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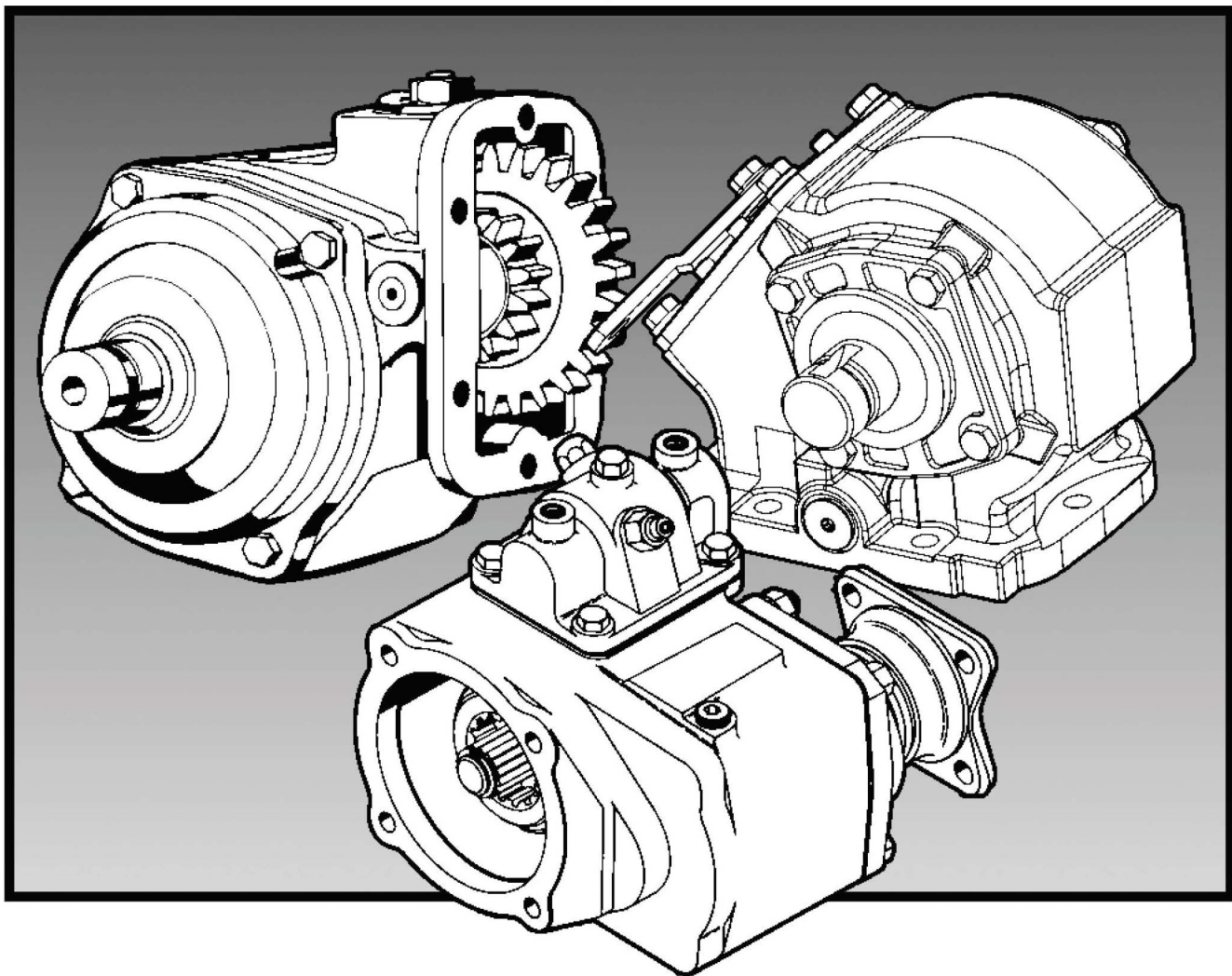
# CHELSEA<sup>®</sup>

