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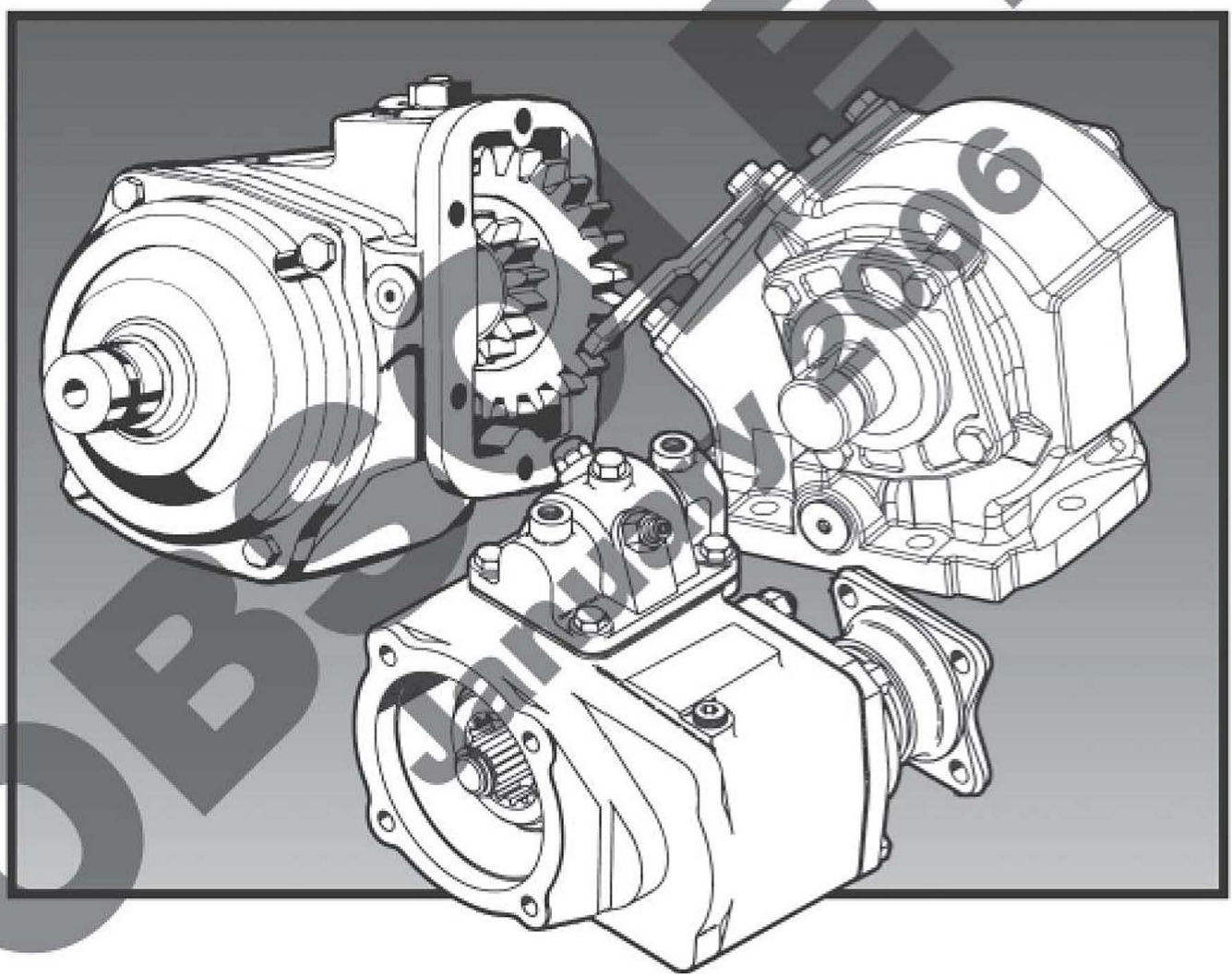
CHELSEA®

Bulletin HY25-2452-M1/US

Effective: February 15, 2002
Supersedes: P410-452 Dated June 1995

Replacement Parts List
453 Series Manual



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January 2006

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Chelsea Products Division
Olive Branch, MS 38654 USA

