

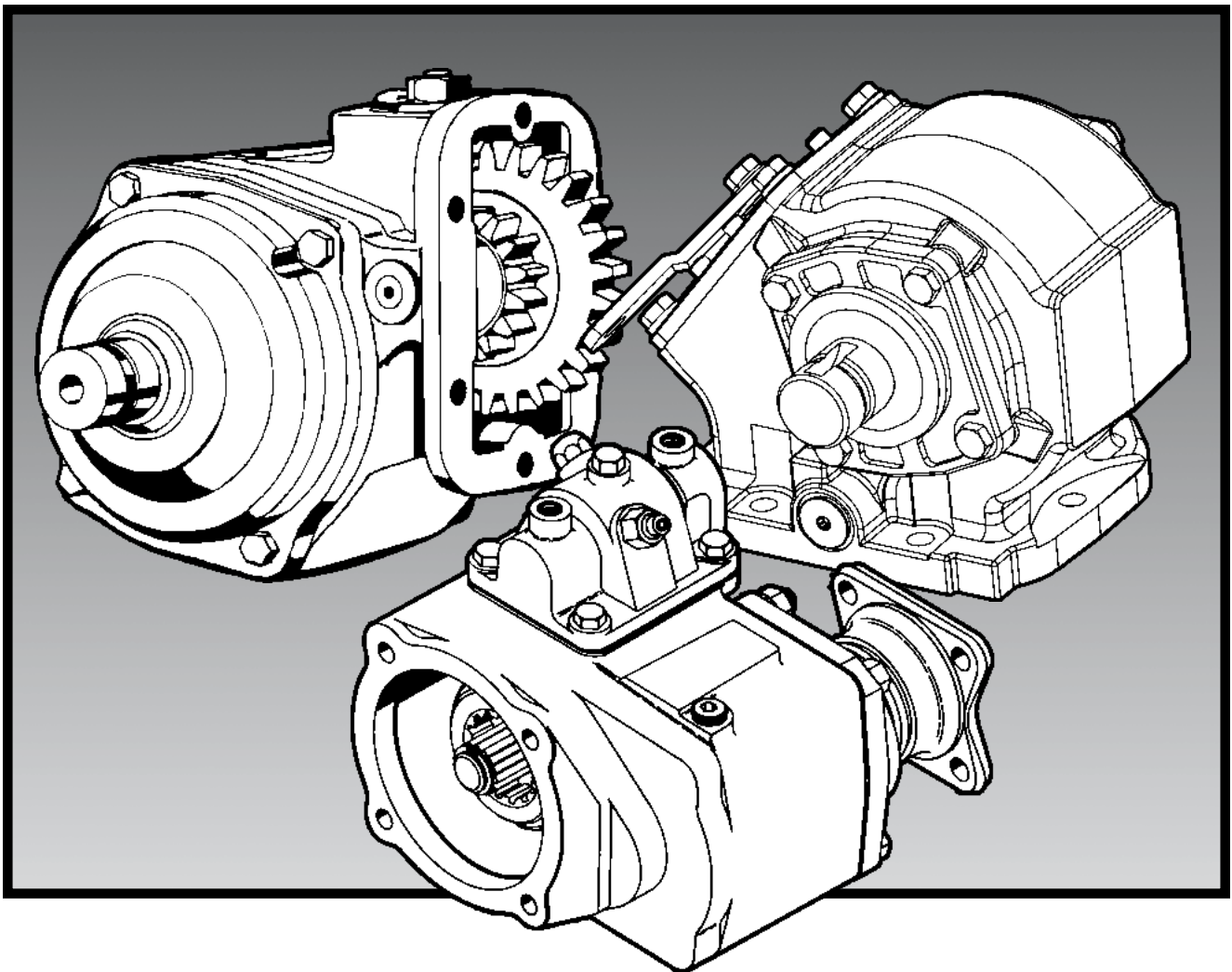
**CHELSEA<sup>®</sup>**

Bulletin HY25-2438-M1/US

## Parts List 438 Series

Effective: December 15, 2001  
Supersedes: P410-438 Dated July 1994

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**Parker**

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 **WARNING**

