



Chelsea PTO 252 Owner's Manual

Pro Gear Chelsea 252 Series PTO owners manual to assist in identifying the parts for your Chelsea Power Take Off unit.

If you need any assistance identifying the correct Power Take Off unit for your truck and equipment, contact your Chelsea replacement part specialists at Pro Gear and Transmission.

Pro Gear stocks every part for your Parker Chelsea PTO including: PTO housings, mounts, driveshafts, gears, bearings, gaskets, cable shift cover assembly, post and plate assembly, brackets, stud kits, seal kits, lever control assembly, air shift cover assembly, direct mount pump conversion kits, stud kits including English and metric references, CAT D&H parts and much more.

Pro Gear Transmission has same day shipping and 1000's of products in stock and ready to ship internationally for your next project.

For parts or service contact the Chelsea specialists at Pro Gear & Transmission, Inc.

1 (877) 776-4600
(407) 872-1901
parts@eprogear.com



[CLICK TO RETURN TO SITE](#)

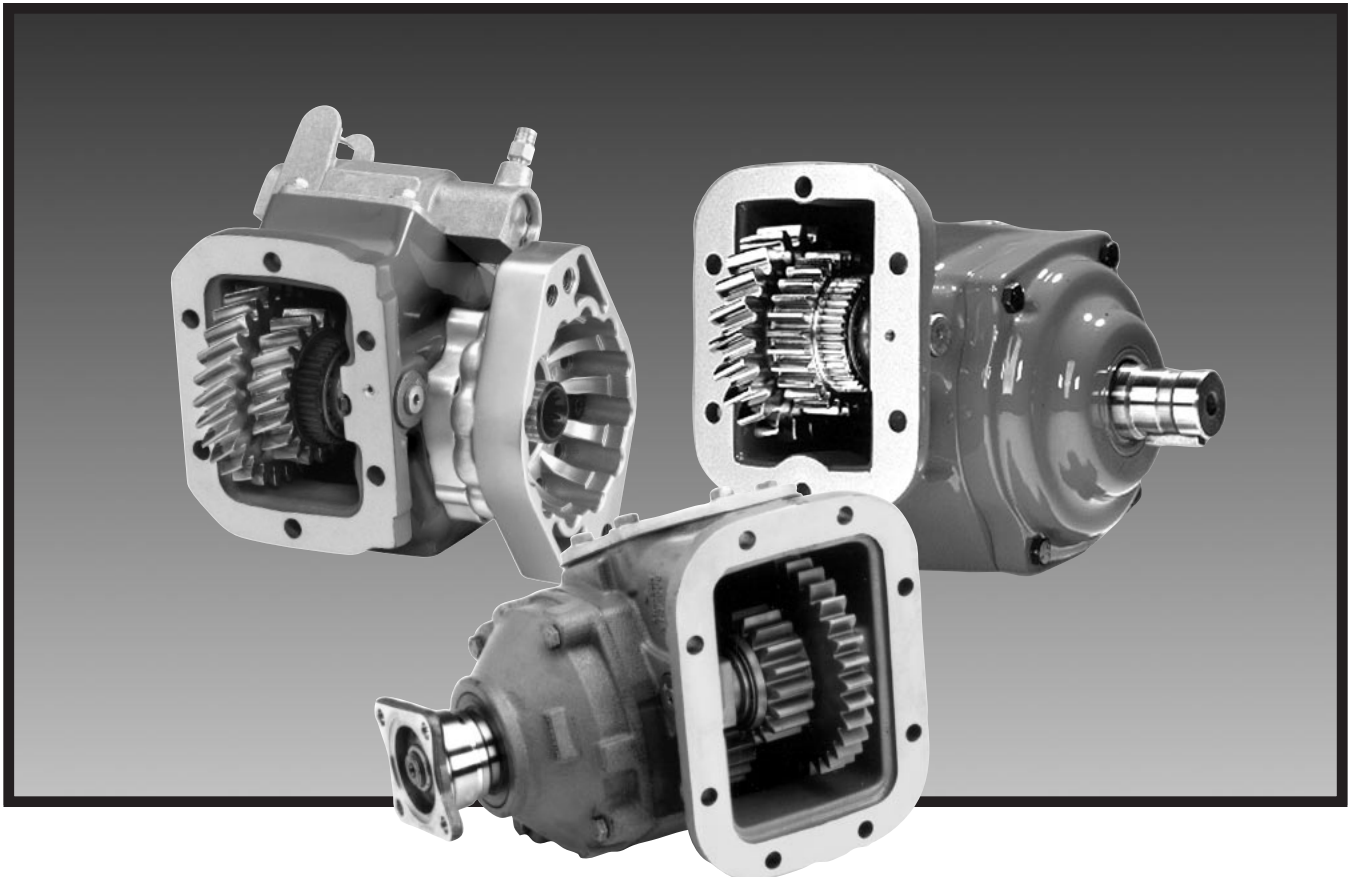
CHELSEA®

Bulletin HY25-1806-M1/US

Owner's Manual Power Take-Offs

Effective: April 2009
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252 Series





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.

Offer of Sale

The items described in this document are hereby offered for sale by Parker Hannifin Corporation, its subsidiaries or its authorized distributors. This offer and its acceptance are governed by the provisions stated in the "Offer of Sale".

Patent Information

The Chelsea® Power Take-Off or its components shipped with this owner's manual may be manufactured under one or more of the following U.S. patents:

4610175 5228355 4597301 5645363 6151975 6142274 6260682 7159701 B2
Other patents pending.

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This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There is no text or other markings on the paper.

Safety Information

These instructions are for your safety and the safety of the end user. Read them carefully until you understand them.

General Safety Information

To prevent injury to yourself and/or damage to the equipment:

- Read carefully all owner's manuals, service manuals, and/or other instructions.
- Always follow proper procedures, and use proper tools and safety equipment.
- Be sure to receive proper training.
- Never work alone while under a vehicle or while repairing or maintaining equipment.
- Always use proper components in applications for which they are approved.
- Be sure to assemble components properly.
- Never use worn-out or damaged components.
- Always block any raised or moving device that may injure a person working on or under a vehicle.
- Never operate the controls of the Power Take-Off or other driven equipment from any position that could result in getting caught in the moving machinery.

Proper Matching of P.T.O.



WARNING: A Power Take-Off must be properly matched to the vehicle transmission and to the auxiliary equipment being powered. An improperly matched Power Take-Off could cause severe damage to the vehicle transmission, the auxiliary driveshaft, and/or the auxiliary equipment being powered. Damaged components or equipment could malfunction causing serious personal injury to the vehicle operator or to others nearby.

To avoid personal injury and/or equipment damage:

- Always refer to Chelsea catalogs, literature, and owner's manuals and follow Chelsea recommendations when selecting, installing, repairing, or operating a Power Take-Off.
- Never attempt to use a Power Take-Off not specifically recommended by Chelsea for the vehicle transmission.
- Always match the Power Take-Off's specified output capabilities to the requirements of the equipment to be powered.
- Never use a Power Take-Off whose range of speed could exceed the maximum safe speed of the equipment to be powered.

Cold Weather Operation of Powershift P.T.O.



WARNING: During extreme cold weather operation [32°F (0°C) and lower], a disengaged powershift Power Take-Off can momentarily transmit high torque that will cause unexpected output shaft rotation. This is caused by the high viscosity of the transmission oil when it is extremely cold. As slippage occurs between the Power Take-Off clutch plates, the oil will rapidly heat up and the viscous drag will quickly decrease.

The Power Take-Off output shaft rotation could cause unexpected movement of the driven equipment resulting in serious personal injury, death or equipment damage.

