



Chelsea PTO 880 Parts Manual

Pro Gear and Transmission presents Chelsea 880 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

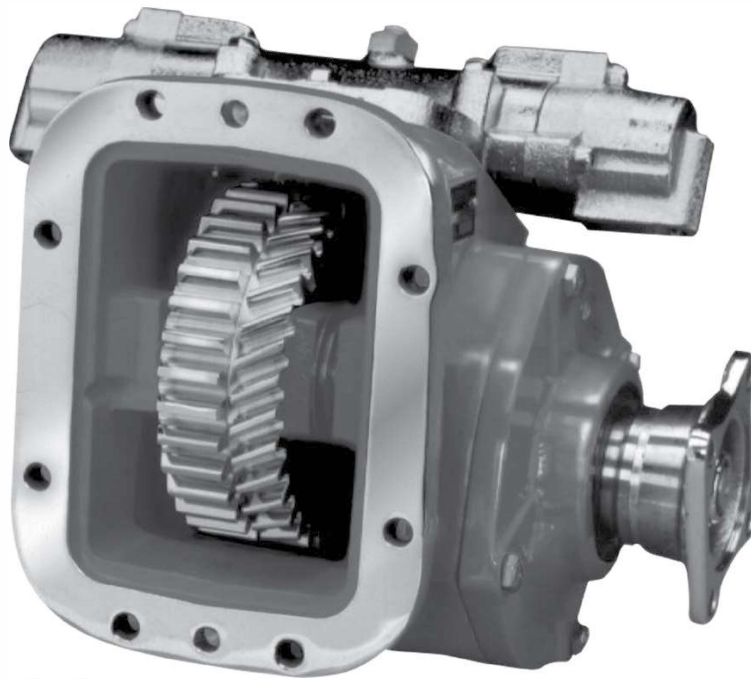
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Effective: October 15, 2018
Supersedes: HY25-2880-M1/US February 2013

Power Take-Offs Parts List

880 Series



ENGINEERING YOUR SUCCESS.

Pro Gear and Transmission, Inc. | 906 West Gore St, Orlando, FL 32805
+1 (877) 776-4600 | +1 (407) 872-1901
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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.

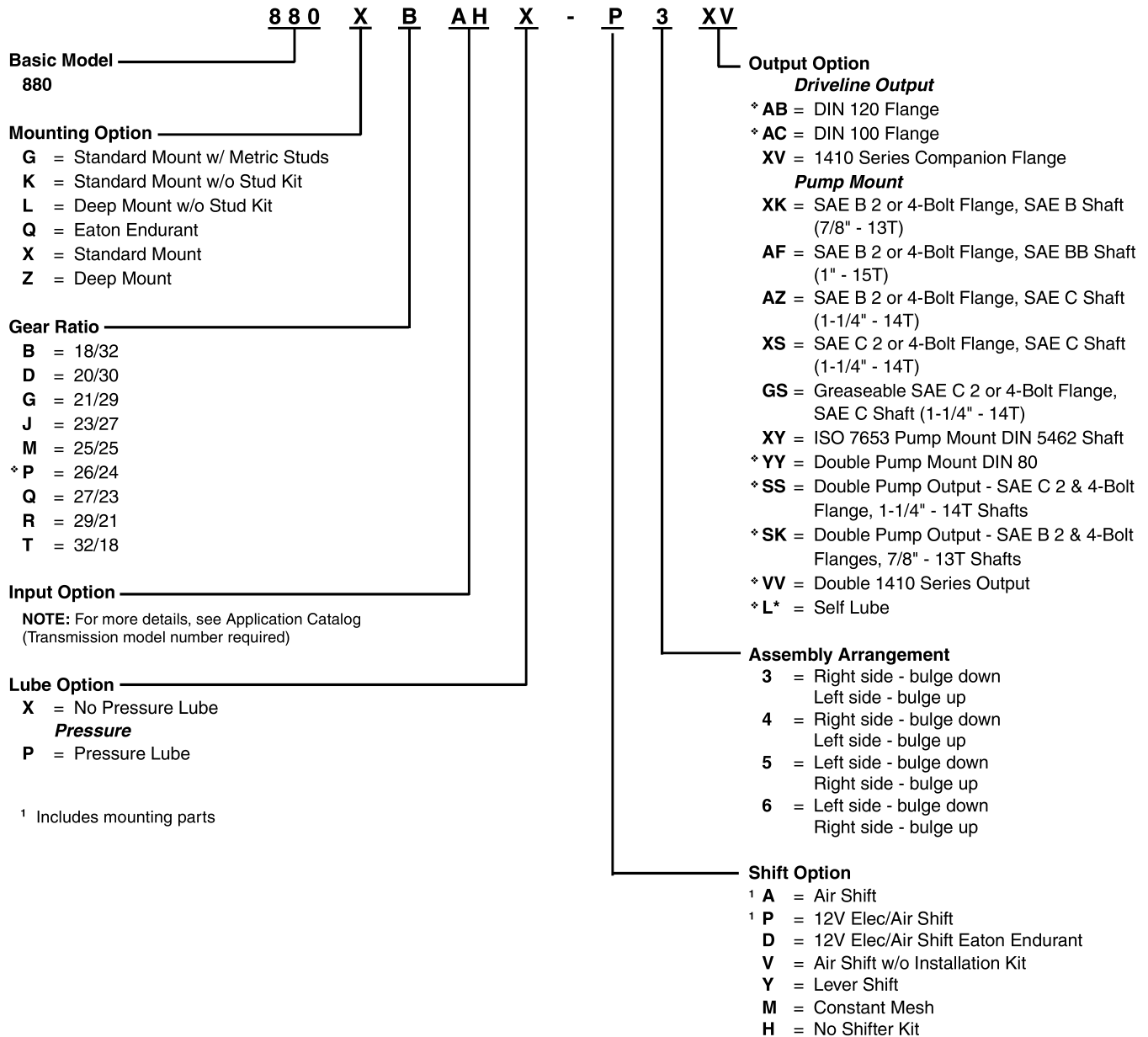
Offer of Sale

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".

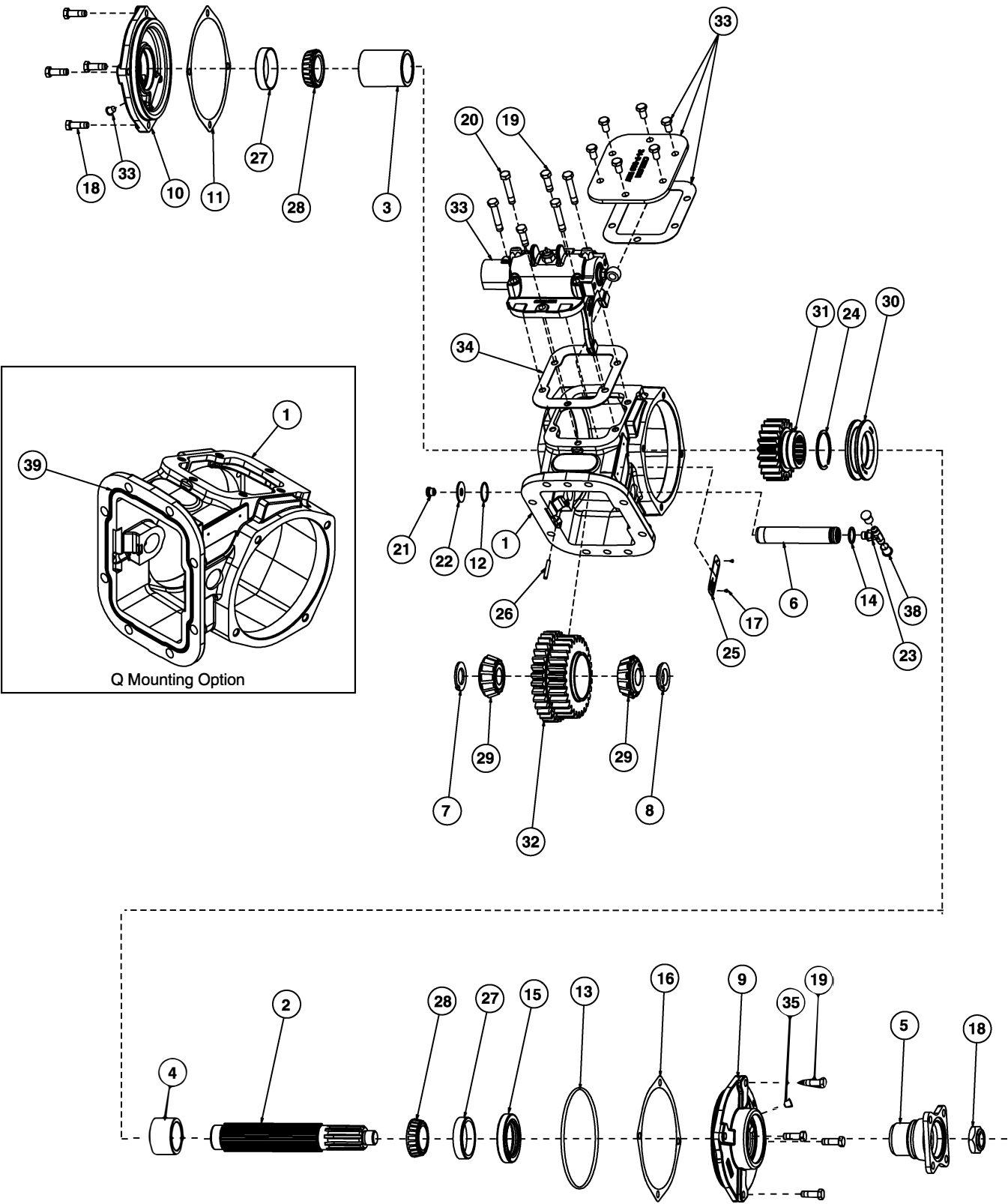
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Model Number Designator

¹ Includes mounting parts

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



Bill of Materials**Parts List
880 Series**

Item	Part Number	Description	Qty.
1	1-P-507	Housing (X Standard Mount) (X, G & K Mounting).....	1 or
	1-P-509	Housing (Z Deep Mount) (Z & L Mounting)	1 or
	1-P-778	Housing (Q Standard Mount) (Q Mounting).....	1
2	3-P-872	Output Shaft 10T Straight (XV Output Only)	1
3	4-P-163	Spacer 1.753" x 2.250" x 2.828" (M Shifter Only).....	1 or
4	4-P-164	Spacer 1.753" x 2.250" x 1.395" (M Shifter Only).....	1
5	3-1-3431	1410 Companion Flange (XV Output)	1
6	9-P-79	Idler Shaft 1.0" (X Lube)	1 or
	9-P-80	Idler Shaft 1.0" (P Lube)	1
7	14-P-80-1	Spacer 1.014" x 1.750" x .111" (Thickness as Required).....	1
	14-P-80-2	Spacer 1.014" x 1.750" x .116"	1
	14-P-80-3	Spacer 1.014" x 1.750" x .121"	1
	14-P-80-4	Spacer 1.014" x 1.750" x .125"	1
8	14-P-81	Spacer 1.014" x 1.750" x .255"	1
9	21-P-517	Bearing Cap (X Lube) (XV Output).....	1 or
	21-P-596	Bearing Cap (P Lube) (XV Output).....	1
10	21-P-546	Bearing Cap (X Lube) (AZ, AF, XV, XK, XS, XY & *AB Output).....	1 or
	21-P-597	Bearing Cap (P Lube) (AZ, AF, XV, XK, XS, XY & *AB Output).....	1
11	22-P-98	Gasket	1
12	28-P-42	O-Ring 1.051" x .070"	1
13	28-P-196	O-Ring 6.000" x .138" (2 for *SS, *SK, *YY, *VV)	1
14	28-P-198	O-Ring .798" x .103"	1
15	28-P-211	Oil Seal 3.001" x 2.00" x .375".....	1
16	55-P-20-1	Bearing Cover Shim .003" (Green).....	1 or
	55-P-20-2	Bearing Cover Shim .010" (Brown).....	1 or
	55-P-20-3	Bearing Cover Shim .020" (Yellow).....	1
17	378422	Drive Screw	2
18	378382	Nut Stop .875"-14 (XV Output)	1
19	378431-11	Hex Head Capscrew .375"-16 x 1.125"	10
20	378431-18	Hex Head Capscrew .375"-16 x 2.000"	4
21	379484	O-Ring Boss Plug .438"-20	1
22	379505	O-Ring Retainer.....	1
23	379556	Tee .438"-20	1
24	379592	Lockring.....	1
25	68-P-51	Name Plate.....	1
26	500597-16	Roll Pin .188" x 1.250".....	1
27	560982	Bearing Cup Tapered 2.5635" x .550"	2
28	560986	Bearing Cone Tapered (XV Output).....	2
29	560978	Bearing Cone Tapered 1.000" x .8448" (B, D, G & J Ratios)	2 or
	560987	Bearing Cone Tapered 1.0005" x .96" (M, P, Q, R & T Ratios)	2
30	61-P-1	Hub Shifter.....	1
31	See Page 5	Output Gear.....	1
32	See Page 5	Input Gear.....	1

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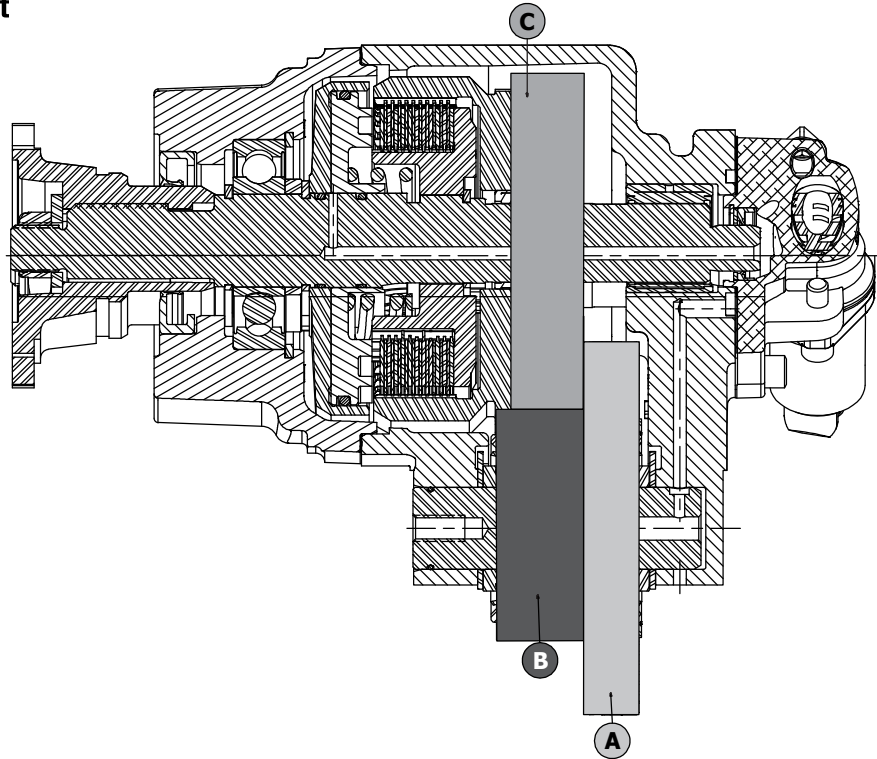
*No longer a current option per 2018 Chelsea Suggested List Price.

Bill of Materials**Parts List
880 Series**

Item	Part Number	Description	Qty.
33	329777X	Air Shifter Cover Ass'y (D Shifter Type)	1 or
	329772X	Air Shifter Cover Ass'y (A Shifter Type)	1 or
	329774X	Lever Shifter Cover Ass'y (Y Shifter Type)	1 or
	329800X	Cover Kit (6-Bolt) (M Shifter Type)	1
34	35-P-59	Gasket (Except M Shifter Type)	1
35	500897-5	Shipping Plug (P Lube)	2
38	379564-2	Cap Thread (.438")	2
39	28-P-381	Mounting Seal O-Ring (For Q Mounting Type)	1
	See pages 35-43 for Bill of Materials for the below loose parts.		
N.S.	379640	Booted Connector (V Shifter Type Only)	1
N.S.	378414	Pressured Protected Valve (V Shifter Type Only)	1
	STUD KITS		
	328170-179X	Stud Kit (X Standard Mount)	1 or
	328170-195X	Stud Kit (L Deep Mount)	1 or
	328170-201X	Stud Kit (G Metric)	1
	328170-217X	Stud Kit (Q Eaton Endurant)	1
	INSTALLATION INSTRUCTION KIT		
	328948-8X	Gasket & Installation Instructions (All Except Q Mount)	1
	328948-48X	Gasket & Installation Instructions (Q Mount)	1
	INSTALLATION KITS		
	328388-61X	Air Shift Installation Kit (A Shift Only)	1
	328388-93X	Elec/Air Shift Installation Kit (P Shift Only)	1
	328751-1X	Indicator Light Kit (Y Shift Only)	1
	329874-2X	12V Elec/Air Kit (Eaton Endurant)	1
	SERVICE KITS		
	328356-51X	Gasket & Seal Kit (Standard XV Output)	
	328356-52X	Gasket & Seal Kit (Pump Output)	
	328356-53X	Gasket & Seal Kit (Y Shifter Type)	
	328356-54X	Gasket & Seal Kit (2 Sided Shifter)(A Shifter Type)	
	328356-72X	Gasket & Seal Kit (1 Sided Shifter)(A Shifter Type)	
	328594-3X	Bearing & Spacer Kit (Pressure Lube for B, D, G & J Ratios)	
	328594-5X	Bearing & Spacer Kit (Pressure Lube for M, P, Q, R & T Ratios)	
	329183X	Overhaul Kit	
	329216-2X	Shifter Kit (Lever Shift)	
	329216-3X	Shifter Kit (Air Shift)	
	329216-4X	Constant Mesh Kit (Standard)	
	HOSE ASSEMBLIES		
	329129X	Hose Assembly (All Other Outputs)	1
	329129-1X	Hose Assembly (L Outputs)	1
	329130-1X	Hose Assembly (Idle Tee to Bearing Cap)	1
	329130-3X	Hose Assembly (Front Bearing Cap to Rear Bearing Cap)	1
	329224X	Pressure Lube Fittings Bag	1
	CONVERSION KITS		
	See pages 33-36	Pump Field Conversion Kits	

N.S. – Not Shown

Input Gear Chart



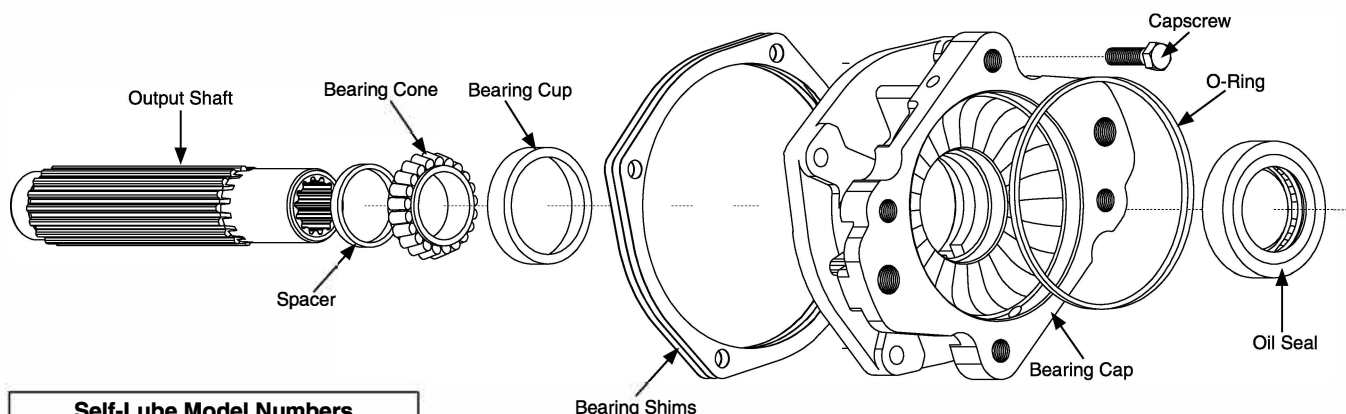
GEAR DESIGNATOR	INPUT GEAR	NO. TEETH A (32)	HELIX ANGLE	NO. TEETH B (32)	OUTPUT GEAR	NO. TEETH C (31)
880*BAB	5-P-1099	27	Spur	18	2-P-730X	32
880*BAH	5-P-1100	32	Spur	18	2-P-730X	32
880*DAH	5-P-1101	32	Spur	20	2-P-731X	30
880*GAH	5-P-1135	32	Spur	21	2-P-732X	29
880*JAH	5-P-1102	32	Spur	23	2-P-733X	27
880*MAH	5-P-1103	32	Spur	25	2-P-734X	25
880*PAH	5-P-1523	32	Spur	26	2-P-735X	24
880*QAH	5-P-1385	32	Spur	27	2-P-818X	23
880*RAH	5-P-1104	32	Spur	29	2-P-736X	21
880*TAH	5-P-1105	32	Spur	32	2-P-737X	18
880*BAK	5-P-1106	32	Spur	18	2-P-730X	32
880*DAK	5-P-1107	32	Spur	20	2-P-731X	30
880*GAK	5-P-1108	32	Spur	21	2-P-732X	29
880*JAK	5-P-1109	32	Spur	23	2-P-733X	27
880*MAK	5-P-1110	32	Spur	25	2-P-734X	25
880*BAR	5-P-1111	29	Left Hand	18	2-P-730X	32
880*JAR	5-P-1112	29	Left Hand	23	2-P-733X	27
880*PAR	5-P-1113	29	Left Hand	26	2-P-735X	24
880*RAR	5-P-1114	29	Left Hand	29	2-P-736X	21
880*TAR	5-P-1115	29	Left Hand	32	2-P-737X	18
880*MBG	5-P-1175	33	Left Hand	25	2-P-734X	25
880*RBG	5-P-1117	33	Left Hand	29	2-P-736X	21
880*TBG	5-P-1177	33	Left Hand	32	2-P-737X	18

