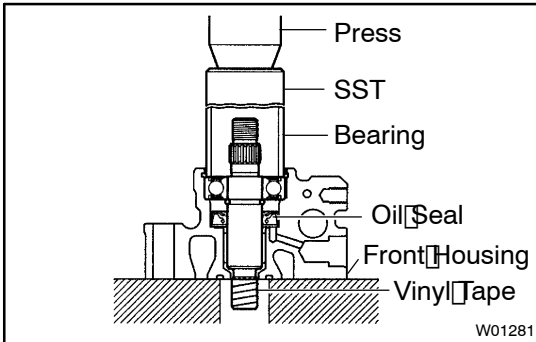


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. **COAT WITH POWER STEERING FLUID**
(See page SR-19)



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

- (a) Wind vinyl tape on the serrated part of the vane pump shaft.
- (b) Using SST, press in the shaft with the bearing.
SST 09608-04031

NOTICE:

Be careful not to damage the oil seal.

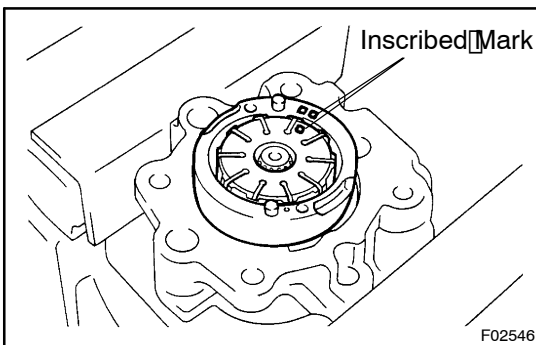
- (c) Using snap ring pliers, install a new snap ring to the front housing.

3. **INSTALL STRAIGHT PINS**

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

NOTICE:

Be careful not to damage the pins.



4. **INSTALL CAM RING**

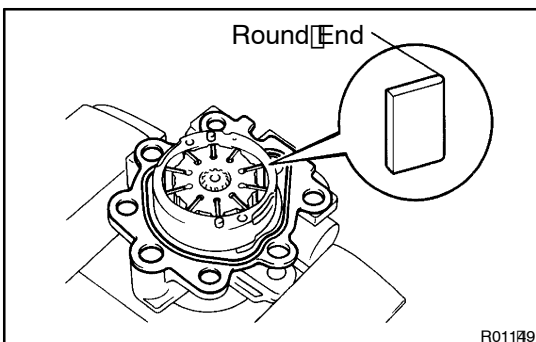
Install the ring with the inscribed mark facing outward.

HINT:

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

5. **INSTALL VANE PUMP ROTOR**

Install the rotor with the inscribed mark facing outward.



6. **INSTALL VANE PLATES AND GASKET**

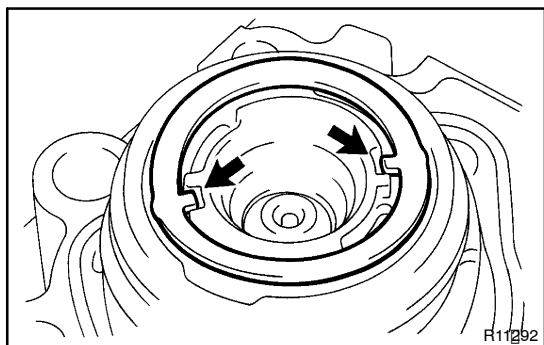
- (a) Install the 10 plates with the round end facing outward.
- (b) Install a new gasket on the front housing.

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

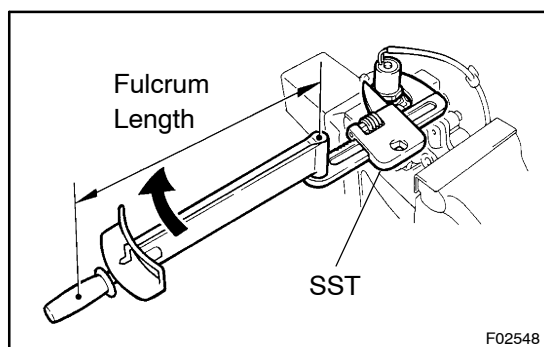
- Coat 2 new O-rings with power steering fluid and install them to the housing.
- Torque the 2 bolts.

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

10. INSTALL SPRING AND FLOW CONTROL VALVE

Install the valve facing the correct direction.

(See page SR-19)



11. INSTALL SOLENOID VALVE

- Install a new O-ring with power steering fluid and install it to the valve.
- Using SST, install the valve.

SST 09922-10010

Torque: 51 N·m (524 kgf·cm, 38 ft·lbf)

NOTICE:

Use SST 09922-10010 in the direction shown in the illustration.

HINT:

Use a torque wrench with a fulcrum length of 345 mm (13.58 in.).

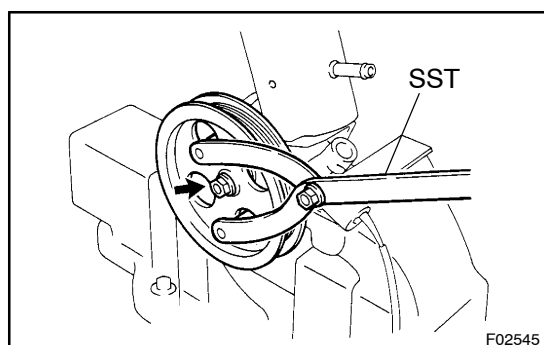
12. INSTALL OIL RESERVOIR

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



13. INSTALL VANE PUMP PULLEY

Using SST to stop the pulley rotating, torque the pulley set nut.

SST 09960-10010 (09962-01000, 09963-01000)

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

14. MEASURE PS VANE PUMP ROTATING TORQUE

(See page SR-22)