

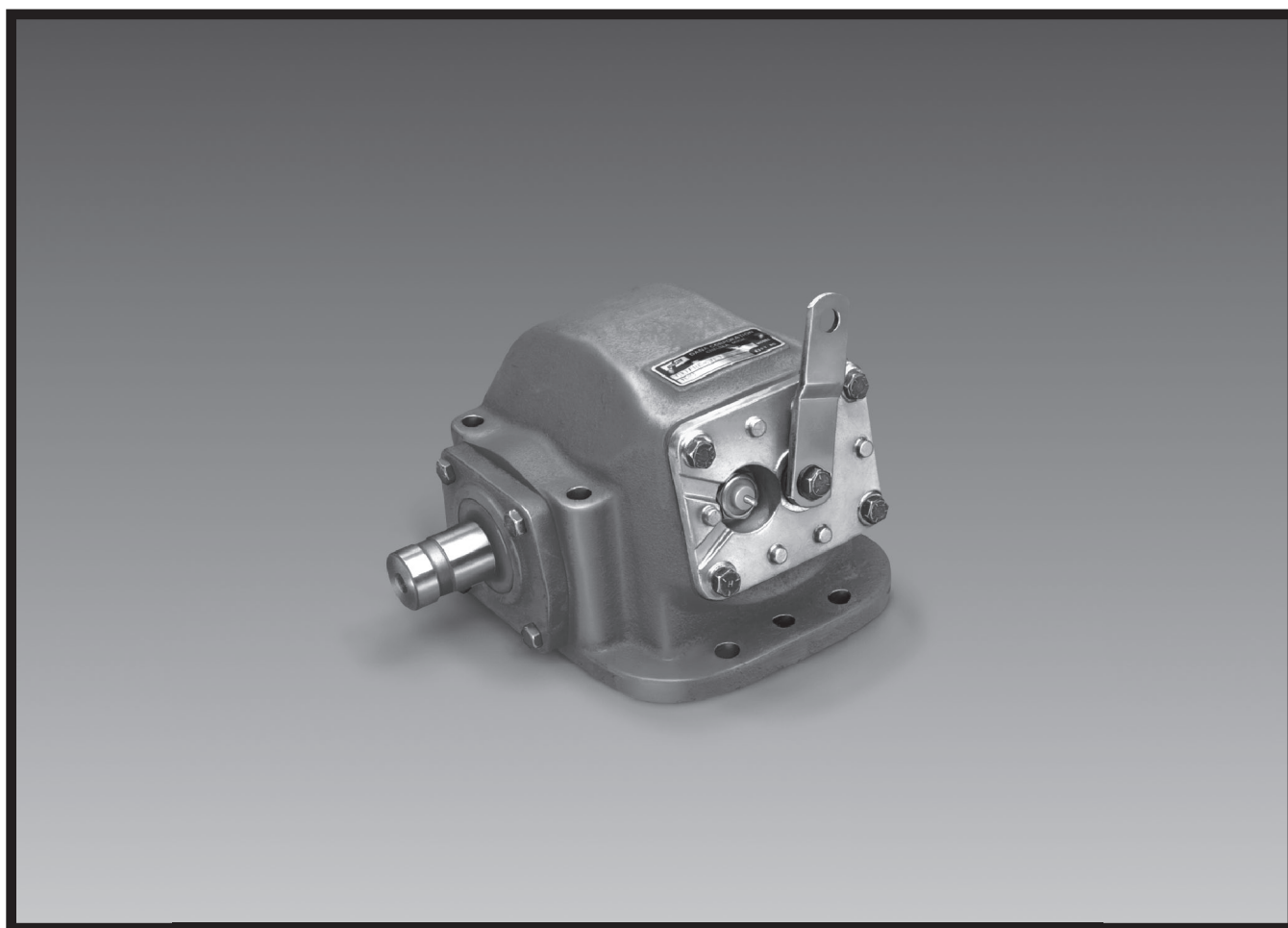
**CHELSEA®**

Bulletin HY25-2812-M1/US

# Parts List 812 Series

Effective: January 15, 2016  
Supersedes: HY25-2812-M1/US  
Dated March 15, 2002

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### **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.

