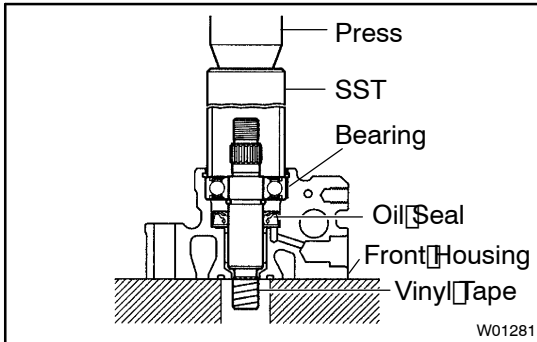


## REASSEMBLY

### NOTICE:

When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page SR-12)



2. INSTALL VANE PUMP SHAFT WITH BEARING

- (a) To prevent oil seal lip damage, wind vinyl tape on the serrated part of the vane pump shaft.
- (b) Using SST and a press, press in the vane pump shaft with the bearing.

SST 09608-04031

### NOTICE:

Be careful not to damage the oil seal.

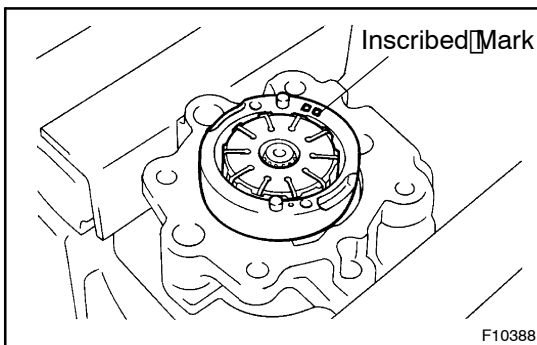
- (c) Using snapping pliers, install a new snapping to the front housing.

3. INSTALL 2 STRAIGHT PINS

Using a plastic hammer, tap in 2 new straight pins to the front housing.

### NOTICE:

Be careful not to damage the straight pins.



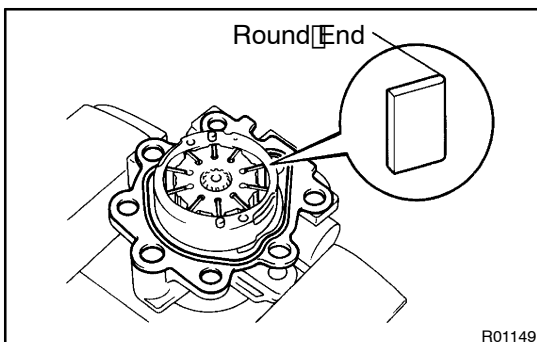
4. INSTALL CAM RING

Install the cam ring with the inscribed mark facing outward.

### HINT:

Align the holes of the cam ring with the 2 straight pins.

5. INSTALL VANE PUMP ROTOR



6. INSTALL 10 VANE PLATES AND GASKET

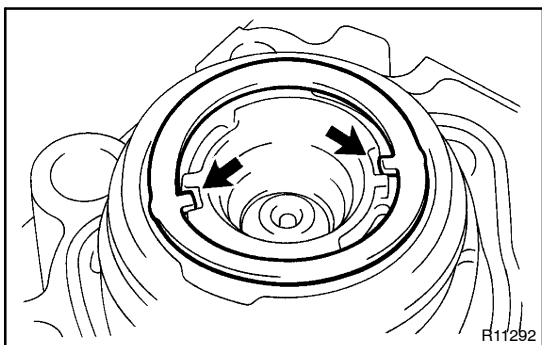
- (a) Install the 10 vane plates with the round end facing outward.
- (b) Install a new gasket on the front housing.

### NOTICE:

Be careful the direction of the gasket.

7. INSTALL SIDE PLATE

Align the holes of the side plate and 2 straight pins.

**8. INSTALL WAVE WASHER**

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

**9. INSTALL REAR HOUSING**

(a) Coat the new O-rings with power steering fluid and install them to the rear housing.

(b) Install the rear housing with the 2 bolts.

**Torque: 24 N·m (240 kgf·cm, 17 ft·lbf)**

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

(a) Install the spring.

(b) Install the flow control valve facing in the correct direction (See page SR-12).

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

(d) Install the pressure port union.

**Torque: 83 N·m (850 kgf·cm, 61 ft·lbf)**

**11. INSTALL OIL RESERVOIR**

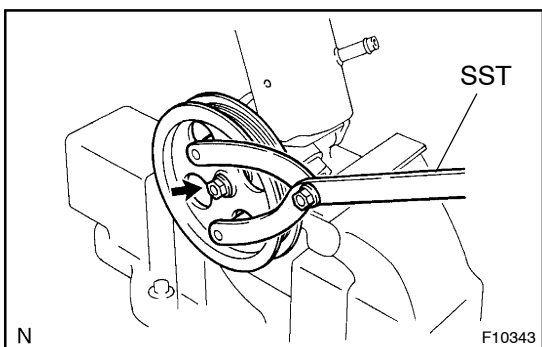
(a) Coat a new O-ring with power steering fluid and install it to the oil reservoir.

(b) Install the oil reservoir with the 3 bolts.

**Torque:**

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

**Rear side bolts: 24 N·m (240 kgf·cm, 17 ft·lbf)**

**12. INSTALL VANE PUMP PULLEY**

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

(b) Using SST, stop the pulley rotating and torque the pulley set nut.

SST 09960-10010 (09962-01000, 09963-01000)

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

**13. MEASURE PS VANE PUMP ROTATING TORQUE (See page SR-15)**