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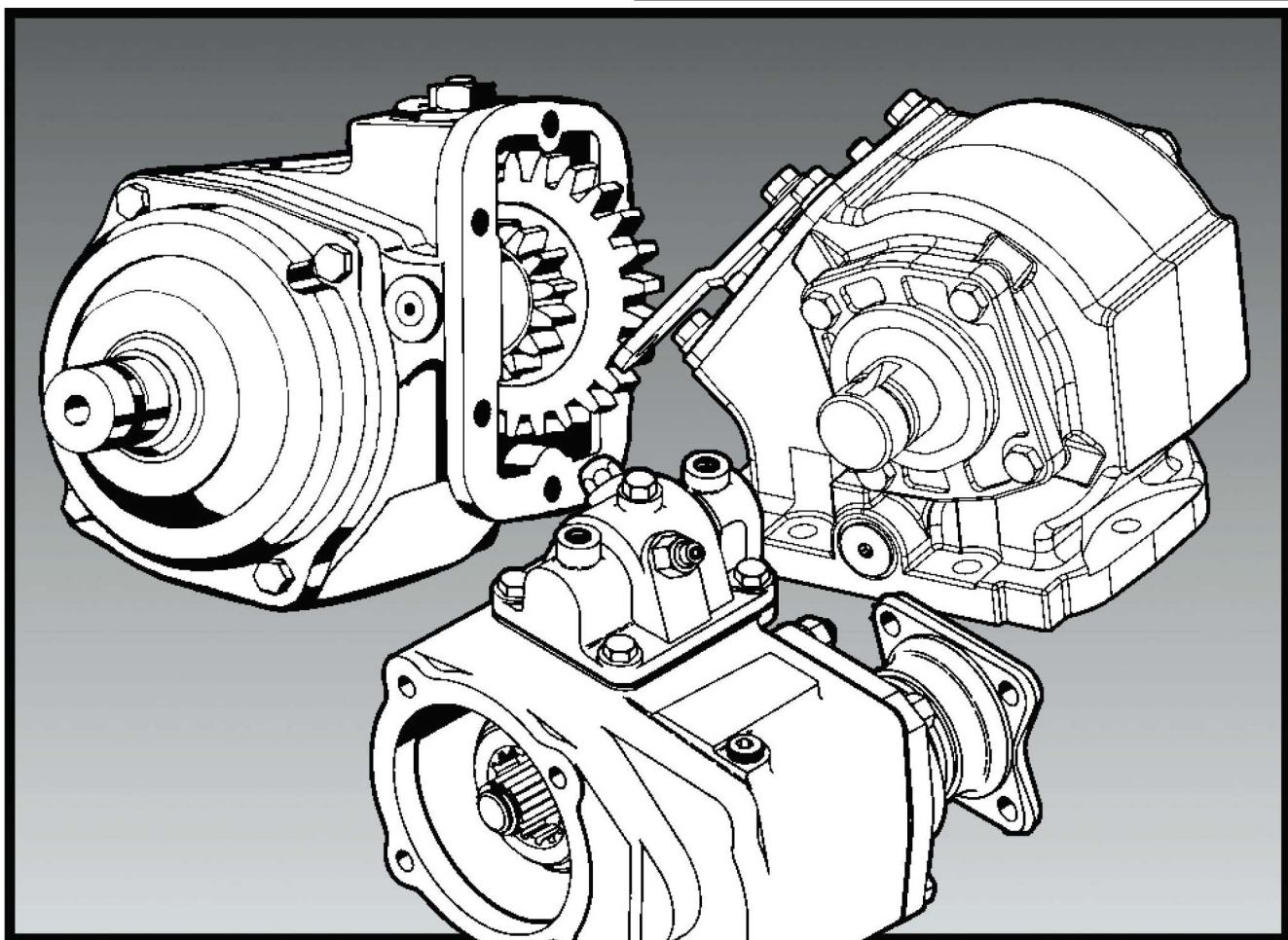
CHELSEA[®]