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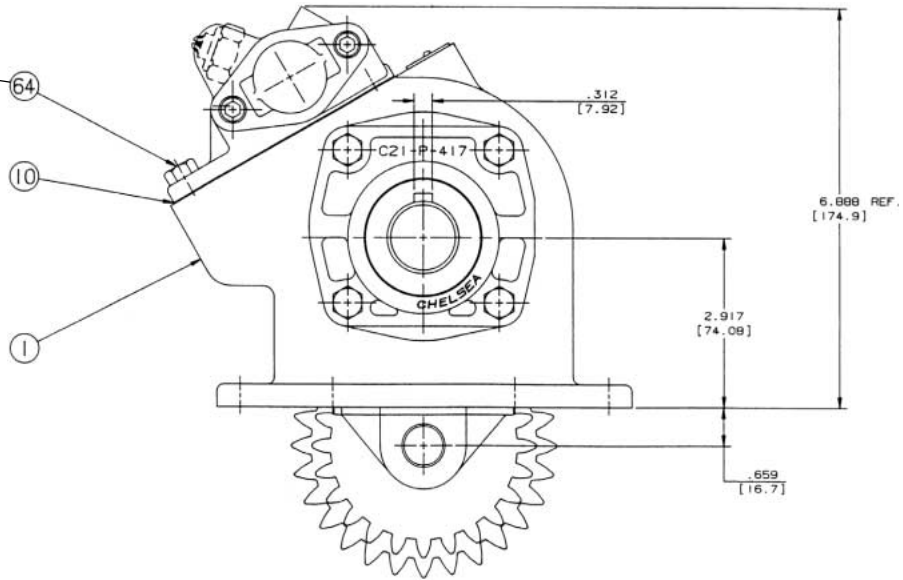
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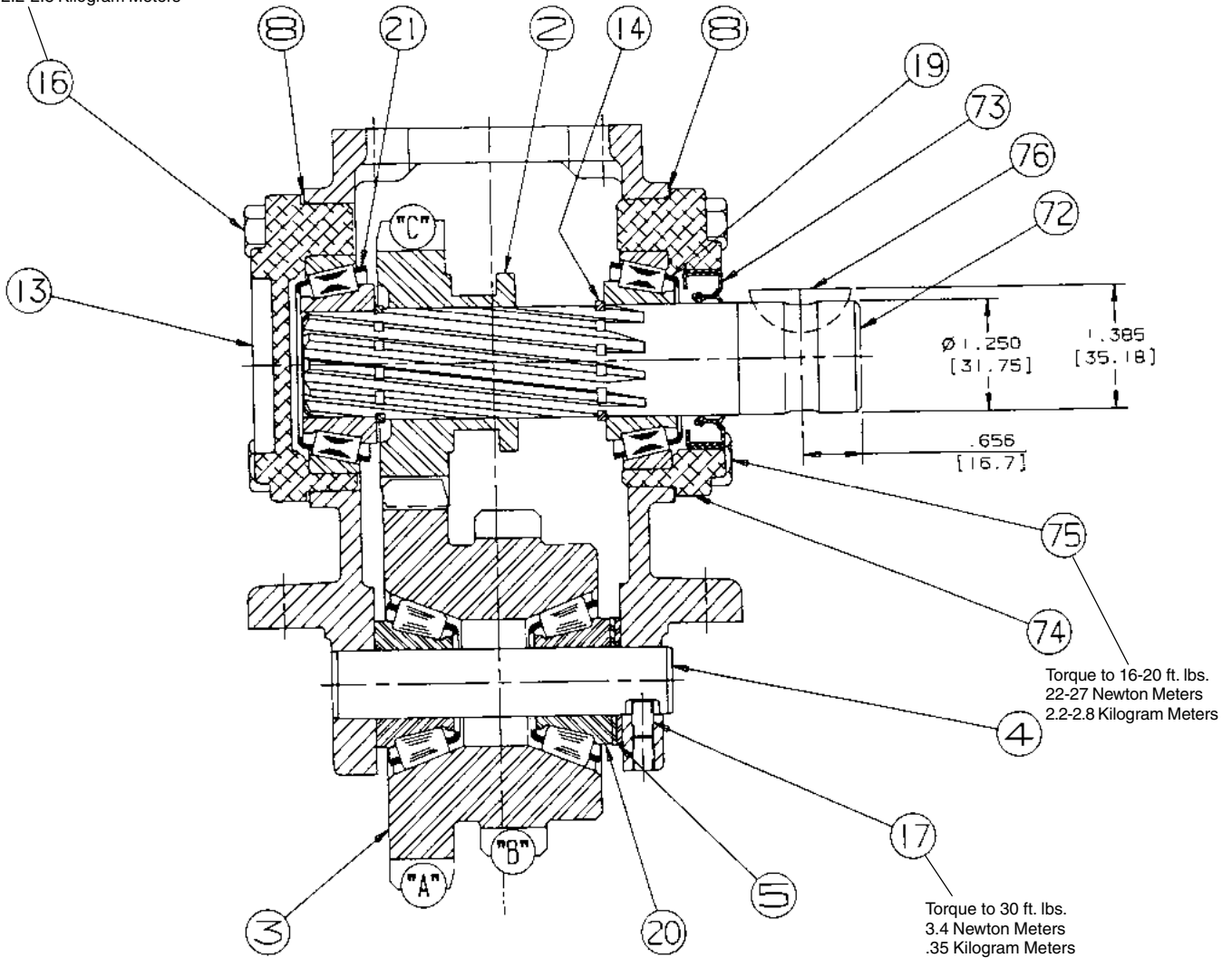
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Torque to 16-20 ft. lbs.  
 22-27 Newton Meters  
 2.2-2.8 Kilogram Meters



