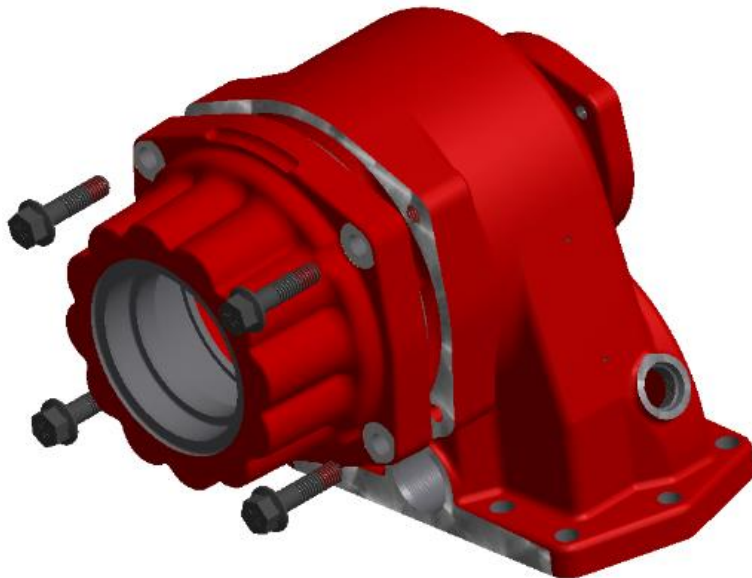


## 280/870 Bearing Cap Bolt Enhancement

Serial Number Jump-Off – 6102\*\*\*\* and Later  
Start Date April 11, 2016

As a part of Chelsea's continuous improvement in power take-off design, Chelsea Engineering has enhanced the robust design of the **280/287** and **870/877** Series PTOs. Our new bearing cap bolt modification will increase our PTO's ability to endure severe vocational applications.

**Effective Monday, April 11, 2016**, Chelsea will begin to produce the 280/287 and 870/877 Series PTOs with a change to the bolts, bearing caps, and housings of the PTOs. Here are the features and benefits of the new design:



**Size** – The nominal size of the bolt will change from 5/16" to 3/8" (Grade 8) – improved fatigue resistance.

**Fastener Style** – The current Socket Head Cap Screw design will be replaced by a Hex Flange Head Cap Screw – improved contact area under the bolt head.

**Spot-faced bolt landing** – The bearing cap will be spot-faced to improve the contact surface area between the bolt and bearing cap – improved bolt torque retention.

This is a running change and there is no need to adjust or alter current inventory.

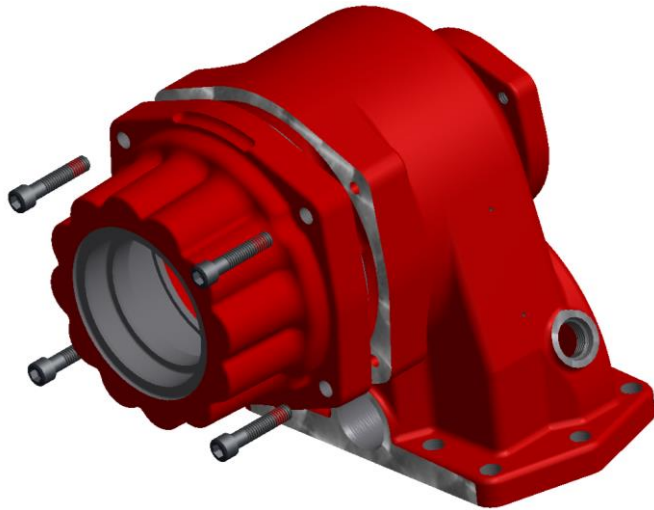
The following pages will address the part number changes associated with this product enhancement.

If you have questions about this bulletin or other technical questions, contact us at:

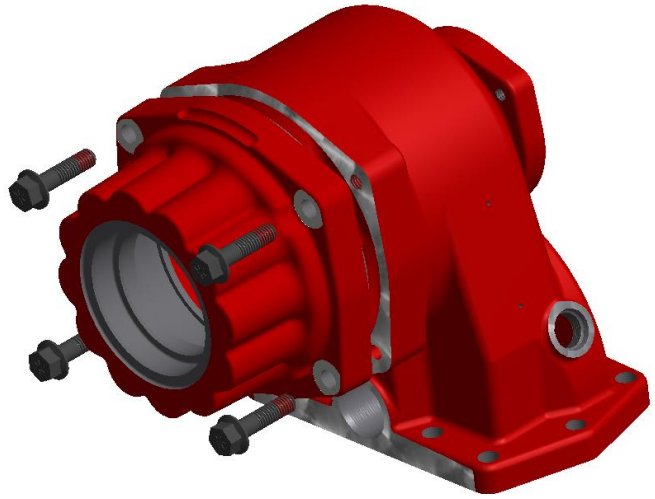
US: Chelsea Customer/Technical Services **1-888-PH4-TRUK** (1-888-744-8785)  
Canada: Parker Hannifin Canada, 1 905-693-3020  
Europe: Parker Hannifin Europe, +49 (0)371 3937 157