Replacement Parts List

812 Series Manual

Bulletin HY25-2812-M1/US

Effective: March 15, 2002
Supersedes: P410-812 Dated March 1996



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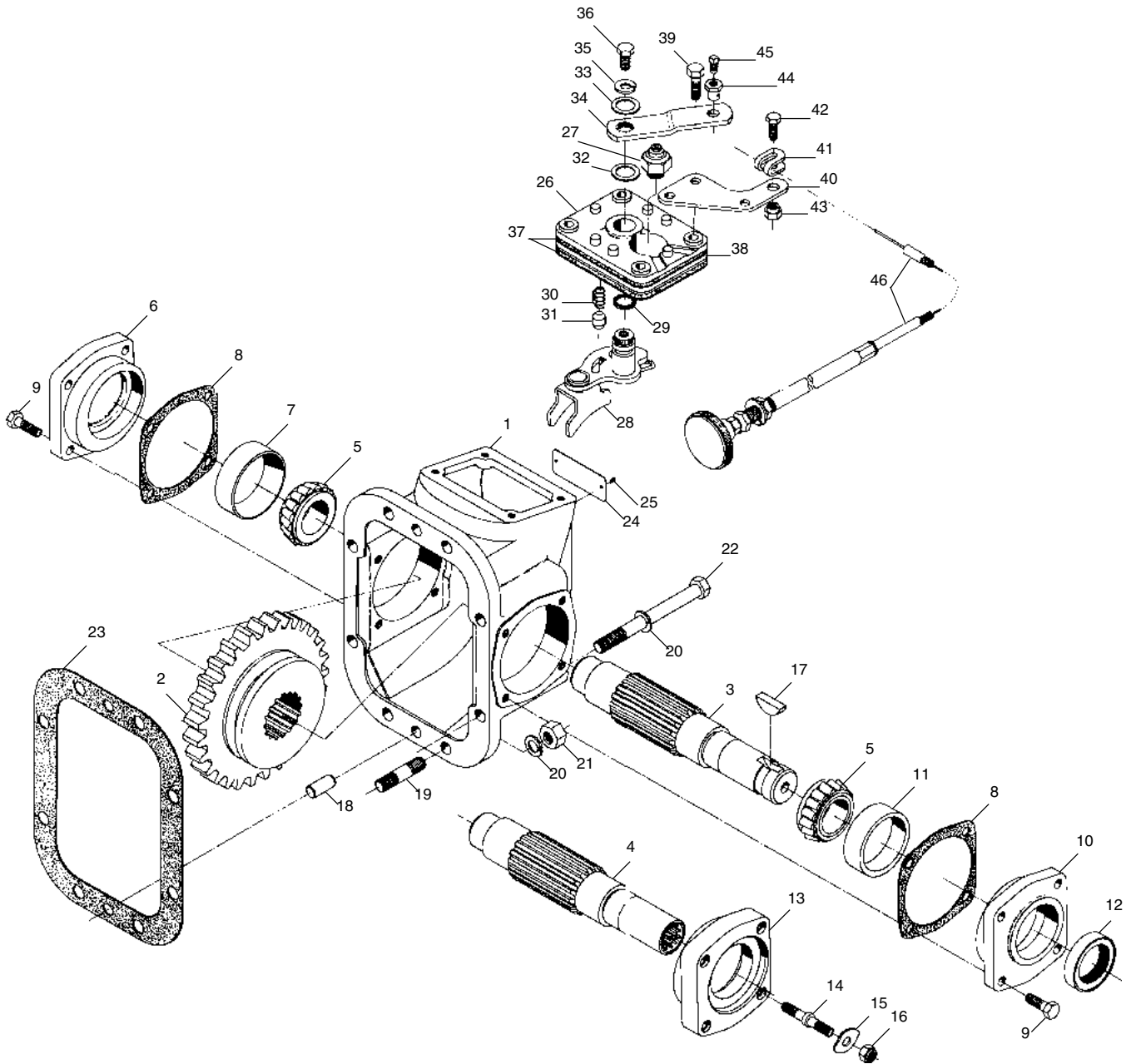
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Bill of Materials

