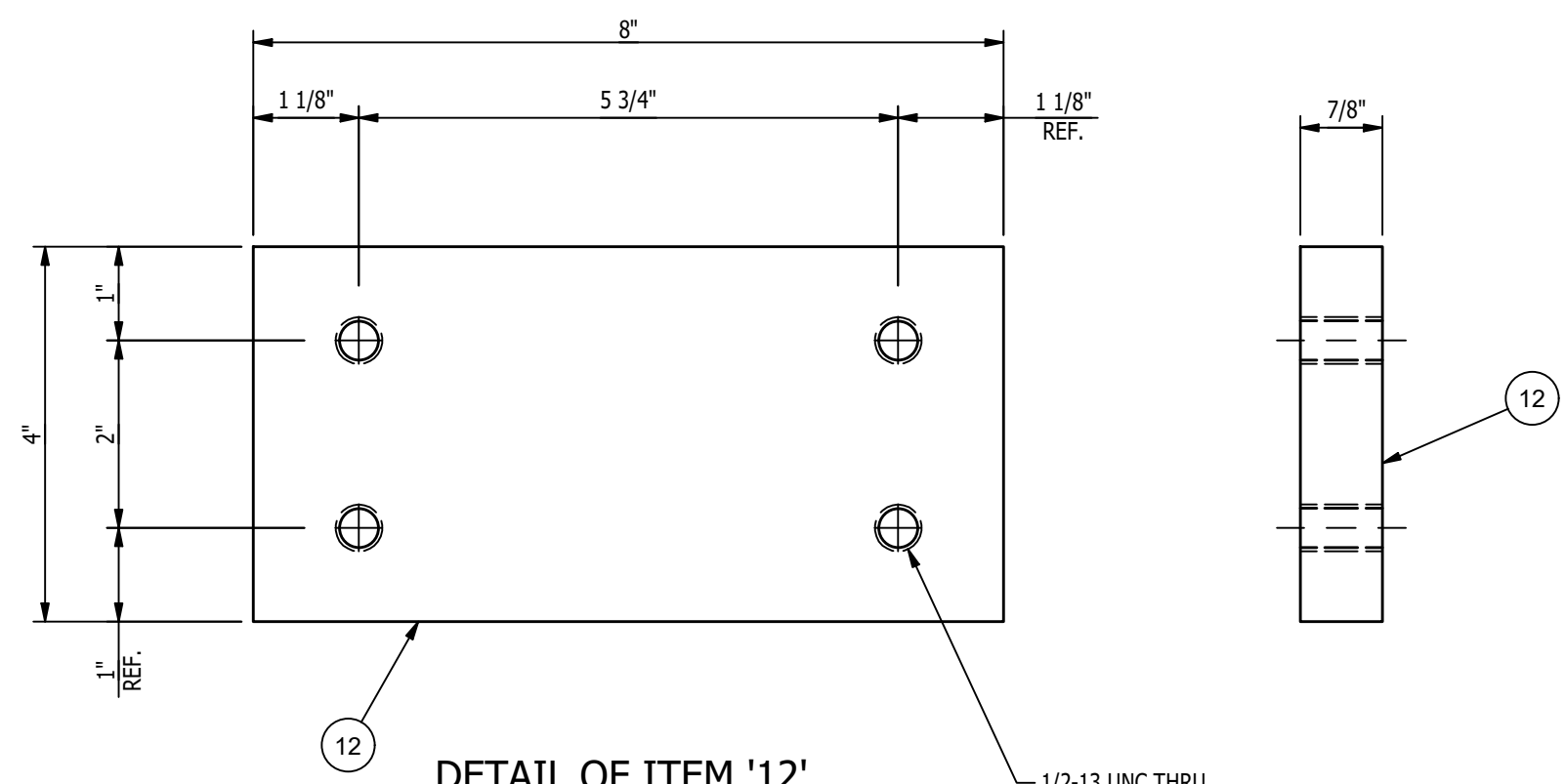


DETAIL OF ITEM '11'
SCALE 3"=1'-0"

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



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



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

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

- SHOP NOTES:
1. ALL MATERIAL IS TO BE FREE FROM RUST, SCALE & WELD SLAG
 2. ALL WELDS 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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D433A			
1	2	BAR 5/8 x 6	1'-3"		
2	2	PL 5/8 x 10 3/4"	11 13/16"		
3	2	HSS 8 x 6 x 3/8 A500 GR. C	4'-7 5/16"		
4	2	BAR 2 x 6	8"		
5	1	HSS 8 x 6 x 3/8 A500 GR. C	6'-6"		
6	2	HSS 8 x 6 x 3/8 A500 GR. C	4'-6 3/8"		
7	4	SHT 10 GA x 5 3/4"	7 3/4"		
8	1	HSS 6 x 6 x 3/8 A500 GR. C	5'-6"		
9	1	PL 1/2 x 6"	2'-0"		
10	1	C 4 x 5.4	1'- 3/4"		
11	1	C 4 x 5.4	1'-3"		
12	1	BAR 7/8 x 4	8"		
14	1	L 2 1/2 x 2 1/2 x 1/4	6"		
		MK-D433B			
1	2	BAR 5/8 x 6	1'-3"		
2	2	PL 5/8 x 10 3/4"	11 13/16"		
3	2	HSS 8 x 6 x 3/8 A500 GR. C	4'-7 5/16"		
4	2	BAR 2 x 6	8"		
5	1	HSS 8 x 6 x 3/8 A500 GR. C	6'-6"		
6	2	HSS 8 x 6 x 3/8 A500 GR. C	4'-6 3/8"		
7	4	SHT 10 GA x 5 3/4"	7 3/4"		
8	1	HSS 6 x 6 x 3/8 A500 GR. C	5'-6"		
12	1	BAR 7/8 x 4	8"		
13	1	UNISTRUT 1-5/8" x 1-5/8" 12 GAGE METAL CHANNEL, SOLID PLAIN FINISH, PART NO. P1000-PL	1'-8"		
14	1	L 2 1/2 x 2 1/2 x 1/4	6"		

REV	BY	DATE	DESCRIPTION	APP
C	MC	11/8/22	ADDED ITEM '14', VIEW 'C-C' & VIEW 'D-D'	
B	MC	11/1/2022	UPDATED LENGTH ITEM 6 IN BOM	
A	MC	10/21/22	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. 1875D433

REV: C

DRAWN BY: SGS
CHECKED BY: CW
DWG DATE: 10/13/22
JOB No: 22096

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

MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D433

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.

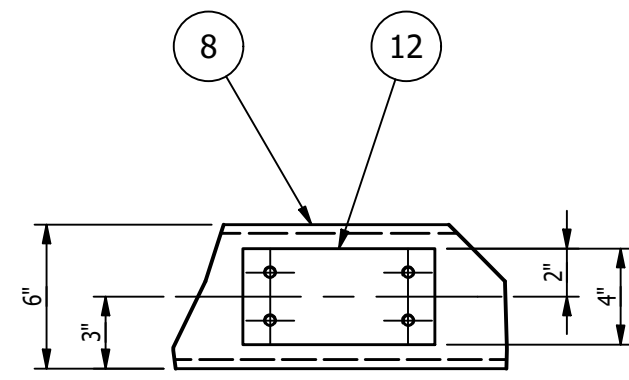
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

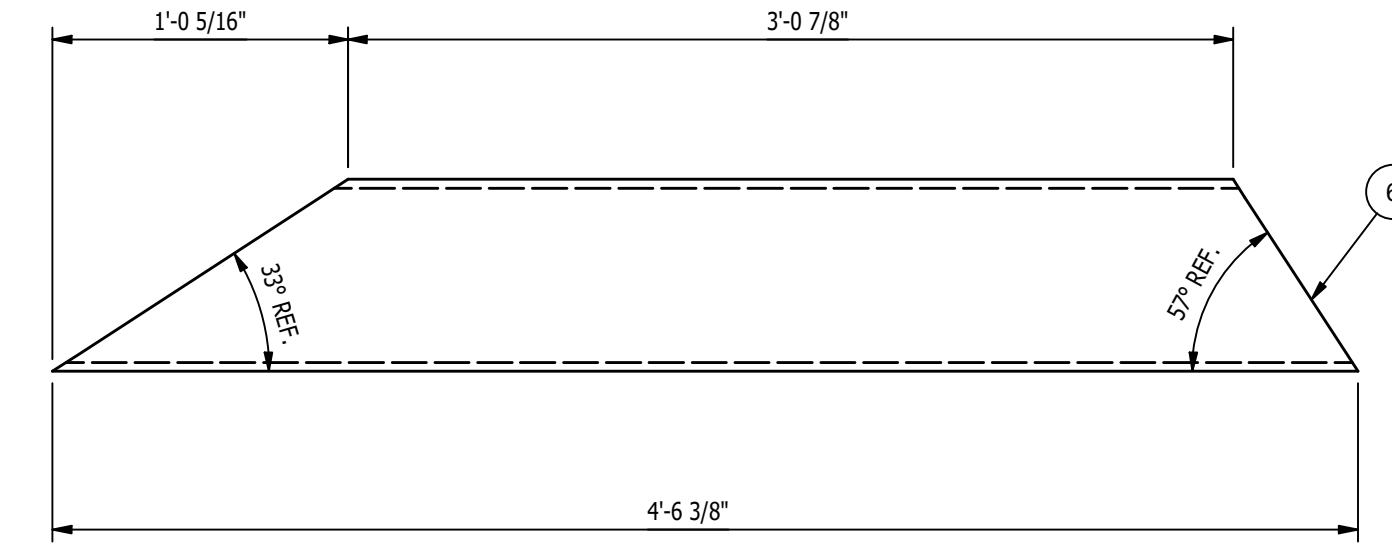
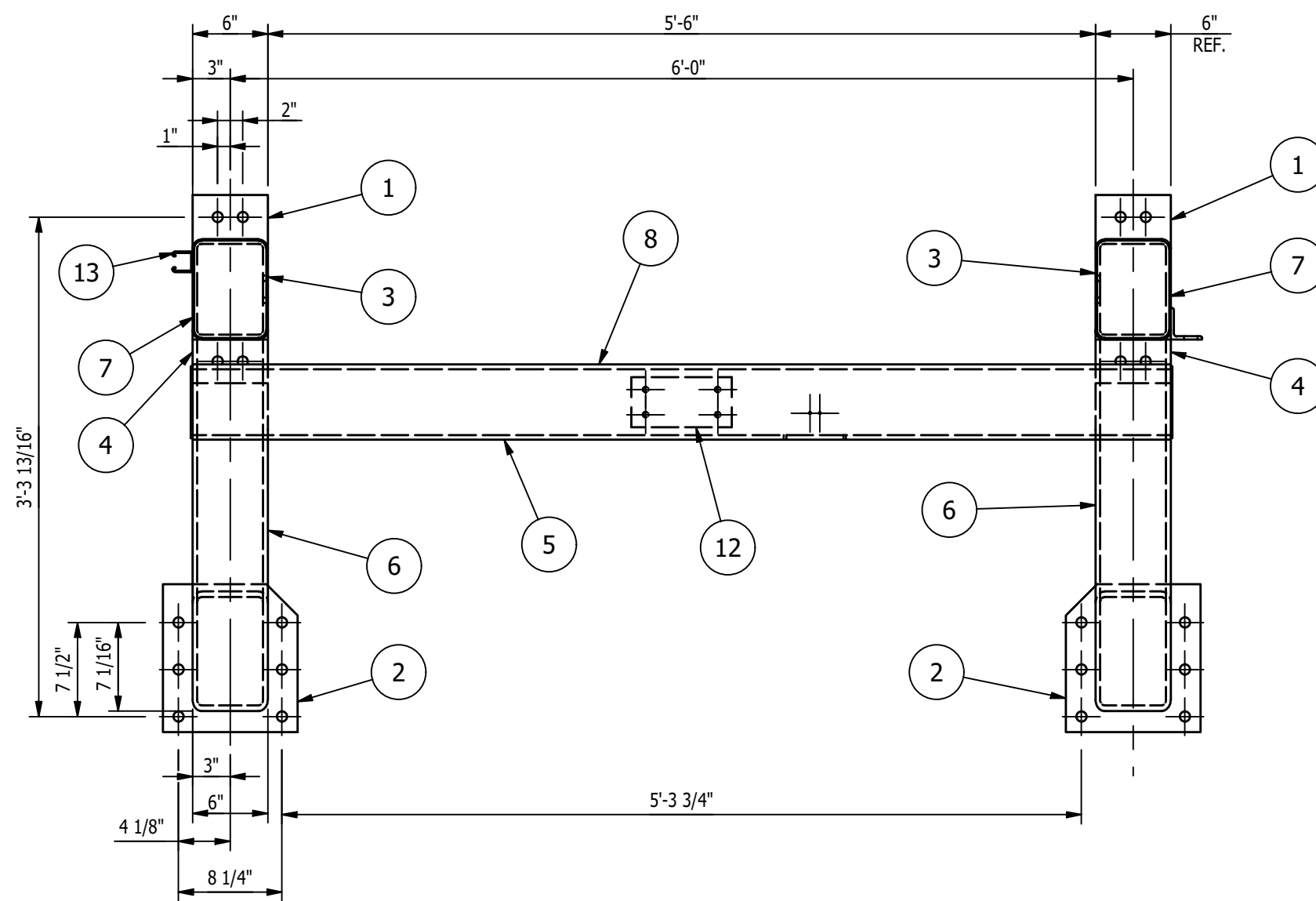
PAINT:
- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

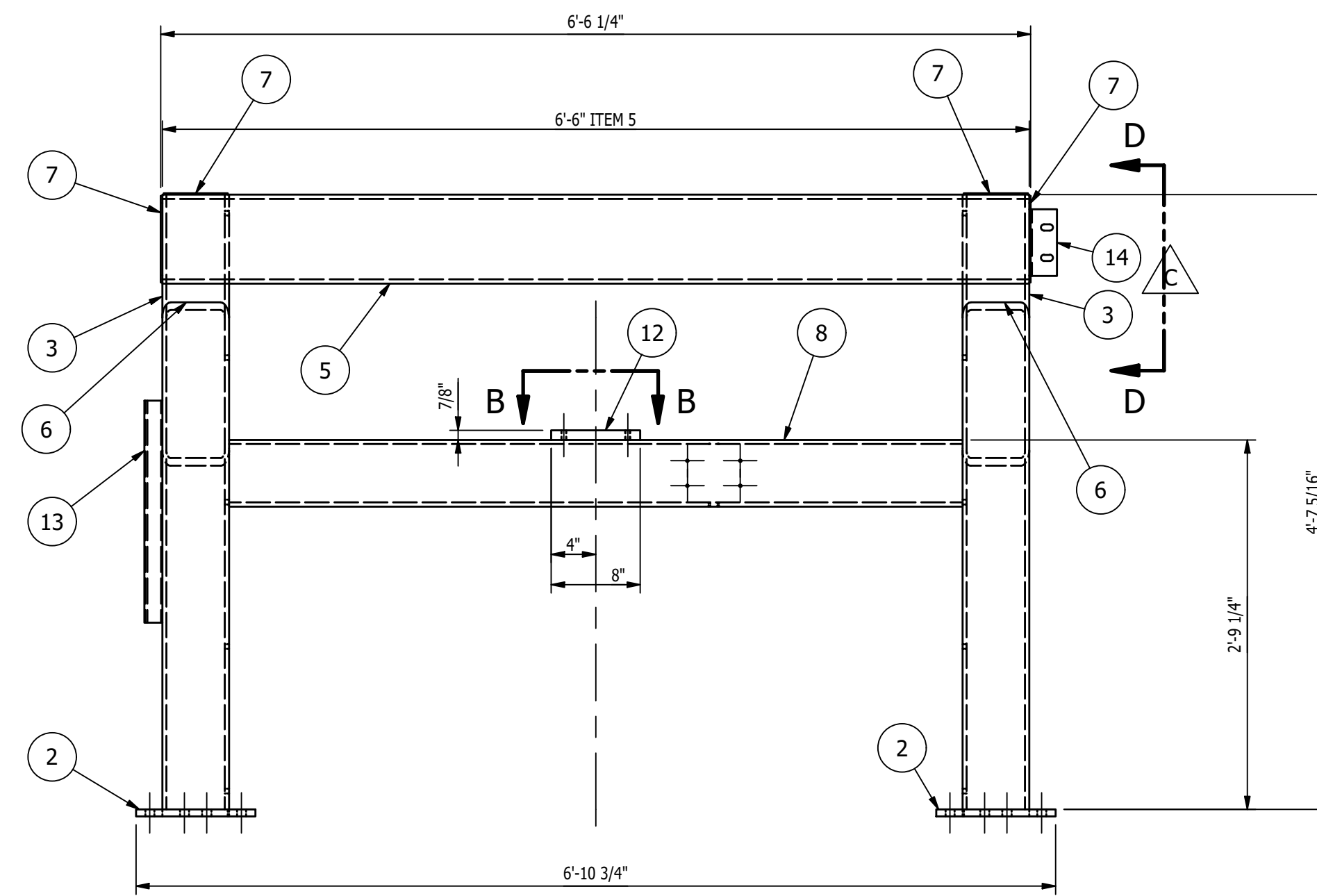
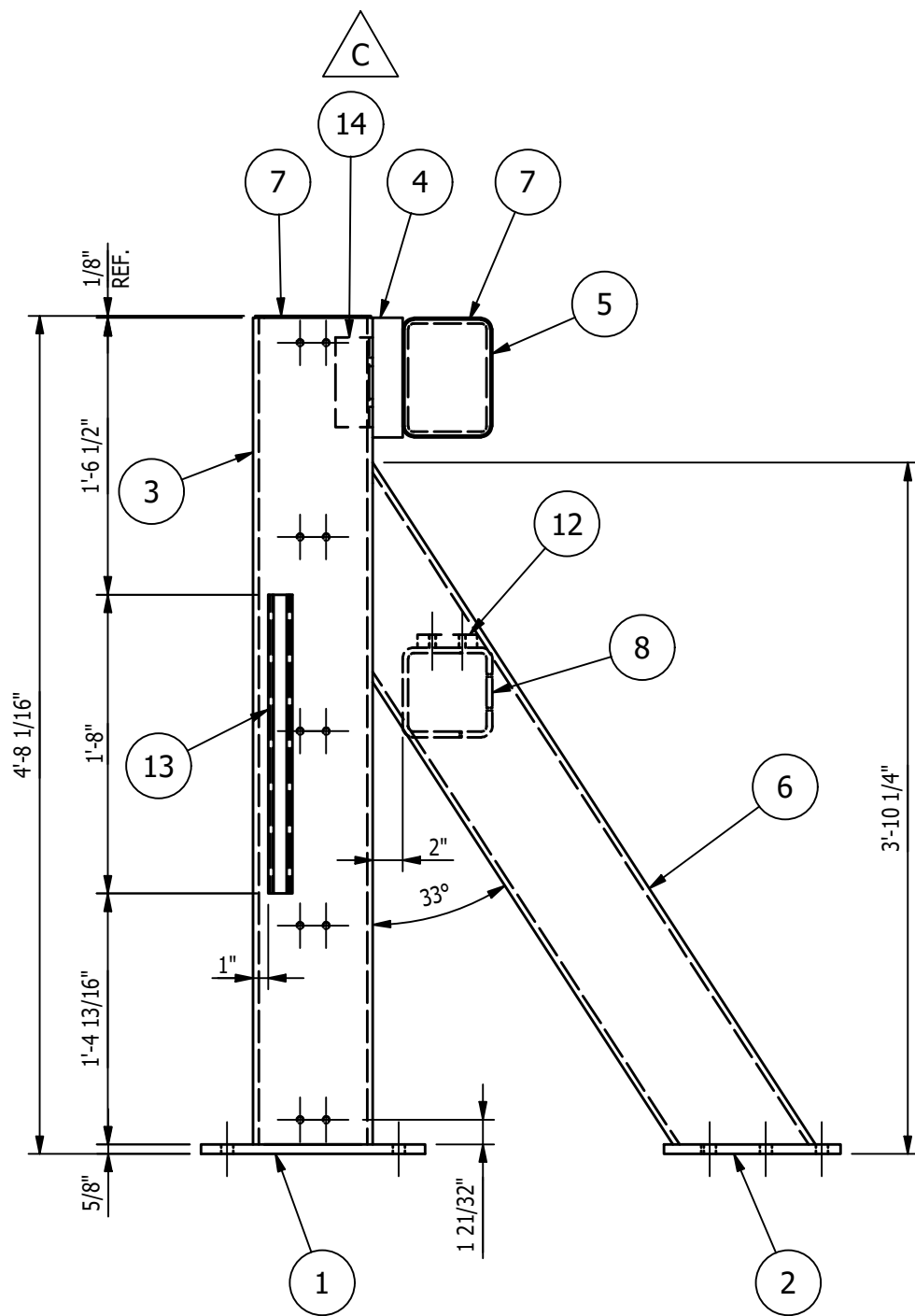
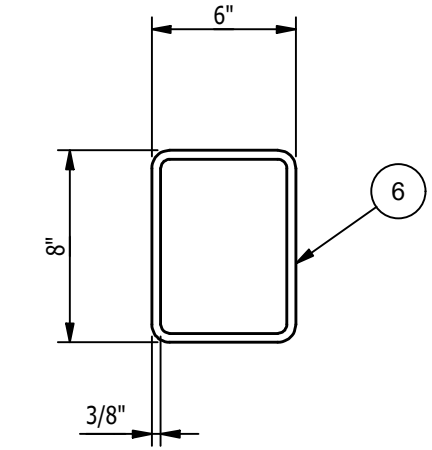
3/200 1875D433 Rev. 000 Drawing/Details/1875D433.dwg



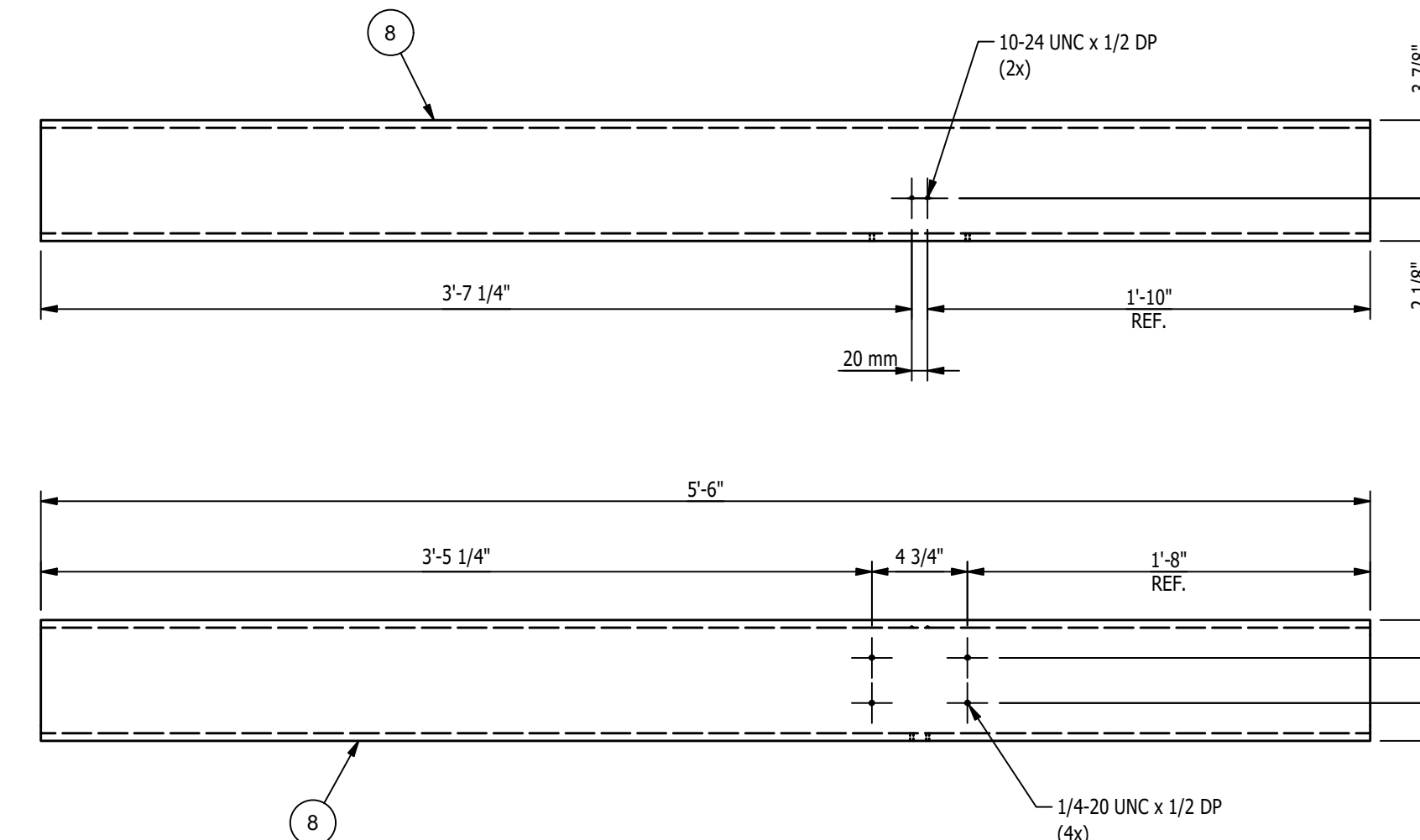
SECTION 'B-B'
SCALE 1 1/2"=1'-0"



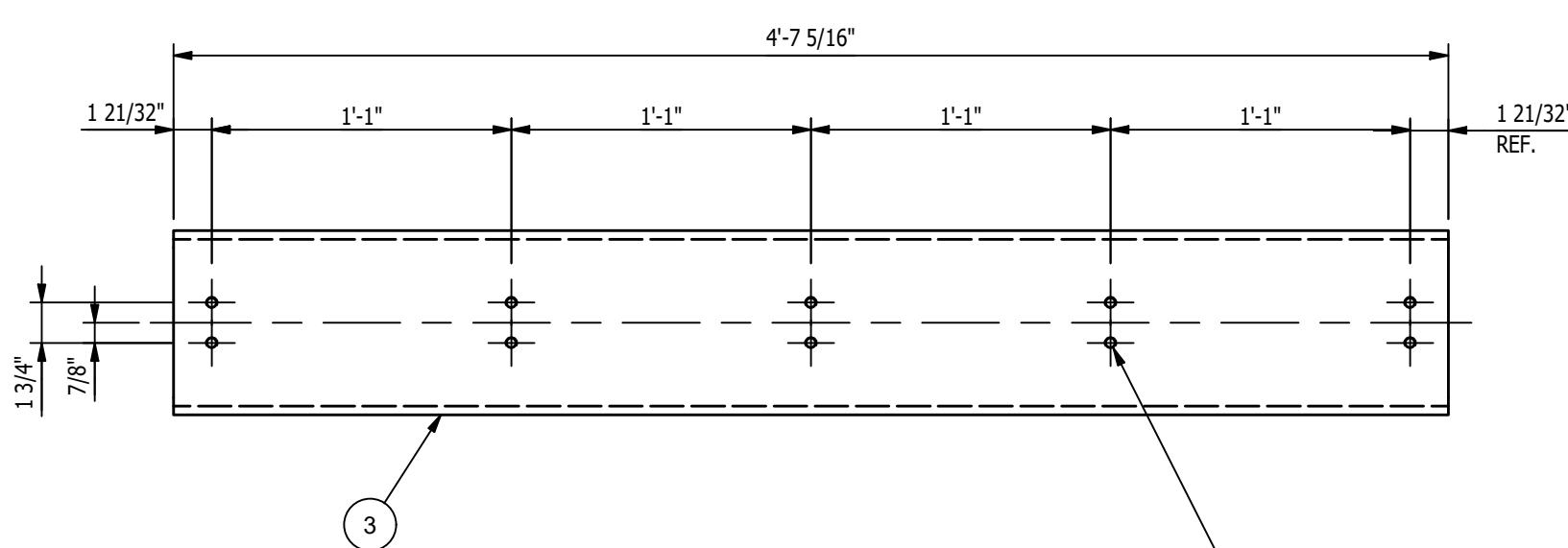
DETAIL OF ITEM '6'
SCALE 1 1/2"=1'-0"



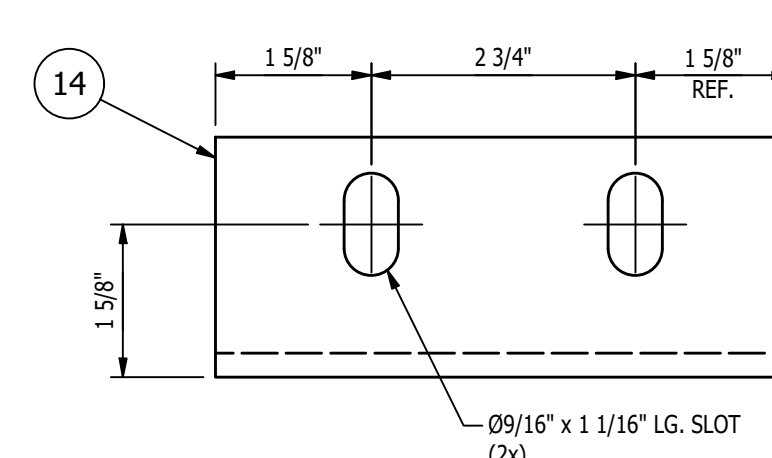
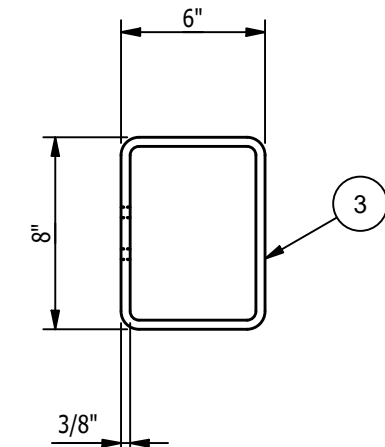
MK-D433B ~ SIDE FRAME WELDMENT
SCALE 1"=1'-0"



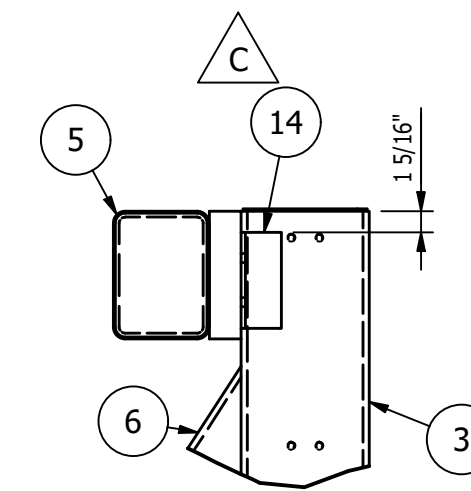
DETAIL OF ITEM '8'
SCALE 1 1/2"=1'-0"



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



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



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

SHEET 2 OF 2

REV	DESCRIPTION	BY	DATE
C	ADDED ITEM '14', VIEW "C-C" & VIEW "D-D"	MC	11/8/22
B	UPDATED LENGTH ITEM 6 IN BOM	MC	11/1/2022
A	FOR FABRICATION	MC	10/21/22

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

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

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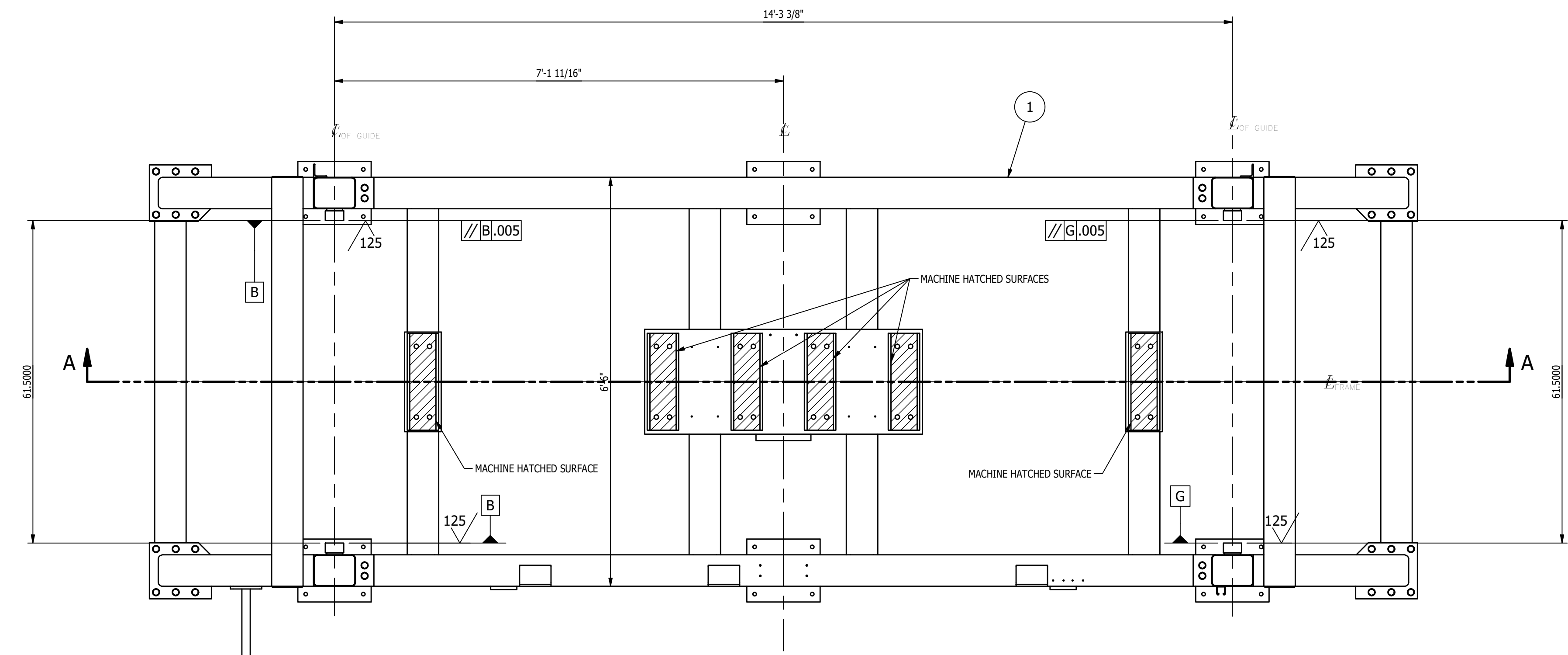
TITLE: **P6700 CONVEYORS CAMPUS BUILDING**
 CLIENT: **VOLVO**
 DRAWING No. **1875D433**

DRAWN BY: **SGS**
 CHECKED BY: **CW**
 DWG DATE: **10/13/22**
 REV: **C**
 JOB No: **22096**

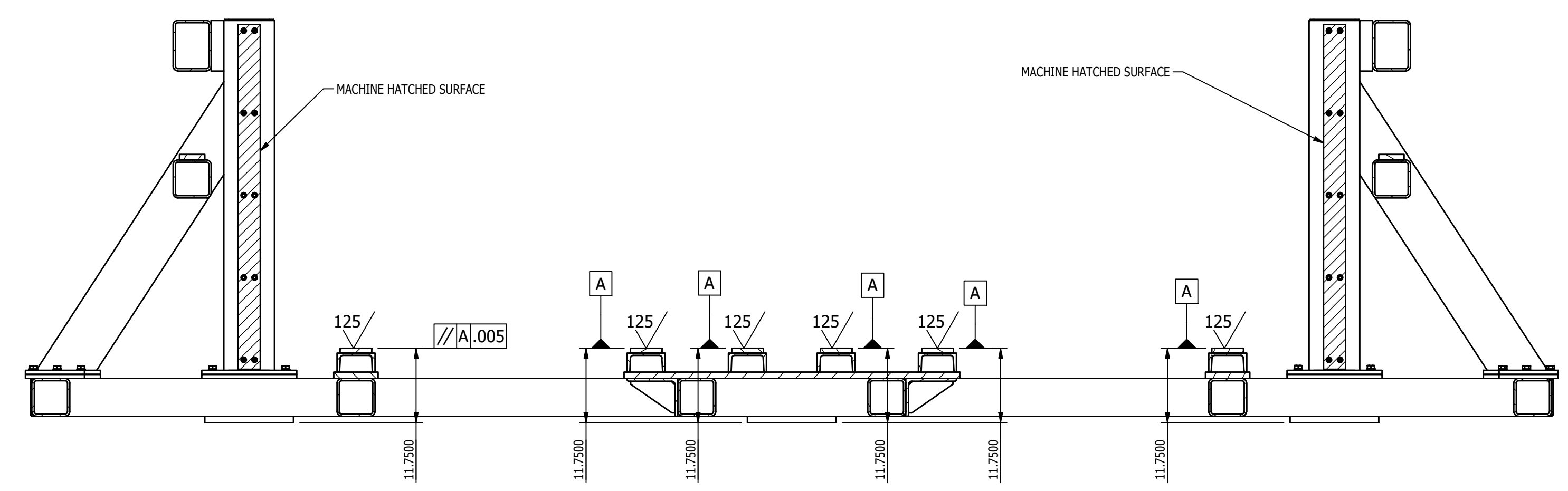
MAGNUM Consulting
 41700 Greenbrook Rd.
 Suite 125
 West, MI 48315
 Phone: (248) 773-8855
 Fax: (248) 773-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D433

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-D434A			
		MK-D450A ~ BASE FRAME ASSEMBLY (BEFORE MACHINING)			



MK-D434A ~ BASE FRAME MACHINING
SCALE 3/4"=1'-0"



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

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

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

SHEET 1 OF 2

REV	BY	DATE	DESCRIPTION	APP
C	MC	11/8/22	UPDATED GEOMETRY PER ITEM '1'	
B	MC	10/31/22	UPDATED GEOMETRY PER ITEM '1'	
A	MC	10/21/22	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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MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D434

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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
PH: 810.373.0322 FAX: 810.373.0326
www.millic.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING

CLIENT: VOLVO

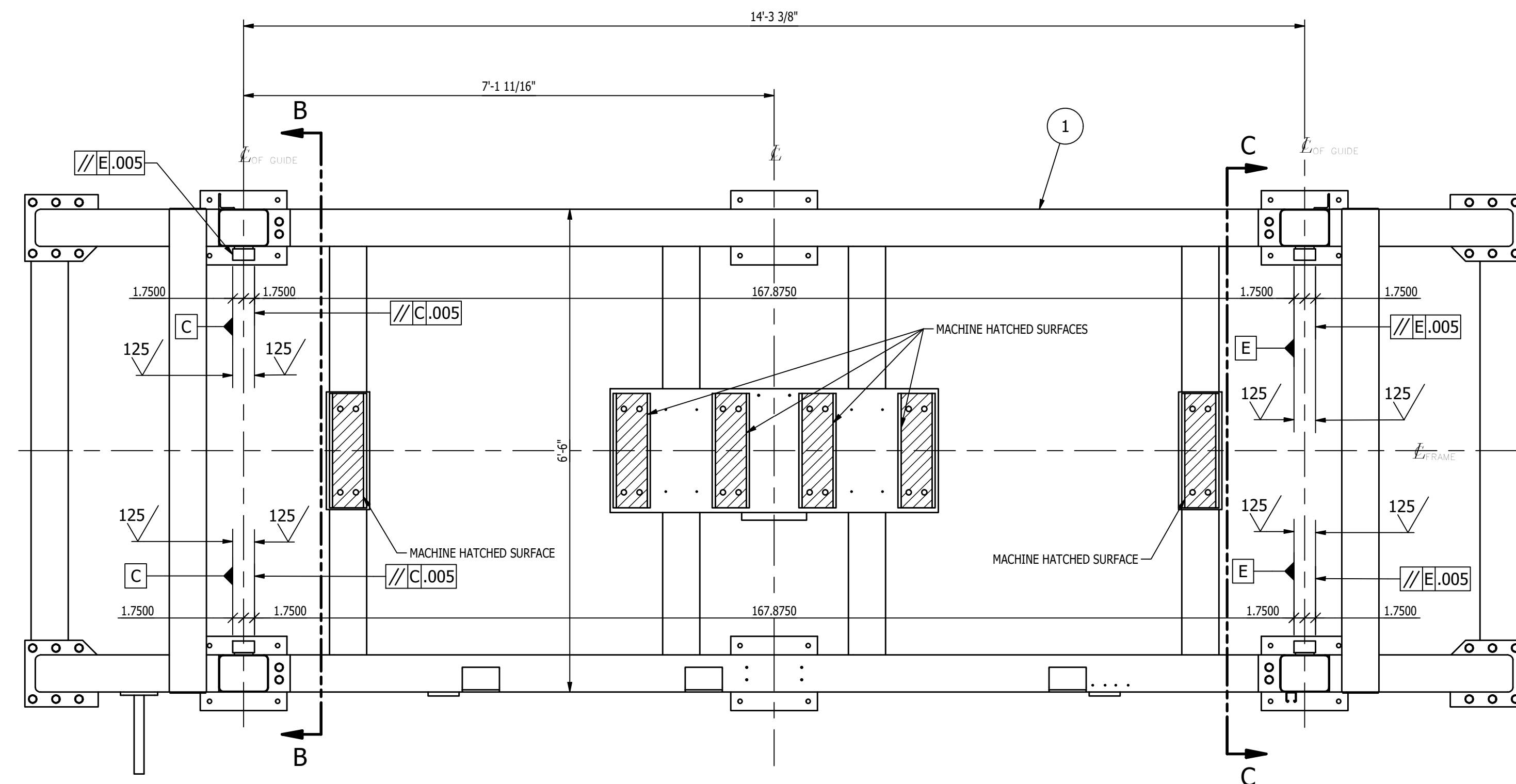
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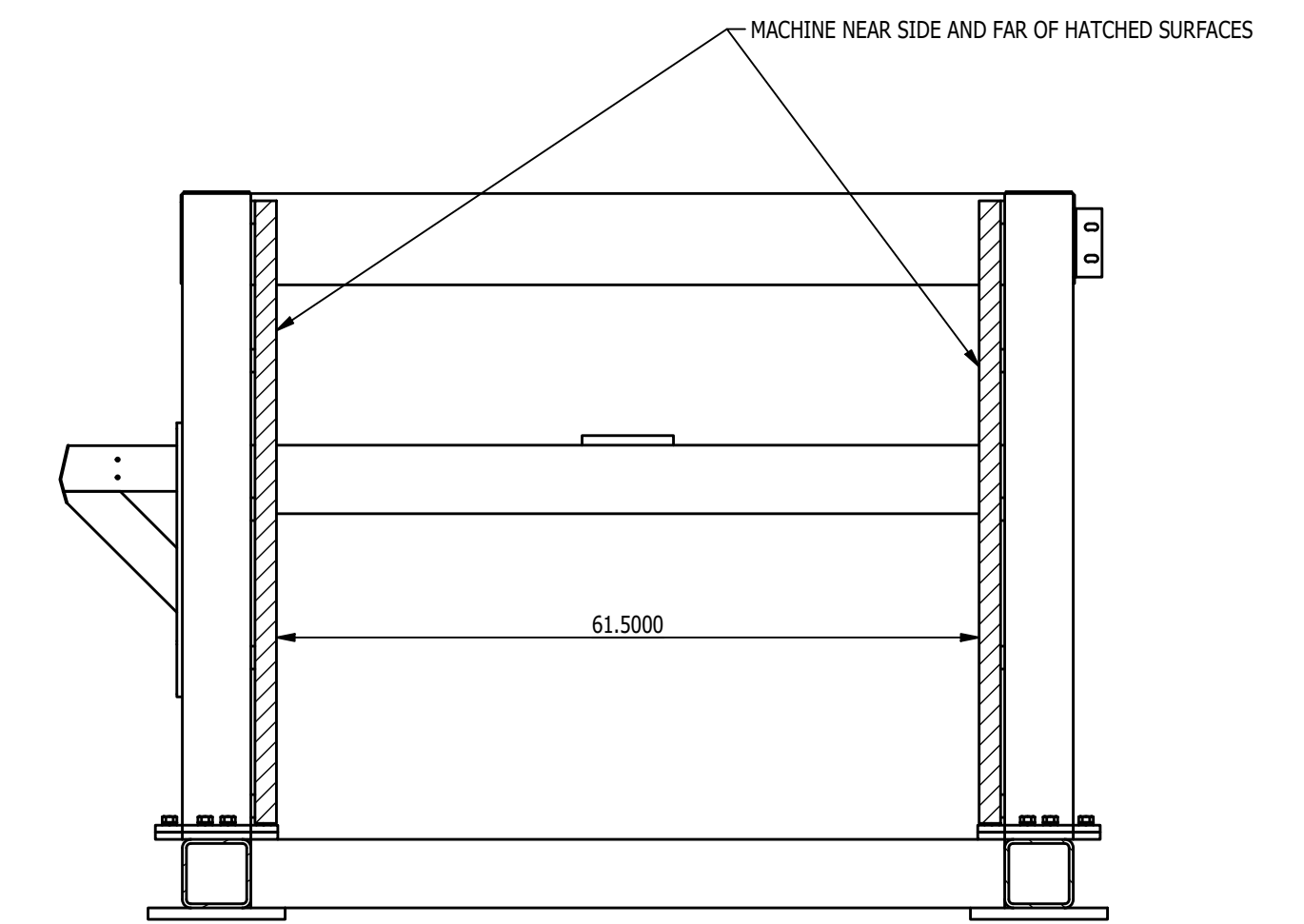
JOB No. 22096

