

REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. **COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page SR-25)**
2. **INSTALL VANE PUMP SHAFT WITH BEARING**
 - (a) Using SST, press in the vane pump shaft with the bearing. SST 09238-47012
 - (b) Using snap ring pliers, install a new snap ring to the front housing.

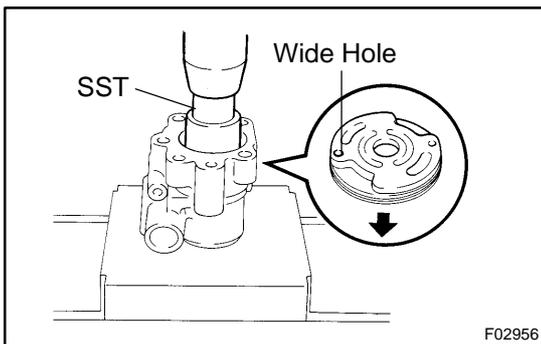
3. INSTALL SIDE FRONT PLATE

- (a) Install a new longer straight pin to the front housing.

NOTICE:

Be careful not to damage the pin.

- (b) Coat 2 new O-rings with power steering fluid and install them to the side front plate.



- (c) Using SST, press in the side front plate. SST 09238-47012

NOTICE:

- **Make sure to install the side front plate facing in the correct direction.**
- **Be careful not to damage the O-ring.**

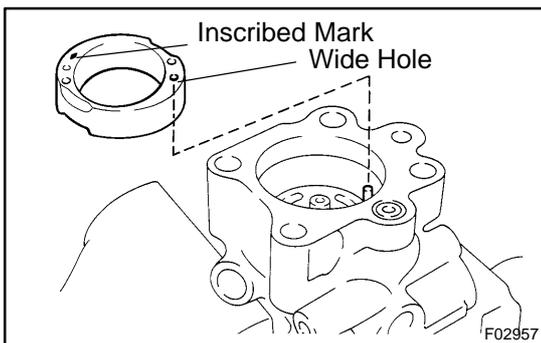
HINT:

Align the wide hole of the side front plate and longer straight pin.

- (d) Install a new shorter straight pin to the side front plate.

NOTICE:

Be careful not to damage the pin.

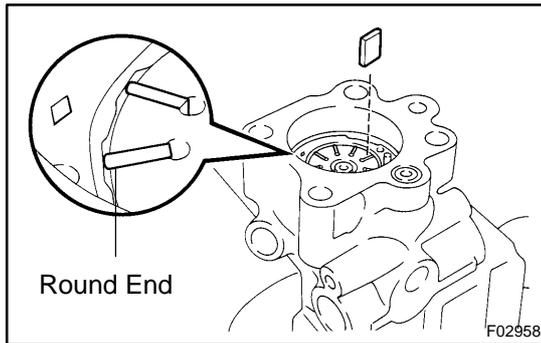


4. INSTALL CAM RING

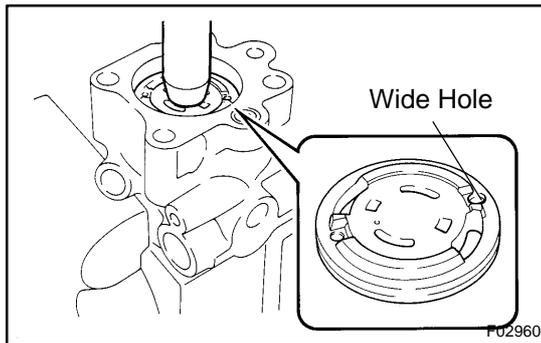
Align the wide hole of the cam ring and longer straight pin, and install the cam ring with the inscribed mark facing outward.

5. INSTALL VANE PUMP ROTOR

Install the vane pump rotor with the inscribed mark facing outward.

**6. INSTALL 10 VANE PLATES**

Install the 10 vane plates with the round end facing outward.

**7. INSTALL SIDE REAR PLATE**

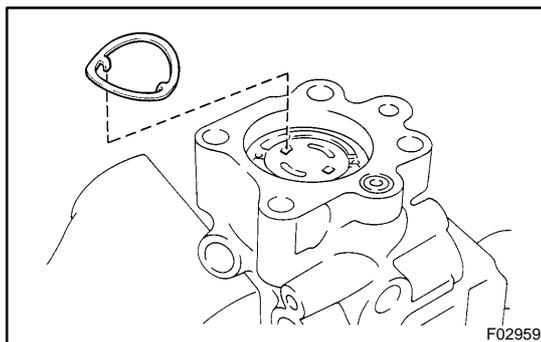
- (a) Coat a new O-ring with power steering fluid and install it to the side rear plate.
- (b) Press in the side rear plate.

NOTICE:

Be careful not to damage the O-ring.

HINT:

Align the wide hole of the side rear plate and longer straight pin.

**8. INSTALL WAVE WASHER**

Install the wave washer so that its protrusions fit into the slots in the side rear plate.

9. INSTALL REAR BRACKET

- (a) Coat a new O-ring with power steering fluid and install it to the rear bracket.
- (b) Install the rear bracket with the 4 bolts.
Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)

10. INSTALL SPRING SEAT

- (a) Coat a new O-ring with power steering fluid and install it to the spring seat.
- (b) Install the spring seat with the bolt hole facing outward.
- (c) Using snap ring pliers, install a new snap ring.

11. 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-25](#)).
- (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: 69 N·m (700 kgf·cm, 51 ft·lbf)

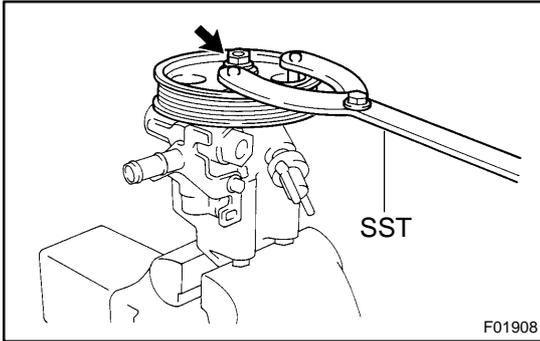
12. INSTALL SUCTION PORT UNION

- (a) Coat a new O-ring with power steering fluid and install it to the suction port union.
- (b) Install the suction port union with the 2 bolts.

Torque: 13 N·m (130 kgf·cm, 9 ft·lbf)

13. INSTALL AIR CONTROL VALVE

Torque: 29 N·m (300 kgf·cm, 22 ft·lbf)

**14. INSTALL VANE PUMP PULLEY**

- (a) Install the nut and vane pump pulley to the vane pump shaft.
- (b) Using SST, stop the pulley rotating and torque the nut.
SST 09960-10010 (09962-01000, 09963-01000)

Torque: 43 N·m (440 kgf·cm, 32 ft·lbf)

15. MEASURE PS VANE PUMP ROTATING TORQUE

(See page [SR-28](#))