Item	Part Number	Description	Quantity
1	1-P-356	Housing, Standard Mount 1 Housing, Deep Mount (Use standard housing and rotate both bearing covers (items 6 & 10) 180° to increase depth by .380")	1
2	See Chart Pg. 3	Drive Gear 1	1
3	See Chart Pg. 3	Drive Shaft 1	1
4	See Chart Pg. 3	Pump Shaft 1	1
5	550397	Cone, Tapered Bearing 2	2
	560970	Cone, Tapered Bearing ("XY" Output)	
6	328274X	Bearing Cap Assembly, Closed End (Includes Race 550221) 1	1
7	550221	Bearing Race 1	1
8	22-P-24-1	Gasket, Bearing Cap (.010" Thickness) A.R.	A.R.
	22-P-24-2	Gasket, Bearing Cap (.020" Thickness) A.R.	A.R.
	22-P-24-3	Gasket, Bearing Cap (.015" Thickness) A.R.	A.R.
9	378430-10	Screw, Hex head Self Locking (.312" - 18 x 1") 8	8
10	328273X	Bearing Cap Assembly, Open End (Includes Race 550221) 1	1
11	550221	Bearing Race 1	1
12	28-P-216	Oil Seal 1	1
13	See Chart Pg. 3	Pump Flanges 1	1
14	379673	Stud, Mounting (For Ass'y "R") 4	4
	328711X	Pump to P.T.O. Mounting, (For Ass'y "R") (Includes Items 15 & 16) 1	1
15	378919	Washer, Special (For Ass'y "R") 4	4
16	500963-1	Nut, Hex Head Self Locking (.312" - 24) (For Ass'y "R") 4	4
17	500007-29	Woodruff Key 1	1
	328170-115X	P.T.O. Mounting Kit 1	1
18	378054	Dowel Pin (.438 x 1.000) 2	2
19	379424-19	Stud (.437" - 14 & 20 x 2.250") 4	4
20	500357-12	Lockwasher (.437") 8	8
21	500371-4	Nut (.437" - 20)" 4	4
22	379287-33	Screw (.437" - 14 x 4.750") Hex Head 4	4
N.S.	379224	Tab Lockwasher 8	8
23	35-P-15-1	Gasket, Mounting (.010" Thickness) A.R.	A.R.
	35-P-15-2	Gasket, Mounting (.020" Thickness) A.R.	A.R.
24	68-P-2	Nameplate 1	1
25	378422	Screw 2	2
	328804-1X	Cover Assembly 1	1
	328804-2X	Wire Control Shifter, Ass'y. 3 & 6 (Includes Items 26-36) 1	1
26	34-P-75	Wire Control Shifter, Ass'y. 4 & 5 (Includes Items 26-36) 1	1
27	379639	Cover, Shifter 1	1
28	328803-1X	Indicator Switch 1	1
	328803-2X	Plate & Post Shifter Assembly, (Ass'y. 3 & 6) 1 (Includes 500603-14 Spring Pin N/S)	1
		Plate & Post Shifter Assembly, (Ass'y. 4 & 5) (Includes 500603-14 Spring Pin N/S) 1	1
29	28-P-191	O-Ring 1	1
30	37-P-19	Spring, Poppet Ball 1	1
31	63-P-16	Ball, Poppet 1	1
32	378004	Washer, Flat 1	1
33	500365-22	Washer, Flat 1	1
34	51-P-22	Shift Lever 1	1
35	500356-10	Lock Washer 1	1
36	500409-6	Screw, Hex head (.312"-24 x .625") 1	1
37	35-P-8	Gasket, Shifter 1 or	1 or
	35-P-8	Gasket, Shifter (Wire Shift Only) 2	2
38	5-A-125	Spacer, (.062") (KAL Only) 1	1
	5-A-188	Spacer, (.188) (See Chart Page 3) 1	1
39	378430-10	Screw, Hex Head (.312"-18 x 1") (Wire Shift Only) 4 or	4 or
	378430-8	Screw, Hex Head (.312"-18 x .750") 4	4