Continued on Next Page

Input Gear Chart (Continued)

GEAR DESIGNATOR	INPUT GEAR	NO. TEETH A (2)	HELIX ANGLE	NO. TEETH B (2)	OUTPUT GEAR	NO. TEETH C (2)
880*GDA	5-P-1174	35	Spur	21	2-P-732X	29
880*BDA	5-P-1120	35	Spur	18	2-P-730X	32
880*MDA	5-P-1121	35	Spur	25	2-P-734X	25
880*RDA	5-P-1122	35	Spur	29	2-P-736X	21
880*TDA	5-P-1123	35	Spur	32	2-P-737X	18
880*MDB	5-P-1124	55	Spur	25	2-P-734X	25
880ZRGZ	5-P-1210	44	Spur	29	2-P-736X	21
880*MDD	5-P-1134	33	Spur	25	2-P-734X	25
880*MDU	5-P-1130	39	Left Hand	25	2-P-734X	25
880*TDU	5-P-1131	39	Left Hand	32	2-P-737X	18
880*RDU	5-P-1176	39	Left Hand	29	2-P-736X	21
880*MEV	5-P-1132	56	Spur	25	2-P-734X	25
880*BJV	5-P-1301	41	Left Hand	18	2-P-730X	32
880*DJV	5-P-1302	41	Left Hand	20	2-P-731X	30
880*GJV	5-P-1303	41	Left Hand	21	2-P-732X	29
880*JJV	5-P-1304	41	Left Hand	23	2-P-733X	27
880*MJV	5-P-1305	41	Left Hand	25	2-P-734X	25
880*PJV	5-P-1308	41	Left Hand	26	2-P-735X	24
880*RJV	5-P-1306	41	Left Hand	29	2-P-736X	21
880*TJV	5-P-1307	41	Left Hand	32	2-P-737X	18
880*GLZ	5-P-1574	39	Right Hand	21	2-P-732X	29
880*JLZ	5-P-1575	39	Right Hand	23	2-P-733X	27
880*QLZ	5-P-1577	39	Right Hand	27	2-P-818X	23
880*IT	Assembled without Input Gear					

Self Lube Bill of Materials



Self-Lube Model Numbers

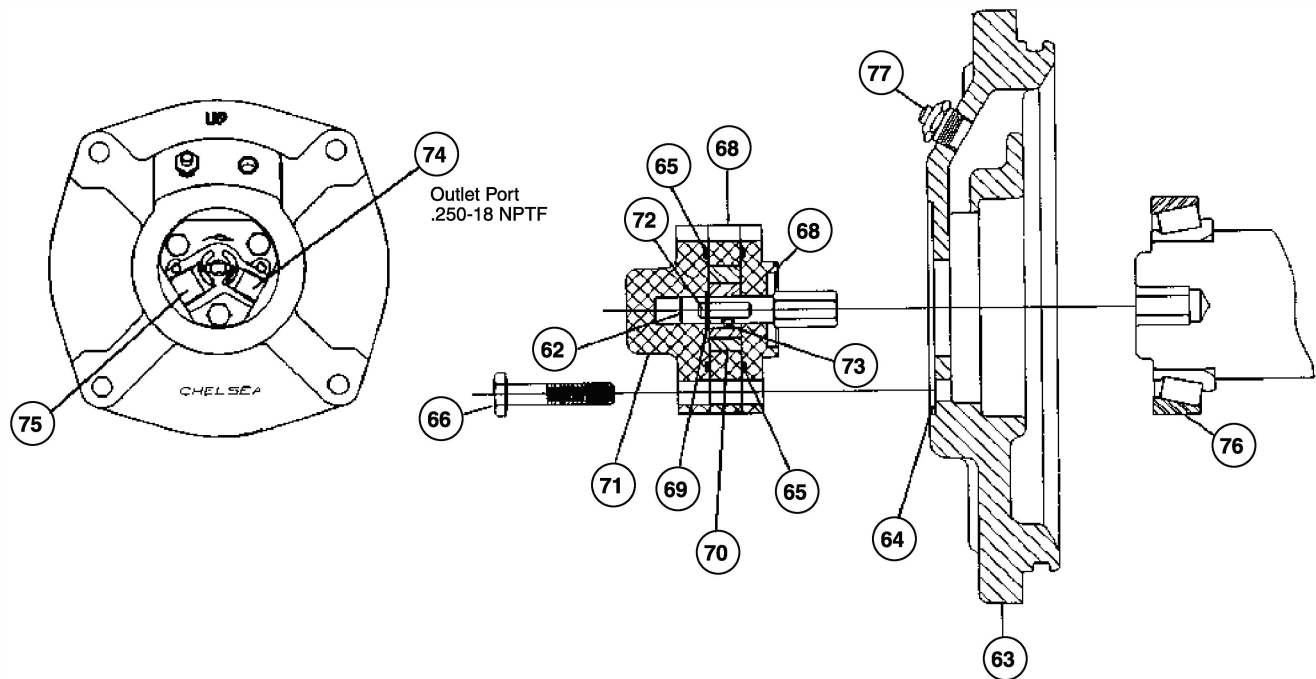
880****P- **LF	Similar to P- **XK
880****P- **LG	Similar to P- **XV
880****P- **LH	Similar to P- **XS
880****P- **LL	Similar to P- **AC

PTO Output	Bearing Cap Open	Bearing Cap Closed (1)	Output Shaft	Oil Seal	Bearing Cone	Bearing Cup	Spacer	Idler Shaft
LF	21-P-592	329127X	3-P-878	28-P-219	560976	560977	4-P-162	9-P-80
LG	21-P-596	329127X	3-P-879	28-P-211	560986	560982	—	9-P-80
LH	21-P-544	329127X	3-P-877	28-P-219	560976	560977	4-P-162	9-P-80
LL	21-P-596	329127X	3-P-879	28-P-211	560986	560982	—	9-P-80

NOTE: Top Mount 912 Split Shaft applications are not flooded with oil as bottom or side mounted applications. When mounting an 880 Series on top of a 912 Split Shaft, one of the three self lube output types must be used.

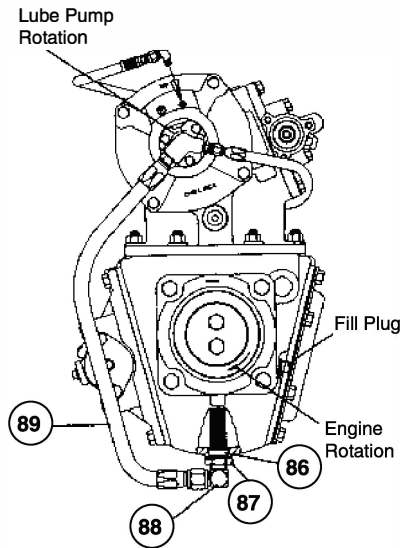
(1) The Closed End Bearing Cap is where the self lube pump is attached. For additional details, see [page 8](#).

Lube Pump Bill of Materials



Item	Part Number	Description	Qty.
	329127X	LUBE PUMP & BEARING CAP ASSEMBLY	1
		(Includes items 62 thru 77)	
62	3-P-881	Pump Driveshaft	1
63	21-P-547	Bearing Cap	1
64	22-P-73	Gasket	1
65	28-P-249	O-Ring	2
66	378429-12	Capscrew, Hex Head (.250"-20 x 1.250")	3
67	379546	Pump Adapter Plate	1
68	379173	Pump Plate	1
69	379175	Retaining Ring	1
70	379176	Gerotors.....	1
71	379525	Pump Cap, Dual Ported.....	1
72	500037-7	Dowel Pin (.188" x .625").....	2
73	500566-3	Drive Ball (.125").....	1
74	500897-8	Shipping Plug (Plastic)	1
75	500897-11	Shipping Plug (Plastic)	1
76	560982	Tapered Bearing Cup.....	1
77	500167-1	Breather.....	1
N.S.	22-P-98	Gasket, Bearing Cap	1
N.S.	378431-11	Hex Capscrew (.375"-16 x 1.125")	4
N.S.	379513-1	Installation Instructions Tag	1
N.S. – Not Shown			

For Chelsea 912 Split Shaft Top Mount Applications



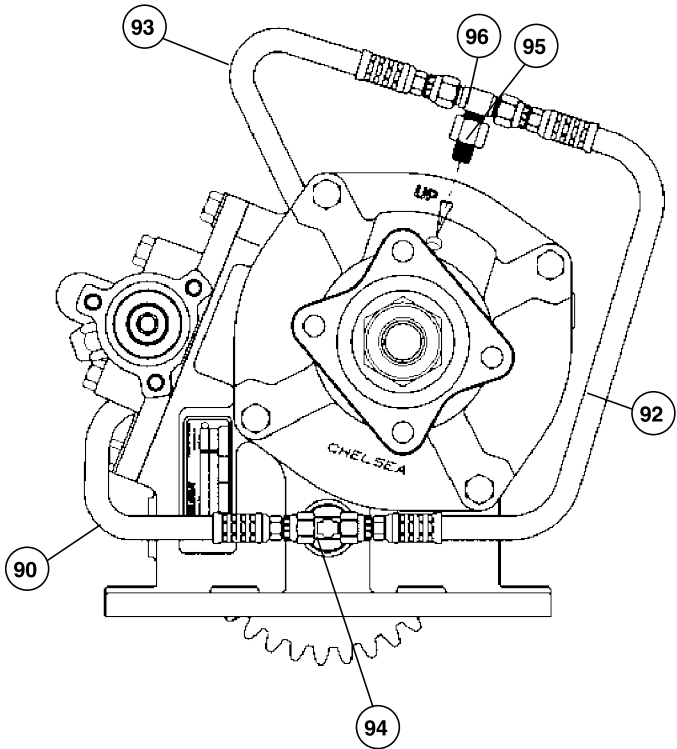
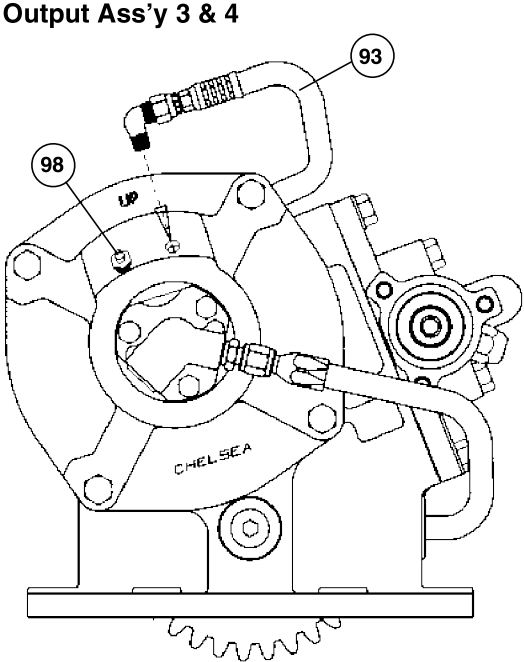
View from Front of Vehicle

Self-Lube Model Numbers
880****P- **LF
880****P- **LG
880****P- **LH

Item	Part Number	Description	
	329110-1X	Installation Kit, for mounting an 880 on a 912 Split Shaft.....	1
86	378117	Drain Plug Gasket	1
87	379526	Screened Strain Plug.....	1
88	379273	90° Elbow	1
89	379181	Hose Assembly, End to End Length 25.625"	1
N.S.	379636	Installation Instructions Tag	1

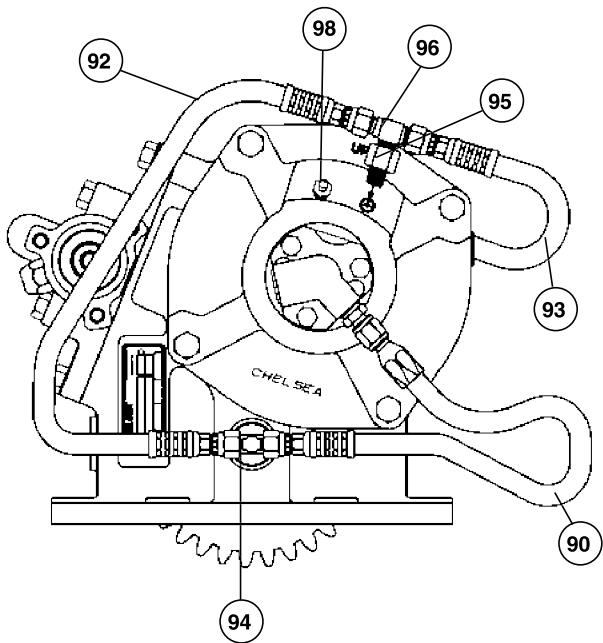
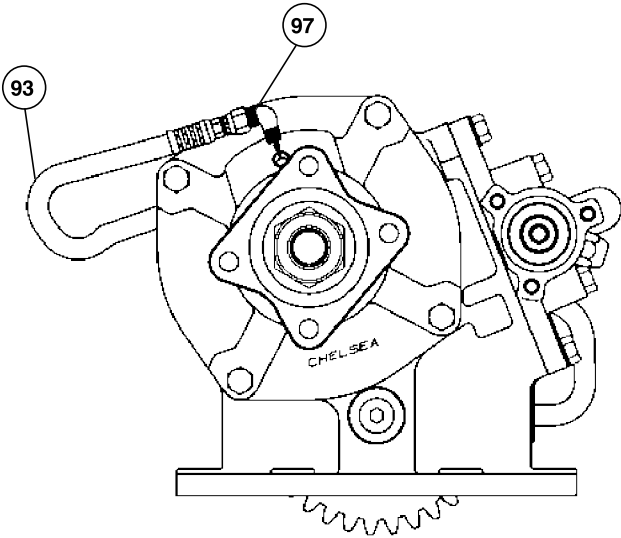
NOTE: When ordering the Self Lube option a P designator must be placed in the lubrication field of the part number.
Ex: 880XBAHP-A3LH. 880 Series on top mount 912 Split Shaft applications can only have a single output due to self lube requirements.

♦ LG Output Ass'y 3 & 4



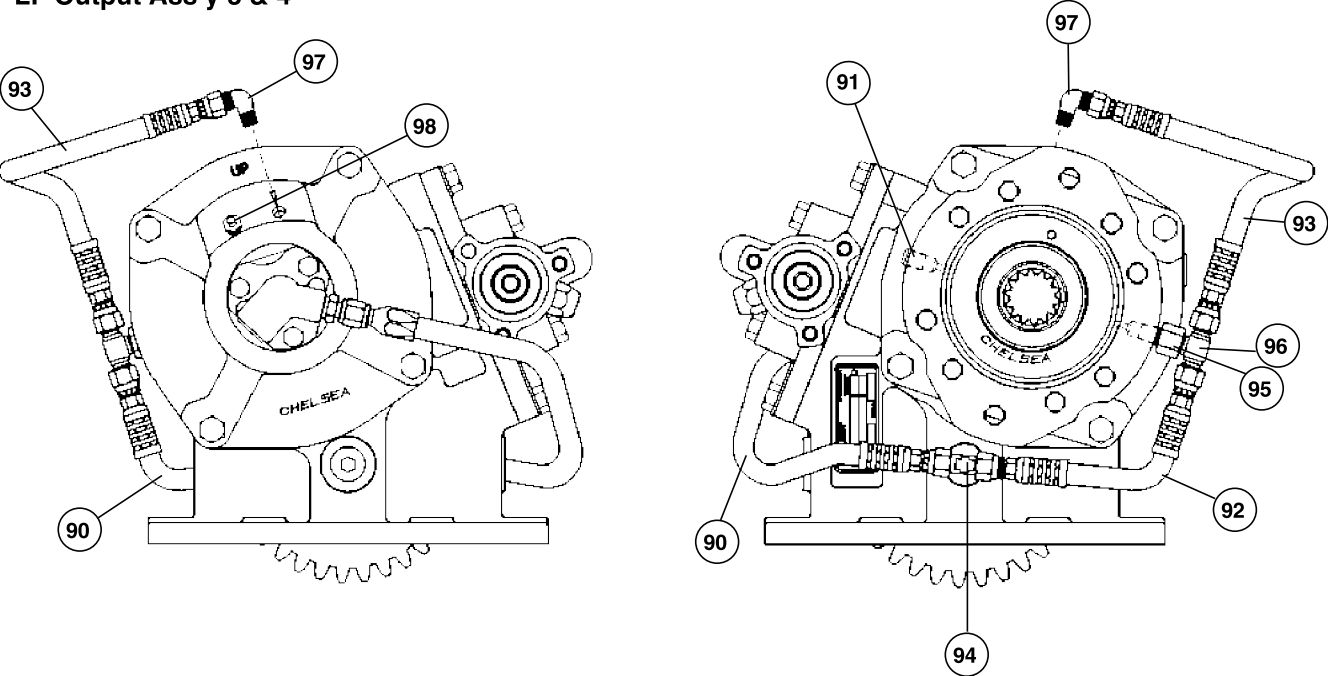
Item	Part Number	Description	Qty.
90	329129X	Hose Assembly, End to End Length 16.000"	1
92	329130-1X	Hose Assembly, End to End Length 16.250"	1
93	329130-3X	Hose Assembly, End to End Length 20.250"	1
94	379556	Tee, O-Ring	1
95	379594	Pipe Adapter	2
96	379627	Tee	1
97	379625	Elbow	1
98	500167	Breather	1

♦ LG Output Ass'y 5 & 6



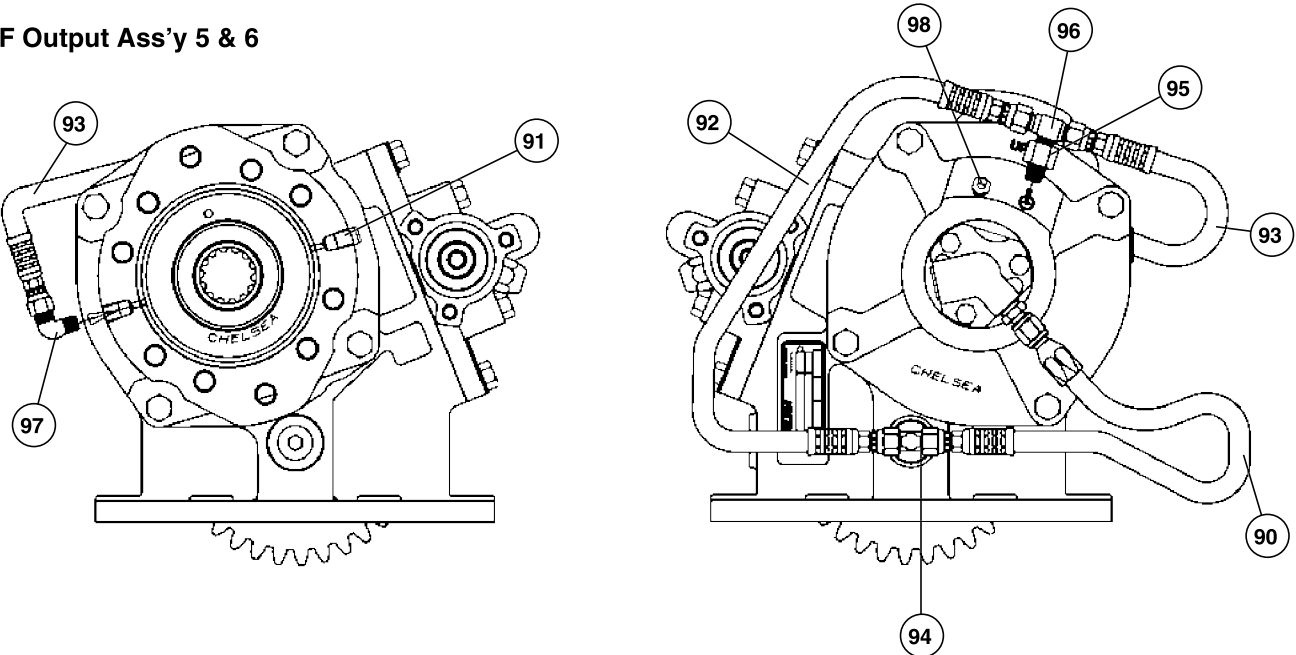
♦ No longer a current option per 2018 Chelsea Suggested List Price.

