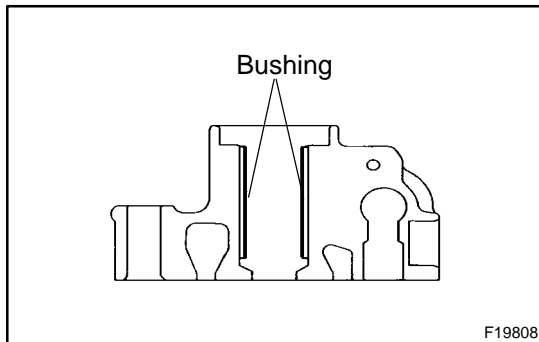


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page [SR-45](#))

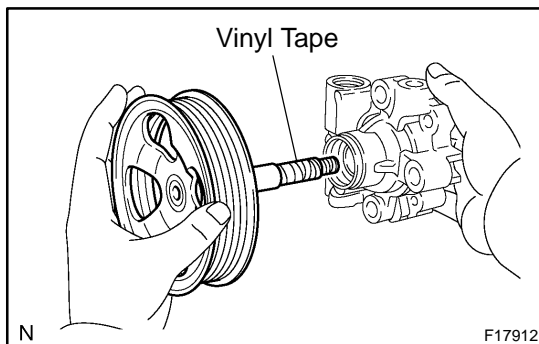


2. INSTALL VANE PUMP SHAFT WITH VANE PUMP PULLEY

- (a) Coat the inside surface of the bushing in the front housing with power steering fluid.
- (b) Gradually insert the vane pump shaft.

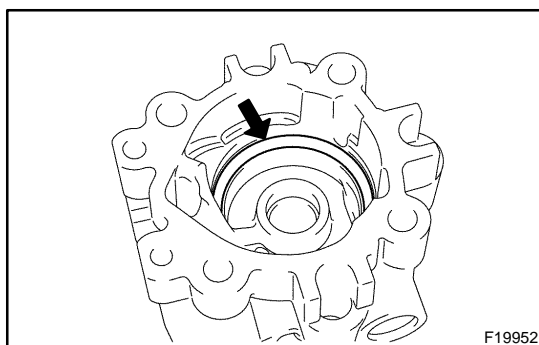
NOTICE:

Do not damage the oil seal lip in the front housing.



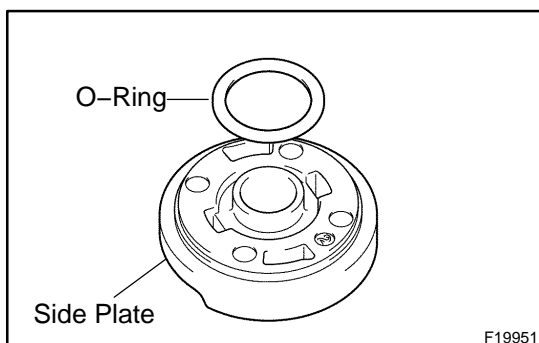
HINT:

Wrap the shaft surface with vinyl tape before inserting.

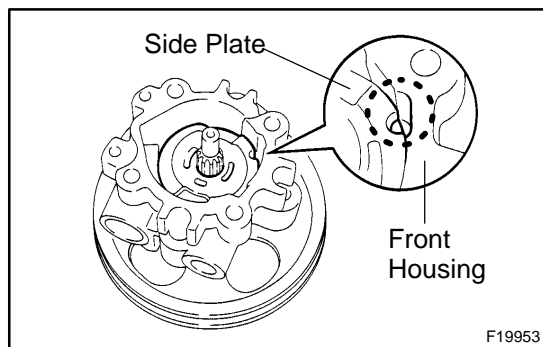


3. INSTALL SIDE PLATE

- (a) Coat a new O-ring with power steering fluid, and install it to the front housing.



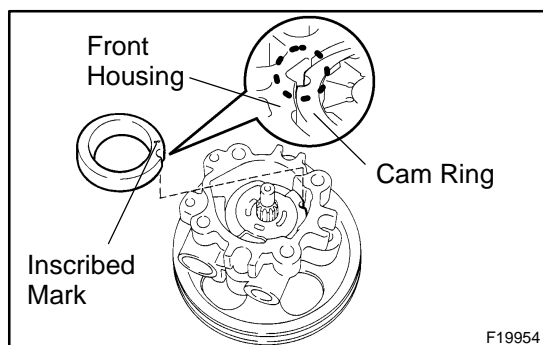
- (b) Coat a new O-ring with power steering fluid, and install it to the side plate.



- (c) Align the dent of the side plate with the dent of the front housing, and install the side plate.

