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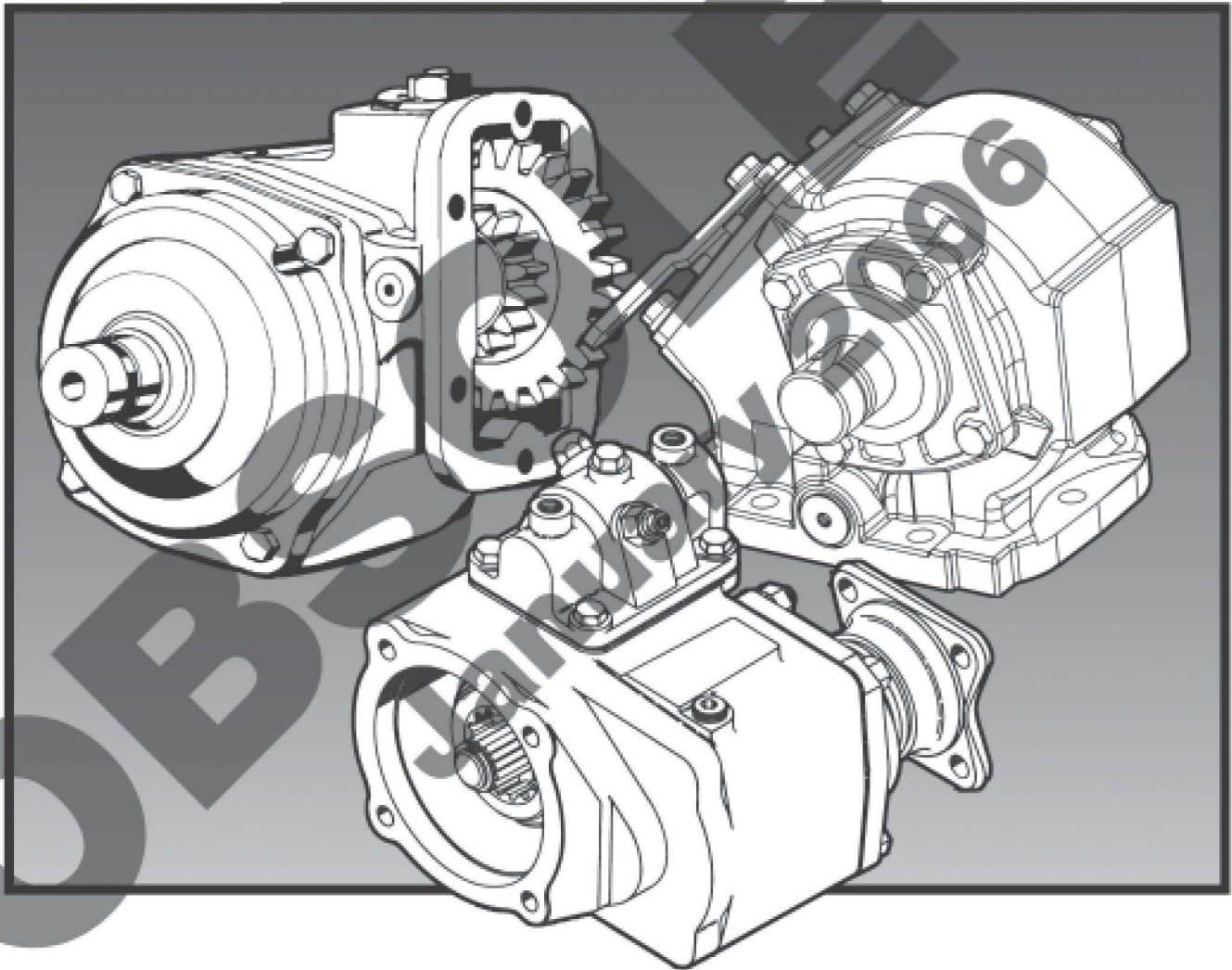
# CHELSEA®

