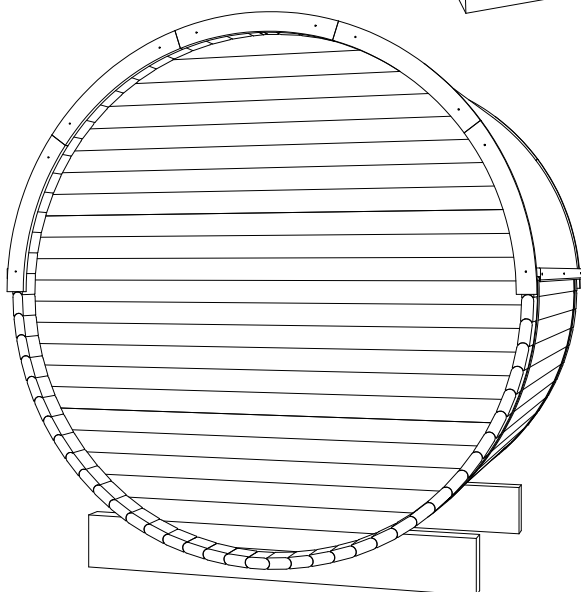
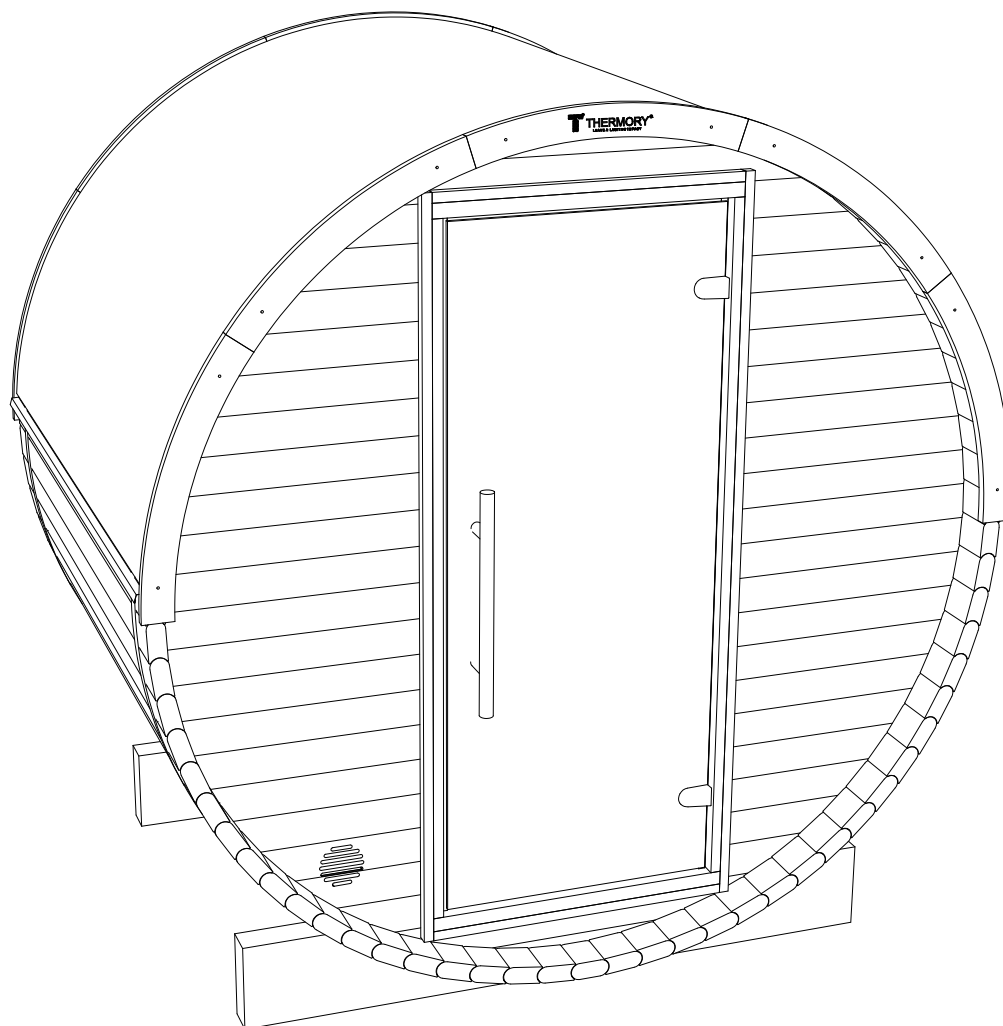
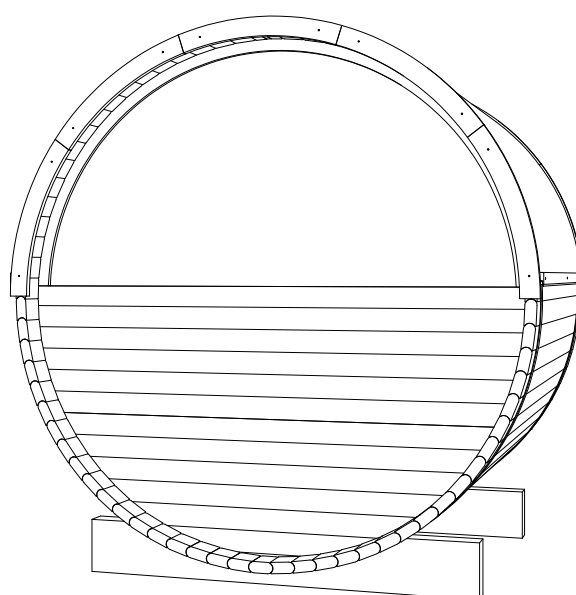


# BARREL SAUNA

## ASSEMBLY INSTRUCTIONS



Model: No54

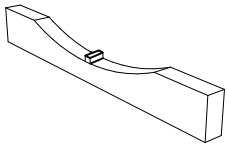


Model: No55

**Note: Please read manual before construction**

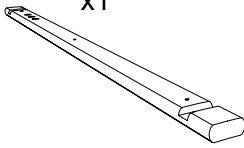
## PART LIST

**A** x2



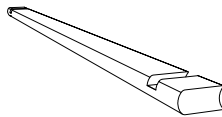
cradle

**B** x1



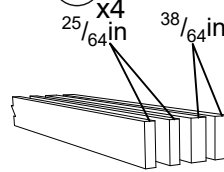
center stave

**C** x74



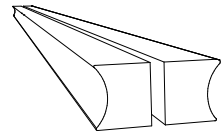
body stave

**H1** x4



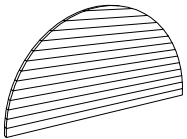
different thickness  
filling peaces

**H** x2



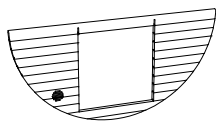
final H tipe stave  
at the top

**V3** x1



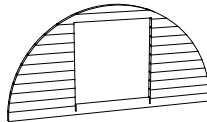
upper rear panel

**F** x1



front panel bottom

**F1** x1



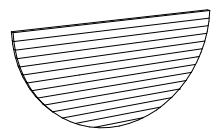
front panel top

**F2** x1



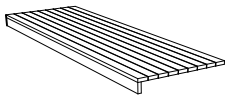
door and door  
moldings

**V** x1



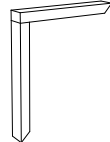
bottom rear panel

**J** x2



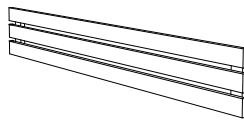
sauna bench

**J1** x2



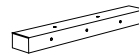
supporting leg

**J2** x2



backrest

**J3** x4



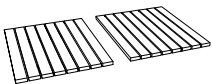
wall mount

**N1** x2



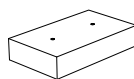
door handle

**L** x2



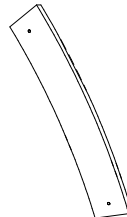
sauna floor

**L1** x6



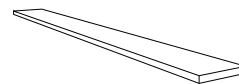
fixing block for sauna  
floor

**W** x10



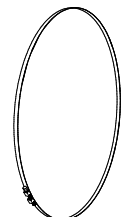
decorative roof  
finishing board

**O** x1



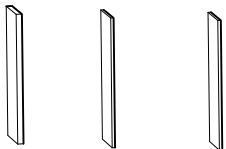
roof board

**I** x2



metal band

Green  $\frac{13}{64}$ in Blue  $\frac{5}{64}$ in White  $\frac{3}{64}$ in



door box spacers

**S1** x30



screw 5.0x100 SS

**S10** x135



screw 4.0x60

**S5** x25



screw 4.0x50 SS

**S4** x11



screw 5.0x120

**S6** x30



screw 5.0x70 SS

**S7** x25



screw 4.2x55 brown

**S2** x25

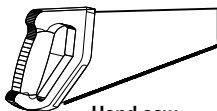


screw 4.0x70 SS

**S14** x10



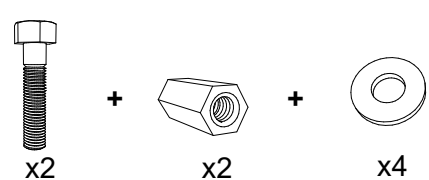
screw 5.0x80



Hand saw

PART LIST

S9



x2

x2

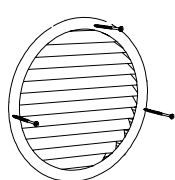
x4

bolt  
ø12x140

hex nut  
M12 (SW19)

