



## Chelsea PTO 276 Parts Manual

Pro Gear Chelsea 276 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

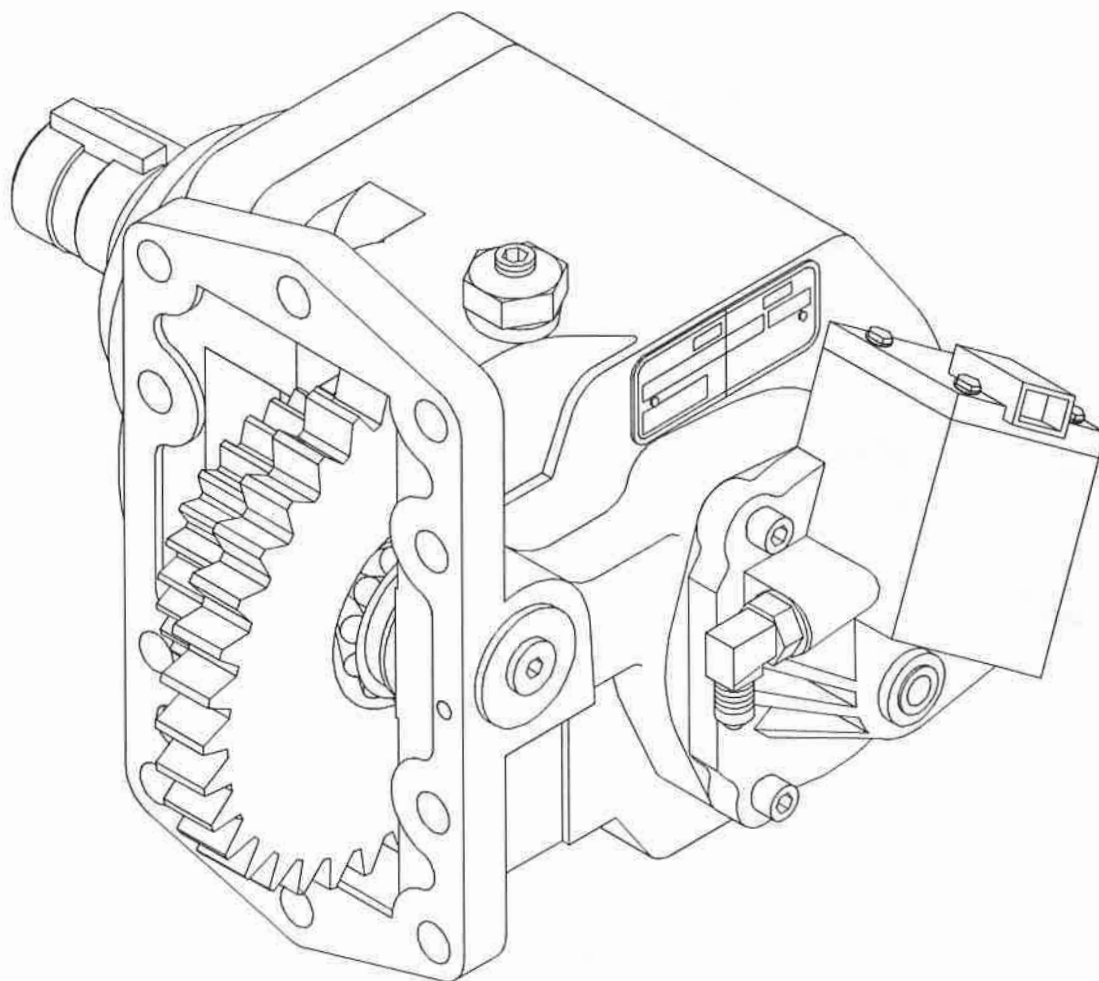
---

# **276 Series Power Take-Off**

---

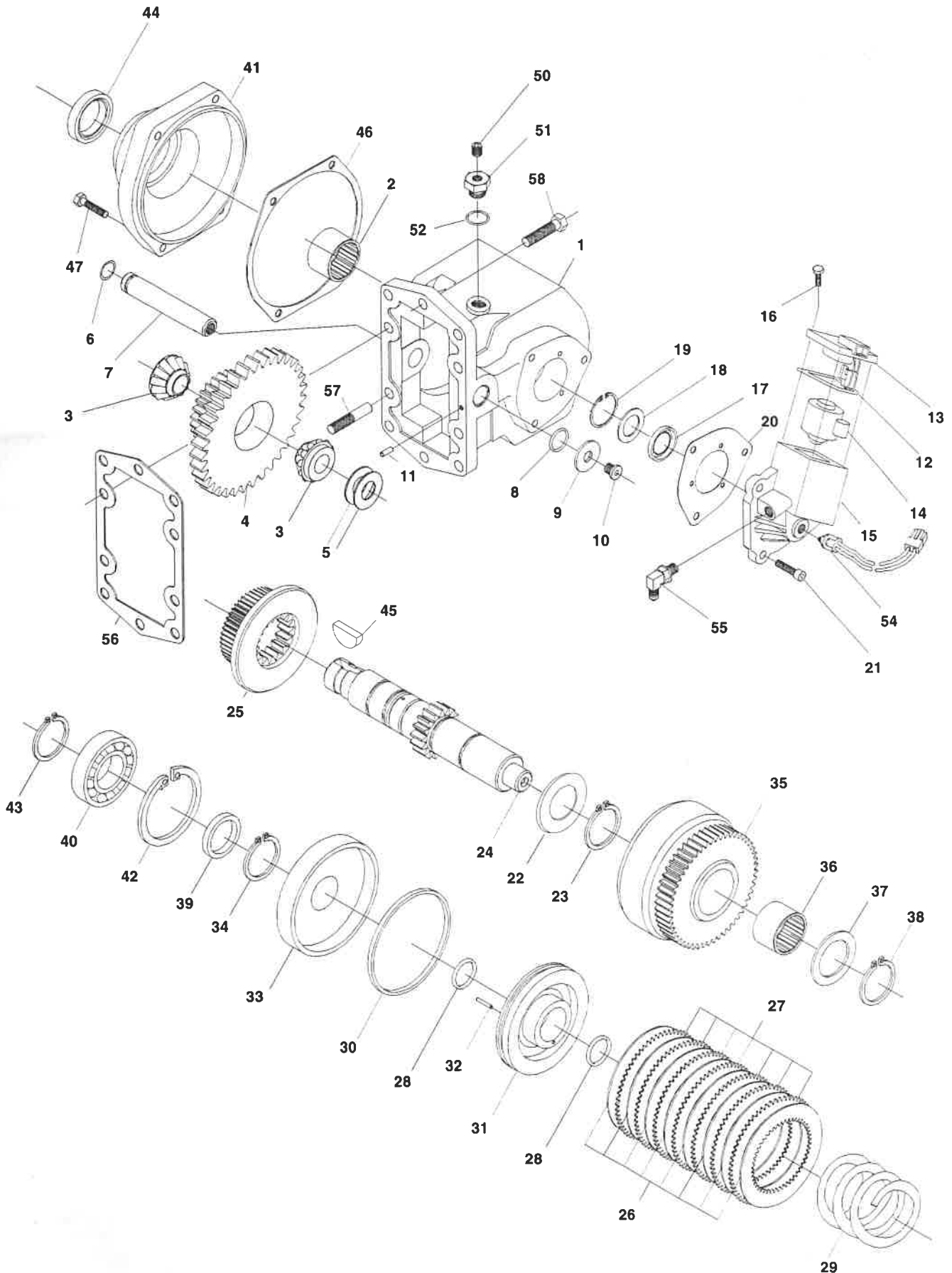
Power Shift for Allison World Class Automatic Transmissions

