

Chelsea PTO 522 Parts Manual

Pro Gear Chelsea 522 Series PTO parts 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.

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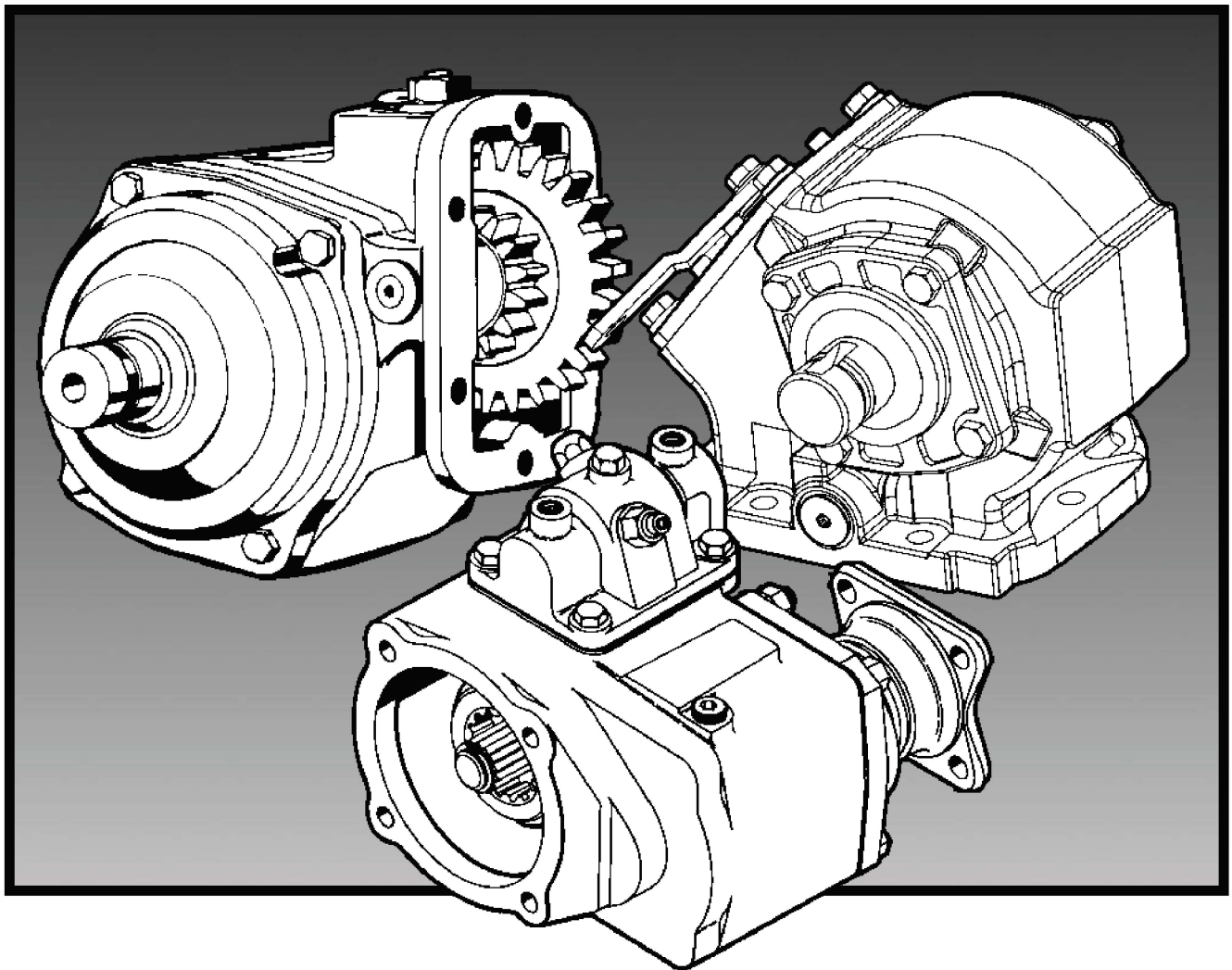
CHELSEA[®]

Parts List

522 Series

Bulletin HY25-2522-M1/US

Effective: December 15, 2010 Supersedes:
HY25-2522-M1/US Nov. 15, 2003





WARNING — User Responsibility

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The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