flat washer

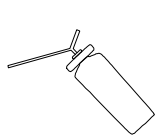
Y1



x1

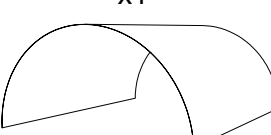
ventilation grill

P7



Construction foam

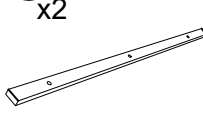
Z



x1

Waterproof roof cover

Z1

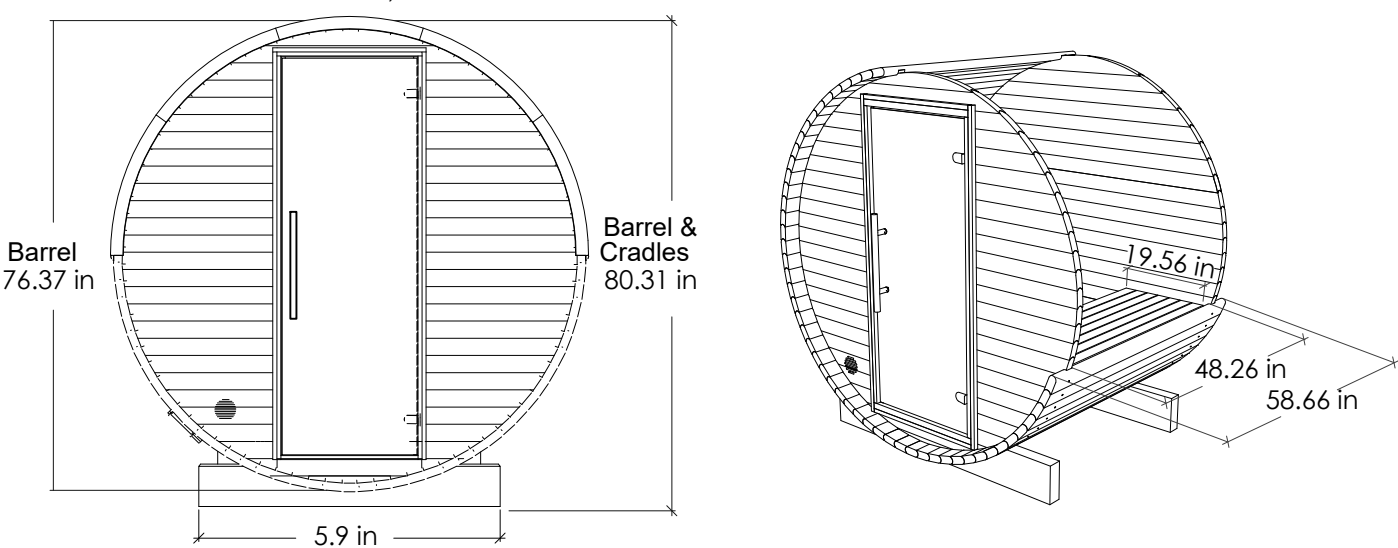


x2

Slat for roof cover

Barrel Dimensions

Model: No54; No55



Barrel 76.37 in

Barrel & Cradles 80.31 in

5.9 in

19.56 in

48.26 in

58.66 in

RECOMMENDATION

2 person recommended

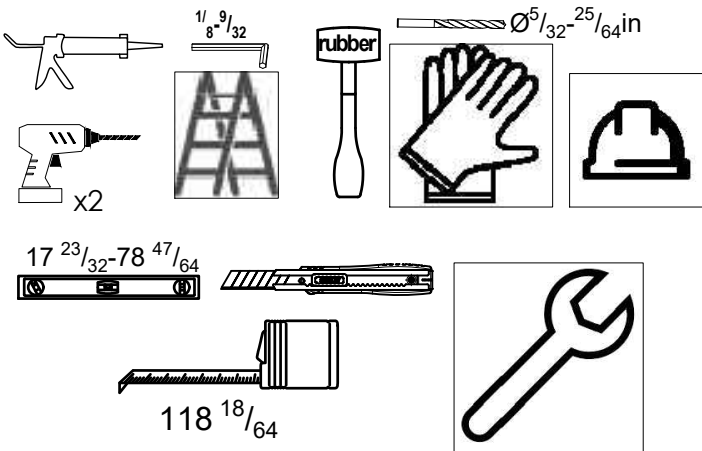
Before you begin, be sure the sauna will fit in your chosen location.

Be sure the site is level and free of standing water after rainfall.

Concrete, pavers or crushed stone is preferred.

Check parts before construction.

TOOLS REQUIRED



$1\frac{1}{8}\frac{9}{32}$

rubber

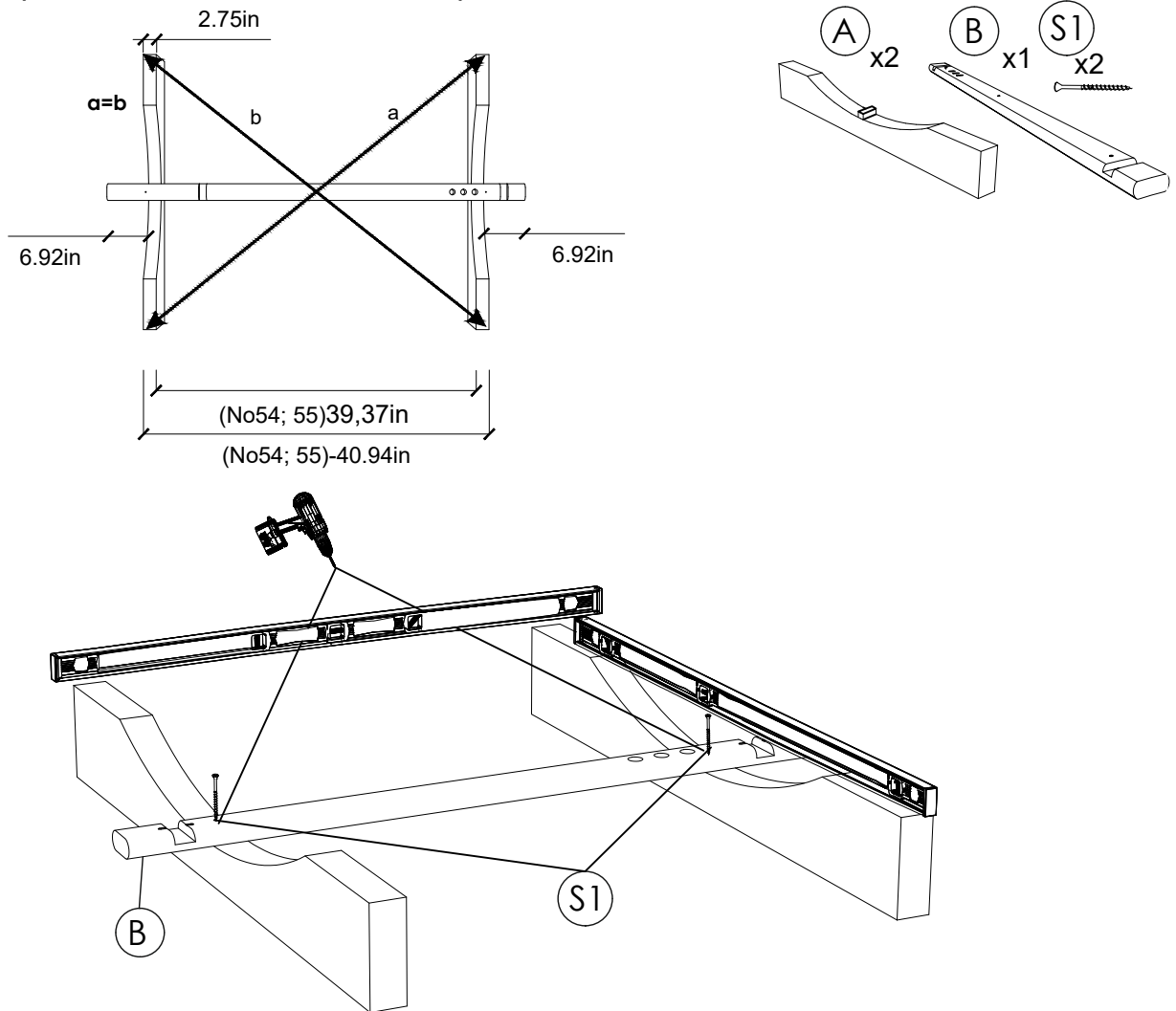
$\varnothing\frac{5}{32}-\frac{25}{64}$ in

x2

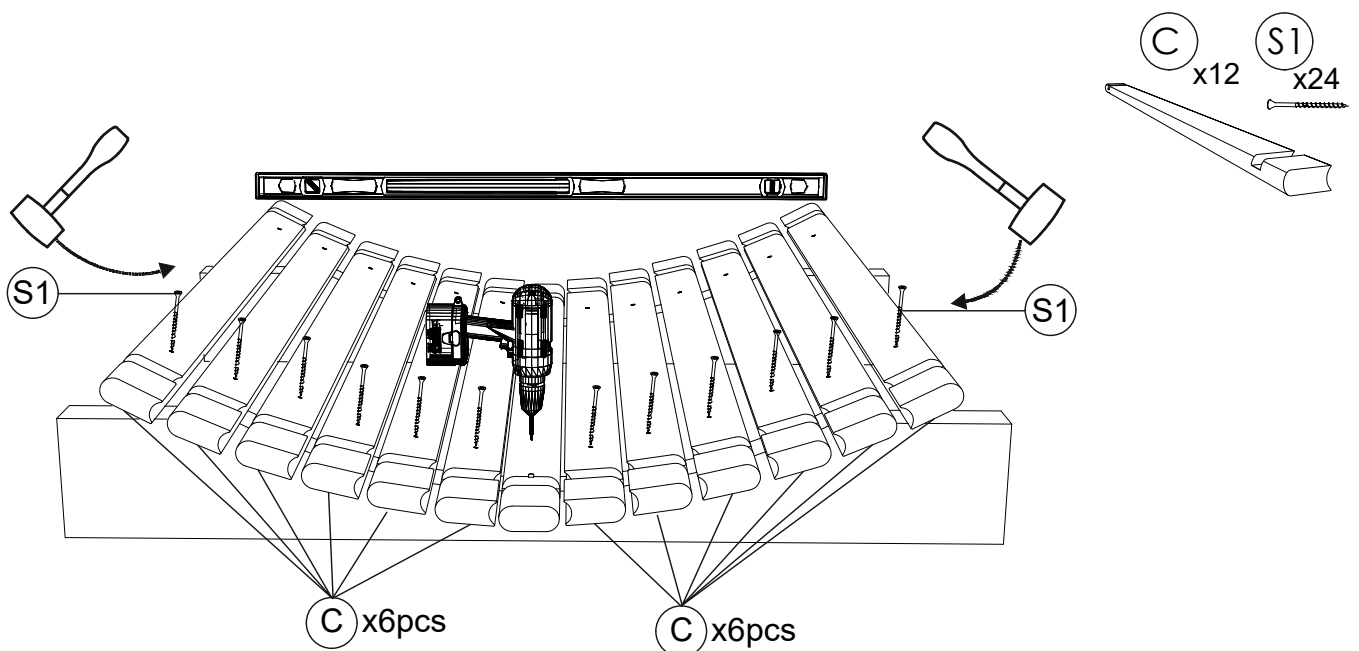
17  $\frac{23}{32}$ -78  $\frac{47}{64}$

