



Chelsea PTO 885 Parts Manual

Pro Gear and Transmission presents Chelsea 885 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.

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

1 (877) 776-4600
(407) 872-1901
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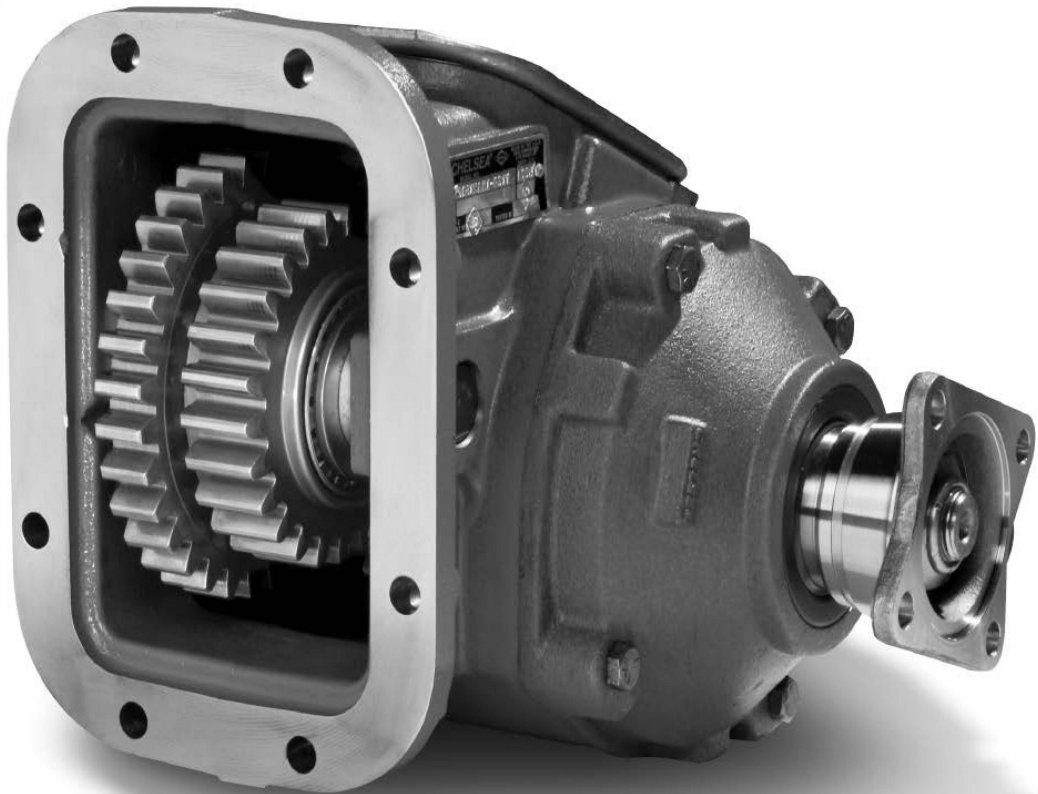
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Effective: November 15, 2018
Supercedes: HY25-2885-M1/US October 15, 2001

Power Take-Off Parts List

885 Series



ENGINEERING YOUR SUCCESS.

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WARNING — User Responsibility

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

This document and other information from Parker Hannifin Corporation, its subsidiaries and authorized distributors provide product or system options for further investigation by users having technical expertise.

The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

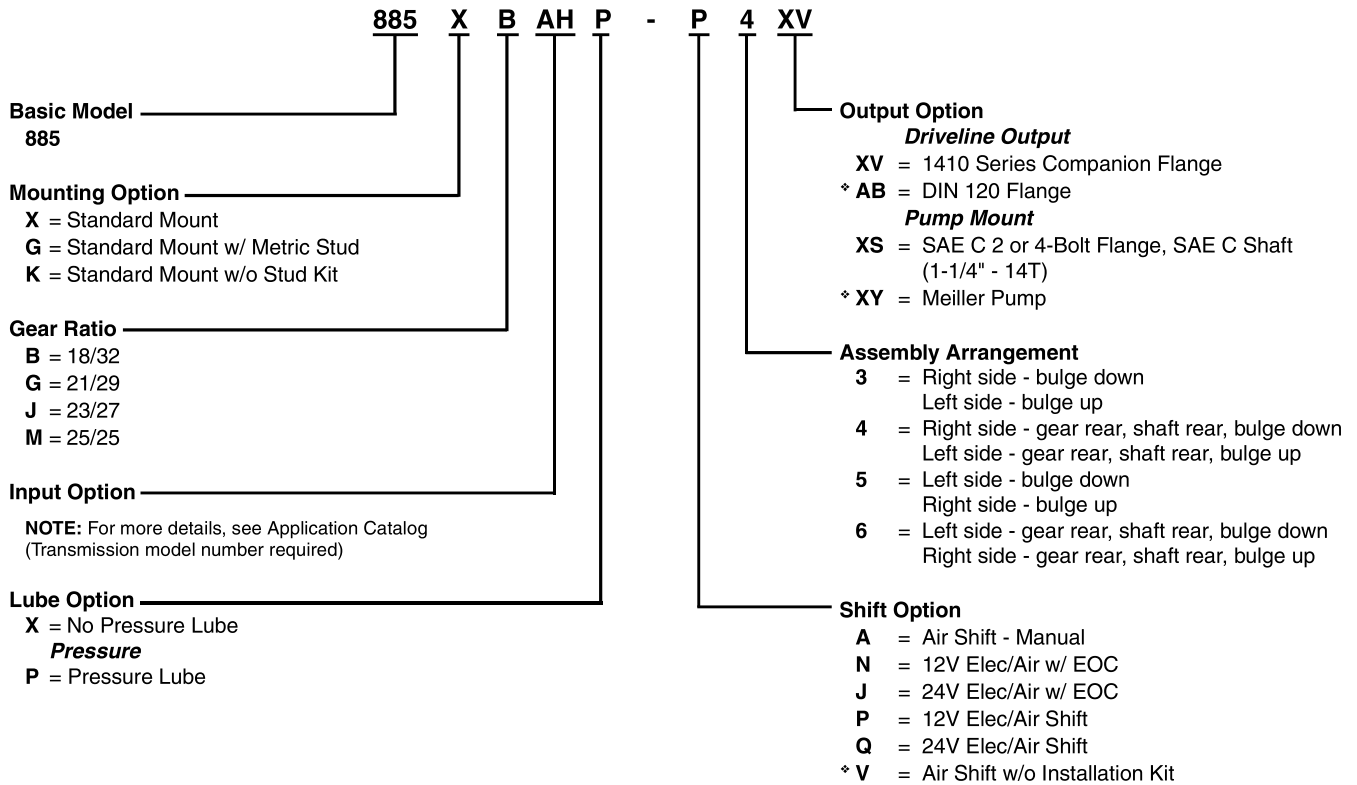
To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.

Offer of Sale

The items described in this document are hereby offered for sale by Parker Hannifin Corporation, its subsidiaries or its authorized distributors. This offer and its acceptance are governed by the provisions stated in the "Offer of Sale".

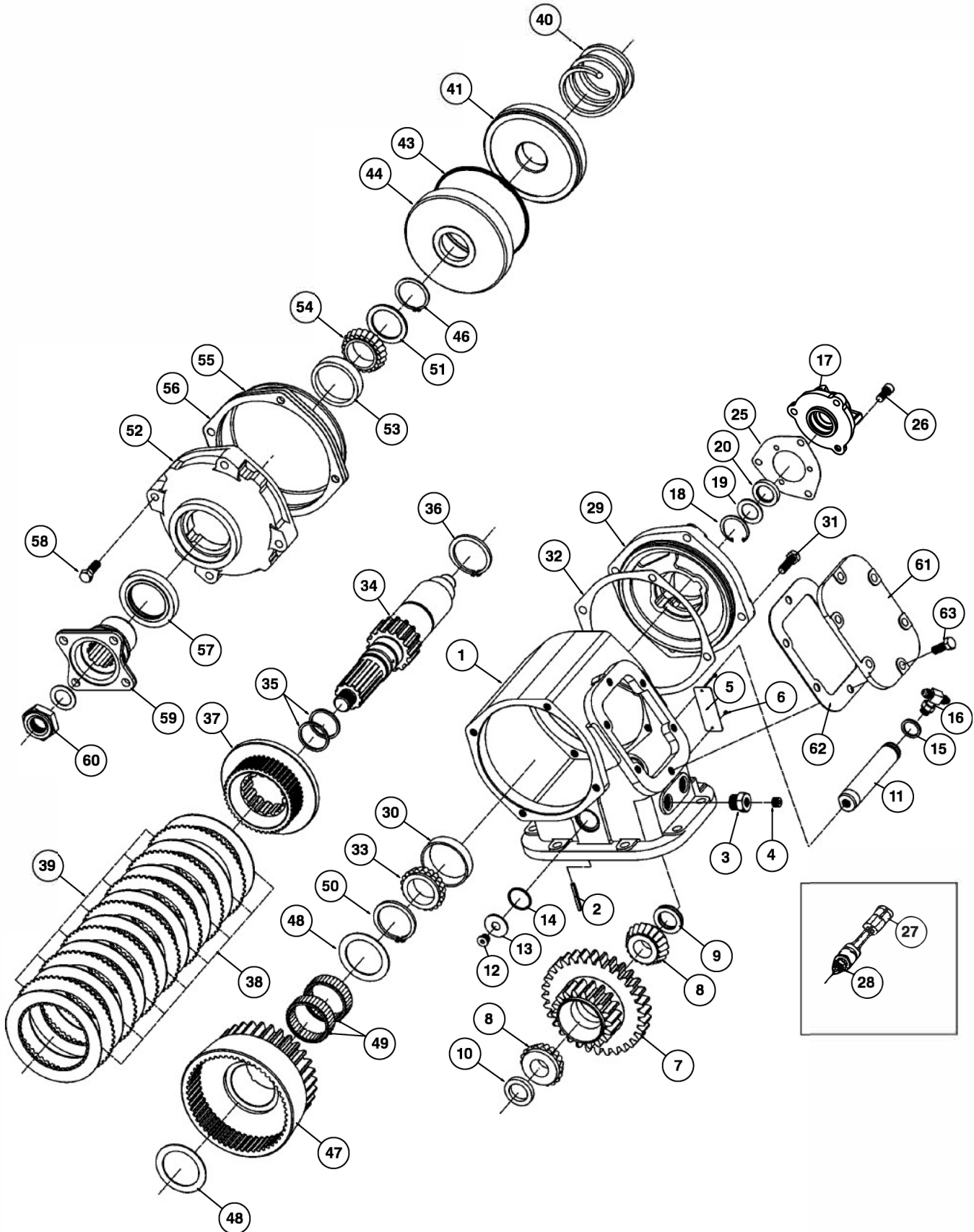
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Model Number Designator

NOTE: Not all options shown are current options available. See Chelsea Price List for current options.

