

REASSEMBLY

1. INSTALL VANE PUMP HOUSING OIL SEAL

- Coat the lip of a new housing oil seal with power steering fluid.
- Using SST and a press, press in the new housing oil seal.

SST 09950-60010 (09951-00280), 09950-70010 (09951-07100)

NOTICE:

Make sure that the oil seal is installed correctly.

2. INSTALL SHAFT SUB-ASSEMBLY WITH PULLEY

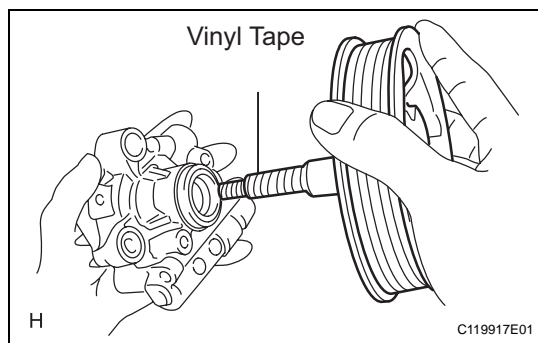
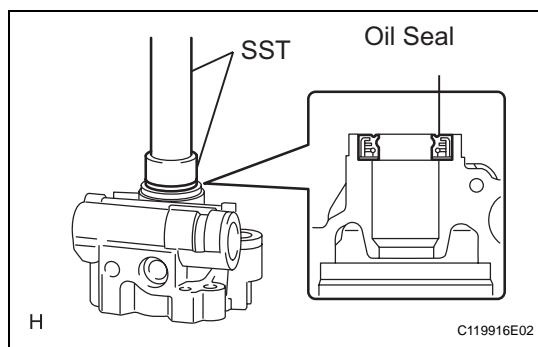
- Coat the inside bushing surface of the front housing with power steering fluid.
- Gradually insert the shaft with pulley.

NOTICE:

Be careful not to damage the lip of the oil seal.

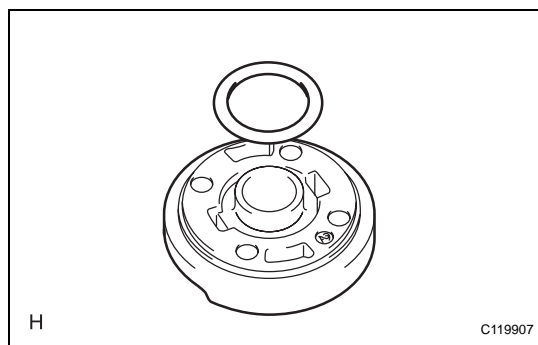
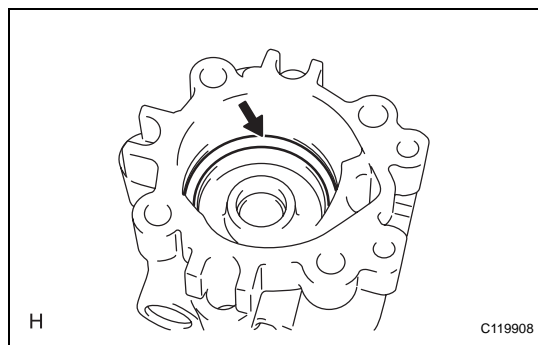
HINT:

Wrap the shaft with vinyl tape before inserting.

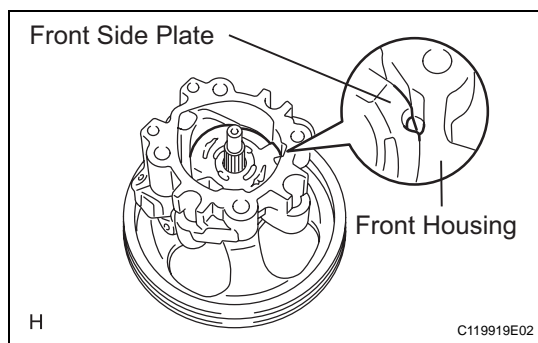


3. INSTALL FRONT VANE PUMP SIDE PLATE

- Coat a new O-ring with power steering fluid and install it to the front housing.