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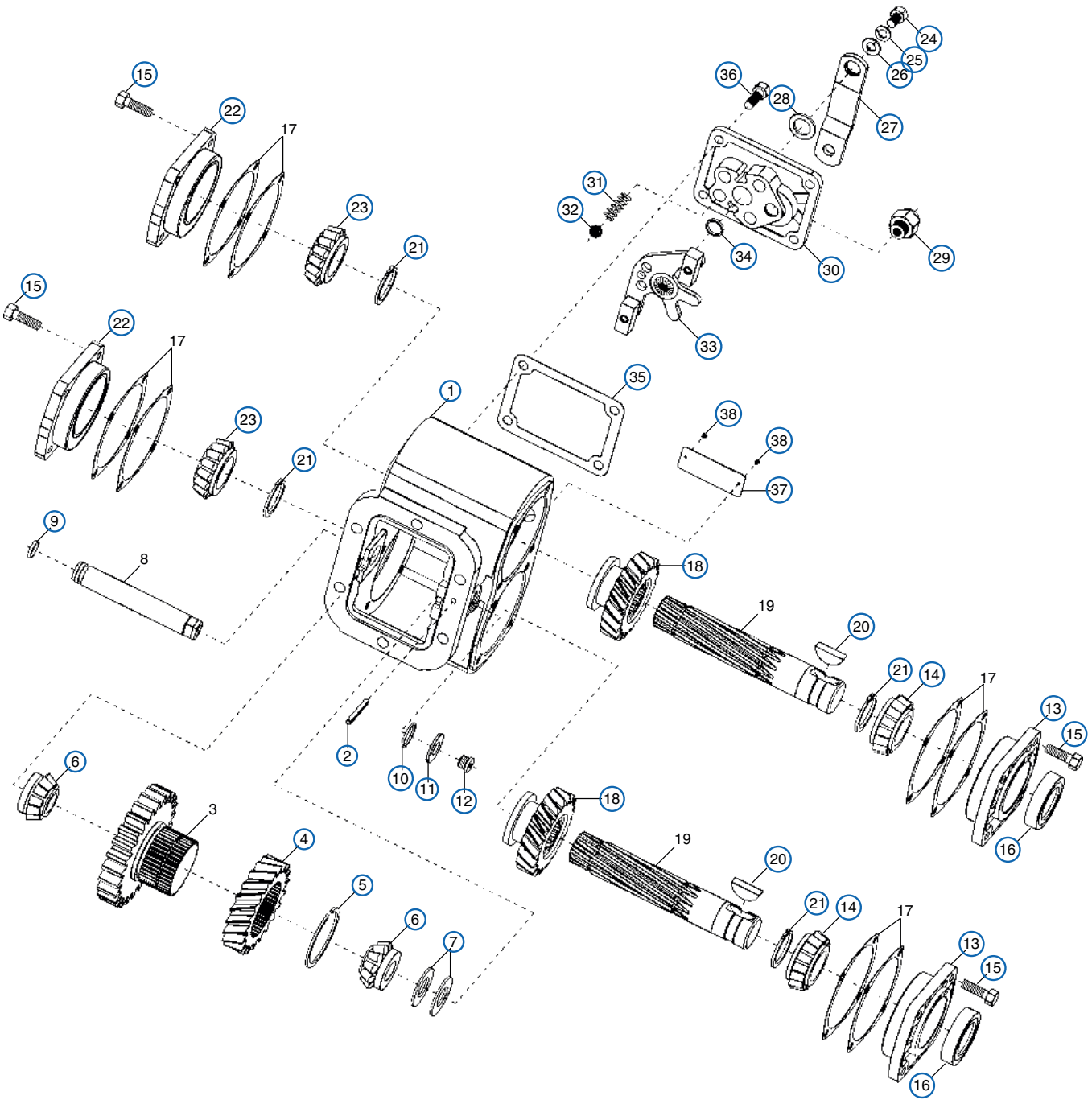