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### **Offer of Sale**

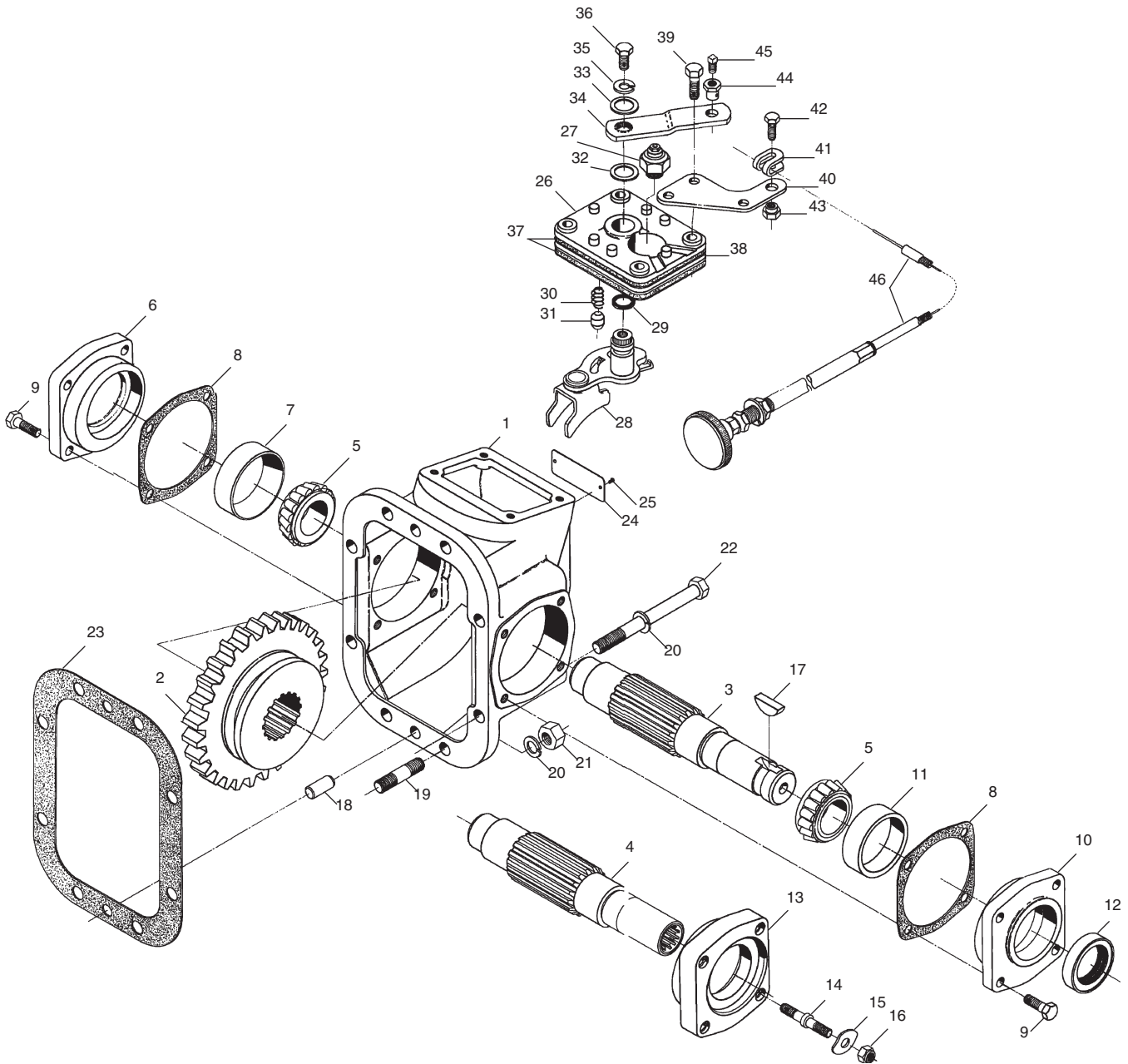
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Bill of Materials

Item	Part Number	Description	Quantity
1	1-P-356	Housing, Standard Mount.....1 Housing, Deep Mount (Use standard housing and rotate both bearing covers (items 6 & 10) 180° to increase depth by .380")	1
2	See Chart Pg. 3	Drive Gear.....1	1
3	See Chart Pg. 3	Drive Shaft.....1	1
4	See Chart Pg. 3	Pump Shaft.....	
5	550397	Cone, Tapered Bearing.....2	2
	560970	Cone, Tapered Bearing ("XY" Output)	
6	328274X	Bearing Cap Assembly, Closed End (Includes Race 550221).....1	1
7	550221	Bearing Race.....1	1
8	22-P-24-1	Gasket, Bearing Cap (.010" Thickness).....A.R.	A.R.
	22-P-24-2	Gasket, Bearing Cap (.020" Thickness).....A.R.	A.R.
	22-P-24-3	Gasket, Bearing Cap (.015" Thickness).....A.R.	A.R.
9	378430-10	Screw, Hex head Self Locking (.312" - 18 x 1").....8	8
10	328273X	Bearing Cap Assembly, Open End (Includes Race 550221).....1	1
11	550221	Bearing Race.....1	1
12	28-P-216	Oil Seal.....1	1
13	See Chart Pg. 3	Pump Flanges.....1	1
14	379673	Stud, Mounting (For Ass'y "R").....4	4
	328711X	Pump to P.T.O. Mounting, (For Ass'y "R") (Includes Items 15 & 16).....1	1
15	378919	Washer, Special (For Ass'y "R").....4	4
16	500963-1	Nut, Hex Head Self Locking (.312" - 24) (For Ass'y "R").....4	4
17	500007-29	Woodruff Key.....1	1
	328170-115X	P.T.O. Mounting Kit.....1	1
18	378054	Dowel Pin (.438 x 1.000).....2	2
19	379424-19	Stud (.437" - 14 & 20 x 2.250").....4	4
20	500357-12	Lockwasher (.437").....8	8
21	500371-4	Nut (.437" - 20).....4	4
22	379287-33	Screw (.437" - 14 x 4.750") Hex Head.....4	4
N.S.	379224	Tab Lockwasher.....8	8
23	35-P-15-1	Gasket, Mounting (.010" Thickness).....A.R.	A.R.
	35-P-15-2	Gasket, Mounting (.020" Thickness).....A.R.	A.R.
24	68-P-2	Nameplate.....1	1
25	378422	Screw.....2	2
		Cover Assembly.....1	1
	328804-1X	Wire Control Shifter, Ass'y. 3 & 6 (Includes Items 26-36).....1	1
	328804-2X	Wire Control Shifter, Ass'y. 4 & 5 (Includes Items 26-36).....1	1
26	34-P-75	Cover, Shifter.....1	1
27	379639	Indicator Switch.....1	1
28	328803-1X	Plate & Post Shifter Assembly, (Ass'y. 3 & 6).....1 (Includes 500603-14 Spring Pin N/S)	1
	328803-2X	Plate & Post Shifter Assembly, (Ass'y. 4 & 5) (Includes 500603-14 Spring Pin N/S).....1	1
29	28-P-191	O-Ring.....1	1
30	37-P-19	Spring, Poppet Ball.....1	1
31	63-P-16	Ball, Poppet.....1	1
32	378004	Washer, Flat.....1	1
33	500365-22	Washer, Flat.....1	1
34	51-P-22	Shift Lever.....1	1
35	500356-10	Lock Washer.....1	1
36	500409-6	Screw, Hex head (.312"-24 x .625").....1	1
37	35-P-8	Gasket, Shifter.....1 or	1 or
	35-P-8	Gasket, Shifter (Wire Shift Only).....2	2
38	5-A-125	Spacer, (.062") (KAL Only).....1	1
	5-A-188	Spacer, (.188) (See Chart Page 3).....1	1
39	378430-10	Screw, Hex Head (.312"-18 x 1") (Wire Shift Only).....4 or	4 or
	378430-8	Screw, Hex Head (.312"-18 x .750").....4	4

