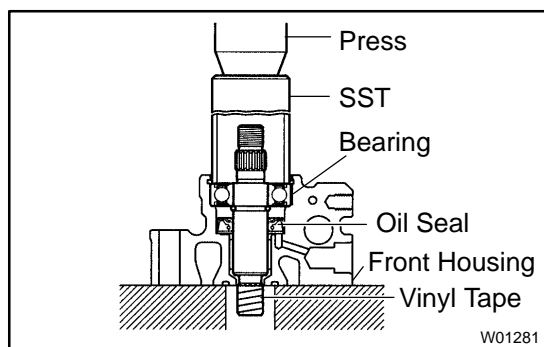


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. **COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page [SR-27](#))**



2. **INSTALL VANE PUMP SHAFT WITH BEARING**

- (a) To prevent oil seal lip damage, wind vinyl tape on the serrated part of the vane pump shaft.
- (b) Using SST, press in the vane pump shaft with the bearing.
SST 09608-04031

NOTICE:

Be careful not to damage the oil seal.

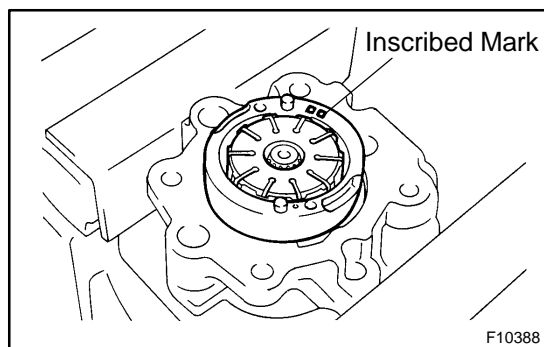
- (c) Using snap ring pliers, install a new snap ring to the front housing.

3. **INSTALL 2 STRAIGHT PINS**

Using a plastic hammer, tap in 2 new straight pins to the front housing.

NOTICE:

Be careful not to damage the straight pins.



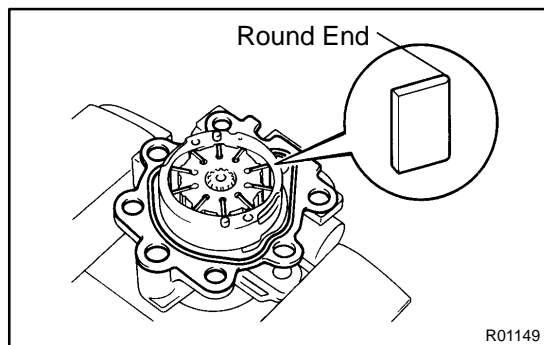
4. **INSTALL CAM RING**

Install the cam ring with the inscribed mark facing outward.

HINT:

Align the holes of the cam ring with the 2 straight pins.

5. **INSTALL VANE PUMP ROTOR**



6. **INSTALL 10 VANE PLATES AND GASKET**

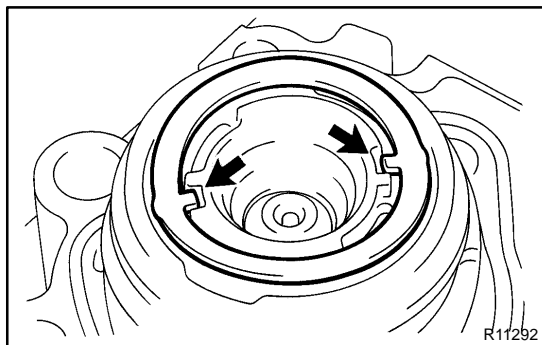
- (a) Install the 10 vane plates with the round end facing outward.
- (b) Install a new gasket on the front housing.

NOTICE:

Be careful the direction of the gasket.

7. **INSTALL SIDE PLATE**

Align the holes of the side plate and 2 straight pins.

**8. INSTALL WAVE WASHER**

Install the wave 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 2 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.

(b) Install the flow control valve facing in the correct direction (See page [SR-27](#)).

(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 OIL RESERVOIR

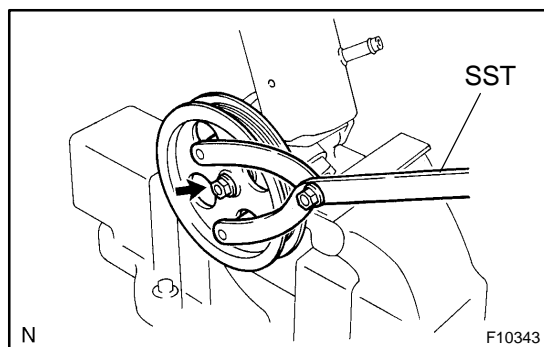
(a) Coat a new O-ring with power steering fluid and install it to the oil reservoir.

(b) Install the oil reservoir with the 3 bolts.

Torque:

Front side bolt: 13 N·m (130 kgf·cm, 9 ft·lbf)

Rear side bolts: 24 N·m (240 kgf·cm, 17 ft·lbf)

**12. INSTALL VANE PUMP PULLEY**

(a) Install the vane pump pulley and nut to the vane pump shaft.

(b) Using SST, stop the pulley rotating and torque the pulley set nut.

SST 09960-10010 (09962-01000, 09963-01000)

Torque: 44 N·m (450 kgf·cm, 33 ft·lbf)

13. MEASURE PS VANE PUMP ROTATING TORQUE (See page [SR-30](#))