Bulletin HY25-2721-M1/JS

## Replacement Parts List 721 Series Manual

Effective: January 15, 2002

Supersedes: P410-721 Dated January 2000



**Parker**

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 **WARNING**

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**Shifter Assembly Side “X”**

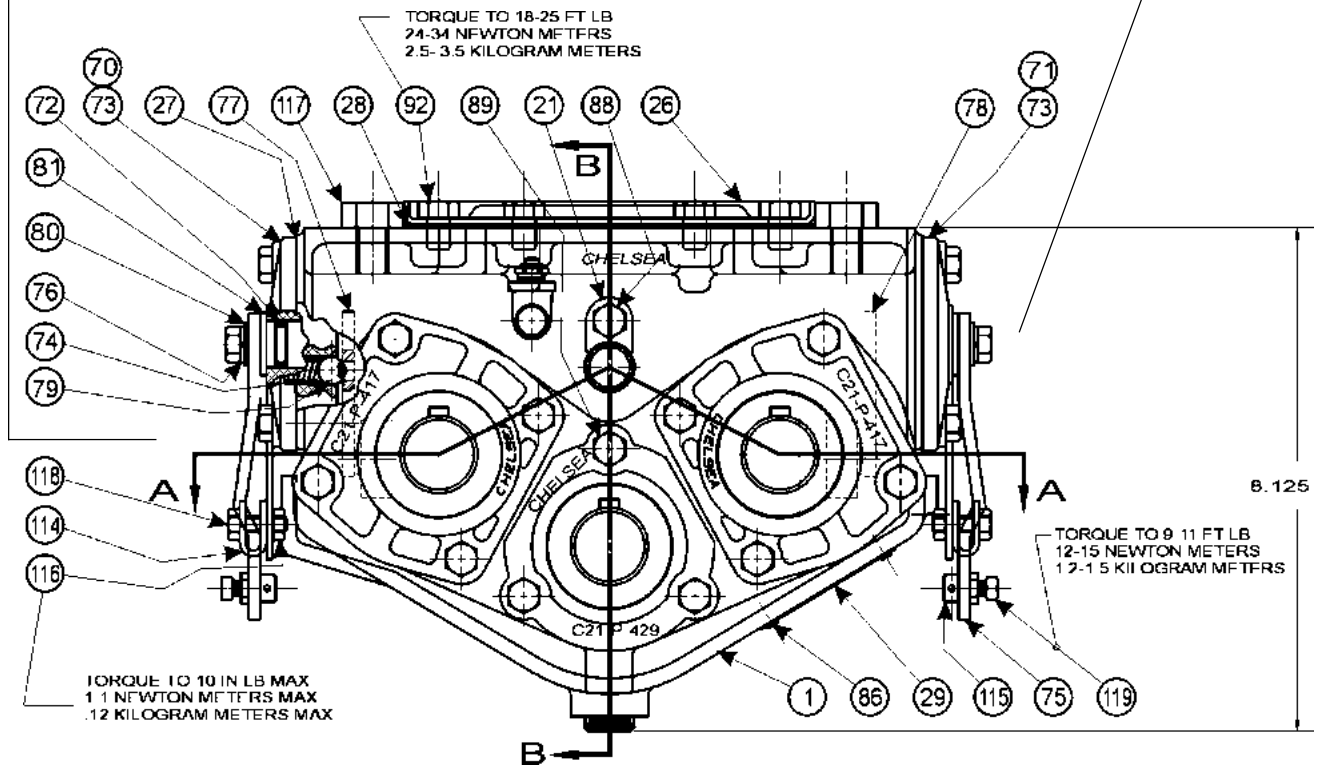
Shifter Cover Assemblies for Side “X”