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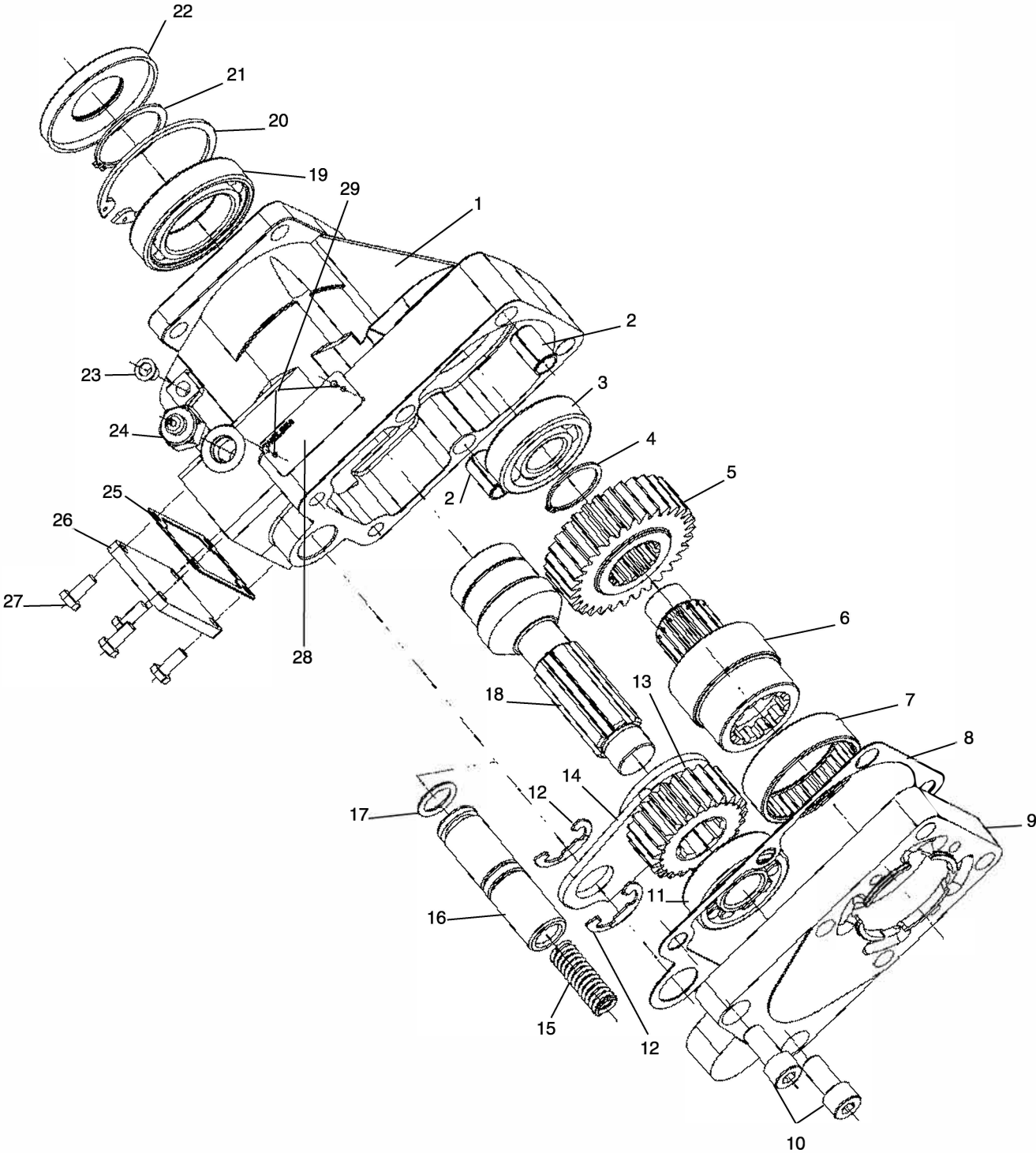
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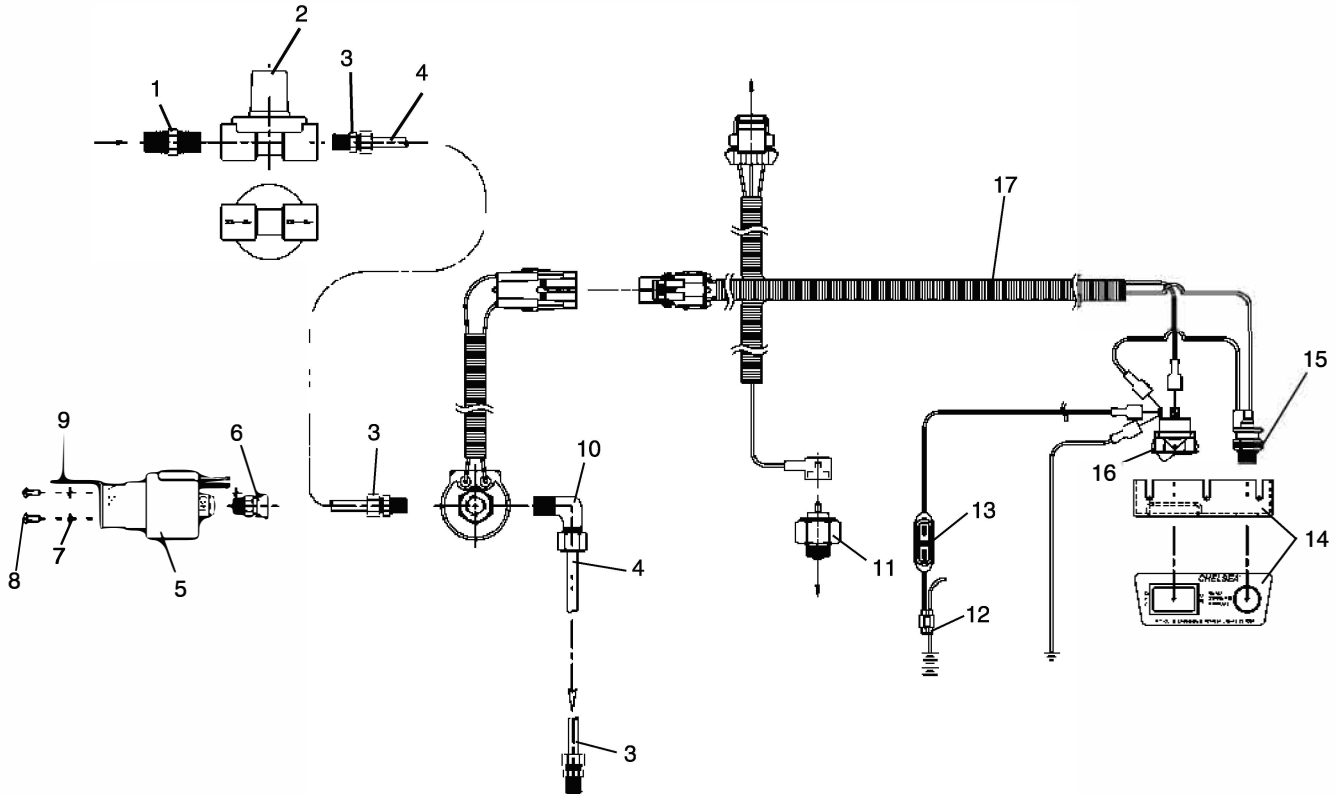