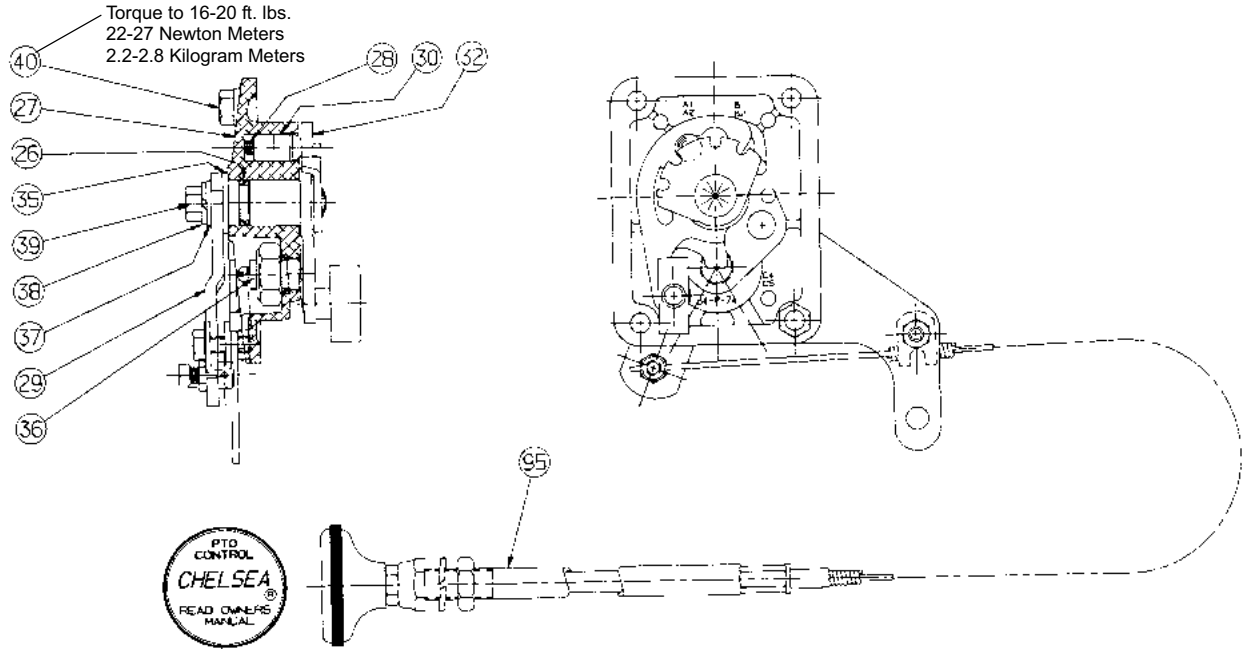
Torque to 16-20 ft. lbs.  
 22-27 Newton Meters  
 2.2-2.8 Kilogram Meters



