

REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT WITH POWER STEERING FLUID
(See page SR-48)

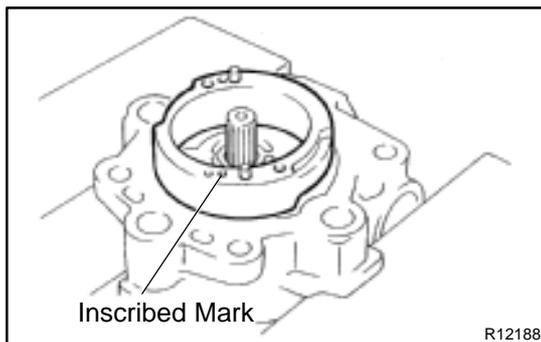
2. INSTALL STRAIGHT PINS

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

NOTICE:

Be careful not to damage the pins.

3. INSTALL VANE PUMP SHAFT

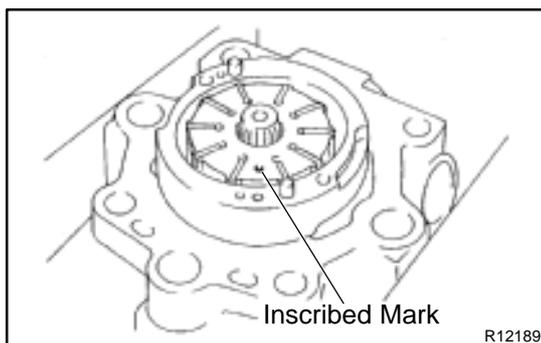


4. INSTALL CAM RING

Install the ring with the inscribed mark facing outward.

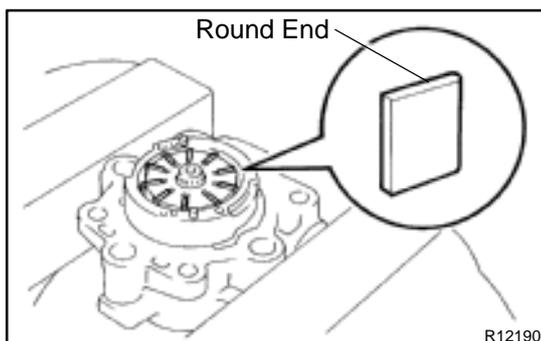
HINT:

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



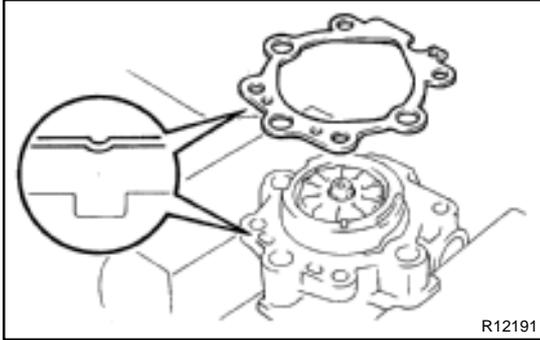
5. INSTALL VANE PUMP ROTOR

- (a) Install the rotor with the inscribed mark facing outward.
- (b) Install a new snap ring to the vane pump shaft.



6. INSTALL VANE PLATES

Install the 10 plates with the round end facing outward.

**7. INSTALL GASKET**

Install a new gasket on the front housing.

NOTICE:

Be careful the direction of the gasket.

8. INSTALL SIDE PLATE

Align the holes of the plate and 2 straight pins.

**9. INSTALL WAVE WASHER**

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

10. INSTALL REAR HOUSING

(a) Coat 2 new O-rings with power steering fluid and install them to the housing.

(b) Torque the 2 bolts.

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

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

(a) Install the valve facing the correct direction.

(See page [SR-48](#))

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

(c) Torque the union.

Torque: 83 N-m (850 kgf-cm, 62 ft-lbf)

12. INSTALL BRACKET

Torque the 2 bolts.

Torque: 43 N-m (440 kgf-cm, 32 ft-lbf)

13. INSTALL OIL RESERVOIR

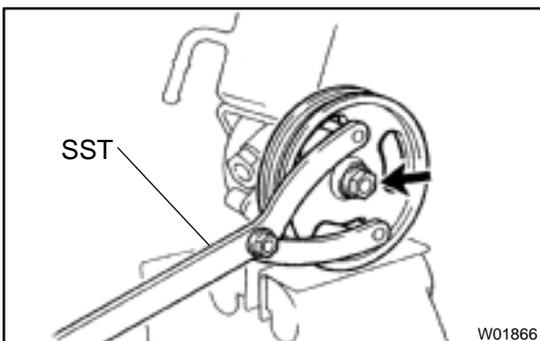
(a) Coat a new O-ring with power steering fluid and install it to the oil reservoir.

(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)

**14. INSTALL VANE PUMP PULLEY**

Using SST to stop the pulley rotating, torque the nut.

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

Torque: 43 N-m (440 kgf-cm, 32 ft-lbf)

15. MEASURE PS VANE PUMP ROTATING TORQUE

(See page [SR-50](#))