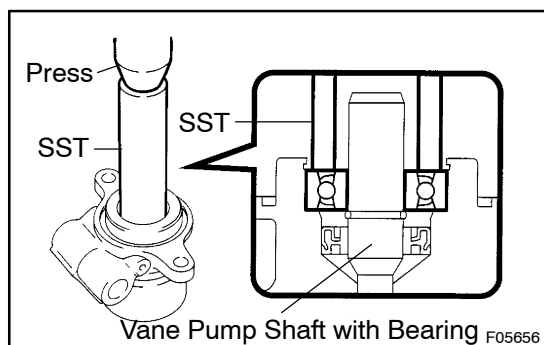


## REASSEMBLY

### NOTICE:

When using a vise, do not overtighten it.

1. COAT WITH POWER STEERING FLUID  
(See page SR-86)



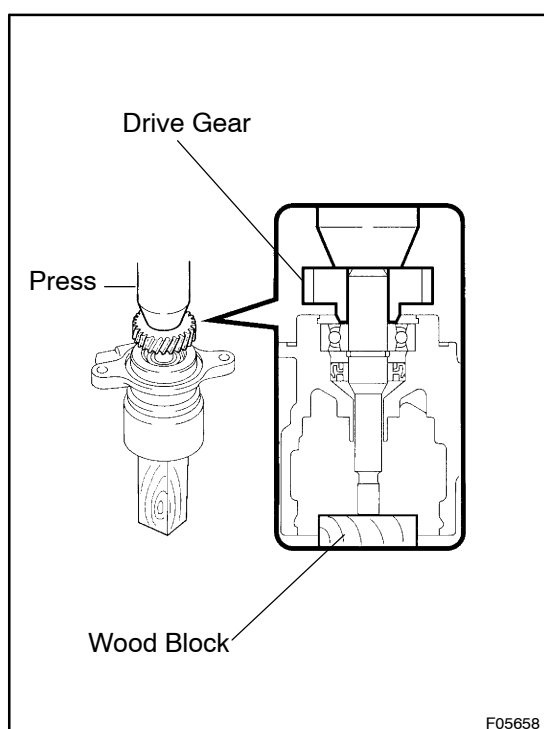
2. INSTALL VANE PUMP SHAFT WITH BEARING

- (a) Using SST, press in the shaft with the bearing.  
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### NOTICE:

Be careful not to damage the oil seal lip.

- (b) Install a new snap ring.



3. INSTALL VANE PUMP DRIVE GEAR

Supporting the vane pump shaft end with the wood block, press in the drive gear to the shaft as shown in the illustration.

### NOTICE:

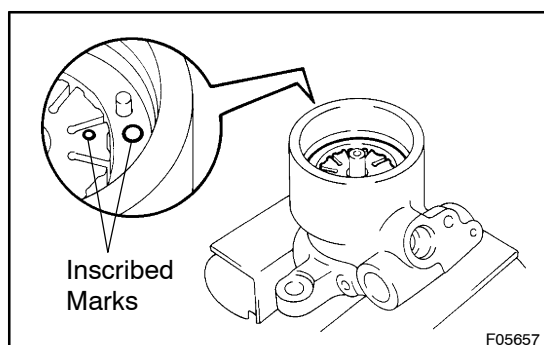
Press in the drive gear until its top surface levels with the top of the pump shaft.

4. INSTALL 2 WAVE WASHERS AND SIDE PLATE

- (a) Install new wave washers.
- (b) Coat 2 new O-rings with power steering fluid and install them to the plate.

5. INSTALL 2 STRAIGHT PINS

Install new pins to the side plate.



6. INSTALL CAM RING AND VANE PUMP ROTOR

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

7. INSTALL 10 VANE PLATES

8. INSTALL REAR HOUSING

- (a) Coat a new O-ring with power steering fluid and install it to the housing.
- (b) Install a new snap ring.

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

- (a) Install the valve facing the correct direction.  
(See page SR-86)
- (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)**

**10. 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)**

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

(See page SR-90)