---



**CHELSEA<sup>®</sup>**

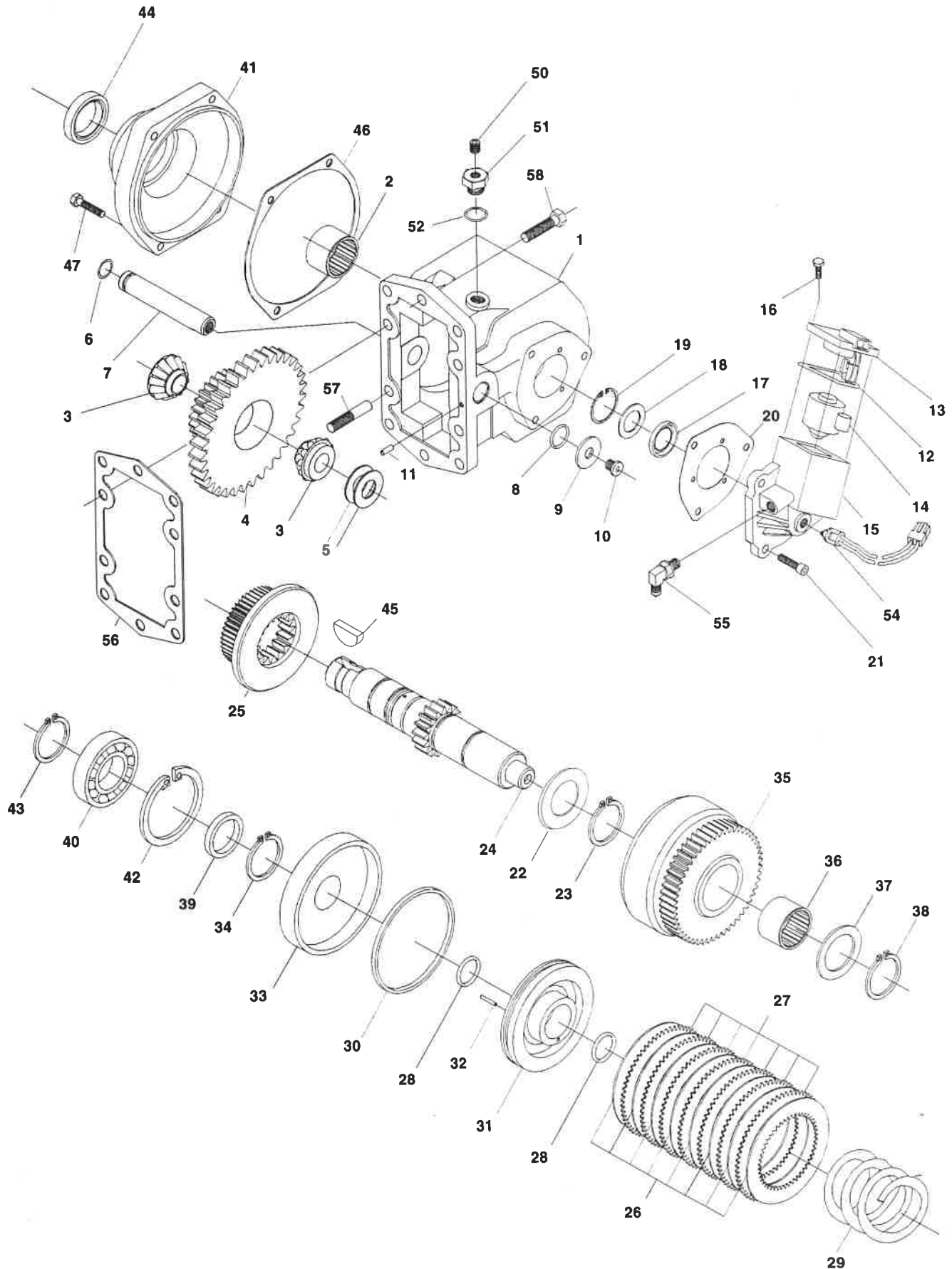




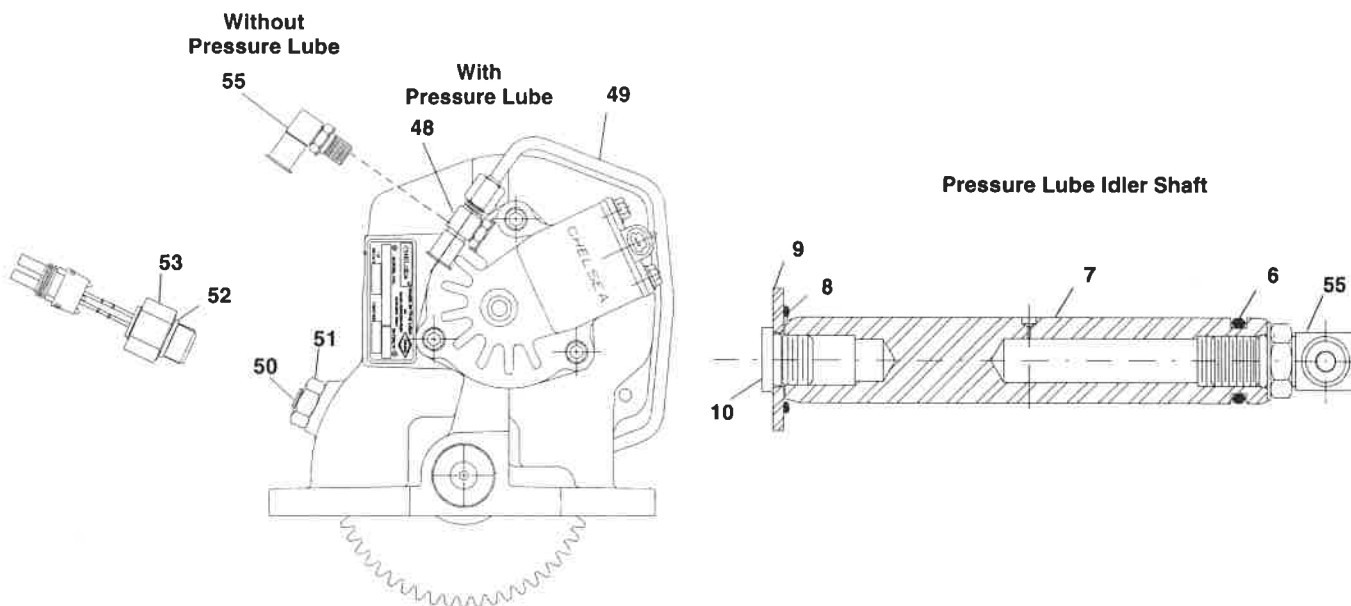


| Item No. | Part Number     | Description  | Quantity |
|----------|-----------------|--|----------|
| 1        | 1-P-454         | HOUSING .....  | 1        |
| 2        | 560972          | NEEDLE BEARING .....                                       | 1        |
| 3        | 550439          | TAPERED BEARING CONE .....                                 | 2        |
| 4        | See Chart Pg. 6 | INPUT GEAR .....   | 1        |
| 5        | 14-P-15         | SPACERS .....  | A.R.     |
| 6        | 28-P-191        | O-RING .....   | 1        |
| 7        | 9-P-70          | IDLER SHAFT, Standard. ....                                | 1        |
|          | 9-P-69          | IDLER SHAFT, Pressure Lube .....                           | 1        |
| 8        | 28-P-190        | O-RING .....   | 1        |
| 9        | 379505          | WASHER .....   | 1        |
| 10       | 379484          | STRAIGHT THREAD CONNECTOR PLUG .....                       | 1        |
| 11       | 500597-16       | SLOTTED PIN .....  | 1        |
|          | 329145-12X      | VALVE AND VALVE CAP ASSEMBLY (12 Volt) .....               | 1        |
|          | 329145-24X      | VALVE AND VALVE CAP ASSEMBLY (24 Volt) .....               | 1        |
|          |                 | Assemblies include items 12 thru 19                        |          |
| 12       | 28-P-193        | BLOCK RING .....   | 1        |
| 13       | 329144X         | VALVE CAP ASSEMBLY (12 Volt) .....                         | 1        |
|          | 329144-1X       | VALVE CAP ASSEMBLY (24 Volt) .....                         | 1        |
| 14       | 379604-1        | SOLENOID VALVE (12 Volt) .....                             | 1        |
|          | 379604-2        | SOLENOID VALVE (24 Volt) .....                             | 1        |
| 15       | 34-P-123        | VALVE CAP .....  | 1        |
| 16       | 379565          | HEX CAPSCREW .....   | 4        |
| 17       | 28-P-119        | OIL SEAL .....   | 1        |