- A) For Cable Shift use 328830-1X
- B) For Air Shift use 328826-1X or 328826-3X

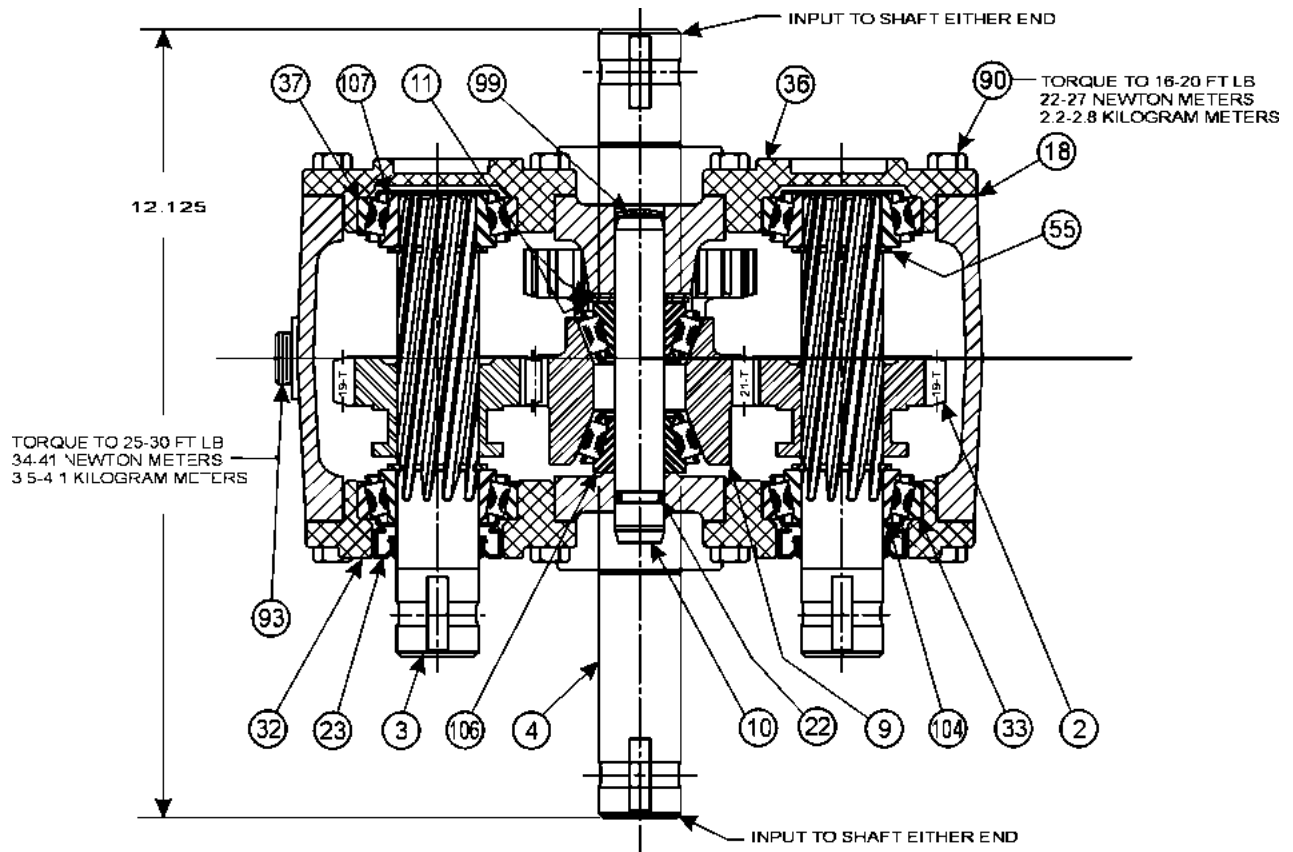
**Shifter Assembly Side “Y”**

Shifter Cover Assemblies for Side “Y”

