

## Chelsea PTO 438 Parts Manual

Pro Gear Chelsea 438 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



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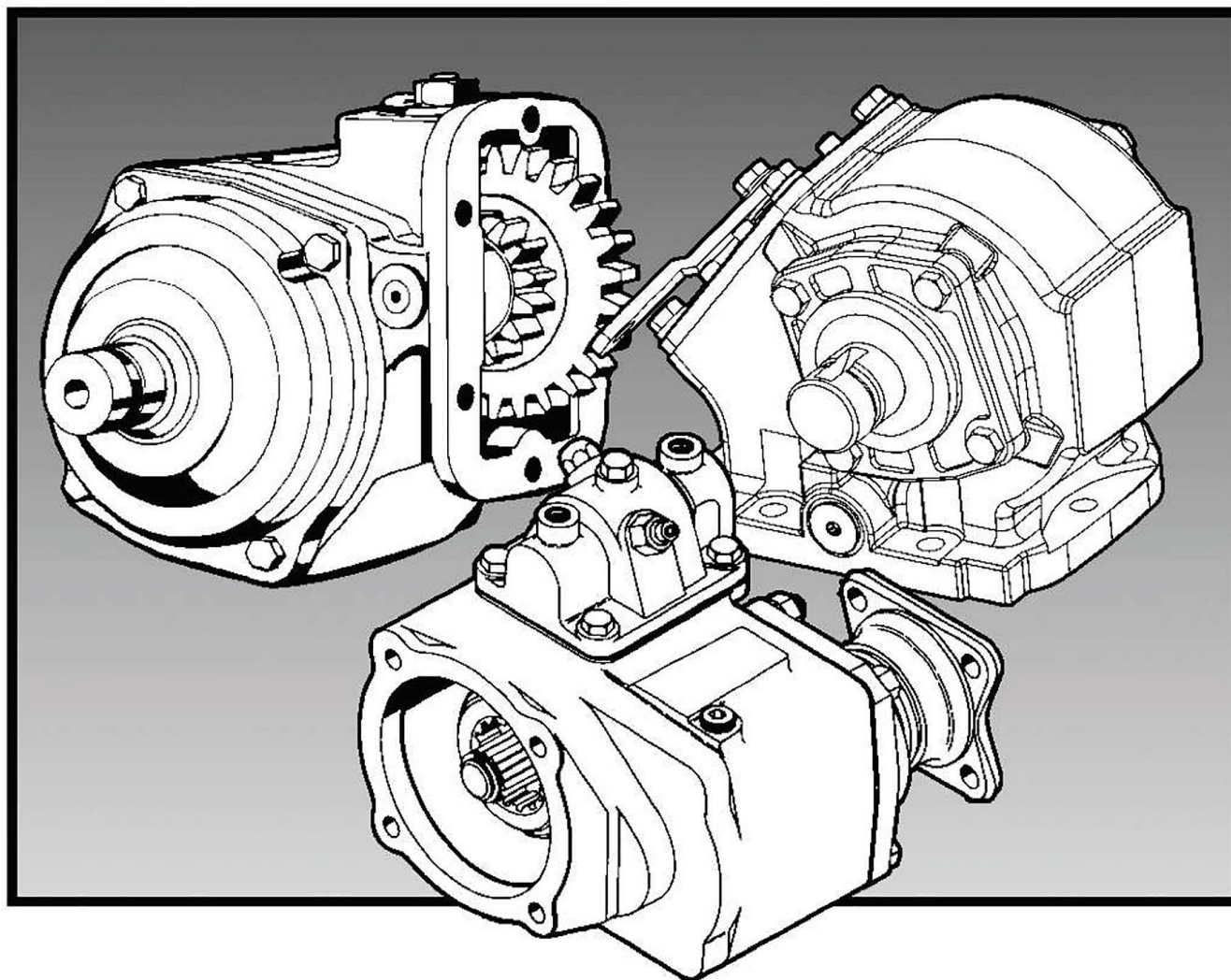
Bulletin HY25-2438-M1/US

# **CHELSEA<sup>®</sup>**

## **Replacement Parts List**

### **438 Series Manual**

Effective: December 15, 2001  
Supersedes: P410-438 Dated July 1994



# **Parker**





## **WARNING**

FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS AND/OR SYSTEMS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.

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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.

