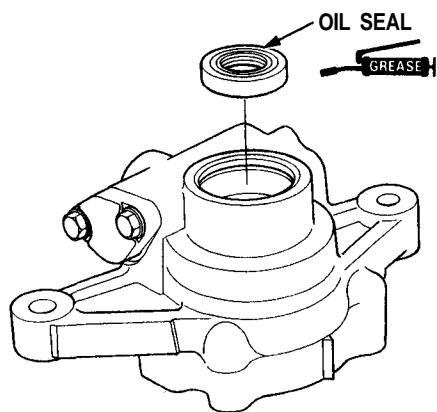


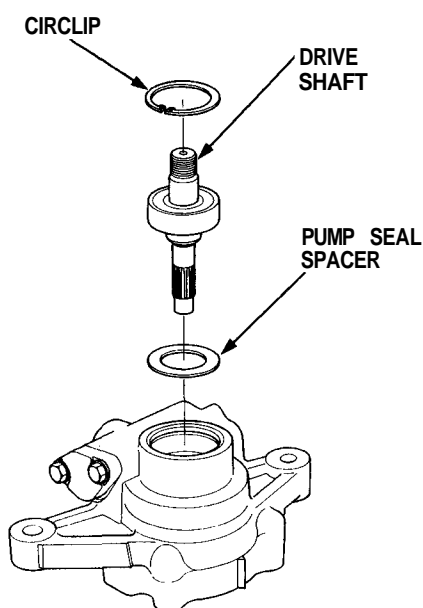
# Steering Pump

## Pump Assembly

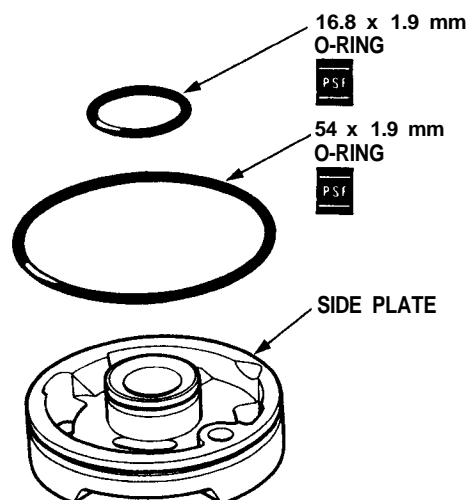
1. Coat the lip of the new oil seal with steering grease (Honda P/N 08733-B070E).
2. Install the new oil seal in the pump housing by hand.



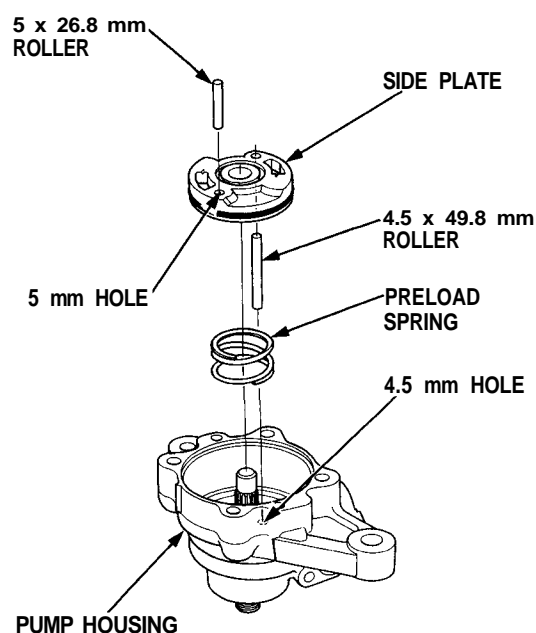
3. Install the pump seal spacer, then install the drive shaft assembly.
4. Install the circlip with its tapered side facing out.



6. Coat the side plate grooves with power steering fluid, then position the 16.8x1.9 mm and 54x1.9 mm O-rings on the side plate.



7. Install the preload spring in the pump housing.
8. Set the 4.5x49.8 mm roller in the 4.5 mm hole in the pump housing.
9. Set the side plate over the roller and install it on the pump housing.
10. Set the 5x26.8 mm roller in the 5 mm hole in the side plate.