118  $\frac{18}{64}$

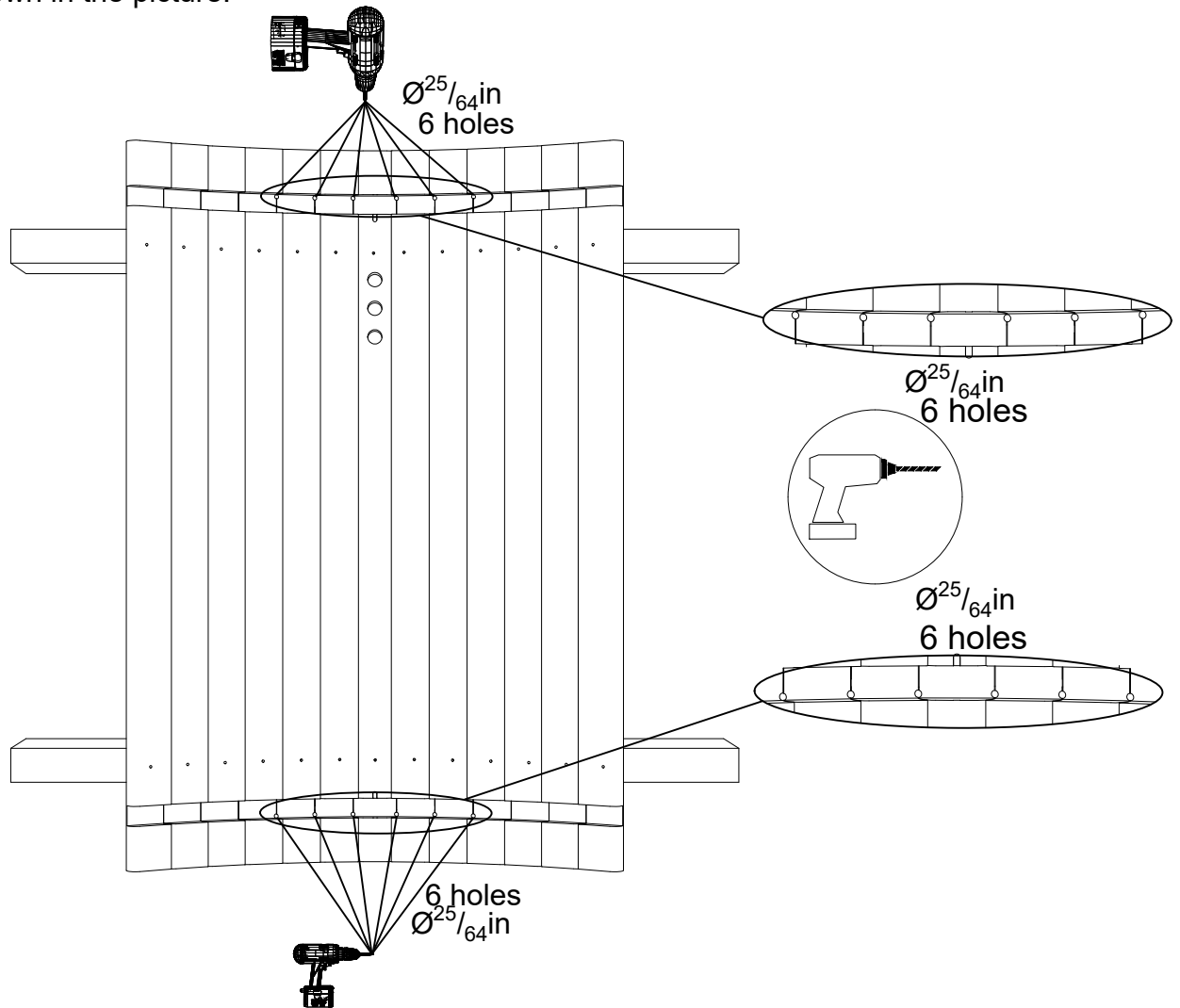
**STEP 1:** Be sure cradles remain level. Place the support cradles (A) on level site. Carefully level for better stability. Place the center stave (B) on wooden dowels embedded in outer support cradles (A). Fix the center stave (B) with (S1). Pre-drill holes before fix staves with screws. Measure support cradles (A) diagonally from corner to corner. Measurements “a” and “b” should be equal to ensure the cradles are square.



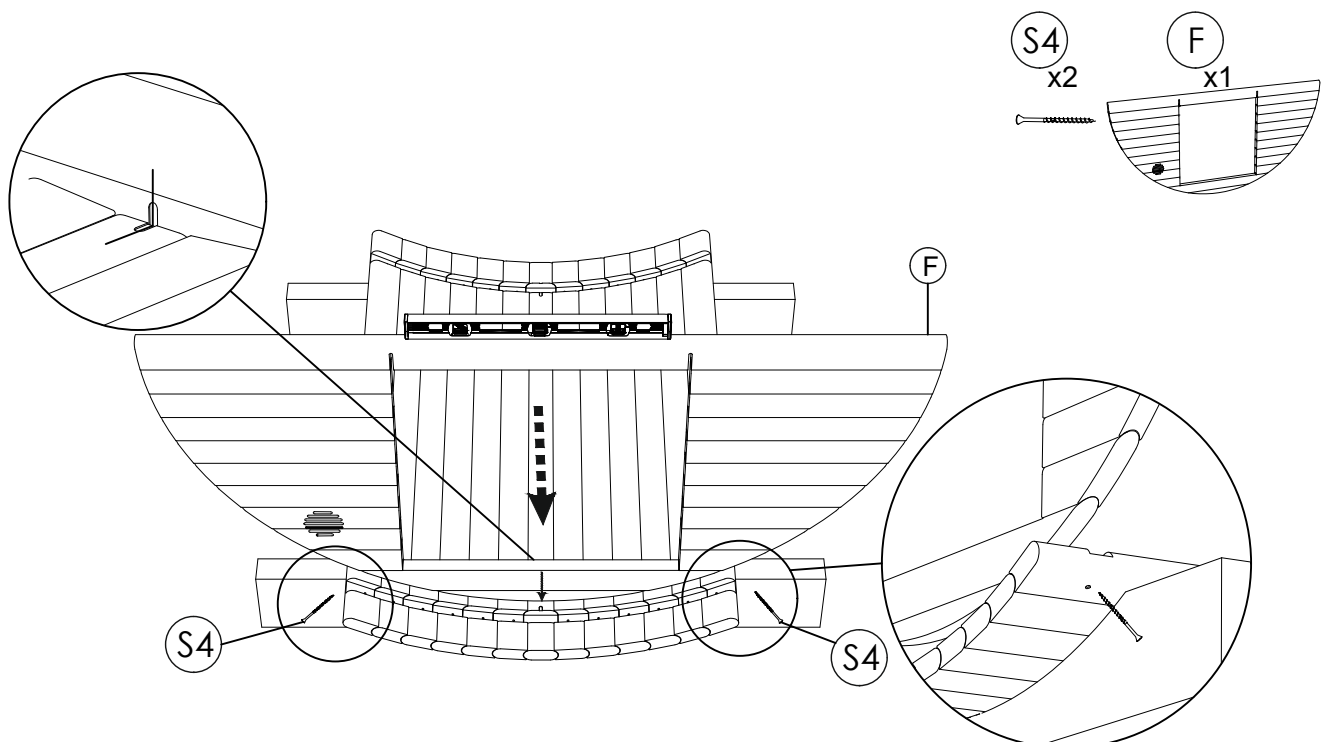
**STEP 2:** Pre-drill holes before fix staves with screws. Place 6 sauna body staves (C) to each side of the center stave (B) and fix with screws (S1). Be sure to align the panel groove on every next body stave, to do that use rubber hammer.