To avoid personal injury and/or equipment damage:

- Driven equipment must have separate controls.
- The driven equipment must be left in the disengaged position when not in operation.
- Do not operate the driven equipment until the vehicle is allowed to warm up.



This symbol warns of possible personal injury.

Safety Information

Rotating Auxiliary Driveshafts



WARNING:



- Rotating auxiliary driveshafts are dangerous. You can snag clothes, skin, hair, hands, etc. This can cause serious injury or death.
- Do not go under the vehicle when the engine is running.
- Do not work on or near an exposed shaft when the engine is running.
- Shut off the engine before working on the Power Take-Off or driven equipment.
- Exposed rotating driveshafts must be guarded.

Guarding Auxiliary Driveshafts



WARNING: We strongly recommend that a Power Take-Off and a directly mounted pump be used to eliminate the auxiliary driveshaft whenever possible. If an auxiliary driveshaft is used and remains exposed after installation, it is the responsibility of the vehicle designer and P.T.O. installer to install a guard.

Using Set Screws



WARNING: Auxiliary driveshafts may be installed with either recessed or protruding set screws. If you choose a square head set screw, you should be aware that it will protrude above the hub of the yoke and may be a point where clothes, skin, hair, hands, etc. could be snagged. A socket head set screw, which may not protrude above the hub of the yoke, does not permit the same amount of torquing as does a square head set screw. Also a square head set screw, if used with a lock wire, will prevent loosening of the screw caused by vibration. Regardless of the choice made with respect to a set screw, an exposed rotating auxiliary driveshaft must be guarded.

IMPORTANT: Safety Information and Owner's Manual

Chelsea Power Take-Offs are packaged with safety information decals, instructions, and an owner's manual. These items are located in the envelope with the P.T.O. mounting gaskets. Also, safety information and installation instructions are packaged with some individual parts and kits. Be sure to read the owner's manual before installing or operating the P.T.O. Always install the safety information decals according to the instructions provided. Place the owner's manual in the vehicle glove compartment.



WARNING: Operating the P.T.O. with the Vehicle in Motion

Some Power Take-Offs may be operated while the vehicle is in motion. To do so, the P.T.O. must have been properly selected to operate at highway speeds and correctly matched to the vehicle transmission and the requirements of the driven equipment.

If in doubt about the P.T.O.'s specifications and capabilities, avoid operating the P.T.O. when the vehicle is in motion. Improper application and/or operation can cause serious personal injury or permanent failure of the vehicle, the driven equipment, and/or the P.T.O.

Always remember to disengage the P.T.O. when the driven equipment is not in operation.



This symbol warns of possible personal injury.

Foreword

This booklet will provide you with information on correct installation of Chelsea® Power Take-Offs (P.T.O.'s). Proper installation and set up procedures will help you get additional and more profitable miles from your truck equipment and components.

It is important that you be sure that you are getting the right transmission/P.T.O. combination when you order a new truck. An inadequate transmission will overwork any P.T.O. in a short period of time. In addition, a mismatched transmission and P.T.O. combination can result in unsatisfactory performance of your auxiliary power system from the start.

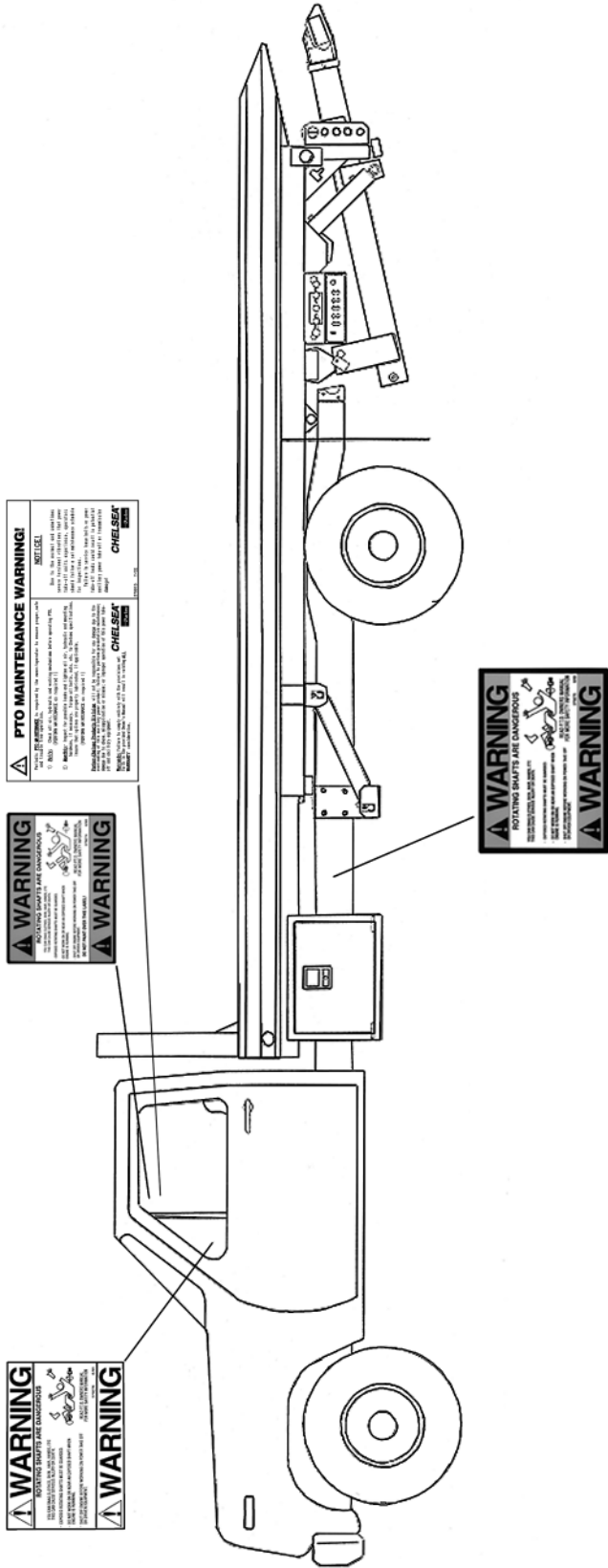
If you have questions regarding correct P.T.O. and transmission combination, please contact your local Chelsea® Auxiliary Power Specialist. They can help you select the properly matched components to insure correct and efficient applications.

Chelsea P.T.O. Safety Label Instructions

1. The two black and orange on white 5" x 7" pressure sensitive vinyl labels, part number 379274; must be placed on the vehicle frame rails (one (1) on each side), in a position that would be HIGHLY visible to anyone that would go under the truck near the P.T.O. rotating shaft. If the vehicle is to be painted after these labels are installed, cover them with two (2) blank masking covers. Remove the masking covers after painting.
2. Place the one (1) black and orange on white 3.5" x 5" pressure sensitive vinyl label, part number 379275, on the visor nearest the operator of the vehicle, this must be placed near the P.T.O. visor label.
3. Place the one (1) red and white with black lettering 3.5" x 7.5" sensitive vinyl label, part number 379915 on the opposite side of the visor from the above label # 379275
4. Place the one (1) white and black heavy duty card, part number 379276, in the vehicle glove box. Again in a position highly visible to the operator, for example: try to place this card on top of whatever may be in the glove box.

If you require labels, please order part number 328946X at no charge from your local Chelsea Warehouse or send request direct to:

**Parker Hannifin Corporation
Chelsea Products Division
8225 Hacks Cross Road
Olive Branch, MS 38654
Customer Service: (662) 895-1011**



Function of Auxiliary Power Shafts

An auxiliary power shaft transmits torque from the power source to the driven accessory. The shaft must be capable of transmitting the maximum torque and R.P.M. required of the accessory, plus any shock loads that develop.