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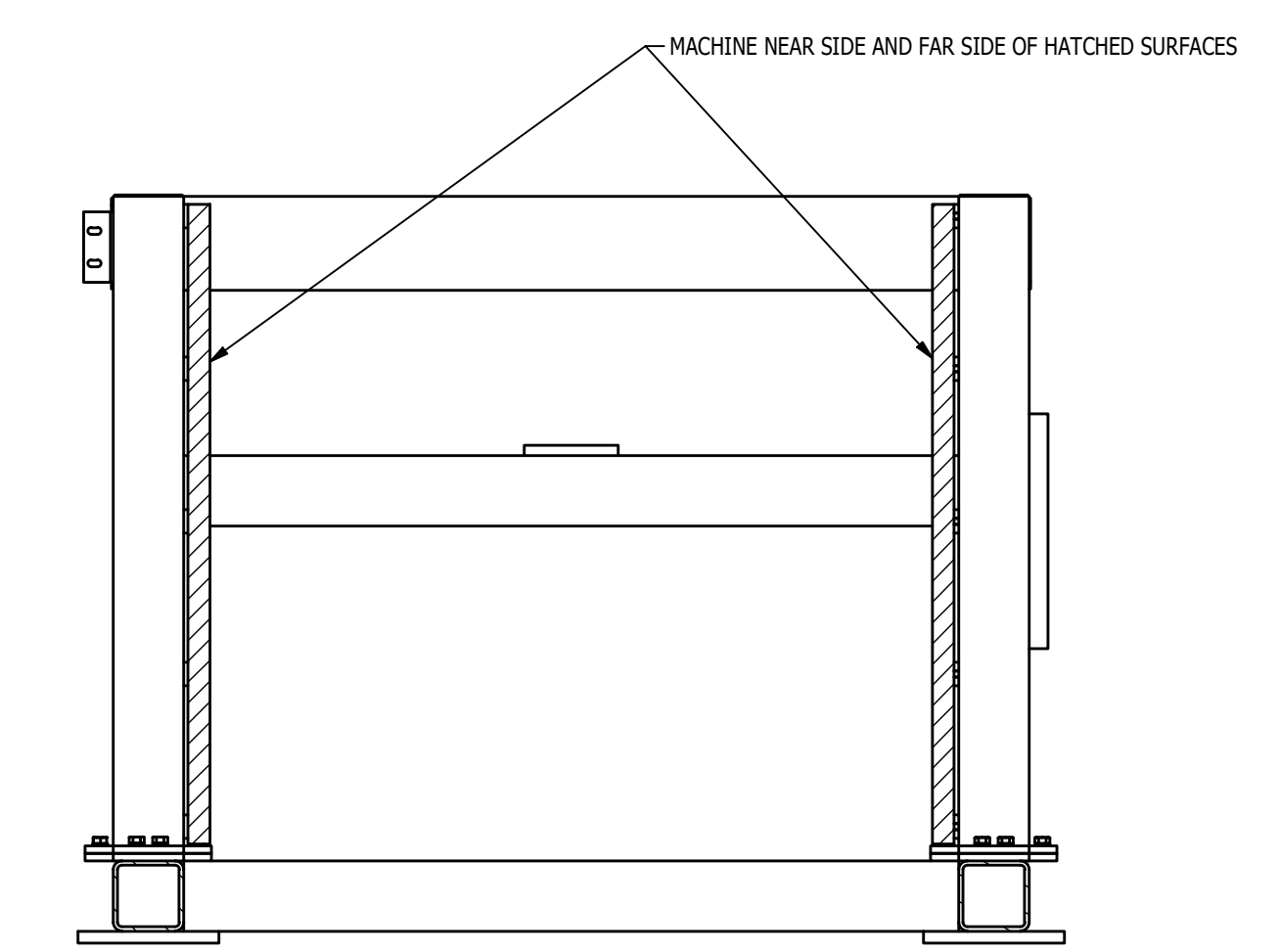
DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 10/11/22



MK-D434A ~ BASE FRAME MACHINING
SCALE 3/4"=1'-0"



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



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

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
C	MC	11/8/22	UPDATED GEOMETRY PER ITEM '1'	
B	MC	10/31/22	UPDATED GEOMETRY PER ITEM '1'	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY

GENERAL NOTES:

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

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

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

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

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

MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
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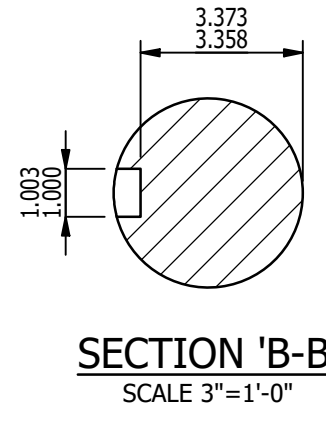
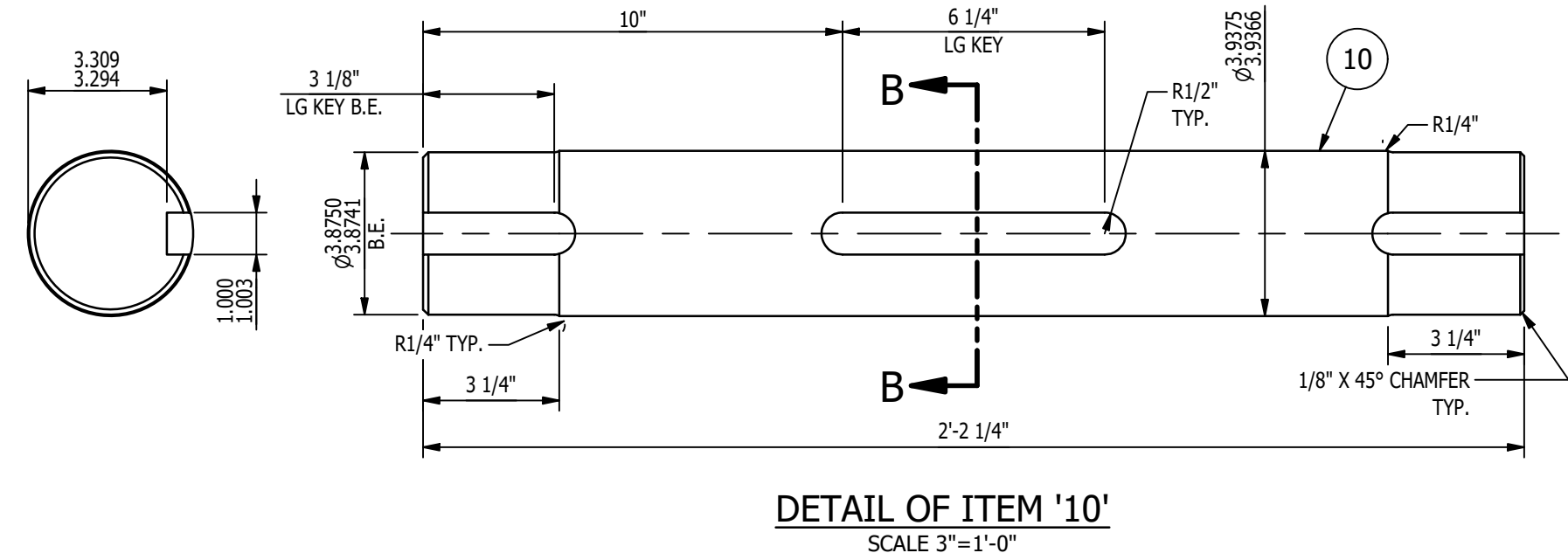
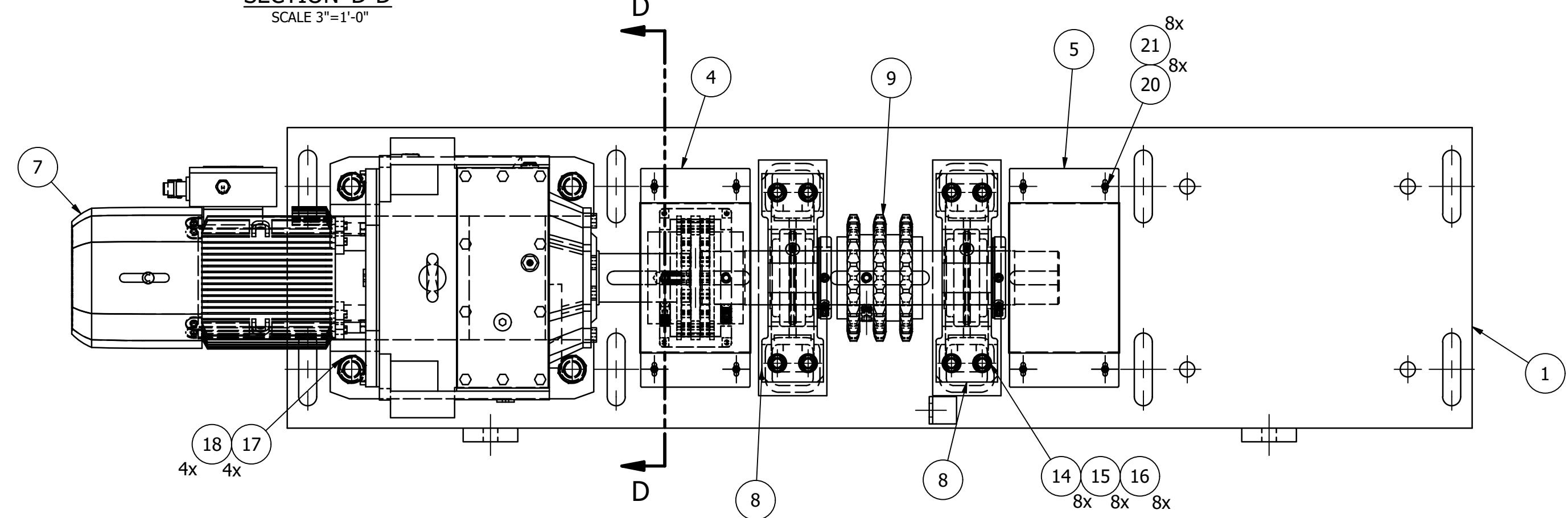
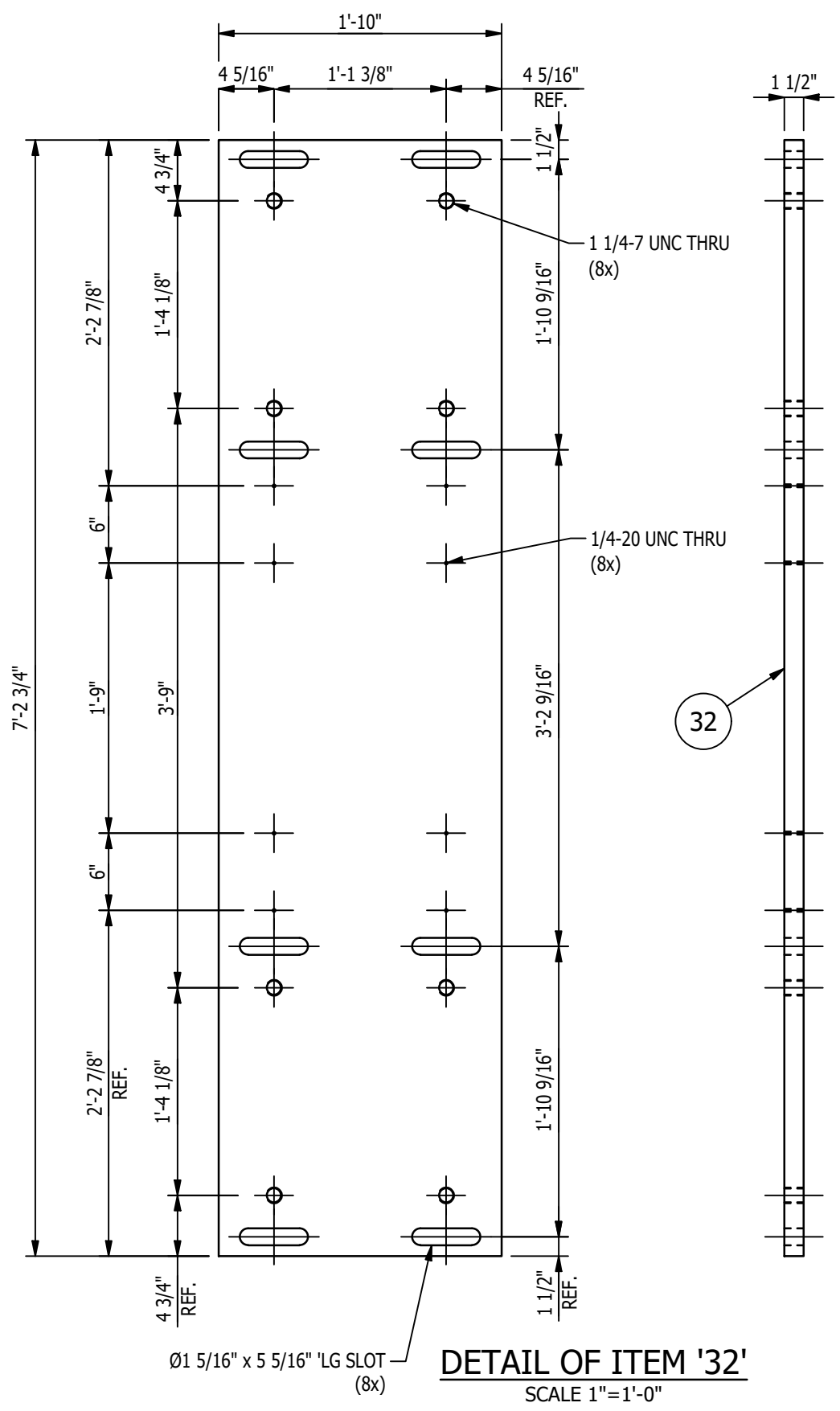
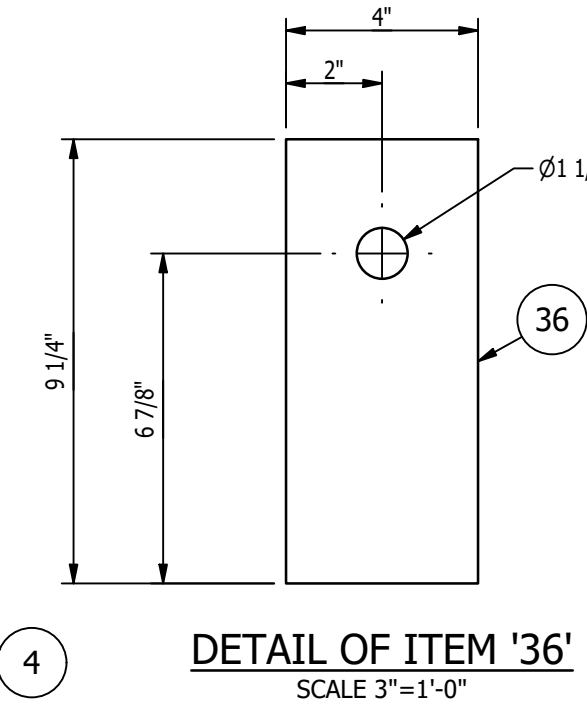
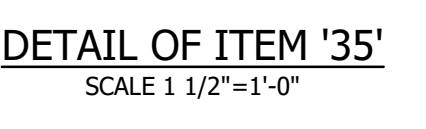
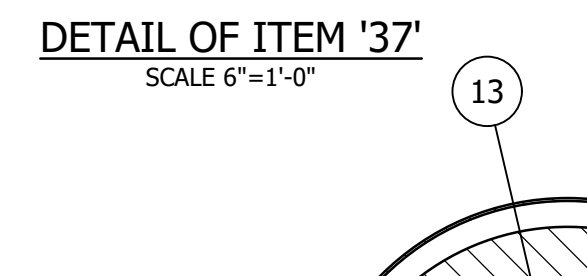
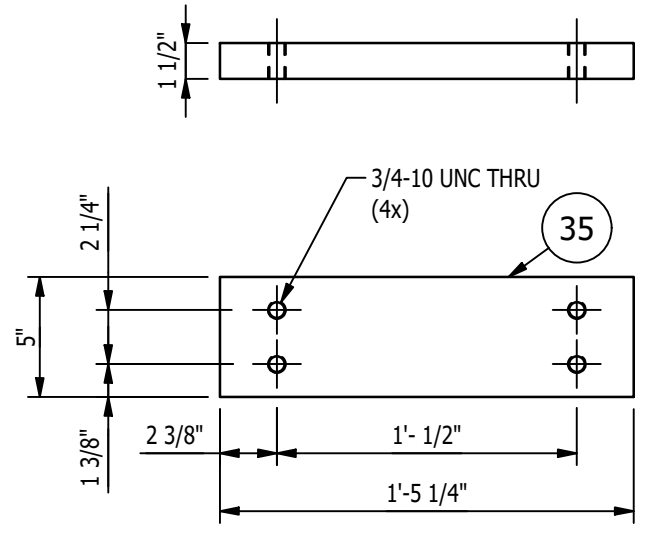
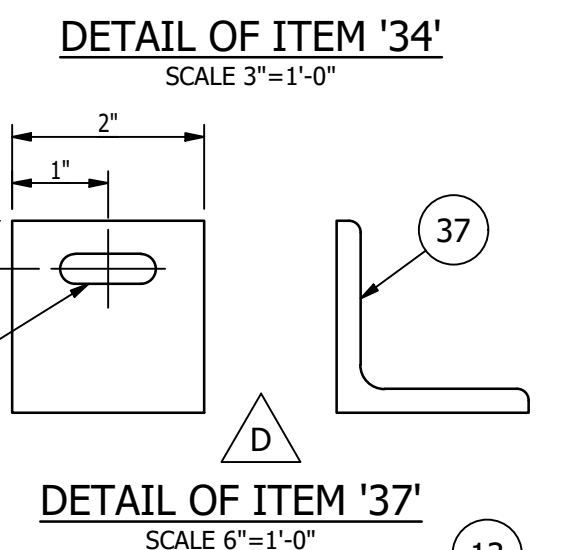
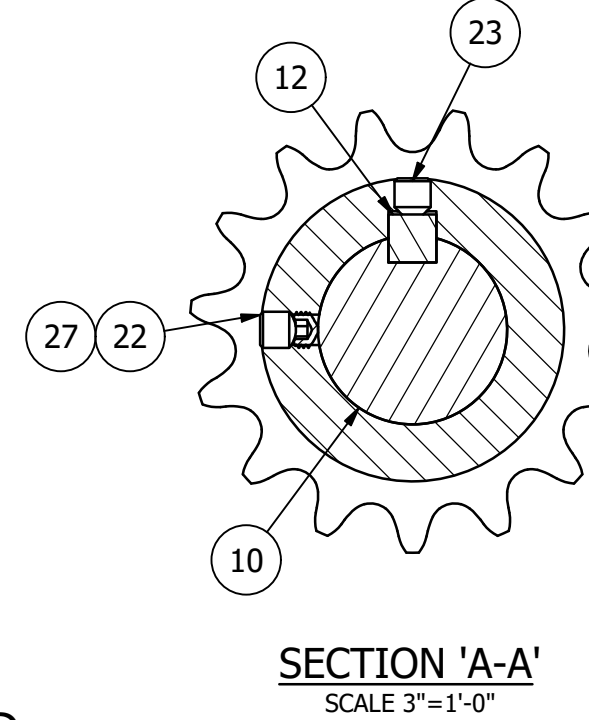
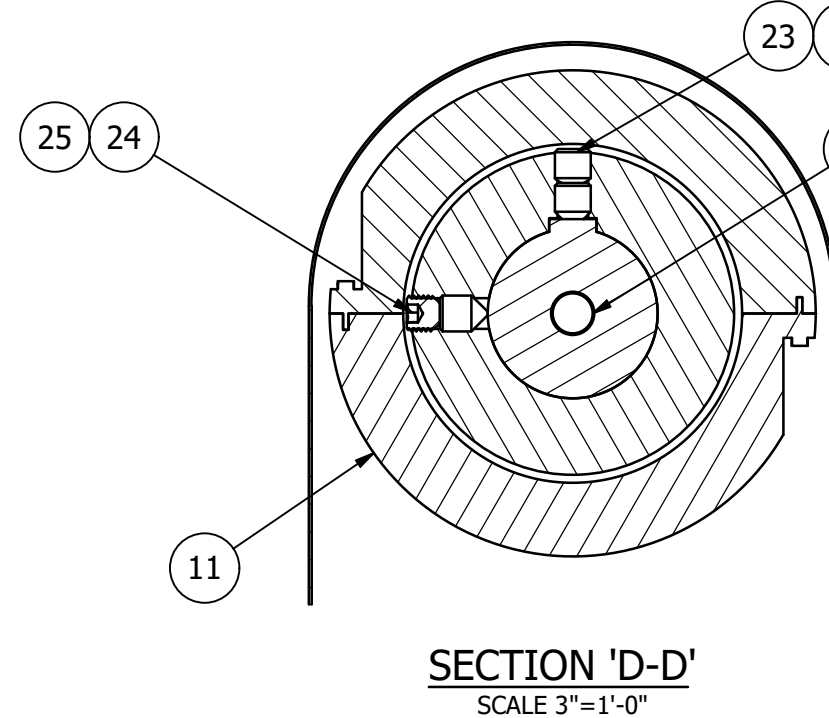
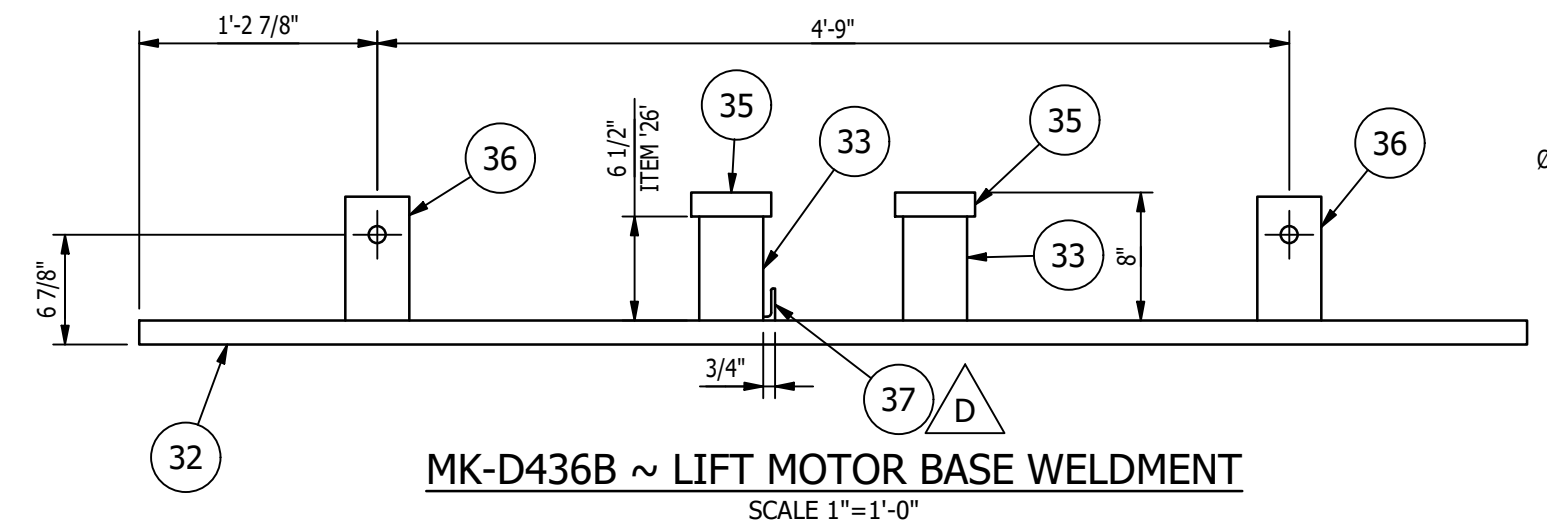
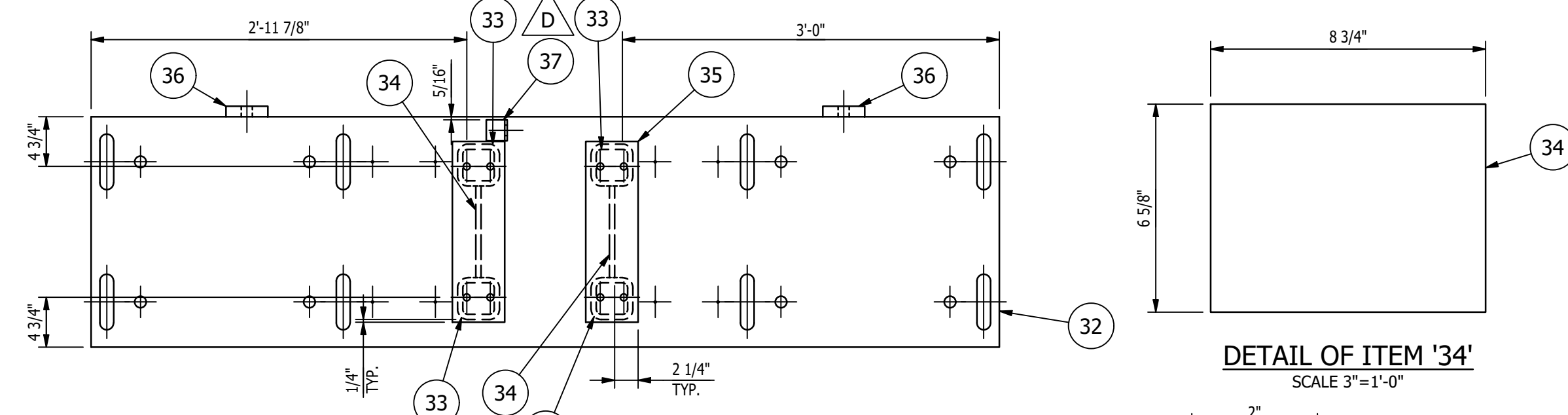
TITLE: P6700 CONVEYORS CAMPUS BUILDING
CLIENT: VOLVO
DRAWING No. 1875D434
REV: C
JOB No: 22096

DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 10/11/22

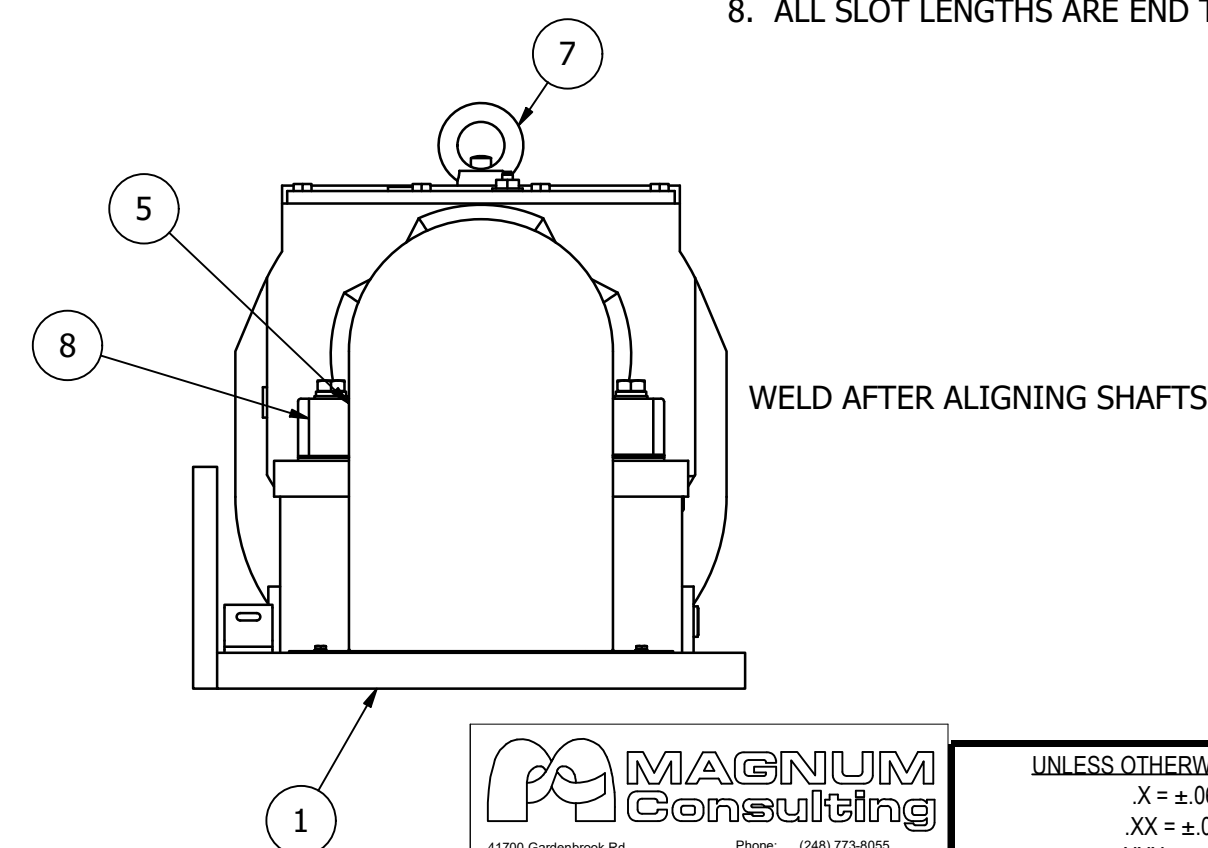
MAGNUM Consulting
 41702 Capetown Blvd
 Suite 125
 West, MI 48375
 Phone: (248) 773-8888
 Fax: (248) 773-8051
 Web: www.mmagnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D434

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



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



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D436A			
1	1	MK-D436B ~ LIFT MOTOR BASE WELDMENT			
3	4	MK-D447B ~ SHIM PACK			
4	1	MK-D446A ~ COUPLING GUARD			
5	1	MK-D446B ~ SHAFT GUARD			
7	1	FT2 GEAR MOTOR PER MOTOR DATA SHEET		1-8	
8	2	DODGE S-2000 PILLOW BLOCK, 4-BOLT BASE, NON-EXPANSION, 3 15/16 BORE, PART NO. 070409		25-3	
9	1	#140-3 TRIPLE STEEL SPROCKET: 1 3/4" PITCH, 15 TOOTH HARDENED, TYPE 'C' HUB, 6.250" LENGTH THRU BORE, 3 15/16 H7 BORE, 1" STD KEYWAY, 2 STD SET SCREWS 90 DEG APART, ONE OVER KEYWAY. KEYWAY TO BE IN LINE WITH SPROCKET TOOTH.		25-1	
10	1	BAR Ø3 15/16 (1045 CRS)	2'-2 1/4"		
11	1	DODGE 10020 CHAIN COUPLING; BORE ONE HALF 90.000/90.035mm WITH KEYWAY FOR 25 X 14 KEY (J59 FIT); BORE SECOND HALF 3.8750/3.8764 WITH 1" KEYWAY (CLASS 1 FIT); W/ 3/4-10 HOLES FOR SET SCREWS, (1) OVER KEY, (1) 90 DEG, KEYWAYS IN LINE WITH SPROCKET TOOTH; W/ 099024 CHAIN COVER		25-6	
12	1	1 x 1 x 6 1/4 LG. SQ. KEYSTOCK		26-5	
13	1	1 x 1 x 3 LG. SQ. KEYSTOCK		26-9	
14	8	3/4-10UNC x 4" LG. HEX HEAD CAP SCREW			
15	8	3/4 TYPE B NARROW FLAT WASHER			
16	8	3/4 SPRING LOCK WASHER			
17	4	1 1/4-7UNC x 4 1/2" LG. HEX HEAD CAP SCREW			
18	4	1 1/4 SPRING LOCK WASHER			
20	8	1/4-20UNC x 3/4" LG. HEX HEAD CAP SCREW			
21	8	1/4 SPRING LOCK WASHER			
22	1	3/4-10UNC x 1/2" LG. HEX SOCKET CONE POINT SET SCREW			
23	3	3/4-10UNC x 3/4" LG. HEX SOCKET CUP POINT SET SCREW			
24	1	3/4-10UNC x 1" LG. HEX SOCKET CONE POINT SET SCREW			
25	2	3/4-10UNC x 3/4" LG. HEX SOCKET OVAL POINT SET SCREW			
27	2	3/4-10UNC x 3/4" LG. HEX SOCKET OVAL POINT SET SCREW			
29	1	3/4-10 x 3/4" LG. HEX SOCKET CONE POINT SET SCREW			
30	4	5/8-11UNC x 1/2" LG. HEX SOCKET OVAL POINT SET SCREW			
31	4	5/8-11UNC x 1/2" LG. HEX SOCKET CONE POINT SET SCREW			
MK-D436B					
32	1	PL 1 1/2 x 1'-10"	7'-2 3/4"		
33	4	HSS 4 x 4 x 1/2 A500 GR. C	6 1/2"		
34	2	PL 1/2 x 6 5/8"	8 3/4"		
35	2	BAR 1 1/2 x 5	1'-5 1/4"		
36	2	BAR 1 x 4	9 1/4"		
37	1	L 2 x 2 x 1/4	2"		

REV	BY	DATE	DESCRIPTION	APP
D	MC	11/18/22	ADDED ITEM '37', ITEM '8' FLIPPED SIDES FOR EASIER ACCESS TO GREASE FITTINGS	
C	MC	11/16/22	REVISED FILLET, DIMS ITEM 10	
B	MC	10/31/22	HOLE LOWERED BY 3/8" ON ITEM '36', BOTTOM OF ITEM '36' IS NOW FLUSH WITH ITEM '32', REV BALLOONS	
A	MC	10/21/22	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.

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. 1875D436

REV: D

DRAWN BY: RJB

CHECKED BY: CW

DWG DATE: 10/3/22

JOB No: 22096

MAGNUM Consulting

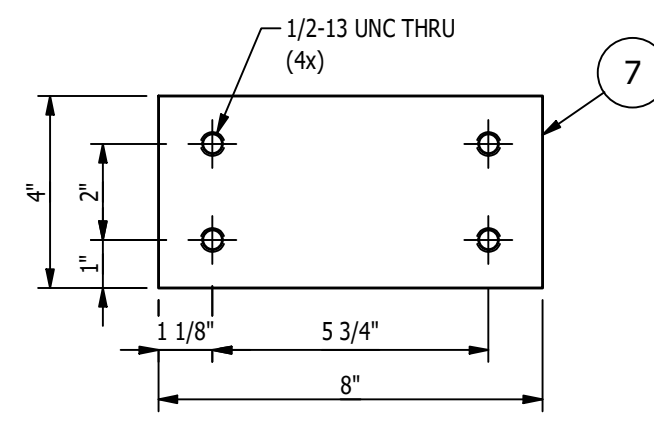
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Suite 125
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Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com

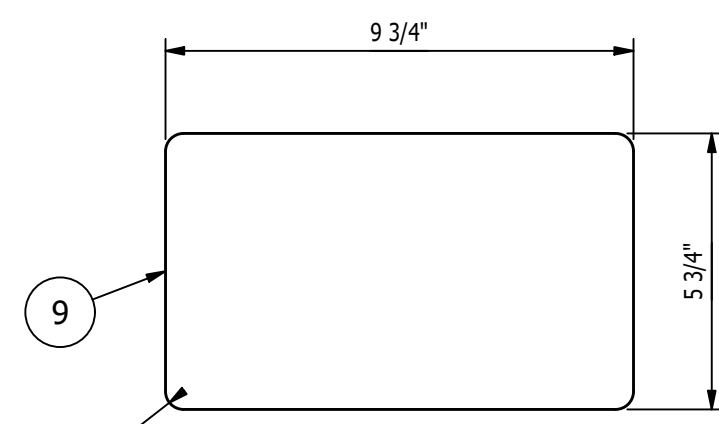
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D436 - REV D

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

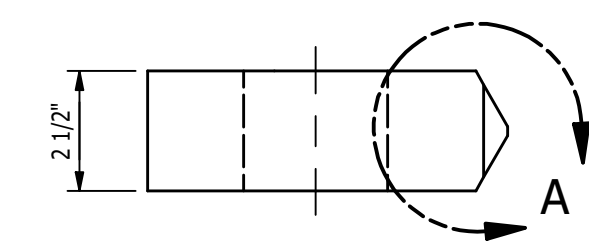
REVISION HISTORY



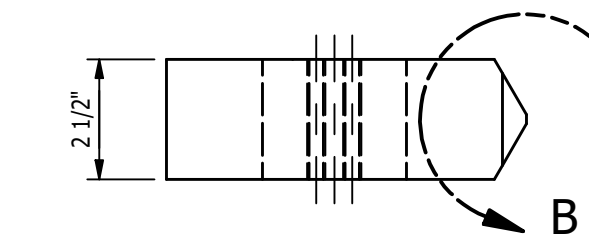
DETAIL OF ITEM '7'
SCALE 3"=1'-0"



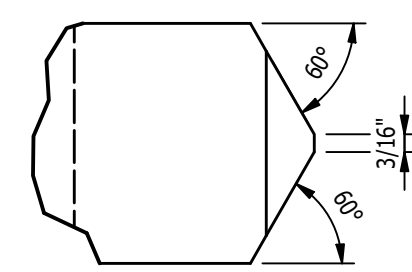
DETAIL OF ITEM '9'
SCALE 3"=1'-0"



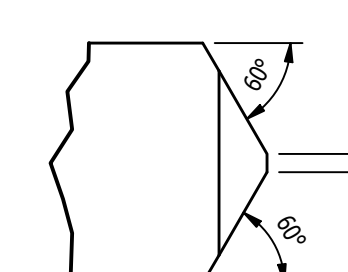
DETAIL OF ITEM '11'
SCALE 3"=1'-0"



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

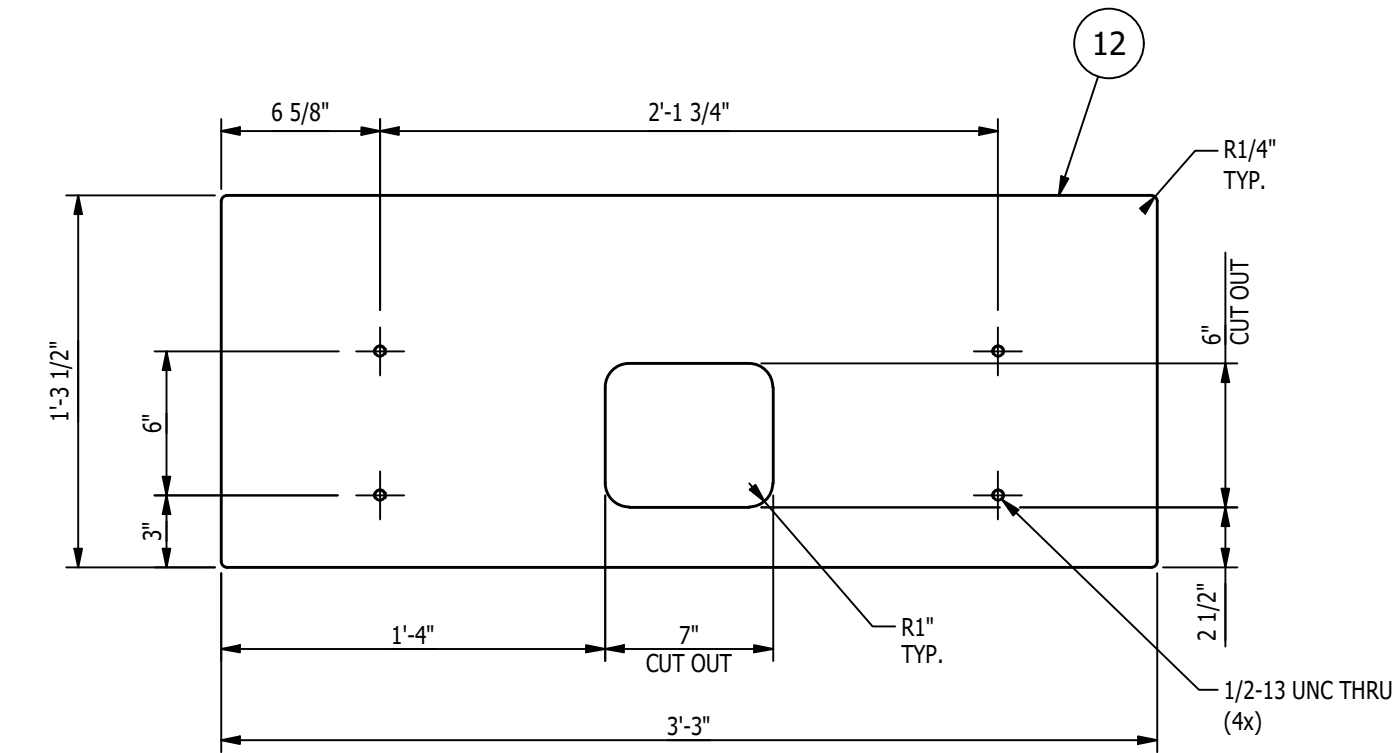
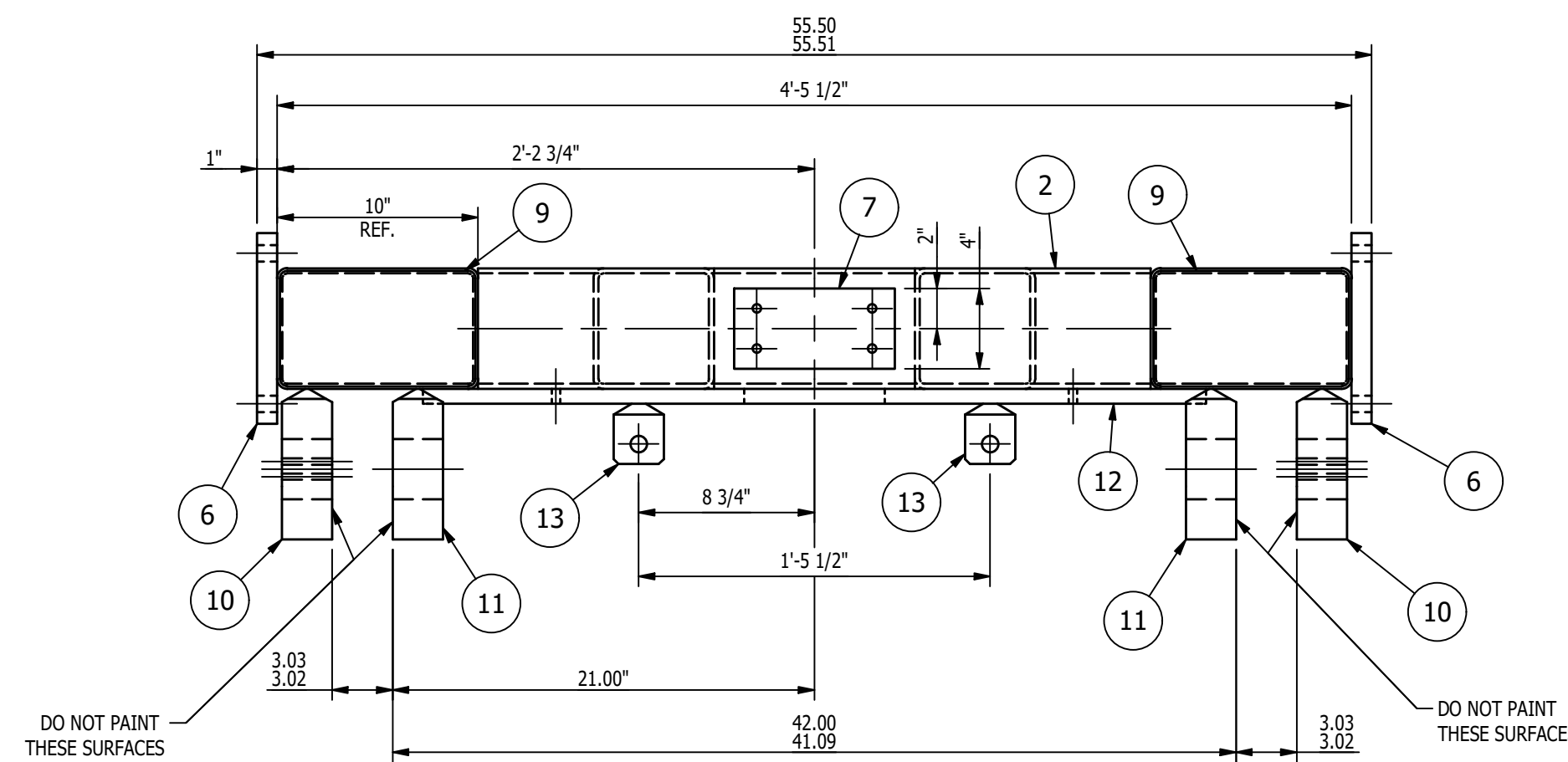


