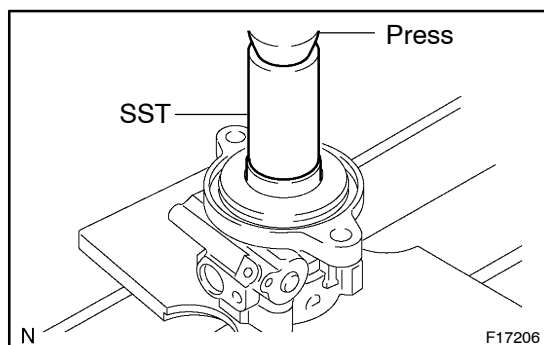


REASSEMBLY

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

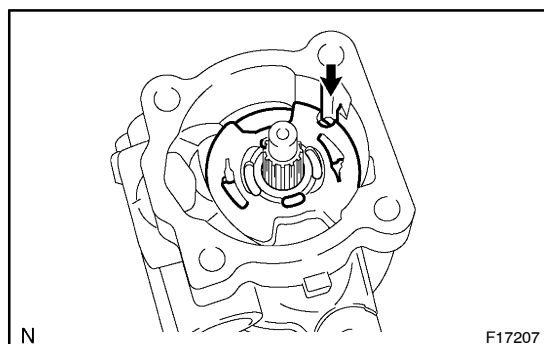
- (a) Using SST, press in the shaft with the bearing to the front housing.

SST 09632-36010

NOTICE:

Be careful not to damage the oil seal lip.

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

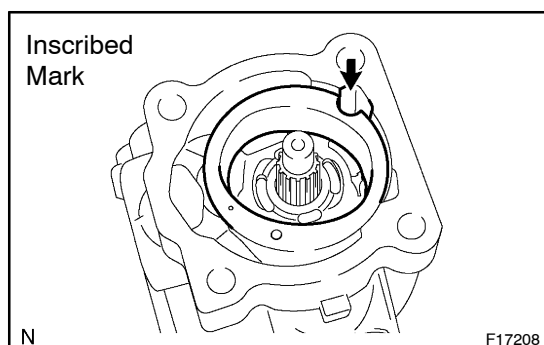


3. INSTALL SIDE PLATE

- (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.

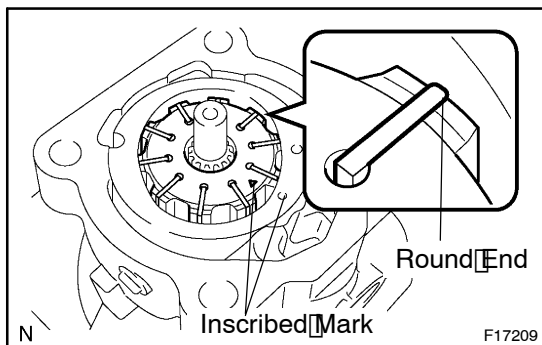
NOTICE:

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

- Coat a new O-ring with power steering fluid and install it to the plate.
- Align the holes of the plate with the straight pins.

7. INSTALL REAR HOUSING

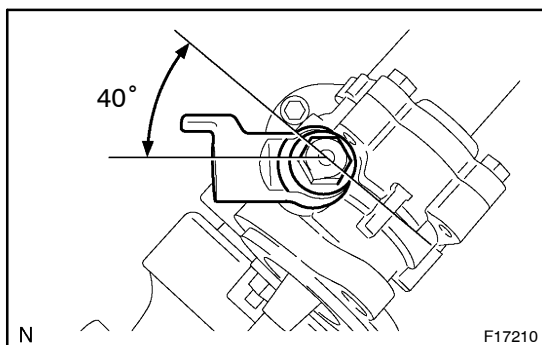
- Coat a new gasket with power steering fluid and install it to the housing.
- Torque the 4 bolts.

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

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

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

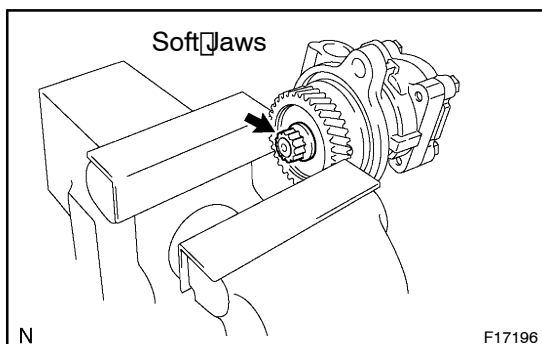
Torque: 69 N·m (700 kgf·cm, 51 ft·lbf)



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

- Install the woodruff key and gear.
- Using soft jaws on a vise, clamp the gear in the vise.

NOTICE:

Be careful not to damage the gear.

- 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

- Coat a new O-ring with power steering fluid and install it to the union.
- Torque the bolt.

Torque: 12 N·m (120 kgf·cm, 9 ft·lbf)