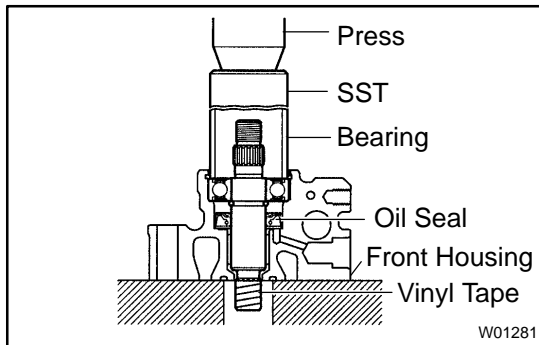


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page [SR-20](#))



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.

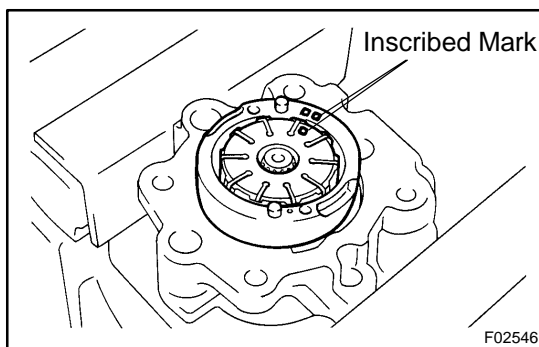
- (c) Using snap ring pliers, install a new snap ring to the front housing.

3. INSTALL STRAIGHT PINS

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

NOTICE:

Be careful not to damage the straight pins.



4. INSTALL CAM RING

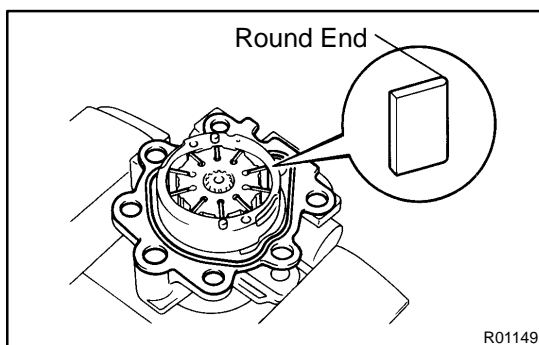
Install the cam ring with the inscribed mark facing outward.

HINT:

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

5. INSTALL VANE PUMP ROTOR

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



6. INSTALL VANE PLATES AND GASKET

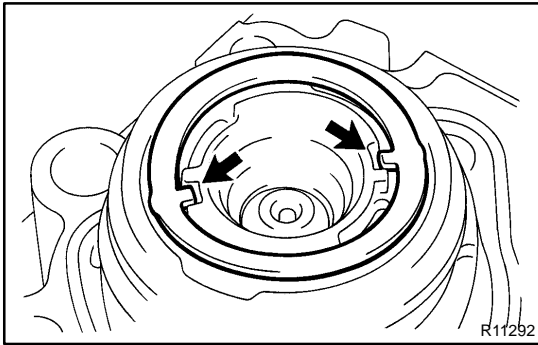
- (a) Install the 10 vane plates with the round end facing outward.
- (b) Install a new gasket on the front housing.

NOTICE:

Be careful the direction of the gasket.

7. INSTALL SIDE PLATE

Align the holes of the side plate and 2 straight pins.

**8. INSTALL WAVE WASHER**

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

9. INSTALL REAR HOUSING

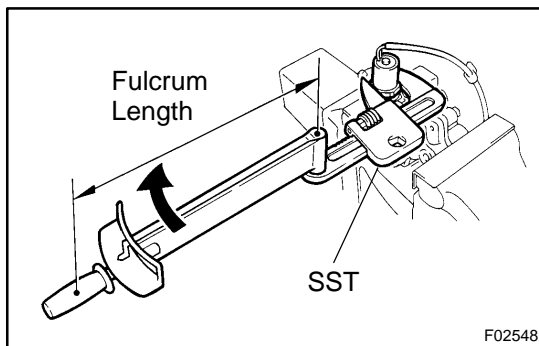
(a) Coat 2 new O-rings with power steering fluid and install them to the rear housing.

(b) Install the rear housing with the 2 bolts.

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

10. INSTALL SPRING AND FLOW CONTROL VALVE

Install the flow control valve facing the correct direction (See page [SR-20](#)).

**11. INSTALL SOLENOID VALVE**

(a) Install a new O-ring with power steering fluid and install it to the solenoid valve.

(b) 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.).

12. INSTALL OIL RESERVOIR

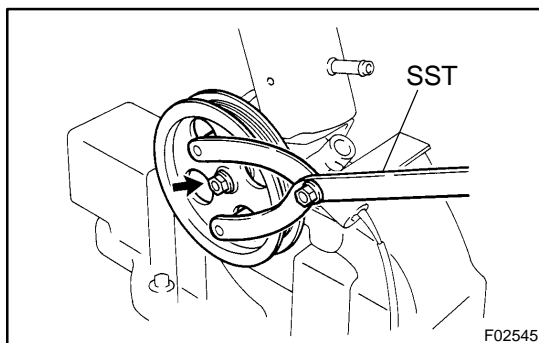
(a) Coat a new O-ring with power steering fluid and install it to the oil reservoir.

(b) Install the oil reservoir with 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 vane pump 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-23](#))