

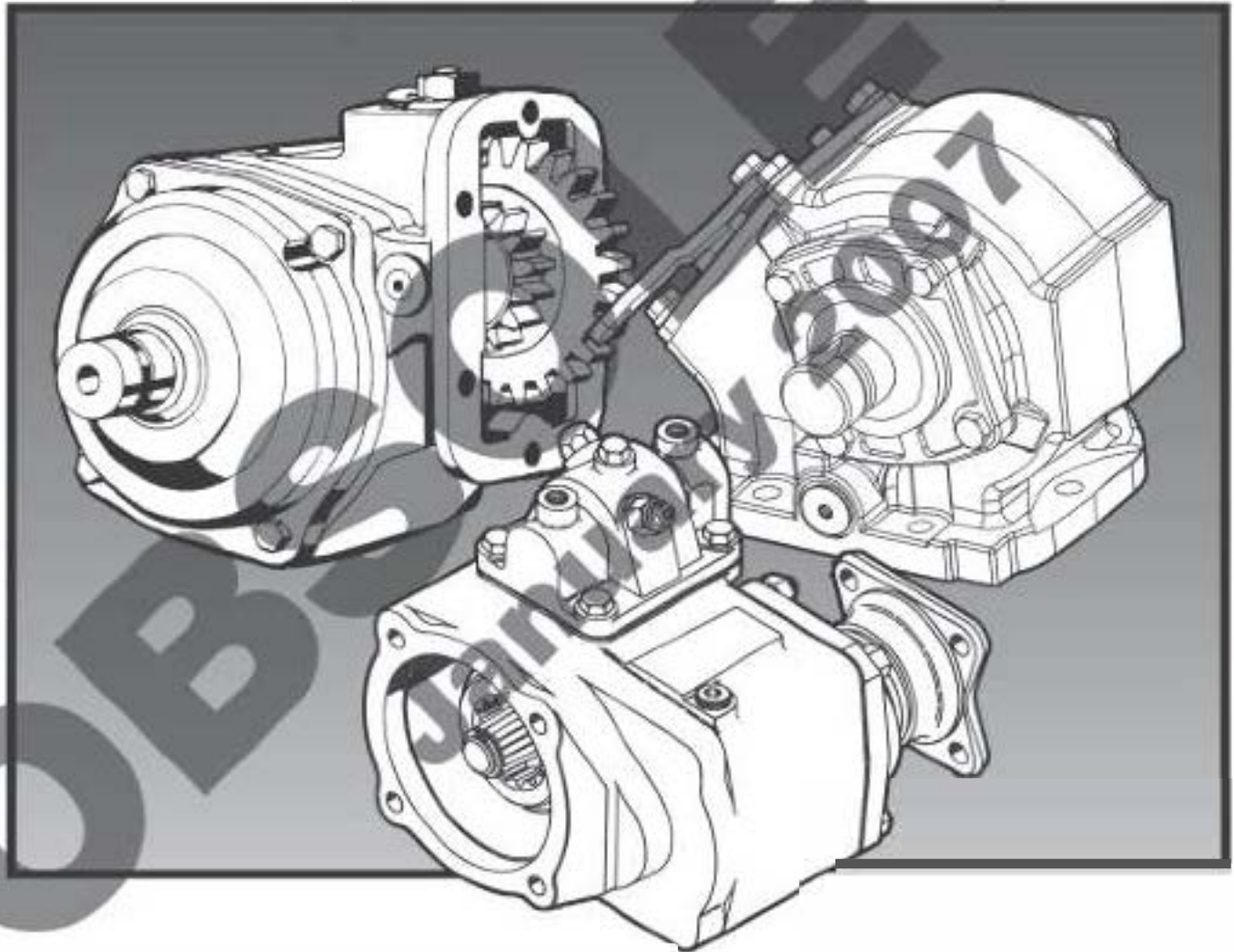


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CHELSEA Replacement Parts List 434 Series Manual

