



Assembly Instructions – 3 Piece Hose Ends

-20 AN Main Supply Hose

Note: Assembling -20 SAE three piece hose ends can be challenging. At a minimum you will need a soft jaw vice and a 1-3/4in wrench. Compressed Air Supercharging has a special tool (P/N WR-20AN) that greatly simplifys this task. This tool is strongly recommended to minimize your grief and maximize the appearance of your finished hose.

- 1) Layout hose (1H) along desired path between components (e.g. from Mechanical Regulator exit to Lock-off). Care should be taken to protect hose from contact with suspension components, high temperatures (exhaust system components) and potential damage from road debris.
- 2) Mark hose at desired length/cut location, remove hose from vehicle.
- 3) Wrap hose at desired cut postion with electrical tape and cut to length with a hacksaw.
- 4) Lubricate inside of hose with rubber lubricant such as Parker O-ring lube.

- 5) Slide Hose End Collar (2H) on to hose and seat fully. Hose should come up and bottom against face of female threads inside Collar.

- 6) Place Hose End Insert (3H) in bench vise soft jaws or in CAS WR-20AN.

- 7) Thread the Hose/Hose Collar assembly onto the Hose End Insert. After several turns the fitting will begin to “bite” into the hose and turning the Hose/Hose Collar will become difficult.
- 8) Continue tightening the Hose/Hose Collar until the gap between the face of the Collar and the face of the Insert is less than .030-in.
- 9) Remove hose assembly and repeat steps 4 through 8 on other end of hose.

Repeat steps 1) through 9) for any remaining hoses (Saftey Shut-off to EPR, or EPR to Ejector).