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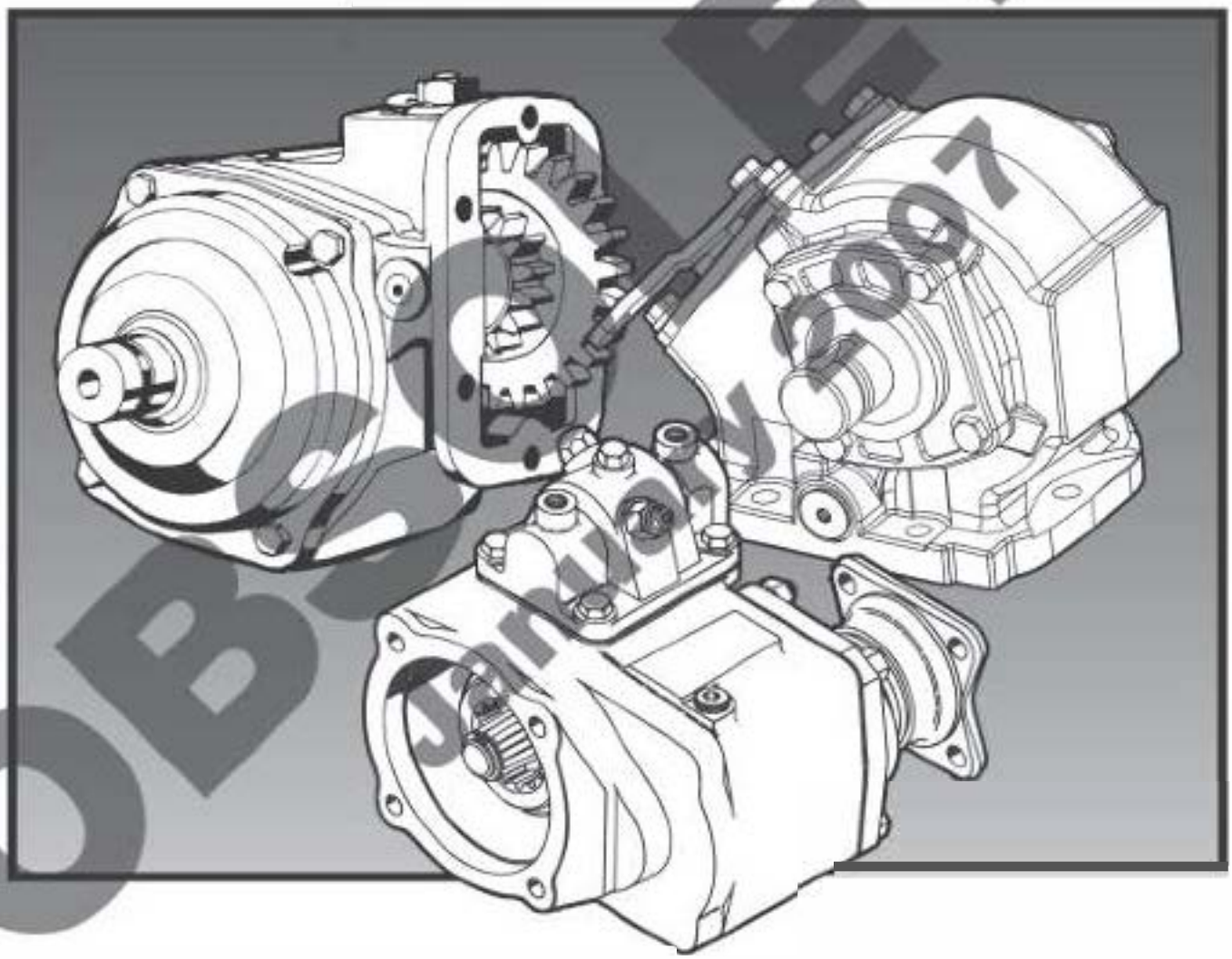
(877) 776-4600 or (407) 872-1901 parts@eprogear.com

# CHELSEA
# Replacement Parts List 434 Series Manual

Bulletin HY25-2434-MWS

Effective: January 15, 2007

Supersedes: HY25-2434-M1/US Dated Nov. 2001



OBSOLETE January 2007

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Chelsea Products Division
Olive Branch, MS 38654 USA