Bulletin HY25-2434-MWS

Effective: January 15, 2007
Supersedes: HY25-2434-M1/US Dated Nov. 2001



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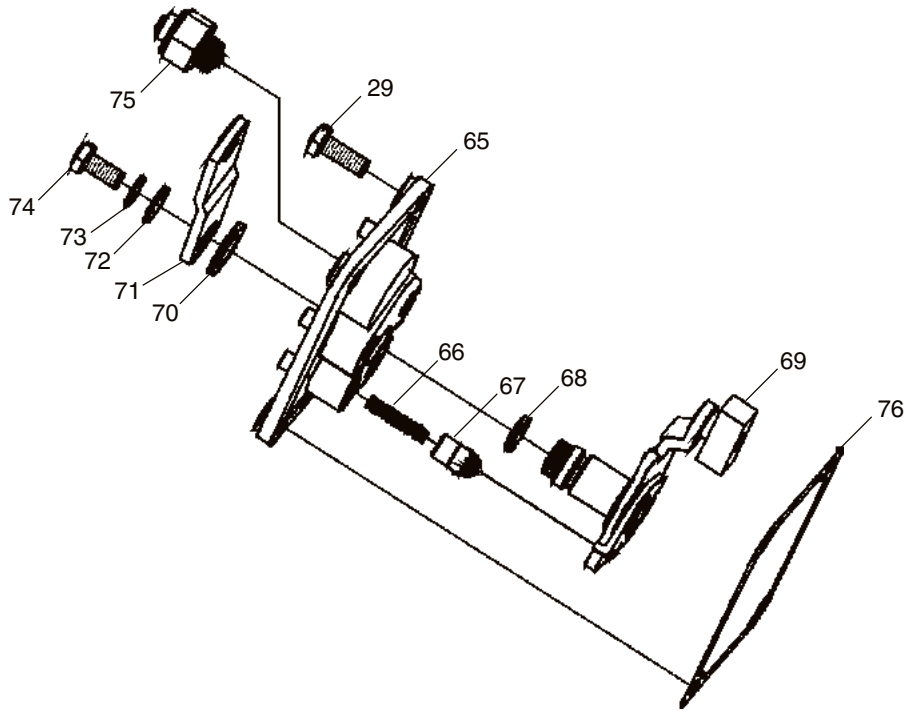
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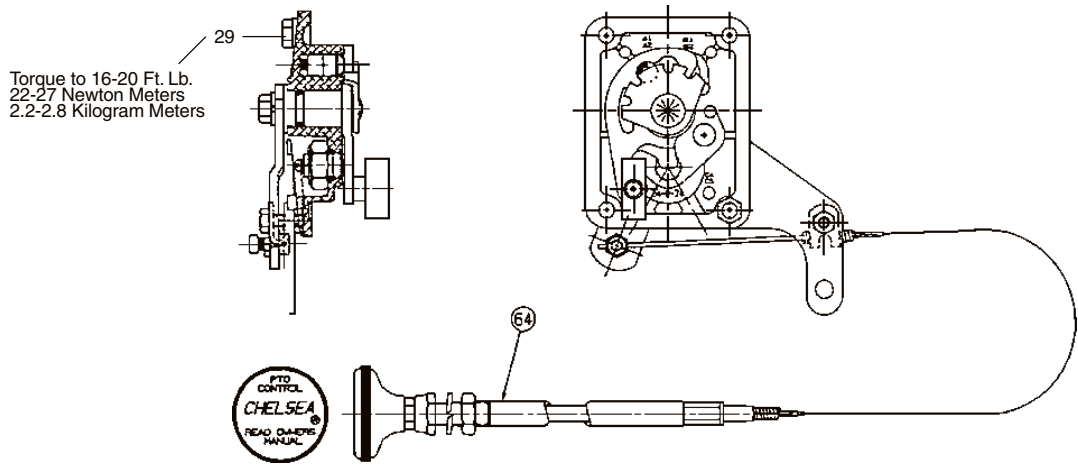
Bill of Materials