N.S. — Not Shown A.R. — As Required

Continued on next page

Item	Part Number	Description	Quantity
	328380X	Loose Parts	
		Parts Kit, Cable Control Mounting (Includes Items 40-45)	1
40	50-P-17	Bracket, Control	1
41	50-P-19	Clip, Swivel	1
42	500396-8	Screw, Hex Head (.250" - 20 x .750")	1
43	378326	Nut, Hex (.250" - 20)	1
44	378019	Pin, Pivot	1
45	500568-4	Set Screw, Square Head (.250" -20 x .500")	1
46	328346-10X	Control Wires, ASSEMBLY	1
		(Includes One Each 378502 Knob and 378441-10, 10' Cable)	
	328948-8X	Gasket & Installation Instructions	1
	328751X	Lever or Wire Shift Kit	1
		Service Kits	
	328356-48X	Gasket & Seal Kit	
	328356-15X	Gasket & Seal Kit, Cable	
	328356-18X	Gasket & Seal Kit, Lever	
	328356-19X	Gasket & Seal Kit, Air	

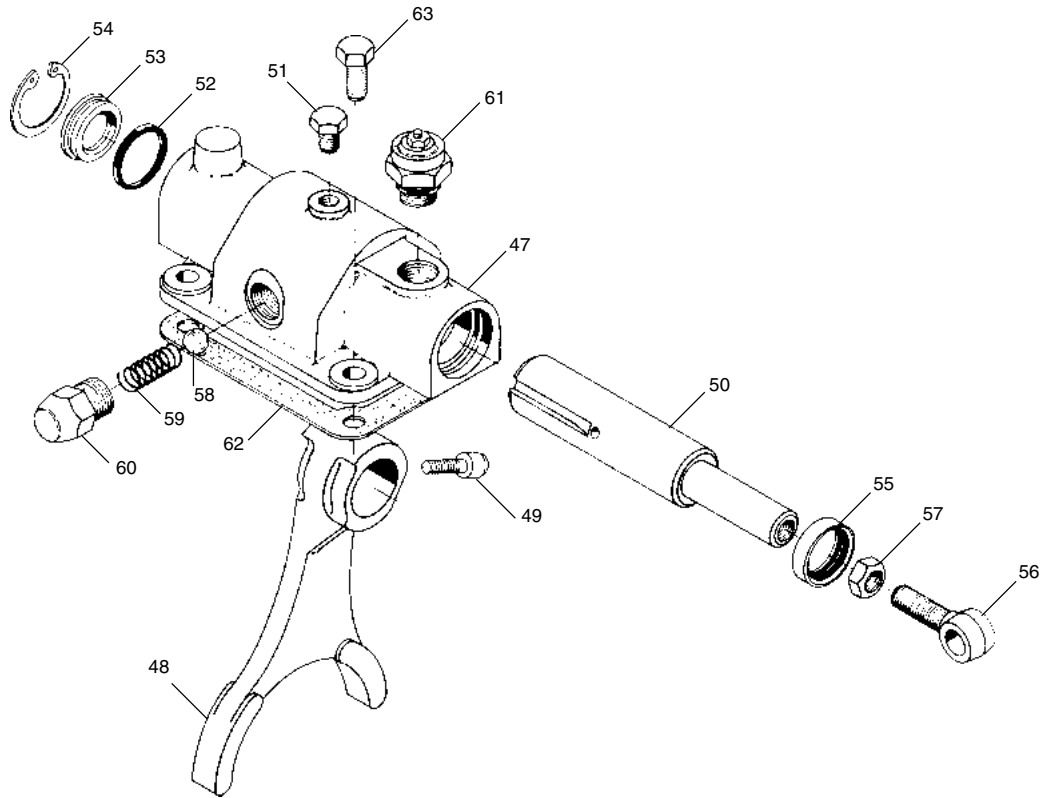
Gear & Shaft Chart

	Drive Gear		Output Shaft Item # 4					Spacer Item 38
	Input Gear Item #2	Helix Angle	XD	XR,RA, RB	XY	AK	XX	
812*KAH	2-P-509	SPUR	3-P-706	3-P-708	3-P-824	3-P-837	3-P-765	5-A-188
812*KBG	2-P-510	LH	3-P-707	3-P-709		3-P-842		5-A-188
812*KAR	2-P-511	LH	3-P-711	3-P-714				5-A-188
812*KAB	2-P-517	SPUR	3-P-706	3-P-708	3-P-824	3-P-837	3-P-765	5-A-188
812*KAL	2-P-533	SPUR	3-P-706	3-P-708	3-P-824	3-P-837	3-P-765	5-A-125
812*KDA	2-P-621	SPUR	3-P-706	3-P-708	3-P-824	3-P-837	3-P-765	5-A-188
812*KDB	2-P-598	SPUR	3-P-706	3-P-708	3-P-824	3-P-837	3-P-765	5-A-188

