

## REASSEMBLY

### NOTICE:

When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page SR-25)
2. INSTALL LONGER STRAIGHT PIN

Using a plastic hammer, tap in a new longer straight pin to the front housing.

### NOTICE:

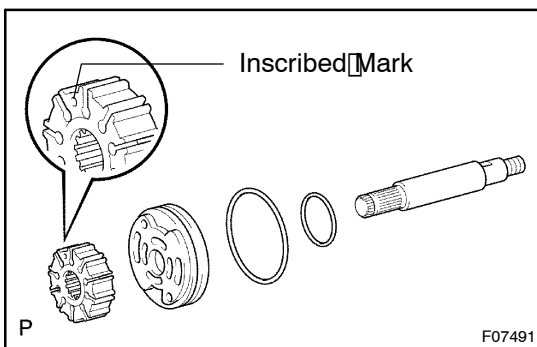
Be careful not to damage the pin.

3. INSTALL SHORTER STRAIGHT PIN

Install a new shorter straight pin to the side front plate.

### NOTICE:

Be careful not to damage the pin.



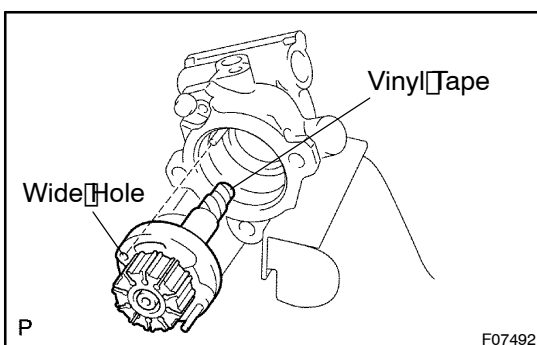
4. INSTALL SIDE FRONT PLATE AND VANE PUMP ROTOR

- (a) Coat 2 new O-rings with power steering fluid and install them to the side front plate.
- (b) Install the side front plate to the vane pump shaft.
- (c) Install the vane pump rotor to the vane pump shaft with the inscribed mark facing outward.

### NOTICE:

Make sure that the side front plate is installed facing in the correct direction.

- (d) Using snap ring pliers, install a new snap ring to the vane pump shaft.

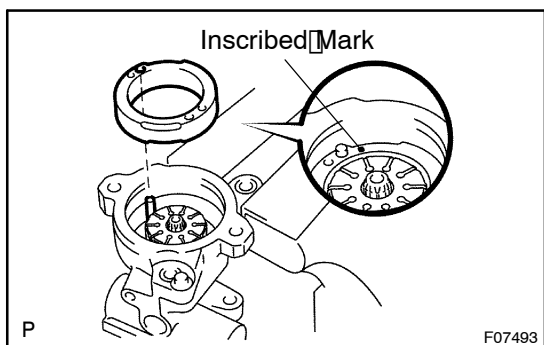


5. INSTALL VANE PUMP SHAFT WITH VANE PUMP ROTOR AND SIDE FRONT PLATE

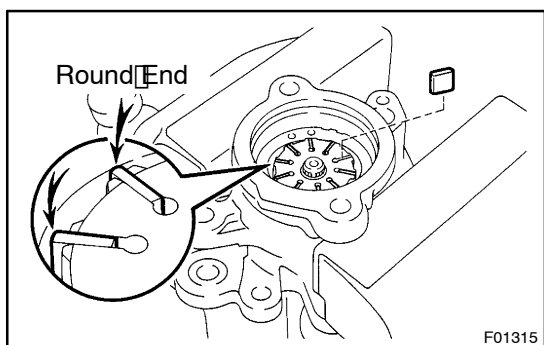
- (a) Wind vinyl tape to the control valve shaft.
- (b) Align the wide hole of the side front plate and longer straight pin, and tap in the vane pump shaft with a plastic hammer.

### NOTICE:

Be careful not to damage the oil seal and O-rings.

**6. INSTALL CAM RING**

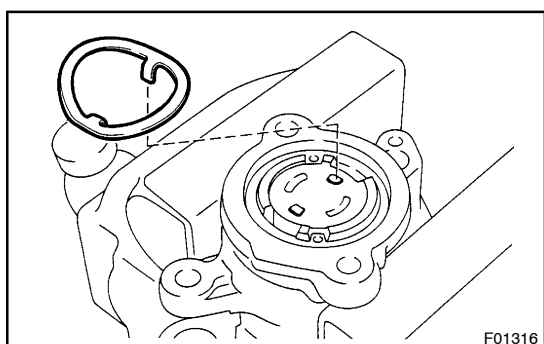
Align the holes of the cam ring and 2 straight pins and install the cam ring with the inscribed mark facing outward.

**7. INSTALL 10 VANE PLATES**

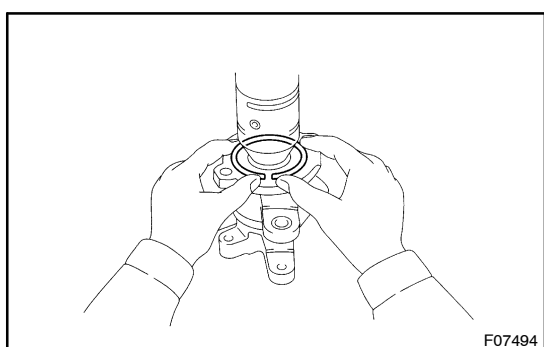
Install the 10 vane plates with the round end facing outward.

**8. INSTALL SIDE REAR PLATE**

- Coat a new O-ring with power steering fluid and install it to the plate.
- Align the holes of the plate and 2 straight pins, and install the side rear plate.

**9. INSTALL WAVE WASHER**

Install the wave washer so that its protrusions fit into the slots in the side rear plate.

**10. INSTALL REAR HOUSING**

- Coat a new O-ring with power steering fluid and install it to the rear housing.
- Apply just enough pressure to compress the wave washer, and install a new snap ring to the front housing.

**11. INSTALL SPRING, FLOW CONTROL VALVE AND PRESSURE PORT UNION**

- Install the spring.
- Install the flow control valve facing in the correct direction (See page SR-25).

- Coat a new O-ring with power steering fluid and install it to the pressure port union.

- Install the pressure port union.

**Torque: 69 N·m (700 kgf·cm, 51 ft·lbf)**

**12. INSTALL SUCTION PORT UNION**

- Coat a new O-ring with power steering fluid and install it to the suction port union.

- Install the suction port union with the bolt.

**Torque: 13 N·m (130 kgf·cm, 9 ft·lbf)**

**13. INSTALL FRONT BRACKET**

Install the front bracket with the 2 bolt.

**Torque:**

**Upper side: 13 N·m (130 kgf·cm, 9 ft·lbf)**

**Lower side: 41 N·m (420 kgf·cm, 30 ft·lbf)**

**14. INSTALL VANE PUMP PULLEY**

(a) Install the woodruff key to the vane pump shaft.

(b) Install the vane pump pulley and nut to the vane pump shaft.

(c) Using SST, stop the pulley rotating and torque the nut.  
SST 09960-10010 (09962-01000, 09963-01000)

**Torque: 44 N·m (450 kgf·cm, 33 ft·lbf)**

**15. MEASURE PS VANE PUMP ROTATING TORQUE**

**(See page SR-28)**

