



## Chelsea PTO 540 Parts Manual

Pro Gear and Transmission presents Chelsea 540 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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# CHELSEA®

Bulletin HY25-2540-M1/US

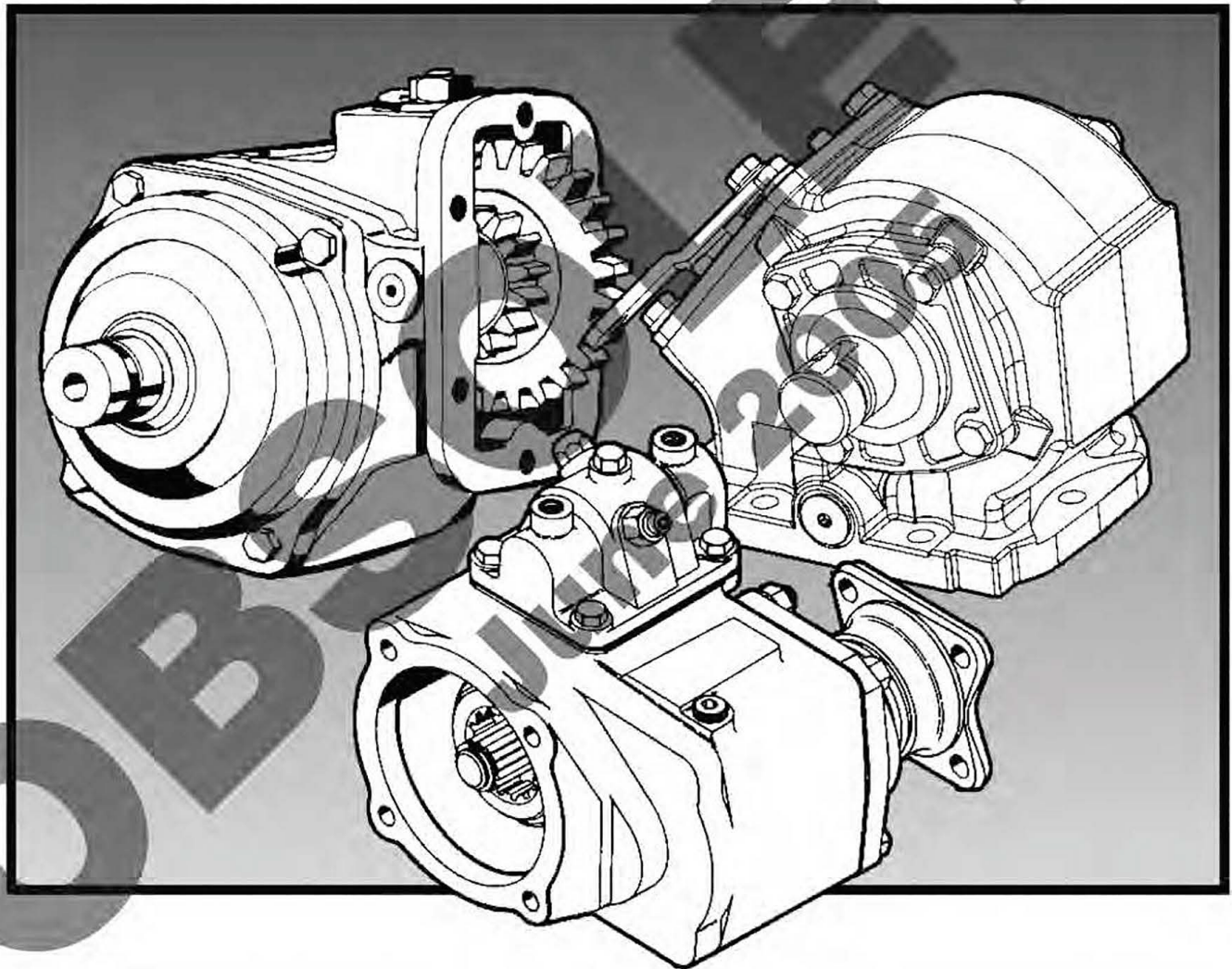
**Pro Gear**  
AND TRANSMISSION

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Effective: November 15, 2001

