Chelsea PTO 732 Parts Manual

Pro Gear Chelsea 732 Series PTO parts manual to assist in identifying the parts for your Chelsea Power Take Off unit.

If you need any assistance identifying the correct Power Take Off unit for your truck and equipment, contact your Chelsea replacement part specialists at Pro Gear and Transmission.

Pro Gear stocks every part for your Parker Chelsea PTO including: PTO housings, mounts, driveshafts, gears, bearings, gaskets, cable shift cover assembly, post and plate assembly, brackets, stud kits, seal kits, lever control assembly, air shift cover assembly, direct mount pump conversion kits, stud kits including English and metric references, CAT D&H parts and much more.

Pro Gear Transmission has same day shipping and 1000’s of products in stock and ready to ship internationally for your next project.

For parts or service contact the Chelsea specialists at Pro Gear & Transmission, Inc.

1 (877) 776-4600
(407) 872-1901
parts@eprogear.com

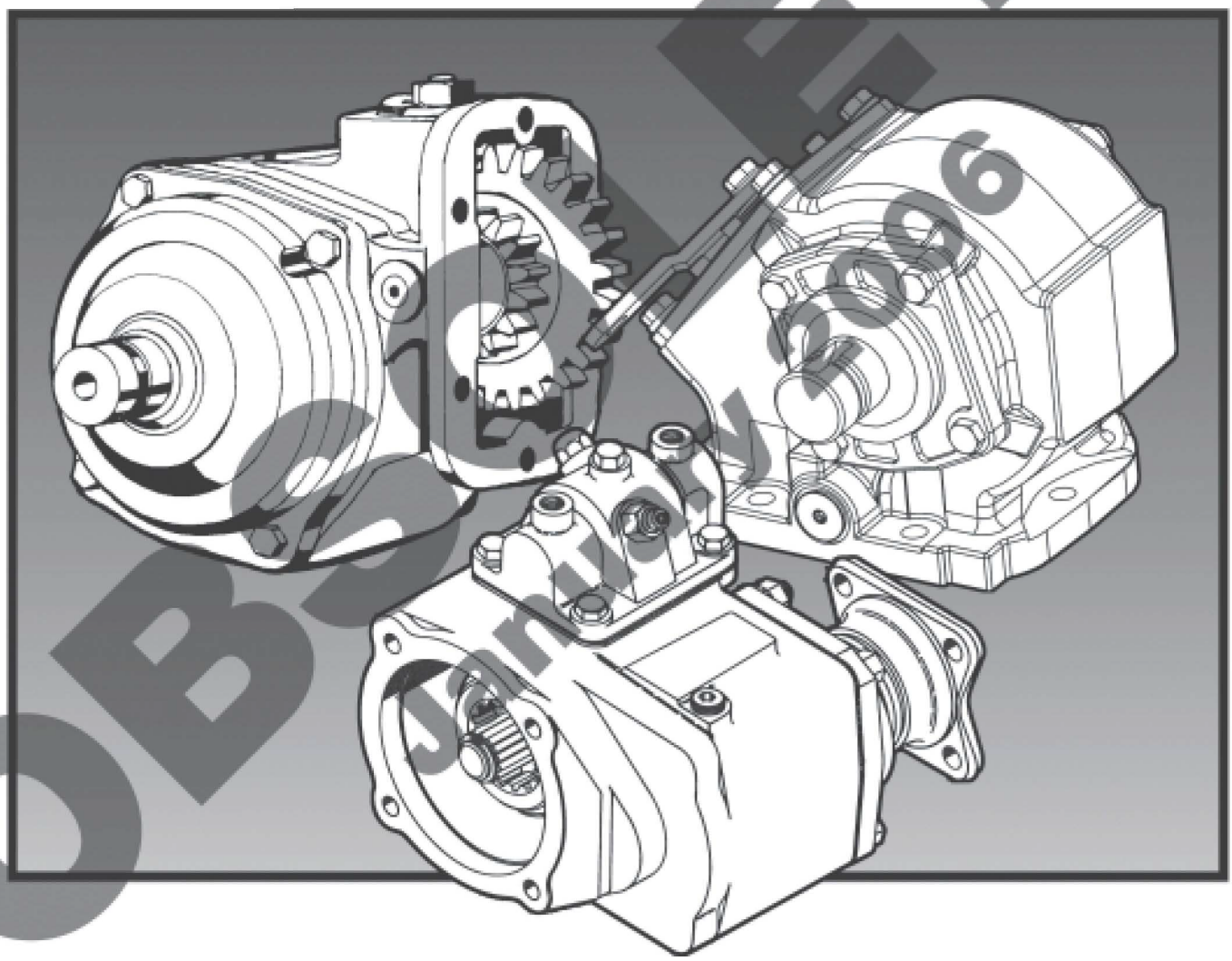
ProGear AND TRANSMISSION
CLICK TO RETURN TO SITE

CHELSEA®

Replacement Parts List
732 Series Manual

Bulletin [illegible]732-M[illegible]/US
March 15, 2002
Supersedes: P410-732 Dated October 1999

OBSOLETE
January 2006



Parker

⚠ WARNING

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This document and other information from Parker Hannifin Corporation, its subsidiaries and authorized distributors provide product and/or system options for further investigation by users having technical expertise. It is important that you analyze all aspects of your application and review the information concerning the product or system in the current product catalog. Due to the variety of operating conditions and applications for these products or systems, the user, through its own analysis and testing, is solely responsible for making the final selection of the products and systems and assuring that all performance, safety and warning requirements of the application are met.

