

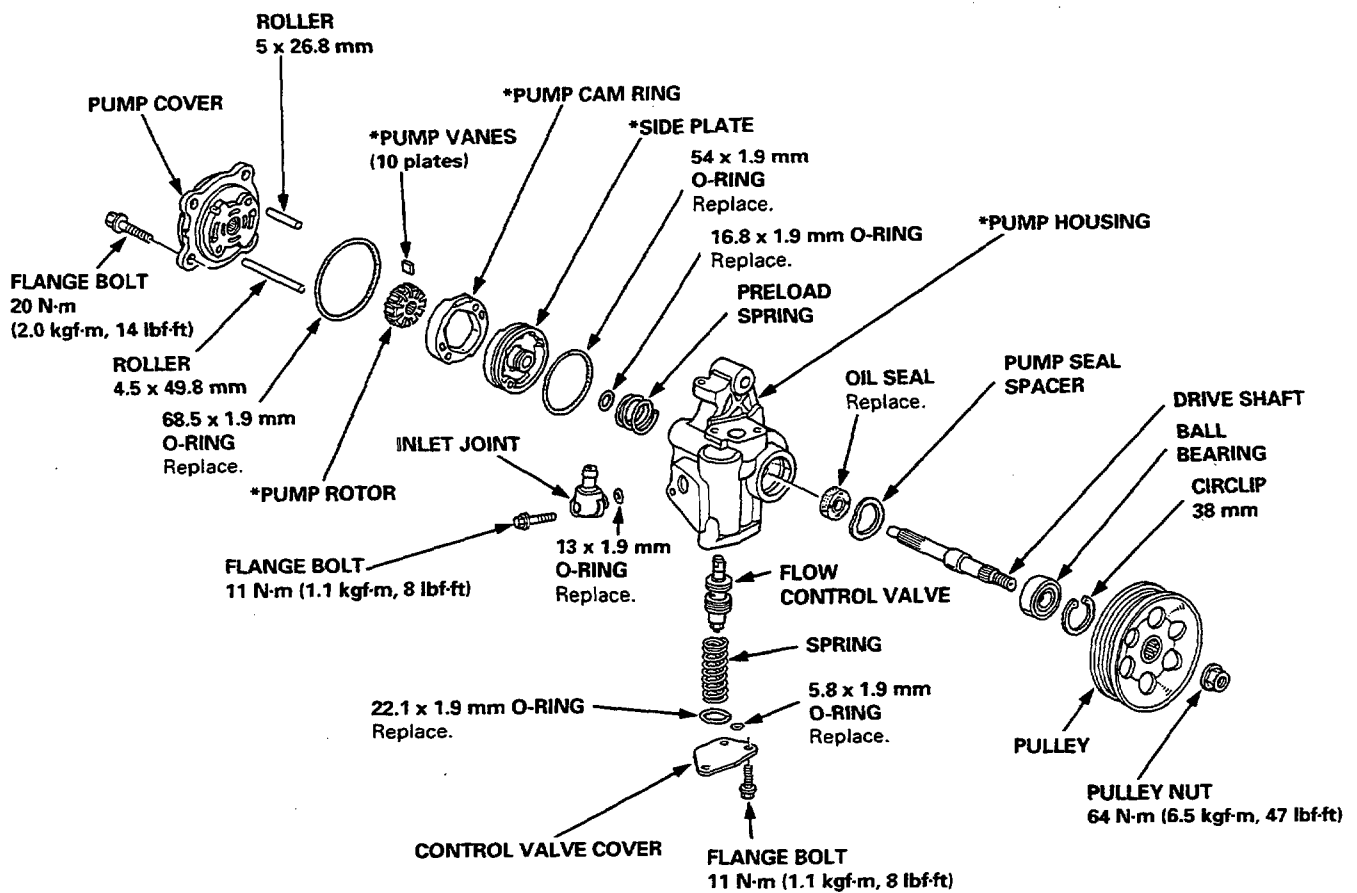
# Power Steering Pump

## Reassembly

**CAUTION:** The power steering components are made of aluminum. Avoid damaging the components during assembly.

**NOTE:**

- Clean the disassembled parts with a solvent and dry them with compressed air. Do not dip the rubber parts in a solvent.
- Always replace the O-rings and rubber seals with new ones before assembly.
- Apply recommended power steering fluid or steering grease (Honda P/N: 08733 - B070E) to the parts indicated in the assembly procedures.
- Do not allow dust, dirt, or other foreign materials to enter the power steering system.
- Replace the pump as an assembly if the parts indicated with asterisk (\*) are worn or damaged.