| Item | Part Number | Description                                   | Quantity |
|------|-------------|---|----------|
| 1    | 1-P-483     | Housing .....                                 | 1        |
| 2    | 2-P-699     | Gear, Output .....                            | 1        |
| 3    | 5-P-951     | Gear, Input .....                             | 1        |
| 4    | 9-P-72      | Shaft, Idler .....                            | 1        |
| 5    | 14-P-15     | Spacers, Input Gear .....                     | A/R      |
| 8    | 22-P-24-1   | Gasket, Bearing Cap (.010) .....              | A/R      |
|      | 22-P-24-2   | Gasket, Bearing Cap (.020) .....              | A/R      |
|      | 22-P-24-3   | Gasket, Bearing Cap (.015) .....              | A/R      |
| 10   | 35-P-8      | Gasket, Shifter Cover .....                   | 1        |
| 11   | 68-P-2      | Name Plate (U.S.A.) .....                     | 1        |
| 13   | 328274X     | Bearing Cap Assembly (Closed) .....           | 1        |
| 14   | 378391      | Lockring .....                                | 2        |
| 15   | 378422      | Drive Screw .....                             | 2        |
| 16   | 378430-10   | Capscrew, Hex Head (.312-18 x 1.000) .....    | 4        |
| 17   | 378452-7    | Set Screw (.250-20 x .500) .....              | 1        |
| 19   | 550397      | Bearing Cone .....                            | 1        |
| 20   | 550439      | Bearing Cone .....                            | 2        |
| 21   | 550532      | Bearing Cone .....                            | 1        |
| 64   | 378430-8    | Capscrew, Hex Head (.312-18 x .750) .....     | 4        |
|      |             | <b>“XR” OUTPUT</b>                            |          |
| 66   | 3-P-283     | Shaft, Output .....                           | 1        |
| 67   | 28-P-216    | Oil Seal .....                                | 1        |
| 68   | 329194X     | Pump Flange Assembly (21-P-574) .....         | 1        |
| 69   | 379673      | Shoulder Stud (.312-24) .....                 | 4        |
| 70   | 379063      | Flat Washer .....                             | 4        |
|      |             | <b>“XD” OUTPUT</b>                            |          |
| 72   | 3-P-202     | Shaft, Output .....                           | 1        |
| 73   | 28-P-216    | Oil Seal .....                                | 1        |
| 74   | 328273X     | Bearing Cap Assembly (Open) .....             | 1        |
| 75   | 378430-10   | Capscrew, Hex Head (.312-18 x 1.000) .....    | 4        |
| 76   | 500007-29   | Woodruff Key .....                            | 1        |
|      |             | <b>“XQ” OUTPUT</b>                            |          |
| 79   | 3-P-282     | Shaft, Output (Pump) .....                    | 1        |
| 80   | 28-P-216    | Oil Seal .....                                | 1        |
| 81   | 328589X     | Bearing Cap Assembly (21-P-269) .....         | 1        |
| 82   | 378447-8    | Capscrew, Socket Head (.312-18 x 1.500) ..... | 4        |
|      |             | <b>“RA” OUTPUT</b>                            |          |
| 83   | 3-P-283     | Output Shaft .....                            | 1        |
| 84   | 28-P-216    | Oil Seal .....                                | 1        |
| 85   | 329195X     | Pump Flange Assembly (21-P-574) .....         | 1        |
| 86   | 21-P-628    | Pump Flange 2-Bolt Rotating .....             | 1        |
| 87   | 378447-6    | Socket Head Capscrew .312-18 X 1.000) .....   | 4        |
|      | 328591-53X  | Pump Field Conversion Kit (“XR” TO “RA”)      |          |
|      | 328591-55X  | Pump Field Conversion Kit (“XD” TO “RA”)      |          |
|      |             | <b>“RA” OUTPUT</b>                            |          |
| 88   | 3-P-283     | Output Shaft .....                            | 1        |
| 89   | 28-P-216    | Oil Seal .....                                | 1        |
| 90   | 329195X     | Pump Flange Assembly (21-P-574) .....         | 1        |
| 91   | 21-P-572    | Pump Flange 4-bolt Rotating .....             | 1        |
| 92   | 378447-6    | Socket Head Capscrew .312-18 X 1.000 .....    | 4        |
|      | 328591-54X  | Pump Field Conversion Kit (“XR” TO “RA”)      |          |
|      | 328591-56X  | Pump Field Conversion Kit (“XD” TO “RA”)      |          |
|      |             | <b>LOOSE PARTS</b>                            |          |
|      | 7170-72X    | Stud Kit .....                                | 1        |
|      | 35-P-72     | Gasket, Mounting .....                        | 2        |
|      | 328961-6X   | Gasket & Installation Instructions .....      | 1        |
| 95   | 328346-15X  | Cable Control Assembly .....                  | 1        |
|      | 328380X     | Cable Control Parts Bag .....                 | 1        |
|      | 328751X     | Installation Kit .....                        | 1        |
|      | 328388-37X  | Installation Kit, Air Shift .....             | 1        |
|      | 328711X     | Installation Kit, “XR” Pump .....             | 1        |
|      | 329166-12X  | Installation Kit, E-Z Shift .....             | 1        |

