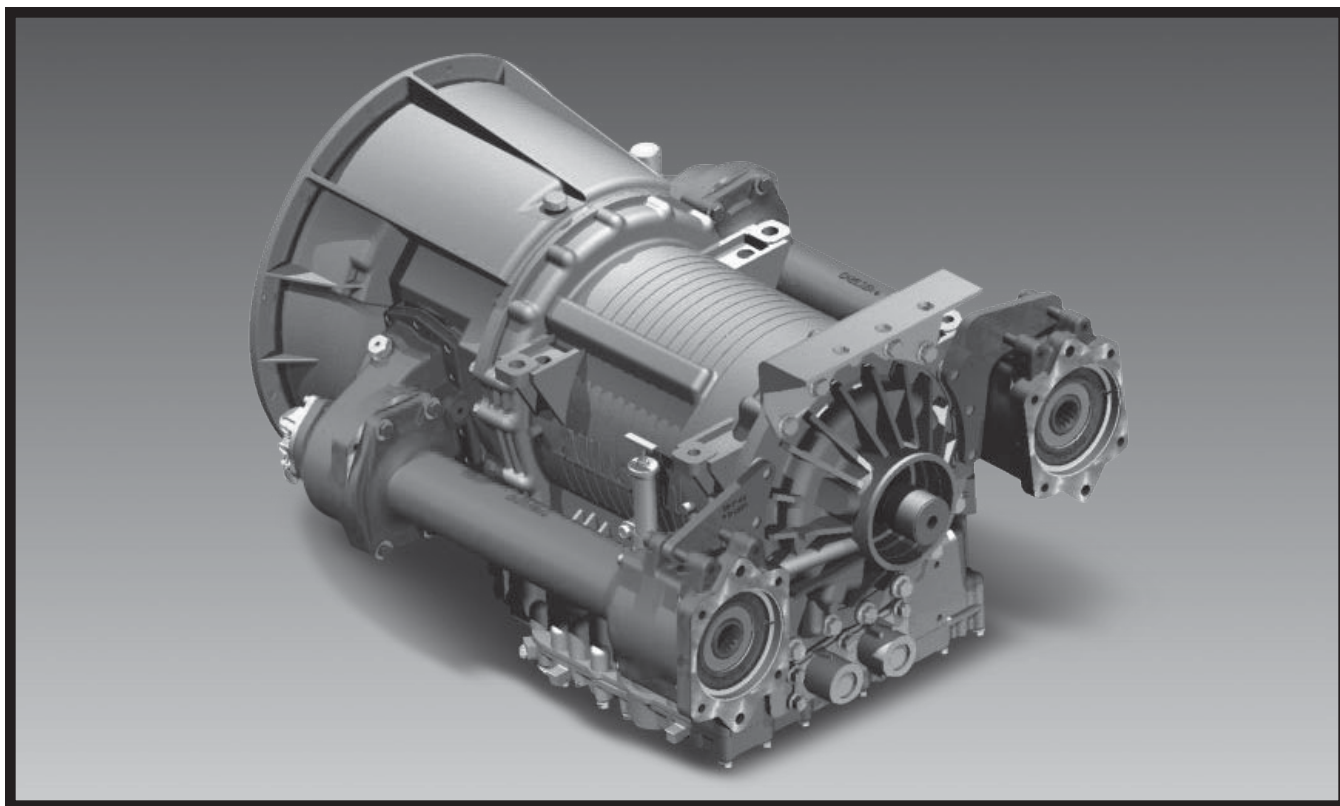


CHELSEA[®]

Bulletin HY25-1890-M1/US

Owner's Manual Power Take-Offs

Effective: June 2010
Supercedes: HY25-1890-M1/US January 2010



**890 Series
891 Series**

**897 Series
898 Series**





WARNING — User Responsibility

FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS 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 or system options for further investigation by users having technical expertise.

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.

To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.

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 7510064 US7690450 B2
Other patents pending.

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General Information

Safety Information	1-2
Direct Mount Pump Recommendations	3
Foreword	4
Chelsea P.T.O. Safety Label Instructions	4-5
Function of Auxiliary Power Shafts	6
Spicer® Universal Joint Engineering Data	7
P.T.O. Pre Installation 890/897 Series	8-9
Mounting the P.T.O. on the Transmission 890/897 Series	9-12
Installation Sketch "XV", "AB", "AC"	13
Electrical Installation Sketch without E.O.C. for 890/891 Series (SK-459)	14
Electrical Installation Sketch with E.O.C. for 890/891 Series (SK-475)	15
Remote Solenoid 890/891 Series (SK-503)	16
Hose Installation Sketch for 890/891 Series (SK-504)	17
Bracket Installation for 890/891 Series	17
Hose Installation Sketch for 897/898 Series (SK-492)	18
Bracket Installation for 897/898 Series	18
Installation Mounting Kit Instructions	19
Pressure Port and Aperture Opening Identification	19
Wet Spline Output Cover Plate	20
P.T.O. Pre Installation 891/898 Series	21-22
Mounting the P.T.O. on the Transmission 891/898 Series	22-25
P.T.O. Shifting Procedure & Precautions	26
P.T.O. Maintenance	27
Offer of Sale	31

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 to 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. 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.

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 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 (Continued)

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

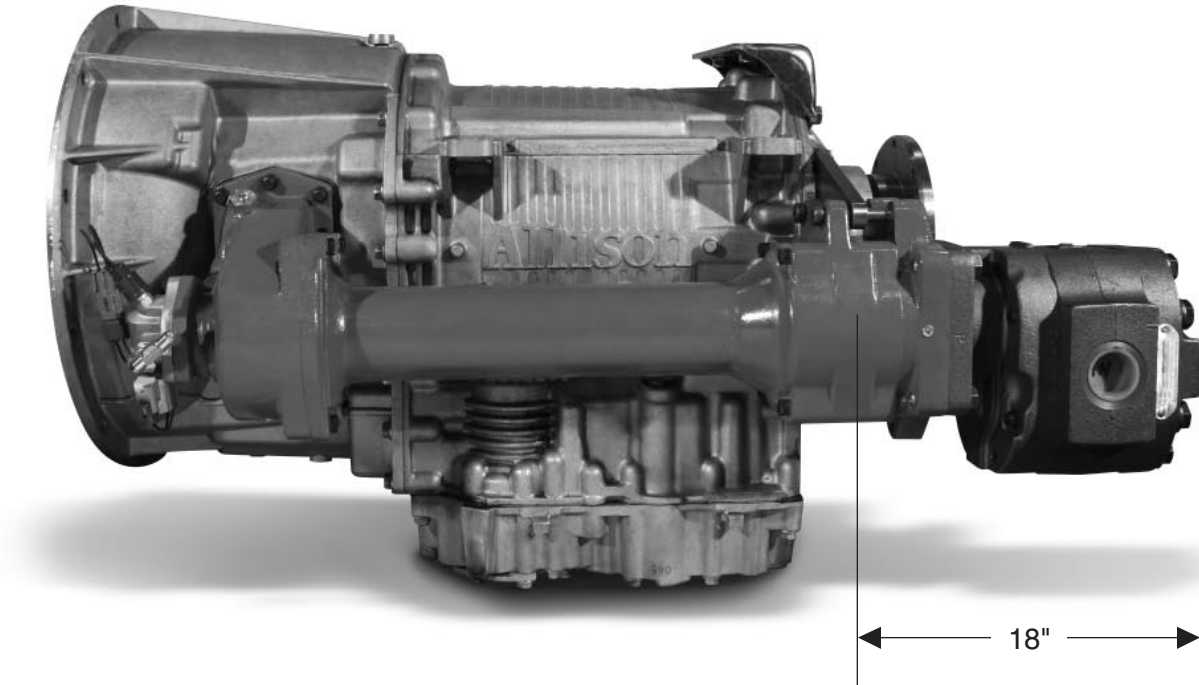
Some Power Take-Offs may be operated when the vehicle is in motion. To do so, the P.T.O. must have been properly selected to operate at highway speeds and correctly matched to the vehicle transmission and the requirements of the driven equipment.

If in doubt about the P.T.O. 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 premature 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.

Direct Mount Pump Recommendations



 **Use caution to ensure that bracket does not pre-load pump/P.T.O. mounting**

Chelsea strongly recommends the use of pump supports (Support Brackets) in all applications. P.T.O. warranty will be void if a pump bracket is not used when:

- 1) The combined weight of pump, fittings and hose exceed **120 pounds [54.43 kg]**.
- 2) The combined length of the P.T.O. and pump is **18 inches [45.72 cm]** or more from the P.T.O. centerline to the end of the pump.

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 ensure 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 directly 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	1.750	1.250	2.500	3.00
Wall Thickness	.065	.095	.083	.083
W = Welded S = Seamless	W	S	W	W
Flange Diameter (Swing Diameter) Rectangular Type	3.500	3.500	3.875	3.875
Bolt Holes - Flange Yoke Circle	2.750	2.750	3.125	3.125
Diameter	.312	.312	.375	.375
Number	4	4	4	4
Male Pilot Dia.	2.250	2.250	2.375	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"

P.T.O. Pre Installation

1. At installation, the input housing is installed to the transmission first. The 890/897 comes from the factory assembled. Remove the 4 bolts that connect the tube section to the input housing (**Fig. 1**).

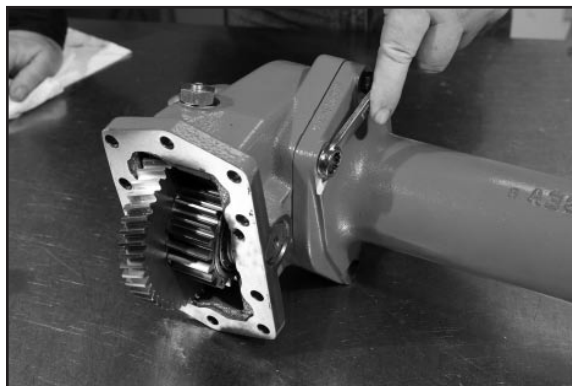


Fig. 1

2. Split the input from the output tube assembly. It will be tight because of the installed O-Ring seal. O-Ring must be installed into the O-Ring groove on the tube pilot shoulder (**Fig. 2**).

