

REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page [SR-31](#))

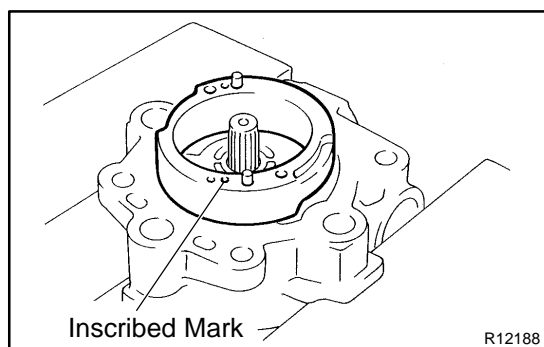
2. INSTALL STRAIGHT PINS

Using a plastic hammer, tap in 2 new straight pins to the front housing.

NOTICE:

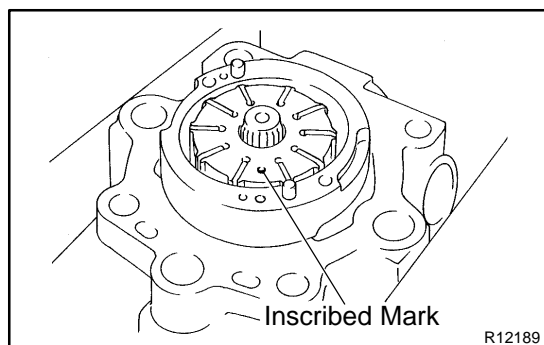
Be careful not to damage the straight pins.

3. INSTALL VANE PUMP SHAFT



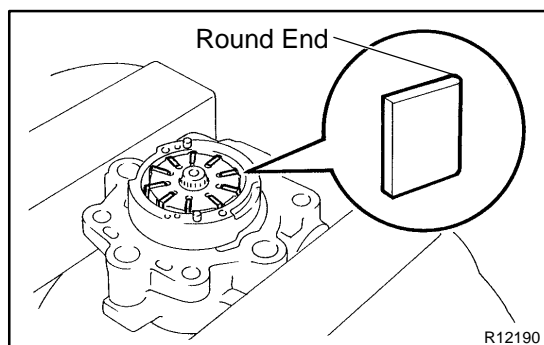
4. INSTALL CAM RING

Align the holes of the cam ring and 2 straight pins, and install the cam ring with the inscribed mark facing outward.



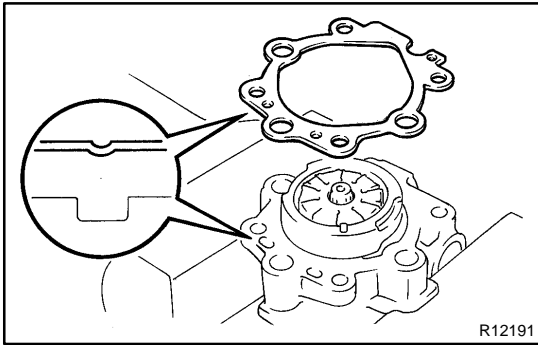
5. INSTALL VANE PUMP ROTOR

- (a) Install the vane pump rotor with the inscribed mark facing outward.
- (b) Install a new snap ring to the vane pump shaft.



6. INSTALL VANE PLATES

Install the 10 vane plates with the round end facing outward.

**7. INSTALL GASKET**

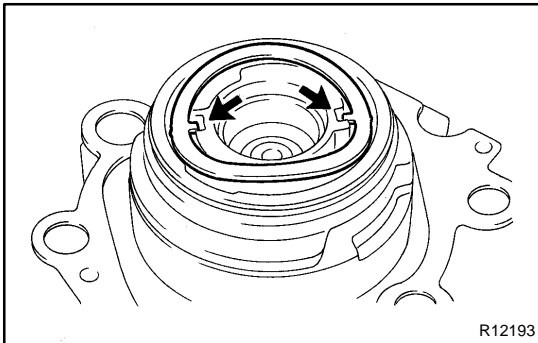
Install a new gasket on the front housing.

NOTICE:

Make sure that the gasket is installed facing in the correct direction.

8. INSTALL SIDE PLATE

Align the holes of the side plate and 2 straight pins, and install the side plate.

**9. INSTALL WAVE WASHER**

Install the wave washer so that its protrusions fit into the slots in the side plate.

10. INSTALL REAR HOUSING

(a) Coat 2 new O-rings with power steering fluid and install them to the housing.

(b) Install the rear housing with the 2 bolts.

Torque: 24 N·m (240 kgf-cm, 17 ft-lbf)

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

(a) Install the spring.

(b) Install the flow control valve facing in the correct direction (See page [SR-31](#)).

(c) Coat a new O-ring with power steering fluid and install it to the pressure port union.

(d) Install the pressure port union.

Torque: 83 N·m (850 kgf-cm, 62 ft-lbf)

12. INSTALL BRACKET

Install the bracket with the 2 bolts.

Torque: 43 N·m (440 kgf-cm, 32 ft-lbf)

13. INSTALL OIL RESERVOIR

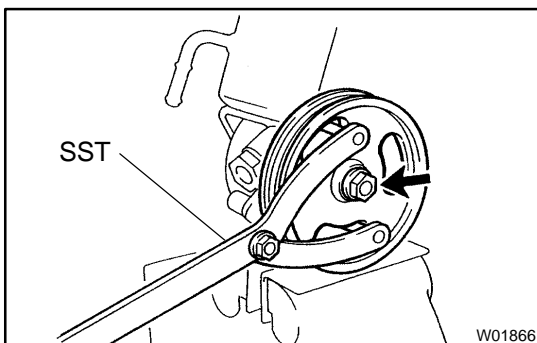
(a) Coat a new O-ring with power steering fluid and install it to the oil reservoir.

(b) Install the oil reservoir with the 3 bolts.

Torque:

Front side bolt: 13 N·m (130 kgf-cm, 9 ft-lbf)

Rear side bolts: 24 N·m (240 kgf-cm, 17 ft-lbf)

**14. INSTALL VANE PUMP PULLEY**

(a) Install the vane pump pulley and nut to the vane pump shaft.

(b) Using SST to stop the pulley rotating, torque the nut.
SST 09960-10010 (09962-01000, 09963-01000)

Torque: 43 N·m (440 kgf-cm, 32 ft-lbf)

15. MEASURE PS VANE PUMP ROTATING TORQUE

(See page [SR-34](#))