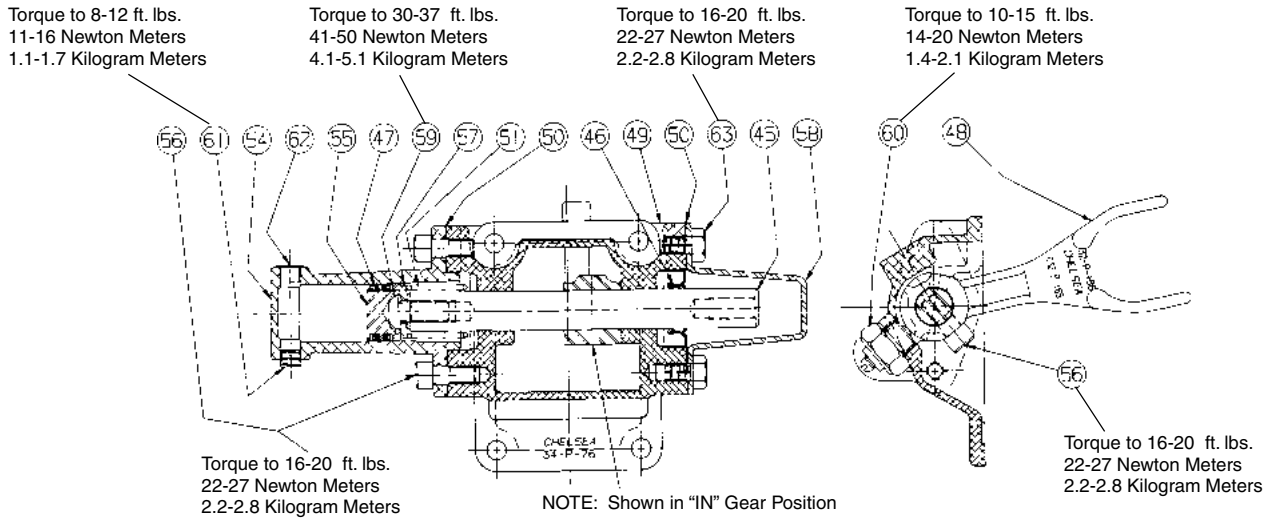
A.R. — As Required

**Assembly 4 & 6**

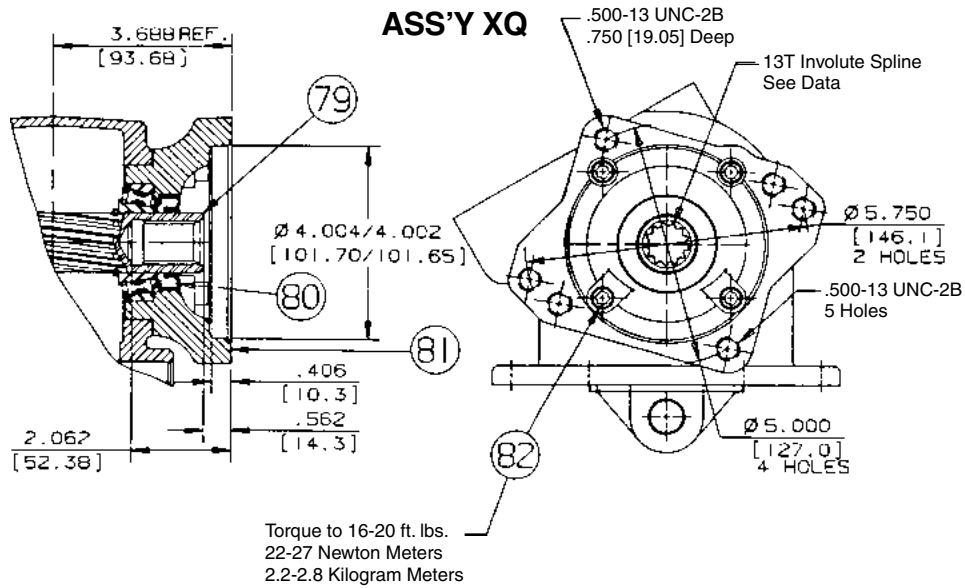
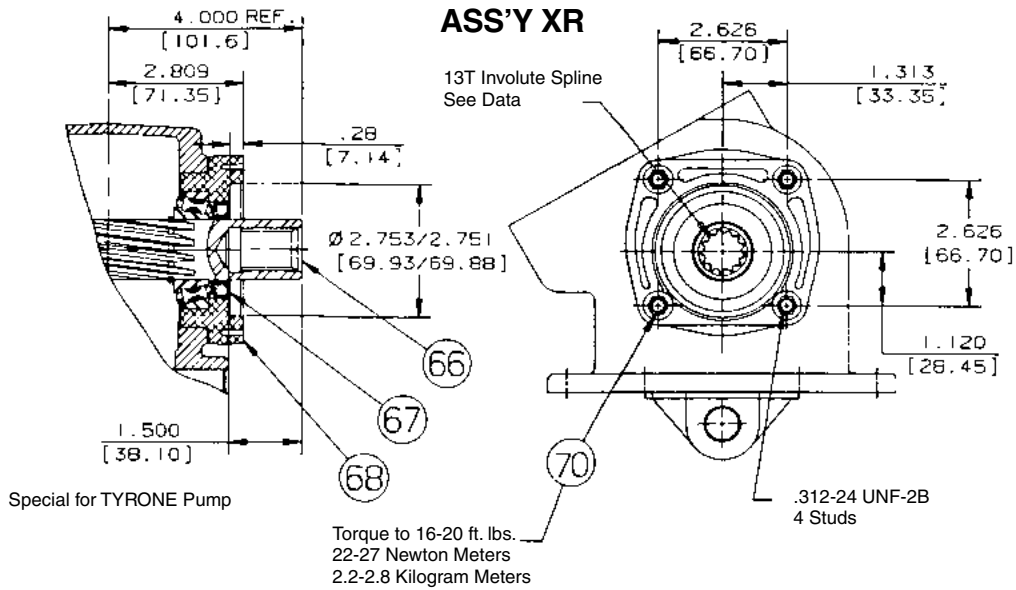