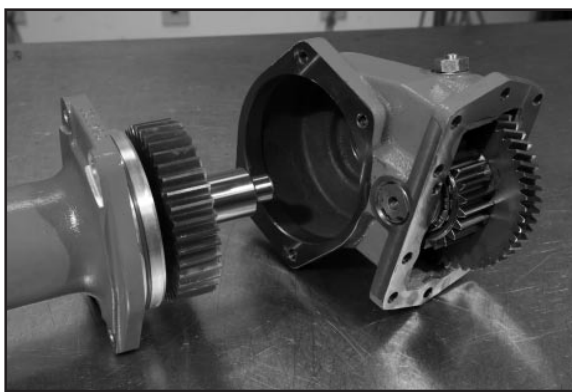
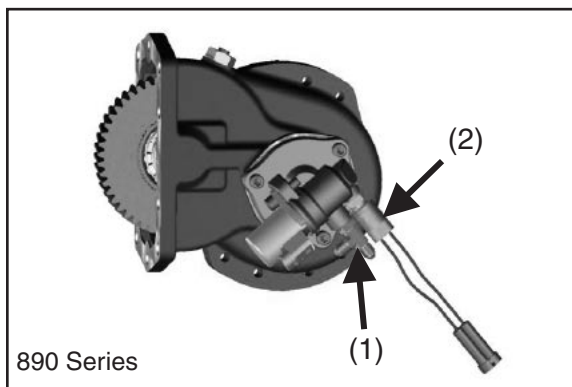


Fig. 2

NOTE: If O-Ring is damaged replace with one supplied with P.T.O. Unit

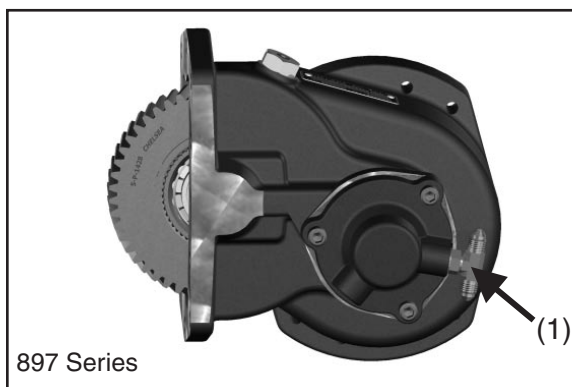
3. Install the "T" fitting (1) into the pressure port on the valve cap as shown. Torque to 156-180 Lbs. in [18-20 N.m.] Next install the pressure switch (890 Series Only) (2) into the port in the valve cap as shown and torque to 120-140 Lbs. in [14-16 N.m.] (**Fig. 3**) (**Fig. 3a**).



890 Series

Fig. 3

NOTE: See Hose Installation Sketch SK-504 (890 Series) on [page 17](#) and SK-492 (897 Series) on [page 18](#).



897 Series

Fig. 3a

P.T.O. Pre Installation (Continued)

When installing a P.T.O., always wear protective clothing and safety glasses.

- The suitable (by transmission model) **Mounting Bracket (50-P-62 for the HD left side, 50-P-60 for the MD left side and 50-P-61 for the MD right side)**, is attached to the P.T.O. output end using the **Shoulder Cap Screws**. Torque to 30-35 Lbs. ft. [41-47 N.m.]([Fig. 4 & 4a](#)). (See Charts on [page 17 & 18](#))

NOTE: Lightly lube the cap screw shaft to help with installation.



Fig.4



Fig. 4a

Mounting the P.T.O. on the Transmission

- Begin by draining the oil from the transmission. Use caution, since the oil may be hot ([Fig. 5](#)).

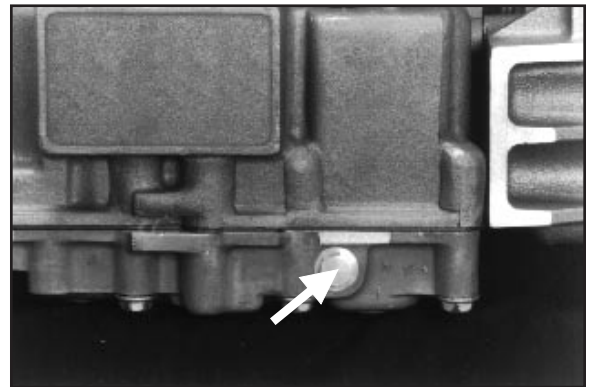


Fig. 5

- Remove the P.T.O. aperture plate with a 15mm socket ([Fig. 6](#)).

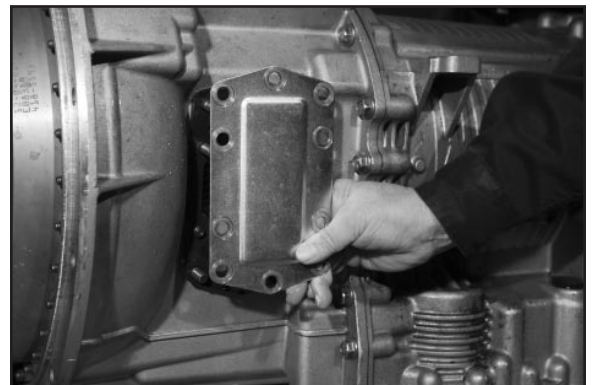


Fig. 6

Mounting the P.T.O. on the Transmission (Continued)

7. Remove the gasket and clean the aperture surface (**Fig. 7**).

NOTE: Do not reuse the gasket that comes with the transmission.

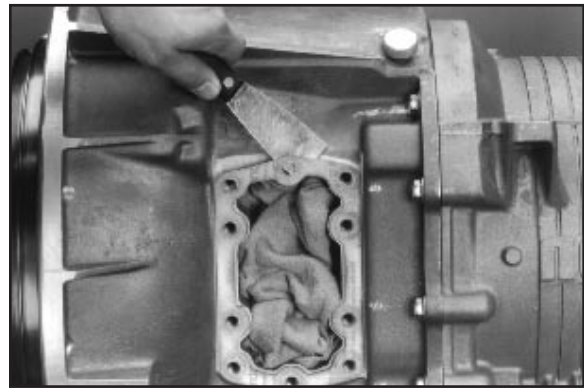


Fig. 7

8. Using a screwdriver, install the dowel pins until they bottom out (**Fig. 8**) (Refer to [page 19](#) for correct location and use).

NOTE: Do not use sealing compounds because they are generally incompatible with automatic transmission fluid.

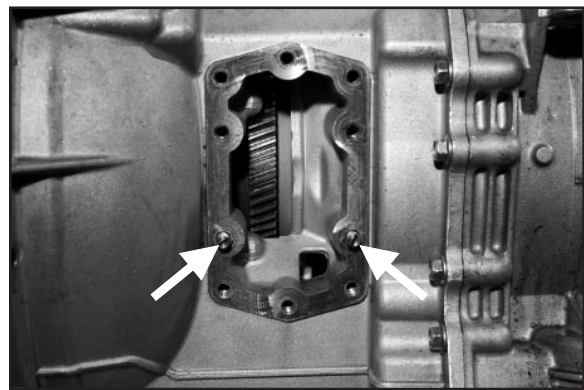


Fig. 8

9. Install the special gasket over the guide pins. The ribbed surface should face outward, toward the installer (**Fig. 9**).

NOTE: To ensure proper backlash and sealing of P.T.O. to transmission, only use gasket furnished with the P.T.O.



Fig. 9

10. Install the remaining capscrews. Torque all to 40 - 50 Lbs. ft. (54 - 68 N.m. or 5.5 - 6.9 Kg.m) (**Fig. 10**).



Fig. 10

Mounting the P.T.O. on the Transmission (Continued)

11. Securely attach the high pressure line to the P.T.O. valve "T" fitting (1), torque to 11-12 Lbs. ft. [15-16 N.m.] (**Fig. 11**) (**Fig. 11a**).

NOTE: For 890 Series see SK-504 [page 17](#) for complete plumbing installation of the transmission pressure hose and the wet spline hose. See [page 18](#) for the 897 Series

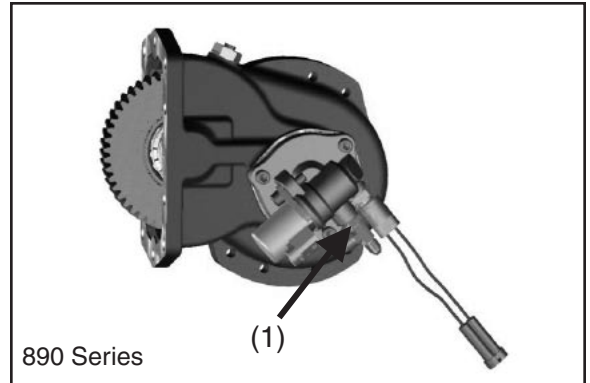


Fig. 11

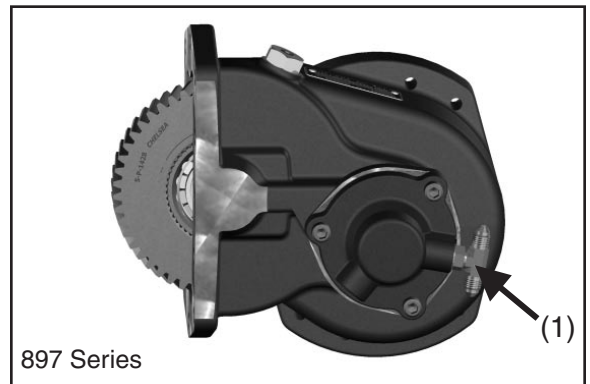


Fig. 11a

12. Install elbow fitting supplied with P.T.O. into transmission main pressure port and torque nut to 13 - 15 Lbs. ft. or 156-180 pds-in. See chart on [page 19](#) for pressure port locations.
- 12a. Securely attach the high pressure line to the elbow fitting at the transmission high pressure port and torque to 11-12 Lbs. ft. [15-16 N.m.]. This fitting is included with the P.T.O. (**Fig. 12**).

NOTE: See SK-504 [page 17](#) for complete plumbing installation of the transmission hose and the wet spline hose.

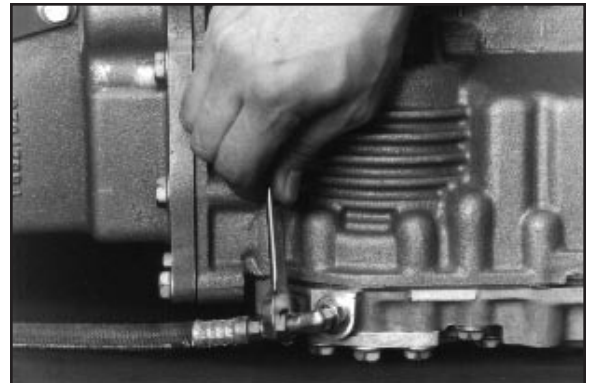


Fig. 12

13. The 3 bolts on the transmission that will line up with the bracket holes must be removed. New longer Bolts (380075 M12-1.75" x 55) will be used for mounting the bracket to the transmission. (**Fig. 13 & 13a**).

