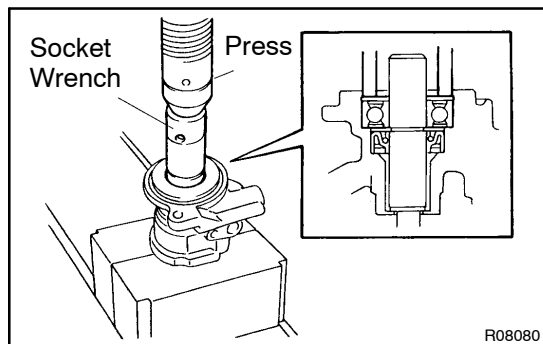




REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. **COAT WITH POWER STEERING FLUID**
(See page [SR-21](#))
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

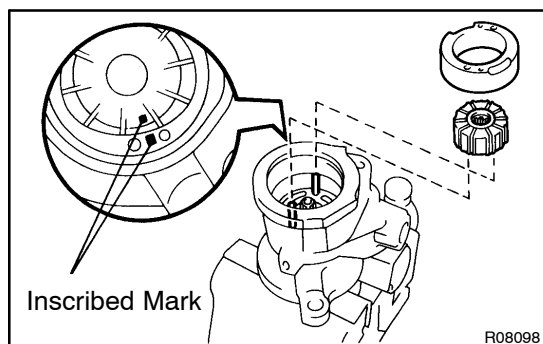
Install a new pin to the front housing.

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 you install the plate facing the correct direction.
(See page [SR-21](#))

5. INSTALL SHORTER STRAIGHT PIN

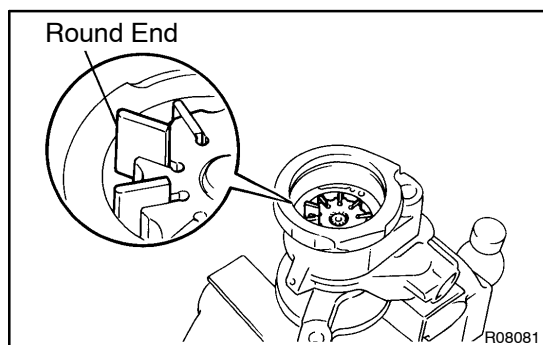
Install a new pin to the side front plate.

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.

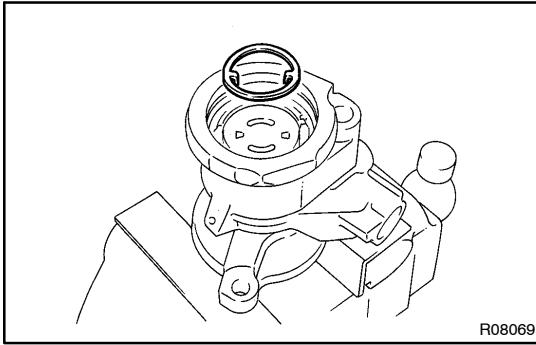


7. INSTALL VANE PLATES

Install the 10 plates with the round end facing outward.

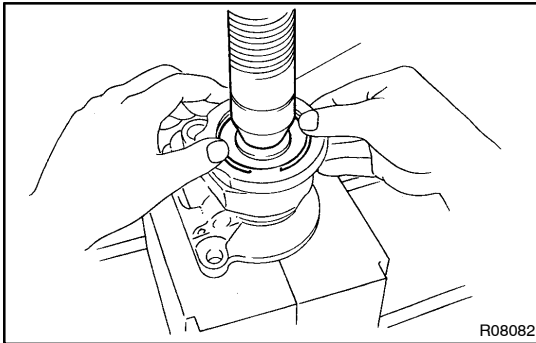
8. INSTALL SIDE REAR PLATE

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



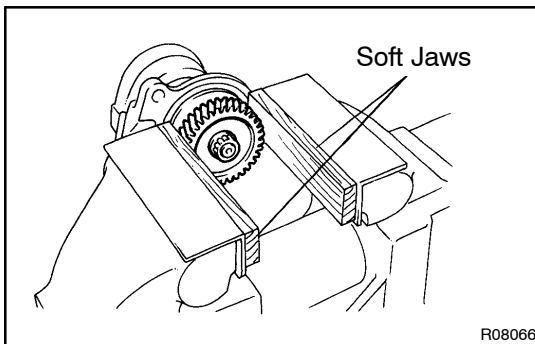
10. INSTALL REAR HOUSING

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

- (a) Install the valve facing the correct direction.
(See page [SR-21](#))
- (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)



12. INSTALL VANE PUMP DRIVE GEAR

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

NOTICE:

Be careful not to damage the gear.

- (c) Torque the gear set nut.

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

13. MEASURE POWER STEERING PUMP ROTATING TORQUE (See page [SR-24](#))

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)