## Pump Rotor Installation

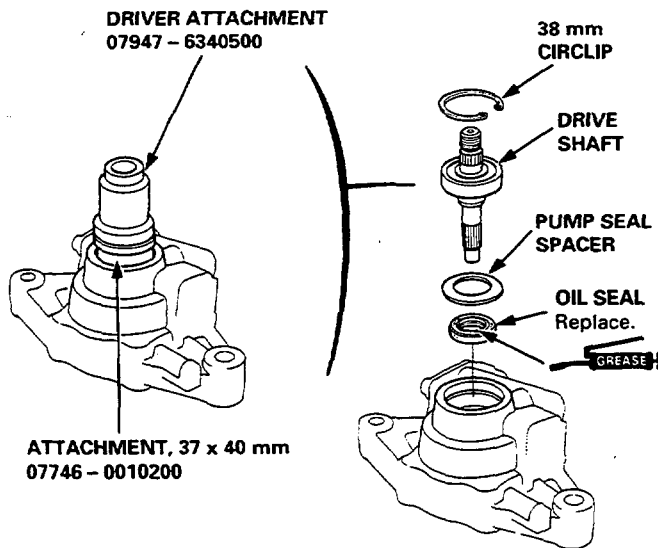
1. Coat the lip of the new oil seal with steering grease (Honda P/N 08733 - B070E).

2. Install the new oil seal in the pump housing by hand, then install the pump seal spacer.

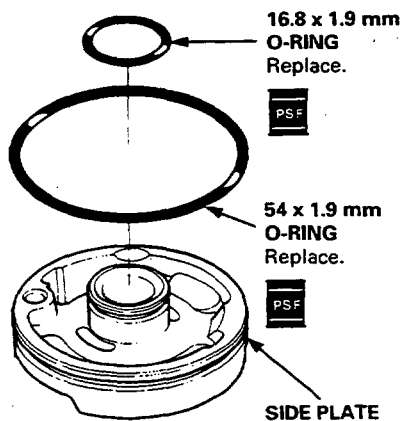
NOTE: Insert the oil seal with its grooved side facing in.

3. Install the pump drive shaft assembly with the special tool.

4. Install the 38 mm circlip with its tapered side facing out.



5. Coat the side plate grooves with the recommended power steering fluid, then position the 16.8 x 1.9 mm and 54 x 1.9 mm O-rings on the side plate.

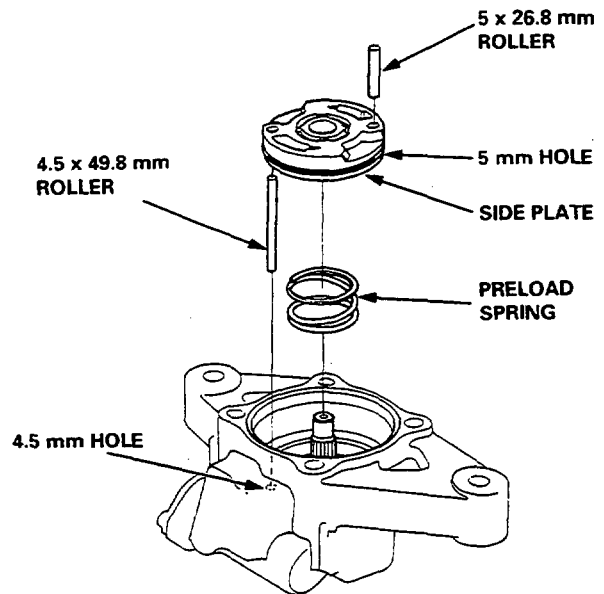


6. Install the preload spring in the pump housing.

7. Set the 4.5 x 49.8 mm roller in the 4.5 mm hole in the pump housing.

8. Set the side plate over the roller and install it on the pump housing.

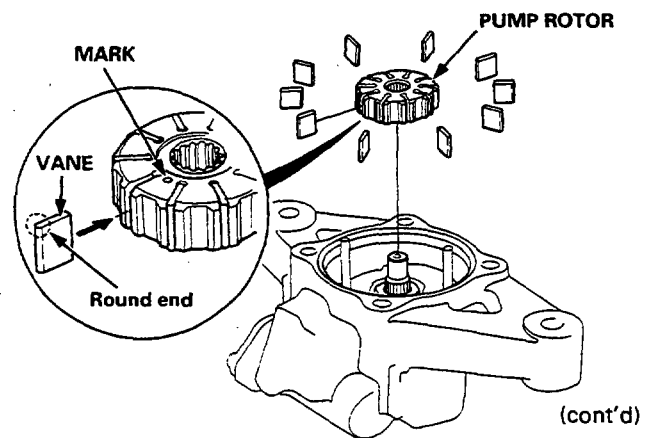
9. Set the 5 x 26.8 mm roller in the 5 mm hole in the side plate.