ENLARGED VIEW 'A'
SCALE 6"=1'-0"

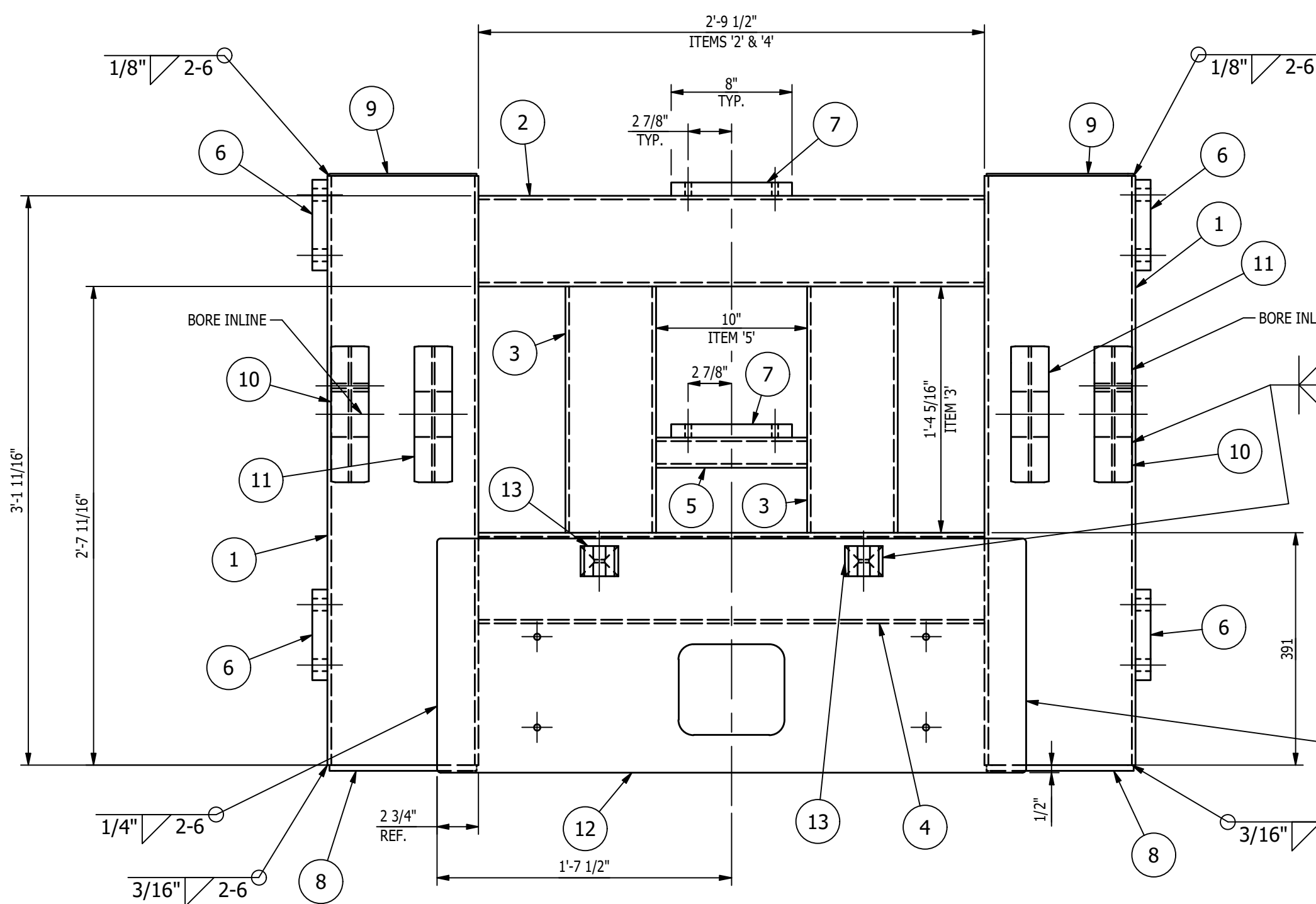


ENLARGED VIEW 'B'
SCALE 6"=1'-0"

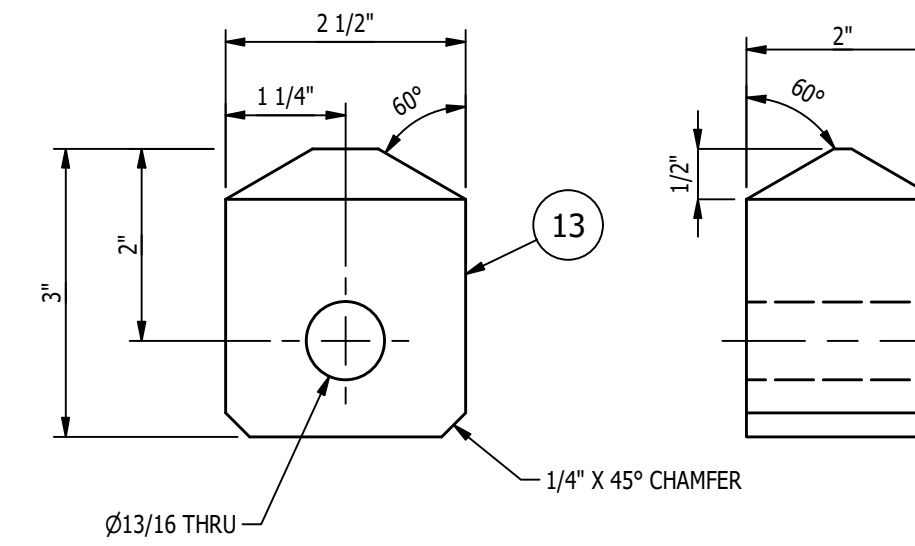
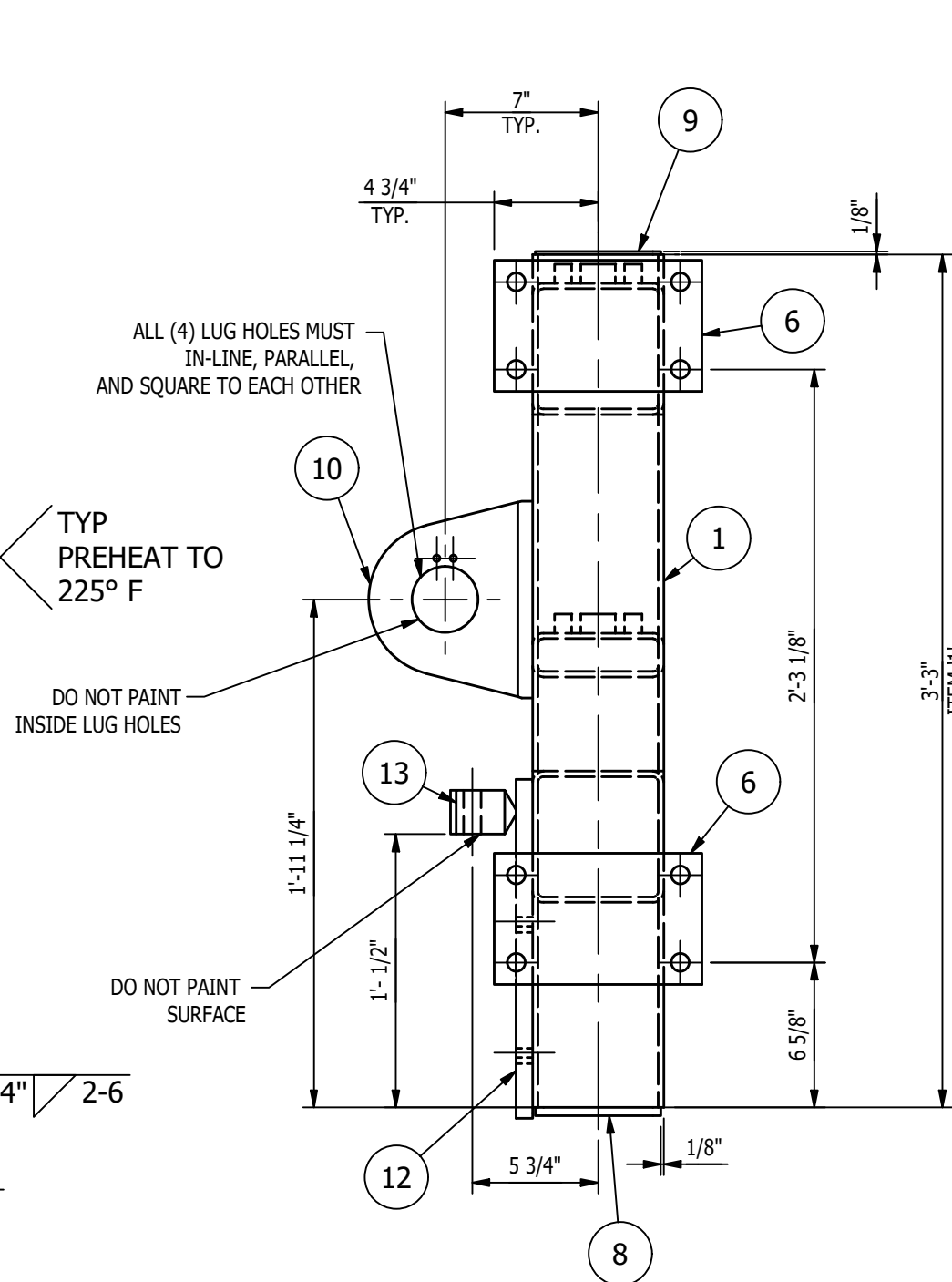
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D437A			
1	2	HSS 10 x 6 x 1/4 A500 GR. C	3'-3"		
2	1	HSS 6 x 6 x 1/4 A500 GR. C	2'-9 1/2"		
3	2	HSS 6 x 6 x 1/4 A500 GR. C	1'-4 5/16"		
4	1	HSS 6 x 6 x 1/4 A500 GR. C	2'-9 1/2"		
5	1	HSS 6 x 2 x 1/4 A500 GR. C	10"		
6	4	PL 1 x 6"	9 1/2"		
7	2	BAR 7/8 x 4	8"		
8	2	PL 3/8 x 5 3/4"	9 3/4"		
9	2	10 GA x 5 3/4"	9 3/4"		
10	2	PL 2 1/2 x 7 1/2	9"		
11	2	PL 2 1/2 x 7 1/2	9"		
12	1	PL 3/4 x 1'-3 1/2"	3'-3"		
13	2	BAR 2 x 2 1/2	3"		



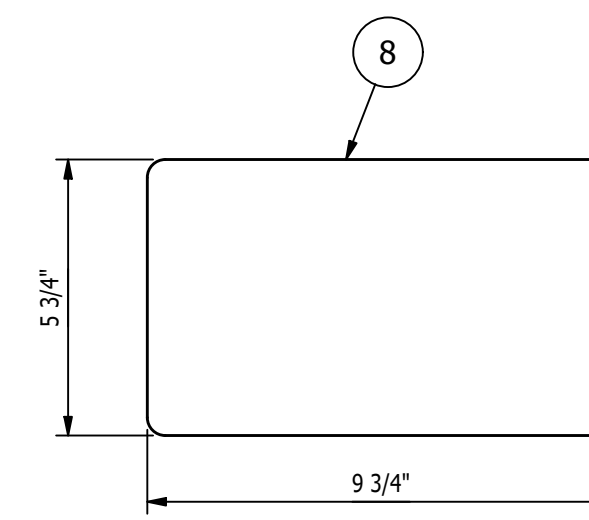
DETAIL OF ITEM '12'
SCALE 1 1/2"=1'-0"



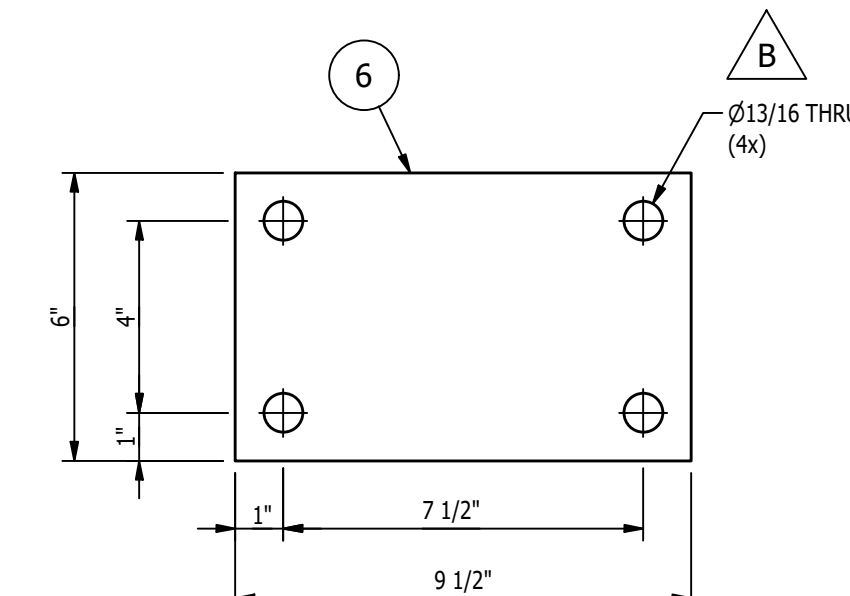
MK-D437A ~ LIFT CARRIAGE END
SCALE 1 1/2"=1'-0"



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



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



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

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/1/2022	REV HOLE SIZES	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY	
B	MC 11/1/2022 REV HOLE SIZES
A	MC 10/21/22 FOR FABRICATION

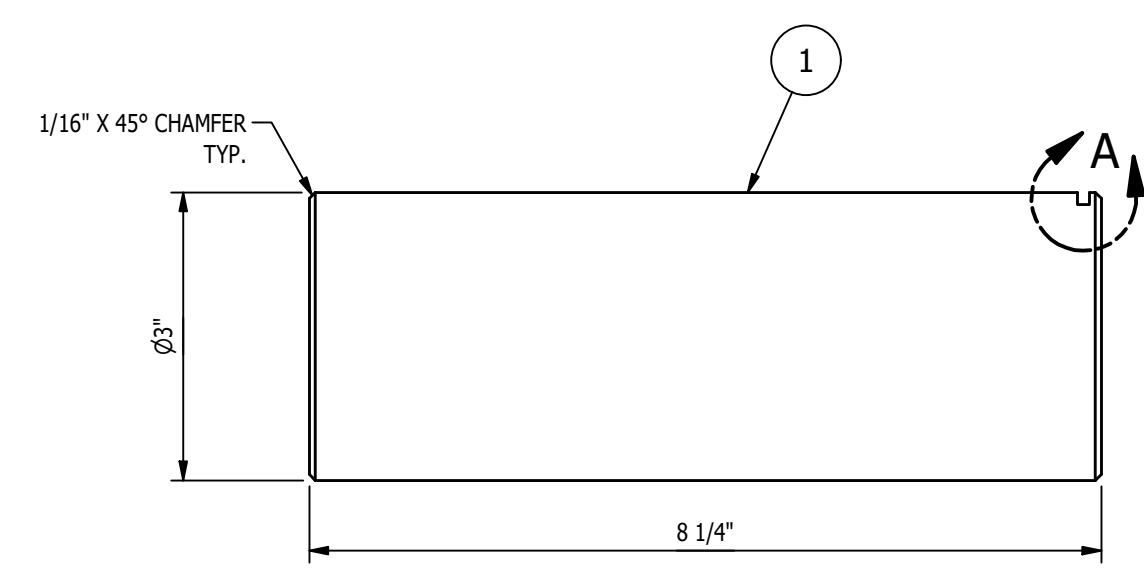
		MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
TITLE: P6700 CONVEYORS CAMPUS BUILDING		DRAWN BY: RJB		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 10/5/22		JOB No: 22096	
DRAWING No. 1875D437		REV: A		JOB No: 22096	

MAGNUM CONSULTING
 41100 Charleston Rd.
 Suite 125
 Norcross, GA 30052
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 Fax: (770) 447-8851
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 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D437 - REV B

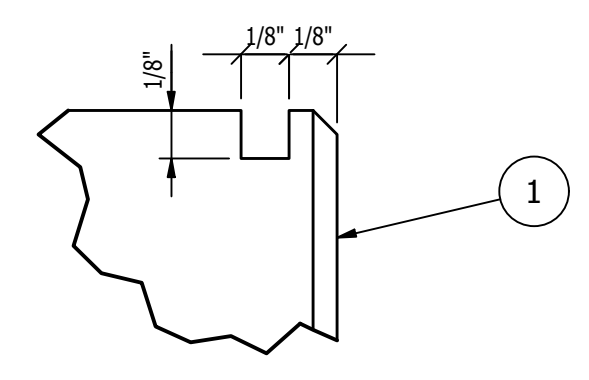
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 X = ±.060
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 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
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 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

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

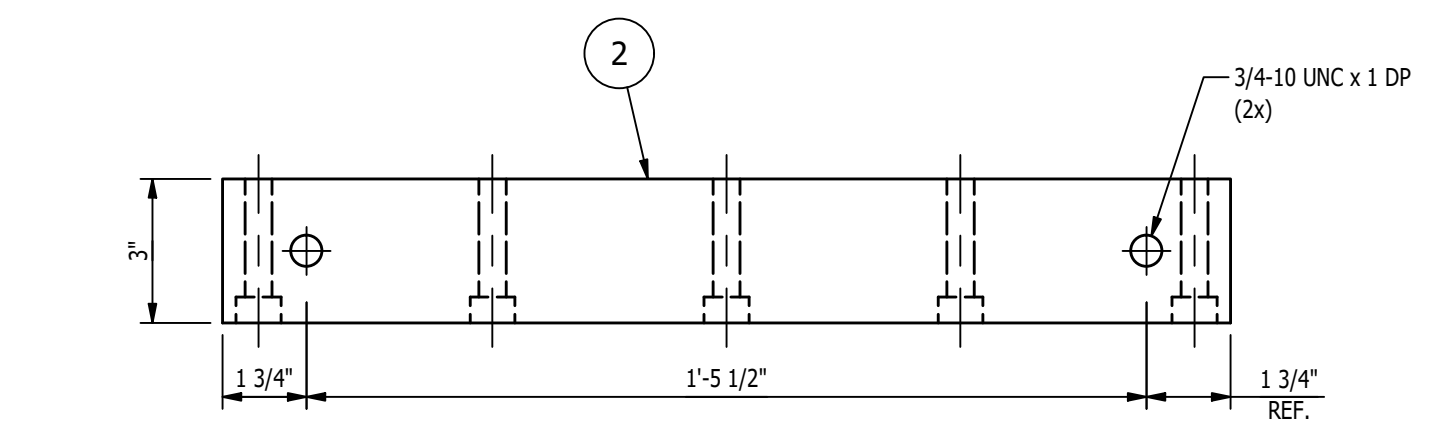
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D440A			
1	1	BAR Ø3 (1045 CRS)	8 1/4"		
		MK-D440B			
2	1	SQ. BAR 3 (1045)	1'-9"		
		MK-D440C			
3	1	PL 1/2 x 11 1/4"	2'-3 1/2"		
4	1	L 3 x 3 x 1/4	1'-9"		
5	3	BAR 1/2 x 1 1/4	3 3/16"		
		MK-D440E			
6	1	BAR 1/2 x 2 1/2 1045 CRS	4 1/4"		
		MK-D440F			
7	1	SHT .125 x 1	1 3/4"		



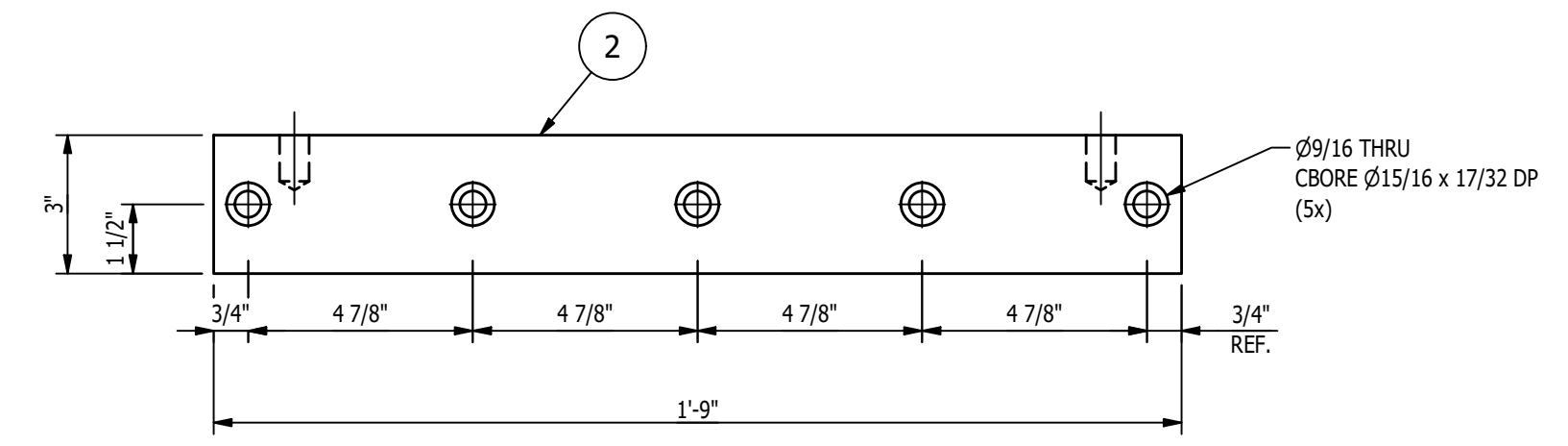
MK-D440A ~ CONNECTION PIN
SCALE 6"=1'-0"



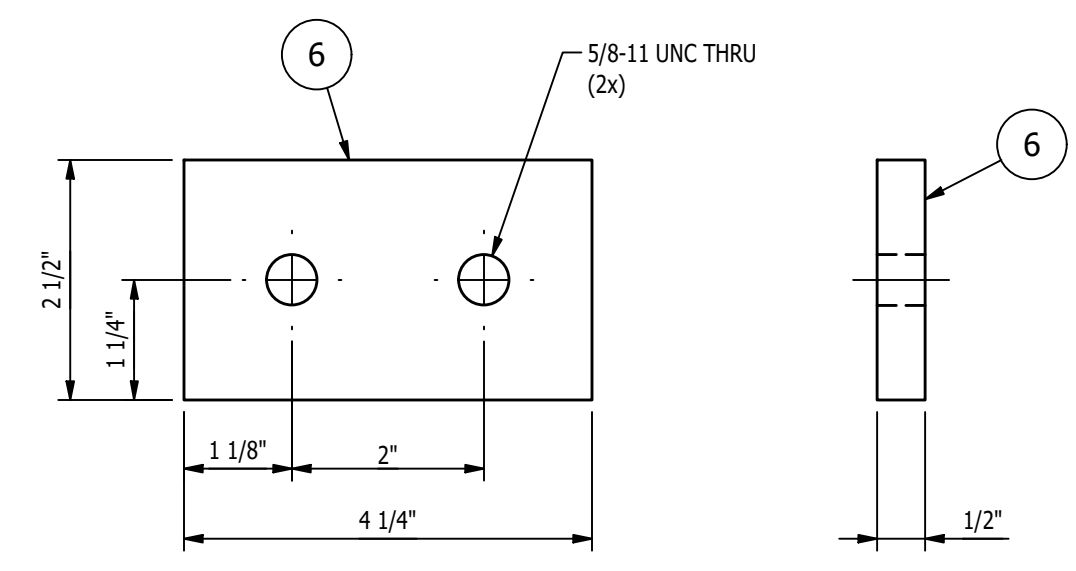
ENLARGED VIEW 'A'
SCALE 2:1



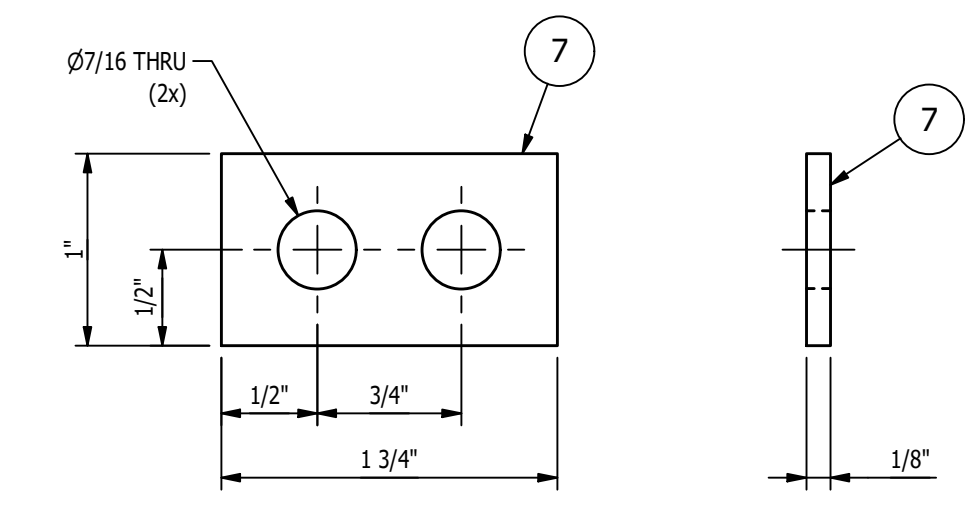
MK-D440B ~ LIFT CAM ROLL GUIDE
SCALE 3"=1'-0"



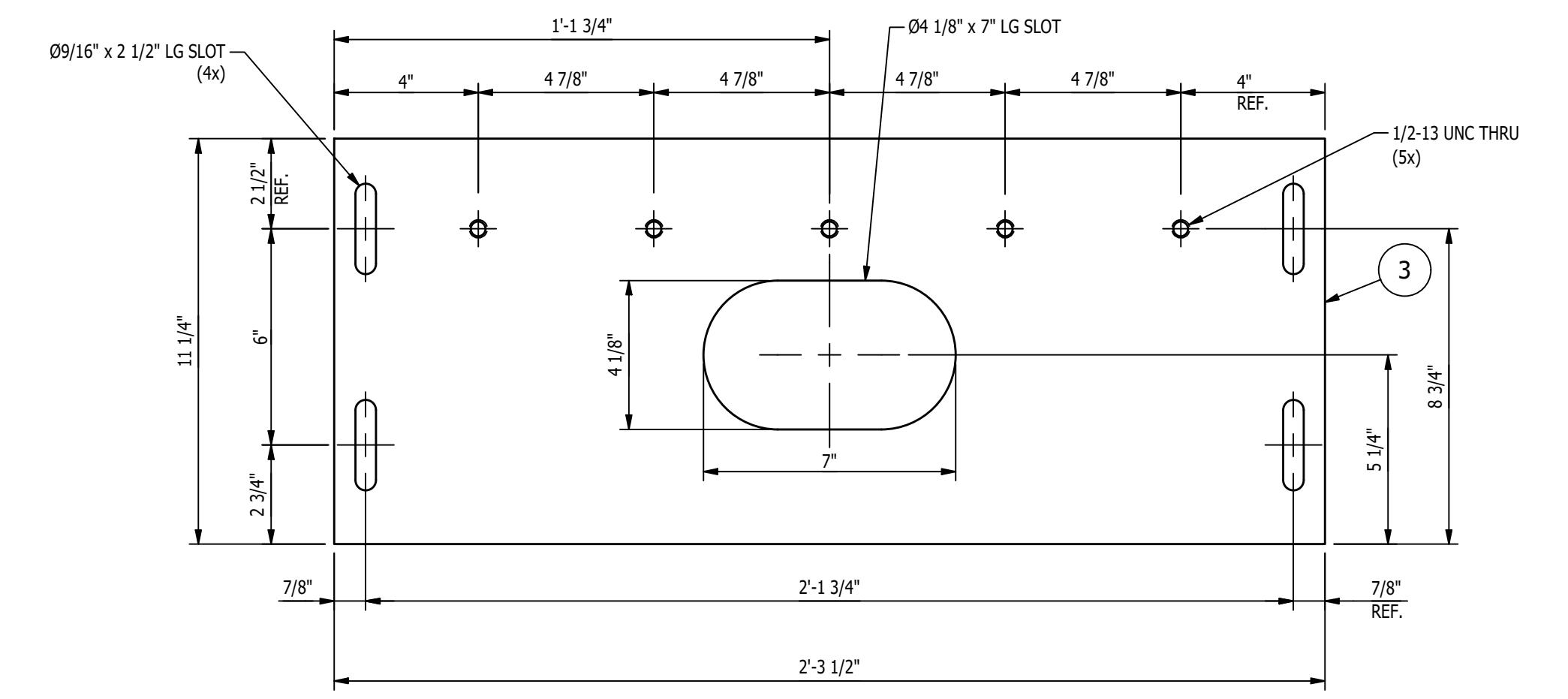
MK-D440C ~ LIFT CAM ROLL GUIDE WELDMENT
SCALE 3"=1'-0"



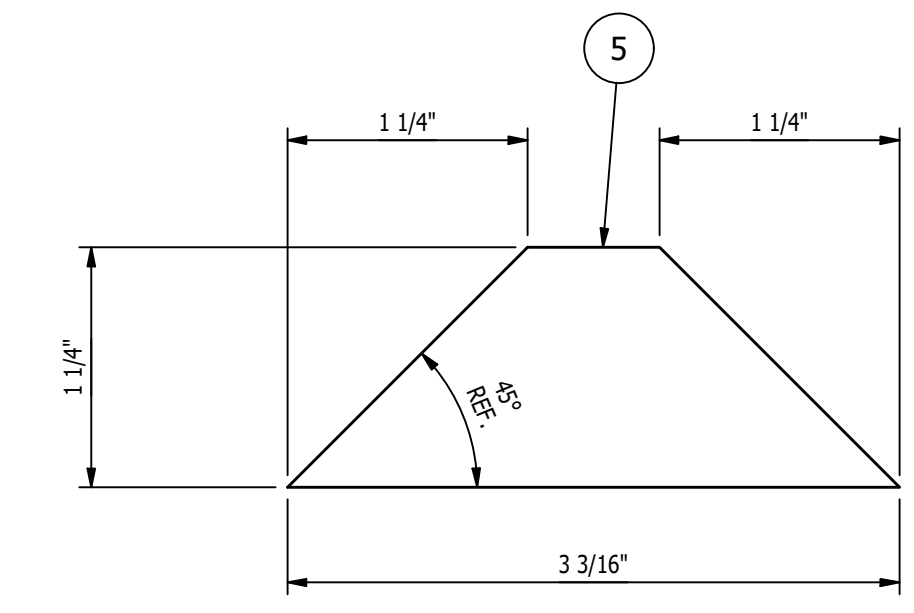
MK-D440E ~ WEAR BAR
SCALE 6"=1'-0"



MK-D440F ~ KEEPER PLATE
SCALE 1'-0"=1'-0"



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

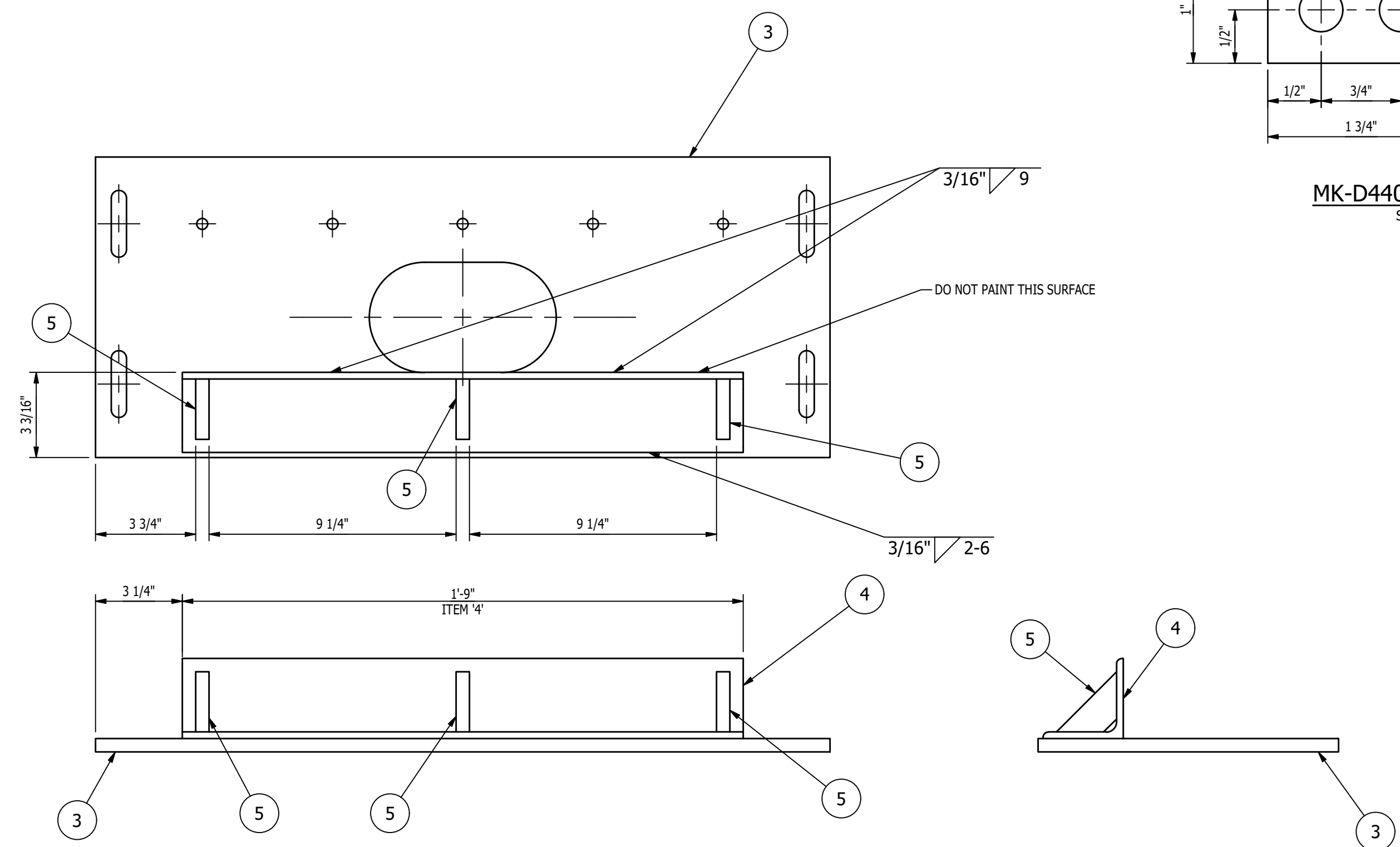


DETAIL OF ITEM '5'
SCALE 1'-0"=1'-0"

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 ITEM '1'



MK-D440D ~ LIFT CAM ROLL GUIDE
SCALE 3"=1'-0"

REV	BY	DATE	DESCRIPTION	APP
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY

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TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D440	DWG DATE: 10/10/22
REV: A	JOB No: 22096

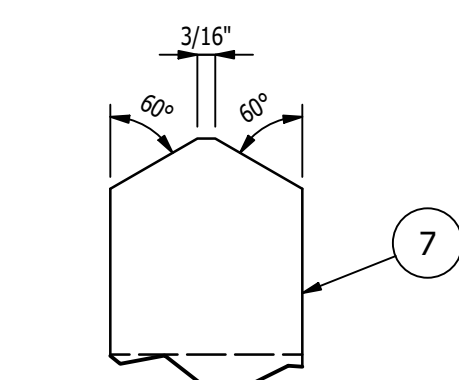
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 Novi, MI 48275
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 ANGLES = ±1°30'
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 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

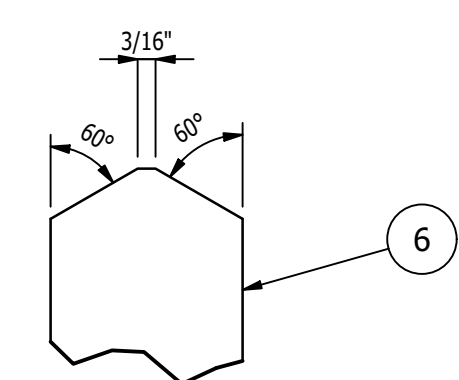
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN 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 10/25/2022 New Job Drawings/Details/1875D440.dwg

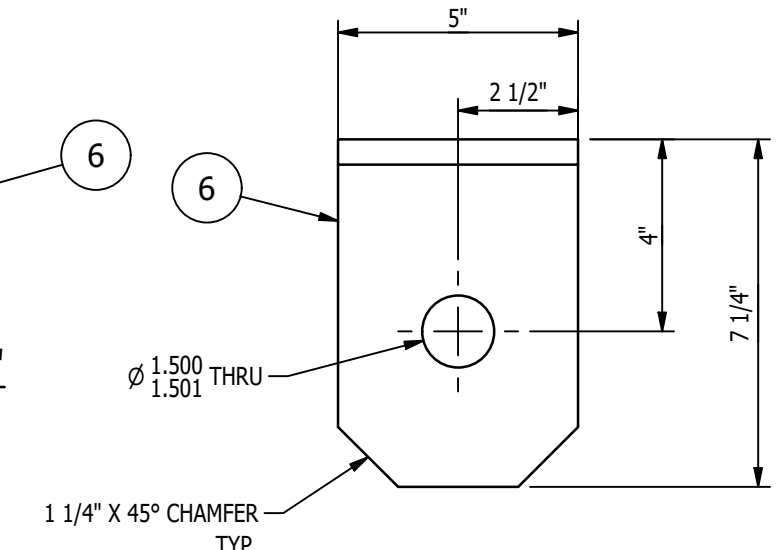
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D442A			
1	6	BAR 3/4 x 4 1/2	8"		
2	2	SHT 10 GA x 5 5/8	5 5/8"		
3	12	BAR 1/4 x 4 1/4	4 1/8"		
4	2	HSS 6 x 6 x 3/8 A500 GR. C	11'-5 3/8"		
5	2	HSS 6 x 6 x 3/8 A500 GR. C	6'-5 5/8"		
6	2	PL 2 x 7 1/4"	5"		
7	2	PL 2 x 7 1/4"	5"		
8	4	BAR 3/8 x 11	11"		
9	2	HSS 6 x 3 x 1/4 A500 GR. C	5'-5 5/8"		
10	2	PL 3/8 x 5 5/8"	5 5/8"		



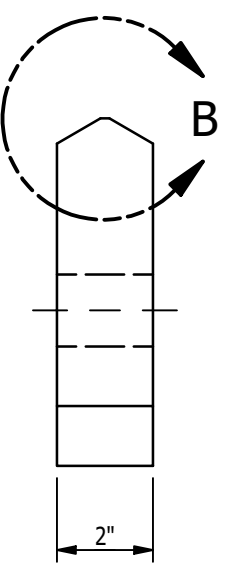
ENLARGED VIEW 'C'
SCALE 6" = 1'-0"



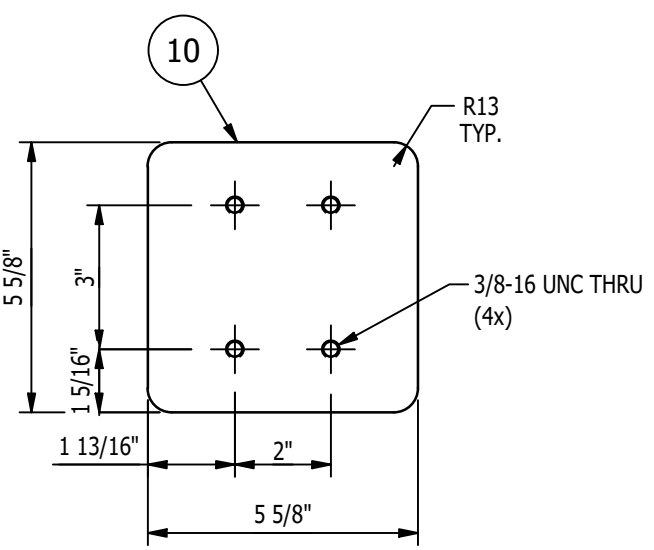
ENLARGED VIEW 'B'
SCALE 6" = 1'-0"



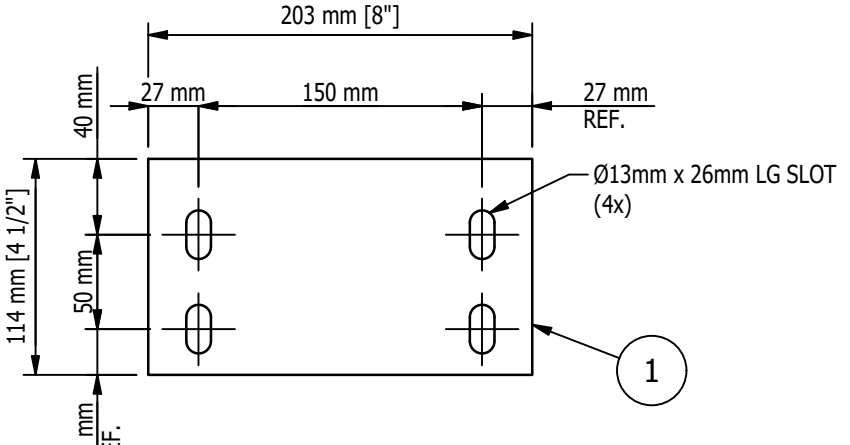
DETAIL OF ITEM '6'
SCALE 3" = 1'-0"



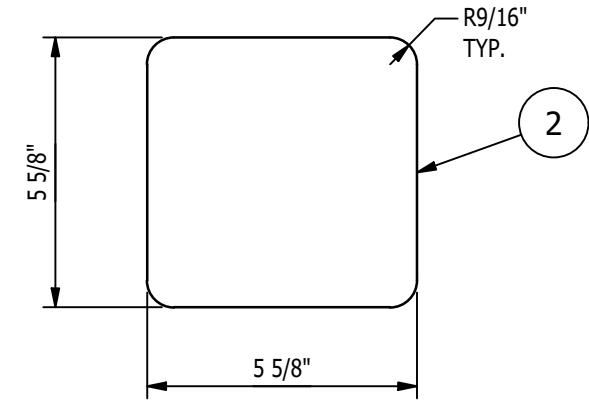
DETAIL OF ITEM '7'
SCALE 3" = 1'-0"



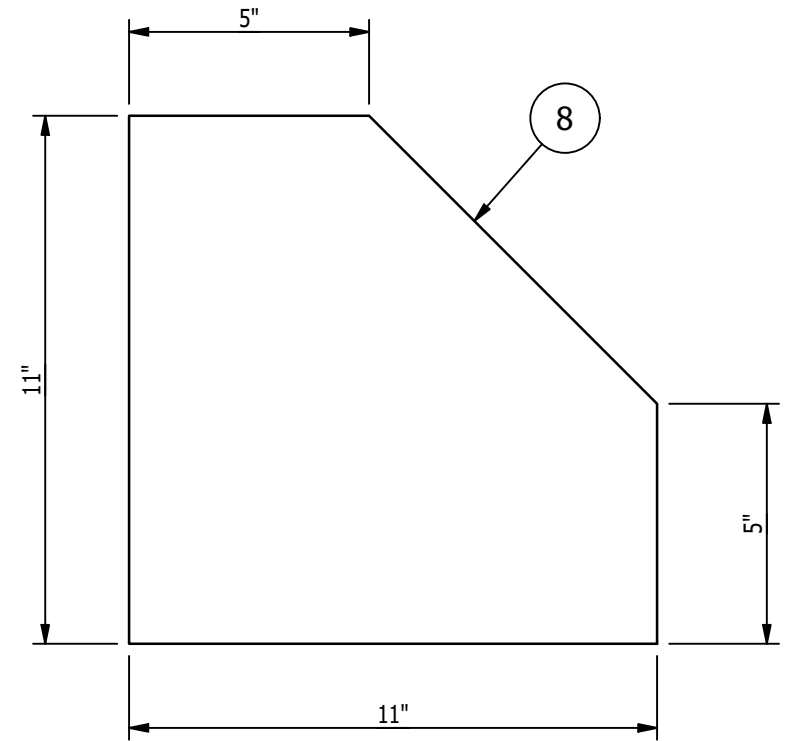
DETAIL OF ITEM '10'
SCALE 3" = 1'-0"