Bill of Materials

522 Series

Item	Part #	Description	Quantity
1	1-P-599X	P.T.O. Housing w/Dowel Pin.....	1
	1-P-608X	P.T.O. Housing w/Dowel Pin ("R" Housing)	?
2	379920	Dowel Pin	2
3	560990	Ball Bearing, Input Shaft.....	1
4	378098	Snap Ring, Input Shaft	1
5	5-P-1388	Input Gear, "T" Ratio (31 Teeth).....	1 or
	5-P-1389	Input Gear, "V" Ratio (34 Teeth).....	1
6	3-P-967	Input Shaft, "AA" Input	1 or
	See Chart Pg. 4 & 5		1
7	561016	Input Bearing, Needle Roller, "AA" Input"	1 or
	See Chart Pg. 4 & 5		1
8	22-P-115	Gasket, Housing.....	1
9	21-P-664	Rear Mounting Plate, "AA" Input.....	1 or
	See Chart Pg. 4 & 5		1
10	379676-6	Hex Capscrew, (M12 - 1.5 x 25)	2
11	561017	Bearing, Cylindrical Roller	1
12	379918	Snap Ring, Shifter Rod.....	2
13	2-P-821	Output Gear, "T" Ratio (23 Teeth)	1 or
	2-P-822	Output Gear, "V" Ratio (20 Teeth)	1
14	32-P-183	Shifter Fork	1
15	37-P-21	Shifter Spring.....	1
16	11-P-155	Shifter Rod.....	1
17	28-P-41	O-Ring, Shifter Rod	1
18	3-P-959	Output Shaft, "XY"	1 or
	See Page 7		1
19	561018	Output Bearing	1
20	379919	Snap Ring, Internal.....	1
21	378477	Snap Ring, Output Shaft.....	1
22	28-P-278	Oil Seal	1
23	500897-3	Shipping Plug	1
24	379652	Indicator Switch, Normally Closed.....	1
	379633	Indicator Switch, Normally Closed ("E" Shift Option).....	?
25	35-P-93	Gasket, Cover Plate.....	1
26	34-P-133	Cover Plate	1
27	378429-6	Hex Capscrew, (.250" - 20 x .625").....	4
28	68-P-2	Name Plate.....	1
29	378422	Drive Screw	2
		Loose Parts	
	328388-37X	Installation Kit ("A" Shifter).....	1
	328388-47X	Installation Kit ("P" Shifter).....	1
	328388-48X	Installation Kit ("Q" Shifter)	1
	328388-82X	Installation Kit ("F" Shifter "AC" Input Only)	1
	378414	Pressure Protection Valve ("V" Shift Only).....	1
	379640	Booted connector ("V" Shifter Only)	1
	329431-1X	Gasket & Seal Service Kit ("AA", "AB", "AM" Input)	1
	329431-2X	Gasket & Seal Service Kit ("AC" Input).....	1
	329431-3X	Gasket & Seal Service Kit ("AD" Input).....	1
	329432-1X	Bearing Service Kit ("AA", "AB" & "AM" Input)	1
	329432-2X	Bearing Service Kit ("AC" & "AD" Input).....	1