## Replacement Parts List

### 912 Series Manual

Bulletin HY25-2912-M1/US

Effective: December 15, 2001  
Supersedes: P410-912 Dated March 2000



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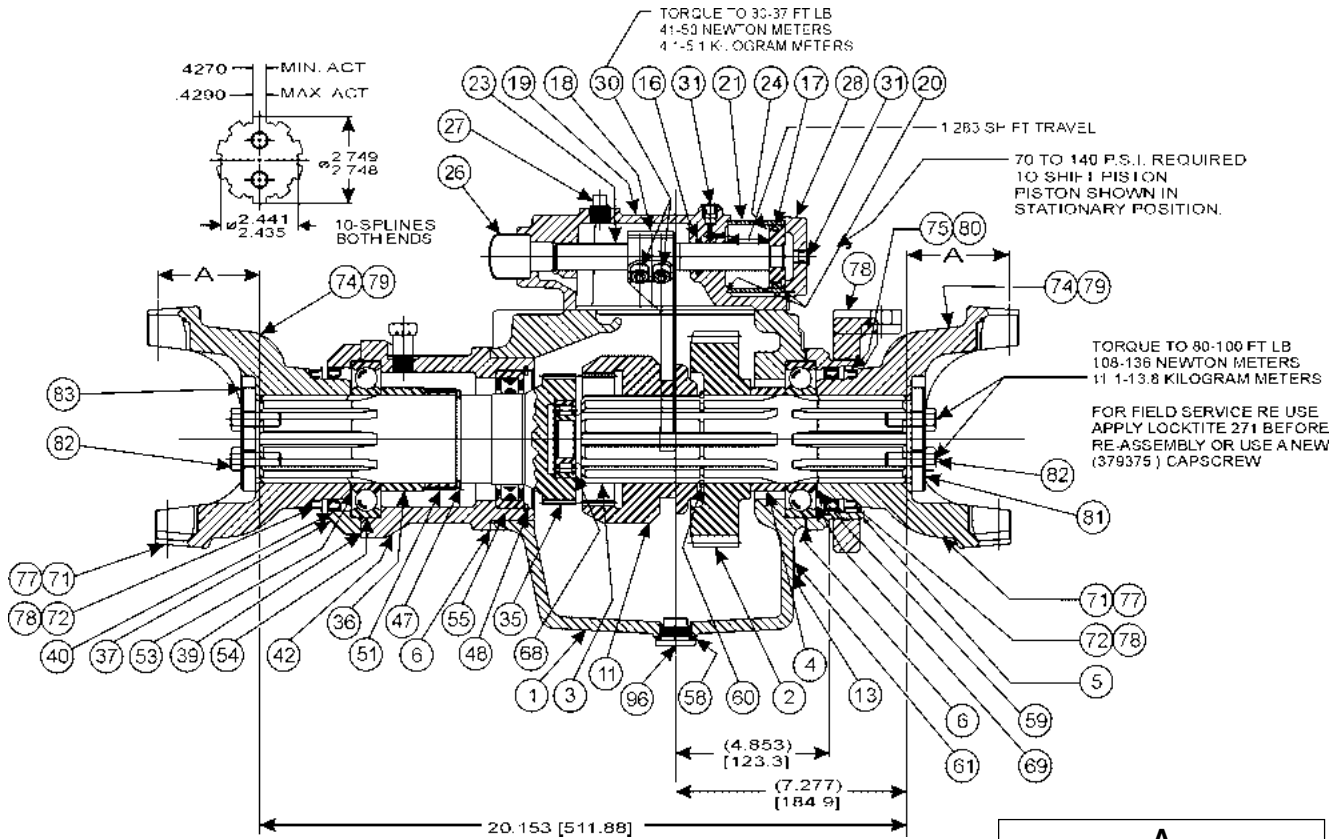
