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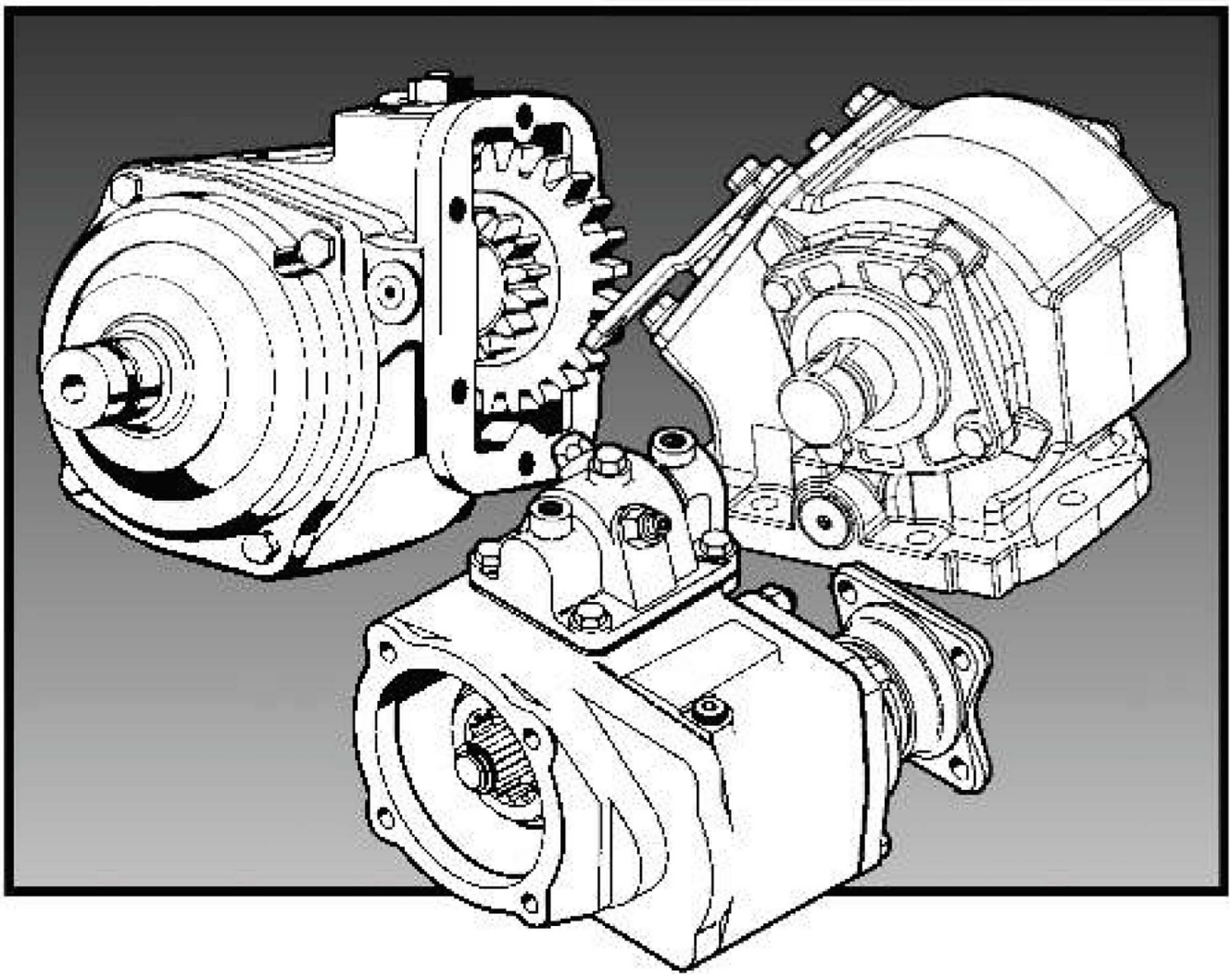
Bulletin HY25-2267-M1/US

CHELSEA®
Replacement Parts List
267 Series Manual

Effective: December 15, 2001
Supersedes: P410-267 Dated March 2001



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⚠ WARNING

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Chelsea Products Division
Olive Branch, MS 38654 USA