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Olive Branch, MS 38654 USA

Item		Part Number	Description	Quantity
1	▶	1-P-520X	Housing, w/Roll Pin, Standard Mount	1
	▶	1-P-521X	Housing, w/Roll Pin, Deep Mount	1
2	▶	500597-14	Roll Pin, Deep Mount	1
	▶	500597-16	Roll Pin, Standard Mount	1
3		See Chart Pg. 4	Gear, Input Cluster	1
4	▶	5-P-1153	Gear, Ratio	1
5	▶	379522	Retaining Ring	1
6	▶	550439	Cone Bearing, Input Gear	2
7	▶	14-P-15	Spacer, Input Gear	A.R.
	▶	9-P-74	Shaft, Input Idler Shaft	1
9	▶	28-P-191	O-Ring	1
10	▶	28-P-190	O-Ring	1
11	▶	379542	Retainer, O-Ring	1
12	▶	379484	Plug, O-Ring Boss	1
13	▶	328273X	Bearing Cap Assembly, Open End (Includes bearing cup)	2
14	▶	550532	Bearing Cone, Open End & Reverse Idler Shaft	2
15	▶	378430-10	Capscrew, Hex head (.3125"-18 x 1")	16
16		28-P-52	Oil Seal, Output Shaft	2
17		22-P-24-1	Gasket, Bearing Cap (.010")	A.R.
		22-P-24-2	Gasket, Bearing Cap (.020")	A.R.
		22-P-24-3	Gasket Bearing Cap (.015")	A.R.
18	▶	2-P-721	Gear, Output	1
	▶	3-P-859	Shaft, Standard Output 1.250" Rd.	2
20	▶	500007-29	Woodruff Key	2
21	▶	378391	Retaining Ring, Output Shaft	4
22	▶	328274X	Bearing Cap Assembly, Closed End (Includes bearing cup)	2
23	▶	550397	Bearing Cone, Closed End, Output Shaft	2
		328837X	Cable Shift Cover Assembly, Single Shift (Consists of Items 24 thru 34)	1
24	▶	500409-6	Screw, Shifter Lever (.3125"-24 x .625")	1
25		500365-10	Lockwasher	1
26	▶	500365-22	Flat Washer	1
27	▶	51-P-13	Shift Lever	1
28	▶	378004	Washer, Shift Lever	1
29		379639	Indicator Switch (Normally Off)	1
30	▶	34-P-74	Cover, Shifter	1
31	▶	37-P-14	Popper Spring, Shifter	1
32	▶	378002	Ball, Shifter	1

N.S. — Not Shown A.R. — As Required

Continued on next page

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Item		Part Number	Description	Quantity
33		**328836X**	Plate & Post Assembly	1
34	▶	**28-P-191**	O-Ring, Shifter Post	1
35	▶	**35-P-8**	Gasket, Shifter Cover	1
36	▶	**378430-8**	Capscrew, Hex Head (.3125"-18 x .750")	3
	▶	**378430-9**	Capscrew, Hex Head (.3125"-18 x.875")	1
37	▶	**68-P-2**	Name Plate	1
38	▶	**378422**	Drive Screw	2
			PARTS SHIPPED LOOSE	
N.S.		**328346-10X**	Cable Control Assembly (Includes 10' Cable 378441-10 & Knob 378502)	1
N.S.		**328380X**	Mounting Parts Kit, Cable Control	1
	▶	**50-P-17**	Bracket, Cable Control	1
	▶	**50-P-19**	Bracket, Swivel	1
	▶	**378019**	Pin, Pivot	1
	▶	**378326**	Nut, Hex	1
	▶	**500396-8**	Capscrew, Hex Head (.250"-20 x .50")	1
	▶	**500568-4**	Setscrew (.250"-20 x .50")	1
N.S.		**7170-2X**	Stud Kit, Standard Mount	1
N.S.		**7170-1X**	Stud Kit, Deep Mount	1
N.S.		**7170-72X**	Stud Kit, “G” Mount (Metric Studs)	1
N.S.		**328948-6X**	Mounting Gaskets and Installation Instructions	1
N.S.		**328751-1X**	Indicator Light, Installation Kit	1
N.S.		**329058X**	INSTALLATION KIT (“FE” Gear Detail Only)	1
			SERVICE ITEMS	
N.S.		**328356-59X**	Gasket & Seal Kit (Contains 8 ea. of 22-P-24-1 & 22-P-2, 4 ea. of 22-P-24-3, 1 28-P-190, 1 28-P-191, 2 28-P-216, 1 35-P-8, 1 35-P-9-1 & 1 35-P-9-2)	1
N.S.		**329218X**	Service Kit, Booted Connector (379640)	1

