

SG102 Series Pump Brackets for Allison 3000/4000

With the release of Parker Hannifin's new SG102 Dump Pump, Parker Chelsea is pleased to release direct mount support brackets for use with Allison 3000 and 4000 Series families of transmissions utilizing 280 Series Power Take-Offs (PTOs).

As noted in the safety section of Chelsea's Applications Catalog, Chelsea requires the use of pump support brackets in all applications in which a) the combined weight of the pump fittings and hose exceeds 40 pounds (18.14 kg) or b) the combined length of the PTO and pump is 18 inches (45.72 cm) or more from the PTO centerline to the end of the pump. These requirements are to ensure the Maximum Bending Moment (MBM) of the PTO+pump is not exceeded, potentially causing damage to the PTO, transmission, driven equipment and/or personnel.

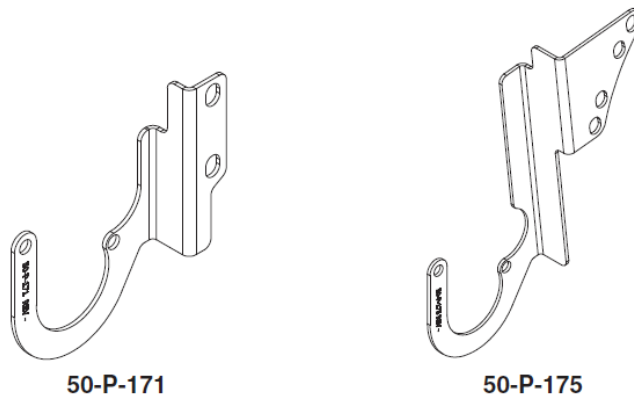


Figure 1 – SG102 Pump Support Brackets

Transmission Series	Transmission Mounting Location	Bracket Kit Part Number	Component	Description	QTY
3000 Series	Left Side	329972-1X	50-P-171	Bracket	1
			379433-5	Capscrews	2
4000 Series	Left Side and Right-Top	329972-2X	50-P-175	Bracket	1
			379433-5	Capscrews	2

-CONT-

Notes for Mounting Rotatable (RK) Flange to 280 Series PTO.

- For proper pump orientation with pump support brackets, use holes shown in *Figure 2* on the output of the PTO.
- For proper pump orientation with pump support brackets, please note the angle of RK output pump flange as shown in *Figure 3*.
- Torque capscrews mounting flange to PTO to 24-28 LB-FT [32-38 Nm]