| 18       | 378811          | WASHER .....   | 1        |
| 19       | 378849          | RETAINING RING .....                                       | 1        |
| 20       | 22-P-92         | GASKET, Valve Cap .....                                    | 1        |
| 21       | 378447-6        | SOCKET HEAD CAPSCREW .....                                 | 3        |
|          | See Chart Pg. 6 | OUTPUT SHAFT & CLUTCH ASSEMBLY (Includes items 22 thru 34) |          |
| 22       | 14-P-49         | SPACER .....   | 1        |
| 23       | 378608          | RETAINING RING .....                                       | 1        |
| 24       | See Chart Pg. 6 | OUTPUT SHAFT .....   | 1        |
| 25       | 2-P-458         | CLUTCH GEAR .....  | 1        |
| 26       | 379485          | FRICTION DISC .....  | 8        |
| 27       | 378684          | CLUTCH PLATE .....   | 7        |
| 28       | 28-P-244        | O-RING .....   | 2        |
| 29       | 37-P-39         | RETURN SPRING .....  | 1        |
|          | 328965X         | PISTON & CYLINDER ASSEMBLY (Includes items 30-32)          |          |
| 30       | 28-P-121        | BLOCK VEE RING .....                                       | 1        |
|          | 328676X         | PISTON ASSEMBLY (Includes items 31 and 32)                 |          |
| 31       | 379133          | PISTON .....   | 1        |
| 32       | 378856          | WIGGLER WIRE .....   | 1        |
| 33       | 378760          | CLUTCH BACK UP CYLINDER .....                              | 1        |
| 34       | 378576          | RETAINING RING .....                                       | 1        |
|          |                 | OUTPUT GEAR ASSEMBLY (Includes items 35 and 36)            |          |
|          | 329005-1X       | B Ratio  |          |
|          | 329005-2X       | D Ratio  |          |
|          | 329005-3X       | G Ratio  |          |
|          | 329005-4X       | M Ratio  |          |
| 35       | See Chart Pg. 6 | OUTPUT GEAR .....  | 1        |
| 36       | 560972          | NEEDLE BEARING .....                                       | 1        |