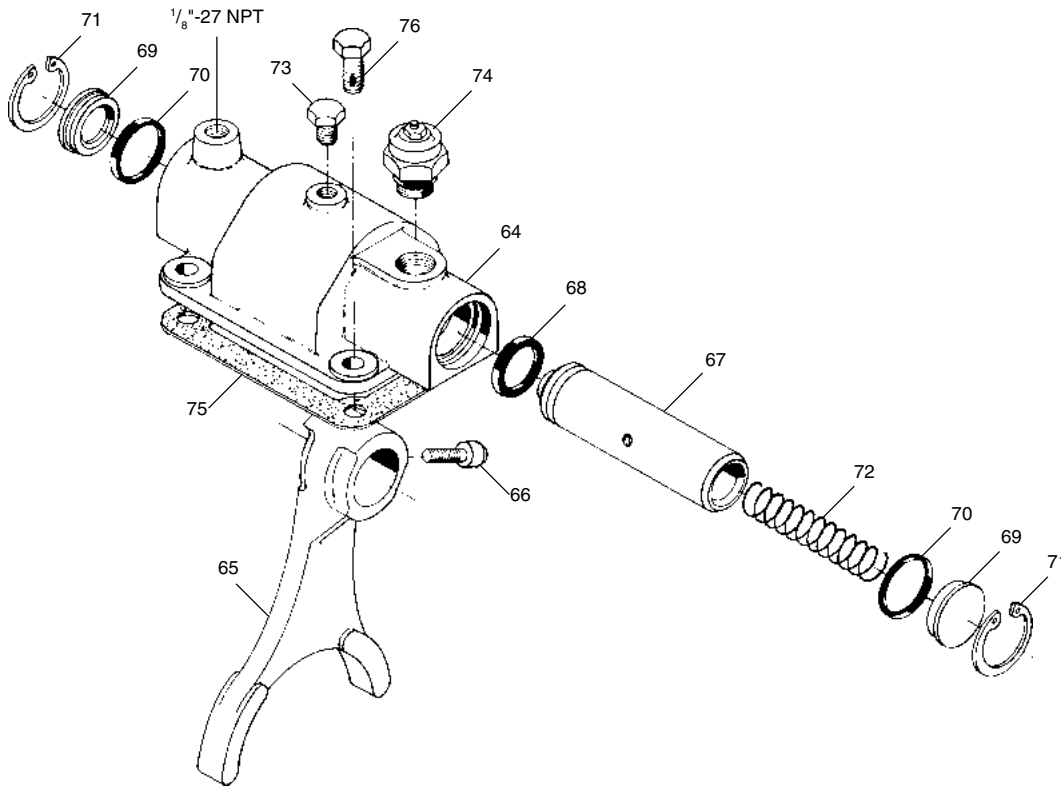
Flange Chart & Conversion Kits

	AK	RA (1)(3)	RB (2)(3)	XR	XY	XX
812*KAH	329010X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-54X (XR to RB) 328591-66X (XD to RB)	328591-64X	328981X	328273X
812*KBG	329101X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-54X (XR to RB) 328591-66X (XD to RB)	328591-64X		
812*KAR		328591-53X (XR to RA) 328591-65X (XD to RA)	328591-66X (XD to RB) 328591-54X (XR to RB)	328591-64X		
812*KAB	329010X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-66X (XD to RB) 328591-54X (XR to RB)	328591-64X	328981X	328273X
812*KAL	329010X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-66X (XD to RB) 328591-54X (XR to RB)	328591-64X	328981X	328273X
812*KDA	329010X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-66X (XD to RB) 328591-54X (XR to RB)	328591-64X	328981X	328273X
812*KDB	329010X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-66X (XD to RB) 328591-54X (XR to RB)	328591-64X	328981X	328273X

