

REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT WITH POWER STEERING FLUID
(See page [SR-24](#))

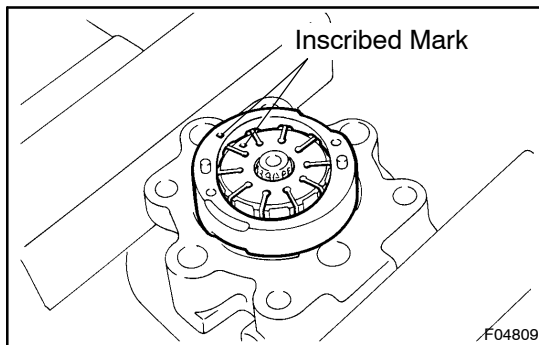
2. INSTALL VANE PUMP SHAFT

3. INSTALL STRAIGHT PINS

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

NOTICE:

Be careful not to damage the pins.



4. INSTALL CAM RING

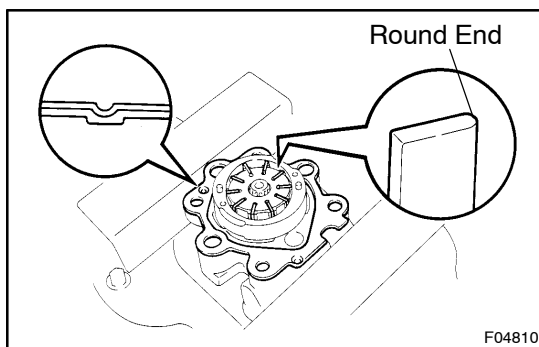
Install the ring with the inscribed mark facing outward.

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 AND GASKET

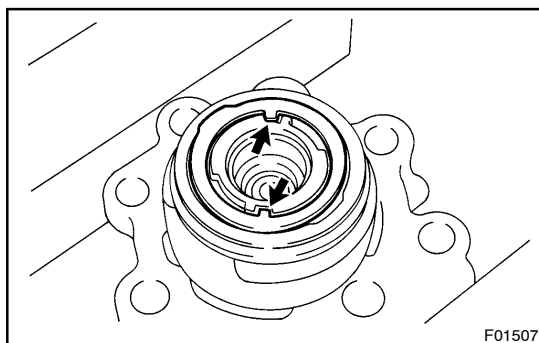
- (a) Install the 10 plates with the round end facing outward.
- (b) Install a new gasket on the front housing.

NOTICE:

Be careful the direction of the gasket.

7. INSTALL SIDE PLATE

Align the holes of the plate and 2 straight pins.



8. INSTALL WAVE WASHER

Install the washer so that its 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 housing.
- (b) Torque the 4 bolts.

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

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

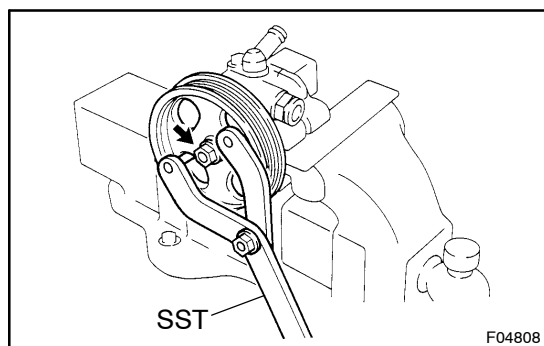
- (a) Install the valve facing the correct direction (See page [SR-24](#)).
- (b) Coat a new O-ring with power steering fluid and install it to the union.
- (c) Torque the union.

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

11. INSTALL SUCTION PORT UNION

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

Torque: 13 N·m (130 kgf·cm, 9 ft·lbf)

**12. 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)

13. MEASURE PS VANE PUMP ROTATING TORQUE
(See page [SR-27](#))