10. Assemble pump rotor to the drive shaft with the "o" mark on the rotor facing upward.

11. Set the 10 vanes in the grooves in the rotor.

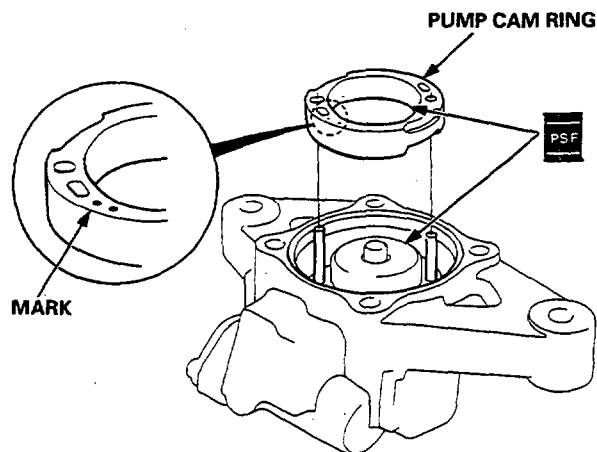
NOTE: Be sure that the round ends of the vanes are in contact with the sliding surface of the cam ring.



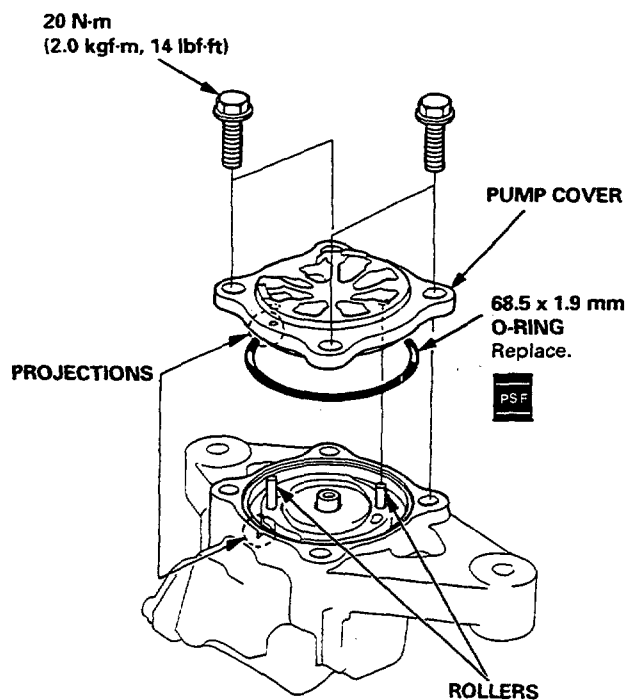
# Power Steering Pump

## Reassembly (cont'd)

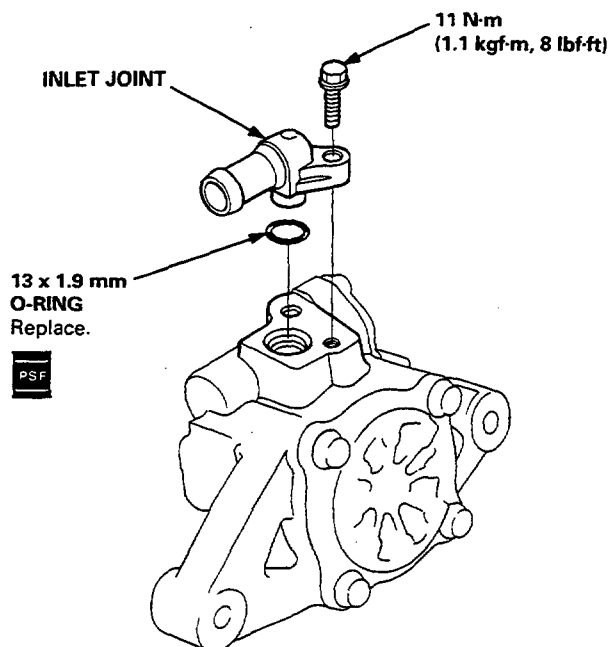
12. Set the pump cam ring over the two rollers with the "0" mark on the cam ring upward.
13. Apply clean power steering fluid to the vanes and cam ring.