N.S. — Not Shown    A.R. — As Required

Continued on next page

**Bill of Materials**

Item	Part Number	Description	Quantity
	<b>328380X</b>	<b>Loose Parts</b>	
40	<b>50-P-17</b>	Parts Kit, Cable Control Mounting (Includes Items 40-45) .....	1
41	<b>50-P-19</b>	Bracket, Control.....	1
42	<b>500396-8</b>	Clip, Swivel.....	1
43	<b>378326</b>	Screw, Hex Head (.250" - 20 x .750").....	1
44	<b>378019</b>	Nut, Hex (.250" - 20) .....	1
45	<b>500568-4</b>	Pin, Pivot.....	1
		Set Screw, Square Head (.250" -20 x .500").....	1
46	<b>328346-10X</b>	Control Wires, ASSEMBLY .....	1
		(Includes One Each 378502 Knob and 378441-10, 10' Cable)	
	<b>328948-8X</b>	Gasket & Installation Instructions .....	1
	<b>328751X</b>	Lever or Wire Shift Kit.....	1
		<b>Service Kits</b>	
	<b>328356-48X</b>	Gasket & Seal Kit	
	<b>328356-15X</b>	Gasket & Seal Kit, Cable	
	<b>328356-18X</b>	Gasket & Seal Kit, Lever	
	<b>328356-19X</b>	Gasket & Seal Kit, Air	