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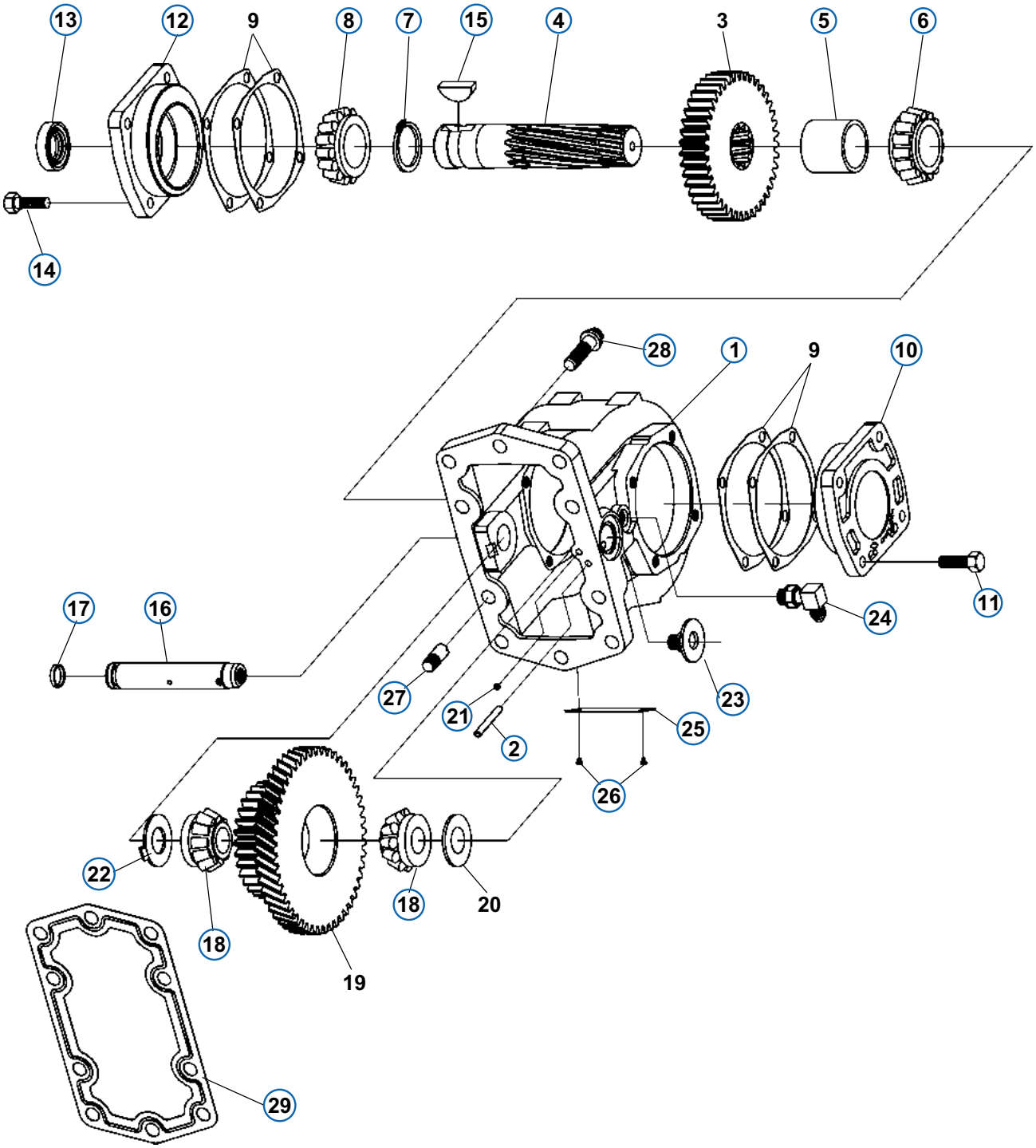

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Item	Part Number	Description	Quantity
1	1-P-584X	Housing with Roll Pin	1
2	500597-16	Slotted Roll Pin, Shipped with Housing	1
3	See Chart Pg. 3	Output Gear	1
4	3-P-202	Output Shaft, Standard 1.25" Round .312" Keyway	1
	See Chart Pg. 5	Output Shaft, Pump Mount	1
5	4-P-157	Spacer, Drive Shaft	1
6	550532	Bearing Cone, Closed End	1
7	378391	Lockring	1
8	550397	Bearing Cone, Open End	1
9	22-P-24-1	Bearing Cap Gasket, .010" thick	A.R.
	22-P-24-2	Bearing Cap Gasket, .020" thick	A.R.
	22-P-24-3	Bearing Cap Gasket, .015" thick	A.R.
10	328274X	Bearing Cap Assembly, Closed End	1
11	378430-10	Hex Capscrew (.312" x 1.00)	4
12	328273X	Bearing Cap Assembly, Open End, Standard Output	1
	See Chart Pg. 5	Bearing Cap Assembly, Open End, Pump Mount	
13	28-P-216	Oil Seal, Standard Output	1
	See Chart Pg. 5	Oil Seal, Pump Mount	
14	378430-10	Hex Capscrew .312" x 1.00" (XD), Open End	4
15	500007-29	Woodruff Key, “XD” Output	1
	379111	Square Key, “XX” Option	1
16	9-P-91	Idler Shaft, Pressure Lube	1
17	28-P-191	O-Ring	1
18	550439	Bearing Cone	2
19	See Chart Pg. 3	Input Gear	1
20	14-P-73-1	Spacer, Input Gear (.149-.151)	A.R.
	14-P-73-2	Spacer, Input Gear (.152-.154)	A.R.
	14-P-73-3	Spacer, Input Gear (.155-.157)	A.R.
	14-P-73-4	Spacer, Input Gear (.1.58-.160)	A.R.
	14-P-73-5	Spacer, Input Gear (.1.61-.163)	A.R.
21	378108	Steel Ball	1
22	31-P-102	Tab Washer, Thrust	1
23	379672	NWD Plug	1
24	379486	90° O-Ring Boss Connector	1
25	68-P-2	Name Plate	1
26	378422	Drive Screw	2
		PARTS SHIPPED LOOSE	
	7170-86X	Mounting Kit, Includes items 24, 27 & 28	1
27	379451	Pilot Screw	2
28	379453-10	Ferry Capscrew	8
	328711X	Pump Mounting Kit, “XR” Output	1
	328948-9X	Gasket & Installation Instructions (Includes Item 29)	1
29	35-P-74	Mounting Gasket	1
		SERVICE KITS	
	329071-1X	Gasket and Seal Kit	
	329071-4X	Bearing Kit	