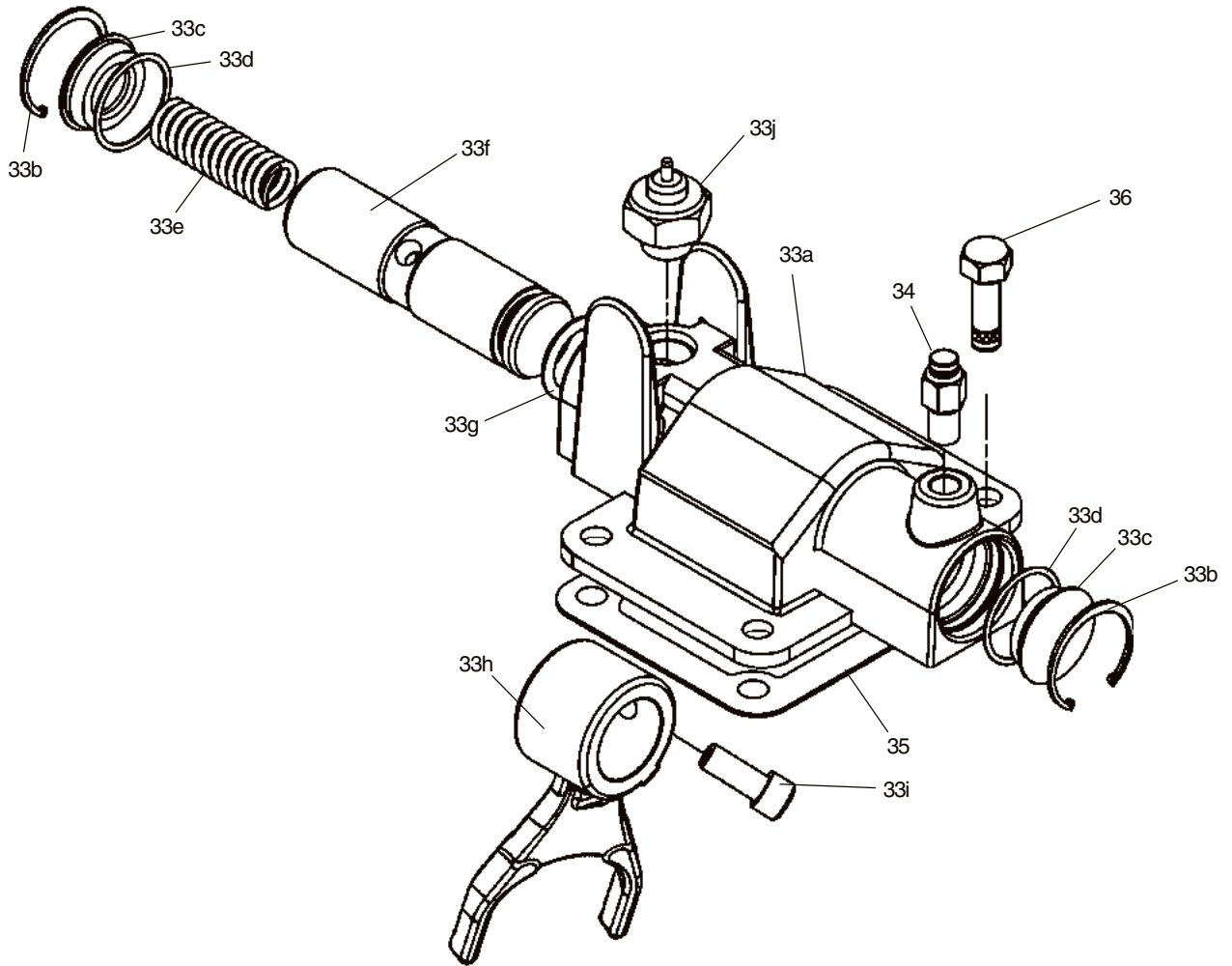
Item	Part Number	Description	Quantity
1	1-P-504	Housing	1
2	2-P-699	Gear, Output (20 teeth)	1
3	5-P-962	Gear, Idler	1
4	9-P-66	Shaft, Idler	1
5	14-P-15	Input Gear Spacers	A/R
8	22-P-24-1	Gasket, Bearing Cap (0.10)	A/R
	22-P-24-2	Gasket, Bearing Cap (.020)	A/R
	22-P-24-3	Gasket, Bearing Cap (.015)	A/R
11	68-P-37	Name Plate	1
13	328274X	Bearing Cap Assembly (Closed End)	1
14	378391	Lockring	2
15	378422	Drive Screw	2
16	378430-10	Capscrew, Hex Head (.312"-18 x 1.000")	4
17	378452-7	Set Screw (.250"-20 x .500")	1
19	550397	Bearing Cone	1
20	550439	Bearing Cone	2
21	550532	Bearing Cone	1
CABLE SHIFT (see page 3)			
26	329038-1X	Cable Shift Cover Assembly (3 & 6)	1 or
	329038-2X	Cable Shift Cover Assembly (4 & 5)	1
29	278430-9	Capscrew, Hex Head (.312"-18 x .875")	1
AIR SHIFT			
33	329363X	Shifter Cover Assembly, Air Shift (Includes Items 33a-33j)	1
33a	34-P-130	Shifter Cover	1
33b	378316	Snap Ring	2
33c	378315	Cover Plug	2
33d	28-P-42	O-Ring	2
33e	37-P-21	Shifter Spring	1
33f	11-P-75	Shaft, Shifter	1
33g	28-P-41	O-Ring	1
33h	32-P-180	Shifter Fork	1