N.S. — Not Shown A.R. — As Required

P.T.O. Model	Input Gear	Number Teeth	Transmission Applications	Helix Angle
452*SAB	**5-P-1001**	19	Universal 5-Pitch	Spur
452*SAG	**5-P-1003**	22	Spicer 5000 & 6000 Series	Spur
452*SAH	**5-P-1004**	22	Universal 6-Pitch	Spur
452*SAP	**5-P-1006**	21	Spicer CM-4954 & D, ES-52-5A & D	Left Hand
452*SAQ	**5-P-1007**	21	Spicer Aux 7041	Left Hand
452*SAR	**5-P-1008**	21	Spicer CM60, 6000 Series	Left Hand
452*SAW	**5-P-1009**	22	New Process 541 R.H. Side	Left Hand
452*SAX	**5-P-1010**	22	L.H. Side Clark 398V & CL 558	Right Hand
452*SBA	**5-P-1011**	23	L.H. Side Navistar T-32 thru 36 & T-494 thru 496	Left Hand
452*SBC	**5-P-1012**	18	Clark 557	Left Hand
452*SBG	**5-P-1015**	23	Spicer 5000 Series & ES-60-5A,C & D	Left Hand
452*SBJ	**5-P-1017**	25	Spicer 3000 Series R.H. Side	Left Hand
452*SBL	**5-P-1019**	22	New Process 205 Transfer Case	Right Hand
452*SBM	**5-P-1020**	22	R.H. Side Clark 398V & CL 558	Left Hand
452*SBN	**5-P-1021**	22	New Process 540 R.H. Side	Left Hand
452*SBP	**5-P-1022**	26	L.H. Chev. CH-465 w/adapter 328555-1X	Right Hand
452*SBQ	**5-P-1023**	25	Chev. CH465,GMC SM465 & Spicer ES-42-5A & 5D	Left Hand
452*SBR	**5-P-1024**	26	Clark & Hino “LA”, “LB”, “LE”	Right Hand
452*SBS	**5-P-1025**	26	New Process 420 & Clark 285V	Left Hand
452*SBZ	**5-P-1028**	26	Warner T-18, T-19, T-98A	Left Hand
452*SCB	**5-P-1029**	25	New Process 435 & 4530	Left Hand
452*SCD	**5-P-1031**	27	Warner T-18’s & T-19’s	Left Hand
452*SDA	**5-P-1037**	23	Mack 2080	Spur
452*SDB	**5-P-1038**	39	Fuller T-8607A & B, T-1106, T-1107A & B	Spur
452*SDC	**5-P-1039**	19	Hino “KA”, “KB”, MFO-6S Nissan MPS-60B & TMH-464	Spur
452*SDH	**5-P-1041**	21	Renault BDSL-132R, 181, 2052R	Left Hand
452*SDK	**5-P-1043**	26	Renault BDSL-2152	Left Hand
452*SDM	**5-P-1045**	17	Clark 450 & 455	Left Hand
452*SDN	**5-P-1046**	19	Clark 457, & Fuller FS-4005C	Left Hand
452*SDQ	**5-P-1048**	20		
452*SDU	**5-P-1050**	28	Fuller FS-5506, 7206A, & 8206A	Left Hand
452*SEC	**5-P-1055**	36	Zed F, S5-42 Close Ratio	Left Hand
452*SED	**5-P-1056**	34	Zed F, S5-42 Wide Ratio	Left Hand
452*SEL	**5-P-1075**	30	Isuzu MSA-5D	Right Hand
452*SES	**5-P-1059**	22		Left Hand
452*SEV	**5-P-1060**	40	Fuller T-14607A	Spur
452*SEW	**5-P-1061**	20	Fuller FS-3005A & B & 4005	Left Hand
452*SFC	**5-P-1064**	26	NVG-4500 Dodge	Left Hand
452*SFE	**5-P-1065**	29	Getrag 360	Left Hand
452*SFM	**5-P-1069**	28	Nissan TMH-704, 762, MHS-50 & 60	Spur
452*SFN	**5-P-1070**	26	Spicer ES52-7A, ESO65-7A	Left Hand
452*SFP	**5-P-1071**	23	Renault G405, G406	Left Hand
452*SFW	**5-P-1098**	28	Fuller FSO-8206A	Left Hand
452*SGQ	**5-P-1150**	26	Tremec 199F	Left Hand
452*SGS	**5-P-1152**	29	Zed F S5-42 Wide Ratio	Left Hand
452*SJP	**5-P-1268**	33		Left Hand
452*SJU	**5-P-1316**	25		Left Hand