| Item No. | Part Number     | Description  | Quantity |
|----------|-----------------|--|----------|
| 37       | 31-P-70         | THRUST WASHER . . . . .                                    | 1        |
| 38       | 378608          | RETAINING RING . . . . .                                   | 1        |
| 39       | 4-P-147         | SPACER . . . . .   | 1        |
| 40       | 550010          | BALL BEARING . . . . .                                     | 1        |
| 41       | See Chart Pg. 6 | BEARING CAP/PUMP FLANGE . . . . .                          | 1        |
| 42       | 378895          | RETAINING RING . . . . .                                   | 1        |
| 43       | 378576          | RETAINING RING . . . . .                                   | 1        |
| 44       | 28-P-225        | OIL SEAL . . . . .   | 1        |
| 45       | 500007-29       | WOODRUFF KEY . . . . .                                     | 1        |
| 46       | 22-P-101        | GASKET, Bearing Cap . . . . .                              | 1        |
| 47       | 378447-8        | SOCKET HEAD CAPSCREW . . . . .                             | 4        |
| 48       | 379556          | RUN TEE, Pressure Lube Only . . . . .                      | 1        |
| 49       | 379597          | STEEL TUBING, Pressure Lube Only . . . . .                 | 1        |
| 50       | 379231          | PIPE PLUG .125-27 NPTF, w/o E.O.C. Only . . . . .          | 1        |
| 51       | 379242          | O-RING BOSS PLUG, w/o E.O.C. Only . . . . .                | 1        |
| 52       | 28-P-171        | O-RING, w/ E.O.C. Only . . . . .                           | 1        |
| 53       | 379243          | SPEED SENSOR, w/ E.O.C. Only . . . . .                     | 1        |
| 54       | 379502          | PRESSURE SWITCH ASSEMBLY . . . . .                         | 1        |
| 55       | 379486          | STRAIGHT THREAD CONNECTOR 90°, w/o Pressure Lube . . . . . | 1        |
| 56       | 35-P-74         | MOUNTING GASKET . . . . .                                  | 1        |
|          | 7170-86X        | STUD KIT, Includes items 57 and 58 . . . . .               | 1        |
| 57       | 379451          | GUIDE SCREW . . . . .                                      | 2        |
| 58       | 379453-10       | HEX HEAD CAPSCREW . . . . .                                | 8        |