33i	378447-4	Capscrew, Socket Head w/ lockpatch (.312"-18 x .750")	1
33j	379639	Indicator Switch (Normally OFF)	1
34	379904	Push Connect, for 1/4" tubing	1
35	35-P-8	Gasket, Shifter Cover	1
36	378430-9	Capscrew, Hex Head (.312"-18 x .875")	4
AIR SHIFT CONVERSION KITS			
	328390-105X	Lever to Air 12V	1
	328390-106X	Lever to Air 24V	1
	328390-117X	Lever or Cable to Air	1
	328390-119X	Lever or Cable to Electric/Air, 12V	1
	328390-120X	Lever or Cable to Electric/Air, 24V	1
OUTPUT, "XD"			
39	3-P-202	Shaft, Output	1
	See Chart Pg. 5	Pump Mounts, Output Shaft	1
40	28-P-216	Oil Seal	1
	See Chart Pg. 5	Pump Mounts, Oil Seal	1
41	328273X	Bearing Cap Assembly	1
	See Chart Pg. 5	Pump Mounts, Bearing Cap Assembly	1
42	378430-10	Capscrew, Hex Head (.312"-18 x 1.000")	4
43	500007-29	Woodruff Key	1
LOOSE PARTS			
	328170-197X	Stud Kit	1
	328961-3X	Installation Instructions	1
64	328345-15X	Cable Control Assembly (See Page 3)	1
	328380X	Cable Control Parts Bag	1
	328751X	Installation Kit	1
	328388-37X	Air Shift Installation Kit	1
	328711X	Installation Kit ("XR" Pump)	1
	329166-12X	E-Z Shift Installation Kit	1