Supersedes: P410-540 Dated August, 1979

## Replacement Parts List 540 Series Manual



# Parker



## **WARNING**

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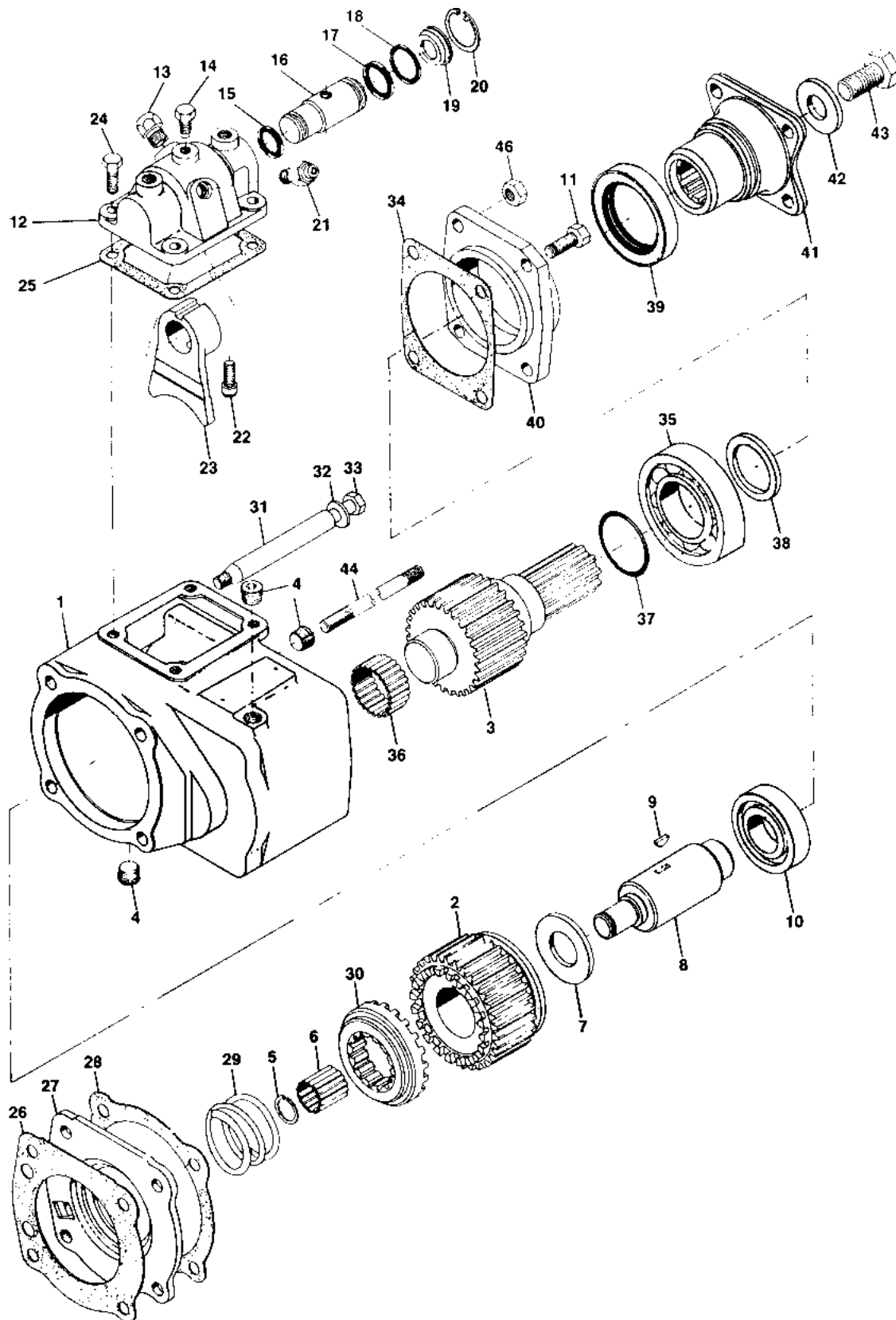
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# Bill of Materials