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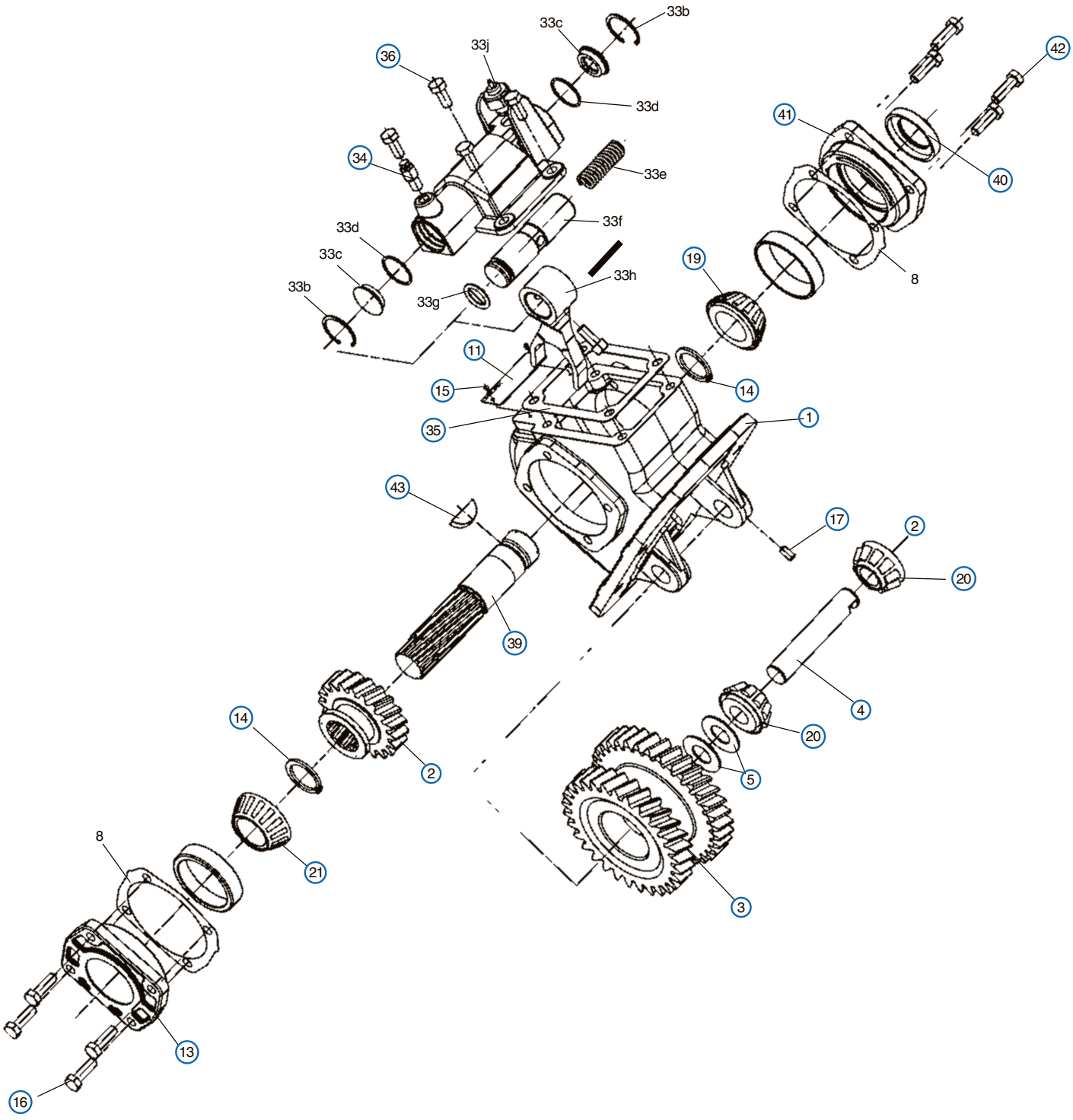




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| Item | | Part Number | Description | Quantity |
|---|---|---|---|---|
| 1 | | 1-P-504 | Housing | 1 |
| 2 | ▶ | 2-P-699 | Gear, Output (20 teeth) | 1 |
| 3 | ▶ | 5-P-962 | Gear, Idler | 1 |
| 4 | ▶ | 9-P-66 | Shaft, Idler | 1 |
| 5 | ▶ | 14-P-15 | 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



