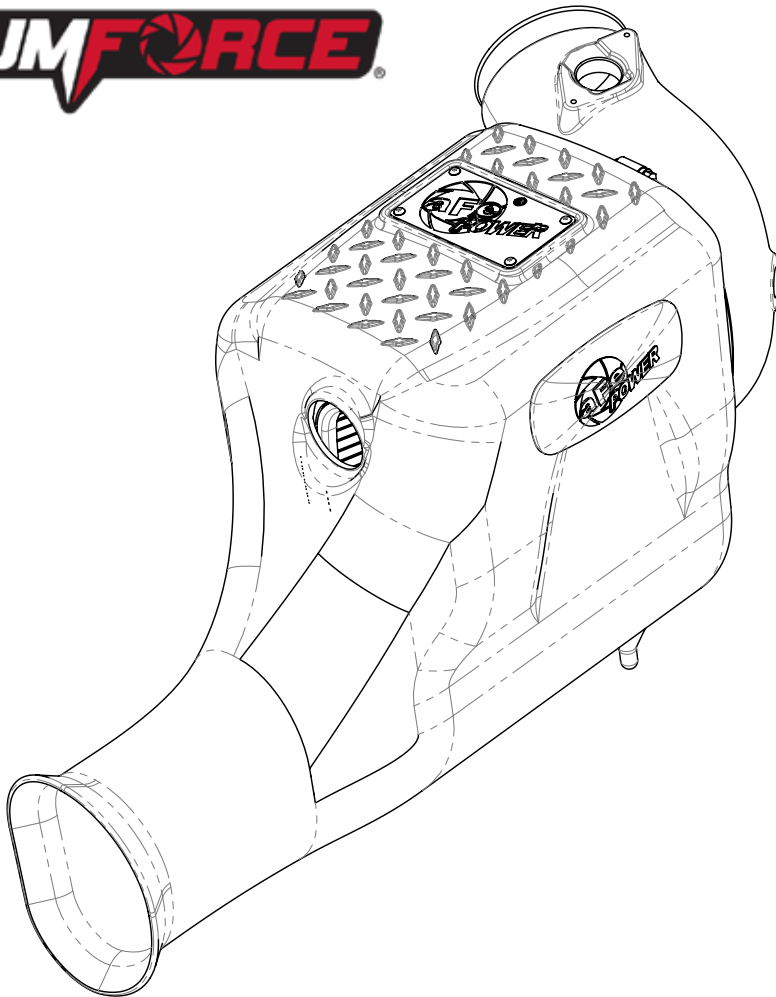


**MAGNUM FORCE**



**advanced FLOW engineering** Magnum FORCE Stage-2 Si Intake System

**Instruction Manual** P/N: 54-81022-1

Make: **Ford** Model: **F-250/F-350/F-450/F-550** Year: **2003-2007** Engine: **V8-6.0L (td)**



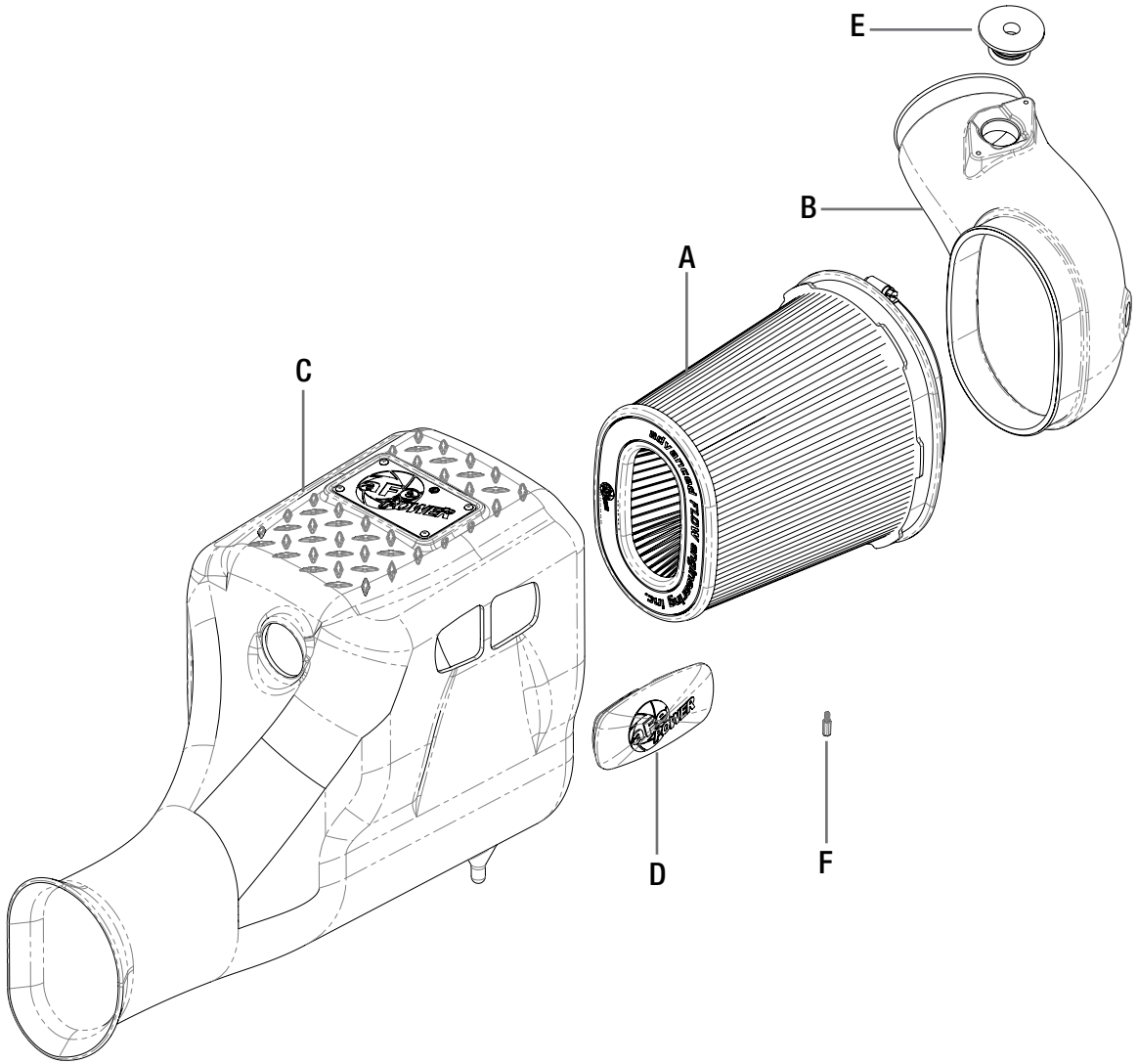
- Please read the entire instruction manual before proceeding.
- Ensure all components listed are present.
- Ensure you have all necessary tools before proceeding.
- Do not attempt to work on your vehicle when the engine is hot.
- Disconnect the negative battery terminal before proceeding.
- Retain factory parts for future use.