| Item | Part Number      | Description                               | Quantity |
|------|------------------|---|----------|
|      |                  | <b>CABLE SHIFT</b>                        |          |
|      | <b>329038-1X</b> | CABLE SHIFTER ASSEMBLY (3 & 6) .....      | 1 or     |
|      | <b>329038-2X</b> | CABLE SHIFTER ASSEMBLY (4 & 5) .....      | 1        |
| 26   | <b>28-P-191</b>  | O-Ring .....                              | 1        |
| 27   | <b>34-P-74</b>   | Shifter Cover Gasket .....                | 1        |
| 28   | <b>37-P-19</b>   | Shifter Spring .....                      | 1        |
| 29   | <b>51-P-22</b>   | Shifter Lever .....                       | 1        |
| 30   | <b>63-P-16</b>   | Poppet Pin .....                          | 1        |
| 32   | <b>328813-1X</b> | Shifter Plate Ass'y (3 & 6) .....         | 1        |
|      | <b>328813-2X</b> | Shifter Plate Ass'y (4 & 5) .....         | 1 or     |
| 35   | <b>378004</b>    | Flat Washer .....                         | 1        |
| 36   | <b>379110</b>    | Indicator Switch (Norm On) .....          | 1        |
| 37   | <b>500365-22</b> | Flat Washer .....                         | 1        |
| 38   | <b>500356-10</b> | Lockwasher .....                          | 1        |
| 39   | <b>500409-6</b>  | Capscrew, Hex Head .....                  | 1        |
| 40   | <b>378430-9</b>  | Capscrew, Hex Head (.312-18 x .875) ..... | 4        |