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267 X G FJ P – M 5 XE

BASIC MODEL
267

MOUNTING TYPE
X = Standard Mounting
S = Super Torque™

GEAR RATIO
B = 25/47
D = 28/44
G = 31/41
M = 35/37
K = 34/38
S = 39/33

INPUT GEAR DESIGNATOR
FJ = Right Hand Helix

LUBRICATION
P = Pressure Lube
W = Wet Spline

SHIFTER TYPE
M = Constant Mesh

OUTPUT TYPE
AF = S.A.E. "BB" 2 or 4 Bolt
AK = S.A.E. "B" 2 Bolt
GA = Greasable Rotatable "B" 2 Bolt
GB = Greasable Rotatable "B" 4 Bolt
GF = Greasable S.A.E. "BB" 2 or 4 Bolt
GH = Greaseable Rotatable S.A.E. "BB" 2 Bolt
GK = Greasable S.A.E. "B" 2 or 4 Bolt
GQ = Greasable S.A.E. "B" 2 or 4 Bolt
GR = Greasable CHELSEA Special
GY = Greasable DIN 5462 Flange w/ 1.245" 12T
GZ = Greaseable Non-Standard 4 Bolt
RA = Rotatable S.A.E. "B" 2 Bolt
RB = Rotatable S.A.E. "B" 4 Bolt
RC = Rotatable S.A.E. "A" 2 Bolt
RD = Rotatable S.A.E. "B" 2 Bolt
RF = Rotatable S.A.E. "BB" 2 Bolt
RY = Rotatable DIN 5462
XD = 1.250" Rd.
XE = S.A.E. "A" 2 or 4 Bolt
XK = S.A.E. "B" 2 or 4 Bolt
XQ = S.A.E. "B" 2 or 4 Bolt
XR = CHELSEA Special
XY = DIN 5462
XX = 1.25" S.A.E. Taper

ASSEMBLY ARRANGEMENT*
3, 4, 5, 6

* 1 Assembly arrangements 4 & 6 will not mount up to the Allison transmission because the output shaft will hit the transmission housing.

2 267 "3" not available with "XK" output. "3" arrangement must use "XQ" flange option.

Input Gear Chart

Model Number	Input Gear Part Number	Helix Angle	No .Teeth Lg. Cluster	No. Teeth Sm. Cluster	Output Gear Part Number	No. Teeth
267*BFJ	5-P-912	Right Hand	50	25	2-P-711	47
267*DFJ	5-P-913	Right Hand	50	28	2-P-712	44
267*GFJ	5-P-914	Right Hand	50	31	2-P-702	41
267*KFJ	5-P-1211	Right Hand	50	34	2-P-763	38
267*MFJ	5-P-915	Right Hand	50	35	2-P-706	37
267*SFJ	5-P-1173	Right Hand	50	39	2-P-808	33
SUPERTORQUE™						
267SBFJ	5-P-1350	Right Hand	50	25	2-P-803	47
267SDFJ	5-P-1293	Right Hand	50	28	2-P-804	44
267SGFJ	5-P-1225	Right Hand	50	31	2-P-773	41
267SKFJ	5-P-1403	Right Hand	50	34	2-P-805	38
267SMFJ	5-P-1351	Right Hand	50	35	2-P-806	37
267SSFJ	5-P-1278	Right Hand	50	39	2-P-807	33

