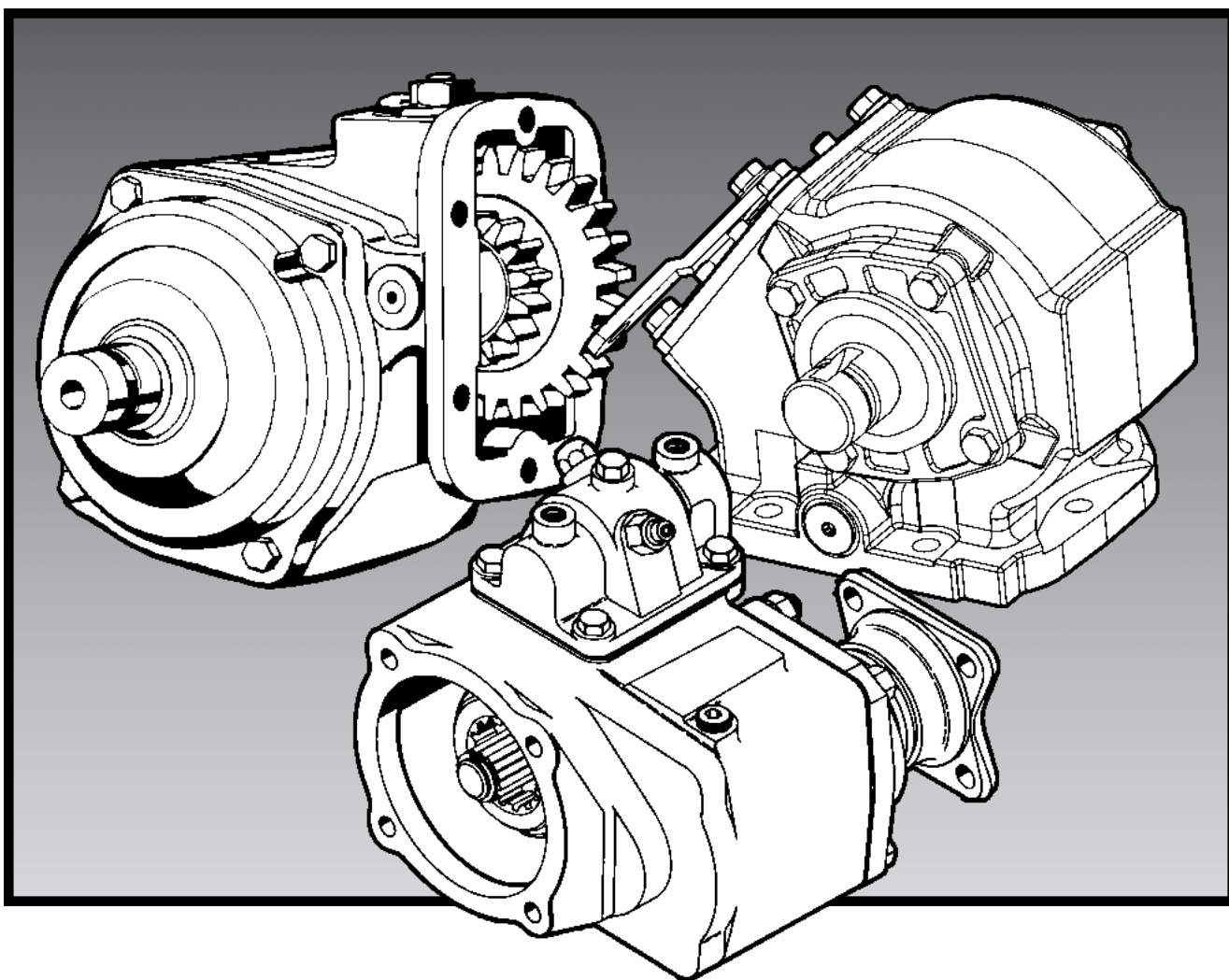


CHELSEA[®]

