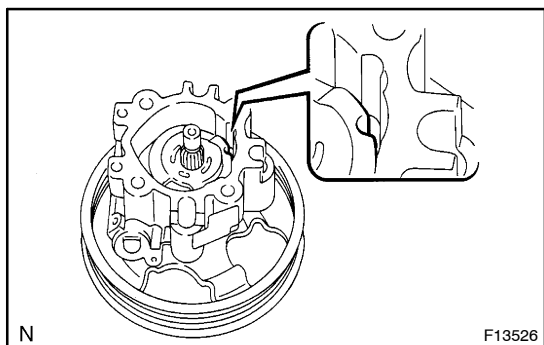


## REASSEMBLY

### NOTICE:

When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page SR-27)
2. INSTALL VANE PUMP SHAFT WITH VANE PUMP PULLEY

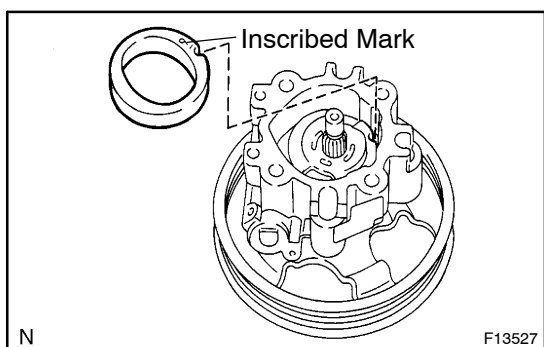


### 3. INSTALL SIDE PLATE

- (a) Coat 2 new O-rings with power steering fluid, and install them to the side plate.
- (b) Align the dent of the side plate with the dent of the front housing, and install the side plate.

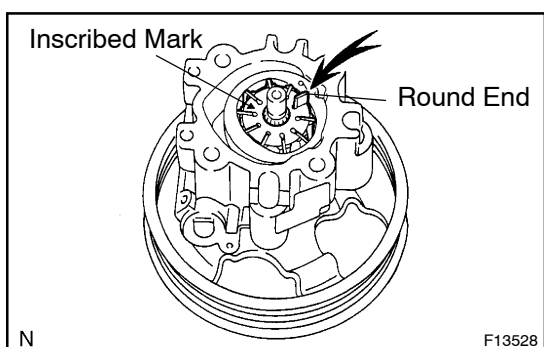
### NOTICE:

Make sure that the side plate is installed facing in the correct direction.



### 4. INSTALL CAM RING

Align the dent of the cam ring with the dent of the side plate, and install the cam ring with the inscribed mark facing outward.



### 5. INSTALL VANE PUMP ROTOR

- (a) Install the vane pump rotor with the inscribed mark facing outward.
- (b) Install a new snap ring to the vane pump shaft.

### 6. INSTALL 10 VANE PLATES

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

### 7. INSTALL REAR HOUSING

- (a) Coat a new O-ring with power steering fluid, and install it to the rear housing.
- (b) Align the straight pin of the rear housing with the dents of the cam ring, side plate and front housing, and install the rear housing with the 4 bolts.

**Torque: 22 N·m (220 kgf·cm, 16 ft·lbf)**

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

- (a) Install the spring.
- (b) Install the flow control valve facing in the correct direction ([See page SR-27](#)).
- (c) Coat a new O-ring with power steering fluid, and install it to the pressure port union.
- (d) Install the pressure port union.

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

**9. 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 with the bolt.

**Torque: 12 N·m (120 kgf·cm, 9 ft·lbf)**

**10. INSTALL PUMP BRACKET**

Install the pump bracket with the 3 bolts.

**Torque: 30 N·m (310 kgf·cm, 22 ft·lbf)**

**11. MEASURE PS VANE PUMP ROTATING TORQUE**

([See page SR-30](#))