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# **CHELSEA<sup>®</sup>**

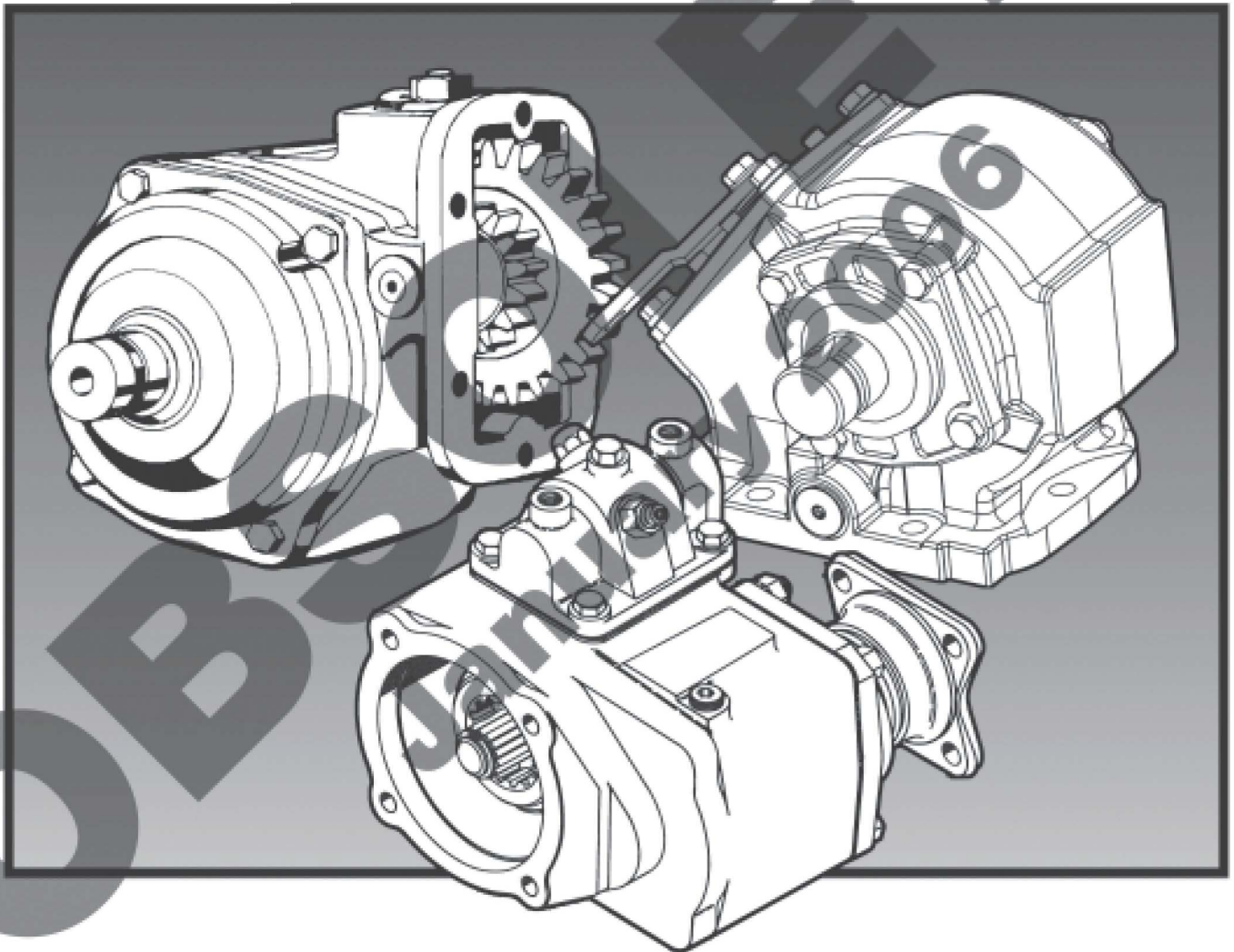
## **Replacement Parts List**

### **732 Series Manual**

Bulletin P410-732-M

March 15, 2002

Supersedes: P410-732 Dated October 1999



**Parker**

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**Orlando, FL 32805**



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 **WARNING**

FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS AND/OR SYSTEMS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.

