SR0PT-01

REASSEMBLY

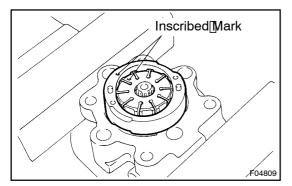
NOTICE:

When using a vise, do not overtighten it.

- 1. COAT WITH POWER STEERING FLUID (See page SR-53)
- 2. INSTALL VANE PUMP SHAFT
- 3. INSTALL 2 STRAIGHT PINS

Using a plastic hammer, tap in the new pins to the front housing. **NOTICE:**

Be careful not to damage the pins.



4. INSTALL CAM RING

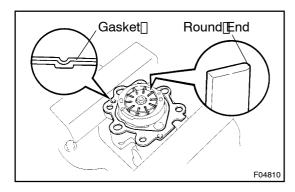
Install the ring with the inscribed mark facing outward.

HINT:

Align the holes of the cam ring with the 2 straight pins.

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 AND GASKET

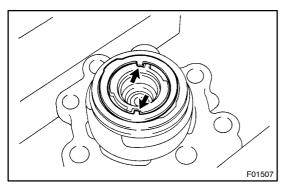
- (a) Install the plates with the round end facing outward.
- (b) Install a new gasket on the front housing.

NOTICE:

Be careful the direction of the gasket.

7. INSTALL SIDE PLATE

Align the holes of the plate and 2 straight pins.



8. INSTALL WAVE WASHER

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

9. INSTALL REAR HOUSING

- (a) Coat 2 new O-rings with power steering fluid and install them to the housing.
- (b) Torque the 4 bolts.

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

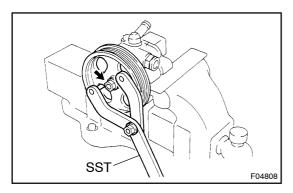
10. INSTALL SPRING, FLOW CONTROL VALVE AND PRESSURE PORT UNION

- (a) Install the valve facing the correct direction. (See page \$R-53)
- (b) Coat hew D-ring with hower steering fluid and install to the lunion.
- (c) Torque the union.

Torque:[83[N·m[850[kgf·cm,[61[ft·lbf)

- 11 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]]



12. INSTALL VANE PUMP PULLEY

Using \$ST, \$top the pulley for tating and torque a new pulley \$et nut.

SST[09960-1001009962-01000,09963-01000)

Torque: 43 N·m 440 kgf·cm, 32 ft·lbf)

13. MEASURE PS VANE PUMP ROTATING TORQUE (See page \$R-56)