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Flange Suffix	Flange Type	Shaft Type	Conversion Kit
AF	S.A.E. “BB” 2 or 4 Bolt	1.0"-15 Spline	328591-30X
AK	S.A.E. “B” 2 Bolt	7/8"-13 Spline	32859128X
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
GF	S.A.E. “BB” 2 or 4 Bolt	1.0"-15 Spline	■328591-71X
GH	S.A.E. “BB” 2 Bolt	1.0"-15 Spline	■328591-116X
GK	S.A.E. “B” 2 or 4 Bolt	7/8"-13 Spline	■328591-89X
● GQ	S.A.E. “B” 2 or 4 Bolt	7/8"-13 Spline	■328591-91X
GR	CHELSEA Special 4 Bolt	7/8"-13 Spline	■328591-76X
GY	DIN 5462 Pump Mountiing	DIN 5462	■328591-92X
GZ	Non-Standard 4 Bolt	1.25"-14 Spline	■328591-93X
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
RC	Rotatable S.A.E “A” 2 Bolt	5/8"-9 Spline	328591-112X
RD	Rotatable S.A.E. “B” 2 Bolt	7/8"-13 Spline	328591-113
RF	Rotatable S.A.E. 2 Bolt	1.0"-15 Spline	328591-78X
RY	Rotatable Rotatable Din 5462	DIN 5462	328591-131X
XE	S.A.E. “A” 2 or 4 Bolt	5/8"-9 Spline	328591-27X
XK	S.A.E. “B” 2 or 4 Bolt	7/8"-13 Spline	328591-16X
● XQ	S.A.E. “B” 2 or 4 Bolt	7/8"-13 Spline	328591-17X
XR	CHELSEA Special 4 Bolt	7/8"-13 Spline	328591-52X
XY	DIN 5462 Pump Mountiing	7/8"-13 Spline	328591-121X
⏩ XX	1.25" S.A.E. Taper	Round w/ Key	-

XR to “XK” Conversion Flange 21-P-525
■ Shaft with Grease Fitting
● Similar to Ass’y “XK” Flange Rotated 90°
⏩ Companion Flange 3-1-604 Furnished by Customer

NOTE: 267 “3” arrangement not available with “XK” output. “3” arrangement must use “XQ” flange.

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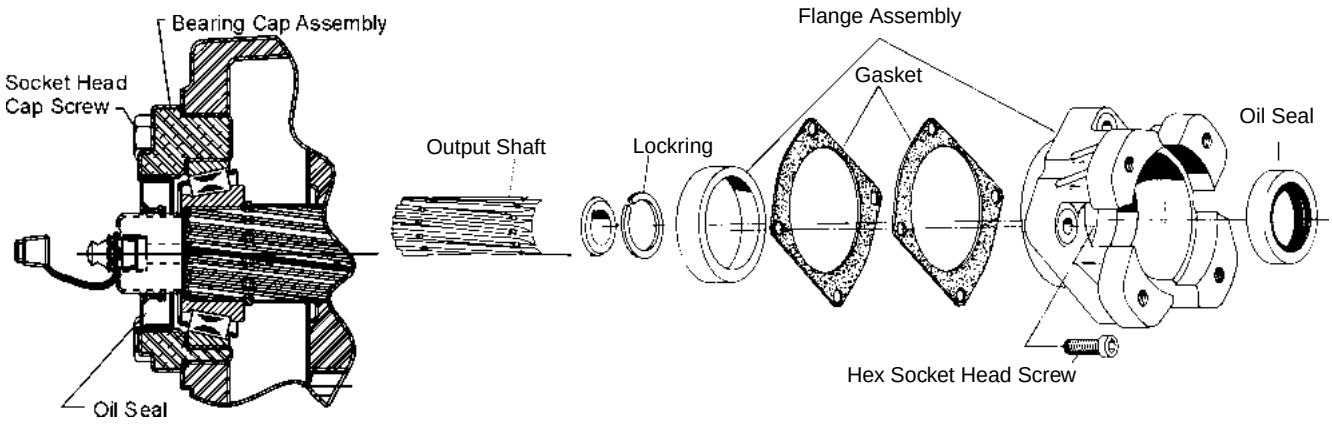

