

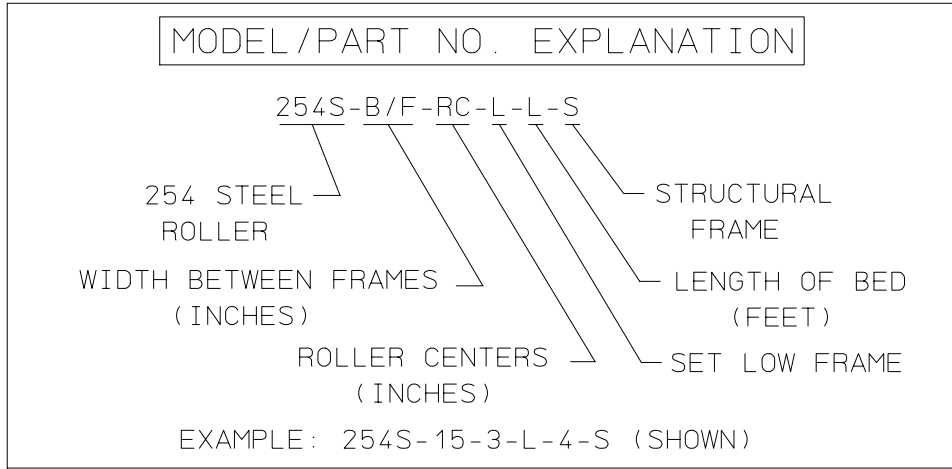
ITEM	QUANTITY	DESCRIPTION	DWG. NO.	PART NUMBER	
				3",6", & 12"RC	4 1/2" & 9"RC
1	1	4" STRUC. FRAME WELD ASS'Y	GC-209		
		12" OAL WELD ASS'Y		A25942-BF	A25972-BF
		24" OAL WELD ASS'Y		A25943-BF	A25973-BF
		36" OAL WELD ASS'Y		A25944-BF	A25974-BF
		48" OAL WELD ASS'Y		A25945-BF	A25975-BF
		60" OAL WELD ASS'Y		A25946-BF	A25976-BF
		72" OAL WELD ASS'Y		A25947-BF	A25977-BF
		84" OAL WELD ASS'Y		A25948-BF	A25978-BF
		96" OAL WELD ASS'Y		A25949-BF	A25979-BF
		108" OAL WELD ASS'Y		A25950-BF	A25980-BF
		120" OAL WELD ASS'Y		A25951-BF	A25981-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	

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

* NOTES: 1. ROLLERS FOR 7" & 9" BF CONVEYOR ASSY'S WILL HAVE PINNED SHAFTS AND WILL REQUIRE A QTY. OF (2) OF ITEM #3 PER ROLLER.
2. ROLLERS FOR 11" BF & ABOVE CONVEYOR ASSY'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			
		TITLE	254S GRAVITY STRUCTURAL CONVEYOR ASS'Y (SET LOW)	SCALE 1/4"=1'	DRAWN TCM
NEXT ASSEMBLY		DATE 8-16-91	MATERIAL NOTED	PART NUMBER SEE EXPLANATION	APPROVED
-	-				DRAWING NUMBER GC-289
-	-				

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