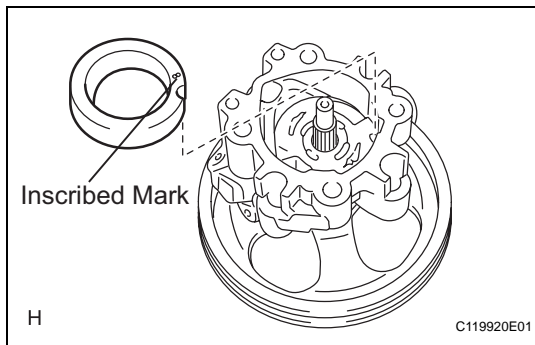
- Coat a new O-ring with power steering fluid and install it to the front side plate.



- Align the dent of the front side plate with that of the front housing and install them.

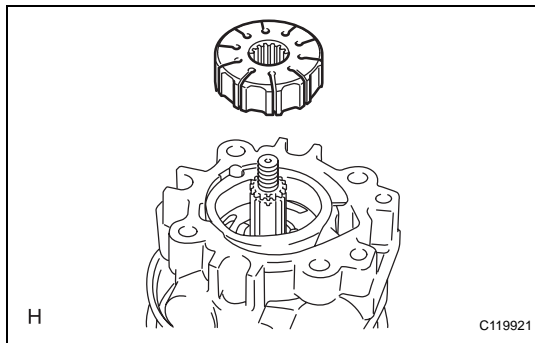
NOTICE:

Make sure that the front side plate is installed correctly.



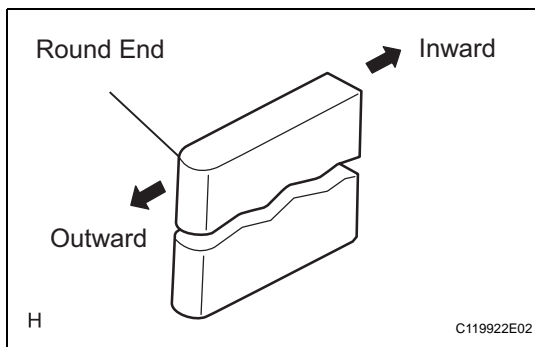
4. INSTALL VANE PUMP CAM RING

- (a) Align the dent of the cam ring with that of the front side plate, and install the cam ring with the inscribed mark facing upward.

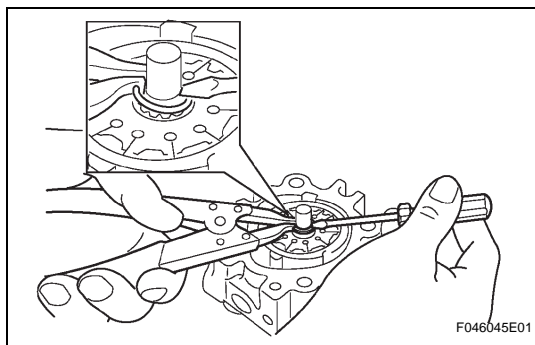


5. INSTALL VANE PUMP ROTOR

- (a) Install the vane pump rotor.

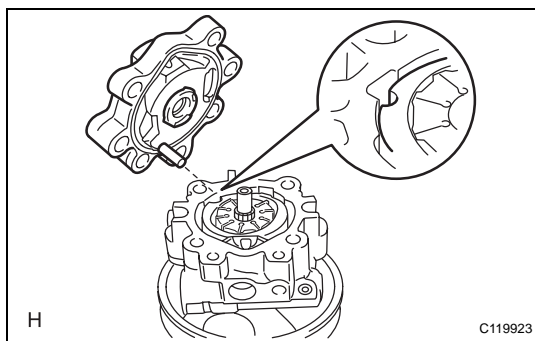


- (b) Apply power steering fluid to the 10 vane pump plates.
- (c) Install the vane pump plates with the round end facing outward.



