

## REASSEMBLY

### NOTICE:

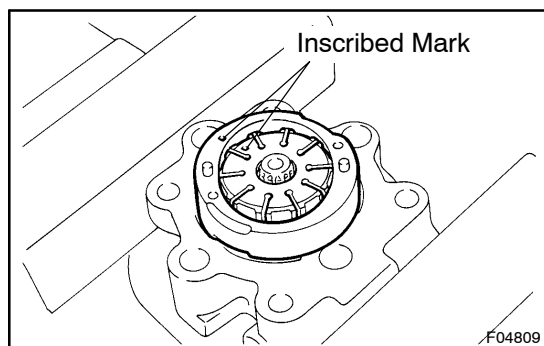
When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page [SR-36](#))
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

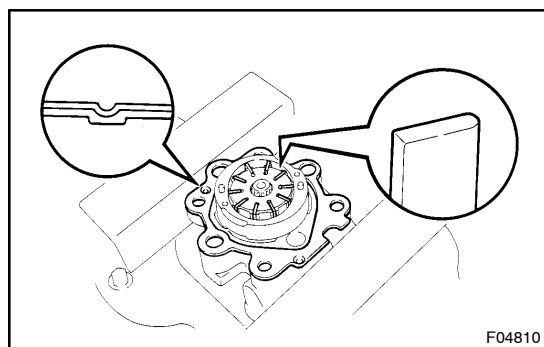
Install the cam ring with the inscribed mark facing outward.

#### HINT:

Align the holes of the cam ring with the straight pins.

### 5. INSTALL VANE PUMP ROTOR

- (a) Install the vane pump rotor with the inscribed mark facing outward.
- (b) Install a new snap ring to the vane pump shaft.



### 6. INSTALL VANE PLATES AND GASKET

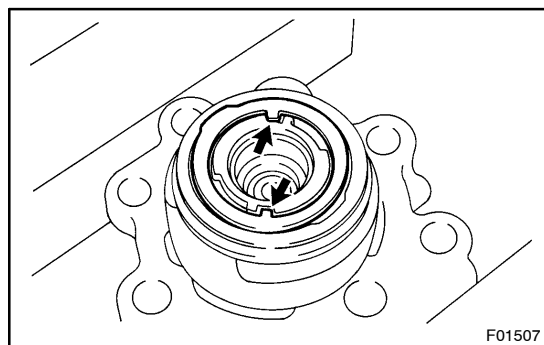
- (a) Install the 10 plates with the round end facing outward.
- (b) Install a new gasket on the front housing.

### NOTICE:

Be careful of 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 rear housing.
- (b) Install the rear housing with the 4 bolts.

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

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

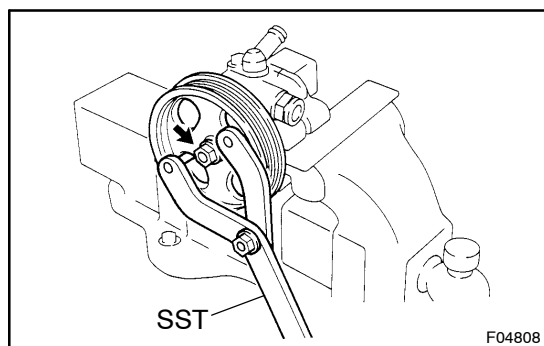
- (a) Install the spring to the front housing.
- (b) Install the flow control valve facing the correct direction (See page [SR-36](#)).
- (c) Coat a new O-ring with power steering fluid and install it to the pressure port union.
- (d) Install the pressure port union.

**Torque: 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) Install the suction port union with the bolt.

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

**12. INSTALL VANE PUMP PULLEY**

- (a) Install the vane pump pulley and nut to the vane pump shaft.
- (b) Using SST to stop the pulley rotating, torque a new pulley set 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-39](#))