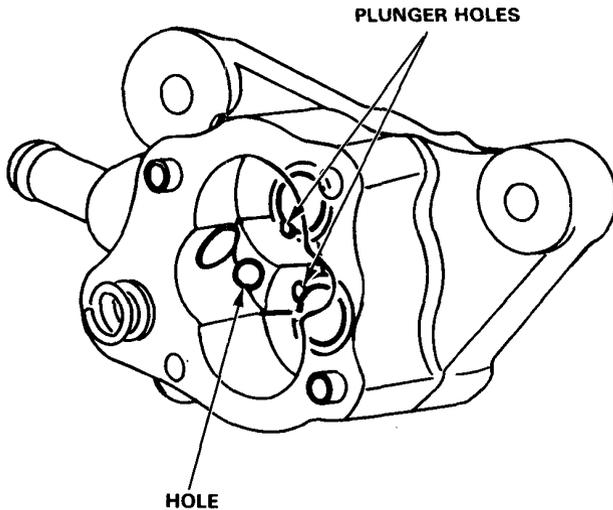


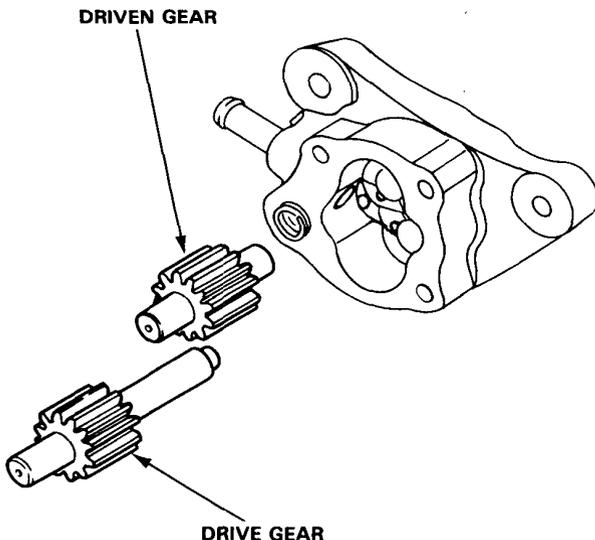
# Pump

## Housing Reassembly

1. Coat the outer surfaces of the plungers with power steering fluid, then install them in the pump housing. Make sure the plunger holes are positioned as shown.



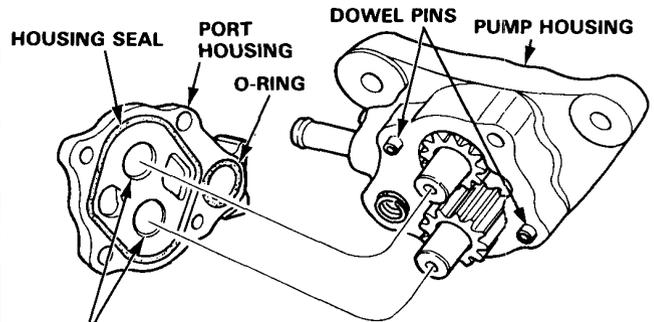
2. Coat the inside of the plungers with power steering fluid.
3. Install the pump drive and driven gears in the pump housing.



4. Coat the bushings on the port housing with power steering fluid.
5. Install the dowel pins in the pump housing, then install the new housing seal and O-ring in the port housing.

NOTE: Coat the new housing seal and O-ring with grease.

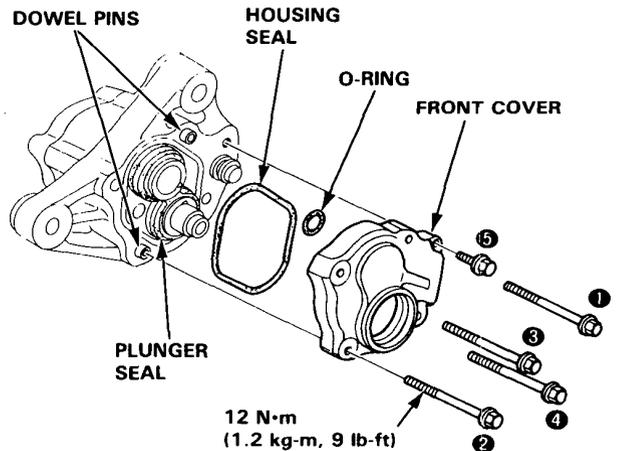
6. Install the port housing on the pump housing.



### BUSHINGS

7. Grease the new plunger seal and install it over the plungers.
8. Install the dowel pins.
9. Fill the groove of the pump housing with grease and install the new housing seal in the pump housing.
10. Grease the new O-ring and install it in the pump housing.
11. Install the pump front cover.

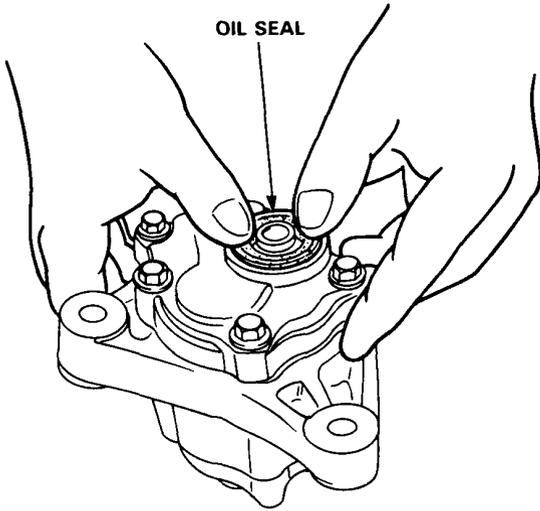
NOTE: Tighten the front cover bolts in the order shown.





12. Loosely install the new oil seal in the pump front cover.

NOTE: The oil seal spring may come out of position if the oil seal is not installed squarely.



13. Install the new oil seal in the pump front cover; get it started by hand, then use the collar driver to push it in the rest of the way.