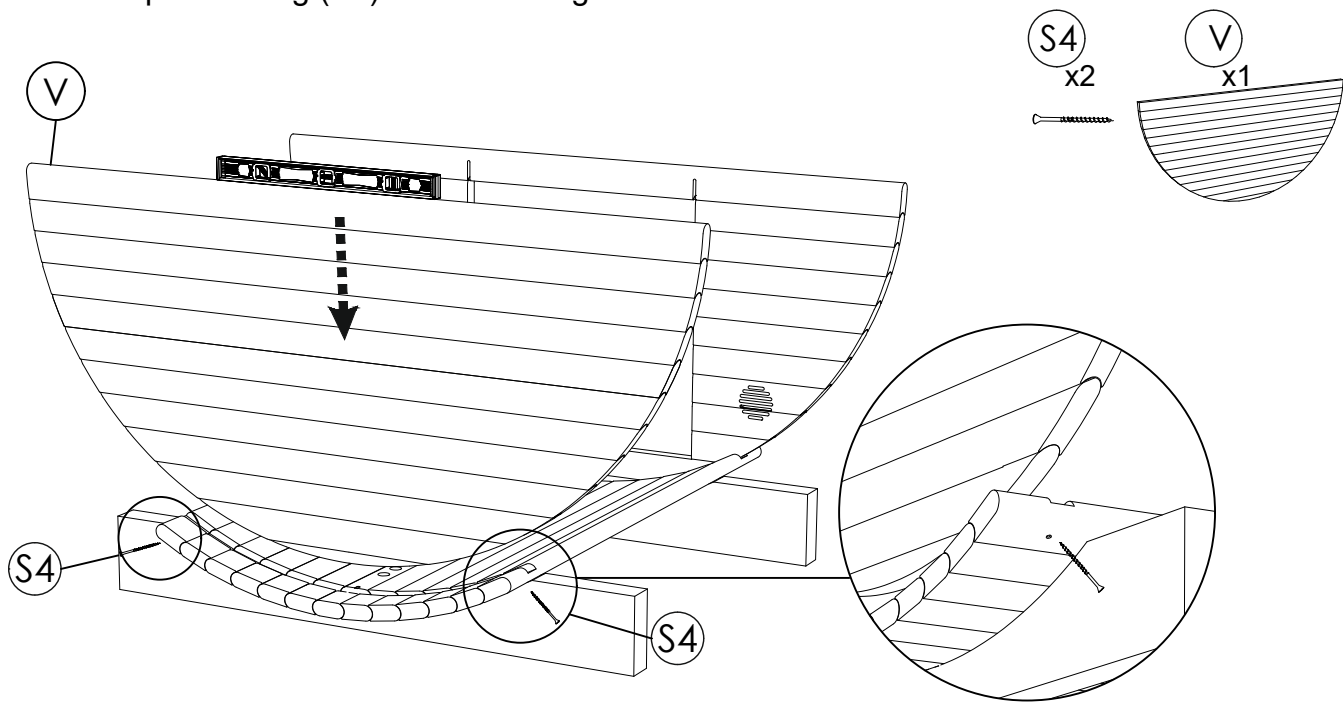
**STEP3:** Drill six  $\frac{25}{64}$ in holes in front and back wall groove to the out-side in board connections as shown in the picture.



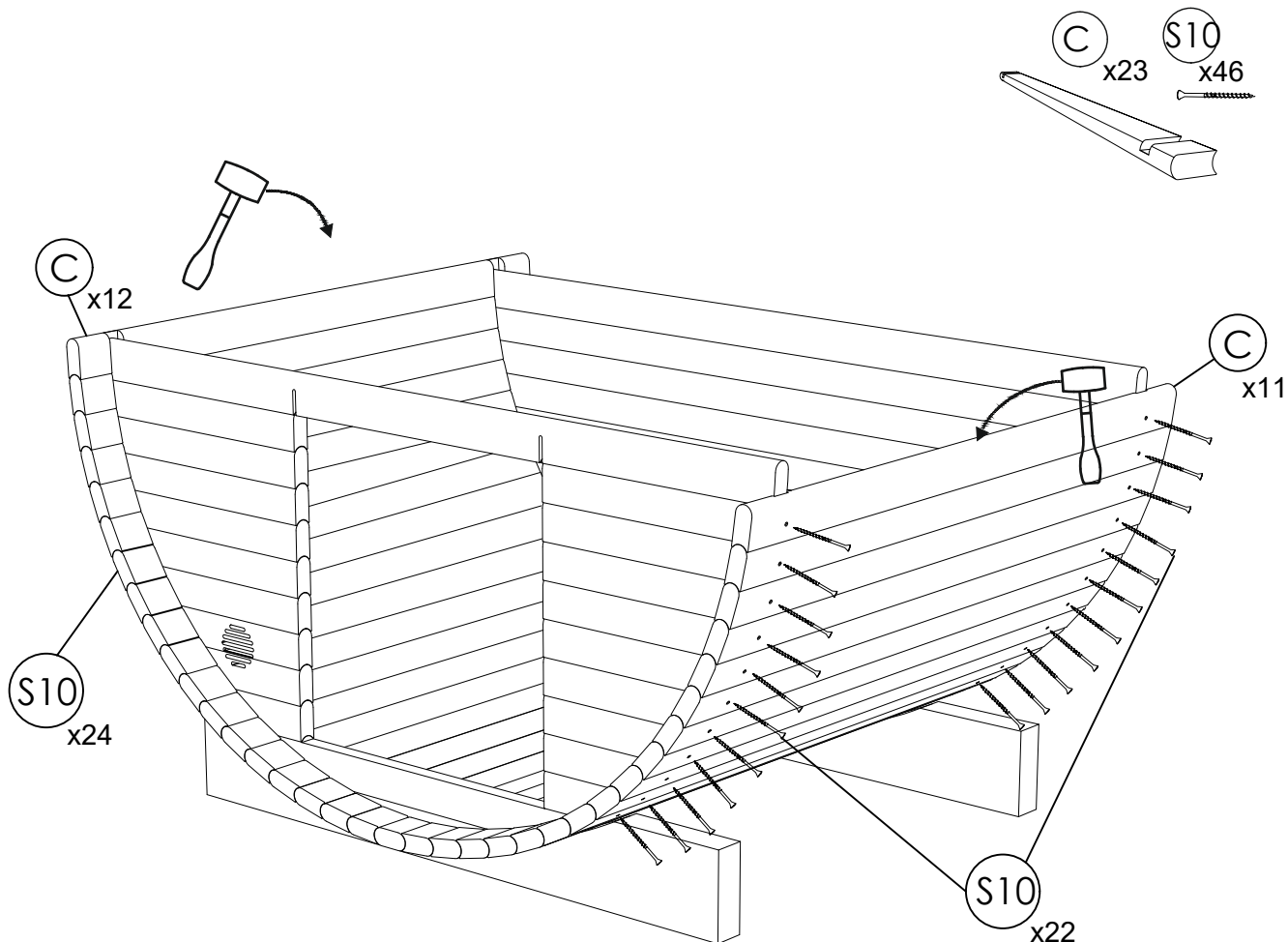
**STEP 4:** Place front bottom panel (F) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides.



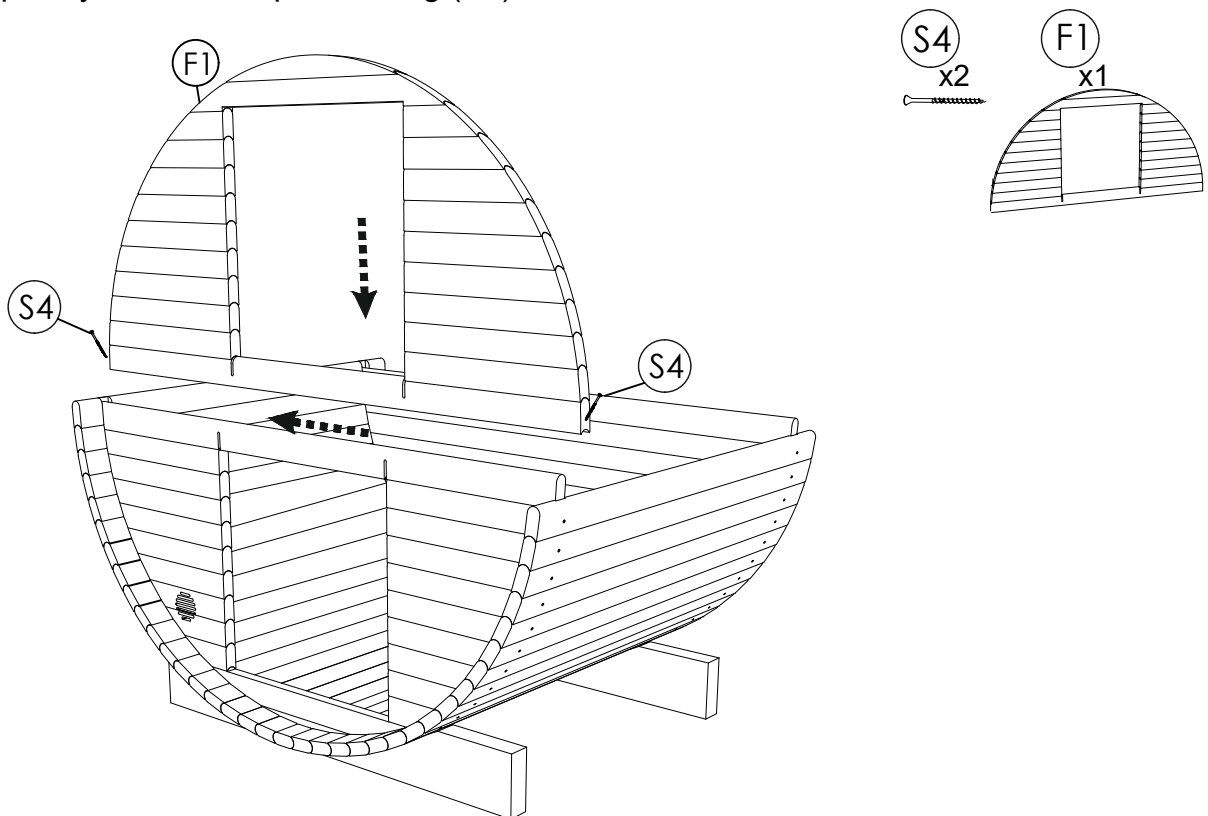
**STEP 5:** Place rear panel (V) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides.