NOTE: See Bracket Installation Chart on [page 17-18](#).

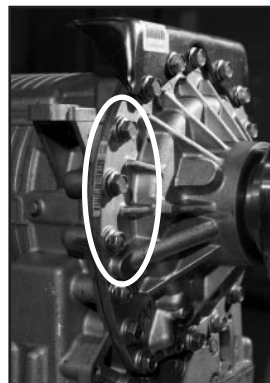


Fig. 13

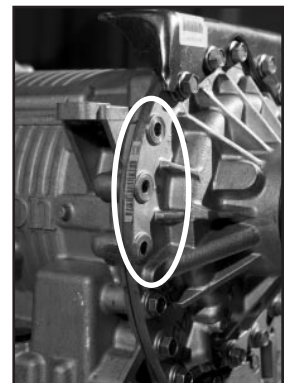


Fig. 13a

Mounting the P.T.O. on the Transmission (Continued)

14. The tube assembly is lined up and inserted into the Input Housing. As this is done, the bolts for the bracket should be started into the rear of the transmission. (**Fig. 14**).
15. As soon as at least 1 bolt is started, the tube assembly cannot fall. The unit can be aligned and slipped together with the transmission taking the weight (**Fig. 15**).

NOTE: When attaching the tube to the input housing use 4 NEW cap screws supplied with the P.T.O.

16. The 4 Hex Head Cap Screws (378431-13, 3/8"-16 x 1.375") and flatwashers 380076-07 make the final attachment between the input housing and the tube assembly. Torque the Cap Screws to 30-35 Lbs. ft. [41-47 N.m.] (**Fig. 16**).
17. The 3 longer bolts in the transmission should be tightened to 75-85 Lbs. ft. [102-115 N.m.] (**Fig. 17**).
18. To complete installation of the P.T.O. see SK drawings on [pages 14-16](#) for wiring and plumbing installation.
19. See SK493 [page 13](#) for installation of "XV", "AB" or "AC" Outputs.
20. When installing pumps use O-Ring supplied with P.T.O. between pump and P.T.O. output. Torque pump bolts to proper torque specifications. Refer to [page 3](#) of this manual for proper pump bracket support requirements.

As with all auxiliary power systems, there are different concerns and needs with varying applications, duty cycles, and driven equipment. Chelsea endeavors to provide options that will ensure trouble free use of our products and system solutions.

For customers that would like an extra level of protection from pump seal leaks, there are double sealed pumps available from Parker to satisfy your needs. Please verify your requirements with your Parker/Chelsea P.T.O. and Pump experts.

⚠ WARNING: Do not run P.T.O. w/wet spline output option if pump is not installed and connected to hydraulic system. Failure to do so may damage P.T.O./Transmission. See [page 20](#) for output cover plate options.

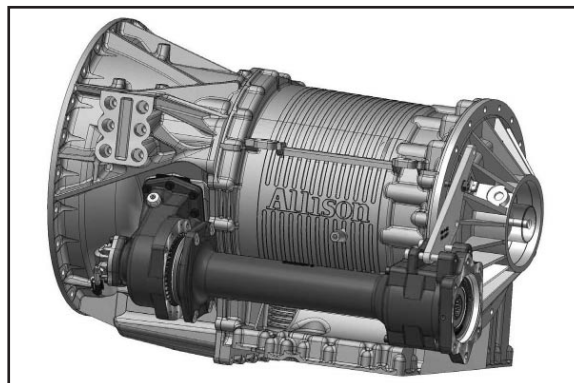


Fig. 14

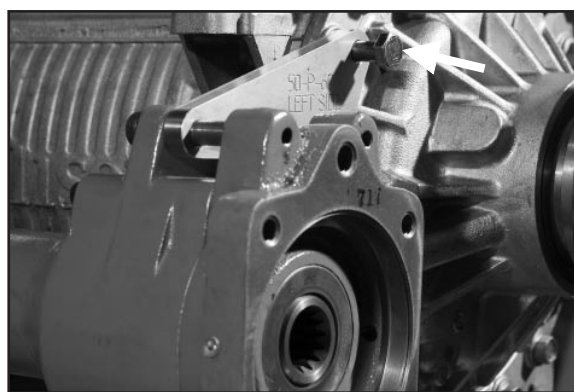


Fig. 15



Fig. 16

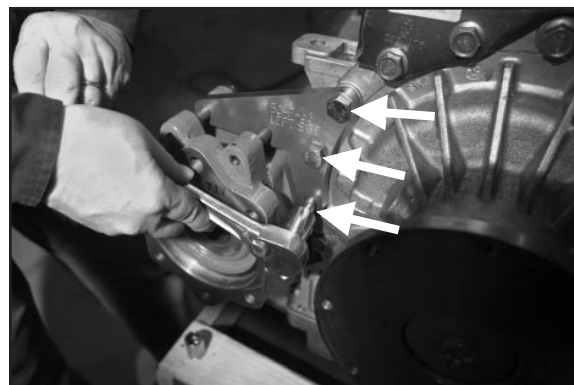
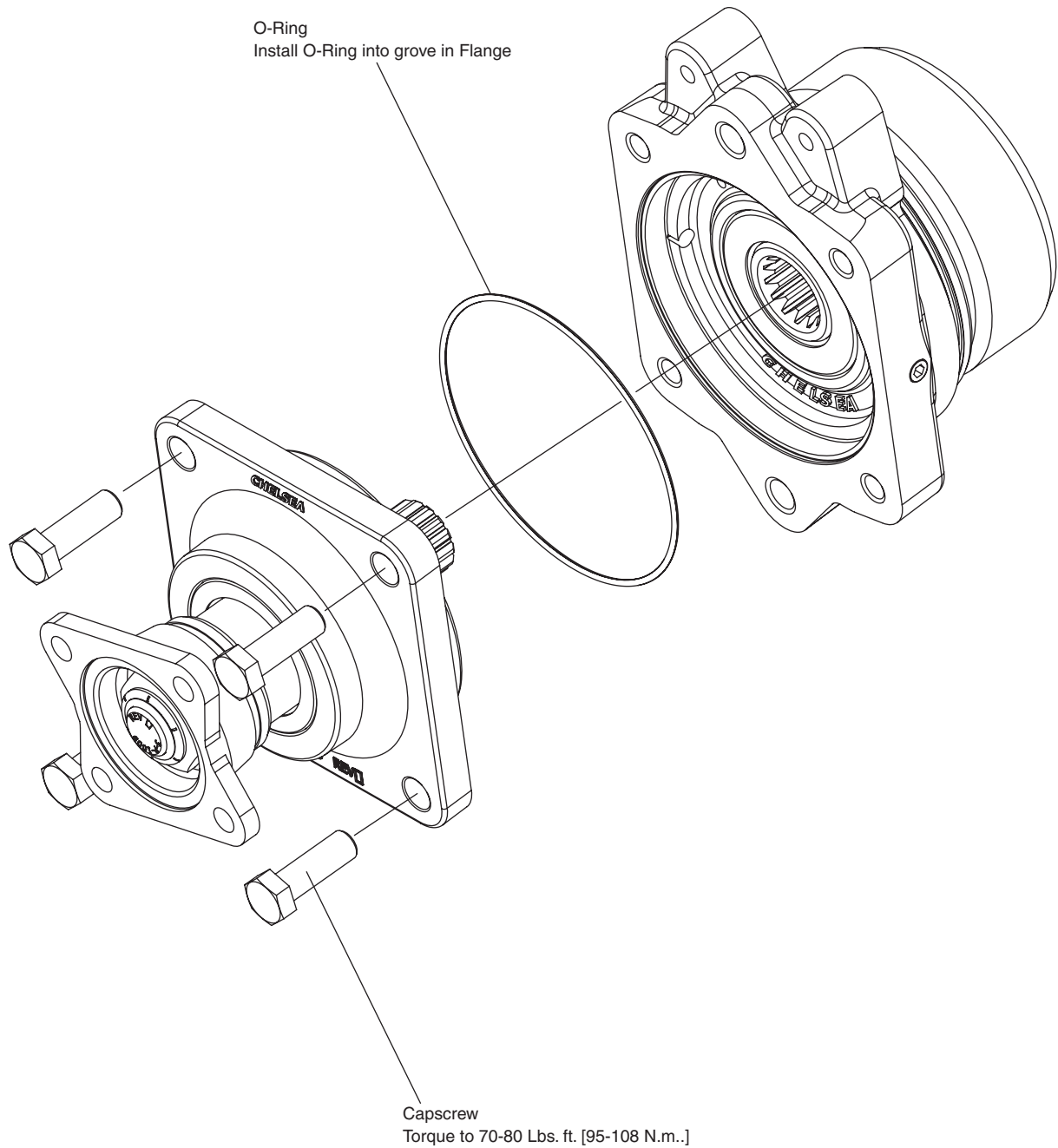
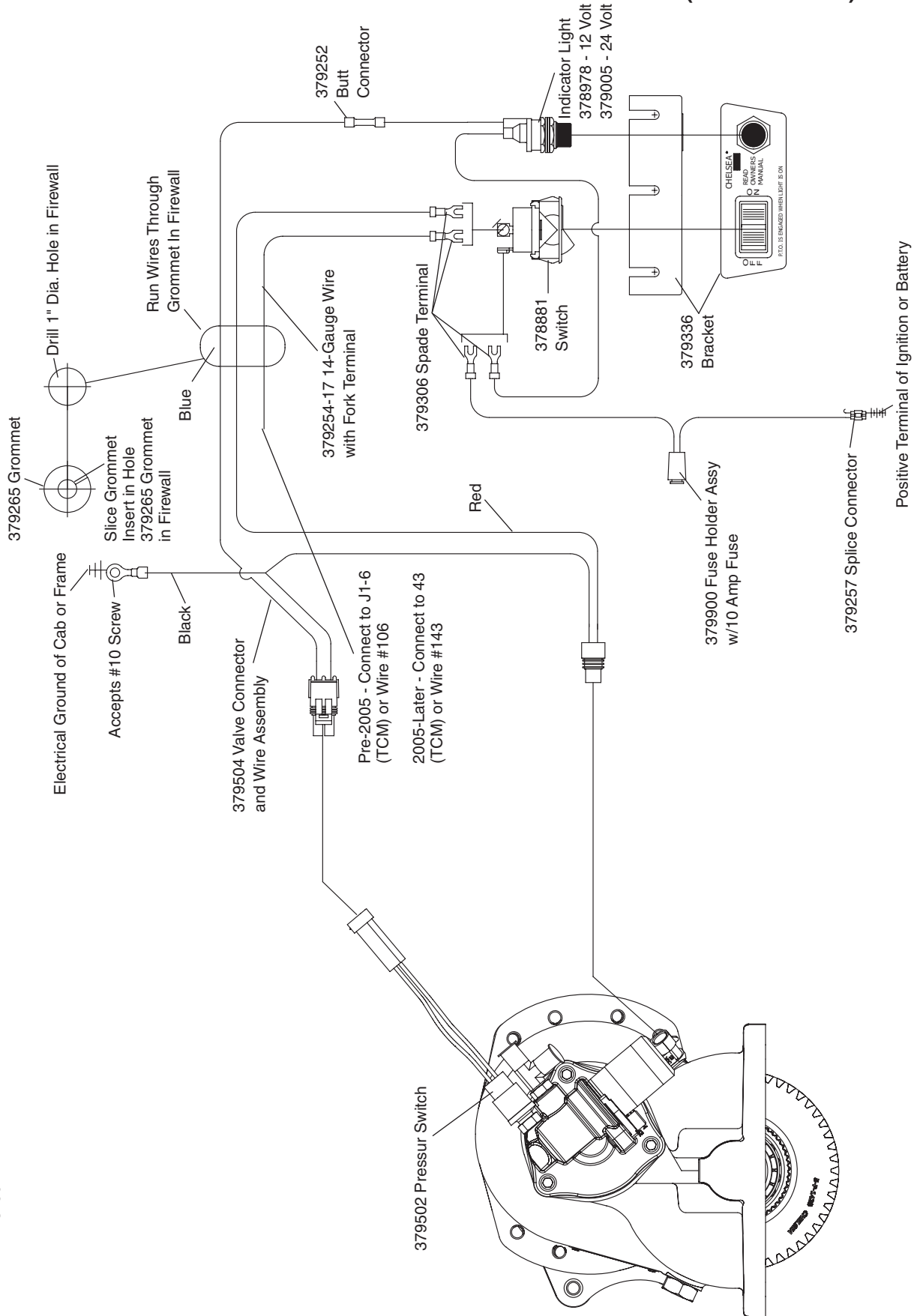