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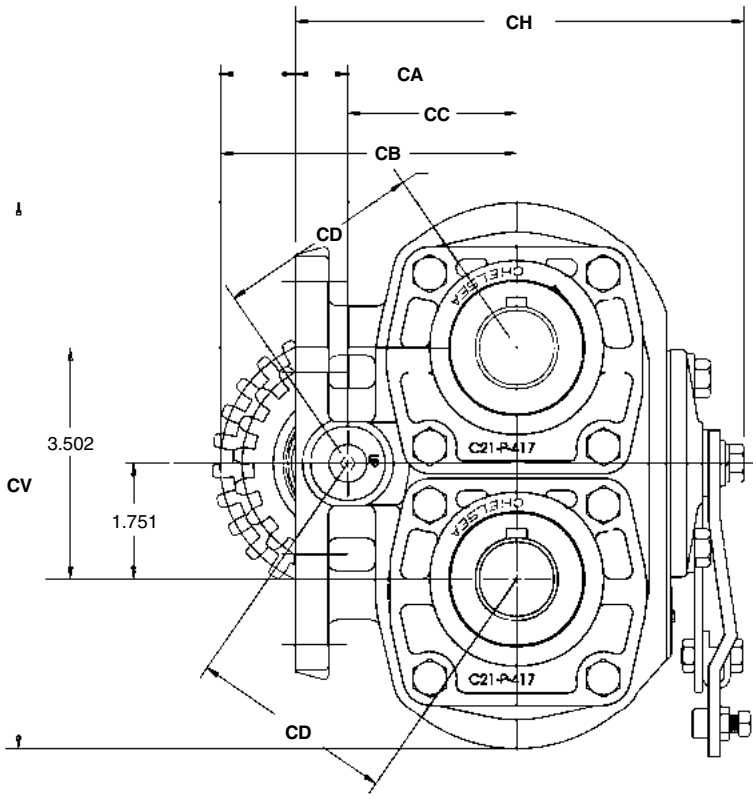
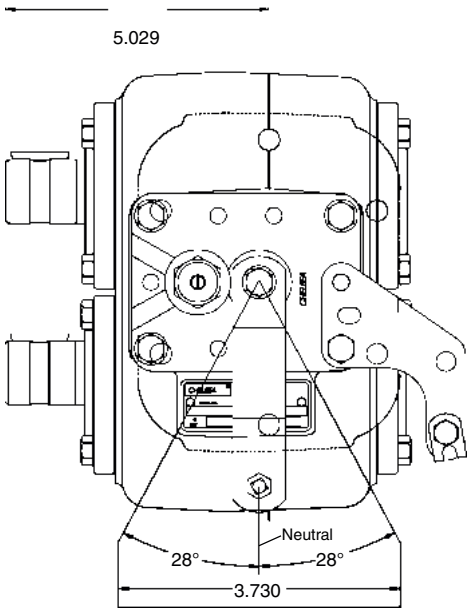


P.T.O. Series	CA	CB	CC	CD	CH	CV
Standard Mount 452X	.792	4.475	2.547	3.091/3.092	6.703	8.250
Deep Mount 452Z	.572	4.459	2.547	3.091/3.091	6.483	8.250



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Model Number Designation

452 Series

452 X S AB X – W 3 DD

Basic Model
452

Mounting Type
G = Standard Mount Metric
X = Standard Mount
Z = Deep Mount
K = Less Stud Kit Standard Mount
L = Less Stud Kit Deep Mount