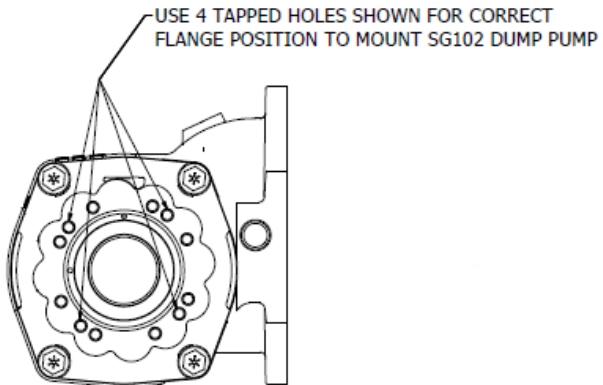


Figure 2 – 280 PTO Prior to Mounting RK Flange

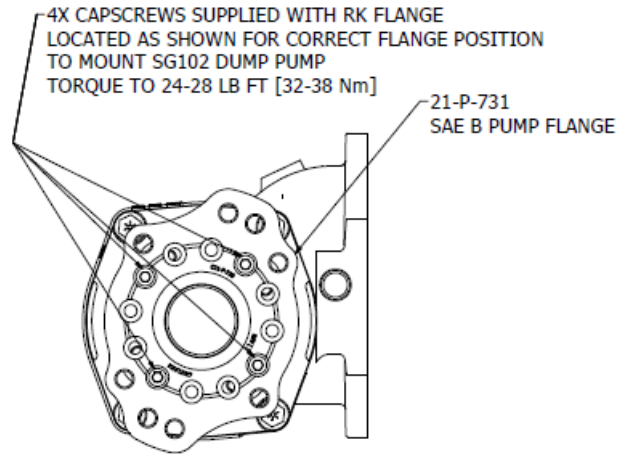


Figure 3 – 280 PTO RK Flange Installed

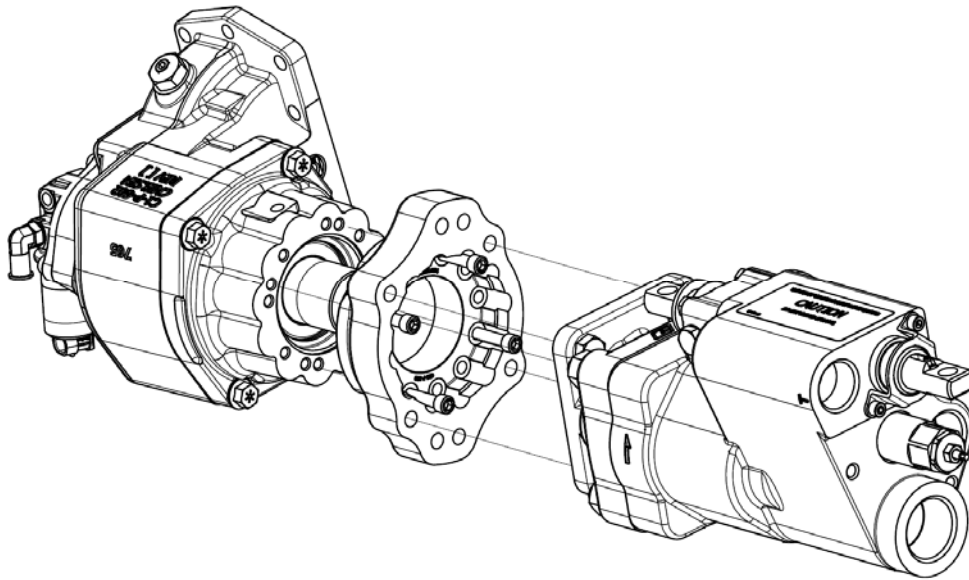


Figure 4 – 280 PTO RK Flange Installed

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Allison 3000 Series Installation

- Install 280 Series PTO and SG102 pump to the transmission in the PTO aperture. Support pump when brackets are not installed.
- Install bracket to transmission using the existing transmission bolts in approved locations as shown in *Figure 4*. Slightly tighten, but do not fully torque to allow alignment all mounting holes.
- Install bracket capscrews into back of SG102 and torque to spec of 30-35 LB-FT [47-54 Nm]
- Torque transmission bolts locations to spec 66-81 LB-FT [90-110 Nm].