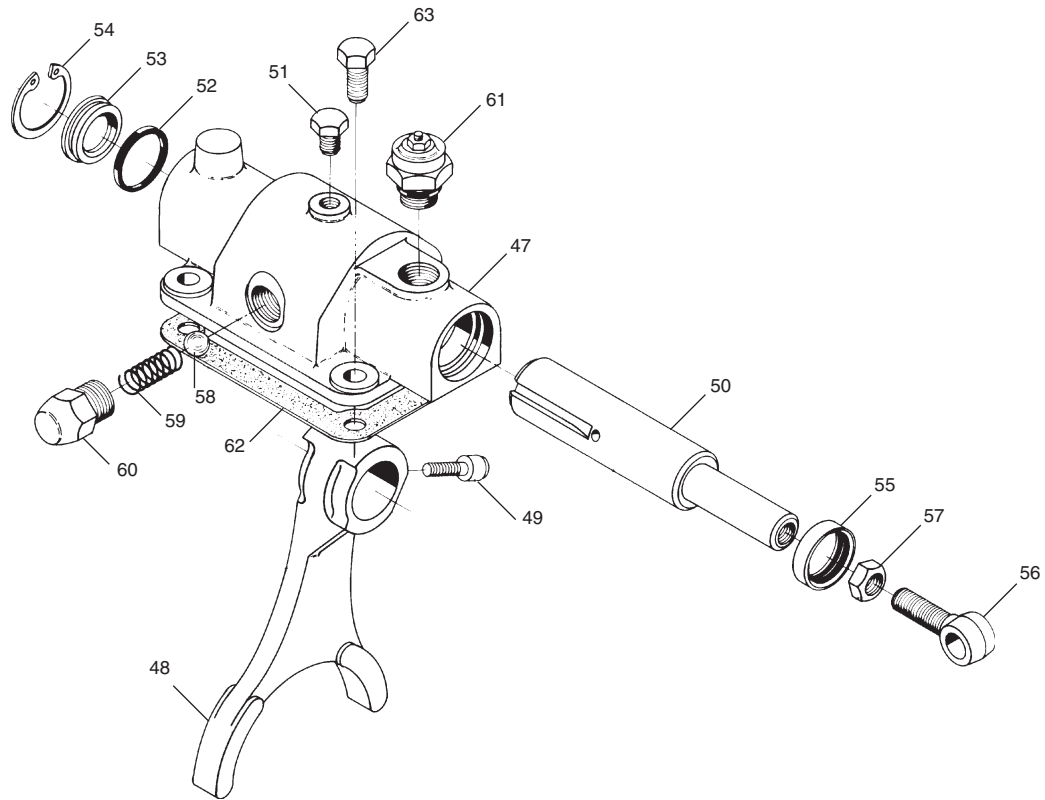
**Gear & Shaft Chart**

	Drive Gear		Output Shaft					Spacer Item 38
	Input Gear Item #2	Helix Angle	XD Item #3	XR,RA, RB Item #4	XY Item #4	AK Item #4	XX Item #3	
812*KAH	2-P-509	SPUR	3-P-706	3-P-708	3-P-824	3-P-837	3-P-765	5-A-188
812*KBG	2-P-510	LH	3-P-707	3-P-709		3-P-842		5-A-188
812*KAR	2-P-511	LH	3-P-711	3-P-714				5-A-188
812*KAB	2-P-517	SPUR	3-P-706	3-P-708	3-P-824	3-P-837	3-P-765	5-A-188
812*KAL	2-P-533	SPUR	3-P-706	3-P-708	3-P-824	3-P-837	3-P-765	5-A-125
812*KDA	2-P-621	SPUR	3-P-706	3-P-708	3-P-824	3-P-837	3-P-765	5-A-188
812*KDB	2-P-598	SPUR	3-P-706	3-P-708	3-P-824	3-P-837	3-P-765	5-A-188

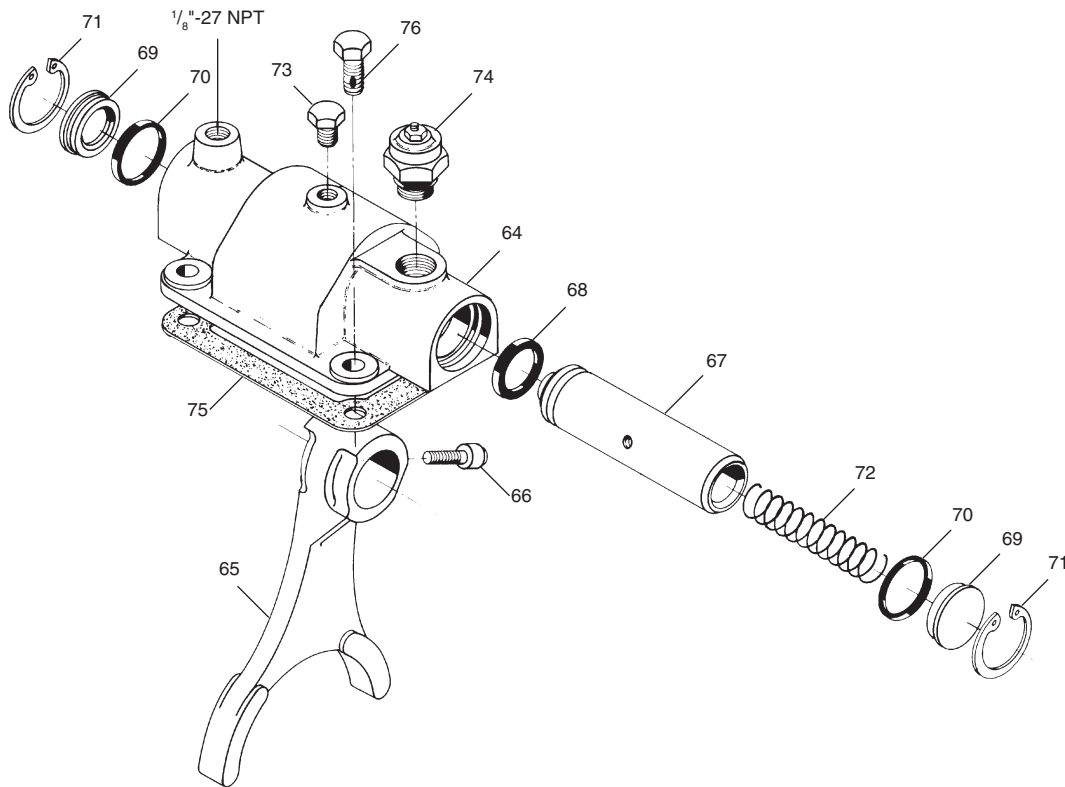
**Flange Chart & Conversion Kits**

	AK	RA (1)(3)	RB (2)(3)	XR	XY	XX
812*KAH	329010X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-54X (XR to RB) 328591-66X (XD to RB)	328591-64X	328981X	328273X
812*KBG	329101X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-54X (XR to RB) 328591-66X (XD to RB)	328591-64X		
812*KAR		328591-53X (XR to RA) 328591-65X (XD to RA)	328591-66X (XD to RB) 328591-54X (XR to RB)	328591-64X		
812*KAB	329010X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-66X (XD to RB) 328591-54X (XR to RB)	328591-64X	328981X	328273X
812*KAL	329010X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-66X (XD to RB) 328591-54X (XR to RB)	328591-64X	328981X	328273X
812*KDA	329010X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-66X (XD to RB) 328591-54X (XR to RB)	328591-64X	328981X	328273X
812*KDB	329010X	328591-53X (XR to RA) 328591-65X (XD to RA)	328591-66X (XD to RB) 328591-54X (XR to RB)	328591-64X	328981X	328273X

- 1 Pump Flange (21-P-628) Shipped Loose with Unit.
- 2 Pump Flange (21-P-572) Shipped Loose with Unit.
- 3 Requires seven 378447-6 socket head capscrews; four to fasten the flange assembly 329195X to the housing and three to the rotatable flange assembly.