The products described herein, including without limitation, product features, specifications, designs, availability and pricing, are subject to change by Parker Hannifin Corporation and its subsidiaries at any time without notice.

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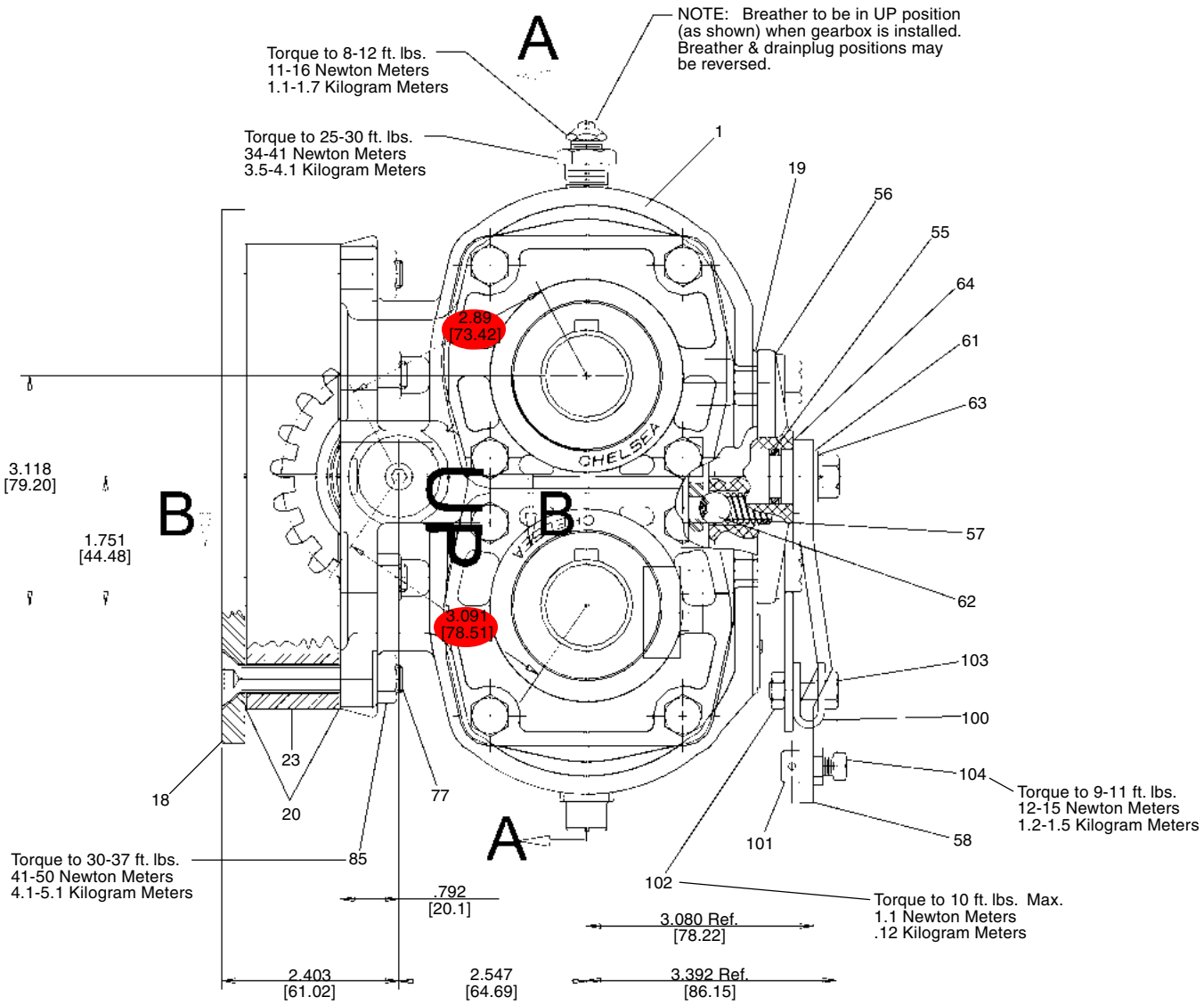
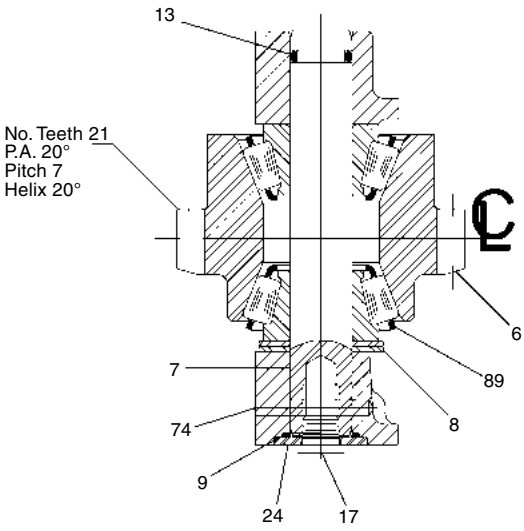
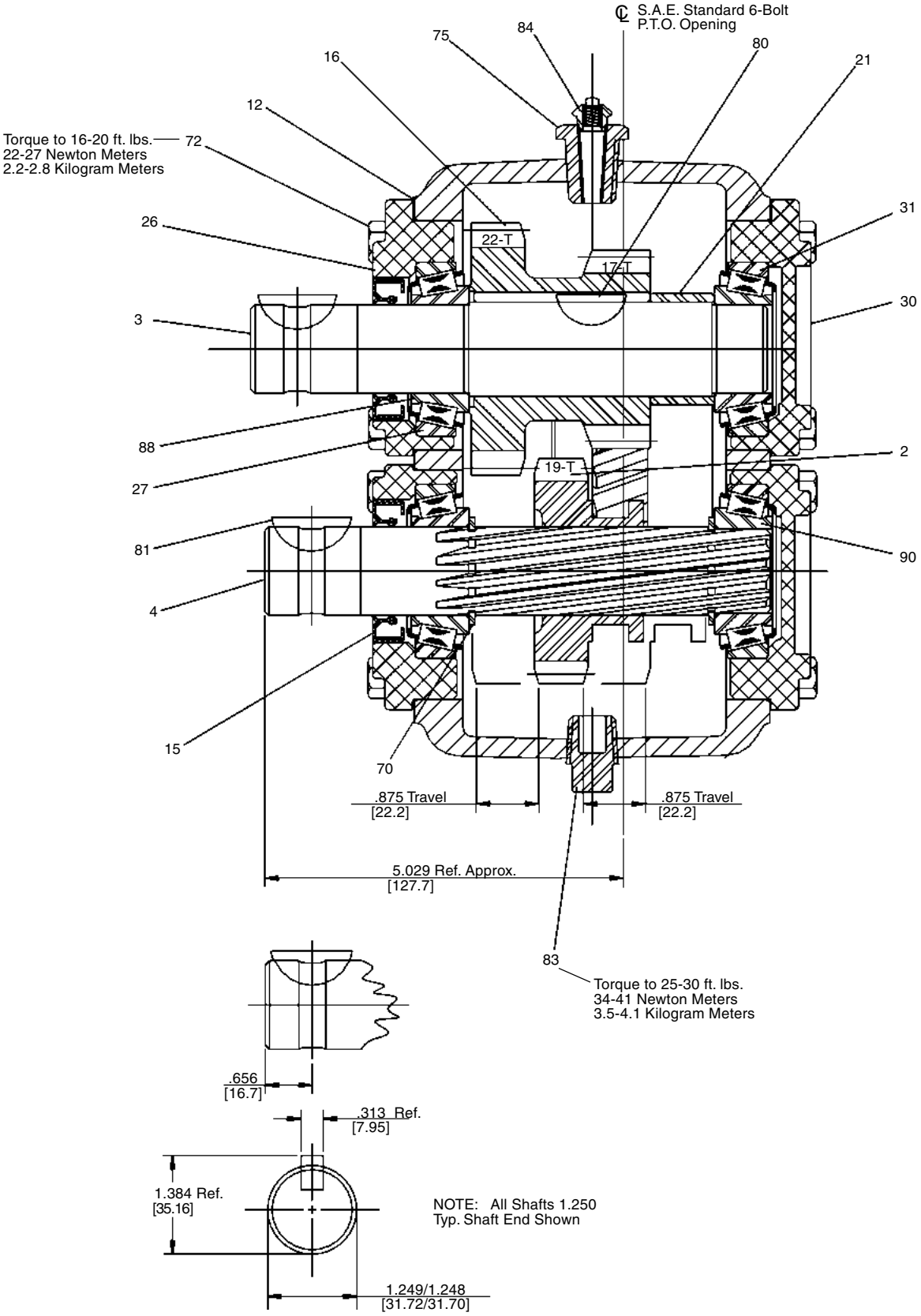