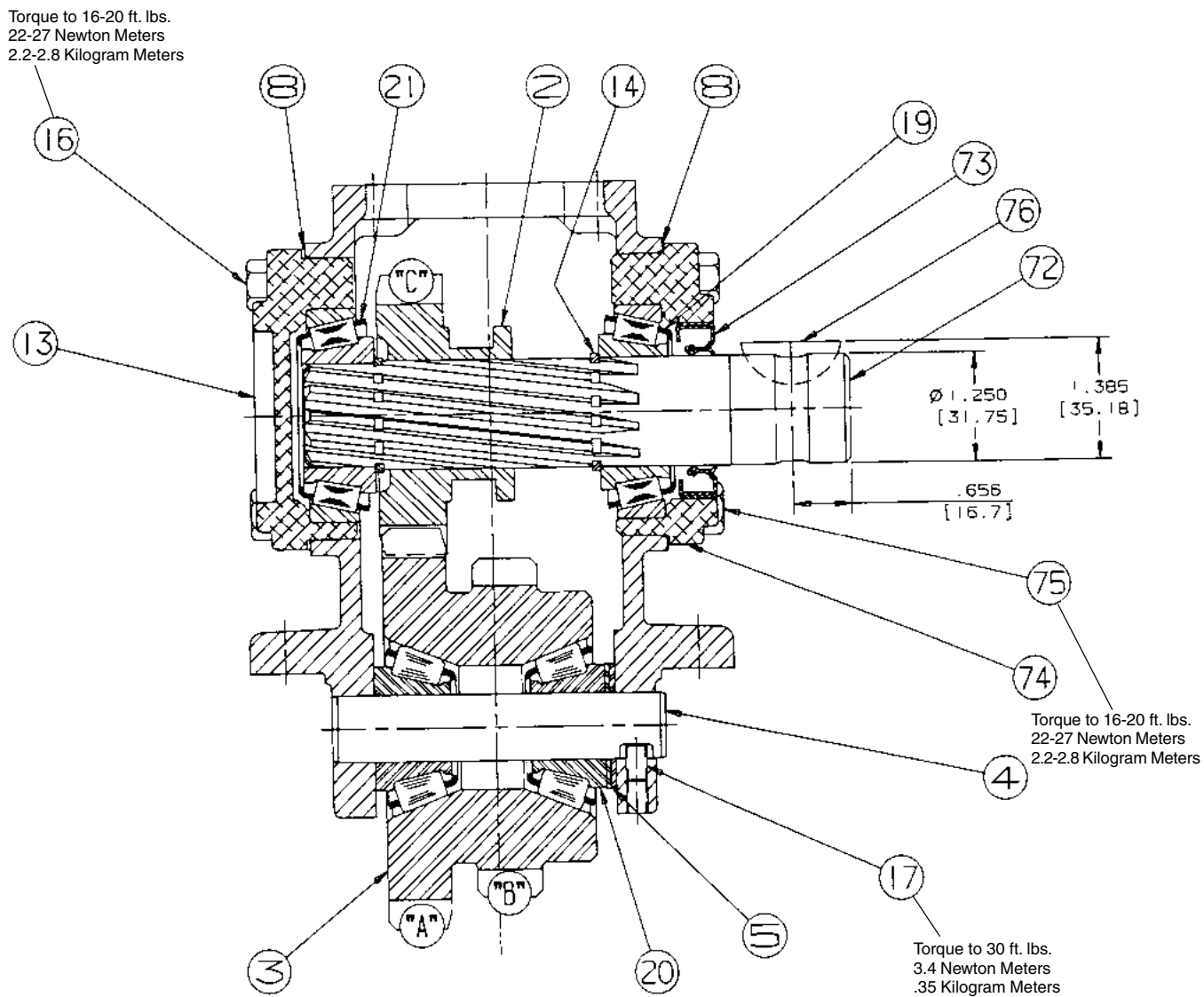
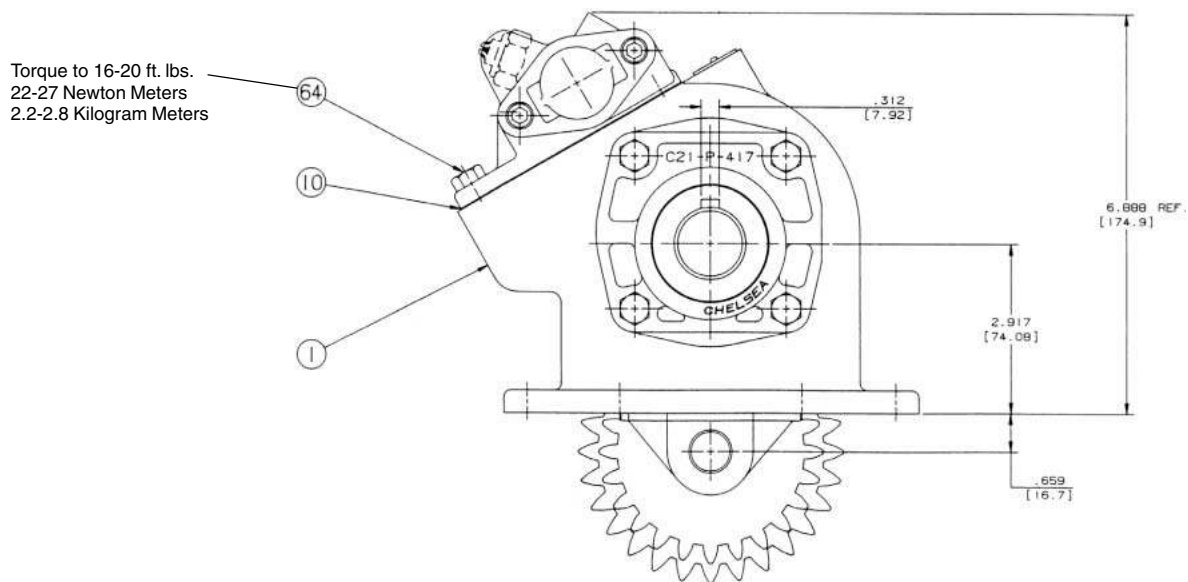
## **Offer of Sale**

