

## REASSEMBLY

### NOTICE:

When using a vise, do not overtighten it.

1. **COAT WITH POWER STEERING FLUID**  
(See page [SR-33](#))
2. **INSTALL VANE PUMP SHAFT WITH BEARING**
  - (a) Wind vinyl tape on the serrated part of the shaft.
  - (b) Using SST, press in the shaft with the bearing to the front housing.  
SST 09608-04031

### NOTICE:

Be careful not to damage the oil seal.

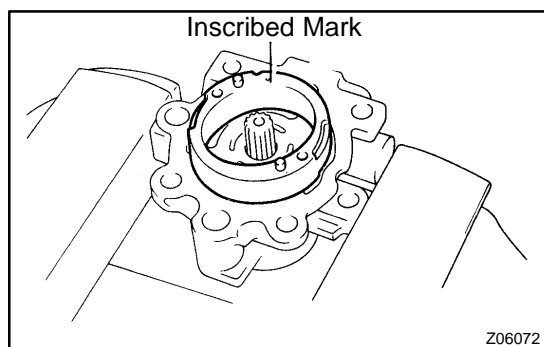
- (c) Using snap ring pliers, install a new snap ring to the front housing.

### 3. INSTALL STRAIGHT PINS

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

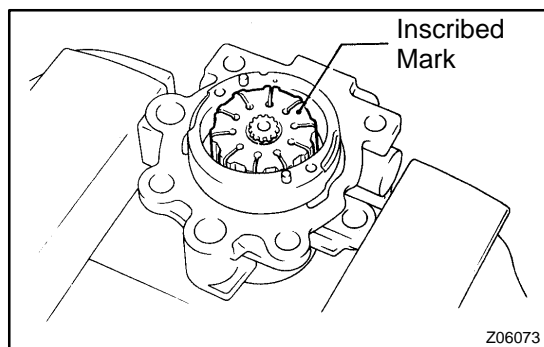
### NOTICE:

Be careful not to damage the pins.



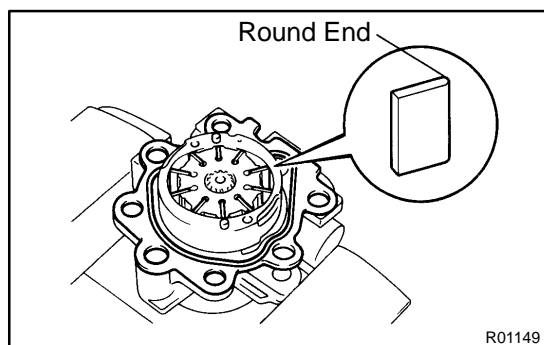
### 4. INSTALL CAM RING

Align the holes of the ring and straight pins, and install the ring with the inscribed mark facing outward.



### 5. INSTALL VANE PUMP ROTOR

Install the rotor with the inscribed mark facing outward.



### 6. INSTALL 10 VANE PLATES

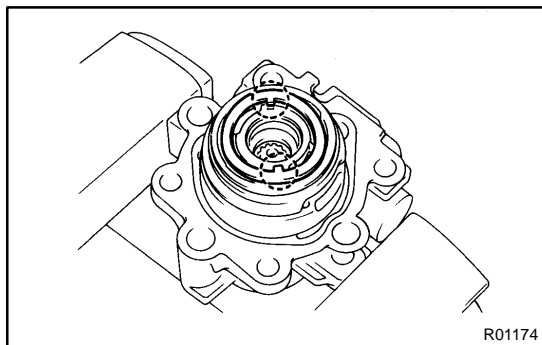
Install the vane plates with the round end facing outward.

### 7. INSTALL GASKET

Install a new gasket to the front housing.

### 8. INSTALL SIDE PLATE

Align the holes of the plate and straight pins.

**9. INSTALL WAVE WASHER**

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

**10. INSTALL REAR HOUSING**

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

- (b) Torque the 2 bolts.

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

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

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

- (b) Install the valve facing the correct direction.

(See page [SR-33](#))

- (c) Torque the union.

**Torque: 83 N·m (850 kgf·cm, 61 ft·lbf)**

**12. INSTALL OIL RESERVOIR**

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

- (b) Torque 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**

(See page [SR-51](#))

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

(See page [SR-46](#))