An auxiliary power shaft operates through constantly relative angles between the power source and the driven accessory, therefore, the length of the auxiliary power shaft must be capable of changing while transmitting torque. This length change, commonly called "slip movement", is caused by movement of the powertrain due to torque reactions and chassis deflections.

Joint operating angles are very important in an auxiliary power joint application. In many cases, the longevity of a joint is dependent on the operating angles. (See chart below)

This information is limited to 1000 through 1310 series applications. For applications requiring a series larger than 1310, contact your local Chelsea distributor.

Determining Shaft Type

1) Solid or tubular?

- a) In applications requiring more than 1000 R.P.M. or where the application necessitates a highly balanced auxiliary power shaft, a tubular shaft should be used.
- b) Spicer's solid shafting auxiliary power joints are designed for 1000 or less R.P.M. intermittent service such as:
 - Driving small hydraulic pumps
 - Driving winches
 - Driving low speed product pumps

2) Joint Series should be determined using the chart on the following page.

SPICER® UNIVERSAL JOINT OPERATING ANGLES			
PROP. SHAFT R.P.M.	MAX. NORMAL OPERATING ANGLE	PROP. SHAFT R.P.M.	MAX. NORMAL OPERATING ANGLE
3000	5° 50'	1500	11° 30'
2500	7° 00'	1000	11° 30'
2000	8° 40'	500	11° 30'

Above based on angular acceleration of 100 RAD/SEC²

Spicer® Universal Joint Engineering Data

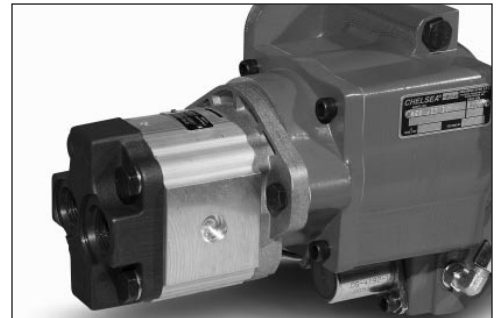
Joint Series	1000	1100	1280	1310
Torque Rating Automotive (Gas or Diesel Engine) Lbs. ft. Continuous	50	54	95	130
Tubing Diameter Wall Thickness W = Welded S = Seamless	1.750 .065 W	1.250 .095 S	2.500 .083 W	3.00 .083 W
Flange Diameter (Swing Diameter) Rectangular Type	3.500	3.500	3.875	3.875
Bolt Holes - Flange Yoke Circle Diameter Number Male Pilot Dia.	2.750 .312 4 2.250	2.750 .312 4 2.250	3.125 .375 4 2.375	3.125 .375 4 2.375
Distance Across Lugs Snap Ring Construction	2.188	2.656	3.469	3.469
Bearing Diameter	.938	.938	1.062	1.062

Maximum Operating Speed * By Tube Size, Solid Shaft Size, and Length *(For speed below 500 R.P.M. or over 2500 R.P.M., contact your Chelsea Distributor)					
Tubing Dia. & Wall Thickness Joint & Shaft (W=Welded S=Seamless)	Max. Installed Length in Inches for Given R.P.M. Centerline to Centerline of Joints for a Two Joint Assembly or Centerline of Joint to Centerline of Center Bearing for a Joint & Shaft R.P.M. - Revolutions per Minute				
	500	1000	1500	2000	2500
1.750" X .065" W	117"	82"	67"	58"	52"
1.250" X .095" S	91"	64"	52"	45"	40"
2.500" X .083" W	122"	87"	70"	62"	55"
3.000" X .083" W	-	-	-	85"	76"
Solid Shaft Diameter					
.750"	60"	42"	35"	30"	27"
.812"	62"	44"	36"	31"	28"
.875"	65"	46"	37"	32"	29"
1.000"	69"	49"	40"	35"	31"
1.250"	77"	55"	45"	39"	35"

Pump Pre-Installation

Installing Pump to P.T.O.

1. When installing the 252 Series on either the Allison or Aisin Transmission one recommendation is to install the Commercial Pump prior to Power Take-Off (P.T.O.) installation.
2. If the Commercial Pump was ordered with the Power Take-Off it will come with a Pump Installation Kit 329296-4X. This kit will include two bolts (378431-11) for mounting the pump to the P.T.O. and a small packet of anti-fretting grease (379688).
3. Before installing the pump to the P.T.O. apply grease to the P.T.O. female splined shaft and to the male pump shaft.
4. Install to pump to the P.T.O. using the bolts provided with the kit. Torque the two pump bolts to 32 – 37 Lbs. ft. [45-50 N.m].
5. You are now ready to install the Power Take-Off to the Transmission.
6. Steps 3 & 4 should be followed even if the pump is not installed at this time, but after the P.T.O. is mounted to the transmission.



Installation of the P.T.O. to the Transmission (GM 3600 Chassis)

1. Before installing the P.T.O to the transmission, you may need to remove the two exhaust pipes that are on the right passenger side of the vehicle and next to the Power Take-Off opening (Fig 1). View is an Extended Cab with L18 engine exhaust.

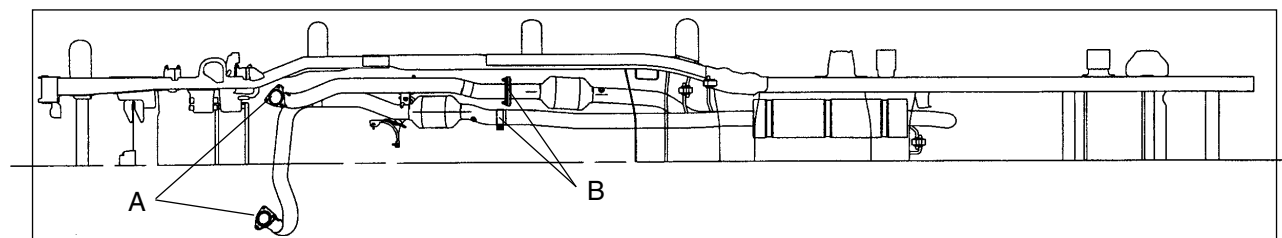


Figure 1

2. Disconnect the connection for the oxygen sensor or remove the oxygen sensor from the exhaust pipe (Fig 2). Next remove the three (3) bolts that secure the exhaust pipe to the exhaust pipe header (A) in (Fig 1) (Fig 3).

Connector

Sensor



Figure 2

This should be done for the left and right exhaust pipes. Remove the attaching bolts for each exhaust pipe at the rear attaching flange (B) in (Fig 1).

3. Remove the lower transmission heat shield [1] and P.T.O. aperture plate [2] from the transmission (Figs. 4 & 5).



Figure 3

NOTE: Make sure aperture surface is clean and dry before proceeding.

1

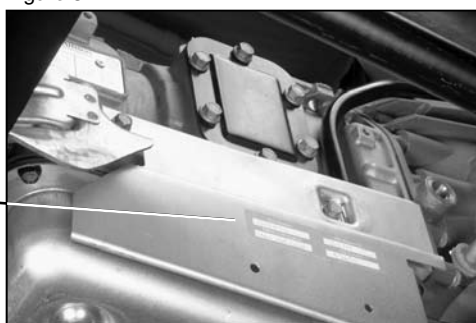


Figure 4

2



Figure 5

Installation of the P.T.O. to the Transmission (GM 3600 Chassis) (Continued)

4. Install the proper studs (379428-14 furnished with P.T.O.) in the P.T.O. aperture pad. The stud kit furnished with the P.T.O. contains five (5) studs and one (1) capscrew and have pre-applied locking/sealing compound. Do not install a stud in the top hole on the aperture pad, this is for the capscrew (See Fig 6) for proper placement of studs. Tighten studs securely and torque to 17-19 Lbs. ft. (23.05- 25.76 N.m).