**Assembly 4 & 6**

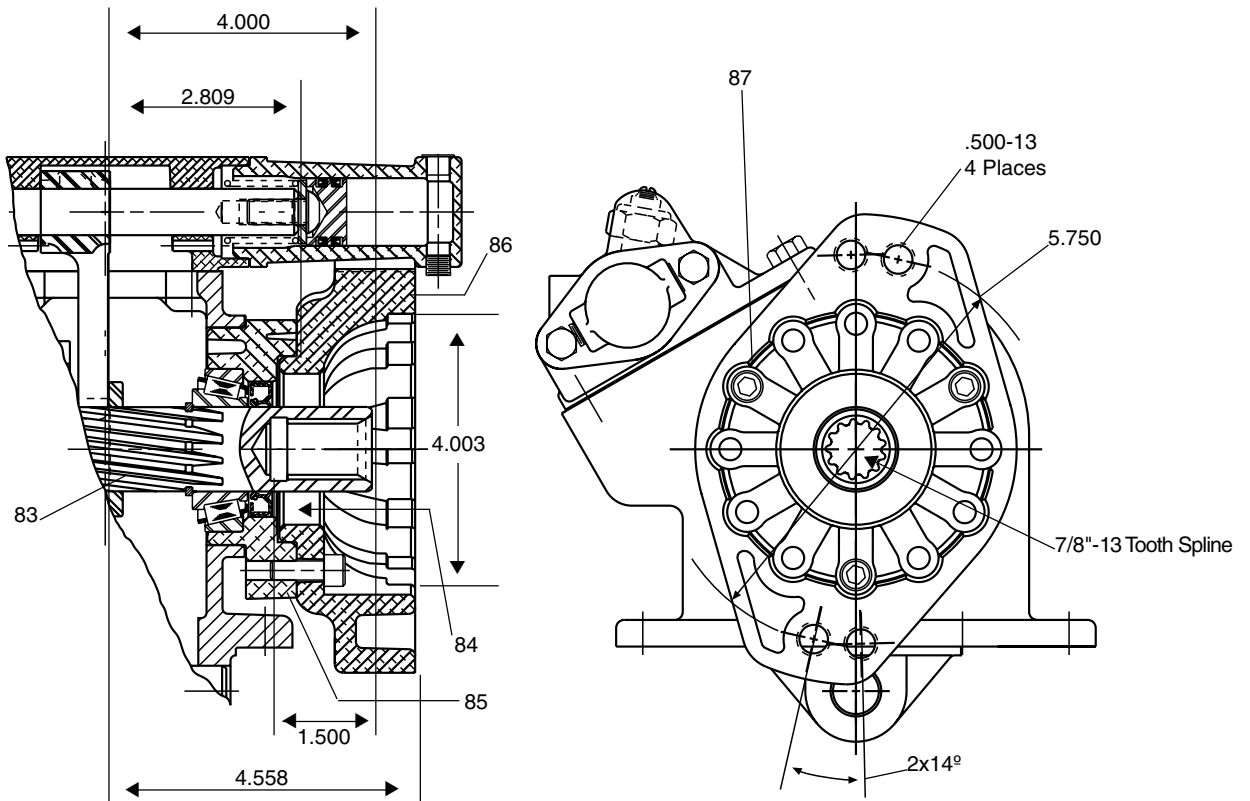


| Item | Part Number      | Description                               | Quantity |
|------|------------------|---|----------|
|      |                  | <b>AIR SHIFT</b>                          |          |
|      | <b>329042-1X</b> | AIR SHIFT COVER ASSEMBLY (3 & 6) .....    | 1 or     |
|      | <b>329042-2X</b> | AIR SHIFT COVER ASSEMBLY (4 & 5) .....    | 1        |
| 45   | <b>11-P-112</b>  | Shaft, Shifter .....                      | 1        |
| 46   | <b>28-P-207</b>  | Oil Seal .....                            | 1        |
| 47   | <b>28-P-256</b>  | Block Vee Ring .....                      | 2        |
| 48   | <b>32-P-166</b>  | Shifter Fork .....                        | 1        |
|      |                  | <b>E-Z SHIFT™</b>                         |          |
|      | <b>329168-1X</b> | E-Z SHIFT COVER ASSEMBLY (3 & 6) .....    | 1        |
|      | <b>329168-2X</b> | E-Z SHIFT COVER ASSEMBLY (4 & 5) .....    | 1        |
| 49   | <b>34-P-76</b>   | Shifter Cover .....                       | 1        |
| 50   | <b>35-P-14</b>   | Gasket .....                              | 2        |
| 51   | <b>37-P-25</b>   | Shifter Spring .....                      | 1        |
| 54   | <b>65-P-14</b>   | Cylinder Cap .....                        | 1        |
| 55   | <b>66-P-4</b>    | Piston, Floating .....                    | 1        |
| 56   | <b>378447-4</b>  | Capscrew, Allen Head .....                | 3        |
| 57   | <b>378462</b>    | Washer, Spring Retainer .....             | 1        |
| 58   | <b>65-p-23</b>   | Shifter Shaft Cover .....                 | 1        |
| 59   | <b>378908</b>    | Capscrew, Button Head .....               | 1        |
| 60   | <b>370110</b>    | Indicator Switch (Norm On) .....          | 1        |
| 61   | <b>379231</b>    | Pipe Plug .125-27 NPTF TH'D .....         | 1        |
| 62   | <b>500897-3</b>  | Shipping Plug .....                       | 1        |
| 63   | <b>378430-4</b>  | Capscrew, Hex Head (.312-18 x .500) ..... | 2        |