Curtis Dalton  
Product Sales Manager  
Chelsea Products



**Old Style**  
Prior to 4/11/16



**New Style**  
4/11/16 and Later

|                    | Old P/N    | New P/N    | Short Description                   | PTO Series      | List Price |
|--------------------|------------|------------|-------------------------------------|-----------------|------------|
| <b>BOLTS</b>       | 378447-8   | 380563-14  | Bolt P/N w/o Brake Option           | 280/287/870/877 | \$ 4.38    |
|                    | 378447-16  | 380563-28  | Bolt P/N w/ Brake Option            | 280/287/870/877 | \$ 7.58    |
| <b>HOUSING</b>     | 1-P-703    | 1-P-763    | Housing P/N - 3 Arr                 | 280/287         | \$ 424.81  |
|                    | 1-P-705    | 1-P-765    | Housing P/N - 5 Arr                 | 280/287         | \$ 424.81  |
|                    | 1-P-708    | 1-P-768    | Housing P/N - 8 Arr                 | 280/287         | \$ 424.81  |
|                    | 1-P-665    | 1-P-762    | Housing P/N - 3 Arr                 | 870/877         | \$ 618.80  |
|                    | 1-P-667    | 1-P-764    | Housing P/N - 5 Arr                 | 870877          | \$ 618.80  |
| <b>BEARING CAP</b> | 21-P-766   | 21-P-881   | Bearing Cap XD/XV/AB/AC/SD/SV/SB/SC | 280/870/287/877 | \$ 155.82  |
|                    | 21-P-767   | 21-P-882   | Bearing Cap RK/RF/RS/RZ/XR          | 280/870/287/877 | \$ 155.82  |
|                    | 21-P-772   | 21-P-883   | Bearing Cap RK/RF/RS/RZ Wet Spline  | 280/870/287/877 | \$ 183.95  |
|                    | 21-P-773   | 21-P-884   | Bearing Cap BA/BB/BC/BV             | 280/287/870/877 | \$ 784.65  |
|                    | 21-P-691   | 21-P-888   | Bearing Cap BD                      | 280/287         | \$ 784.65  |
|                    | 23-P-68    | 23-P-73    | Drag Brake Bearing Cap Spacer       | 280/287/870/877 | \$ 316.19  |
| <b>GASKET</b>      | 22-P-101   | 22-P-151   | Bearing Cap Gasket                  | 280/287/870/870 | \$ 7.05    |
| <b>SEAL KITS</b>   | 329071-55X | 329071-79X | Gasket & Seal Kit - 870             | 870/877         | \$ 205.42  |
|                    | 329071-62X | 329071-80X | Gasket & Seal Kit - 280             | 280/287         | \$ 182.90  |

**CONVERSION KITS – 280/870 ONLY**

| <b>Old Kit<br/>Prior to 4/11/16</b> | <b>New Kit<br/>4/11/16 &amp; After</b> | <b>Short Description</b>    | <b>PTO Series</b> | <b>List Price</b> |
|-------------------------------------|--|-----------------------------|-------------------|-------------------|
| 329160-77X                          | 329160-119X                            | KIT-CONVERSION-XD/XV TO SD  | 280               | \$ 552.55         |
| 329160-78X                          | 329160-120X                            | KIT-CONVERSION-XV TO SV     | 280               | \$ 584.03         |
| 329160-79X                          | 329160-121X                            | KIT-CONVERSION-XD TO RK DRY | 280               | \$ 921.55         |
| 329160-80X                          | 329160-122X                            | KIT-CONVERSION-XD TO RK WET | 280               | \$ 1,060.66       |
| 329160-81X                          | 329160-123X                            | KIT-CONVERSION-XD TO BA     | 870               | \$ 2,985.39       |
| 329160-82X                          | 329160-124X                            | KIT-CONVERSION-XD TO RF DRY | 870/280           | \$ 988.44         |
| 329160-83X                          | 329160-125X                            | KIT-CONVERSION-XD TO RF WET | 870/280           | \$ 1,127.55       |
| 329160-84X                          | 329160-126X                            | KIT-CONVERSION-XD TO RS DRY | 870               | \$ 988.44         |
| 329160-85X                          | 329160-127X                            | KIT-CONVERSION-XD TO RS WET | 870               | \$ 1,127.55       |
| 329160-86X                          | 329160-128X                            | KIT-CONVERSION-XD TO RY DRY | 870               | \$ 1,165.45       |
| 329160-87X                          | 329160-129X                            | KIT-CONVERSION-XD TO RY WET | 870               | \$ 1,304.56       |
| 329160-88X                          | 329160-130X                            | KIT-CONVERSION-XD TO AB     | 870/280           | \$ 952.20         |
| 329160-89X                          | 329160-131X                            | KIT-CONVERSION-XD TO SB     | 280               | \$ 559.18         |
| 329160-92X                          | 329160-134X                            | KIT-CONVERSION-XD TO AC     | 870/280           | \$ 945.57         |
| 329160-93X                          | 329160-135X                            | KIT-CONVERSION-XD TO SC     | 280               | \$ 552.55         |
| 329160-94X                          | 329160-136X                            | KIT-CONVERSION-XD TO BD     | 280               | \$ 1,820.64       |
| 329160-95X                          | 329160-137X                            | KIT-CONVERSION-XD TO RZ DRY | 870/280           | \$ 1,127.54       |
| 329160-96X                          | 329160-138X                            | KIT-CONVERSION-XD TO RZ WET | 870/280           | \$ 1,266.65       |
| 329160-97X                          | 329160-139X                            | KIT-CONVERSION-XD TO XV     | 280               | \$ 945.57         |
| 329160-98X                          | 329160-140X                            | KIT-CONVERSION-XD TO BB     | 870               | \$ 2,041.55       |
| 329160-99X                          | 329160-141X                            | KIT-CONVERSION-XD TO BC     | 870               | \$ 2,041.55       |