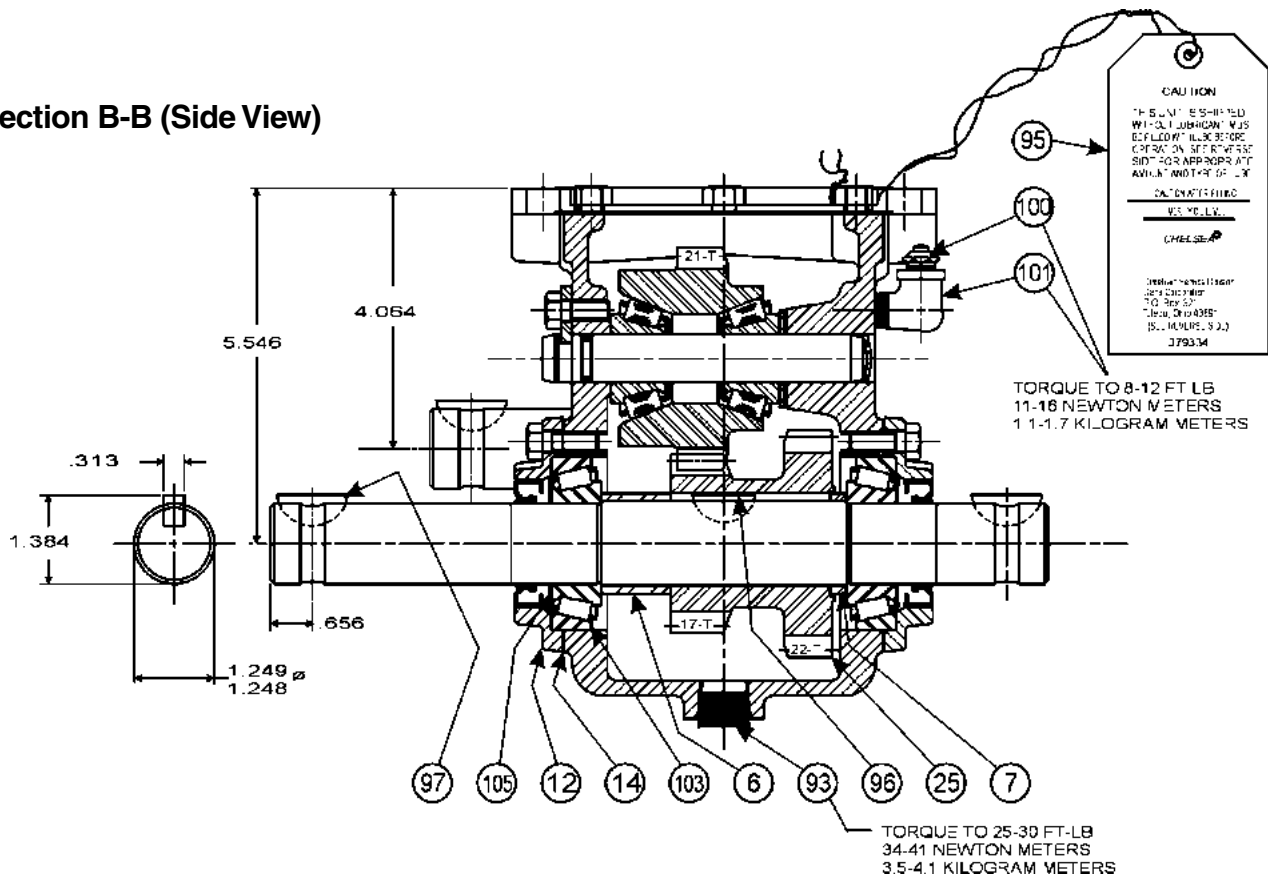
- A) For Cable Shift use 328830-2X
- B) For Air Shift use 328826-2X or 328826-4X



