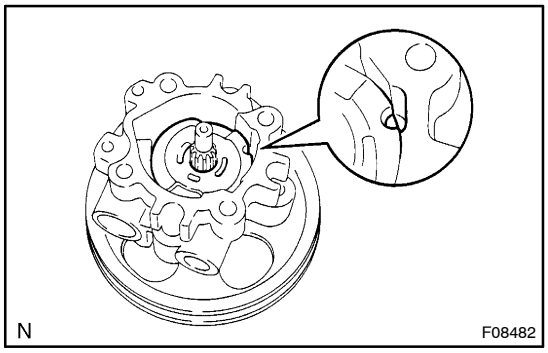
SR0VV–02

REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. **COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID (See page SR–23)**
2. **INSTALL VANE PUMP SHAFT WITH VANE PUMP PULLEY**



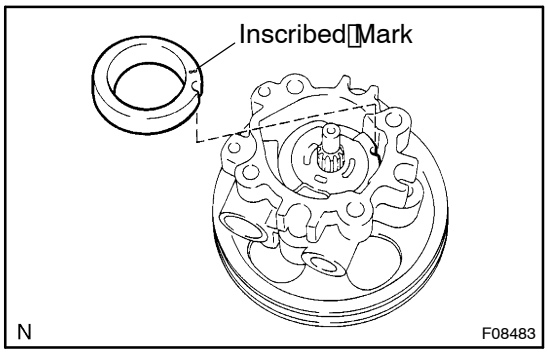
3. **INSTALL SIDE PLATE**

(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.

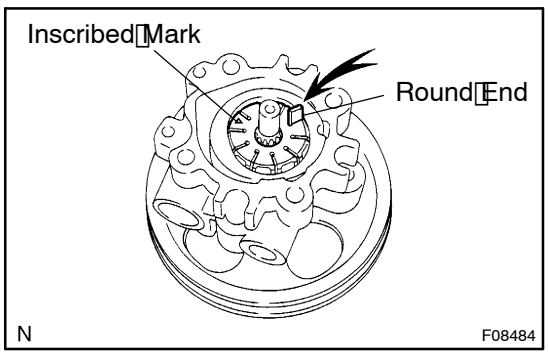
NOTICE:

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)

(c) Install the rear bracket with the bolt.

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

8. **INSTALL OIL PRESSURE SWITCH**

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–23).

(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 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 with the bolt.

Torque: 12 N·m (120 kgf·cm, 9 ft·lbf)

11. MEASURE PS VANE PUMP ROTATING TORQUE (See page SR–26)