

## REASSEMBLY

### 1. INSPECT PRESSURE PORT UNION

If the union seat in the pressure port union is severely damaged, it may cause fluid leakage. In that case, replace the vane pump assembly.

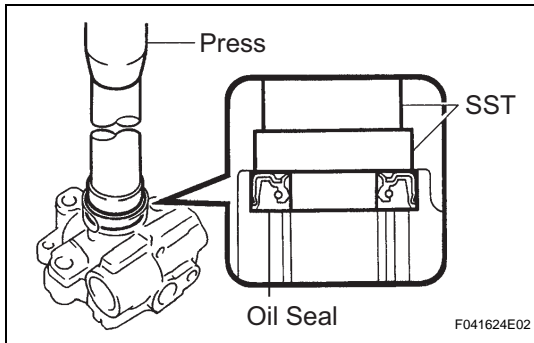
### 2. INSTALL VANE PUMP HOUSING OIL SEAL

- Coat a new vane pump housing oil seal lip with power steering fluid.
- Using SST and a press, install the vane pump housing oil seal.

**SST 09950-60010 (09951-00330), 09950-70010 (09951-07100)**

**NOTICE:**

**Make sure that the housing oil seal is installed in the correct direction.**



### 3. INSTALL PUMP BRACKET FRONT

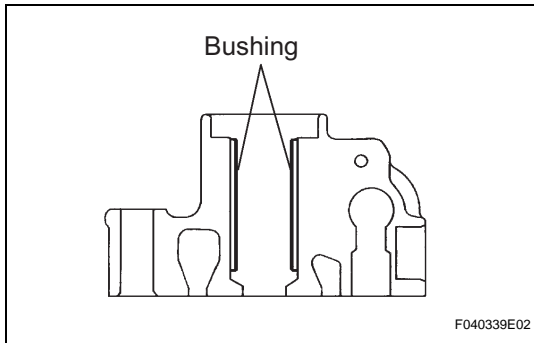
- Install the pump bracket front with the bolt.  
**Torque: 43 N\*m (438 kgf\*cm, 32 ft.\*lbf)**

### 4. INSTALL VANE PUMP SHAFT

- Coat the busing surface of the vane pump housing front with power steering fluid.
- Gradually insert the vane pump shaft from the pulley side.

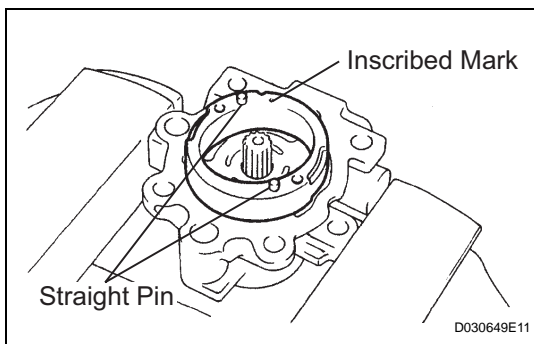
**NOTICE:**

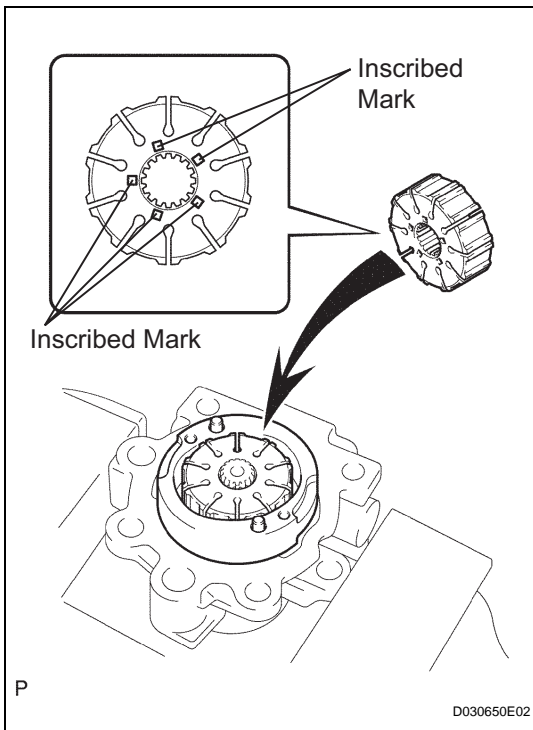
- Do not damage the vane pump housing oil seal lip in the vane pump housing front.
- After installation, check the vane pump housing oil seal lip.



