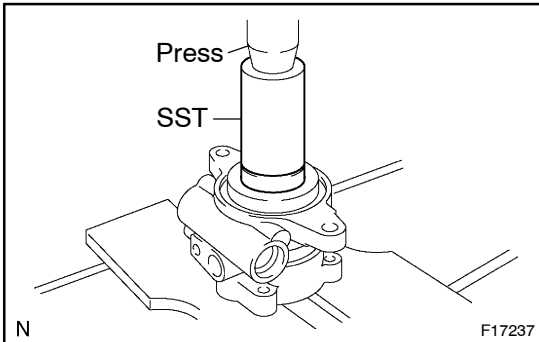


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. **COAT WITH POWER STEERING FLUID**
(See page SR-41)



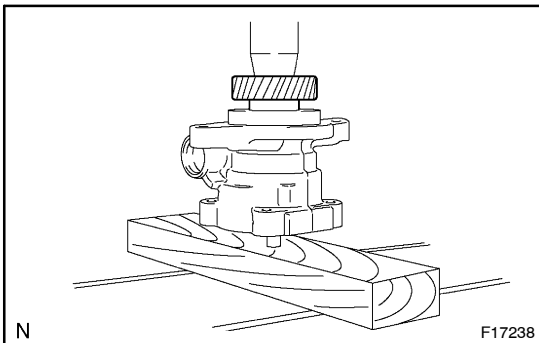
2. **INSTALL VANE PUMP SHAFT WITH BEARING**

- (a) Using SST, press in the shaft with the bearing.
SST 09612-22011

NOTICE:

Be careful not to damage the oil seal lip.

- (b) Install a new snap ring.

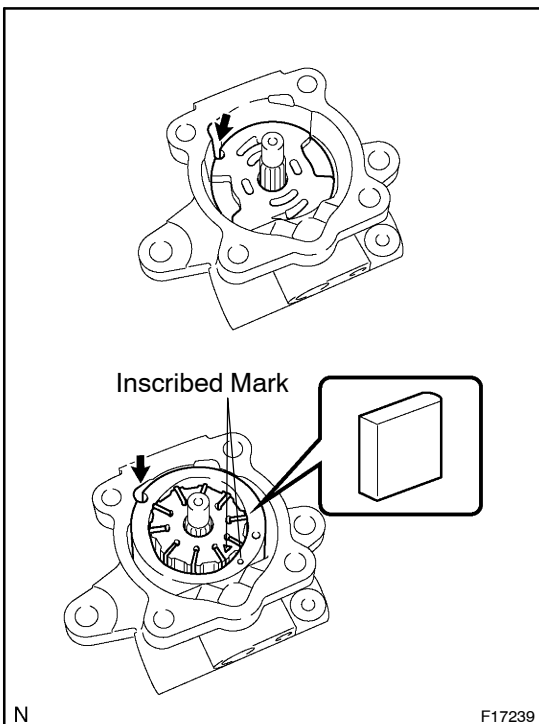


3. **INSTALL VANE PUMP DRIVE GEAR**

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 SIDE PLATE**

- (a) Coat 2 new O-rings with power steering fluid and install them.
- (b) Install the side plate as shown in the illustrating.

HINT:

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

5. **INSTALL CAM RING AND VANE PUMP ROTOR**

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

6. **INSTALL 10 VANE PLATES**

7. **INSTALL REAR HOUSING**

- (a) Coat a new gasket with power steering fluid and install it to the housing.
- (b) Install 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-41)

- (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-44)