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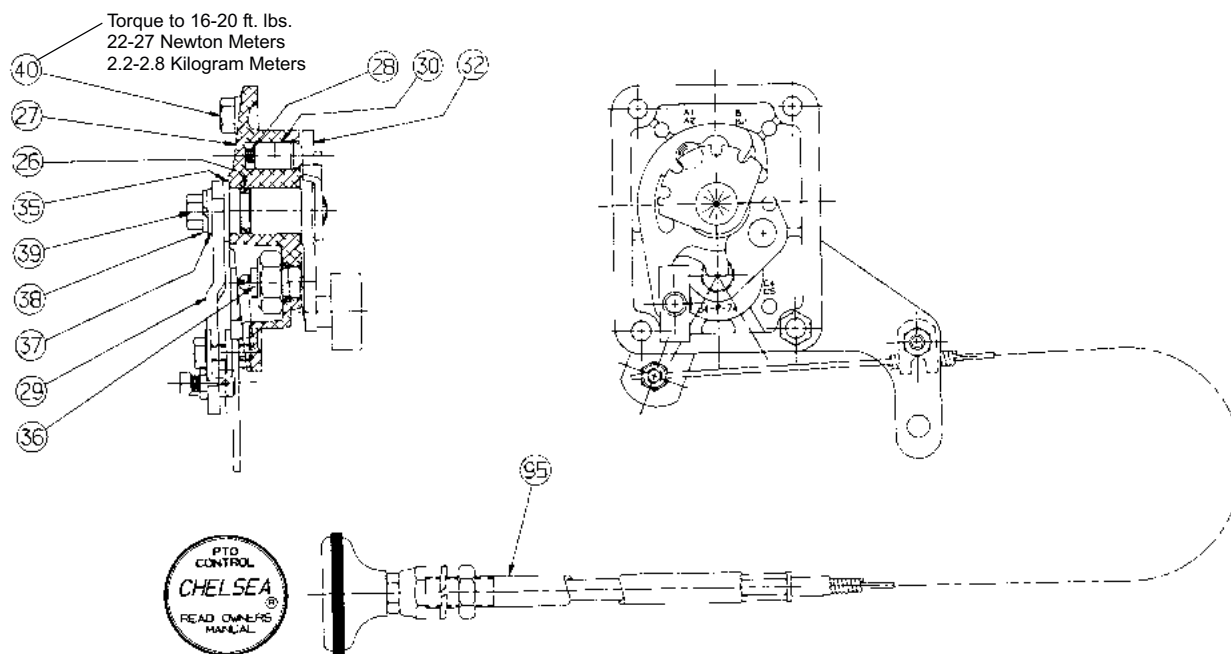
Cross Sectional View .....	1
Bill of Materials .....	2
Cable Shift Control Assembly .....	3
Air Shift Control Assembly .....	4
Pump Flange & Shaft Dimensions .....	5-6
Model Number Designation .....	7
Assembly Arrangements .....	7
Offer of Sale .....	8



