

| Item | Part Number | Description | Quantity |
|------|---|--|-----------------------|
| 1 | { 1-P-195 1-P-196 | HOUSING-Standard Mount HOUSING-Deep Mount | 1 1 |
| 2 | See Chart Pg. 10 | CLUSTER GEAR, Input | 1 |
| 3 | 550439 | BEARING CONE, Input | 2 |
| | 328017X | GEAR SPACER KIT, Input (contains Item 4) | 1 |
| 4 | { 14-P-15-1 14-P-15-2 14-P-15-3 14-P-15-4 14-P-15-5 | GEAR SPACER, Input (.055") GEAR SPACER, Input (.060") GEAR SPACER, Input (.065") GEAR SPACER, Input (.070") GEAR SPACER, Input (.075") | 1 1 1 1 1 |
| 5 | 9-P-60 | IDLER SHAFT | 1 |
| 6 | { 378452-7 378452-4 | SET SCREW-For Standard Mount (1/4"-20 x 1/2") SET SCREW-For Deep Mount (1/4" - 20 x 5/16") | 1 1 |
| 7 | 2-P-425 | SLIDING GEAR, Output (19 Teeth) | 1 |
| 8 | 378391 | LOCK RING | 2 |
| 9 | 3-P-202 | DRIVE SHAFT, Output (1 1/4" Round) | 1 |
| 10 | { 22-P-24-1 22-P-24-2 | BEARING CAP GASKET (.010") BEARING CAP GASKET (.020") | A.R. A.R. |

A.R.-As Required

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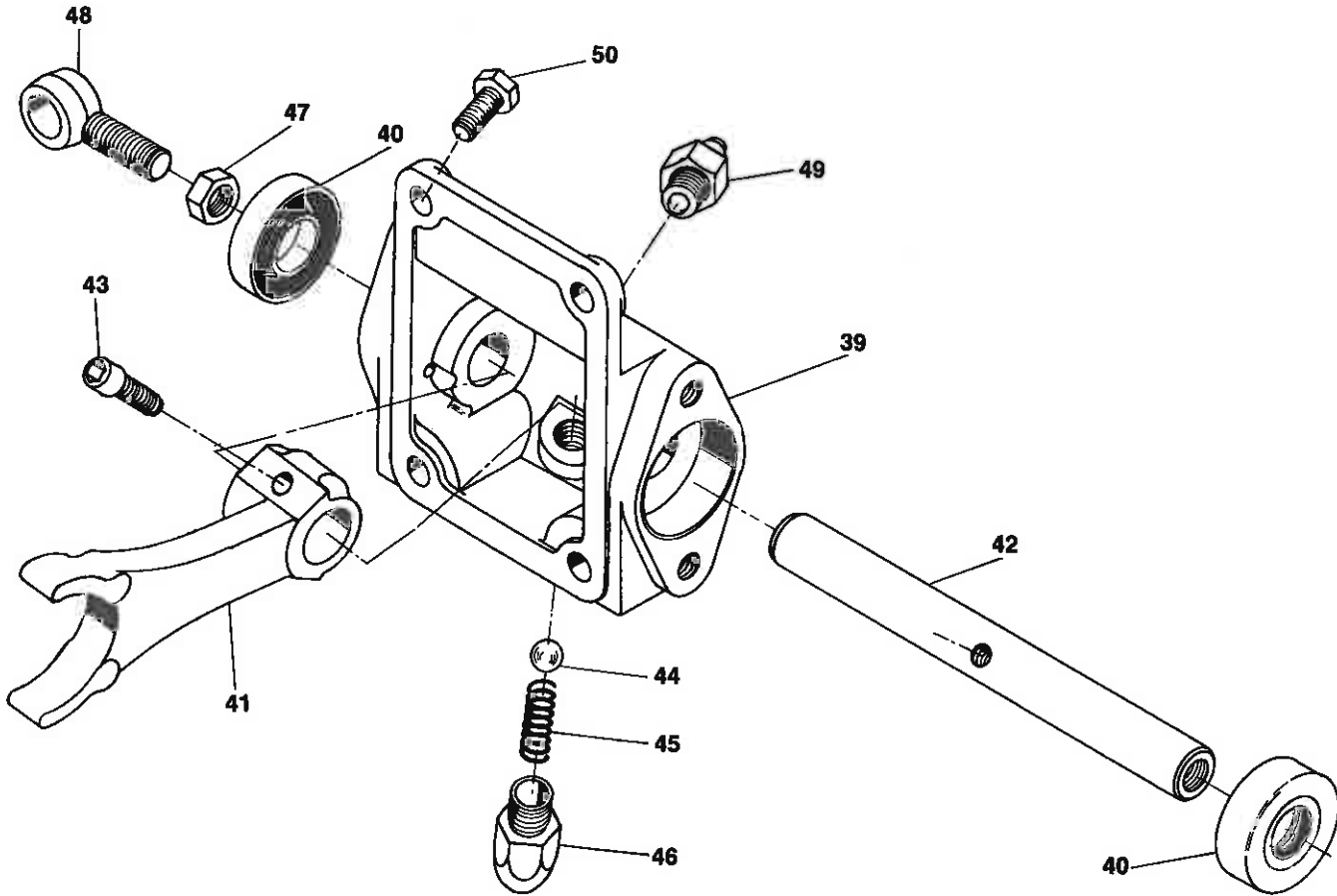
**381 SERIES
WIRE CONTROL**