* No longer a current option per 2018 Chelsea Suggested List Price.



Bill of Materials**Parts List
885 Series**

Item	Part Number	Description	Qty.
1	1-P-528X	PTO Housing, Standard Mount (Includes Item 2)	1
2	500597-16	Slotted Roll Pin (Included with Item 1)	1
3	379242	O-Ring Boss Plug (1 Req'd w/EOC)	2
4	379231	Pipe Plug (.125"-27 NPTF) (1 Req'd w/EOC)	2
5	68-P-2	Name Plate	1
6	378422	Drive Screw	2
7	See Page 6	Input Gear.....	1
8	560987	Tapered Bearing Cone (M Ratio).....	2
9	See Below	Input Bearing Spacer.....	1
	14-P-80-1	Bearing Adjusting Spacer (.110"-.112")	A/R
	14-P-80-2	Bearing Adjusting Spacer (.115"-.117")	A/R
	14-P-80-3	Bearing Adjusting Spacer (.120"-.122")	A/R
	14-P-80-4	Bearing Adjusting Spacer (.124"-.126")	A/R
10	14-P-81	Input Bearing Spacer.....	1
11	9-P-79	Idler Shaft (X Lube Option)	1 or
	9-P-80	Idler Shaft (P Lube Option)	1
12	379484	Straight Threaded Connector.....	1
13	379505	O-Ring Retainer.....	1
14	28-P-42	O-Ring (-023)	1
15	28-P-198	O-Ring (-117)	1
16	379556	Run Tee, O-Ring Boss	1
	21-P-644X	Cap and Seal Assembly (Includes 17-20)	1
17	21-P-644	Bearing Cap	1
18	378849	Retaining Ring.....	1
19	378811	Washer.....	1
20	28-P-179	Oil Seal (1.379" x .875" x .249").....	1
25	22-P-112	Valve Cap Gasket	1
26	378447-6	Hex Head Capscrew (.312"-18 x 1.000")	2
27	379243	Speed Sensor w/EOC.....	1
28	28-P-171	O-Ring w/EOC	1
29	See Below	Bearing Cap (Rear Side)	
	21-P-552	Bearing Cap Ass'y 4 & 6.....	1 or
	21-P-588	Bearing Cap Ass'y 3 & 5.....	1
30	560982	Tapered Bearing Cup.....	1
31	378431-18	Hex Head Capscrew .375"-16 x 2.000"	4
32	22-P-98	Bearing Cap Gasket	1

N.S. – Not Shown

A/R – As Required

Continued on Next Page

Bill of Materials**Parts List
885 Series**

Item	Part Number	Description	Qty.
33	560986	Tapered Bearing Cone (*AB & XV Output)	1
	560976	Tapered Bearing Cone (XS Output)	
	560985	Tapered Bearing Cone (*XY Output)	
34	329314-*X	Drive Shaft & Clutch Ass'y (See page 11 for options) (Includes Items 35-46).....	1
35	28-P-194	O-Ring	2
36	379465	Lockring	1
37	2-P-844	Inner Clutch Gear Assembly	1
38	379489	Clutch Plate (Friction)	8
39	379776	Clutch Plate (Steel)	7
40	37-P-24	Spring	1
41	379821	Piston, Clutch	1
43	28-P-260	O-Ring, Piston	1
44	379820	Backup Cylinder	1
46	379532	Lockring (XV)	1
	See Page 7	AB, XS & XV Options	1
47	See Page 6	Output Gear	1
48	31-P-92	Thrust Washer	2
49	560975	Caged Roller Bearing	2
50	379511	Lockring	1
51	4-P-76	Drive Shaft Spacer	1
	4-P-170	Drive Shaft Spacer (XS Only Ass'y 3 & 5)	1
52	See Below	Bearing Cap Ass'y (Output Side)	
	21-P-584	Bearing Cap Ass'y 3 & 5 (*AB & XV Output) (*AB & XV Output P Lube)	1
	21-P-517	Bearing Cap Ass'y 4 & 6 (*AB & XV Output)	1
	21-P-515	Bearing Cap Ass'y 4 & 6 (XS Output Only)	1
	21-P-586	Bearing Cap Ass'y 3 & 5 (XS Output Only)	1
	21-P-544	Bearing Cap Ass'y 4 & 6 (XS Output P Lube)	1
	21-P-645	Bearing Cap Ass'y 3 & 5 (XS Output P Lube)	1
	21-P-541	Bearing Cap Ass'y 4 & 6 (*XY Output Only)	1
	21-P-596	Bearing Cap Ass'y 4 & 6 (*AB & XV Output P Lube)	1
53	See Below	Tapered Bearing Cup	
	560977	Tapered Bearing Cup (XS Output)	1 or
	560984	Tapered Bearing Cup (*XY Output)	1 or
	560982	Tapered Bearing Cup (*AB & XV Output)	1
54	See Below	Tapered Bearing Cone	
	560976	Tapered Bearing Cone (XS Output)	1 or
	560985	Tapered Bearing Cone (*XY Output)	1 or
	560986	Tapered Bearing Cone (*AB & XV Output)	1 or
55	28-P-196	O-Ring (-258)	1
56	See Below	Shim, Bearing Cover	A/R
	55-P-20-1	Shim, Bearing Cover (.003" Green)	A/R
	55-P-20-2	Shim, Bearing Cover (.010" Brown)	A/R
	55-P-20-3	Shim, Bearing Cover (Yellow)	A/R
57	28-P-211	Oil Seal (*AB & XV Output)	1 or
	28-P-267	Oil Seal (*XY Output)	1 or
	28-P-219	Oil Seal (XS Output)	1

N.S. – Not Shown

A/R – As Required

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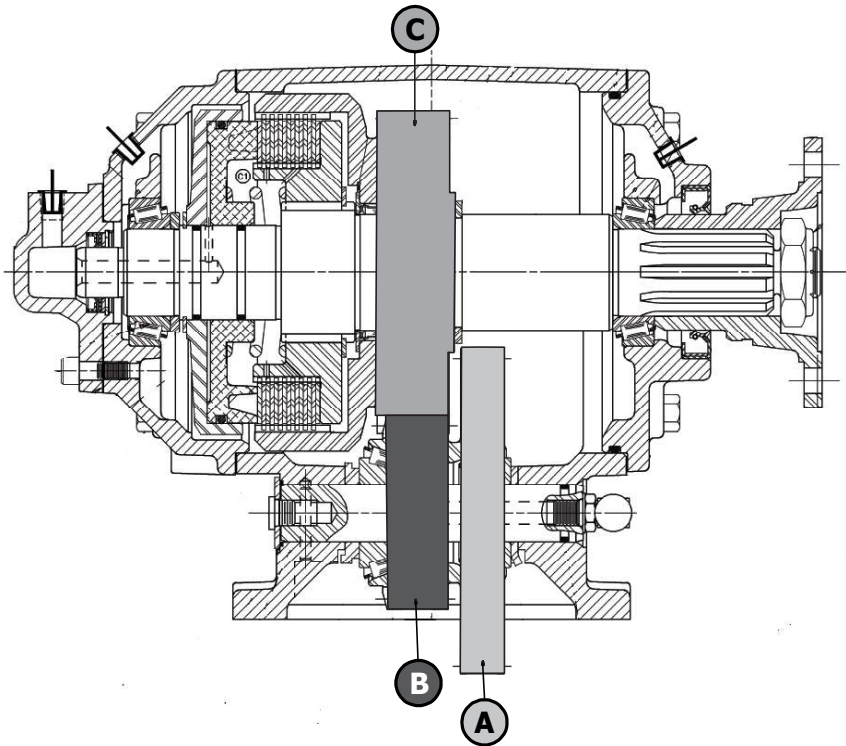
* No longer a current option per 2018 Chelsea Suggested List Price.

Bill of Materials**Parts List
885 Series**

Item	Part Number	Description	Qty.
58	378431-11	Hex Head Capscrew (.375"-16 x 1.125")	4
59	3-1-3431	Flange (1410 Series) (XV Output Only)	1
	379558	Flange (DIN 120 Series) (*AB Output)	1
60	380486X	Locknut (*AB & XV Output Only) with washer required	1
61	34-P-16	Cover	1
62	35-P-69	Gasket	1
63	378431CR-6	Hex Head Capscrew (.375"-16 x .625")	6
N.S.	500365-26	Flat Washer (used with item 63)	6
N.S.	379564-2	Shipping Cap (P Lube Only)	2
N.S.	379097	Inspection Tag	1
N.S.	See Below	Pipe Plug/Shipping Plug	2
N.S.	379231	Pipe Plug (.125"-27 NPTF) (X Lube Option) (1 Required w/EOC)	1
N.S.	500897-5	Shipping Plug (P Lube Option)	1
See pages 17-18 for Bill of Materials for the below loose parts.			
		GASKET KIT	
	328948-17X	Gasket & Installation Instructions	1
		STUD KITS	
	328170-179X	Stud Kit (Standard Mount)	1 or
	328170-201X	Stud Kit (Metric Mount)	1
		INSTALLATION KITS	1
	328388-50X	12V Installation Kit w/o EOC	1
	328388-51X	24V Installation Kit w/o EOC	1
	328388-52X	12V Installation Kit w/EOC	1
	328388-53X	24V Installation Kit w/EOC	1
	328388-71X	Installation Kit (V Option)	1
	328388-99X	Installation Kit (A Option)	1
	329650X	12V & 24V Control Box w/EOC	1
		HOSE ASSEMBLY KITS	
	329228X	Pressure Lube Mounting Kit (P Lube Only)	1
	329129-1X	Pressure Lube Hose (36" Long from end to end) (P Lube Only)	1
	329130-1X	Pressure Lube Hose (16.0"-15.5" Long from end to end) (P Lube Only)	1
	329130-3X	Pressure Lube Hose (20.0"-20.5" Long from end to end) (P Lube Only)	1
N.S. – Not Shown A/R – As Required			

* No longer a current option per 2018 Chelsea Suggested List Price.