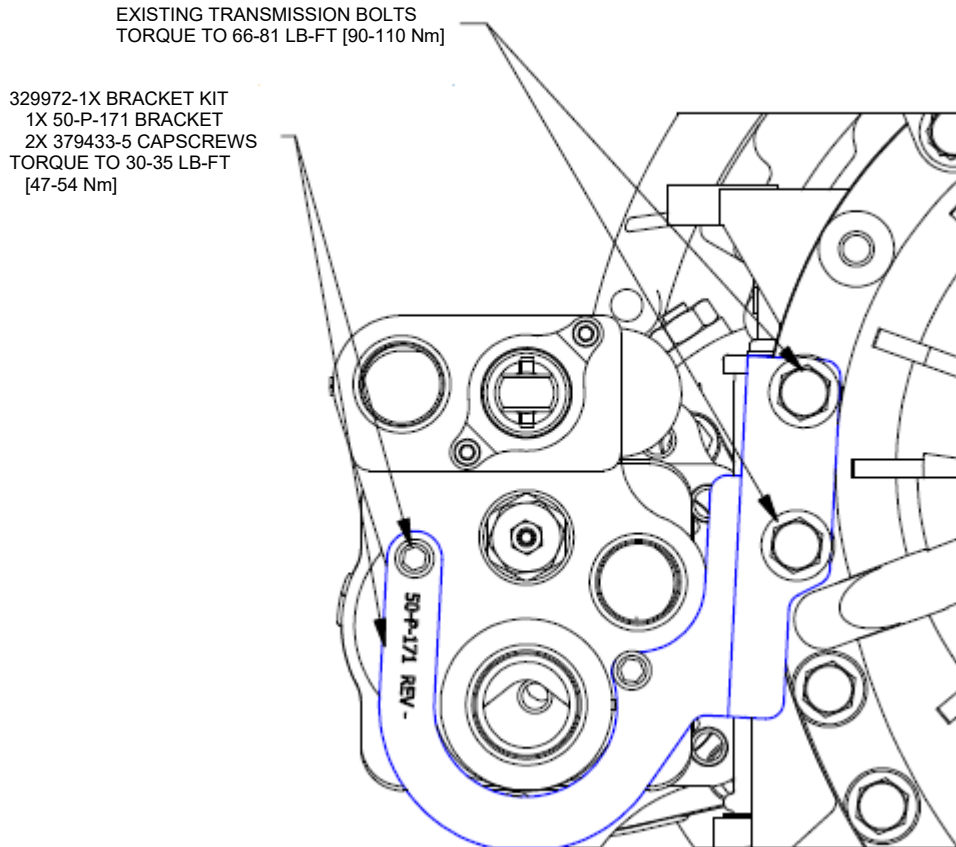


Figure 4 – Allison 3000 Family Left Side Mount Bolt Locations

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Allison 4000 Series Installation

- Install 280 Series PTO and SG102 pump to the transmission in the PTO aperture. Support pump when brackets are not installed.
- Install bracket to transmission using the existing transmission bolts in approved locations as shown in *Figure 5* and *Figure 6*. Slightly tighten, but do not fully torque to allow alignment all mounting holes.
- Install bracket capscrews into back of SG102 and torque to spec of 30-35 LB-FT [47-54 Nm]
- Torque transmission bolts locations to spec 74-89 LB-FT [100-120 Nm].

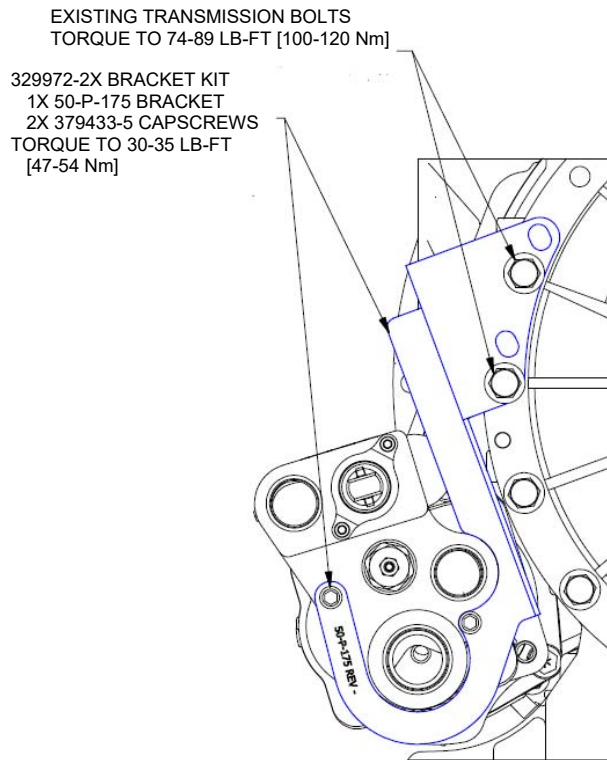


Figure 5 – Allison 4000 Left Side Bolt Locations

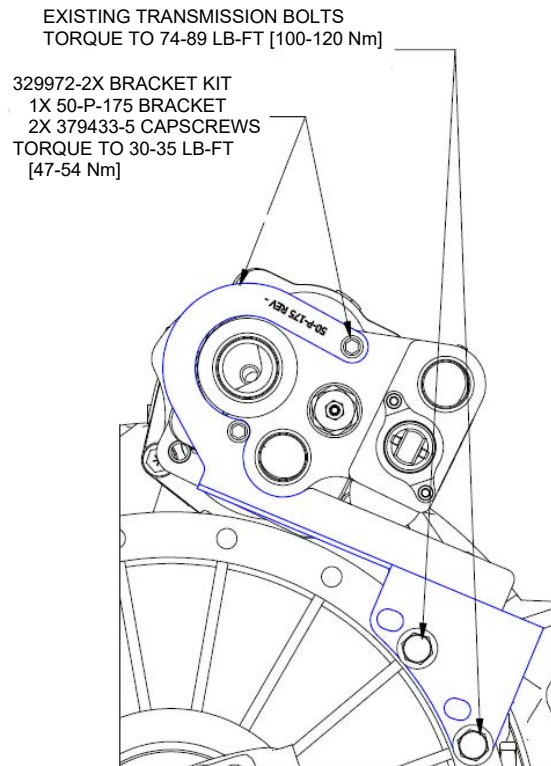


Figure 6 – Allison 4000 Right-Top Bolt Locations

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

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