NOTE: Breather to be in UP position (as shown) when gearbox is installed. Breather & drainplug positions may be reversed.
Torque to 8-12 ft. lbs.
11-16 Newton Meters
1.1-1.7 Kilogram Meters
Torque to 25-30 ft. lbs.
34-41 Newton Meters
3.5-4.1 Kilogram Meters
A
B
1
19
56
55
64
61
63
57
62
103
100
104
58
101
102
2.89
[73.42]
3.091
[78.51]
3.118
[79.20]
1.751
[44.48]
23
20
18
77
85
Torque to 30-37 ft. lbs.
41-50 Newton Meters
4.1-5.1 Kilogram Meters
Torque to 9-11 ft. lbs.
12-15 Newton Meters
1.2-1.5 Kilogram Meters
Torque to 10 ft. lbs. Max.
1.1 Newton Meters
.12 Kilogram Meters
.792
[20.1]
3.080 Ref.
[78.22]
2.403
[61.02]
2.547
[64.69]
3.392 Ref.
[86.15]


13
No. Teeth 21
P.A. 20°
Pitch 7
Helix 20°
P.T.O. Opening
6
89
8
7
74
9
24
17

Section B-B

Section A-A

Ref. Assembly 3 Shown



Item		Part Number	Description	Quantity
1		1-P-524	Housing, Gearbox	1
2	▶	2-P-721	Gear, Sliding (19-T)	1
3	▶	3-P-315	Drive Shaft STD. (1.250" Dia. Input)	1
4	▶	3-P-859	Drive Shaft STD. (1.250" Dia. Output)	1
6		5-P-220	Gear, Idler	1
7	▶	9-P-74	Shaft, Idler	1
8	▶	14-P-15	Spacer, Idler Gear	1
9	▶	28-P-190	O-Ring	1
12		22-P-24-1	Gasket, Bearing Cap (.010" Thick)	A/R
		22-P-24-2	Gasket, Bearing Cap (.020" Thick)	A/R
		22-P-24-3	Gasket, Bearing Cap (.015" Thick)	A/R
13	▶	28-P-191	O-Ring	1
15	▶	28-P-216	Oil Seal	2
16	▶	33-P-64	Gear, Reverse Idler	1
17	▶	379484	O-Ring Boss Plug	1
18		34-P-18	Cover Plate	1
19	▶	35-P-8	Gasket, Shifter Cover (.020" Thick)	1
20		35-P-9-2	Gasket, (.020" Thick)	1
21	▶	40-P-4	Spacer, Reverse Idler Gear	2
22	▶	68-P-2	Name Plate (Chelsea)	1
23		7-A-1250	Spacer	1
24	▶	379542	Retainer O-Ring	1
	▶	328273X	Bearing Cap Sub-Assembly, Open (Includes Items 26 & 27)	
26		21-P-418	Bearing Cap	1
27	▶	550221	Bearing Cup	1
	▶	328274X	Bearing Cap Sub-Assembly, Closed (Includes Items 30 & 31)	
30		21-P-420	Bearing Cap	1
31	▶	550221	Bearing Cup	1
49	▶	378430-8	Capscrew, Hex Head (.312"-18 x .75")	4
70	▶	378391	Retaining Ring	2
71	▶	378422	Drive Screw	2
72	▶	378430-10	Capscrew, Hex Head (.312"-18 x 1.000")	16
74	▶	500597-16	Roll Pin (Standard Mount)	1
75		379131-4	Reducer Bushing	1
77		379212-2	Capscrew, Flat Head Hex Socket (.375"-16 x 2.500") (with Patch)	6
78	▶	379334	Oil Level Caution Tag (Ship Wired to Unit)	1
80	▶	500007-24	Woodruff Key (Ref. Input Shaft)	1
81	▶	500007-29	Woodruff Key (.312" x 1.125")	2
83		500114-3	Pipe Plug (.500"-14)	1
84		500167-1	Pressure Relief Fitting	1
85	▶	500370-3	Nut, Hex (.375"-16)	6
88	▶	550397	Bearing Cone, Tapered	3
90	▶	550532	Bearing Cone, Tapered	1
	▶	328380X	Wire Control Parts Bag (Includes Items 99 thru 104)	
99	▶	50-P-17	Bracket	1
100	▶	50-P-19	Bracket, Swivel	1
101	▶	378019	Pivot Pin	1
102	▶	378326	Nut, Hex Bushing	1
103	▶	500396-8	Screw, Hex Head (.250"-20 x .750")	1
104	▶	500568-4	Set Screw, Square Head (.250"-20 x .500")	1
		328751X	Installation Kit, Wire or Lever Control	1