# 276 SERIES PARTS LIST



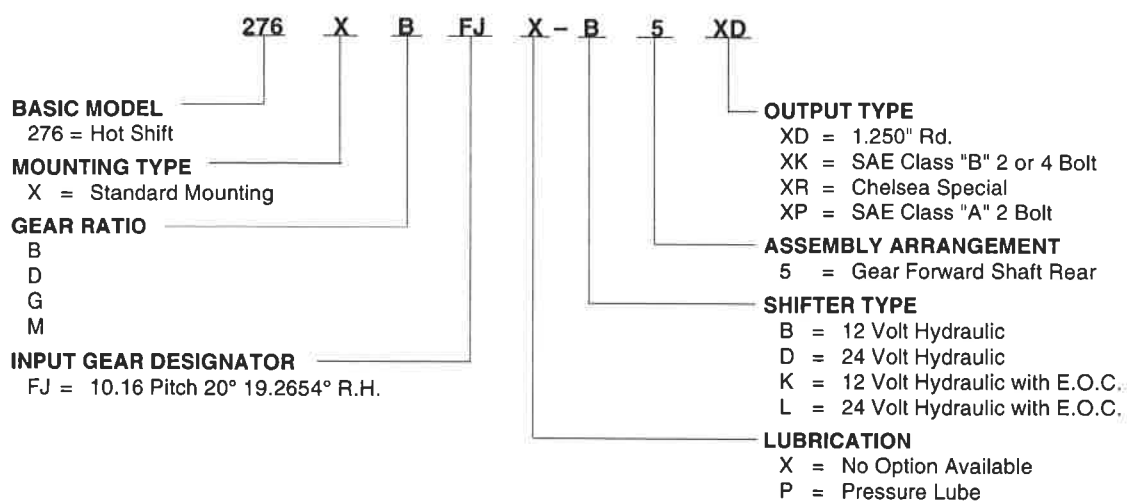
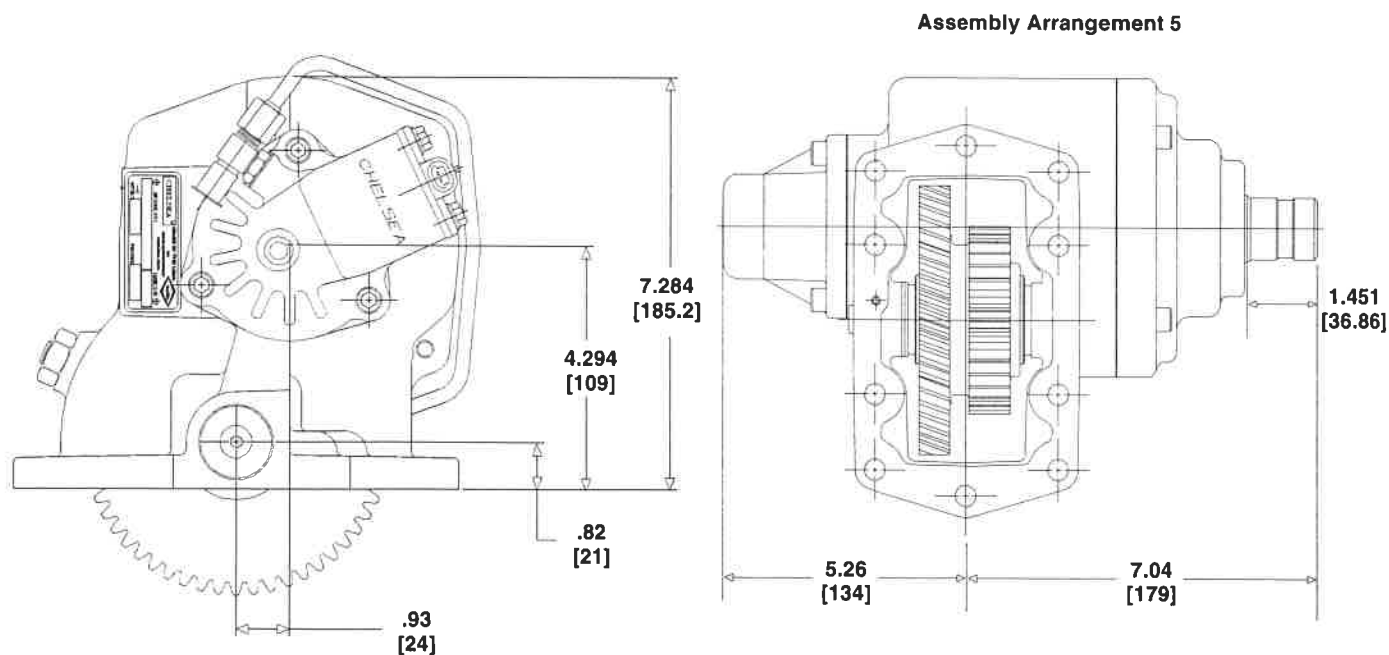
| Item No. | Part Number | Description                                 | Quantity |
|----------|-------------|---|----------|
|          |             | PARTS SHIPPED LOOSE                         |          |
|          | 379486      | 90° O-RING CONNECTOR .....                  | 1        |
|          | 328748X     | PUMP MOUNTING KIT, For "XR" Pump Only ..... | 1        |
|          | 328948-9X   | GASKET & INSTALLATION INSTRUCTIONS .....    | 1        |
|          | 329075-1X   | HIGH PRESSURE HOSE ASSEMBLY .....           | 1        |
|          | 329024-12X  | INSTALLATION KIT 12V, Less E.O.C. ....      | 1        |
|          | 329024-24X  | INSTALLATION KIT 24V, Less E.O.C. ....      | 1        |
|          | 329076X     | INSTALLATION KIT 12V, With E.O.C. ....      | 1        |
|          | 328924-12X  | CONTROL BOX 12V, With E.O.C. ....           | 1        |
|          | 328924-24X  | CONTROL BOX 24V, With E.O.C. ....           | 1        |
|          |             | SERVICE KITS                                |          |
|          | 329071-19X  | GASKET & SEAL KIT                           |          |
|          | 329071-5X   | BEARING KIT                                 |          |
|          | 329071-7X   | CLUTCH REPAIR KIT                           |          |
|          | 329175-12X  | E.O.C. FIELD CONVERSION KIT 12V             |          |
|          | 329175-24X  | E.O.C. FIELD CONVERSION KIT 24V             |          |

## GEAR CHART

| Model No. | Input Gear Part No.<br>Item No. 4 | Number Teeth | Output Gear Part No.<br>Item No. 35 | Number Teeth |
|-----------|-----------------------------------|--------------|-------------------------------------|--------------|
| 276*BFJ   | 5-P-912                           | 25           | 2-P-688                             | 47           |
| 276*DFJ   | 5-P-913                           | 28           | 2-P-684                             | 44           |
| 276*GFJ   | 5-P-914                           | 31           | 2-P-683                             | 41           |
| 276*MFJ   | 5-P-915                           | 35           | 2-P-682                             | 37           |