**Bill of Materials****Power Take-Off****438 Series**

Item	Part Number	Description	Quantity
1	1-P-483	Housing .....	1
2	2-P-699	Gear, Output .....	1
3	5-P-951	Gear, Input .....	1
4	9-P-72	Shaft, Idler .....	1
5	14-P-15	Spacers, Input Gear .....	A/R
8	22-P-24-1	Gasket, Bearing Cap (.010) .....	A/R
	22-P-24-2	Gasket, Bearing Cap (.020) .....	A/R
	22-P-24-3	Gasket, Bearing Cap (.015) .....	A/R
10	35-P-8	Gasket, Shifter Cover .....	1
11	68-P-2	Name Plate (U.S.A.) .....	1
13	328274X	Bearing Cap Assembly (Closed) .....	1
14	378391	Lockring .....	2
15	378422	Drive Screw .....	2
16	378430-10	Capscrew, Hex Head (.312-18 x 1.000) .....	4
17	378452-7	Set Screw (.250-20 x .500) .....	1
19	550397	Bearing Cone .....	1
20	550439	Bearing Cone .....	2
21	550532	Bearing Cone .....	1
64	378430-8	Capscrew, Hex Head (.312-18 x .750) .....	4
		<b>“XR” OUTPUT</b>	
66	3-P-283	Shaft, Output .....	1
67	28-P-216	Oil Seal .....	1
68	329194X	Pump Flange Assembly (21-P-574) .....	1
69	379673	Shoulder Stud (.312-24) .....	4
70	379063	Flat Washer .....	4
		<b>“XD” OUTPUT</b>	
72	3-P-202	Shaft, Output .....	1
73	28-P-216	Oil Seal .....	1
74	328273X	Bearing Cap Assembly (Open) .....	1
75	378430-10	Capscrew, Hex Head (.312-18 x 1.000) .....	4
76	500007-29	Woodruff Key .....	1
		<b>“XQ” OUTPUT</b>	
79	3-P-282	Shaft, Output (Pump) .....	1
80	28-P-216	Oil Seal .....	1
81	328589X	Bearing Cap Assembly (21-P-269) .....	1
82	378447-8	Capscrew, Socket Head (.312-18 x 1.500) .....	4
		<b>“RA” OUTPUT</b>	
83	3-P-283	Output Shaft .....	1
84	28-P-216	Oil Seal .....	1
85	329195X	Pump Flange Assembly (21-P-574) .....	1
86	21-P-628	Pump Flange 2-Bolt Rotating .....	1
87	378447-6	Socket Head Capscrew .312-18 X 1.000 .....	4
	328591-53X	Pump Field Conversion Kit (“XR” TO “RA”) .....	
	328591-55X	Pump Field Conversion Kit (“XD” TO “RA”) .....	
		<b>“RA” OUTPUT</b>	
88	3-P-283	Output Shaft .....	1
89	28-P-216	Oil Seal .....	1
90	329195X	Pump Flange Assembly (21-P-574) .....	1
91	21-P-572	Pump Flange 4-bolt Rotating .....	1
92	378447-6	Socket Head Capscrew .312-18 X 1.000 .....	4
	328591-54X	Pump Field Conversion Kit (“XR” TO “RA”) .....	
	328591-56X	Pump Field Conversion Kit (“XD” TO “RA”) .....	
		<b>LOOSE PARTS</b>	
	7170-72X	Stud Kit .....	1
	35-P-72	Gasket, Mounting .....	2
	328961-6X	Gasket & Installation Instructions .....	1
95	328346-15X	Cable Control Assembly .....	1
	328380X	Cable Control Parts Bag .....	1
	328751X	Installation Kit .....	1
	328388-37X	Installation Kit, Air Shift .....	1
	328711X	Installation Kit, “XR” Pump .....	1
	329166-12X	Installation Kit, E-Z Shift .....	