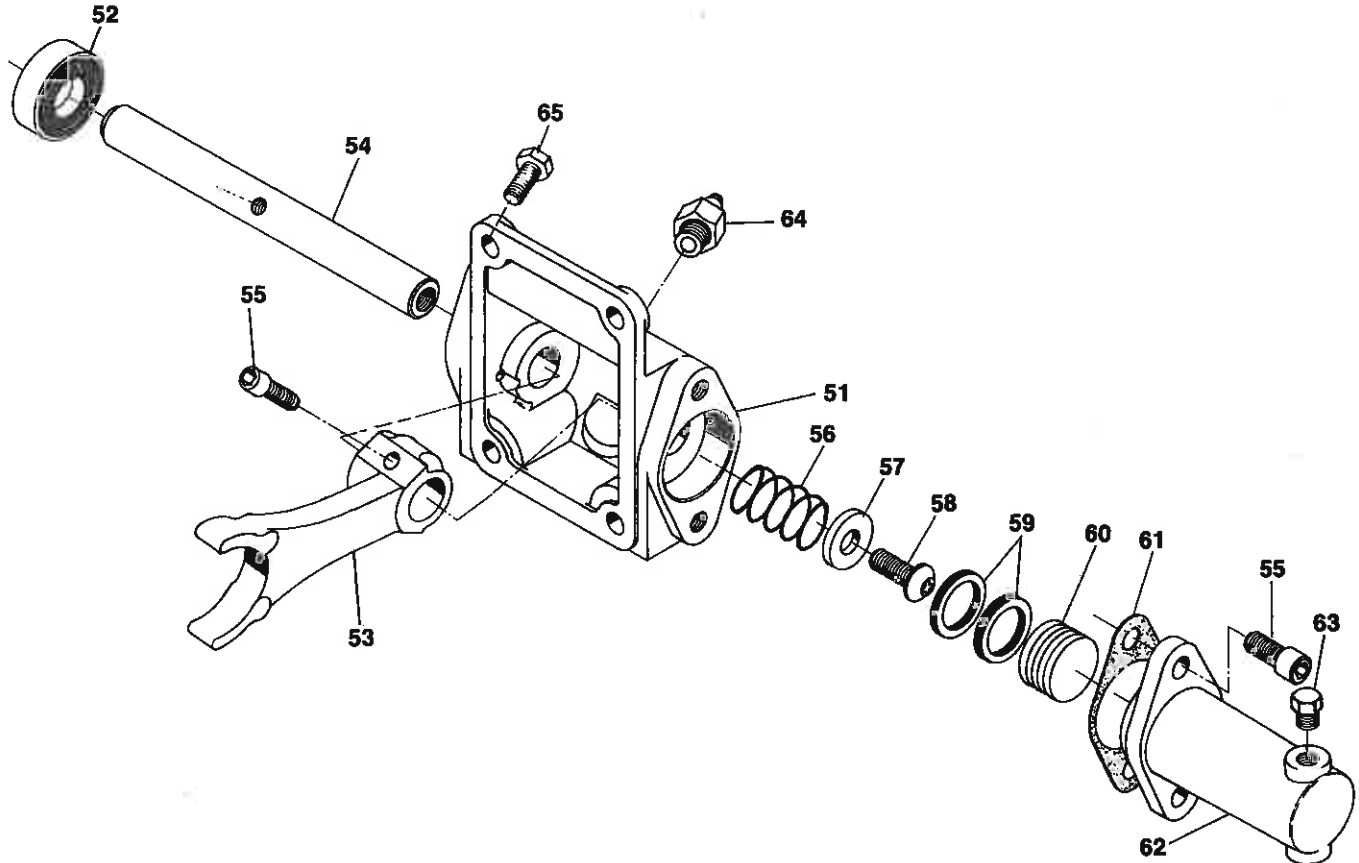
P410-381

| Item | Part Number | Description | Quantity |
|------|-------------|---|----------|
| 11 | 550532 | BEARING CONE, Closed End | 1 |
| | 328274X | BEARING CAP ASSEMBLY, Closed End (contains Items 12-13) | 1 |
| 12 | 550221 | BEARING CUP, Closed End | 1 |
| 13 | 21-P-131 | BEARING CAP, Closed End | N.S.S. |
| 14 | 550397 | BEARING CONE, Output | 1 |
| | 328273X | BEARING CAP ASSEMBLY, Output (contains Items 15-16) | 1 |
| 15 | 550221 | BEARING CUP, Output | 1 |
| 16 | 21-P-130 | BEARING CAP, Output | N.S.S. |
| 17 | 28-P-52 | OIL SEAL, Output | 1 |
| 18 | 378430-10 | SCREW, hex head (Eslock $\frac{5}{16}$ " - 18 x 1") | 8 |
| | 328816-1X | WIRE SHIFT COVER ASSEMBLY, Assembly 3 & 6 (contains Items 19-28) | 1 |
| | 328816-2X | WIRE SHIFT COVER ASSEMBLY, Assembly 4 & 5 (contains Items 19-28) | 1 |
| 19 | 34-P-74 | SHIFTER COVER | 1 |
| 20 | 37-P-19 | SHIFTER SPRING | 1 |
| 21 | 63-P-16 | POPPET | 1 |
| 22 | 28-P-49 | O-RING ($\frac{3}{4}$ " Outside Diameter) | 1 |
| | 328814-1X | POST & PLATE ASSEMBLY (Assembly 3 & 6) | 1 |
| 23 | 328814-2X | POST & PLATE ASSEMBLY (Assembly 4 & 5) | 1 |
| 24 | 378004 | FLAT WASHER (1" Outside Diameter) | 1 |
| 25 | 51-P-22 | SHIFTER LEVER | 1 |
| 26 | 378003 | LOCK WASHER ($\frac{5}{16}$ " | 1 |
| 27 | 500409-6 | SCREW, hex head ($\frac{3}{16}$ " - 24 x $\frac{5}{8}$ ") | 1 |
| 28 | 378969 | INDICATOR SWITCH | 1 |
| 29 | 35-P-8 | SHIFTER COVER GASKET (.020") | 1 |
| 30 | 378430-9 | SCREW, hex head (Eslock $\frac{5}{16}$ " - 18 x $\frac{7}{8}$ ") | 4 |
| | | LOOSE PARTS | |
| 31 | 500007-29 | WOODRUFF KEY | 1 |
| N.S. | 328346-10X | WIRE CONTROL CABLE ASSEMBLY (10X = 10 Foot Cable) | 1 |
| | 328380X | WIRE CONTROL MOUNTING PARTS (contains Items 32-37) | 1 |
| 32 | 50-P-17 | BRACKET | 1 |
| 33 | 50-P-19 | SWIVEL BRACKET | 1 |
