

**BULLETIN BULLETIN BULLETIN BULLETIN BULLETIN****Date:** June 6, 1989**To:** All Chelsea Power Take-Off Customers**Subject:** Warner 1356 Transfer Case

Previously you were notified about a problem obtaining sufficient lubrication for P.T.O. applications on the Warner 1356 transfer case.

Working jointly both Warner and Chelsea have arrived at a solution for providing adequate lubrication for P.T.O. applications on the Warner transfer case.

The 381 or 420 series are the only Chelsea P.T.O.'s that should be used for this application. A new wire or lever shift cover will be required for either Power Take-Off. The new shift covers will have a provision so the breather assembly from the transfer case may be placed in our shift cover. Listed below are the shift cover part numbers and corresponding P.T.O.'s.

SHIFT COVER	DESCRIPTION	P.T.O. MODEL
329054-1X	WIRE SHIFT COVER	381
329055-1X	WIRE SHIFT COVER	420
329056-1X	LEVER SHIFT COVER	381 & 420

The following are the installation instructions for the 381 and 420 series P.T.O.'S on Warner's 1356 transfer case.

1. Remove breather hose and barbed fitting from transfer case.
2. Remove 1/8-27 pipe plug from the Power Take-Off shift cover and install the pipe plug in the breather hole location in the transfer case.
3. Remove the shift cover from the P.T.O. Install the P.T.O. on the transfer case and set backlash at .006 to .012. For more detailed instruction on setting backlash see the P.T.O. owners manual.

4. It has been established, through testing this P.T.O. on the Warner transfer case, that 4.8 quarts (4.525 liters) of oil must be added to the transfer case for continuous duty and maximum load P.T.O. conditions if all the oil was drained from the transmission then 6.9 quarts (6.529 liters) of oil will be required to refill the transmission. The procedure for adding oil to the transfer case is as follows:
 - A. Add oil to the transfer case through the shift cover opening until the oil begins to run out of the shifter opening.
 - B. Install the shift cover on the P.T.O. Torque the shift covers four capscrews to 16-20 lb. ft. (2.2-2.8 kg. meters).
 - C. Pump the remaining oil into the P.T.O. through the 1/8-27 N.P.T. breather hole in the shifter cover.
 - D. To check for proper oil level between the P.T.O. and the transfer case remove the top capscrew from the output shaft bearing cover. The oil level should be at this hole. Reinstall the capscrew and torque to the same specifications as the shift cover.
5. Reinstall the barbed fitting and breather hose from the transfer case into the P.T.O. shift cover.

Enclosed is a sketch of the P.T.O. and transfer case indicating the position of the breather assembly on the transfer case and its new location on the Chelsea Power Take-Off.



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Power Take-Offs