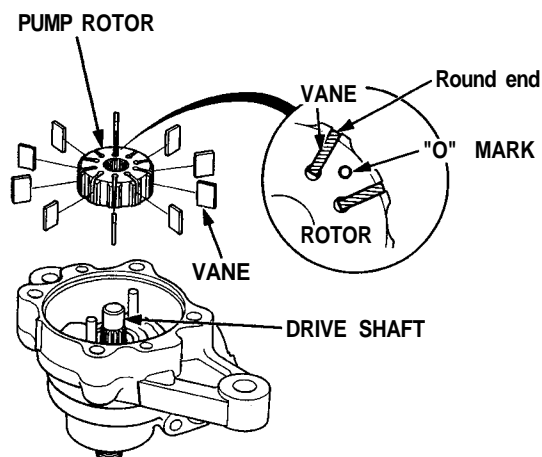




11. Assemble pump rotor to the drive shaft with the "O" mark on the rotor facing upward.

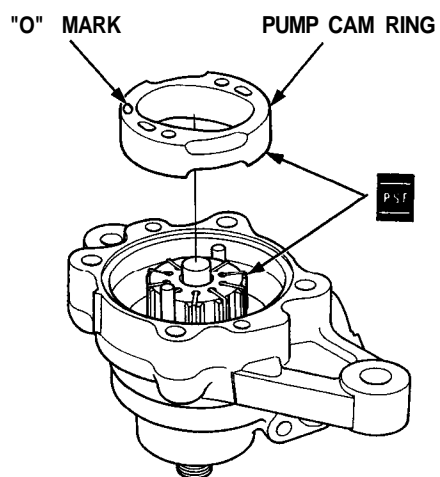
12. Set the 10 vanes in each groove in the rotor.

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

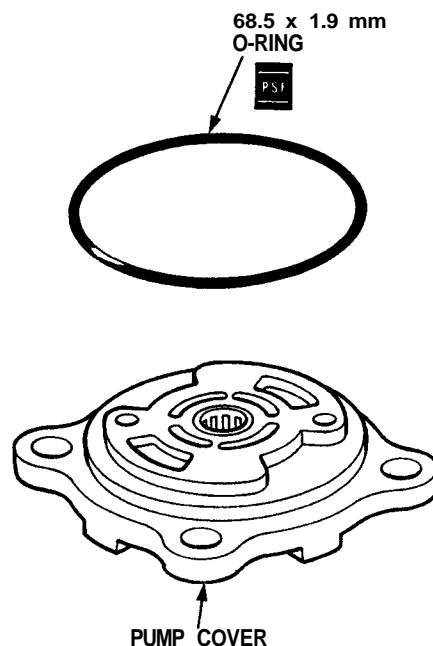


13. Set the pump cam ring over the two rollers with the "O" mark on the cam ring upward.

14. Apply clean power steering fluid to the pump vanes and pump cam ring.

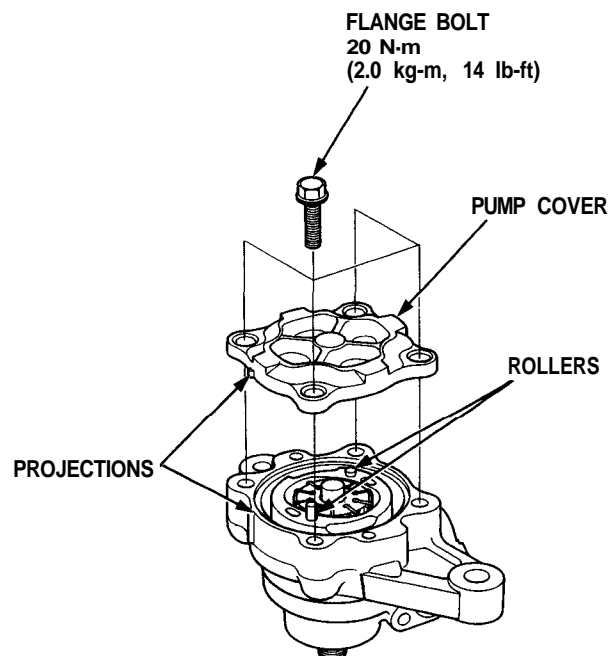


15. Install the 68.5 x 1.9 mm O-ring on the pump cover.



16. Align the roller set holes in the pump cover with the rollers.

17. Align the projection on the pump housing and the projection on the pump cover and tighten the four bolts.



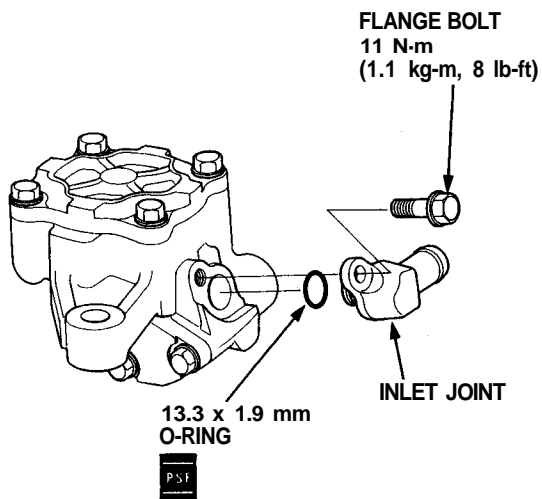
(cont'd)

# Steering Pump

## Pump Assembly (cont'd)

18. Set the 13.3 x 1.9 mm O-ring on the inlet joint.

19. Install the inlet joint on the pump housing.



20. Install the flow control valve (see page [17-34](#)).

21. Install the pulley (see page [17-32](#)) and check that the pump turns smoothly by turning the pulley.