- 1 Pump Flange (21-P-628) Shipped Loose with Unit.
- 2 Pump Flange (21-P-572) Shipped Loose with Unit.
- 3 Requires seven 378447-6 socket head capscrews; four to fasten the flange assembly 329195X to the housing and three to the rotatable flange assembly.



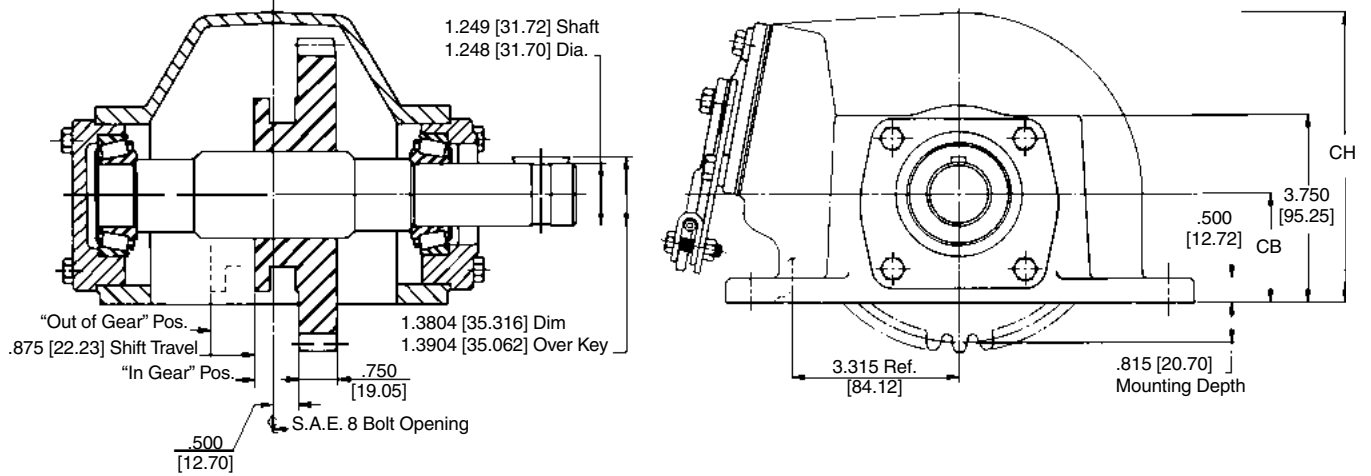
Item	Part Number	Description	Quantity
	328752X	Lever Control Cover Assembly (Includes Items 47-61).....	1
47	34-P-60	Cover, Shifter	1
48	32-P-133	Shift Fork.....	1
49	378447-4	Screw, Hex Socket Head (.312" - 18 x .750")	1
50	11-P-117	Shaft, Shifter	1
51	379123	Screw, Hex Head (.312" - 24 x .375").....	1
52	28-P-42	O-Ring	1
53	378315	Plug, Cover	1
54	378316	Snap Ring	1
55	28-P-229	Oil Seal	1
56	36-P-1	Eye Bolt.....	1
57	500381-3	Nut, Hex (.375" - 24)	1
58	378002	Ball, Poppet.....	1
59	37-P-14	Spring, Poppet Ball	1
60	378554	Cap.....	1
61	379639	Switch, Indicator	1
62	35-P-8	Gasket, Shifter Cover	1
63	378430-8	Screw, Hex Head (.312"-18 x .750")	4