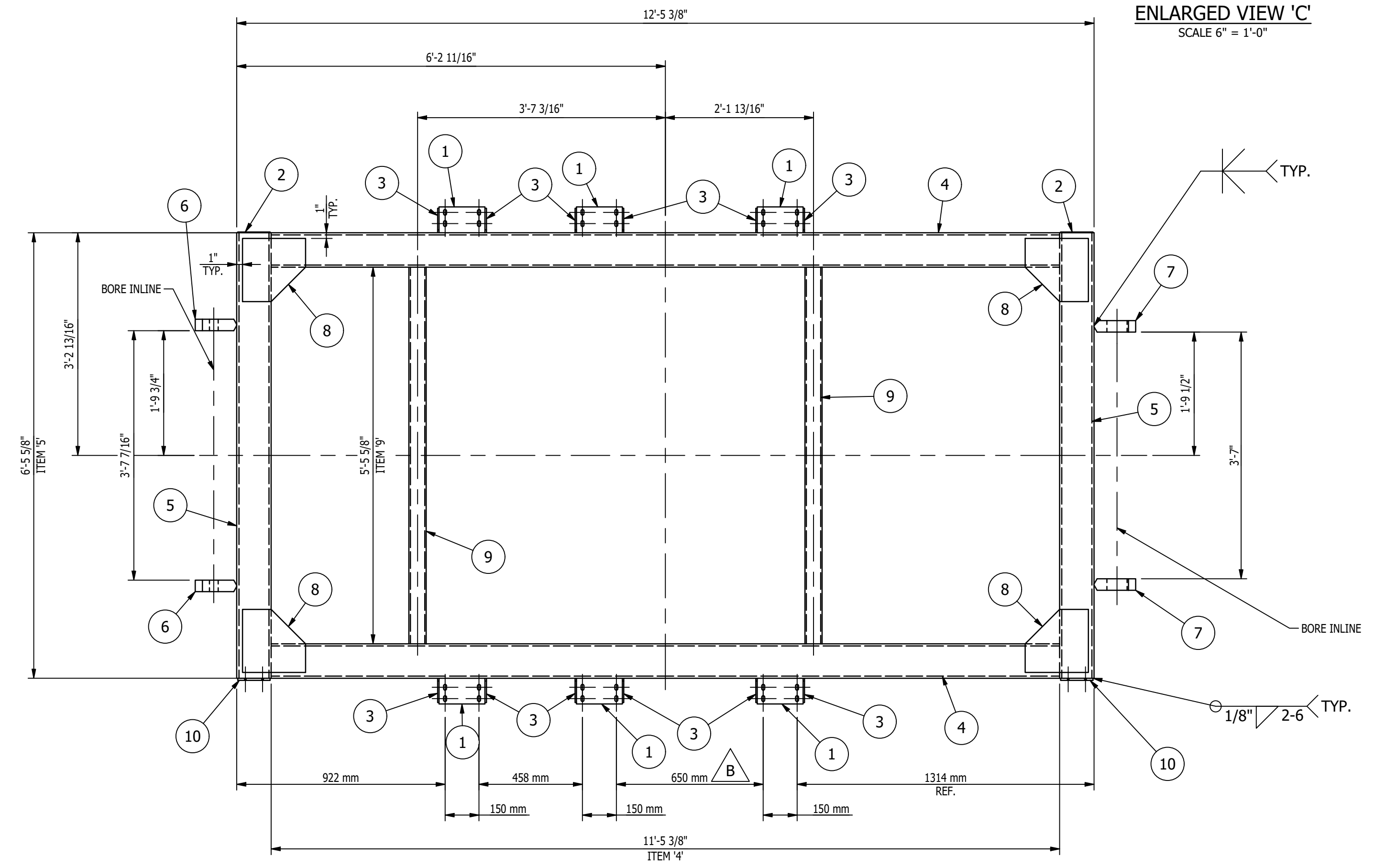
DETAIL OF ITEM '1'
SCALE 3" = 1'-0"



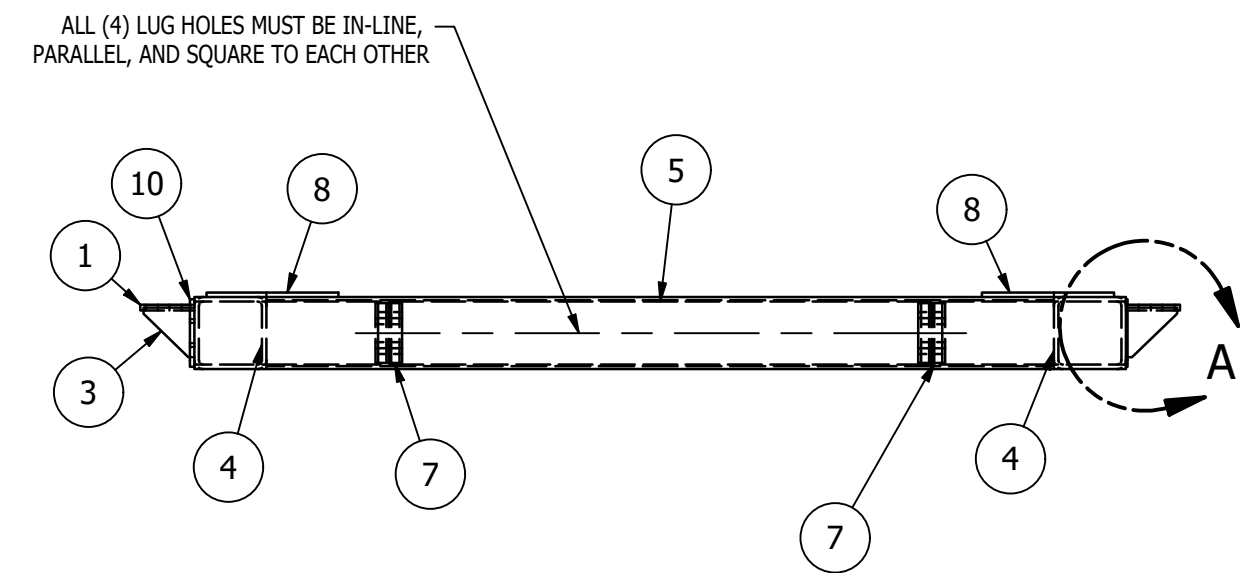
DETAIL OF ITEM '2'
SCALE 3" = 1'-0"



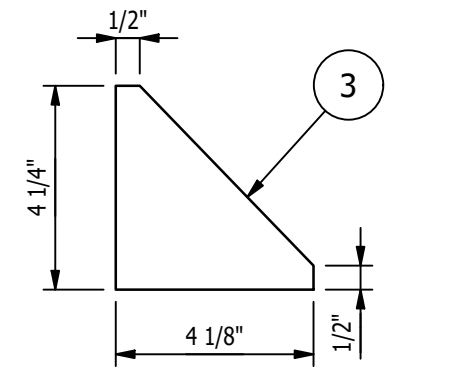
DETAIL OF ITEM '8'
SCALE 3" = 1'-0"



MK-D442A ~ MOVING CARRIAGE WELDMENT
SCALE 3/4" = 1'-0"



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



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

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/1/2022	REVISED DIM	
A	MC	10/21/22	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. 1875D442	DWG DATE: 10/10/22
REV: B	JOB No: 22096

MAGNUM Consulting
41100 Dardickwood Rd.
Suite 125
West, MI 48315
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:

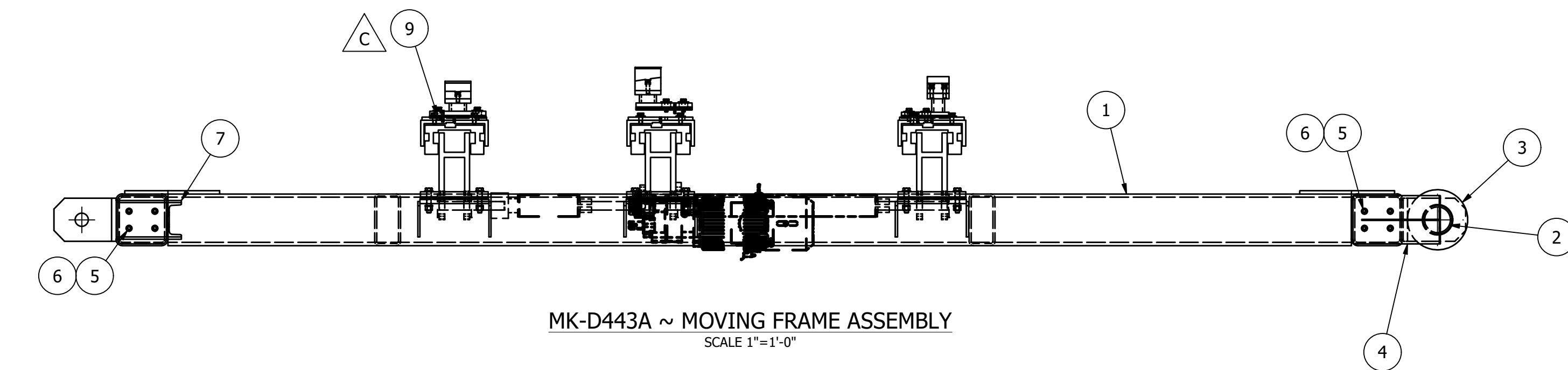
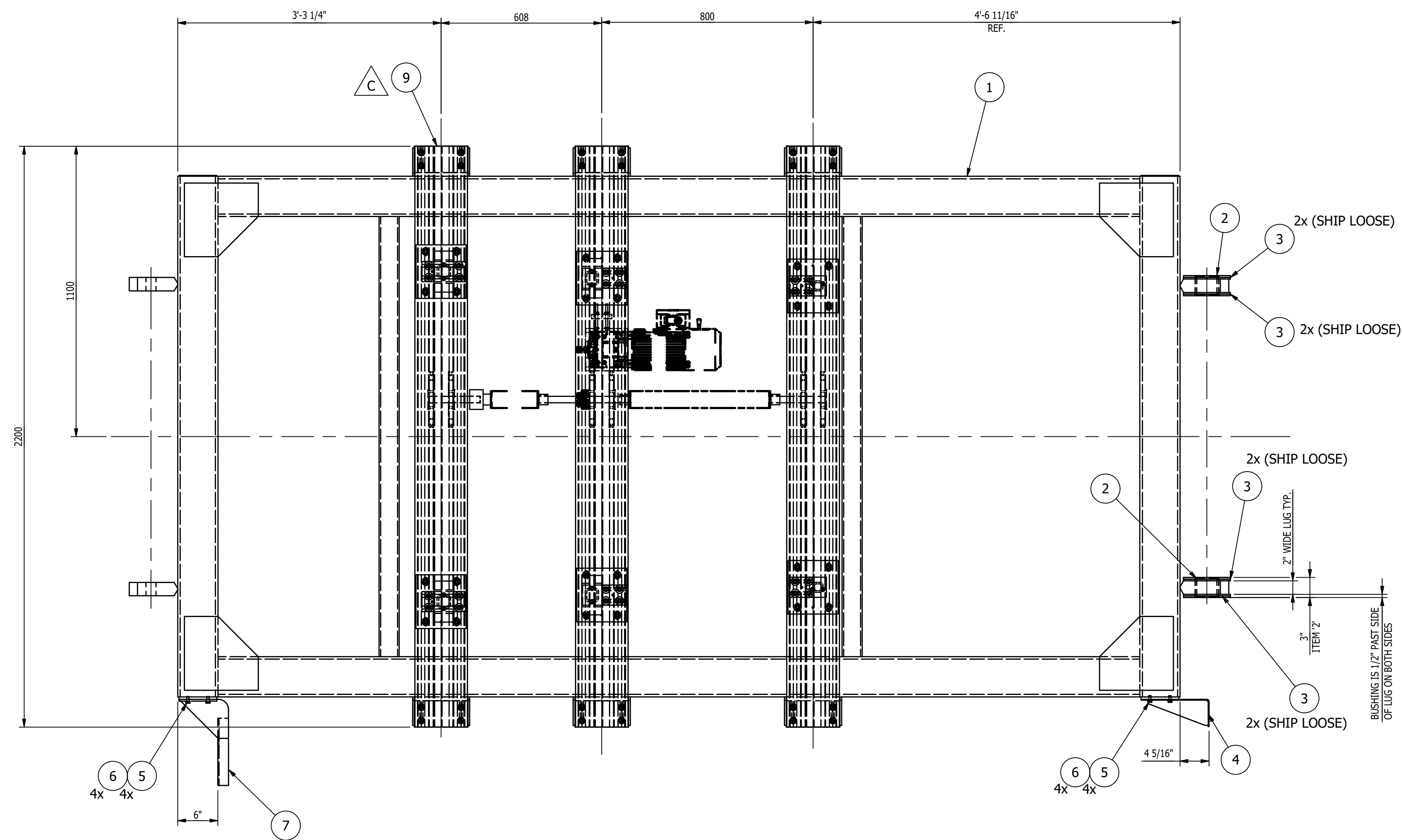
- ALL WELDS TO BE "E70XX", (PER AWS D1.1)

PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

COPIES:

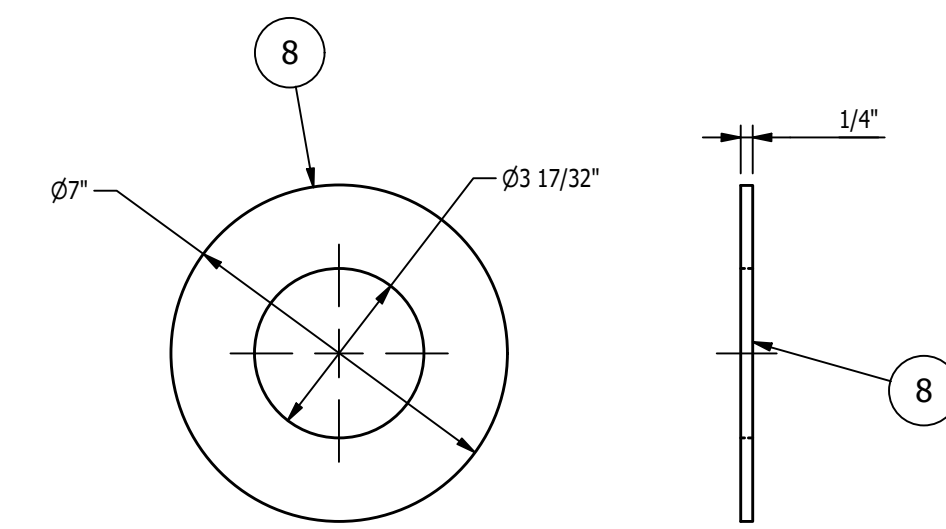
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.



MK-D443A ~ MOVING FRAME ASSEMBLY
SCALE 1"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
1	1	MK-D443A ~ MOVING CARRIAGE WELDMENT			
2	2	BUNTING CAST BRONZE SLEEVE BEARING, 3.5" OD, 3" ID, 3" LG, BUNTING PART NO. CB485624		26-6	
3	8	MK-D443B ~ SPACER			
4	1	MK-D449A ~ PROX SWITCH BRACKET			
5	8	3/8 SPRING LOCK WASHER			
6	8	3/8-16UNC x 3/4" LG. HEX HEAD CAP SCREW			
7	1	MK-D448A ~ CAT TRACK MOUNT			
9	1	MK-D400A ~ FORK ASSEMBLY			
		MK-D443B			
8	1	BAR 1/4 x 7	7"		

△ C



MK-D443B ~ SPACER
SCALE 3"=1'-0"

SHOP NOTES:

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

PAINT NOTES:

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

REV	BY	DATE	DESCRIPTION	APP
C	MC	11/8/2022	REVISED ITEM '9'	
B	MC	11/1/2022	ADDED "SHIP LOOSE" NOTE FOR ITEM 3	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY

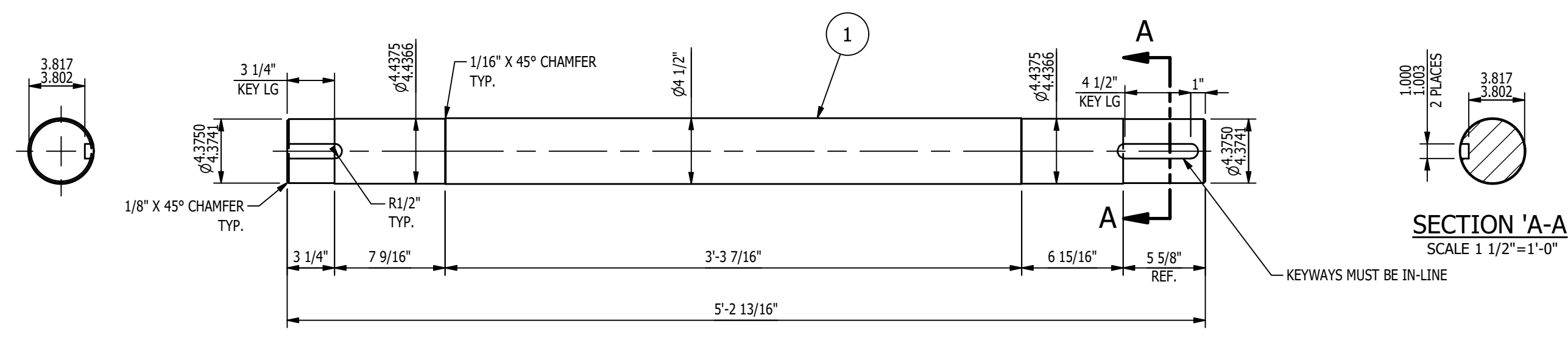
MILLER INDUSTRIES
3070 W. THOMPSON RD.
FENTON, MI 48430
PH: 810.373.0322 FAX: 810.373.0326
www.millc.com

TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D443	DWG DATE: 10/10/22
REV: C	JOB No: 22096

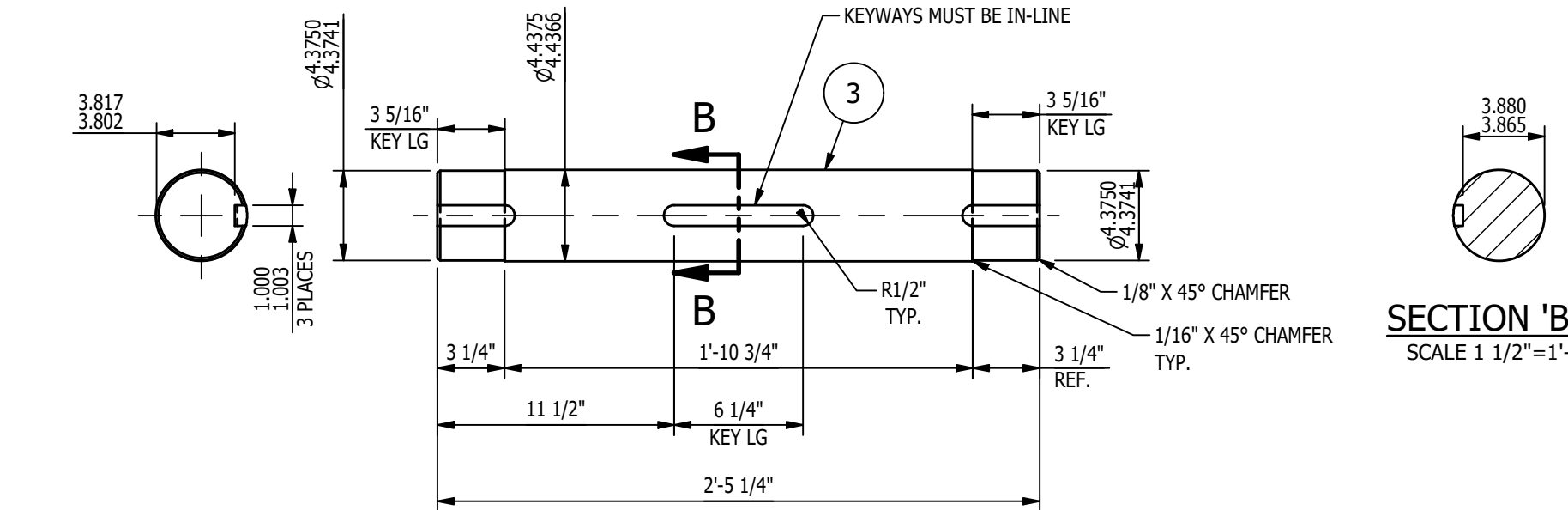
MAGNUM CONSULTING
41100 Clarkston Rd.
Suite 125
North, MI 48135
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D443

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

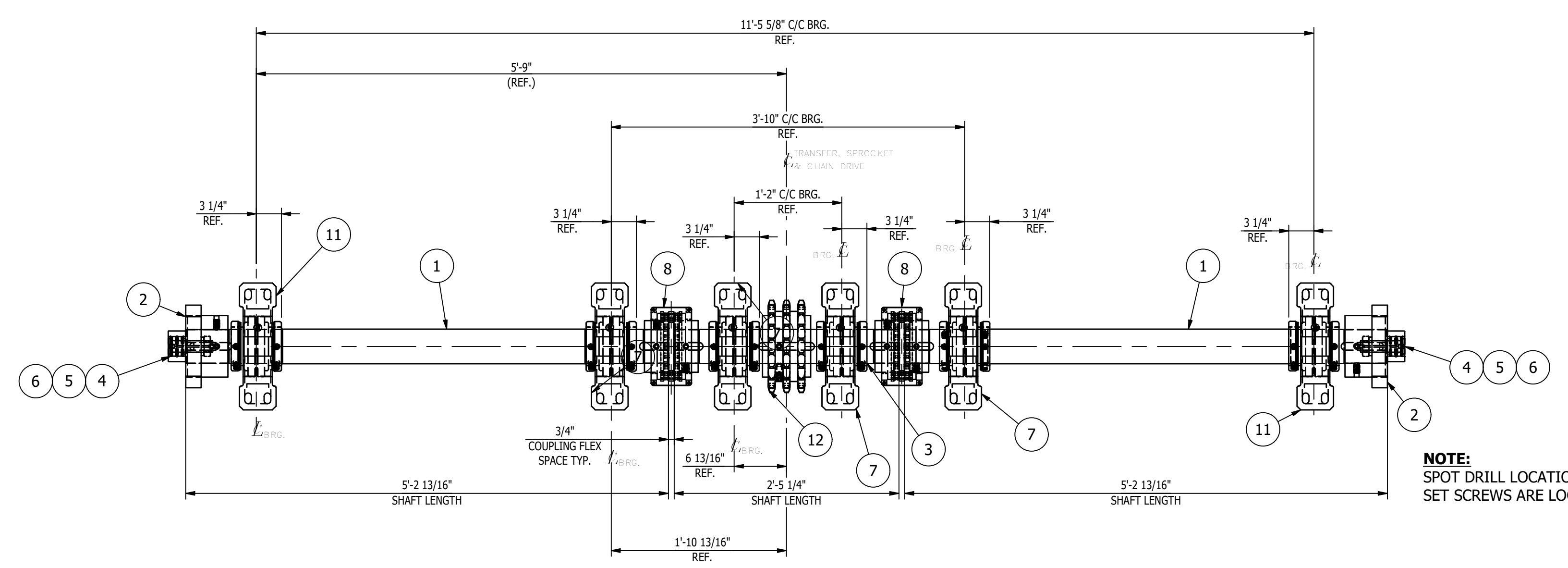
GENERAL NOTES:
MATERIALS:
- ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
- ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
- ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
- ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
HOLES:
- ALL HOLES ARE 13/16" DIA. U.N.O.
- ALL BOLTED CONNECTIONS TO BE 3/4" 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 '1'
SCALE 1 1/2"=1'-0"

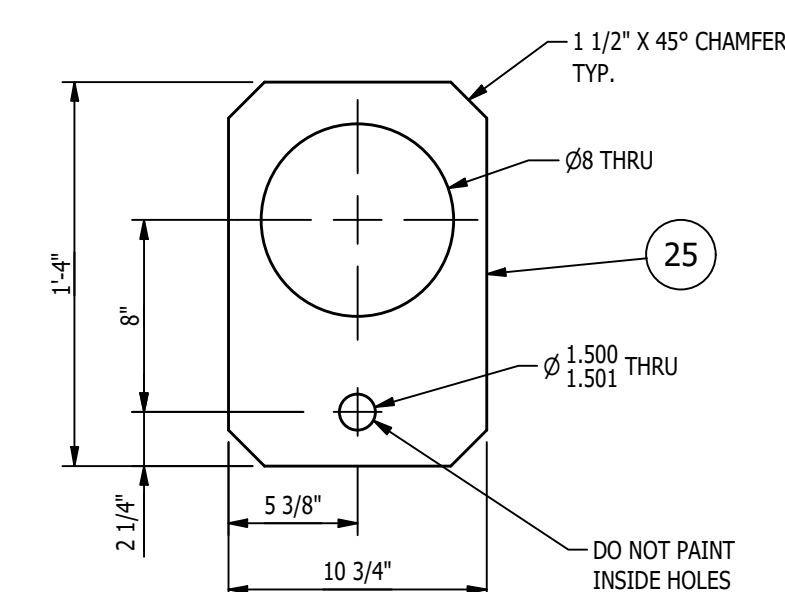


DETAIL OF ITEM '3'
SCALE 1 1/2"=1'-0"

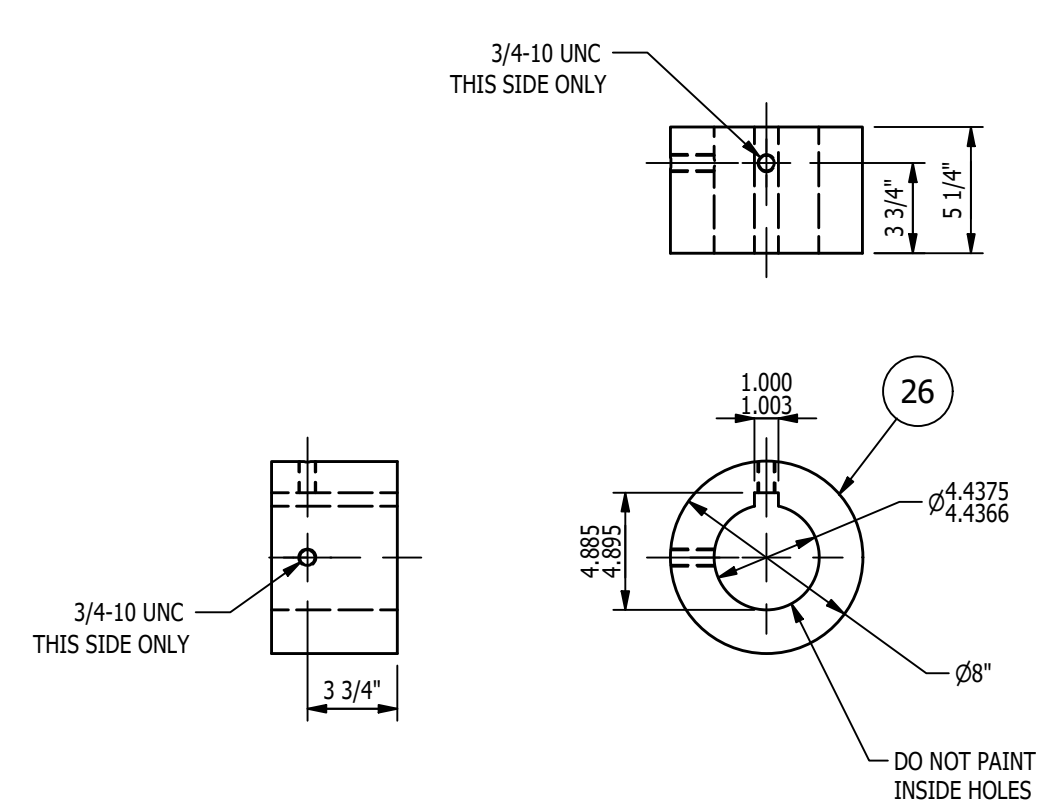


MK-D444A ~ LIFT SHAFT ASSEMBLY
SCALE 1"=1'-0"

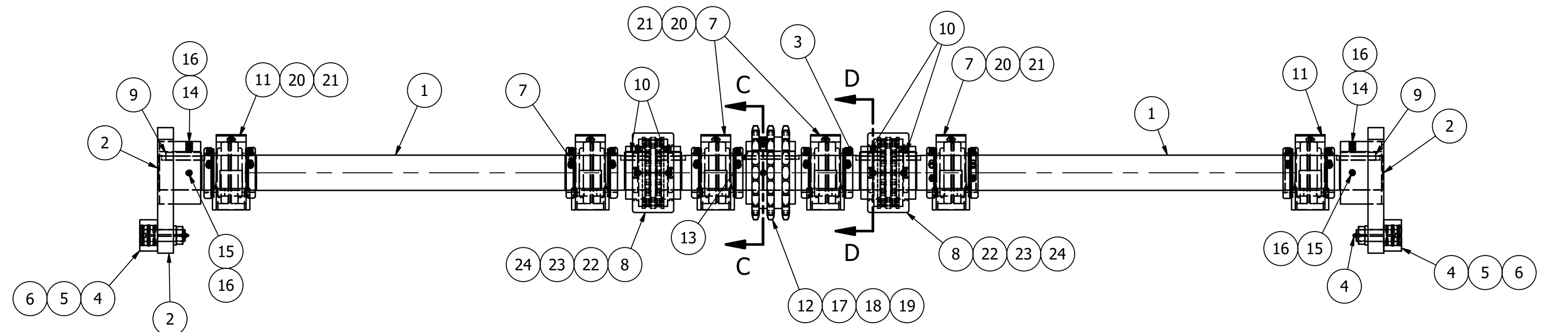
NOTE:
SPOT DRILL LOCATIONS WHERE SET SCREWS ARE LOCATED



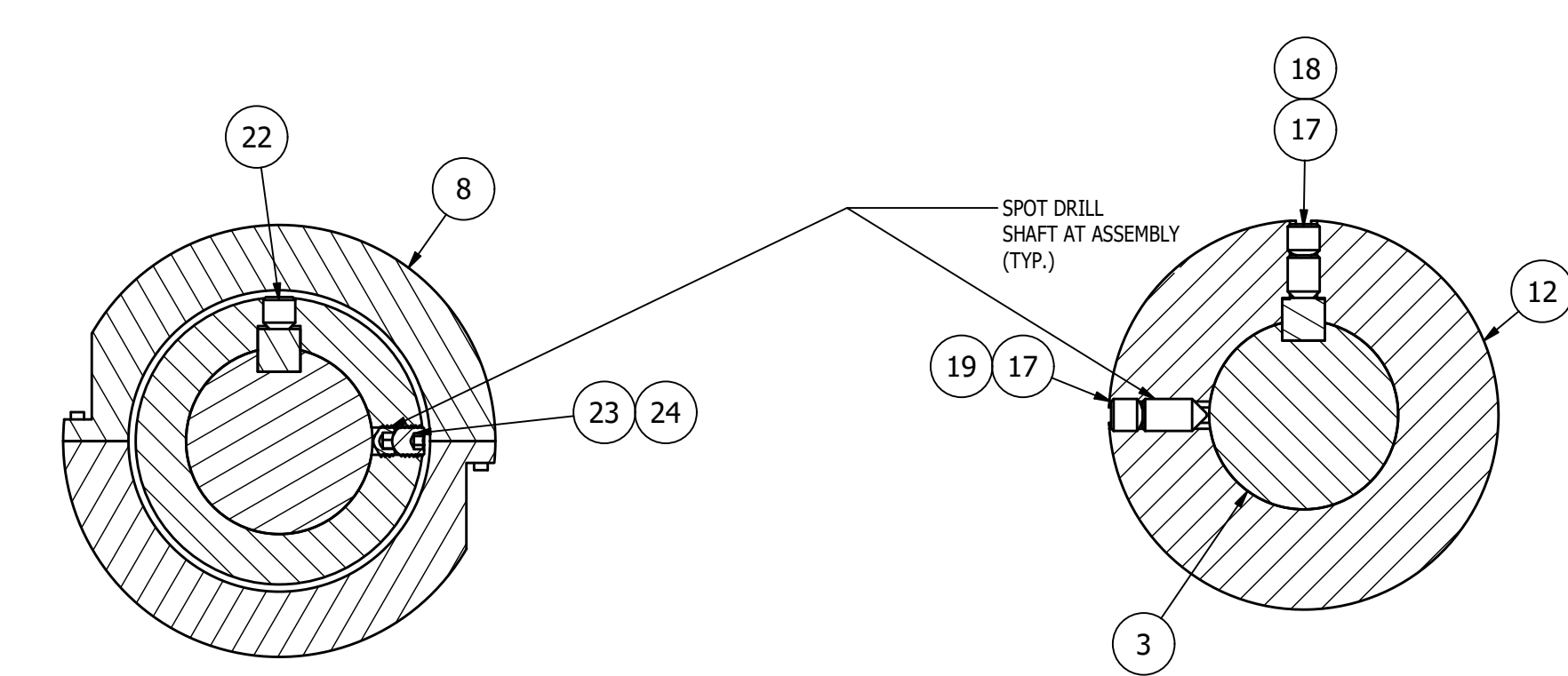
DETAIL OF ITEM '25'
SCALE 1 1/2"=1'-0"



DETAIL OF ITEM '26'
(MACHINE AFTER WELDING TO ITEM '25')
SCALE 1 1/2"=1'-0"



MK-D444B ~ CRANK ARM
SCALE 1 1/2"=1'-0"



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

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D444A			
1	2	BAR Ø4 1/2 (1045 CRS)	5'-2 13/16"		
2	2	MK-D444B ~ CRANK ARM			
3	1	BAR Ø4 7/16 (1045 CRS)	2'-5 1/4"		
4	2	PCI PLAIN XR STUD ROLLER, 4" ROLLER OD, 2.25" ROLLER WIDTH, 1 1/2-12 UNF THREAD, PCI PART NO. PXR-4.00-R		25-8	
5	2	1 1/2-12UNF HEX JAM NUT			
6	2	1 1/2 SPRING LOCK WASHER			
7	4	DODGE S-2000 PILLOW BLOCK, 4-BOLT BASE, NON-EXPANSION, 4 7/16 BORE		25-4	
8	2	DODGE 10020 CHAIN COUPLING; BORE BOTH HALVES 4.3764/4.3750 WITH KEYWAY FOR 1" KEY (CLASS 1 FIT); W/ 3/4-10 HOLES FOR SET SCREWS, (1) OVER KEY, (1) @ 90 DEG, KEYWAYS IN-LINE WITH SPROCKET TOOTH; W/ 099024 CHAIN COVER		25-7	
9	2	1 x 1 x 4 1/2" LG. SQ. KEYSTOCK		26-2	
10	4	1 x 1 x 3 1/4" LG. SQ. KEYSTOCK	3 1/4"	26-4	
11	2	DODGE S-2000 PILLOW BLOCK, 4-BOLT BASE, EXPANSION, 4 7/16 BORE		25-5	
12	1	#140-3 TRIPLE STEEL SPROCKET: 1 3/4" PITCH, 20 TOOTH HARDENED, HUB PROTRUDING 0.754 ON BOTH SIDES, 6.250" LENGTH THRU BORE, 4 7/16 H7 BORE, 1" STD KEYWAY, (2) 3/4-10 HOLES FOR SET SCREWS, (1) OVER KEY, (1) 90 DEG, KEYWAY TO BE IN-LINE WITH SPROCKET TOOTH.		25-2	
13	1	1 x 1 x 6 1/4 LG. SQ. KEYSTOCK		26-5	
14	2	3/4-10 x 3/4 LG. HEX SOCKET CUP POINT SET SCREW			
15	2	3/4-10 x 3/4 LG. HEX SOCKET CONE POINT SET SCREW			
16	4	3/4-10 x 3/4 LG. HEX SOCKET OVAL POINT SET SCREW			
17	2	3/4-10UNC x 3/4 LG. HEX SOCKET OVAL POINT SET SCREW			
18	1	3/4-10UNC x 1" LG. HEX SOCKET CUP POINT SET SCREW			
19	1	3/4-10UNC x 1 1/2" LG. HEX SOCKET CONE POINT SET SCREW			
20	24	5/8-11UNC x 1/2 LG. HEX SOCKET OVAL POINT SET SCREW			
21	24	5/8-11UNC x 1/2 LG. HEX SOCKET CONE POINT SET SCREW			
22	4	3/4-10UNC x 3/4 LG. HEX SOCKET CUP POINT SET SCREW			
23	4	3/4-10UNC x 1/2 LG. HEX SOCKET CONE POINT SET SCREW			
24	4	3/4-10UNC x 3/4 LG. HEX SOCKET OVAL POINT SET SCREW			
		MK-D444B			
25	1	PL 2 x 10 3/4"	1'-4"		
26	1	BAR Ø8 (1045 CRS)	5 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 A53 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 MK-D444B ONE SHOP COAT OF LIGHT GREY RAL 7035 DO NOT PAINT MACHINED ITEMS, FASTENERS OF PURCHASED ITEMS.

DO NOT PAINT ITEMS '1' & '3'

REV	BY	DATE	DESCRIPTION	APP
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY	
DESCRIPTION	APP

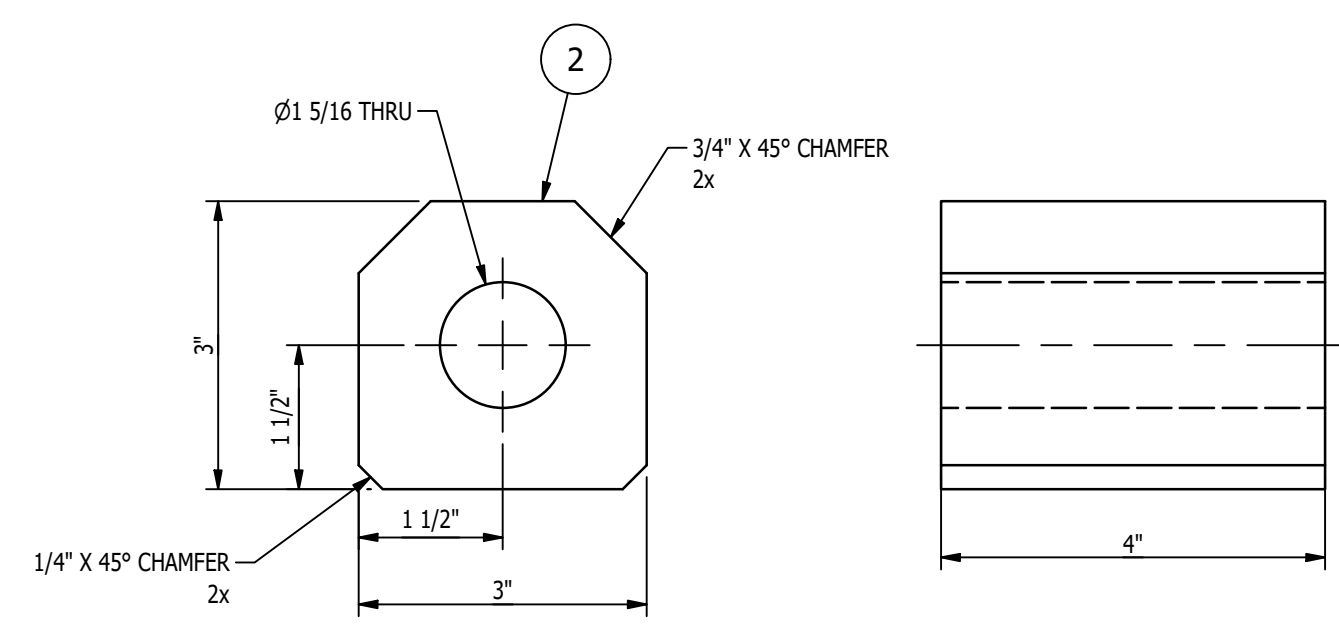
MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millic.com	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.
TITLE: P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY: RJB
CLIENT: VOLVO	CHECKED BY: CW
DRAWING No. 1875D444	DWG DATE: 10/7/22
REV: A	JOB No: 22096

MAGNUM CONSULTING
 41100 QuakerRoad Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 772-8822
 Fax: (248) 772-8821
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D444

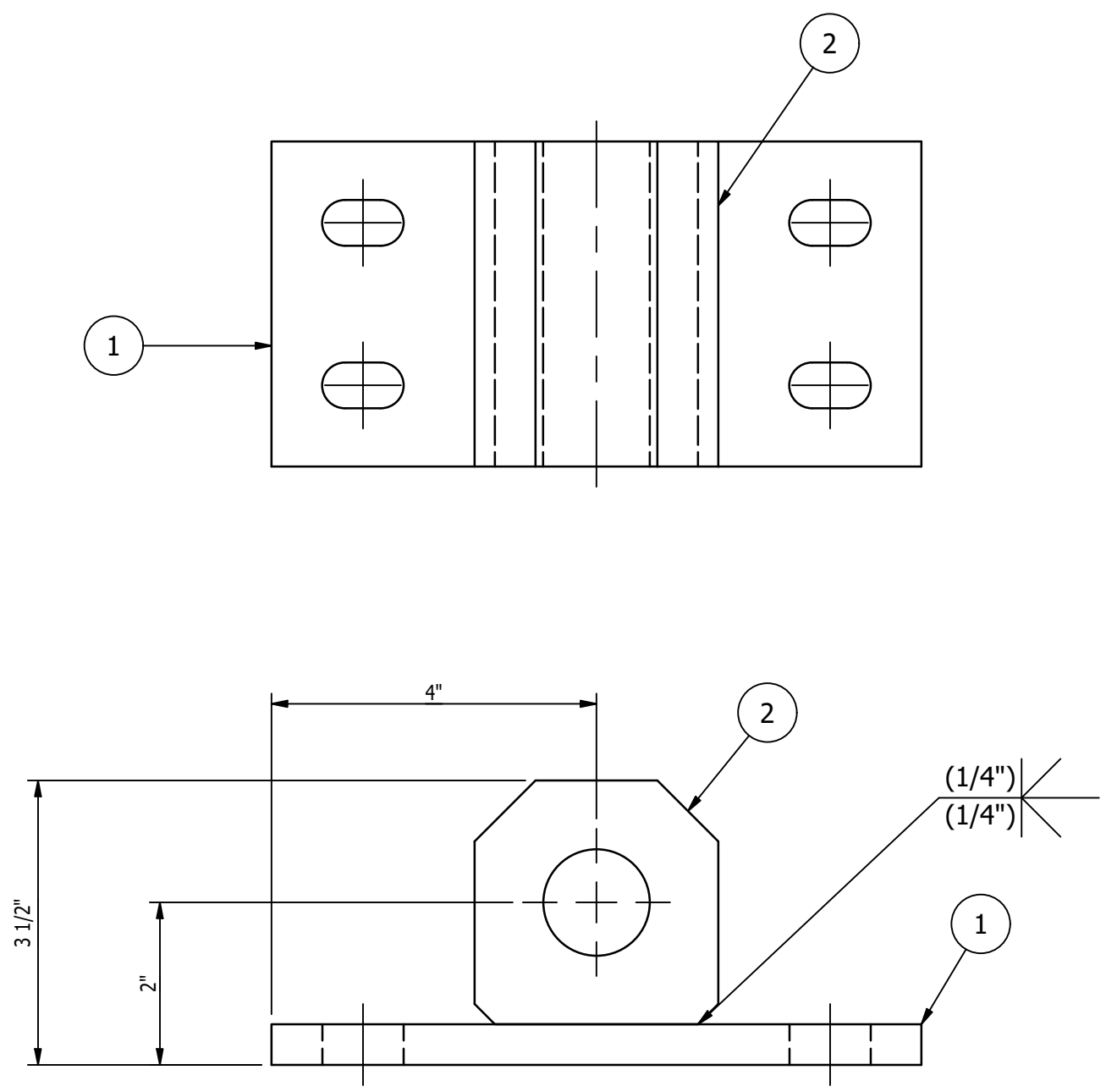
UNLESS OTHERWISE NOTED:
 X = ±.060
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 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
 BREAK ALL SHARP EDGES
 DEBURR ALL HOLES
 DO NOT SCALE DRAWING

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

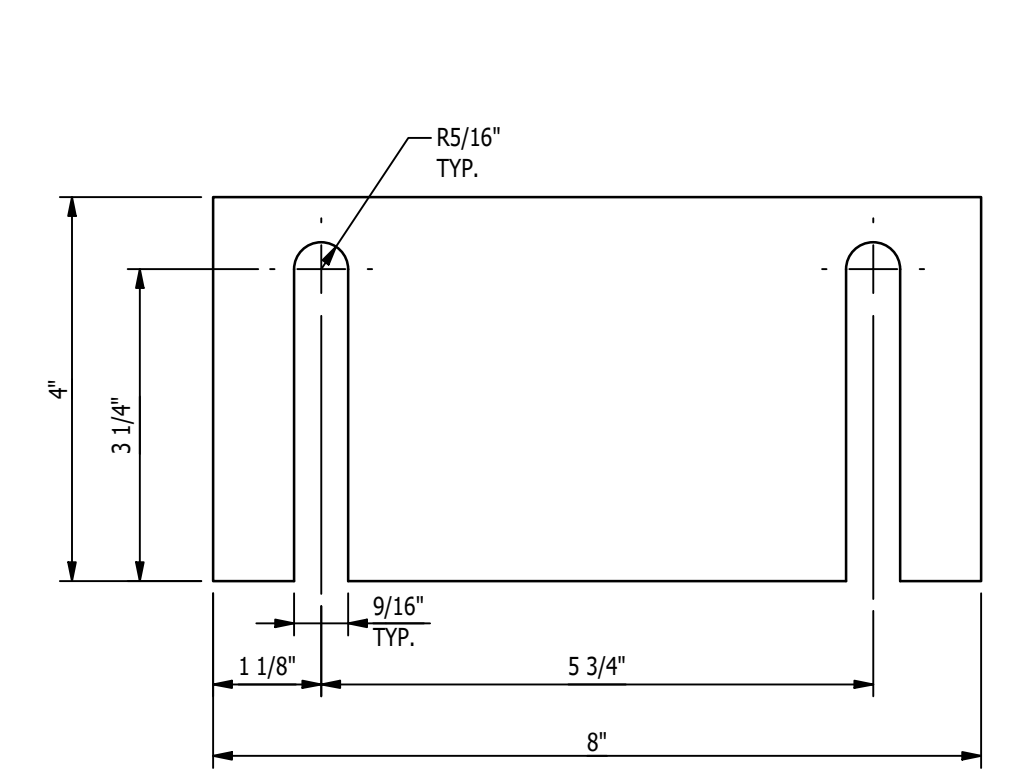
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D445A			
1	1	BAR 1/2 x 4	8"		
2	1	SQ. BAR 3	4"		
		MK-D445B			
3	1	SHT 10 GA x 4	8"		
4	2	SHT 16 GA x 4	8"		
5	2	SHT 20 GA x 4	8"		



