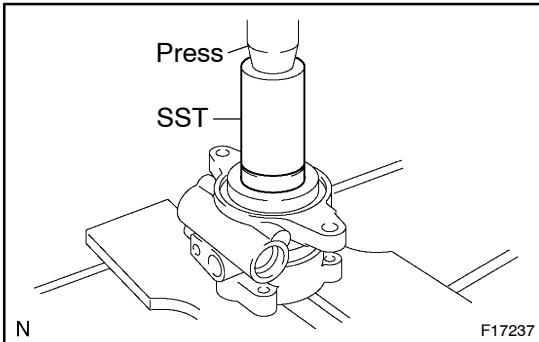


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT WITH POWER STEERING FLUID
(See page SR-41)



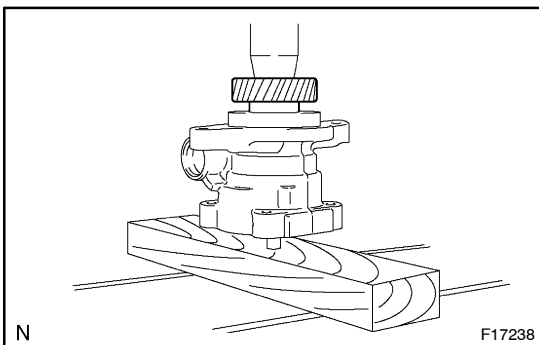
2. INSTALL VANE PUMP SHAFT WITH BEARING

- (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.

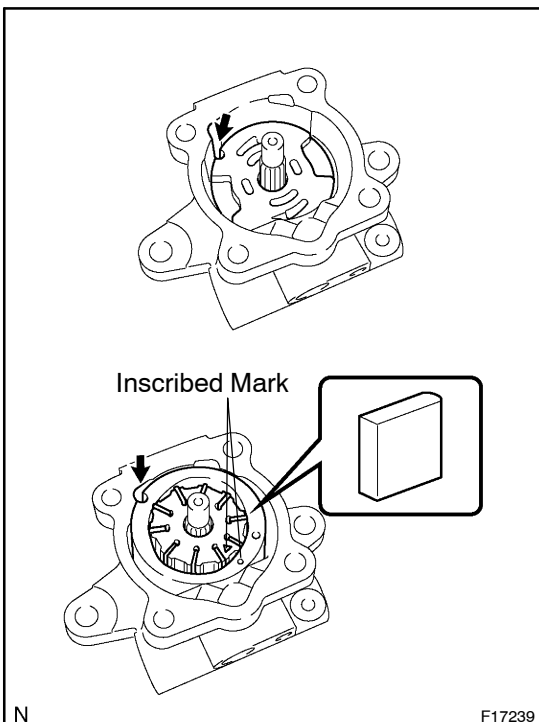


3. INSTALL VANE PUMP DRIVE GEAR

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 SIDE PLATE

- (a) Coat 2 new O-rings with power steering fluid and install them.
- (b) Install the side plate as shown in the illustrating.

HINT:

Align the hole of the side plate with the hole of the front housing.

5. INSTALL CAM RING AND VANE PUMP ROTOR

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

6. INSTALL 10 VANE PLATES

7. INSTALL REAR HOUSING

- (a) Coat a new gasket with power steering fluid and install it to the housing.
- (b) Install the 4 bolts.

Torque: 22 N·m (225 kgf·cm, 16 ft·lbf).

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

- (a) Install the valve facing the correct direction.
(See page SR-41)

- (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)

9. 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: 12 N·m (120 kgf·cm, 9 ft·lbf)

10. MEASURE PS VANE PUMP ROTATING TORQUE
(See page SR-44)