♦ LF Output Ass’y 3 & 4



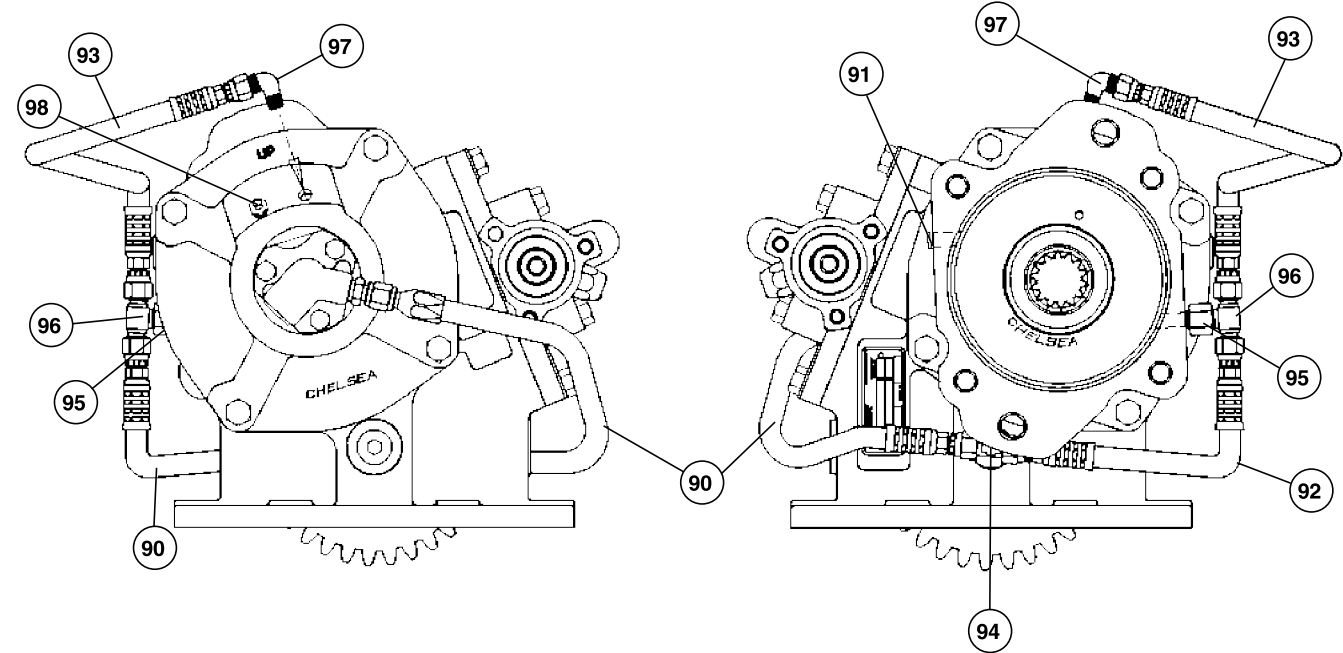
Item	Part Number	Description	Qty.
90	329129X	Hose Assembly, End to End Length 16.000"	1
91	379231	Pipe Plug	1
92	329130-1X	Hose Assembly, End to End Length 16.250"	1
93	329130-3X	Hose Assembly, End to End Length 20.250"	1
94	379556	Tee, O-Ring	1
95	379594	Pipe Adapter.....	2
96	379627	Tee.....	1
97	379625	Elbow.....	1
98	500167	Breather.....	1

♦ LF Output Ass’y 5 & 6



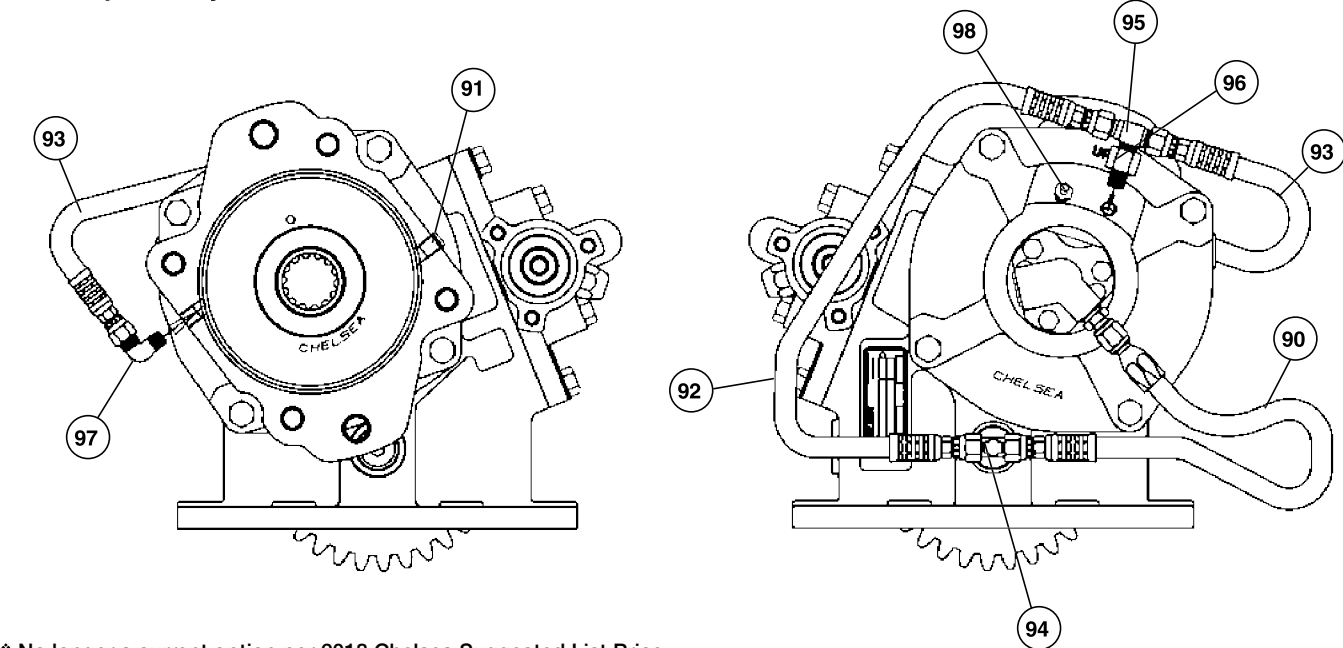
♦ No longer a current option per 2018 Chelsea Suggested List Price.

♦ LH Output Ass'y 3 & 4



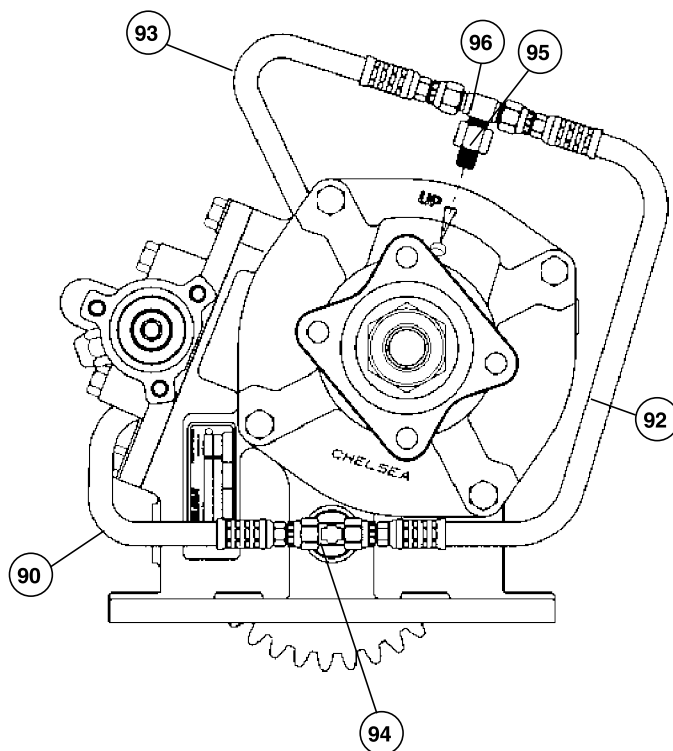
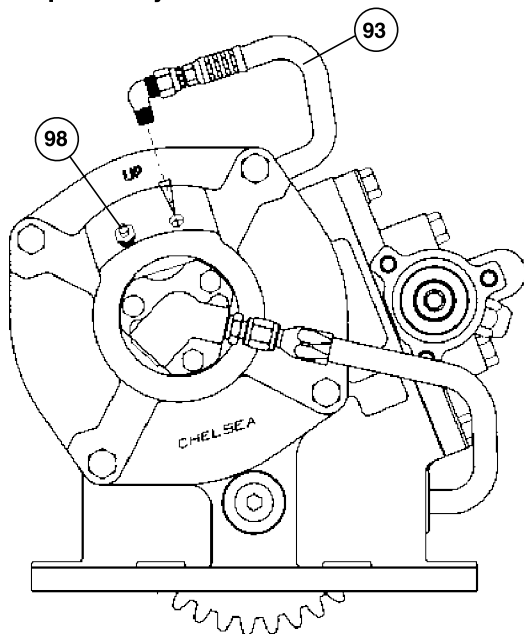
Item	Part Number	Description	Qty.
90	329129X	Hose Assembly, End to End Length 16.000"	1
91	379231	Pipe Plug	1
92	329130-1X	Hose Assembly, End to End Length 16.250"	1
93	329130-3X	Hose Assembly, End to End Length 20.250"	1
94	379556	Tee, O-Ring	1
95	379594	Pipe Adapter.....	2
96	379627	Tee.....	1
97	379625	Elbow.....	1
98	500167	Breather.....	1

♦ LH Output Ass'y 5 & 6



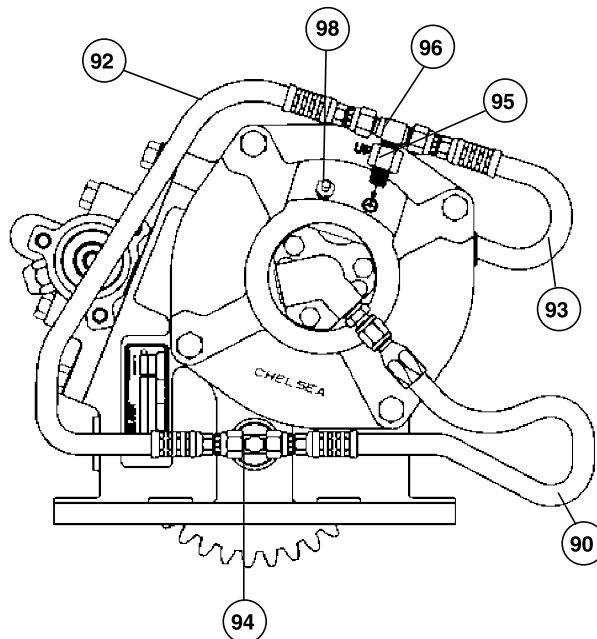
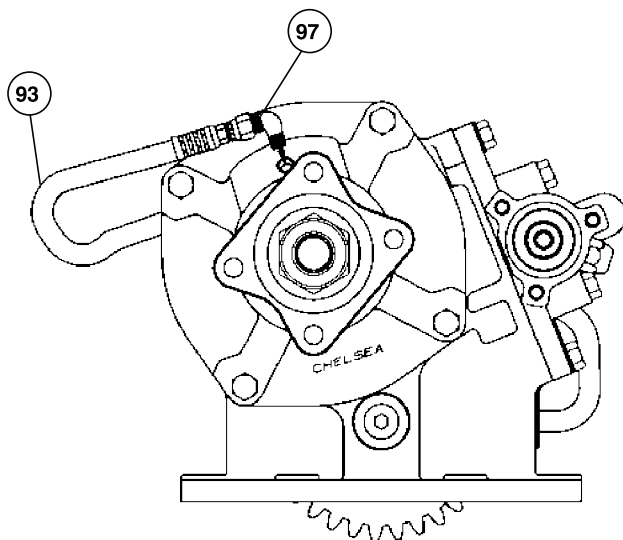
♦ No longer a current option per 2018 Chelsea Suggested List Price.

♦LL Output Ass'y 3 & 4



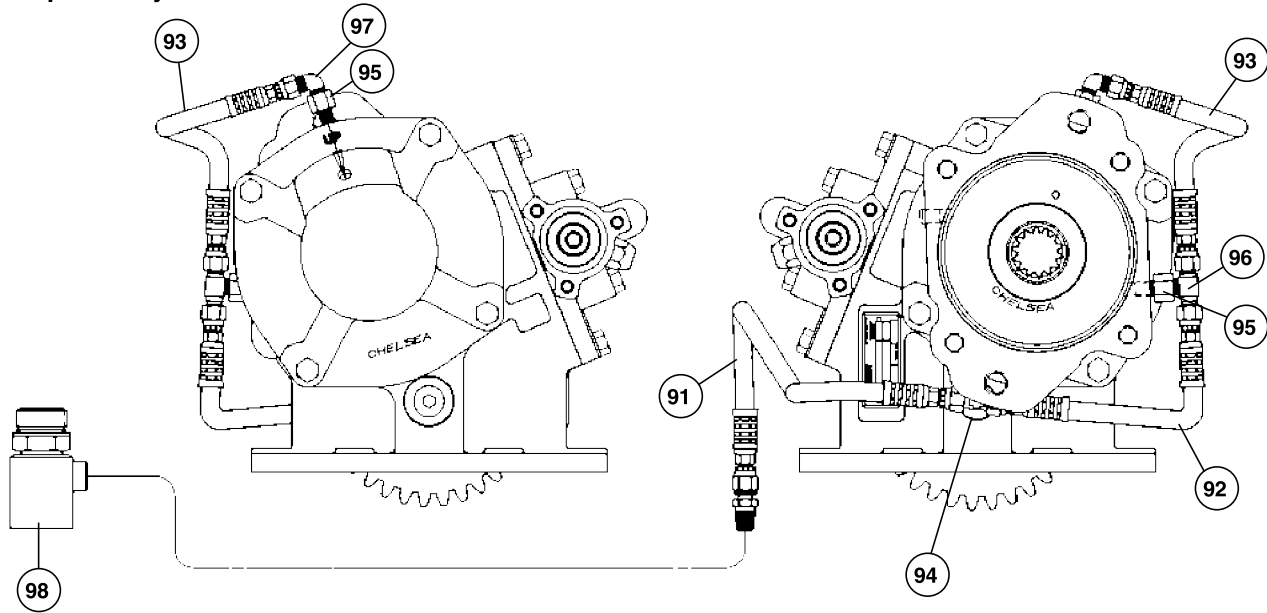
Item	Part Number	Description	Qty.
90	329129X	Hose Assembly, End to End Length 16.000"	1
92	329130-1X	Hose Assembly, End to End Length 16.250"	1
93	329130-3X	Hose Assembly, End to End Length 20.250"	1
94	379556	Tee, O-Ring	1
95	379594	Pipe Adapter.....	2
96	379627	Tee.....	1
97	379625	Elbow.....	1
98	500167	Breather.....	1

♦LL Output Ass'y 5 & 6



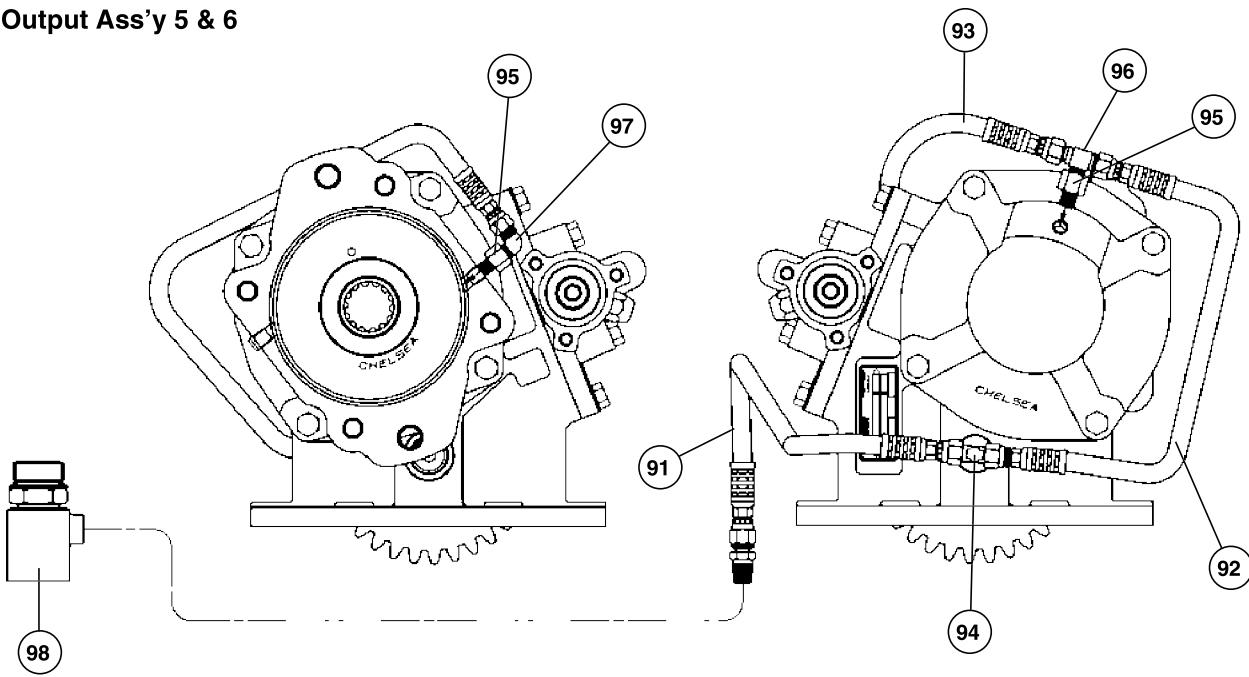
♦ No longer a current option per 2018 Chelsea Suggested List Price.

XS Output Ass'y 3 & 4



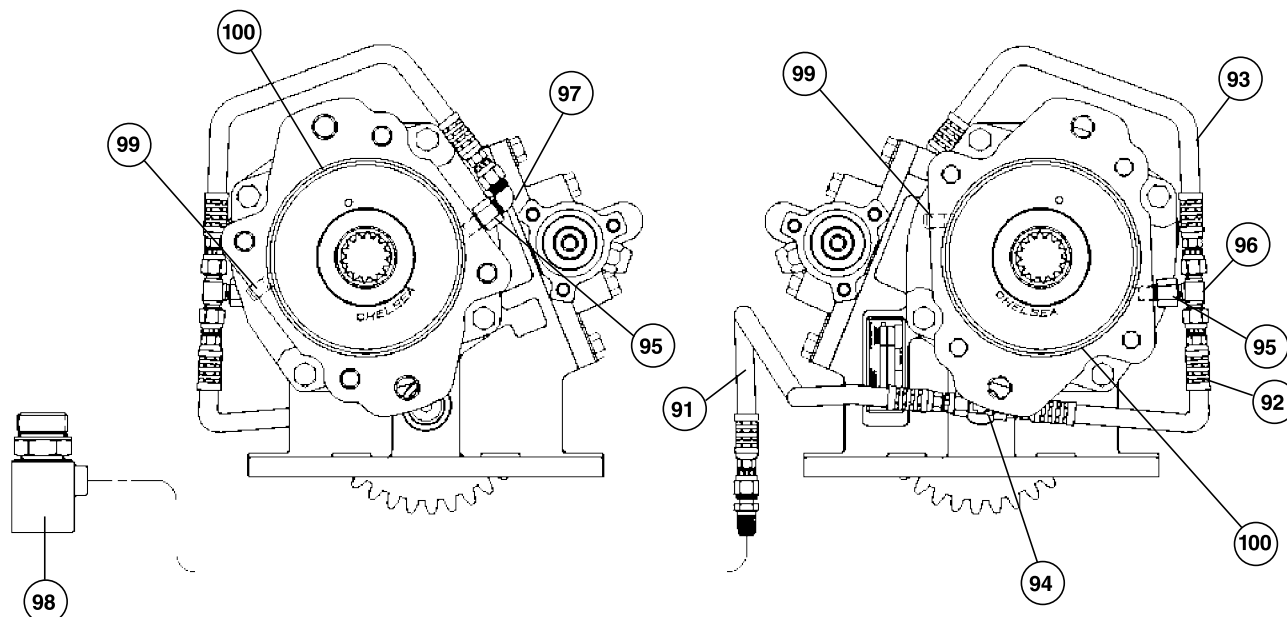
Item	Part Number	Description	Qty.
91	329129-1X	Hose Assembly, End to End Length 36.000"	1
92	329130-1X	Hose Assembly, End to End Length 16.250"	1
93	329130-3X	Hose Assembly, End to End Length 20.250"	1
94	379556	Tee, O-Ring	1
95	379594	Pipe Adapter	2
96	379627	Tee	1
97	379625	Elbow	1
98	378897	Transmission Tee Fitting	1

XS Output Ass'y 5 & 6



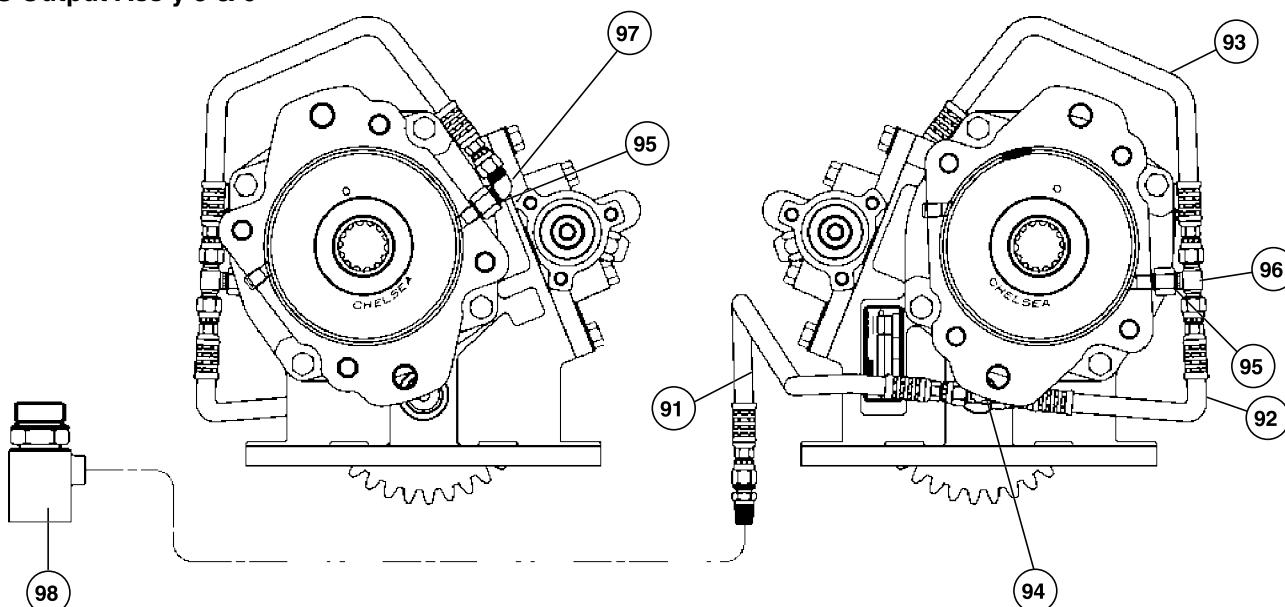
✦ No longer a current option per 2018 Chelsea Suggested List Price.