This document and other information from Parker Hannifin Corporation, its subsidiaries and authorized distributors provide product and/or system options for further investigation by users having technical expertise. It is important that you analyze all aspects of your application and review the information concerning the product or system in the current product catalog. Due to the variety of operating conditions and applications for these products or systems, the user, through its own analysis and testing, is solely responsible for making the final selection of the products and systems and assuring that all performance, safety and warning requirements of the application are met.

The products described herein, including without limitation, product features, specifications, designs, availability and pricing, are subject to change by Parker Hannifin Corporation and its subsidiaries at any time without notice.

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Front View ..... 1

Side View ..... 2

Bill of Materials ..... 3

Lever Control ..... 4

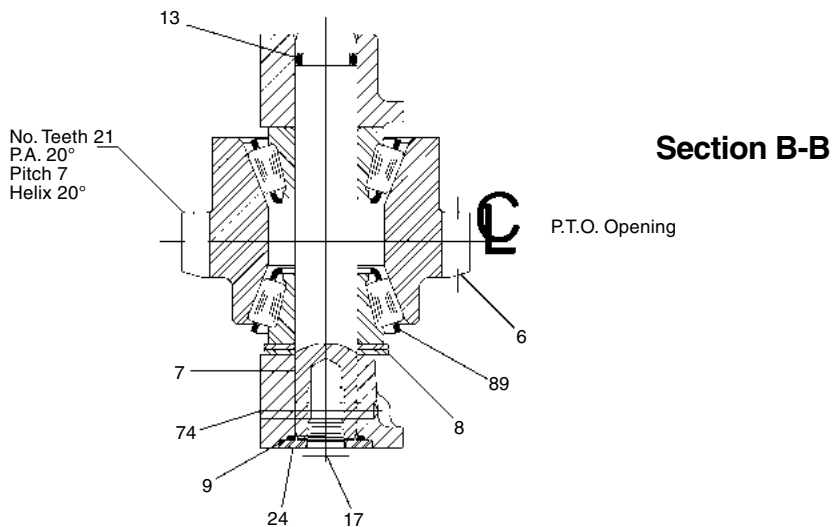
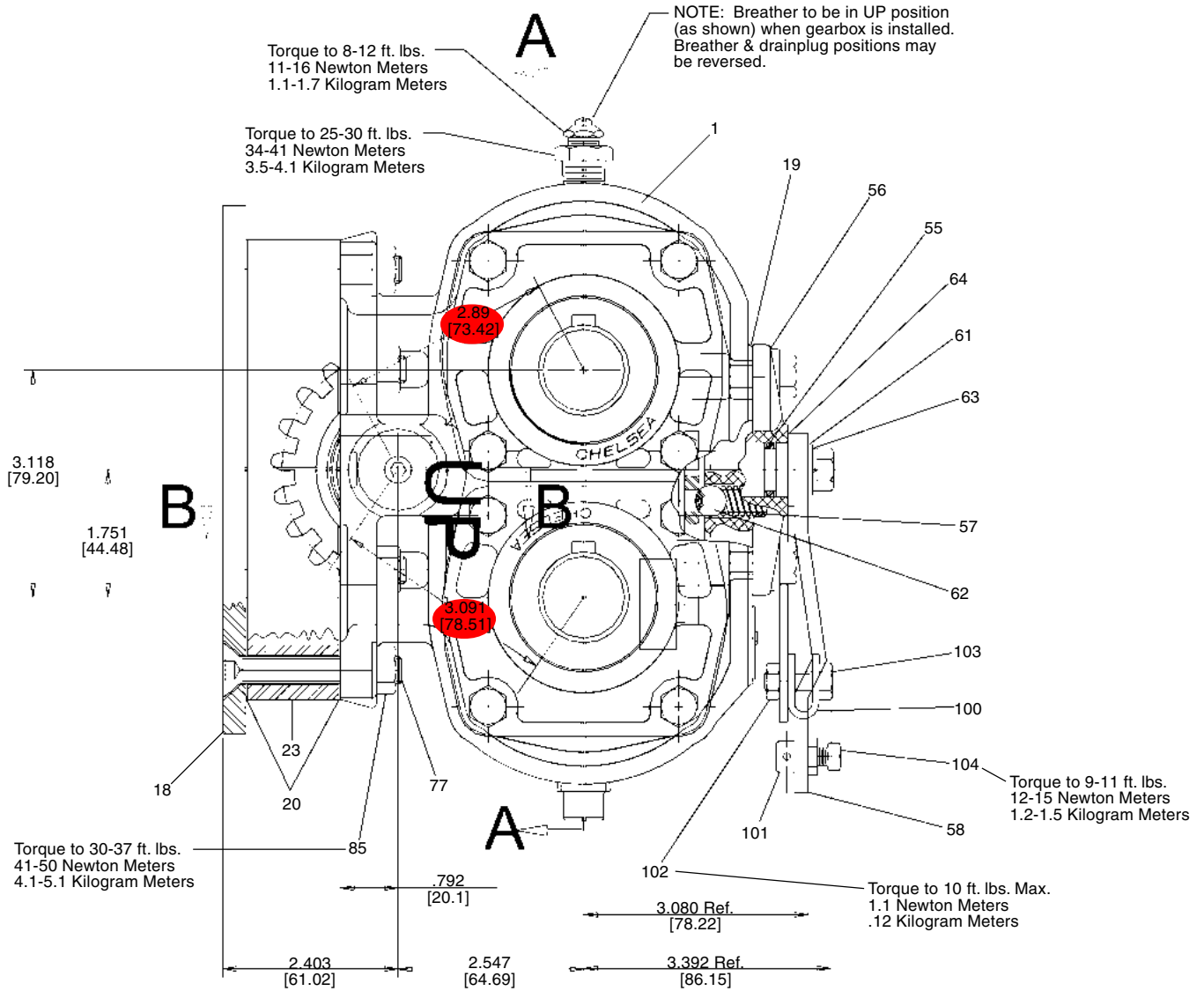
Cable Control ..... 5