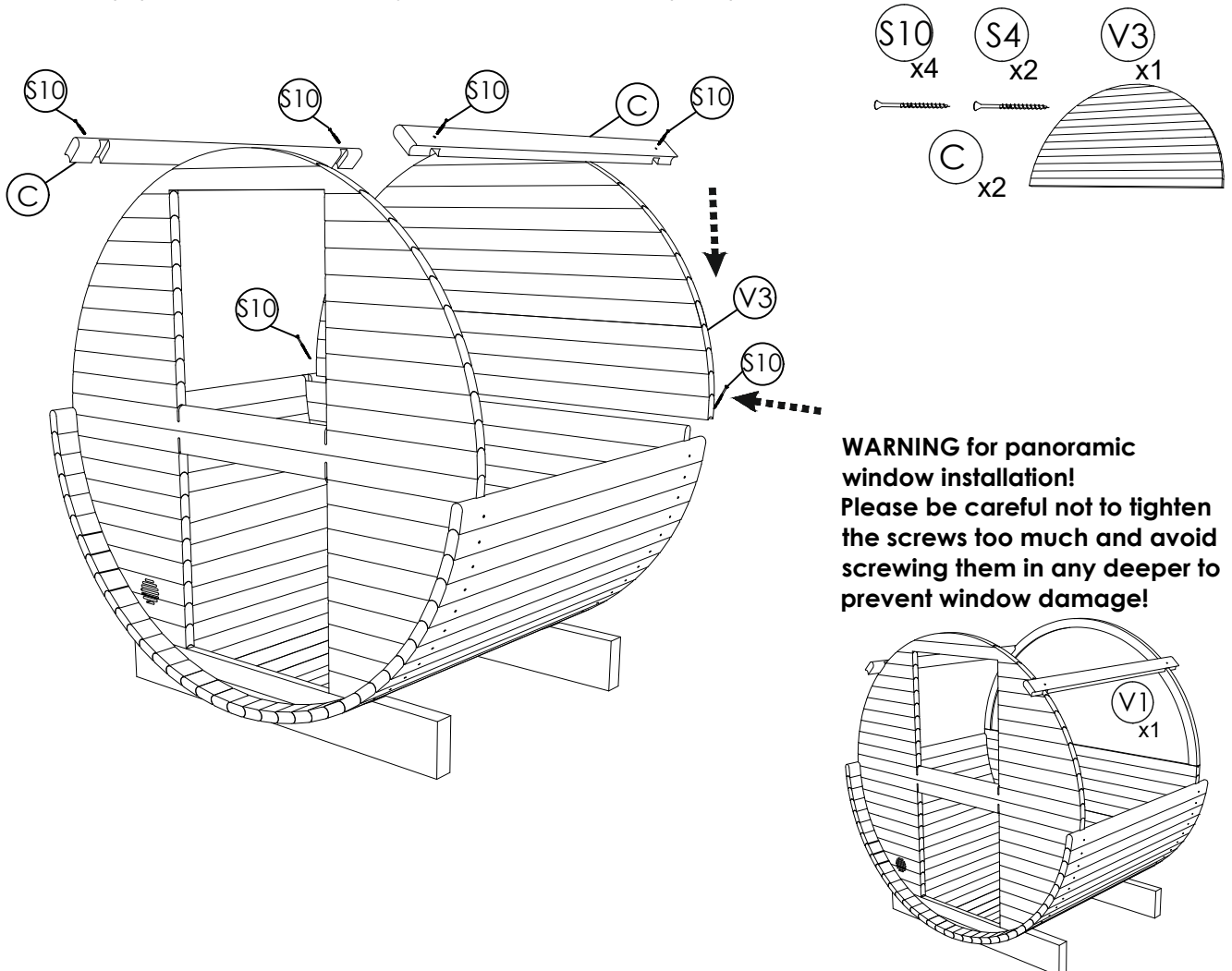
**STEP 6:** Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10) . Fix one stave higher on left side than at right.



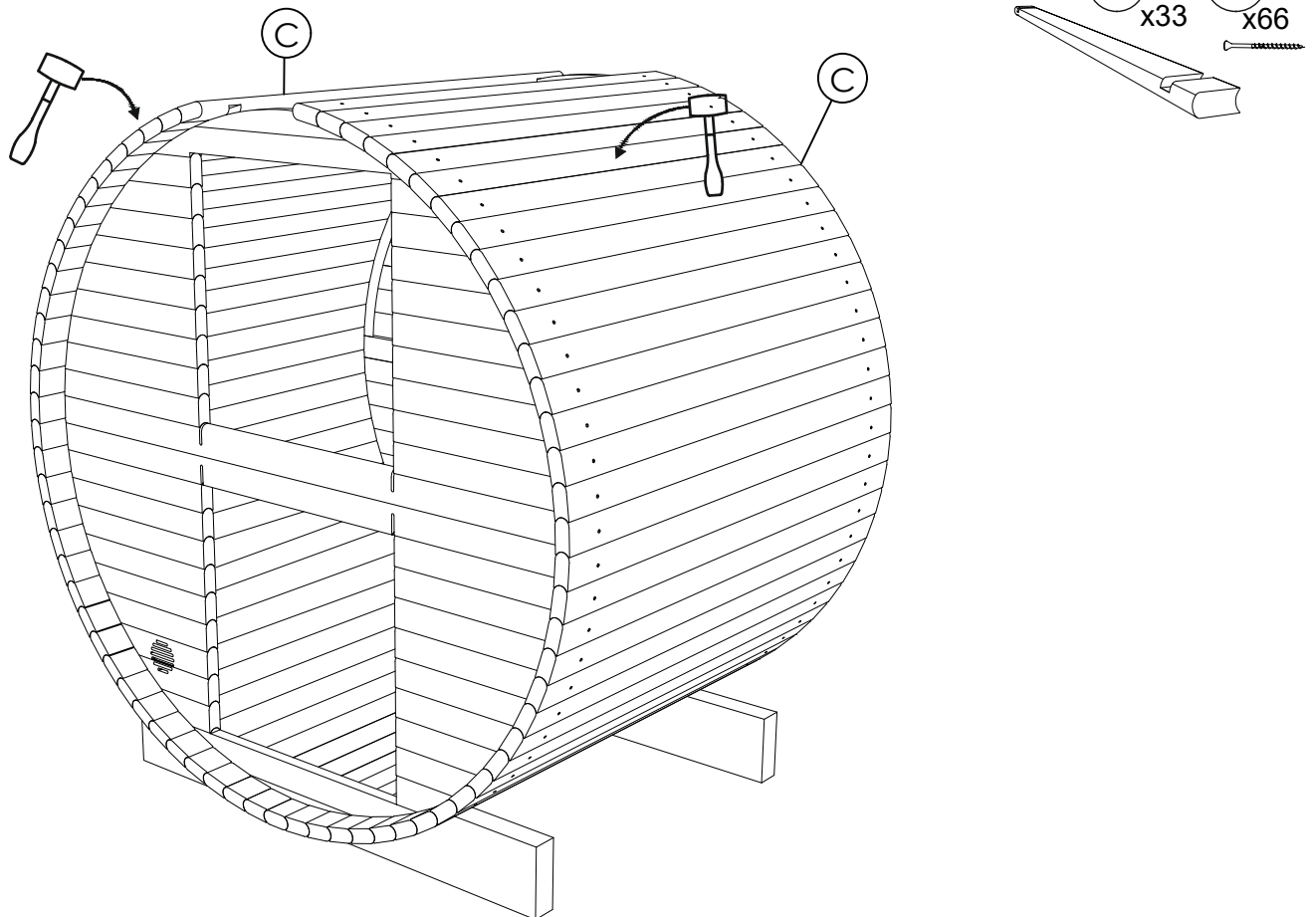
**STEP 7:** Place front top panel (F1) on front bottom panel (F), be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws on both sides.



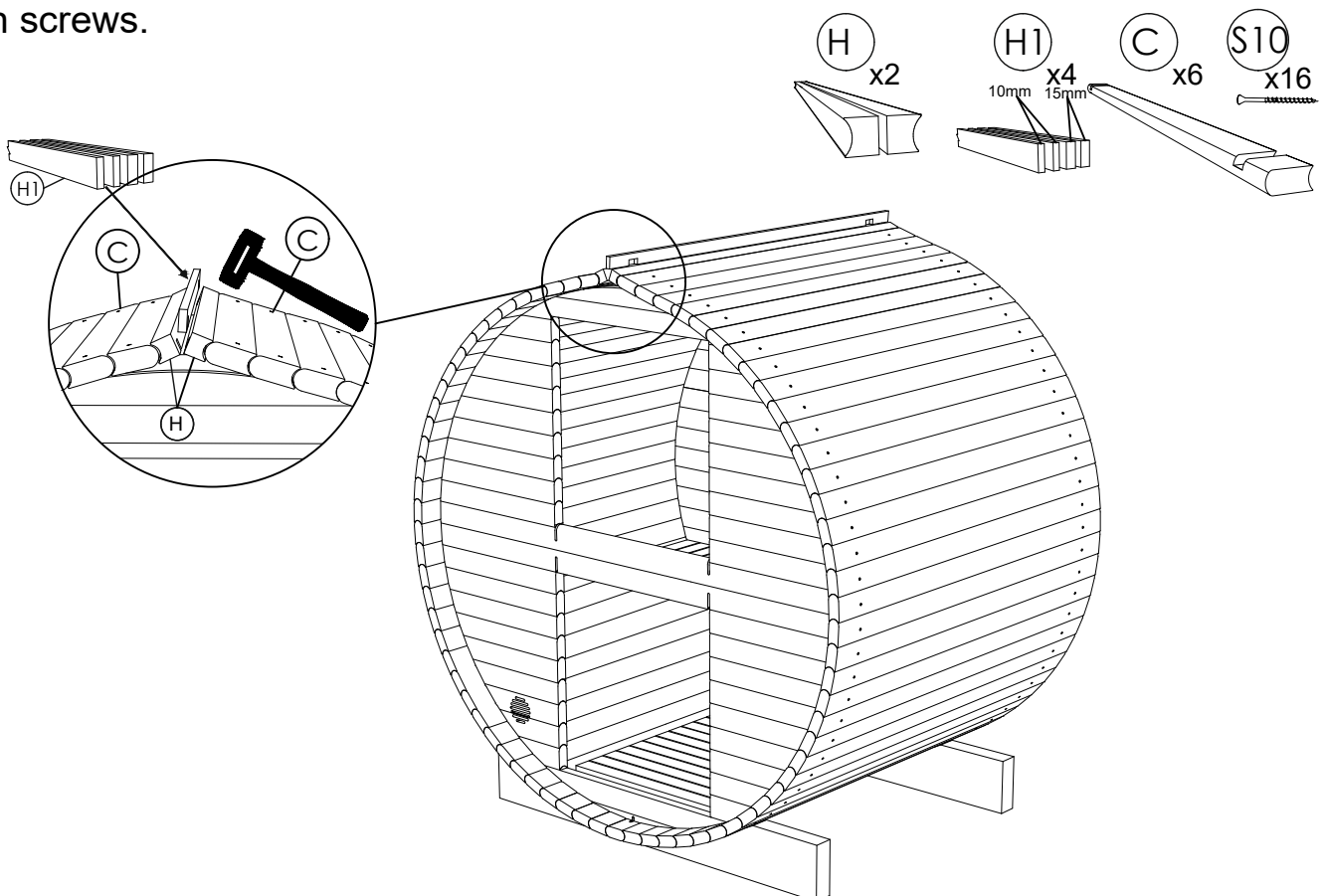
**STEP 8:** Take the upper rear panel (V3 or V1-panoramic window) and place it on the bottom rear panel (V). Secure it by using 2 screws (S4). Connect the panels (F2; V3) together by placing one body staves (C) both sides where you can reach, with (S10) screws.