Fig. 17

Installation Sketch "XV", "AB", "AC" Outputs 890/897 Series (SK-493)

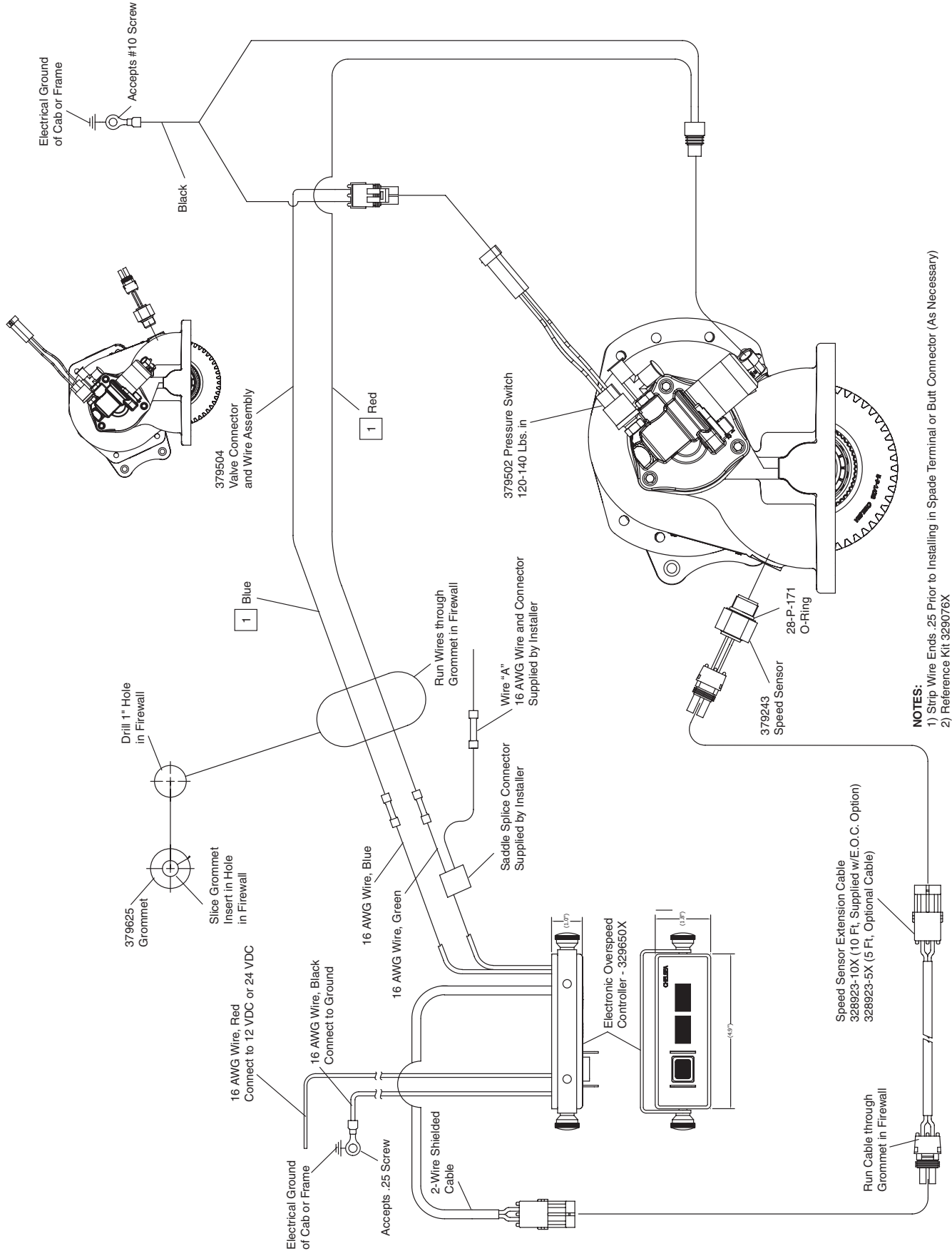


Electrical Installation Sketch without E.O.C. for 890 and 891 Series (SK-459 Rev B)



Strip Wire Ends .25" Prior To Installing in Spade Terminal or Butt Connector (As Necessary)
 Reference Kit 329024-12X For 12 Volt Installation.
 Reference Kit 329024-24X For 24 Volt Installation.

Electrical Installation Sketch with E.O.C. for 890 and 891 Series (SK-475)



NOTES:
 1) Strip Wire Ends .25 Prior to Installing in Spade Terminal or Butt Connector (As Necessary)
 2) Reference Kit 329076X

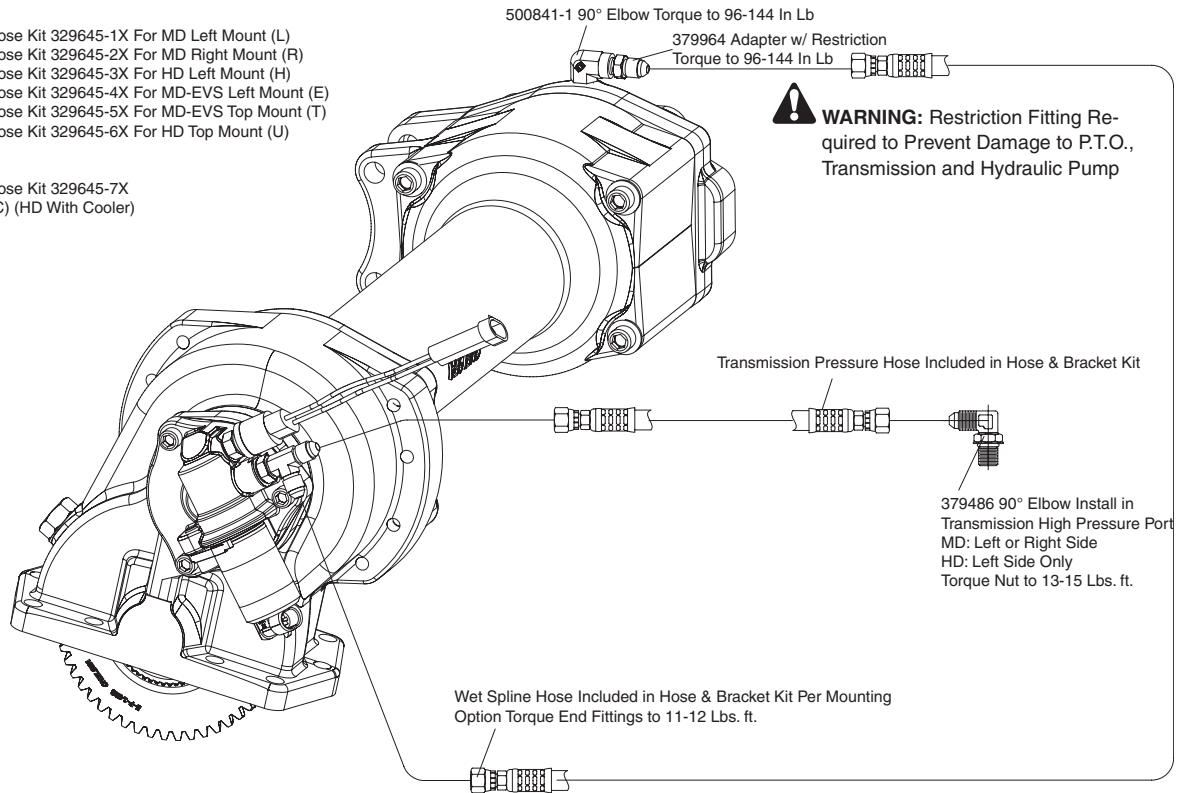
Hose Installation Sketch for 890 and 891 Series (SK-504)

890 Series

- Reference Bracket & Hose Kit 329645-1X For MD Left Mount (L)
- Reference Bracket & Hose Kit 329645-2X For MD Right Mount (R)
- Reference Bracket & Hose Kit 329645-3X For HD Left Mount (H)
- Reference Bracket & Hose Kit 329645-4X For MD-EVS Left Mount (E)
- Reference Bracket & Hose Kit 329645-5X For MD-EVS Top Mount (T)
- Reference Bracket & Hose Kit 329645-6X For HD Top Mount (U)

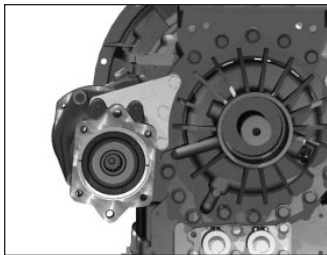
891 Series

- Reference Bracket & Hose Kit 329645-7X For HD-C Left Mount (C) (HD With Cooler)

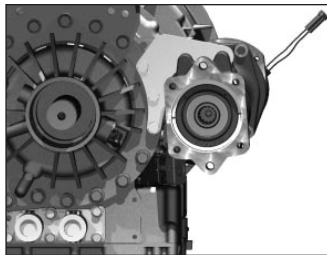


HOSE AND BRACKET CHART 890/891 SERIES (Supplied w/P.T.O.)