*SS Output Ass'y 5 & 6

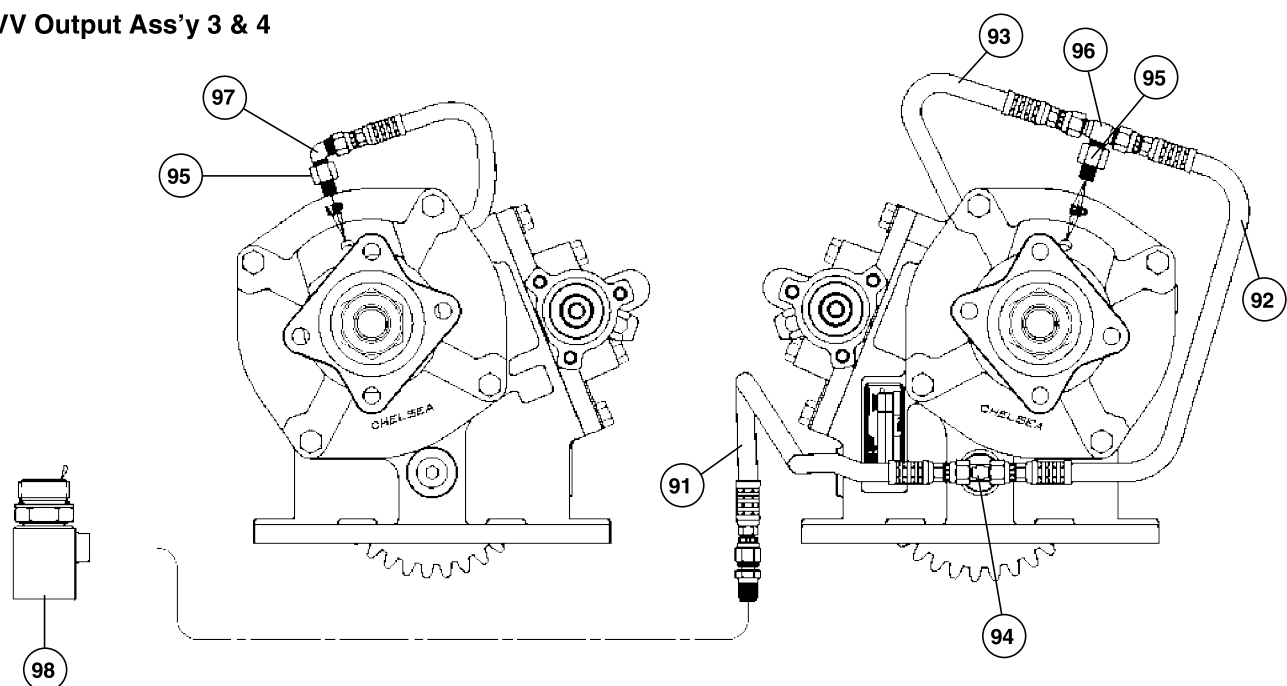


Item	Part Number	Description	Qty.
91	329129-1X	Hose Assembly, End to End Length 36.000"	1
92	329130-1X	Hose Assembly, End to End Length 16.250"	1
93	329130-3X	Hose Assembly, End to End Length 20.250"	1
94	379556	Tee, O-Ring	1
95	379594	Pipe Adapter	2
96	379627	Tee	1
97	379625	Elbow	1
98	378897	Transmission Tee Fitting	1
99	329231	Pipe Plug	1
100	28-P-245	O-Ring	1

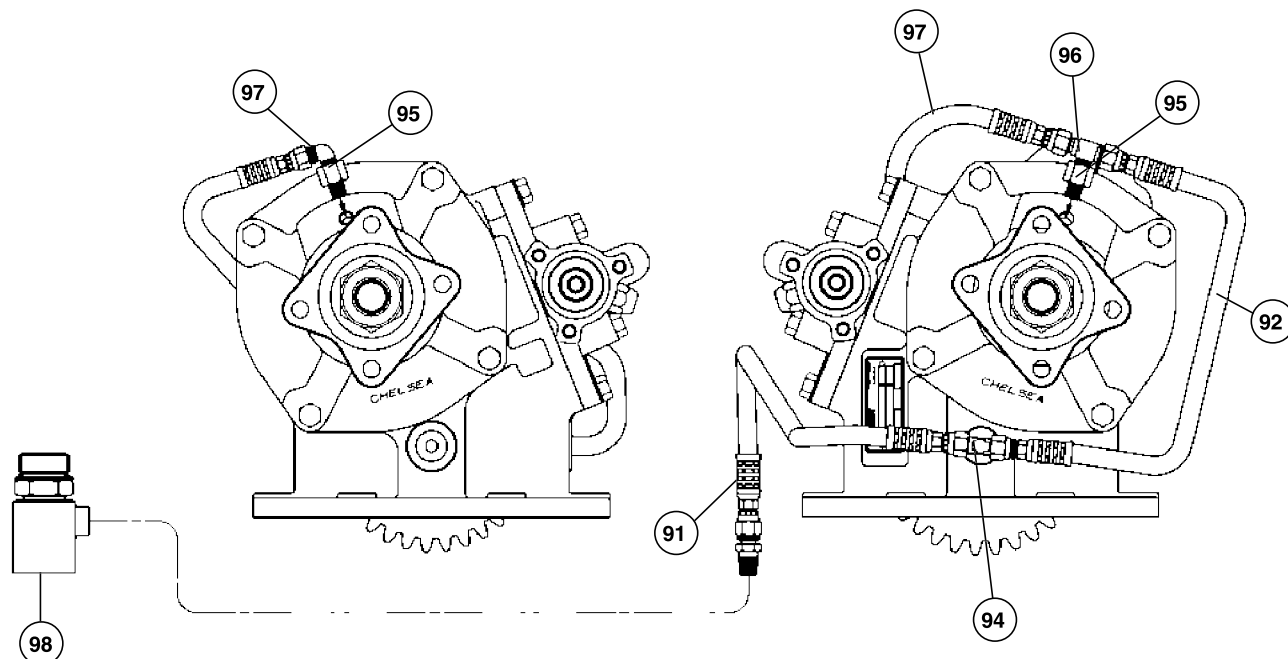
*SS Output Ass'y 5 & 6



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

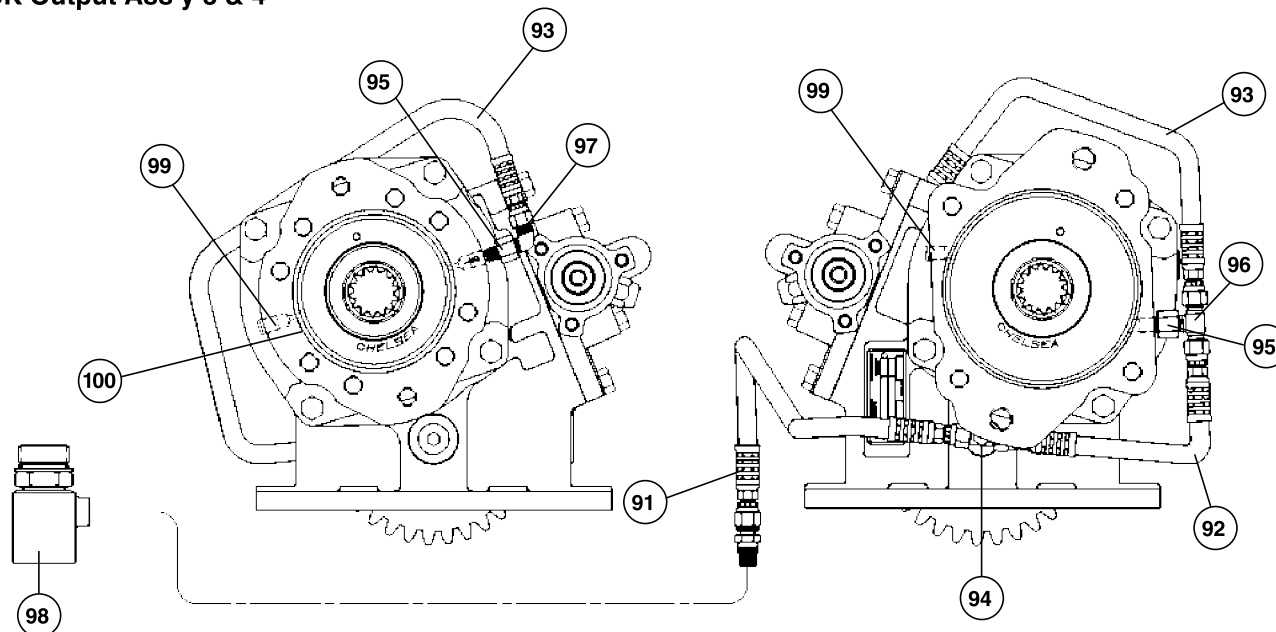


Item	Part Number	Description	Qty.
91	329129-1X	Hose Assembly, End to End Length 36.000"	1
92	329130-1X	Hose Assembly, End to End Length 16.250"	1
93	329130-3X	Hose Assembly, End to End Length 20.250"	1
94	379556	Tee, O-Ring	1
95	379594	Pipe Adapter.....	2
96	379627	Tee.....	1
97	379625	Elbow.....	1
98	379897	Transmission Tee Fitting	1



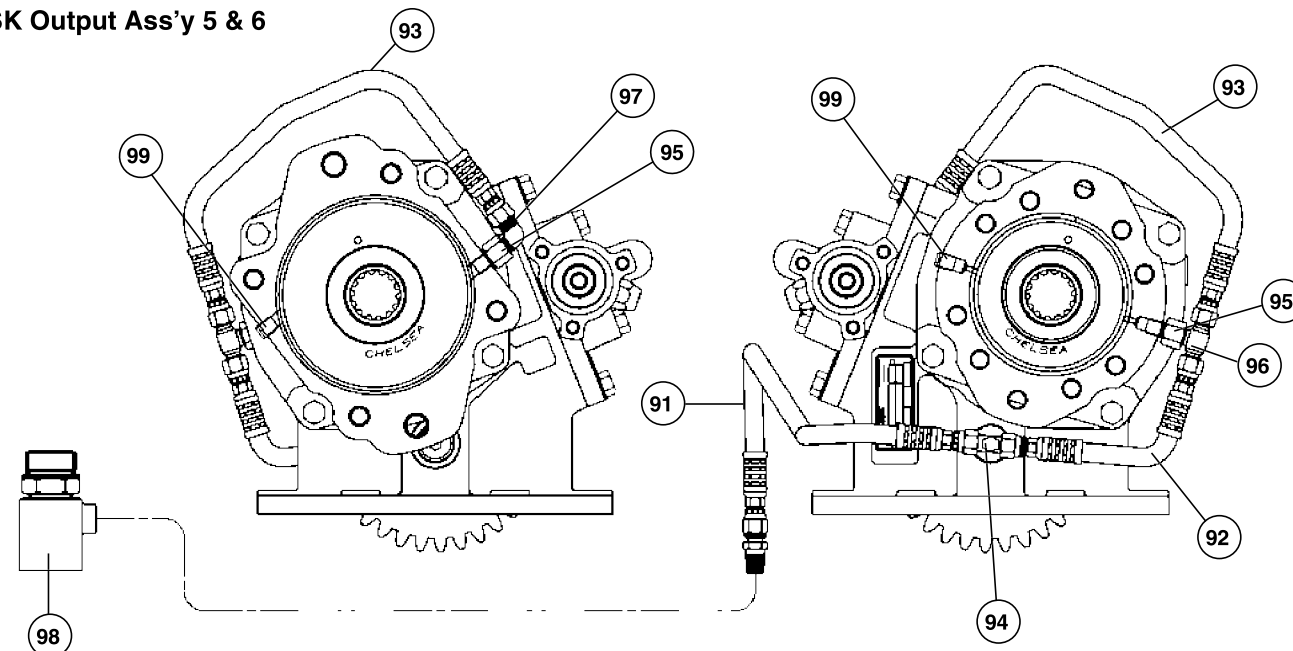
✧ No longer a current option per 2018 Chelsea Suggested List Price.

♦SK Output Ass'y 3 & 4

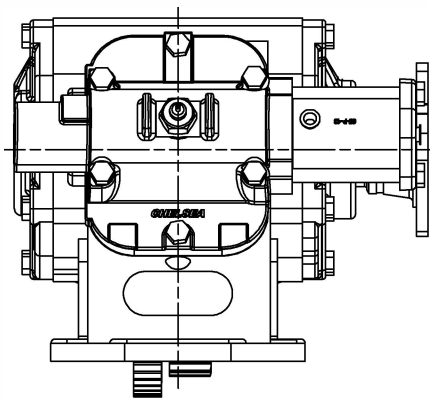


Item	Part Number	Description	Qty.
91	329129-1X	Hose Assembly, End to End Length 36.000"	1
92	329130-1X	Hose Assembly, End to End Length 16.250"	1
93	329130-3X	Hose Assembly, End to End Length 20.250"	1
94	379556	Tee, O-Ring	1
95	379594	Pipe Adapter	2
96	379627	Tee	1
97	379625	Elbow	1
98	378897	Transmission Tee Fitting	1
99	379231	Pipe Plug	1
100	28-P-245	O-Ring	1

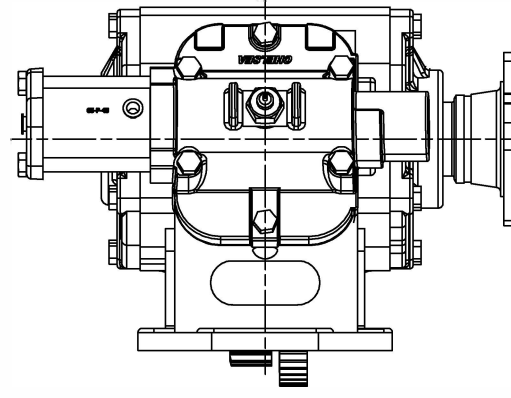
♦SK Output Ass'y 5 & 6



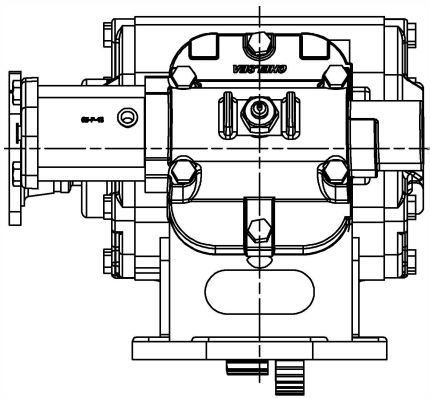
♦ No longer a current option per 2018 Chelsea Suggested List Price.



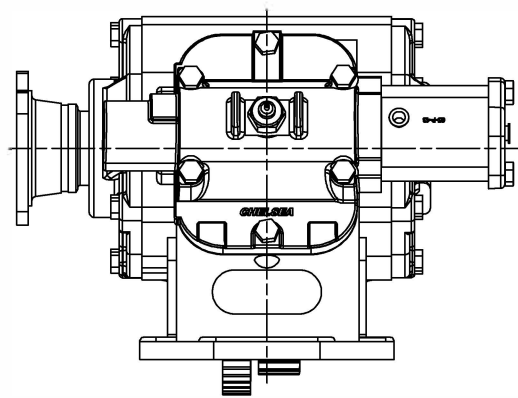
Ass'y 3



Ass'y 4

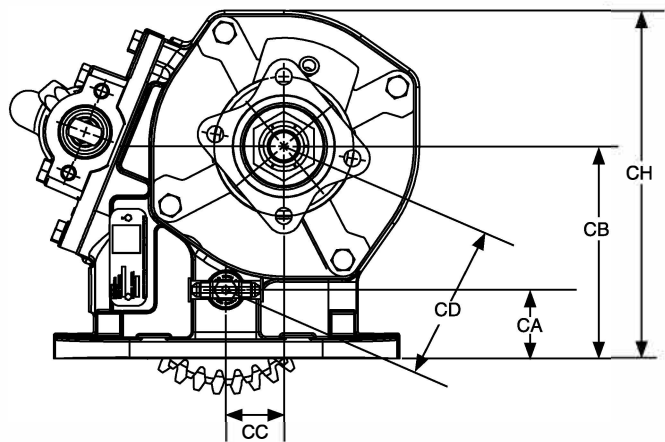


Ass'y 5

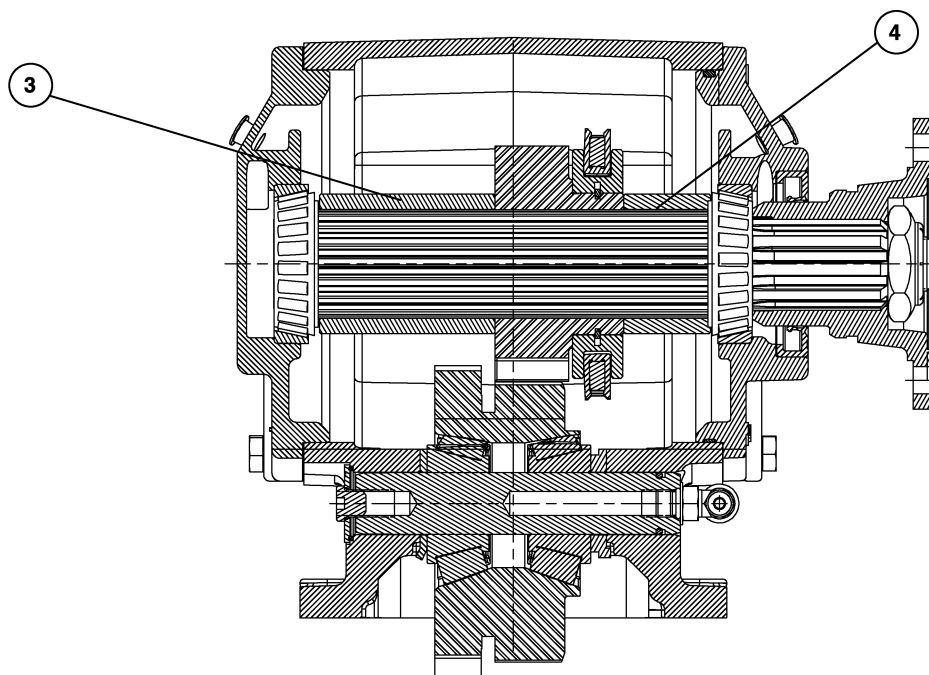


Ass'y 6

PTO Housing Dimensions

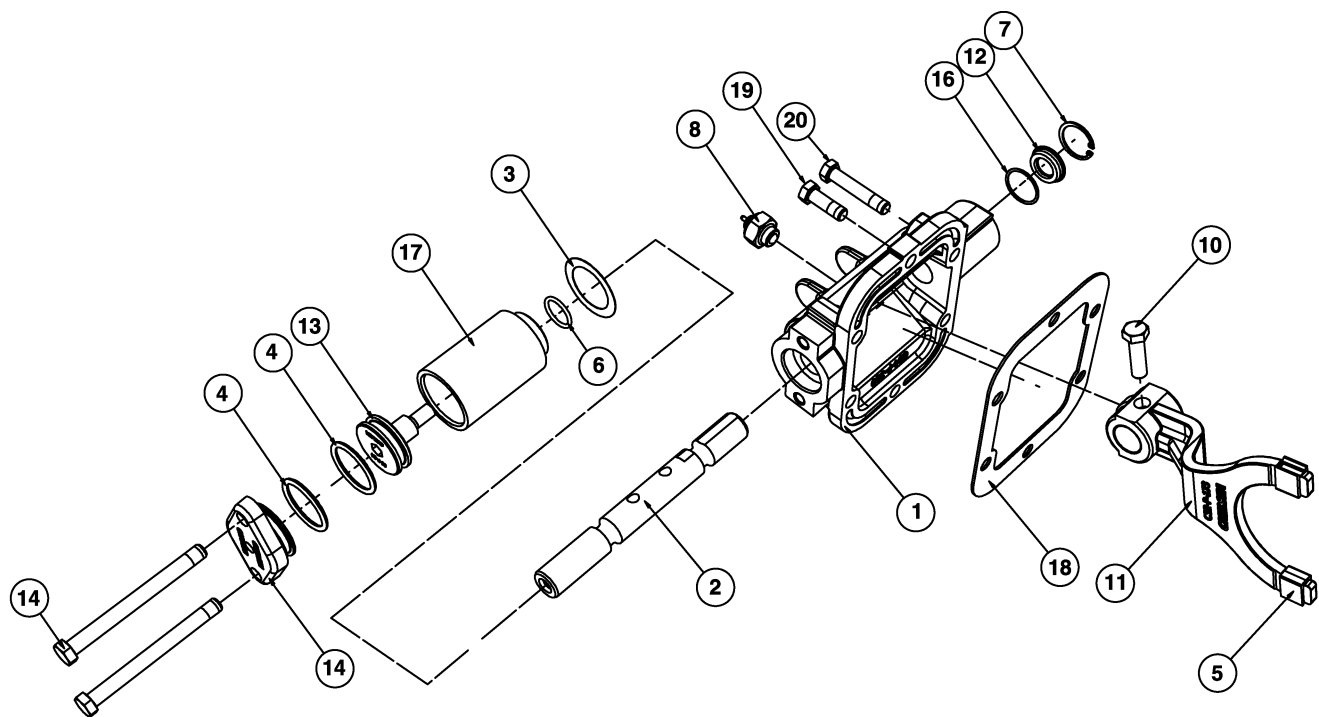


PTO Series	Housing Number	CA	CB	CC	CD	CH
880G	1-P-507X	1.84"	5.71"	1.561"	4.166"	9.35
880K	1-P-507X	1.84"	5.71"	1.561"	4.166"	9.35
880L	1-P-509X	0.92"	5.71"	1.561"	4.166"	9.35
880Q	1-P-778X	1.67"	5.71"	1.561"	4.166"	9.35
880X	1-P-507X	1.84"	5.71"	1.561"	4.166"	9.35
880Z	1-P-509X	0.92"	5.71"	1.561"	4.166"	9.35

