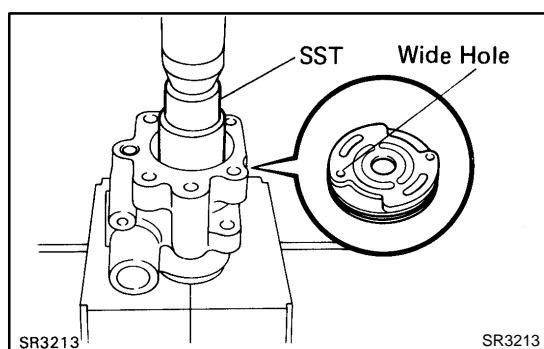


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. **COAT WITH POWER STEERING FLUID**
(See page [SR-43](#))
2. **INSTALL VANE PUMP SHAFT WITH BEARING**
 - (a) Using SST, press in the pump shaft with the bearing to the front housing.
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.
 - (b) Coat 2 new O-rings with power steering fluid and install them to the side front plate.



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

NOTICE:

- Be careful not to damage the O-ring.
- Make sure to install the side front plate facing the correct direction.

HINT:

Align the wide hole on the side front plate with the longer straight pin.

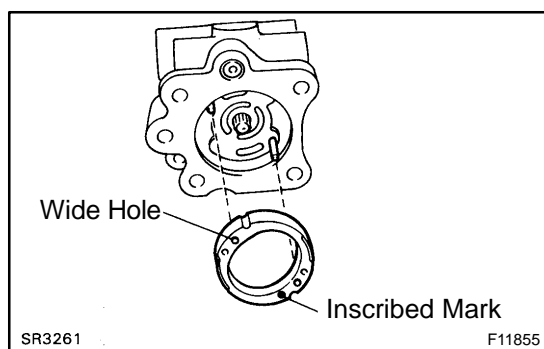
- (d) Install a new shorter straight pin to the plate.

4. INSTALL CAM RING

Match the wide hole of the cam ring with the longer straight pin, and install the cam ring.

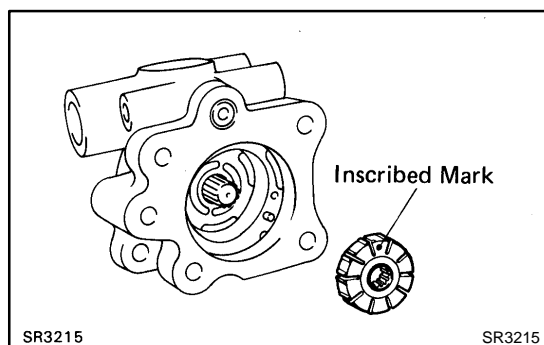
HINT:

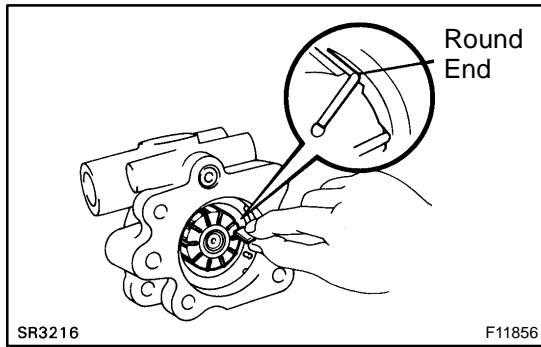
Install the cam ring with the inscribed mark facing the rear.



5. INSTALL VANE PUMP ROTOR

Install the rotor with the inscribed mark facing outward.



**6. INSTALL 10 VANE PLATES**

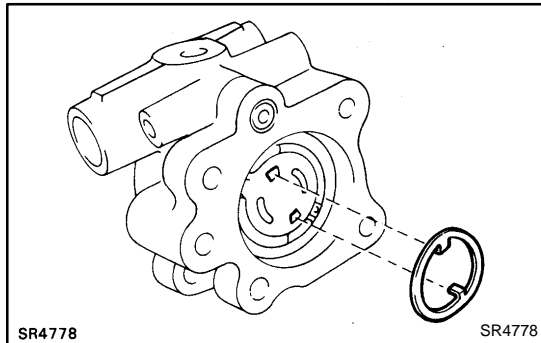
Install the vane plates with the round end facing outward.

7. INSTALL SIDE REAR PLATE

- Coat a new O-ring with power steering fluid and install it to the plate.
- Align the wide hole with the longer straight pin and install the side rear plate.

NOTICE:

Be careful not to damage the O-ring.

**8. INSTALL WAVE WASHER**

Install the 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 bracket.
- Torque 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, FLOW CONTROL VALVE AND PRESSURE PORT UNION

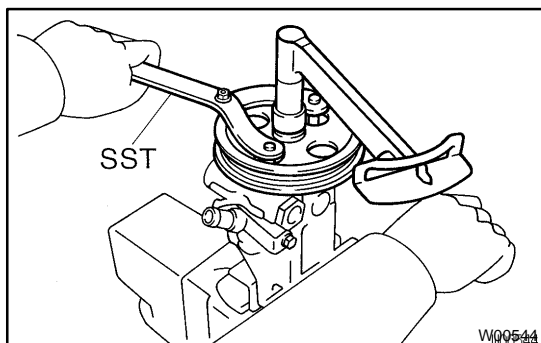
- Coat a new O-ring with power steering fluid and install it to the union.
- Install the valve facing the correct direction.
(See page [SR-43](#))
- Torque the union.

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

12. INSTALL SUCTION PORT UNION

- Coat a new O-ring with power steering fluid and install it to the union.
- Torque the 2 bolts.

Torque: 13 N·m (130 kgf-cm, 9 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-46](#))