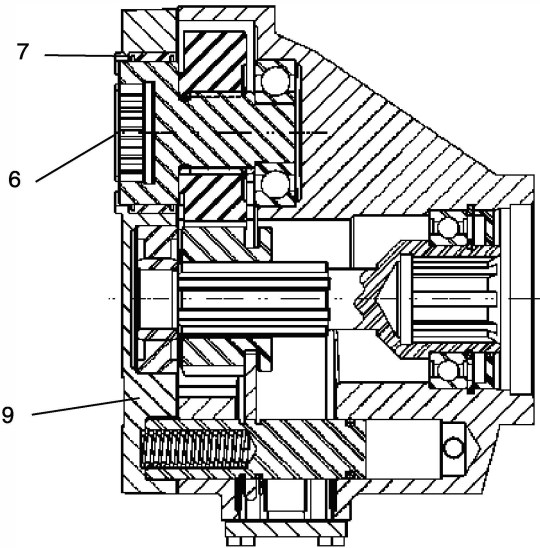
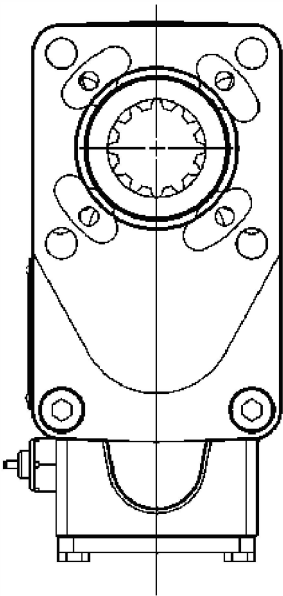
[See Kit Bill of Materials on page 9-10](#)



Item	Part #	Description	Quantity
	328388-82X	12V Electric/Air Installation Kit w/ZMTEC Wire Harness	
1	378416	Hex Nipple, (.25 - 18 NPTF).....	1
2	378414	Pressure Protection Valve	1
3	379042	Male Connector, 1/4" Tube to Male Pipe (.125" - 25 NPT)	3
4	379044-7	Plastic Tubing	1
5	75-P-10	Solenoid, 12V	1
6	379106	Atmospheric Breather (.125" - 27 NPTF)	1
7	500357-7	Lock Washer	2
8	500457-6	Round Head Slotted Screw (.438" x .190" - 32 UNF- 2A).....	2
9	379258	Bracket	1
10	379043	Male Elbow 90°, 1/4" Tube to Pipe (.125" - 27 NPTF).....	1
12	379257	Connector	1
17	75-P-9	Wiring Harness (includes items 13, 14, 15 & 16).....	1
13	379900	Fuse, 10 AMP	1
14	379336	Switch Bracket	1
15	378978	Indicator Light, 12V	1
16	75-P-11	Switch, P.T.O.	1

522**AM Input

- Eaton FS-4106
- Eaton FS-5206

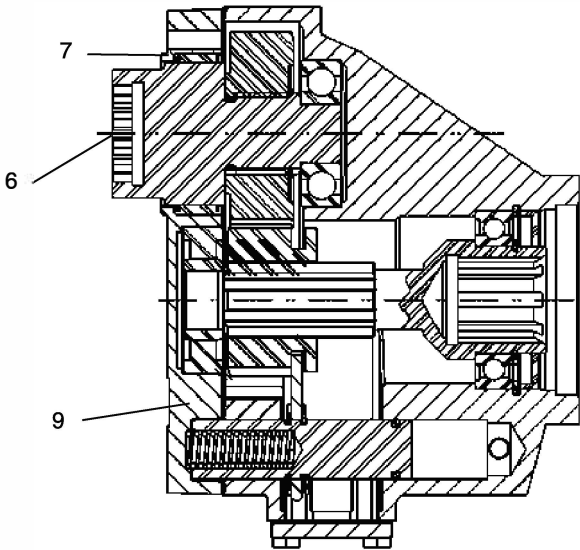
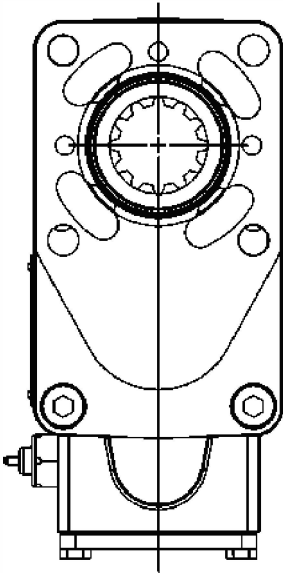


Item	Part Number	Description	Quantity
9	21-P-658	Mounting Plate.....	1
6	3-P-958	Input Shaft, (12 Tooth - 40mm Internal Spline).....	1
7	561016	Needle Roller Bearing	1
	8000-18X	P.T.O. Mounting Kit.....	1
	328952-20X	Gasket and Caution Label Kit.....	1