## OUTPUT SHAFT CHART

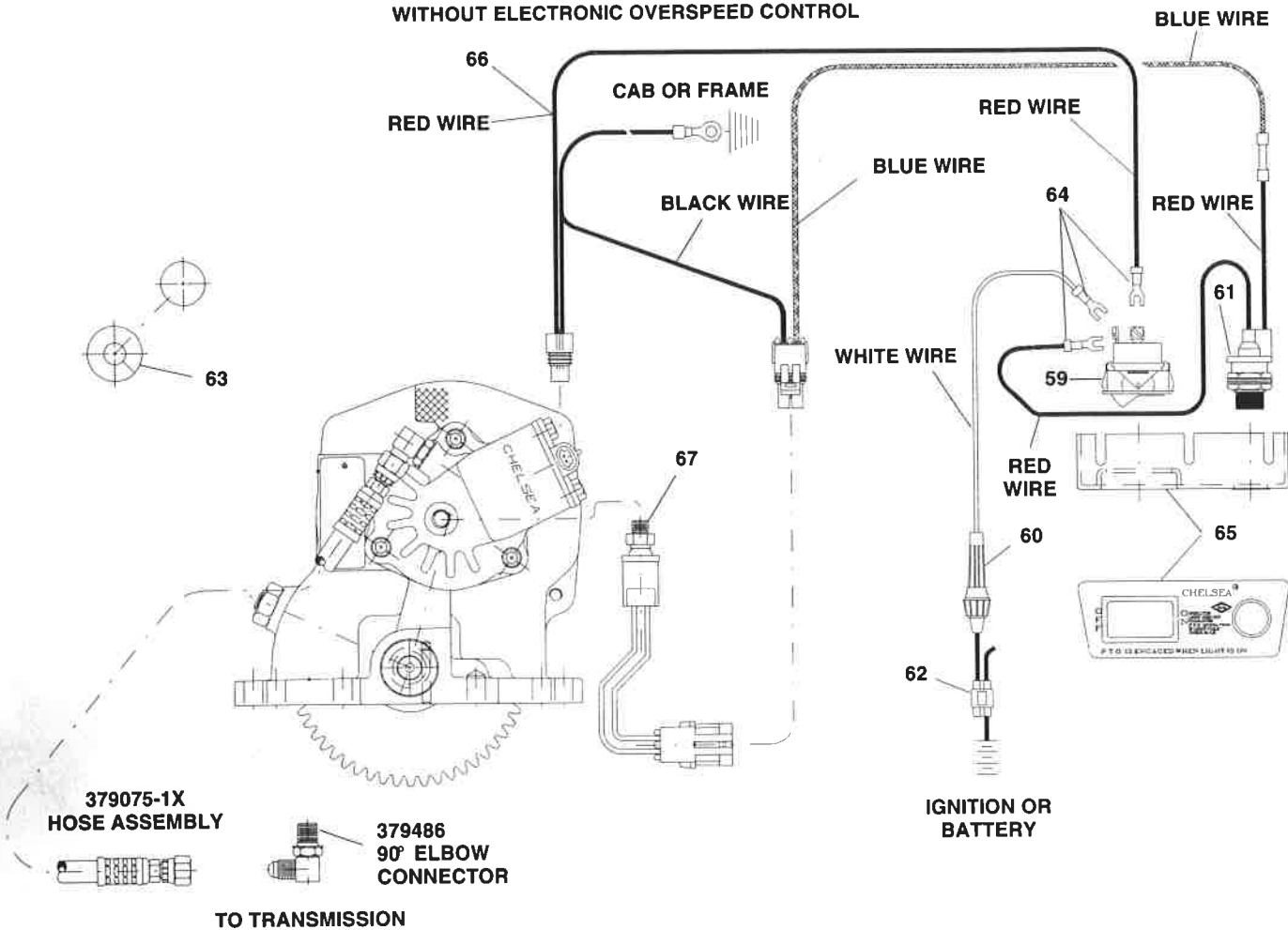
| Model No.   | Output Shaft<br>Item No. 24 | Output Shaft &<br>Clutch Ass'y | Bearing Cap/Pump Flange<br>Item No. 41 |
|-------------|-----------------------------|--------------------------------|--|
| 276*.-***XD | 3-P-831                     | 329006-1X                      | 21-P-480                               |
| 276*.-***XK | 3-P-832                     | 329006-2X                      | 21-P-482                               |
| 276*.-***XP | 3-P-832                     | 329006-2X                      | 21-P-568                               |
| 276*.-***XR | 3-P-833                     | 329006-3X                      | 21-P-484                               |