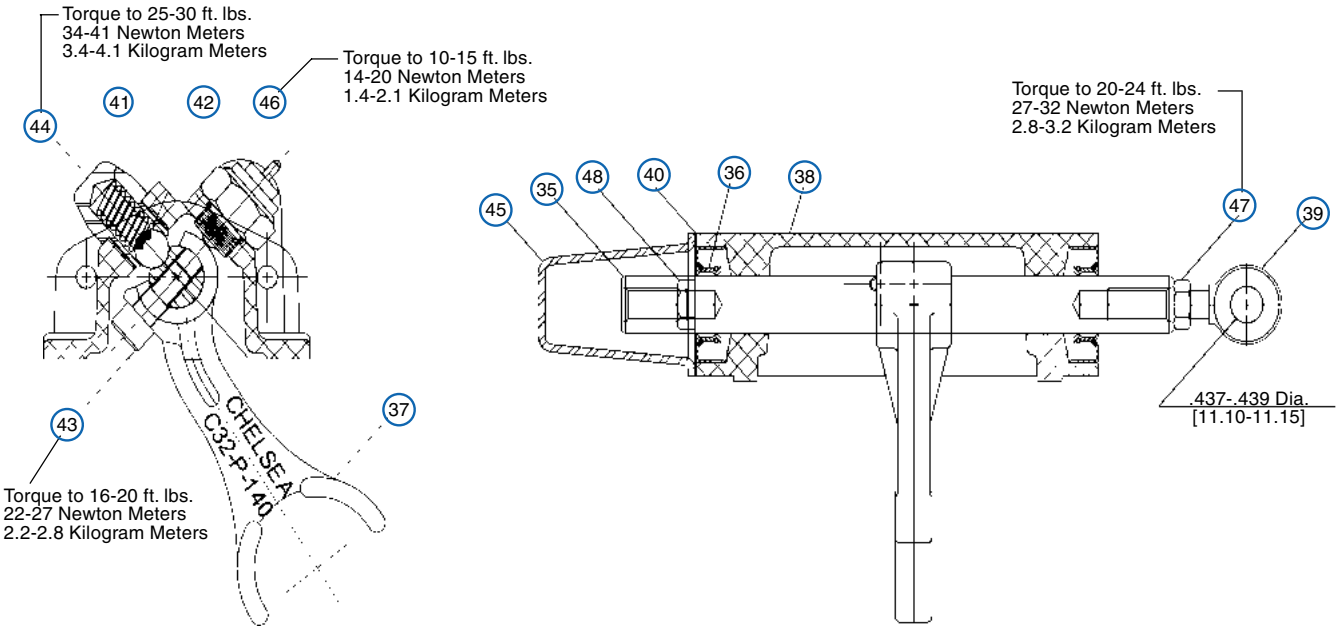
A.R. — As Required

HY25-2732-M1/US

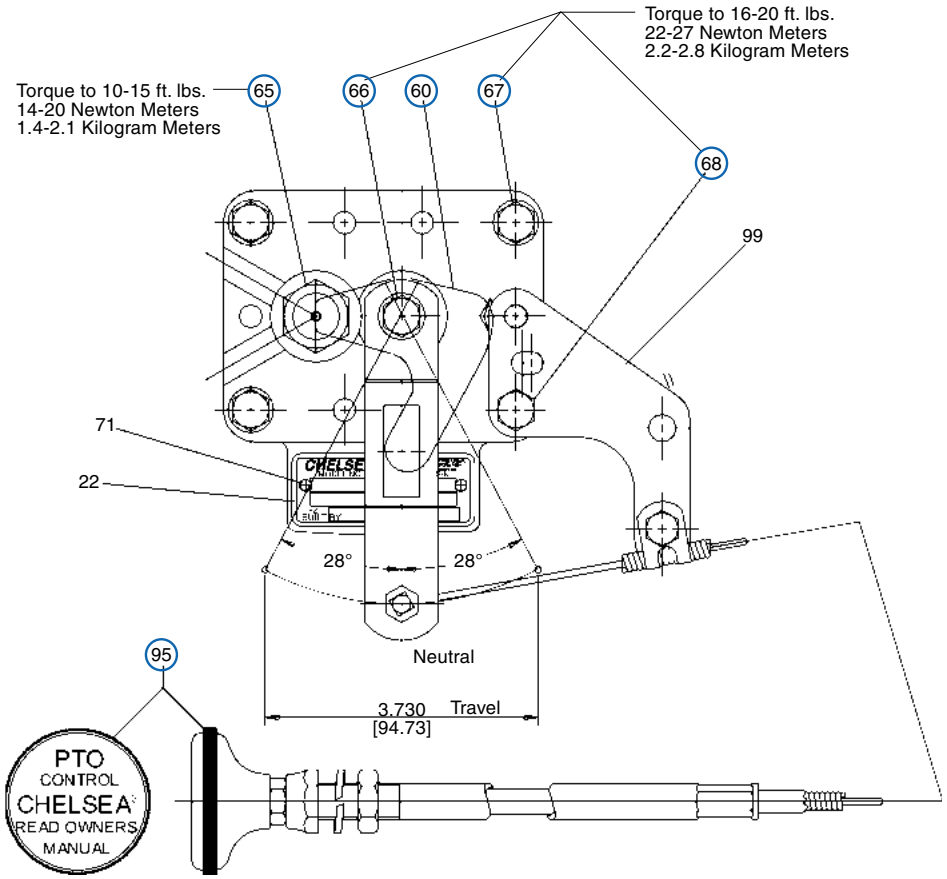
Lever Control

Power Take-Off

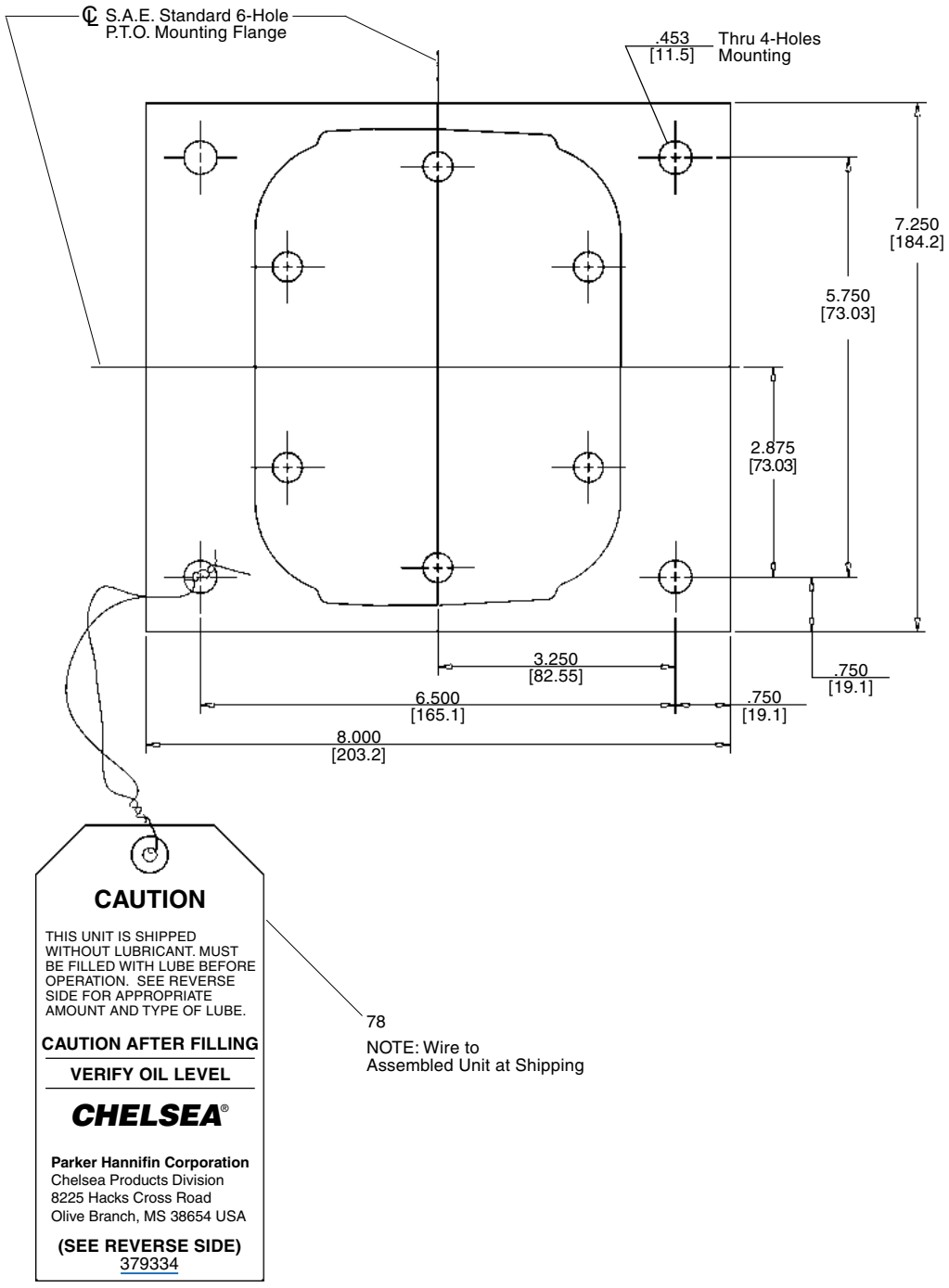
732 Series



Item	Part Number	Description	Quantity
▶	**328825-1X**	**LEVER CONTROL ASSEMBLY** (Includes Items 35-48)	
35 ▶	**11-P-129**	Shaft, Shifter	1
36 ▶	**28-P-207**	Oil Seal	2
37 ▶	**32-P-141**	Shifter Fork	1
38 ▶	**34-P-82**	Cover, Shifter	1
39 ▶	**36-P-1**	Eye Bolt (.375"-24)	1
40 ▶	**35-P-14**	Gasket	1
41 ▶	**37-P-14**	Spring	1
42 ▶	**378002**	Ball/Poppet	1
43 ▶	**378447-4**	Capscrew, Socket Head (.312"-18 x .75")	1
44 ▶	**378554**	Cap, Poppet	1
45 ▶	**65-P-23**	Cover, Shifter Shaft	1
46 ▶	**379652**	Indicator Switch (Norm “ON”)	1
47 ▶	**500381-3**	Nut, Hex (.375"-24)	1
48 ▶	**378430-4**	Capscrew, Hex Head	2



Item	Part Number	Description	Quantity
▶	**328830-1X**	**WIRE CONTROL SHIFT COVER SUB-ASSEMBLY** (Included Items 55 thru 66)	1
55 ▶	**28-P-191**	O-Ring	1
56 ▶	**34-P-74**	Cover, Shifter	1
57 ▶	**37-P-14**	Spring, Poppet	1
58 ▶	**51-P-13**	Lever, Shifter	1
