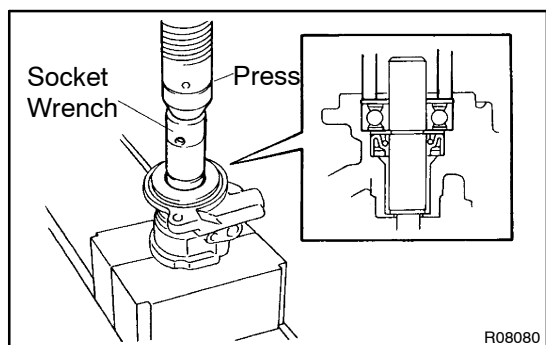


## REASSEMBLY

### NOTICE:

When using a vise, do not overtighten it.

1. **COAT WITH POWER STEERING FLUID**  
(See page SR-38)



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 to install the plate facing the correct direction.**

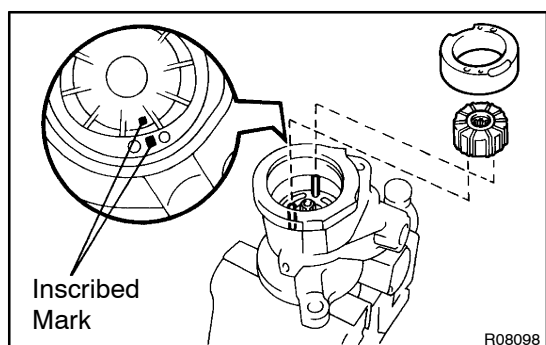
(See page SR-38)

5. **INSTALL SHORTER STRAIGHT PIN**

Install a new pin to the side front plate.

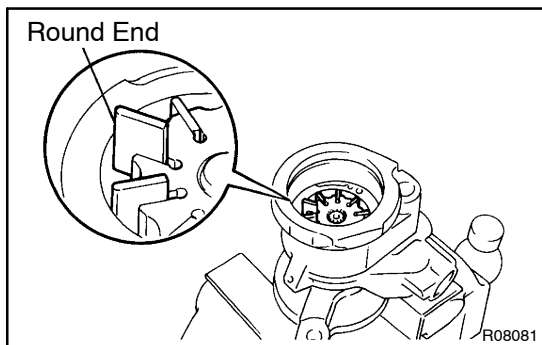
### NOTICE:

**Be careful not to damage the pin.**



6. **INSTALL CAM RING AND VANE PUMP ROTOR**

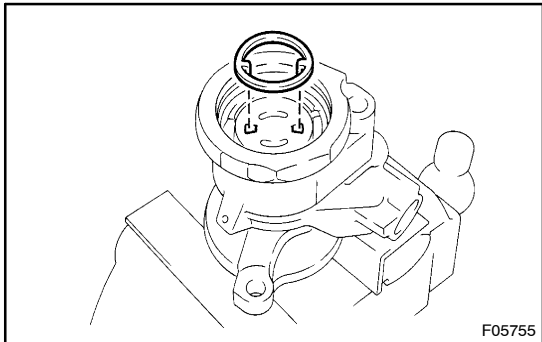
Install the ring and rotor with the inscribed marks facing outward.

**7. INSTALL 10 VANE PLATES**

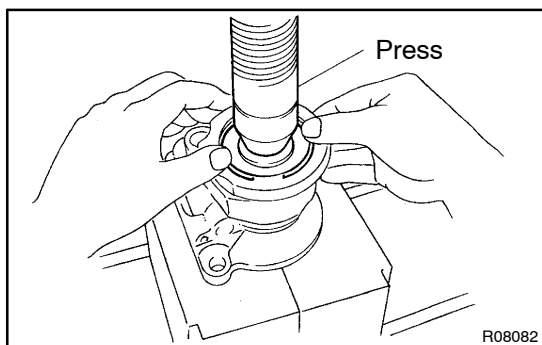
Install the plates with the round end facing outward.

**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.

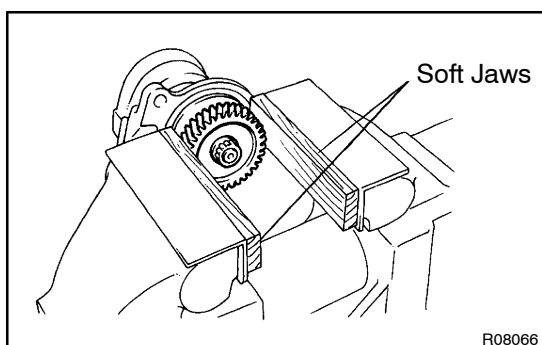
**10. INSTALL REAR HOUSING**

- (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-38)
- (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 PS VANE PUMP ROTATING TORQUE**

(See page SR-42)

**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)**