Bulletin HY25-2438-M1/US

Parts List 438 Series

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



 **WARNING**

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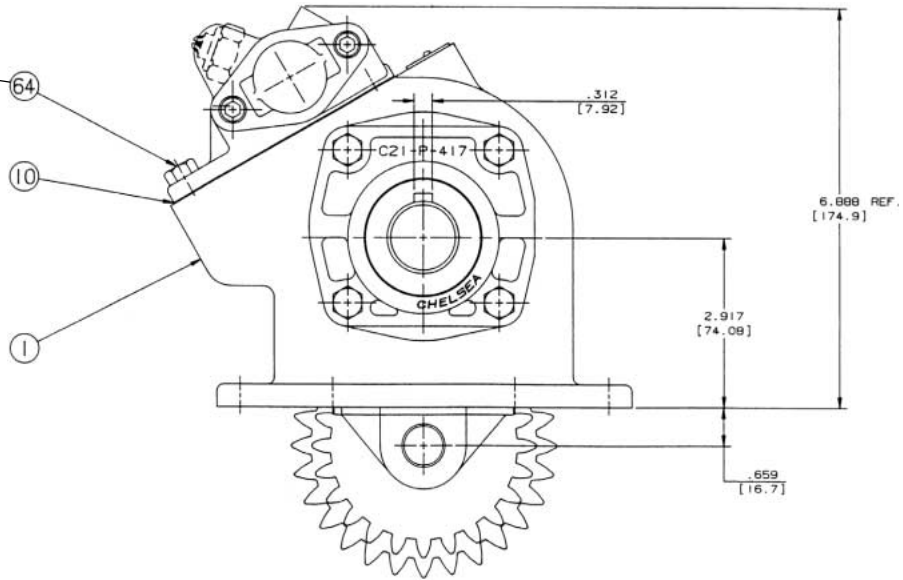
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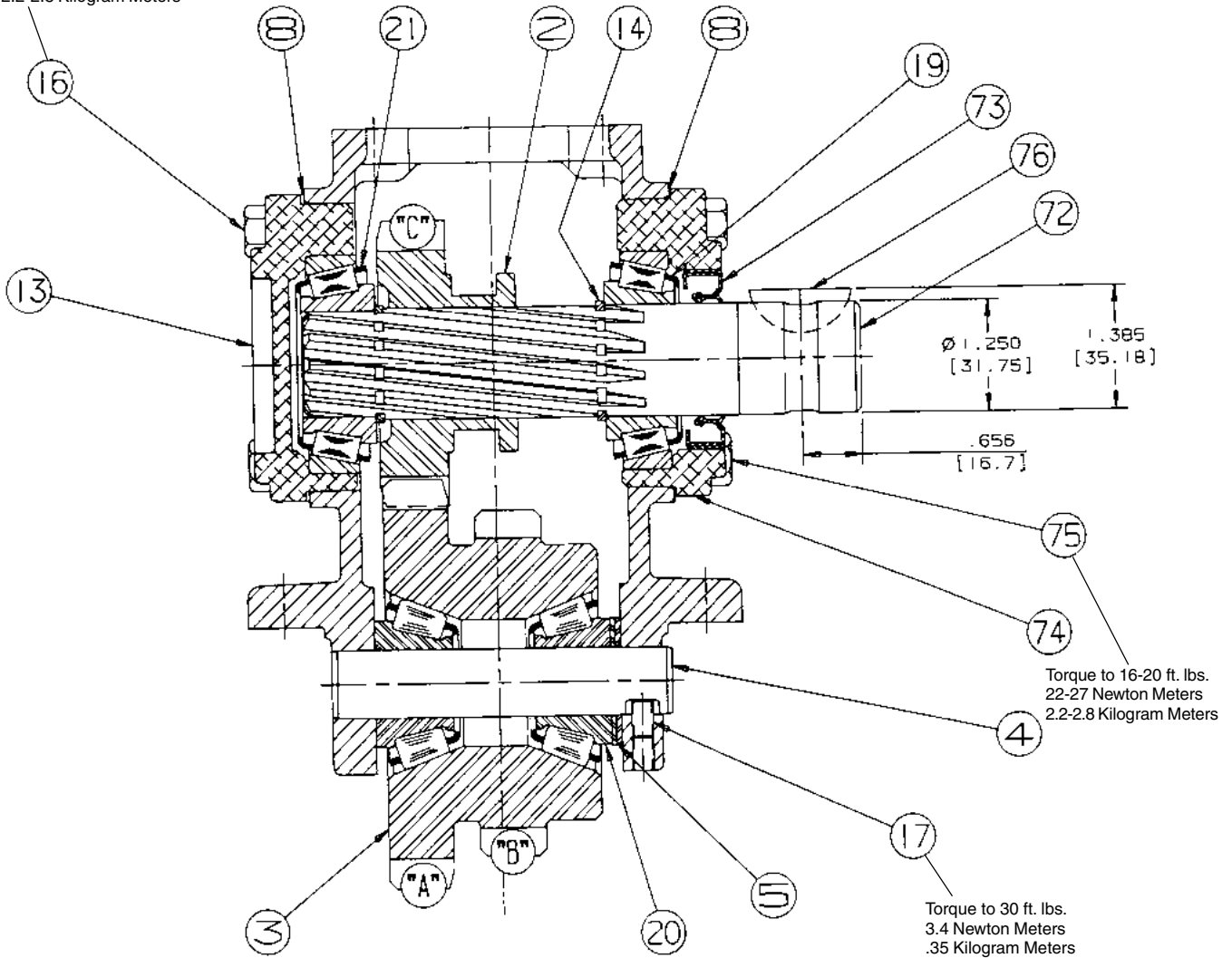
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Torque to 16-20 ft. lbs.
 22-27 Newton Meters
 2.2-2.8 Kilogram Meters