60 ▶	**328829-1X**	Plate Assembly, Shifter	1
61 ▶	**500365-22**	Washer, Flat	1
62 ▶	**378002**	Ball (.438" Dia.)	1
63 ▶	**500356-10**	Lockwasher	1
64 ▶	**378004**	Washer, Flat	1
65 ▶	**379652**	Indicator Switch (Norm “ON”)	1
66 ▶	**500409-6**	Capscrew, Hex Head (.312"-24 x .625")	1
67 ▶	**378430-8**	Capscrew, Hex Head (.312"-18 x .750")	3
68 ▶	**378430-9**	Capscrew, Hex Head (.312"-18 x .875")	1
95 ▶	**328346-10X**	Cable Control Assembly	1
▶	**328380X**	Parts Bag, Wire Control	1


℄ S.A.E. Standard 6-Hole
P.T.O. Mounting Flange
.453
[11.5]
Thru 4-Holes
Mounting
7.250
[184.2]
5.750
[73.03]
2.875
[73.03]
3.250
[82.55]
6.500
[165.1]
8.000
[203.2]
.750
[19.1]
.750
[19.1]
CAUTION
THIS UNIT IS SHIPPED WITHOUT LUBRICANT. MUST BE FILLED WITH LUBE BEFORE OPERATION. SEE REVERSE SIDE FOR APPROPRIATE AMOUNT AND TYPE OF LUBE.
CAUTION AFTER FILLING
VERIFY OIL LEVEL
CHELSEA®
Parker Hannifin Corporation
Chelsea Products Division
8225 Hacks Cross Road
Olive Branch, MS 38654 USA
(SEE REVERSE SIDE)
379334
78
NOTE: Wire to
Assembled Unit at Shipping