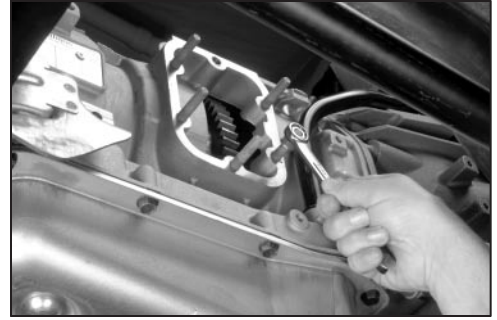


Figure 6

CAUTION: Over tightening of studs may damage stud and/or transmission threads.

5. Place the gasket (35-P-41) provided with the P.T.O. over the studs (Fig 7). Only one gasket is required because the 252 Series P.T.O. does not require the backlash to be set.
6. Secure the P.T.O./Pump to the transmission. Install the long bolt to the top hole in the P.T.O. and the flange nuts (provided with the P.T.O.) to the studs (Fig 8).



Figure 7

NOTE: Flange nuts do not require lockwashers.

7. Fasten the Power Take-Off to the transmission. Torque the five (5) flange nuts (379744) to 35-40 Lbs. ft. [47-54 N.m]. Torque the capscrew (379578-48) to 30-35 Lbs. ft. [41-47 N.m]



Figure 8

Installation of the P.T.O. to the Transmission (GM 3600 Chassis) (Continued)

8. Next we will move to the installation of the plumbing. Remove the transmission oil filter located on the lower left side of the transmission (Fig 9). Next remove the main pressure port plug next to the filter and install the 90° O-Ring fitting (379486). (Fig 10)



WARNING: Oil may be hot. Use extreme caution to ensure that you do not accidentally come in contact with hot oil.

9. Attach the hydraulic hose to the transmission main pressure port. Fitting as shown in (Fig 11). Re-install the filter at this time.

Next attach the other end of the hose to the P.T.O. 90° O-Ring fitting (379486) as shown in (Fig 12)



Figure 9



Figure 10



Figure 11

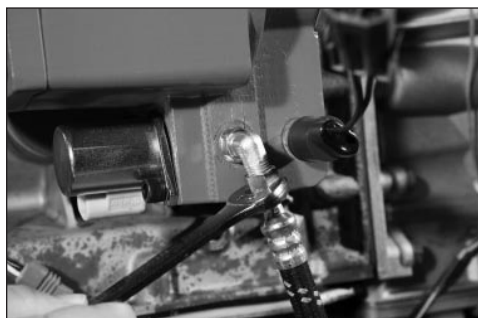


Figure 12



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Installation of the P.T.O. to the Transmission (GM 3600 Chassis) (Continued)

10. Reattach the OE supplied transmission heat shield to the bottom of the transmission. Torque the bolts to 13 Lbs. ft. [17 N.m] (Fig 13).

Model Year 2007-2009 GM 3500 Series Wiring Harness - 252 Series

11. For 2007-2009 model year "C/K" Series 3500 trucks equipped with Allison 1000, 2000/2400 transmission, Chelsea wiring harness 329620X is required to complete the truck to Power Take-Off (P.T.O.) interface.
12. Pressure switch connections (Fig 14).
Grey w/green connector to grey pressure switch connector.
13. Solenoid valve connections (Fig 15).
Grey w/blue connector to white solenoid connector.

OE Supplied



Figure 13

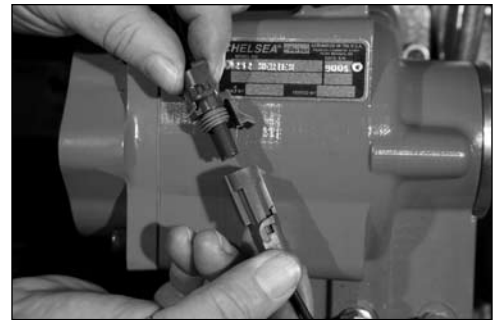


Figure 14

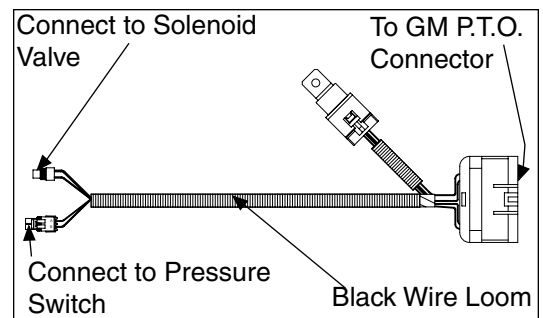


Figure 15

NOTE: After installing the P.T.O. and harness, all trucks will need to be reprogrammed by a GM dealer. The P.T.O. Load Feedback and P.T.O. Engage Relay functions need to be reset to ENABLE before the system will function properly.

To change Stationary Preset P.T.O. to Stationary Variable P.T.O. or Mobile Variable P.T.O. the BCM (Body Control Module) must be reprogrammed.

GM UI (Upfitter Integration) Bulletin #80 is recommended to assist installers and end-users in understanding the P.T.O. system on these trucks. (www.gmupfitter.com)



Part Number 329620X

Installation of the P.T.O. to the Transmission (GM 3600 Chassis) (Continued)

14. Reinstall the two engine exhaust pipes at this time. Torque the rear flange bolts to 30 Lbs. ft. [40 N.m] and the exhaust manifold pipe nuts to 39 Lbs. ft. [50 N.m] (Fig 16).

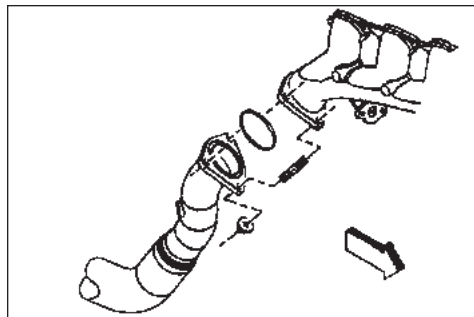


Figure 16

15. Reattach the oxygen sensor at this time also. If the oxygen sensor was removed at the pipe, torque to 31 Lbs. ft. [42 N.m]. If the sensor was disconnected at the plug, snap back into place (Fig 17).

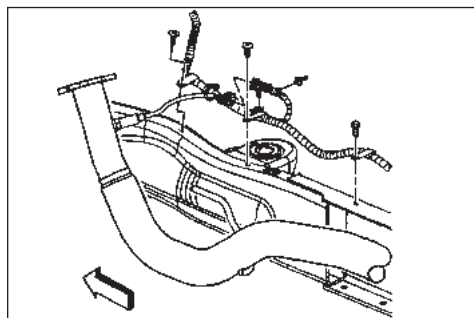


Figure 17

Installation of the P.T.O. to the Transmission (Allison 1000, 2000/2400)

1. Remove P.T.O. aperture plate from the transmission.
(Fig 1)



WARNING: Oil may be hot. Use extreme caution to ensure that you do not accidentally come in contact with hot oil.

NOTE: Make sure aperture surface is clean and dry before proceeding.



Figure 1

2. Install the proper studs (379428-14 furnished with P.T.O.) in the P.T.O. aperture pad. The stud kit furnished with the P.T.O. contains five (5) studs and one (1) capscrew and have pre-applied locking/sealing compound. Do not install a stud in the top hole on the aperture pad, this is for the capscrew (See Fig 2) for proper placement of studs. Tighten studs securely and torque to 17-19 Lbs. ft. (23 - 25 N.m).

