

REASSEMBLY

NOTICE:

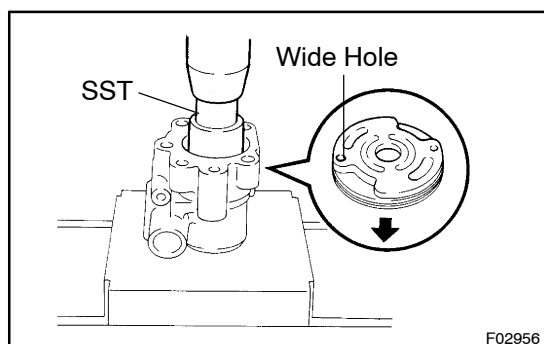
When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page SR-15)
2. INSTALL VANE PUMP SHAFT WITH BEARING
 - (a) Using SST, press in the vane pump shaft with the bearing. SST 09238-47012
 - (b) Using snap ring pliers, install a new snap ring to the front housing.
3. INSTALL SIDE FRONT PLATE
 - (a) Install a new longer straight pin to the front housing.

NOTICE:

Be careful not to damage the pin.

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



- (c) Using SST, press in the side front plate. SST 09238-47012

NOTICE:

- Make sure that the side front plate is installed facing in the correct direction.
- Be careful not to damage the O-ring.

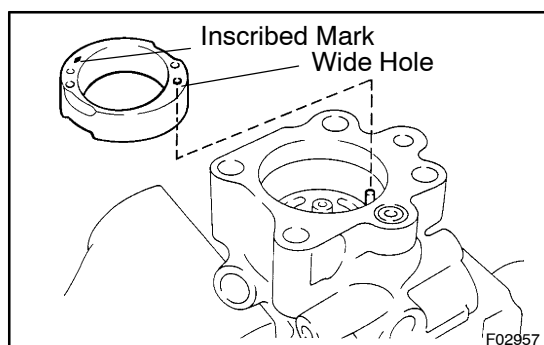
HINT:

Align the wide hole of the plate and longer straight pin.

- (d) Install a new shorter straight pin to the front side plate.

NOTICE:

Be careful not to damage the pin.

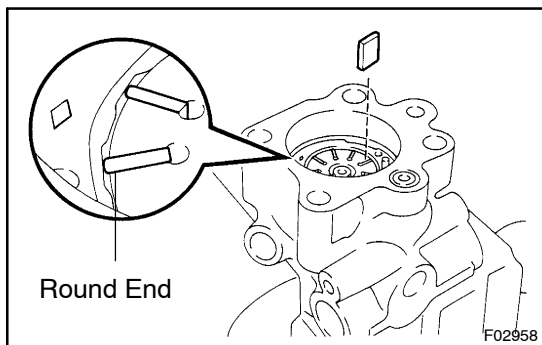


4. INSTALL CAM RING

Align the wide hole of the cam ring and longer straight pin, and install the cam ring with the inscribed mark facing outward.

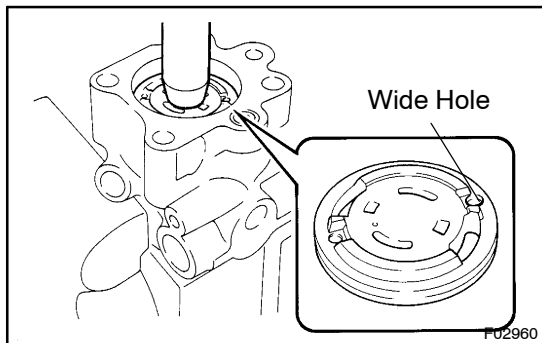
5. INSTALL VANE PUMP ROTOR

Install the vane pump rotor with the inscribed mark facing outward.



6. INSTALL VANE PLATES

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



7. INSTALL SIDE REAR PLATE

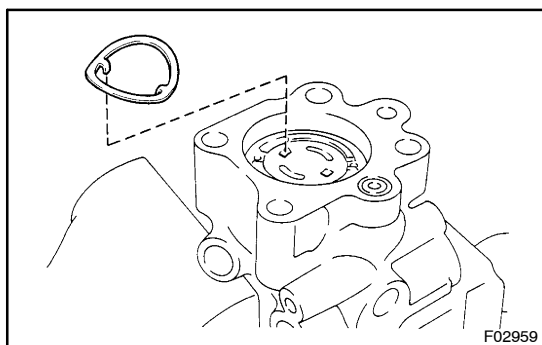
- Coat a new O-ring with power steering fluid and install it to the side rear plate.
- Using a press, press in the side rear plate.

NOTICE:

Be careful not to damage the O-ring.

HINT:

Align the wide hole of the side rear plate and longer straight pin.



8. INSTALL WAVE WASHER

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

9. INSTALL REAR BRACKET

- Coat a new O-ring with power steering fluid and install it to the rear bracket.
- Install the rear bracket to the front housing with the 4 bolts.

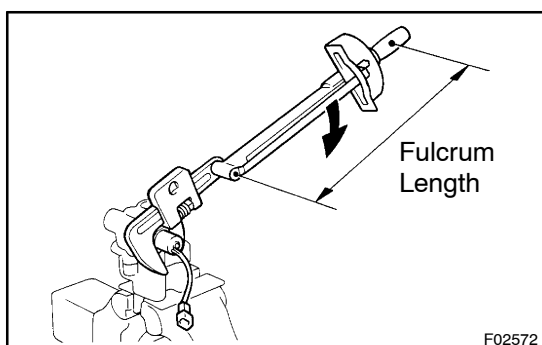
Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)

10. INSTALL SPRING SEAT

- Coat a new O-ring with power steering fluid and install it to the spring seat.
- Install the spring seat with the bolt hole facing outward.
- Using snap ring pliers, install a new snap ring.

11. INSTALL SPRING AND FLOW CONTROL VALVE

- Install the spring.
- Install the flow control valve facing the correct direction (See [page SR-15](#)).



12. INSTALL SOLENOID VALVE

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

SST 09922-10010

Torque: 51 N·m (520 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.).

13. INSTALL SUCTION PORT UNION

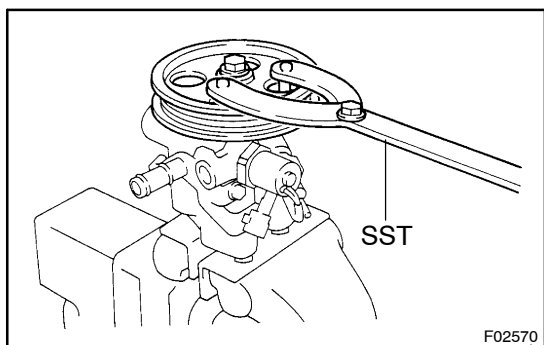
- (a) Coat a new O-ring with power steering fluid and install it to the suction port union.
- (b) Install the suction port union to the vane pump assembly with the 2 bolts.

Torque: 13 N·m (130 kgf·cm, 9 ft·lbf)

14. INSTALL AIR CONTROL VALVE

Install a new union seat and air control valve.

Torque: 29 N·m (300 kgf·cm, 22 ft·lbf)

**15. INSTALL VANE PUMP PULLEY**

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

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

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

16. MEASURE PS VANE PUMP ROTATING TORQUE

(See [page SR-18](#))