Flange Suffix	Conversion Kit*	Front				Rear Cap Greasable Option		
		Flange Assembly	Output Shaft	Socket Head (4 Req'd)	Oil Seal	Brg. Cap Assembly	Socket Head (4 Req'd)	Oil Seal
AF	328591-30X	329088X	3-P-854	378447-10	28-P-219			
AK	328591-28X	328989X	3-P-282	378447-8	28-P-216			
GA	328591-72X	329195X & 21-P-628	3-P-923X	● 378447-6	28-P-216	328273X	378430-10	28-P-268
GB	328591-74X	329195X & 21-P-572	3-P-923X	● 378447-6	28-P-216	328273X	378430-10	28-P-268
GF	328591-71X	329088X	3-P-921X	378447-10	28-P-219	328273X	378430-10	28-P-268
GH	328591-116X	329264X & 21-P-626	3-P-941X	378447-6 (7)	28-P-219	328273X	378430-10	28-P-268
GK	328591-89X	328333X	3-P-933X	378447-8	28-P-216	328273X	378430-10	28-P-268
▸GQ	328591-91X	328589X	3-P-933X	378442-8	28-P-216	328273X	378430-10	28-P-268
GR	328591-76X	329194X	3-P-923X	⏩ 379673	28-P-216	328273X	378430-10	28-P-268
GY	328591-92X	329234X	3-P-938X	378430-10	28-P-216	328273X	378430-10	28-P-268
GZ	328591-93X	329052X	3-P-844	378447-11	28-P-230			
RA	328591-55X	329195X & 21-P-628	3-P-283	● 378447-6	28-P-216			
RB	328591-56X	329195X & 21-P-572	3-P-283	● 348447-6	28-P-216			
RC	328591-112X	329322X & 21-P-638	3-P-800	⏪ 328170-210X	28-P-216			
RD	328591-112X	329322X & 21-P-638	3-P-800	⏪ 328170-210X	28-P-216			
RF	328591-78X	329264X & 21-P-626	3-P-924	378447-6 (7)	28-P-219			
RY	328591-132X	329356X & 21-P-625	3-P-768	378447-8 (4) 378740-6 (3)				
XK	328591-16X	329333X	3-P-282	348447-8	28-P-216			
▸XQ	328591-17X	329589X	3-P-282	348447-8	28-P-216			
XR	328591-52X	329194X	3-P-283	⏩ 379673	28-P-216			
XY	328591-121X	329234X	3-P-768	378430-10	28-P-230			

* Consists of all the items shown in the illustration, plus Lockring (Item 5) and Bearing Cap Gasket (Item 8)

● Seven required; four to fasten the Flange Assembly 328195X to the housing and three to fasten the rotatable flange to the flange assembly.

▸ Similar to "XK" Assembly, only rotated 90°

⏩ Special shoulder stud

⏪ Consists of (4) 378447-6 capscrews for attaching the bearing cap and (6) 378446-4 for attaching the pump flange.

NOTE: To convert P.T.O.'s with AK, XP, XQ, XN, or XK output to the lube pump option, use 329097-1X. To convert P.T.O.'s with XD output to the lube pump option, use 329096-1X

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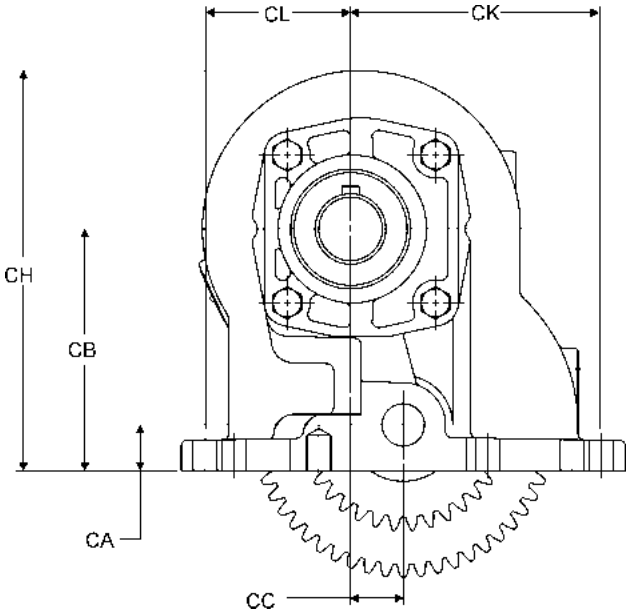
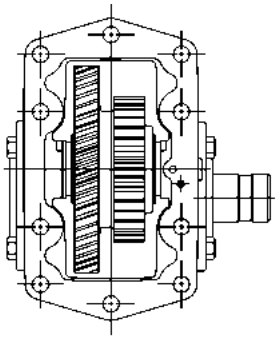
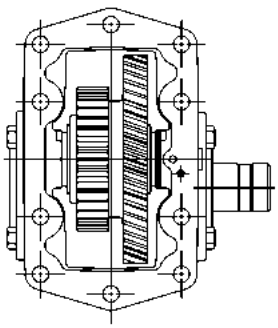
P.T.O. Housing Dimensions