CAUTION: Over tightening of studs may damage stud and/or transmission threads.



Figure 2

3. Place the gasket (35-P-41) provided with the P.T.O. over the studs (Fig 3). Only one gasket is required because the 252 Series P.T.O. does not require the backlash to be set.
4. Secure the P.T.O./Pump to the transmission. Install the long bolt to the top hole in the P.T.O. and the flange nuts (provided with the P.T.O.) to the studs (Fig 4).

NOTE: Flange nuts do not require lockwashers.



Figure 3

5. Fasten the Power Take-Off to the transmission. Torque the five (5) flange nuts (379744) to 35-40 Lbs. ft. [47-54 N.m]. Torque the capscrew (379578-48) to 30-35 Lbs. ft. [41-47 N.m]



Figure 4

Installation of the P.T.O. to the Transmission (Allison 1000, 2000/2400)

6. Remove the transmission oil filter located on the lower left side of the transmission (Fig 5). Next remove the main pressure port plug next to the filter and install the 90° O-Ring fitting (379486). (Fig 6)



WARNING: Oil may be hot. Use extreme caution to ensure that you do not accidentally come in contact with hot oil.

7. Attach the hydraulic hose to the transmission main pressure port. Fitting as shown in (Fig 7). Re-install the filter at this time.

Next attach the other end of the hose to the P.T.O. 90° O-Ring fitting (379486) as shown in (Fig 8)



Figure 5



Figure 6



Figure 7

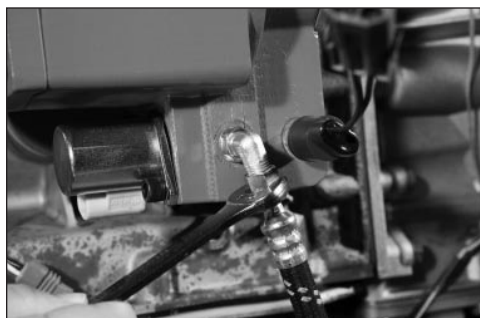


Figure 8



This symbol warns of possible personal injury.

Installation of the P.T.O. to the Transmission (Allison 1000, 2000/2400)

NOTE: If using the GM provided in-dash switch, skip to item # 9

8. Install the P.T.O. rocker switch and bracket in the cab. Under the vehicle connect the two Packard connectors.

A) The gray w/green male harness connector to the gray pressure female connector. (Fig. 9)

B) The gray male w/blue connector to the white solenoid female connector. (Fig. 10)

C) Route the other end of the Chelsea wiring over the transmission and into the cab and connect wires as illustrated on [page 16](#).

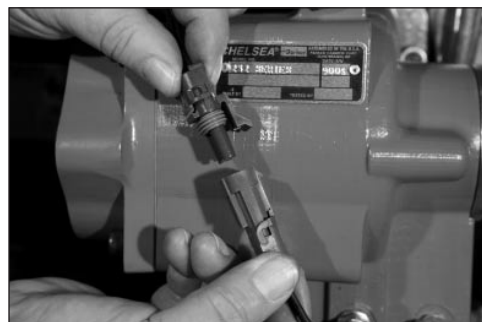


Figure 9



Figure 10

GM “C/K” Series P.T.O. Wiring Harness

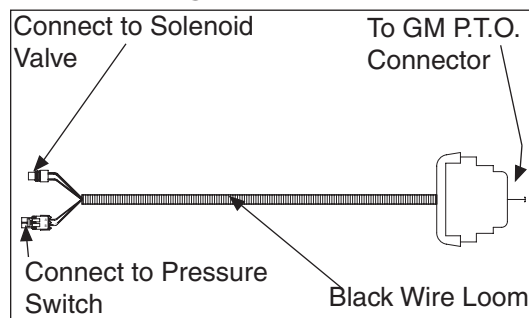
9. For model year 2003 and higher GM “C/K” Series 4500, 5500, 6500, 7500 and 8500 trucks may be equipped with the Allison 1000, 2000/2400 transmissions. In these vehicles GM Truck has integrated a P.T.O. connector, located in the right hand engine compartment area. A Power Take-Off switch has also been incorporated into the GM dash panel to control P.T.O. operation. With the P.T.O. option ordered on the truck, the P.T.O. connector and in-dash switch simplify the interface for the body builder.

In order for the customer to utilize the full capability of the P.T.O./transmission, Chelsea has designed a wiring harness that must be used between the GM P.T.O. connector and the Chelsea Power Take-Off. These are for P.T.O. Non E.O.C. applications only.

The main purpose of the wiring harness on the Allison 1000, 2000/2400 transmissions will be to engage the torque converter lock-up clutch. The harness will also allow the end-user to utilize the stalk-mounted cruise control to control Power Take-Off R.P.M.

See wiring harness part number 329619X for the 252 Series Power Take-Offs.