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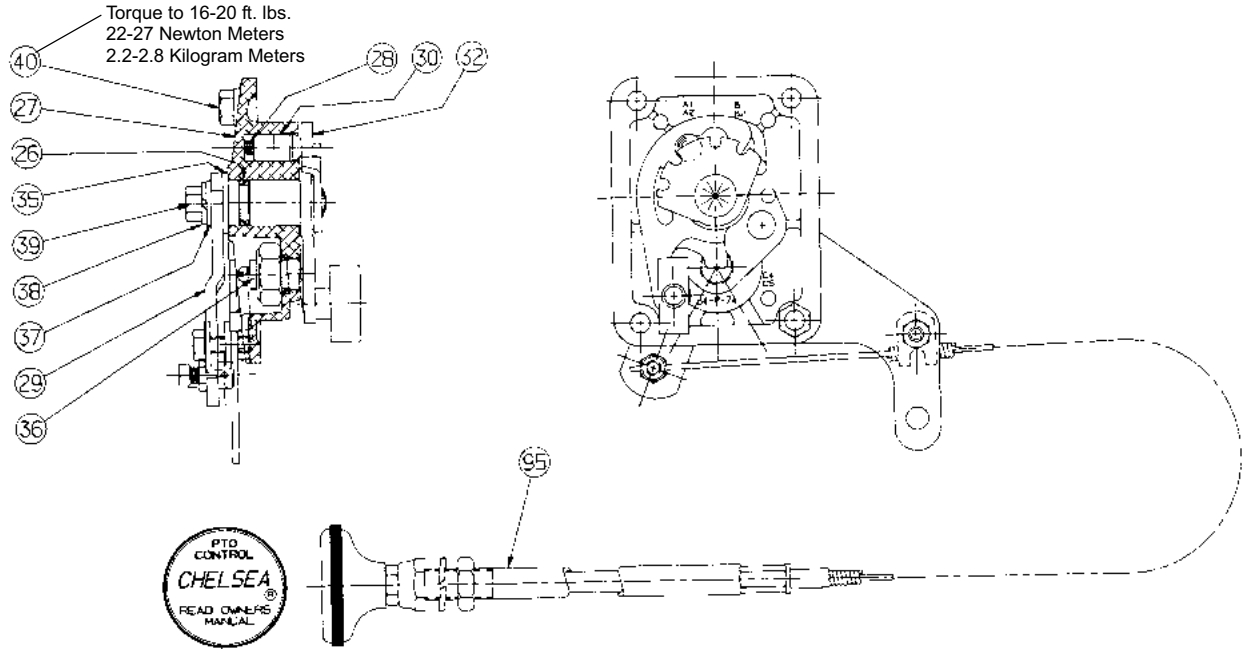


Bill of Materials

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
		“XR” OUTPUT	
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
		“XD” OUTPUT	
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
		“XQ” OUTPUT	
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
		“RA” OUTPUT	
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”)	
		“RA” OUTPUT	
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”)	
		LOOSE PARTS	
	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	1