**STEP 9:** Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws(S10).

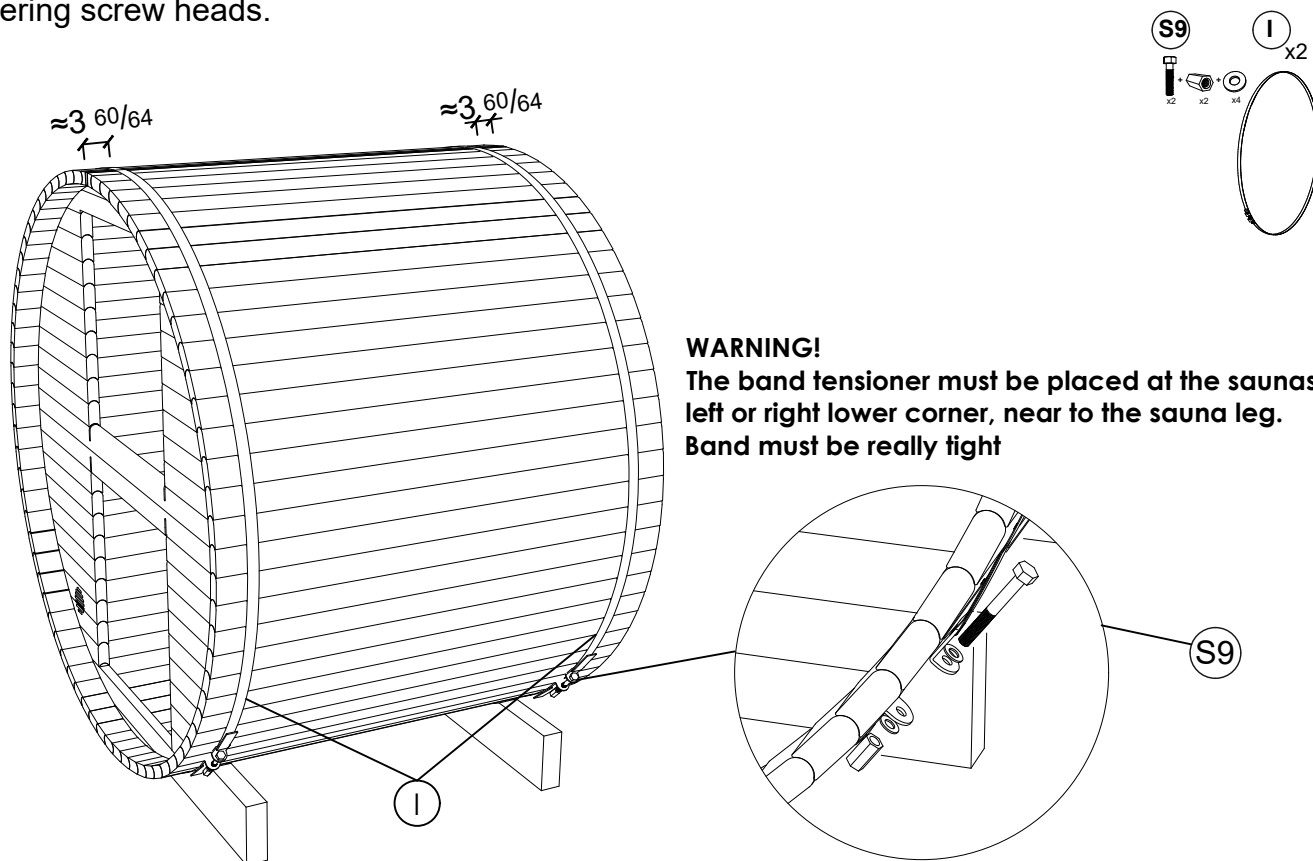


**STEP 10:** To finish the roof top joint, don't screw about last 3 boards (C) to each side, use roof finishing item (H). Different thickness filling pieces (H1) are provided to completely fill the gap. Once necessary parts are in, fix last boards with screws.

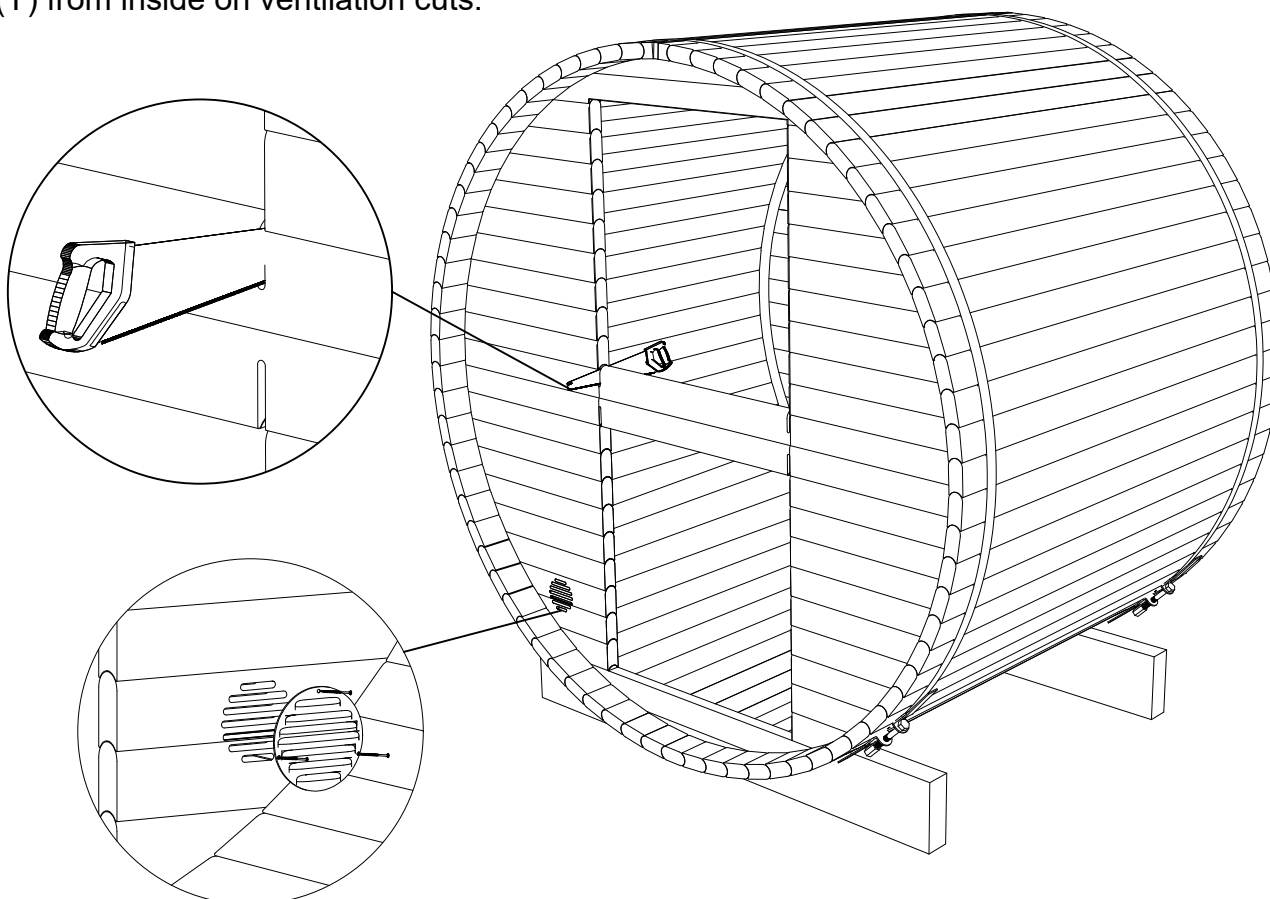




**STEP 11:** Install steel bands (I) by wrapping bands around the barrel, then connect with bolts and nuts (S9). Place steel bands evenly around the barrel approx  $\approx 3 \frac{60}{64}$ in from both sides, covering screw heads.

