



P.T.O. CONVERSION AND CAPSCREWS

PTO-TEC-98

TECHNICAL

DATE: September 30, 1999

TO: All Chelsea® Power Take-Off Customers

Chelsea Power Take-Offs have a flexible design and are frequently converted to meet the requirements of the customers for different shifters, output flanges and assembly arrangements. The locking patch on the capscrews and hex head bolts seals and secures the fastener on the original installation. This locking mechanism has been proven to be effective for our assembly requirements.

However, if the assembly bolts are taken out of the P.T.O. in order to re-configure the P.T.O. in another speed, output or assembly arrangement, Chelsea requires the rebuilder to use a drop of Loctite 290 on each capscrew and hex head bolt. This will provide a secure installation when the bolts or capscrews are properly torqued. Capscrews that are furnished with a conversion kit and are being installed for the first time do not require the drop of Loctite. On the reverse side of this bulletin is a chart showing the torque specifications for the bearing cap, shift cover capscrews and hex head bolts.

Jeff King
Brand Development Manager
Chelsea Auxiliary Power Products

PTO INFO



Thread	Torque Specification	P.T.O. Series
.312-18	16-20 Ft. Lb. 22-27 Newton Meters 2.2-2.8 Kg. Meters	100, 221, 230, 231, 260, 266, 270, 271, 277, 290, 340, 352, 429, 434, 435, 436, 437, 438, 440/442, 446/447, 488/489, 452 700, 712, 721, 732, 741, 2230, 2240/2242, 800 and 812
.375-16	30-37 Ft. Lb. 41-50 Newton Meters 4.1-5.1 Kg. Meters	520 Series Bearing Covers
.312-18	16-20 Ft. Lb. 22-27 Newton Meters 2.2-2.8 Kg. Meters	520 Series Shift Covers
.375-16	30-37 Ft. Lb. 41-50 Newton Meters 4.1-5.1 Kg. Meters	540 and 541 Series Bearing Covers
.312-18	16-20 Ft. Lb. 22-27 Newton Meters 2.2-2.8 Kg. Meters	540 and 541 Series Shift Covers
.500-13	80-100 Ft. Lb. 108-136 Newton Meters 11.1-13.8 Kg. Meters	852 and 863 Series Bearing Covers
.375-16	30-37 Ft. Lb. 41-50 Newton Meters 4.1-5.1 Kg. Meters	880, 859 & 941 Series Bearing Covers. 880 and 941 Shift Cover
.500-13	80-100 Ft. Lb. 108-136 Newton Meters 11.1-13.8 Kg. Meters	901 and 912 Series Bearing Covers
.438-14	48-59 Ft. Lb. 66-81 Newton Meters 6.6-8.2 Kg Meters	912 Series Shift Cover