| 34 | 500396-8 | SCREW, hex head ($\frac{1}{4}$ " - 20 x $\frac{3}{4}$ ") | 1 |
| 35 | 378326 | NUT, hex ($\frac{1}{4}$ " - 20) | 1 |
| 36 | 378019 | PIVOT PIN | 1 |
| 37 | 500568-4 | SET SCREW ($\frac{1}{4}$ " - 20 x $\frac{1}{2}$ ") | 1 |
| 38 | 35-P-9-1 | GASKET, housing (.010") | A.R. |
| | 35-P-9-2 | GASKET, housing (.020") | A.R. |
| | | PTO MOUNTING STUD KIT (See P400-A For Optional Kits) | |
| N.S. | 328170-76X | For Standard Mount | 1 |
| N.S. | 328170-77X | For Deep Mount | 1 |
| | | BEARING & SPACER KIT | |
| N.S. | 328594X | Must be Ordered Separate (contains 2 pieces each Items 3 & 4; 1 piece each Items 5 & 6; 1 each 68-P-1 & 68-P-2 Nameplates) | 1 |
| | | GASKET & SEAL KIT | |
| N.S. | 328356-13X | Must be Ordered Separate (contains 4 pieces Item 10; 1 piece each Item 8, 17, 22, 29 & 38) | 1 |

N.S.-Not shown
A.R.-As Required
N.S.S.-Not Sold Separately



| Item | Part Number | Description | Quantity |
|------|------------------|---|----------|
| | 328831-1X | LEVER CONTROL COVER ASSEMBLY, Assembly 3 & 6 (contains Items 39-49)..... | 1 |
| | 328831-2X | LEVER CONTROL COVER ASSEMBLY, Assembly 4 & 5 (contains Items 39-49)..... | 1 |
| 39 | 34-P-87 | SHIFTER FORK..... | 1 |
| 40 | 28-P-4 | OIL SEAL..... | 2 |
| 41 | 32-P-144 | SHIFTER FORK..... | 1 |
| 42 | 11-P-112 | SHIFTER SHAFT..... | 1 |
| 43 | 378447-4 | SCREW, hex socket (5/16" - 18 x 3/4")..... | 1 |
| 44 | 378002 | SHIFTER BALL..... | 1 |
| 45 | 37-P-14 | SHIFTER SPRING..... | 1 |
| 46 | 378554 | SPRING CAP..... | 1 |
| 47 | 500381-3 | JAM NUT, hex head..... | 1 |
| 48 | 36-P-1 | EYE BOLT..... | 1 |
| 49 | 378969 | INDICATOR SWITCH..... | 1 |
| 50 | 378430-8 | SCREW, hex head (Eslock 5/16" - 18 x 3/4")..... | 4 |



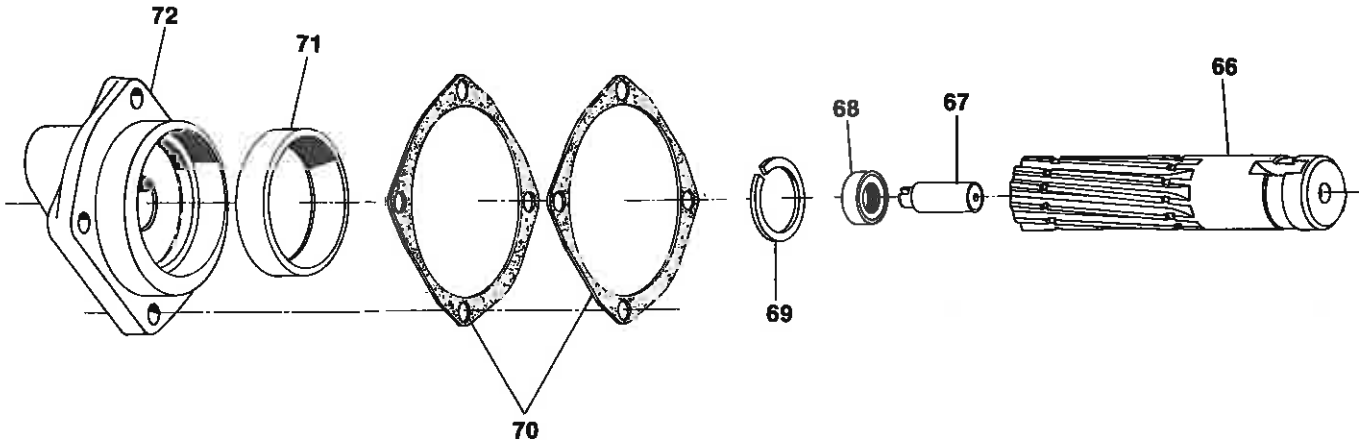
NOTE: To Assemble Air Shift Cover Assembly From Lever Control Cover Assembly, omit Shifter Ball, Spring, Cylinder End Oil Seal, Jam Nut and Eye Bolt.