A.R. — As Required

**Assembly 4 & 6**

Item	Part Number	Description	Quantity
	<b>329038-1X</b>	<b>CABLE SHIFT</b>	
	<b>329038-2X</b>	CABLE SHIFTER ASSEMBLY (3 & 6) .....	1 or
		CABLE SHIFTER ASSEMBLY (4 & 5) .....	1
26	<b>28-P-191</b>	O-Ring .....	1
27	<b>34-P-74</b>	Shifter Cover Gasket .....	1
28	<b>37-P-19</b>	Shifter Spring .....	1
29	<b>51-P-22</b>	Shifter Lever .....	1
30	<b>63-P-16</b>	Poppet Pin .....	1
32	<b>328813-1X</b>	Shifter Plate Ass'y (3 & 6) .....	1
	<b>328813-2X</b>	Shifter Plate Ass'y (4 & 5) .....	1 or
35	<b>378004</b>	Flat Washer .....	1
36	<b>379110</b>	Indicator Switch (Norm On) .....	1
37	<b>500365-22</b>	Flat Washer .....	1
38	<b>500356-10</b>	Lockwasher .....	1
39	<b>500409-6</b>	Capscrew, Hex Head .....	1
40	<b>378430-9</b>	Capscrew, Hex Head (.312-18 x .875) .....	4

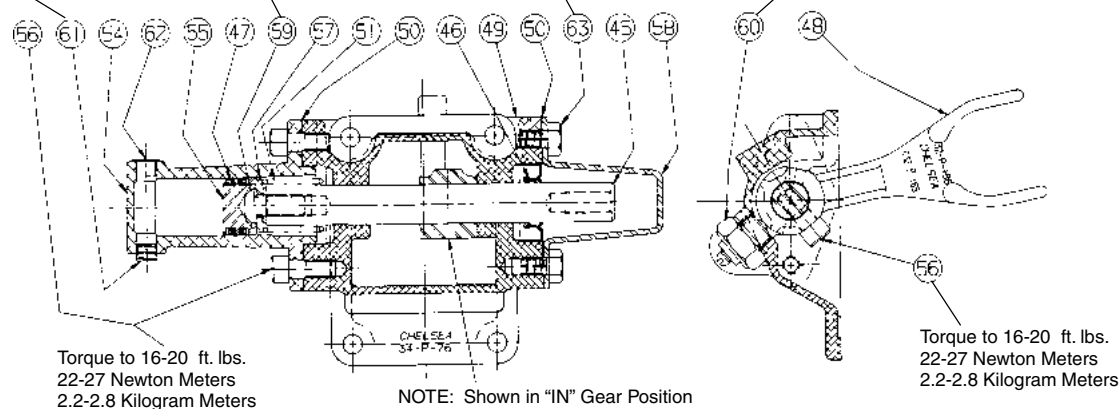
**Assembly 4 & 6**

Torque to 8-12 ft. lbs.  
11-16 Newton Meters  
1.1-1.7 Kilogram Meters

Torque to 30-37 ft. lbs.  
41-50 Newton Meters  
4.1-5.1 Kilogram Meters

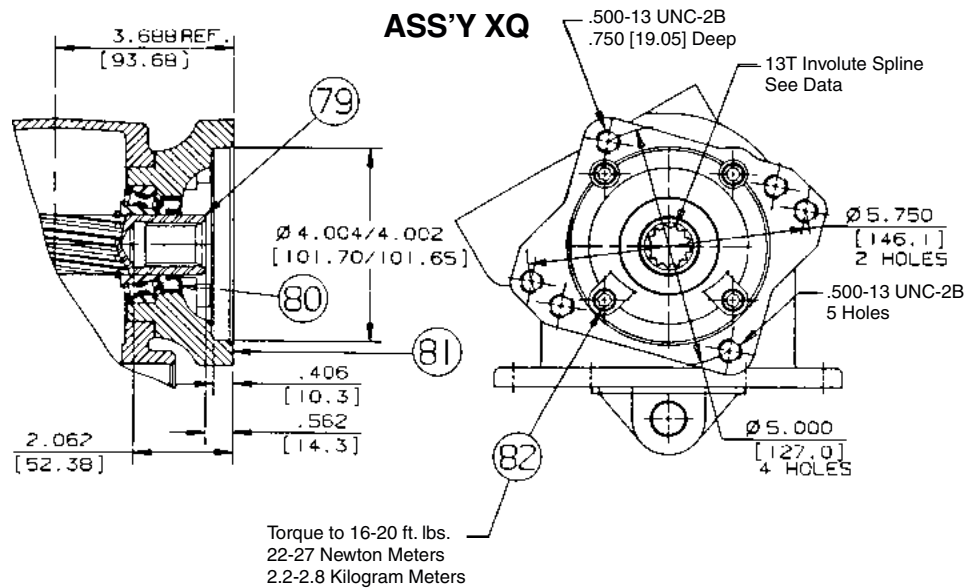
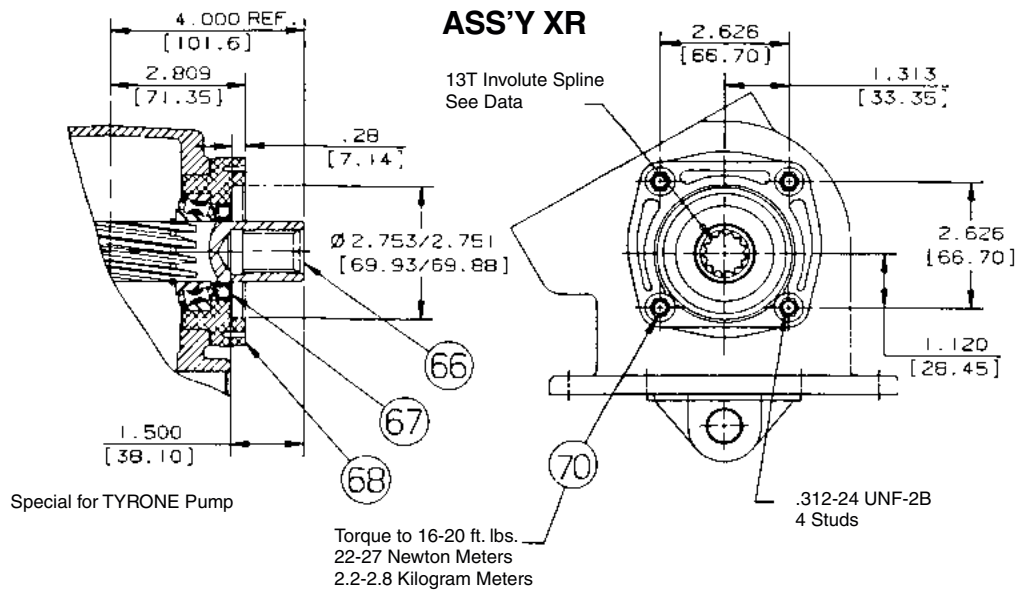
Torque to 16-20 ft. lbs.  
22-27 Newton Meters  
2.2-2.8 Kilogram Meters