Model Number Designation

732 Series

732 W – G XD D

Basic Model
732

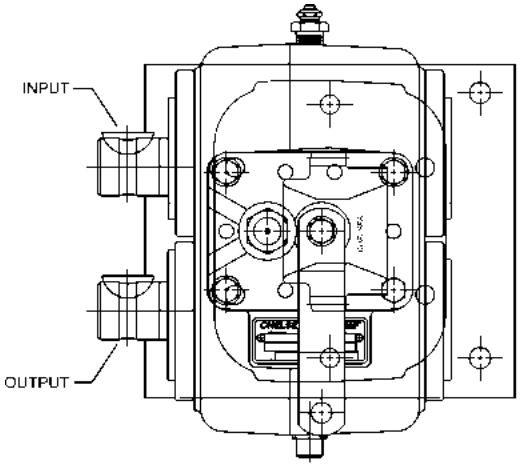
Shifter Type
W = Cable
Y = Lever

Assembly Arrangement
G, H, J, K

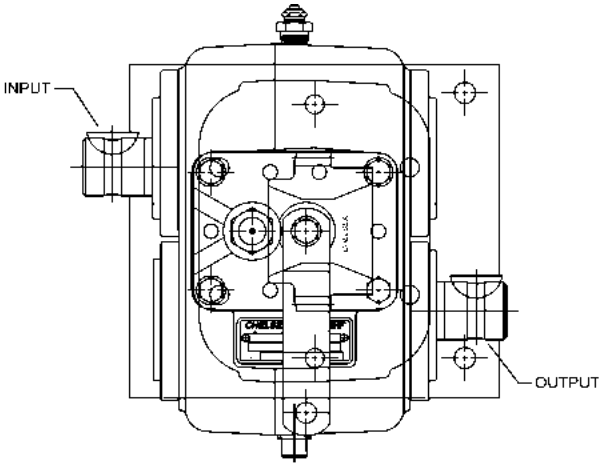
Input-Output Shaft
D = 1.250" Round

Output Shaft
XD = 1.250" Round

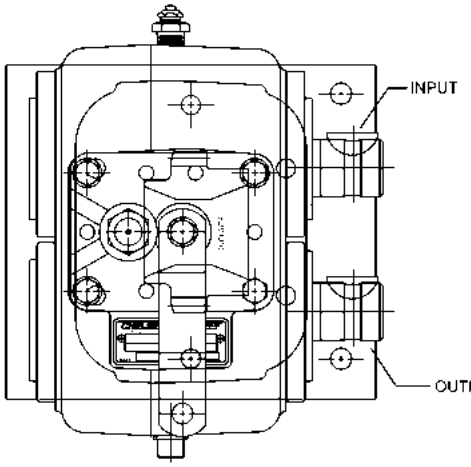
Assembly Arrangements



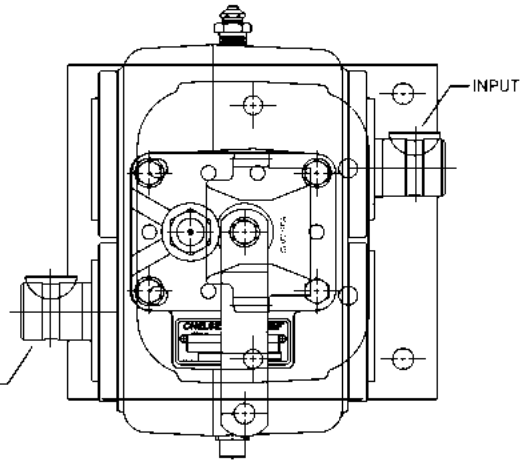
Ass'y G



Ass'y H



Ass'y J



Ass'y K

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2. Payment: Payment shall be made by Buyer net 30 days from the date of delivery of the items purchased hereunder. Amounts not timely paid shall bear interest at the maximum rate permitted by law for each month or portion thereof that the Buyer is late in making payment. Any claims by Buyer for omissions or shortages in a shipment shall be waived unless Seller receives notice thereof within 30 days after Buyer's receipt of the shipment.

3. Delivery: Unless otherwise provided on the face hereof, delivery shall be made F.O.B. Seller's plant. Regardless of the method of delivery, however, risk of loss shall pass to Buyer upon Seller's delivery to a carrier. Any delivery dates shown are approximate only and Seller shall have no liability for any delays in delivery.

4. Warranty: Seller warrants that the items sold hereunder shall be free from defects in material or workmanship for a period of:

(A) All Power Take-Off units one (1) year from date of installation.

(B) Except 267, 277, 278, 242, 244, 246, 250, 251 and 859 series two (2) years from date of installation. **THIS WARRANTY COMPRISES THE SOLE AND ENTIRE WARRANTY PERTAINING TO ITEMS PROVIDED HEREUNDER. SELLER MAKES NO OTHER WARRANTY, GUARANTEE, OR REPRESENTATION OF ANY KIND WHATSOEVER. ALL OTHER WARRANTIES, INCLUDING BUT NOT LIMITED TO, MERCHANTABILITY AND FITNESS FOR PURPOSE, WHETHER EXPRESS, IMPLIED, OR ARISING BY OPERATION OF LAW, TRADE USAGE, OR COURSE OF DEALING ARE HEREBY DISCLAIMED. NOTWITHSTANDING THE FOREGOING, THERE ARE NO WARRANTIES WHATSOEVER ON ITEMS BUILT OR ACQUIRED WHOLLY OR PARTIALLY, TO BUYER'S DESIGNS OR SPECIFICATIONS.**

5. Limitation Of Remedy: SELLER'S LIABILITY ARISING FROM OR IN ANY WAY CONNECTED WITH THE ITEMS SOLD OR THIS CONTRACT SHALL BE LIMITED EXCLUSIVELY TO REPAIR OR REPLACEMENT OF THE ITEMS SOLD OR REFUND OF THE PURCHASE PRICE PAID BY BUYER, AT SELLER'S SOLE OPTION. IN NO EVENT SHALL SELLER BE LIABLE FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES OF ANY KIND OR NATURE WHATSOEVER, INCLUDING BUT NOT LIMITED TO LOST PROFITS ARISING FROM OR IN ANY WAY CONNECTED WITH THIS AGREEMENT OR ITEMS SOLD HEREUNDER, WHETHER ALLEGED TO ARISE FROM BREACH OF CONTRACT, EXPRESS OR IMPLIED WARRANTY, OR IN TORT, INCLUDING WITHOUT LIMITATION, NEGLIGENCE, FAILURE TO WARN OR STRICT LIABILITY.

