



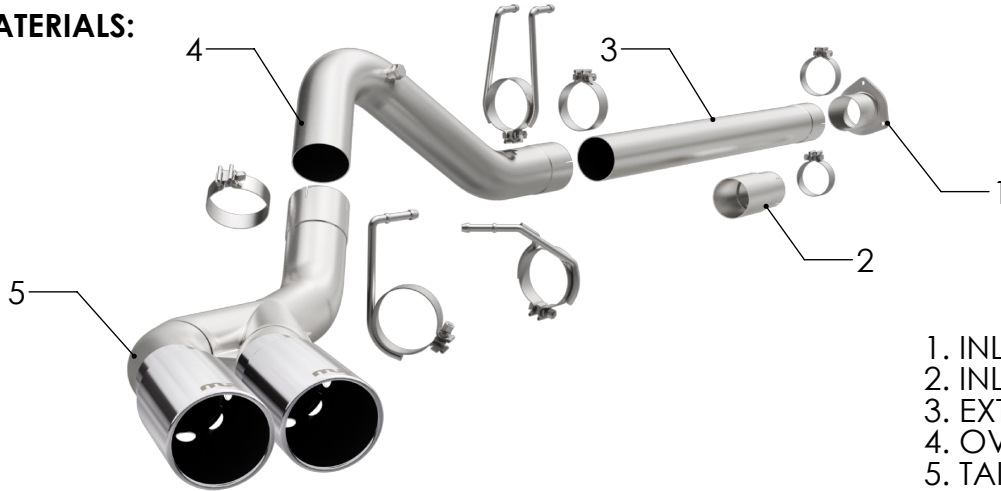
# INSTALLATION INSTRUCTIONS



FORD F-250/F-350 SUPER DUTY

PART NO. 17873

## BILL OF MATERIALS:



1. INLET ASSY - 6.7L
2. INLET PIPE - 6.4L
3. EXTENSION PIPE
4. OVER AXLE ASSY
5. TAIL PIPE ASSY



WEAR SAFETY GLASSES



READ INSTRUCTIONS THOROUGHLY BEFORE INSTALLING PRODUCT



SPRAY LUBRICANT

To ease removal of existing exhaust components (especially on older vehicles) spray penetrating lubricant on all fasteners and hangers/insulators that will be loosened or removed and let soak before disassembly.

## HARDWARE KIT:

1. [1] Hanger Assy #1
2. [1] Hanger Assy #2
3. [1] Hanger Assy #3
4. [4] 4.00" Clamp
5. [1] 3.50" Clamp

## MINIMUM REQUIRED TOOLS:



Saw (Or Other Cutting Tool)



15 mm



Hanger Tool (Or Pry Bar)

## MAGNAFLOW RECOMMENDS PROFESSIONAL INSTALLATION ON ALL THEIR PRODUCTS



**WARNING:** When working on, under, or around any vehicle exercise caution. Please allow the vehicle's exhaust system to cool before removal, as exhaust system temperatures may cause severe burns. If working without a lift always consult vehicle manual for correct lifting specifications. Always wear safety glasses and ensure a safe work area. Serious injury or death could occur if safety measures are not followed.

**ATTENTION:** Always install any supplied band or U-bolt clamps to the proper torque specifications of 40-45 ft-lb for band clamps and 30-35 ft-lb for U-bolt clamps. Over tightening will result in the clamps breaking and will NOT be warranted by MagnaFlow.

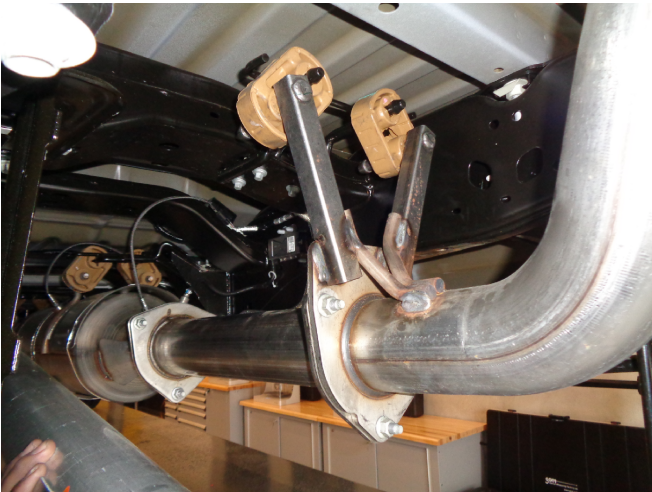
MAGNAFLOW: 1901 Corporate Centre Dr - Oceanside, CA 92056 | 1(800)990-0905