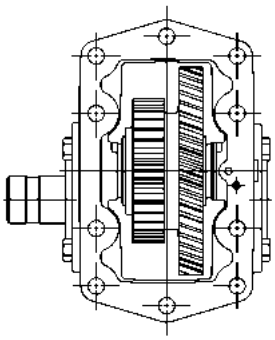


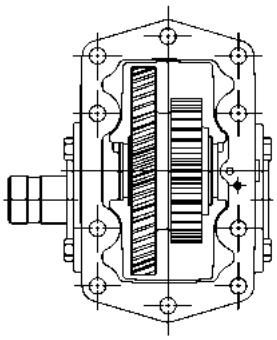
P.T.O. Series	Housing Number	CA	CB	CC	CH	CK	CL
267 ▶	1-P-584	0.816	4.294	0.933	7.104	4.437	2.571

Assembly Arrangements


Assembly Arrangement 3


Assembly Arrangement 4*


Assembly Arrangement 5**


Assembly Arrangement 6*

* The 267 Series is shown for assemblies 4 & 6, however, assemblies 4 & 6 will not mount up to the Allison World Class Transmission due to the output shaft/bell housing interference.

** 1). Gear forward, output shaft rear and bulge down - left side.
2). Gear forward, output shaft rear and bulge up - right side.

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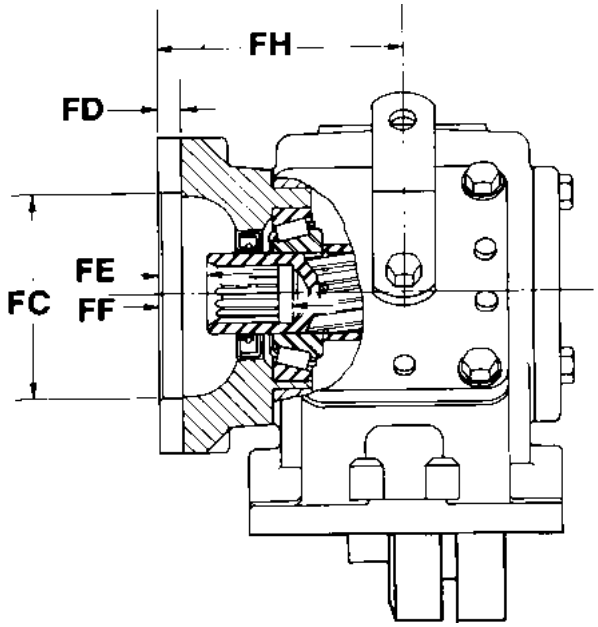
Pump Flange & Shaft Dimensions



Pump Flange & Shaft Dimensions

Pump Flange Suffix	Bolt Circle Dia.	BOLT HOLES		FC	FD	FE	FF	FH	OUTPUT SHAFT
		Tapped Hole	No. Equally Spaced	Female Pilot Diameter	Pilot Depth	Face to end of Shaft	Face thru Hole	Face to Center of P.T.O.	Hole Dia.
AF, GF	5.750	.500"-13	2	4.003	0.406	0.516	1.984	4.322	1"-15 Spline
	5.000	.500"-13	4	4.003	0.406	0.516	1.984	4.322	
AK	5.750	.500"-13	2	4.003	0.406	0.562	2.062	3.688	7/8"-13 Spline
AZ, GF	5.000	.500"-13	4	4.003	0.406	0.695	2.392	4.985	1.25"-14 Spline
RA*****, GA	5.750	.500"-13	2**tt**	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
RC*****	4.188	.375-16	2**tt**	3.253	0.270	0.525	1.462	3.694	5/8"- 9 Spline
RD*****	4.188	.375-16	2**tt**	3.253	0.270	0.525	2.024	3.694	7/8"-13 Spline
RF*****, GH	5.750	.500"-13	2**tt**	4.003	0.406	0.501	1.969	4.569	1.0"-15 Spline
RY	3.150	M12-1.75	4	3.152	0.394	0.360	2.274	4.79	DIN 5462
XE	5.000	.500"-13	4	3.253	0.344	0.562	1.500	3.688	5/8"- 9 Spline
XK, GK	5.750	.531"-13**ttt**	2	4.003	0.406	0.562	2.062	3.688	7/8"-13 Spline
	5.000	.531"-13**ttt**	4	4.003	0.406	0.562	2.062	3.688	
XY, GY	4.454	M12-1.75	4	3.152	0.393	0.594	2.508	4.697	DIN 5462
XQ, GQ	5.750	.500"-13	2	4.003	0.406	0.562	2.062	3.688	7/8"-13 Spline
	5.000	.500"-13	4	4.003	0.406	0.562	2.062	3.688	
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
tt Two Set of Holes Spaced 14° Apart
ttt Not Tapped
NOTE: To convert an “XR” to an “XK”, use conversion flange number 21-P-525

