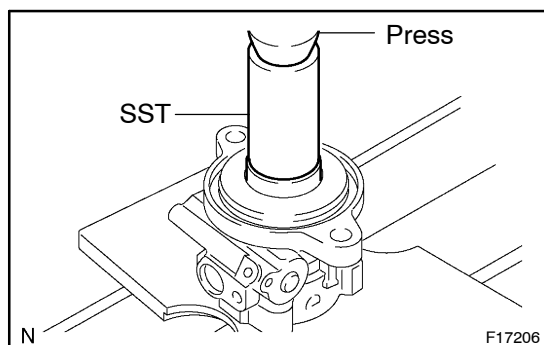


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT WITH POWER STEERING FLUID
(See page SR-22)



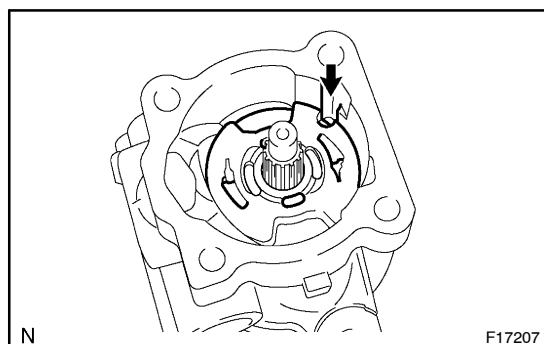
2. INSTALL VANE PUMP SHAFT WITH BEARING

- (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 lip.

- (b) Install the snap ring to the front housing.

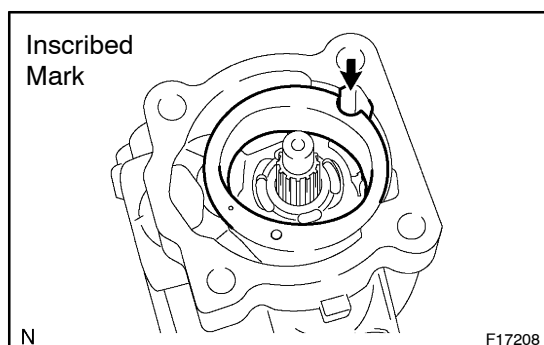


3. INSTALL SIDE PLATE

- (a) Coat new O-ring with power steering fluid and install them to the plate.
- (b) Align the hole of the plate and longer straight pin.

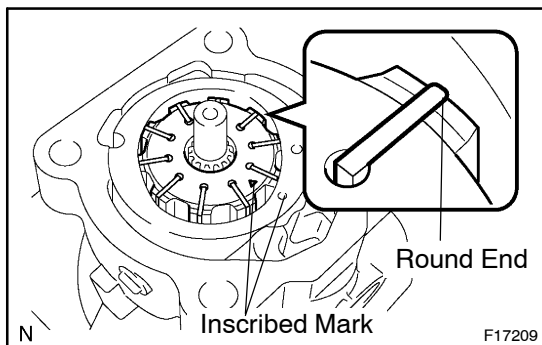
NOTICE:

Make sure to install the plate facing the correct direction.
(See page SR-22)



4. INSTALL CAM RING AND VANE PUMP ROTOR

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

**5. INSTALL 10 VANE PLATES**

Install the plates with the round end facing outward.

6. 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.

7. INSTALL REAR HOUSING

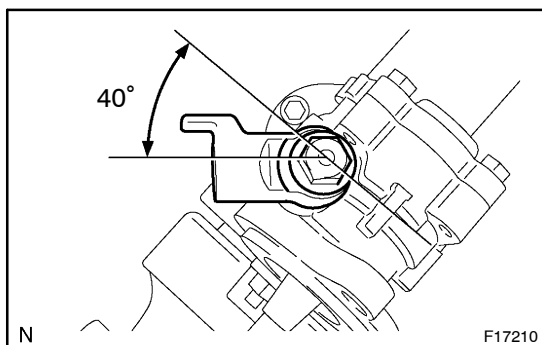
- (a) Coat a new gasket with power steering fluid and install it to the housing.
- (b) Torque the 4 bolts.

Torque: 22 N·m (225 kgf·cm, 16 ft·lbf).

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

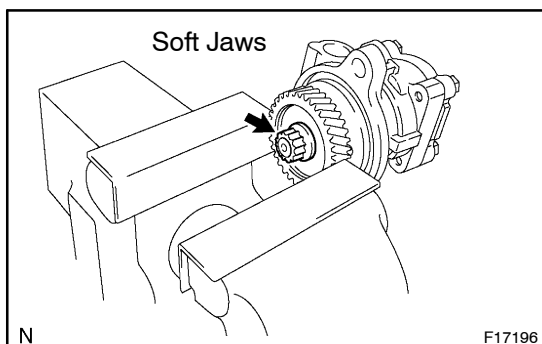
- (a) Install the valve facing the correct direction.
(See page SR-22)
- (b) Coat a new O-ring with power steering fluid and install it to the union.
- (c) Torque the union.

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

**9. INSTALL PRESSURE FEED TUBE UNION**

Install the union as shown in the illustration.

Torque: 50 N·m (510 kgf·cm, 37 ft·lbf)

**10. 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)

11. MEASURE PS VANE PUMP ROTATING TORQUE

(See page SR-25)

12. 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: 12 N·m (120 kgf·cm, 9 ft·lbf)