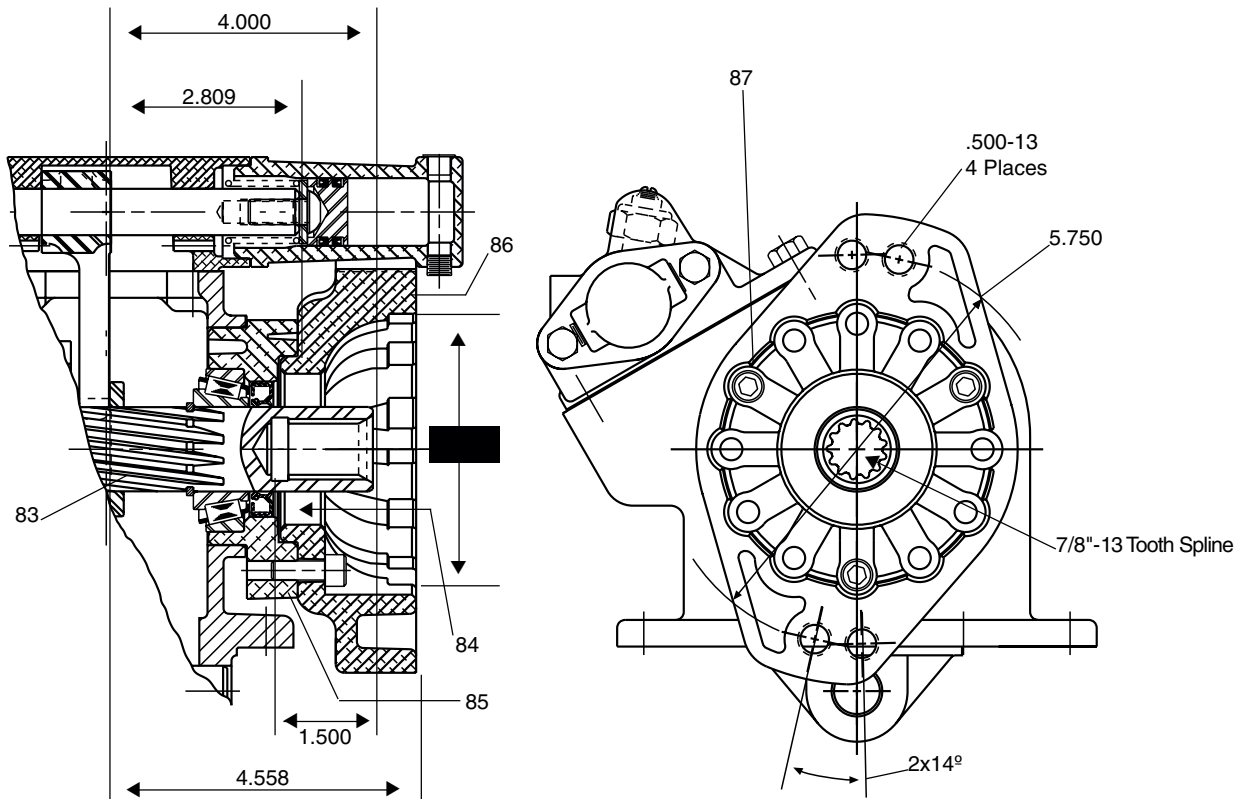
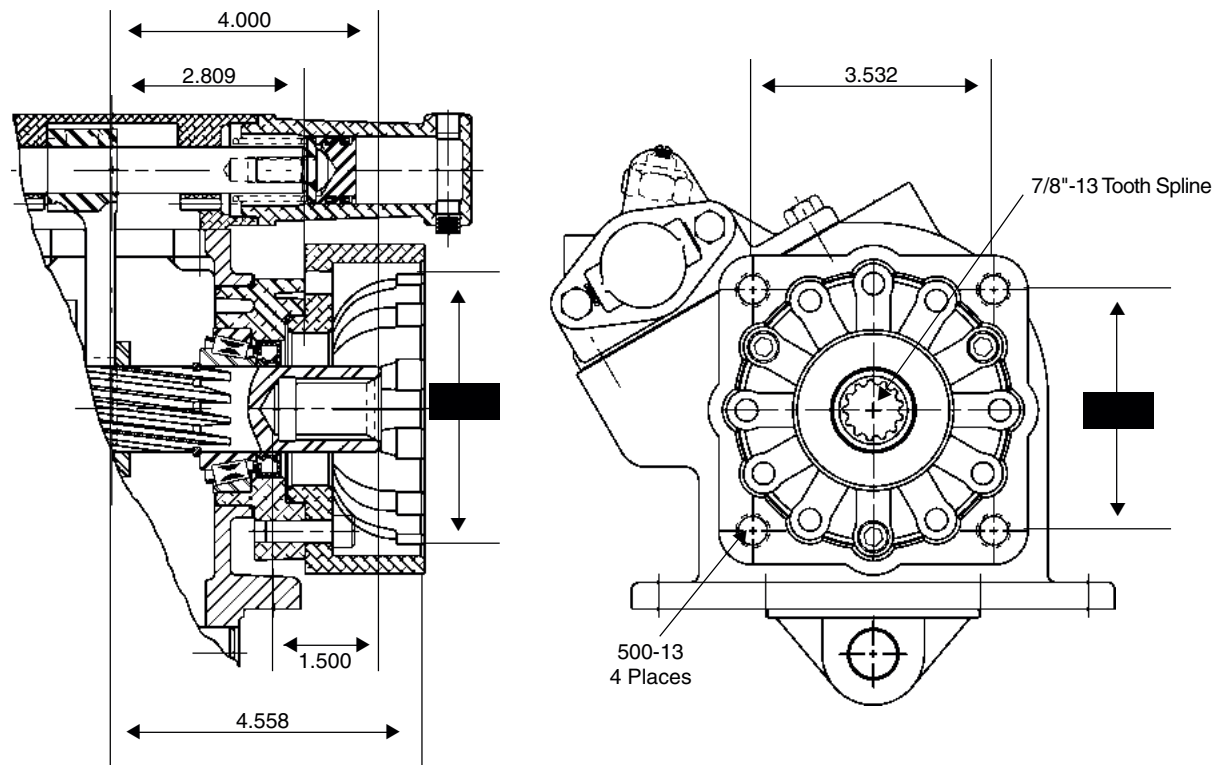
Torque to 10-15 ft. lbs.  
14-20 Newton Meters  
1.4-2.1 Kilogram Meters