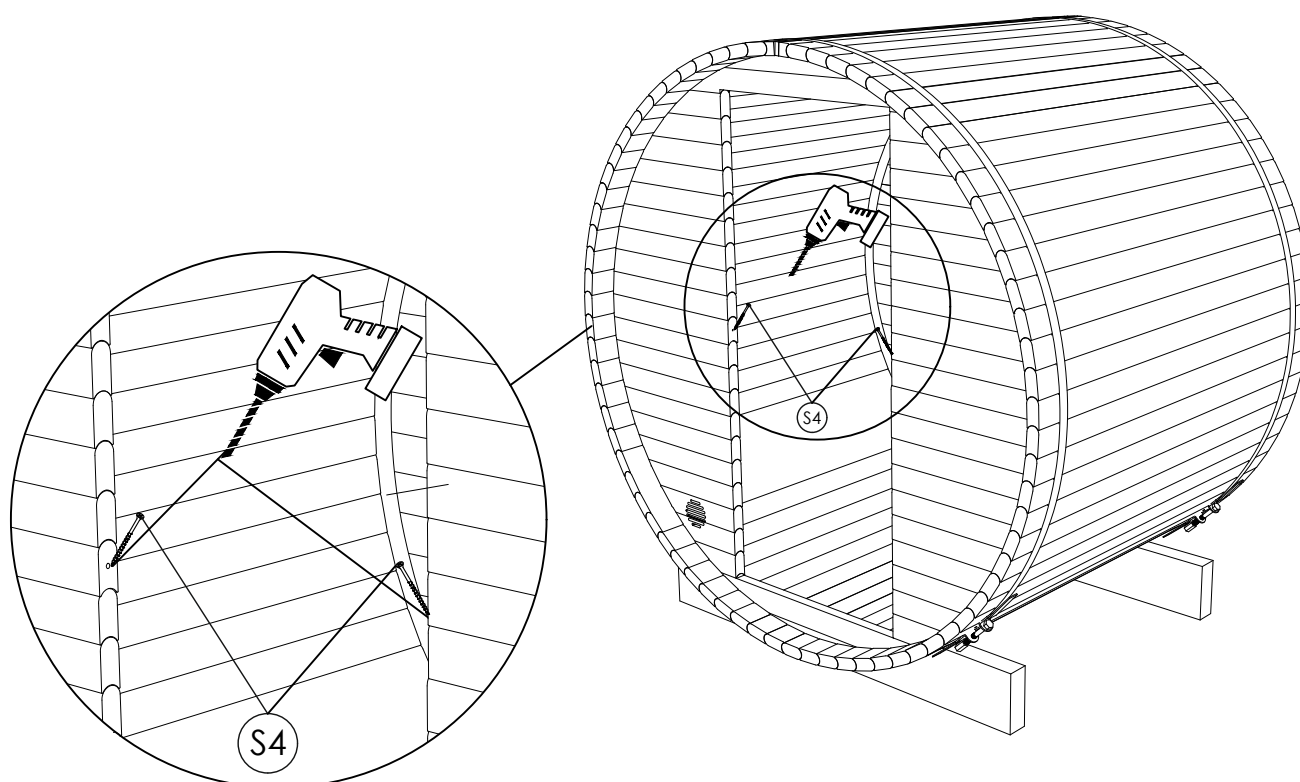


**STEP 12:** Draw straight line to connect both cuts. Use hand saw or other cutting machine to saw out excess boards for door box. It's recommended to saw out boards from inside. Fix ventilation grill (Y) from inside on ventilation cuts.



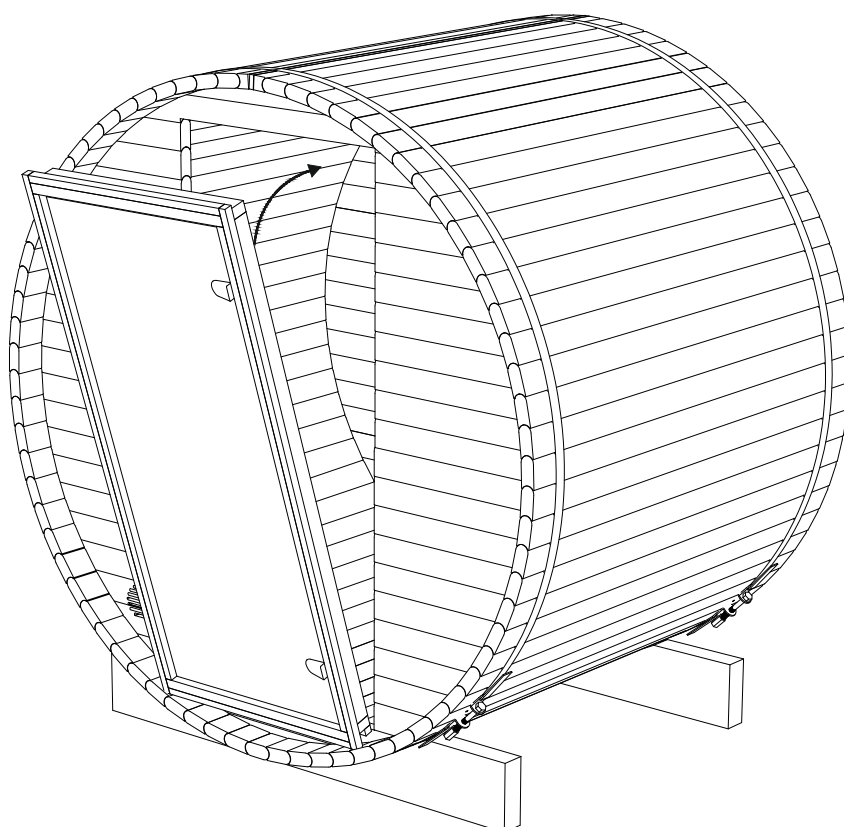
**STEP 13:** Pre-drill holes for screws. Fix both panels together using (S4) screws.

