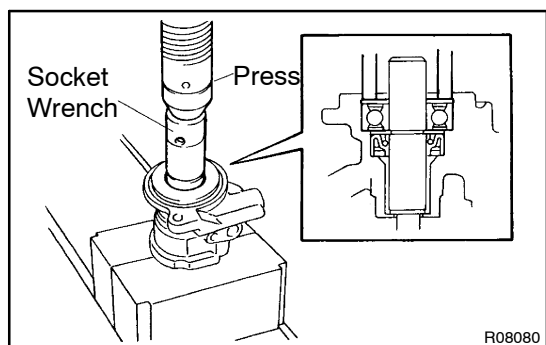


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT WITH POWER STEERING FLUID
(See page SR-38)



2. INSTALL VANE PUMP SHAFT WITH BEARING

- (a) Using a socket wrench (29 mm), press in the shaft with the bearing to the front housing.

NOTICE:

Be careful not to damage the oil seal lip.

- (b) Using snap ring pliers, install a new snap ring to the front housing.

3. INSTALL LONGER STRAIGHT PIN

Install a new pin to the front housing.

NOTICE:

Be careful not to damage the pin.

4. INSTALL SIDE FRONT PLATE

- (a) Coat 2 new O-rings with power steering fluid and install them to the plate.
- (b) Align the hole of the plate and longer straight pin.

NOTICE:

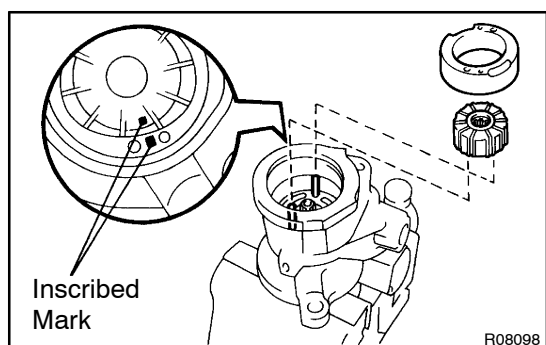
Make sure to install the plate facing the correct direction.
(See page SR-38)

5. INSTALL SHORTER STRAIGHT PIN

Install a new pin to the side front plate.

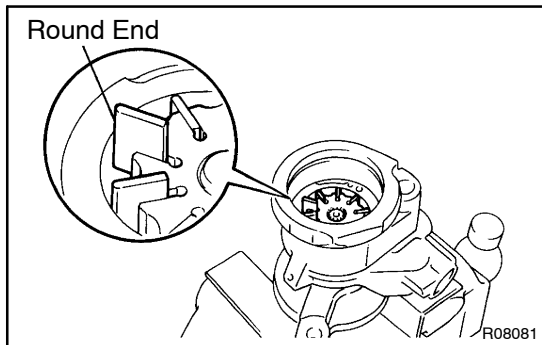
NOTICE:

Be careful not to damage the pin.



6. INSTALL CAM RING AND VANE PUMP ROTOR

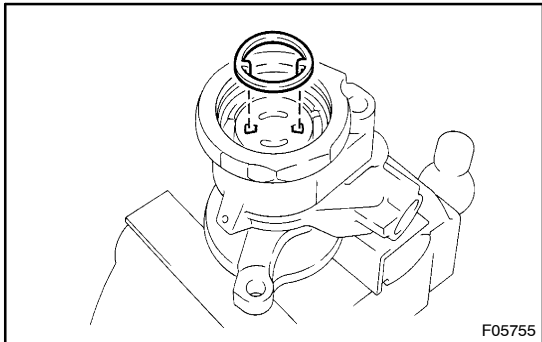
Install the ring and rotor with the inscribed marks facing outward.

**7. INSTALL 10 VANE PLATES**

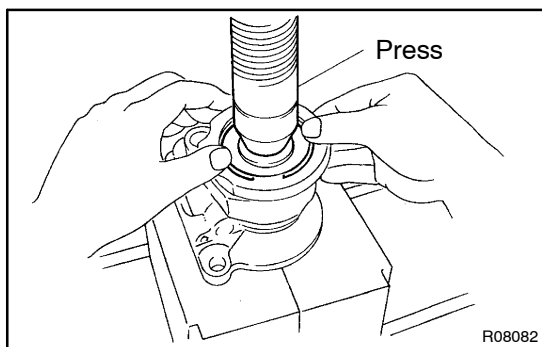
Install the plates with the round end facing outward.

8. INSTALL SIDE REAR PLATE

- Coat a new O-ring with power steering fluid and install it to the plate.
- Align the holes of the plate with the straight pins.

**9. INSTALL WAVE WASHER**

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

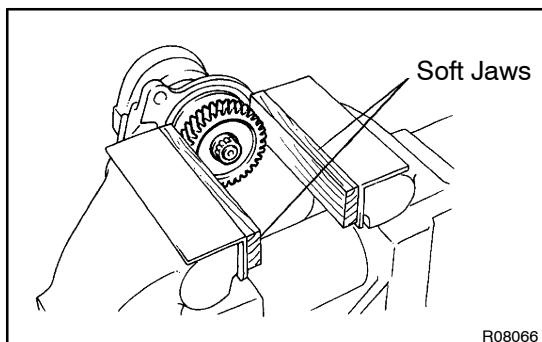
**10. INSTALL REAR HOUSING**

- Coat a new O-ring with power steering fluid and install it to the housing.
- Using a press, apply just enough pressure to compress the wave washer, and install a new snap ring to the front housing.

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

- Install the valve facing the correct direction.
(See page SR-38)
- Coat a new O-ring with power steering fluid and install it to the union.
- Torque the union.

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

**12. INSTALL VANE PUMP DRIVE GEAR**

- Install the woodruff key and gear.
- Using soft jaws on a vise, clamp the gear in the vise.

NOTICE:

Be careful not to damage the gear.

- Torque the gear set nut.

Torque: 74 N·m (750 kgf·cm, 54 ft·lbf)

13. MEASURE PS VANE PUMP ROTATING TORQUE

(See page SR-42)

14. 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)