**Section A-A (Top View)**



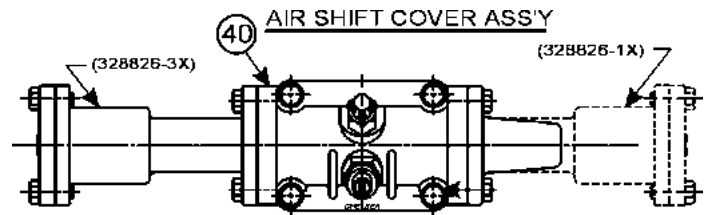
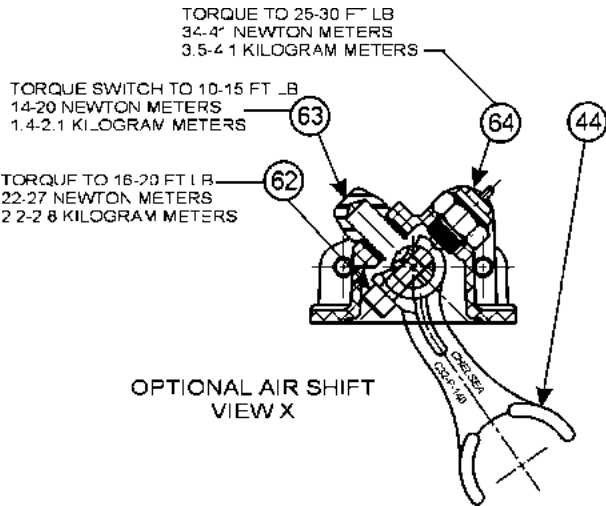
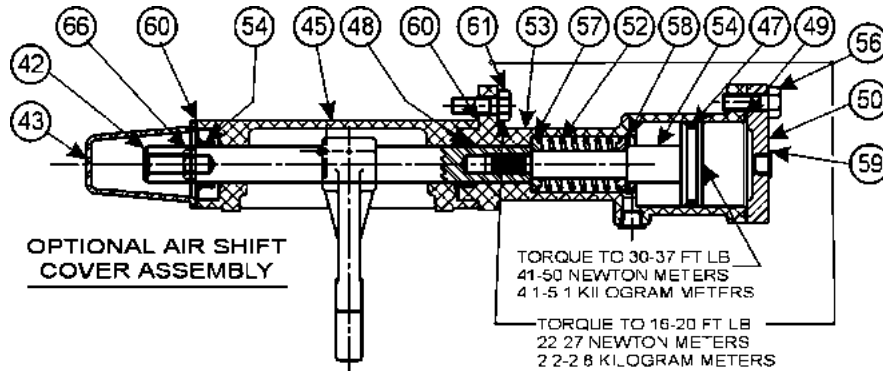
**Section B-B (Side View)**