Model Year 2003 and Higher GM “C” Series Wiring Harness for 252 Series

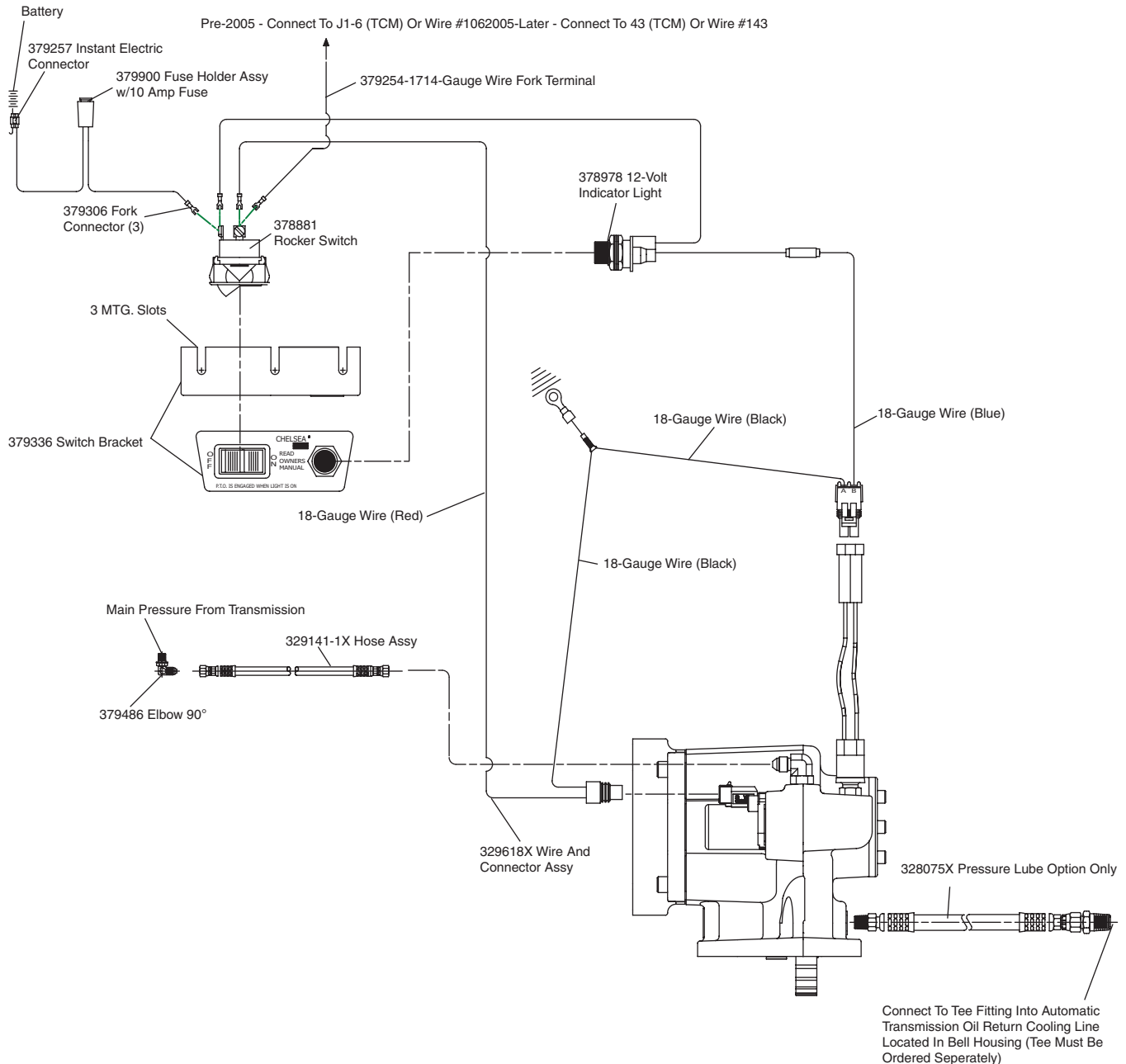


Part Number 329619X

NOTE: For 2006 Model Year Chev. Kodiak and GMC Topkick C4500-C7500 Series with 6.6L Diesel or 8.1L Gas engines and Allison 1000/2200/2300 Series transmission. The P.T.O. may not operate properly due to a GM change in feedback logic in the TCM. Please refer to GM UI Bulletin#76 REV. 1 dated 6/09/2006 or latest revision for complete details.

Installation Sketch 12V without Speed Limiter 252 for Allison 1000, 2000/2400 (SK-456 Rev A)

329296-8X (12V Installation Kit)



Dodge Overview

P.T.O. Operation

The 3500/4500/5500 Dodge Chassis Cab vehicle, when equipped with either the automatic Aisin 6 speed or manual G-56 6 speed transmissions, will allow for an aftermarket upfit with a transmission driven P.T.O. (Power Take-Off). The customer will have the ability to operate the P.T.O. in either a "stationary" or "mobile" mode. The vehicles will be factory set to the "stationary" mode. In order to select the "mobile" mode a DaimlerChrysler Dealership is required to modify the vehicles settings using their proprietary Dealer service tool.

Stationary Mode

To operate the P.T.O. in this mode the vehicle must meet the following conditions:

- Be in "park" positions (vehicles equipped with automatic transmission)
- Up fitter provider (on/off) switch has been activated
- Parking brake applied (vehicles equipped with manual transmission)
- Vehicle must be running
- No vehicle, brake or clutch switch faults present
- P.T.O. must be correctly installed using the vehicle provided circuits

The customer has the choice to operate the P.T.O. by utilizing the cruise control switches or by utilizing a remote control (provided by the P.T.O. supplier). To operate the feature using the cruise control switches the customer must first activate the up fitter provided on/off switch. Next, the cruise control "on" switch is selected. Following this step the "set" switch must be depressed. The vehicle is now in the P.T.O. mode and is ready for use. In order to increase or decrease the engine idle speed, to optimize the P.T.O. function, the "accel" and "decel" cruise switches can be used respectively. To disengage P.T.O. operation and return to "standard vehicle operation" simply turn the up fitter provided on/off switch to the off position.

To operate the P.T.O. via a remote switch the customer must make sure the above conditions are met. It is vital for proper operation that the P.T.O. and remote have been installed correctly paying special attention to ensure the vehicle provided wiring has been connected properly. This is the responsibility of the installer of the P.T.O. and switches/remote system. It is the responsibility of the P.T.O. manufacturer to ensure that their electrical (switches and remote) system is compatible with the vehicle's electrical architecture and software functionality.

Mobile Mode

To operate the P.T.O. in this mode the vehicle must meet the following conditions:

- Dealer selected "mobile" mode activated via Dealer proprietary service tool
- Up fitter provider (on/off) switch has been activated
- Vehicle must be in "park" or "drive" position (vehicles equipped with automatic transmission)
- Parking brake must not be applied
- No vehicle, brake or clutch switch faults present
- Vehicle must be running
- P.T.O. must be correctly installed using the vehicle provided circuits

The customer may choose to use the P.T.O. while the vehicle is moving. To do so the P.T.O. function must be activated prior to taking the vehicle out of "park". This is accomplished by activating the up fitter provided P.T.O. on/off switch. At this point the customer may place the vehicle in a forward or reverse gear and have P.T.O. operation. To disengage P.T.O. operation and return to "standard vehicle operation" simply turn the up fitter provided on/off switch to the off position.

NOTE: For application specific information with respect to P.T.O. and pump requirements and additional vehicle information (wiring schematics, preset idle values, engine speed limits, and vehicle hardware and software requirements) please refer to the Dodge Body Builders Guide by accessing "Wiring Diagrams" and choosing the appropriate links.

Installation Instructions for 252 Series Dodge/Aisin

The current Power Take-Off (P.T.O.) installation is from under the vehicle, an alternative method for Dodge has been developed with the help of Chelsea Products that allows the installation from above by removing the P.T.O. patch panel in the floor.

The installation instructions below are shown using a Dodge 4500 crew cab for installation, but applies to all Dodge work trucks. See Dodge upfitter web site for any changes to this installation information.

1. Unbolt the seat and move it to the rear of the cabin. (Fig 1)
2. Remove the sill guards (rocker panel covers) passenger side to allow the floor mat to be lifted. They are removed by prying straight up to disengage metal clips. (Fig 2)
3. Lift the floor mat and fold it rearward and towards the driver side to expose the patch panel (Fig 3)
4. Remove the fasteners and sealer from around the patch panel. Cut away the sound deadener pad to expose the transmission P.T.O. access. (Fig 4)
5. See installation of the P.T.O. for complete P.T.O. installation instructions on [page 17-19](#) of this manual.
6. To assemble, reverse the above procedure (1-4) using RTV to reseal the P.T.O. floor pan patch panel.



Figure 1



Figure 2



Figure 3



Figure 4

Installation Instructions for Dodge/Aisin (Continued)

Under Vehicle Installation

3. To access the P.T.O. aperture on the right (passenger) side of the transmission, the exhaust pipe will need to be removed. (Fig 5)
4. To make this process easier the following information is provided.

The front end of the exhaust pipe at the turbo charger is secured with a V band clamp part number 52121895AB. It is tightened to a torque value of 150 inch pounds.

At the rear of the pipe the M10x1.5 nuts are torqued to 43 Lbs. ft.

The part number for the gasket that is located between the front pipe and the catalytic converter/ particulate filter (if it is damaged or lost) is 52122213AB.

More specific instructions on removing and installing the exhaust pipe are available in the Dodge Truck service manual.

If there are any additional questions related to this procedure please contact the Dodge Truck Body Builder Hotline at (866) 205-4102 or dodgebbg@dcx.com.

5. Install Power Take-Off as described on [pages 17-19](#) of this manual.

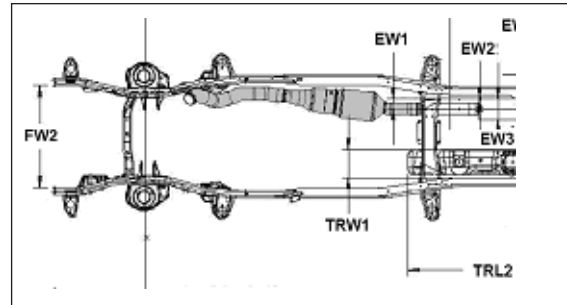


Figure 5

Installation of the P.T.O. to the Transmission

1. Before mounting the P.T.O. remove the high pressure port plug located on the left side (drivers side of transmission) and install part number 379749 male connector fitting into port. Also install the 90° swivel nut (part number 379703) onto the male connector (379749) (Fig 1).