| Item | Part Number | Description | Quantity |
|------|-------------------|--|----------|
| | 328832-1X | AIR SHIFT COVER ASSEMBLY, Assembly 3 & 6 (contains Items 51-64)..... | 1 |
| | 328832-2X | AIR SHIFT COVER ASSEMBLY, Assembly 4 & 5 (contains Items 51-64)..... | 1 |
| 51 | 34-P-76 | SHIFTER COVER..... | 1 |
| 52 | 28-P-4 | OIL SEAL (Used Only on Side Without Cylinder) | 1 |
| 53 | 32-P-144 | SHIFTER FORK | 1 |
| 54 | 11-P-122 | SHIFTER SHAFT | 1 |
| 55 | 378447-4 | SCREW, hex socket (5/16" - 18 x 3/4") | 3 |
| 56 | 37-P-25 | SHIFTER SPRING | 1 |
| 57 | 378462 | SPRING RETAINER WASHER..... | 1 |
| 58 | 378908 | SCREW, button head | 1 |
| 59 | 28-P-55 | BLOCK VEE RING..... | 2 |
| 60 | 66-P-4 | PISTON..... | 1 |
| 61 | 35-P-14 | CYLINDER CAP GASKET..... | 1 |
| 62 | 65-P-14 | CYLINDER CAP | 1 |
| 63 | 500118-3 | PIPE PLUG (1/8" - 27 N.P.T.)..... | 1 |
| N.S. | 500897-3 | SHIPPING PLUG | 1 |
| 64 | 378969 | INDICATOR SWITCH..... | 1 |
| 65 | 378430-8 | SCREW, hex head (Eslock 5/16" - 18 x 3/4")..... | 4 |
| N.S. | 328388-27X | AIR SHIFT INSTALLATION KIT | 1 |

N.S.-Not shown

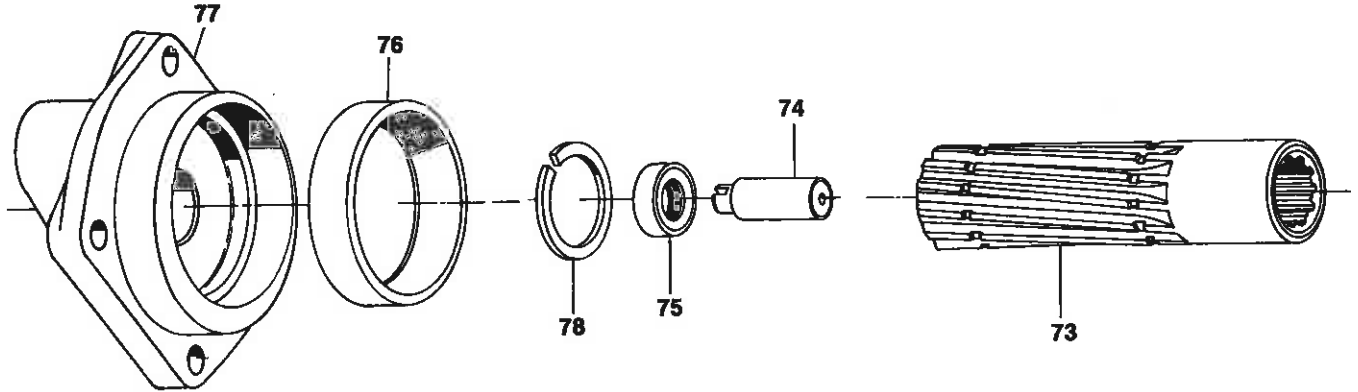
AIR SHIFT CONVERSION KITS

| Description | Part Number | Quantity |
|--------------------------------------|-------------------|----------|
| Wire to Air for Assembly 3 & 6 | 328390-63X | 1 |
| Wire to Air for Assembly 4 & 5 | 328390-64X | 1 |
| Lever to Air All Assemblies..... | 328390-67X | 1 |



| Item | Part Number | Description | Quantity |
|------|------------------|---|----------|
| | 328648X | HOLLEY GOVERNOR DRIVE CONVERSION KIT (contains Items 66-72) | 1 |
| | 328060X | DRIVE SHAFT & SPINNER ASSEMBLY (contains Items 66-67) | 1 |
| 66 | 3-P-270 | DRIVE SHAFT, Standard | 1 |
| 67 | 378178 | SPINNER | 1 |
| 68 | 28-P-53 | OIL SEAL | 1 |
| 69 | 378391 | LOCK RING | 1 |
| 70 | 22-P-24-1 | BEARING CAP GASKET (.010") | 1 |
| | 22-P-24-2 | BEARING CAP GASKET (.020") | 1 |
| | 328588X | BEARING CAP ASSEMBLY (contains Items 71-72) | 1 |
| 71 | 550221 | BEARING CUP | 1 |
| 72 | 21-P-272 | BEARING CAP | N.S.S. |