**Bill of Materials**

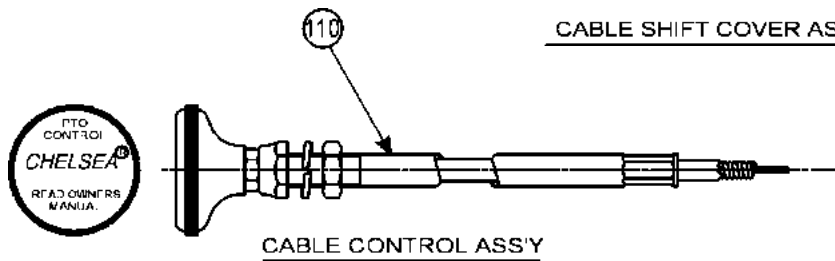
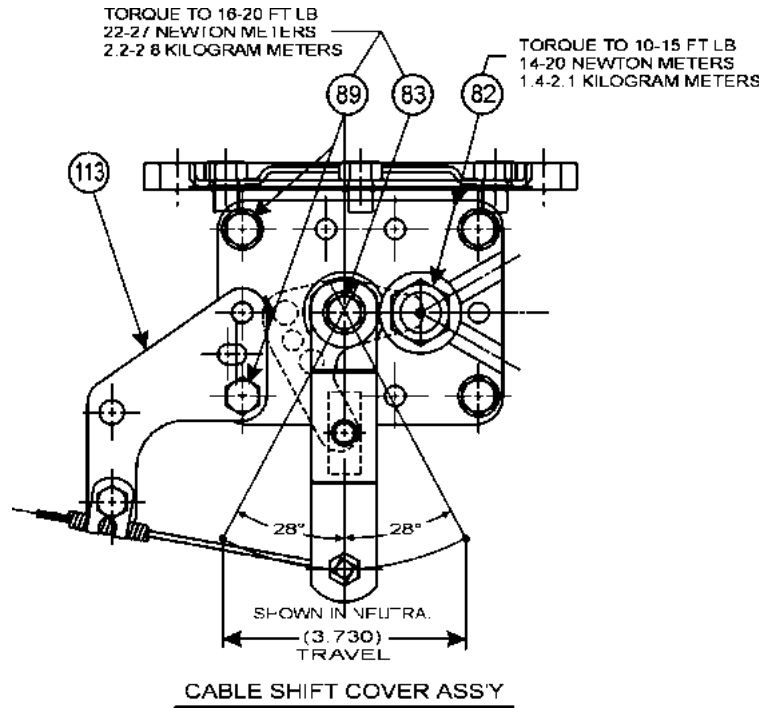
Item	Part Number	Description	Quantity
1	1-P-337	Housing, Gearbox .....	1
2	2-P-721	Gear, Sliding 19-T .....	2
3	3-P-859	Drive Shaft, Standard Output (1.250" Dia.) .....	2
4	3-P-205	Drive Shaft, Standard Input (1.250" Dia.) .....	1
6	4-P-46	Spacer .....	1
7	4-P-47	Spacer .....	1
9	5-P-220	Gear, Idler .....	1
10	9-P-56	Shaft, Idler .....	1
11	14-P-15	Spacer .....	A.R.
12	21-P-67	Bearing Cap, Open .....	2
14	22-P-23-1	Gasket, Bearing Cap .....	A.R.
	22-P-23-2	Gasket, Bearing Cap .....	A.R.
18	22-P-24-1	Gasket, Bearing Cap (.010" Thick) .....	A.R.
	22-P-24-2	Gasket, Bearing Cap (.020" Thick) .....	A.R.
	22-P-24-3	Gasket, Bearing Cap (.015" Thick) .....	A.R.
21	27-P-9	Retaining Plate .....	1
22	28-P-191	O-Ring .....	1
23	28-P-216	Oil Seal .....	4
25	33-P-64	Gear, Drive .....	1
26	34-P-16	Cover Plate .....	1
27	35-P-8	Gasket, Shifter Cover (.020" Thick) .....	2
28	35-P-59	Gasket, Cover Plate .....	2
29	68-P-2	Name Plate .....	1
	328273X	BEARING CAP SUB-ASSEMBLY, Open (Includes Items 32-32) .....	2
32	21-P-418	Bearing Cap (Open) .....	1
33	550221	Bearing Cup .....	1
	328274X	BEARING CAP SUB-ASSEMBLY, Closed (Includes Items 36-37) .....	2
36	21-P-420	Bearing Cap (Closed) .....	1
37	550221	Bearing Cup .....	1
85	378391	Lockring .....	4
86	378422	Drive Screw .....	2
88	378430-8	Capscrew, Hex Head (.375"-16 x .500") .....	1
89	378430-9	Capscrew, Hex Head (.375"-16 x .875") .....	14
90	378430-10	Capscrew, Hex Head (.375"-16 x 1.000") .....	16
92	378431-4	Capscrew, Hex Head (.375"-16 x .500") .....	6
93	379064	Pipe Plug (.500"-14) .....	2
95	379334	Oil Level Caution Tag (Shipped Wired to Unit) .....	1
96	500007-24	Woodruff Key (Ref. Input Shaft) .....	1
97	500007-29	Woodruff Key (.312" x 1.125") .....	4
99	500166-10	Welch Plug (.750" Dia.) .....	1
100	500167-1	Breather Cap .....	1
101	500925-1	Pipe, Street Elbow .....	1
103	550218	Bearing Cup .....	2
104	550397	Bearing Cone .....	2
105	550437	Bearing Cone .....	2
106	550439	Bearing Cone .....	2
107	550532	Bearing Cone .....	2