14. Install the 68.5 x 1.9 mm O-ring on the pump cover.
15. Align the roller set holes in the pump cover with the rollers.
16. Align the projection on the pump housing and the projection on the pump cover, and tighten the four bolts.



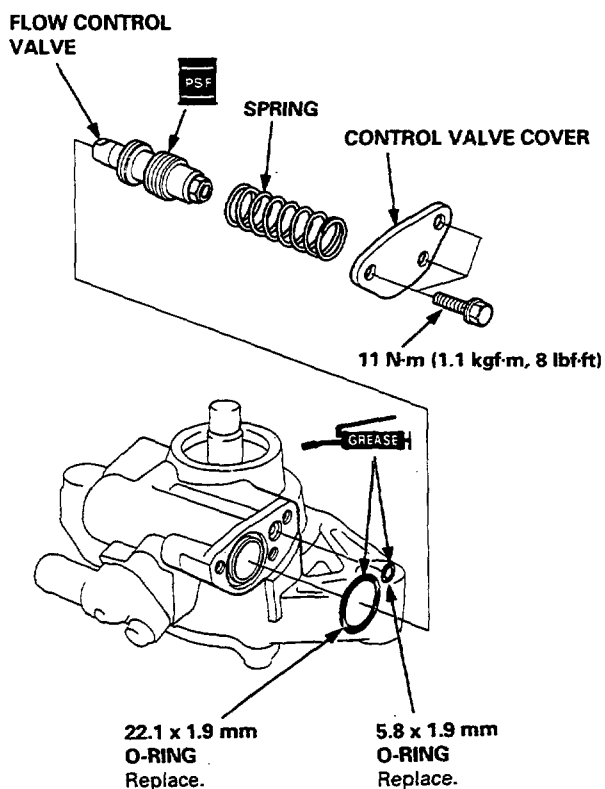
17. Set the 13 x 1.9 mm O-ring on the inlet joint.
18. Install the inlet joint on the pump housing.





## Flow Control Valve Installation

1. Apply steering grease (Honda P/N 08733 - B070E) to new O-rings.
2. Coat the flow control valve with clean power steering fluid.
3. Install the flow control valve, spring and control valve cover on the pump housing.
4. Tighten the three control cover bolts.

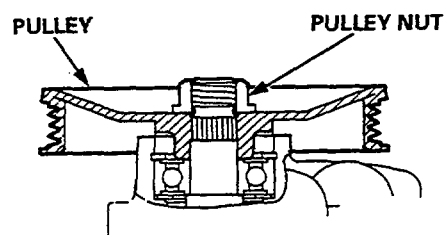


## Pulley Installation

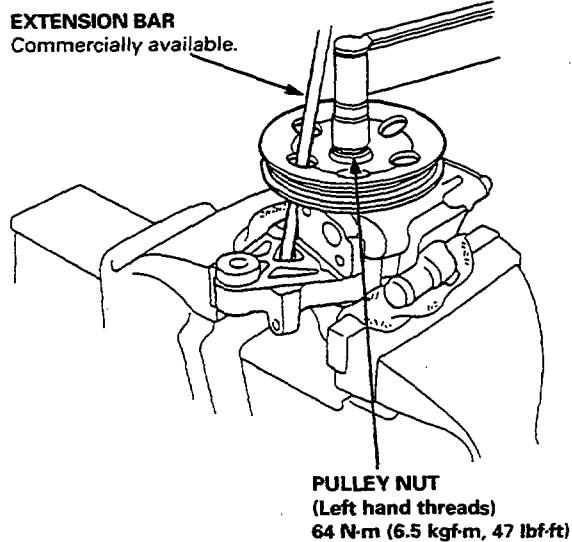
1. Hold the steering pump in a vise with soft jaws.

**CAUTION:** Be careful not to damage the pump housing with the jaws of the vise.

2. Install the pump pulley as shown, then install the pulley nut.



3. Hold the pulley with an extension bar and tighten the pulley nut.



4. Check that the pump turns smoothly by turning the pulley.