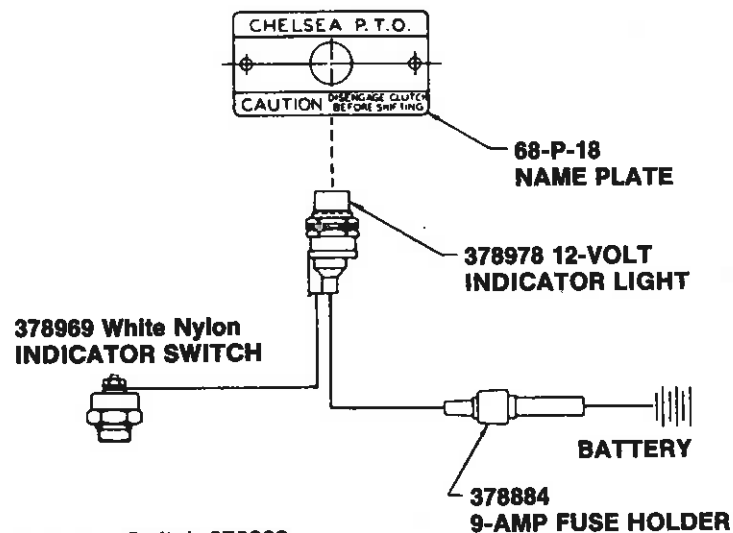
N.S.S.-Not Sold Separately



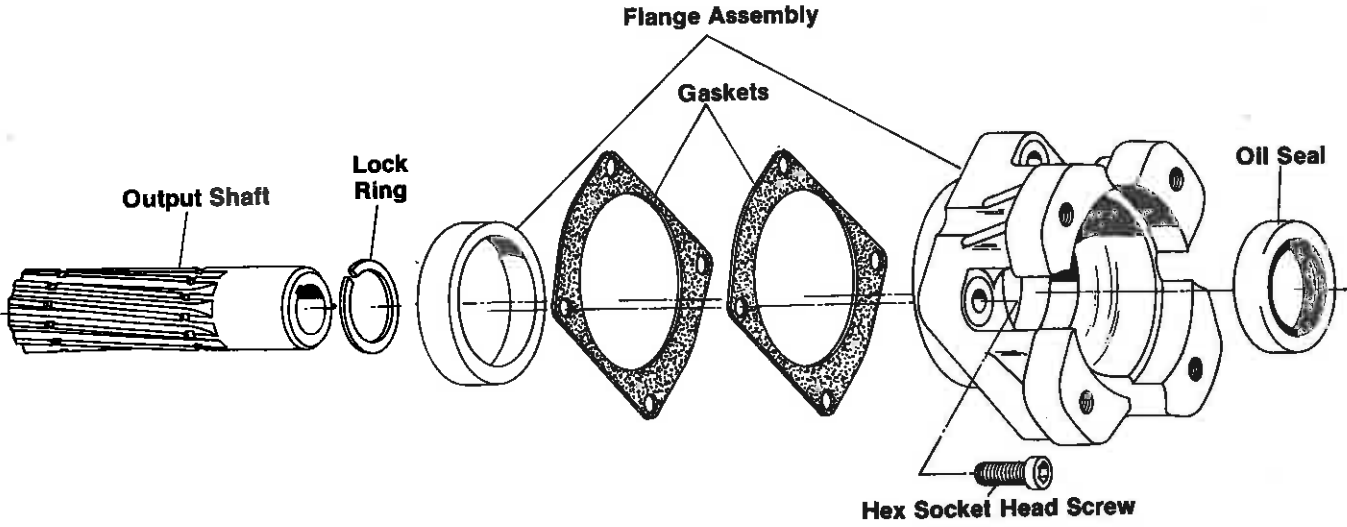
| Item | Part Number | Description | Quantity |
|------|-----------------|--|----------|
| | 328160X | PUMP SHAFT & SPINNER ASSEMBLY (contains Items 73-74), (For Pump Suffix G) | 1 |
| | 328097X | PUMP SHAFT & SPINNER ASSEMBLY (contains Items 73-74), (For Pump Suffix J,M) | 1 |
| | 328096X | PUMP SHAFT & SPINNER ASSEMBLY (contains Items 73-74), (For Pump Suffix K, N, P, Q) | 1 |
| | 328743X | PUMP SHAFT & SPINNER ASSEMBLY (contains Items 73-74), (For Pump Suffix L,R) | 1 |
| 73 | 3-P-348 | PUMP SHAFT (For Pump Suffix G) | 1 |
| | 3-P-311 | PUMP SHAFT (For Pump Suffix J,M) | 1 |
| | 3-P-310 | PUMP SHAFT (For Pump Suffix K, N, P, Q) | 1 |
| | 3-P-702 | PUMP SHAFT (For Pump Suffix L, R) | 1 |
| 74 | 378178 | SPINNER | 1 |
| 75 | 28-P-53 | OIL SEAL | 1 |
| | 328588X | HOLLEY GOVERNOR DRIVE BEARING CAP ASSEMBLY, (contains Items 76-77) | 1 |
| 76 | 550221 | BEARING CUP | 1 |
| 77 | 21-P-272 | BEARING CAP | N.S.S. |
| 78 | 378391 | LOCK RING | 1 |