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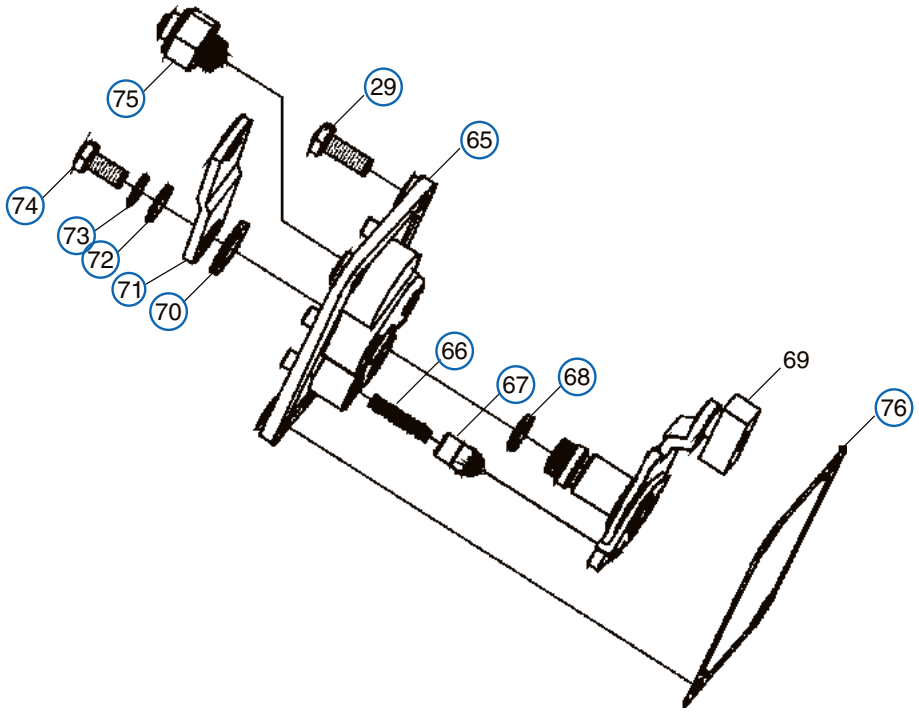