# 540 Series

Item	Part Number	Description	Quantity
1	1-P-369	Housing, P.T.O. .... 1	1
	1-P-371	For 540-P or 540-R Ratios	
2	See Chart Pg. 5	For 540-S Ratio	1
3	See Chart Pg. 5	Input Gear ..... 1	1
		Output Gear & Shaft ..... 1	1
4	378888	Pipe Plug (.250"-18) ..... 3	3
5	379071	Retainer Ring ..... 1	1
6	550890	Roller Bearing Assembly ..... 1	1
7	31-P-76	Thrust Washer ..... 1	1
8	3-P-751	Input Bearing Shaft ..... 1	1
9	378210	Pro Key ..... 1	1
10	550697	Ball Bearing ..... 1	1
11	378431-10	Screw, Hex Head (.375"-16 x 1.00") ..... 2	2
	328793X	<b>AIR SHIFT ASSEMBLY</b> (Includes items 12 thru 23) ..... 1	1
12	34-P-72	Shifter Cover ..... 1	1
13	378554	Cap ..... 1	1
14	378285-1	Guide Screw (.312"-24) ..... 1	1
15	28-P-71	O-ring ..... 1	1
16	11-P-120	Shift Shaft ..... 1	1
17	28-P-41	O-ring ..... 1	1
18	28-P-42	O-ring ..... 1	1
19	378315	Cover Plug ..... 1	1
20	378316	Retainer Ring ..... 1	1
N.S.	5008997-3	Shipping Plug ..... 2	2
21	378969	Indicator Switch ..... 1	1
22	378447-4	Screw, Socket Head (.312"-18 x .750") ..... 1	1
23	32-P-137	Shift FORK ..... 1	1
24	378430-8	Screw, Hex Head (.312"-18 X .750") ..... 4	4
25	35-P-40	Gasket, Shift Cover ..... 1	1
		<b>MOUNTING KITS</b>	
	328794-4X	MOUNTING KITS for Spicer 1007 & 1420 Transmission ..... 1	1
		(Includes items 26 thru 33)	
	328794-5X	MOUNTING KITS for Spicer 1107 Transmission ..... 1	1
		(Includes items 26 thru 33)	
26	22-P-61	Gasket, Adaptor Cover ..... 1	1
27		Adaptor Cover ..... 1	1
	21-P-351	For 540-*AB, Spicer 1007 & 1420 Transmissions	
	21-P-352	For 540-*AC, Spicer 1107 Transmissions	
28	22-P-62	Gasket, P.T.O. Mounting ..... 1	1
29		Spring ..... 1	1
	37-P-45	For 540-*AB, Spicer 1007 & 1420 Transmissions	
	37-P-46	For 540-*AC, Spicer 1107 Transmissions	
30	57-P-17	Clutch ..... 1	1
31	379077	Cone Lock Sleeve ..... 2	2
32	500365-26	Flat Washer ..... 2	2
33	379433-14	Screw, Hex Hd. (.375"-16 x 3.00") ..... 2	2