N.S.S.-Not Sold Separately

**WIRE & LEVER CONTROL INDICATOR LIGHT INSTALLATION KIT
 328751X***



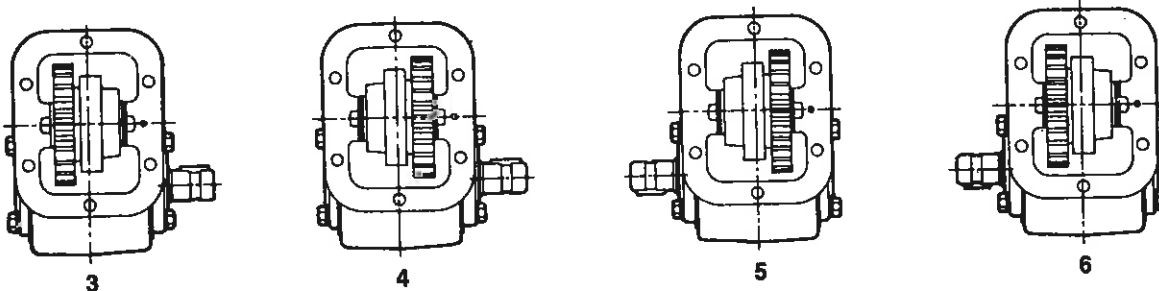
*This kit does not contain Indicator Switch 378969.



| Pump Mounting Suffix | Output Shaft | Flange Assembly (Includes Pump Flange & 550221 Bearing Cup) | Hex Socket Head Screw & Dimensions Quantity Required — Four | Conversion Kit ① |
|----------------------|--------------|---|--|------------------|
| G | 3-P-281 | 328580X | 378447-8 (5/16" - 18 x 1 1/2") | 328591-10X |
| J | 3-P-284 | 328580X | 378447-8 (5/16" - 18 x 1 1/2") | 328591-11X |
| K | 3-P-282 | 328333X ② | 378447-8 (5/16" - 18 x 1 1/2") | 328591-16X |
| L | 3-P-283 | 328580X | 378447-8 (5/16" - 18 x 1 1/2") | 328591-18X |
| M | 3-P-284 | 328583X | 378447-7 (5/16" - 18 x 1 1/4") | 328591-20X |
| N | 3-P-282 | 328584X | 378447-8 (5/16" - 18 x 1 1/2") | 328591-21X |
| P | 3-P-282 | 328328X | 378447-7 (5/16" - 18 x 1 1/4") | 328591-23X |
| Q ③ | 3-P-282 | 328589X ④ | 378447-8 (5/16" - 18 x 1 1/2") | 328591-17X |
| R ⑤ | 3-P-283 | 328710X | 378918 Stud (4 Required) | 328591-25X |

- ① Conversion Kits consist of all Items listed plus 28-P-52 Oil Seal, 378391 Lock Ring, and 22-P-24-1, 22-P-24-2 Gaskets.
- ② 21-P-166 Pump Flange interferes with Air Shift Cylinder on Assembly Arrangement 3 & 5 use 'Q' Flange Assembly.
- ③ Similar to 'K' Assembly, only rotated 65°.
- ④ 21-P-269 Pump Flange interferes with Mounting Base on Deep Mount Assembly Arrangement 3.
- ⑤ 328711X Pump to P.T.O. Mounting Kit contains 4 each: 378919 Washer and 500963-1 Hex Locknut.

ASSEMBLY ARRANGEMENTS



381 SERIES

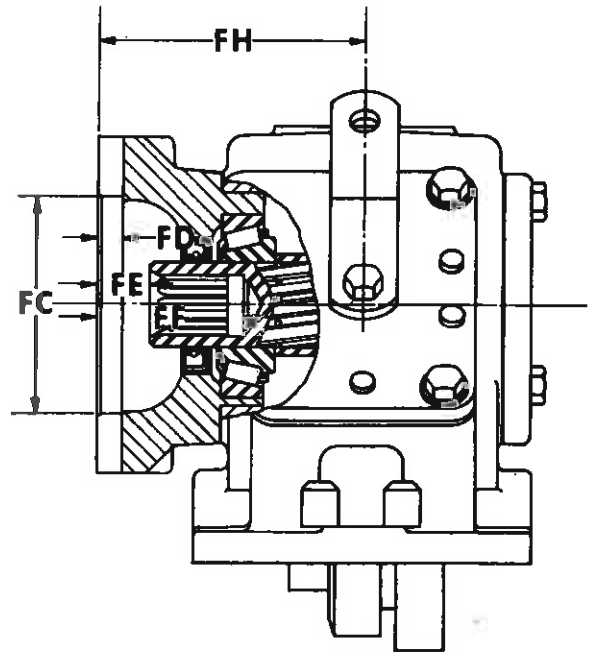
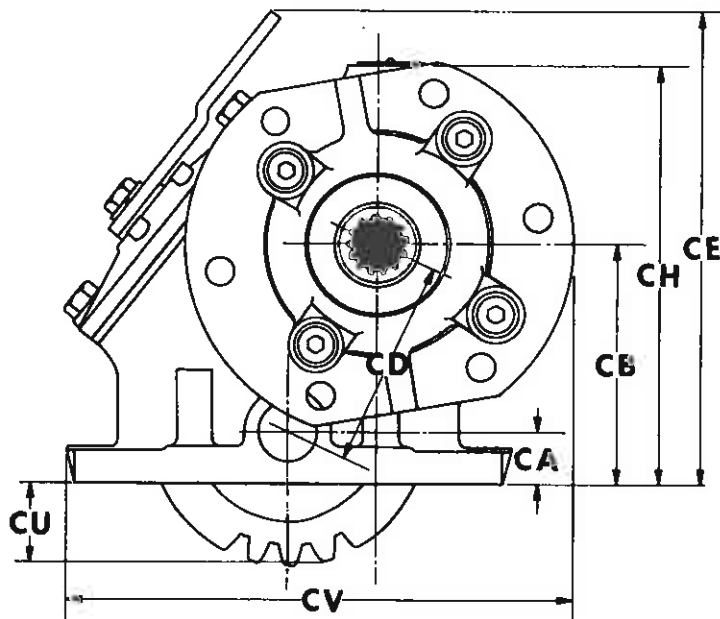
P410-381