**PTO HOUSING DIMENSIONS**




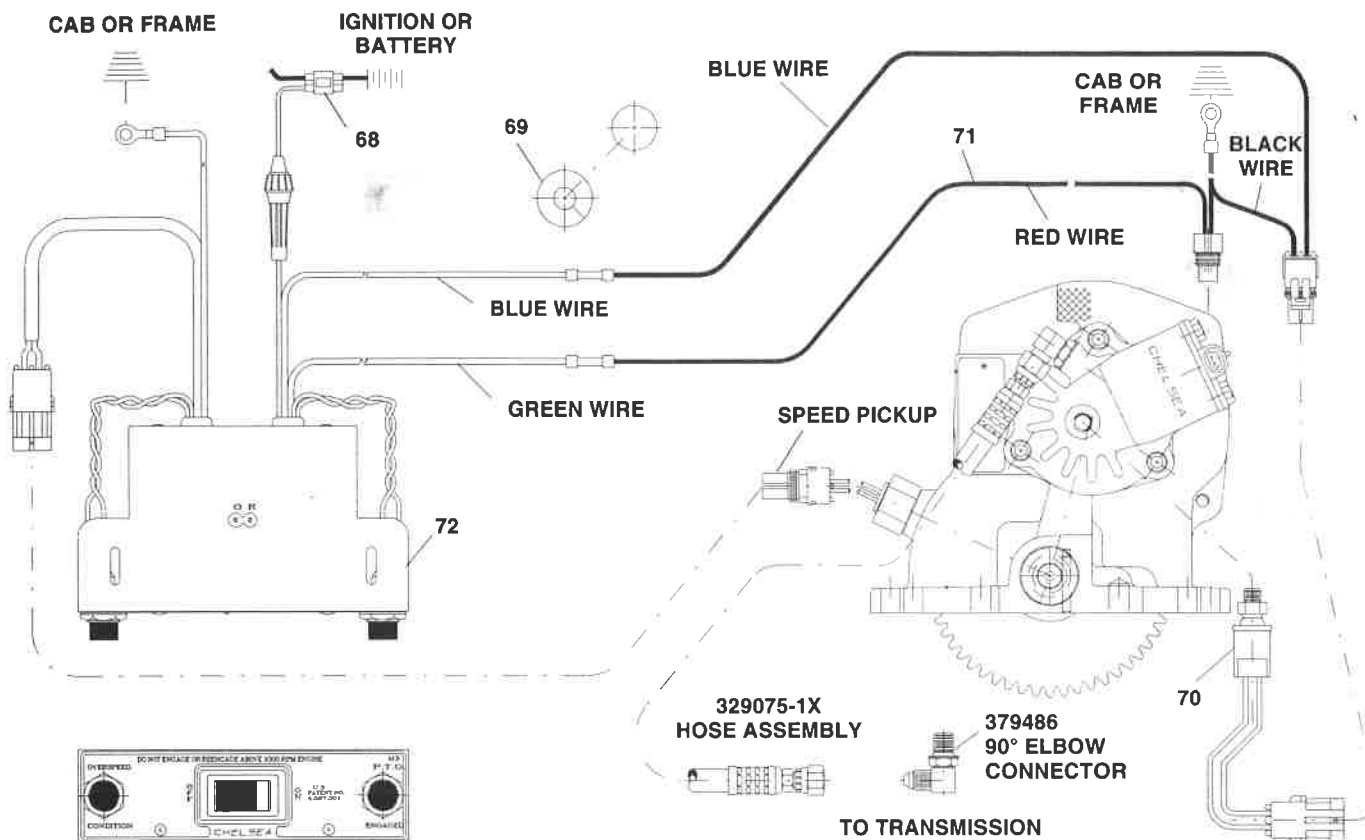
# 276 SERIES SHIFT INSTALLATION KIT

WITHOUT ELECTRONIC OVERSPEED CONTROL



| Item No. | Part Number       | Description                              | Quantity |
|----------|-------------------|--|----------|
|          | <b>329024-12X</b> | 12 VOLT SHIFT INSTALLATION KIT . . . . . | 1        |
|          | <b>329024-24X</b> | 24 VOLT SHIFT INSTALLATION KIT . . . . . | 1        |
| 59       | <b>378881</b>     | SWITCH . . . . .                         | 1        |
| 60       | <b>378884</b>     | FUSE, 9 Amp . . . . .                    | 1        |
| 61       | <b>378978</b>     | INDICATOR LIGHT, 12 Volt. . . . .        | 1 or     |
|          | <b>379005</b>     | INDICATOR LIGHT, 24 Volt. . . . .        | 1        |
| 62       | <b>379257</b>     | CONNECTOR, Splice . . . . .              | 1        |
| 63       | <b>379265</b>     | GROMMET. . . . .                         | 1        |
| 64       | <b>379306</b>     | FORK CONNECTOR. . . . .                  | 3        |
| 65       | <b>379336</b>     | BRACKET . . . . .                        | 1        |
| 66       | <b>379504</b>     | VALVE CONNECTOR & WIRE . . . . .         | 1        |
| 67       | <b>379502</b>     | PRESSURE SWITCH . . . . .                | 1        |

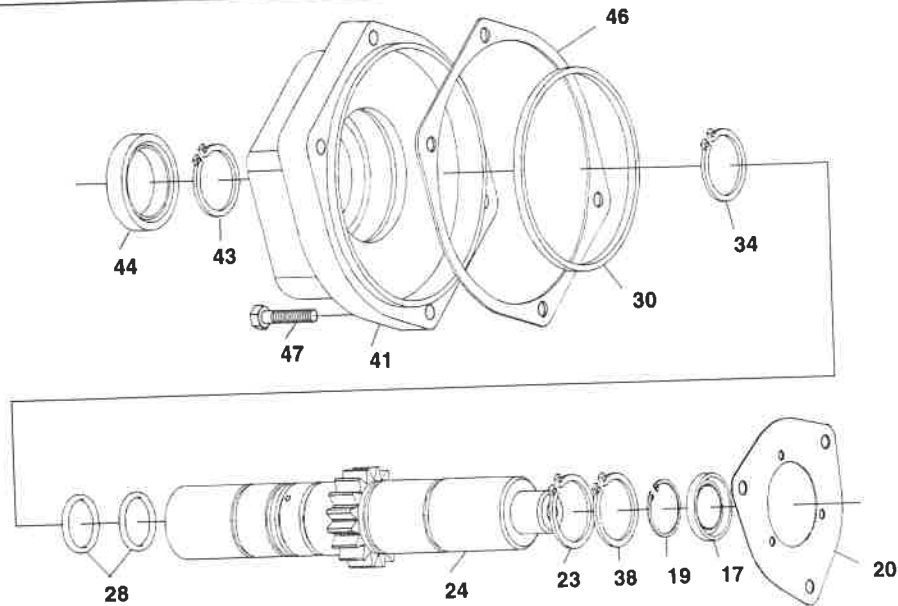
WITH ELECTRONIC OVERSPEED CONTROL



| Item No. | Part Number       | Description  | Quantity |
|----------|-------------------|--|----------|
|          | <b>329076X</b>    | SHIFT INSTALLATION KIT . . . . .   | 1        |
| 68       | <b>379257</b>     | CONNECTOR, Splice . . . . .  | 1        |
| 69       | <b>379265</b>     | GROMMET . . . . .  | 1        |
| 70       | <b>379502</b>     | PRESSURE SWITCH . . . . .  | 1        |
| 71       | <b>379504</b>     | VALVE CONNECTOR & WIRE . . . . .   | 1        |
| N.S.     | <b>379252</b>     | BUTT CONNECTOR . . . . .   | 1        |
| N.S.     | <b>379061</b>     | WIRE TIE . . . . .   | 6        |
| 72       | <b>328924-12X</b> | CHELSEA E.O.C., 12 Volt. . . . .   | 1        |
|          | <b>328924-24X</b> | CHELSEA E.O.C., 24 Volt. . . . .   | 1        |
|          | <b>329175-12X</b> | E.O.C. FIELD CONVERSION KIT, 12 Volt<br>(Includes 329076X and items 52, 53 and 72) |          |
|          | <b>329175-24X</b> | E.O.C. FIELD CONVERSION KIT, 24 Volt<br>(Includes 329076X and items 52, 53 and 72) |          |