Technical Support: 1(800) 959-9226 | Email: moreinfo@magnaflow.com

# INSTALLATION INSTRUCTIONS



Step 1. Remove the OEM system by first detaching the O2 sensor from the over axle pipe (6.7L only).

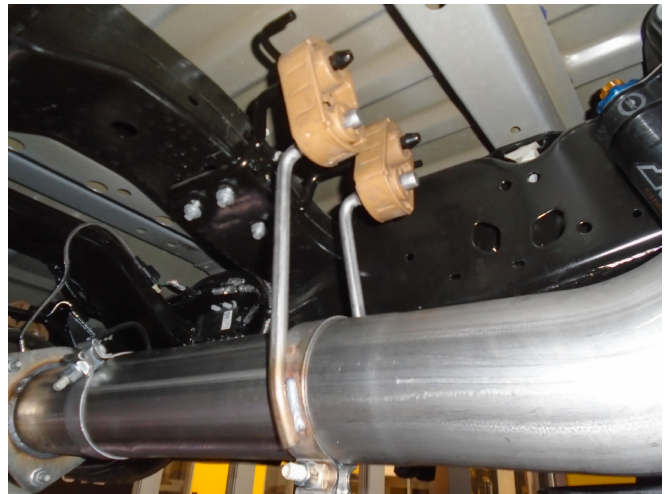


Step 2. Next, Unbolt the extension pipe assembly from the DPF outlet flange (6.7L) or loosen the band clamp attaching the inlet pipe (6.4L). Working front to rear disengage all welded hangers from the rubber insulators. Be sure to retain all mounting hardware as it will be needed to install your new MAGNAFLOW system.

2007.5 - 2010 6.4L		
W/BASE	CONFIG	EXTN. PIPE
172.4"	CC/LB	NO CUT
156.2"	CC/SB	CUT 26.3"
158.0"	EC/LB	CUT 28.1"
141.8"	EC/SB	CUT 11.9"
137.0"	SC/LB	CUT 7.1"

2011 - 2017 6.7L			
W/BASE	CONFIG	EXTN. PIPE	ADAPTER
176.0"	CC/LB	CUT 11.5"	NO CUT
159.8"	CC/SB	CUT 26.5"	NO CUT
164.2"	EC/LB	CUT 30.5"	NO CUT
148.0"	EC/SB	NOT USED	NO CUT
141.6"	SC/LB	NOT USED	CUT 3.5"

Step 3. Determine the overall length of the Inlet Pipe Assembly and the Extension Pipe, if required using the charts. The measurements are what needs to be cut from the outlet ends of the pipes. for new model years cut the extensions pipe as needed.



Step 4. Begin the installation by loosely attaching the Inlet Pipe Assembly to the OEM flange outlet using the OEM hardware (6.7L), or loosely attaching the Inlet Adapter to the DPF outlet using the supplied clamp (6.4L). Loosely attach the Extension Pipe, if needed, using the supplied clamp.

## INSTALLATION INSTRUCTIONS



Step 5. Loosely slip Hanger Clamp Assy #1 over the inlet end of the Over Axle Pipe Assembly and locate the hangers to the rubber insulators. Loosely install the Over Axle Pipe Assembly using the supplied clamp.



Step 6. To install the Tail Pipe Assembly loosely slip the Hanger Clamp Assembly over the pipe inlet. #2 for model years up to 2017, #3 for model years 2017 and up. Loosely secure using the supplied clamp and engaging the welded hanger to the rubber insulator.



Step 7. For 6.7L models remove the O2 sensor plug from the Over Axle Pipe and attach the O2 sensor.



Step 8. Once a final position has been chosen for the new exhaust system, evenly tighten all clamps from front to rear using the torque specifications on page one of the instructions. Inspect all fasteners after 25-50 miles of operation and re-tighten if necessary.