A.R.—As Required



Item	Part Number	Description	Quantity
	329038-1X	CABLE SHIFT COVER ASSEMBLY, (3 & 6)	1 or
	329038-2X	CABLE SHIFT ASSEMBLY, (4 & 5)	1
	All the above shifter assemblies include items 65 thru 75		
65	34-P-74	Cover Plate, Shifter	1
66	37-P-19	Spring	1
67	63-P-16	Poppet Pin	1
68	28-P-191	O-Ring	1
	POST AND PLATE ASS'Y		
69	328813-1X	For Assemblies 3 & 6	1
	328813-2X	For Assemblies 4 & 5	1
70	378004	Flat Washer	1
71	51-P-22	Shifter Lever	1
72	500365-22	Flat Washer	1
73	500356-10	Lock Washer	1
74	500409-6	Capscrew, Hex Head (.312"-24 x .625")	1
75	379652	Indicator Switch, Pin Style (Normally On)	1
76	35-P-8	Gasket, Shifter Cover	1
29	378430-9	Capscrew, Hex Head (.312"-18 x .875")	4





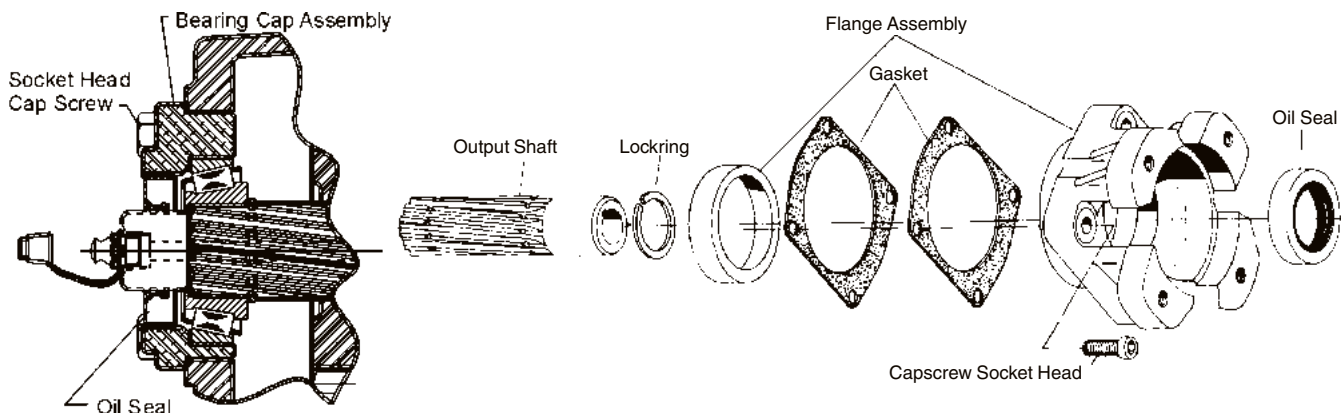
Item	Part Number	Description	Quantity
33	329363X	Shifter Cover Assembly, Air Shift (Includes Items 33a-33j)	1
33a	34-P-130	Shifter Cover	1
33b	378316	Snap Ring	2
33c	378315	Cover Plug	2
33d	28-P-42	O-Ring	2
33e	37-P-21	Shifter Spring	1
33f	11-P-75	Shaft, Shifter	1
33g	28-P-41	O-Ring	1
33h	32-P-180	Shifter Fork	1
33i	378447-4	Capscrew, Socket Head w/ lockpatch (.312"-18 x .750")	1
33j	379639	Indicator Switch (Normally OFF)	1
34	379904	Push Connect, for 1/4" tubing	1
35	35-P-8	Gasket, Shifter Cover	1
36	378430-9	Capscrew, Hex Head (.312"-18 x .875")	4
		Air Shift Conversion Kits	
	328390-105X	Lever to Air 12V	1
	328390-106X	Lever to Air 24V	1
	328390-117X	Lever or Cable to Air	1
	328390-119X	Lever or Cable to Electric/Air, 12V	1
	328390-120X	Lever or Cable to Electric/Air, 24V	1

Direct Mount Pump Conversion Kits

Flange Suffix	Flange Type	Shaft Type	Conversion Kit*
XR	Chelsea Special 4 Bolt	7/8"-13 Spline	328591-52x
RA	Rotatable S.A.E. "B" 2 Bolt	7/8"-13 Spline	328591-55x
RB	Rotatable S.A.E. "B" 4 Bolt	7/8"-13 Spline	328591-56x
RF	Rotatable S.A.E. "BB" 2 Bolt	1.0"-15 Spline	328591-78x
GA	Rotatable S.A.E. "B" 2 Bolt	7/8"-13 Spline	**328591-72x
GB	Rotatable S.A.E. "B" 4 Bolt	7/8"-13 Spline	**328591-74x
GH	Rotatable S.A.E. "BB" 2 Bolt	1.0"-15 Spline	**328591-116x
GR	Chelsea Special 4 Bolt	7/8"-13 Spline	**328591-76x