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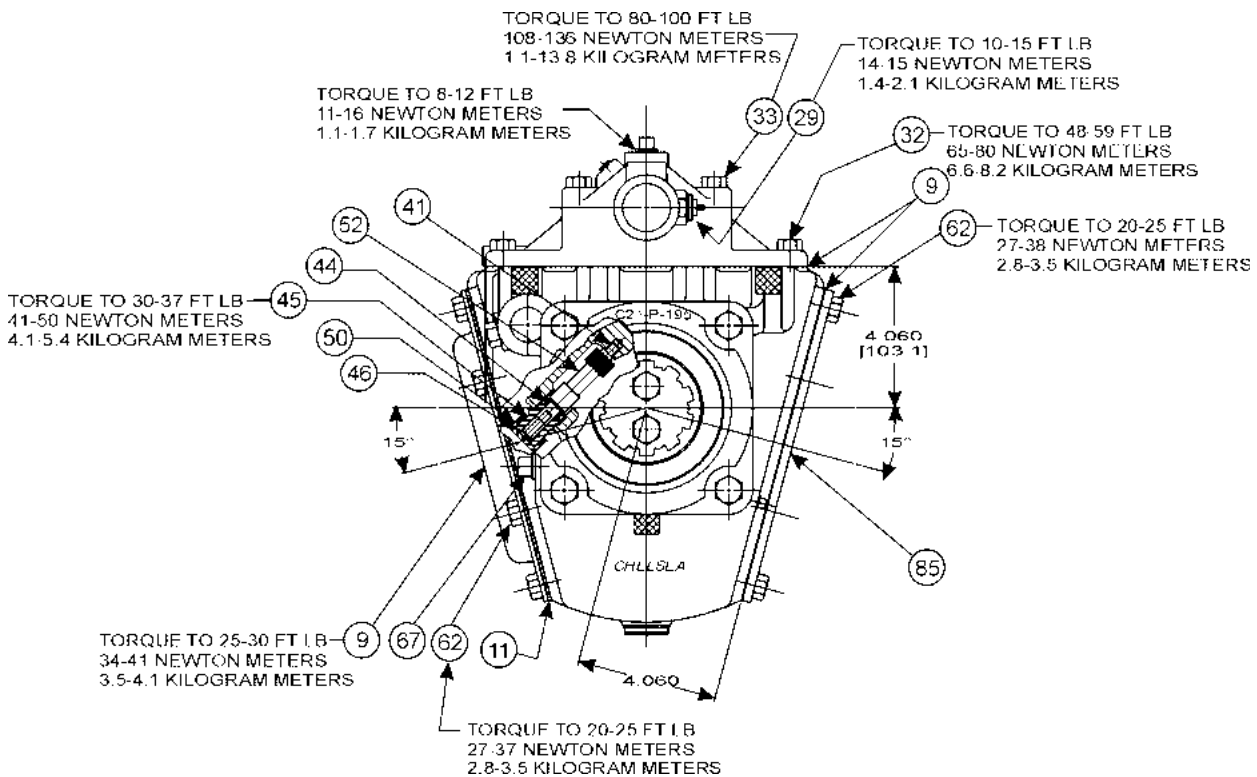
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SPL-250 .....	3.538 [89.86]
1810 .....	3.300 [83.82]
1610 Flange ..	1.253 [31.83]