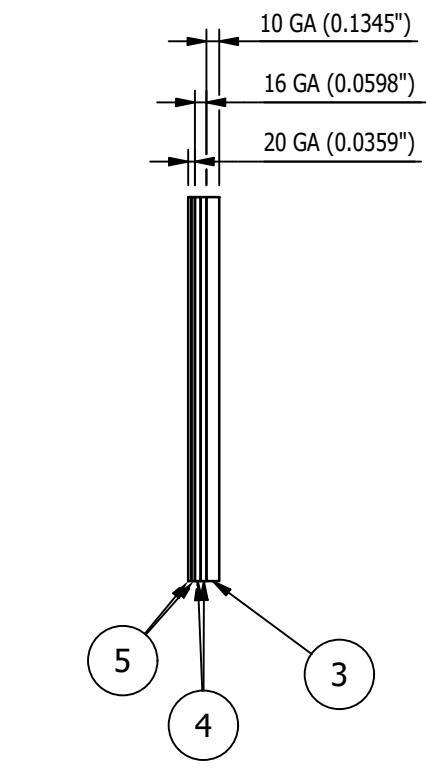
DETAIL OF ITEM '2'
SCALE 6"=1'-0"



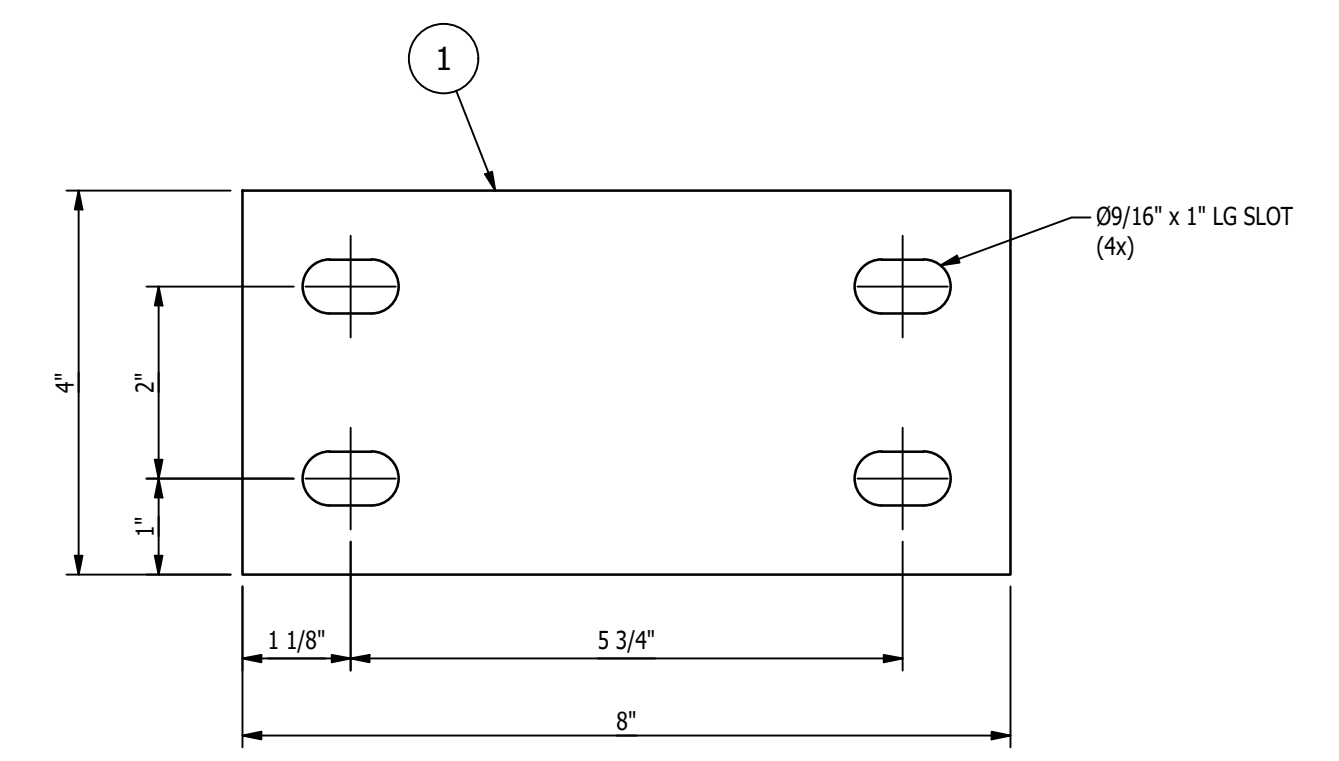
MK-D445A ~ LOCKING PIN BRACKET
SCALE 6"=1'-0"



MK-D445B ~ SHIM PACK
SCALE 6"=1'-0"



NO PAINT
B



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

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

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

DO NOT PAINT ITEMS '3', '4', & '5'

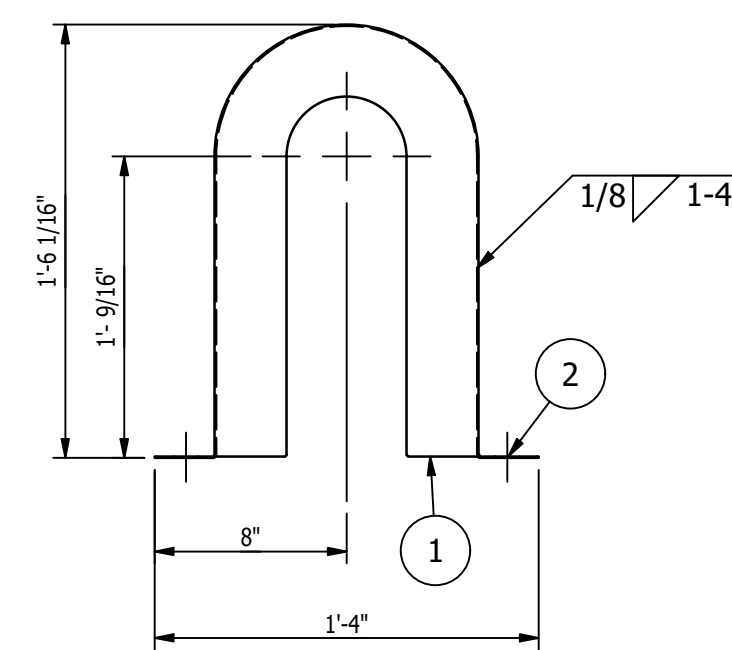
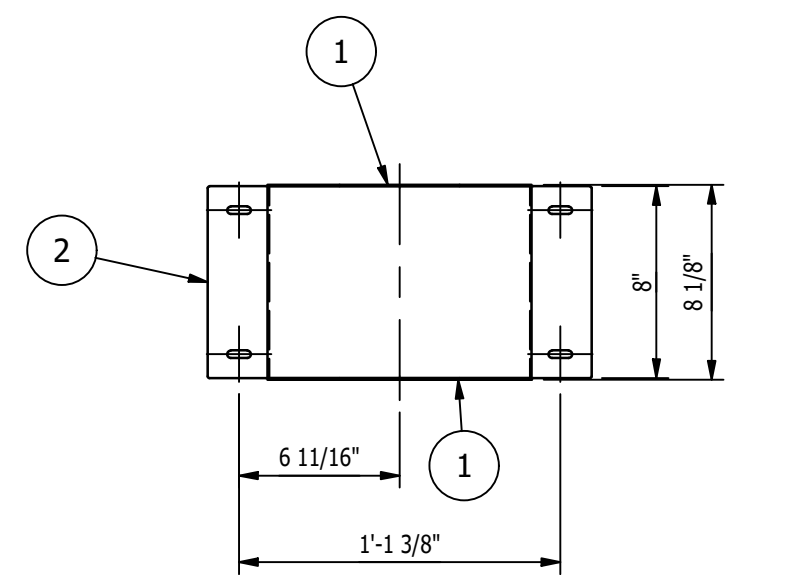
REV	BY	DATE	DESCRIPTION	APP
B	MC	11/1/2022	ADDED "NO PAINT" NOTE	
A	MC	10/21/22	FOR FABRICATION	

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.
TITLE:	P6700 CONVEYORS CAMPUS BUILDING			DRAWN BY: RJB
CLIENT:	VOLVO			CHECKED BY: CW
DRAWING No.	1875D445	REV: B	JOB No:	22096

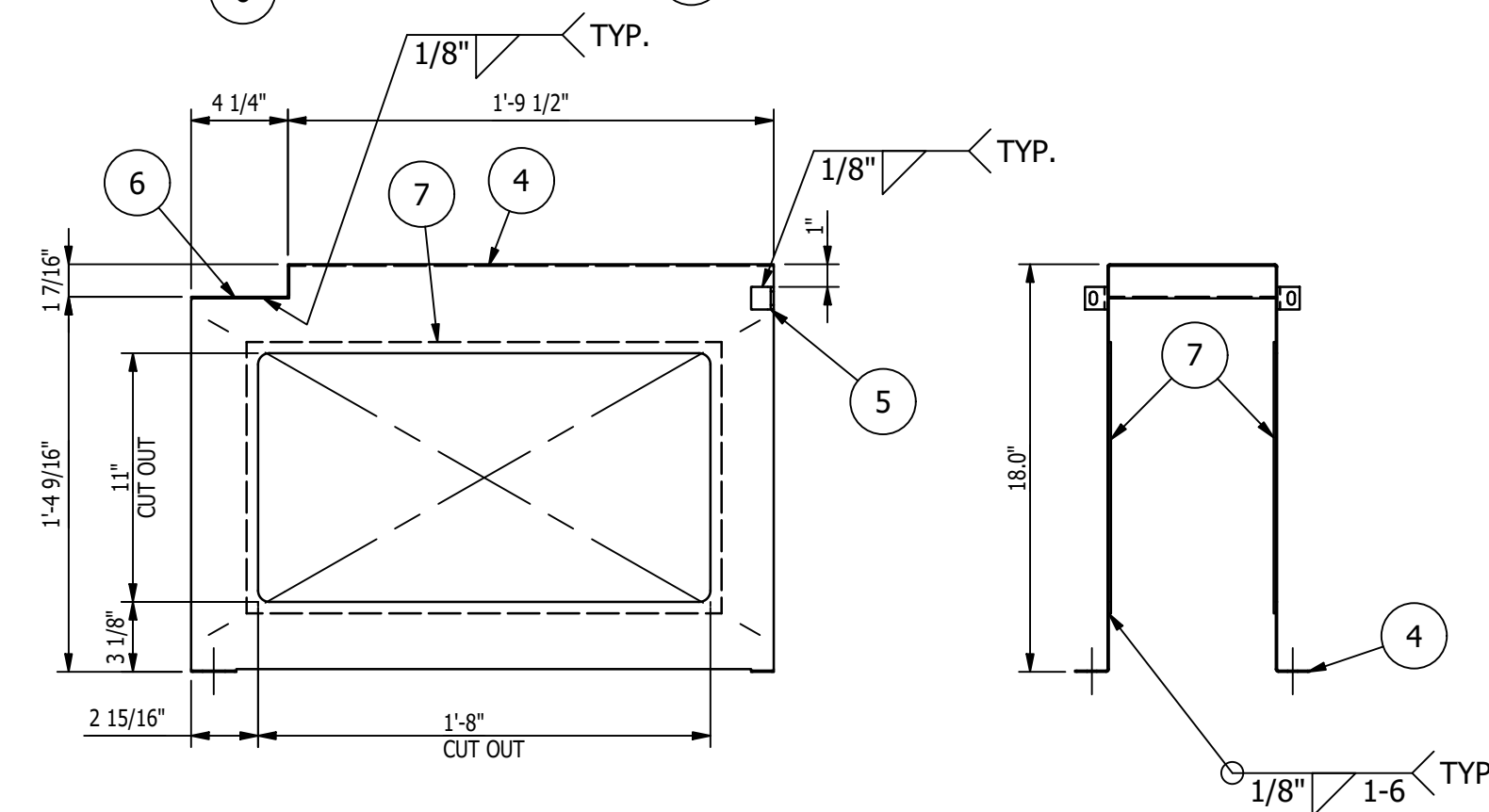
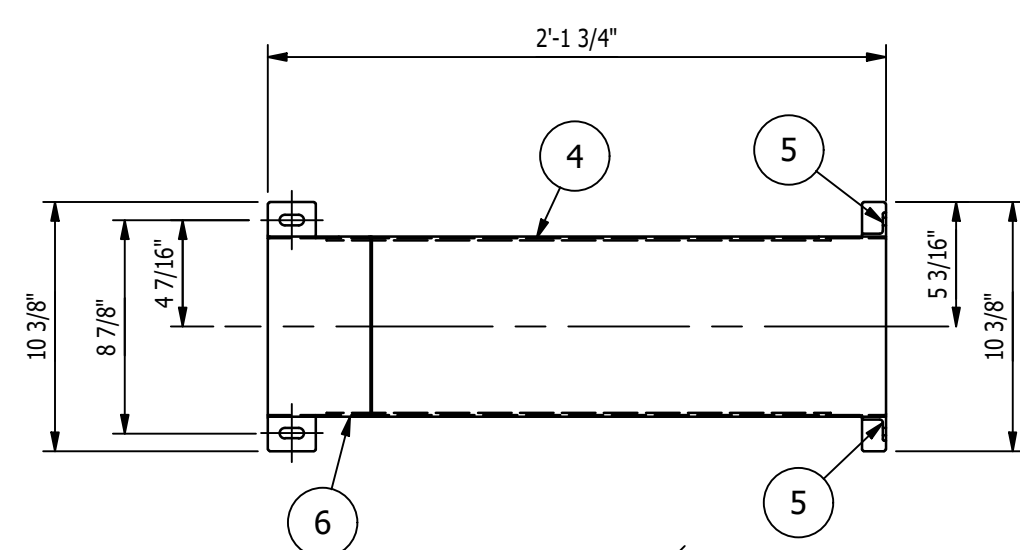
MAGNUM CONSULTING
 41100 Dardickwood Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 772-8822
 Fax: (248) 772-8851
 Web: www.mmagnum.com
 MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D445 - REV B

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

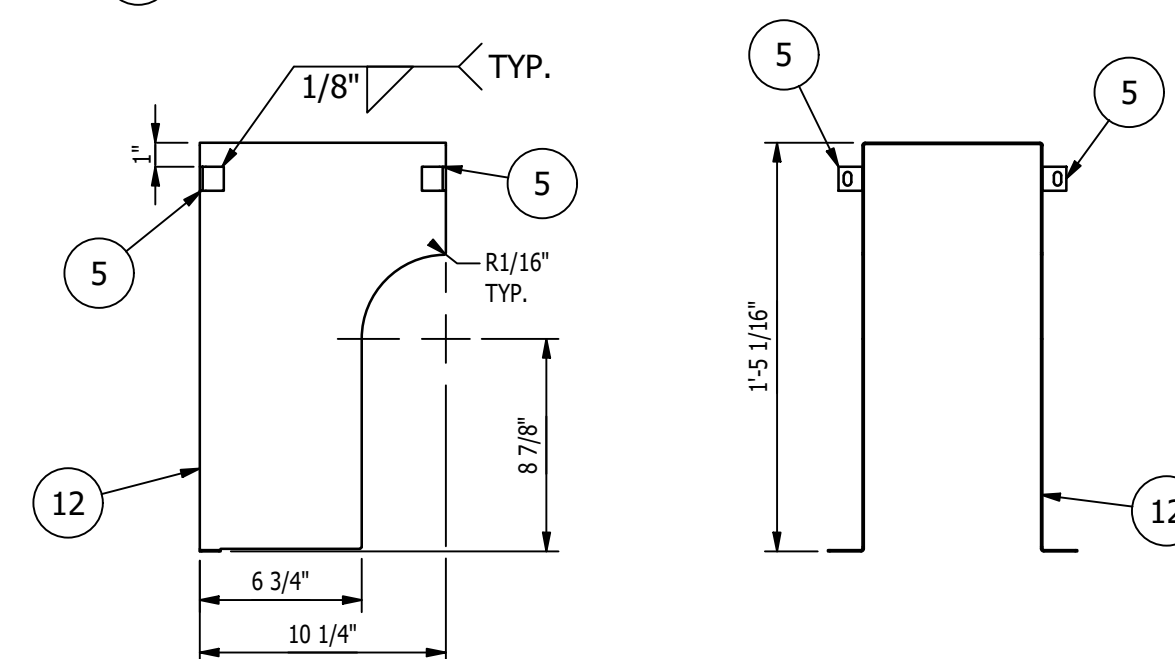
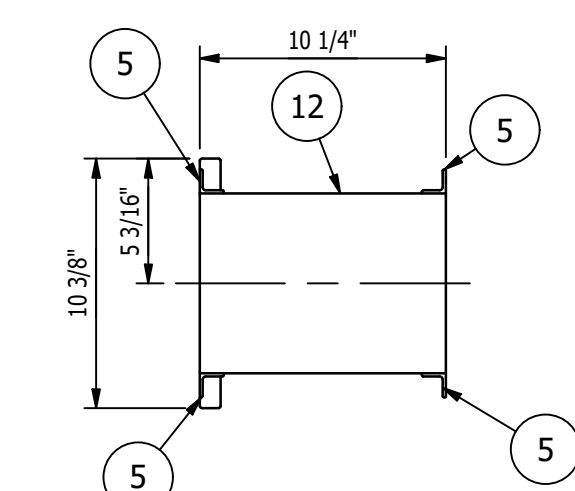
GENERAL NOTES:
 MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.
 HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO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



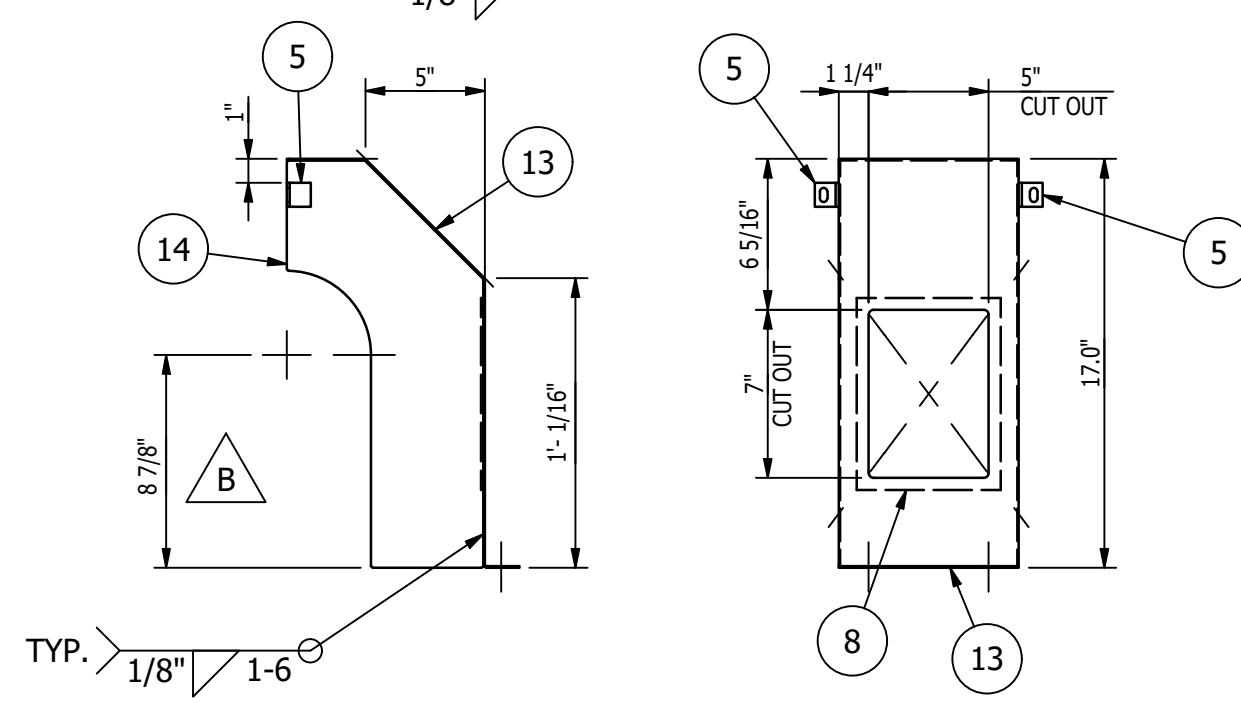
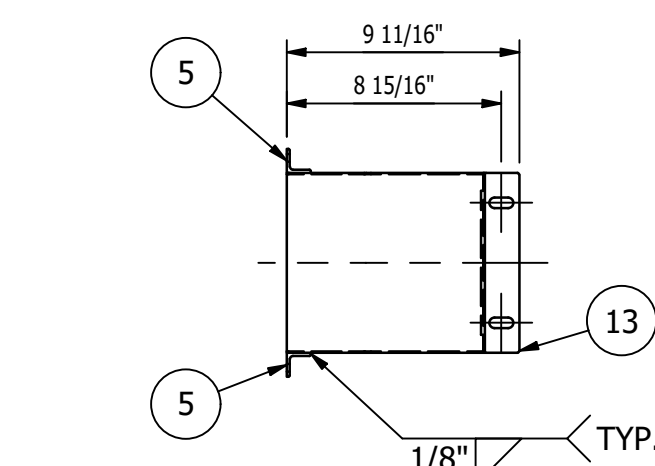
MK-D446A ~ COUPLING GUARD
SCALE 1 1/2"=1'-0"



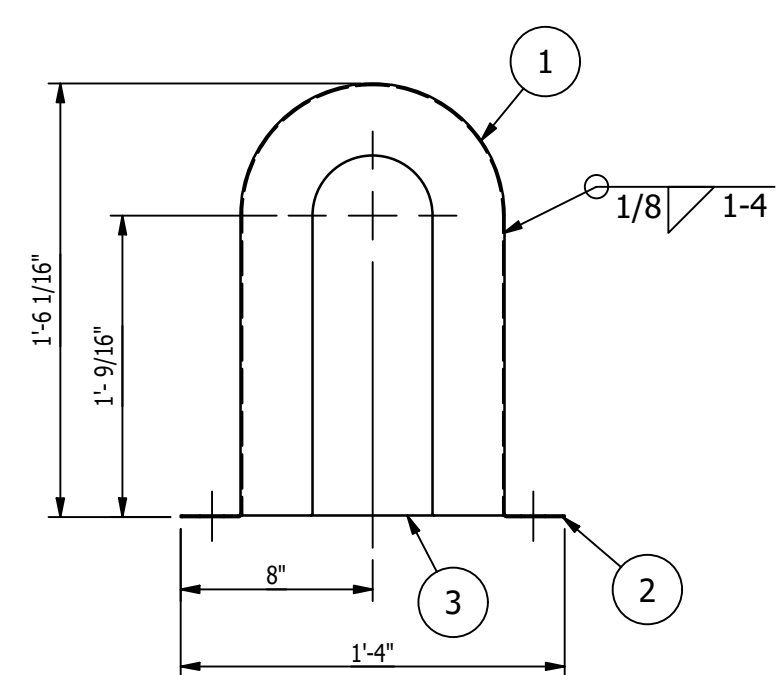
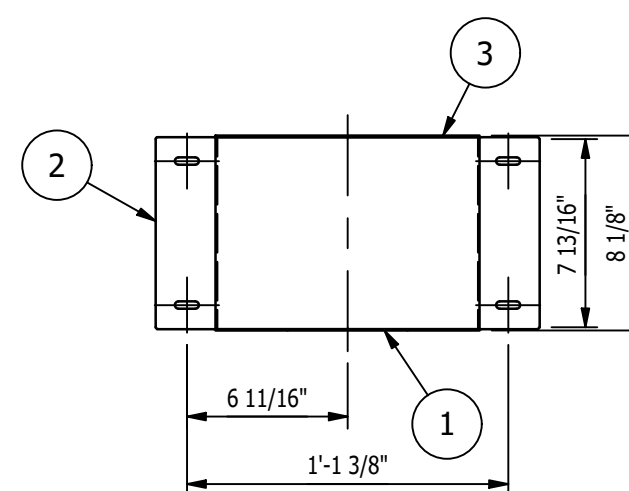
MK-D446C ~ CHAIN GUARD
SCALE 1 1/2"=1'-0"



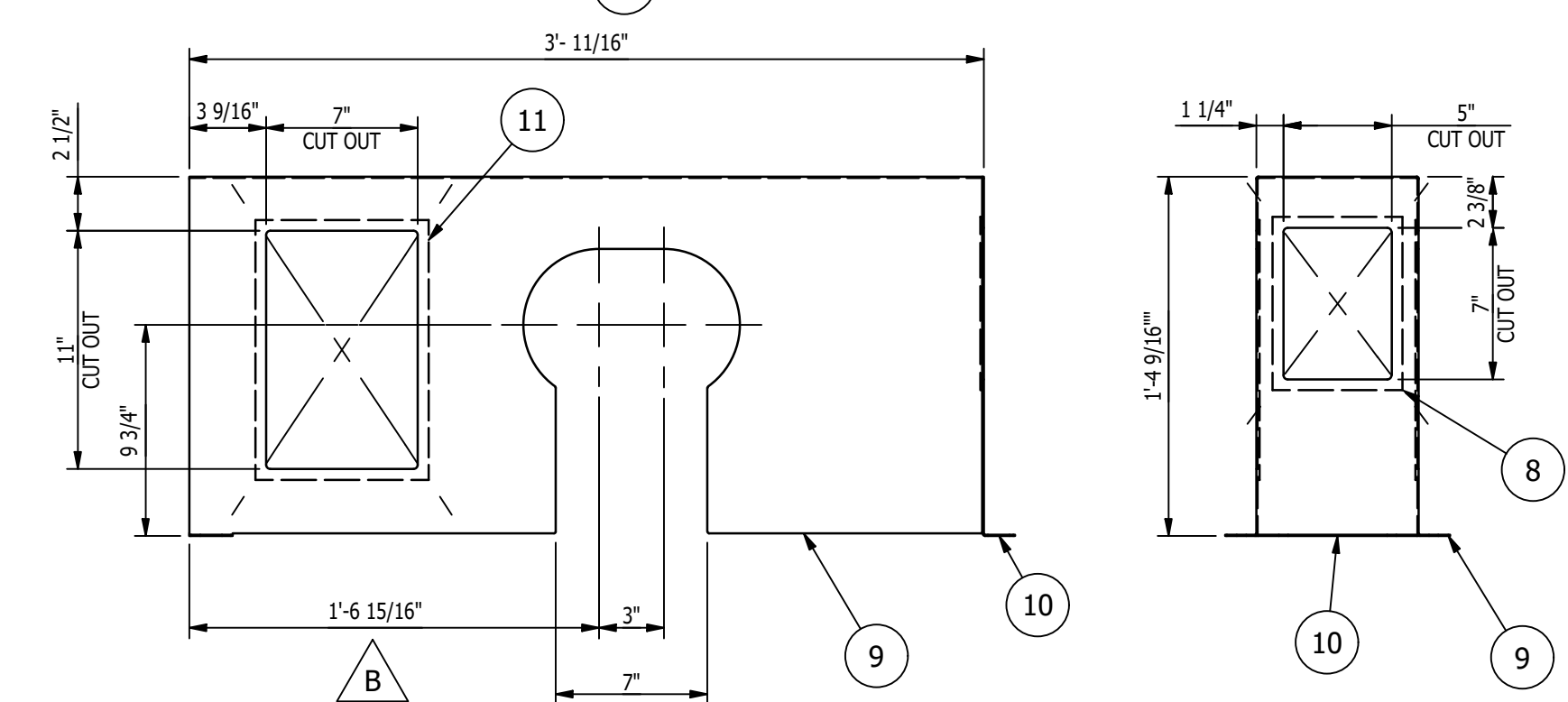
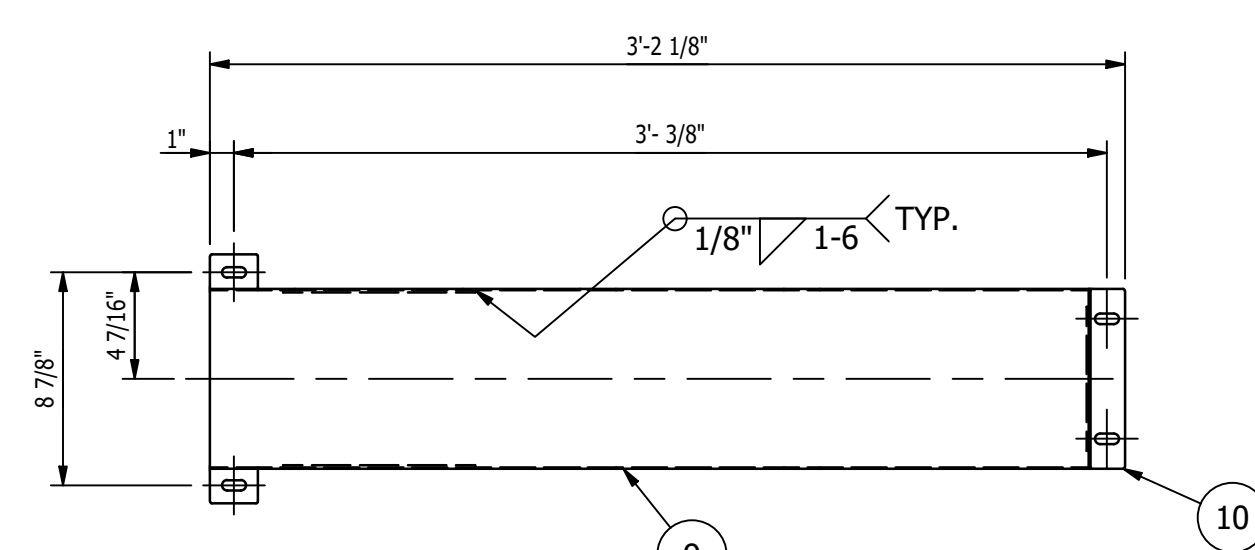
MK-D446E ~ CHAIN GUARD
SCALE 1 1/2"=1'-0"



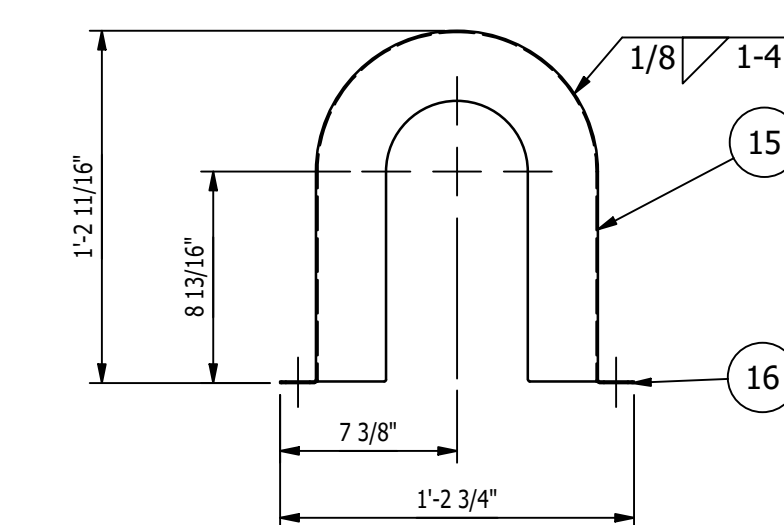
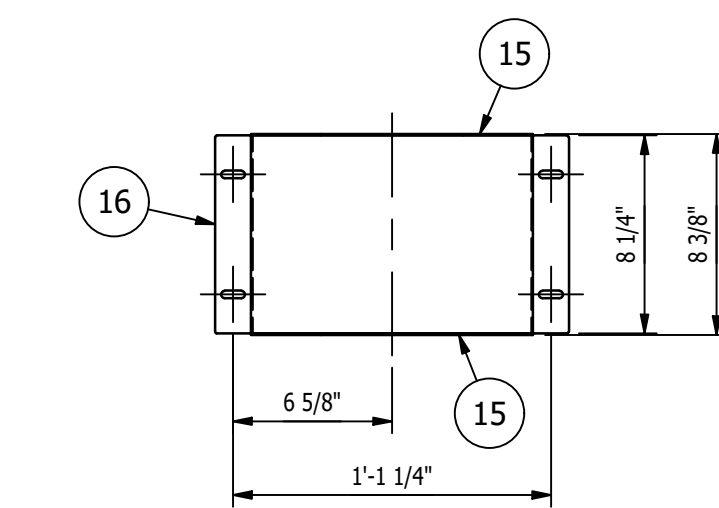
MK-D446F ~ CHAIN GUARD
SCALE 1 1/2"=1'-0"



MK-D446B ~ SHAFT GUARD
SCALE 1 1/2"=1'-0"



MK-D446D ~ CHAIN GUARD
SCALE 1 1/2"=1'-0"



MK-D446G ~ COUPLING GUARD
SCALE 1 1/2"=1'-0"

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
MK-D446A					
1	2	SHT 16 GA x 11	1'-6"		
2	1	SHT 16 GA x 8	3'-11 1/4"		
MK-D446B					
1	1	SHT 16 GA x 11	1'-6"		
2	1	SHT 16 GA x 8	3'-11 1/4"		
3	1	SHT 16 GA x 11	1'-6"		
MK-D446C					
4	1	SHT 16 GA x 2'-1 3/4	3'-10 1/8"		
5	2	L 1 x 1 x 1/8	1"		
6	1	SHT 16 GA x 5 11/16	7 1/2"		
7	2	EXP MTL, 1/2-#13 x 12	1'-9"		
MK-D446D					
8	1	EXP MTL, 1/2-#13 x 6	8"		
9	1	SHT 16 GA x 3'-0 5/8	3'-7 1/4"		
10	1	SHT 16 GA x 7 1/2	1'-6"		
11	2	EXP MTL, 1/2-#13 x 8	1'-0"		
MK-D446E					
5	4	L 1 x 1 x 1/8	1"		
12	1	SHT 16 GA x 10 1/4	3'-8 1/8"		
MK-D446F					
5	2	L 1 x 1 x 1/8	1"		
8	1	EXP MTL, 1/2-#13 x 6	8"		
13	1	SHT 16 GA x 7 1/2	1'-11 11/16"		
14	2	SHT 16 GA x 8 3/16	1'-5"		
MK-D446G					
15	2	SHT 16 GA x 11 3/4	1'-2 5/8"		
16	1	SHT 16 GA x 8 1/4	3'-2 15/16"		

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

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

MAGNUM CONSULTING
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Phone: (248) 772-8822 Fax: (248) 772-8851 Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D446 - REV B

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

GENERAL NOTES:
MATERIALS:
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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 REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

SHEET 1 OF 2

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/31/22	ADJUSTED LOCATION OF OPENING ON ITEM '9' & '14'; ADDED DETAIL VIEWS, ROLL DIMS ITEMS '2', '16'	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY

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

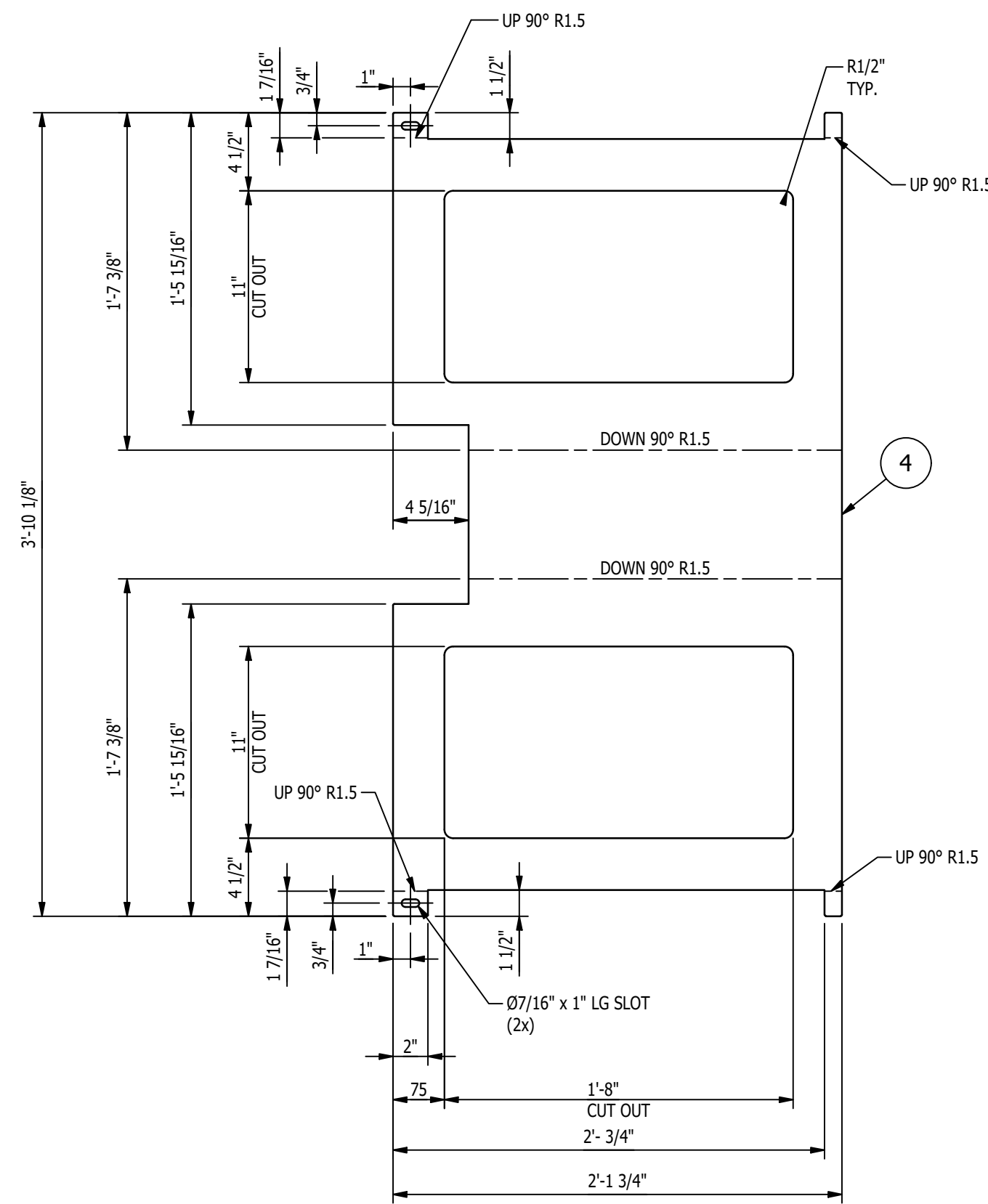
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CLIENT: VOLVO

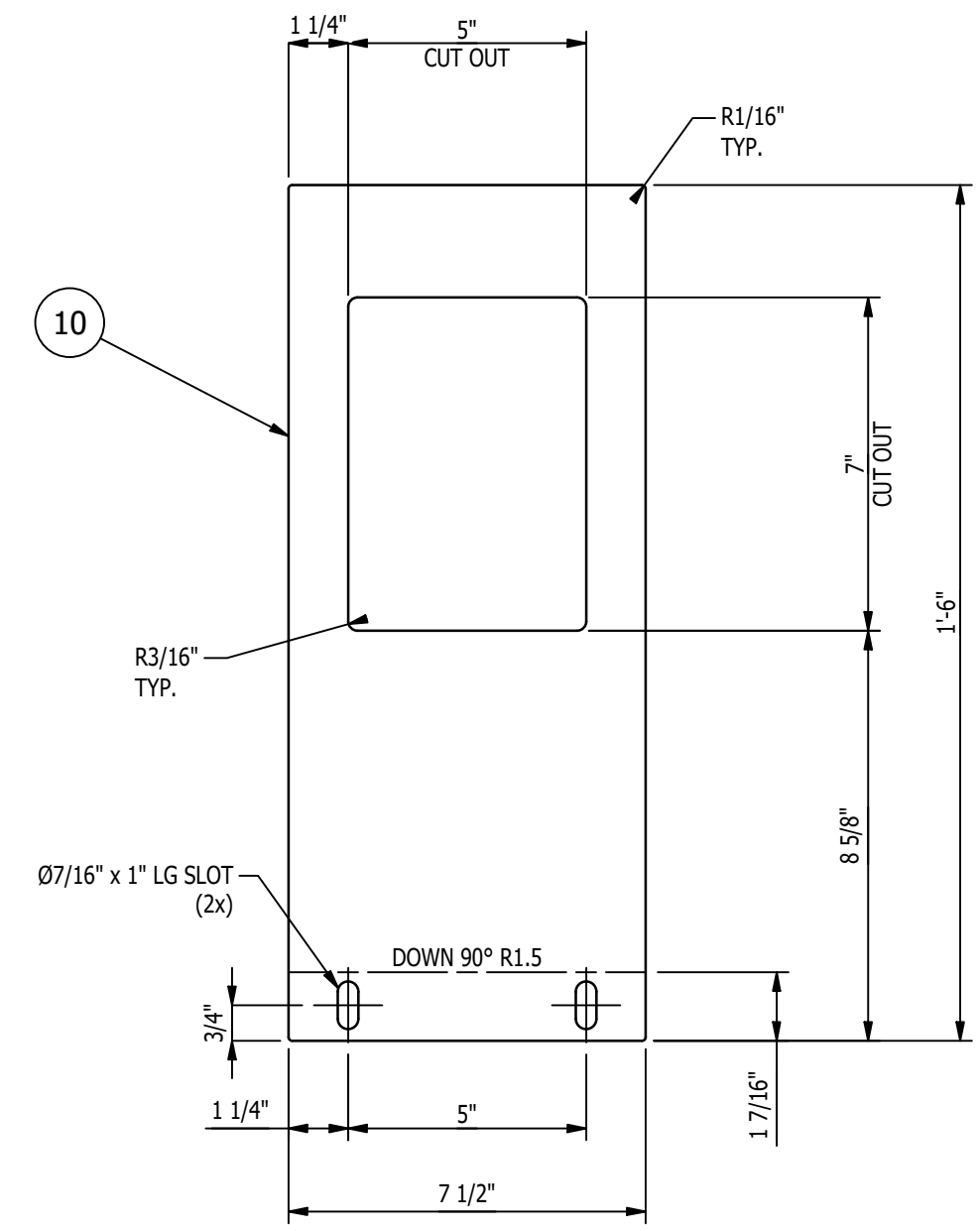
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REV: B