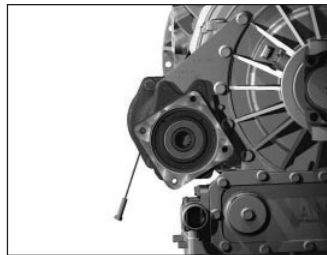
P.T.O.	TRANS	LOCATION	HOSE & BRACKET KIT	HOSE-PRESSURE ¹	HOSE-WET SPLINE ²
890	MD	Left	329645-1X	329130-5X	329130-11X
890	MD	Right	329645-2X	329130-11X	329130-11X
890	HD	Left	329645-3X	329130-4X	329130-11X
890	MD-EVS	Left	329645-4X	329130-5X	329130-11X
890	MD-EVS	Top	329645-5X	329075-2X	329130-11X
890	HD	Top	329645-6X	329075-2X	329130-11X
891	HD w/Cooler	Left	329645-7X	329130-4X	329130-11X



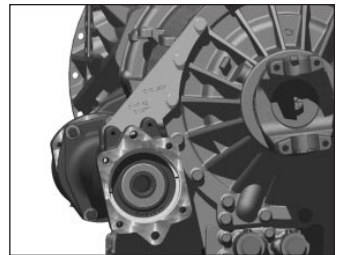
MD Left



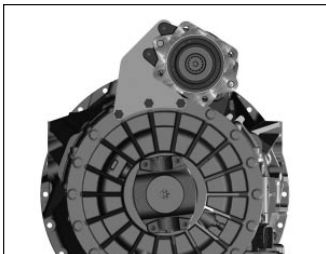
MD Right



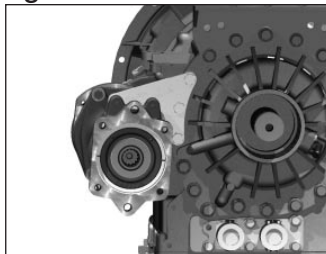
HD Left w/Cooler



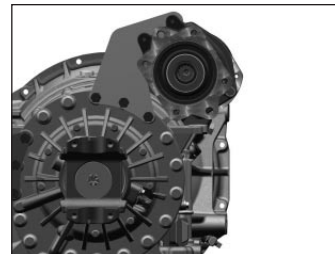
HD Left



HD Top



MD-EVS Left



MD-EVS Top

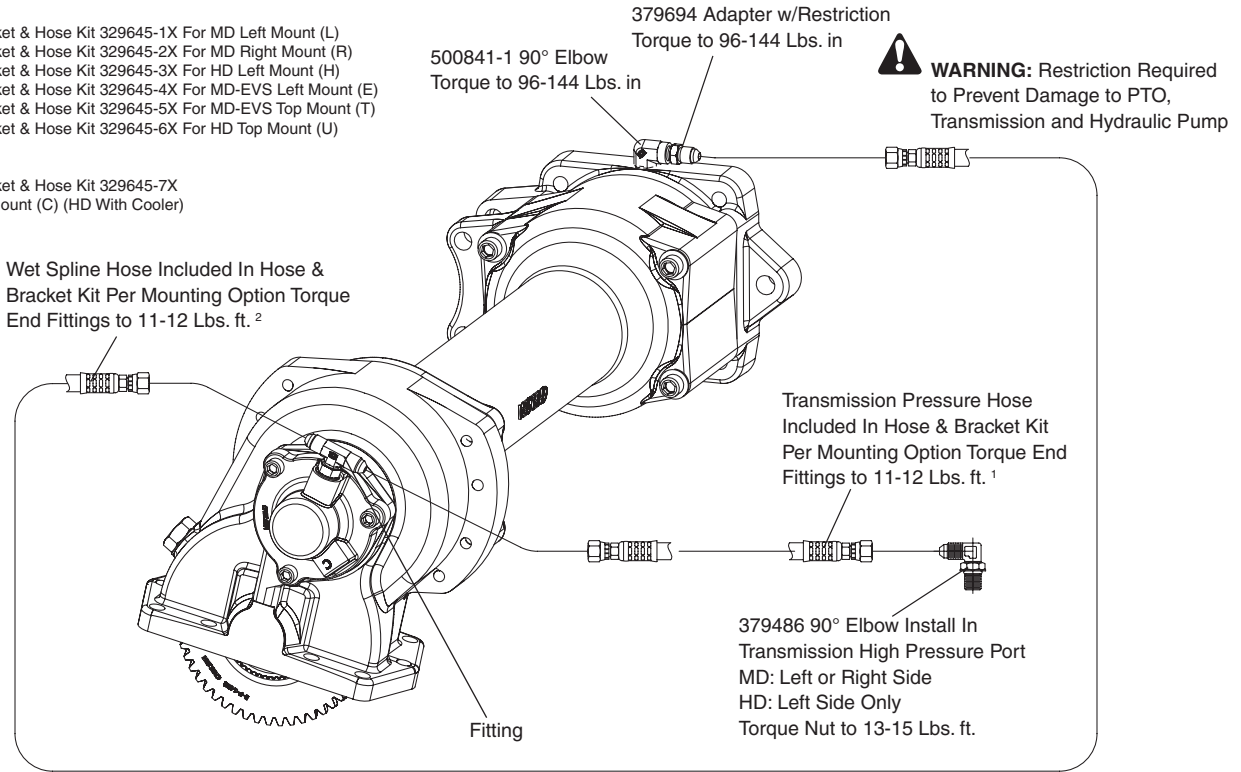
Hose Installation Sketch for 897/898 Series (SK-492 Rev A)

897 Series

- Reference Bracket & Hose Kit 329645-1X For MD Left Mount (L)
- Reference Bracket & Hose Kit 329645-2X For MD Right Mount (R)
- Reference Bracket & Hose Kit 329645-3X For HD Left Mount (H)
- Reference Bracket & Hose Kit 329645-4X For MD-EVS Left Mount (E)
- Reference Bracket & Hose Kit 329645-5X For MD-EVS Top Mount (T)
- Reference Bracket & Hose Kit 329645-6X For HD Top Mount (U)

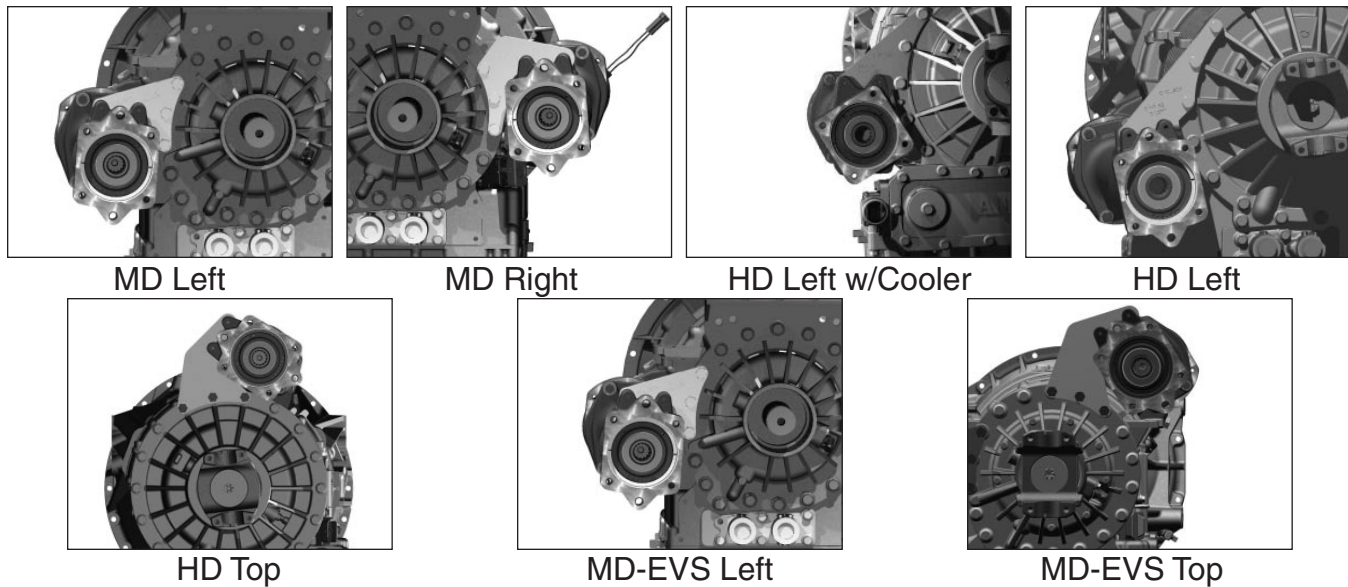
898 Series

- Reference Bracket & Hose Kit 329645-7X For HD-C Left Mount (C) (HD With Cooler)

