

## REASSEMBLY

### NOTICE:

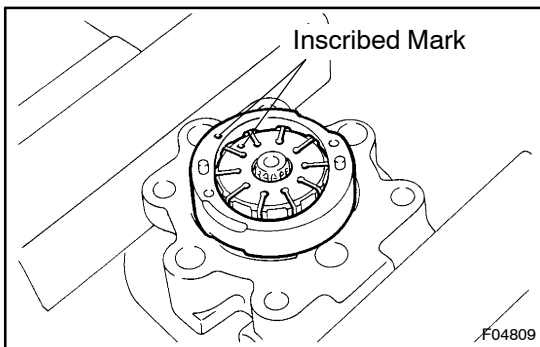
When using a vise, do not overtighten it.

1. COAT WITH POWER STEERING FLUID  
(See page SR-53)
2. INSTALL VANE PUMP SHAFT
3. INSTALL 2 STRAIGHT PINS

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

### NOTICE:

Be careful not to damage the pins.



#### 4. INSTALL CAM RING

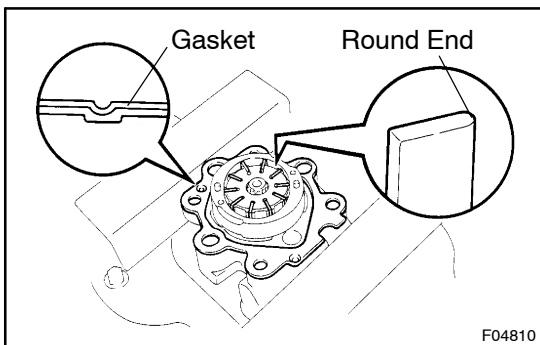
Install the ring with the inscribed mark facing outward.

#### HINT:

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

#### 5. INSTALL VANE PUMP ROTOR

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



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

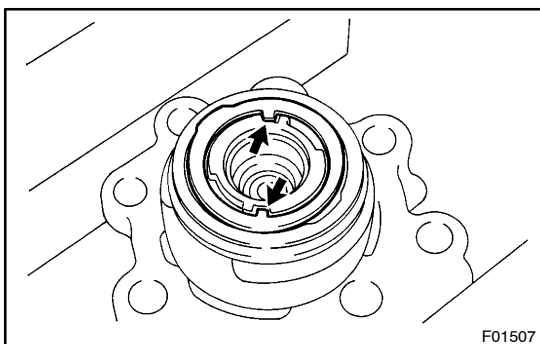
- (a) Install the plates with the round end facing outward.
- (b) Install a new gasket on the front housing.

### NOTICE:

Be careful the direction of the gasket.

#### 7. INSTALL SIDE PLATE

Align the holes of the plate and 2 straight pins.



#### 8. INSTALL WAVE WASHER

Install the 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 housing.
- (b) Torque the 4 bolts.

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

**10. INSTALL SPRING, FLOW CONTROL VALVE AND PRESSURE PORT UNION**

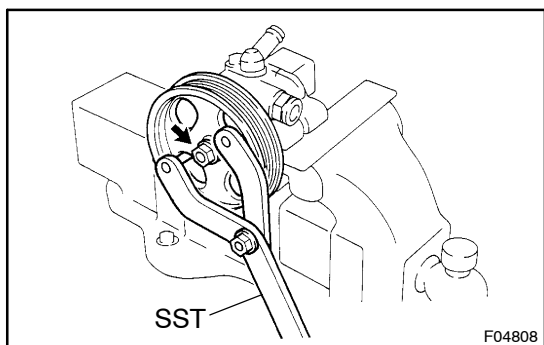
- (a) Install the valve facing the correct direction.  
(See page SR-53)
- (b) Coat a new O-ring with power steering fluid and install it to the union.
- (c) Torque the union.

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

**11. 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)**

**12. INSTALL VANE PUMP PULLEY**

Using SST, stop the pulley rotating and torque a new pulley set nut.

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

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

**13. MEASURE PS VANE PUMP ROTATING TORQUE**

(See page SR-56)