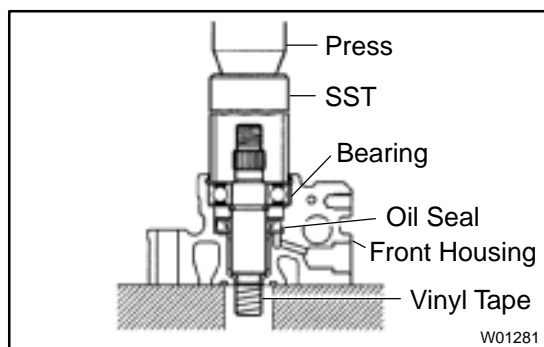


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. **COAT WITH POWER STEERING FLUID**
(See page [SR-20](#))



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

- (a) Wind vinyl tape on the serrated part of the vane pump shaft.
- (b) Using SST, press in the shaft with the bearing to the housing.
SST 09608-04031

NOTICE:

Be careful not to damage the oil seal.

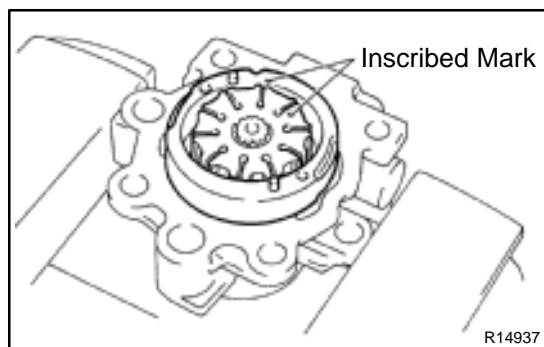
- (c) Using snap ring pliers, install a new snap ring to the front housing.

3. **INSTALL STRAIGHT PINS**

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

NOTICE:

Be careful not to damage the pin.



4. **INSTALL CAM RING**

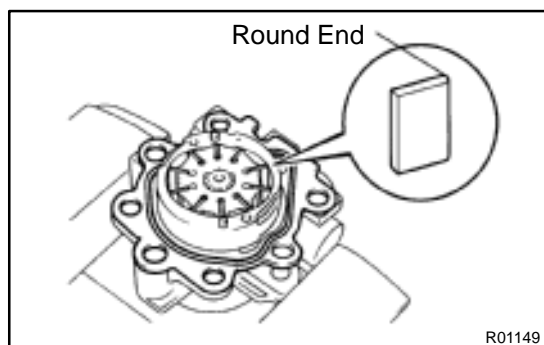
Install the ring with the inscribed mark facing outward.

HINT:

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

5. **INSTALL VANE PUMP ROTOR**

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



6. **INSTALL VANE PLATES**

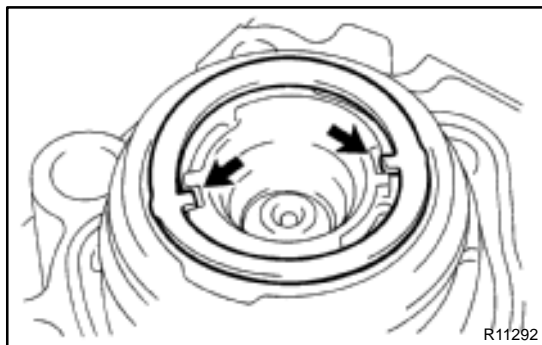
Install the 10 plates with the round end facing outward.

7. **INSTALL GASKET**

Install a new gasket on the front housing.

8. **INSTALL SIDE PLATE**

Align the holes of the side plate and straight pins, and install the plate.

**9. INSTALL WAVE WASHER**

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

10. INSTALL REAR HOUSING

(a) Coat 2 new O-rings with power steering fluid and install them to the housing.

(b) Torque the 2 bolts.

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

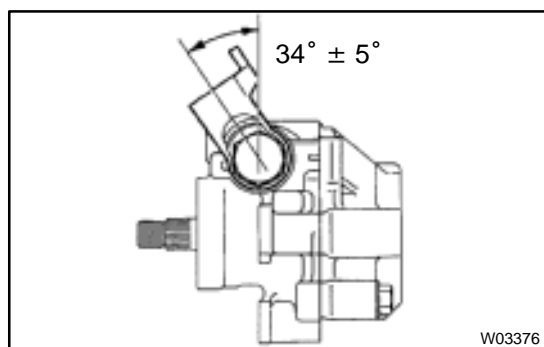
11. INSTALL COMPRESSION SPRING, FLOW CONTROL VALVE AND PRESSURE PORT UNION

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

(b) Install the valve facing the correct direction (See page [SR-20](#)).

(c) Torque the union.

Torque: 83 N·m (850 kgf·cm, 61 ft·lbf)

**12. INSTALL PRESSURE FEED NO.2 TUBE**

Install new gaskets on each side of the No.2 tube and torque the union bolt.

Torque: 69 N·m (700 kgf·cm, 51 ft·lbf)

HINT:

Install the tube at the angle shown in the illustration.

13. INSTALL OIL RESERVOIR

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

(b) Torque the 3 bolts.

Torque:

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

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

14. INSTALL PROTECTOR

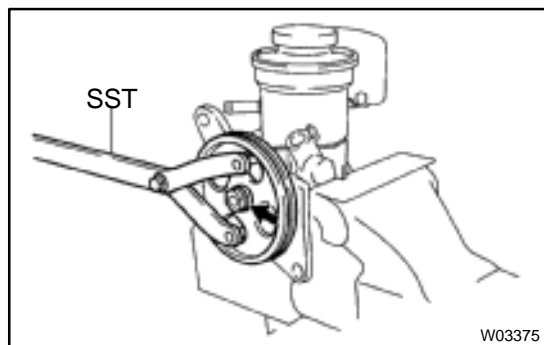
Torque the 2 bolts.

Torque: 5.5 N·m (55 kgf·cm, 48 in.-lbf)

15. INSTALL FRONT AND REAR BRACKETS

Torque the 3 bolts.

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

**16. INSTALL VANE PUMP PULLEY**

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)

17. MEASURE PS VANE PUMP ROTATING TORQUE
(See page [SR-23](#))