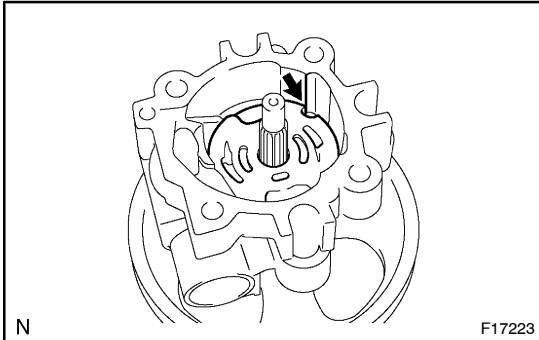


## REASSEMBLY

1. COAT WITH POWER STEERING FLUID  
(See page SR-32)
2. INSTALL VANE PUMP SHAFT

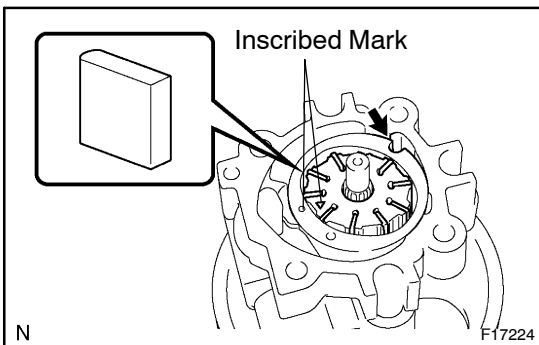


### 3. INSTALL SIDE PLATE

- (a) Install a new O-ring to the front housing.
- (b) Install a new O-ring to side plate.
- (c) Install the side plate as shown in the illustrating.

HINT:

Align the hole of the side plate with the hole of the front housing.



### 4. INSTALL CAM RING

Install the ring with the inscribed mark facing outward.

HINT:

Align the hole of the cam ring with the hole of the front housing.

### 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

- (a) Install the plates with the round end facing outward.

### 7. INSTALL REAR HOUSING

- (a) Coat new gasket with power steering fluid and install it to the housing.
- (b) Temporarily install the 4 bolts.
- (c) Using SST, hold the vane pump assembly in a vise.
- (d) 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-32).
- (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 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)**

**10. MEASURE PS VANE PUMP ROTATING TORQUE**  
([See page SR-35](#))