

**Fig. 10—Installing Thrust Plate**

lock ring making sure ring is seated in groove (Fig. 11).

(6) Install two dowel pins in holes in pump cavity. Carefully insert drive shaft, rotor and thrust plate assembly in pump cavity indexing locating holes with dowel pins (Fig. 12).

(7) Slide cam ring over rotor on dowel pins with arrow on ring facing "UP" (Fig. 13).

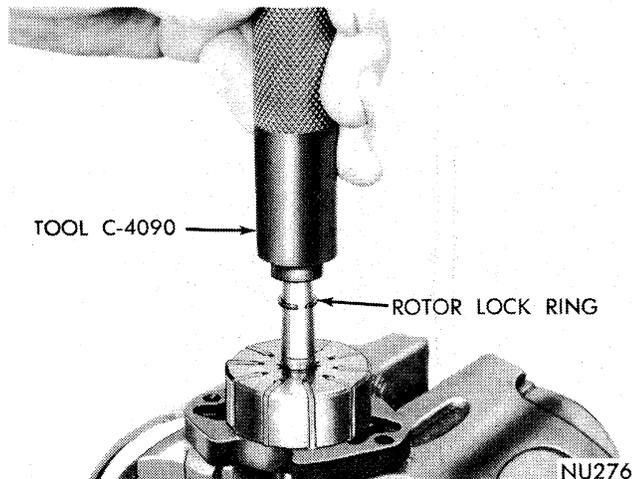
(8) Install ten vanes in rotor slots with radius edge facing out towards cam ring inner surface (Fig. 14). **CAUTION: Vanes installed with flat edge out will result in noisy pump operation.**

(9) Position pressure plate on dowel pins. Place a 1-1/4 inch socket in groove of pressure plate and seat entire assembly on "O" ring in pump cavity by pressing down on socket with both thumbs (Fig. 15).

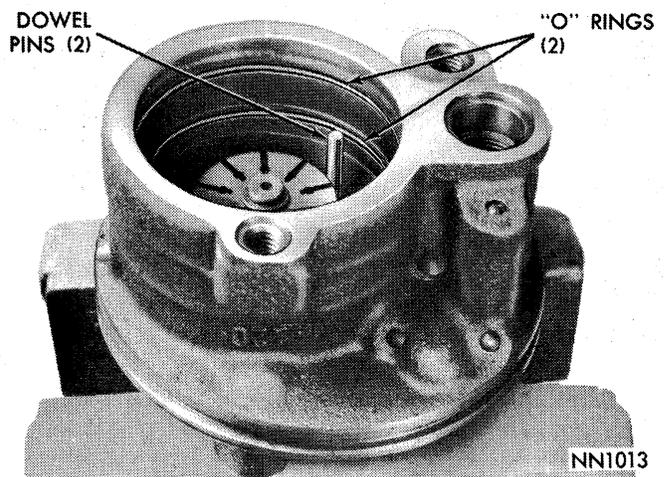
(10) Place spring in groove in pressure plate and position end cover lip edge UP over spring.

(11) Press end cover down below retaining ring groove with thumb and install ring making sure it is seated in groove (Fig. 16).

This operation can be performed in an arbor press



**Fig. 11—Installing Rotor Lock Ring**



**Fig. 12—Rotor and Thrust Plate Installed**

if available. Care should be exerted to prevent cocking the end cover in the bore or distorting the assembly.

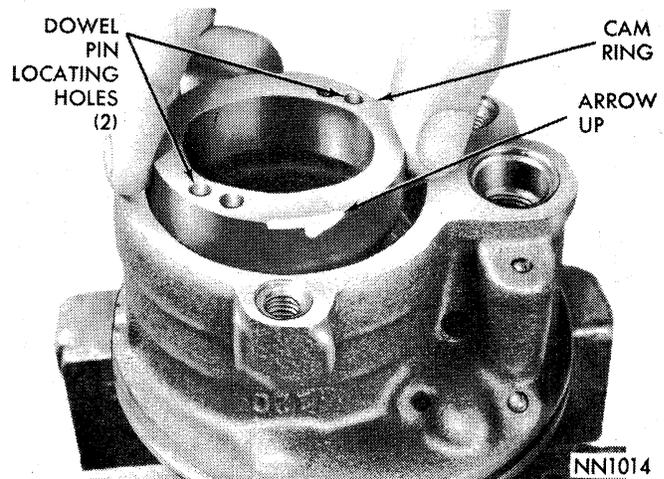
(12) Using a punch, tap retainer ring ends around in the groove until opening is opposite flow control valve bore. This is important for maximum retention of the retainer ring (Fig. 16).

(13) Replace reservoir "O" ring seal, two mounting stud "O" ring seals and flow control valve "O" ring seal on pump body, lubricate with power steering fluid and carefully position reservoir on pump body. Visually align the mounting stud holes until studs can be started in threads.

(14) Using a plastic hammer, tap reservoir down on pump and insert flow control valve spring and valve (Hexagon plug down). Lubricate with power steering fluid (Fig. 17).

(15) Replace "O" ring on pressure hose fitting and **CAUTION: Be sure "O" ring is installed on upper groove. It is possible to install "O" ring in lower groove. This would restrict relief outlet orifice.**

(16) Install pressure hose fitting and tighten



**Fig. 13—Installing Cam Ring**