Item	Part Number	Description	Quantity
	<b>328752X</b>	Lever Control Cover Assembly (Includes Items 47-61) .....	1
47	<b>34-P-60</b>	Cover, Shifter .....	1
48	<b>32-P-133</b>	Shift Fork.....	1
49	<b>378447-4</b>	Screw, Hex Socket Head (.312" - 18 x .750").....	1
50	<b>11-P-117</b>	Shaft, Shifter .....	1
51	<b>379123</b>	Screw, Hex Head (.312" - 24 x .375").....	1
52	<b>28-P-42</b>	O-Ring.....	1
53	<b>378315</b>	Plug, Cover .....	1
54	<b>378316</b>	Snap Ring .....	1
55	<b>28-P-229</b>	Oil Seal.....	1
56	<b>36-P-1</b>	Eye Bolt.....	1
57	<b>500381-3</b>	Nut, Hex (.375" - 24) .....	1
58	<b>378002</b>	Ball, Poppet.....	1
59	<b>37-P-14</b>	Spring, Poppet Ball .....	1
60	<b>378554</b>	Cap.....	1
61	<b>379639</b>	Switch, Indicator.....	1
62	<b>35-P-8</b>	Gasket, Shifter Cover .....	1
63	<b>378430-8</b>	Screw, Hex Head (.312"-18 x .750").....	4

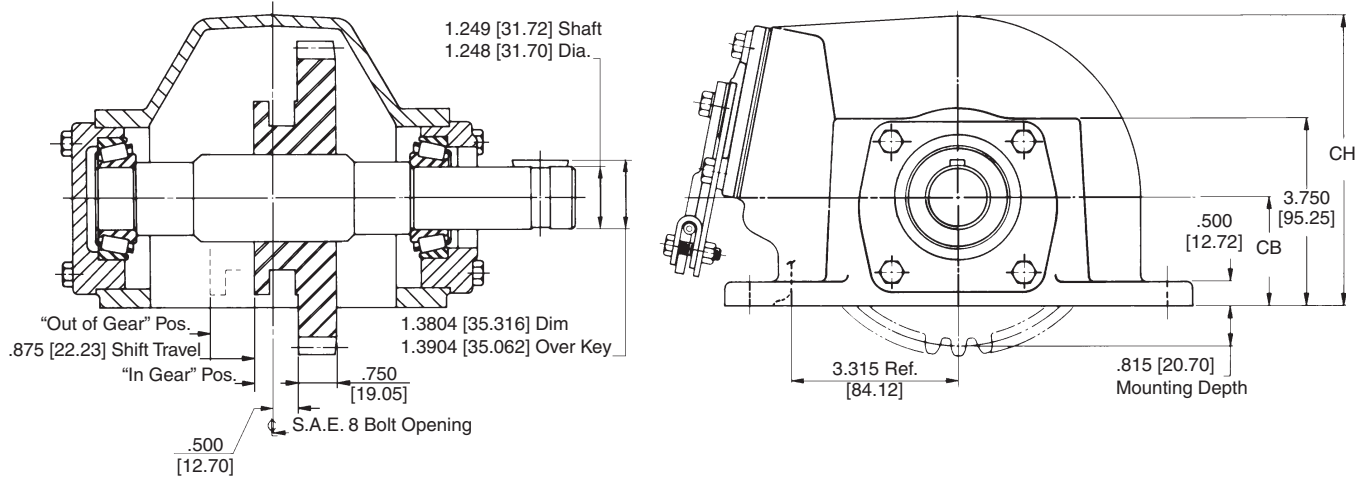


Item	Part Number	Description	Quantity
	<b>328753X</b>	Air Shift Cover Assembly (Includes Items 64-74) .....	1
64	<b>34-P-115</b>	Cover, Shifter .....	1
65	<b>32-P-133</b>	Shift Fork.....	1
66	<b>378447-4</b>	Screw, Hex Socket Head (.312" - 18 x .750").....	1
67	<b>11-P-75</b>	Shaft, Piston.....	1
68	<b>28-P-41</b>	O-Ring.....	1
69	<b>378315</b>	Plug, Cover .....	2
70	<b>28-P-42</b>	O-Ring.....	2
71	<b>378316</b>	Snap Ring .....	2
72	<b>37-P-21</b>	Spring.....	1
73	<b>379123</b>	Screw, Hex Head Cap (.312" - 24 x .375").....	1
74	<b>379639</b>	Switch, Indicator.....	1
75	<b>35-P-8</b>	Gasket, Shifter Cover .....	1
76	<b>378430-8</b>	Screw, Hex Head (.312" - 18 x .750").....	4
	<b>328388-37X</b>	Installation Kit, Air Shift.....	1
	<b>328388-47X</b>	Installation Kit, 12 Volt Electric over Air .....	1
	<b>328388-48X</b>	Installation Kit, 24 Volt Electric over Air .....	1
		Air Shift Conversion Kit	
		Air-o-matic	
	<b>328390-90X</b>	Wire to Air, All Assemblies.....	1
	<b>328390-89X</b>	Lever to Air, All Assemblies .....	1
	<b>328390-113X</b>	Wire to 12 Volt Electric over Air .....	1
	<b>328390-114X</b>	Wire to 24 Volt Electric over Air .....	1
	<b>328390-111X</b>	Lever to 12 Volt Electric over Air .....	1
	<b>328390-112X</b>	Lever to 24 Volt Electric over Air.....	1

