

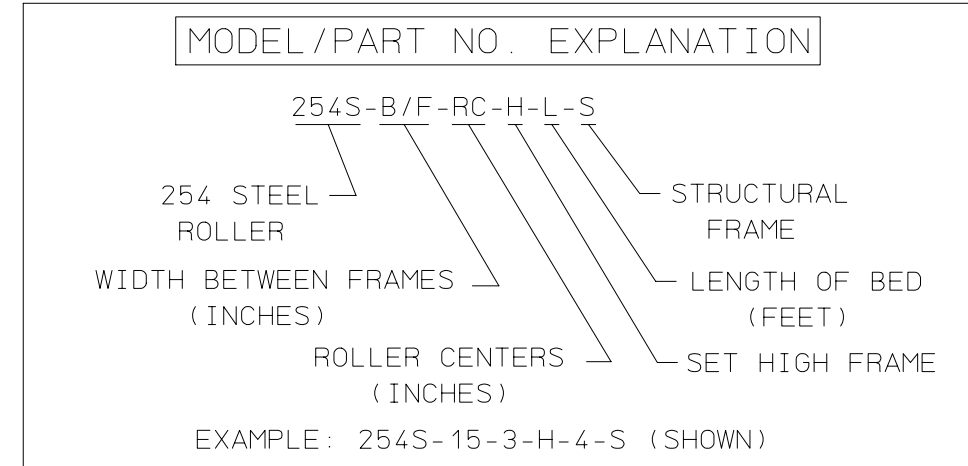
| ITEM | QUANTITY | DESCRIPTION | DWG. NO. | PART NUMBER | |
|------|-----------|-----------------------------|-----------|------------------|----------------|
| | | | | 3", 6", & 12" RC | 4 1/2" & 9" RC |
| 1 | 1 | 4" STRUC. FRAME WELD ASS'Y | GC-194 | | |
| | | 12" OAL WELD ASS'Y | | A25882-BF | A25912-BF |
| | | 24" OAL WELD ASS'Y | | A25883-BF | A25913-BF |
| | | 36" OAL WELD ASS'Y | | A25884-BF | A25914-BF |
| | | 48" OAL WELD ASS'Y | | A25885-BF | A25915-BF |
| | | 60" OAL WELD ASS'Y | | A25886-BF | A25916-BF |
| | | 72" OAL WELD ASS'Y | | A25887-BF | A25917-BF |
| | | 84" OAL WELD ASS'Y | | A25888-BF | A25918-BF |
| | | 96" OAL WELD ASS'Y | | A25889-BF | A25919-BF |
| | | 108" OAL WELD ASS'Y | | A25890-BF | A25920-BF |
| | | 120" OAL WELD ASS'Y | A25891-BF | A25921-BF | |
| * 2 | SEE CHART | 254S ROLLER ASSEMBLY | PC-062 | 254S-BF-A | |
| | | 254S PINNED ROLLER ASSEMBLY | PC-062A | 254S-BF-A-P | |
| * 3 | SEE CHART | 1/8" DIA X 1" LG COTTER PIN | P.P. | FSW09957-01 | |

* NOTES: 1. ROLLERS FOR 7" BF CONVEYOR ASS'Y'S WILL HAVE PINNED SHAFTS AND WILL REQUIRE A QTY. OF (2) OF ITEM #3 PER ROLLER.
 2. ROLLERS FOR 9" BF & ABOVE CONVEYOR ASS'Y'S WILL BE SPRING LOADED.

| | | | | |
|--|---|--|-----------------|----------------|
| 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 TCM | |
| - | 254S GRAVITY STRUCTURAL CONVEYOR ASS'Y (SET HIGH) | 1/4"=1' | APPROVED | |
| - | DATE | MATERIAL | PART NUMBER | DRAWING NUMBER |
| - | 8-16-91 | NOTED | SEE EXPLANATION | GC-288 |

MODEL: 254S

| | |
|--------|--|
| REV #0 | NEW ISSUE ERN-664 |
| REV #1 | ADDED PINNED ROLLER ASSY & COTTER PIN TO CHART. ADDED BF NOTES ECN-1411 |
| REV #2 | CHNGD ROLLER PART NUMBER ECN-1656 |



| QUANTITIES REQUIRED | | | | | | | |
|---------------------|------|-------|-----------|-------|-------|--------|--|
| OAL | ITEM | 3" RC | 4 1/2" RC | 6" RC | 9" RC | 12" RC | |
| 12" | 2 | 4 | 3 | 2 | 2 | 1 | |
| | 3 | 8 | 6 | 4 | 4 | 2 | |
| 24" | 2 | 8 | 6 | 4 | 3 | 2 | |
| | 3 | 16 | 12 | 8 | 6 | 4 | |
| 36" | 2 | 12 | 8 | 6 | 4 | 3 | |
| | 3 | 24 | 16 | 12 | 8 | 6 | |
| 48" | 2 | 16 | 11 | 8 | 6 | 4 | |
| | 3 | 32 | 22 | 16 | 12 | 8 | |
| 60" | 2 | 20 | 14 | 10 | 7 | 5 | |
| | 3 | 40 | 28 | 20 | 14 | 10 | |
| 72" | 2 | 24 | 16 | 12 | 8 | 6 | |
| | 3 | 48 | 32 | 24 | 16 | 12 | |
| 84" | 2 | 28 | 19 | 14 | 10 | 7 | |
| | 3 | 56 | 38 | 28 | 20 | 14 | |
| 96" | 2 | 32 | 22 | 16 | 11 | 8 | |
| | 3 | 64 | 44 | 32 | 22 | 16 | |
| 108" | 2 | 36 | 24 | 18 | 12 | 9 | |
| | 3 | 72 | 48 | 36 | 24 | 18 | |
| 120" | 2 | 40 | 27 | 20 | 14 | 10 | |
| | 3 | 80 | 54 | 40 | 28 | 20 | |