** Shaft with Grease Fitting

Pump Conversion Kit Bill of Material

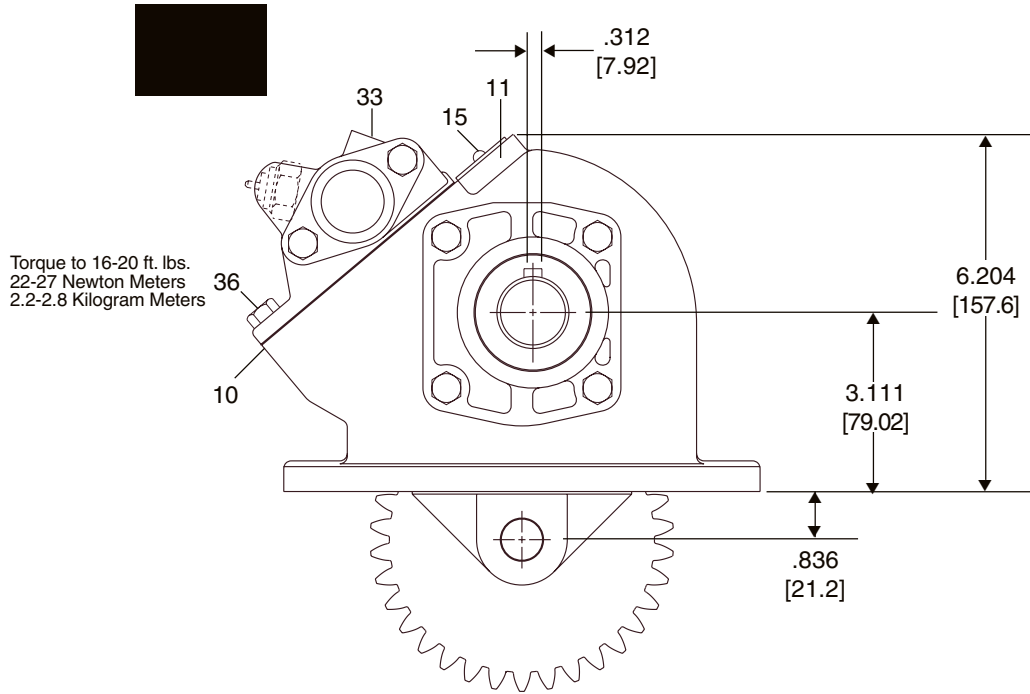


Flange Suffix	Conversion Kit *	Front				Rear Cap Greasable Option		
		Flange Assembly	Output Shaft	Socket Head	Oil Seal	Bearing Cap Assembly	Socket Head	Oil Seal
GA	328591-72X	329195X & 21-P-628	3-P-923X	378447-6 tt	28-P-216	328273X	378430-10	28-P-268
GB	328591-74X	329195X & 21-P-572	3-P-923X	378447-6 tt	28-P-216	328273X	378430-10	28-P-268
GH	328591-116X	329264X & 21-P-626	3-P-941X	378447-6 tt	28-P-216	328273X	378430-10	28-P-268
GR	328591-76X	329194X	3-P-923X	379673 t	28-P-216	328273X	378430-10	28-P-268
RA	328591-55X	329195X & 21-P-628	3-P-283	378447-6 tt	28-P-216			
RB	328591-56X	329195X & 21-P-572	3-P-283	348447-6 tt	28-P-216			
RF	328591-78X	329264X & 21-P-626	3-P-924	378447-6 tt	28-P-219			
XR	328591-52X	329194X	3-P-283	379673 t	28-P-216			

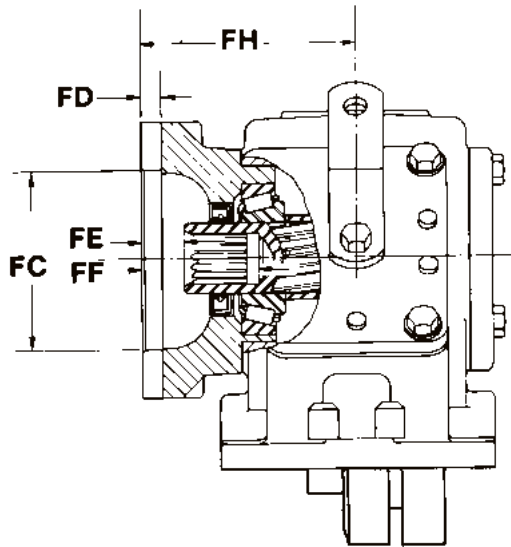
* Consists of all items shown in the illustration, plus Lockring (item 14) and Bearing Cap Gasket (item 8)

t Special shoulder stud.

tt Seven required; four (4) to fasten the Flange Assembly 328195X to housing and three (3) to fasten the rotatable flange to the flange assembly.