### 5. INSTALL VANE PUMP CAM RING

- Align the holes of the vane pump cam ring with the 2 straight pins, and install the vane pump cam ring with the inscribed mark facing upward.



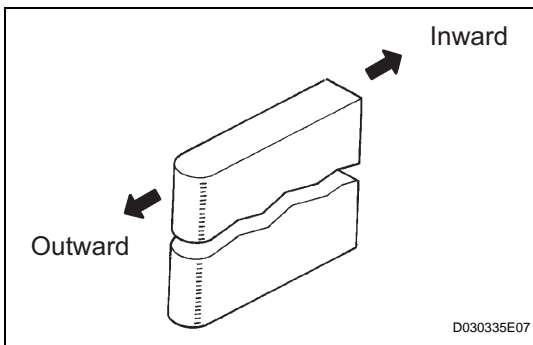


## 6. INSTALL VANE PUMP ROTOR

- (a) Install the vane pump rotor with the inscribed mark facing downward.

**NOTICE:**

**Make sure that the vane pump rotor is installed in the correct direction.**

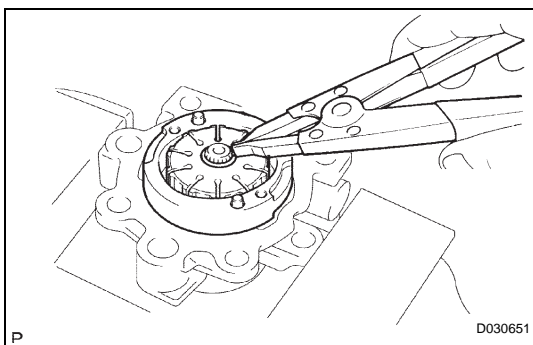


- (b) Coat all 10 vane pump plates with power steering fluid.

- (c) Install the vane pump plates with the round end facing outward.

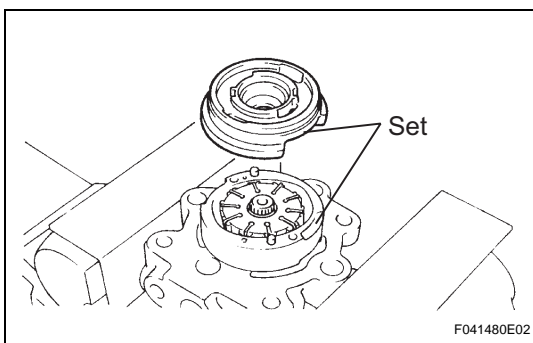
**NOTICE:**

**Make sure that the vane pump plates are installed in the correct direction.**



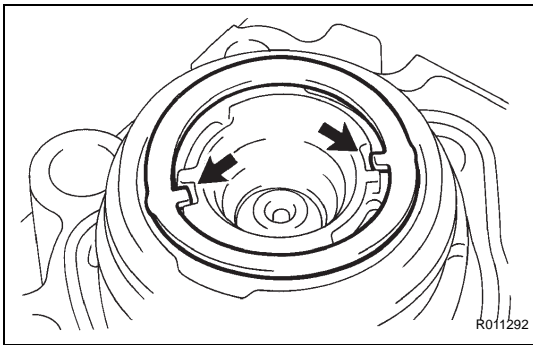
## 7. INSTALL VANE PUMP SHAFT SNAP RING

- (a) Using a snap ring expander, install a new vane pump shaft snap ring onto the vane pump shaft.