**Case Dimensions**

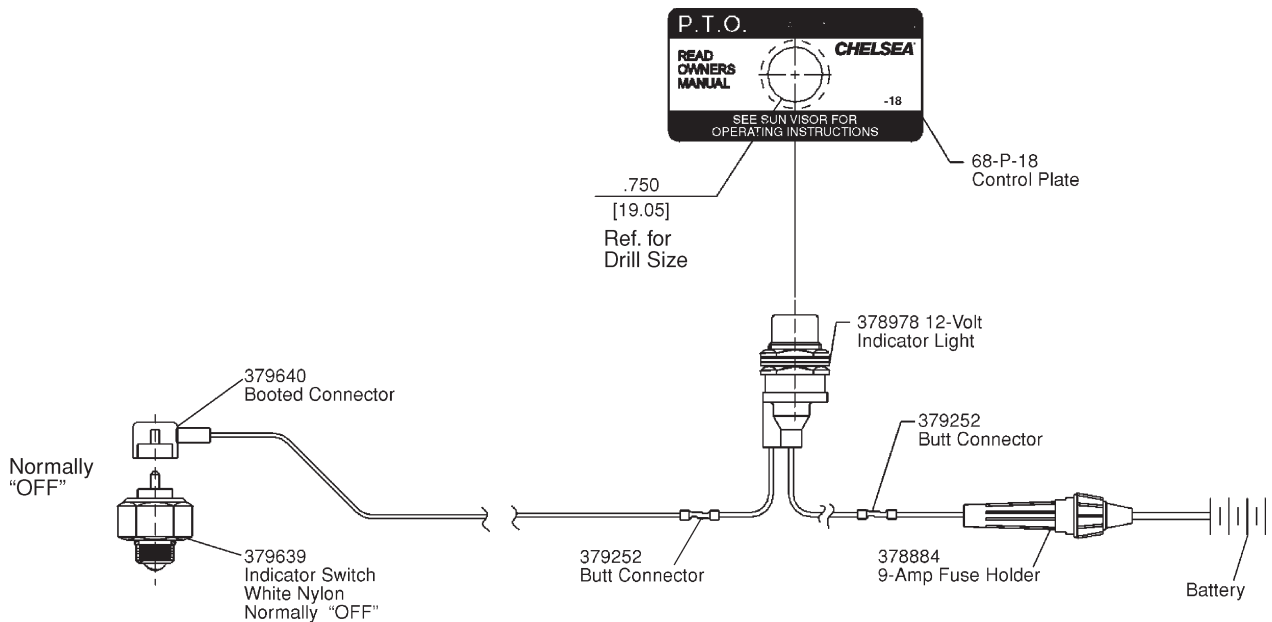
**Basic Model 812**

- CB Face of Case to Center Line of Output Shaft Hole.....2.188"
- CH Face of Case to Extreme Horizontal Edge of Case — Clearance.....5.813"

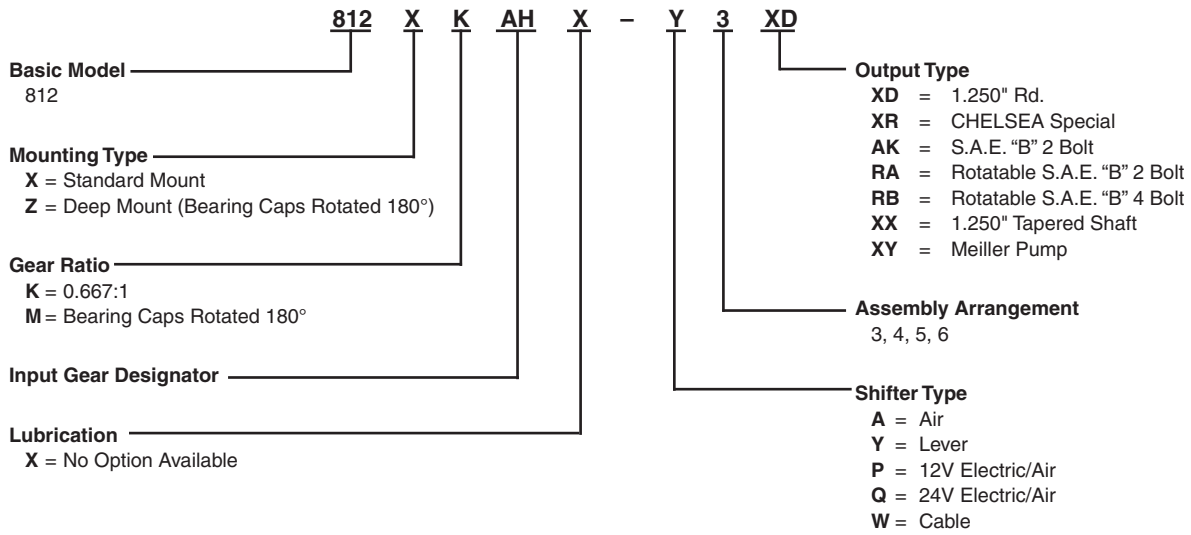


Metric Dimensions in Millimeters Given in Brackets

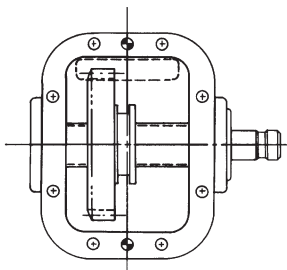
**Cable & Lever Control Indicator Light Installation Sketch  
328751-1X**