Constant Mesh Parts

Item	Part Number	Description	Qty.
	329216-1X	Constant Mesh Kit, Fuller CEEMAT™	
3	4-P-171	Spacer, Output Shaft 2.825" width, Constant mesh only.....	1
4	4-P-164	Spacer, Output Shaft 1.392" width, Constant mesh only.....	1
16	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
	34-P-319	6-Bolt Cover Plate - Thick	1
	35-P-117	6 Bolt Gasket	1
	329216-4X	Constant Mesh Kit, Standard	
	378431CR-6	Hex Head Capscrew (.375"-16 x .625").....	6
3	4-P-163	Spacer, Output Shaft 2.825" width, Constant mesh only.....	1
4	4-P-164	Spacer, Output Shaft 1.392" width, Constant mesh only.....	1
	34-P-319	6-Bolt Cover Plate - Thick	1
	35-P-117	6 Bolt Gasket	1
16	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

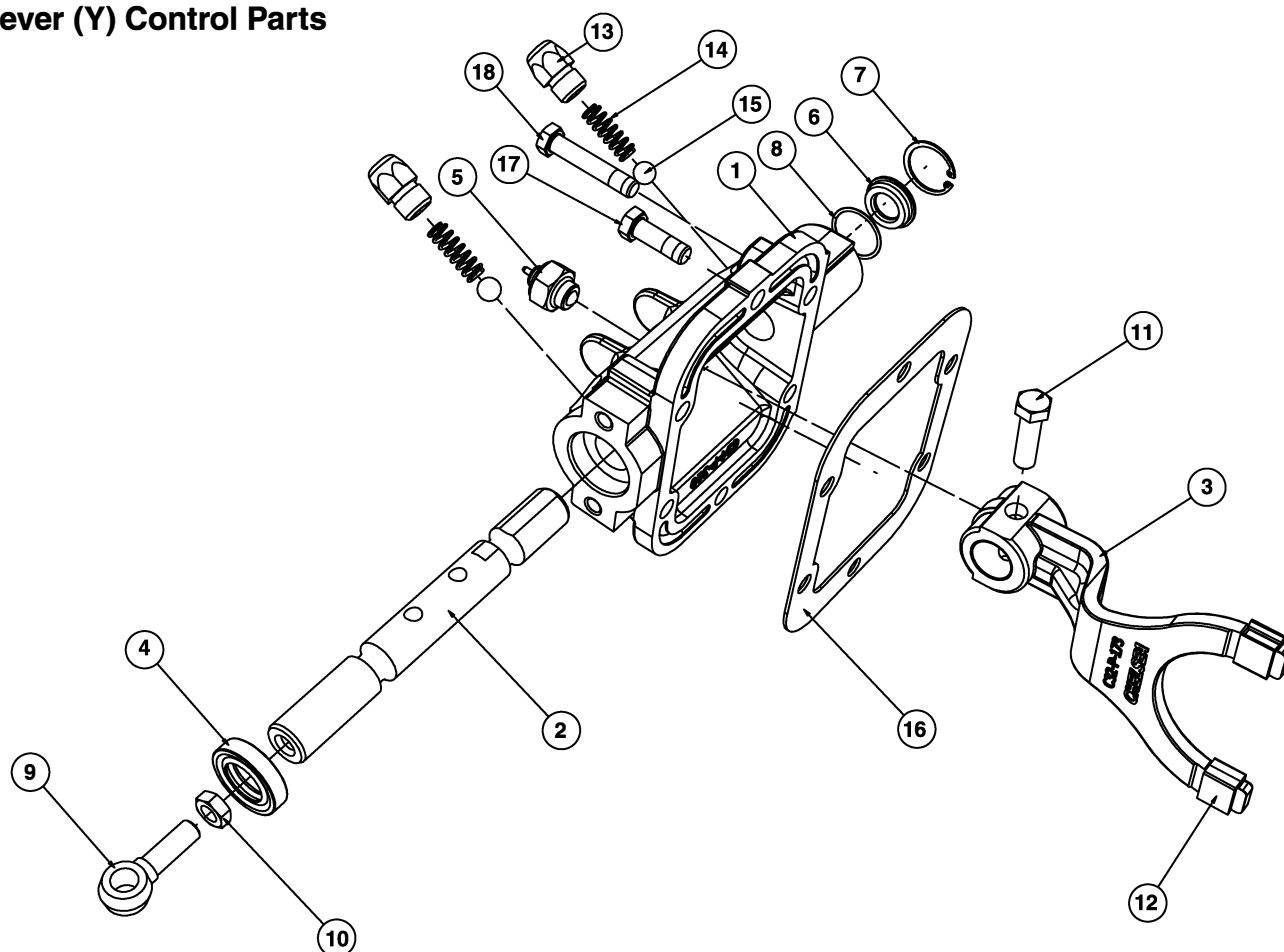
Air Shift (A) Control Parts



Item	Part Number	Description	
	329216-3X	Air Shifter Kit.....	1
	328388-61X	Installation Kit	1
	329772X	Air Shift Cover Assembly (Includes items 1 thru 17)	
1	34-P-311	Cover Shifter.....	1
2	11-P-165	Shaft Shifter.....	1
3	22-P-113	Gasket .823"	1
4	28-P-61	O-Ring 1.359" x .139".....	2
5	64-P-9	Clip Shifter Fork.....	1
6	28-P-198	O-Ring .798" x .103".....	1
7	378316	Lockring Internal.....	1
8	380515	Switch Indicator	1
N.S.	500897-5	Plug Shipping	2
10	378431-12	Capscrew HH .375"-16 x 1.250"	2
11	32-P-172	Fork Shifter	1
12	378315	Plug Cover	1
13	66-P-24	Piston Shifter	1
14	379027	Cap Cylinder.....	1
15	378431-30	Capscrew HH .375"-16 x 4.00"	2
16	28-P-42	O-Ring 1.051" x .070".....	1
17	65-P-43	Cylinder Air Shift.....	1
18	35-P-59	Gasket	1
19	378431-11	Capscrew Hex Head, (.375"-16 x 1.125").....	2
20	378431-18	Capscrew Hex Head, (.375"-16 x 2.000").....	4

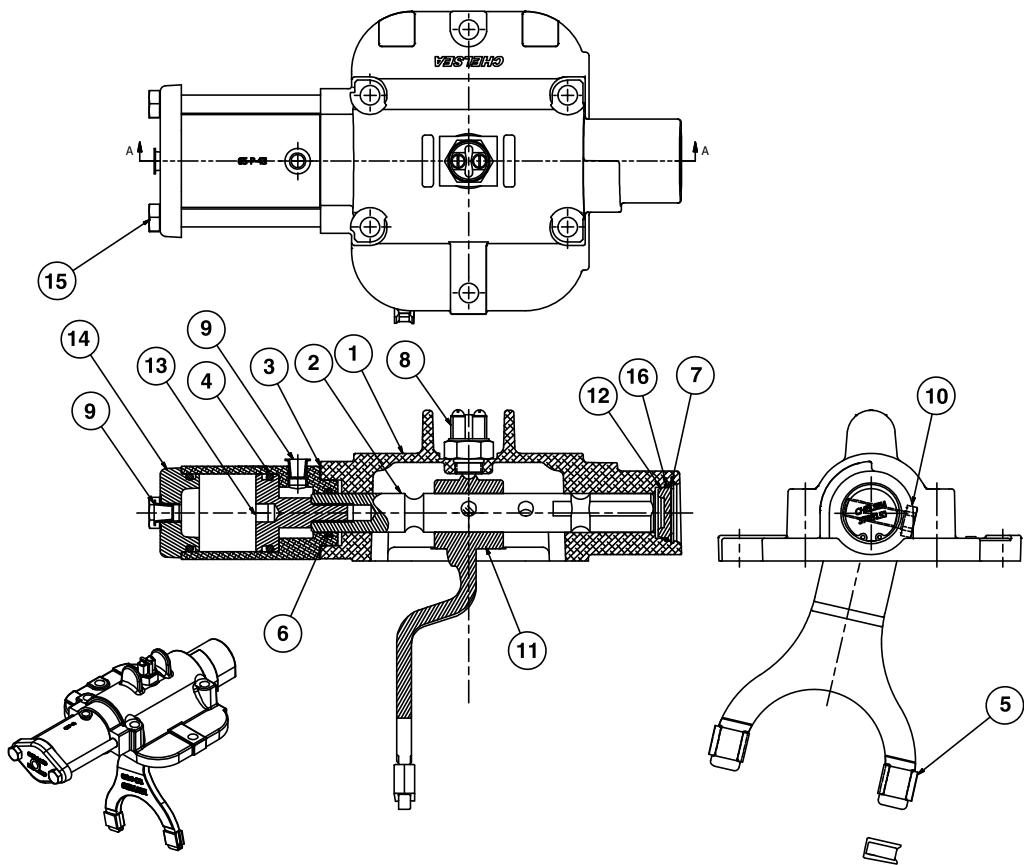
N.S. – Not Shown

Lever (Y) Control Parts



Item	Part Number	Description	
	329216-2X	Shifter Kit Lever	1
	328751-1X	Installation Kit	1
	329774X	Lever Control Assembly (Includes items 1 thru 15)	
1	34-P-312	Cover Shifter	1
2	11-P-165	Shaft Shifter	1
3	32-P-172	Fork Shifter	1
4	28-P-218	Oil Seal	1
5	380515	Switch Indicator	1
6	378315	Plug Cover	1
7	378316	Lock ring, Internal	1
8	28-P-42	O-Ring	1
9	36-P-1	Eye Bolt	1
10	500381-3	Hex Jamb Nut, .375"-24	1
11	378431-12	Capscrew HH .375"-16 x 1.250"	2
12	64-P-9	Clip Shifter Fork	2
13	378554	Cap Poppet	2
14	37-P-41	Spring .406" x 1.125"	2
15	378002	Ball Shifter .437"	2
16	35-P-59	Gasket	1
17	378431-11	Capscrew Hex Head (.375"-16 x 1.125")	2
18	378431-18	Capscrew Hex Head (.375"-16 x 2.000")	4

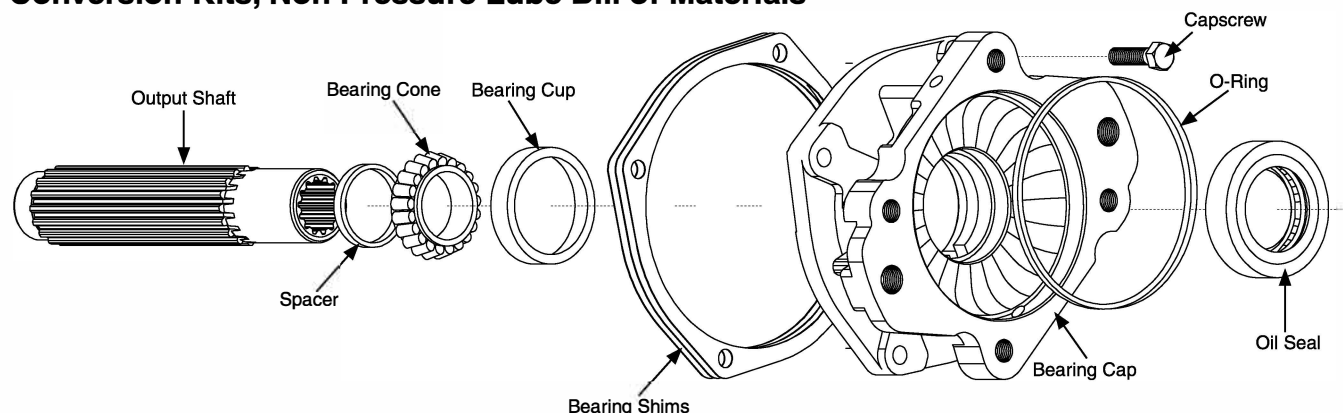
Electric Over Air Shift (D) Control Parts



Item	Part Number	Description	Qty.
	329777X	COVER ASSEMBLY (Includes items 1 thru 17)	
1	34-P-311	Cover Shifter.....	1
2	11-P-165	Shaft Shifter.....	1
3	22-P-113	Gasket 1.3865" x 1.937" x .015".....	1
4	28-P-61	O-Ring 1.359" x .139".....	2
5	64-P-9	Clip Shifter Fork.....	2
6	28-P-198	O-Ring .798" x .103".....	1
7	378316	Lockring Internal.....	1
8	379038	Switch Indicator	1
9	500897-5	Plug Shipping	2
10	378431-12	Capscrew HH .375"-16 x 1.250".....	1
11	32-P-172	Fork Shifter	1
12	378315	Plug Cover	1
13	66-P-24	Piston Shifter	1
14	379027	Cap Cylinder.....	1
15	378431-30	Capscrew HH .375"-16 x 4.00"	2
16	28-P-42	O-Ring 1.051" x .070".....	1
17	65-P-43	Cylinder Air Shift.....	1

Direct Mount Pump Option Description**For Bottom or Side Mounted Transmissions (Fuller, Mack or Spicer)****Output Option Conversion Kits (Splash Lube)**

Flange Suffix	Flange Type	Shaft Type	Conversion Kit (From XV)
AF	SAE B 2 & 4-Bolt	SAE BB (1" - 15T)	328591-104X (Splash Lube) 328591-105X (Pressure Lube)
AZ	SAE B 2 & 4-Bolt	SAE C (1-1/4" - 14T)	328591-127X (Splash Lube) 328591-128X (Pressure Lube)
XK	SAE B 2 & 4-Bolt	SAE B (7/8" - 13T)	328591-32X (Splash Lube) 328591-58X (Pressure Lube)
XS	SAE C 2 & 4-Bolt	SAE C (1-1/4" - 14T)	328591-31X (Splash Lube) 328591-49X (Pressure Lube)
XY	ISO 7653	DIN 5462 Spline	328591-34X (Splash Lube)
GS	Greaseable Output Shaft SAE C 2 or 4-Bolt	SAE C (1-1/4" - 14T)	328591-135X (XV to GS) 328591-133X (XS to GS)

Conversion Kits, Non Pressure Lube Bill of Materials

PTO Output	Conversion Kit	Bearing Cap	Output Shaft	Oil Seal	Bearing Cone/Cup	Spacer	O-Ring
AF (XV to AF)	328591-104X	21-P-539	3-P-940	28-P-219	560976/560977	4-P-162	28-P-259
AZ (XV to AZ)	328591-127X	21-P-539	3-P-873	28-P-219	560976/560977	4-P-162	28-P-259
GS (XV to GS)	328591-135X	21-P-515 (O) 21-P-653X (R)	3-P-949X	28-P-219 28-P-226	560976/560977 560986/560982	4-P-162	28-P-245
GS (XS to GS)	328591-133X	21-P-653X (R)	3-P-949X	28-P-219 (O) 28-P-226 (R)	560976/560977 560986/560982	4-P-162	28-P-245 (O)
XK	328591-32X	21-P-539	3-P-874	28-P-219	560976/560977	4-P-162	28-P-259
* XK		21-P-539	3-P-901*	28-P-219	560976/560977	4-P-162	28-P-259
XS	328591-31X	21-P-515	3-P-873	28-P-219	560976/560977	4-P-162	28-P-245
* XS		21-P-515	3-P-900*	28-P-219	560976/560977	4-P-162	28-P-245
* XY	328591-34X	21-P-541	3-P-878	28-P-267	560985/560984 (O) 560986/560982 (R)		28-P-196

* Special pump shaft, housing (1-P-530) and closed end bearing cap (21-P-590), required for 880F when used with Fuller CEEMAT™ transmission. This option is only available in the 5 assembly arrangement. No Conversion Kit is currently available. Parts must be ordered separately.

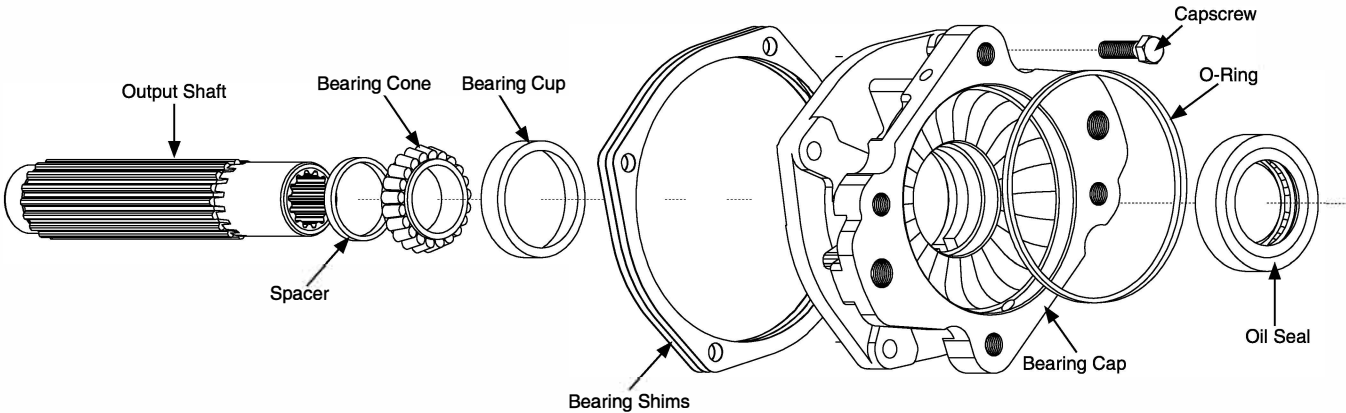
FOOTNOTES: O = Output Bearing Cap R = Rear Bearing Cap

NOTE: The Conversion Kits include all the items shown plus two each of the Bearing Shims 55-P-20-1, 55-P-20-2, 55-P-20-3, 560977 Bearing Cup, and four Hex Head Capscrews 379286-11.

NOTE: These options and conversion kits are normally used on the bottom or side openings of Fuller, Mack & Spicer Transmissions.

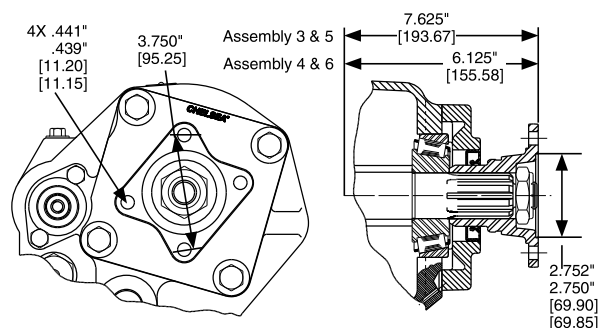
NOTE: See Kits Bills of Material in back of book for complete Conversion Kit BOM.

Conversion Kits, Pressure Lube Bill of Materials

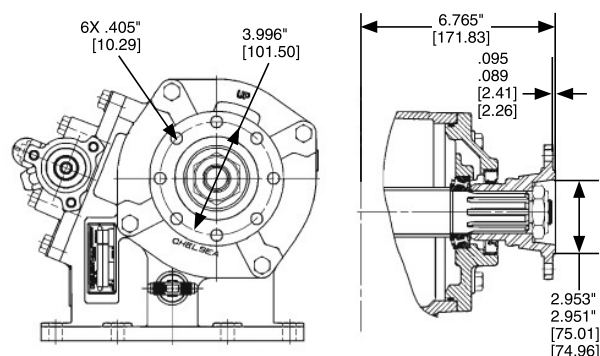


PTO Output	Conversion Kit	Bearing Cap	Output Shaft	Oil Seal	Bearing Cone/Cup	Spacer	O-Ring
AF	328591-105X (Pressure Lube)	21-P-592	3-P-940	28-P-219	560976/560977	4-P-162	28-P-259
AZ	328591-128X (Pressure Lube)	21-P-592	3-P-873	28-P-219	560976/560977	4-P-162	28-P-259
XK	328591-58X (Pressure Lube)	21-P-592	3-P-874	28-P-219	560976/560977	4-P-162	28-P-259
XS	328591-49X (Pressure Lube)	21-P-544	3-P-873	28-P-219	560976/560977	4-P-162	28-P-245

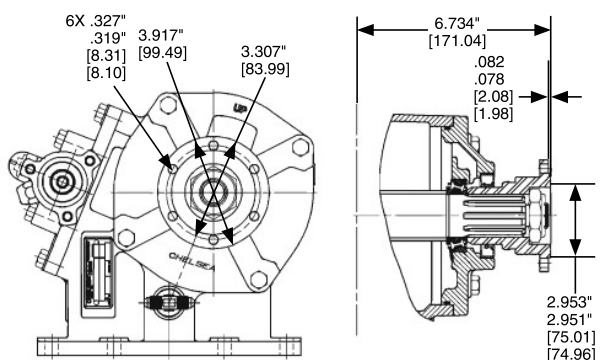
Bill of Materials - Driveline Output



XV Output Option 1410 Series Companion Flange		
Part Number	Description	Qty.
3-P-872	Output Shaft (1-1/2"-10T)	1
28-P-211	Oil Seal	1
21-P-517	Bearing Cap (X Lube)	1
21-P-595	Bearing Cap (P Lube)	1
378431-11	Socket Hex Capscrew (.375"-16 x 1.125")	4
378382	Hex Nut .875"-14	1
3-1-3431	Companion Flange 1410 Series	1
560982	Tapered Bearing Cup	1
560986	Tapered Bearing Cone	1



* AB Output Option DIN 120 Flange		
Part Number	Description	Qty.
3-P-872	Output Shaft	1
21-P-517	Bearing Cap, Output	1
21-P-596	Bearing Cap, Output (For Pressure Lube)	1
28-P-211	Oil Seal	1
378558	Hex Nut	1
379558	Companion Flange	1
560982	Tapered Bearing Cup	1
560986	Tapered Bearing Cone	1
†328591-59X	Conversion Kit (XV to AB) (Splash Lube)	
†328591-60X	Conversion Kit (XV to AB) (Pressure Lube)	

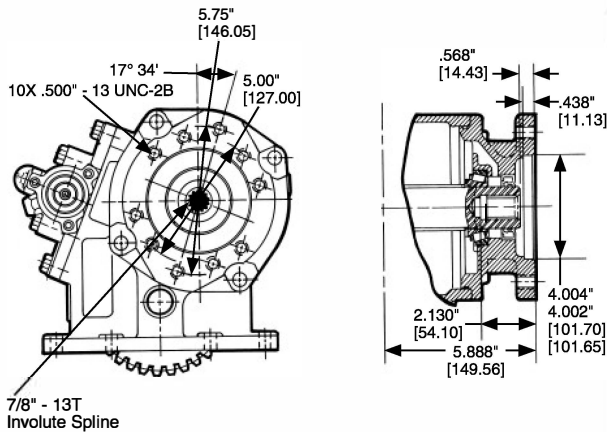


* AC Output Option DIN 100 Flange		
Part Number	Description	Qty.
3-P-872	Output Shaft	1
21-P-517	Bearing Cap, Output	1
21-P-596	Bearing Cap, Output (For Pressure Lube)	1
28-P-211	Oil Seal	4
378382	Hex Nut	1
379742	Companion Flange (DIN 100)	1
560982	Tapered Bearing Cup	1
560986	Tapered Bearing Cone	1
†328591-119X	Conversion Kit (XV to AC) (X Lube Option)	
†328591-120X	Conversion Kit (XV to AC) (P Lube Option)	

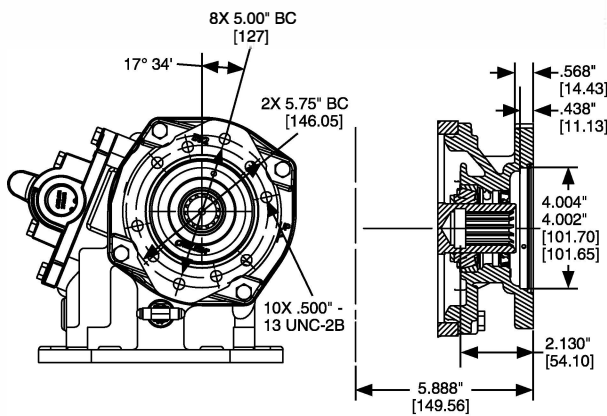
* No longer a current option per 2018 Chelsea Suggested List Price.