Gear Chart

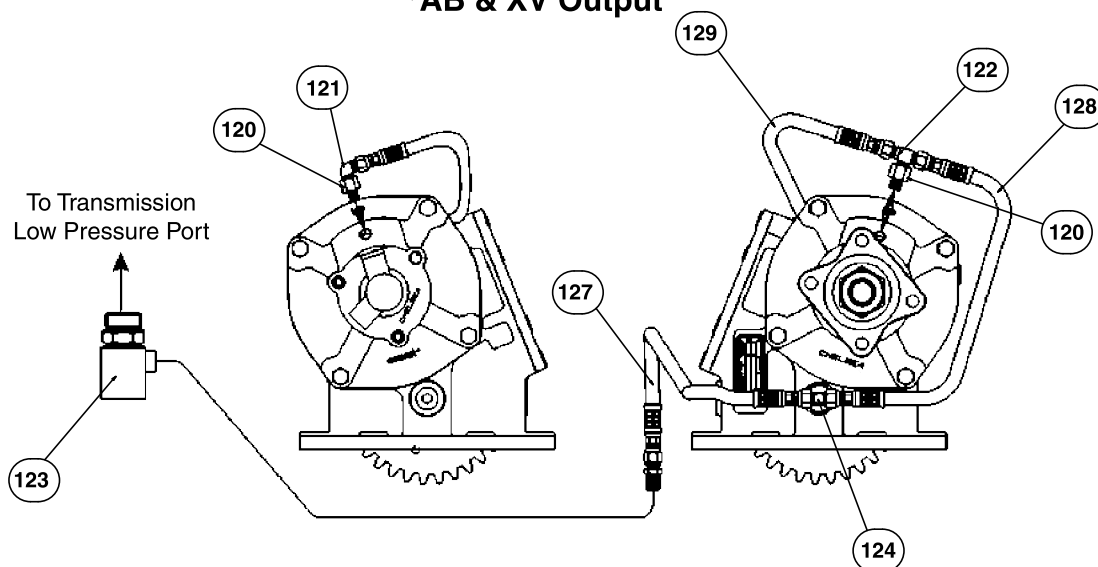


GEAR DESIGNATOR	INPUT GEARS	NO. TEETH A	HELIX ANGLE	NO. TEETH B	OUTPUT GEARS	NO. TEETH C
885*BAH	5-P-1100	32	SPUR	18	2-P-742	32
885*GAH	5-P-1135	32	SPUR	21	2-P-473	29
885*JAH	5-P-1102	32	SPUR	23	2-P-744	27
885*MAH	5-P-1103	32	SPUR	25	2-P-762	25
885*BAK	5-P-1106	32	SPUR	18	2-P-742	32
885*GAK	5-P-1108	32	SPUR	21	2-P-473	29
885*JAK	5-P-1109	32	SPUR	23	2-P-744	27
885*MAK	5-P-1110	32	SPUR	25	2-P-762	25
885*BDA	5-P-1120	35	SPUR	18	2-P-742	32
885*GDA	5-P-1174	35	SPUR	21	2-P-743	29
885*MDA	5-P-1121	35	SPUR	25	2-P-762	25
NOTE: Check Current Price Sheet for Availability of Input Options						

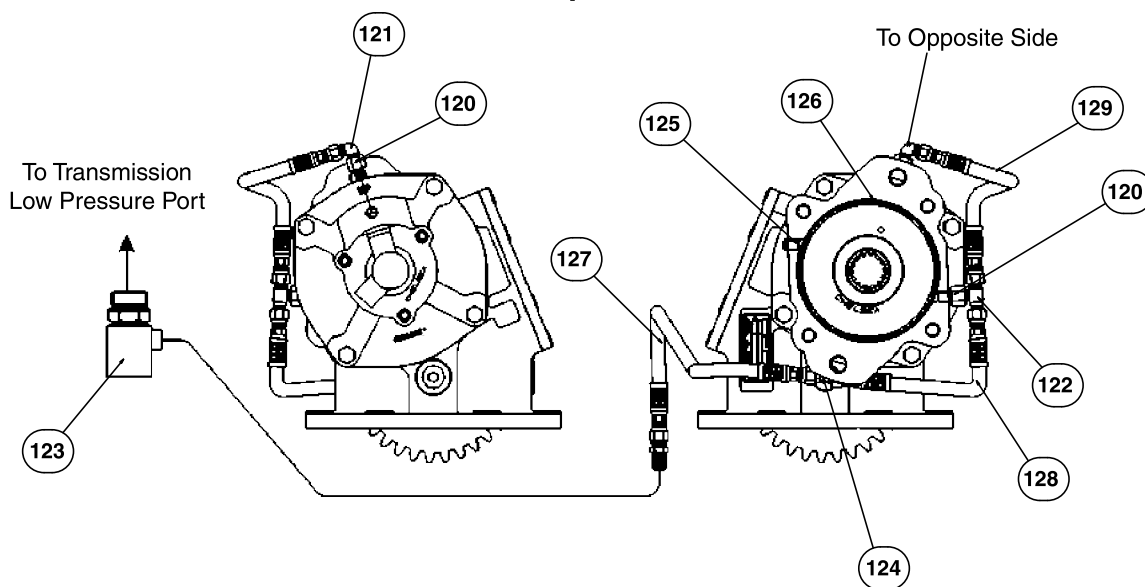
Pressure Lubrication Hose Plumbing

(SK-336 Rev C)

***AB & XV Output**



XS Output



Item	Part Number	Description	Qty.
	329228X	Pressure Lube Mounting Kit (Includes items 120, 121, 122 & 123)	1
120	379896	Pipe Adapter with .031" Orifice	2
121	379625	90° Male Elbow SAE 37° (JIC)	1
122	379627	Male Pipe Branch Tee to Male SAE 37° (JIC).....	1
123	378897	Street Tee.....	1
124	379556	Straight Thread O-Ring Branch Tee to Male 37° (JIC)	1
125	379231	Hex Socket Pipe Plug.....	1
126	28-P-245	O-Ring.....	1
127	329129-1X	Pressure Lube Hose, End to End Length 36.0"	1
128	329130-1X	Pressure Lube Hose, End to End Length 16.0"	1
129	329130-3X	Pressure Lube Hose, End to End Length 20.0"	1

* No longer a current option per 2018 Chelsea Suggested List Price.

Pressure Lube Output Options

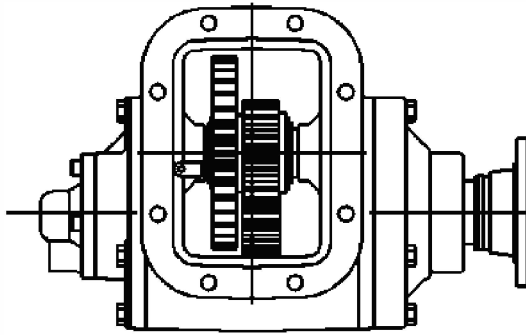
Output Suffix	Bearing Cap (52)		Output Shaft (34)	Drive Shaft & Clutch Ass'y (34-46)	Oil Seal (57)	Bearing Cup (53)	Bearing Cone (54)	Spacer (51)	Idle Shaft (11)
	Open	Closed							
885****P-*4XS	21-P-544	21-P-552	3-P-884	329314-3X	28-P-219	560977	560976	4-P-76	9-P-80
885****P-*6XS	21-P-544	21-P-552	3-P-884	329314-3X	28-P-219	560977	560976	4-P-76	9-P-80
885****P-*3XS	21-P-645	21-P-588	3-P-898	329314-4X	28-P-219	560977	560976	4-P-170	9-P-80
885****P-*5XS	21-P-645	21-P-588	3-P-898	329314-4X	28-P-219	560977	560976	4-P-170	9-P-80
885****P-*4XV	21-P-596	21-P-552	3-P-883	329314-1X	28-P-211	560982	560986	4-P-76	9-P-80
885****P-*6XV	21-P-596	21-P-552	3-P-883	329314-1X	28-P-211	560982	560986	4-P-76	9-P-80
885****P-*3XV	21-P-584	21-P-588	3-P-897	329314-2X	28-P-211	560982	560986	4-P-76	9-P-80
885****P-*5XV	21-P-584	21-P-588	3-P-897	329314-2X	28-P-211	560982	560986	4-P-76	9-P-80
*885****P-*4AB	21-P-596	21-P-552	3-P-883	329314-1X	28-P-211	560982	560986	4-P-76	9-P-80
*885****P-*6AB	21-P-596	21-P-552	3-P-883	329314-1X	28-P-211	560982	560986	4-P-76	9-P-80
*885****P-*3AB	21-P-584	21-P-588	3-P-897	329314-2X	28-P-211	560982	560986	4-P-76	9-P-80
*885****P-*5AB	21-P-584	21-P-588	3-P-897	329314-2X	28-P-211	560982	560986	4-P-76	9-P-80