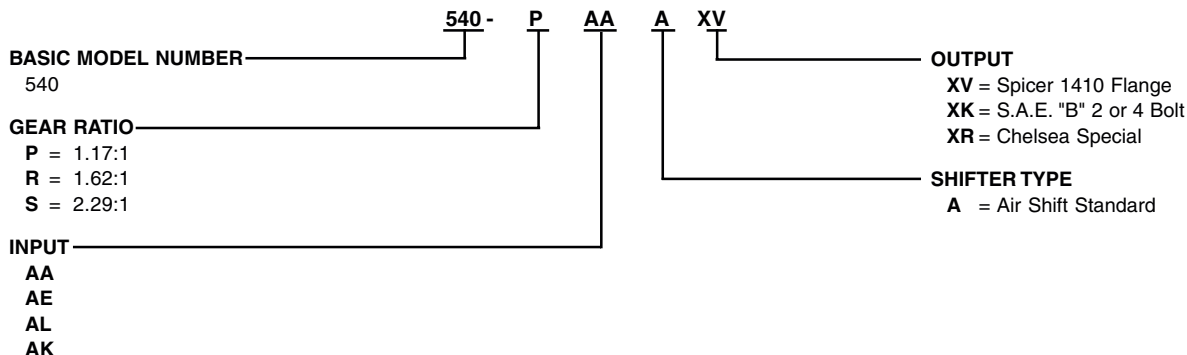
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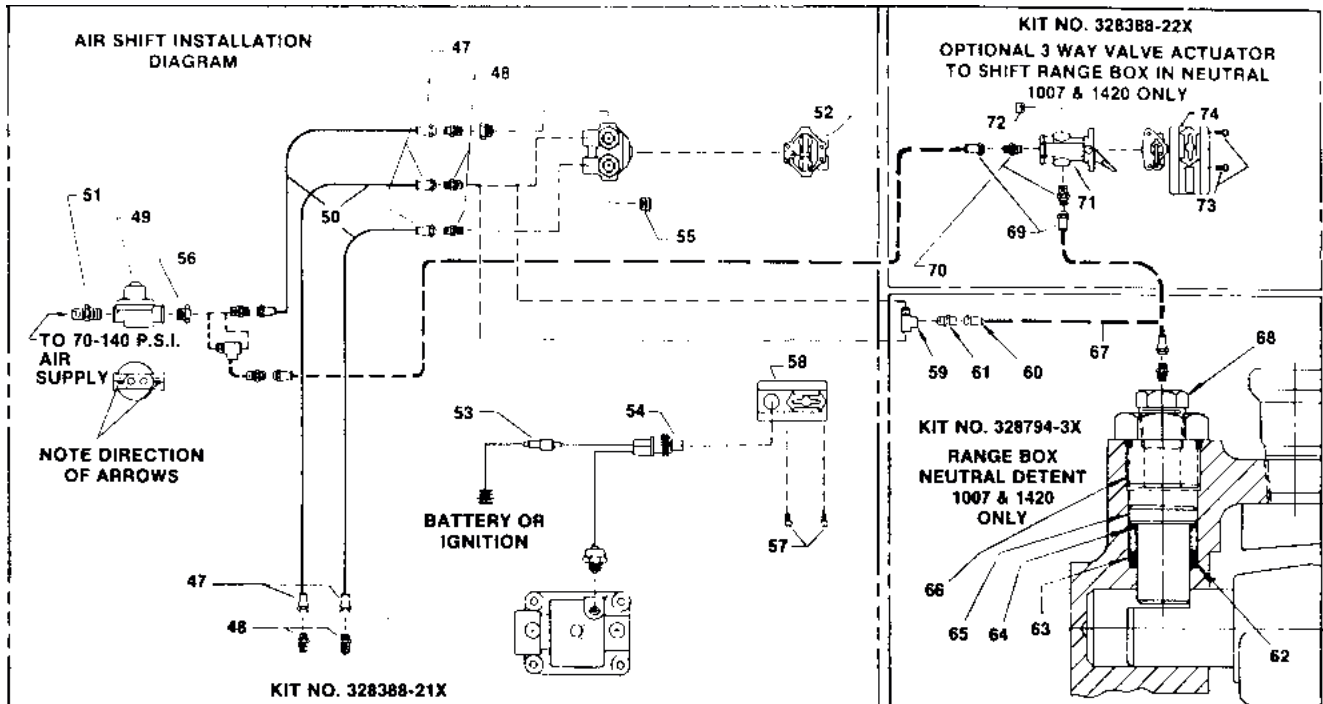
## Bill of Materials