See Kit Bill of Materials on page 9-10

522**AA Input

- ZF 6S-850
- ZF S6-36

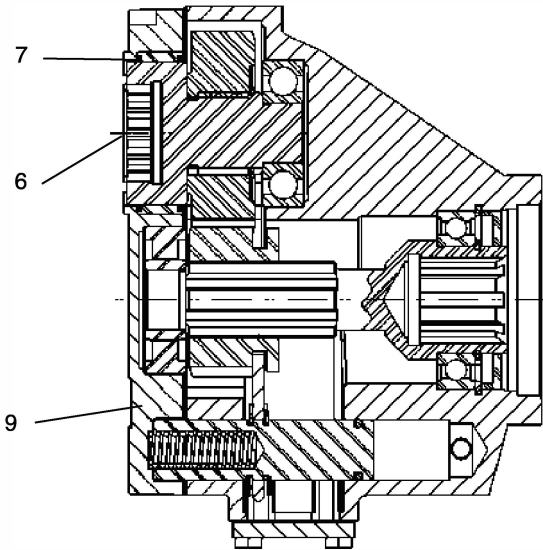
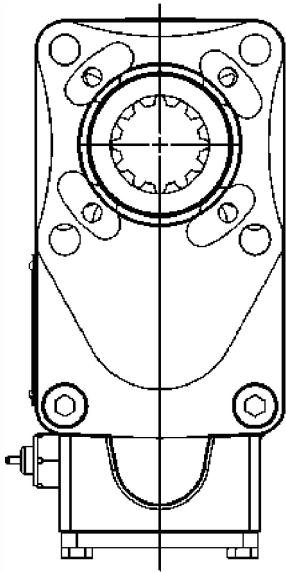


Item	Part Number	Description	Quantity
9	21-P-664	Mounting Plate	1
6	3-P-967	Input Shaft, (12 Tooth - 40mm Internal Spline).....	1
7	561016	Needle Roller Bearing	1
	8000-18X	P.T.O. Mounting Kit.....	1
	328952-20X	Gasket and Caution Label Kit.....	1

See Kit Bill of Materials on page 9-10

522AB Input**

- Iveco 2845.6
- Iveco 2855.5

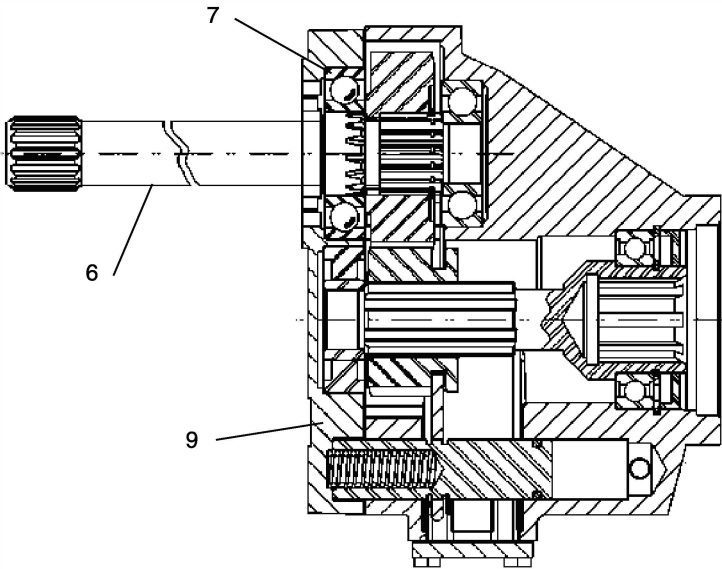
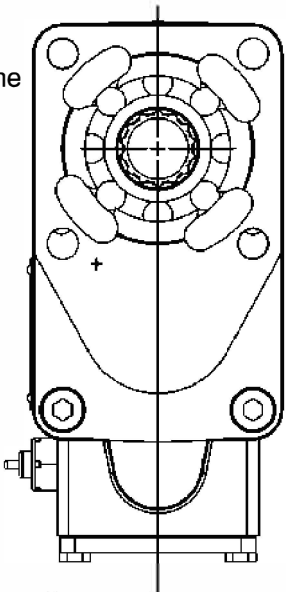


Item	Part Number	Description	Quantity
9	21-P-665	Mounting Plate	1
6	3-P-958	Input Shaft, (12 Tooth - 40mm Internal Spline).....	1
7	561016	Needle Roller Bearing	1
	8000-18X	P.T.O. Mounting Kit.....	1
	328952-20X	Gasket and Caution Label Kit.....	1