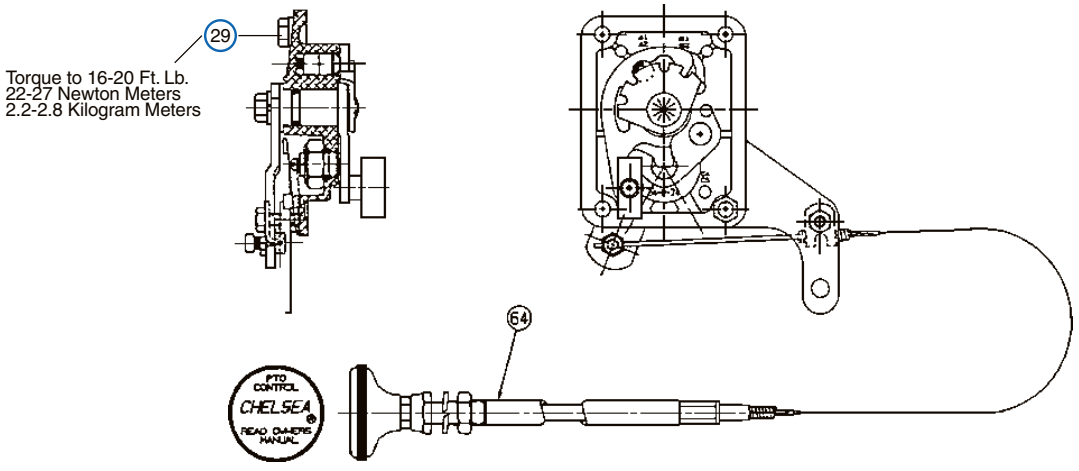
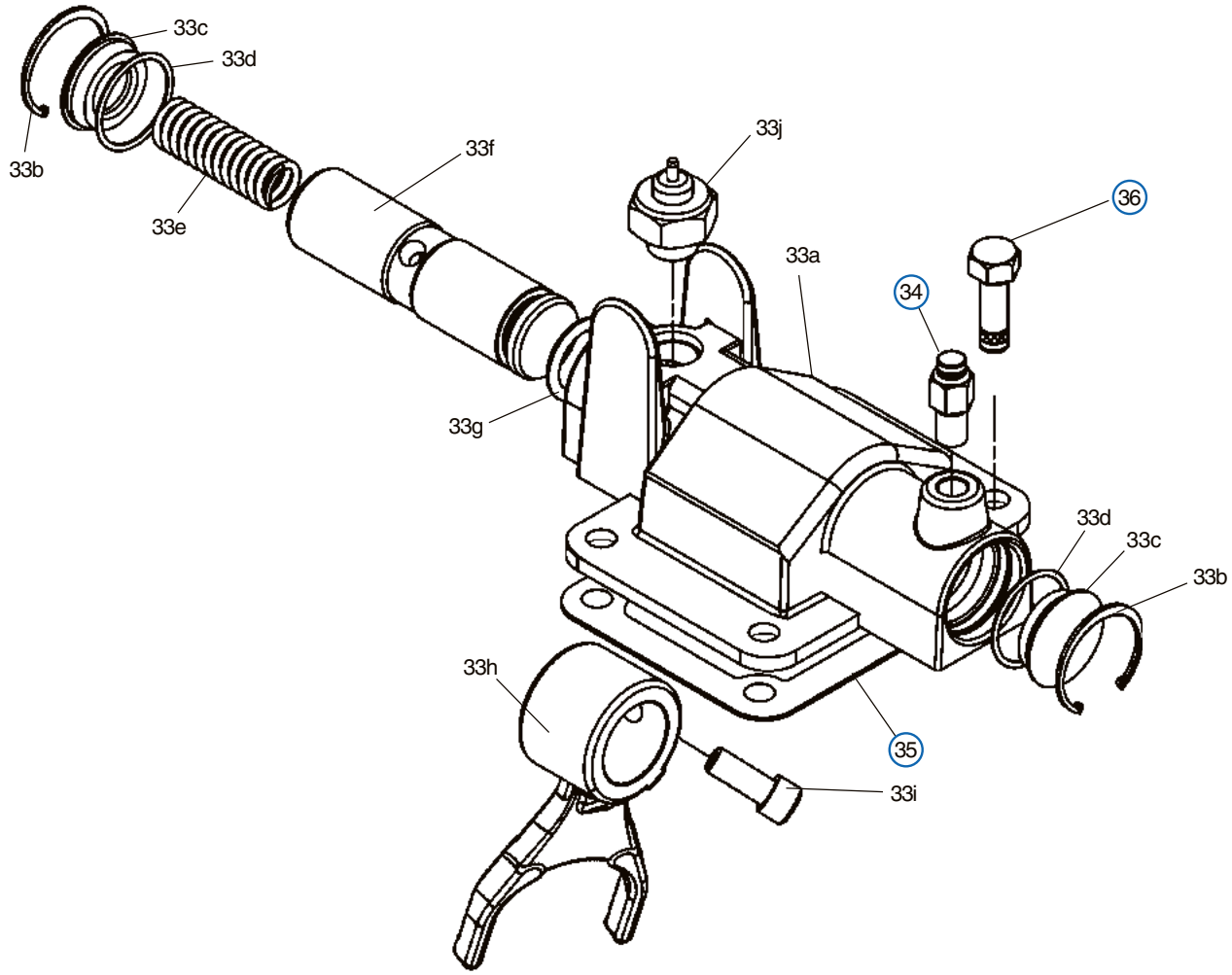