Non-Pressure Lube Output Options

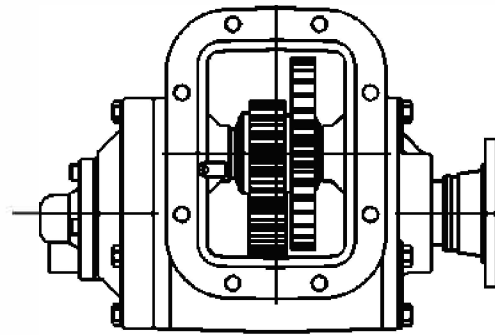
Output Suffix	Bearing Cap (52)		Output Shaft (34)	Drive Shaft & Clutch Ass'y (34-46)	Oil Seal (57)	Bearing Cup (53)	Bearing Cone (54)	Spacer (51)	Idle Shaft (11)
	Open	Closed							
885****X-*4XS	21-P-515	21-P-552	3-P-884	329314-3X	28-P-219	560977	560976	4-P-76	9-P-79
885****X-*6XS	21-P-515	21-P-552	3-P-884	329314-3X	28-P-219	560977	560976	4-P-76	9-P-79
885****X-*3XS	21-P-586	21-P-588	3-P-898	329314-4X	28-P-219	560977	560976	4-P-170	9-P-79
885****X-*5XS	21-P-586	21-P-588	3-P-898	329314-4X	28-P-219	560977	560976	4-P-170	9-P-79
885****X-*4XV	21-P-517	21-P-552	3-P-883	329314-1X	28-P-211	560982	560986	4-P-76	9-P-79
885****X-*6XV	21-P-517	21-P-552	3-P-883	329314-1X	28-P-211	560982	560986	4-P-76	9-P-79
885****X-*3XV	21-P-584	21-P-588	3-P-897	329314-2X	28-P-211	560982	560986	4-P-76	9-P-79
885****X-*5XV	21-P-584	21-P-588	3-P-897	329314-2X	28-P-211	560982	560986	4-P-76	9-P-79
*885****X-*4XY	21-P-541	21-P-552	3-P-885	329314-5X	28-P-267	560984	560985	4-P-76	9-P-79
*885****X-*6XY	21-P-541	21-P-552	3-P-885	329314-5X	28-P-267	560984	560985	4-P-76	9-P-79
*885****X-*4AB	21-P-517	21-P-552	3-P-883	329314-1X	28-P-211	560982	560986	4-P-76	9-P-79
*885****X-*6AB	21-P-517	21-P-552	3-P-883	329314-1X	28-P-211	560982	560986	4-P-76	9-P-79
*885****X-*3AB	21-P-584	21-P-588	3-P-887	329314-2X	28-P-211	560982	560986	4-P-76	9-P-79
*885****X-*5AB	21-P-584	21-P-588	3-P-887	329314-2X	28-P-211	560982	560986	4-P-76	9-P-79

For Drive Shaft & Clutch Assembly Bill of Materials, See [Page 17](#)

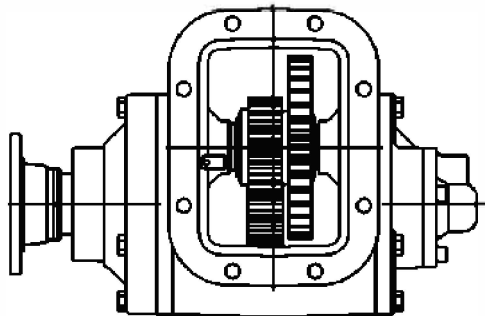
* No longer a current option per 2018 Chelsea Suggested List Price.



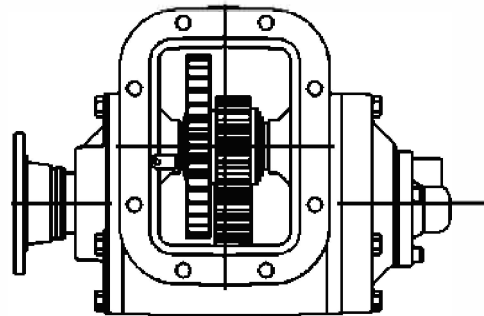
Ass'y 3



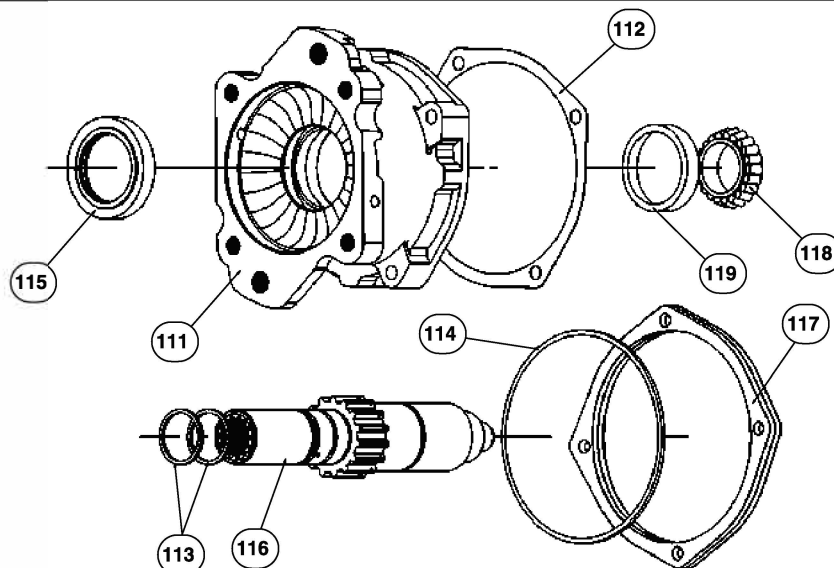
Ass'y 4



Ass'y 5



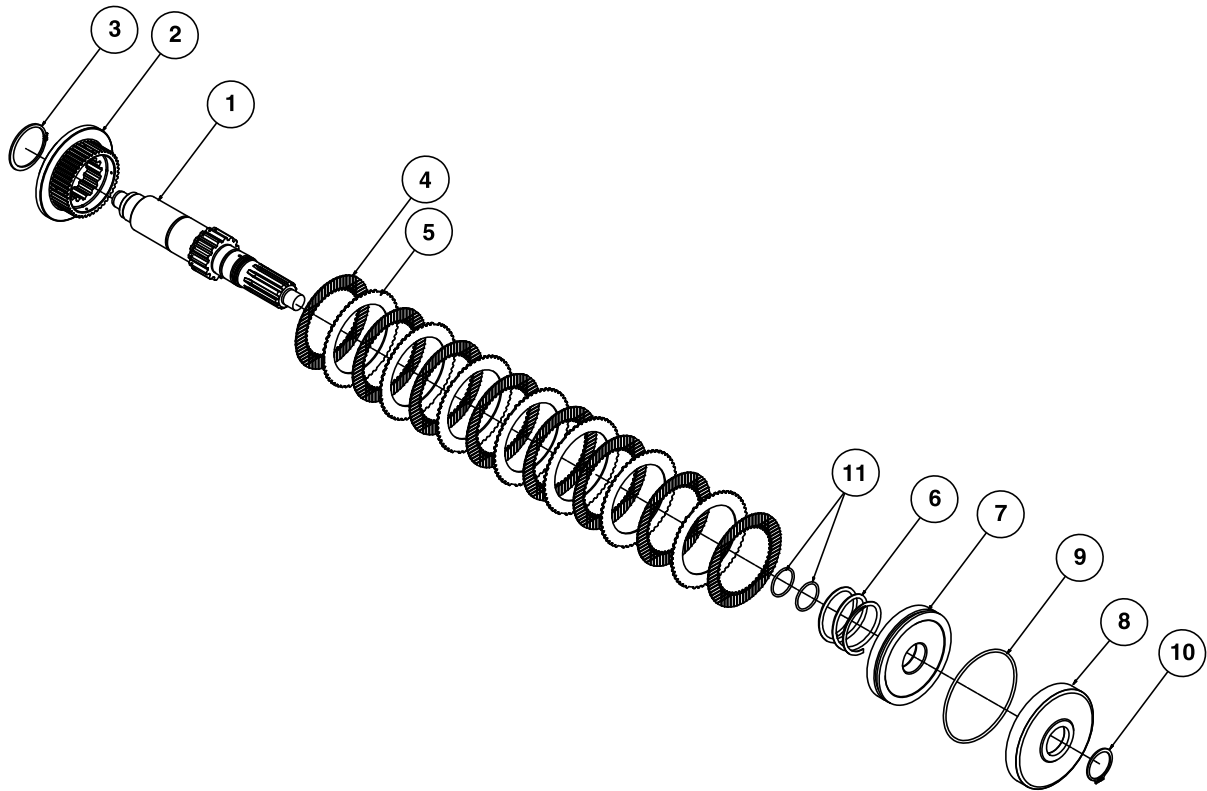
Ass'y 6



Item	Part Number	Description	Qty.
	328591-57X	3 & 5 Assembly XS Conversion Only	
		Class C 2 & 4-Bolt Pump Mounting	
111	21-P-568	Bearing - Cap.....	1
112	22-P-98	Gasket	1
113	28-P-194	O-Ring	1
114	28-P-196	O-Ring	1
115	28-P-219	Oil Seal	1
116	3-P-898	XS Shaft for Ass'y.....	1
117	55-P-20-1	Shim, Bearing Cover.....	2
	55-P-20-2	Shim, Bearing Cover.....	2
	55-P-20-3	Shim, Bearing Cover.....	2
118	560976	Bearing - Tapered Cone 1.6255" x .778"	1
119	560977	Bearing - Tapered Cup 2.892" x .580"	1
	328591-37X (NLA)	4 & 6 Assembly XS Conversion	
		Class C 2 & 4-Bolt Pump Mounting (includes items 111 thru 119)	
111	21-P-544	Bearing Cap.....	1
112	22-P-98	Bearing Cap Gasket	1
113	28-P-194	O-Ring	2
114	28-P-196	O-Ring	1
115	28-P-219	Oil Seal	1
116	3-P-884	Output Shaft.....	1
117	55-P-20-1	Shim, Bearing Cover (Green)	2
	55-P-20-2	Shim, Bearing Cover (Brown)	2
	55-P-20-3	Shim, Bearing Cover (Yellow)	1
118	560976	Bearing - Tapered Cone (XS Output) 1.6255" x .778"	1
119	560977	Bearing - Tapered Cup (XS Output) 2.892" x .580"	
	328591-38X (NLA)	4 & 6 Assembly XY Conversion (3 & 5 Not Available)	
		Meiller Pump Mount DIN 80mm (includes items 111 thru 119)	
111	21-P-541	Bearing Cap.....	1
112	22-P-98	Bearing Cap Gasket	1
113	28-P-194	O-Ring	1
114	28-P-196	O-Ring	1
115	28-P-267	Oil Seal	1
116	3-P-885	Output Shaft.....	1
117	55-P-20-1	Shim, Bearing Cover (Green)	2
	55-P-20-2	Shim, Bearing Cover (Brown)	2
	55-P-20-3	Shim, Bearing Cover (Yellow)	2
118	560984	Bearing - Tapered Cone (XY Output) 2.875" x .5938"	1
119	560985	Bearing - Tapered Cup (XY Output) 1.750" x .7188"	1