Mounting Detail ..... 6

Model Number Designation ..... 7

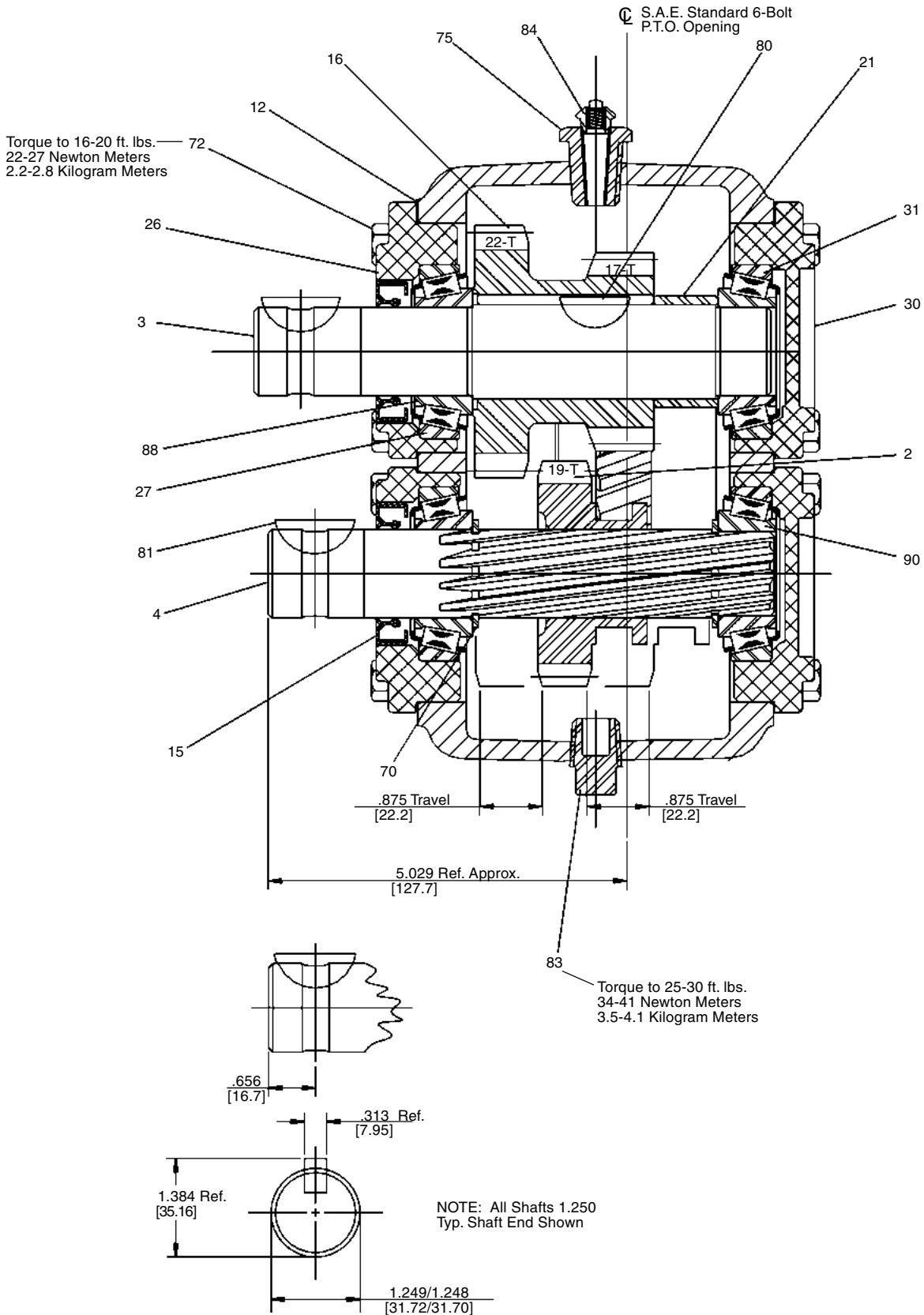