A.R. — As Required



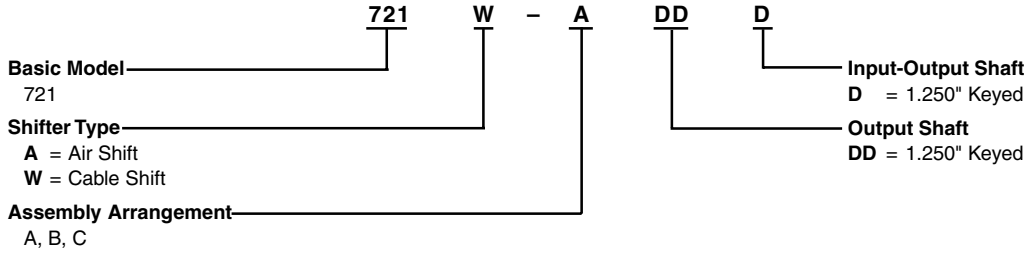
Item	Part Number	Description	Quantity
	<b>328826-1X &amp; 3X</b>	AIR SHIFT COVER ASSEMBLY (Includes Items 42-66)	1 or
40	<b>328826-2X &amp; 4X</b>	AIR SHIFT COVER ASSEMBLY (Includes Items 42-66)	1
42	<b>11-P-129</b>	Shifter Shaft	1
43	<b>65-P-23</b>	Cover, Shifter Shaft	1
44	<b>32-P-141</b>	Shifter Fork	1
45	<b>34-P-82</b>	Cover, Shifter	1
	<b>328824X</b>	Sub-Assembly	1
47	<b>28-P-61</b>	O-Ring	1
48	<b>28-P-71</b>	O-Ring	1
49	<b>28-P-2500</b>	O-Ring	1
50	<b>34-P-81</b>	Cap	1
52	<b>38-P-50</b>	Spring	1
53	<b>65-P-15</b>	Cylinder	1
54	<b>66-P-13</b>	Piston	1
56	<b>378430-9</b>	Capscrew, Hex Head (.312"-18 x .875")	2
57	<b>379102</b>	Washer, Spring Retainer	2
58	<b>379103</b>	Retaining Ring (N-5000-106)	1
59	<b>500897-3</b>	Shipping Plug	2
60	<b>35-P-14</b>	Gasket	2
61	<b>378430-9</b>	Capscrew, Hex Head (.312"-18 x .875")	2
62	<b>378447-4</b>	Capscrew, Socket Head (.312"-18 x .75")	1
63	<b>378554</b>	Poppet Cap	1
64	<b>379652</b>	Indicator Switch (Norm. "ON")	1
65	<b>65-P-23</b>	Cover, Shifter Shaft	1
66	<b>378430-4</b>	Capscrew, Hex Head	2
	<b>328388-40X</b>	SHIFT INSTALLATION KIT, Air-O-Matic	