Connect hose and route to P.T.O. side of transmission

NOTE: Refer to “Installation Sketches SK-455 for complete wiring and plumbing instructions starting on [page 20](#) of this owner's manual.

2. Remove the P.T.O. aperture plate from the transmission. (Fig 2)



WARNING: Oil may be hot. Use extreme caution to ensure that you do not accidentally come in contact with hot oil.

3. Install the proper studs (379908 furnished with P.T.O.) in the P.T.O. aperture pad. The stud kit furnished with the P.T.O. contains five (5) studs and one (1) capscrew and have pre-applied locking/sealing compound. Do not install a stud in the top hole on the aperture pad, this is for the capscrew (See Fig 3) for proper placement of studs. Tighten studs securely and torque to 17-19 Lbs. ft. [23.05-25.76 N.m] (Fig 3)

CAUTION: Over tightening of studs may damage stud and/or transmission threads.

4. Place the gasket (35-P-41) provided with the P.T. O. over the studs (Fig 4). Only one gasket is required because the 252 Series P.T.O. does not require the backlash to be set. (Fig 4)

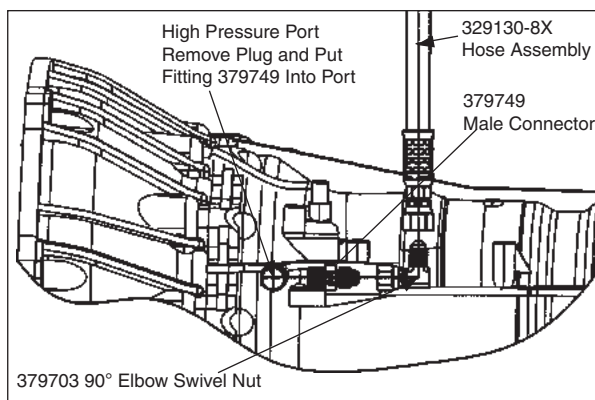


Figure 1



Figure 2

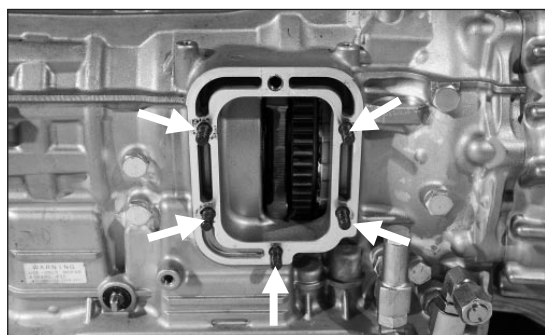


Figure 3



Figure 4

Installation of the P.T.O. to the Transmission (Continued)

5. Secure the P.T.O. to the transmission. Install the long bolt to the top hole in the P.T.O. and the flange nuts (provided with the P.T.O.) to the studs (Fig 5).

NOTE: Flange nuts do not require lockwashers.

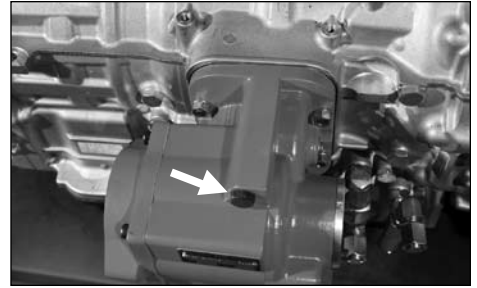


Figure 5

6. Torque the five (5) flange nuts (379744) to 35-40 Lbs. ft. [46-54 N.m].

Torque the capscrew (379577-48) to 30-35 Lbs. ft. (Fig 6)

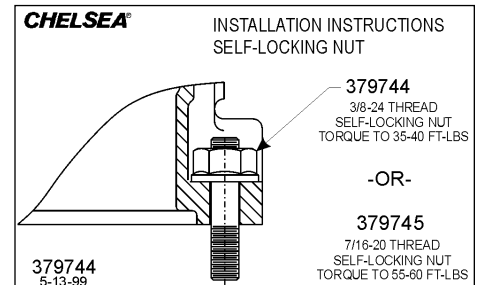


Figure 6

7. Attach hydraulic hose to P.T.O. (Fig 7)



Figure 7

8. Connect electrical wires to P.T.O. (Fig. 8 and 8A)

Connect the weather tight connector (black & white wire) with the GRAY plastic cover and the BLUE seal to the Solenoid valve. (Fig 8)

Connect the weather tight connector (two black wires) with the GRAY plastic cover and the GREEN seal to the pressure switch. (Fig 8A)

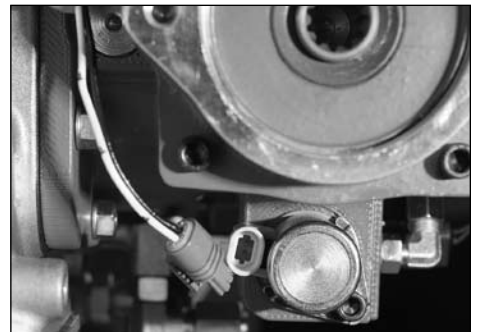


Figure 8



Figure 8A

Wiring Charts - Model Year 2007-2009 Dodge Chassis Cab, 6.7L w/Aisin Transmission

2007 Wiring Chart

	Chelsea Wire	Connected to Dodge Wire	Location
1	Orange	*K425 Orange w/Brown Stripe	Terminal #9, 10-way Connector on Bellhousing
2	Violet 1	*V937 Violet w/Brown Stripe	Terminal #8, 10-way Connector on Bellhousing
3	Violet 2	G425 Violet w/Yellow Stripe	Upfitter Jumper Connector**
4	Pink	F922 Pink w/Red Stripe	Upfitter Jumper Connector**
5	Orange	K427 Orange w/Lt. Green Stripe	Unterminated Wires Near Master Cylinder
6	Pink	F922C Pink w/Red Stripe	Unterminated Wires Near Master Cylinder
7	Black	Z914 Black	Unterminated Wires Near Master Cylinder
8	Violet	G425 Violet w/Yellow Stripe	Unterminated Wires Near Master Cylinder
	Chelsea Wire	Connected to	Location
9	Male Gray Connector w/Green seal	Pressure Switch	P.T.O.
10	Male Gray Connector w/Blue seal	P.T.O. Solenoid	P.T.O.

* **NOTE:** These two wires must be cut from Dodge 10 way connector. Do not cut any other wires.

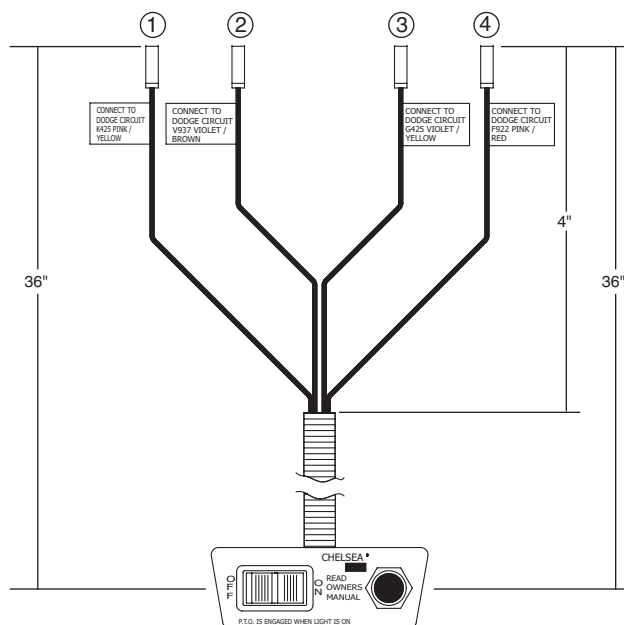
** **NOTE:** Stored in Vehicle Glove Box. Connect to Mating Plug under Instrument Panel Near Grommet.