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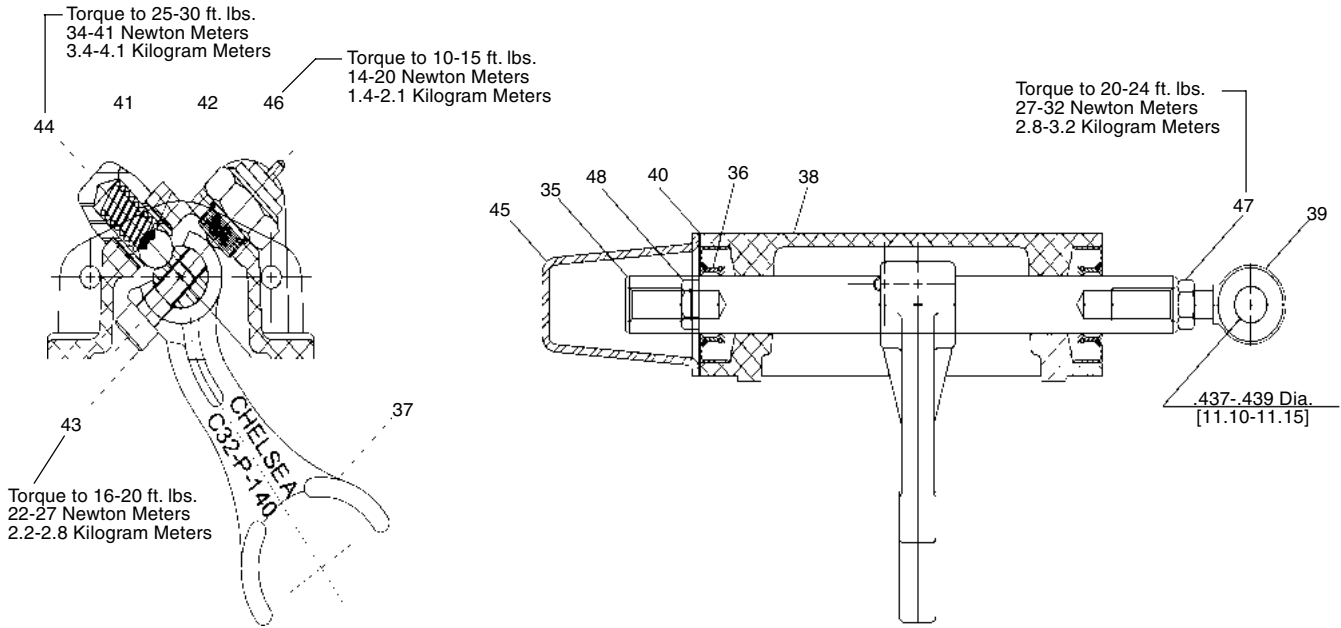
**Section A-A**

