

ITEM	QTY	DESCRIPTION	DWG #	PART#
1	2	HOOK STUD BOLT		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-059	M003240-12
		12" OAL		M003240-12
		18" OAL		M003240-18
		24" OAL		M003240-24
		30" OAL		M003240-30
		36" OAL		M003240-36
		48" OAL		M003240-48
		60" OAL		M003240-60
		72" OAL		M003240-72
		84" OAL		M003240-84
		96" OAL		M003240-96
		108" OAL		M003240-108
		120" OAL		M003240-120
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)		FSW00195
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	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		
24"	16	8	6	4	3	2		
30"	20	10	7	5	4	3		
36"	24	12	8	6	4	3		
48"	32	16	11	8	6	4		
60"	40	20	14	10	7	5		
72"	48	24	16	12	8	6		
84"	56	28	19	14	10	7		
96"	64	32	22	16	11	8		
108"	72	36	24	18	12	9		
120"	80	40	27	20	14	10		

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	3	3	3	4	4	5	
8	2	4	4	4	4	6	6	6	8	8	10	
9	2	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°

ROACH MANUFACTURING CORPORATION

808 HWY 463 NORTH, TRUMANN ARKANSAS 72472

TITLE	138 GRAVITY ROLLER CONVEYOR ASSEMBLY	SCALE	1/4"=1'	DRAWN	REEVES
DATE	8-1-91	MATERIAL	NOTED	PART NUMBER	SEE EXPLANATION
				DRAWING NUMBER	GC-094

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

REV	NEW ISSUE	ECN-254
#1	CHANGED PART#'S.	ECN-1168
#2	CHANGED ROLLER ASSY. PART#'S	ECN-1450
#3	CHANGED ROD TO OMITTED 3/8" HARDWARE, CHANGED SIDE CHANNEL PART#'S	ECN-1526
#4	REPLACED 14 GA. HRS PAINTED MODEL (138H) W/ 12 GA. HRS PAINTED (138P) CHANGED CROSSMEMBER PART NO. TO -BF	ECN-1629