P.T.O. CASE PUMP FLANGE & SHAFT DIMENSIONS



| P.T.O. Series | Part Number | CA | CB | CD | CE (d) | CH (d) | CU | CV |
|-----------------|-------------|-------|--------|--------|---------|--------|--------|--------|
| 420X Standard | 1-P-195 | .792" | 3.604" | 3.087" | 7.500" | 6.250" | 1.100" | 7.250" |
| 420Z Deep Mount | 1-P-196 | .572" | 3.384" | 3.087" | 7.2187" | 6.000" | 1.330" | 7.250" |

(d) - Approximate Dimension for estimating clearance in installations.



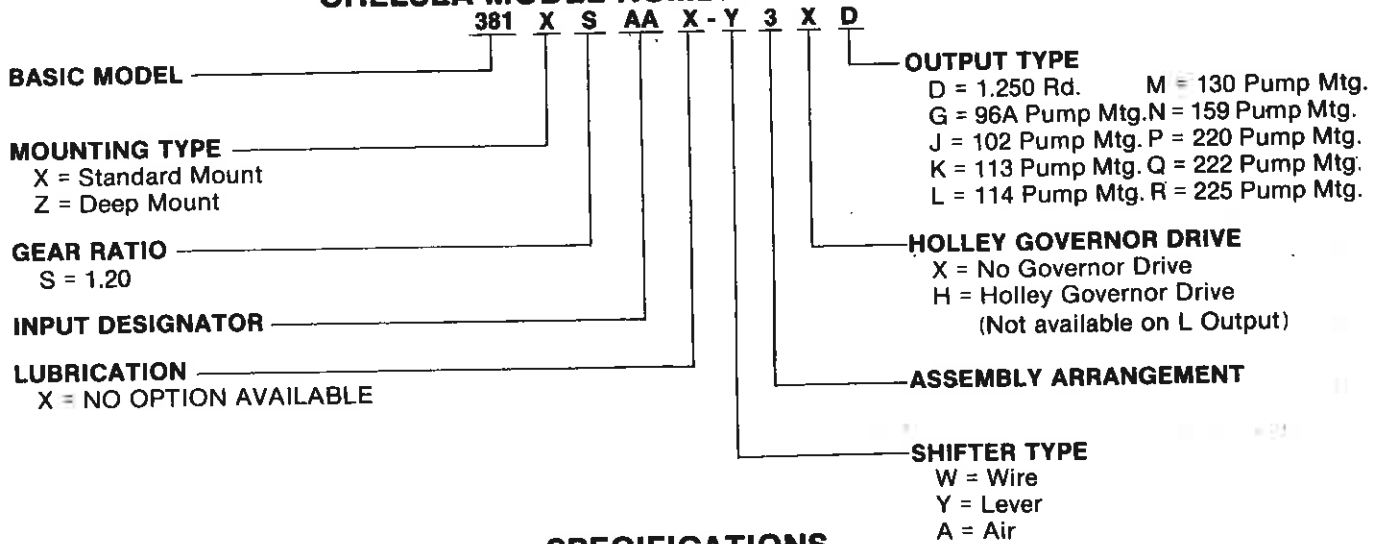
| Pump Suffix | Bolt Holes | | | FC Female Pilot Diameter | FD Depth of Pilot | FE Face to outer end of Shaft | FF Face thru Shaft Hole | FH Face to Center of P.T.O. | Output Shaft Hole | | |
|-------------|--|----------------|-----------------------------|--------------------------------|----------------------------|---|-------------------------------------|--------------------------------------|-----------------------|-----------------|------------------------|
| | Circle | Tapped Hole | Number Equally Spaced | | | | | | Round Hole Dia. | Keyway Width | Spline Hole Dia. |
| G | 4.188" | 3/8"-16 | 4 | 3.251/3.253" | .562" | .469" | 2.094" | 4.562" | 3/4" | 3/16" | — |
| J | 4.188" | 3/8"-16 | 4 | 3.251/3.253" | .562" | 1.406" | 2.812" | 4.562" | 3/4" | 3/16" | — |
| K | 5.000" | 1/2"-13 | 4 | 4.0005/4.0025" | .406" | .562" | 1.938" | 3.688" | — | — | 7/8"-13T |
| | 5.750" | 1/2"-13 | 2 | | | | | | | | |
| L | 4.188" | 3/8"-16 | 4 | 3.251/3.253" | .562" | .562" | 2.062" | 4.562" | — | — | 7/8"-13T |
| M | 3.250" | 3/8"-16 | 6 | 2.626/2.631" | .688" | .312" | 1.719" | 3.438" | 3/4" | 3/16" | — |
| N | 4.750" | 13/32" | Drill 6 | 3.251/3.253" | .375" | .750" | 2.125" | 3.875" | — | — | 7/8"-13T |
| P | 5.000" | 1/2"-13 | 4 | 3.251/3.253" | .344" | .562" | 1.937" | 3.688" | — | — | 7/8"-13T |
| | 4.188" | 3/8"-16 | 2 | | | | | | | | |
| Q | 5.000" | 1/2"-13 | 4 | 4.0005/4.0025" | .406" | .562" | 1.938" | 3.688" | — | — | 7/8"-13T |
| | 5.750" | 1/2"-13 | 2 | | | | | | | | |
| R | Special Assembly For Mounting To Chelsea 1438 Only, See Page 8 . | | | | | | | | | | |