†Conversion Kits do not include all parts listed above. See [pages 38-43](#) for Conversion Kit BOMs.

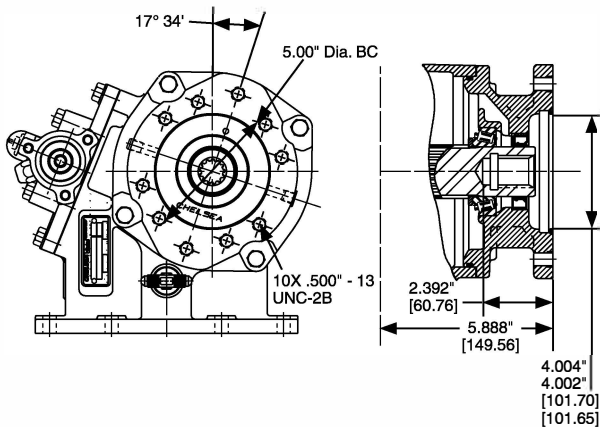
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Output Options**Parts List
880 Series****Bill of Materials - Pump Mount Output**

XK Output Option SAE B 2 or 4-Bolt Flange, SAE B Shaft (7/8" - 13T)		
Part Number	Description	Qty.
3-P-901	Output Shaft (F Mounting Type).....	1
3-P-874	Output Shaft (All Other Mounting Types)	1
28-P-219	Oil Seal	1
4-P-162	Spacer	1
21-P-539	Bearing Cap, Output.....	1
21-P-592	Bearing Cap, Output (For Pressure Lube).....	1
378447-6	Socket Hex Capscrew (.312"-18 x 1.000").....	4
28-P-259	O-Ring	1
560977	Tapered Bearing Cup.....	1
560976	Tapered Bearing Cone.....	1
379231	Pipe Plug (Pressure Lube Only)	1
500897-3	Shipping Plug (Pressure Lube Only)	1
†328591-32X	Conversion Kit (XV to XK) (Splash Lube)	
†328591-58X	Conversion Kit (XV to XK) (Pressure Lube)	



AF Output Option SAE B 2 or 4-Bolt Flange, SAE BB Shaft (1" - 15T)		
Part Number	Description	Qty.
28-P-219	Oil Seal	1
28-P-259	O-Ring	1
560976	Bearing Cone.....	1
560977	Bearing Cup.....	1
379231	Pipe Plug (Pressure Lube Only)	1
500897-3	Shipping Plug (Pressure Lube Only)	2
21-P-592	Bearing Cap - Output (Pressure Lube).....	1
21-P-539	Bearing Cap - Output.....	1
3-P-940	Output Shaft	1
4-P-162	Spacer	1
†328591-104X	Conversion Kit (XV to AF) (Splash Lube)	
†328591-105X	Conversion Kit (XV to AF) (Pressure Lube)	

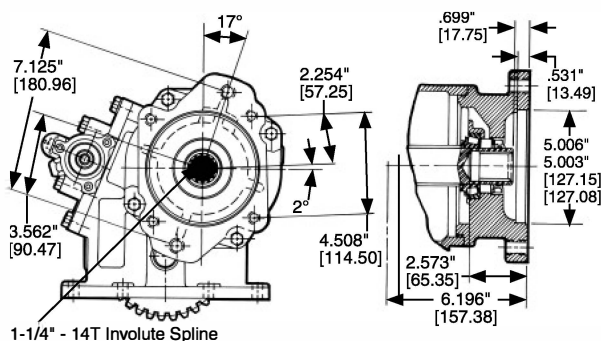


AZ Output Option SAE B 2 or 4-Bolt Flange, SAE C Shaft (1-1/4" - 14T)		
Part Number	Description	Qty.
3-P-873	Output Shaft	1
28-P-219	Oil Seal	1
21-P-539	Bearing Cap, Output.....	1
21-P-592	Bearing Cap, Output (Pressure Lube Only).....	1
28-P-259	O-Ring	1
500007-29	Woodruff Key.....	1
379231	Pipe Plug (Pressure Lube Only)	1
500897-3	Shipping Plug (Pressure Lube Only)	1
†328591-127X	Conversion Kit (XV to AZ) (Splash Lube)	
†328591-128X	Conversion Kit (XV to AZ) (Pressure Lube)	

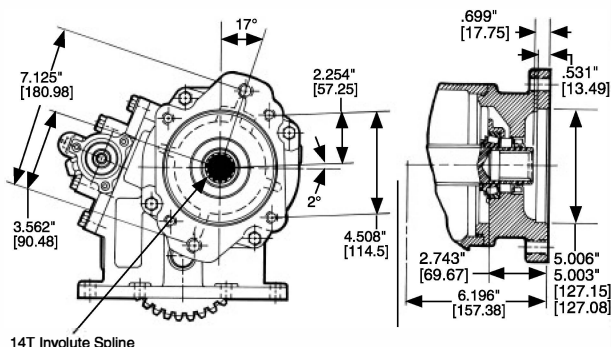
†Conversion Kits do not include all parts listed above. See [pages 38-43](#) for Conversion Kit BOMs.

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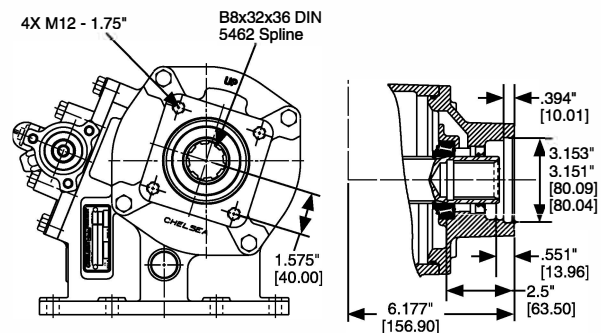
Bill of Materials - Pump Mount Output (Continued)



XS Output Option SAE C 2 or 4-Bolt Flange, SAE C Shaft (1-1/4" - 14T)		
Part Number	Description	Qty.
3-P-202	Output Shaft	1
28-P-216	Oil Seal	1
329273X	Bearing Cap Ass'y.....	1
378447-6	Socket Hex Capscrew (.312"-18 x 1.000").....	4
500007-29	Woodruff Key.....	1
379828	Companion Flange	1
378454-7	Set Screw	1
†328591-31X	Conversion Kit (XV to XS) (Splash Lube)	
†328591-49X	Conversion Kit (XV to XS) (Pressure Lube)	



GS Output Option Greaseable SAE C 2 or 4-Bolt Flange, SAE C Shaft (1-1/4" - 14T)		
Part Number	Description	Qty.
3-P-202	Output Shaft (1-1/4" Round w/ 5/16" Keyway).....	1
28-P-216	Oil Seal	1
329273X	Bearing Cap Ass'y.....	1
378447-6	Socket Hex Capscrew (.312"-18 x 1.000").....	4
500007-29	Woodruff Key.....	1
379828	Companion Flange	1
378454-7	Set Screw	1
†328591-135X	Conversion Kit (XV to GS)	
†328591-133X	Conversion Kit (XS to GS)	

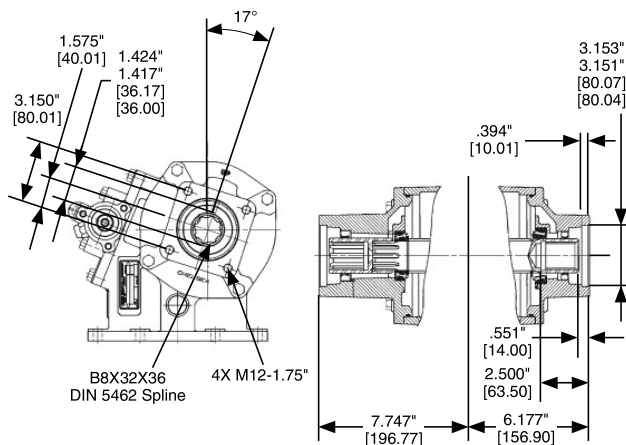


XY Output Option ISO 7653 Pump Mount DIN 5462 Shaft		
Part Number	Description	Qty.
3-P-876	Output Shaft (DIN 5462 - 10T)	1
28-P-267	Oil Seal	1
329273X	Bearing Cap Ass'y.....	1
378447-6	Socket Hex Capscrew (.312"-18 x 1.000").....	4
†328591-34X	Conversion Kit (XV to XY) (Splash Lube)	

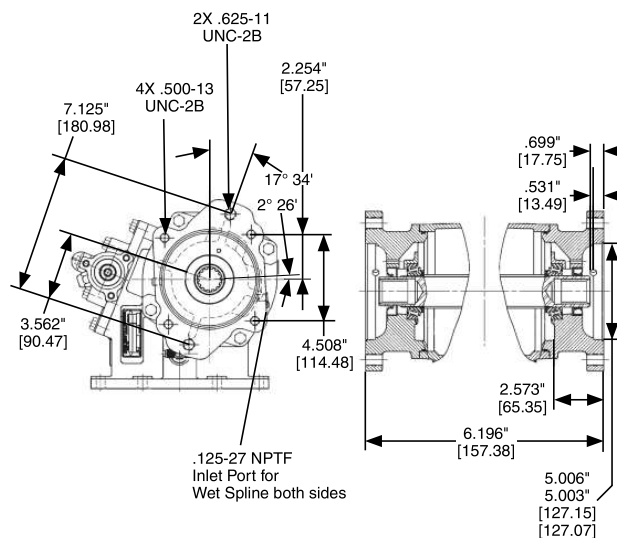
†Conversion Kits do not include all parts listed above. See [pages 38-43](#) for Conversion Kit BOMs.

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Bill of Materials - Pump Mount Output (Continued)



* YY Output Option DIN 80mm Flange, DIN 5462 Shaft (Both Ends)		
Part Number	Description	Qty.
3-P-880	Output Shaft	1
21-P-541	Output Bearing Cap.....	1
21-P-652	Rear Bearing Cap.....	1
28-P-287	Oil Seal	1
28-P-275	Oil Seal	1
379555	Lockring	1
560984	Tapered Bearing Cup.....	1
560985	Tapered Bearing Cone.....	1
561012	Tapered Bearing Cup.....	1
561011	Tapered Bearing Cup.....	1
378898	Flat Hex Capscrew (.438"-14 x 1.000")	1
379560	Spline Coupling	1
†328591-61X	Conversion Kit (XV to YY) (Splash Lube)	



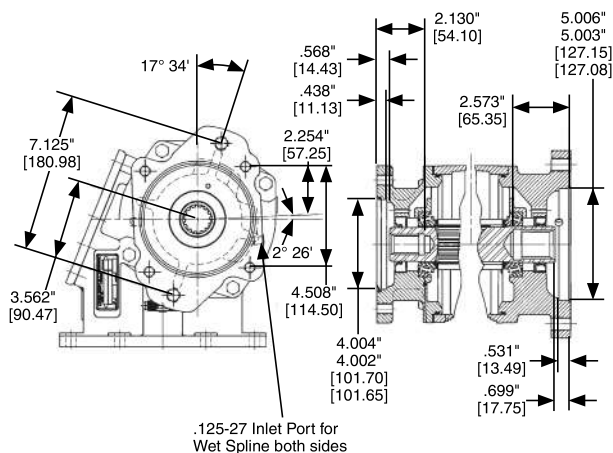
* SS Output Option SAE C 2 or 4-Bolt Flange, SAE C Shaft (1-1/4" - 14T Both Ends)		
Part Number	Description	Qty.
3-P-875	Output Shaft	1
4-P-162	Spacer	2
21-P-515	Output Bearing Cap.....	1
21-P-544	Output Bearing Cap (For Pressure Lube).....	1
21-P-515	Rear Bearing Cap.....	1
21-P-544	Rear Bearing Cap (For Pressure Lube).....	1
28-P-219	Oil Seal	1
28-P-214	Oil Seal	1
28-P-245	O-Ring	2
560977	Tapered Bearing Cup.....	2
560976	Tapered Bearing Cone.....	2
379231	Pipe Plug (Pressure Lube)	2
500897-3	Shipping Plug (Pressure Lube).....	2
69-P-18	Tag (Wet Spline Only).....	1
†328591-50X	Conversion Kit (XV to SS) (Splash Lube)	
†328591-51X	Conversion Kit (XV to SS) (Pressure Lube)	

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

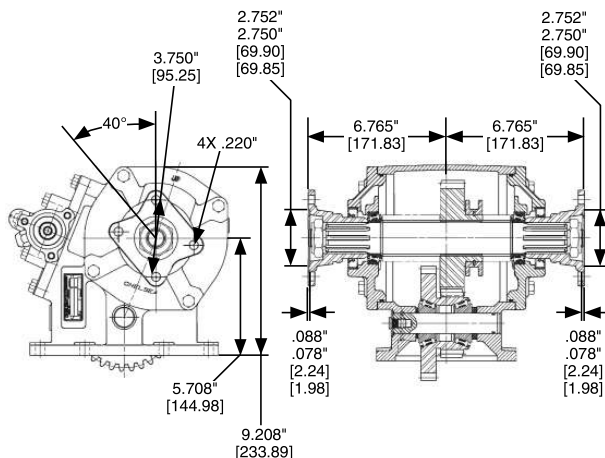
†Conversion Kits do not include all parts listed above. See [pages 38-43](#) for Conversion Kit BOMs.

Continued on next page

Bill of Materials - Pump Mount Output (Continued)



* SK Output Option SAE C 2 or 4-Bolt Flange, SAE C Shaft (1-1/4" - 14T Right Side) SAE B 2 or 4-Bolt Flange, SAE C Shaft (7/8" - 13T Left Side)		
Part Number	Description	Qty.
3-P-902	Output Shaft	1
4-P-162	Spacer	2
21-P-515	Output Bearing Cap.....	1
21-P-593	Output Bearing Cap (For Pressure Lube).....	1
21-P-539	Rear Bearing Cap.....	1
21-P-592	Rear Bearing Cap (For Pressure Lube).....	1
28-P-219	Oil Seal	1
28-P-214	Oil Seal	1
28-P-245	O-Ring	1
28-P-259	O-Ring	1
560977	Tapered Bearing Cup.....	1
560976	Tapered Bearing Cone.....	1
379231	Pipe Plug	2
500897-3	Shipping Plug	2
69-P-18	Tag (Wet Spline Only).....	1
†328591-67X	Conversion Kit (XV to SK) (Pressure Lube)	

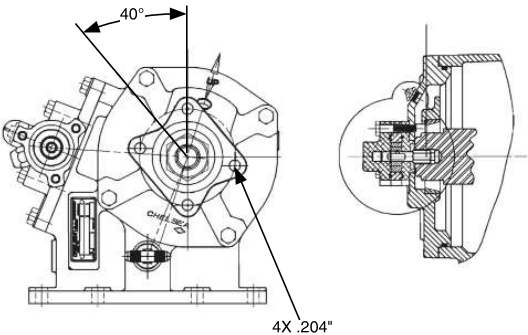


* VV Output Option 1410 Companion Flanges (Both Sides)		
Part Number	Description	Qty.
3-P-916	Output Shaft 1-1/2"-10T (Both Sides).....	1
21-P-517	Output Bearing Cap.....	1
21-P-596	Output Bearing Cap (For Pressure Lube).....	1
21-P-517	Rear Bearing Cap.....	1
21-P-596	Rear Bearing Cap (For Pressure Lube).....	1
28-P-211	Oil Seal	2
378382	Hex Nut.....	2
380503	Companion Flange 1410 Series	2
560982	Tapered Bearing Cup.....	2
560986	Tapered Bearing Cone.....	2
†328591-68X	Conversion Kit (XV to VV) (Splash Lube)	
†328591-69X	Conversion Kit (XV to VV) (Splash Lube)	

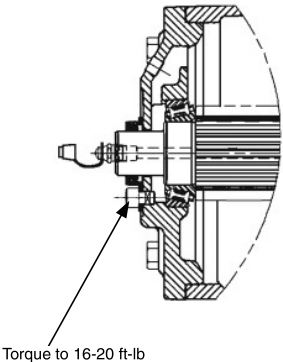
* No longer a current option per 2018 Chelsea Suggested List Price.

†Conversion Kits do not include all parts listed above. See [pages 38-43](#) for Conversion Kit BOMs.

Bill of Materials - Pump Mount Output (Continued)



L* Output Option Self Lube		
Part Number	Description	Qty.
3-P-878	Output Shaft	1
3-P-879	Output Shaft (LF Output)	
3-P-879	Output Shaft (LG Output)	
3-P-877	Output Shaft (LH Output)	
3-P-879	Output Shaft (LL Output)	
329127X	Bearing Cap & Lube Pump Ass'y	1
500897-3	Plastic Plug.....	2
500167-1	Relief Valve Fitting.....	2
†329111-1X	Conversion Kit (LG)	
†329111-2X	Conversion Kit (LH)	
†329111-2X	Conversion Kit (LF)	

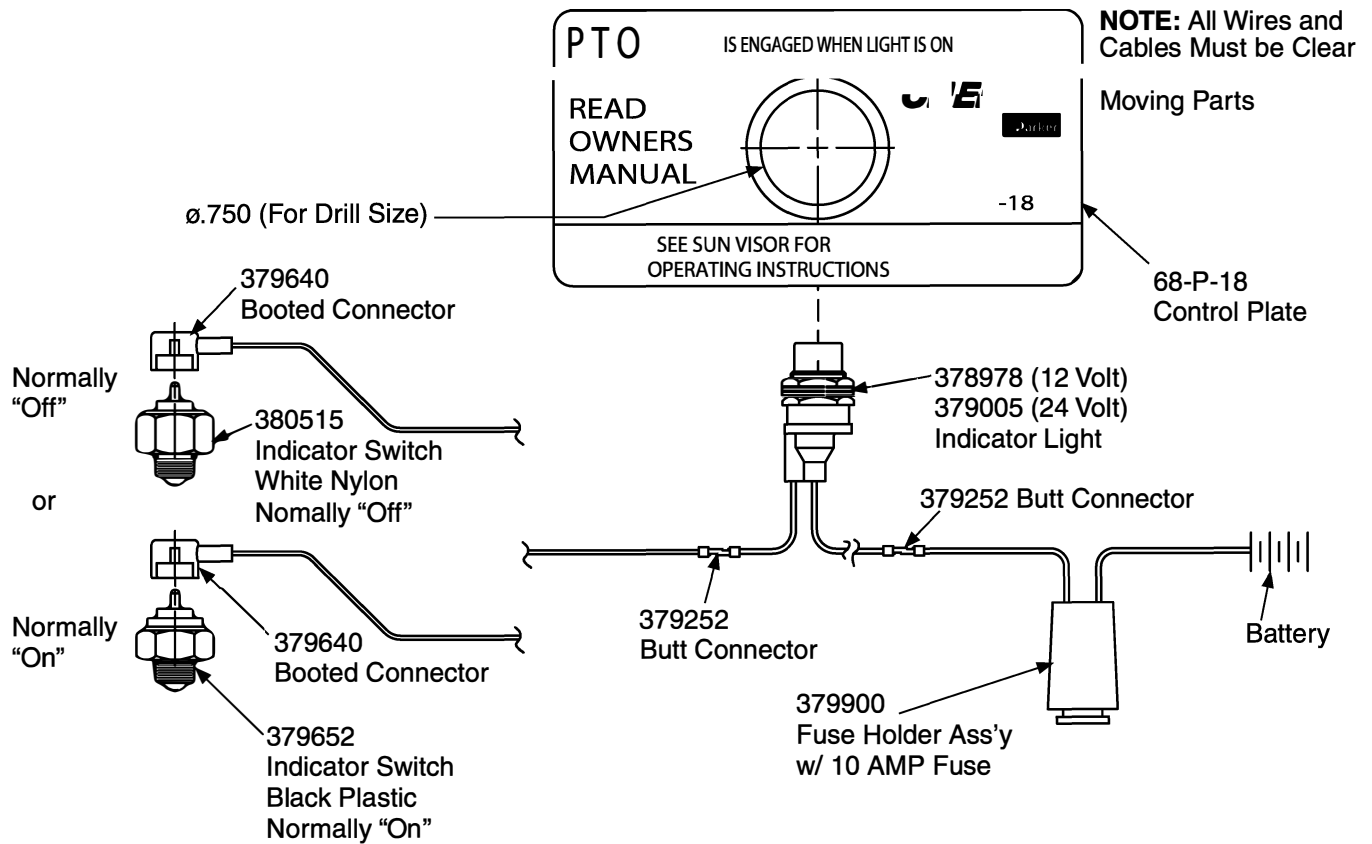


G* Output Option Greaseable		
Part Number	Description	Qty.
3-P-949X	Greaseable Output Shaft Ass'y (GS Output)	1
379432-1	Socket Head Capscrew .312"-18 x .375"	3
28-P-226	Shaft Seal.....	1
21-P-653	Bearing Cap	1
379231	Pipe Plug	1
†328591-133X	Conversion Kit (XS to GS)	
†328591-135X	Conversion Kit (XV to GS)	

✦ No longer a current option per 2018 Chelsea Suggested List Price.
†Conversion Kits do not include all parts listed above. See [pages 38-43](#) for Conversion Kit BOMs.

