

## REASSEMBLY

### NOTICE:

When using a vise, do not overtighten it.

1. **COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page SR-31)**
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.

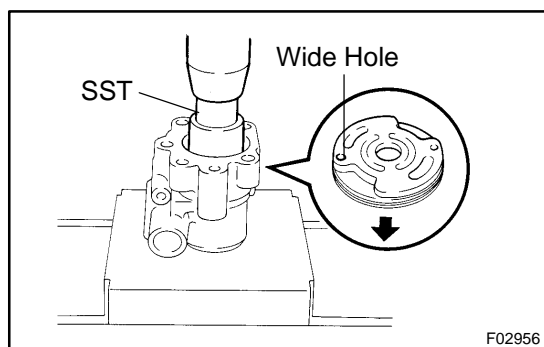
### 3. INSTALL SIDE FRONT PLATE

- (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 side front 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.

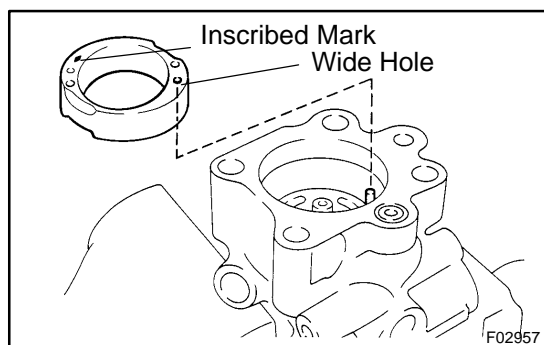
### HINT:

Align the wide hole of the side front 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.

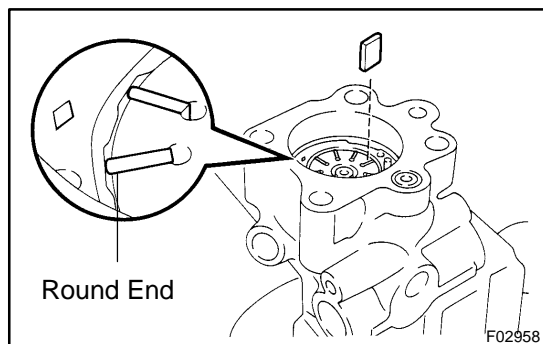


### 4. INSTALL CAM RING

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

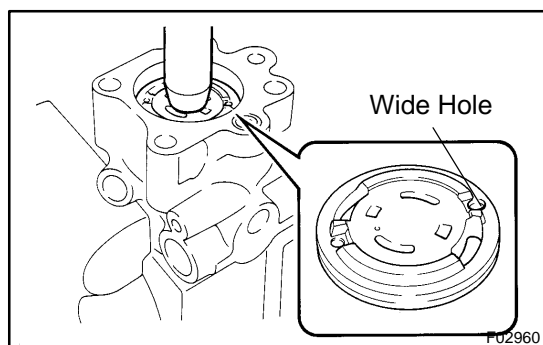
### 5. INSTALL VANE PUMP ROTOR

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

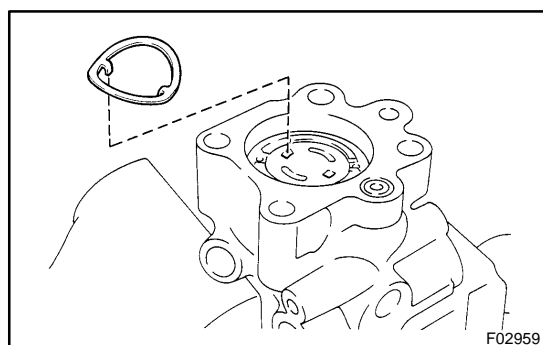
- Coat a new O-ring with power steering fluid and install it to the side rear plate.
- Using a press, press in the side rear plate.

### 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.

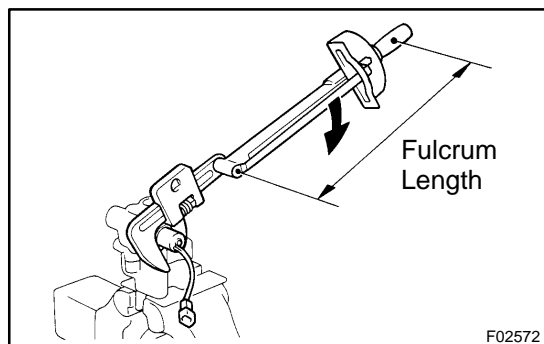
**Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)**

## 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-31](#)).

**12. 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.).

**13. INSTALL SUCTION PORT UNION**

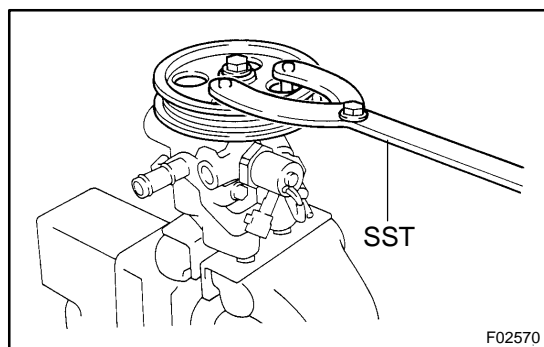
- (a) Coat a new O-ring with power steering fluid and install it to the suction port union.
- (b) Install the suction port union to the vane pump assembly with the 2 bolts.

**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-34](#))