| P.T.O. Model | Input Cluster Gear | Number of Teeth | Transmission Applications | Pitch & Pressure Angle |
|--------------|--------------------|-----------------|--|-------------------------------------|
| 381*SAA | 5-P-416 | 18 | Military 6 x 6 (Reference Only) | 5P-17°30' PA-Spur |
| 381*SAB | 5-P-213 | 19 | Universal 5-Pitch | 5P-20° PA-Spur |
| 381*SAC | 5-P-575 | 19 | Fiat | 5.3474P-22°30' PA-Spur |
| 381*SAG | 5-P-215 | 22 | Spicer | 6P-17°30' PA-Spur |
| 381*SAH | 5-P-214 | 22 | Universal 6-Pitch | 6P-20° PA-Spur |
| 381*SAL | 5-P-534 | 23 | Fuller T-1056A Series | 6.2418P-19°17' PA-Spur |
| 381*SAQ | 5-P-414 | 21 | Spicer 7041 Series | 6P-17°30' PA-26°00'48" L.H. |
| 381*SAR | 5-P-216 | 21 | Spicer 6000 Series | 6P-17°30' PA-26°10'37" L.H. |
| 381*SAW | 5-P-219 | 22 | New Process 541 Series | 6P-20° PA-17°40'41" L.H. |
| 381*SAX | 5-P-525 | 22 | Clark 397V Series | 6.100P-25° PA-18°40'48" R.H. |
| 381*SBA | 5-P-271 | 23 | I.H.C. T-34, T-35 Series | 6.5400P-18°27'54" PA-23°26'48" L.H. |
| 381*SBE | 5-P-210 | 27 | Chevrolet 4-Speed | 7P-20° PA-Spur |
| 381*SBF | 5-P-205 | 27 | Warner T-9, T-97 Series | 7P-22°30' PA-Spur |
| 381*SBG | 5-P-419 | 24 | Spicer 5000 Series | 7P-17°30' PA-28°4'23" L.H. |
| 381*SBH | 5-P-212 | 25 | Spicer 3152 Series | 7P-20° PA-20° R.H. |
| 381*SBJ | 5-P-211 | 25 | Chevrolet 4-Speed | 7P-20° PA-20° L.H. |
| 381*SBL | 5-P-449 | 23 | New Process 205 T.C. | 7P-20° PA-30°20'40" R.H. |
| 381*SBM | 5-P-524 | 22 | Clark 390V Series | 7P-25° PA-30°46'48" L.H. |
| 381*SBN | 5-P-218 | 22 | New Process 540 Series | 7.1592P-16°53'01" PA-33°30' L.H. |
| 381*SBP | 5-P-360 | 26 | Chevrolet 465 with adapter | 7.3449P-20° PA-24° R.H. |
| 381*SBQ | 5-P-359 | 25 | Chevrolet 465 Series | 7.3449P-20° PA-24° L.H. |
| 381*SBR | 5-P-345 | 26 | Clark 300V & 380V Series and New Process 420 with adapter | 7.6168P-18°29'22" PA-23°12'57" R.H. |
| 381*SBS | 5-P-208 | 26 | New Process 420 Series | 7.6168P-18°29'22" PA-23°12'57" L.H. |
| 381*SBY | 5-P-206 | 26 | Warner T-98 Series | 8.0829P-20° PA-30° R.H. |
| 381*SBZ | 5-P-207 | 26 | Warner T-98 Series | 8.0829P-20° PA-30° L.H. |
| 381*SCB | 5-P-272 | 25 | New Process 435 Series | 8.1160P-20° PA-33°30' L.H. |
| 381*SCC | 5-P-447 | 26 | New Process 4 Speed 435-D Series | 8.2559P-20° PA-33°30' L.H. |
| 381*SCD | 5-P-363 | 27 | Warner T-18A & T-18B Series | 8.0829P-20° PA-30° L.H. |
| 381*SCM | 5-P-217 | 22 | New Process | 6P-20° PA-Spur |
| 381*SDB | 5-P-619 | 39 | Fuller T 11606 Series | 10.1P-20° PA-Spur |
| 381*SDD | 5-P-687 | 20 | Spicer | 5.8500P-20° PA-Spur |
| ▲381*KIT | — | — | — | — |

▲Includes All Parts Except Input Cluster Gear, Which Must be Ordered According to Transmission Application in P400-A.

When reinstalling the Power Take-Off on the transmission, the backlash between the Power Take-Off gear and the transmission gear should be approximately .006-.012". If too few gaskets are used, the unit will whine; if too many, the unit will clatter.

CHELSEA MODEL NUMBER CONSTRUCTION



SPECIFICATIONS

| | |
|--------------------------|---------------|
| Torque Rating | 140 Lbs. Ft.* |
| Horsepower Rating | 13.2* |
| 500 RPM of Output Shaft | 26.5* |
| 1000 RPM of Output Shaft | 26 Lbs. |
| Approximate Weight | |

* - Based on Intermittent Service