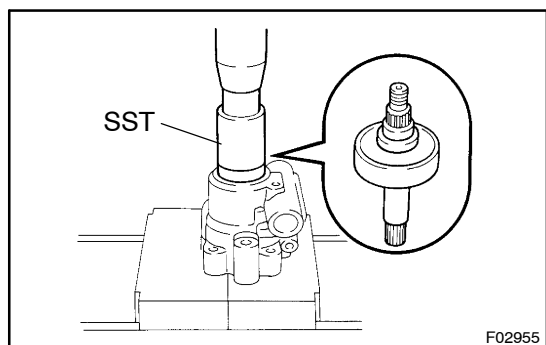




## REASSEMBLY

### NOTICE:

When using a vise, do not overtighten it.

### 1. COAT WITH POWER STEERING FLUID (See page SR-63)

### 2. INSTALL VANE PUMP SHAFT WITH BEARING

- Using SST, press in the pump shaft with the bearing.  
SST 09238-47012
- Using snap ring pliers, install a new snap ring to the front housing.

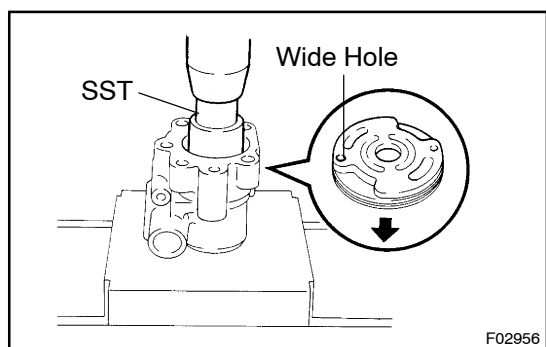
### 3. INSTALL SIDE FRONT PLATE

- Install a new longer straight pin to the front housing.

### NOTICE:

Be careful not to damage the pin.

- Coat 2 new O-rings with power steering fluid and install them to the plate.



- Using SST, press in the plate.  
SST 09238-47012

### NOTICE:

- Make sure to install the side front plate facing the correct direction.
- Be careful not to damage the O-ring.

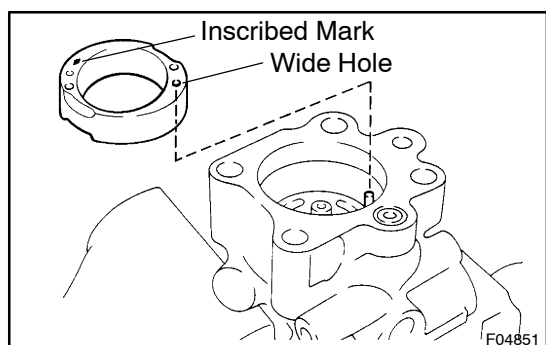
### HINT:

Align the wide hole of the plate and longer straight pin.

- Install a new shorter straight pin to the plate.

### NOTICE:

Be careful not to damage the pin.

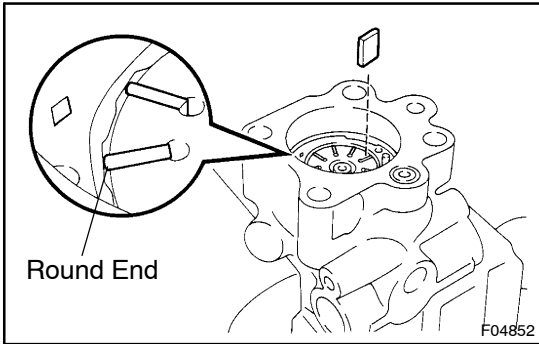


### 4. INSTALL CAM RING

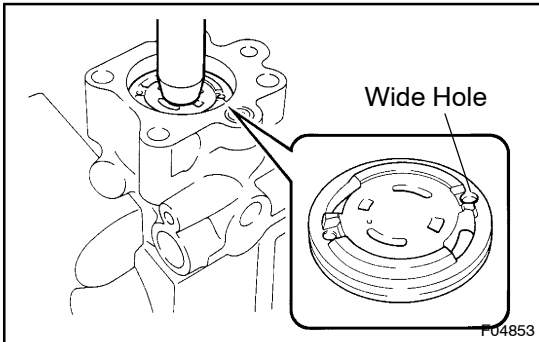
Align the wide hole of the ring and longer straight pin, and install the ring with the inscribed mark facing outward.

### 5. INSTALL VANE PUMP ROTOR

Install the rotor with the inscribed mark facing outward.

**6. INSTALL 10 VANE PLATES**

Install the plates with the round end facing outward.

**7. INSTALL SIDE REAR PLATE**

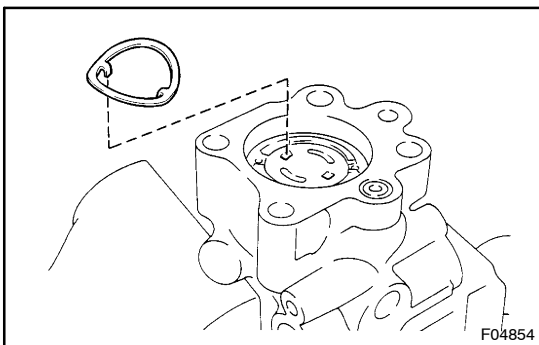
- Coat a new O-ring with power steering fluid and install it to the plate.
- Press in the plate.

**NOTICE:**

**Be careful not to damage the O-ring.**

**HINT:**

Align the wide hole of the plate and longer straight pin.

**8. INSTALL WAVE WASHER**

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

**9. INSTALL REAR BRACKET**

- Coat a new O-ring with power steering fluid and install it to the bracket.
- Torque the 4 bolts.

**Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)**

**10. INSTALL SPRING SEAT**

- Coat a new O-ring with power steering fluid and install it to the spring seat.
- Install the spring seat with the bolt hole facing outward.
- Using snap ring pliers, install a new snap ring.

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

- Install the valve facing the correct direction.  
(See page SR-63)
- 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 SUCTION PORT UNION**

- Coat a new O-ring with power steering fluid and install it to the union.
- Torque the 2 bolts.

**Torque: 13 N·m (130 kgf·cm, 9 ft·lbf)**

**13. MEASURE PS VANE PUMP ROTATING TORQUE**

**(See page SR-66)**