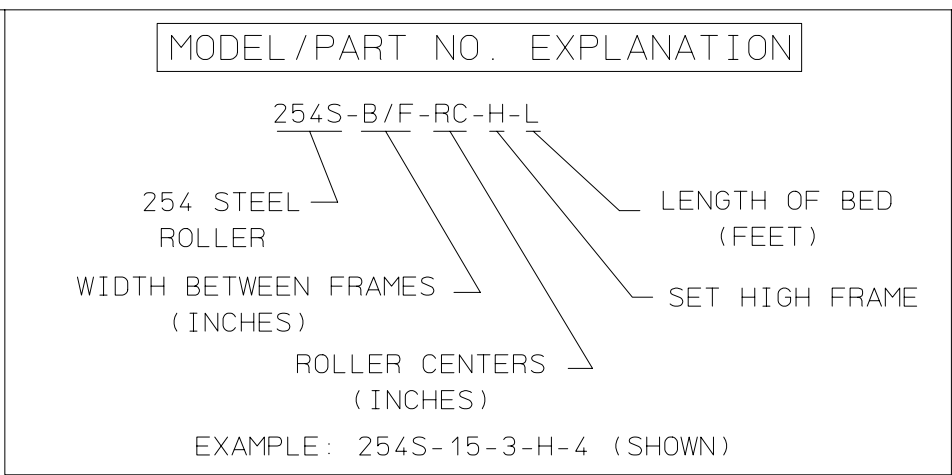


ITEM	QTY	DESCRIPTION	DWG. NO.	PART NO.
1	4	MODIFIED BOLT-IN BUTT COUPLING	GA-150	M01157
2	SEE CHART	254S ROLLER ASSEMBLY	PC-062	254S-BF-A
3	2	MEDIUM DUTY SIDE CHANNEL	GC-056	M00001-OAL
4	SEE CHART	FRAME CROSSBRACE	GC-1000	M00119-BF
5	SEE CHART	3/8" X 3/4" HHCS	P.P.	FSW00355
6	SEE CHART	3/8" NYLON INSERT FLANGE NUT	P.P.	FSW09304-02

QUANTITIES REQUIRED												
OAL												
ITEM	12"	24"	36"	48"	60"	72"	84"	96"	108"	120"	132"	144"
4	1	2	2	2	2	3	3	3	4	4	5	5
5	8	12	12	12	12	16	16	16	20	20	24	24
6	8	12	12	12	12	16	16	16	20	20	24	24

ROLLER QUANTITIES REQUIRED					
OAL	3" RC	4 1/2" RC	6" RC	9" RC	12" RC
12"	4	3	2	2	1
24"	8	6	4	3	2
36"	12	8	6	4	3
48"	16	11	8	6	4
60"	20	14	10	7	5
72"	24	16	12	8	6
84"	28	19	14	10	7
96"	32	22	16	11	8
108"	36	24	18	12	9
120"	40	27	20	14	10
132"	44	30	22	15	11
144"	48	33	24	16	12



TOLERANCES UNLESS NOTED:  
 FRACTIONAL ± 1/32  
 0.00 ± 0.03  
 0.000 ± 0.005  
 ANGLES ± 1°

ROACH MANUFACTURING CORPORATION  
 808 HWY 463 NORTH, TRUMANN ARKANSAS 72472

NEXT ASSEMBLY	TITLE	SCALE	DRAWN
-	254S GRAVITY ROLLER CONVEYOR ASS'Y (SET HIGH)	1/4"=1'	TCM
-	DATE	MATERIAL	PART NUMBER
-	7-26-91	NOTED	SEE EXPLANATION
DRAWING NUMBER			GC-089
REV	NEW ISSUE	#0 ERN-253	
REV	CHANGED PART NO'S	#1 ECN-1168	
REV	CHNGD ROLLER PART NUMBER	#2 ECN-1656	

MODEL: 254S

