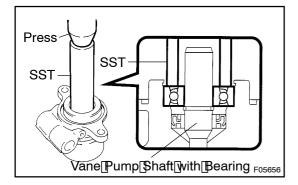
SR0QB-01

# **REASSEMBLY**

### NOTICE:

When using a vise, do not overtighten it.

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



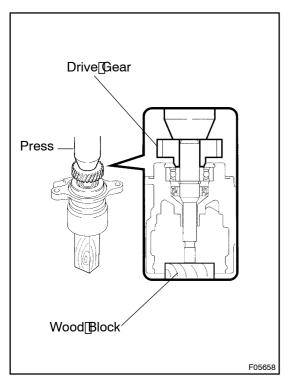
### 2. INSTALL VANE PUMP SHAFT WITH BEARING

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

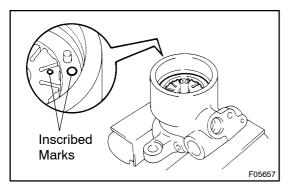
Supporting the vane pump shaft end with the wood block, press in the drive gear to the shaft as shown in the illustration.

#### NOTICE:

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

- 4. INSTALL 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 out ward.

- 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 tacing the correct direction. (See page R-86)
- (b) Coat hew D-ring with hower steering fluid and install to he linion.
- (c) Torque the union.

Torque:[69[N·m[700[kgf·cm,[51[ft·lbf)

- 10. INSTALL SUCTION PORT UNION
- (a) Coat hew D-ring with hower steering fluid and install to the lunion.
- (b) Torque the bolt.

Torque: 13[N·m[130[kgf·cm,[9[ft·lbf)

11 MEASURE PS VANE PUMP ROTATING TORQUE (See page \$R-90)