

ITEM	QTY	DESCRIPTION	DWG #	PART #
1	2	HOOK STUD BOLT	P P	FSW08375
2	1	LIGHT DUTY HOOK (RH)	GA-022	MCW06266
3	1	LIGHT DUTY HOOK (LH)		MCW06267
4	4	5/16" X 3/4" HHCS	P P	FSW00255
5	6	5/16" FLANGE NUT	P P	FSW09204
6	2	LIGHT DUTY CHANNEL	GC-270	M005400-12
		12" OAL		M005400-18
		18" OAL		M005400-24
		24" OAL		M005400-30
		30" OAL		M005400-36
		36" OAL		M005400-48
		48" OAL		M005400-60
		60" OAL		M005400-72
		72" OAL		M005400-84
		84" OAL		M005400-96
		96" OAL		M005400-108
		108" OAL		M005400-120
		120" OAL		
7	SEE CHART	CROSSMEMBER 12" OAW	GB-038	S100220-10
		18" OAW		S100220-16
		24" OAW		S100220-22
8	SEE CHART	1/4"-20 INDENT HHCS	P P	FSW00180
		12" OAW (10 5/8" LG)		FSW00190
		18" OAW (16 5/8" LG)		FSW00195
		24" OAW (22 5/8" LG)		
9	SEE CHART	1/4"-20 HEX INDENT LOCK NUT	P P	FSW09102
10	SEE CHART	138A ROLLER ASS'Y	PB-413G	138A-BF-B
		138G ROLLER ASS'Y		138G-BF-A

OAL	ITEM# 10 ROLLER QUANTITIES REQUIRED													
	1	1/2	RC	3	RC	4	1/2	RC	6	RC	9	RC	12	RC
12"	8			4		3			2		2		1	
18"	12			6		4		3	2		2		2	
24"	16			8		6		4	3		2		2	
30"	20			10		7		5	4		3		2	
36"	24			12		8		6	4		3		2	
48"	32			16		11		8	6		4		2	
60"	40			20		14		10	7		5		2	
72"	48			24		16		12	8		6		2	
84"	56			28		19		14	10		7		2	
96"	64			32		22		16	11		8		2	
108"	72			36		24		18	12		9		2	
120"	80			40		27		20	14		10		2	

NOTE: 138P CONVEYORS REQUIRE 138G ROLLERS

NOTE:
1. IN PLACE OF (Ø) IN COMPONENT PART NUMBERS SPECIFY 'A' FOR ALUMINUM, 'G' FOR GALVANIZED STEEL, OR 'H' FOR HOT ROLL PAINTED STEEL.

ITEM	QUANTITIES REQUIRED											
	12"	18"	24"	30"	36"	48"	60"	72"	84"	96"	108"	120"
7	1	2	2	2	2	2	3	3	3	4	4	5
8	2	4	4	4	4	4	6	6	6	8	8	10
9	2	4	4	4	4	4	6	6	6	8	8	10

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

NEXT ASSEMBLY	DATE	MATERIAL	PART NUMBER
-	-	-	-
-	8-7-91	NOTED	SEE EXPLANATION

ROACH MANUFACTURING CORPORATION
808 HWY 463 NORTH, TRUMANN ARKANSAS 72472

TITLE	SCALE	DRAWN
138 GRAVITY ROLLER CONVEYOR ASSEMBLY	1/4"=1'	REEVES
DATE	PART NUMBER	DRAWING NUMBER
8-7-91	NOTED	GC-093

MODEL: 138A, 138G, 138P
SET-LOW

REV	ISSUE
#0	ERN-664
#1	CHANGED ROLLER ASSY. PART #'S ECD-1450
#2	CHANGED ROD TO HOOK STUD BOLT. OMITTED 3/8" HARDWARE. CHANGED SIDE CHANNEL PART #'S ECD-1526
#3	REPLACED 14 GA. (138H) W/ 12 GA. HRS PAINTED (138P) CHANGED CROSSMEMBER PART NO. TO -BF ECD-1629