NLA – No Longer Available

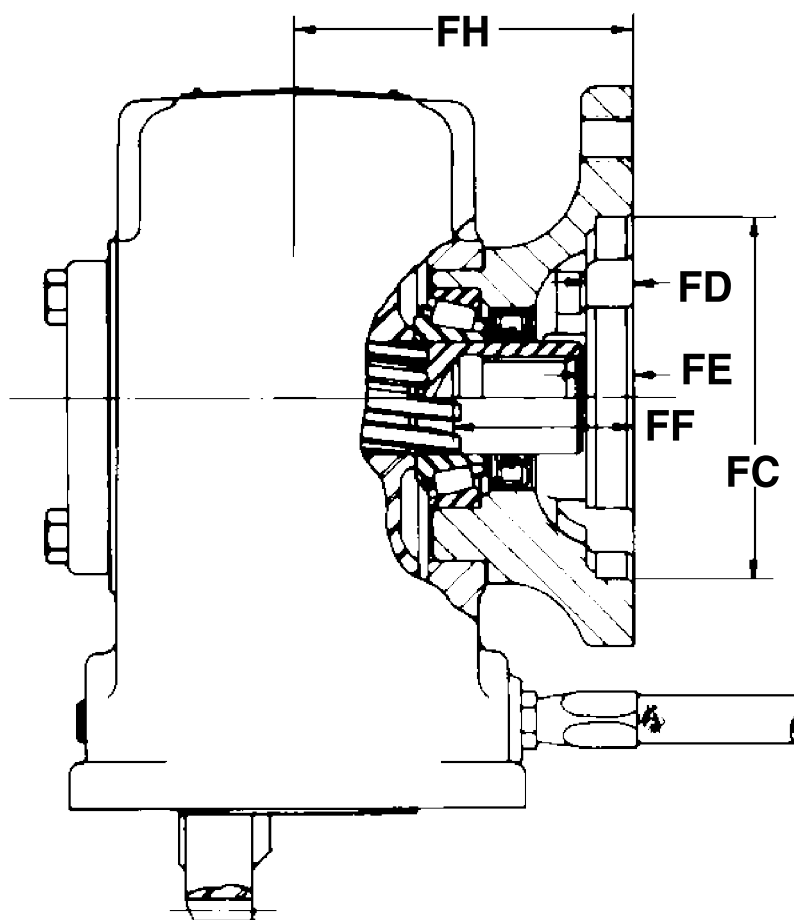
Drive Shaft & Clutch Assembly 329314-*X



Item	Part Number	Description	Qty.
1	3-P-883	Output Shaft (XV & *AB 4 & 6) (329314-1X)	1 or
	3-P-887	Output Shaft (XV & *AB 3 & 5) (329314-2X)	1 or
	3-P-884	Output Shaft (XS 4 & 6) (329314-3X)	1 or
	3-P-898	Output Shaft (XS 3 & 5) (329314-4X)	1 or
	3-P-885	Output Shaft (*XY 4 & 6) (329314-5X)	1
2	2-P-844	Inner Clutch Gear	1
3	379532	Lockring	1
4	379489	Friction Disc	8
5	379776	Clutch Plate	7
6	37-P-24	Spring 2.531" x 2.13"	1
7	379821	Piston Clutch	1
8	379820	Back-Up Cylinder Clutch	1
9	28-P-260	O-Ring 4.984" x .139"	1
10	379465	Lockring	1
11	28-P-194	O-Ring 1.424" x .103"	2

* No longer a current option per 2018 Chelsea Suggested List Price.

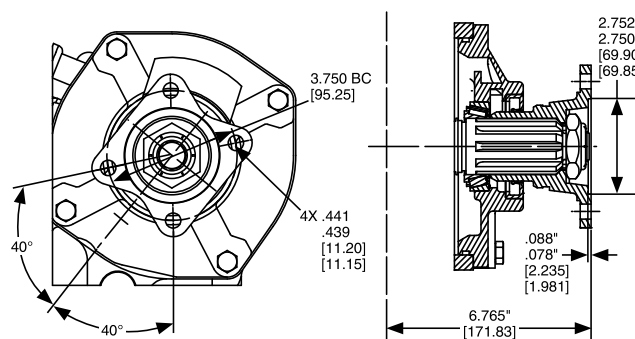
PTO Case Pump Flange & Shaft Dimensions



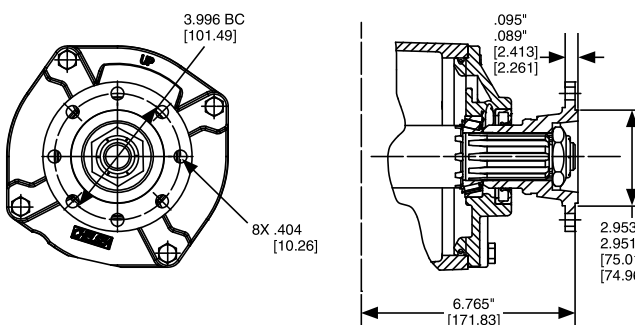
Pump Flange Suffix	Bolt Circle Dia.	Bolt Holes		FC	FD	FE	FF	FH	Output Shaft
		Tapped Hole	No. Equally Spaced	Female Pilot Diameter	Pilot Depth	Face to end of Shaft	Face thru Hole	Face to Center of PTO	Shaft Data
XS	7.125"	.625" - 11 UNC-2B	2	5.003"	0.531"	0.699"	2.574"	6.196"	1-1/4" - 14T Involute
	4.508"	.500" - 13 UNC-2B	4						
✧ AB	3.996"	N/A	8	2.952"	0.092"	N/A	N/A	6.765"	N/A
✧ XY	3.150"	M12-17.75"	4	3.152"	0.394"	0.516"	2.500"	6.177"	DIN 5462
XV	3.750"	.400" thru holes	4	2.751"	0.089"	N/A	N/A	6.765"	1-1/2" - 10T Spur

✧ No longer a current option per 2018 Chelsea Suggested List Price.

Bill of Materials – Driveline Output

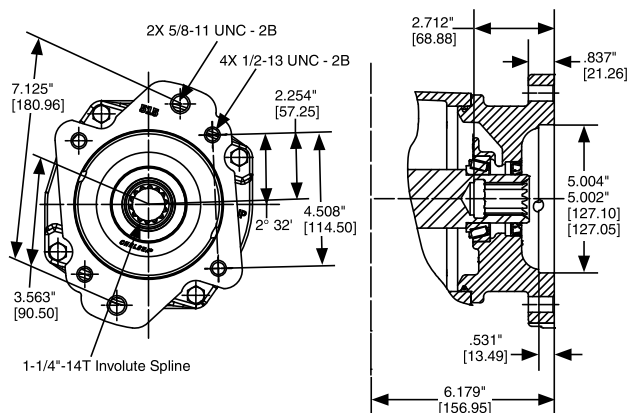


XV Output Option 1410 Series Companion Flange		
Part Number	Description	Qty.
21-P-517	Bearing Cap Ass'y 4 & 6.....	1
21-P-584	Bearing Cap Ass'y 3 & 5.....	1
21-P-596	Bearing Cap Ass'y 4 & 6 (P Lube).....	1
28-P-211	Oil Seal.....	1
378431-11	Hex Capscrew .375\"-16 x 1.125\".....	1
560982	Tapered Bearing Cone.....	1
560986	Tapered Bearing Cone.....	1
378382	Locknut.....	1
3-1-3431	Spicer 1410 Series Flange.....	1

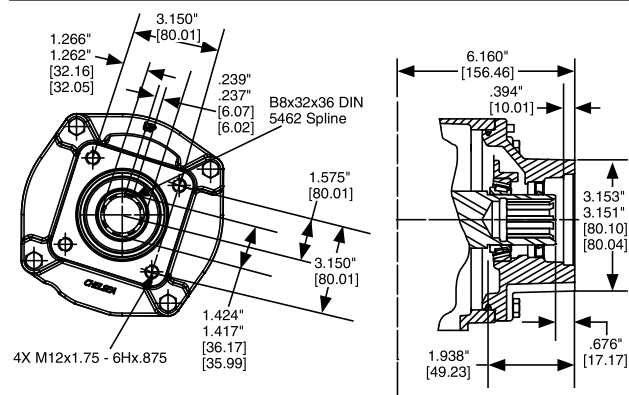


*AB Output Option DIN 120 Flange		
Part Number	Description	Qty.
21-P-517	Bearing Cap Ass'y 4 & 6.....	1
21-P-584	Bearing Cap Ass'y 3 & 5.....	1
21-P-596	Bearing Cap Ass'y 4 & 6 (P Lube).....	1
28-P-211	Oil Seal.....	1
378431-11	Hex Capscrew .375\"-16 x 1.125\".....	1
560982	Tapered Bearing Cone.....	1
560986	Tapered Bearing Cone.....	1
378382	Locknut.....	1
3-1-3431	Spicer 1410 Series Flange.....	1

Bill of Materials – Pump Mount



XS Output Option SAE C 2 or 4-Bolt Flange, SAE C Shaft (1-1/4 - 14T)		
Part Number	Description	Qty.
21-P-515	Bearing Cap Ass'y 4 & 6.....	1
21-P-586	Bearing Cap Ass'y 3 & 5.....	1
21-P-544	Bearing Cap Ass'y 4 & 6 (P Lube).....	1
21-P-645	Bearing Cap Ass'y 3 & 5 (P Lube).....	1
28-P-219	Oil Seal.....	1
378431-11	Hex Capscrew .375\"-16 x 1.125\".....	1
560977	Tapered Bearing Cone.....	1
560976	Tapered Bearing Cone.....	1