**Bill of Materials**

Item	Part Number	Description	Quantity
1	1-P-484	Housing (912 Series) .....	1
2	2-P-710	P.T.O. Drive Gear .....	1
3	3-P-848	Drive Shaft, Input .....	1
4	4-P-87	Spacer, Bearing .....	1
5	21-P-513	Bearing Retainer, Input .....	1
6	22-P-45	Gasket .....	2
7	28-P-237	Oil Seal .....	1
9	34-P-53	Cover Plate .....	2
10	35-P-15-2	Gasket, Cover (.020" Thick) .....	2
11	35-P-32	Gasket, Cover Plate (.094" Thick) .....	1
12	57-P-11	Sliding Clutch .....	1
13	68-P-2	Name Plate .....	1
	<b>329063X</b>	<b>AIR SHIFT COVER ASSEMBLY, 912 Series .....</b>	<b>1</b>
16	28-P-114	O-Ring .....	1
17	28-P-115	O-Ring .....	1
18	32-P-164	Shifter Fork .....	1
19	34-P-109	Shifter Cover .....	1
20	35-P-30	Gasket .....	2
21	65-P-13	Cyl. Air Shift .....	1
	<b>329064X</b>	<b>Shifter Shaft Sub Assembly .....</b>	<b>1</b>
23	11-P-148	Shifter Shaft .....	1
24	66-P-8	Piston .....	1
25	378431-26	Cap Screw, Hex Head .....	2
26	378473	Plug, Housing .....	1
27	378513	Breather .....	1
28	378838	Cylinder Cap .....	1
29	379652	Indicator Switch .....	1
30	379374	Capscrew, Socket Head .....	2
31	500897-3	Shipping Plug .....	2
32	378432-11	Cap Screw, Hex Head (.438"-14 x 1.125") w/Patch .....	6
33	378432-26	Cap Screw, Hex Head (.438"-14 x 3.00") w/Patch .....	2
	<b>329065X</b>	<b>Tail Shaft Sub ASSEMBLY (Items 35-55) (Ref. 3.750" Dia. Hub) .....</b>	<b>1</b>
	<b>329098X</b>	<b>Tail Shaft Sub ASSEMBLY, No Speedo (Items 35-55, Less Items 44 &amp; 45) .....</b>	<b>1</b>
35	3-P-821	Output Shaft .....	1
36	4-P-145	Spacer, Output Shaft .....	1
37	21-P-512	Bearing Cap Output .....	1
N.S.	378513	Breather .....	1
39	22-P-85	Gasket, Output Cap .....	1
40	28-P-237	Oil Seal .....	1
41	45-P-7	Bushing .....	1
42	54-P-20	Bearing Retainer .....	1
	<b>328984X</b>	<b>Bushing Assembly, Speedo .....</b>	<b>1</b>
44	28-P-181	Seal .....	1
45	379337	Bushing .....	1
46	378309	Gasket Dust Cap .....	1
47	378357	Lockring .....	1
48	378359	Lockring .....	1
49	378433-12	Capscrew, Hex Head .....	4
50	378512	Dust Cap .....	1
51	379322	Gear, Speedo-Drive .....	1
52	379333	Gear, Speedo-Driven .....	1
53	379479	Gasket, Shaft .....	1
54	550574	Ball Bearing .....	1
55	550811	Roller Bearing .....	1
57	378116	Drain Plug .....	1
58	378117	Gasket, Copper .....	1
59	379479	Gasket, Shaft .....	1