Indicator Light Installation & Dash Drilling Template

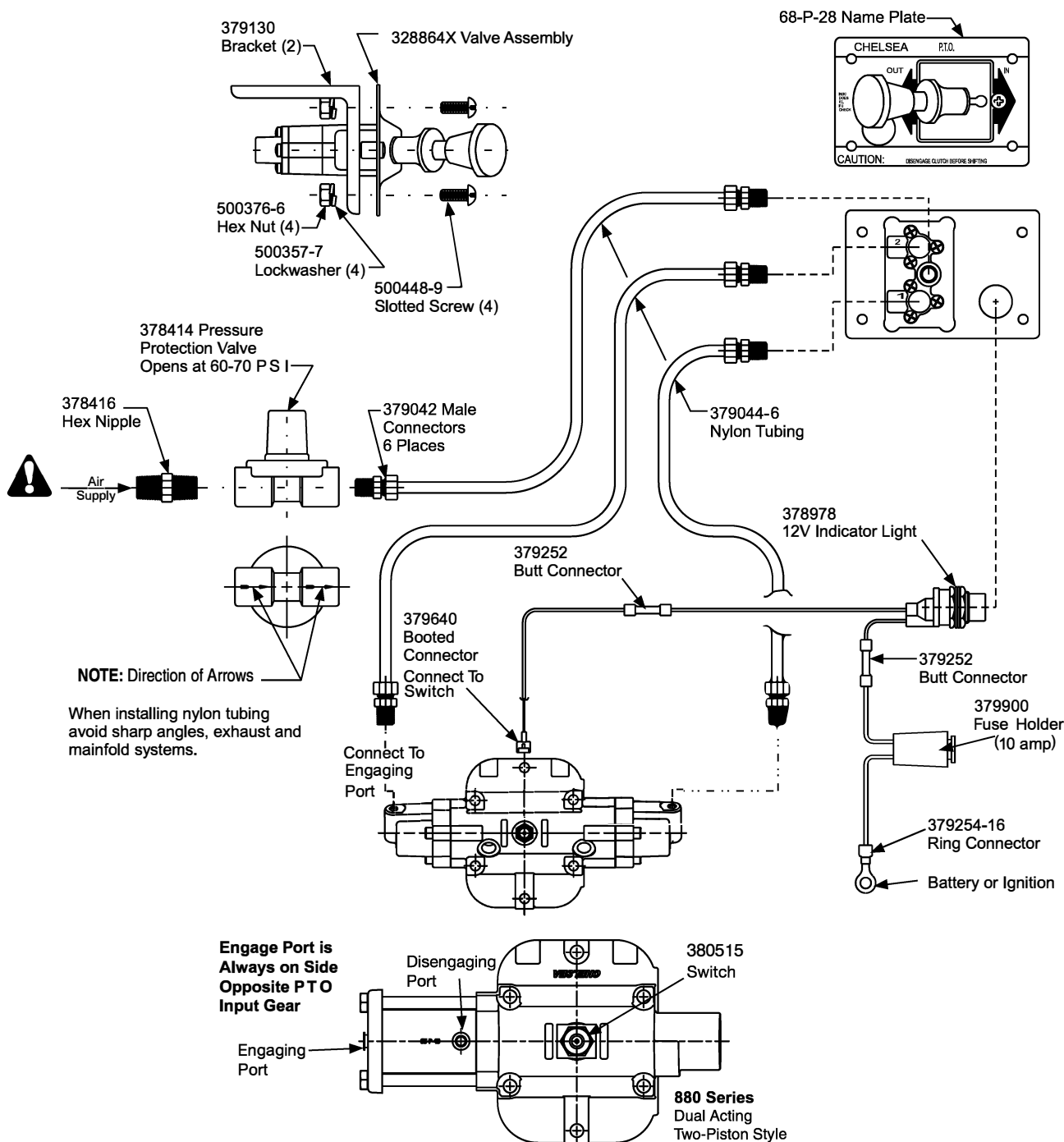
(SK-286 Rev G)



Air Shift – A Shift

(SK-276 Rev M)

Installation Kit: 328388-61X



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

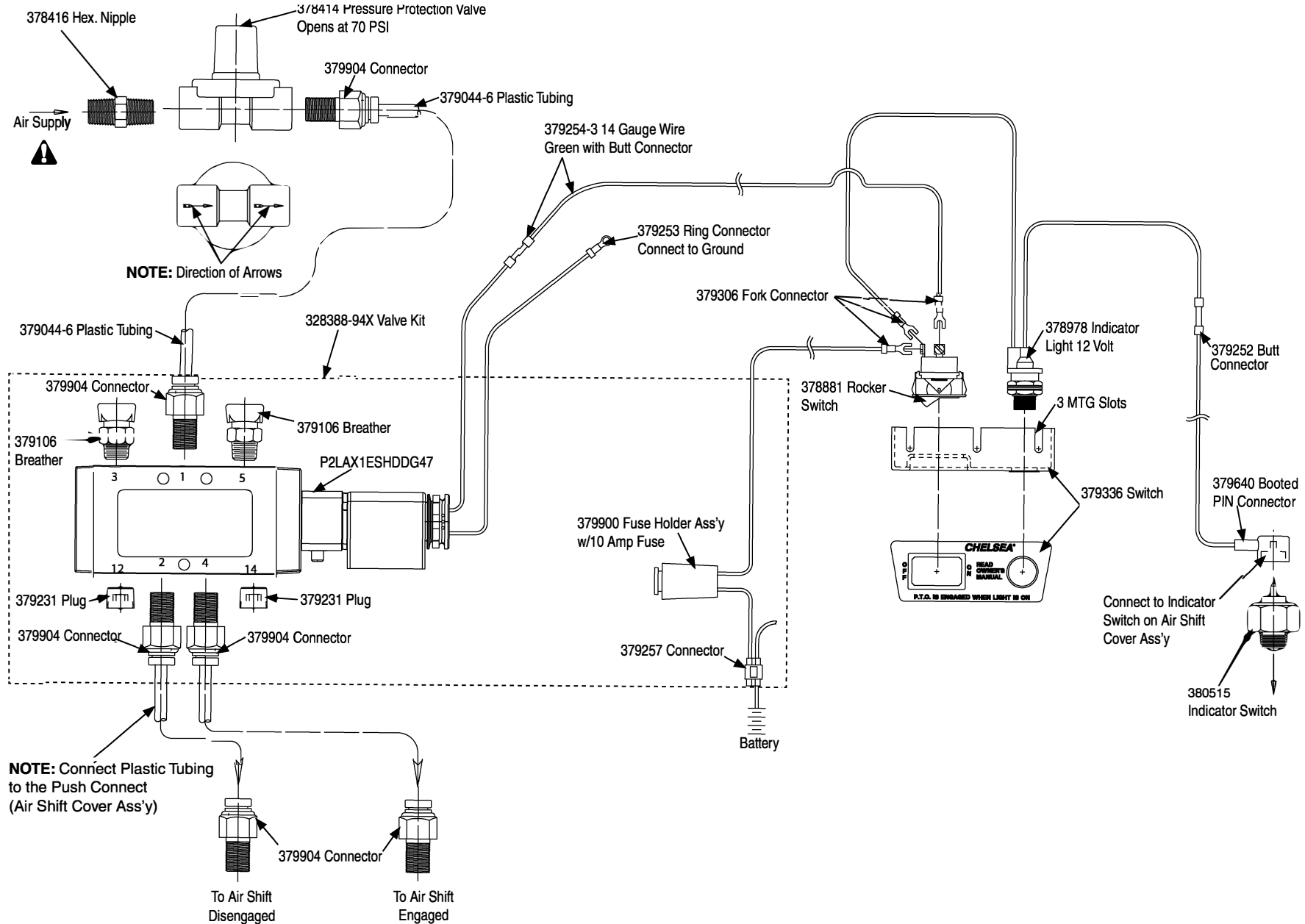
CAUTION: When installing nylon tubing avoid sharp angles, exhaust and manifold systems.

IMPORTANT: When this installation is used on vehicles with automatic transmissions, the PTO drive gear must be stopped before shifting.

NOTE: Tube nut is reusable as long as nylon tubing is not removed from the tube nut.

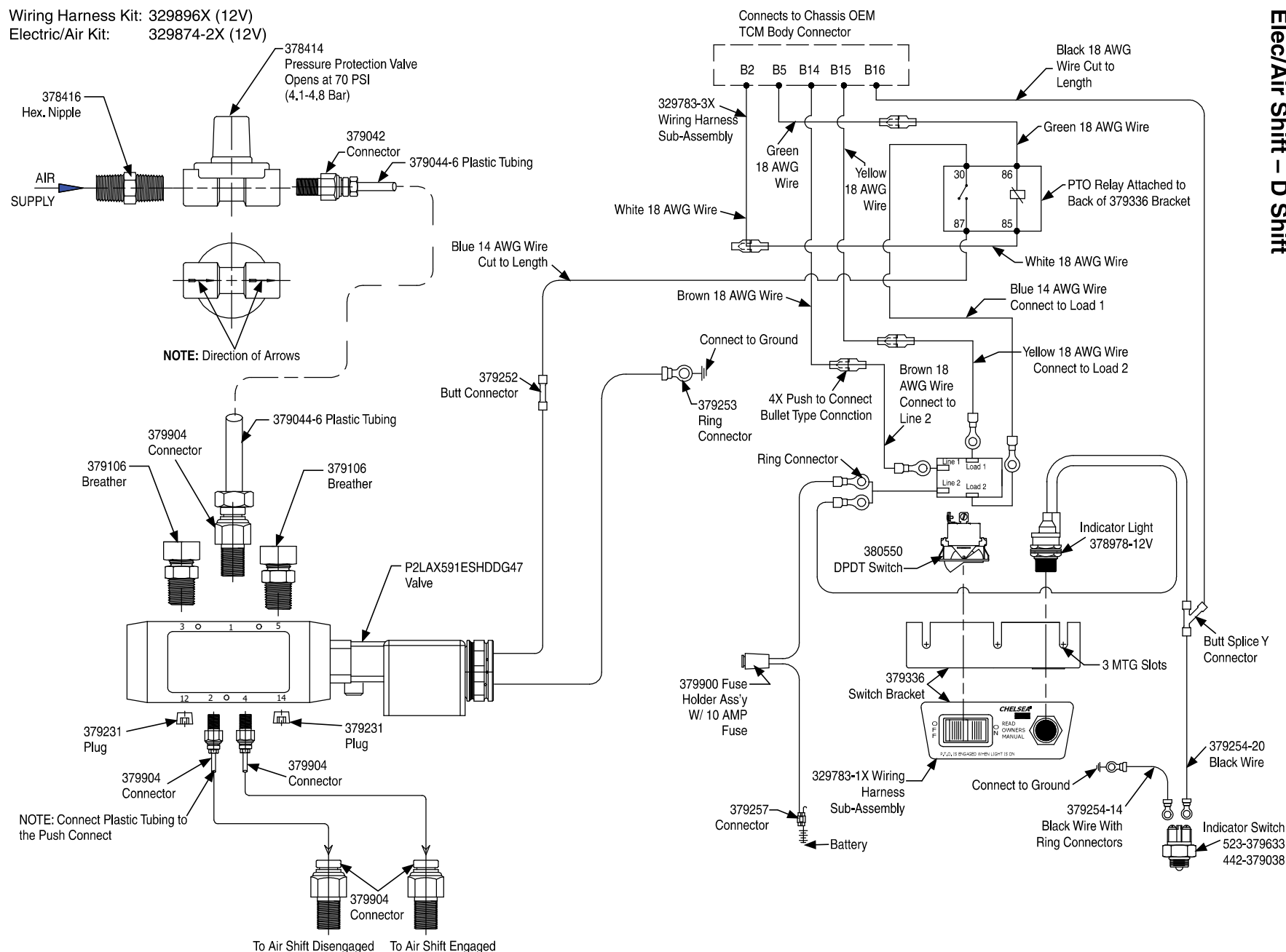
Electric/Air Shift – Por Q Shift

Installation Kit: 328388-93X (12V)



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

(SK-447 Rev B)



(SK-631 Rev A)

Part Number	Description	Qty.	Part Number	Description	Qty.
STUD KITS			INSTALLATION INSTRUCTION KITS		
328170-179X	Stud Kit (Standard Mount)		328948-8X	Gasket & Installation Instructions (All Except Q Mount)	
379424-21	Stud (.438"-14 x .438"-20 x 2.250")	8	35-P-15-1	Gasket .010"	1
379745	11/16" Hex Head Flange Nut (.438"-20)	8	35-P-15-2	Gasket .020"	1
328170-195X	Stud Kit (Deep Mount)		328948-48X	Gasket & Installation Instructions (Q Mount)	
379424-18	Stud (.438"-14 x .438"-20 x 2.000")	2	328946X	Caution Label Kit	1
379745	11/16" Hex Head Flange Nut (.438"-20)	8	379085-1	PTO Instructions Decal	1
379424-21	Stud (.438"-14 x .438"-20 x 2.250")	8	28-P-381	O-Ring Mounting Seal	1
328170-201X	Stud Kit (Metric Mount)		379624	Product Warranty Card	1
379745	11/16" Hex Head Flange Nut (.438"-20)	8	Owner's Manual	HY25-1135-M1/US	1
379429-19	Stud (M12 x 1.175" x .438"-20 x 2.000") ...	8	Safety Guide	HY25-1002-M1/US	1
328170-217X	Stud Kit (Eaton Endurant)		69-P-27	Supplemental Install Instructions	1
380605	Locking Patch Stud (M12-1.75 x .438"-20 x 1.921")	8	Continued on Next Page		
379745	11/16" Hex Head Flange Nut (.438"-20)	8			
BOMs in each kit group are listed in order based on part number.					

Part Number	Description	Qty.	Part Number	Description	Qty.
INSTALLATION KITS			SERVICE KITS		
328388-61X	Air Shift (A Shift Only)		328356-51X	Gasket & Seal Kit (Standard XV Output)	
68-P-28	Name Plate.....	1	22-P-98	Gasket.....	1
328388-45X	Air Shift.....	1	28-P-198	O-Ring.....	1
329090-2X	Valve Kit.....	1	28-P-198	O-Ring.....	1
328864X	Shifter Valve.....	1	28-P-211	Oil Seal.....	1
378414	Pressure Protection Valve.....	1	28-P-42	O-Ring.....	1
379044-6	Nylon Tubing.....	1	35-P-15-1	Mounting Gasket.....	2
379130	Support Bracket.....	2	35-P-15-2	Mounting Gasket.....	2
379252	Butt Connector.....	2	35-P-59	Gasket.....	1
379640	Booted Connector.....	1	55-P-20-1	Shim, Bearing Cover Green.....	2
379254-16	Ring Connect.....	1	55-P-20-2	Shim, Bearing Cover Brown.....	2
			55-P-20-3	Shim, Bearing Cover Yellow.....	2
328388-93X	Elec/Air Shift Kit (P Shift Only)		328356-52X	Gasket & Seal Kit (Pump Output)	
328388-94X	Valve and Connector Kit.....	1	22-P-98	Gasket.....	1
378414	Air Shifter Pressure Protection Valve.....	1	28-P-198	O-Ring.....	1
378881	Rocker Switch.....	1	28-P-198	O-Ring.....	1
378978	12V Indicator Light.....	1	28-P-219	Oil Seal.....	1
379044-6	Tubing (.253" x .179" x 30').....	1	28-P-42	O-Ring.....	1
379252	Electrical Butt Connector.....	2	35-P-15-1	Mounting Gasket.....	2
379336	Elec/Air Shifter Bracket Switch.....	1	35-P-15-2	Mounting Gasket.....	2
379254-3	14 Gauge Wire, Green		35-P-59	Gasket.....	1
	w/ Butt Connector.....	1	55-P-20-1	Shim, Bearing Cover Green.....	2
379640	Booted Connector.....	1	55-P-20-2	Shim, Bearing Cover Brown.....	2
			55-P-20-3	Shim, Bearing Cover Yellow.....	2
328751-1X	Indicator Light Kit		328356-53X	Gasket & Seal Kit (Y Shifter Type)	
378978	Indicator Light.....	1	28-P-218	Oil Seal.....	2
379252	Butt Connect.....	2	35-P-59	Shift Cover Gasket.....	1
68-P-18	Name Plate.....	1			
379640	Booted Connector.....	1			
379900	Ass'y Fuse.....	1			
			328356-54X	Gasket & Seal Kit (2 Sided Shifter)	
				(A Shifter Type)	
			22-P-96	Gasket.....	2
			28-P-61	O-Ring.....	4
			35-P-59	Shift Cover Gasket.....	1

Continued on Next Page

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

Part Number	Description	Qty.	Part Number	Description	Qty.
SERVICE KITS (Cont'd)			SERVICE KITS (Cont'd)		
328356-72X	Gasket & Seal Kit (1 Sided Shifter) (A Shifter Type)		329183X	Repair Kit/Overhaul	
22-P-113	Gasket .823"	1	14-P-66-1	Non Tabbed	2
28-P-61	O-Ring 1.359" x .139"	2	14-P-66-2	Non Tabbed	2
28-P-198	O-Ring .798" x .103"	1	14-P-66-3	Non Tabbed	2
28-P-42	O-Ring 1.051" x .070"	1	22-P-96	Gasket 880	2
35-P-59	Gasket	2	22-P-98	Gasket	1
328594-3X Bearing & Spacer Kit (Pressure Lube for B, D, G & J Ratios)			28-P-198	O-Ring	1
14-P-66-1	Non Tabbed	2	28-P-198	O-Ring	1
14-P-66-2	Non Tabbed	2	28-P-211	Oil Seal	1
14-P-66-3	Non Tabbed	2	28-P-218	Oil Seal	2
28-P-198	O-Ring	1	28-P-219	Oil Seal	1
28-P-42	O-Ring	1	28-P-42	O-Ring	1
379484	Plug O-Ring	1	28-P-61	O-Ring	4
379486	90° Elbow	1	35-P-15-1	Mounting Gasket	2
379505	Retainer O-Ring	1	35-P-15-2	Mounting Gasket	2
379564-2	Cap Thread	2	35-P-59	Gasket	1
379556	Tee .438"-2	1	55-P-20-1	Shim, Bearing Cover Green	2
560978	Bearing Cone (Tapered)	2	55-P-20-2	Shim, Bearing Cover Brown	2
9-P-80	Idler Shaft	1	55-P-20-3	Shim, Bearing Cover Yellow	2
14-P-81	Washer	1	560976	Bearing Tape	1
328594-5X Bearing & Spacer Kit (Pressure Lube for M, P, Q, R & T Ratios)			560977	Bearing Tape	1
14-P-66-1	Non Tabbed	2	560978	Bearing Cone Tapered	2
14-P-66-2	Non Tabbed	2	560982	Bearing Cup Tapered	2
14-P-66-3	Non Tabbed	2	560986	Bearing Tape	2
28-P-198	O-Ring	1	560987	Tapered Bearing Cone	2
28-P-42	O-Ring	1	329216-2X Shifter Kit (Lever Shift)		
379484	Plug O-Ring	1	328751-1X	Install Kit	1
379486	90° Elbow	1	329125X	Shifter Cover	1
379505	Retainer O-Ring	1	35-P-59	Gasket	1
379564-2	Cap Thread	2	378431-11	Hex Capscrew	2
379556	Tee .438"-2	1	378431-18	Capscrew	4
560987	Tapered Bearing Cone	2	329216-3X Shifter Kit (Air Shift)		
9-P-80	Idler Shaft	1	328388-61X	Air Shift	1
14-P-81	Washer	1	329126X	Shifter Cover	1
			35-P-59	Gasket	1
			378431-11	Hex Capscrew	2
			378431-18	Capscrew	4
			329216-4X Constant Mesh Kit		
			34-P-16	Cover 6-Bolt	1
			35-P-59	Gasket	1
			378431CR-6	Capscrew Hex	6
			4-P-163	Spacer	1
			4-P-164	Spacer, Output Shaft	1
			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

