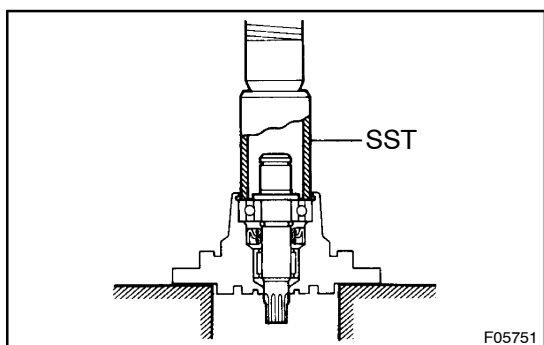


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT WITH POWER STEERING FLUID
(See page SR-75)



2. INSTALL VANE PUMP SHAFT WITH BEARING

- (a) Using SST, press in the shaft with the bearing to the front housing.
SST 09632 -36010

NOTICE:

Be careful not to damage the oil seal.

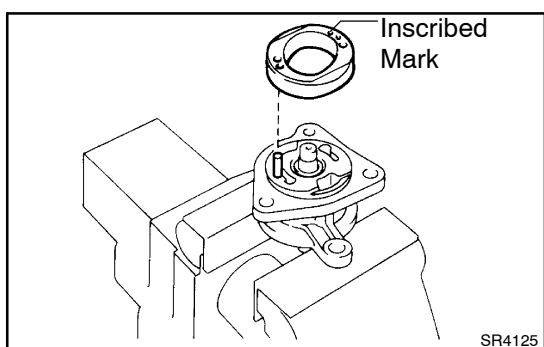
- (b) Using snap ring pliers, install a new snap ring to the front housing.

3. INSTALL STRAIGHT PIN

Install the new straight pin to the front housing.

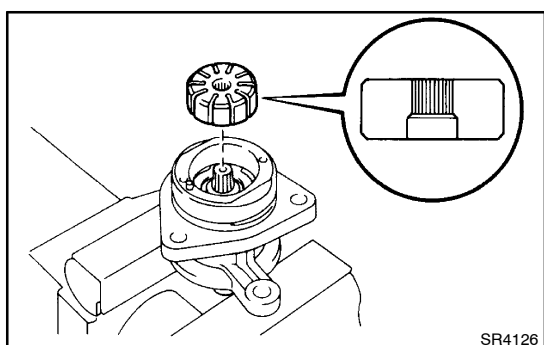
NOTICE:

Do not damage the pin.



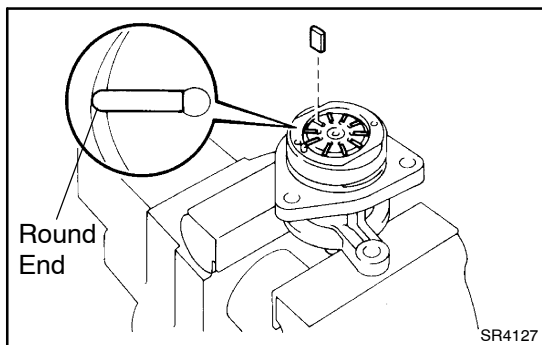
4. INSTALL CAM RING

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



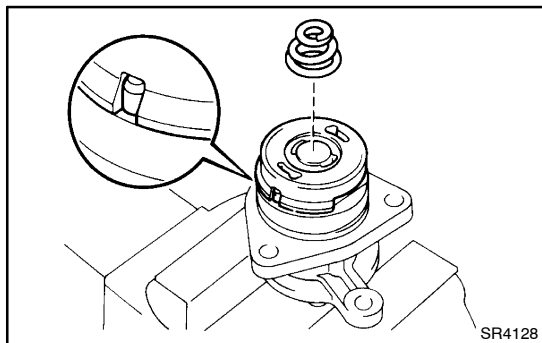
5. INSTALL VANE PUMP ROTOR

Install the rotor as shown in the illustration.



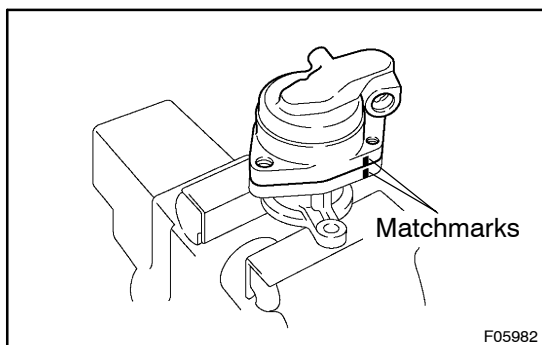
6. INSTALL 10 VANE PLATES

Install the plates with the round end facing outward.



7. INSTALL PRESSURE PLATE AND SPRING

- Coat a new O-ring with power steering fluid and install it to the pressure plate.
- Align the cut portion of the pressure plate to the straight pin and install it.
- Place the spring facing the correct direction.



8. INSTALL REAR HOUSING

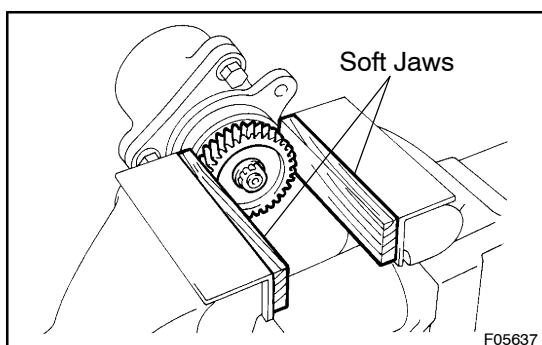
- Coat a new O-ring with power steering fluid and install it to the front housing.
- Align the matchmarks on the front and rear housing.
- Torque the 3 bolts.

Torque: 42 N·m (425 kgf·cm, 31 ft·lbf)

9. INSTALL VALVE LOCK SCREW, SPRING AND FLOW CONTROL VALVE

- Coat a new O-ring with power steering fluid and install it to the valve lock screw.
- Torque the valve lock screw.

Torque: 64 N·m (650 kgf·cm, 47 ft·lbf)



10. INSTALL VANE PUMP DRIVE GEAR

- Install the woodruff key and gear.
- Using soft jaws on a vise, clamp the gear in a vise.

NOTICE:

Be careful not to damage the gear.

- Torque the gear set nut.

Torque: 74 N·m (750 kgf·cm, 54 ft·lbf)

11. MEASURE PS VANE PUMP ROTATING TORQUE

(See page SR-78)