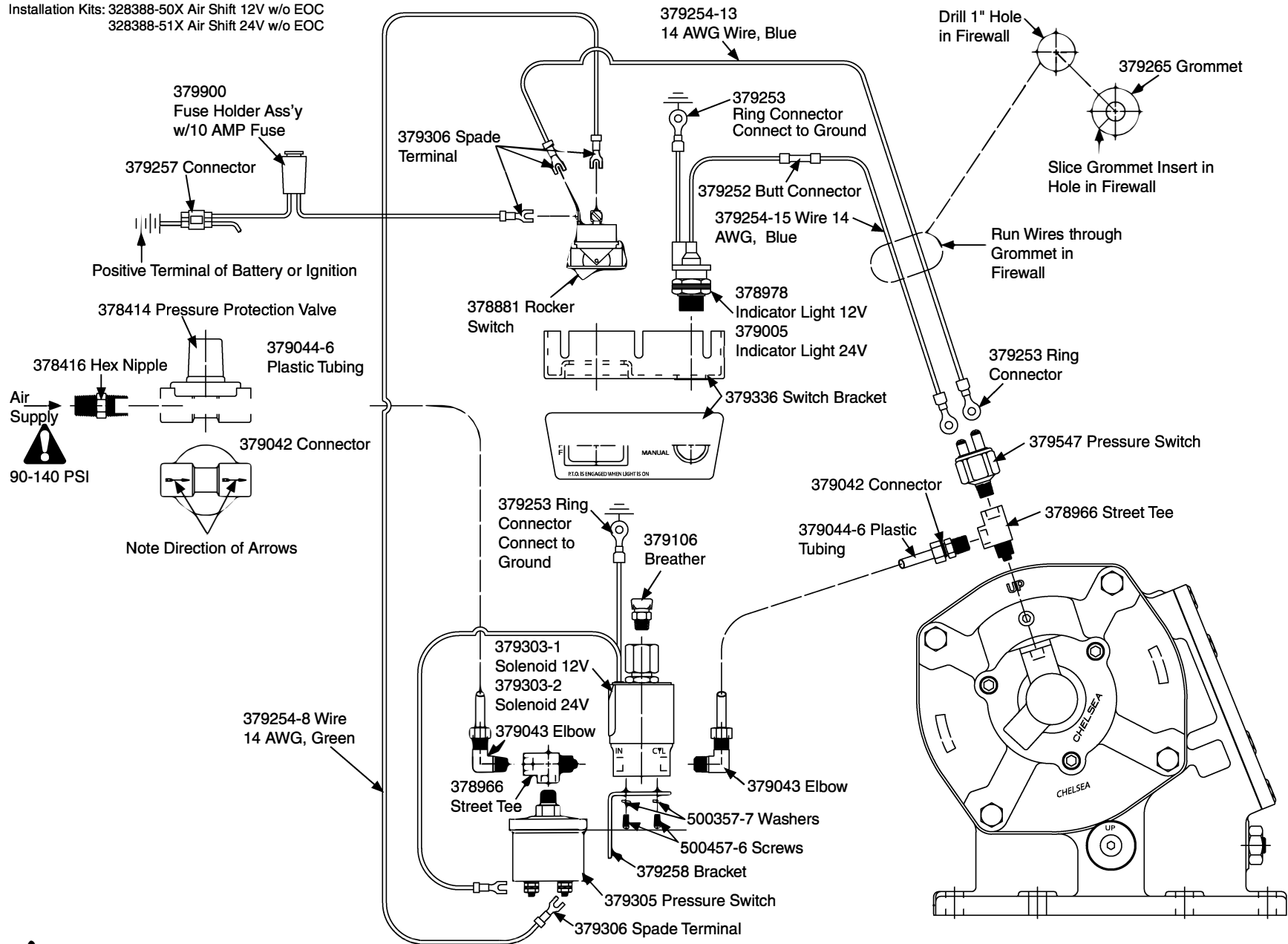


*XY Output Option Meiller Pump		
Part Number	Description	Qty.
21-P-515	Bearing Cap Ass'y 4 & 6.....	1
21-P-586	Bearing Cap Ass'y 3 & 5.....	1
21-P-544	Bearing Cap Ass'y 4 & 6 (P Lube).....	1
21-P-645	Bearing Cap Ass'y 3 & 5 (P Lube).....	1
28-P-219	Oil Seal.....	1
378431-11	Hex Capscrew .375\"-16 x 1.125\".....	1
560977	Tapered Bearing Cone.....	1
560976	Tapered Bearing Cone.....	1

* No longer a current option per 2018 Chelsea Suggested List Price.

Sh ft Option P (12V), Q (24V)
EI c/Air w/o EOC

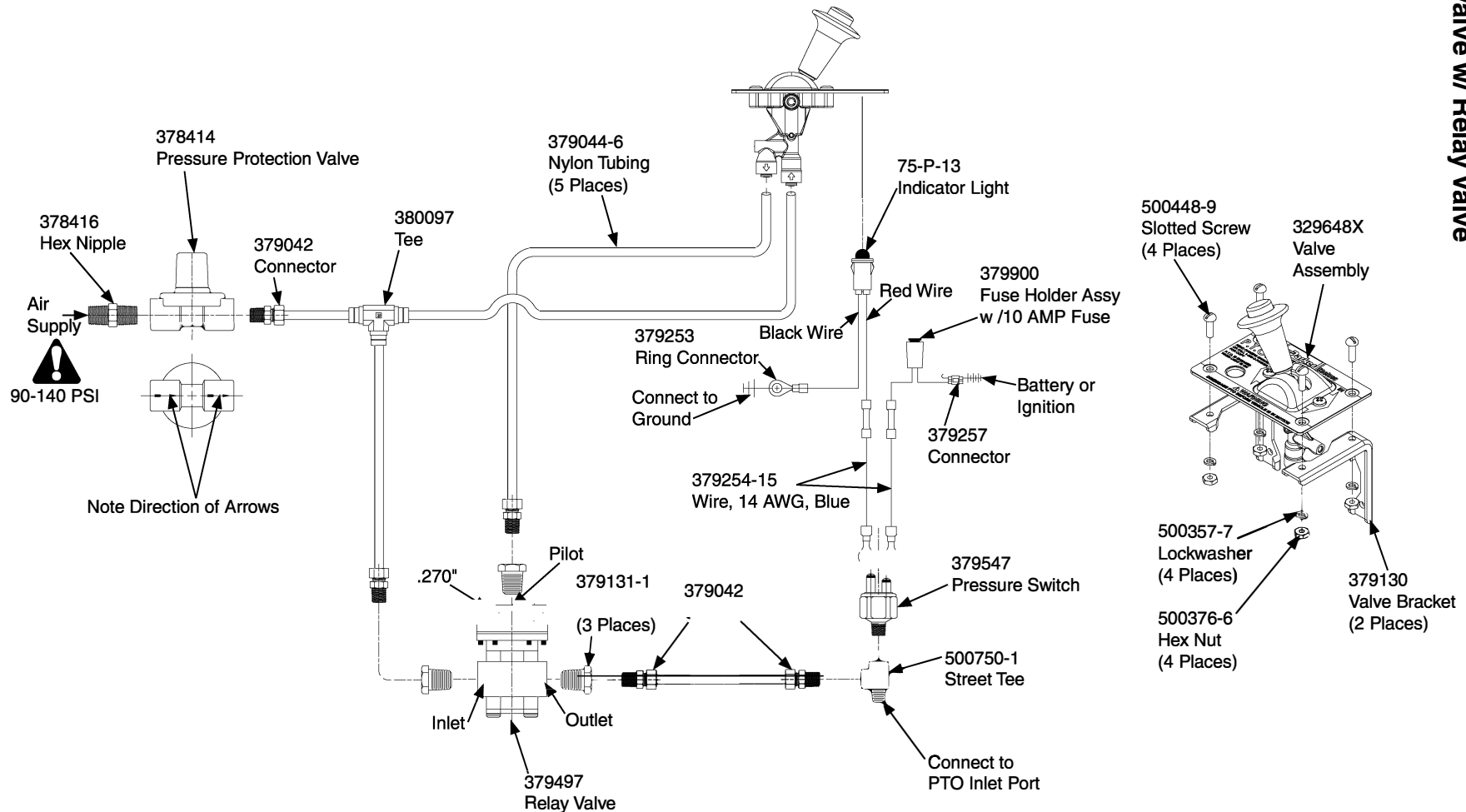
Installation Kits: 328388-50X Air Shift 12V w/o EOC
328388-51X Air Shift 24V w/o EOC



WARNING: Connect directly to air supply. Do not use tubing between air supply and pressure protection valve.
NOTE: Strip Wire ends .25" Prior to Installing in Connectors

(SK-301 Rev D)

