



# Cast Products, Inc.

Installation Procedure  
SA2403

\*Inside-the-Bumper\* Mount

\*Fore-warn\* Siren Speaker

For 10' Tall Bumper

1) The speaker assembly is required to be on a flat surface with at least 6 3/8" vertical height for the trim bezel ST2025 to bolt through. See FIGURE 1.

2) Remove the speaker trim bezel from the speaker unit. Four #1/4-20 x 1 1/4" stainless bolts (provided) will bolt the trim through the bumper to the speaker.

3) Position the trim bezel on the face of the bumper in the appropriate location, and mark the center of the four .280" holes pre-drilled in the trim bezel. make sure the trim is level or parallel with the bumper. Also mark the inside opening of the trim. See FIGURE 2.

4) Drill four clearance holes for the #1/4-20 bolts and cut the opening in the bumper face for the speaker to protrude through.

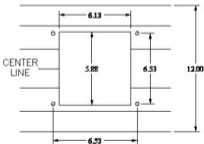
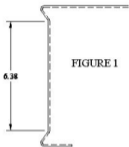
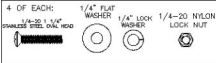


FIGURE 2

## SA2401, SA2403, & SA2404



FOR 1 SIREN

- 5) Install the speaker assembly in the bumper (from the rear of the bumper) and locate the trom bezel around the face of the housing from the front side.
- 6) Install the #1/4-20 x 1 1/4" screws, washers, lock-washer and #1/4-20 Nylon lock nuts. It is suggested to use some sort of medium grade loc-tite on the threads as well.
- 7) Tighten all hardware and continue with the electrical connections as per their manufacturers directions.