See Kit Bill of Materials on page 9-10

522AC Input**

- ZF Meritor Freedomline
- ZF Astronic

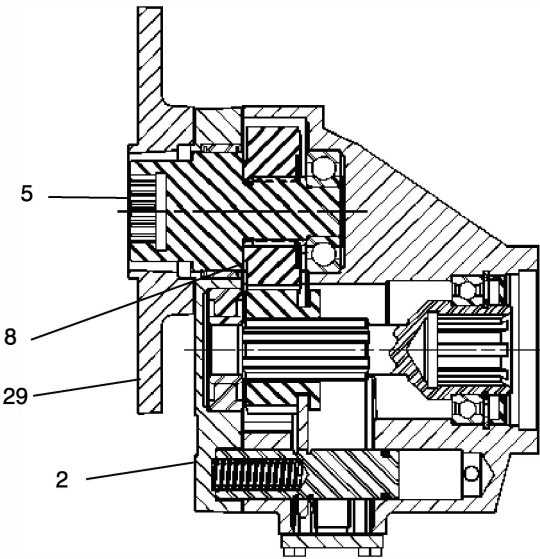
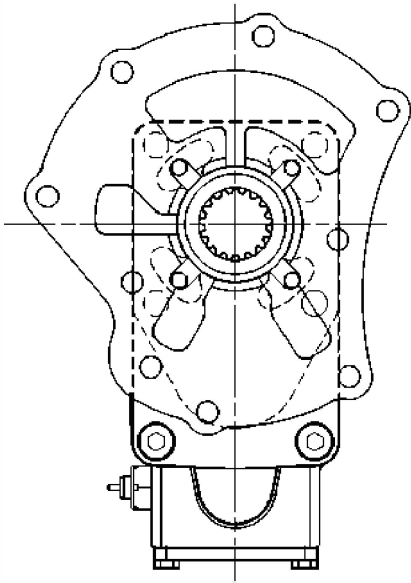


Item	Part Number	Description	Quantity
9	21-P-668	Mounting Plate	1
6	3-P-965	Input Shaft, (14 Tooth - 32mm External Spline).....	1
7	550010	Ball Bearing	1
	8000-18X	P.T.O. Mounting Kit.....	1
	328952-21X	Gasket and Caution Label Kit.....	1

See Kit Bill of Materials on page 9-10

522**AE Input

- Mercedes G60
- Mercedes G85



Item	Part Number	Description	Quantity
2	21-P-658	Mounting Plate ("AE" Input)	1
5	3-P-984	Input Shaft (17 Tooth - 37MM Spline)	1
8	561016	Needle Roller Bearing	1
29	26-P-74	Adapter Plate.....	1
	8000-18X	P.T.O. Mounting Kit.....	1
	328952-20X	Gasket & Caution Label Kit	1
	8000-20X	Adapter Plate Mounting Kit.....	1
	35-P-98	Gasket for Adapter Plate	1

[See Kit Bill of Materials on page 9-10](#)

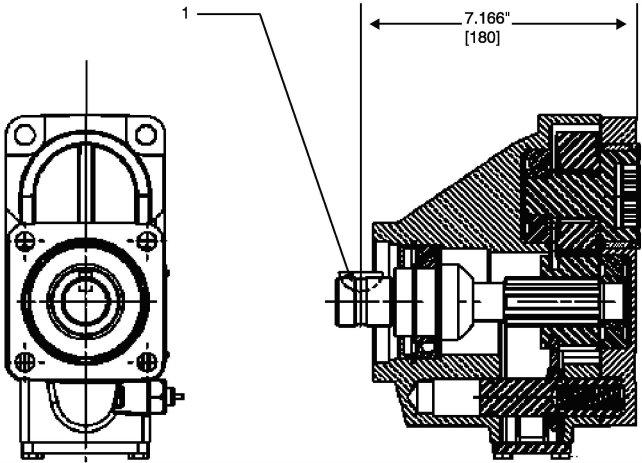
Output Options

Power Take-Off
522 Series

Output	Shaft Part Number	Description
XD	3-P-960	1 -1/4" Round Shaft
XX	3-P-961	1 -1/4" Round Shaft S.A.E. Taper
XY	3-P-959	DIN 5462, 8 Tooth