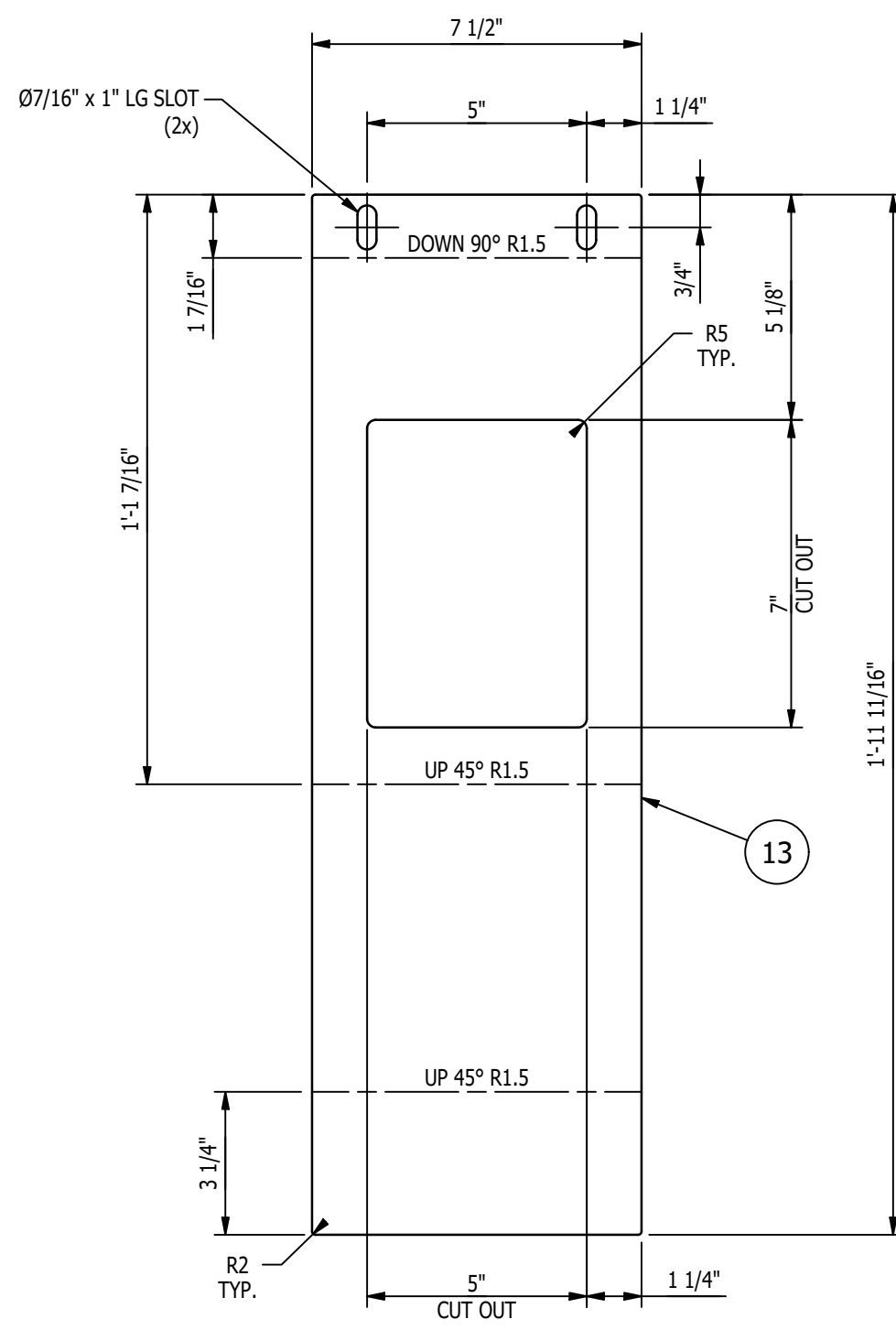
DRAWN BY: RJB
CHECKED BY: CW
DWG DATE: 10/3/22
JOB No: 22096



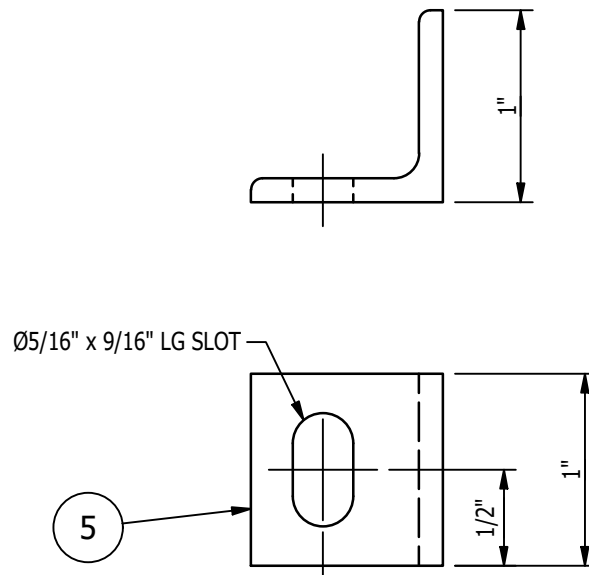
DETAIL OF ITEM '4'
SCALE 1 1/2"=1'-0"



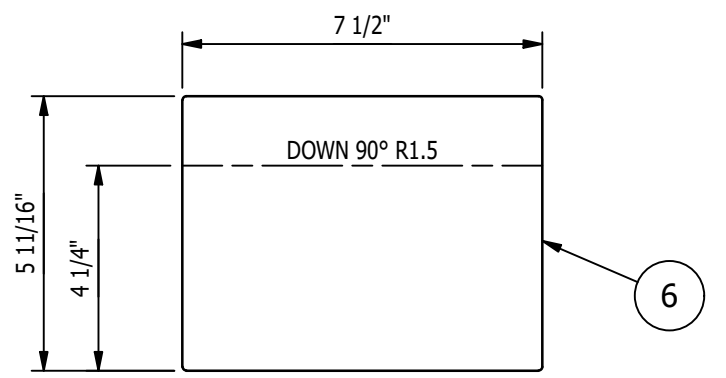
DETAIL OF ITEM '10'
SCALE 3"=1'-0"



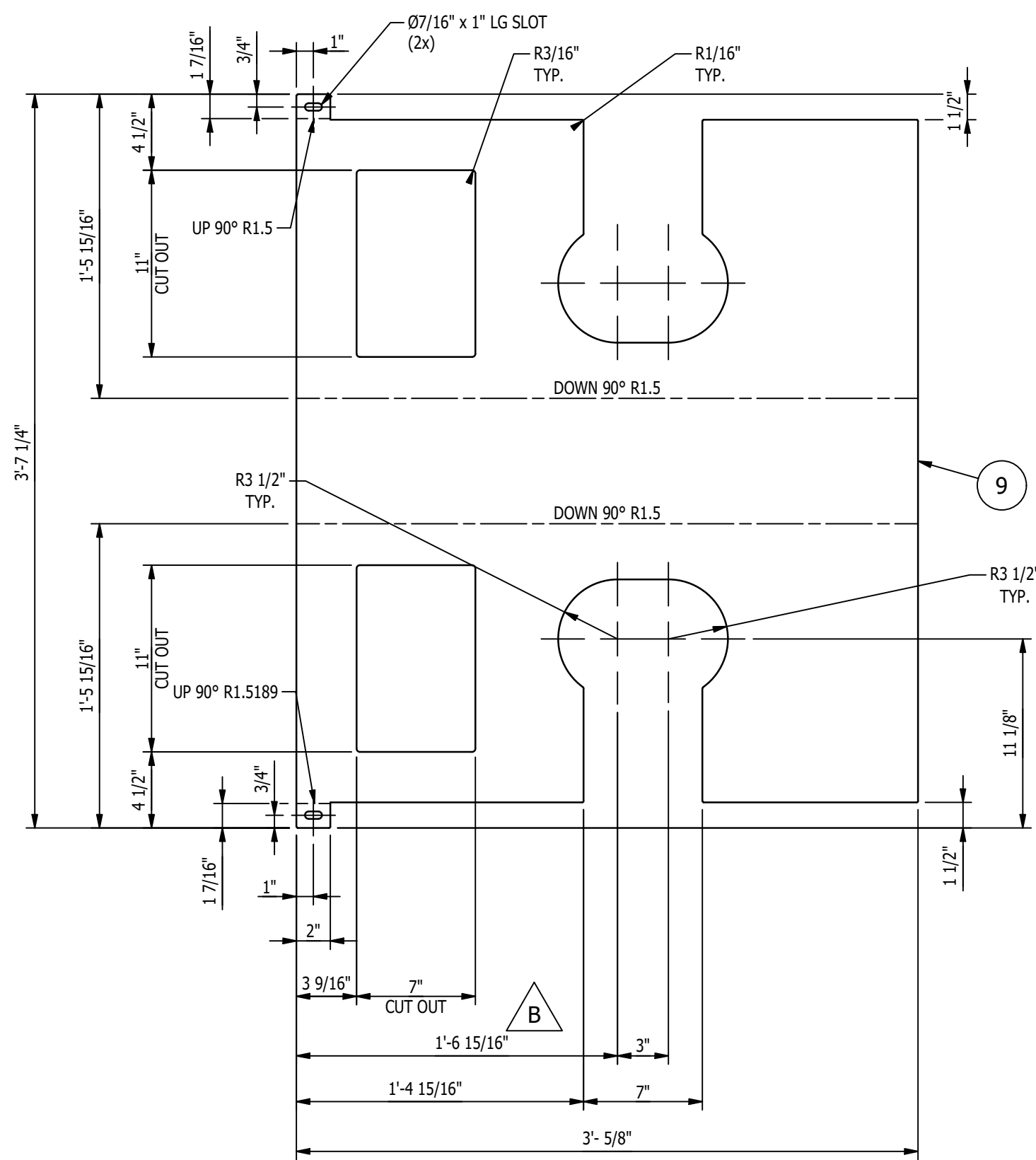
DETAIL OF ITEM '13'
SCALE 3"=1'-0"



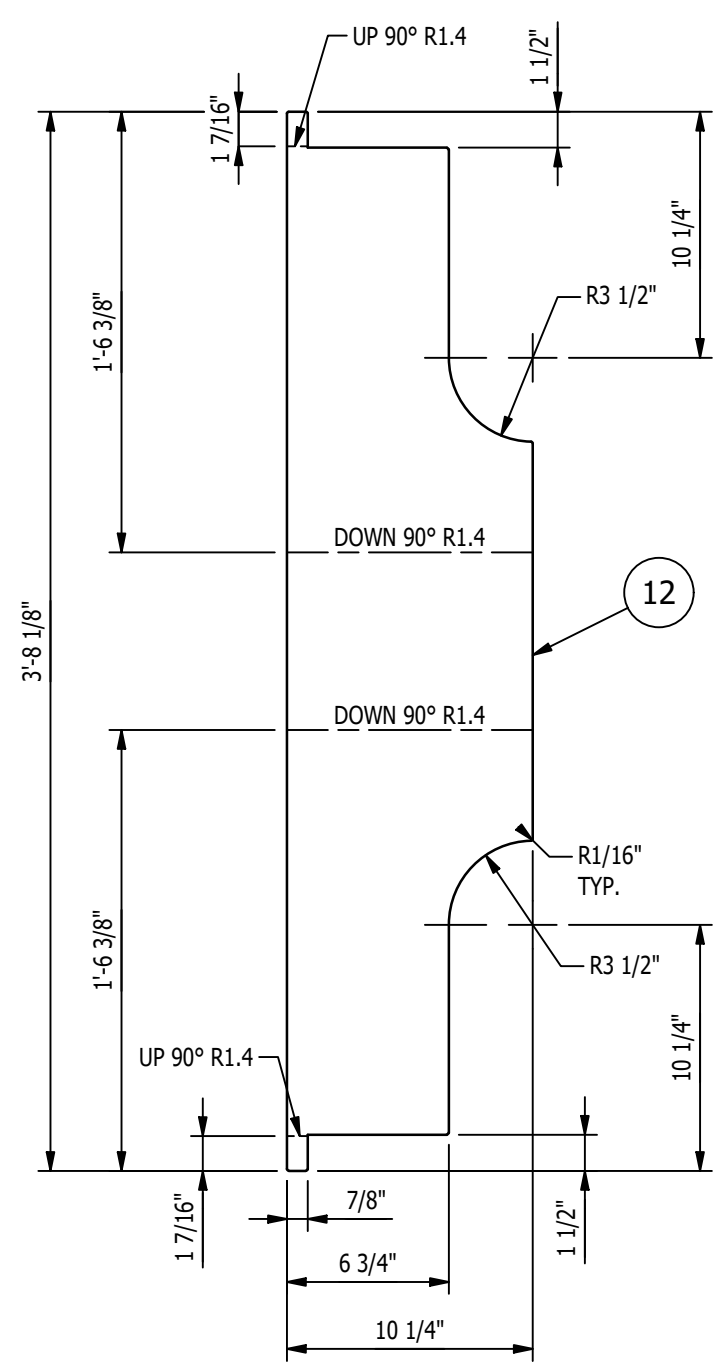
DETAIL OF ITEM '5'
SCALE 1'-0"=1'-0"



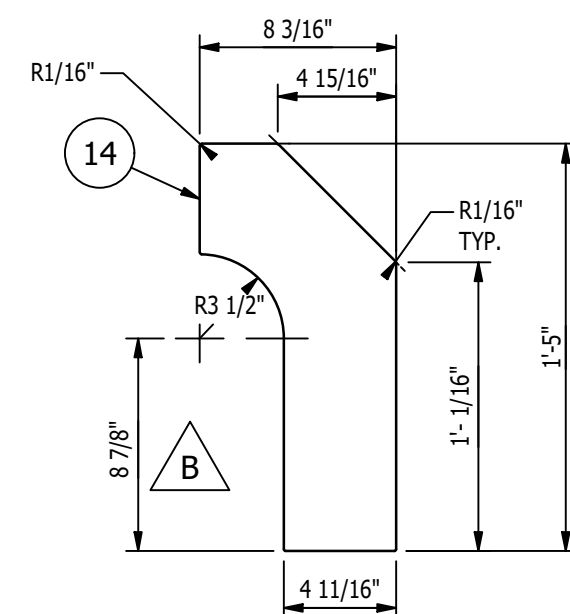
DETAIL OF ITEM '6'
SCALE 3"=1'-0"



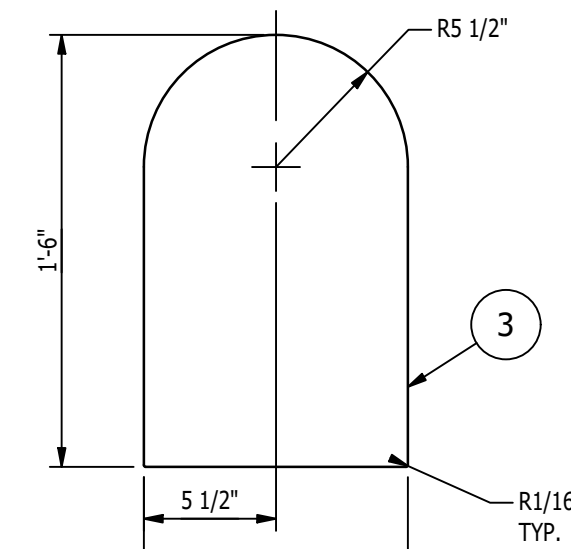
DETAIL OF ITEM '9'
SCALE 1 1/2"=1'-0"



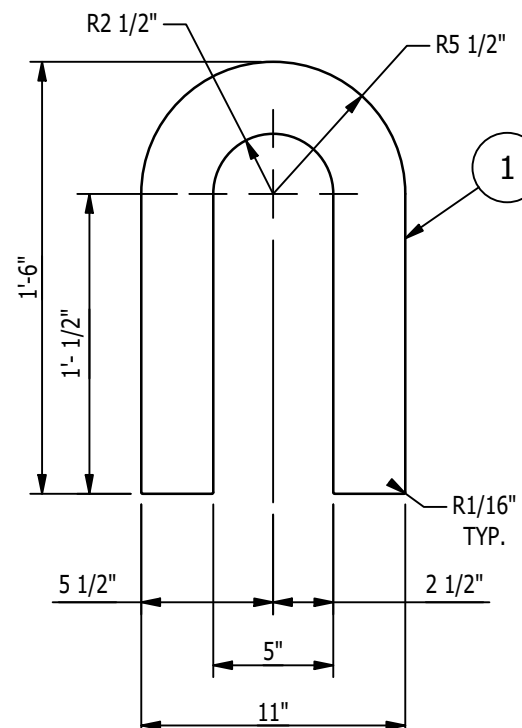
DETAIL OF ITEM '12'
SCALE 1 1/2"=1'-0"



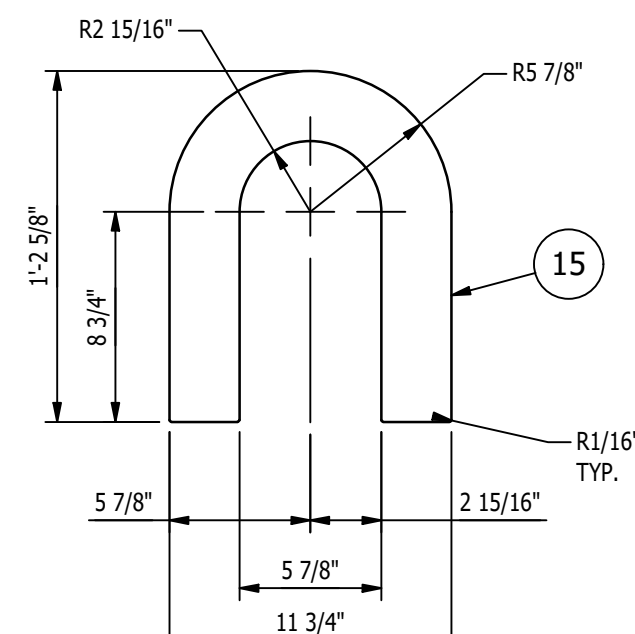
DETAIL OF ITEM '14'
SCALE 1 1/2"=1'-0"



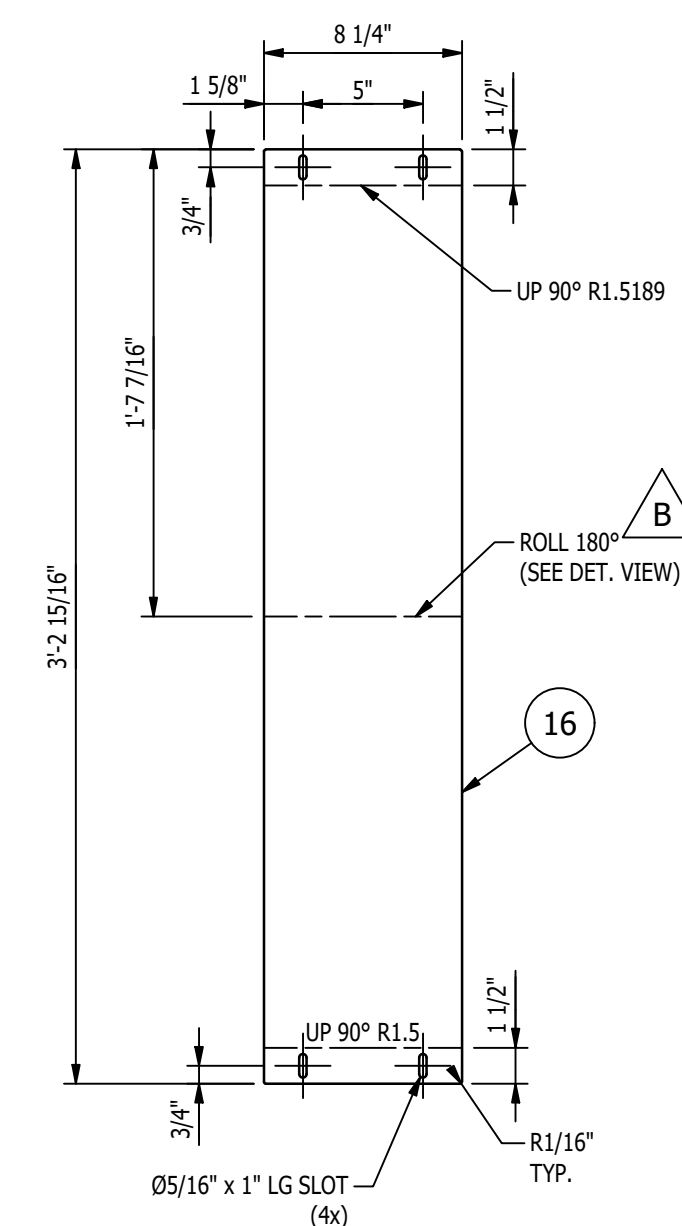
DETAIL OF ITEM '3'
SCALE 1 1/2"=1'-0"



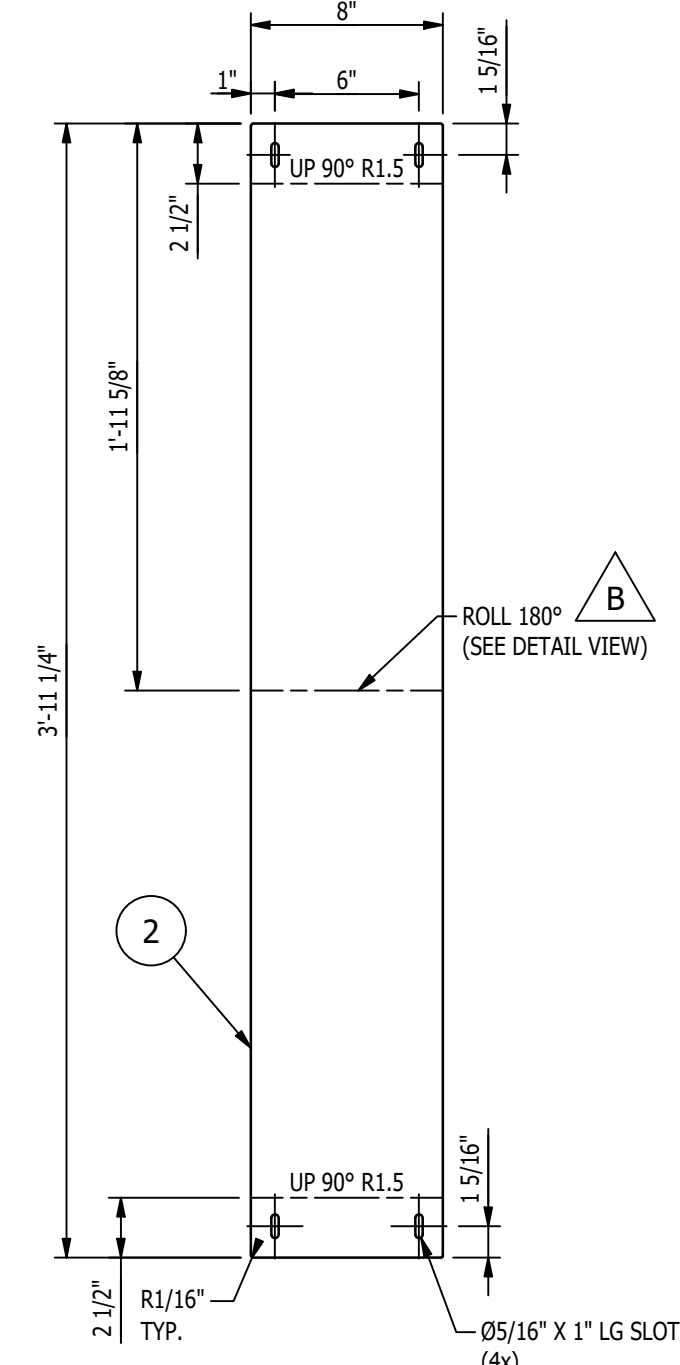
DETAIL OF ITEM '1'
SCALE 1 1/2"=1'-0"



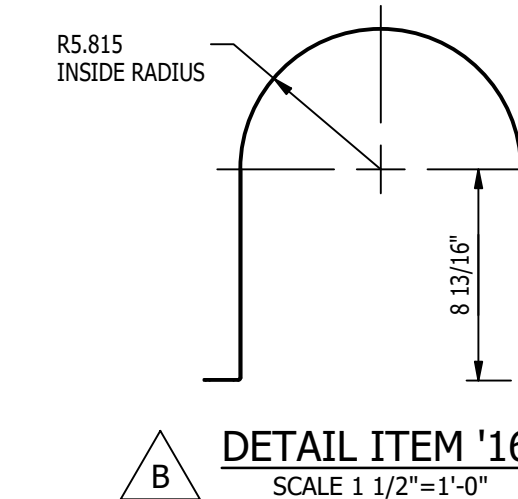
DETAIL OF ITEM '15'
SCALE 1 1/2"=1'-0"



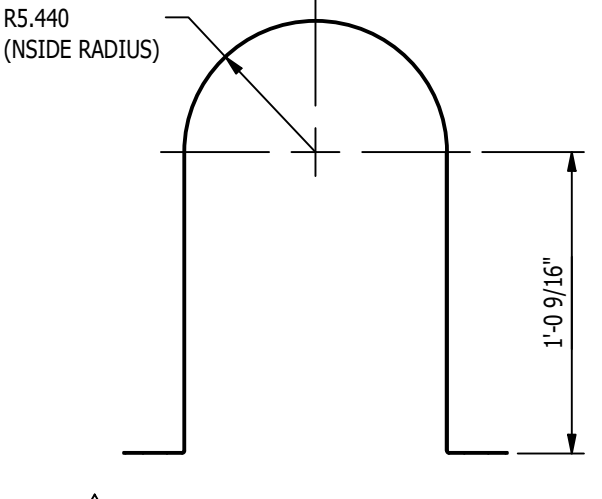
FLAT PATTERN '16'
SCALE 1 1/2"=1'-0"



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



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



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

SHEET 2 OF 2

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/31/22	ADJUSTED LOCATION OF OPENING ON ITEM '9' & '14'; ADDED DETAIL VIEWS, ROLL DIMS ITEMS '2', '16'	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.	
TITLE:	P6700 CONVEYORS	3070 W. THOMPSON RD.		DRAWN BY:	RJB
CLIENT:	VOLVO	FENTON, MI 48430		CHECKED BY:	CW
DRAWING No.	1875D446	PH: 810.373.0322 FAX: 810.373.0326		DWG DATE:	10/3/22
		www.milic.com		REV:	B
				JOB No:	22096

MAGNUM Consulting
41100 Gardenbrook Rd.
Suite 125
West, MI 48375
Phone: (248) 773-2882
Fax: (248) 773-8851
Web: www.mmagnum.com

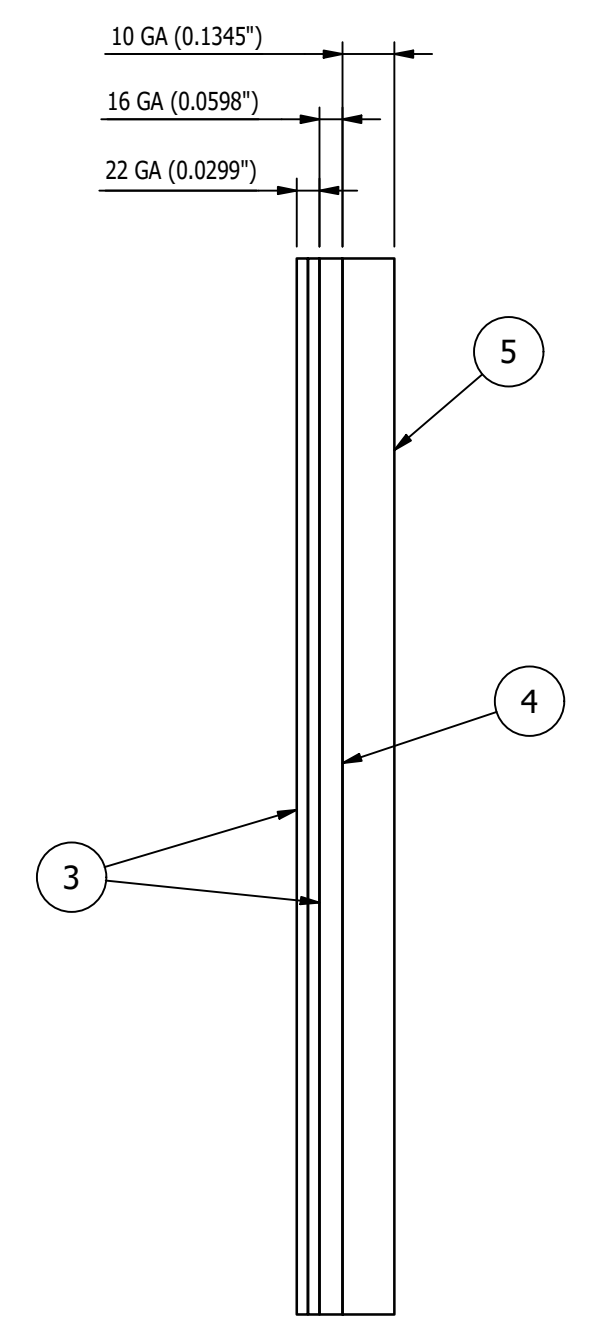
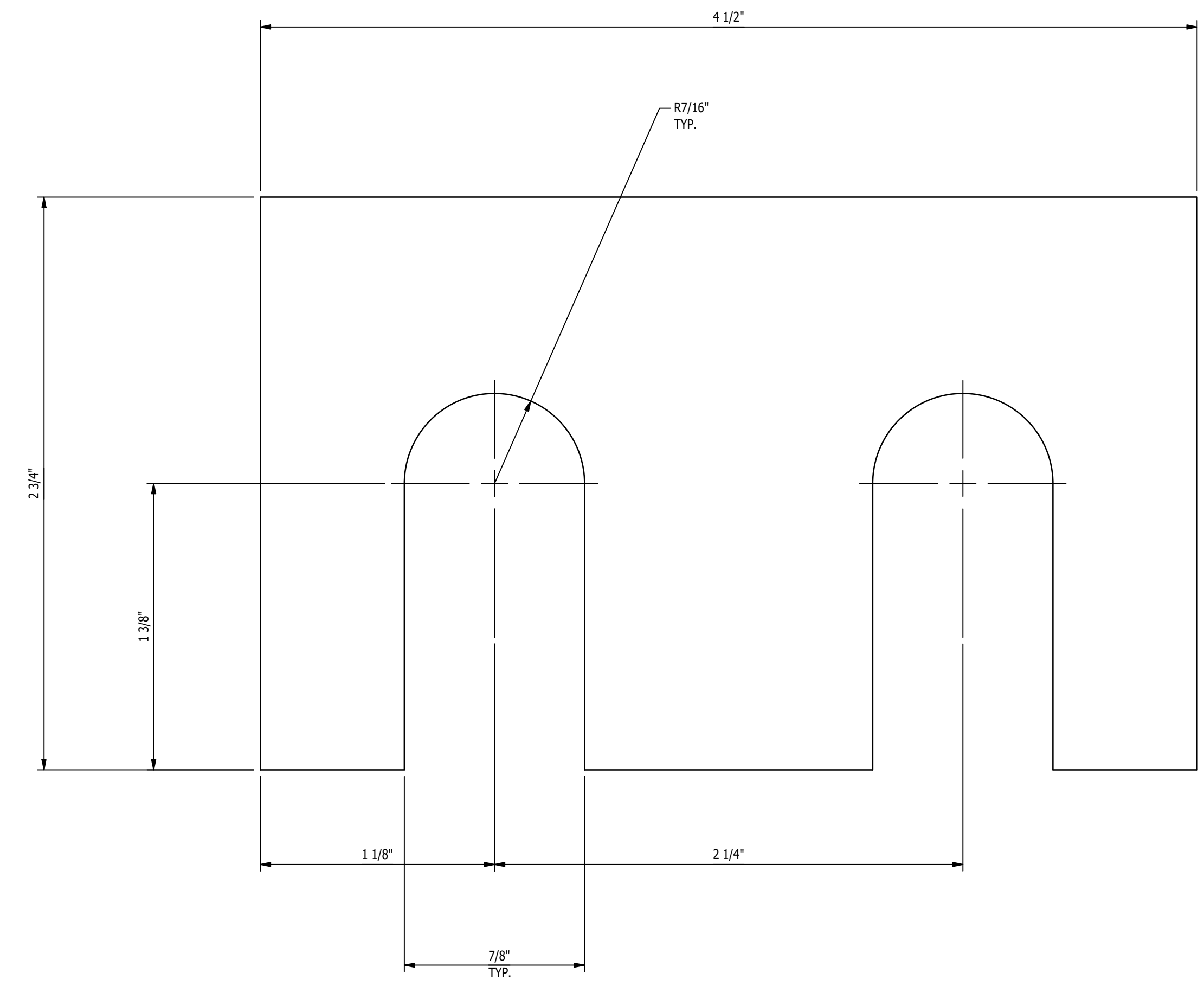
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D446 - REV B

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

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D447B			
3	2	SHT 22 GA x 2 3/4"	4 1/2"		
4	1	SHT 16 GA x 2 3/4"	4 1/2"		
5	1	SHT 10 GA x 2 3/4"	4 1/2"		

B



MK-D447B ~ SHIM PACK
SCALE 2:1

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

PAINT NOTES:
DO NOT PAINT

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/1/2022	REVISED BOM DIMS ITEM 5, BALLOONS	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY		MILLER INDUSTRIES		PROPRIETARY AND CONFIDENTIAL	
		3070 W. THOMPSON RD.		INFORMATION CONTAINED IN THIS	
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TITLE: P6700 CONVEYORS		DRAWN BY: RJB		CHECKED BY: CW	
CLIENT: VOLVO		DWG DATE: 10/3/22		JOB No: 22096	
DRAWING No. 1875D447		REV: B			

MAGNUM Consulting
41100 Charleston Rd. Suite 125 West, MI 48375
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XXX = ±.005
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ANGLES = ±1°30'
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DEBURR ALL HOLES
DO NOT SCALE DRAWING

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MATERIALS:

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

HOLES:

- ALL HOLES ARE 13/16" DIA. U.N.O.
- 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)

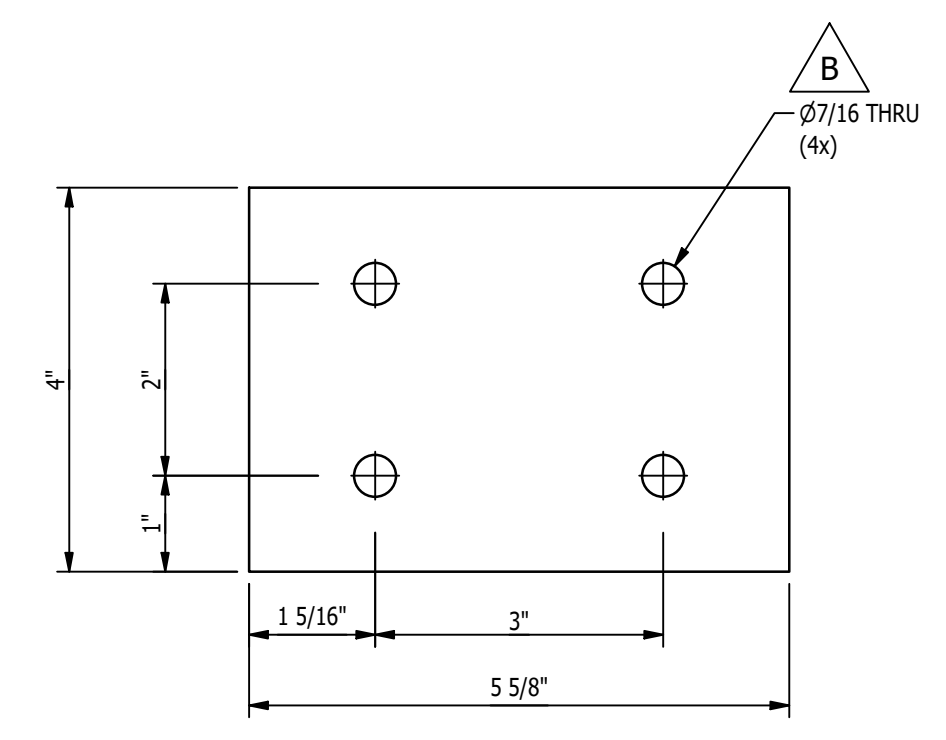
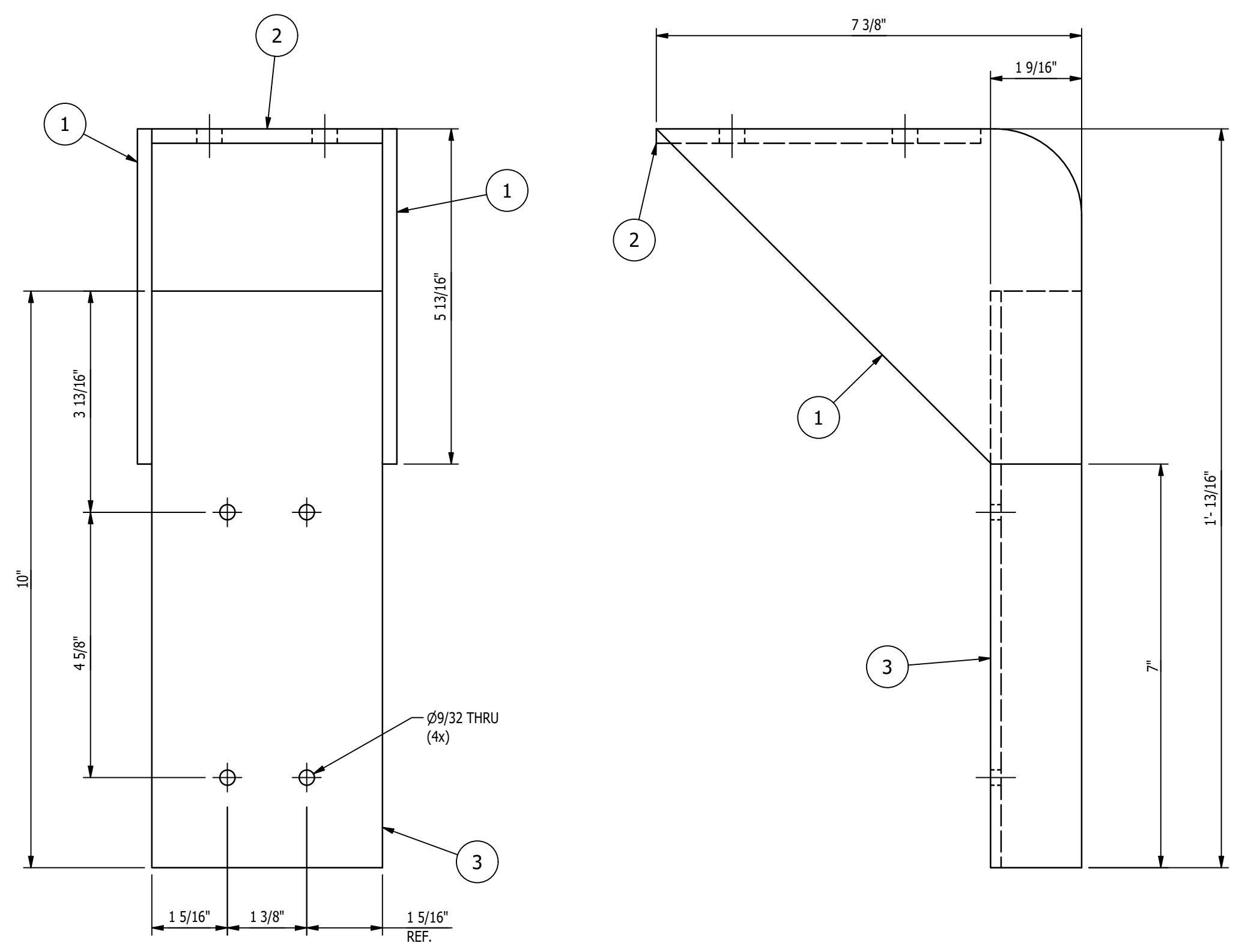
PAINT:

- PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

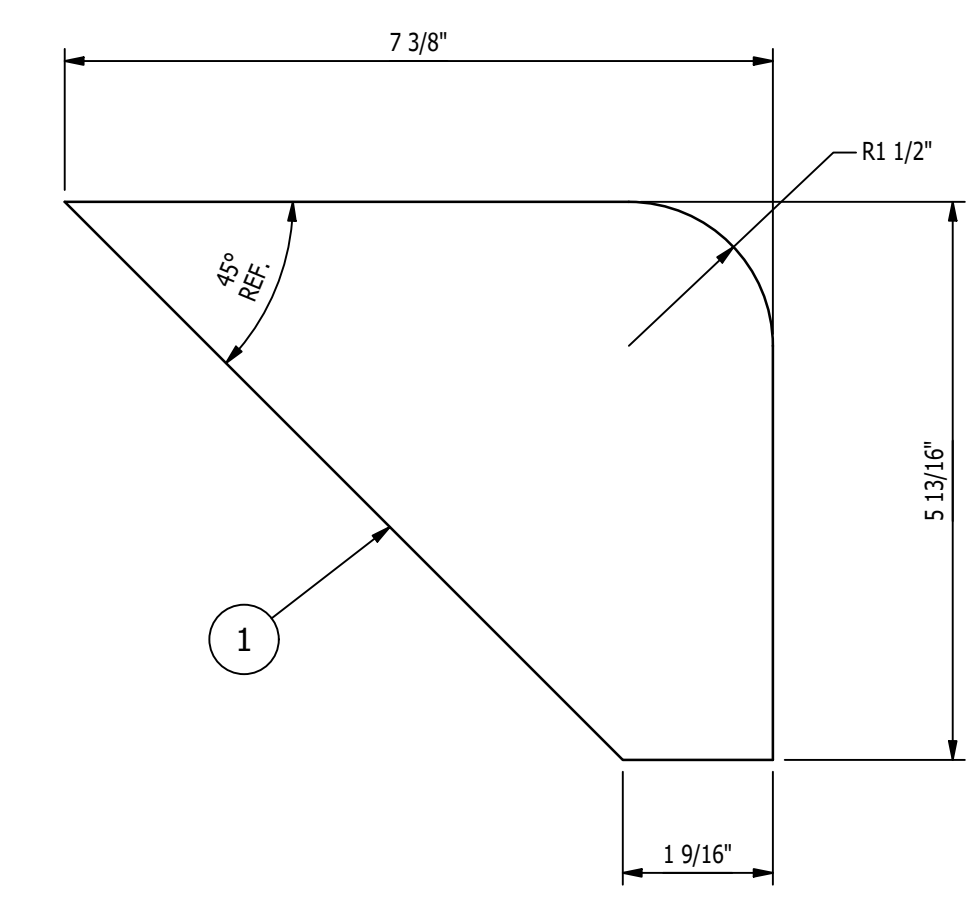
COPIES:

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

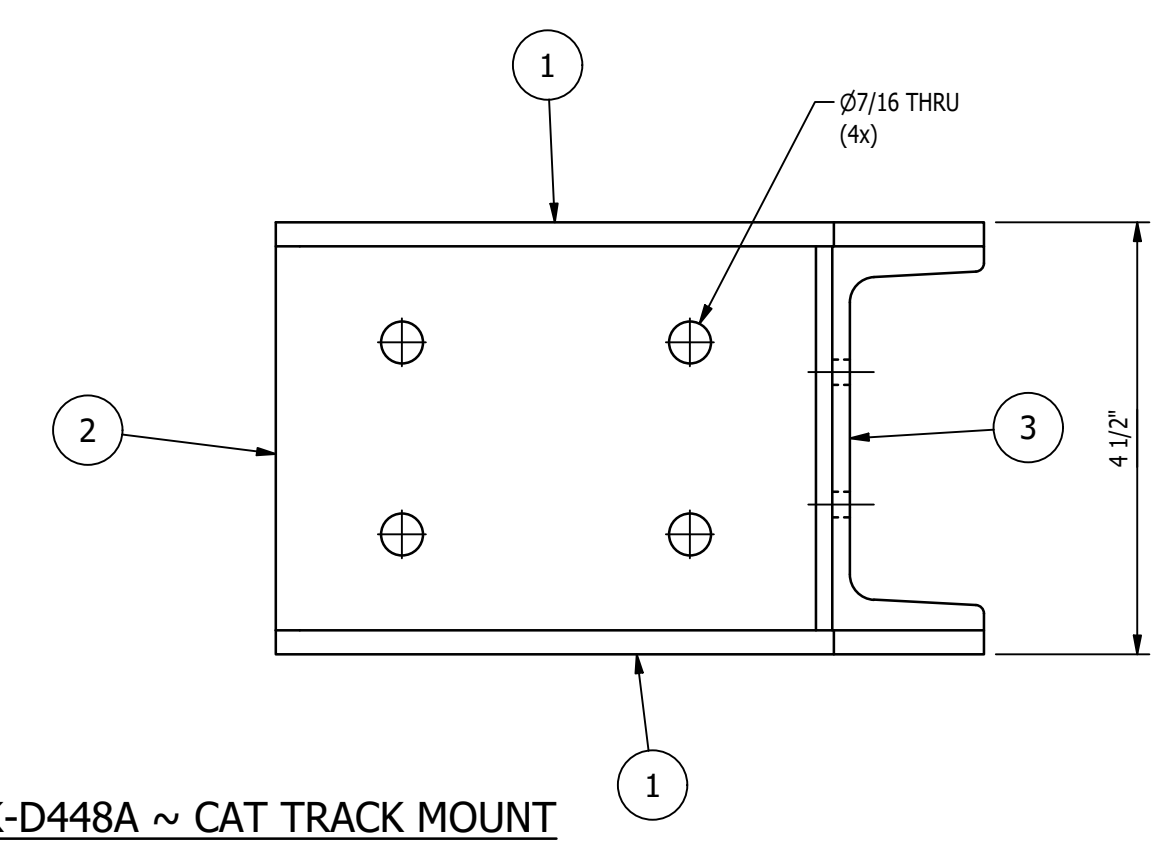
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D448A			
1	2	PL 1/4 x 5 13/16"	7 3/8"		
2	1	PL 1/4 x 4"	5 5/8"		
3	1	C 4 x 5.4	10"		



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



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



MK-D448A ~ CAT TRACK MOUNT
SCALE 6"=1'-0"

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 - ALL HARDWARE MUST BE METRIC CLASS 8.8 OR SAE GR 5 AND ZINC PLATED
 - MARK ASSEMBLIES AND SUB-ASSEMBLIES (WHERE APPLICABLE) WITH MK IDENTIFIERS.
 - ALL SLOT LENGTHS ARE END TO END U.N.O.