## 540 Series

Item	Part Number	Description	Quantity
34	<b>22-P-63</b> <b>22-P-64</b>	GASKET, Pump Flange & Bearing Cap ..... For 540-P or 540-R For 540-S	1
35	<b>550311</b> <b>550010</b>	BALL BEARING ..... For 540-P or 540-R For 540-S	1
36	<b>560959</b> <b>560961</b>	NEEDLE BEARING ASSEMBLY ..... For 540-P or 540-R For 540-S	1
37	<b>28-P-156</b>	O-RING, For Standard Output Only on a 540-S	
38	<b>4-P-76</b> <b>378477</b> <b>378748</b>	RETAINER RING ..... For Standard Output Only on a 540-P or 540-R For Pump Output Only on a 540-P or 540-R For Pump Output Only on a 540-S	1
39	<b>28-P-35</b> <b>28-P-77</b> <b>28-P-52</b>	OIL SEAL ..... For 540-P or 540-R Standard Output For 540-S Standard Output For All Pump Outputs	1
40	<b>21-P-354</b> <b>21-P-356</b> <b>21-P-360</b> <b>21-P-364</b> <b>21-P-358</b> <b>21-P-362</b>	PUMP FLANGES & BEARING CAPS ..... Bearing Cap for 540-P or 540-R Standard Output Bearing Cap for 540-S Standard Output Pump Flange for 540-P or 540-R with 113 Pump Suffix Pump Flange for 540-S with 113 Pump Suffix Pump Flange for 540-P or 540-R with 225 Pump Suffix Pump Flange for 540-S with 225 Pump Suffix	1
41	<b>3-1-3431</b> <b>3-1-3881</b>	1410 SERIES FLANGE ..... For 540-P or 540-R For 540-S	1
42	<b>4-P-130</b>	Retainer Washer .....	1
43	<b>378345-7</b>	Screw, Hex Head (.625"-11 x 1.125") .....	1
44	<b>328794-7X</b> <b>379423-100</b>	MOUNTING STUD KIT (Includes items 44 thru 46) ..... Stud (.375"-16 x .375"-24 x 7.125") .....	1 2
46	<b>379794</b>	Flange Nut (.375"-24) .....	2

## Model Number Designation





Item	Part Number	Description	Quantity
	<b>328388-21X</b>	AIR SHIFT INSTALLATION KIT (Includes items 47-58) .....	1
47	<b>378356</b>	Tube Nut .....	6
48	<b>378360</b>	Male Connector .....	6
49	<b>378414</b>	Pressure Protection Valve .....	1
50	<b>378415-7</b>	Nylon Tubing (35 Ft. Coil) .....	1
51	<b>378416</b>	Hex Nipple (1/4" NPT) .....	1
52	<b>378504</b>	Control Valve .....	1
53	<b>378884</b>	Fuse Holder .....	1
54	<b>378978</b>	Indicator Light (12 volt) .....	1
55	<b>500133-3</b>	Pipe Plug (1/4" NPT) .....	1
56	<b>500714-1</b>	Reducer (1/4" to 1/8" NPT) .....	2
57	<b>500796-4</b>	Screw .....	2
58	<b>68-P-19</b>	Control Plate .....	1

**WARNING:** The vehicle may start to move during this P.T.O. operation unless neutral is maintained in the range box and the brakes are set.

**NOTE:** The 1420-3A also must be shifted to its "on highway" mode for stationary operation. See transmission shifting instructions.

----- Follow these lines only when hooking up the 328790-3X Detnet Kit, for stationary applications only.

----- Follow these lines only when hooking up the 328790-3X Detent Kit, and the 328388-22X Air Shift Kit, for both mobile and stationary applications.