Ref. Assembly 3 Shown



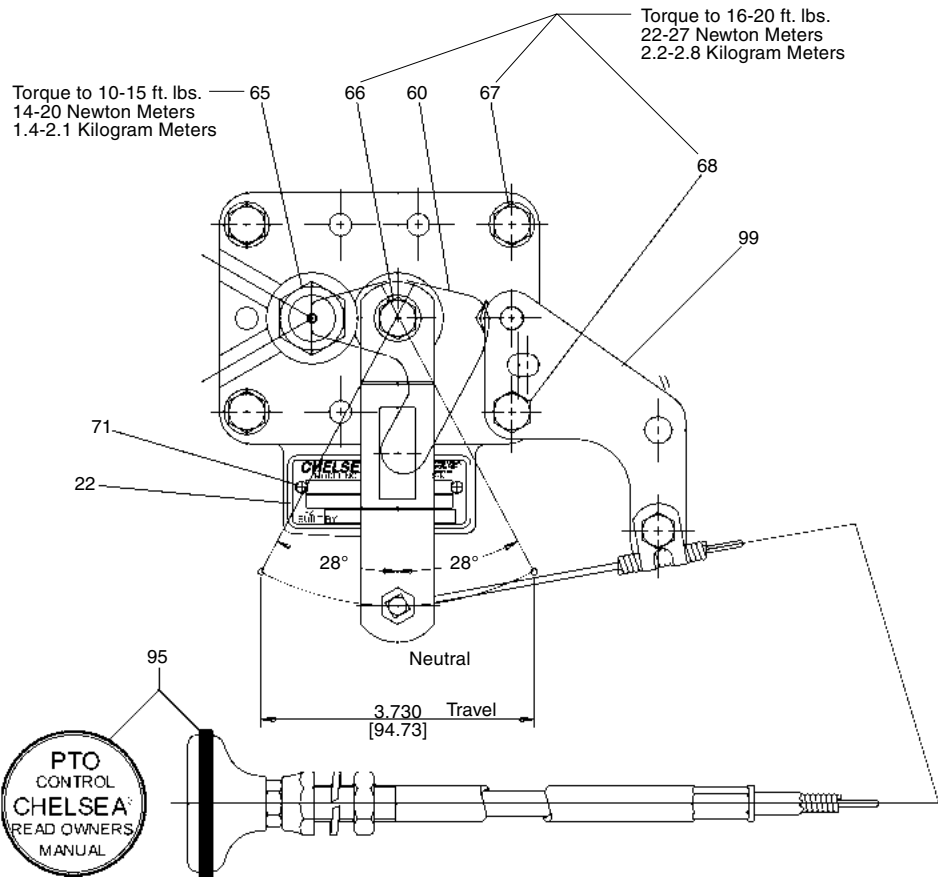
Item	Part Number	Description	Quantity
1	1-P-524	Housing, Gearbox .....	1
2	2-P-721	Gear, Sliding (19-T) .....	1
3	3-P-315	Drive Shaft STD. (1.250" Dia. Input) .....	1
4	3-P-859	Drive Shaft STD. (1.250" Dia. Output) .....	1
6	5-P-220	Gear, Idler .....	1
7	9-P-74	Shaft, Idler .....	1
8	14-P-15	Spacer, Idler Gear .....	1
9	28-P-190	O-Ring .....	1
12	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
13	28-P-191	O-Ring .....	1
15	28-P-216	Oil Seal .....	2
16	33-P-64	Gear, Reverse Idler .....	1
17	379484	O-Ring Boss Plug .....	1
18	34-P-18	Cover Plate .....	1
19	35-P-8	Gasket, Shifter Cover (.020" Thick) .....	1
20	35-P-9-2	Gasket, (.020" Thick) .....	1
21	40-P-4	Spacer, Reverse Idler Gear .....	2
22	68-P-2	Name Plate (Chelsea) .....	1
23	7-A-1250	Spacer .....	1
24	379542	Retainer O-Ring .....	1
	328273X	Bearing Cap Sub-Assembly, Open (Includes Items 26 & 27)	
26	21-P-418	Bearing Cap .....	1
27	550221	Bearing Cup .....	1
	328274X	Bearing Cap Sub-Assembly, Closed (Includes Items 30 & 31)	
30	21-P-420	Bearing Cap .....	1
31	550221	Bearing Cup .....	1
49	378430-8	Capscrew, Hex Head (.312"-18 x .75") .....	4
70	378391	Retaining Ring .....	2
71	378422	Drive Screw .....	2
72	378430-10	Capscrew, Hex Head (.312"-18 x 1.000") .....	16
74	500597-16	Roll Pin (Standard Mount) .....	1
75	379131-4	Reducer Bushing .....	1
77	379212-2	Capscrew, Flat Head Hex Socket (.375"-16 x 2.500") (with Patch) .....	6
78	379334	Oil Level Caution Tag (Ship Wired to Unit) .....	1
80	500007-24	Woodruff Key (Ref. Input Shaft) .....	1
81	500007-29	Woodruff Key (.312" x 1.125") .....	2
83	500114-3	Pipe Plug (.500"-14) .....	1
84	500167-1	Pressure Relief Fitting .....	1
85	500370-3	Nut, Hex (.375"-16) .....	6
88	550397	Bearing Cone, Tapered .....	3
90	550532	Bearing Cone, Tapered .....	1
	328380X	Wire Control Parts Bag (Includes Items 99 thru 104)	
99	50-P-17	Bracket .....	1
100	50-P-19	Bracket, Swivel .....	1
101	378019	Pivot Pin .....	1
102	378326	Nut, Hex Bushing .....	1
103	500396-8	Screw, Hex Head (.250"-20 x .750") .....	1
104	500568-4	Set Screw, Square Head (.250"-20 x .500") .....	1
	328751X	Installation Kit, Wire or Lever Control .....	1