Shift Option A
Manual Air Valve w/ Relay Valve



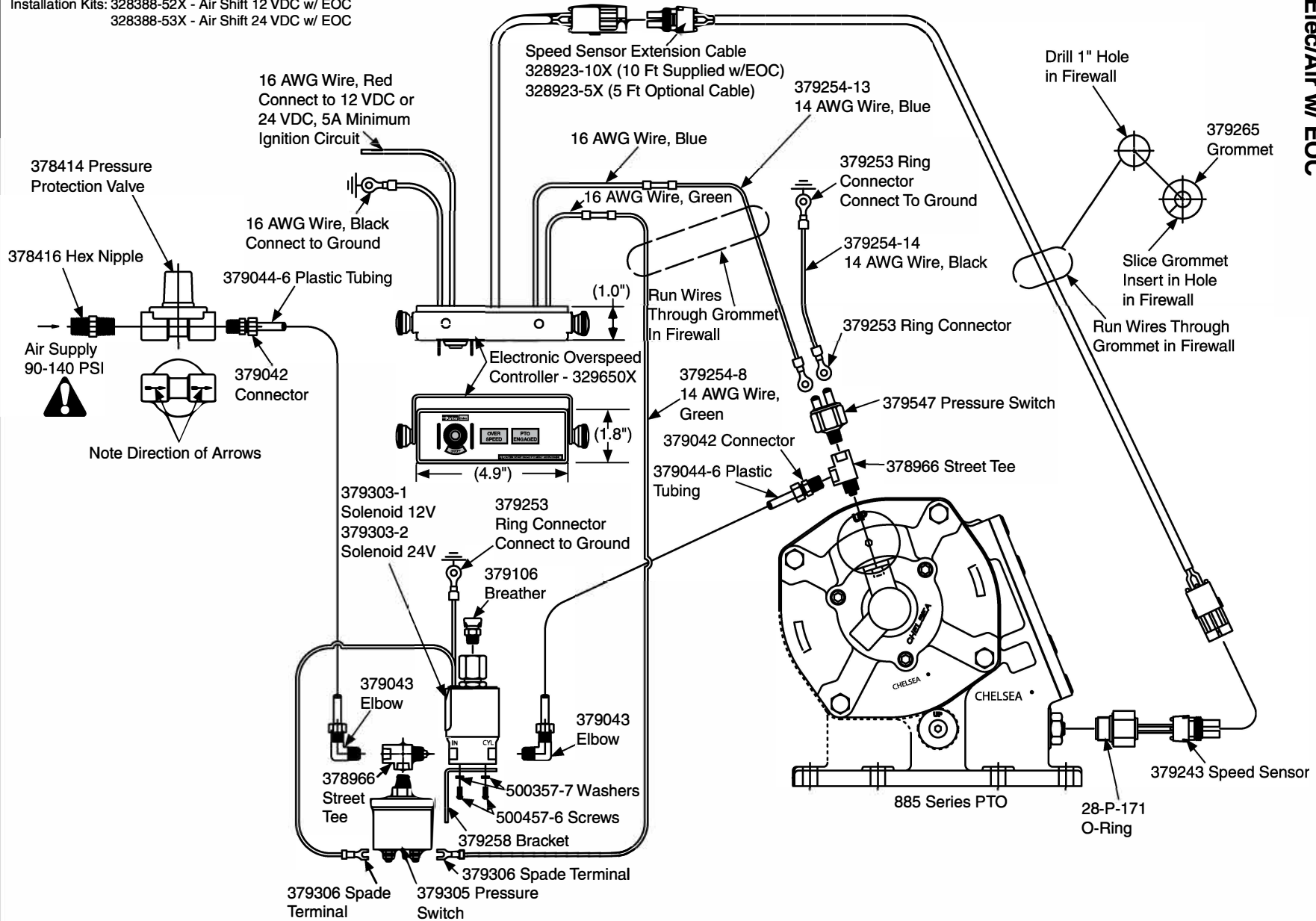
WARNING: Connect directly to air supply. Do not use tubing between air supply and pressure protection valve.

Caution: When installing nylon tubing avoid sharp angles, exhaust and manifold systems.

See SK-204 Drilling Template for Control Plate in HY25-1240-M1/US Owner's Manual

Shift Option N (12V), J (24V)
Elec/Air w/ EOC

Installation Kits: 328388-52X - Air Shift 12 VDC w/ EOC
328388-53X - Air Shift 24 VDC w/ EOC



WARNING: Connect directly to air supply. Do not use tubing between air supply and pressure protection valve.
NOTE: Strip Wire Ends .25" Prior to Installing in Connectors

(SK-468 Rev A)

Part Number	Description	Qty.
GASKET KITS		
328948-17X	Gasket and Installation Kit	
328946X	Caution Label Kit	1
35-P-15-1	Gasket,Housing .010	2
35-P-15-2	Gasket, Housing .020	2
379085-2	Instructions Label	1
379624	Card Product Warranty	1
Owners Manual	HY25-1240-M1/US	1
Safety Guide	HY25-1002-M1/US	1

Part Number	Description	Qty.
STUD KITS		
328170-179X	Stud Kit (Standard Mount)	
379424-21	Stud .438"	8
379745	Flange Nut	8

328170-201X	Stud Kit (Metric Mount)	
379745	Flange Nut	8
379429-19	Metric Stud	8

Part Number	Description	Qty.
INSTALLATION KITS		
329314-1X	Drive Shaft & Clutch Ass'y (XV & *AB 4 & 6)	
28-P-194	O-Ring	2
3-P-883	Standard Shaft.....	1
2-P-844	Gear Clutch	1
37-P-24	Spring	1
379465	Lockring	1
379489	Friction Disc.....	8
379532	Lockring	1
28-P-260	O-Ring	1
379820	Backup Cylinder	1
379821	Clutch Piston	1
379776	Clutch Plate	7

329314-2X	Drive Shaft & Clutch Ass'y (XV & *AB 3 & 5)	
28-P-194	O-Ring	2
3-P-897	Standard Shaft.....	1
28-P-260	O-Ring	1
379820	Backup Cylinder	1
379821	Clutch Piston	1
2-P-844	Gear Clutch	1
37-P-24	Spring	1
379465	Lockring	1
379489	Friction Disc.....	8
379532	Lockring	1
379776	Clutch Plate	7

* No longer a current option per 2018 Chelsea Suggested List Price.

BOMs in each kit group are listed in order based on part number.

Part Number	Description	Qty.
INSTALLATION KITS (Cont'd)		
329314-3X	Drive Shaft & Clutch Ass'y (XS 4&6)	
28-P-194	O-Ring	2
3-P-884	Output Shaft	1
28-P-260	O-Ring	1
379820	Backup Cylinder	1
379821	Clutch Piston	1
2-P-844	Gear Clutch	1
37-P-24	Spring	1
379465	Lockring	1
379489	Friction Disc.....	8
379532	Lockring	1
379776	Clutch Plate	7

329314-4X	Drive Shaft & Clutch Ass'y (XS 3&5)	
28-P-194	O-Ring	2
3-P-898	Output Shaft	1
28-P-260	O-Ring	1
379820	Backup Cylinder	1
379821	Clutch Piston	1
2-P-844	Gear Clutch	1
37-P-24	Spring	1
379465	Lockring	1
379489	Friction Disc.....	8
379532	Lockring	1
379776	Clutch Plate	7

329314-5X	Drive Shaft & Clutch Ass'y (*XY 4&6)	
28-P-194	O-Ring	2
3-P-885	Output Shaft	1
28-P-260	O-Ring	1
379820	Backup Cylinder	1
379821	Clutch Piston	1
2-P-844	Gear Clutch	1
37-P-24	Spring	1
379465	Lockring	1
379489	Friction Disc.....	8
379532	Lockring	1
379776	Clutch Plate	7

328388-50X	12V Installation Kit w/o EOC	
328388-49X	Air Shift	1
378414	Pressure Protection Valve.....	1
378881	Rocker Switch.....	1
378978	Indicator Light	1
379044-6	Nylon Tubing	1
379253	Ring Connector.....	1
379254-13	Wire, Blue	1
379254-15	Wire Ring	1
379254-8	Wire/Fork	1
379303-1	Valve 12V	1
379305	Pressure Switch.....	1
379306	Fork Connector	4
379336	Switch Bracket	1
379640	Booted Connector.....	1
379900	Fuse Ass'y	1

Continued on Next Page

Part Number	Description	Qty.	Part Number	Description	Qty.
328388-51X 24V Installation Kit w/o EOC			328388-99X 24V Installation Kit (A Option)		
379900	Fuse Ass'y.....	1	328931X	Valve Kit.....	1
328388-49X	Air Shift.....	1	500357-7	Lockwasher	4
378414	Pressure Protection Valve	1	500376-6	Nut 10-24.....	4
378881	Rocker Switch.....	1	500448-9	Screw Slot	4
379005	Indicator Light.....	1	329090-6X	Valve Kit.....	1
379044-6	Nylon Tubing.....	1	378416	Hex Nipple	1
379253	Ring Connector.....	1	379042	Male Connector	5
379254-13	Wire, Blue	1	379044-6	Nylon Tubing	1
379254-15	Wire Ring.....	1	379130	Support Bracket.....	2
379254-8	Wire/Fork.....	1	379131-1	Reducer Bushing.....	3
379303-2	Valve 24V	1	379253	Ring Connector.....	1
379305	Pressure Switch.....	1	379254-15	Wire Ring.....	2
379306	Fork Connector.....	4	379257	Splice Connector	1
379336	Switch Bracket.....	1	379497	Pilot Valve	1
379640	Booted Connector.....	1	379547	Pressure Switch.....	1
328388-52X 12V Installation Kit w/EOC			379900	Fuse Ass'y.....	1
328388-49X	Air Shift.....	1	380097	Tee-Union, .250" Tube	1
329650X	Control Box 12V/24V (w/EOC)	1	500750-1	Tee Street, .125"-27	1
378414	Pressure Protection Valve	1	75-P-13	Indicator Light.....	1
379044-6	Nylon Tubing.....	1	329650X 12V & 24V Control Box w/EOC		
379254-13	Wire, Blue	1	328923-10X	Speed Sensor Cable 10 ft.....	1
379254-14	Wire, Black	1	Owners Manual	HY25-1650-M1/US	1
379254-8	Wire/Fork.....	1	329228X Pressure Lube Kit		
379303-1	Solenoid Valve 12V.....	1	379896	Adapter Straight Restriction (.125"-27).....	2
379305	Pressure Switch.....	1	379625	90° Elbow (.125"-27 x .438"-20)	1
379306	Fork Connector.....	1	379627	Tee (.125"-27).....	1
379106	Breather Cap	1	378897	Adapter Tee Street 1.3125-12.....	1
328388-53X 24V Installation Kit w/EOC			SK-336	Pressure Lube Installation Sketch	1
328388-49X	Air Shift.....	1			
329650X	Control Box 12V/24V (w/EOC)	1			
378414	Pressure Protection Valve	1			
379044-6	Nylon Tubing.....	1			
379254-13	Wire, Blue	1			
379254-14	Wire, Black	1			
379254-8	Wire/Fork.....	1			
379303-2	Solenoid Valve 24V.....	1			
379305	Pressure Switch.....	1			
379306	Fork Connector.....	1			
328388-71X 24V Installation Kit (V Option)					
379547	Pressure Switch.....	1			
378966	Street Tee	2			
379305	Pressure Switch.....	1			
379106	Breather Cap	1			
379303-2	Solenoid Valve 24V.....	1			
500357-7	Lockwasher	2			
500457-6	Slotted Screw	2			
379258	Bracket.....	1			
378414	Pressure Protection Valve	1			

BOMs in each kit group are listed in order based on part number.