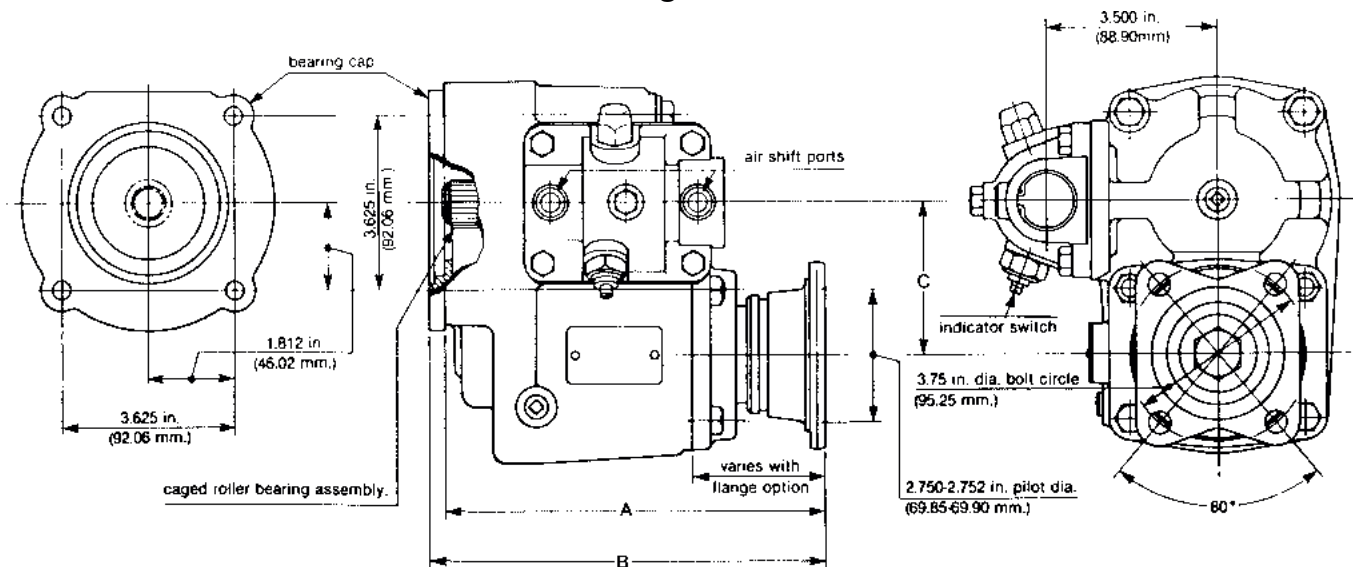


Item	Part Number	Description	Quantity
	<b>▲ 328794-3X</b>	NEUTRAL DETENT INSTALLATION KIT (Includes items 59 thru 68) .....	1
59	<b>500750-1</b>	Street Tee (1/8" NPT) .....	1
60	<b>378356</b>	Tube Nut .....	2
61	<b>378360</b>	Male Connector .....	2
62	<b>28-P-154</b>	O-Ring .....	1
63	<b>379072</b>	Washer .....	1
64	<b>37-P-44</b>	Spring .....	1
65	<b>66-P-10</b>	Piston .....	1
66	<b>379073</b>	Adaptor .....	1
67	<b>378415-7</b>	Nylon Tubing (35 Ft. Coil) .....	1
68	<b>500714-1</b>	Pipe Reducer (1/4" to 1/8" NPT) .....	1
	<b>* 328388-22X</b>	AIR SHIFT INSTALLATION KIT FOR NEUTRAL DETENT .....	
		(Includes items 69 thru 74) .....	1
69	<b>328356</b>	Tube Nut .....	2
70	<b>379360</b>	Male Connector .....	2
71	<b>378463</b>	Control Valve .....	1
72	<b>500132-3</b>	Pipe Plug (1/8" NPT) .....	1
73	<b>500796-4</b>	Screw .....	2
74	<b>68-P-23</b>	Control Plate .....	1

▲ The Spicer 1007 & 1420-3A Transmission has a "range box" mounted to the rear of the main box. This range box must be kept in neutral, for stationary operation of the countershaft P.T.O. Detent Kit 329794-3X must be purchased separately and installed in the range box for stationary operation of the countershaft P.T.O.