| Item | Part Number | Description | Quantity |
|---|---|---|---|
| | **329038-1X** | CABLE SHIFT COVER ASSEMBLY, (3 & 6) | 1 or |
| | **329038-2X** | CABLE SHIFT ASSEMBLY, (4 & 5) | 1 |
| | All the above sh[redacted]ver assemblies include items 65 thru 75 | | |
| 65 ▶ | **34-P-74** | Cover Plate, Shifter | 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 |



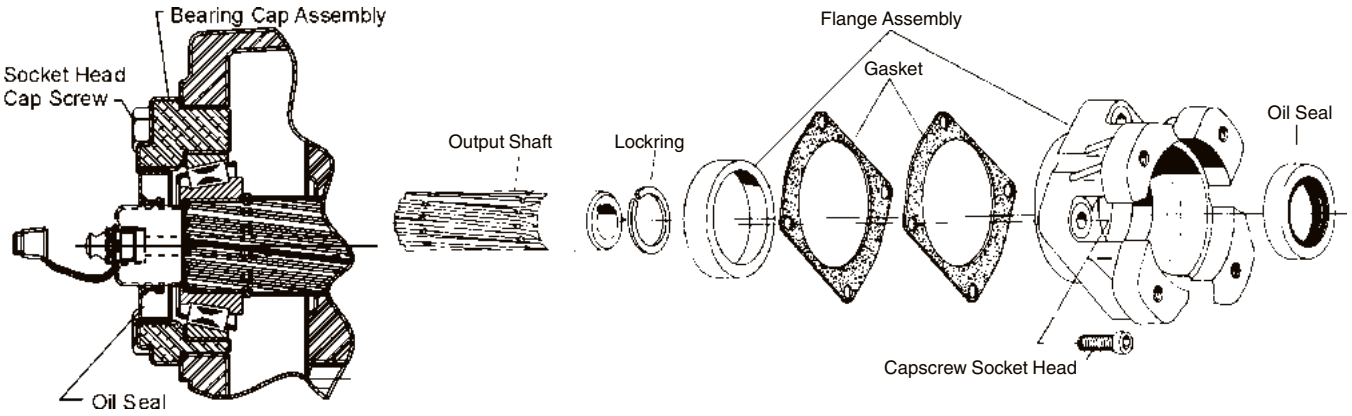



| Item | Part Number | Description | Quantity |
|---|---|---|---|
| 33 ▶ | **329363X** | Shifter Cover Assembly, Air Shift ( Includes Items 33a-33j) | 1 |
| 33a | **34-P-130** | Shifter Cover | 1 |
| 33b | **378316** | Snap Ring | 2 |
| 33c | **378315** | Cover Plug | 2 |
| 33d | **28-P-42** | O-Ring | 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 |