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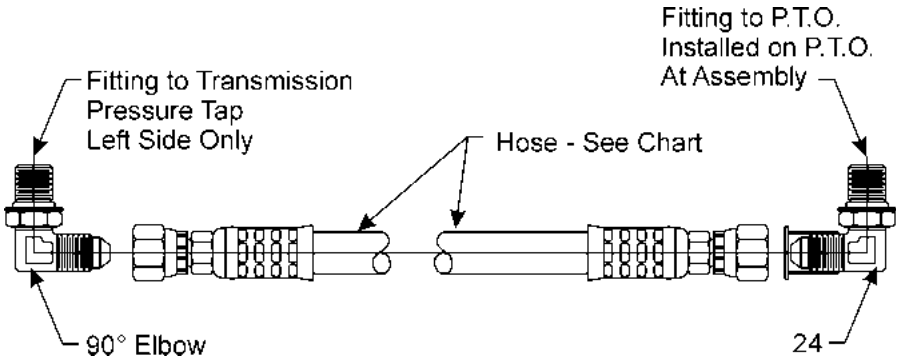
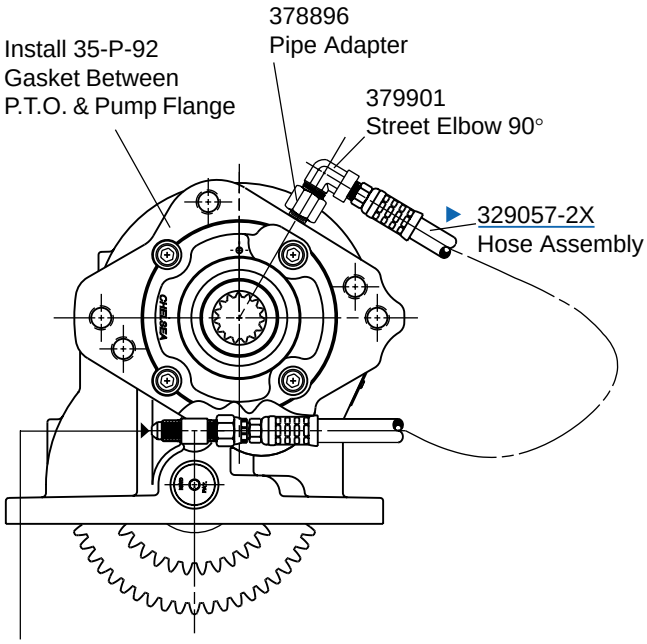
Pressure Lube & Pressure Lube Hose Chart

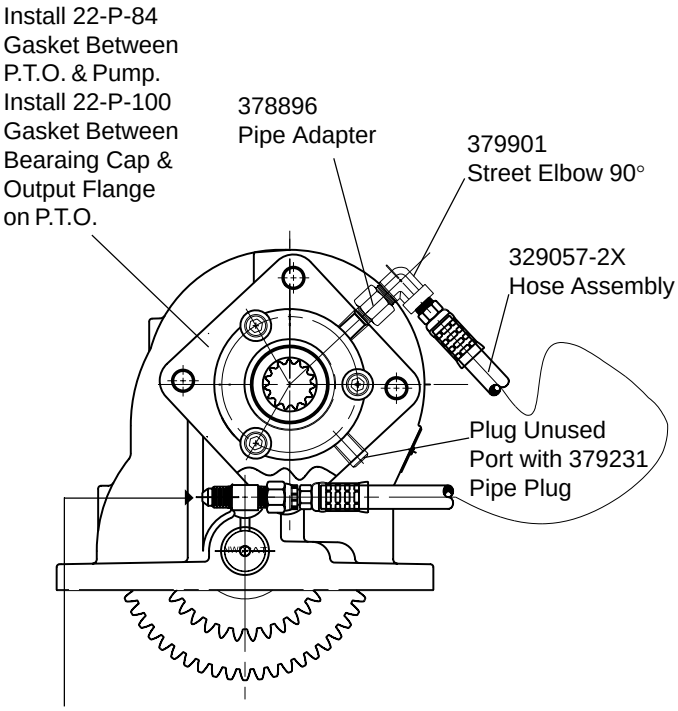


Trans	Side	Hose Part Number
MD	Left	329130-1X
MD	Right	329075-2X
HD	Left	329130-1X
HD	Top Right	329075-3X

"AF" Wet Spline



"RY" Wet Spline



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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, 250, 251 and 859 series two (2) years from date of installation. **THIS WARRANTY COMPRISES THE SOLE AND ENTIRE WARRANTY PERTAINING TO ITEMS PROVIDED HEREUNDER. SELLER MAKES NO OTHER WARRANTY, GUARANTEE, OR REPRESENTATION OF ANY KIND WHATSOEVER. ALL OTHER WARRANTIES, INCLUDING BUT NOT LIMITED TO, MERCHANTABILITY AND FITNESS FOR PURPOSE, WHETHER EXPRESS, IMPLIED, OR ARISING BY OPERATION OF LAW, TRADE USAGE, OR COURSE OF DEALING ARE HEREBY DISCLAIMED. NOTWITHSTANDING THE FOREGOING, THERE ARE NO WARRANTIES WHATSOEVER ON ITEMS BUILT OR ACQUIRED WHOLLY OR PARTIALLY, TO BUYER'S DESIGNS OR SPECIFICATIONS.**