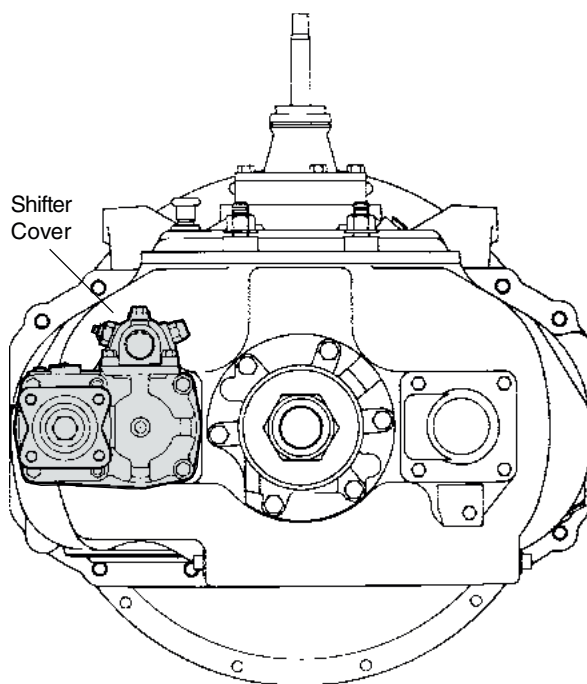
\* This Air Shift Kit must be installed when the P.T.O. is to be used in both mobile and stationary applications.

## 540 Counter Shaft P.T.O. Dimensional Drawings

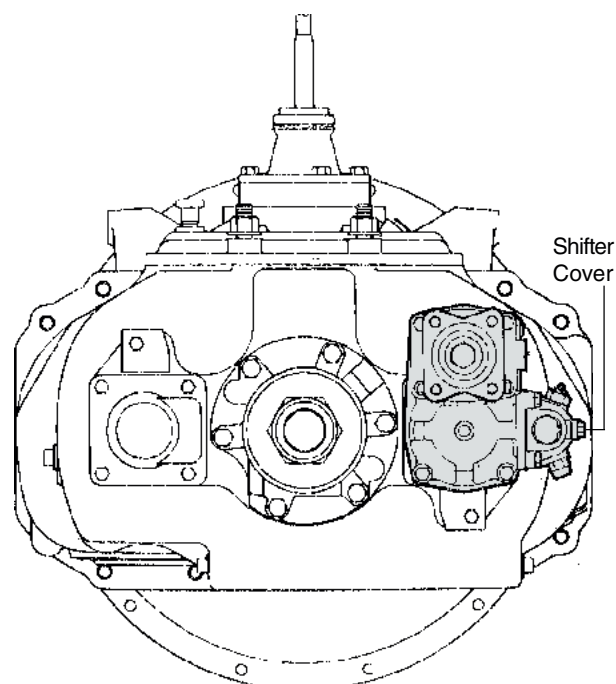


## Gear Data

Model No.	Input Gear Item 2		Standard Output Shaft Spicer® 1410 Item 3		Pump Output Shaft XK and XR Item 3	
	Part Number	No. of Teeth	Part Number	No. of Teeth	Part Number	No. of Teeth
540-P	5-P-573	34	3-P-749	29	3-P-753	29
540-R	5-P-572	39	3-P-748	24	3-P-752	24
540-S	5-P-572	39	3-P-750	17	3-P-574	17