Continued on Next Page

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

Part Number	Description	Qty.	Part Number	Description	Qty.
CONVERSION KITS			CONVERSION KITS (Cont'd)		
328591-31X	Conversion Kit (XV to XS) (Splash Lube)		328591-34X	Conversion Kit (XV to XY) (Splash Lube)	
378422-1	Drive Screw	2	378422-1	Drive Screw	2
21-P-515	Bearing Cap	1	21-P-541	Pump Flange	1
22-P-98	Gasket	1	22-P-98	Gasket	1
28-P-198	O-Ring	1	28-P-198	O-Ring	1
28-P-219	Oil Seal.....	1	3-P-876	Output Shaft	1
3-P-873	Output Shaft	1	328948-8X	Gasket & Installation Instructions	1
328948-8X	Gasket & Installation Instructions	1	378431-11	Hex Capscrew	4
378431-11	Hex Capscrew	4	379555	Lock ring	1
379688	Lubricant.....	1	379688	Lubricant.....	1
4-P-162	Spacer	1	55-P-20-1	Shim, Bearing Cover Green	2
55-P-20-1	Shim, Bearing Cover Green	2	55-P-20-2	Shim, Bearing Cover Brown	3
55-P-20-2	Shim, Bearing Cover Brown	3	55-P-20-3	Shim, Bearing Cover Yellow.....	2
55-P-20-3	Shim, Bearing Cover Yellow.....	2	560982	Tapered Bearing Cup.....	1
560976	Bearing Tape.....	1	560984	Bearing Tapered Cup.....	1
560977	Bearing Tape.....	1	560985	Bearing Tapered Cone.....	1
560982	Tapered Bearing Cup.....	1	560986	Tapered Bearing Cone.....	1
560986	Tapered Bearing Cone.....	1	28-P-267	Oil Seal.....	1
68-P-2	Name Plate.....	1	68-P-2	Name Plate.....	1
328591-32X	Conversion Kit (XV to XK) (Splash Lube)		328591-49X	Conversion Kit (XV to XS) (Pressure Lube)	
21-P-539	Flange.....	1	378422-1	Drive Screw	2
22-P-98	Gasket	1	379688	Lubricant.....	1
28-P-198	O-Ring	1	21-P-544	Flange.....	1
28-P-219	Oil Seal.....	1	22-P-98	Gasket	1
3-P-874	Output Shaft	1	28-P-198	O-Ring	1
328948-8X	Gasket & Installation Instructions	1	28-P-198	O-Ring	1
378431-11	Hex Capscrew	4	28-P-219	Oil Seal.....	1
379688	Lubricant.....	1	28-P-42	O-Ring	1
4-P-162	Spacer	1	3-P-873	Output Shaft	1
55-P-20-1	Shim, Bearing Cover Green	2	328948-8X	Gasket & Installation Instructions	1
55-P-20-2	Shim, Bearing Cover Brown	3	329129-1X	Pressure Lube	1
55-P-20-3	Shim, Bearing Cover Yellow.....	2	329130-1X	Pressure Lube	1
560976	Bearing Tape.....	1	329130-3X	20 Inch Hose Assembly.....	1
560977	Bearing Tape.....	1	329224X	Loose Part	1
560982	Tapered Bearing Cup.....	1	379231	Plug Pipe	1
560986	Tapered Bearing Cone.....	1	378431-11	Hex Capscrew	4
378422-1	Drive Screw	2	379484	Plug O-Ring.....	1
68-P-2	Name Plate.....	1	379505	Retainer, O-Ring.....	1
			379556	Tee .438" - 2	1
			379564-2	Cap Thread.....	1
			4-P-162	Spacer XV	1
			55-P-20-1	Shim, Bearing Cover Green	1
			55-P-20-2	Shim, Bearing Cover Brown	3
			55-P-20-3	Shim, Bearing Cover Yellow.....	1
			560976	Bearing Tape.....	1
			560977	Bearing Tape.....	1
			560982	Tapered Bearing Cup.....	1
			560986	Tapered Bearing Cone.....	1
			9-P-80	Idle Shaft	1
			21-P-597	Bearing Cap	1
			28-P-245X	O-Ring Kit.....	1
			68-P-2	Name Plate.....	1

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

Part Number	Description	Qty.	Part Number	Description	Qty.
CONVERSION KITS (Cont'd)			CONVERSION KITS (Cont'd)		
328591-50X *	Conversion Kit (XV to SS) (Splash Lube)		328591-58X	Conversion Kit (XV to XK) (Pressure Lube)	
3-P-875	Output Shaft	1	21-P-592	Special Bracket.....	1
4-P-162	Spacer	2	22-P-98	Gasket	1
21-P-515	Output Bearing Cap.....	1	28-P-198	O-Ring	1
21-P-544	Output Bearing Cap (For Pressure Lube)..	1	28-P-198	O-Ring	1
21-P-515	Rear Bearing Cap.....	1	28-P-219	Oil Seal.....	1
21-P-544	Rear Bearing Cap (For Pressure Lube).....	1	28-P-259	O-Ring	1
28-P-219	Oil Seal.....	1	28-P-42	O-Ring	1
28-P-245	O-Ring	2	3-P-874	Output Shaft	1
560977	Tapered Bearing Cup.....	2	328948-8X	Gasket & Installation Instructions	1
560976	Tapered Bearing Cone.....	2	329129-1X	Pressure Lube	1
379231	Pipe Plug	2	329130-1X	Pressure Lube	1
500897-3	Shipping Plug	2	329130-3X	20 Inch Hose Assembly	1
69-P-18	Tag (Wet Spline Only).....	1	329224X	Loose Part	1
328591-51X *			379231	Plug Pipe	1
3-P-875	Output Shaft	1	378431-11	Hex Capscrew	4
4-P-162	Spacer	2	379484	Plug O-Ring	1
21-P-515	Output Bearing Cap.....	1	379505	Retainer, O-Ring.....	1
21-P-544	Output Bearing Cap (For Pressure Lube)..	1	379556	Tee .438"-2	1
21-P-515	Rear Bearing Cap.....	1	379564-2	Cap Thread.....	1
21-P-544	Rear Bearing Cap (For Pressure Lube).....	1	379688	Lubricant.....	1
28-P-219	Oil Seal.....	1	4-P-162	Spacer	1
28-P-245	O-Ring	2	55-P-20-1	Shim, Bearing Cover Green	1
560977	Tapered Bearing Cup.....	2	55-P-20-2	Shim, Bearing Cover Brown	3
560976	Tapered Bearing Cone.....	2	55-P-20-3	Shim, Bearing Cover Yellow.....	1
379231	Pipe Plug	2	560976	Bearing Tape.....	1
500897-3	Shipping Plug	2	560977	Bearing Tape.....	1
69-P-18	Tag (Wet Spline Only).....	1	560982	Tapered Bearing Cup.....	1
			560986	Tapered Bearing Cone.....	1
			9-P-80	Idle Shaft	1
			378422-1	Drive Screw	2
			21-P-597	Bearing Cap	1
			68-P-2	Name Plate	1
			328591-59X *	Conversion Kit (XV to AB) (Splash Lube)	
			3-P-872	Output Shaft	1
			28-P-216	Output Bearing Cap.....	1
			329273X	Output Bearing Cap (For Pressure Lube)..	1
			378447-6	Oil Seal.....	1
			500007-29	Hex Nut.....	2
			379558	Companion Flange	2
			560982	Tapered Bearing Cup.....	2
			560986	Tapered Bearing Cone.....	2
			328591-60X *	Conversion Kit (XV to AB) (Pressure Lube)	
			3-P-872	Output Shaft	1
			28-P-216	Output Bearing Cap.....	1
			329273X	Output Bearing Cap (For Pressure Lube)..	1
			378447-6	Oil Seal.....	1
			500007-29	Hex Nut.....	2
			379558	Companion Flange	2
			560982	Tapered Bearing Cup.....	2
			560986	Tapered Bearing Cone.....	2

Continued on Next Page

* 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.	Part Number	Description	Qty.
CONVERSION KITS (Cont'd)			CONVERSION KITS (Cont'd)		
328591-61X *	Conversion Kit (XV to YY) (Splash Lube)		328591-104X	Conversion Kit (XV to AF) (Splash Lube)	
3-P-880	Output Shaft	1	3-P-940	Output Shaft	1
21-P-541	Output Bearing Cap.....	1	378422-1	Drive Screw	2
21-P-652	Rear Bearing Cap.....	1	55-P-20-2	Shim, Bearing Cover Brown	3
28-P-287	Oil Seal	1	28-P-198	O-Ring	1
379555	Lockring.....	1	560977	Bearing Tape.....	1
560984	Tapered Bearing Cup.....	1	560976	Bearing Tape.....	1
560985	Tapered Bearing Cone.....	1	55-P-20-3	Shim, Bearing Cover Yellow.....	2
561012	Tapered Bearing Cup.....	1	21-P-539	Flange.....	1
561011	Tapered Bearing Cup.....	1	22-P-98	Gasket	1
378898	Flat Hex Capscrew (.438"-14 x 1.000")	1	378431-11	Hex Capscrew	4
379555	Spline Coupling	1	328948-8X	Gasket & Installation Instructions	1
			28-P-219	Oil Seal.....	1
328591-67X *	Conversion Kit (XV to SK) (Pressure Lube)		379688	Lubricant.....	1
3-P-902	Output Shaft	1	4-P-162	Spacer	1
4-P-162	Spacer	2	55-P-20-1	Shim, Bearing Cover Green	2
21-P-515	Output Bearing Cap (For Pressure Lube)..	1	560982	Tapered Bearing Cup.....	1
21-P-593	Rear Bearing Cap.....	1	560986	Tapered Bearing Cone.....	1
21-P-539	Rear Bearing Cap (For Pressure Lube)....	1	68-P-2	Name Plate.....	1
21-P-592	Rear Bearing Cap.....	1			
28-P-219	Oil Seal	1	328591-105X	Conversion Kit (XV to AF) (Pressure Lube)	
28-P-245	O-Ring	1	21-P-592	Special Bracket.....	1
28-P-259	O-Ring	1	21-P-597	Bearing Cap	1
560977	Tapered Bearing Cup.....	1	22-P-98	Gasket	1
560976	Tapered Bearing Cone.....	1	28-P-198	O-Ring	1
379231	Pipe Plug	2	28-P-198	O-Ring	1
500897-3	Shipping Plug	2	28-P-219	Oil Seal.....	1
69-P-18	Tag (Wet Spline Only).....	1	28-P-259	O-Ring	1
			28-P-42	O-Ring	1
328591-68X *	Conversion Kit (XV to VV) (Splash Lube)		328948-8X	Gasket & Installation Instructions	1
3-P-916	Output Shaft	1	329129-1X	Pressure Lube	1
21-P-517	Output Bearing Cap.....	1	329130-1X	Pressure Lube	1
21-P-596	Output Bearing Cap (For Pressure Lube)..	1	329130-3X	20 Inch Hose Assembly.....	1
21-P-517	Rear Bearing Cap.....	1	329224X	Loose Part	1
21-P-596	Rear Bearing Cap (For Pressure Lube)....	1	379231	Plug Pipe	1
28-P-211	Oil Seal	2	378431-11	Hex Capscrew	4
378382	Hex Nut.....	2	379484	Plug O-Ring	1
3-1-3431	Companion Flange	2	379505	Retainer, O-Ring.....	1
560982	Tapered Bearing Cup.....	2	379556	Tee .438"-2	1
560986	Tapered Bearing Cone.....	2	379564-2	Cap Thread.....	1
			379688	Lubricant.....	1
328591-69X *	Conversion Kit (XV to VV) (Splash Lube)		4-P-162	Spacer	1
3-P-916	Output Shaft	1	55-P-20-1	Shim, Bearing Cover Green	1
21-P-517	Output Bearing Cap.....	1	55-P-20-2	Shim, Bearing Cover Brown	3
21-P-596	Output Bearing Cap (For Pressure Lube)..	1	55-P-20-3	Shim, Bearing Cover Yellow.....	1
21-P-517	Rear Bearing Cap.....	1	560976	Bearing Tape.....	1
21-P-596	Rear Bearing Cap (For Pressure Lube)....	1	560977	Bearing Tape.....	1
28-P-211	Oil Seal	2	560982	Tapered Bearing Cup.....	1
378382	Hex Nut.....	2	560986	Tapered Bearing Cone.....	1
3-1-3431	Companion Flange	2	9-P-80	Idle Shaft	1
560982	Tapered Bearing Cup.....	2	3-P-940	Output Shaft	1
560986	Tapered Bearing Cone.....	2	378422-1	Drive Screw	2
			68-P-2	Name Plate.....	1

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

Part Number	Description	Qty.	Part Number	Description	Qty.
CONVERSION KITS (Cont'd)			CONVERSION KITS (Cont'd)		
328591-119X *	Conversion Kit (XV to AC) (X Lube Option)		328591-128X	Conversion Kit (XV to AZ) (Pressure Lube)	
3-P-872	Output Shaft	1	3-P-873	Output Shaft	1
28-P-217	Output Bearing Cap.....	1	28-P-42	O-Ring	1
21-P-596	Output Bearing Cap (For Pressure Lube)..	1	28-P-259	O-Ring	1
28-P-211	Oil Seal	1	28-P-219	Oil Seal	1
378382	Hex Nut.....	4	28-P-198	O-Ring	1
379742	Companion Flange	1	28-P-198	O-Ring	1
560982	Tapered Bearing Cup.....	1	22-P-98	Gasket	1
560986	Tapered Bearing Cone.....	1	21-P-597	Bearing Cap	1
			21-P-592	Special Bracket.....	1
328591-120X *	Conversion Kit (XV to AC) (P Lube Option)		9-P-80	Idle Shaft	1
3-P-872	Output Shaft	1	560986	Tapered Bearing Cone.....	1
28-P-216	Output Bearing Cap.....	1	560982	Tapered Bearing Cup.....	1
329273X	Output Bearing Cap (For Pressure Lube)..	1	560977	Bearing Tape.....	1
378447-6	Oil Seal	1	560976	Bearing Tape.....	1
500007-29	Hex Nut.....	4	55-P-20-3	Shim, Bearing Cover Yellow.....	2
379558	Companion Flange	1	55-P-20-2	Shim, Bearing Cover Brown	2
560982	Tapered Bearing Cup.....	1	55-P-20-1	Shim, Bearing Cover Green	2
560986	Tapered Bearing Cone.....	1	4-P-162	Spacer	1
			379556	Tee .438"-2	1
328591-127X	Conversion Kit (XV to AZ) (Splash Lube)		379505	Retainer, O-Ring.....	1
378422-1	Drive Screw	2	379484	Plug O-Ring	1
560986	Tapered Bearing Cone.....	1	378431-11	Hex Capscrew	4
560977	Bearing Tape.....	1	379231	Plug Pipe	1
560976	Bearing Tape.....	1	378422-1	Drive Screw	2
55-P-20-3	Shim, Bearing Cover Yellow.....	2	329224X	Loose Part	1
55-P-20-2	Shim, Bearing Cover Brown	2	329130-3X	20 Inch Hose Assembly	1
55-P-20-1	Shim, Bearing Cover Green	2	329130-1X	Pressure Lube	1
4-P-162	Spacer	1	329129-1X	Pressure Lube	1
379688	Lubricant.....	1	68-P-2	Name Plate.....	1
3-P-873	Output Shaft	1			
28-P-219	Oil Seal	1	328591-133X	Conversion Kit (XS to GS)	
28-P-198	O-Ring	1	28-P-198	O-Ring	1
21-P-539	Flange.....	1	379432-1	Capscrew.....	3
378431-11	Hex Capscrew	4	28-P-226	Thrust Bearing	1
68-P-2	Name Plate.....	1	28-P-219	Oil Seal	1
			22-P-98	Gasket	1
			21-P-653X	Bearing Cap Assembly	1
			3-P-949X	Output Shaft	1
			379688	Lubricant.....	1
			3-P-949	Output Shaft	1
			379819	Grease Fit.....	1
			500168-2	Fitting.....	1
			379231	Pipe Plug	1
			560986	Tapered Bearing Cone.....	1
			560982	Tapered Bearing Cup.....	1
			560986	Tapered Bearing Cone.....	1

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Part Number	Description	Qty.	Part Number	Description	Qty.
CONVERSION KITS (Cont'd)			CONVERSION KITS (Cont'd)		
328591-135X	Conversion Kit (XV to GS)		329111-2X *	Conversion Kit (LF & LH)	
379432-1	Capscrew.....	3	21-P-544	Pump Flange	1
28-P-198	O-Ring	1	28-P-196	O-ring 5.859" x .139"	1
55-P-20-2	Shim, Bearing Cover Brown	2	28-P-198	O-ring 0.798" x .103"	1
28-P-226	Thrust Bearing.....	1	28-P-219	Oil seal 2.506" x 1.625" x .375"	1
28-P-219	Oil Seal	1	3-P-877	Output Shaft	1
22-P-98	Gasket	1	329110-1X	Installation Kit	1
55-P-20-3	Shim, Bearing Cover Yellow.....	2	378117	Drain Plug.....	1
21-P-515	Bearing Cap	1	379181	Hose assembly	1
55-P-20-1	Shim, Bearing Cover Green	2	379273	90° Elbow	1
21-P-653X	Bearing Cap Assembly.....	1	379526	Strain Plug	1
3-P-949X	Output Shaft	1	379636	Installation Instructions	1
379688	Lubricant.....	2	329127X	Bearing Cap & Lube Pump Assembly	1
3-P-949	Output Shaft	1	329129X	Hose Assembly.....	1
379819	Grease Fit.....	1	329130-1X	Pressure Lube	1
500168-2	Fitting.....	1	329130-3X	20 Inch Hose Assembly	1
560982	Tapered Bearing Cup.....	1	329224X	Loose Parts Kit	1
560986	Tapered Bearing Cone.....	1	379231	Pipe Plug	1
560976	Bearing Tape.....	1	379516-1	Install Sketch	1
560977	Bearing Tape.....	1	379556	Tee .438"-20	1
4-P-162	Spacer	1	379688	Lubricant.....	1
			4-P-162	Spacer XV	1
329111-1X *	Conversion Kit (LG)		55-P-20-1	Shim, Bearing Cover Green	3
21-P-596	Bearing Cap	1	55-P-20-2	Shim, Bearing Cover Brown	3
28-P-194	O-ring 1.424" x .103"	1	55-P-20-3	Shim, Bearing Cover Yellow.....	3
28-P-196	O-ring 5.859" x .139"	1	560976	Tapered Bearing Cone.....	1
28-P-198	O-ring 0.798" x .103"	1	560977	Tapered Bearing Cup.....	2
28-P-211	Oil seal 3.001" x 2.00" x .375"	1	560986	Tapered Bearing Cone.....	1
3-P-879	Output Shaft	1	9-P-80	Idler Shaft	1
329110-1X	Installation Kit	1	378422-1	Driven Screw	2
378117	Drain Plug.....	1	28-P-42	O-ring 1.051" x .070"	1
379181	Hose assembly	1	28-P-245X	O-ring 5.071" x .103"	1
379273	90° Elbow	1	68-P-2	Name Plate.....	1
379526	Strain Plug	1			
379636	Installation Instructions.....	1			
329127X	Bearing Cap & Lube Pump Assembly	1			
329129X	Hose Assembly.....	1			
329130-1X	Pressure Lube	1			
329130-3X	20 Inch Hose Assembly	1			
329224X	Loose Parts Kit	1			
379516-1	Install Sketch	1			
379556	Tee .438"-20	1			
55-P-20-1	Shim, Bearing Cover Green	3			
55-P-20-2	Shim, Bearing Cover Brown	3			
55-P-20-3	Shim, Bearing Cover Yellow.....	3			
560982	Tapered Bearing Cup.....	1			
560986	Tapered Bearing Cone.....	2			
9-P-80	Idler Shaft	1			
378422-1	Driven Screw	2			
68-P-2	Name Plate.....	1			

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

Part Number	Description	Qty.
CONVERSION KITS (Cont'd)		
329111-3X *	Conversion Kit (LL)	
378422-1	Driven Screw	2
379231	Pipe Plug	1
379516-1	Install Sketch	1
379556	Tee .438"-20	1
379688	Lubricant.....	1
4-P-162	Spacer XV	1
55-P-20-1	Shim, Bearing Cover Green	3
55-P-20-2	Shim, Bearing Cover Brown	3
55-P-20-3	Shim, Bearing Cover Yellow.....	3
560976	Tapered Bearing Cone.....	1
560977	Tapered Bearing Cup.....	1
560986	Tapered Bearing Cone.....	1
9-P-80	Idler Shaft	1
21-P-592	Bearing Cap	1
28-P-194	O-Ring 1.424" x .103".....	1
28-P-196	O-Ring 5.859" x .139".....	1
28-P-198	O-Ring .798 " x .103"	1
28-P-219	Oil Seal 2.506" x 1.625" x .375".....	1
28-P-259	O-Ring	1
3-P-878	Output Shaft	1
329110-1X	Installation Kit	1
378117	Drain Plug.....	1
379181	Hose Assembly.....	1
379273	90° Elbow	1
379526	Strain Plug	1
379636	Installation Instructions.....	1
329127X	Bearing Cap & Lube Pump Assembly	1
329129X	Hose Assembly.....	1
329130-1X	Pressure Lube	1
329130-3X	20 Inch Hose Assembly.....	1
329224X	Loose Part	1
68-P-2	Name Plate.....	1

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

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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



Parker Hannifin Corporation
Chelsea Products Division
8225 Hacks Cross Road
Olive Branch, Mississippi 38654 USA
www.parker.com/chelsea

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