A.R. — As Required

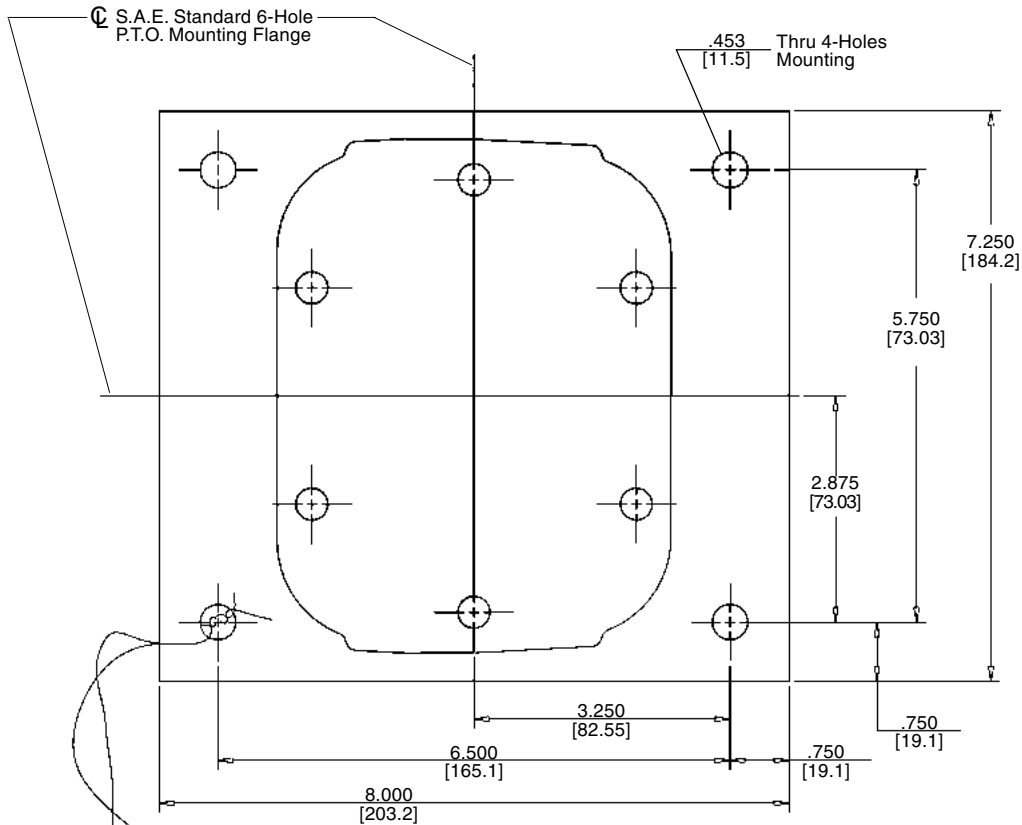


Item	Part Number	Description	Quantity
	<b>328825-1X</b>	<b>LEVER CONTROL ASSEMBLY (Includes Items 35-48)</b>	
35	<b>11-P-129</b>	Shaft, Shifter .....	1
36	<b>28-P-207</b>	Oil Seal .....	2
37	<b>32-P-141</b>	Shifter Fork .....	1
38	<b>34-P-82</b>	Cover, Shifter .....	1
39	<b>36-P-1</b>	Eye Bolt (.375"-24) .....	1
40	<b>35-P-14</b>	Gasket .....	1
41	<b>37-P-14</b>	Spring .....	1
42	<b>378002</b>	Ball/Poppet .....	1
43	<b>378447-4</b>	Capscrew, Socket Head (.312"-18 x .75") .....	1
44	<b>378554</b>	Cap, Poppet .....	1
45	<b>65-P-23</b>	Cover, Shifter Shaft .....	1
46	<b>379652</b>	Indicator Switch (Norm "ON") .....	1
47	<b>500381-3</b>	Nut, Hex (.375"-24) .....	1
48	<b>378430-4</b>	Capscrew, Hex Head .....	2





Item	Part Number	Description	Quantity
	<b>328830-1X</b>	<b>WIRE CONTROL SHIFT COVER SUB-ASSEMBLY</b> (Included Items 55 thru 66)	1
55	<b>28-P-191</b>	O-Ring .....	1
56	<b>34-P-74</b>	Cover, Shifter .....	1
57	<b>37-P-14</b>	Spring, Poppet .....	1
58	<b>51-P-13</b>	Lever, Shifter .....	1
60	<b>328829-1X</b>	Plate Assembly, Shifter .....	1
61	<b>500365-22</b>	Washer, Flat .....	1
62	<b>378002</b>	Ball (.438" Dia.) .....	1
63	<b>500356-10</b>	Lockwasher .....	1
64	<b>378004</b>	Washer, Flat .....	1
65	<b>379652</b>	Indicator Switch (Norm "ON") .....	1
66	<b>500409-6</b>	Capscrew, Hex Head (.312"-18 x .625") .....	1
67	<b>378430-8</b>	Capscrew, Hex Head (.312"-18 x .750") .....	3
68	<b>378430-9</b>	Capscrew, Hex Head (.312"-18 x .875") .....	1
95	<b>328346-10X</b>	Cable Control Assembly .....	1
	<b>328380X</b>	Parts Bag, Wire Control .....	1



**CAUTION**

THIS UNIT IS SHIPPED WITHOUT LUBRICANT. MUST BE FILLED WITH LUBE BEFORE OPERATION. SEE REVERSE SIDE FOR APPROPRIATE AMOUNT AND TYPE OF LUBE.