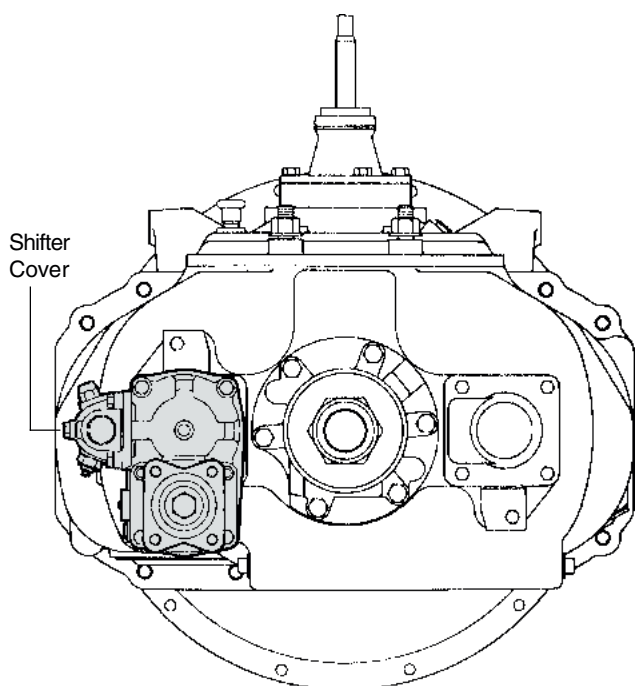
Standard position for left hand side of transmission, with shifter cover in top position.



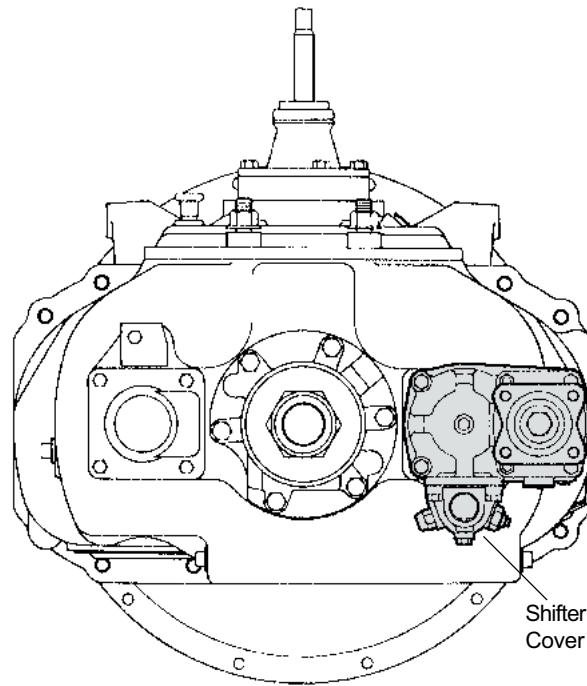
Standard position for right hand side of transmission, with shifter cover in side position.

## Optional Mounting Positions

Use optional positions when interference prevents standard position mounting.



Optional position for left hand side of transmission, with shifter cover in side position.



Optional position for right hand side of transmission, with shifter cover in bottom position.

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**2. Payment:** Payment shall be made by Buyer net 30 days from the date of delivery of the items purchased hereunder. Amounts not timely paid shall bear interest at the maximum rate permitted by law for each month or portion thereof that the Buyer is late in making payment. Any claims by Buyer for omissions or shortages in a shipment shall be waived unless Seller receives notice thereof within 30 days after Buyer's receipt of the shipment.

**3. Delivery:** Unless otherwise provided on the face hereof, delivery shall be made F.O.B. Seller's plant. Regardless of the method of delivery, however, risk of loss shall pass to Buyer upon Seller's delivery to a carrier. Any delivery dates shown are approximate only and Seller shall have no liability for any delays in delivery.

**4. Warranty:** Seller warrants that the items sold hereunder shall be free from defects in material or workmanship for a period of:

(A) All Power Take-Off units one (1) year from date of installation.

(B) Except 267, 277, 278, 242, 244, 246, 250, 251 and 859 series two (2) years from date of installation.

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