

REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT WITH POWER STEERING FLUID

(See page SR-63)

2. INSTALL VANE PUMP SHAFT WITH BEARING

- (a) Using SST, press in the pump shaft with the bearing.
SST 09238 –47012

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

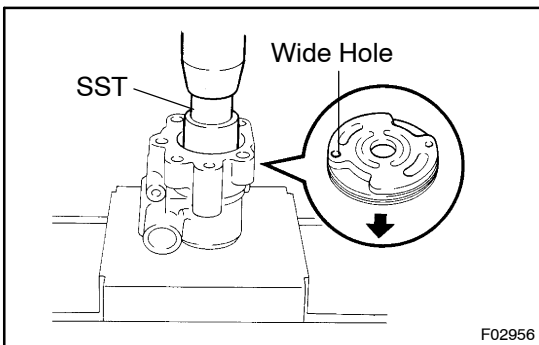
3. INSTALL SIDE FRONT PLATE

- (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 plate.



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

NOTICE:

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

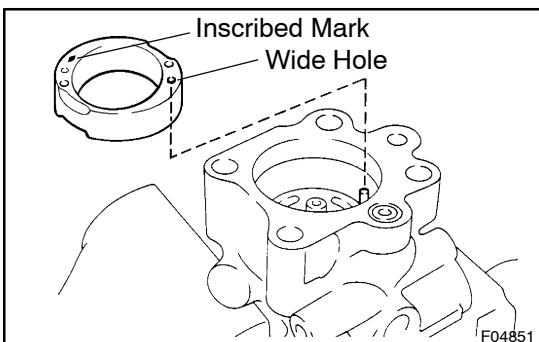
HINT:

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

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

NOTICE:

Be careful not to damage the pin.

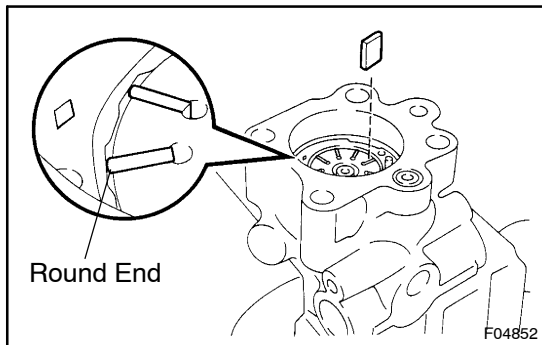


4. INSTALL CAM RING

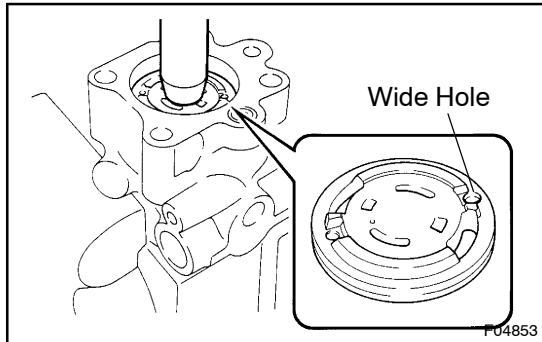
Align the wide hole of the ring and longer straight pin, and install the ring with the inscribed mark facing outward.

5. INSTALL VANE PUMP ROTOR

Install the rotor with the inscribed mark facing outward.

**6. INSTALL 10 VANE PLATES**

Install the plates with the round end facing outward.

**7. INSTALL SIDE REAR PLATE**

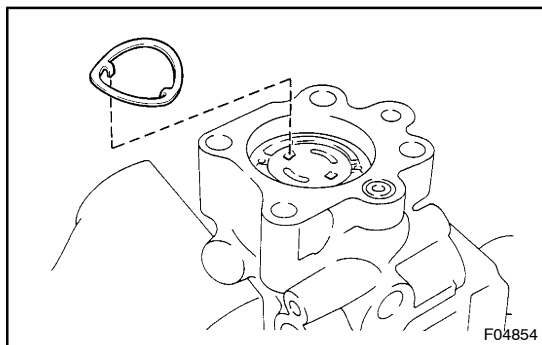
- Coat a new O-ring with power steering fluid and install it to the plate.
- Press in the plate.

NOTICE:

Be careful not to damage the O-ring.

HINT:

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

**8. INSTALL WAVE WASHER**

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

9. INSTALL REAR BRACKET

- Coat a new O-ring with power steering fluid and install it to the bracket.
- Torque the 4 bolts.

Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)

10. INSTALL SPRING SEAT

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

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

- Install the valve facing the correct direction.
(See page SR-63)
- Coat a new O-ring with power steering fluid and install it to the union.
- Torque the union.

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

12. INSTALL SUCTION PORT UNION

- Coat a new O-ring with power steering fluid and install it to the union.
- Torque the 2 bolts.

Torque: 13 N·m (130 kgf·cm, 9 ft·lbf)

13. MEASURE PS VANE PUMP ROTATING TORQUE

(See page SR-66)