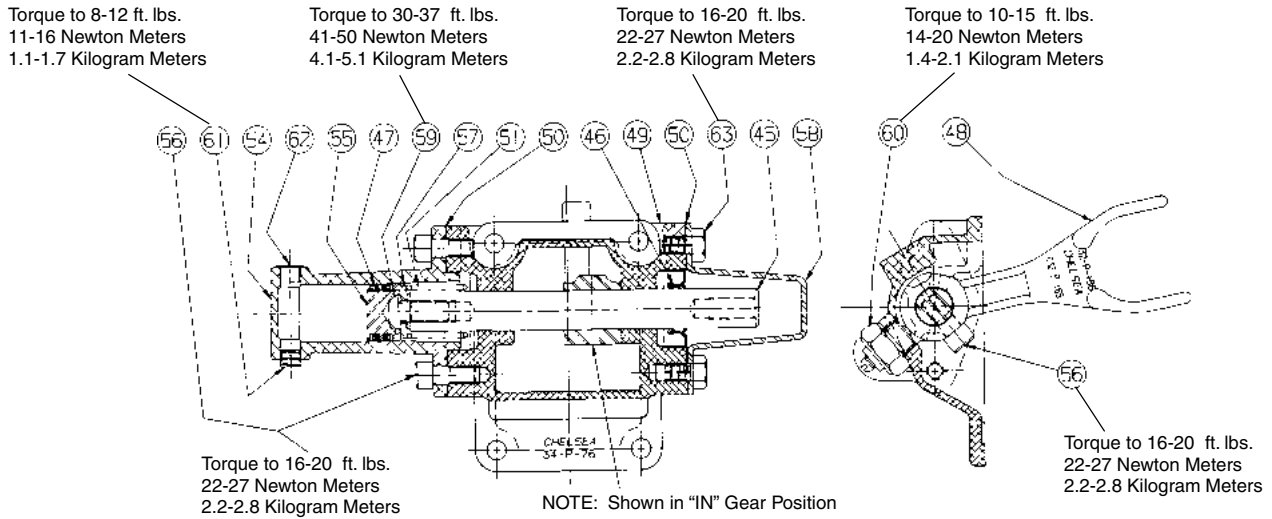
A.R. — As Required

Assembly 4 & 6

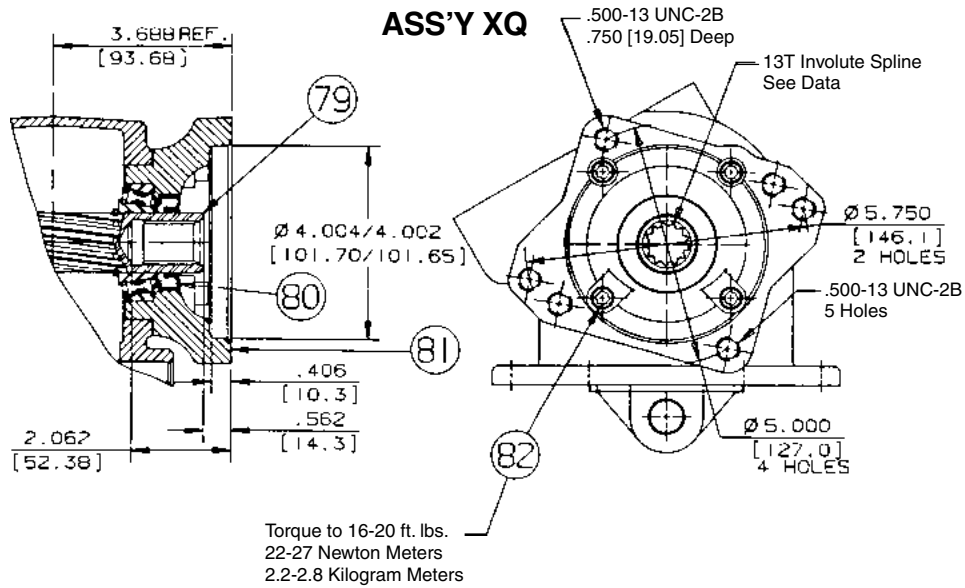
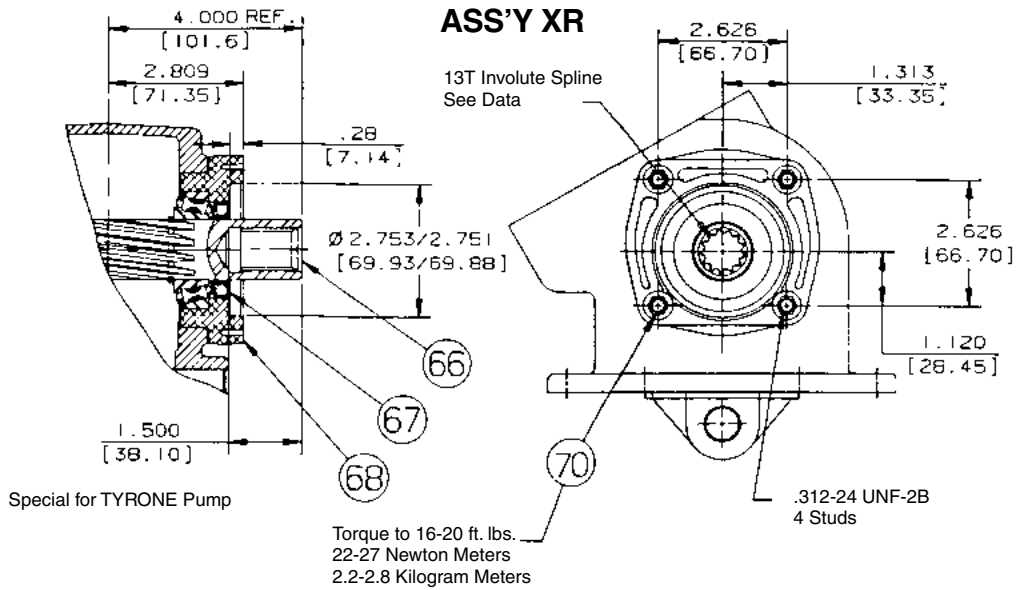


Item	Part Number	Description	Quantity
		CABLE SHIFT	
	329038-1X	CABLE SHIFTER ASSEMBLY (3 & 6)	1 or
	329038-2X	CABLE SHIFTER ASSEMBLY (4 & 5)	1
26	28-P-191	O-Ring	1
27	34-P-74	Shifter Cover Gasket	1
28	37-P-19	Shifter Spring	1
29	51-P-22	Shifter Lever	1
30	63-P-16	Poppet Pin	1
32	328813-1X	Shifter Plate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