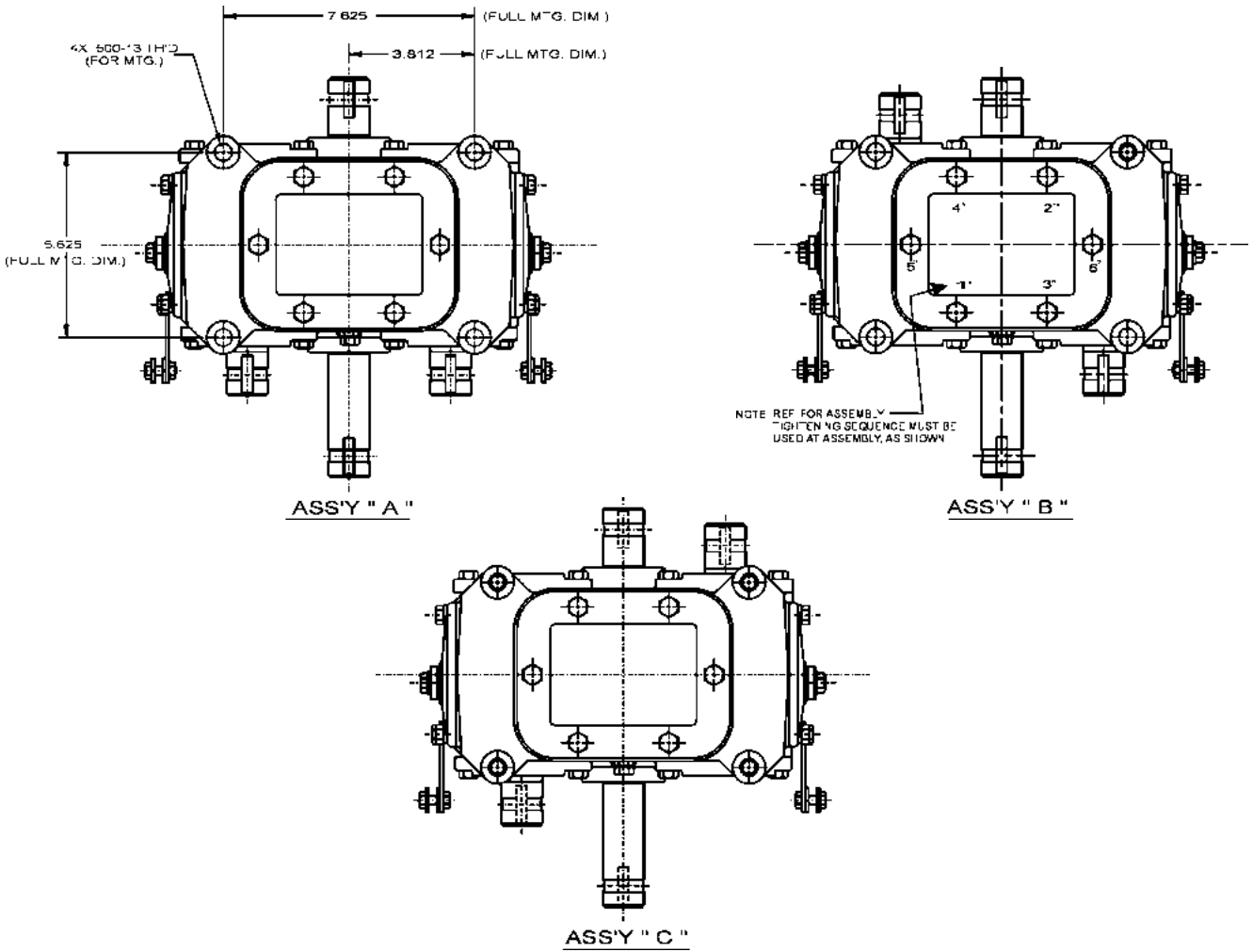


Item	Part Number	Description	Quantity
70	328830-1X	SHIFT COVER SUB-ASSEMBLY, Wire Control .....	1
71	328830-1X	SHIFT COVER SUB-ASSEMBLY, Wire Control (Includes Items 72-83) .....	1
72	28-P-191	O-Ring .....	2
73	34-P-74	Cover, Shifter .....	2
74	37-P-14	Spring, Poppet .....	2
75	51-P-13	Lever, Shifter .....	2
76	500365-22	Flat Washer .....	2
77	328829-1X	Shifter Plate Assembly, Side "X" .....	1
78	328829-2X	Shifter Plate Assembly, Side "Y" .....	1
79	378002	Ball (.438" Dia.) .....	2
80	500356-10	Lockwasher .....	2
81	378004	Flat Washer .....	2
82	379652	Indicator Switch (Norm "ON") .....	2
83	500409-6	Capscrew, Hex Head (.312"-24 x .625") .....	2
110	328346-10X	Wire Control Assembly .....	1
	328537	Parts Bag, Wire Control (Includes Items 113-119) .....	1
113	50-P-17	Bracket .....	2
114	50-P-19	Bracket, Swivel .....	2
115	378019	Pivot Pin .....	2
116	378326	Bushing Nut, Hex .....	2
117	378982	Spacer, Mtg. .....	2
118	500396-8	Screw, Hex Head (.250"-20 x .750") .....	2
119	500568-4	Set Screw, Square Head (.250"-20 x .500") .....	2
	328838X	INSTALLATION KIT, Wire Control .....	2

Model Number Designation



Assembly Arrangements





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9/01-P

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