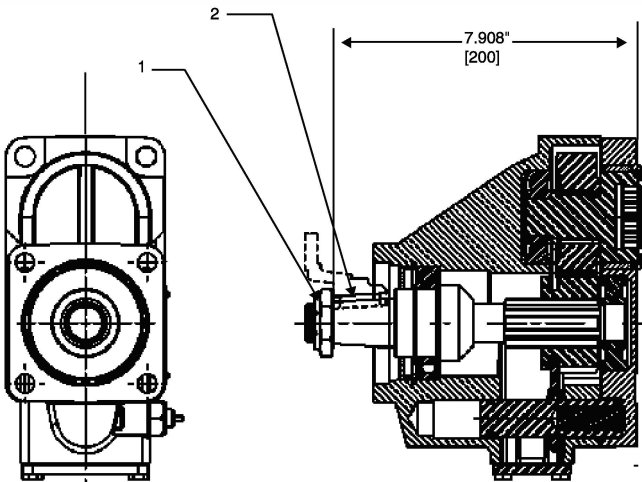
XD Output

1 = 500007-29 Woodruff Key

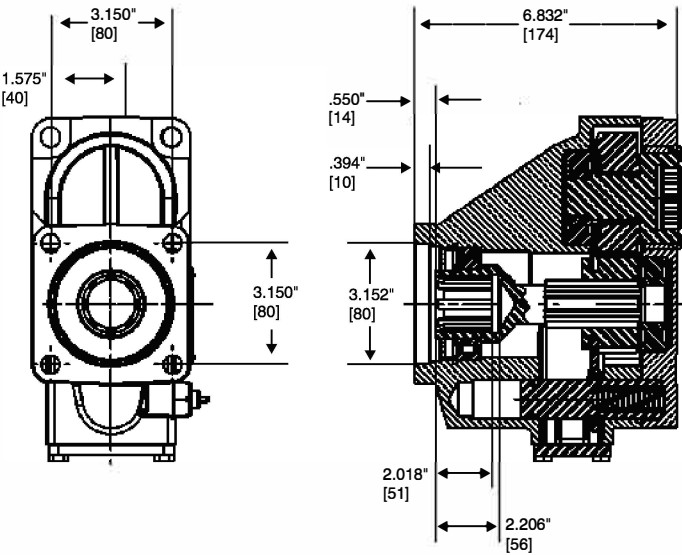


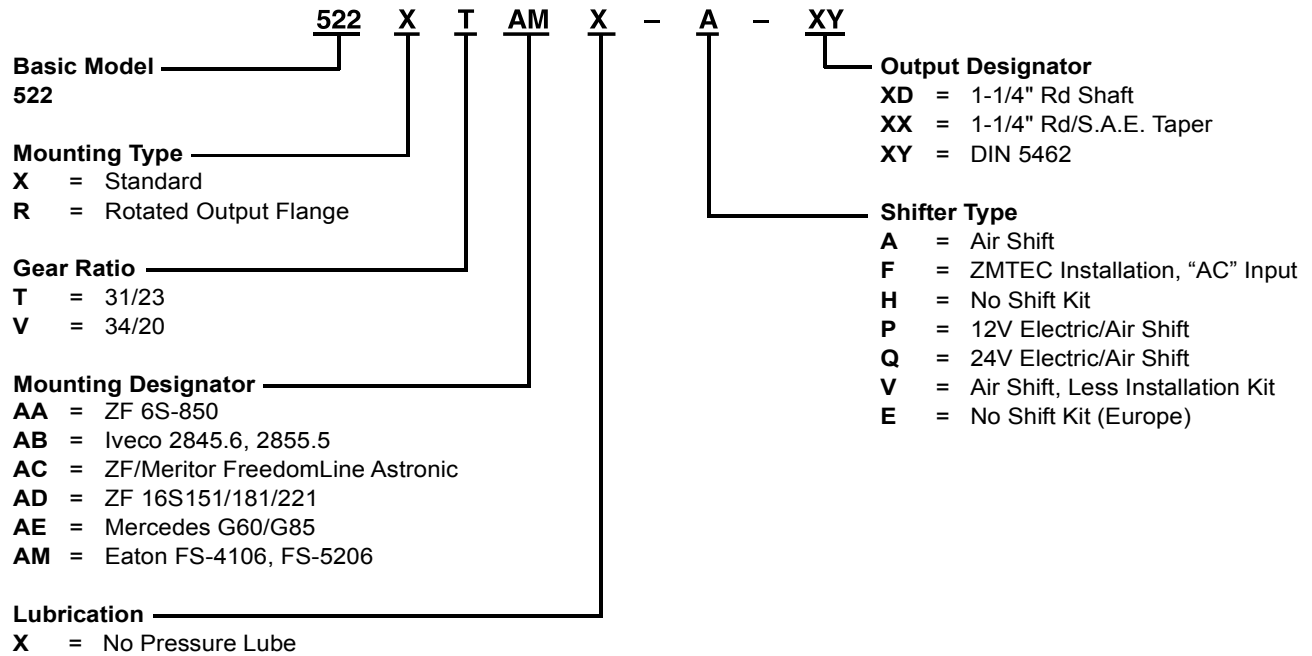
XX Output

1 = 501181 Hex Lock Nut
2 = 379111 Square Key



XY Output



Model Number Designation**522 Series**

Kit Bill of Materials**Power Take-Off****522 Series**

329090-1X	Valve Kit		328388-46X	Inst Kit Parts Bag	
328863X	Valve Air Control	1	379900	Ass'y Fuse	1
378414	Valve, Pressure Protection	1	378416	Hex Nipple	1
			379042	Male Connector	2
329431-1X	Service Kit, Sealing (AA,AB,AM)		379043	Male Elbow	1
22-P-115	Gasket Housing / Backplate	1	379253	Ring Connector	1
22-P-117	Gasket Mounting	1	379257	Splice Connector	1
28-P-41	O-Ring Shifter Rod	1	379306	Fork Connector	4
28-P-278	Oil Seal Output Shaft	1	500357-7	Lockwasher	2
35-P-93	Gasket Cover Plate	1	500457-6	Slotted Screw	2
Safety Guide	HY25-1002-M1/US	1	379904	Push Connector	1
329431-2X	Service Kit, Sealing (AC Input)		328388-47X	12V Electric Over	
22-P-115	Gasket Housing / Backplate	1	328388-46X	Inst Kit Parts Bag	1
28-P-41	O-Ring Shifter Rod	1	378414	Pressure Port	1
28-P-278	Oil Seal Output Shaft	1	378881	Rocker Switch	1
35-P-93	Gasket Cover Plate	1	378978	Indicator	1
35-P-94	Gasket Mounting	1	379044-7	Nylon Tubing	1
Safety Guide	HY25-1002-M1/US	1	379252	Butt Connector	2
			379258	Bracket	1
329431-3X	Service Kit, Sealing (AD Input)		379303-1	Valve 12V	1
22-P-115	Gasket Housing / Backplate	1	379336	Switch Bracket	1
28-P-41	O-Ring Shifter Rod	1	379254-3	Wire, Green	1
28-P-278	Oil Seal Output Shaft	1	379106	Breather-Cap	1
35-P-93	Gasket Cover Plate	1	379640	Booted Connector	1
35-P-97	Gasket Mounting	1			
Safety Guide	HY25-1002-M1/US	1			
			328388-48X	24V Electric Over	
329432-1X	Service Kit, Bearing (AA,AB,AM)		379640	Booted Connector	1
378098	Snap Ring (Input Shaft)	1	328388-46X	Inst Kit Parts Bag	1
378477	Snap Ring (Output Shaft)	1	378414	Pressure Port	1
379918	Snap Ring (Shifter Rod)	1	378881	Rocker Switch	1
379919	Snap Ring (Internal)	1	379005	Indicator	1
560990	Ball Bearing (Input Shaft)	1	379044-7	Nylon Tubing	1
561016	Bearing Needle Roller (Input Shaft)	1	379252	Butt Connector	1
561017	Bearing Cylindrical Roller (Output Shaft)	1	379258	Bracket	1
