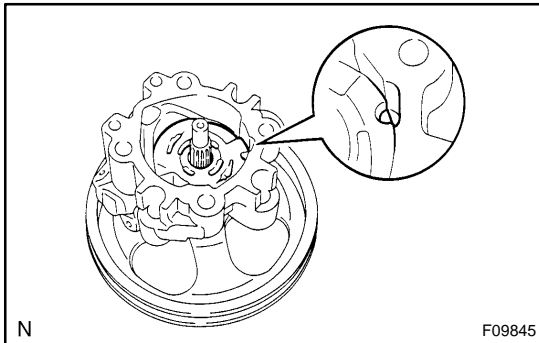


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page SR-22)
2. INSTALL VANE PUMP SHAFT WITH VANE PUMP PULLEY

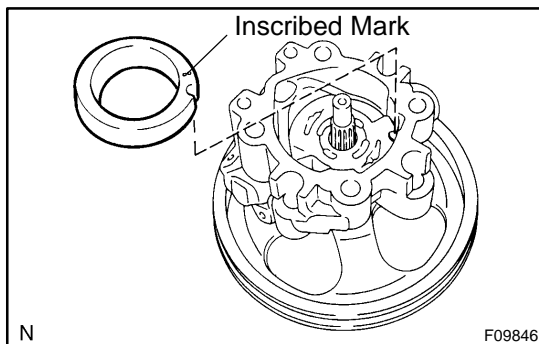


3. INSTALL SIDE PLATE

- (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.

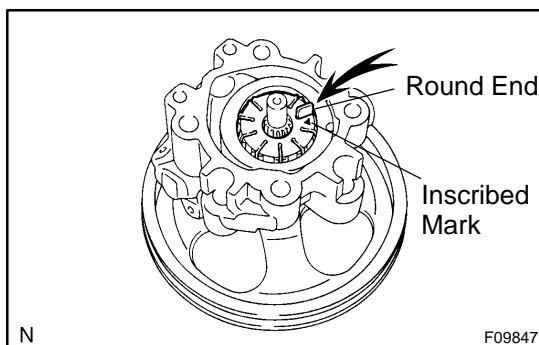
NOTICE:

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 OIL PRESSURE SENSOR

- (a) Coat a new O-ring with power steering fluid, and install it to the oil pressure sensor.
- (b) Install the oil pressure sensor.

Torque: 21 N·m (210 kgf·cm, 15 ft·lbf)

9. INSTALL SPRING, FLOW CONTROL VALVE AND PRESSURE PORT UNION

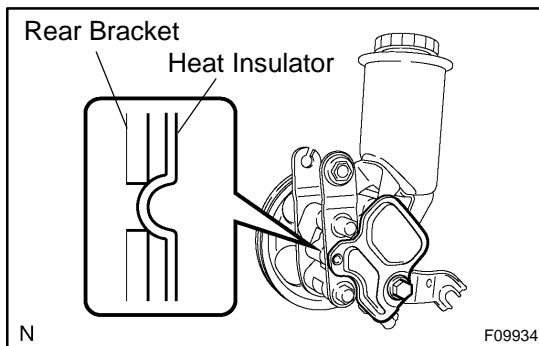
- (a) Install the spring.
- (b) Install the flow control valve facing in the correct direction (See page [SR-22](#)).
- (c) Coat a new O-ring with power steering fluid, and install it to the pressure port union.
- (d) Install the pressure port union.

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

10. INSTALL FRONT AND REAR BRACKETS

Install the front and rear brackets with the 2 bolts.

Torque: 44 N·m (440 kgf·cm, 32 ft·lbf)

**11. INSTALL HEAT INSULATOR AND REAR STAY**

Install the heat insulator and rear stay with the bolt.

Torque: 44 N·m (440 kgf·cm, 32 ft·lbf)

NOTICE:

Install the heat insulator, pressing its projection into a hole in the rear bracket, as shown in the illustration.

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: 9.0 N·m (90 kgf·cm, 78 in.-lbf)

13. MEASURE PS VANE PUMP ROTATING TORQUE (See page [SR-25](#))