Item	Part Number	Description	Quantity
	328753X	Air Shift Cover Assembly (Includes Items 64-74)	1
64	34-P-115	Cover, Shifter	1
65	32-P-133	Shift Fork	1
66	378447-4	Screw, Hex Socket Head (.312" - 18 x .750")	1
67	11-P-75	Shaft, Piston	1
68	28-P-41	O-Ring	1
69	378315	Plug, Cover	2
70	28-P-42	O-Ring	2
71	378316	Snap Ring	2
72	37-P-21	Spring	1
73	379123	Screw, Hex Head Cap (.312" - 24 x .375")	1
74	379639	Switch, Indicator	1
75	35-P-8	Gasket, Shifter Cover	1
76	378430-8	Screw, Hex Head (.312" - 18 x .750")	4
	328388-37X	Installation Kit, Air Shift	1
	328388-47X	Installation Kit, 12 Volt Electric over Air	1
	328388-48X	Installation Kit, 24 Volt Electric over Air	1
		Air Shift Conversion Kit	
		Air-o-matic	
	328390-90X	Wire to Air, All Assemblies	1
	328390-89X	Lever to Air, All Assemblies	1
	328390-113X	Wire to 12 Volt Electric over Air	1
	328390-114X	Wire to 24 Volt Electric over Air	1
	328390-111X	Lever to 12 Volt Electric over Air	1
	328390-112X	Lever to 24 Volt Electric over Air	1

