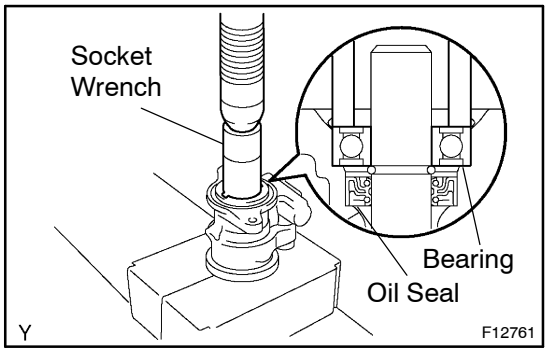
SR1CX–03

REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page SR–5)



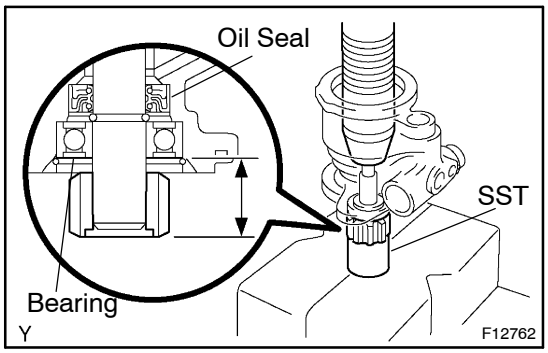
2. INSTALL VANE PUMP SHAFT WITH BEARING TO FRONT HOUSING

(a) Using a socket wrench (29mm) and a press, install the vane pump shaft with the bearing to the front housing.

NOTICE:

Be careful not to damage the oil seal lip.

(b) Using a snap ring expander, install a new snap ring to the vane pump shaft.



3. INSTALL VANE PUMP DRIVE GEAR

Using SST and a press, install the vane pump drive gear.

SST 09631–12031

Standard length:

25.1 – 26.2 mm (0.99 – 1.03 in.)

4. INSTALL LONGER STRAIGHT PIN

Install a new longer straight pin to the front housing.

NOTICE:

Be careful not to damage the pin.

5. INSTALL SIDE FRONT PLATE

(a) Coat 2 new O–rings with power steering fluid and install them to the side front plate.

(b) Align the hole of the side front plate and longer straight pin.

NOTICE:

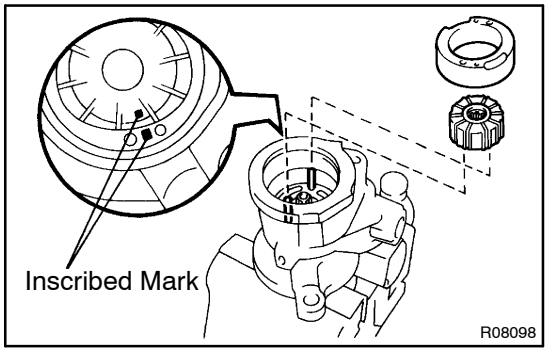
Make sure to install the side front plate facing the correct direction (See page SR–5).

6. INSTALL SHORTER STRAIGHT PIN

Install a new shorter straight pin to the side front plate.

NOTICE:

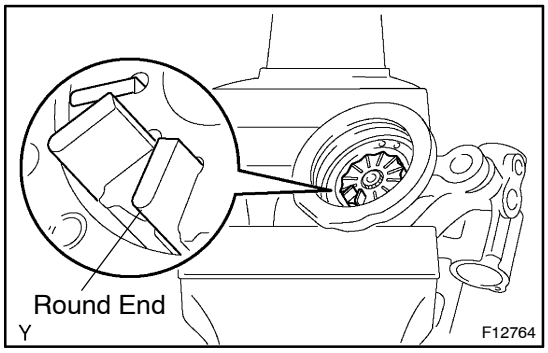
Be careful not to damage the pin.



7. INSTALL CAM RING AND VANE PUMP ROTOR

(a) Align the holes of the cam ring and straight pins, and install the cam ring with the inscribed mark facing outward.

(b) Install the vane pump rotor with the inscribed mark facing outward.



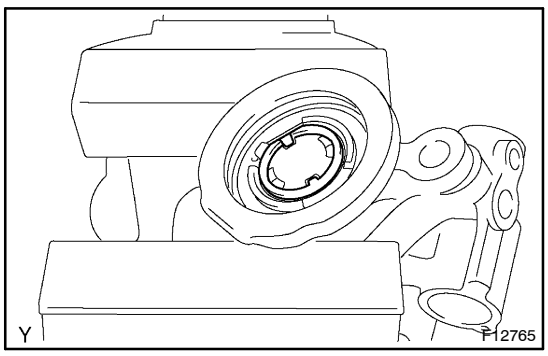
8. INSTALL VANE PLATES

Install the 10 plates with the round end facing outward.

9. INSTALL SIDE REAR PLATE

(a) Coat a new O–ring with power steering fluid and install it to the side rear plate.

(b) Align the holes of the side rear plate and the straight pins.

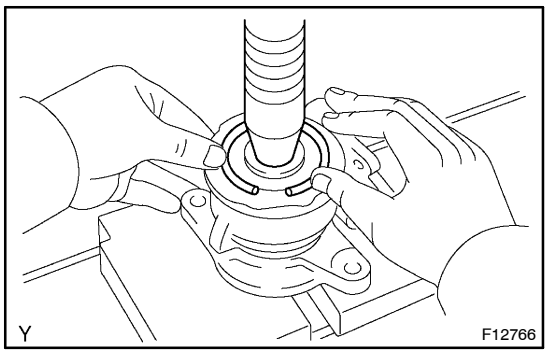


10. INSTALL WAVE WASHER

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

11. INSTALL REAR HOUSING

(a) Coat a new O–ring with power steering fluid and install it to the rear housing.



(b) Using a press, apply just enough pressure to compress the wave washer, and install a new snap ring to the front housing.

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

(a) Install the spring.

(b) Install the flow control valve facing in the correct direction (See page SR–5).

(c) Coat a new O–ring with power steering fluid and install it to the pressure port union.

(d) Install the pressure port union.

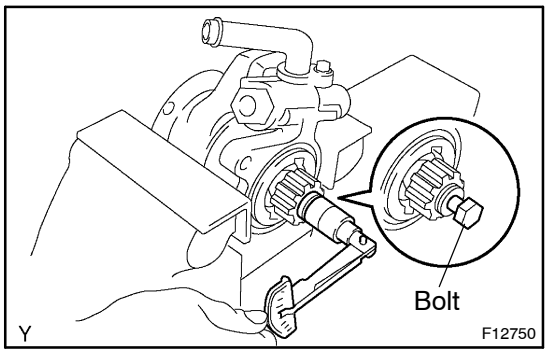
Torque: 69 N·m (700 kgf·cm, 51 ft·lbf)

13. INSTALL 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 2 bolts.

Torque: 13 N·m (130 kgf·cm, 9 ft·lbf)



14. MEASURE POWER STEERING VANE PUMP ROTATING TORQUE

(a) Check that the pump rotates smoothly without abnormal noise.

(b) Temporarily install a bolt to the vane pump shaft.

(c) Using a bolt, check the PS vane pump rotating torque.

Bolt part number: 91111–51035

Rotating torque:

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