

REASSEMBLY

NOTICE:

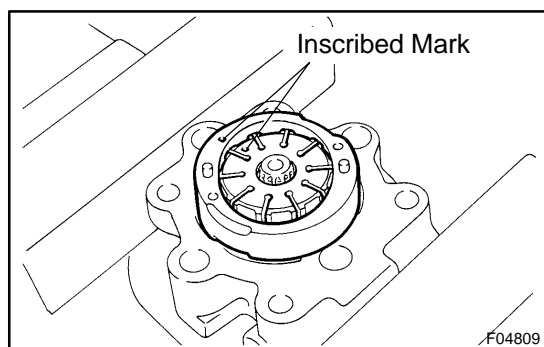
When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page [SR-59](#))
2. INSTALL VANE PUMP SHAFT WITH VANE PUMP PULLEY
3. INSTALL STRAIGHT PINS

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

NOTICE:

Be careful not to damage the pins.



4. INSTALL CAM RING

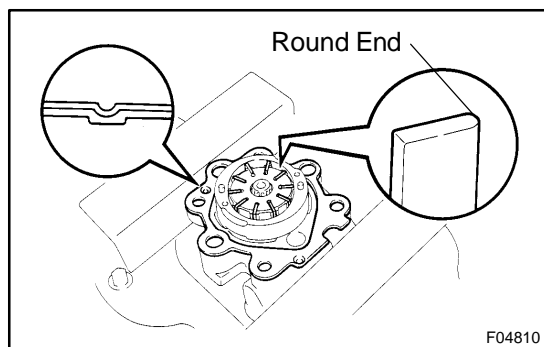
Install the cam ring with the inscribed mark facing outward.

HINT:

Align the hole of the cam ring with the one of the straight pins.

5. INSTALL VANE PUMP ROTOR

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



6. INSTALL VANE PLATES AND GASKET

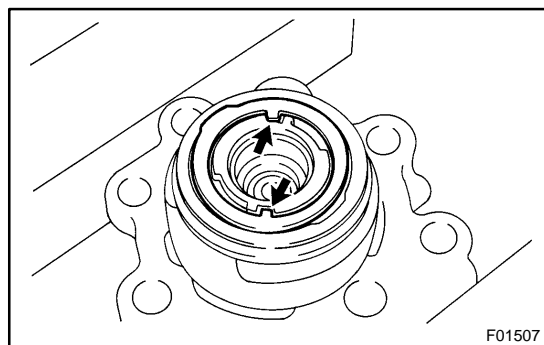
- (a) Install the 10 plates with the round end facing outward.
- (b) Install a new gasket on the front housing.

NOTICE:

Be careful of the direction of the gasket.

7. INSTALL SIDE PLATE

Align the hole of the plate with the hole of the 2 straight pins.



8. INSTALL WAVE WASHER

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

9. INSTALL REAR HOUSING

- (a) Coat 2 new O-rings with power steering fluid and install them to the rear housing.
- (b) Install the rear housing with the 4 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 on the front housing.
- (b) Install the flow control valve in the correct direction
(See page [SR-59](#)).
- (c) Coat a new O-ring with power steering fluid and install it on the pressure port union.
- (d) Install the pressure port union.

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

11. INSTALL SUCTION PORT UNION

- (a) Coat a new O-ring with power steering fluid and install it on the suction port union.
- (b) Install the suction port union with the bolt.

Torque: 13 N·m (130 kgf-cm, 9 ft-lbf)

12. MEASURE PS VANE PUMP ROTATING TORQUE

(See page [SR-62](#))