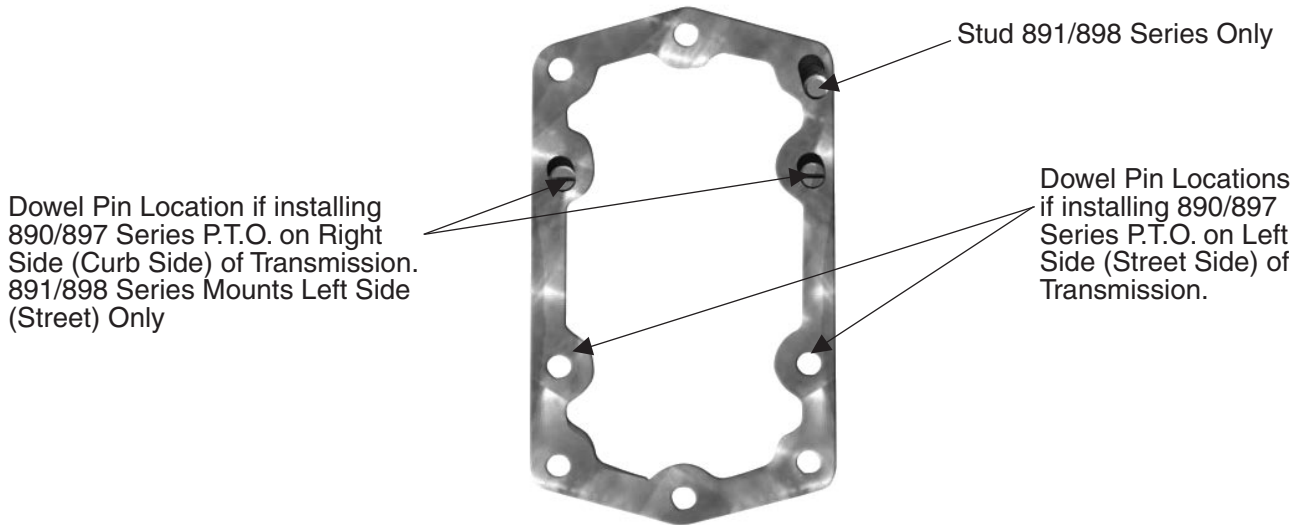


HOSE AND BRACKET CHART 897/898 SERIES (Supplied w/P.T.O.)

P.T.O.	TRANS	LOCATION	HOSE & BRACKET KIT	HOSE-PRESSURE ¹	HOSE-WET SPLINE ²
897	MD	Left	329645-1X	329130-5X	329130-11X
897	MD	Right	329645-2X	329130-11X	329130-11X
897	HD	Left	329645-3X	329130-4X	329130-11X
897	MD-EVS	Left	329645-4X	329130-5X	329130-11X
897	MD-EVS	Top	329645-5X	329075-2X	329130-11X
897	HD	Top	329645-6X	329075-2X	329130-11X
898	HD w/Cooler	Left	329645-7X	329130-4X	329130-11X

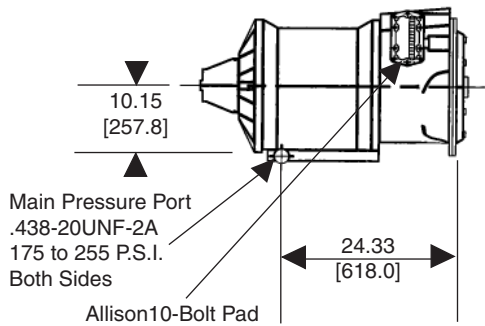


Installation Mounting Kit Instructions

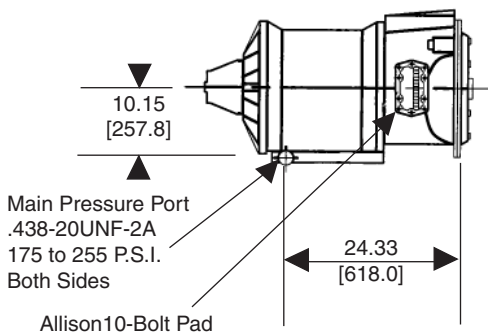
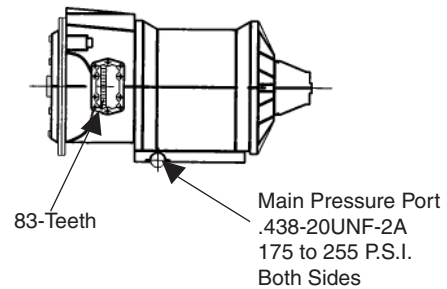


Pressure Port and Aperture Opening Identification

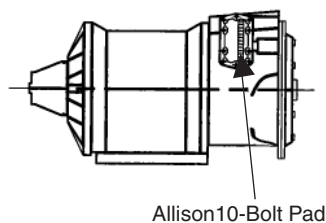
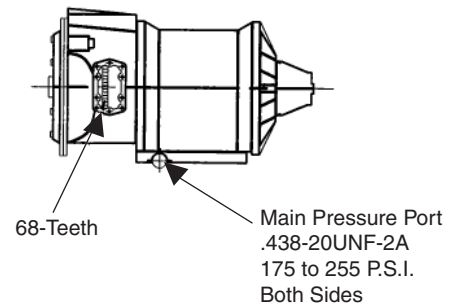
1. These drawings represent left and right views of the MD and HD pressure ports on the transmission.



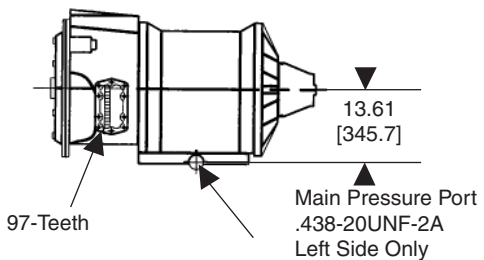
MD
Top/Left



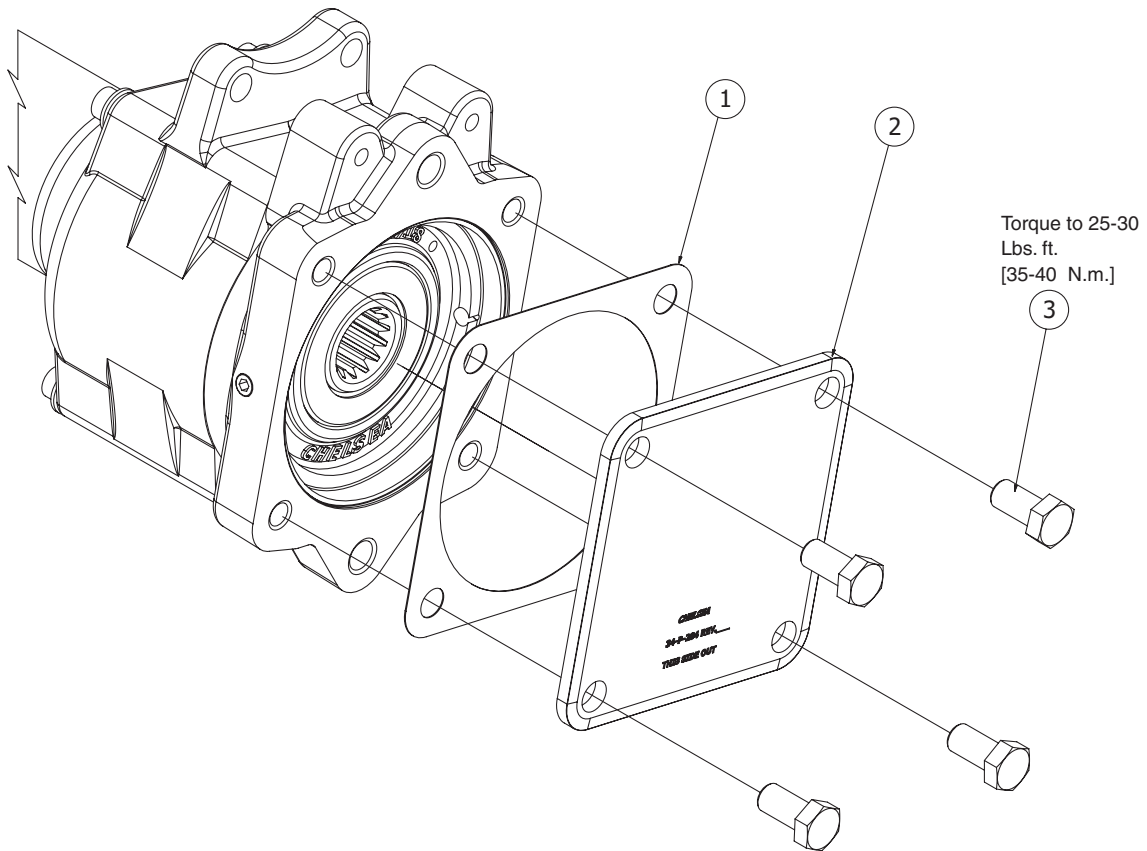
MD
Right/Left



HD
Top/Left



Wet Spline Output Cover Plates



KITS: 329654X "XS", "CS" Output
 329658X "XK", "AF", "AZ", "CK", "CF", "CZ" Output
 329659X "XY", "CY" Output

Item	Part Number	Description	Quantity
1	22-P-25-2 35-P-104 379943	Gasket "XS", "CS" Output Gasket "XK", "AF", "AZ", "CK", "CF", "CZ" Output Gasket "XY", "CY" Output	1 or 1 or 1
2	34-P-284 34-P-285 379940	Cover "XS", "CS" Cover "XK", "AF", "AZ", "CK", "CF", "CZ" Cover "XY", "CY"	1 or 1 or 1
3	378433-10 378433-10 379579-4	Capscrew "XS", "CS" Capscrew "XK", "AF", "AZ", "CK", "CF", "CZ" Capscrew "XY", "CY"	1 or 1 or 1

P.T.O. Pre Installation

1. At installation, the input housing is installed to the transmission first. The 891/898 comes from the factory assembled. Remove the 4 bolts that connect the tube section to the input housing (**Fig. 1**).

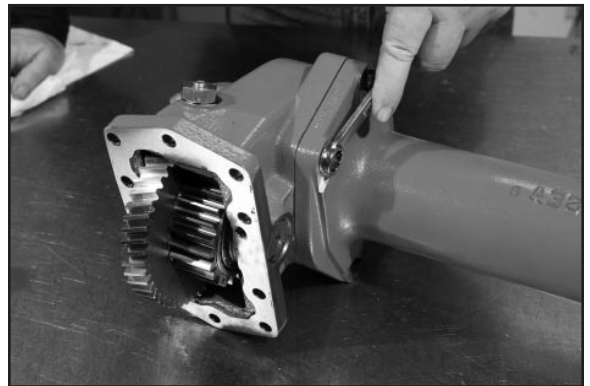


Fig. 1

2. Split the input from the output tube assembly. It will be tight because of the installed O-Ring seal. O-Ring must be installed into the O-Ring groove on the tube pilot shoulder (**Fig. 2**).