NOTICE:

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

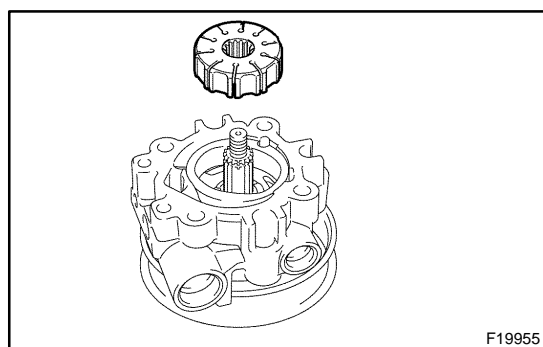


4. INSTALL CAM RING

Align the dent of the cam ring with the dent of the side plate, and install the cam ring with the inscribed mark facing outward.

NOTICE:

Make sure that the cam ring is installed in the correct direction.

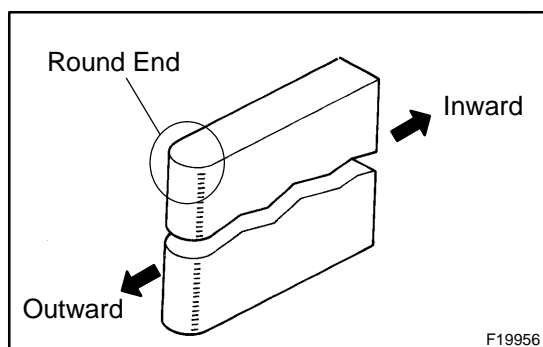


5. INSTALL VANE PUMP ROTOR

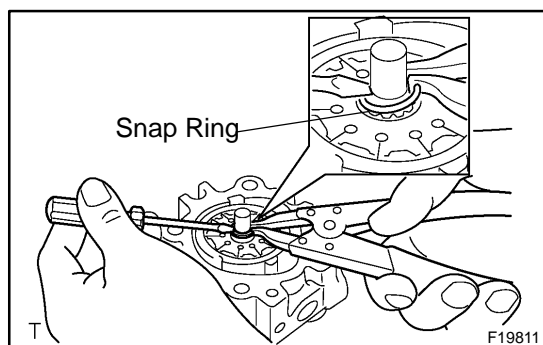
- (a) Install the vane pump rotor.

HINT:

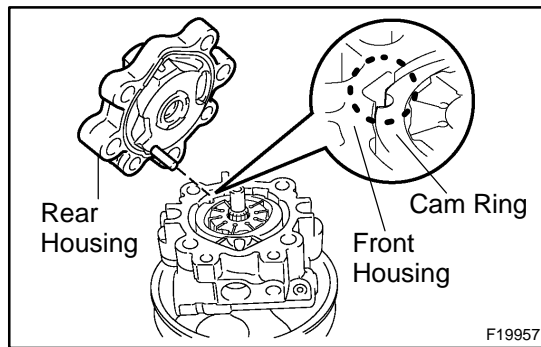
Vane pump rotor has no specific direction.



- (b) Coat 10 vane plates with power steering fluid.
- (c) Install the 10 vane plates with the round end facing outward.



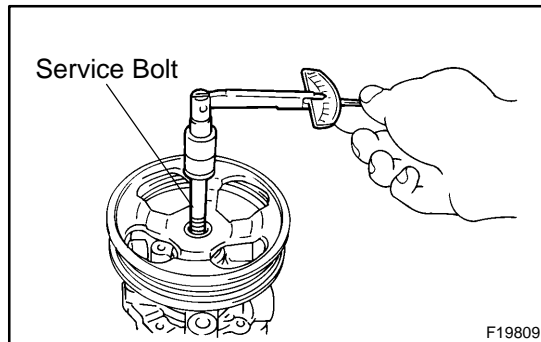
- (d) Using a screwdriver and a snap ring expander, install a new snap ring to the vane pump shaft.



6. INSTALL REAR HOUSING

- Coat a new O-ring with power steering fluid, and install it to the rear housing.
- Align the straight pin of the rear housing with the dents of the cam ring, side plate and front housing, and install the rear housing with the 4 bolts.

Torque: 22 N·m (220 kgf-cm, 16 ft-lbf)



7. INSPECT PRELOAD

- Check that the pump rotates smoothly without abnormal noise.

- Temporarily install the service bolt.

Recommended service bolt:

Thread diameter: 10 mm (0.39 in.)

Thread pitch: 1.25 mm (0.0492 in.)

Bolt length: 50 mm (1.97 in.)

- Using a torque wrench, check the pump rotating torque.

Rotating torque:

0.27 N·m (2.8 kgf-cm, 2.4 in.-lbf) or less

If the rotating torque is not as specified above, check the installation of the vane pump housing oil seal.

8. INSTALL OIL PRESSURE SWITCH

Torque: 21 N·m (210 kgf-cm, 15 ft-lbf)

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

- Coat the spring and flow control valve with power steering fluid.
- Install the spring.
- Install the flow control valve in the correct direction (See page [SR-45](#)).
- 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)

10. 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: 12 N·m (120 kgf-cm, 9 ft-lbf)