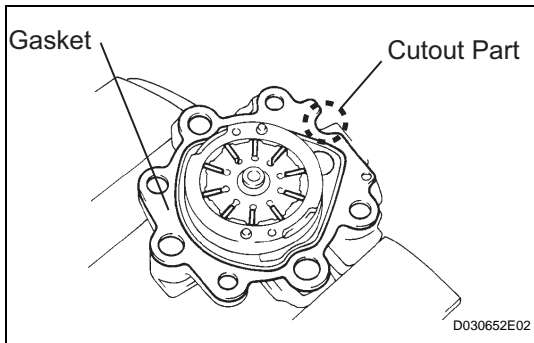
## 8. INSTALL VANE PUMP SIDE PLATE REAR

- (a) Align the groove of the vane pump cam ring with that of the vane pump side plate rear to install.



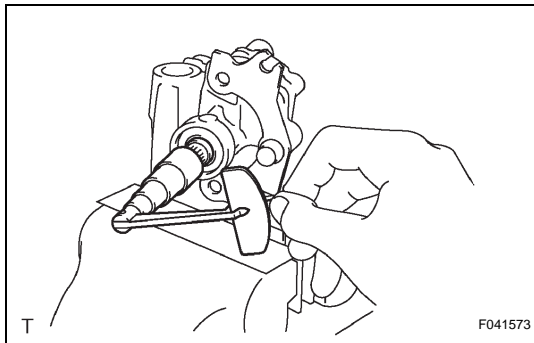
- (b) Install the wave washer so that its protrusions fit into the slots in the vane pump side plate rear.
- (c) Coat 2 new O-rings with power steering fluid and install them onto the vane pump side plate rear.

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#### 9. INSTALL VANE PUMP HOUSING REAR

- (a) Install a new gasket to the vane pump housing front.  
**NOTICE:**  
**Make sure that the gasket is installed with the cutout in the correct position.**
- (b) Install the vane pump housing rear with the 4 bolts.  
**Torque: 24 N\*m (245 kgf\*cm, 18 ft.\*lbf)**



#### 10. MEASURE VANE PUMP ROTATION TORQUE

- (a) Check that the vane pump rotates smoothly without abnormal noise.
- (b) Temporarily install the nut to the vane pump shaft.
- (c) Using a torque wrench, check the vane pump rotating torque.  
**Torque: Rotating torque**  
**0.27 N\*m (2.8 kgf\*cm, 2.4 in.\*lbf) or less**

#### 11. INSTALL VANE PUMP BRACKET REAR

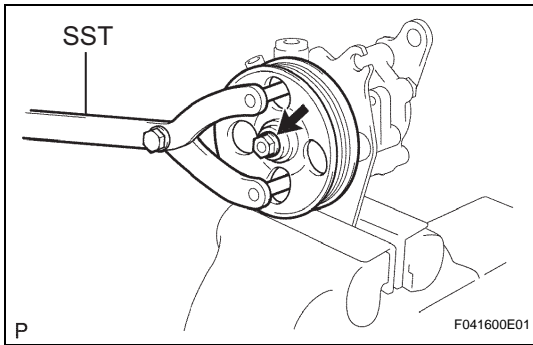
- (a) Install the vane pump bracket rear with the 2 bolts.  
**Torque: 43 N\*m (438 kgf\*cm, 32 ft.\*lbf)**

#### 12. INSTALL FLOW CONTROL VALVE

- (a) Coat the compression spring with power steering fluid and install it to the vane pump housing front.
- (b) Coat the flow control valve with power steering fluid.
- (c) Install the flow control valve to the vane pump housing front.  
**NOTICE:**  
**Make sure that the flow control valve is installed correctly.**
- (d) Coat a new O-ring with power steering fluid and install it to the pressure port union.
- (e) Install the pressure port union to the vane pump housing front.  
**Torque: 83 N\*m (846 kgf\*cm, 61 ft.\*lbf)**

#### 13. INSTALL POWER STEERING SUCTION PORT UNION

- (a) Coat a new O-ring with power steering fluid and install it to the suction port union.
- (b) Install the suction port union with the bolt to the vane pump housing front.  
**Torque: 13 N\*m (133 kgf\*cm, 10 ft.\*lbf)**

**14. INSTALL VANE PUMP PULLEY**

- (a) Install the vane pump pulley to the vane pump shaft.
- (b) Using SST, keep the vane pump pulley from rotating and install the nut.

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

**Torque: 44 N\*m (449 kgf\*cm, 32 ft.\*lbf)**