

BILL OF MATERIAL MATERIAL FOR ONE					
A3 REQ'D	A2 REQ'D	A1 REQ'D	PART NO.	PART	MATERIAL
		X	1	COUCH ROLL ASSEMBLY	
		1	2	SHAFT END	C-1025 C.F. STL.
		1	3	SHAFTEND	C-1025 C.F. STL.
		1	4	THIN	COIL
	X	1	5	COUCH ROLLER SHELL	
		2	6	NUT	SEE DETAIL.
		2	7	GASKET	" "
		2	8	SLEEVE	DWG # 8186-2
		2	9	GREASE SEAL	NATIONAL # B1-355821-S
		2	10	SEAL HOUSING	DWG # 8186-4
		2	11	COVER PLATE	DWG # 8186-1
		2	12	BEARING	SKF ROLLER BRG. # N219
		1	13	OUTER SPACER	DWG # 8186-5
		1	14	BEARING	SKF BALL BRG # 6219
		12	15	CAP SCREWS	3/8"-16 X 1 1/2" LG. HEX. HDW/LOCURSHIER
		2	16	GREASE FITTING	LINK BELT # A1186 BUTTON HEAD
		1	17	INNER SPACER	DWG # 8186-3
		1	18	BRG. HOUSING	HRS C-1020
		1	19	TUBING	12 3/4 O.D. 1562 3.W. HRS.
		1	20	BRG. HOUSING	HRS C1020
		1	21	RUBBER COVER	(SEE NOTE NO 1)

NOTES:

1. RED NATURAL RUBBER DUROMETER READING 30-35 SHORE A
2. RUBBER HARDNESS MAY BE READ BY D.E.S. PLASTOMETER USING A 1/8" BALL - RANGE ALLOWED 200-240
3. CONCENTRICITY BETWEEN THE DIAMETERS INDICATED TO BE WITHIN .002 T.I.R.
4. COUCH ROLL ASSEMBLY TO BE STATICALLY BALANCED.
5. FOR PLANT 257 COUCH ROLL JOURNAL TO BE TURN DOWN TO $2.936 \pm .002$ DIA. (FOR OUTSIDE BR. DODGE 2 15/16 BORE DBL. INTERLOCK. SEE DWG. NO. 11012 REF.)

REF. ASSY. DWG. # 8152

APPROX. WT. TOTAL ROLL = 2200 #

58	B4	AMBLER No. 2 P/M	J.J.H	6-15-63	109
57			D.A.	10/11/60	111
PLANT No	J.S No	REF. DWG. & REMARKS	BY	DATE	EWA
S. A. No.	KEASBEY & MATTISON CO.		SYMBOL		
JOB No.	AMBLER, PA. CENTRAL ENGINEERING DEPARTMENT		EWA-411		
PLANT No. 7 HILLSBORO, TEXAS					
13" PIPE MACHINE COUCH ROLL ASSY & DETAILS					
DR. DA.	APP. CSE	CK. E. W.	APP. G. W. Z.	DATE 10/11/60	SCALE 3 W. 1 ET
THIS DRAWING IS THE PROPERTY OF AND MUST NOT BE USED IN ANY MANNER DETRIMENTAL TO KEASBEY & MATTISON CO. IT IS ONLY LOANED SUBJECT TO RECALL AT ANY TIME			PRINT ISSUED	ISSUE	
			DWG. No.	REV.	
			8179	D	

CTD028854