P.T.O. Housing, Pump Flange & Shaft Dimensions

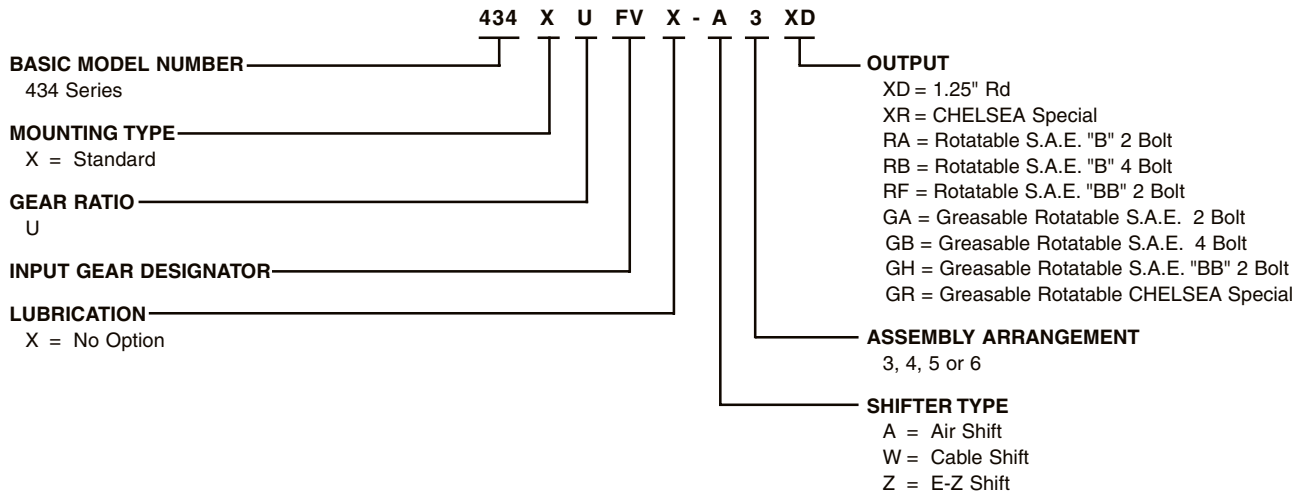


Pump Flange Suffix	Bolt Circle Dia.	Bolt Holes		FC Female Pilot Dia.	FD Pilot Depth	FE Face to End of Shaft	FF Face thru Hole	FH Face to Center of P.T.O.	Output Shaft Hole Diameter
		Tapped Hole	No. Equally Spaced						
RA*, GA	5.750	.500"-13	2 **	4.003	0.406	0.558	2.058	4.588	7/8"-13 Spline
RB*, GB	5.000	.500"-13	4	4.003	0.406	0.558	2.058	4.588	7/8"-13 Spline
RF*, GH	5.750	.500"-13	2 **	4.003	0.406	0.501	1.969	4.569	1"-15 Spline
XR, GR	3.710	.312"-24(Studs)	4	2.752	0.281	N/A	N/A	2.809	7/8"-13 Spline

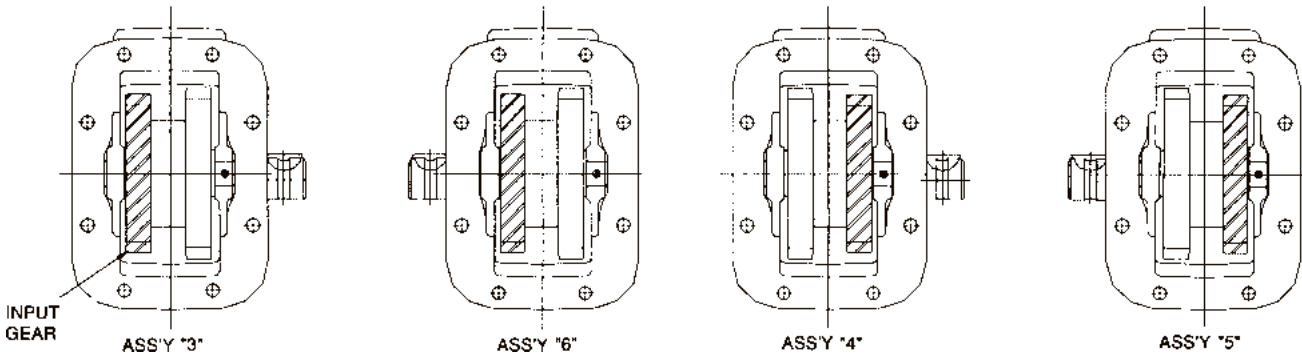
* Rotatable Flange Rotates in 30° Increments

** Two Set of Holes Spaced 14° Apart

Model Number Designation



Assembly Arrangements



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

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1/06-P

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