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	11/1/2022	REVISED HOLE DIMS	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY				
		MILLER INDUSTRIES 3070 W. THOMPSON RD. FENTON, MI 48430 PH: 810.373.0322 FAX: 810.373.0326 www.millc.com		<small>PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MILLER INDUSTRIES. ANY REPRODUCTION IN PART OR AS WHOLE WITHOUT THE WRITTEN PERMISSION OF MILLER INDUSTRIES IS PROHIBITED.</small>
TITLE: P6700 CONVEYORS CAMPUS BUILDING		CLIENT: VOLVO		DRAWN BY: RJB CHECKED BY: CW DWG DATE: 10/6/22
DRAWING No. 1875D448		REV: B		JOB No: 22096

MAGNUM CONSULTING
 4110 Quakerwood Rd. Suite 125, West, MI 48375
 Phone: (248) 772-8822 Fax: (248) 772-8851 Web: www.m4magnum.com

MAGNUM JOB #: 1875
 MAGNUM DRAWING #: 1875D448 - REV B

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 XX = ±.030
 XXX = ±.005
 FRACTIONS = ±1/16"
 ANGLES = ±1°30'
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 DEBURR ALL HOLES
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GENERAL NOTES:

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

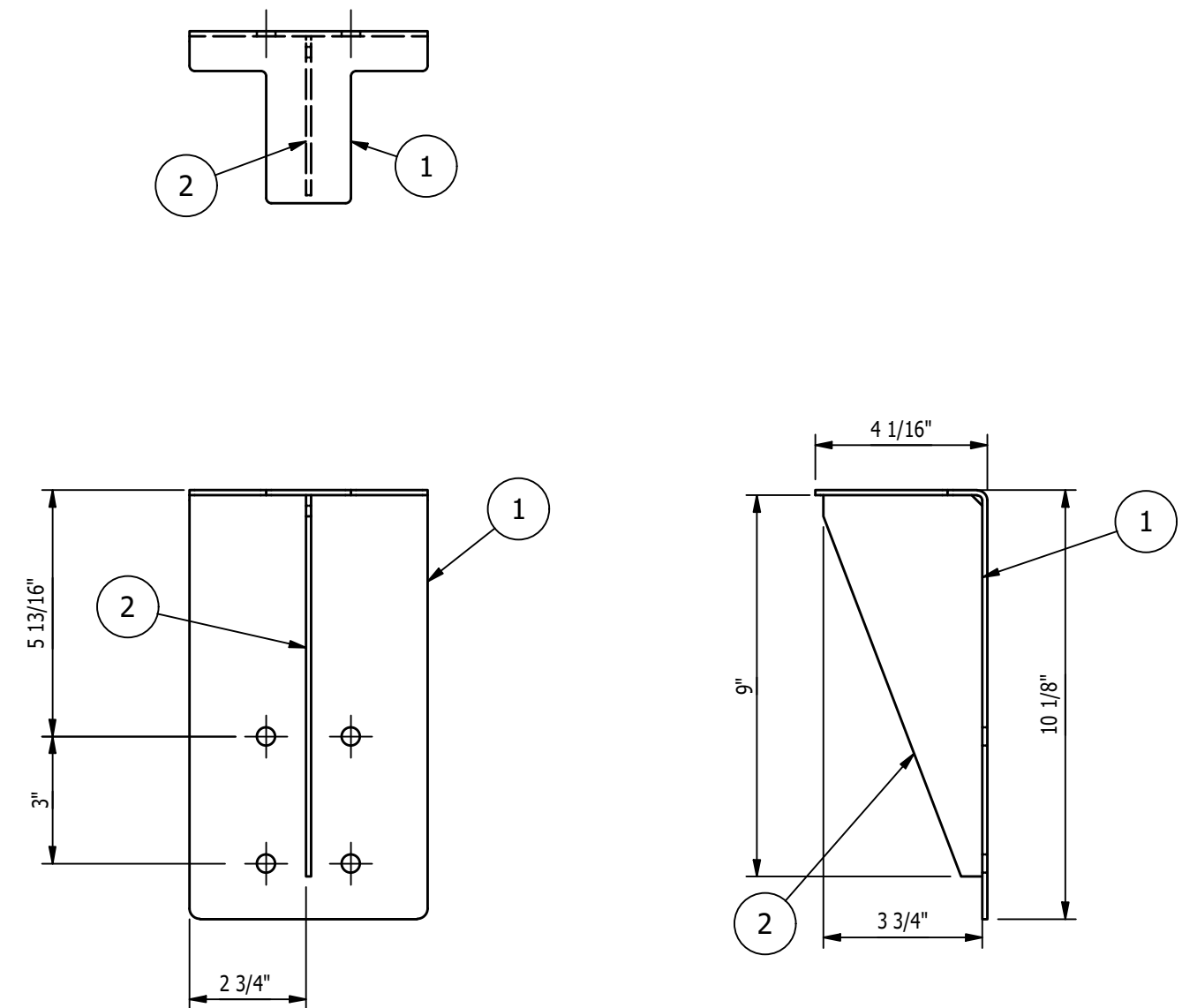
HOLES:
 - ALL HOLES ARE 13/16" DIA. U.N.O.
 - ALL BOLTED CONNECTIONS TO BE 3/4" DIA. A325-N (SHEAR BEARING TYPE CONNECTIONS) WITH BOLTS INSTALLED IN SNUG TIGHT CONDITION, UNLESS NOTED.

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

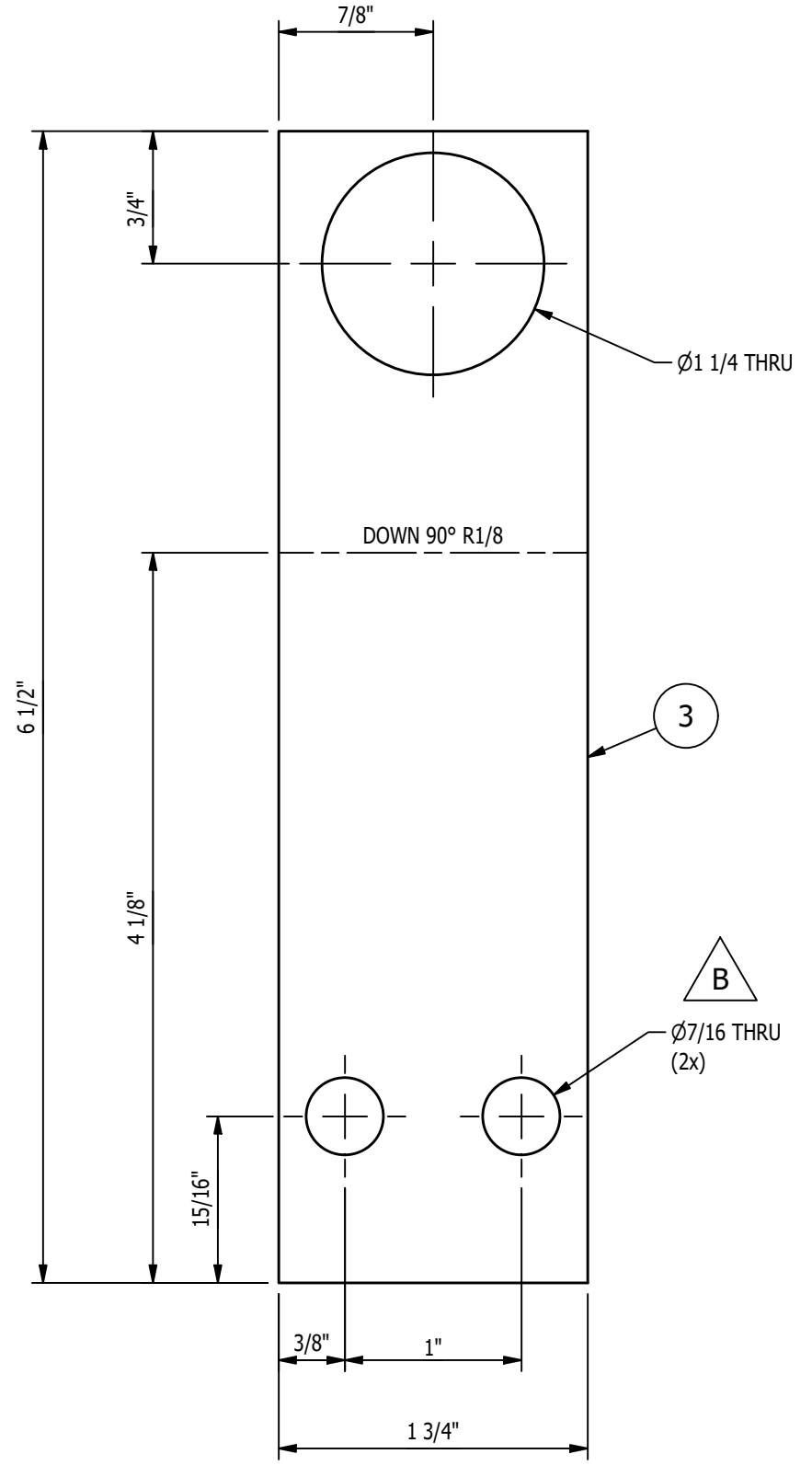
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

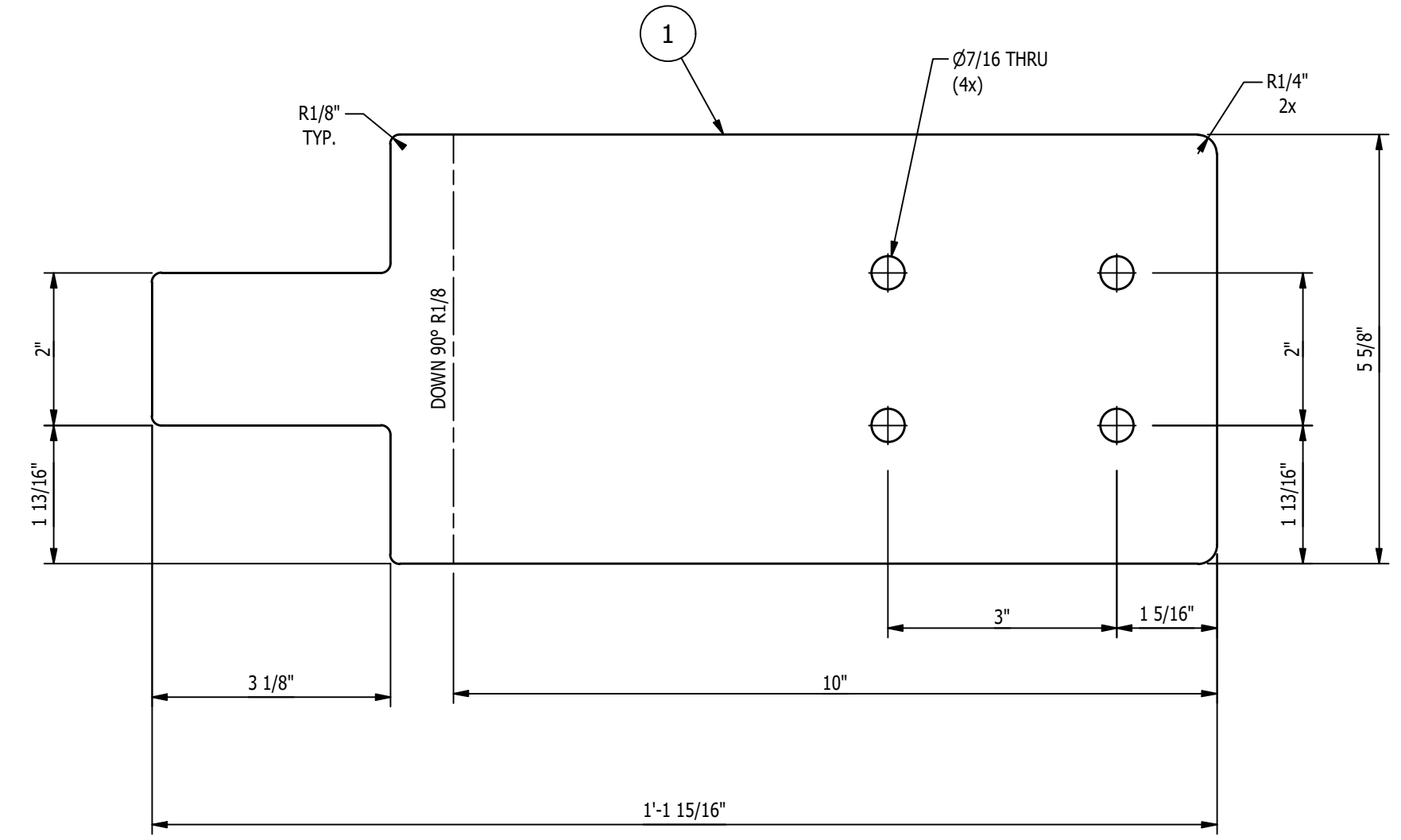
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D449A			
1	1	SHT 11 GA x 5 5/8	1'-1 15/16"		
2	1	SHT 11 GA x 3 3/4	9"		
		MK-D449B			
3	1	SHT 11 GA x 1 3/4	6 1/2"		



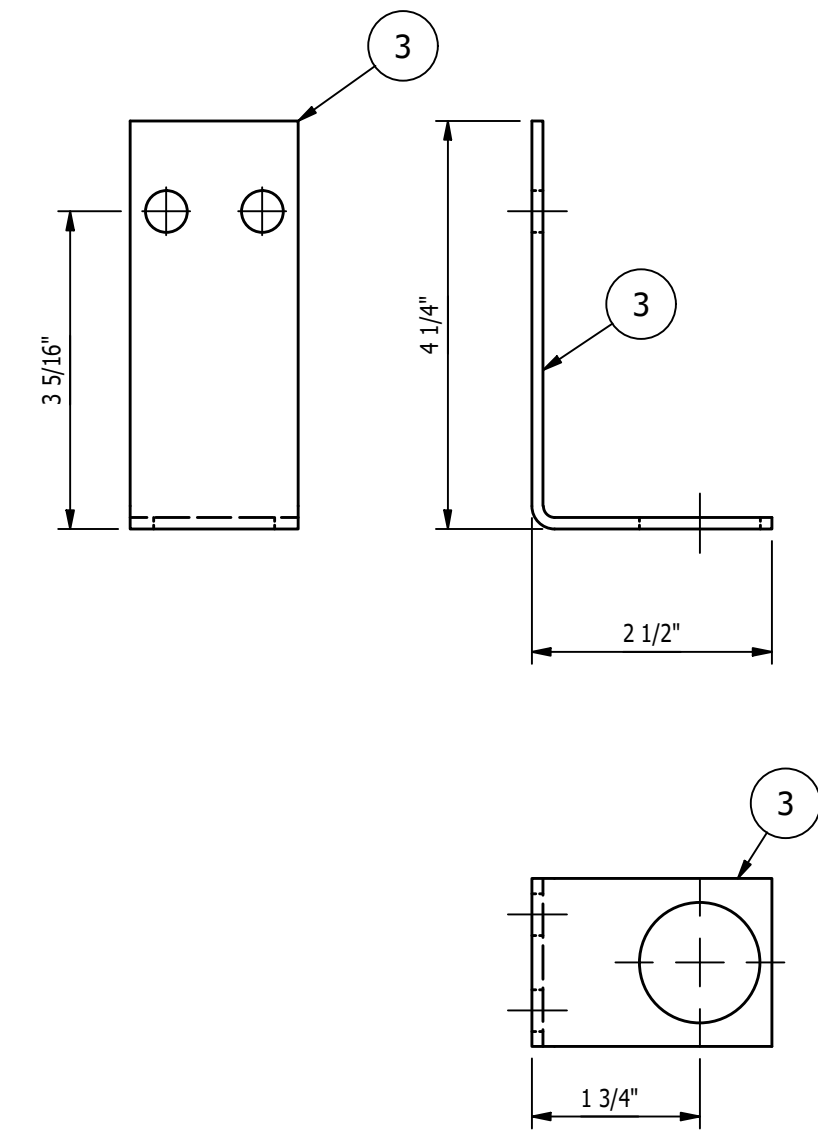
MK-D449A ~ PROX SWITCH BRACKET
SCALE 3"=1'-0"



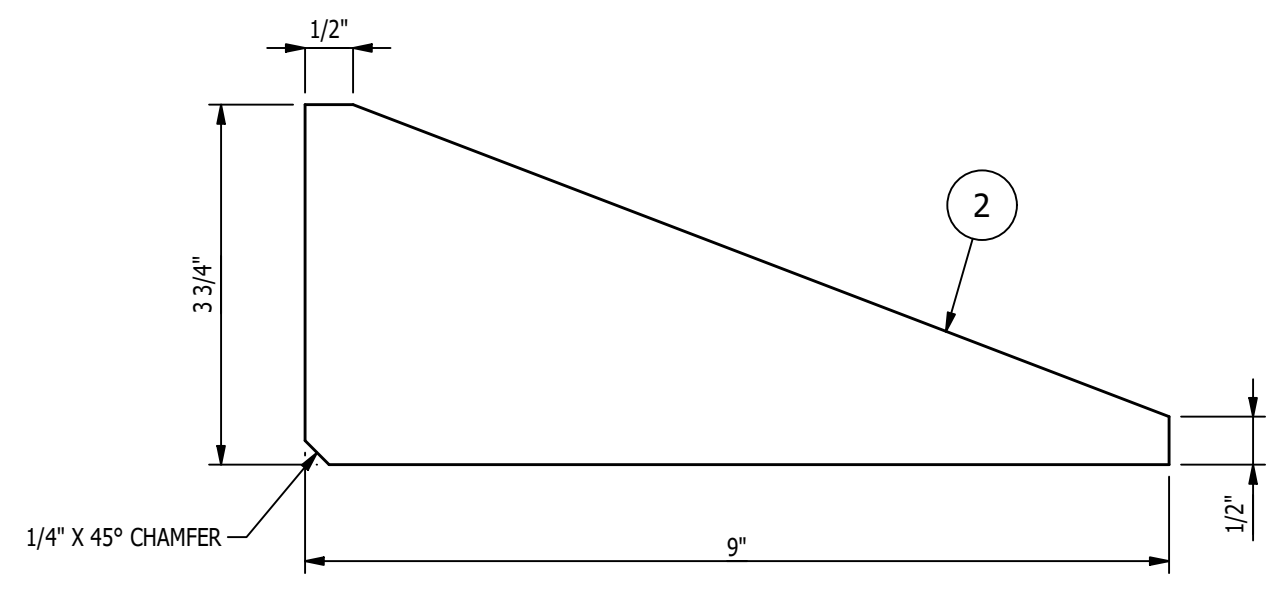
FLAT PATTERN OF ITEM '3'
SCALE 1'-0" = 1'-0"



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



MK-D449B ~ PROX SWITCH BRACKET
SCALE 6"=1'-0"



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

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

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

REV	BY	DATE	DESCRIPTION	APP
B	MC	10/31/22	CHANGED HOLE SIZE ON ITEM '3'	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY

MAGNUM Consulting
41100 Charleston Rd.
Suite 125
New, MI 48175
Phone: (248) 772-8822
Fax: (248) 772-8851
Web: www.mmagnum.com
MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D449

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

GENERAL NOTES:

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

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

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

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

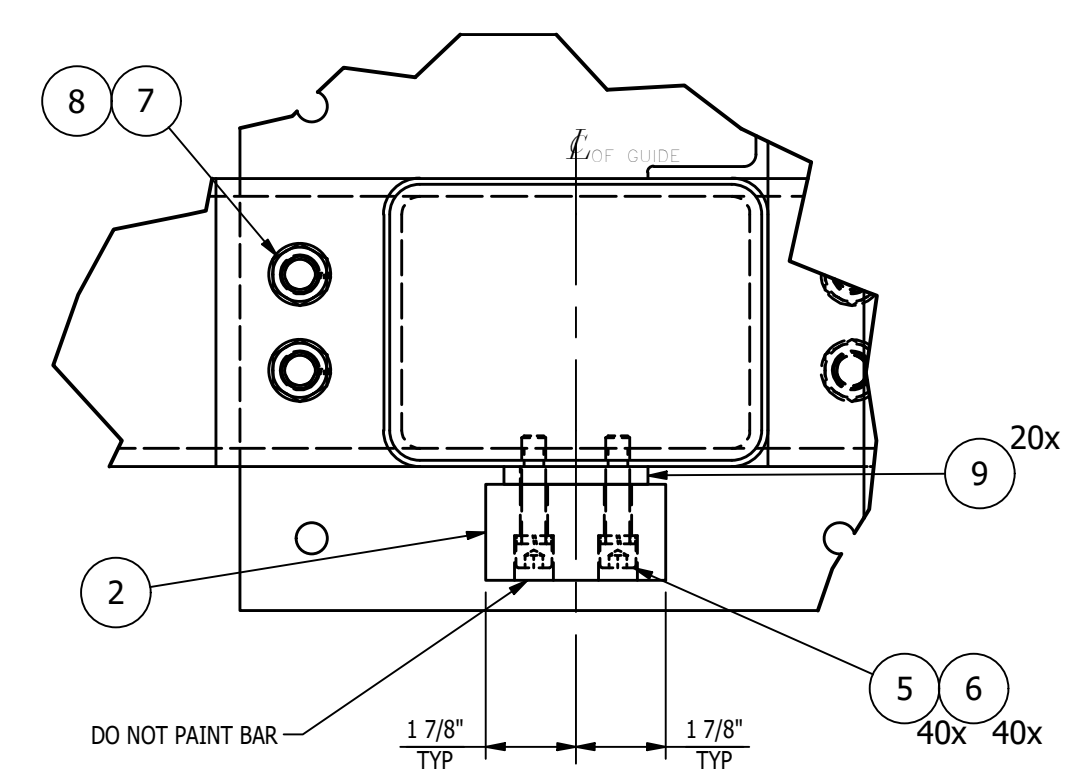
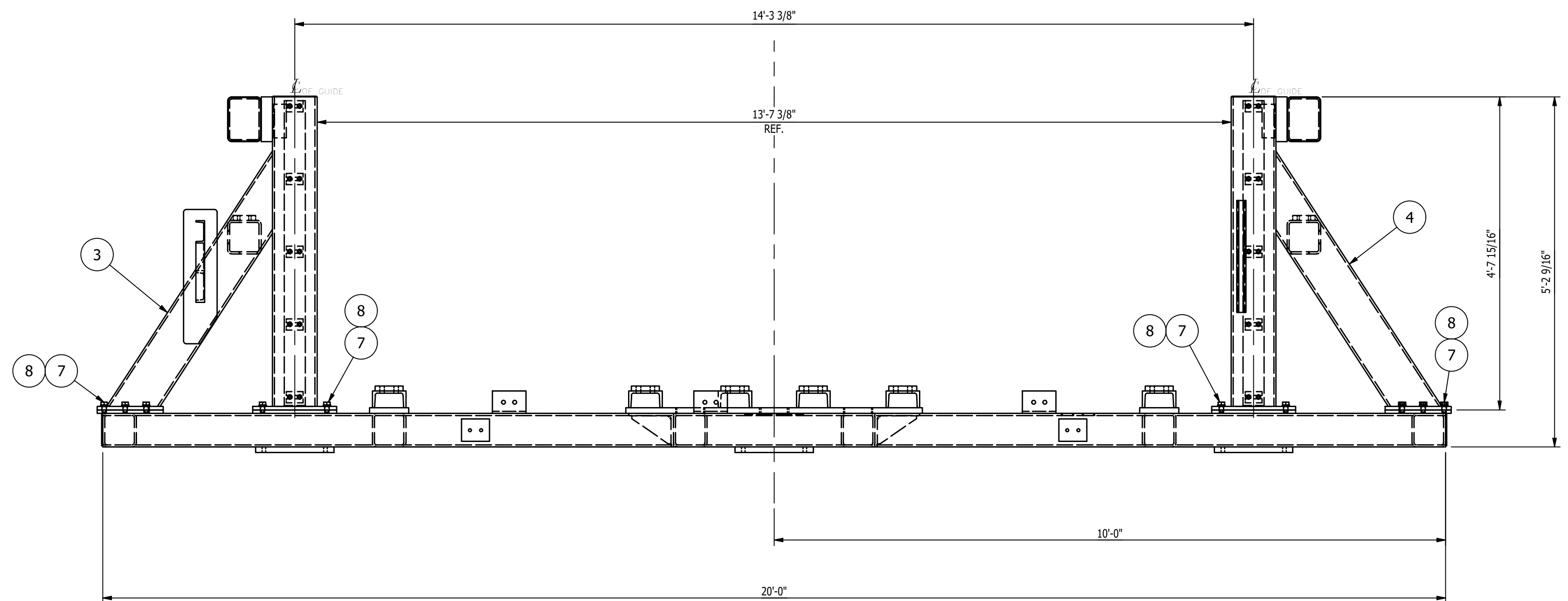
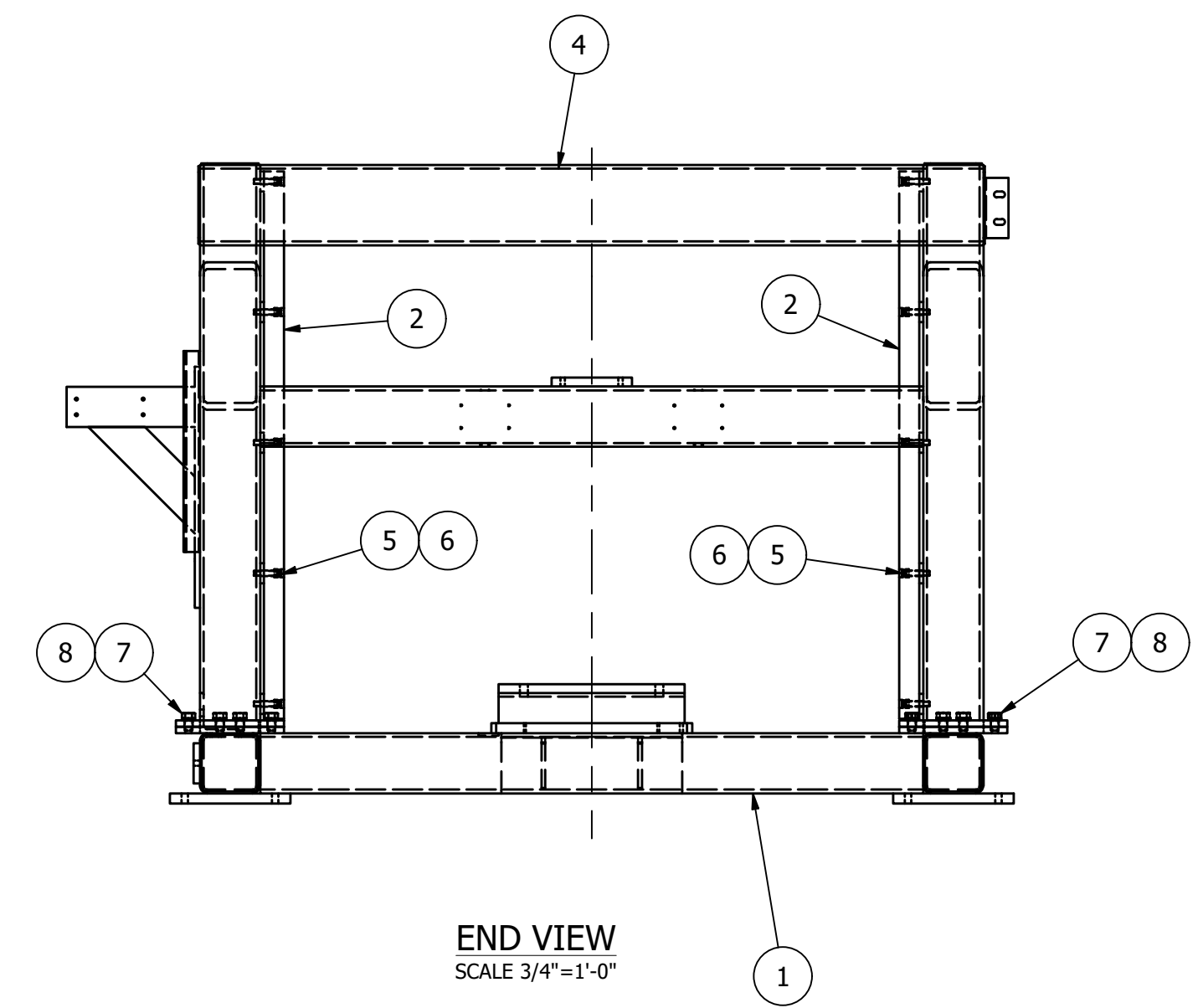
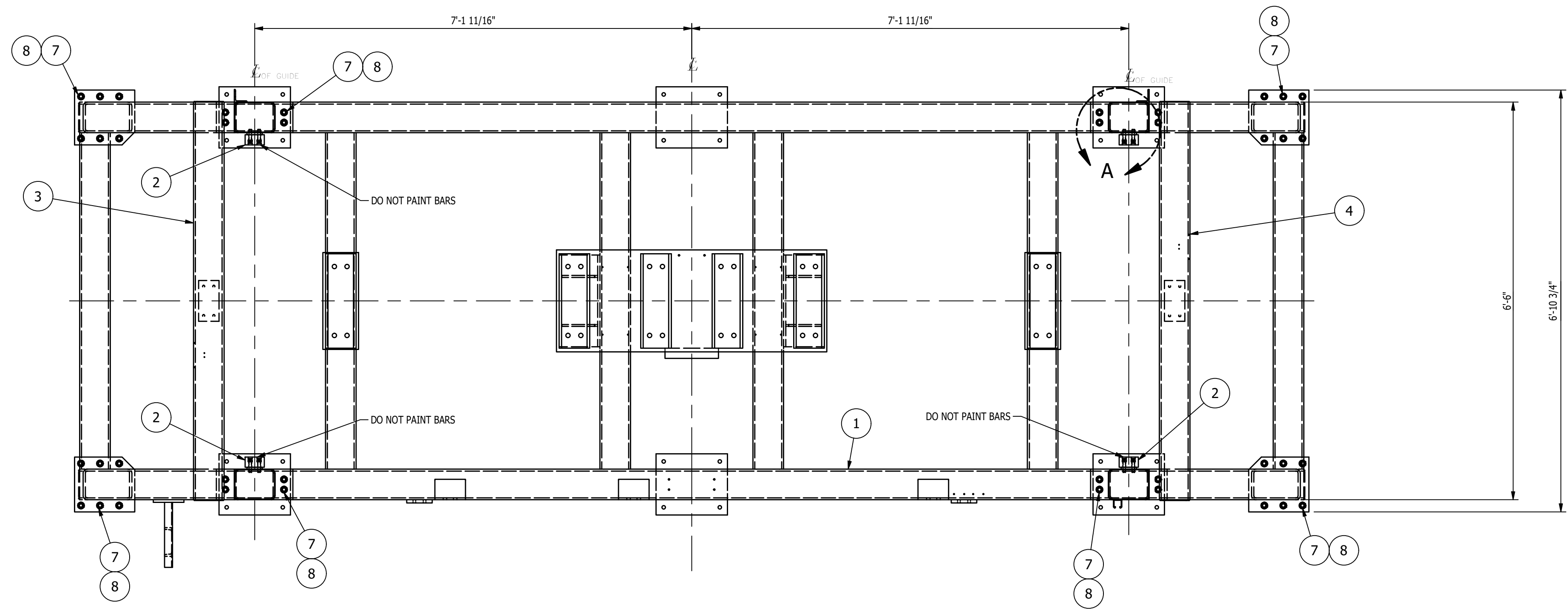
COPIES:
- ALL REentrant CUTS TO BE A MIN 1/2" RADIUS U.N.O.

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

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.	1875D449	DWG DATE:	10/12/22
REV:	B	JOB No:	22096

BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D450A			
1	1	MK-D432A ~ BASE FRAME WELDMENT			
2	4	MK-D435B ~ GUIDE BAR			
3	1	MK-D433A ~ SIDE FRAME WELDMENT			
4	1	MK-D433B ~ SIDE FRAME WELDMENT			
5	40	1/2-13UNC x 2 1/4" LG. HEX SOCKET HEAD CAP SCREW			
6	40	1/2 HIGH COLLAR SPRING LOCK WASHER			
7	40	3/4-10UNC x 1 1/4" LG. HEX HEAD BOLT			
8	40	3/4 HEAVY SPRING LOCK WASHER			
9	20	MK-D435C ~ SPACER			



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

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

REV	BY	DATE	DESCRIPTION	APP
C	MC	11/8/22	UPDATED GEOMETRY PER ITEMS '3' & '4'	
B	MC	10/31/22	GEOMETRY UPDATED PER ITEM '1'	
A	MC	10/21/22	FOR FABRICATION	

REVISION HISTORY

MK-D450A ~ BASE FRAME ASSEMBLY (BEFORE MACHINING)
 SCALE 3/4"=1'-0"

MAGNUM CONSULTING
 41100 Charleston Rd.
 Suite 125
 Norcross, GA 30071
 Phone: (770) 772-8822
 Fax: (770) 772-8821
 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)

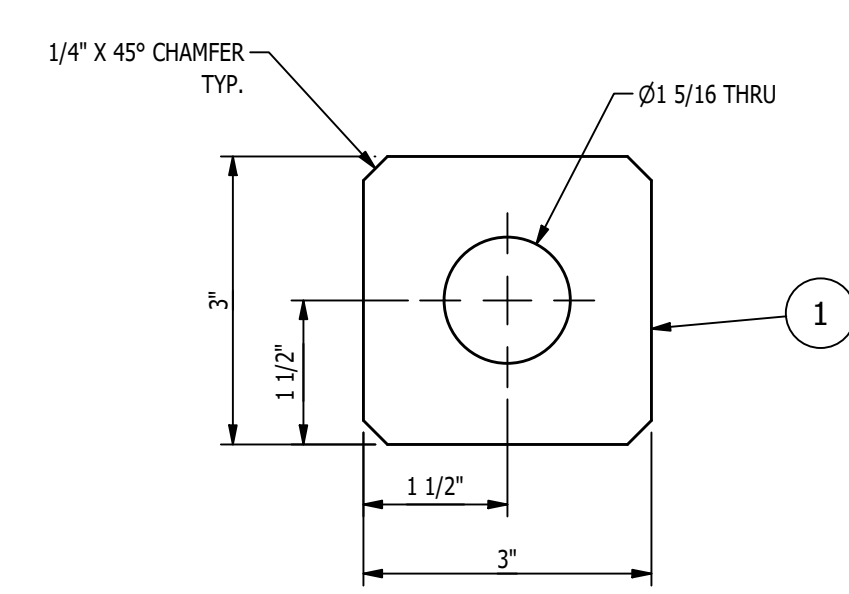
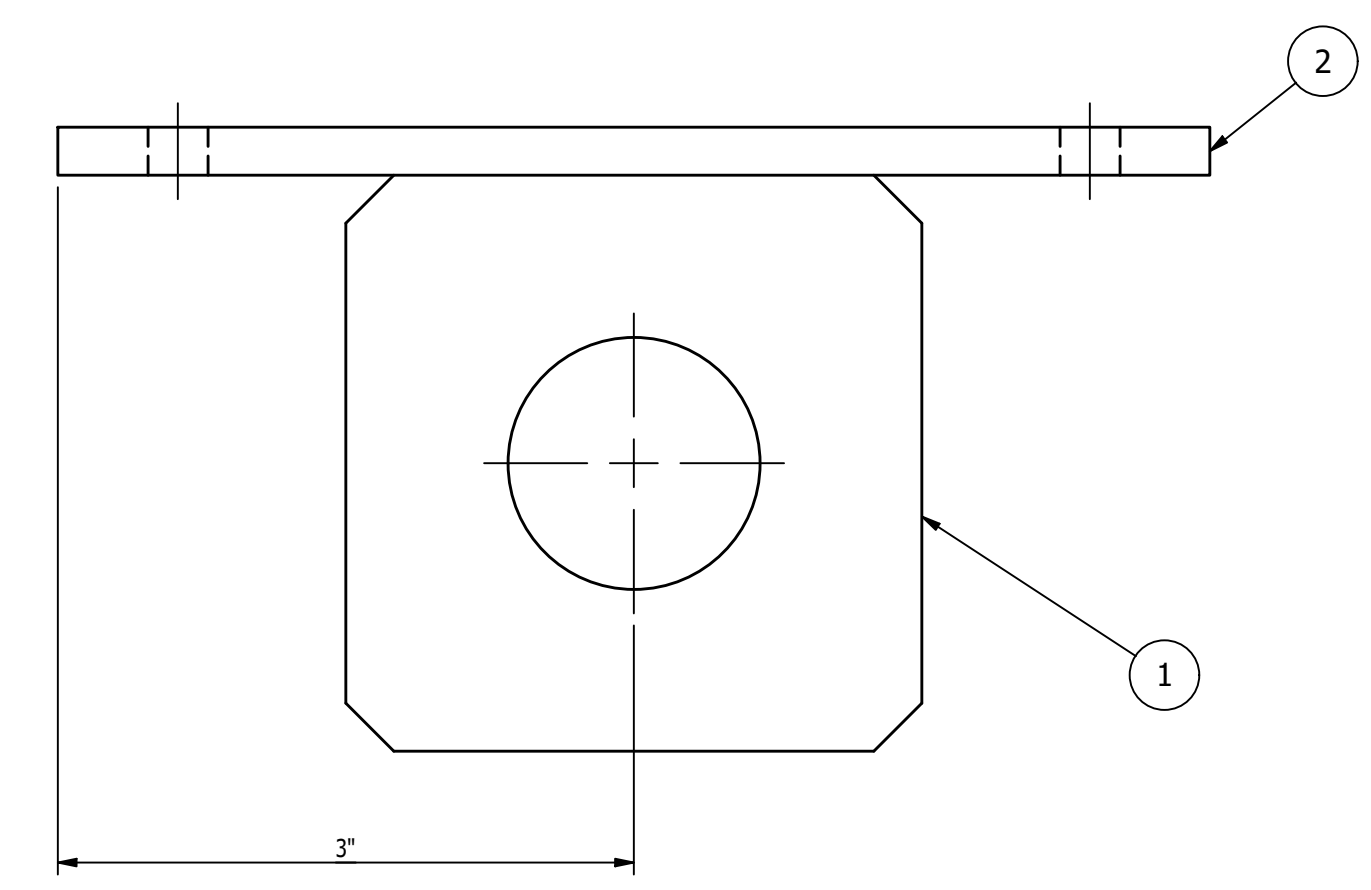
PAINT:
 - PAINT PER CUSTOMER SPECIFICATIONS U.N.O.