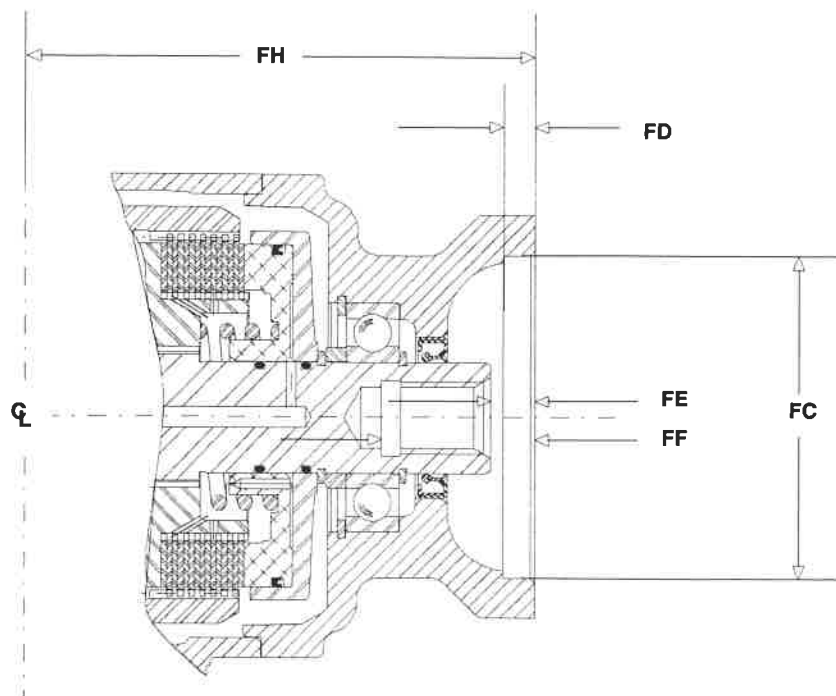
N.S. — Not Shown

# 276 SERIES PUMP CONVERSION KIT BILL OF MATERIAL



| Item No. | Part Number | Description                             | Quantity |
|----------|-------------|---|----------|
|          |             | <b>PUMP FIELD CONVERSION KIT</b>        |          |
|          | 329160-21X  | "XK" Output                             |          |
|          | 329160-22X  | "XR" Output                             |          |
|          | 329160-23X  | "XP" Output                             |          |
| 17       | 28-P-119    | OIL SEAL, High Pressure .....           | 1        |
| 19       | 378849      | RETAINING RING .....                    | 1        |
| 20       | 22-P-92     | GASKET, Valve Cap .....                 | 1        |
| 23       | 378608      | RETAINING RING .....                    | 1 or     |
| 24       | 3-P-832     | OUTPUT SHAFT, XK & XP Outputs .....     | 1        |
|          | 3-P-833     | OUTPUT SHAFT, XR Output. ....           | 2        |
| 28       | 28-P-244    | O-RING. ....                            | 1        |
| 30       | 28-P-121    | BLOCK VEE RING. ....                    | 1        |
| 34       | 378576      | RETAINING RING .....                    | 1        |
| 38       | 378608      | RETAINING RING .....                    | 1 or     |
| 41       | 21-P-482    | PUMP FLANGE, XK Output. ....            | 1 or     |
|          | 21-P-484    | PUMP FLANGE, XR Output. ....            | 1        |
|          | 21-P-568    | PUMP FLANGE, XP Output. ....            | 1        |
| 43       | 378576      | RETAINING RING .....                    | 1        |
| 44       | 28-P-225    | OIL SEAL .....                          | 1        |
| 46       | 22-P-101    | GASKET, Bearing Cap. ....               | 4        |
| 47       | 378447-8    | SOCKET HEAD CAPSCREW .....              | 1        |
| N.S.     | 328748X     | PUMP MOUNTING KIT, XR Output Only ..... |          |

N.S. — Not Shown



| Pump<br>Flange<br>Suffix | Bolt<br>Circle<br>Dia. | BOLT HOLES     |                          | FC                          | FD             | FE                         | FF                   | FH                          | OUTPUT SHAFT   | Keyway<br>Width |
|--------------------------|------------------------|----------------|--------------------------|-----------------------------|----------------|----------------------------|----------------------|-----------------------------|----------------|-----------------|
|                          |                        | Tapped<br>Hole | No.<br>Equally<br>Spaced | Female<br>Pilot<br>Diameter | Pilot<br>Depth | Face to<br>end<br>of Shaft | Face<br>thru<br>Hole | Face to<br>Center<br>of PTO | Hole<br>Dia.   |                 |
| XK                       | 5.00                   | .500"-13       | 4                        | 4.003                       | .406           | .562                       | 1.940                | 6.410                       | 7/8"-13 Spline | -               |
|                          | 5.75                   | .500"-13       | 2                        | 4.003                       | .406           | .562                       | 1.940                | 6.410                       | 7/8"-13 Spline | -               |
| XP                       | 4.188                  | .500"-13       | 2                        | 3.253                       | .344           | .562                       | 1.940                | 6.410                       | 7/8"-13 Spline | -               |
| XR                       | 3.71                   | .312"-18       | 4                        | 2.752                       | .281           | N/A                        | N/A                  | 5.860                       | 7/8"-13 Spline | -               |