Parker Hannifin Corporation – Chelsea Division

Offer of Sale

The items described in this document and other documents and descriptions provided by Parker Hannifin Corporation, its subsidiaries and its authorized distributors ("Seller") are hereby offered for sale at prices to be established by Seller. This offer and its acceptance by any customer ("Buyer") shall be governed by all of the following Terms and Conditions. Buyer's order for any item described in its document, when communicated to Seller verbally, or in writing, shall constitute acceptance of this offer. All goods, services or work described will be referred to as "Products".

1. Terms and Conditions. Seller's willingness to offer Products, or accept an order for Products, to or from Buyer is subject to these Terms and Conditions or any newer version of the terms and conditions found on-line at www.parker.com/saleterms/. Seller objects to any contrary or additional terms or conditions of Buyer's order or any other document issued by Buyer.

2. Price Adjustments; Payments. Prices stated on Seller's quote or other documentation offered by Seller are valid for 30 days, and do not include any sales, use, or other taxes unless specifically stated. Unless otherwise specified by Seller, all prices are F.C.A. Seller's facility (INCOTERMS 2010). Payment is subject to credit approval and is due 30 days from the date of invoice or such other term as required by Seller's Credit Department, after which Buyer shall pay interest on any unpaid invoices at the rate of 1.5% per month or the maximum allowable rate under applicable law.

3. Delivery Dates; Title and Risk; Shipment. All delivery dates are approximate and Seller shall not be responsible for any damages resulting from any delay. Regardless of the manner of shipment, title to any products and risk of loss or damage shall pass to Buyer upon placement of the products with the shipment carrier at Seller's facility. Unless otherwise stated, Seller may exercise its judgment in choosing the carrier and means of delivery. No deferment of shipment at Buyer's request beyond the respective dates indicated will be made except on terms that will indemnify, defend and hold Seller harmless against all loss and additional expense. Buyer shall be responsible for any additional shipping charges incurred by Seller due to Buyer's acts or omissions.

4. Warranty. Seller warrants that all products sold, other than the 590 Series, conform to the applicable Parker Chelsea standard specification for the lesser period of 2 years (24 Months) from date of service or 2-1/2 years (30 Months) from date of build (as marked on the product name plate). Seller warrants that the 590 Series will conform to the applicable Seller standard specification for the lesser period of 2 years (24 Months) from date of service or 2000 hours of usage. The prices charged for Seller's products are based upon the exclusive limited warranty stated above, and upon the following disclaimer: **DISCLAIMER OF WARRANTY: THIS WARRANTY COMPRISES THE SOLE AND ENTIRE WARRANTY PERTAINING TO PRODUCTS PROVIDED HEREUNDER. SELLER DISCLAIMS ALL OTHER WARRANTIES, EXPRESS AND IMPLIED, INCLUDING DESIGN, MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.**

5. Claims; Commencement of Actions. Buyer shall promptly inspect all Products upon delivery. No claims for shortages will be allowed unless reported to the Seller within 10 days of delivery. No other claims against Seller will be allowed unless asserted in writing within 30 days after delivery. Buyer shall notify Seller of any alleged breach of warranty within 30 days after the date the defect is or should have been discovered by Buyer. Any action based upon breach of this agreement or upon any other claim arising out of this sale (other than an action by Seller for an amount due on any invoice) must be commenced within 12 months from the date of the breach without regard to the date breach is discovered.

6. LIMITATION OF LIABILITY. UPON NOTIFICATION, SELLER WILL, AT ITS OPTION, REPAIR OR REPLACE A DEFECTIVE PRODUCT, OR REFUND THE PURCHASE PRICE. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER FOR ANY SPECIAL, INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES ARISING OUT OF, OR AS THE RESULT OF, THE SALE, DELIVERY, NON-DELIVERY, SERVICING, USE OR LOSS OF USE OF THE PRODUCTS OR ANY PART THEREOF, OR FOR ANY CHARGES OR EXPENSES OF ANY NATURE INCURRED WITHOUT SELLER'S WRITTEN CONSENT, EVEN IF SELLER HAS BEEN NEGLIGENT, WHETHER IN CONTRACT, TORT OR OTHER LEGAL THEORY. IN NO EVENT SHALL SELLER'S LIABILITY UNDER ANY CLAIM MADE BY BUYER EXCEED THE PURCHASE PRICE OF THE PRODUCTS.

7. User Responsibility. The user, through its own analysis and testing, is solely responsible for making the final selection of the system and Product and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application and follow applicable industry standards and Product information. If Seller provides Product or system options, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the Products or systems.

8. Loss to 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, will be considered obsolete and may be destroyed by Seller after two consecutive years have elapsed without Buyer ordering the items 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. Special Tooling. A tooling charge may be imposed for any special tooling, including without limitation, dies, fixtures, molds and patterns, acquired to manufacture Products. 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 Products, 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.

10. Buyer's Obligation; Rights of Seller. To secure payment of all sums due or otherwise, Seller shall retain a security interest in the goods delivered and this agreement shall be deemed a Security Agreement under the Uniform Commercial Code. Buyer authorizes Seller as its attorney to execute and file on Buyer's behalf all documents Seller deems necessary to perfect its security interest.

11. Improper use and Indemnity. Buyer shall indemnify, defend, and hold Seller harmless from any claim, liability, damages, lawsuits, and costs (including attorney fees), whether for personal injury, property damage, patent, trademark or copyright infringement or any other claim, brought by or incurred by Buyer, Buyer's employees, or any other person, arising out of: (a) improper selection, improper application or other misuse of Products purchased by Buyer from Seller; (b) any act or omission, negligent or otherwise, of Buyer; (c) Seller's use of patterns, plans, drawings, or specifications furnished by Buyer to manufacture Product; or (d) Buyer's failure to comply with these terms and conditions. Seller shall not indemnify Buyer under any circumstance except as otherwise provided.

12. Cancellations and Changes. Orders shall not be subject to cancellation or change by Buyer for any reason, except with Seller's written consent and upon terms that will indemnify, defend and hold Seller harmless against all direct, incidental and consequential loss or damage. Seller may change product features, specifications, designs and availability with notice to Buyer.

13. Limitation on Assignment. Buyer may not assign its rights or obligations under this agreement without the prior written consent of Seller.

14. Force Majeure. Seller does not assume the risk 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, strikes or labor disputes, acts of any government or government agency, acts of nature, delays or failures in delivery from carriers or suppliers, shortages of materials, or any other cause beyond Seller's reasonable control.

15. Waiver and Severability. Failure to enforce any provision of this agreement will not waive that provision nor will any such failure prejudice Seller's right to enforce that provision in the future. Invalidation of any provision of this agreement by legislation or other rule of law shall not invalidate any other provision herein. The remaining provisions of this agreement will remain in full force and effect.

16. Termination. Seller may terminate this agreement for any reason and at any time by giving Buyer thirty (30) days written notice of termination. Seller may immediately terminate this agreement, in writing, if Buyer: (a) commits a breach of any provision of this agreement (b) appoints a trustee, receiver or custodian for all or any part of Buyer's property (c) files a petition for relief in bankruptcy on its own behalf, or by a third party (d) makes an assignment for the benefit of creditors, or (e) dissolves or liquidates all or a majority of its assets.

17. Governing Law. This agreement and the sale and delivery of all Products hereunder shall be deemed to have taken place in and shall be governed and construed in accordance with the laws of the State of Ohio, as applicable to contracts executed and wholly performed therein and without regard to conflicts of laws principles. Buyer irrevocably agrees and consents to the exclusive jurisdiction and venue of the courts of Cuyahoga County, Ohio with respect to any dispute, controversy or claim arising out of or relating to this agreement.

18. 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 Section. Seller will defend and indemnify Buyer against allegations of infringement of U.S. patents, U.S. trademarks, copyrights, trade dress and trade secrets ("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 a Product sold pursuant to this Agreement 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 a Product 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 the Product, replace or modify the Product so as to make it noninfringing, or offer to accept return of the Product 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 Products 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 Product sold hereunder. The foregoing provisions of this Section shall constitute Seller's sole and exclusive liability and Buyer's sole and exclusive remedy for infringement of Intellectual Property Rights.

19. Entire Agreement. This agreement contains the entire agreement between the Buyer and Seller and constitutes the final, complete and exclusive expression of the terms of sale. All prior or contemporaneous written or oral agreements or negotiations with respect to the subject matter are herein merged.

20. Compliance with Law, U. K. Bribery Act and U.S. Foreign Corrupt Practices Act. Buyer agrees to comply with all applicable laws and regulations, including both those of the United Kingdom and the United States of America, and of the country or countries of the Territory in which Buyer may operate, including without limitation the U. K. Bribery Act, the U.S. Foreign Corrupt Practices Act ("FCPA") and the U.S. Anti-Kickback Act (the "Anti-Kickback Act"), and agrees to indemnify and hold harmless Seller from the consequences of any violation of such provisions by Buyer, its employees or agents. Buyer acknowledges that they are familiar with the provisions of the U. K. Bribery Act, the FCPA and the Anti-Kickback Act, and certifies that Buyer will adhere to the requirements thereof. In particular, Buyer represents and agrees that Buyer shall not make any payment or give anything of value, directly or indirectly to any governmental official, any foreign political party or official thereof, any candidate for foreign political office, or any commercial entity or person, for the purpose of influencing such person to purchase products or otherwise benefit the business of Seller.

07/14



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