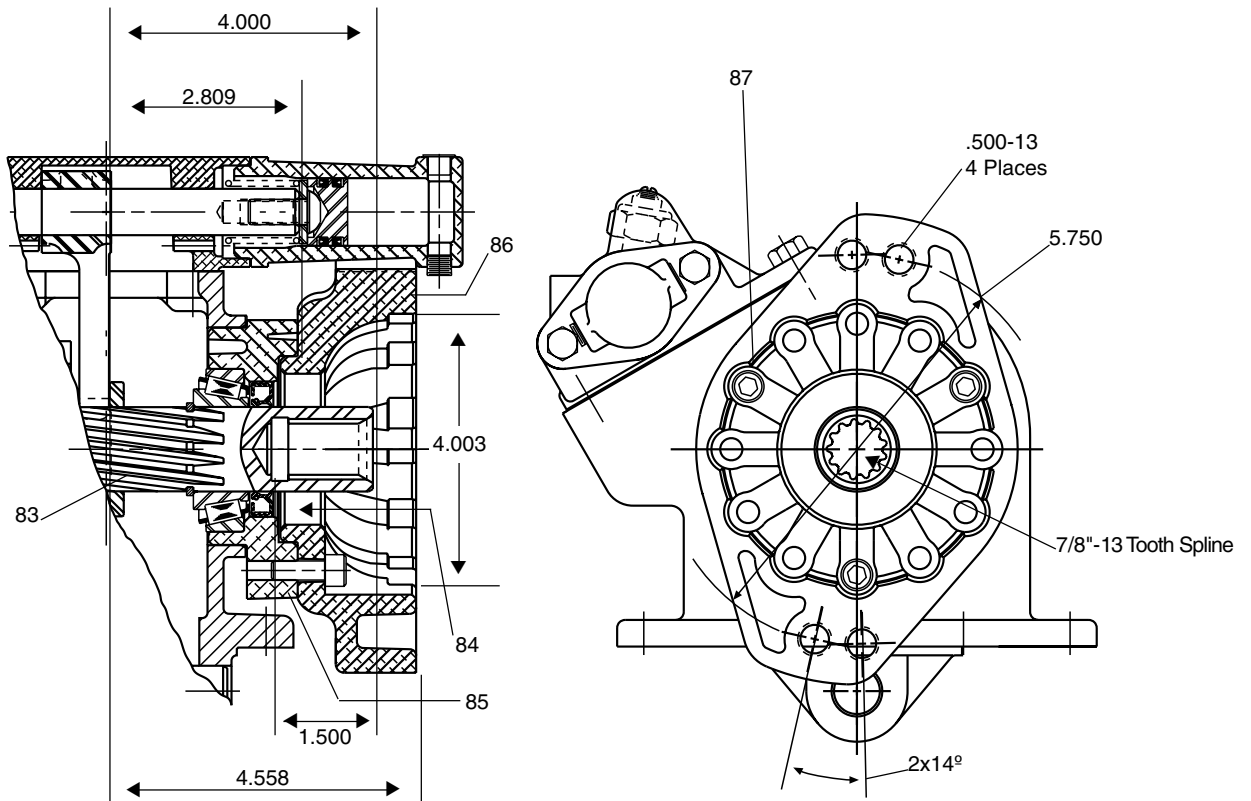
Assembly 4 & 6



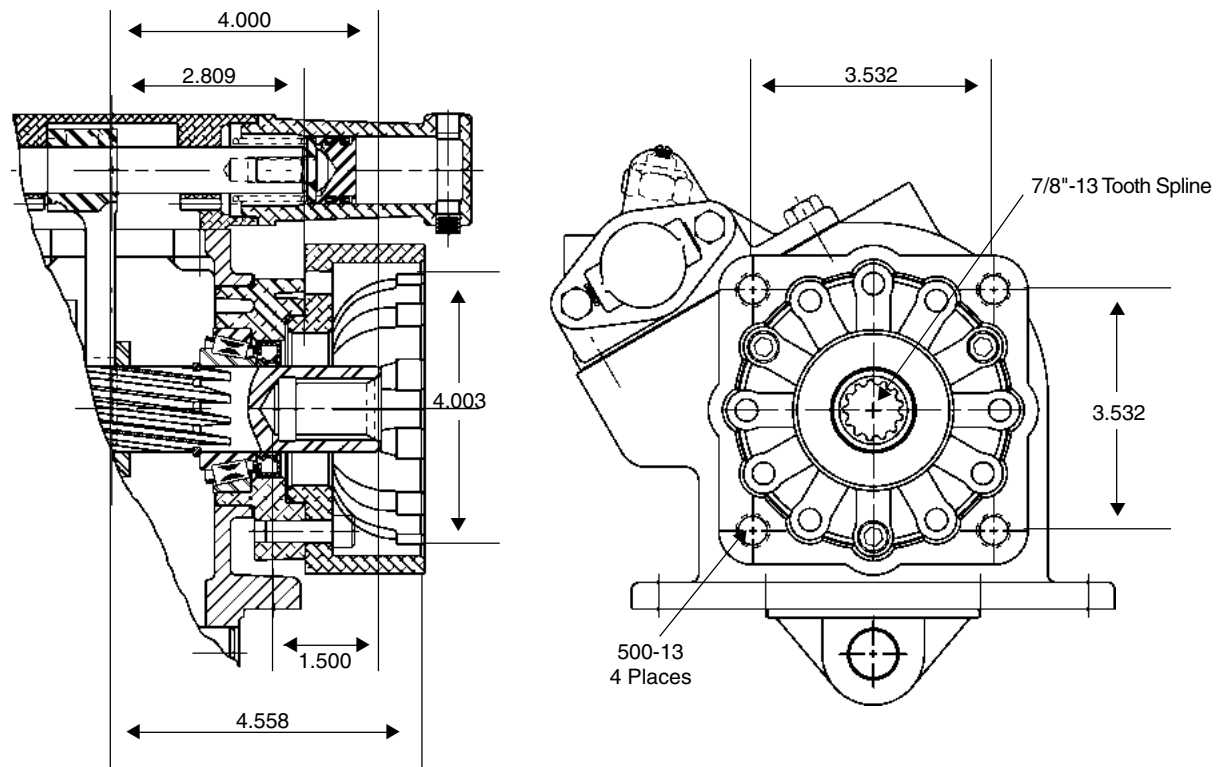
Item	Part Number	Description	Quantity
		AIR SHIFT	
	329042-1X	AIR SHIFT COVER ASSEMBLY (3 & 6)	1 or
	329042-2X	AIR SHIFT COVER ASSEMBLY (4 & 5)	1
45	11-P-112	Shaft, Shifter	1
46	28-P-207	Oil Seal	1
47	28-P-256	Block Vee Ring	2
48	32-P-166	Shifter Fork	1
		E-Z SHIFT™	
	329168-1X	E-Z SHIFT COVER ASSEMBLY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