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

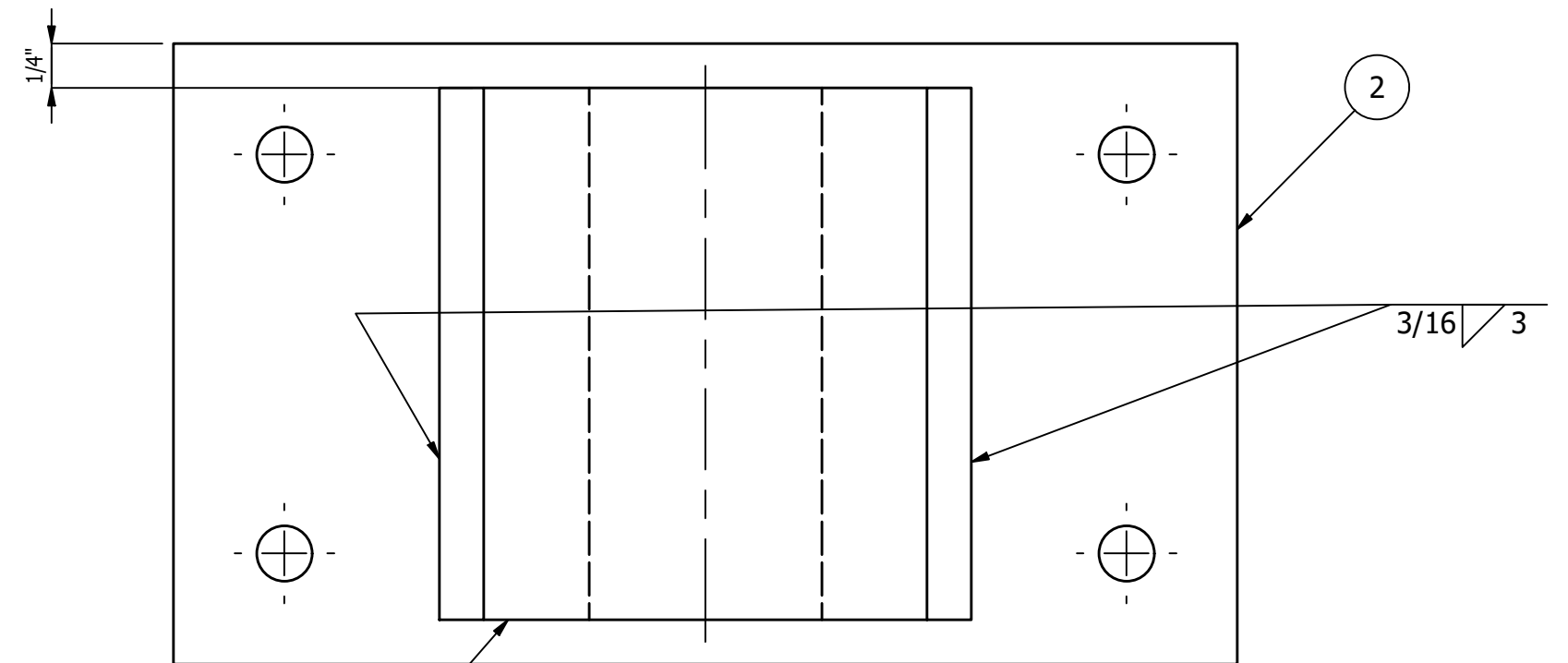
MILLER INDUSTRIES
 3070 W. THOMPSON RD.
 FENTON, MI 48430
 PH: 810.373.0322 FAX: 810.373.0326
 www.millic.com

TITLE:	P6700 CONVEYORS CAMPUS BUILDING	DRAWN BY:	RJB
CLIENT:	VOLVO	CHECKED BY:	CW
DRAWING No.	1875D450	DWG DATE:	10/21/22
REV:	C	JOB No.:	22096

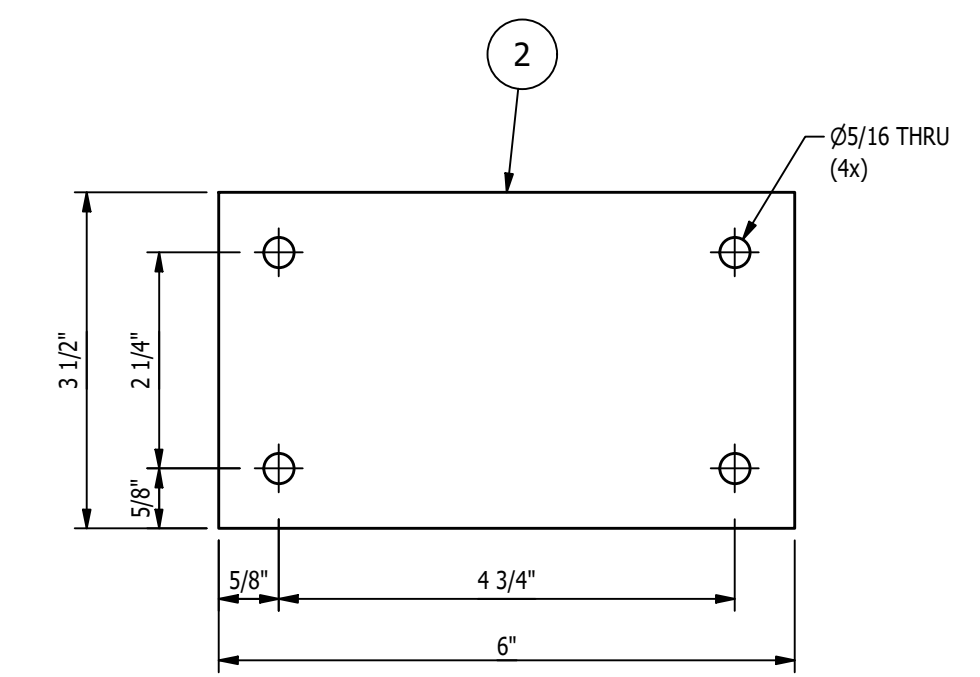
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D451A			
1	1	SQ. BAR 3 (A36)	3"		
2	1	BAR 1/4 x 3 1/2	6"		



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



MK-D451A ~ PIN HOLDER
SCALE 1'-0"=1'-0"



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

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

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	10/21/22	FOR FABRICATION	

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

CLIENT: VOLVO	DRAWN BY: RJB
DRAWING No. 1875D451	CHECKED BY: CW
REV: A	DWG DATE: 10/12/22
JOB No: 22096	

	MAGNUM CONSULTING 41700 QuakerRoad Rd. Suite 125 Novi, MI 48275	Phone: (248) 772-8822 Fax: (248) 772-8851 Web: www.mmagnum.com
MAGNUM JOB #: 1875 MAGNUM DRAWING #: 1875D451		

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:

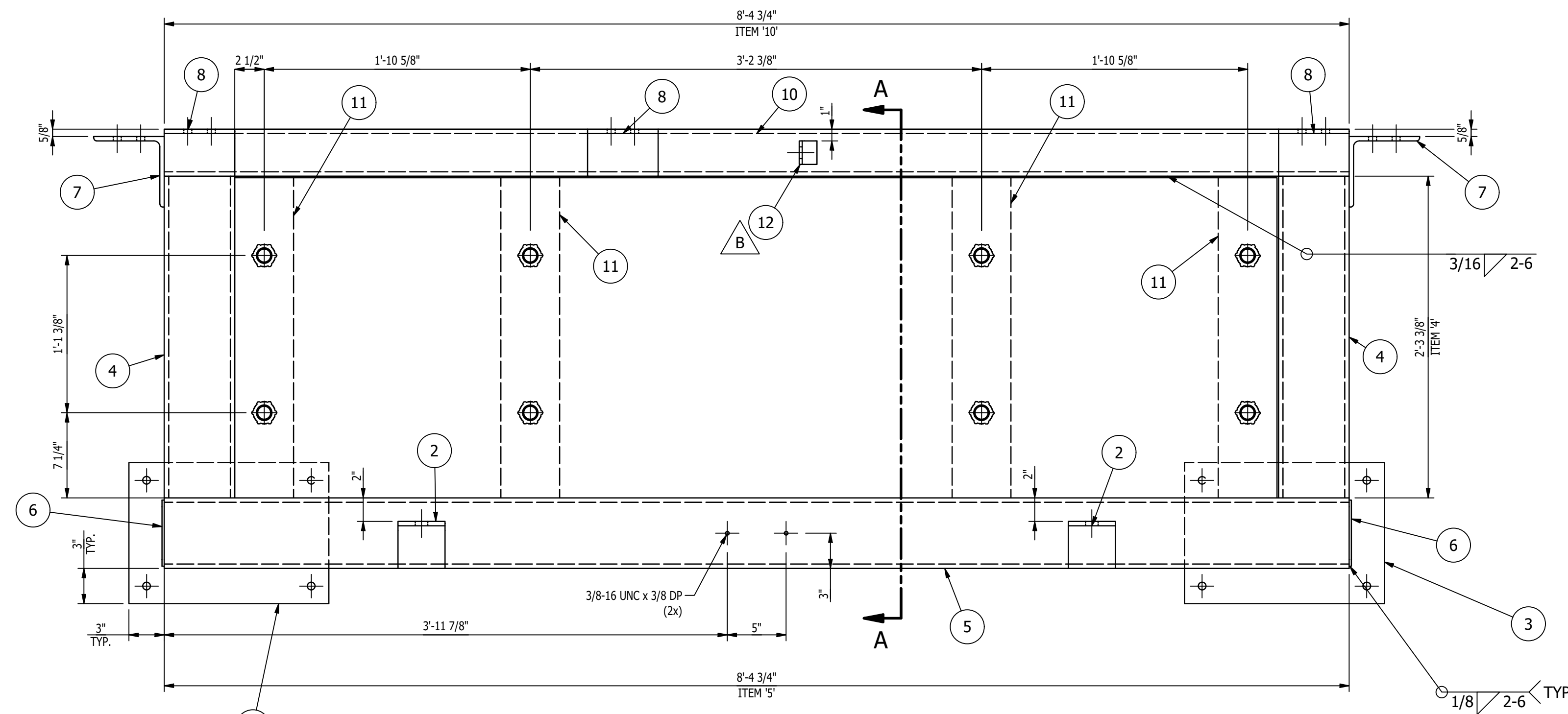
MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

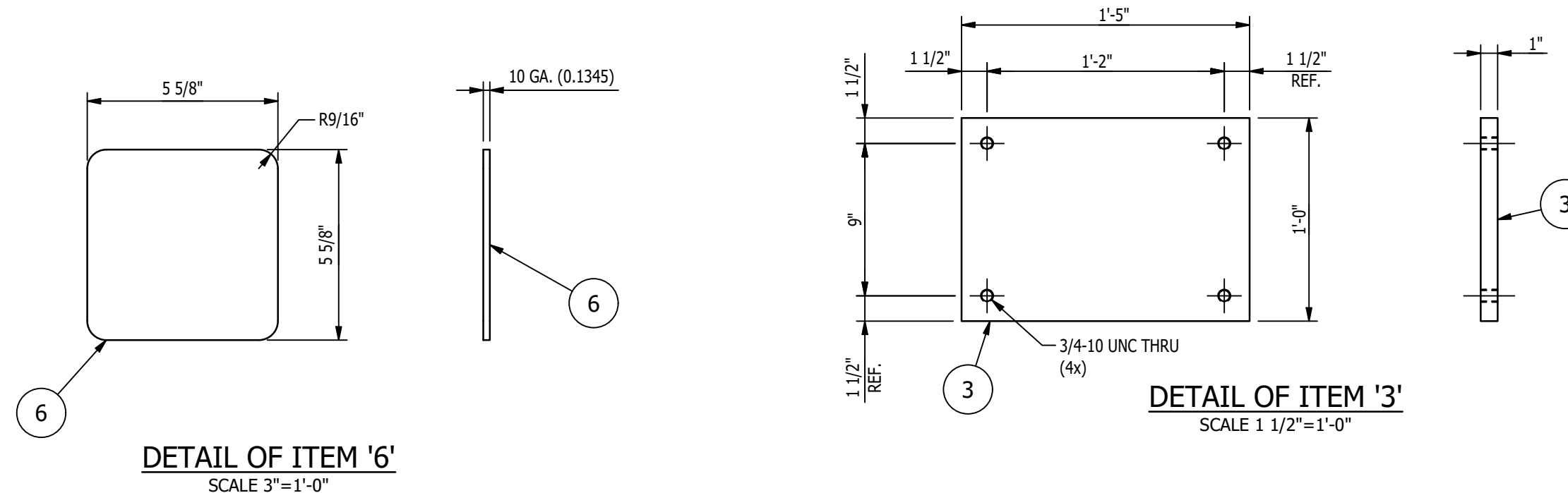
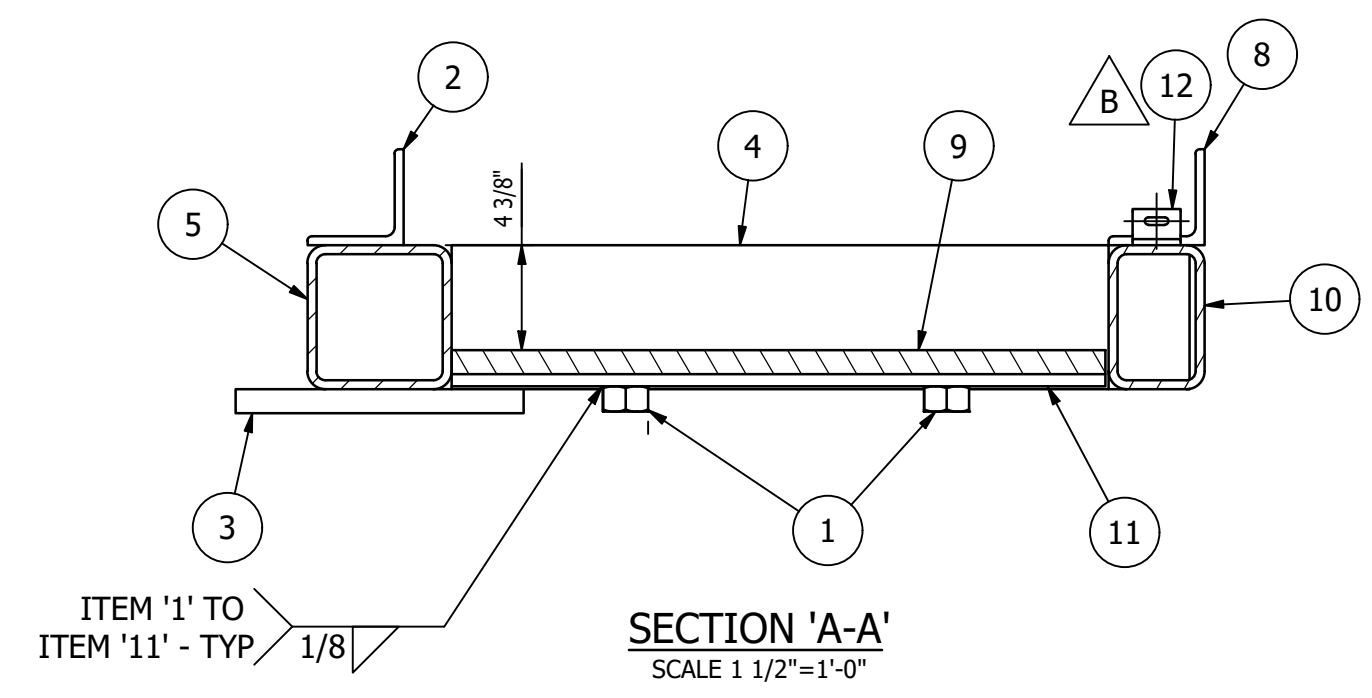
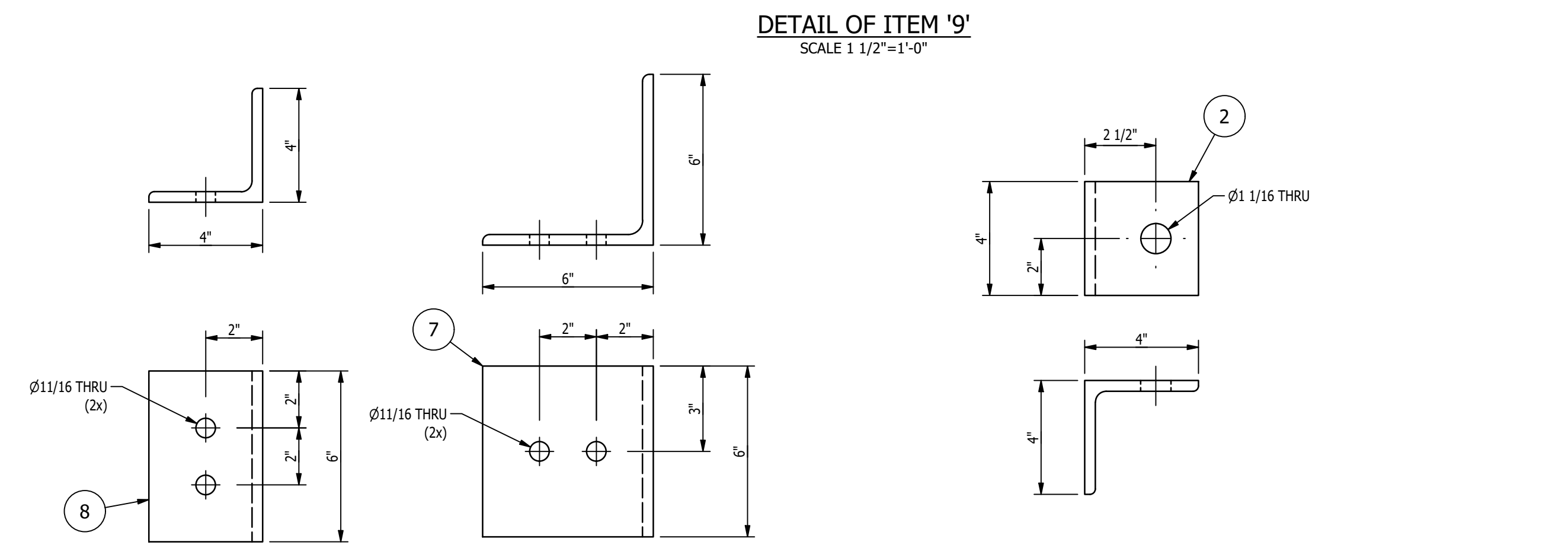
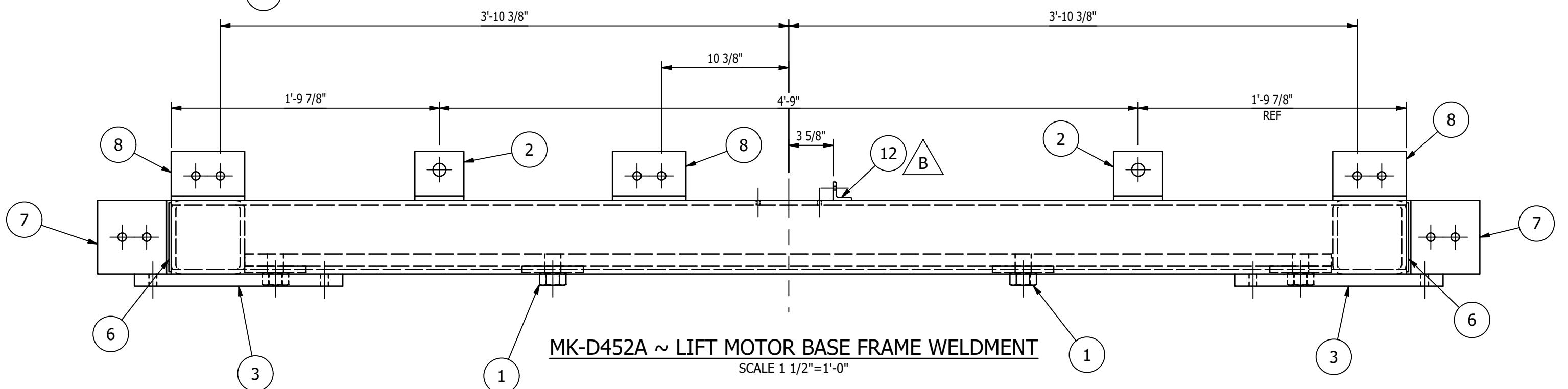
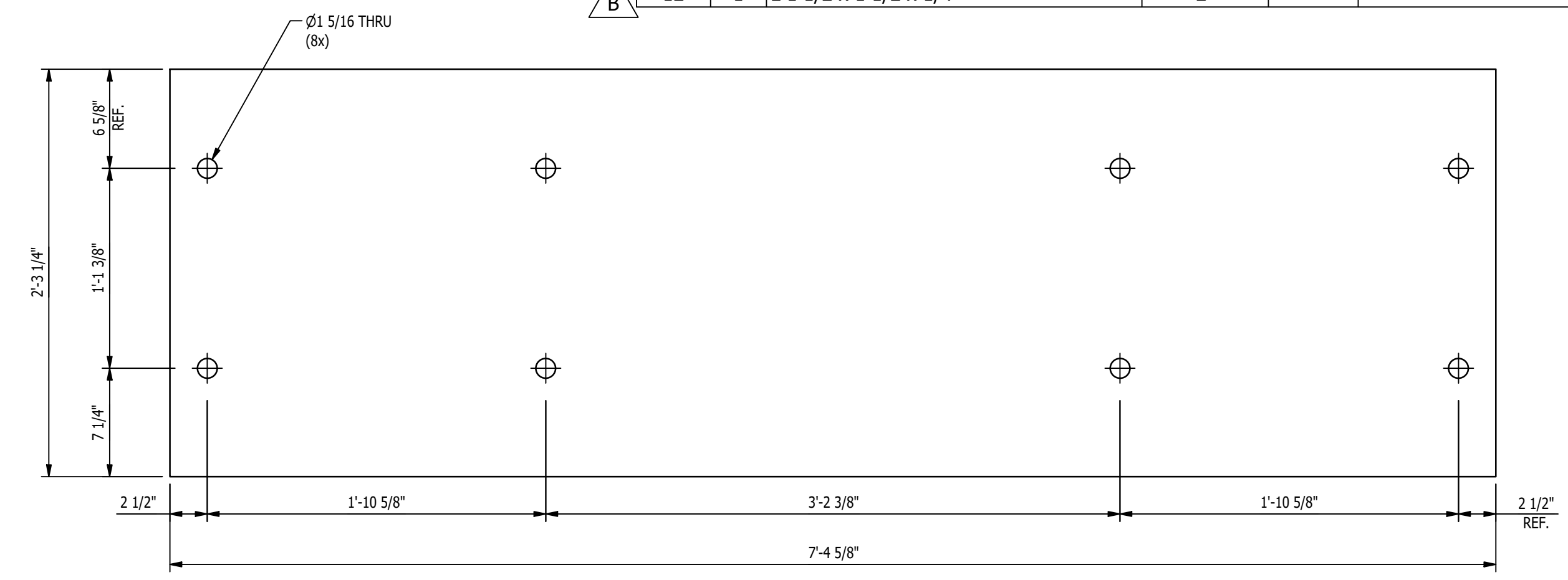
WELDS:
 - ALL WELDS TO BE "E70XX", (PER AWS D1.1)

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

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



BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D452A			
1	8	1 1/4-7UNC HEX NUT			
2	2	L 4 x 4 x 3/8	4"		
3	2	BAR 1 x 1'-0"	1'-5"		
4	2	HSS 6 x 6 x 3/8 A300 GR. C	2'-3 3/8"		
5	1	HSS 6 x 6 x 3/8 A300 GR. C	8'-4 3/4"		
6	2	SHT. STL. 10 GA. x 5 5/8	5 5/8"		
7	2	L 6 x 6 x 3/8	6"		
8	3	L 4 x 4 x 3/8	6"		
9	1	PL 1 x 2'-3 1/4"	7'-4 5/8"		
10	1	A500 GR. C HSS 6 x 4 x 3/8	8'-4 3/4"		
11	4	PL 1/2 x 5"	2'-3 1/4"		
12	1	L 1 1/2 x 1 1/2 x 1/4	2"		



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

- 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	11/18/22	ADDED ITEM '12'	
A	MC	10/31/22	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.	1875D452	DWG DATE:	10/28/22
REV:	B	JOB No.:	22096

MAGNUM CONSULTING
 41100 Dardickwood Rd.
 Suite 125
 West, MI 48375
 Phone: (248) 772-8888
 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:

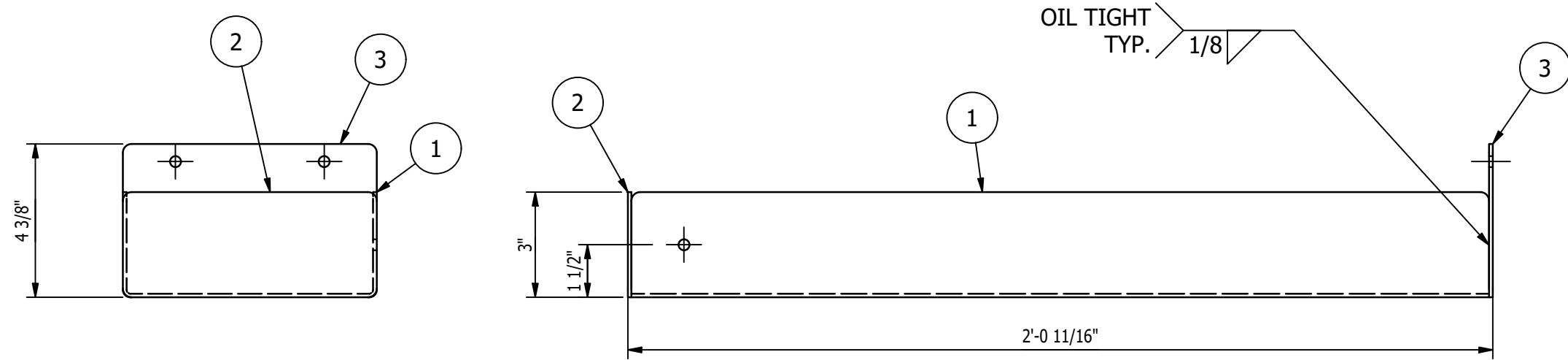
MATERIALS:
 - ALL WIDE FLG. MATERIAL TO BE ASTM A992-GR50 U.N.O.
 - ALL TUBE MATERIAL TO BE ASTM A500, GRADE B U.N.O.
 - ALL PIPE MATERIAL TO BE ASTM A53, GRADE B U.N.O.
 - ALL OTHER MATERIAL TO BE ASTM-A36 U.N.O.

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.

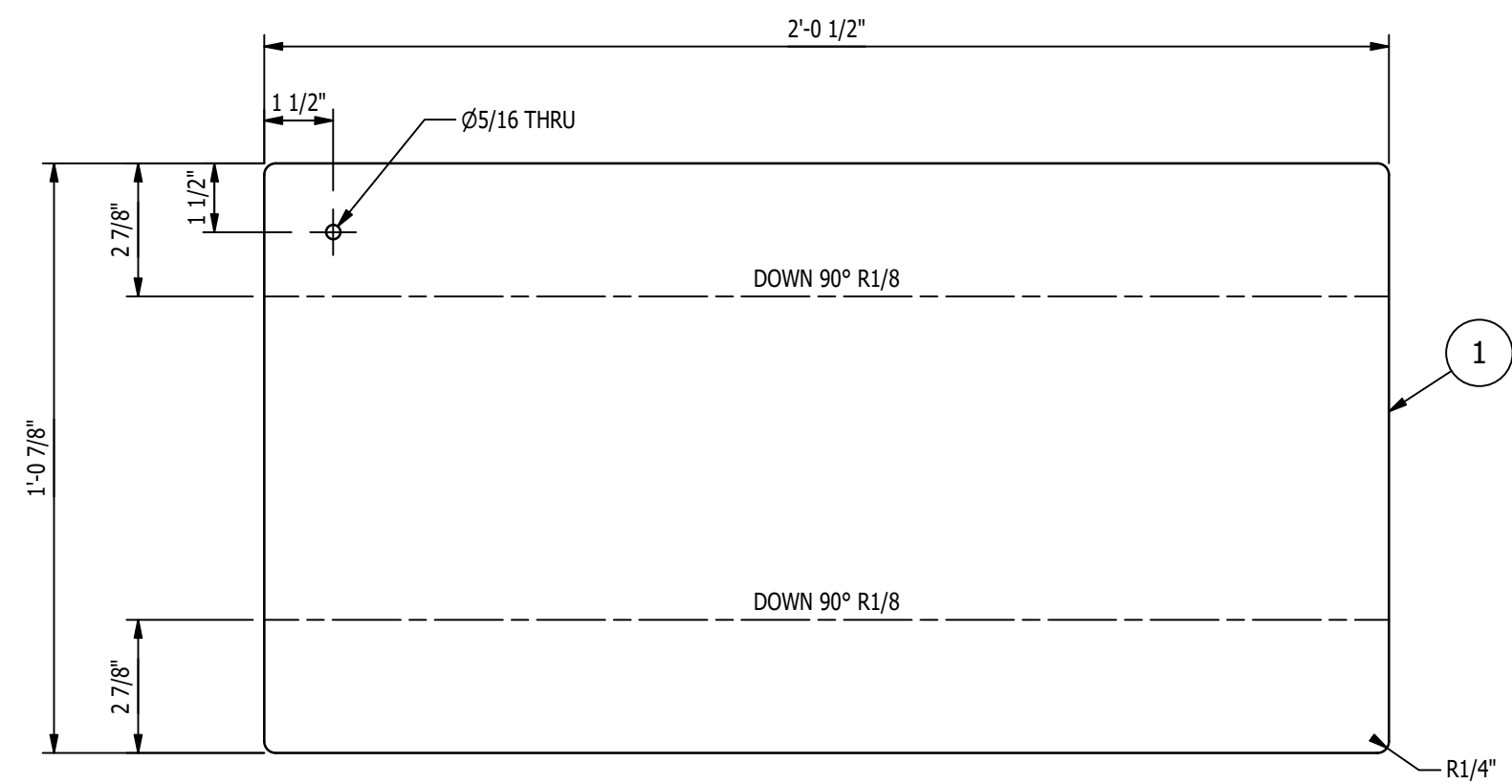
WELDS:
 - ALL WELDS TO BE 'E70XX', (PER AWS D1.1)

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

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

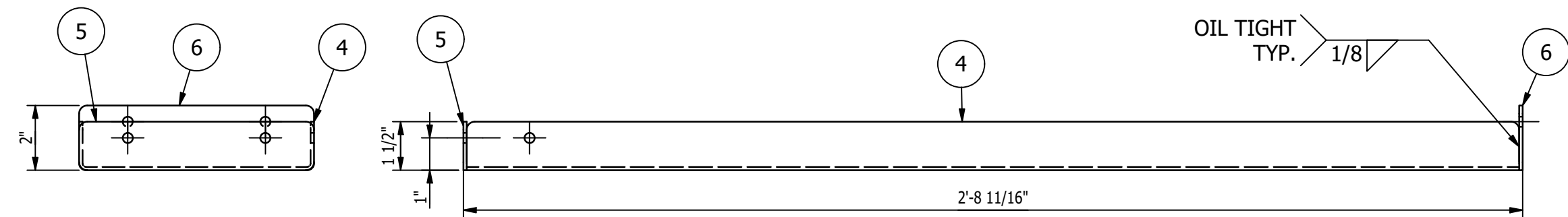


MK-D453A ~ DRIP PAN
SCALE 3"=1'-0"

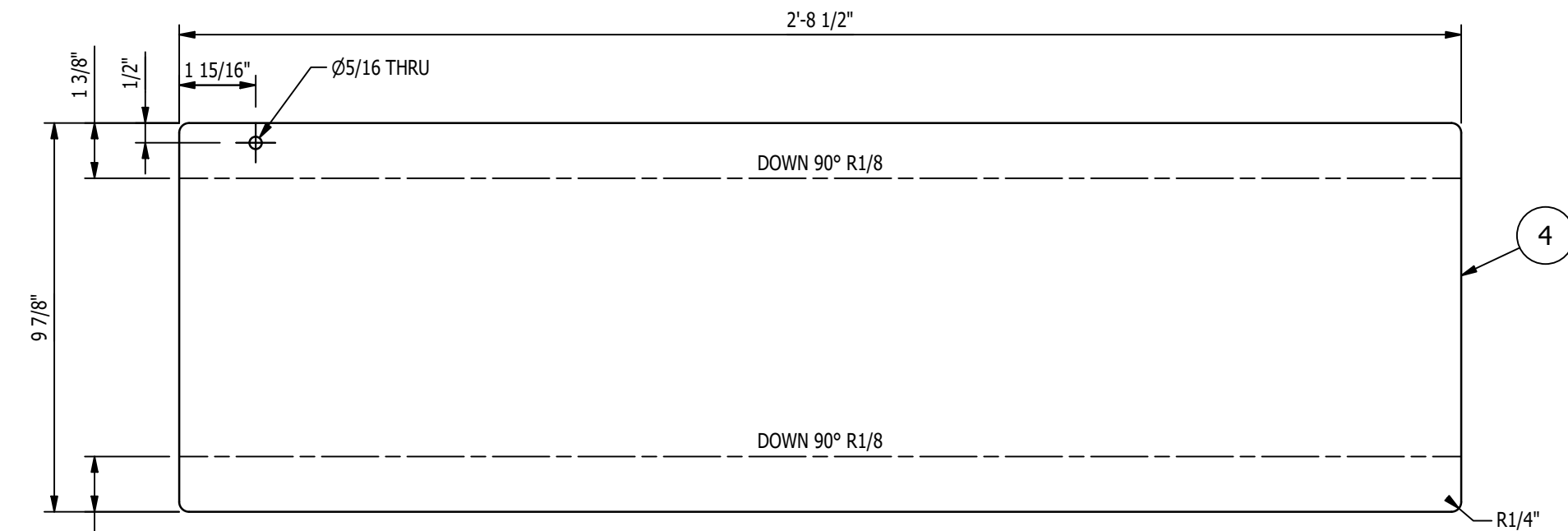


FLAT PATTERN OF ITEM '1'
SCALE 3"=1'-0"

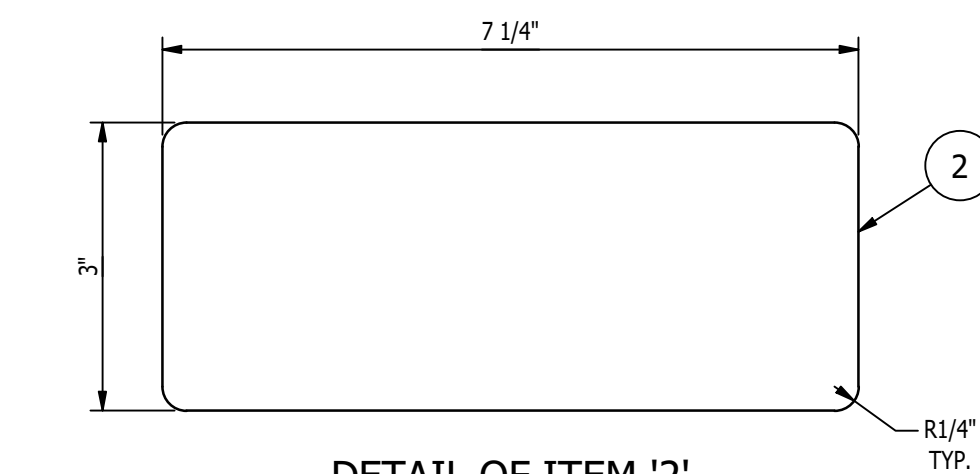
BILL OF MATERIAL					
MARK	QTY	DESCRIPTION	LENGTH	ABM #	REMARKS
		MK-D453A			
1	1	SHT 12 GA x 1'-0 7/8	2'- 1/2"		
2	1	SHT 12 GA x 3	7 1/4"		
3	1	SHT 12 GA x 4 3/8	7 1/4"		
		MK-D453B			
4	1	SHT 12 GA x 9 7/8	2'-8 1/2"		
5	1	SHT 12 GA x 1 1/2	7 1/4"		
6	1	SHT 12 GA x 2	7 1/4"		
		MK-D453C			
7	1	SHT 12 GA x 8 7/8	1'-5 1/2"		
8	1	SHT 12 GA x 1	7 1/4"		
9	1	SHT 12 GA x 1	7 1/4"		
		MK-D453D			
10	1	SHT 12 GA x 2 1/4	6 3/4"		



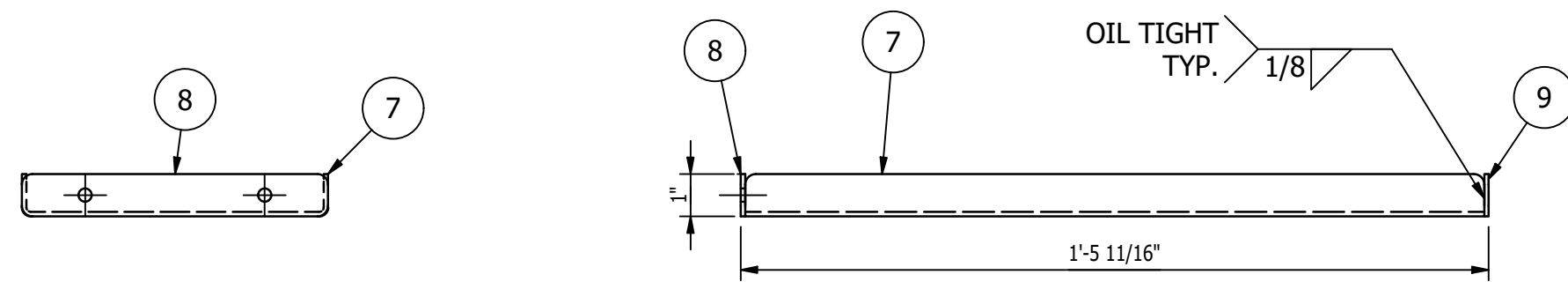
MK-D453B ~ DRIP PAN
SCALE 3"=1'-0"



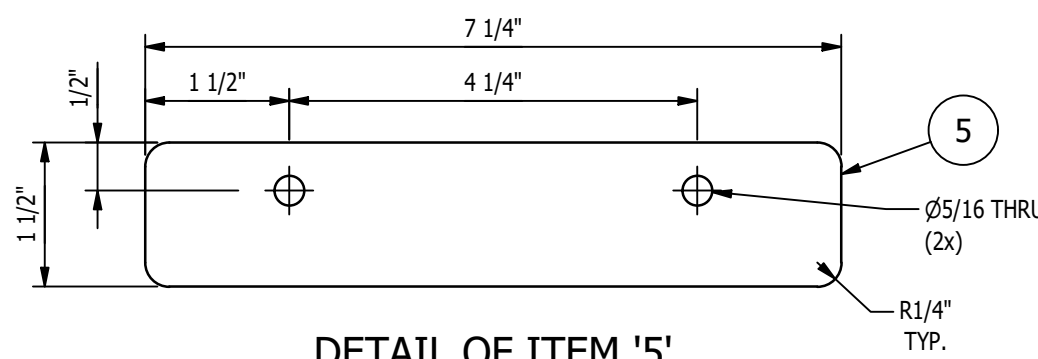
DETAIL OF ITEM '4'
SCALE 3"=1'-0"



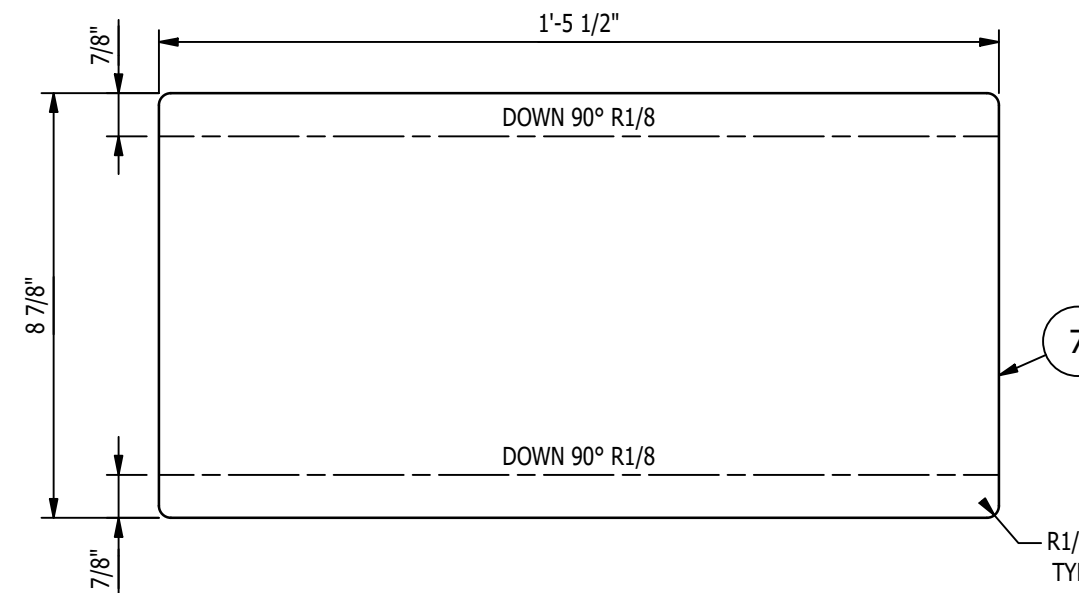
DETAIL OF ITEM '2'
SCALE 6"=1'-0"



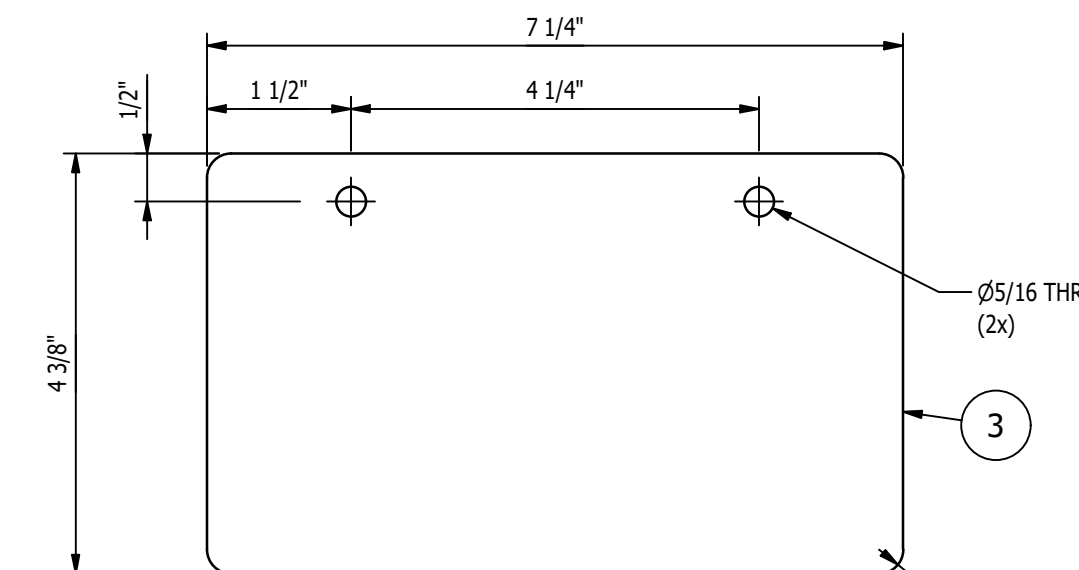
MK-D453C ~ DRIP PAN
SCALE 3"=1'-0"



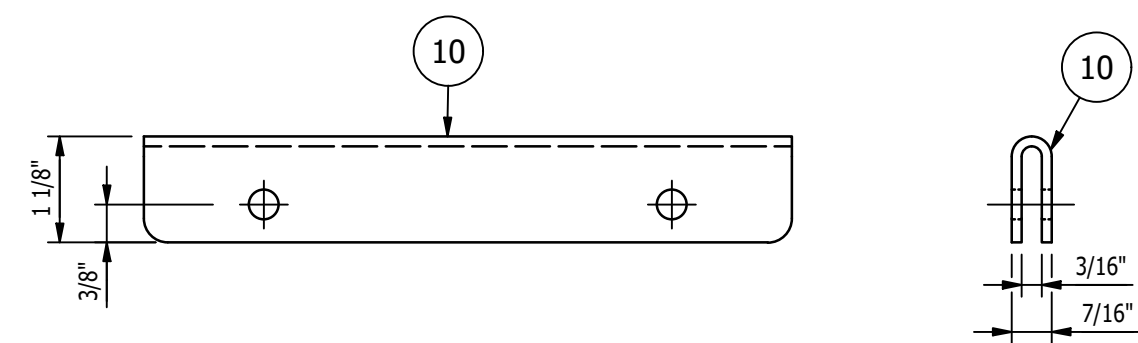
DETAIL OF ITEM '5'
SCALE 6"=1'-0"



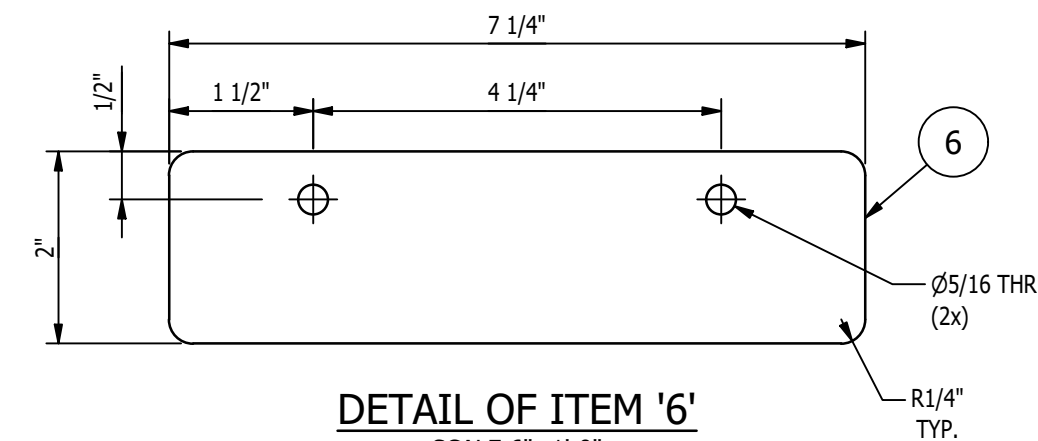
FLAT PATTERN OF ITEM '7'
SCALE 3"=1'-0"



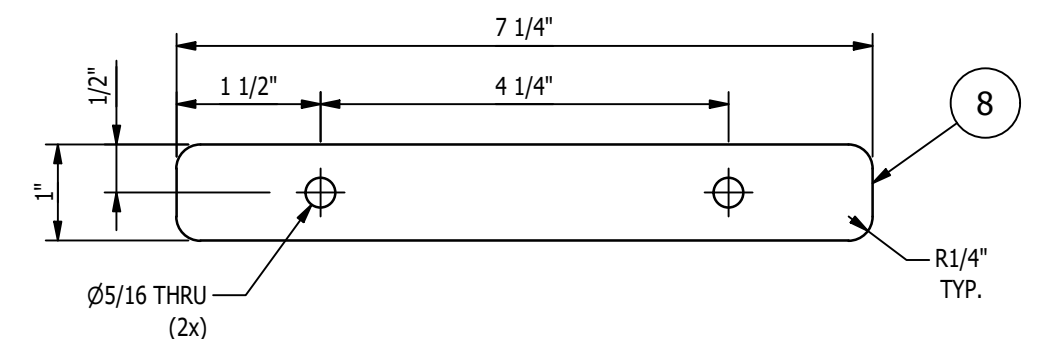
DETAIL OF ITEM '3'
SCALE 6"=1'-0"



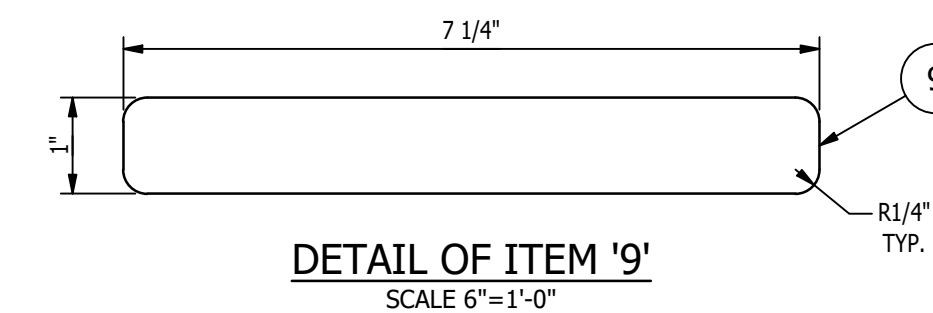
MK-D453D ~ DRIP PAN END COVER
SCALE 6"=1'-0"



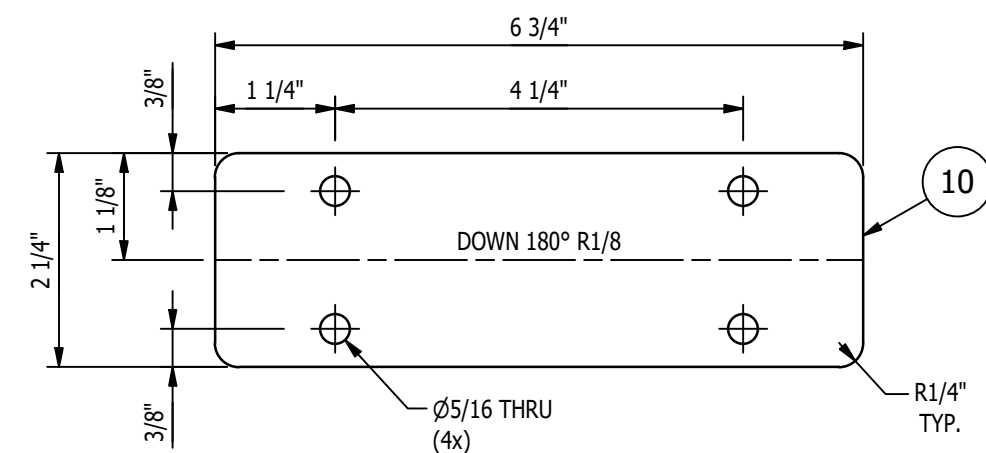
DETAIL OF ITEM '6'
SCALE 6"=1'-0"



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



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



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

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

REV	BY	DATE	DESCRIPTION	APP
A	MC	11/18/22	FOR FABRICATION	

REVISION HISTORY		DRAWN BY: RJB	
TITLE:	P6700 CONVEYORS CAMPUS BUILDING	CHECKED BY:	CW
CLIENT:	VOLVO	DWG DATE:	11/18/22
DRAWING No.	1875D453	REV:	A
		JOB No:	22096

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MAGNUM JOB #: 1875
MAGNUM DRAWING #: 1875D453 - 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.