**CAUTION AFTER FILLING**

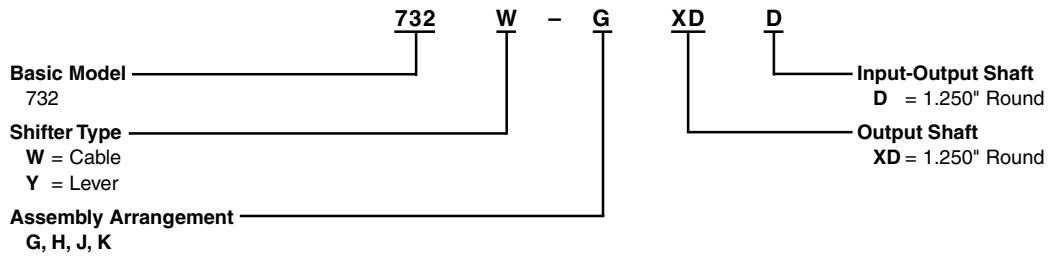
**VERIFY OIL LEVEL**

**CHELSEA®**

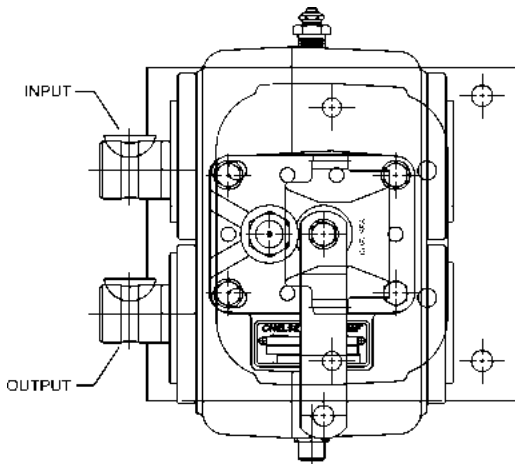
Parker Hannifin Corporation  
 Chelsea Products Division  
 8225 Hacks Cross Road  
 Olive Branch, MS 38654 USA

**(SEE REVERSE SIDE)**  
 379334

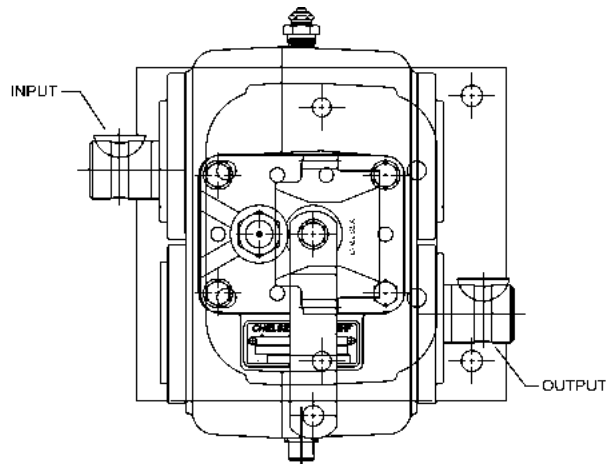
78  
 NOTE: Wire to Assembled Unit at Shipping



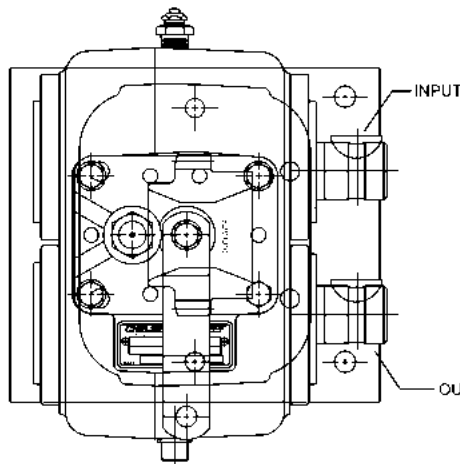
**Assembly Arrangements**



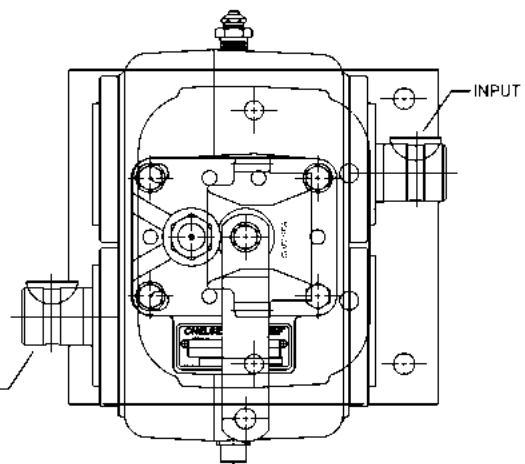
**Ass'y G**



**Ass'y H**



**Ass'y J**



**Ass'y K**

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have the right to alter, discard or otherwise dispose of any special tooling or other property in its sole discretion at any time.

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**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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9/01-P

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