“RA” Output

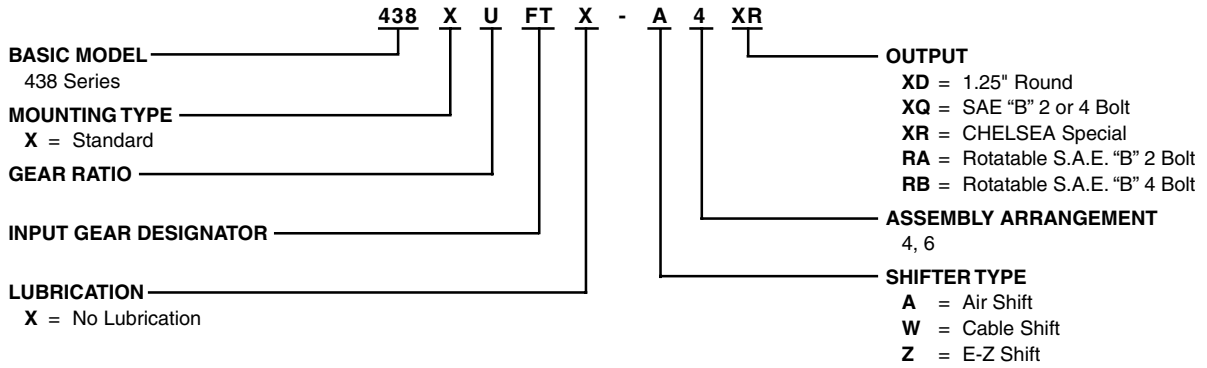


“RB” Output

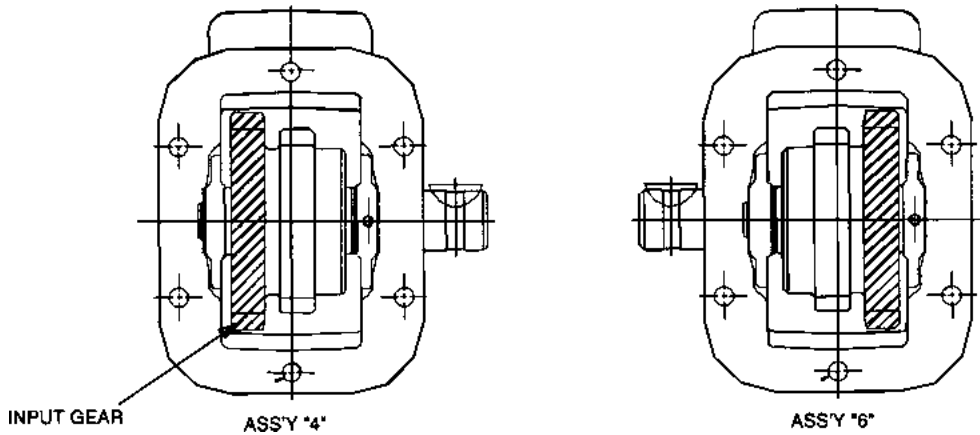


Note: “RA” and “RB” Flanges Rotate in 30° Increments

Model Number Designation



Assembly Arrangements



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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.

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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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