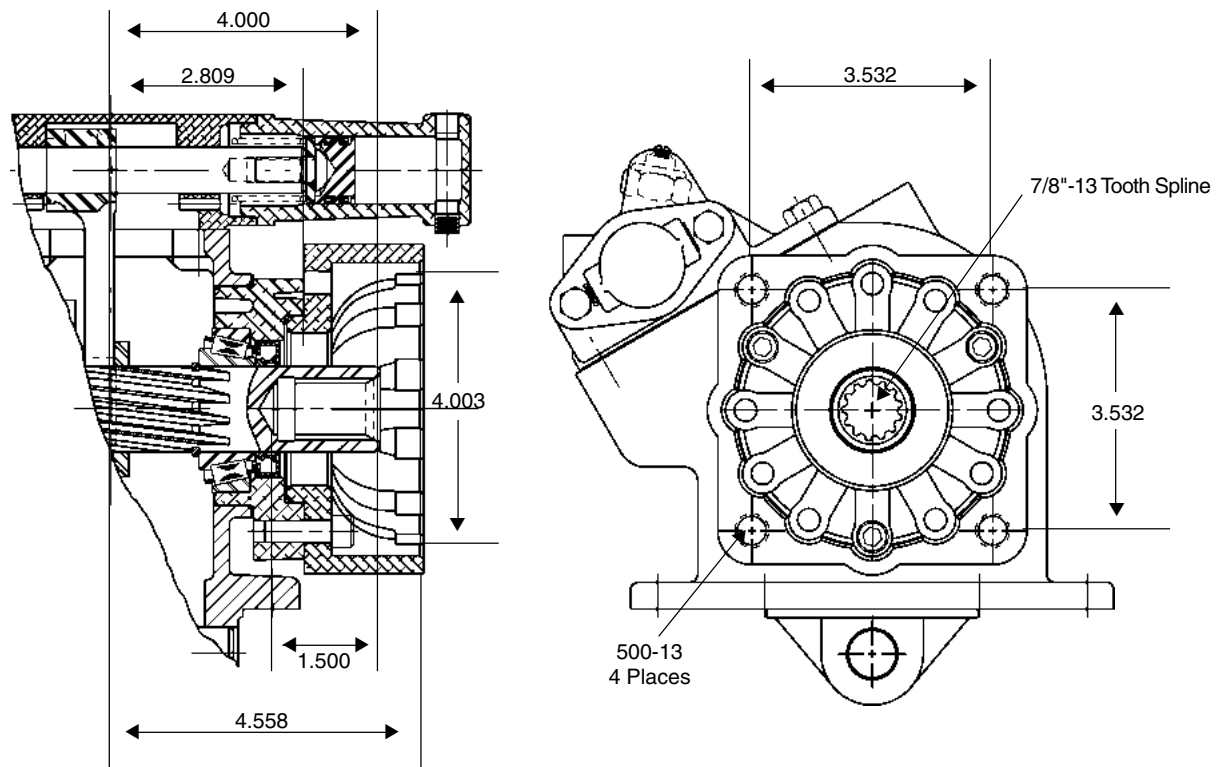




**“RA” Output**

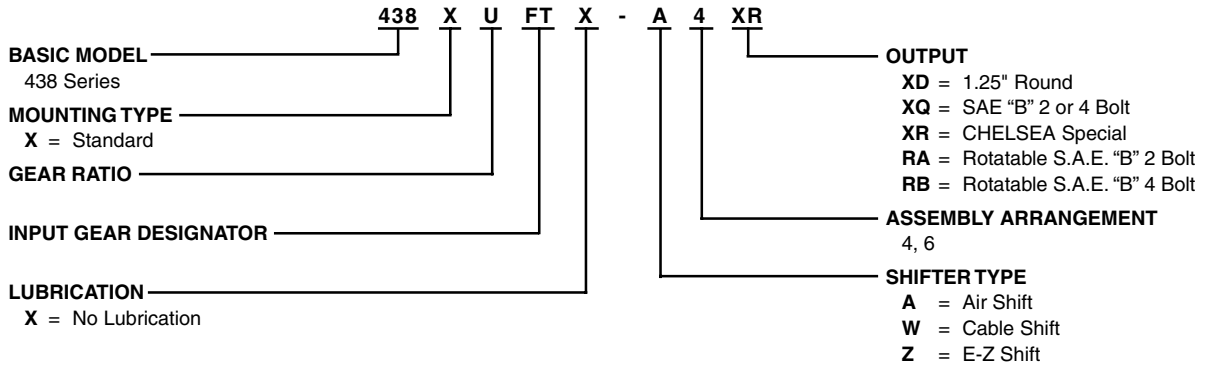


**“RB” Output**

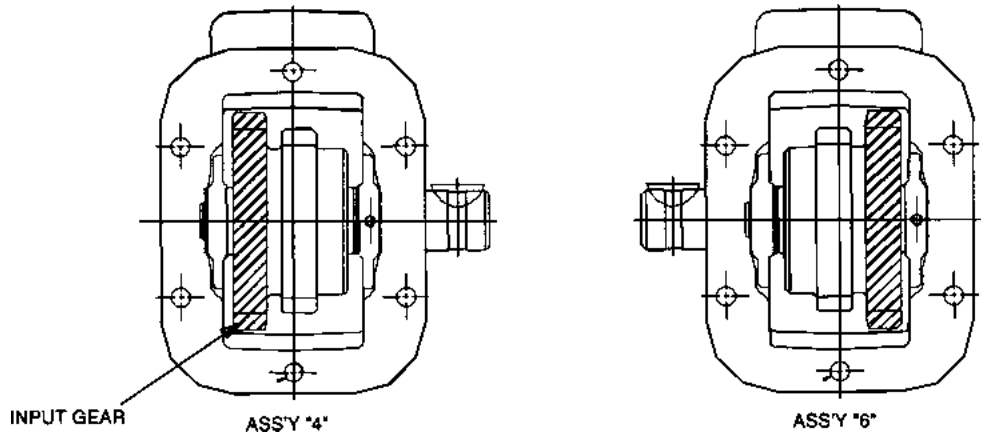


Note: “RA” and “RB” Flanges Rotate in 30° Increments

**Model Number Designation**



**Assembly Arrangements**



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**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:

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(B) Except 267, 277, 278, 242, 244, 245, 250, 251 and 859 series two (2) years from date of installation. **THIS WARRANTY COMPRISES THE SOLE AND ENTIRE WARRANTY PERTAINING TO ITEMS PROVIDED HEREUNDER. SELLER MAKES NO OTHER WARRANTY, GUARANTEE, OR REPRESENTATION OF ANY KIND WHATSOEVER. ALL OTHER WARRANTIES, INCLUDING BUT NOT LIMITED TO, MERCHANTABILITY AND FITNESS FOR PURPOSE, WHETHER EXPRESS, IMPLIED, OR ARISING BY OPERATION OF LAW, TRADE USAGE, OR COURSE OF DEALING ARE HEREBY DISCLAIMED. NOTWITHSTANDING THE FOREGOING, THERE ARE NO WARRANTIES WHATSOEVER ON ITEMS BUILT OR ACQUIRED WHOLLY OR PARTIALLY, TO BUYER'S DESIGNS OR SPECIFICATIONS.**

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**12. Entire Agreement/Governing Law:** The terms and conditions set forth herein, together with any amendments, modifications and any different terms or conditions expressly accepted by Seller in writing, shall constitute the entire Agreement concerning the items sold, and there are no oral or other representations or agreements which pertain thereto. This Agreement shall be governed in all respects by the law of the State of Ohio. No actions arising out of the sale of the items sold hereunder or this Agreement may be brought by either party more than two (2) years after the cause of action accrues.

9/01-P



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