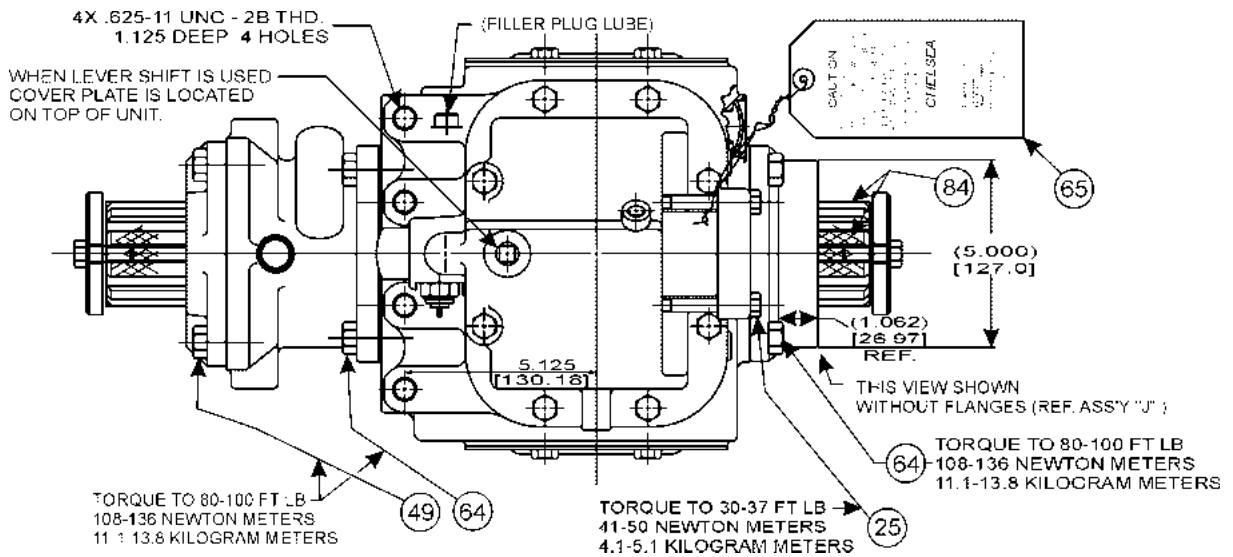
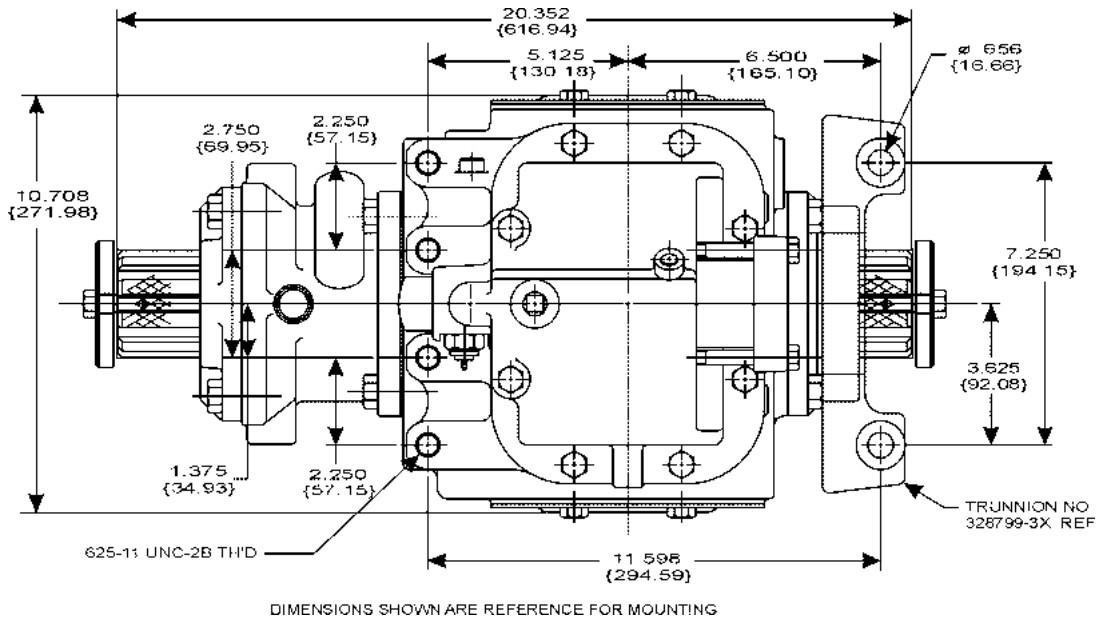
N.S. — Not Shown

