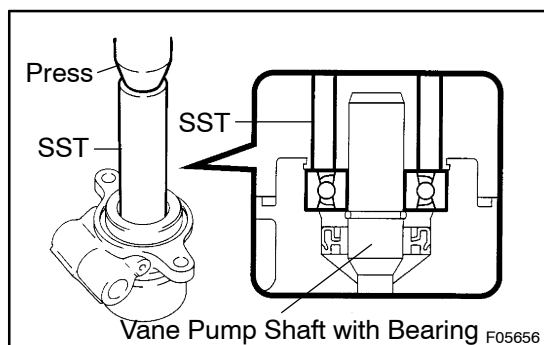


## REASSEMBLY

### NOTICE:

When using a vise, do not overtighten it.

1. COAT WITH POWER STEERING FLUID  
(See page SR-86)



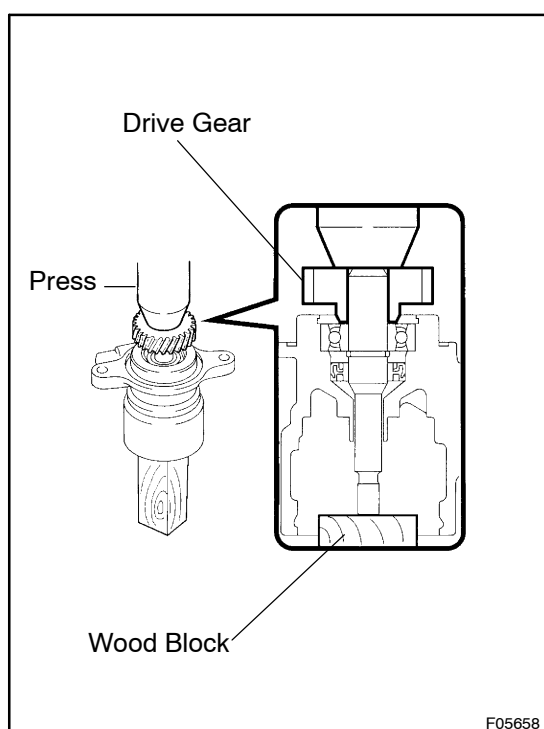
### 2. INSTALL VANE PUMP SHAFT WITH BEARING

- (a) Using SST, press in the shaft with the bearing.  
SST 09612-22011

### NOTICE:

Be careful not to damage the oil seal lip.

- (b) Install a new snap ring.



### 3. INSTALL VANE PUMP DRIVE GEAR

Supporting the vane pump shaft end with the wood block, press in the drive gear to the shaft as shown in the illustration.

### NOTICE:

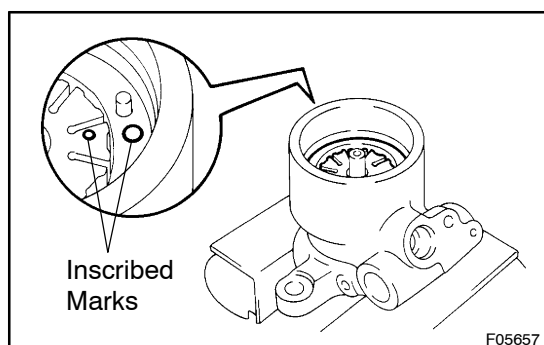
Press in the drive gear until its top surface levels with the top of the pump shaft.

### 4. INSTALL 2 WAVE WASHERS AND SIDE PLATE

- (a) Install new wave washers.
- (b) Coat 2 new O-rings with power steering fluid and install them to the plate.

### 5. INSTALL 2 STRAIGHT PINS

Install new pins to the side plate.



### 6. INSTALL CAM RING AND VANE PUMP ROTOR

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

### 7. INSTALL 10 VANE PLATES

### 8. INSTALL REAR HOUSING

- (a) Coat a new O-ring with power steering fluid and install it to the housing.
- (b) Install a new snap ring.

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

- (a) Install the valve facing the correct direction.  
(See page SR-86)
- (b) Coat a new O-ring with power steering fluid and install it to the union.
- (c) Torque the union.

**Torque: 69 N·m (700 kgf·cm, 51 ft·lbf)****10. 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)****11. MEASURE PS VANE PUMP ROTATING TORQUE  
(See page SR-90)**