Gear Ratio
S

Input Gear Designator

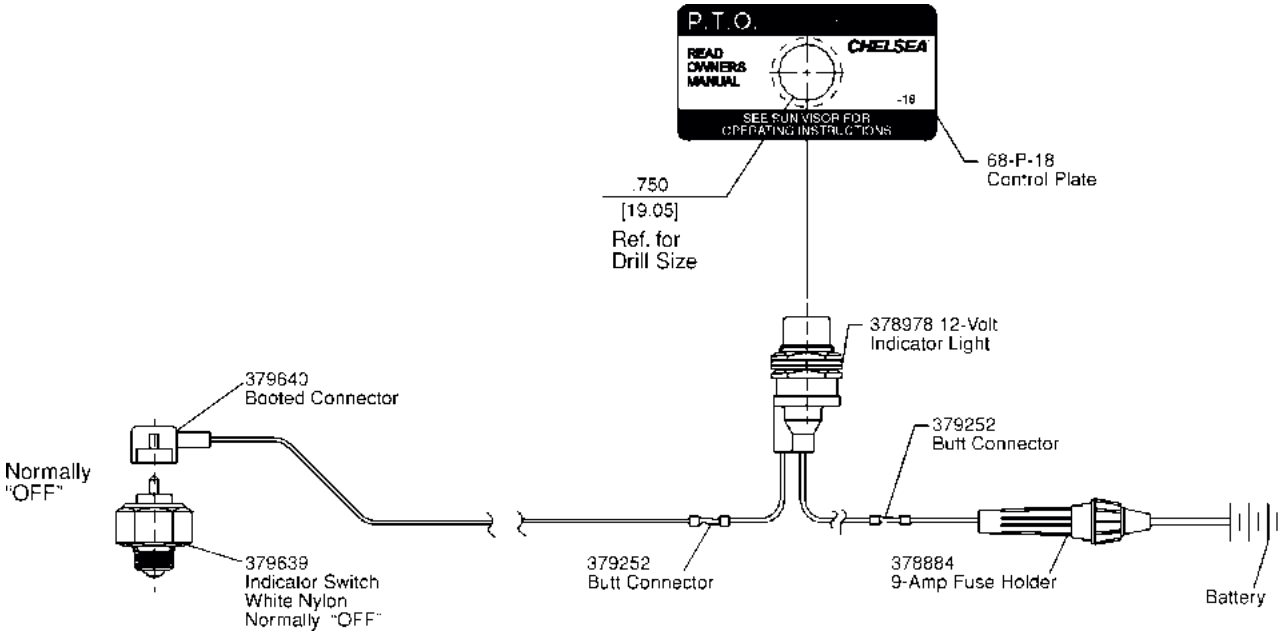
Lubrication
X = No Option Available

Output Type
DD = 1.250" Rd.

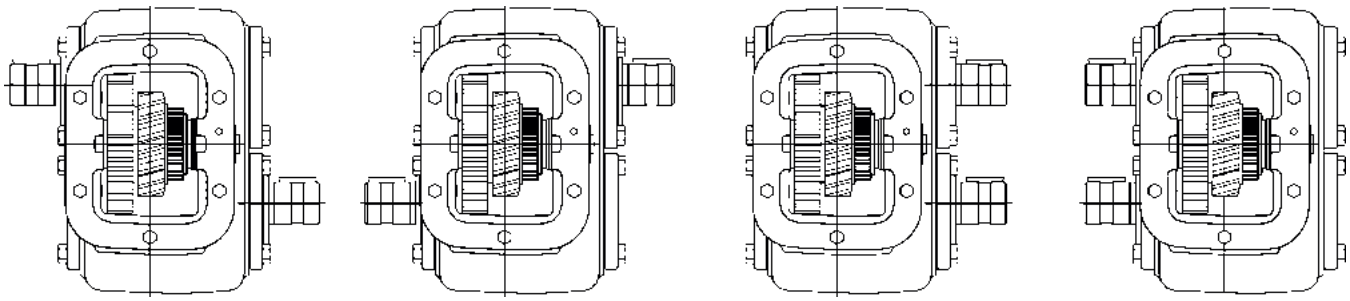
Assembly Arrangement
1, 2, 3 & 6

Shifter Type
W = Wire Control (Standard)
C = Special Control & Bracket Kit

Indicator Light Installation Sketch



Assembly Arrangements



Ass'y 1 **Ass'y 2** **Ass'y 3** **Ass'y 6**

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Notes

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(B) Except 267, 277, 278, 242, 244, 246, 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.**

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9/01-P

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- Roll off, Dump truck, garbage trucks and crane
  PTO hydraulic system

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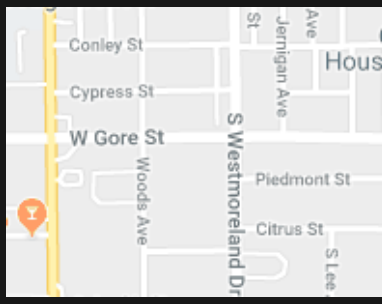

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