A.R. — As Required

Item	Part Number	Description	Quantity
60	378357	Retaining Ring .....	1
61	378422	Drive Screw .....	2
62	378432-9	Capscrew, Hex Head (.438"-14 X .875") w/Patch .....	10
64	378433-12	Capscrew, Hex Head (.500"-13 X 1.25") w/Patch .....	8
65	379334	Oil Level Caution Tag w/Wire Tie .....	1
67	500114-3	Pipe Plug (.500"-14 N.P.T.F.) .....	1
68	550443	Roller Bearing .....	1
69	550574	Ball Bearing .....	1
<b>END YOKE OPTIONS</b>			
	6-4-6931-1X	End Yoke & Slinger Ass'y, 1710 Series (1/2 Round) .....	2 or
71	6-4-6821-1	Yoke, 1710 Series .....	1
72	231616	Slinger (Ref. Spicer No.) .....	1
	6.5-4-3561-1X	End Yoke & Slinger Ass'y, 1810 Series (1/2 Round) .....	2 or
74	6.5-4-3491-1	Yoke, 1810 Series .....	1
75	231616	Slinger (Ref. Spicer No.) .....	1
	170-4-521-1X	End Yoke & Slinger Ass'y, SPL170 Series (1/2 Round) .....	2 or
77	170-4-511-1	Yoke, SPL170 Series .....	1
78	231616	Slinger (Ref. Spicer No.) .....	1
	250-4-241-1X	End Yoke & Slinger Ass'y, SPL250 Series (1/2 Round) .....	2 or
79	250-4-231-1	Yoke, SPL250 Series .....	1
80	231616	Slinger (Ref. Spicer No.) .....	1
	5-1-6611X	Companion Flange Ass'y .....	2
N.S.	2-5-6601	1610 Companion Flange .....	1
N.S.	231616	Slinger (Ref. Spicer No.) .....	1
81	328799-3X	Trunnion Block .....	1
82	379375	Capscrew, Hex Head (.500"-20 X 1.250") w/Drylock 200 .....	4
83	379350	Washer Lock Plate .....	2
84	379372	Protective Shipping Net (Red) ("J" Assembly Only) .....	2
85	378280	Shipping Cover .....	1
<b>LOOSE PARTS</b>			
	328388-39X	Installation Kit, Air Shift .....	1
<b>SERVICE PARTS</b>			
	328948-10X	Gasket & Installation Instructions .....	1
	328356-62X	Seal Kit, Air shift	
	328356-63X	Seal Kit, w/Speedometer	
	328356-64X	Seal Kit, w/o Speedometer	
	328356-65X	Seal Kit, Lever Shift	

N.S. — Not Shown

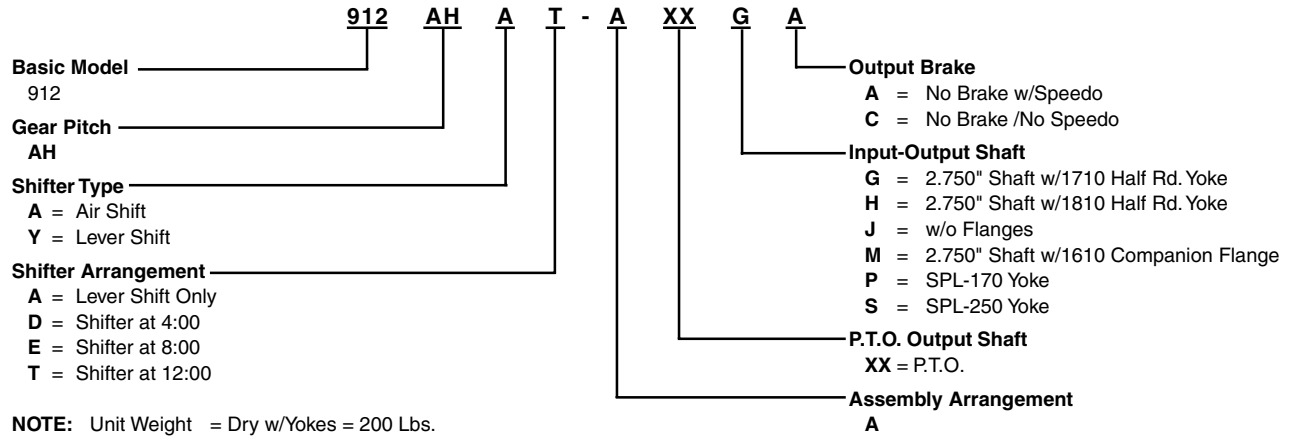
A.R. — As Required





**Model Number Designation**

**Power Take-Off  
912 Series**



**NOTE:** Unit Weight = Dry w/Yokes = 200 Lbs.  
 Oil Capacity = 2.5 Qts. (Less P.T.O.)  
 Type of Lube = S.A.E. 30 or S.A.E. 50 Wt.





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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.

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**4. Warranty:** Seller warrants that the items sold hereunder shall be free from defects in material or workmanship for a period of:

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9/01-P

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