5. Limitation Of Remedy: SELLER'S LIABILITY ARISING FROM OR IN ANY WAY CONNECTED WITH THE ITEMS SOLD OR THIS CONTRACT SHALL BE LIMITED EXCLUSIVELY TO REPAIR OR REPLACEMENT OF THE ITEMS SOLD OR REFUND OF THE PURCHASE PRICE PAID BY BUYER, AT SELLER'S SOLE OPTION. IN NO EVENT SHALL SELLER BE LIABLE FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES OF ANY KIND OR NATURE WHATSOEVER, INCLUDING BUT NOT LIMITED TO LOST PROFITS ARISING FROM OR IN ANY WAY CONNECTED WITH THIS AGREEMENT OR ITEMS SOLD HEREUNDER, WHETHER ALLEGED TO ARISE FROM BREACH OF CONTRACT, EXPRESS OR IMPLIED WARRANTY, OR IN TORT, INCLUDING WITHOUT LIMITATION, NEGLIGENCE, FAILURE TO WARN OR STRICT LIABILITY.

6. Changes, Reschedules and Cancellations: Buyer may request to modify the designs or specifications for the items sold hereunder as well as the quantities and delivery dates thereof, or may request to cancel all or part of this order, however, no such requested modification or cancellation shall become part of the contract between Buyer and Seller unless accepted by Seller in a written amendment to this Agreement. Acceptance of any such requested modification or cancellation shall be at Seller's discretion, and shall be upon such terms and conditions as Seller may require.

7. Special Tooling: A tooling charge may be imposed for any special tooling, including without limitation, dies, fixtures, molds and patterns, acquired to manufacture items sold pursuant to this contract. 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 items sold hereunder, 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.

8. 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, may be considered obsolete and may be destroyed by Seller after two (2) consecutive years have elapsed without Buyer placing an order for the items which are 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. Taxes: Unless otherwise indicated on the face hereof, all prices and charges are exclusive of excise, sales, use, property, occupational or like taxes which may be imposed by any taxing authority upon the manufacture, sale or delivery of the items sold hereunder. If any such taxes must be paid by Seller or if Seller is liable for the collection of such tax, the amount thereof shall be in addition to the amounts for the items sold. Buyer agrees to pay all such taxes or to reimburse Seller therefore upon receipt of its invoice. If Buyer claims exemption from any sales, use or other tax imposed by any taxing authority, Buyer shall save Seller harmless from and against any such tax, together with any interest or penalties thereon which may be assessed if the items are held to be taxable.

10. 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 Part 10. Seller will defend and indemnify Buyer against allegations of infringement of U.S. Patents, U.S. Trademarks, copyrights, trade dress and trade secrets (hereinafter '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 an item sold pursuant to this contract 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 an item sold hereunder 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 said item, replace or modify said item so as to make it noninfringing, or offer to accept return of said item 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 items 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 item sold hereunder. The foregoing provisions of this Part 10 shall constitute Seller's sole and exclusive liability and Buyer's sole and exclusive remedy for infringement of Intellectual Property Rights.
If a claim is based on information provided by Buyer or if the design for an item delivered hereunder is specified in whole or in part by Buyer, Buyer shall defend and indemnify Seller for all costs, expenses or judgments resulting from any claim that such item infringes any patent, trademark, copyright, trade dress, trade secret or any similar right.

11. Force Majeure: Seller does not assume the risk of 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, acts of God, strikes or labor disputes, acts, laws, rules or regulations of any government or government agency, fires, floods, delays or failures in delivery of carriers or suppliers, shortages of materials and any other cause beyond Seller's control.

12. Entire Agreement/Governing Law: The terms and conditions set forth herein, together with any amendments, modifications and any different terms or conditions expressly accepted by Seller in writing, shall constitute the entire Agreement concerning the items sold, and there are no oral or other representations or agreements which pertain there/to. This Agreement shall be governed in all respects by the law of the State of Ohio. No actions arising out of the sale of the items sold hereunder or this Agreement may be brought by either party more than two (2) years after the cause of action accrues.

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For parts or service call us
Pro Gear & Transmission, Inc.

1 (877) 776-4600

(407) 872-1901

parts@eprogear.com

906 W. Gore St.

Orlando, FL 32805