6. INSTALL VANE PUMP SHAFT SNAP RING

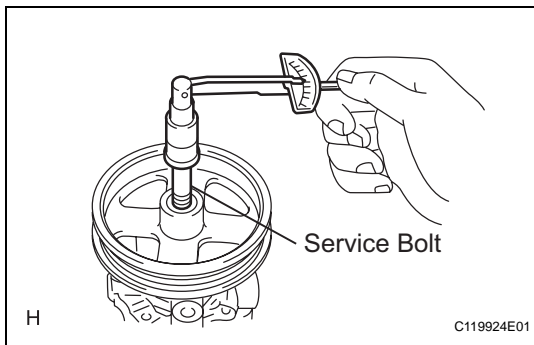
- (a) Using a screwdriver and snap ring expander, install a new snap ring to the shaft.



7. INSTALL REAR VANE PUMP HOUSING

- (a) Apply power steering fluid to a new O-ring and install it to the rear housing.
- (b) Align the straight pin of the rear housing with the dents of the cam ring, the front side plate and the front housing, and install the rear housing with the 4 bolts.

Torque: 22 N*m (224 kgf*cm, 16 ft.*lbf)



8. INSPECT PRELOAD

- (a) Check that the pump rotates smoothly without abnormal noise.
- (b) Temporarily install the service bolt.

Recommended service bolt:

Thread diameter:

10 mm (0.39 in.)

Thread pitch:

1.25 mm (0.0492 in.)

Bolt length:

50 mm (1.97 in.)

- (c) Using a torque wrench, check the pump rotating torque.

Standard rotating torque:

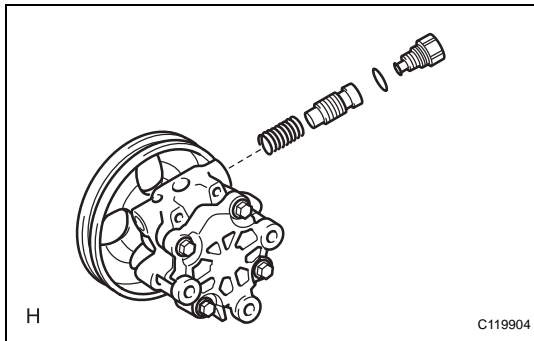
0.27 N*m (2.8 kgf*cm, 2.4 in.*lbf) or less

If the rotating torque is not as specified, check the installation of the housing oil seal.

9. INSTALL POWER STEERING OIL PRESSURE SENSOR

- (a) Apply power steering fluid to a new O-ring and install it to the oil pressure sensor.
- (b) Install the oil pressure sensor to the front housing.

Torque: 21 N*m (214 kgf*cm, 15 ft.*lbf)



10. INSTALL FLOW CONTROL VALVE

- (a) Apply power steering fluid to the compression spring and flow control valve.
- (b) Install the compression spring and the flow control valve.
- (c) Apply power steering fluid to a new O-ring and install it to the pressure port union.
- (d) Install the pressure port union.

Torque: 69 N*m (704 kgf*cm, 51 ft.*lbf)

11. INSTALL FRONT PUMP BRACKET

- (a) Install the front bracket and rear bracket with the 2 bolts.

12. INSTALL VANE PUMP OIL RESERVOIR ASSEMBLY

- (a) Apply power steering fluid to a new O-ring and install it to the oil reservoir.
- (b) Install the oil reservoir to the front housing with the 3 bolts.

Torque: 9.0 N*m (92 kgf*cm, 80 in.*lbf)

13. INSTALL VANE PUMP OIL RESERVOIR CAP SUB-ASSEMBLY