NOTE: If O-Ring is damaged replace with one supplied with P.T.O. Unit

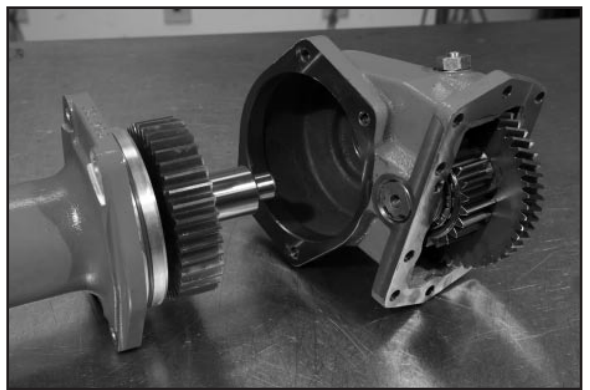
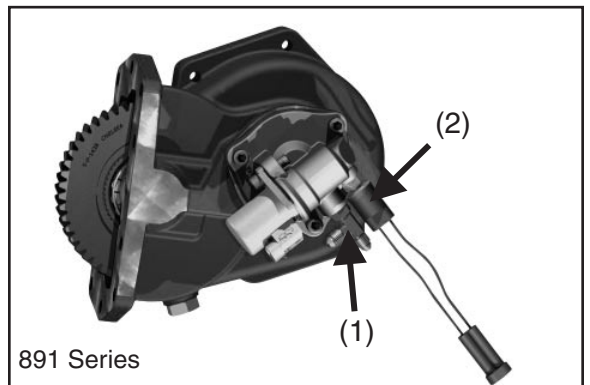


Fig. 2

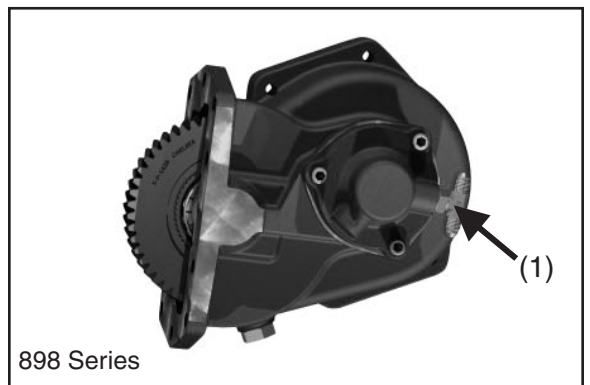
3. Install the "T" fitting (1) into the pressure port on the valve cap as shown. Torque to 156-180 Lbs. in [18-20 N.m.] Next install the pressure switch (891 Series Only) (2) into the port in the valve cap as shown and torque to 120-140 Lbs. in [14-16 N.m.] (**Fig. 3**) (**Fig. 3a**).



891 Series

Fig. 3

NOTE: See Hose Installation Sketch SK-504 (891 Series) on [page 17](#) and SK-492 (898 Series) on [page 18](#).



898 Series

Fig. 3a

P.T.O. Pre Installation (Continued)

When installing a P.T.O., always wear protective clothing and safety glasses.

- The suitable (by transmission model) **Mounting Bracket (50-P-62 for the HD left side, 50-P-60 for the MD left side and 50-P-61 for the MD right side)**, is attached to the P.T.O. output end using the **Shoulder Cap Screws**. Torque to 30-35 Lbs. ft. [41-47 N.m.](**Fig. 4 & 4a**). (See Charts on [page 17 & 18](#))

NOTE: Lightly lube the cap screw shaft to help with installation.



Fig.4



Fig. 4a

Mounting the P.T.O. on the Transmission

- Begin by draining the oil from the transmission. Use caution, since the oil may be hot (**Fig. 5**).

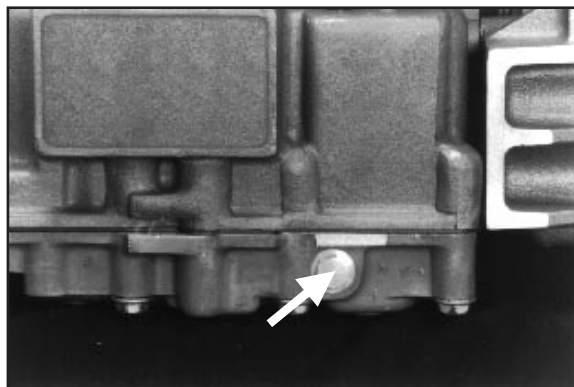


Fig. 5

- Remove the P.T.O. aperture plate with a 15mm socket (**Fig. 6**).

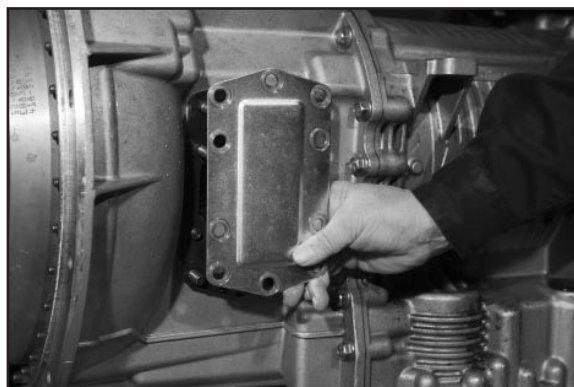


Fig. 6

Mounting the P.T.O. on the Transmission (Continued)

7. Remove the gasket and clean the aperture surface (**Fig. 7**).

NOTE: Do not reuse the gasket that comes with the transmission.

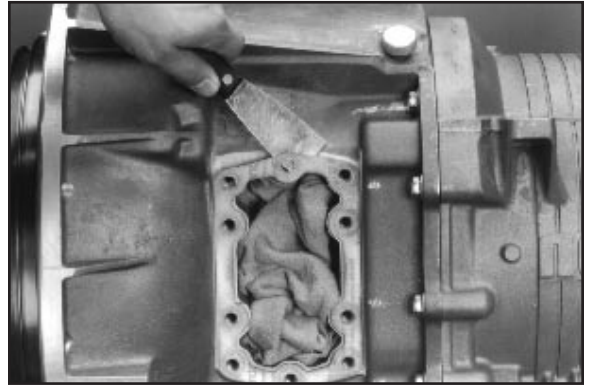


Fig. 7

8. Using a screwdriver, install the dowel pins (2) until they bottom out. Next install stud as shown. Tighten stud (1) securely and torque to 19-21 Lbs. ft. (**Fig. 8**) (Refer to [page 19](#) for correct location and use).

NOTE: Do not use sealing compounds because they are generally incompatible with automatic transmission fluid.

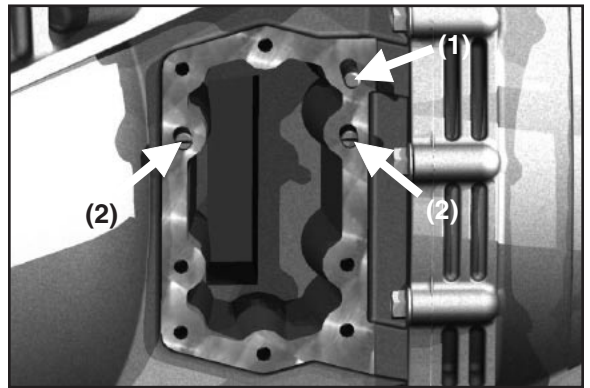


Fig. 8

9. Install the special gasket over the guide pins. The ribbed surface should face outward, toward the installer (**Fig. 9**).

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

NOTE: To ensure proper backlash and sealing of P.T.O. to transmission, only use gasket furnished with the P.T.O.

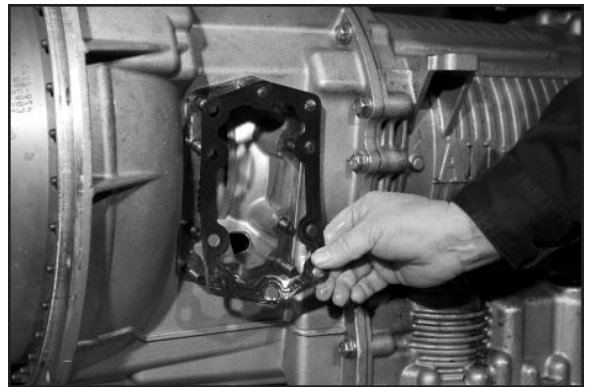


Fig. 9

10. Install the remaining capscrews and nut. Torque all to 40 - 50 Lbs. ft. (54 - 68 N.m. or 5.5 - 6.9 Kg.m) (**Fig. 10**).

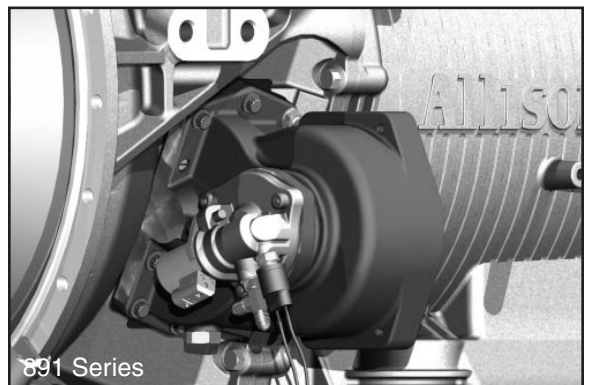


Fig. 10

Mounting the P.T.O. on the Transmission (Continued)

11. Securely attach the high pressure line to the P.T.O. valve "T" fitting (1), torque to 11-12 Lbs. ft. [15-16 N.m.] (**Fig. 11**) (**Fig. 11a**).