6. Changes, Reschedules and Cancellations: Buyer may request to modify the designs or specifications for the items sold hereunder as well as the quantities and delivery dates thereof, or may request to cancel all or part of this order, however, no such requested modification or cancellation shall become part of the contract between Buyer and Seller unless accepted by Seller in a written amendment to this Agreement. Acceptance of any such requested modification or cancellation shall be at Seller's discretion, and shall be upon such terms and conditions as Seller may require.

7. Special Tooling: A tooling charge may be imposed for any special tooling, including without limitation, dies, fixtures, molds and patterns, acquired to manufacture items sold pursuant to this contract. Such special tooling shall be and remain Seller's property notwithstanding payment of any charges by Buyer. In no event will Buyer acquire any interest in apparatus belonging to Seller which is utilized in the manufacture of the items sold hereunder, even if such apparatus has been specially converted or adapted for such manufacture and notwithstanding any charges paid by Buyer. Unless otherwise agreed, Seller shall have the right to alter, discard or otherwise dispose of any special tooling or other property in its sole discretion at any time.

8. Buyer's Property: Any designs, tools, patterns, materials, drawings, confidential information or equipment furnished by Buyer or any other items which become Buyer's property, may be considered obsolete and may be destroyed by Seller after two (2) consecutive years have elapsed without Buyer placing an order for the items which are manufactured using such property, Seller shall not be responsible for any loss or damage to such property while it is in Seller's possession or control.

9. Taxes: Unless otherwise indicated on the face hereof, all prices and charges are exclusive of excise, sales, use, property, occupational or like taxes which may be imposed by any taxing authority upon the manufacture, sale or delivery of the items sold hereunder. If any such taxes must be paid by Seller or if Seller is liable for the collection of such tax, the amount thereof shall be in addition to the amounts for the items sold. Buyer agrees to pay all such taxes or to reimburse Seller therefore upon receipt of its invoice. If Buyer claims exemption from any sales, use or other tax imposed by any taxing authority, Buyer shall save Seller harmless from and against any such tax, together with any interest or penalties thereon which may be assessed if the items are held to be taxable.

10. Indemnity For Infringement of Intellectual Property Rights: Seller shall have no liability for infringement of any patents, trademarks, copyrights, trade dress, trade secrets or similar rights except as provided in this Part 10. Seller will defend and indemnify Buyer against allegations of infringement of U.S. Patents, U.S. Trademarks, copyrights, trade dress and trade secrets (hereinafter 'Intellectual Property Rights'). Seller will defend at its expense and will pay the cost of any settlement or damages awarded in an action brought against Buyer based on an allegation that an item sold pursuant to this contract infringes the Intellectual Property Rights of a third party. Seller's obligation to defend and indemnify Buyer is contingent on Buyer notifying Seller within ten (10) days after Buyer becomes aware of such allegations of infringement, and Seller having sole control over the defense of any allegations or actions including all negotiations for settlement or compromise. If an item sold hereunder is subject to a claim that it infringes the Intellectual Property Rights of a third party, Seller may, at its sole expense and option, procure for Buyer the right to continue using said item, replace or modify said item so as to make it noninfringing, or offer to accept return of said item and return the purchase price less a reasonable allowance for depreciation. Notwithstanding the foregoing, Seller shall have no liability for claims of infringement based on information provided by Buyer, or directed to items delivered hereunder for which the designs are specified in whole or part by Buyer, or infringements resulting from the modification, combination or use in a system of any item sold hereunder. The foregoing provisions of this Part 10 shall constitute Seller's sole and exclusive liability and Buyer's sole and exclusive remedy for infringement of Intellectual Property Rights.

If a claim is based on information provided by Buyer or if the design for an item delivered hereunder is specified in whole or in part by Buyer, Buyer shall defend and indemnify Seller for all costs, expenses or judgments resulting from any claim that such item infringes any patent, trademark, copyright, trade dress, trade secret or any similar right.

11. Force Majeure: Seller does not assume the risk of and shall not be liable for delay or failure to perform any of Seller's obligations by reason of circumstances beyond the reasonable control of Seller (hereinafter 'Events of Force Majeure'). Events of Force Majeure shall include without limitation, accidents, acts of God, strikes or labor disputes, acts, laws, rules or regulations of any government or government agency, fires, floods, delays or failures in delivery of carriers or suppliers, shortages of materials and any other cause beyond Seller's control.

12. Entire Agreement/Governing Law: The terms and conditions set forth herein, together with any amendments, modifications and any different terms or conditions expressly accepted by Seller in writing, shall constitute the entire Agreement concerning the items sold, and there are no oral or other representations or agreements which pertain there/to. This Agreement shall be governed in all respects by the law of the State of Ohio. No actions arising out of the sale of the items sold hereunder or this Agreement may be brought by either party more than two (2) years after the cause of action accrues.

9/01-P