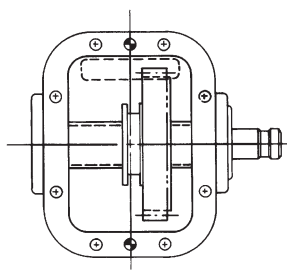
**Model Number Designation**



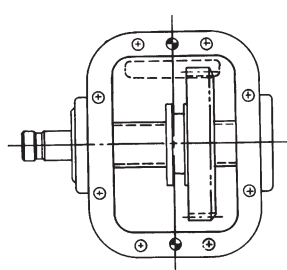
**Assembly Arrangements**



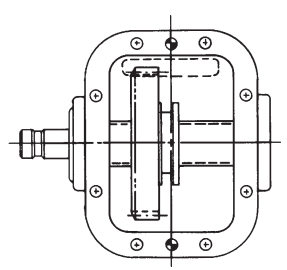
**Assembly 3**



**Assembly 4**



**Assembly 5**



**Assembly 6**

# Parker Hannifin Corporation – Chelsea Division

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**1. Terms and Conditions.** Seller’s willingness to offer Products, or accept an order for Products, to or from Buyer is subject to these Terms and Conditions or any newer version of the terms and conditions found on-line at [www.parker.com/saleterms/](http://www.parker.com/saleterms/). Seller objects to any contrary or additional terms or conditions of Buyer’s order or any other document issued by Buyer.

**2. Price Adjustments; Payments.** Prices stated on Seller’s quote or other documentation offered by Seller are valid for 30 days, and do not include any sales, use, or other taxes unless specifically stated. Unless otherwise specified by Seller, all prices are F.C.A. Seller’s facility (INCOTERMS 2010). Payment is subject to credit approval and is due 30 days from the date of invoice or such other term as required by Seller’s Credit Department, after which Buyer shall pay interest on any unpaid invoices at the rate of 1.5% per month or the maximum allowable rate under applicable law.

**3. Delivery Dates; Title and Risk; Shipment.** All delivery dates are approximate and Seller shall not be responsible for any damages resulting from any delay. Regardless of the manner of shipment, title to any products and risk of loss or damage shall pass to Buyer upon placement of the products with the shipment carrier at Seller’s facility. Unless otherwise stated, Seller may exercise its judgment in choosing the carrier and means of delivery. No deferment of shipment at Buyer’s request beyond the respective dates indicated will be made except on terms that will indemnify, defend and hold Seller harmless against all loss and additional expense. Buyer shall be responsible for any additional shipping charges incurred by Seller due to Buyer’s acts or omissions.

**4. Warranty.** Seller warrants that all products sold, other than the 590 Series, conform to the applicable Parker Chelsea standard specification for the lesser period of 2 years (24 Months) from date of service or 2-1/2 years (30 Months) from date of build (as marked on the product name plate). Seller warrants that the 590 Series will conform to the applicable Seller standard specification for the lesser period of 2 years (24 Months) from date of service or 2000 hours of usage. 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 DESIGN, MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.**

**5. Claims; Commencement of Actions.** Buyer shall promptly inspect all Products upon delivery. No claims for shortages will be allowed unless reported to the Seller within 10 days of delivery. No other claims against Seller will be allowed unless asserted in writing within 30 days after delivery. Buyer shall notify Seller of any alleged breach of warranty within 30 days after the date the defect is or should have been discovered by Buyer. Any action based upon breach of this agreement or upon any other claim arising out of this sale (other than an action by Seller for an amount due on any invoice) must be commenced within 12 months from the date of the breach without regard to the date breach is discovered.

**6. LIMITATION OF LIABILITY. UPON NOTIFICATION, SELLER WILL, AT ITS OPTION, REPAIR OR REPLACE A DEFECTIVE PRODUCT, OR REFUND THE PURCHASE PRICE. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER FOR ANY SPECIAL, INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES ARISING OUT OF, OR AS THE RESULT OF, THE SALE, DELIVERY, NON-DELIVERY, SERVICING, USE OR LOSS OF USE OF THE PRODUCTS OR ANY PART THEREOF, OR FOR ANY CHARGES OR EXPENSES OF ANY NATURE INCURRED WITHOUT SELLER’S WRITTEN CONSENT, EVEN IF SELLER HAS BEEN NEGLIGENT, WHETHER IN CONTRACT, TORT OR OTHER LEGAL THEORY. IN NO EVENT SHALL SELLER’S LIABILITY UNDER ANY CLAIM MADE BY BUYER EXCEED THE PURCHASE PRICE OF THE PRODUCTS.**

**7. User Responsibility.** The user, through its own analysis and testing, is solely responsible for making the final selection of the system and Product 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 and follow applicable industry standards and Product information. If Seller provides Product or system options, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the Products or systems.