NOTE: For 891 Series see SK-504 [page 17](#) for complete plumbing installation of the transmission pressure hose and the wet spline hose. See [page 18](#) for the 898 Series

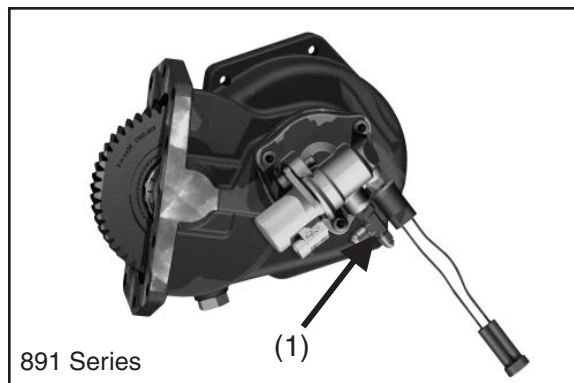


Fig. 11

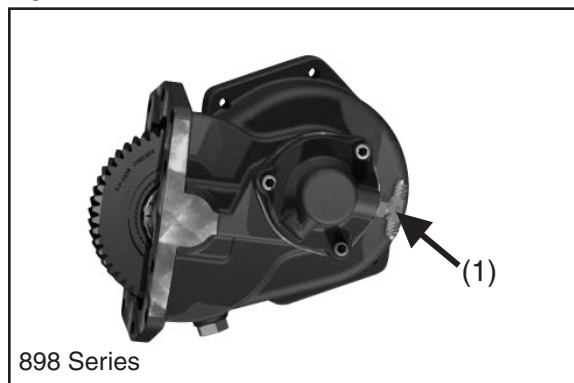


Fig. 11a

12. Install elbow fitting supplied with P.T.O. into transmission main pressure port and torque nut to 13 - 15 Lbs. ft. or 156-180 pds-in. See chart on [page 19](#) for pressure port locations.
- 12a. Securely attach the high pressure line to the elbow fitting at the transmission high pressure port and torque to 11-12 Lbs. ft. [15-16 N.m.]. This fitting is included with the P.T.O. (**Fig. 12**).

NOTE: See SK-504 [page 17](#) for complete plumbing installation of the transmission hose and the wet spline hose.

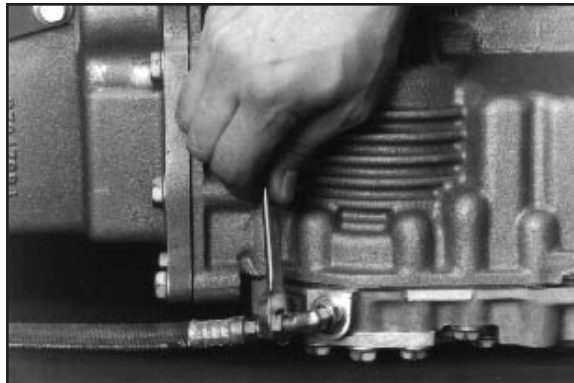


Fig. 12

13. The 3 bolts on the transmission that will line up with the bracket holes must be removed. New longer Bolts (380075 M12-1.75" x 55) will be used for mounting the bracket to the transmission. (**Fig. 13** & **13a**).

NOTE: See Bracket Installation Chart on [page 17-18](#).

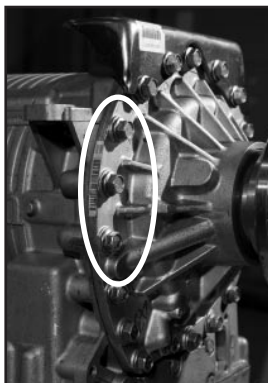


Fig. 13

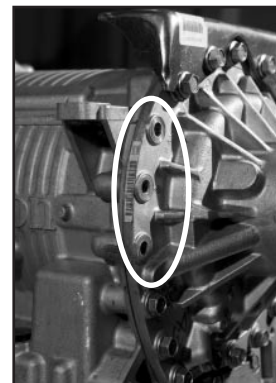


Fig. 13a

Mounting the P.T.O. on the Transmission (Continued)

14. The tube assembly is lined up and inserted into the Input Housing. As this is done, the bolts for the bracket should be started into the rear of the transmission. (**Fig. 14**).

15. As soon as at least 1 bolt is started, the tube assembly cannot fall. The unit can be aligned and slipped together with the transmission taking the weight (**Fig. 15**).

NOTE: When attaching the tube to the input housing use 4 NEW cap screws supplied with the P.T.O.

16. The 4 Hex Head Cap Screws (378431-13, 3/8"-16 x 1.375") and flatwashers 380076-07 make the final attachment between the input housing and the tube assembly. Torque the Cap Screws to 30-35 Lbs. ft. [41-47 N.m.] (**Fig. 16**).

17. The 3 longer bolts in the transmission should be tightened to 75-85 Lbs. ft. [102-115 N.m.] (**Fig. 17**).

18. To complete installation of the P.T.O. see SK drawings on [pages 14-16](#) for wiring and plumbing installation.

19. See SK493 [page 13](#) for installation of "XV", "AB" or "AC" Outputs.

20. When installing pumps use O-Ring supplied with P.T.O. between pump and P.T.O. output. Torque pump bolts to proper torque specifications. Refer to page 3 of this manual for proper pump bracket support requirements.

As with all auxiliary power systems, there are different concerns and needs with varying applications, duty cycles, and driven equipment. Chelsea endeavors to provide options that will ensure trouble free use of our products and system solutions.

For customers that would like an extra level of protection from pump seal leaks, there are double sealed pumps available from Parker to satisfy your needs. Please verify your requirements with your Parker/Chelsea P.T.O. and Pump experts.

! **WARNING:** Do not run P.T.O. w/wet spline output option if pump is not installed and connected to hydraulic system. Failure to do so may damage P.T.O./Transmission. See [page 20](#) for output cover plate options.

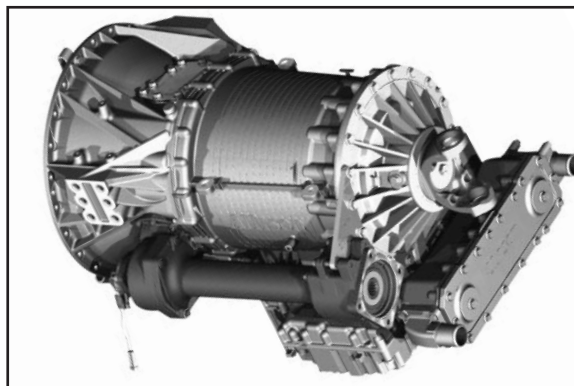


Fig. 14



Fig. 15

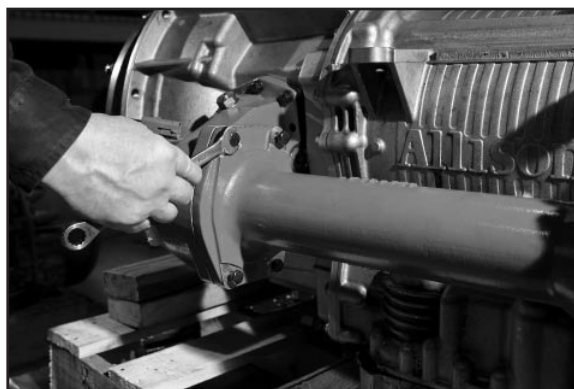


Fig. 16

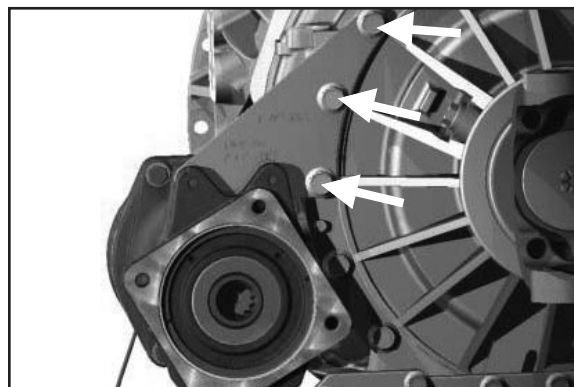


Fig. 17

P.T.O. Shifting Procedure & Precautions

CAUTION: This vehicle is equipped with a Power Take-Off. Shut engine off before working on the Power Take-Off or getting below the vehicle. Consult the operating instructions before using the P.T.O. (See sun visor.)

POWER TAKE-OFF OPERATION — VEHICLE STATIONARY

Automatic Transmission with Powershift P.T.O.s

Engage the P.T.O. with the engine at idle speed.

NOTE: Powershift P.T.O.s: The engine must be at idle or below 1000 R.P.M. when the P.T.O. is engaged. See the transmission manufacturer's instructions for special procedures.

IMPORTANT:

Failure to follow the proper shifting or operating sequences will result in premature P.T.O. failure with possible damage to other equipment.



Warning: Cold Weather Operation of Powershift P.T.O.s

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 quickly decreases.

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 or equipment damage:

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

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. Ensure 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.

Offer of Sale

The items described in this document and other documents or descriptions provided by Parker Hannifin Corporation, its subsidiaries and its authorized distributors are hereby offered for sale at prices to be established by Parker Hannifin Corporation, its subsidiaries and its authorized distributors. This offer and its acceptance by any customer ("Buyer") shall be governed by all of the following Terms and Conditions. Buyer's order for any such items, when communicated to Parker Hannifin Corporation, its subsidiary or an authorized distributor ("Seller") verbally or in writing, shall constitute acceptance of this offer.

1. Terms and Conditions of Sale: All descriptions, quotations, proposals, offers, acknowledgments, acceptances and sales of Seller's products are subject to and shall be governed exclusively by the terms and conditions stated herein. Buyer's acceptance of any offer to sell is limited to these terms and conditions. Any terms or conditions in addition to, or inconsistent with those stated herein, proposed by Buyer in any acceptance of an offer by Seller, are hereby objected to. No such additional, different or inconsistent terms and conditions shall become part of the contract between Buyer and Seller unless expressly accepted in writing by Seller. Seller's acceptance of any offer to purchase by Buyer is expressly conditional upon Buyer's assent to all the terms and conditions stated herein, including any terms in addition to, or inconsistent with those contained in Buyer's offer. Acceptance of Seller's products shall in all events constitute such assent.

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 certain Products, namely PTOs, SEMs, and Wet Line Kits sold hereunder shall be free from defects in material or workmanship for a period of twenty four months from the date of delivery to Buyer. Seller warrants that certain Products namely Pumps, and Hydraulic Accessories shall be free from defects in material or workmanship for a period of eighteen months from the date of delivery to the Buyer. The prices charged for Seller's products are based upon the exclusive limited warranty stated above, and upon the following disclaimer: **DISCLAIMER OF WARRANTY: THIS WARRANTY COMPRISES THE SOLE AND ENTIRE WARRANTY PERTAINING TO PRODUCTS PROVIDED HEREUNDER. SELLER DISCLAIMS ALL OTHER WARRANTIES, EXPRESS AND IMPLIED, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.**

5. Limitation Of Remedy: SELLER'S LIABILITY ARISING FROM OR IN ANYWAY 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 ANYWAY 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.

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Parker Hannifin Corporation
Chelsea Products Division
8225 Hacks Cross Road
Olive Branch, Mississippi 38654 USA
Tel: (662) 895-1011
Fax: (662) 890-5379
www.parker.com/chelsea

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