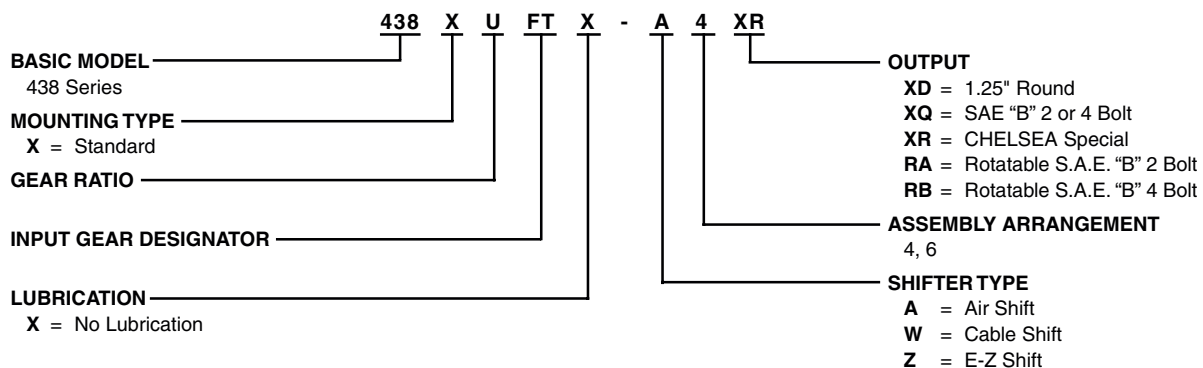
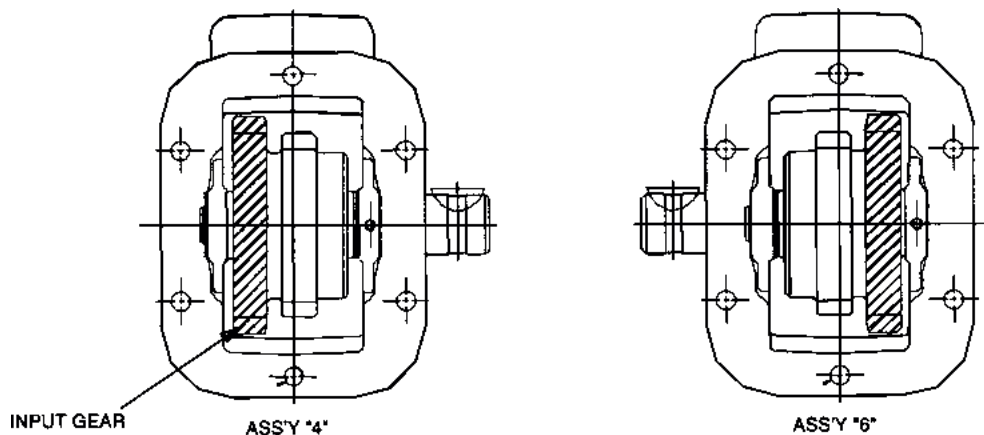
Item	Part Number	Description	Quantity
		<b>AIR SHIFT</b>	
	<b>329042-1X</b>	AIR SHIFT COVER ASSEMBLY (3 & 6) .....	1 or
	<b>329042-2X</b>	AIR SHIFT COVER ASSEMBLY (4 & 5) .....	1
45	<b>11-P-112</b>	Shaft, Shifter .....	1
46	<b>28-P-207</b>	Oil Seal .....	1
47	<b>28-P-256</b>	Block Vee Ring .....	2
48	<b>32-P-166</b>	Shifter Fork .....	1
		<b>E-Z SHIFT™</b>	
	<b>329168-1X</b>	E-Z SHIFT COVER ASSEMBLY (3 & 6) .....	1
	<b>329168-2X</b>	E-Z SHIFT COVER ASSEMBLY (4 & 5) .....	1
49	<b>34-P-76</b>	Shifter Cover .....	1
50	<b>35-P-14</b>	Gasket .....	2
51	<b>37-P-25</b>	Shifter Spring .....	1
54	<b>65-P-14</b>	Cylinder Cap .....	1
55	<b>66-P-4</b>	Piston, Floating .....	1
56	<b>378447-4</b>	Capscrew, Allen Head .....	3
57	<b>378462</b>	Washer, Spring Retainer .....	1
58	<b>65-p-23</b>	Shifter Shaft Cover .....	1
59	<b>378908</b>	Capscrew, Button Head .....	1
60	<b>370110</b>	Indicator Switch (Norm On) .....	1
61	<b>379231</b>	Pipe Plug .125-27 NPTF TH'D .....	1
62	<b>500897-3</b>	Shipping Plug .....	1
63	<b>378430-4</b>	Capscrew, Hex Head (.312-18 x .500) .....	2





**“RA” Output****“RB” Output**

Note: “RA” and “RB” Flanges Rotate in 30° Increments

**Assembly Arrangements**

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**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, 245, 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.**

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**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.

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