**8. Loss to 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, will be considered obsolete and may be destroyed by Seller after two consecutive years have elapsed without Buyer ordering the items 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. Special Tooling.** A tooling charge may be imposed for any special tooling, including without limitation, dies, fixtures, molds and patterns, acquired to manufacture Products. 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 Products, 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.

**10. Buyer’s Obligation; Rights of Seller.** To secure payment of all sums due or otherwise, Seller shall retain a security interest in the goods delivered and this agreement shall be deemed a Security Agreement under the Uniform Commercial Code. Buyer authorizes Seller as its attorney to execute and file on Buyer’s behalf all documents Seller deems necessary to perfect its security interest.

**11. Improper use and Indemnity.** Buyer shall indemnify, defend, and hold Seller harmless from any claim, liability, damages, lawsuits, and costs (including attorney fees), whether for personal injury, property damage, patent, trademark or copyright infringement or any other claim, brought by or incurred by Buyer, Buyer’s employees, or any other person, arising out of: (a) improper selection, improper application or other misuse of Products purchased by Buyer from Seller; (b) any act or omission, negligent or otherwise, of Buyer; (c) Seller’s use of patterns, plans, drawings, or specifications furnished by Buyer to manufacture Product; or (d) Buyer’s failure to comply with these terms and conditions. Seller shall not indemnify Buyer under any circumstance except as otherwise provided.

**12. Cancellations and Changes.** Orders shall not be subject to cancellation or change by Buyer for any reason, except with Seller’s written consent and upon terms that will indemnify, defend and hold Seller harmless against all direct, incidental and consequential loss or damage. Seller may change product features, specifications, designs and availability with notice to Buyer.

**13. Limitation on Assignment.** Buyer may not assign its rights or obligations under this agreement without the prior written consent of Seller.

**14. Force Majeure.** Seller does not assume the risk 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, strikes or labor disputes, acts of any government or government agency, acts of nature, delays or failures in delivery from carriers or suppliers, shortages of materials, or any other cause beyond Seller’s reasonable control.

**15. Waiver and Severability.** Failure to enforce any provision of this agreement will not waive that provision nor will any such failure prejudice Seller’s right to enforce that provision in the future. Invalidation of any provision of this agreement by legislation or other rule of law shall not invalidate any other provision herein. The remaining provisions of this agreement will remain in full force and effect.

**16. Termination.** Seller may terminate this agreement for any reason and at any time by giving Buyer thirty (30) days written notice of termination. Seller may immediately terminate this agreement, in writing, if Buyer: (a) commits a breach of any provision of this agreement (b) appoints a trustee, receiver or custodian for all or any part of Buyer’s property (c) files a petition for relief in bankruptcy on its own behalf, or by a third party (d) makes an assignment for the benefit of creditors, or (e) dissolves or liquidates all or a majority of its assets.

**17. Governing Law.** This agreement and the sale and delivery of all Products hereunder shall be deemed to have taken place in and shall be governed and construed in accordance with the laws of the State of Ohio, as applicable to contracts executed and wholly performed therein and without regard to conflicts of laws principles. Buyer irrevocably agrees and consents to the exclusive jurisdiction and venue of the courts of Cuyahoga County, Ohio with respect to any dispute, controversy or claim arising out of or relating to this agreement.

**18. 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 Section. Seller will defend and indemnify Buyer against allegations of infringement of U.S. patents, U.S. trademarks, copyrights, trade dress and trade secrets (“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 a Product sold pursuant to this Agreement 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 a Product 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 the Product, replace or modify the Product so as to make it noninfringing, or offer to accept return of the Product 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 Products 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 Product sold hereunder. The foregoing provisions of this Section shall constitute Seller’s sole and exclusive liability and Buyer’s sole and exclusive remedy for infringement of Intellectual Property Rights.

**19. Entire Agreement.** This agreement contains the entire agreement between the Buyer and Seller and constitutes the final, complete and exclusive expression of the terms of sale. All prior or contemporaneous written or oral agreements or negotiations with respect to the subject matter are herein merged.

**20. Compliance with Law, U. K. Bribery Act and U.S. Foreign Corrupt Practices Act.** Buyer agrees to comply with all applicable laws and regulations, including both those of the United Kingdom and the United States of America, and of the country or countries of the Territory in which Buyer may operate, including without limitation the U. K. Bribery Act, the U.S. Foreign Corrupt Practices Act (“FCPA”) and the U.S. Anti-Kickback Act (the “Anti-Kickback Act”), and agrees to indemnify and hold harmless Seller from the consequences of any violation of such provisions by Buyer, its employees or agents. Buyer acknowledges that they are familiar with the provisions of the U. K. Bribery Act, the FCPA and the Anti-Kickback Act, and certifies that Buyer will adhere to the requirements thereof. In particular, Buyer represents and agrees that Buyer shall not make any payment or give anything of value, directly or indirectly to any governmental official, any foreign political party or official thereof, any candidate for foreign political office, or any commercial entity or person, for the purpose of influencing such person to purchase products or otherwise benefit the business of Seller.

07/14



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