| 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 |

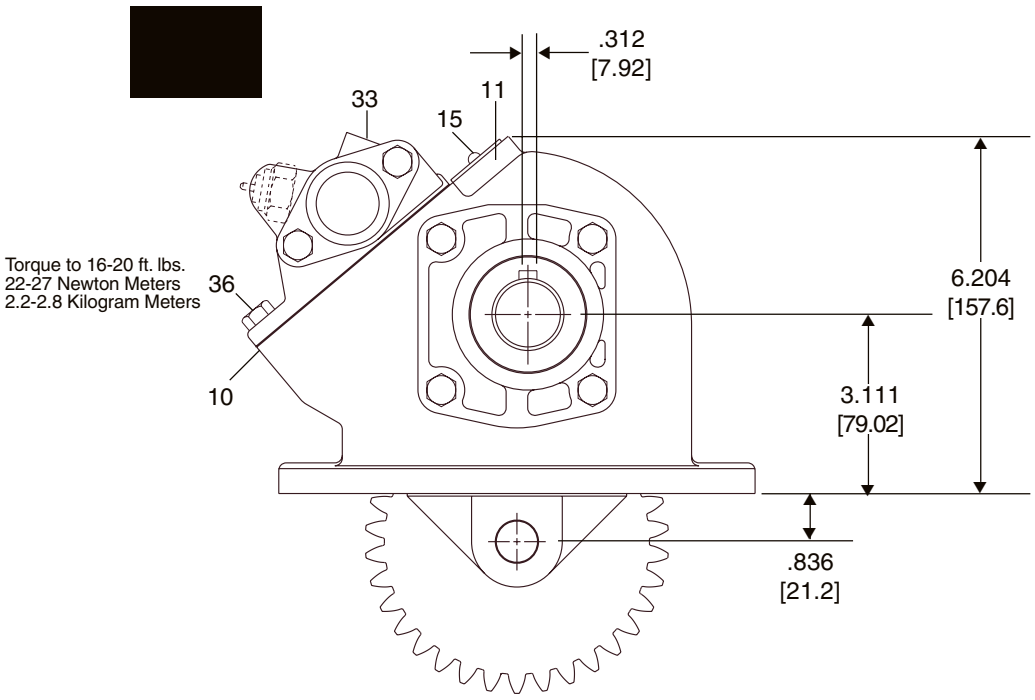
** Shaft with Grease Fitting

## Pump Conversion Kit Bill of Material

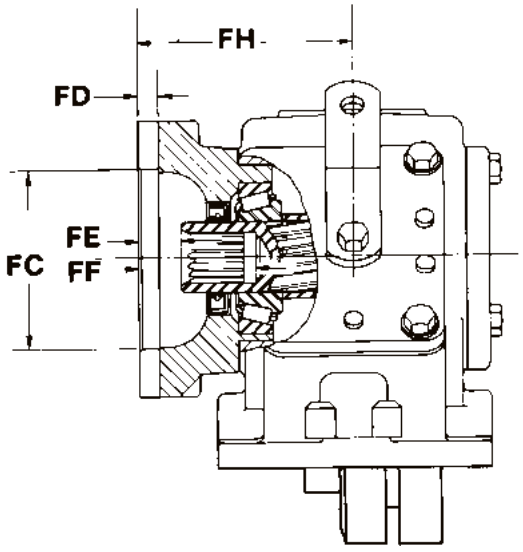



| Flange Suffix | Conversion Kit * | Front | | | | Rear Cap Greasable Option | | |
|---|---|---|---|---|---|---|---|---|
| | | Flange Assembly | Output Shaft | Socket Head | Oil Seal | Bearing Cap Assembly | Socket Head | Oil Seal |
| GA | 328591-72X | 329195X & 21-P-628 | 3-P-923X | 378447-6 tt | 28-P-216 | 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 | FD | FE | FF | FH | Output Shaft |
|---|---|---|---|---|---|---|---|---|---|
| | | Tapped Hole | No. Equally Spaced | Female Pilot Dia. | Pilot Depth | Face to End of Shaft | Face thru Hole | Face to Center of P.T.O. | Hole Diameter |
| 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



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Chelsea Products Division
Olive Branch, MS 38654 USA

**434 X U FV X - A 3 XD**

**BASIC MODEL NUMBER**
434 Series

**MOUNTING TYPE**
X = Standard

**GEAR RATIO**
U

**INPUT GEAR DESIGNATOR**

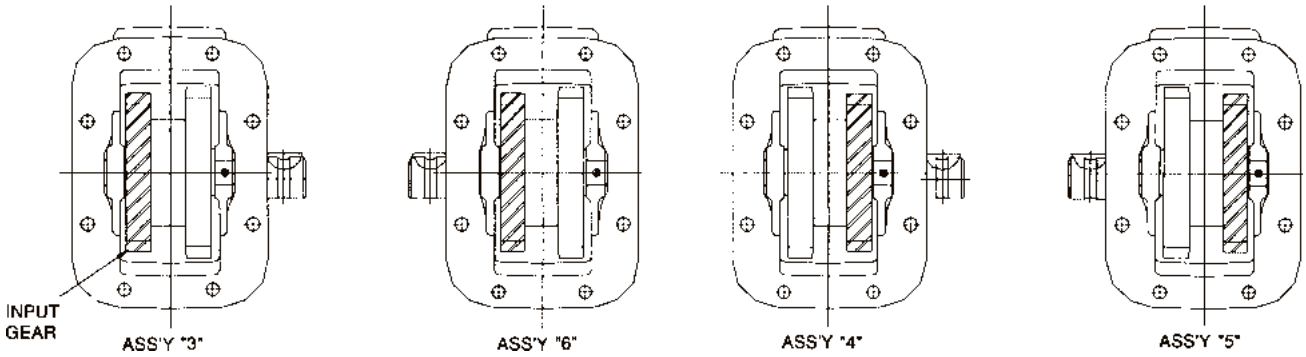
**LUBRICATION**
X = No Option

**OUTPUT**
XD = 1.25" Rd
XR = CHELSEA Special
RA = Rotatable S.A.E. "B" 2 Bolt
RB = Rotatable S.A.E. "B" 4 Bolt
RF = Rotatable S.A.E. "BB" 2 Bolt
GA = Greasable Rotatable S.A.E. 2 Bolt
GB = Greasable Rotatable S.A.E. 4 Bolt
GH = Greasable Rotatable S.A.E. "BB" 2 Bolt
GR = Greasable Rotatable CHELSEA Special

**ASSEMBLY ARRANGEMENT**
3, 4, 5 or 6

**SHIFTER TYPE**
A = Air Shift
W = Cable Shift
Z = E-Z Shift

## Assembly Arrangements



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**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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**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.

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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.

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1/06-P



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Chelsea Products Division
Olive Branch, MS 38654 USA

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