Label	Qty.	Description	Part Number
A	1	Air Filter (Pro 5R)	24-91143
B	1	Tube	05-73003B1
C	1	Housing	05-81022B2
D	1	Plug	05-01429
E	1	Plug, Temp. Sensor	05-01228
F	1	Torx Bit: T20	03-50066

**Installation will require the following tools:**

8mm nut driver, Torx (T20) driver, and pliers.

Note: Legal in California for use on race vehicles only. The use of this device on vehicles used on public streets or highways is strictly prohibited in California and others states that have adopted California emission regulations.



**Figure A****Refer to Figure A for Steps 1-2**

Step 1: Remove the (2) hoses shown in the picture by compressing the spring clamps and pulling the hoses off. ①

Step 2: The coolant hose can be tucked out of the way so that it does not leak.

**NOTE:** Make sure the vehicle is cool before removing the coolant line. If the temperature is low enough so that the reservoir cap can be safely removed, then the coolant line can be safely removed as well.



Figure B

**Refer to Figure B for Steps 3-5**

Step 3: Disconnect the MAF sensor plug. ②

Step 4: Remove the filter minder from the rubber grommet factory intake tube. ③

Step 5: Loosen the clamp at the intake tube. ④





Figure C

**Refer to Figure C for Step 6**

Step 6: Pull straight up to remove the OE intake.

**Figure D****Refer to Figure D for Steps 7-8**

Step 7: Remove the OE grommet from the factory intake tube. ⑤

Step 8: Carefully remove the MAF sensor from the factory intake tube using the provided T20 Torx bit and a bit driver.

**NOTE:** Some models years are equipped with a temp. sensor instead of a MAF sensor, and this intake was designed to work with both sensor types.

**Figure E****Refer to Figure E for Steps 9-10**

Step 9: Reinstall the rubber grommet into the new aFe intake tube as shown.

Step 10: Install the MAF sensor using the factory screws and the T20 Torx bit and driver.

**NOTE:** If your vehicle is equipped with a temp sensor instead of a MAF sensor, then you will need to install the Temp Sensor Adaptor (05-01228). Insert the temp sensor into the temp sensor adaptor.



INSTALL



Figure F

**Refer to Figure F for Step 11**

Step 11: Position the intake tube into the vehicle so that it is tucked under the coolant reservoir. This will provide room to install the intake housing in a future step.



Figure G

**Refer to Figure G for Step 12**

Step 12: Insert the air filter into the aFe housing and make sure the clamp is loosely installed as shown.



Figure H

**Refer to Figure H for Step 13**

Step 13: Install the intake housing into the vehicle and make sure the front of the housing passes through the panel on the core support as shown. ⑥



**Figure I****Refer to Figure I for Steps 14-15**

Step 14: After the housing is secured, install the aFe intake tube into the factory coupler and then into the aFe air filter.

Step 15: Insert the filter minder into the rubber grommet.



**Figure J****Refer to Figure J for Steps 16-19**

Step 16: Tighten both hose clamps on the intake tube.

Step 17: With the spring clamp removed, insert the rubber hose into the front of the intake housing.

Step 18: Connect the MAF sensor harness.

Step 19: Reconnect the coolant hose and make sure the spring clamp is secured properly.



INSTALL

Figure K

### **Refer to Figure K for Steps 20-21**

Step 20: If desired, there is a plug included to block any hot engine heat that may be a concern. In cold weather, it is recommended that the plug is removed to help the engine warm up quickly and maintain optimal operating temperatures.

Step 21: Make sure all clamps and connections are secured. Your installation is now complete!

*NOTE: Retighten all connections after approximately 100-200 miles.*