2008-2009 Wiring Chart

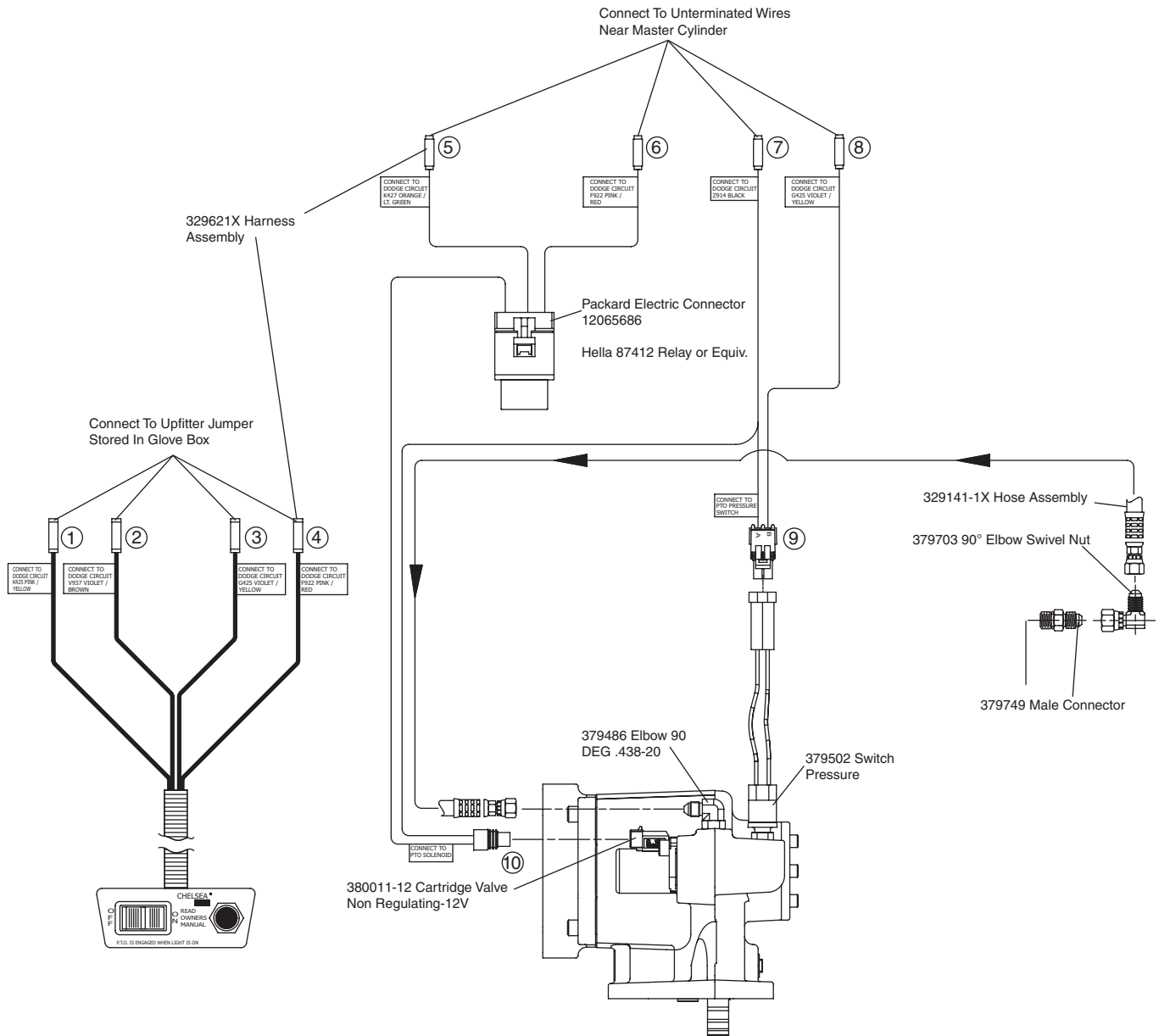
	Chelsea Wire	Connected to Dodge Wire	Location
1	Orange	K425 Pink w/Yellow Stripe	Upfitter Jumper Connector
2	Violet 1	V937 Violet w/Brown Stripe	Upfitter Jumper Connector
3	Violet 2	G425 Violet w/Yellow Stripe	Upfitter Jumper Connector
4	Pink	F922 Pink w/Red Stripe	Upfitter Jumper Connector
5	Orange	K427 Orange w/Lt. Green Stripe	Unterminated Wires Near Master Cylinder
6	Pink	F922C Pink w/Red Stripe	Unterminated Wires Near Master Cylinder
7	Black	Z914 Black	Unterminated Wires Near Master Cylinder
8	Violet	G425 Violet w/Yellow Stripe	Unterminated Wires Near Master Cylinder
	Chelsea Wire	Connected to	Location
9	Male Gray Connector w/Green seal	Pressure Switch	P.T.O.
10	Male Gray Connector w/Blue seal	P.T.O. Solenoid	P.T.O.

NOTE: Wire Numbers on the Chelsea Wiring Chart are for Reference to Model Year Wiring.

NOTE: Upfitter Connector is shipped loose with vehicle and is stored behind seat.



Installation Sketch Dodge/Aisin Transmission (SK-455 Rev A)



Power Take-Off Maintenance

Power Take-Off Maintenance

Due to the normal and sometime severe torsional vibrations that power take-off units experience, operators should follow a set maintenance schedule for inspections. Failure to service loose bolts or power take-off leaks could result in potential auxiliary power-take-off or transmission damage.

Periodic P.T.O. MAINTENANCE is required by the owner/operator to ensure proper, safe and trouble free operation.

Daily: Check all air, hydraulic and working mechanisms before operating
P.T.O. Perform maintenance as required.

Monthly: Inspect for possible leaks and tighten all air, hydraulic and mounting hardware, if necessary. Torque all bolts, nuts, etc. to Chelsea specifications. Insure that splines are properly lubricated, if applicable. Perform maintenance as required.

With regards to the direct mounted pump splines, the P.T.O. requires the application of a specially formulated anti-fretting, high pressure, high temperature grease. The addition of the grease has been proven to reduce the effects of the torsional vibrations, which result in fretting corrosion on the P.T.O. internal splines as well as the pump external splines. Fretting corrosion appears as a "rusting and wearing" of the pump shaft splines. Severe duty applications, which require long P.T.O. running times and high torque may require more frequent regreasing. Applications such as Utility Trucks that run continuously and are lightly loaded also require frequent regreasing due to the sheer hours of running time. It is important to note that service intervals will vary for each and every application and is the responsibility of the end user of the product. Chelsea also recommends that you consult your pump owners manuals and technical services for their maintenance guidelines. Fretting corrosion is caused by many factors and without proper maintenance; the anti-fretting grease can only reduce its effects on components.

Chelsea offers the grease to our customers in two packages. The first is a 5/8 fluid ounce tube (379688), which is included with every applicable P.T.O., and the second is a 14-ounce grease cartridge (379831). Chelsea also offers greaseable shafts for most all output designators.

Warranty: Failure to comply entirely with the provisions set forth in the appropriate Owner's Manual will result in voiding of ALL Warranty consideration.

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This image shows a single page of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There is no text or other markings on the page.

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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 18 months from date of sale.

(B) Except 267, 269, 277, 278, 246, 247, 250, 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 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.

6/08-P



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