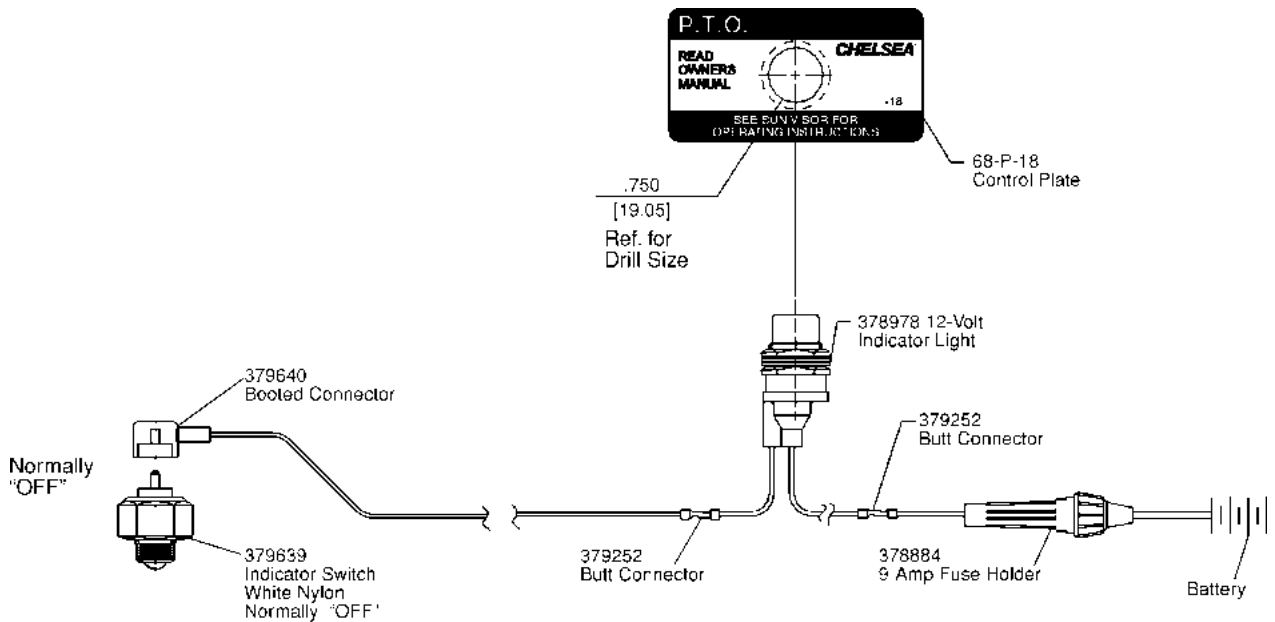
Basic Model 812

CB	Face of Case to Center Line of Output Shaft Hole	2.188"
CH	Face of Case to Extreme Horizontal Edge of Case — Clearance	5.813"



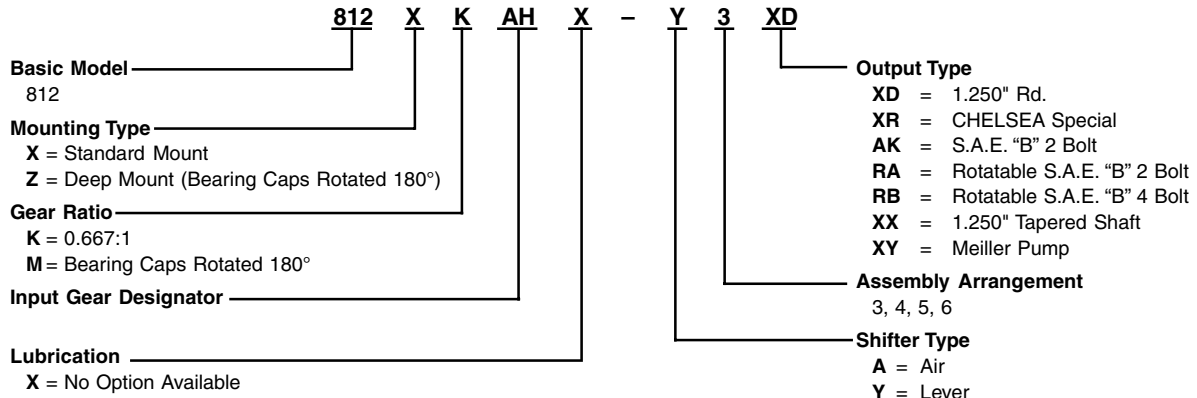
Metric Dimensions in Millimeters Given in Brackets

**Cable & Lever Control Indicator Light Installation Sketch
 328751-1X**

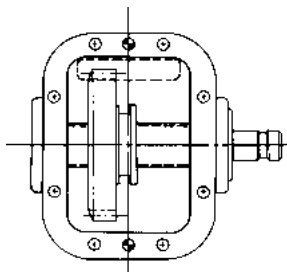


Model Number Designation

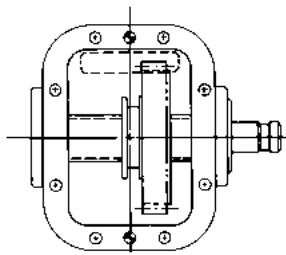
**Power Take-Off
812 Series**



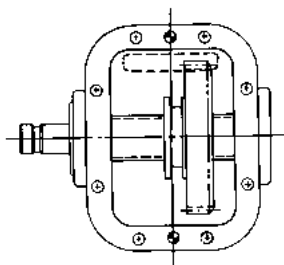
Assembly Arrangements



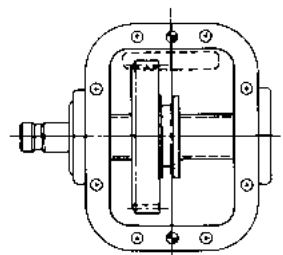
Assembly 3



Assembly 4



Assembly 5



Assembly 6

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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, 245, 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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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 thereto. 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.

9/01-P

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