561018	Ball Bearing (Output Shaft)	1	379303-2	Valve 24V	1
			379336	Switch Bracket	1
329432-2X	Service Kit, Bearing (AC & AD)		379106	Breather-Cap	1
378098	Snap Ring (Input Shaft)	1	379254-3	Wire, Green	1
378477	Snap Ring (Output Shaft)	1			
379918	Snap Ring (Shifter Rod)	1	328388-82X	Air Shift Kit Freedomline	
379919	Snap Ring (Internal)	1	378416	Hex Nipple	1
550010	Ball Bearing (Input Shaft)	1	379042	Male Connector	3
560990	Bearing Needle Roller (Input Shaft)	1	379043	Male Elbow	1
561017	Bearing Cylindrical Roller (Output Shaft)	1	379253	Ring Connector	1
561018	Ball Bearing (Output Shaft)	1	379257	Splice Connector	1
			500357-7	Lockwasher	2
328388-37X	Air Shift		500457-6	Slotted Screw	2
328388-44X	Air Shift	1	378414	Pressure Port	1
329090-1X	Valve Kit	1	379044-7	Nylon Tubing	1
379044-7	Nylon Tubing	1	379258	Bracket	1
379130	Support Bracket	2	75-P-10	Air Solenoid	1
68-P-27	Control Plate	1	75-P-9	Wiring Harness	1
379640	Booted Connector	1	379106	Breather-cap	1
328388-44X	Air Shift Kit		328952-20X	Gasket & Installation Kit	
378416	Hex Nipple	1	328946X	Caution Label Kit	1
378978	Indicator	1	379085-1	P.T.O. Instructions Decal	1
379042	Male Connector	2	379281-1	Gasket, Envelope	1
379043	Male Elbow	1	79624	Product Warranty Card	1
379252	Butt Connector	2	22-P-117	Mounting Gasket	1
500357-7	Lockwasher	8	Safety Guide	HY25-1002-M1/US	1
500376-6	Nut 10-24	4			
500448-9	Screw Slot	4			
379900	Ass'y Fuse	1			
379904	Push Connector	1			

328952-21X	Gasket and Caution Label	1
35-P94	Mounting Gasket.....	1
8000-18X	Stud Kit	
379676-15	Capscrew Socket Head M12 x 80 Lg (1.75 Pitch)	4
379140-7	M12 Lockwasher.....	4
8000-20X	Adapter Plate Mounting Kit	
379740-7	Capscrew Socket Head M10 x 30 LG (1.5 Pitch).....	9
379140-8	Lockwasher M10.....	7

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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.

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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.

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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.

10/09-P



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