(S4)  
x2

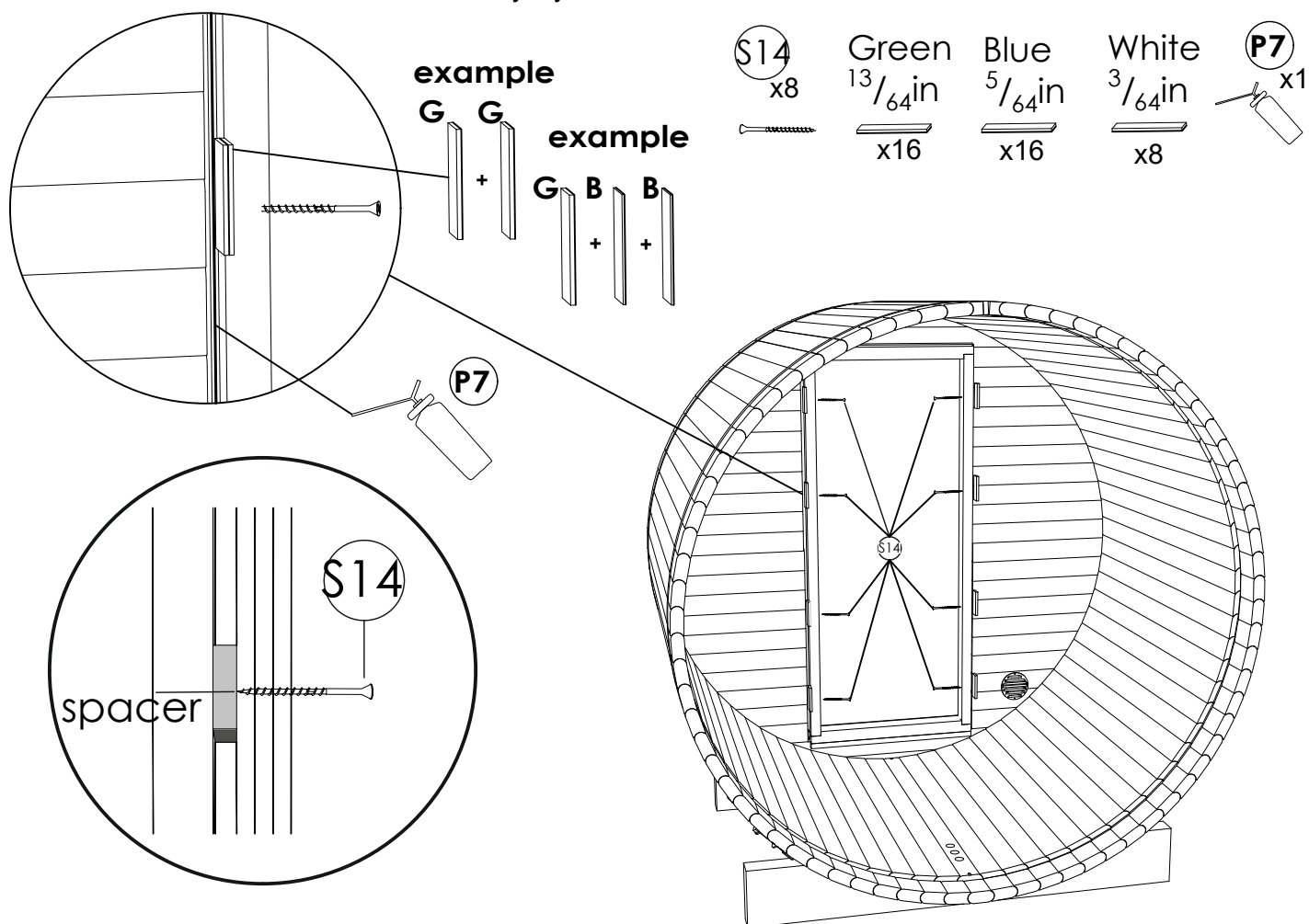


**STEP 14:** Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.

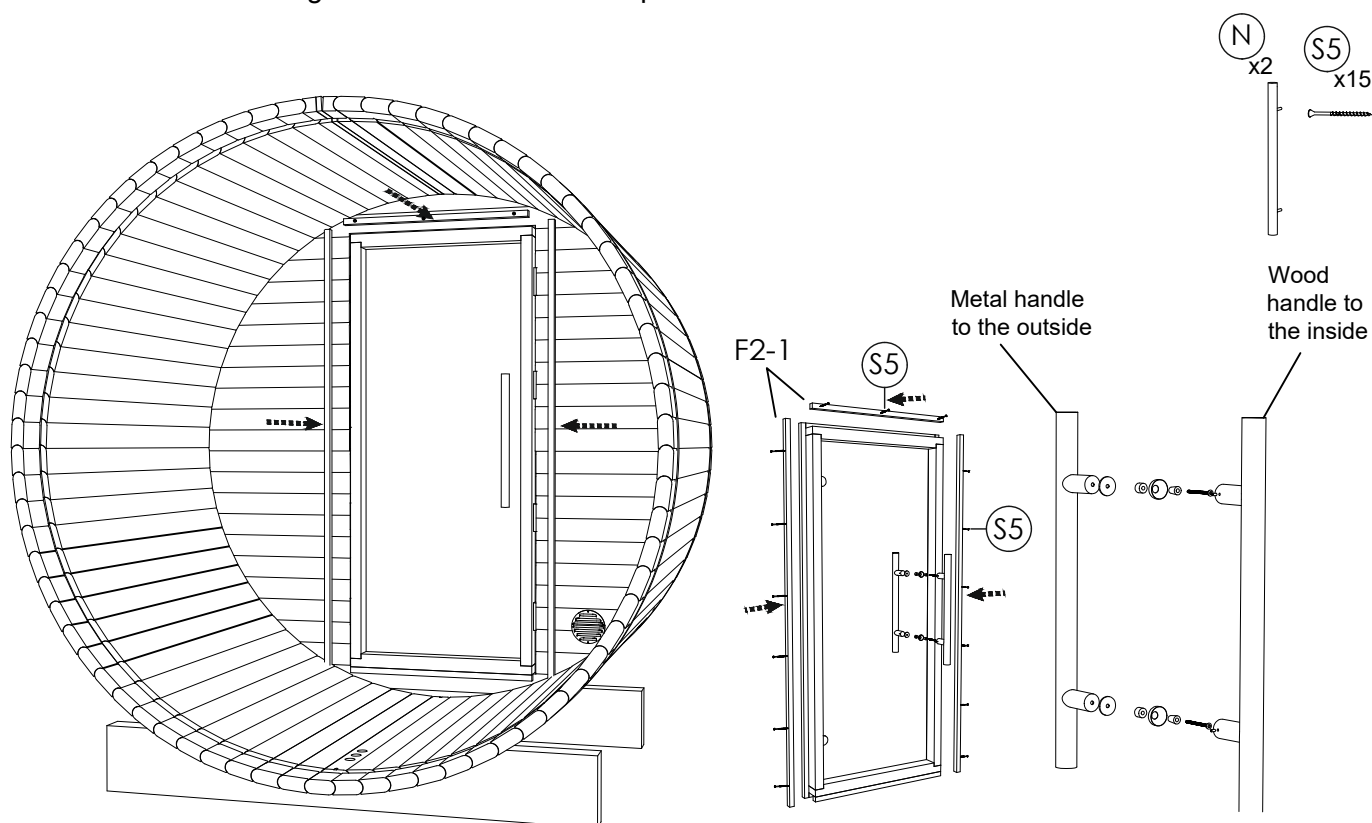
(F2)  
x1



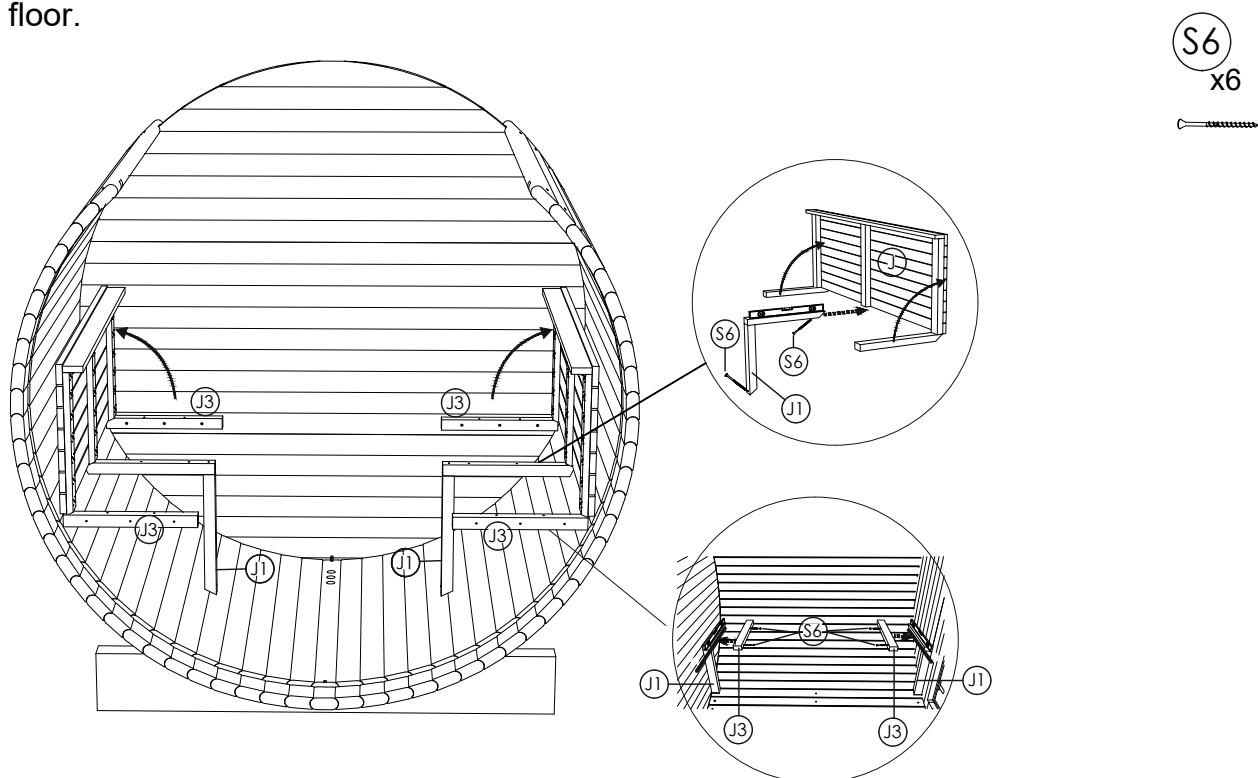
**STEP 15:** Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. First, fix one side of the door box with screws (S14) through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly, they can't slip down before door is fixed with screws. Use screws (S14) to fix doors. Check door box, both sides should be straight, they must not be bent inwards or outwards. Use foam around door box. Don't clean up the foam until it's dried out. The excess amount will come off easily if you don't touch it while it's wet.



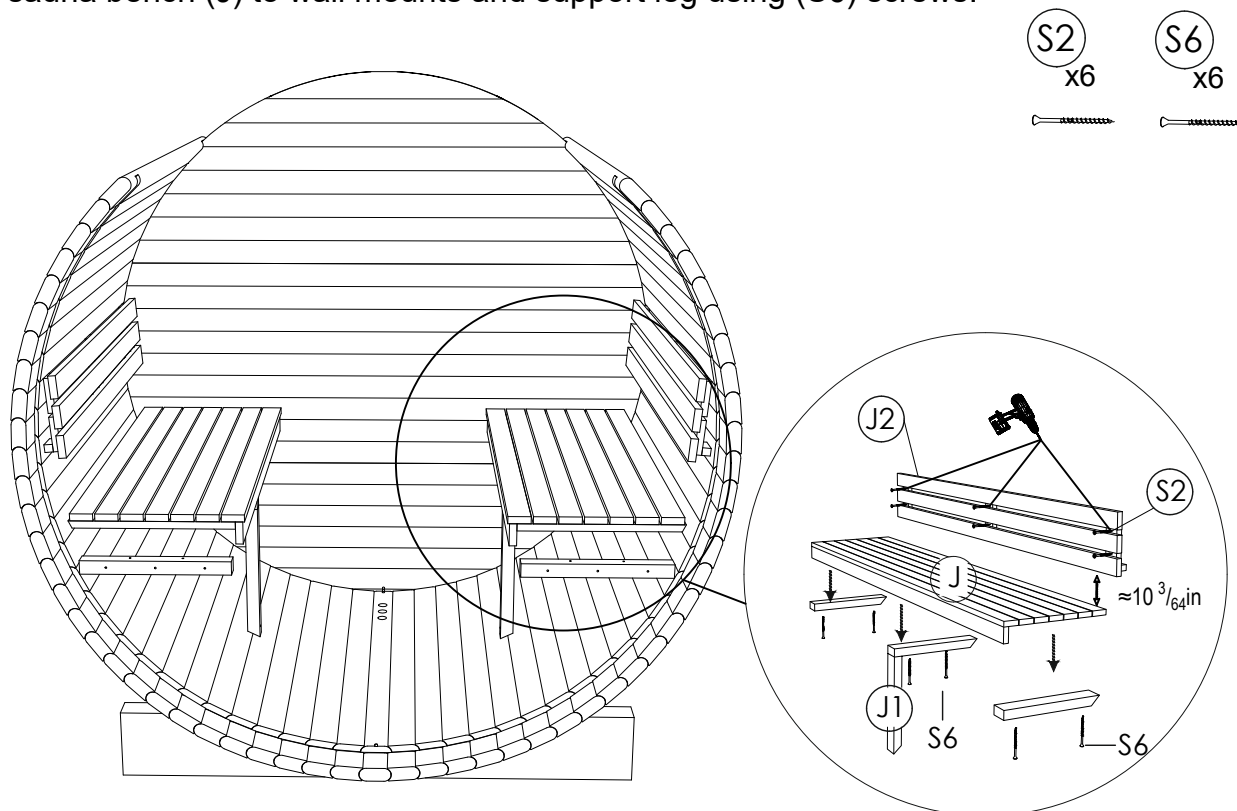
**STEP 16:** Fix door moldings to both sides and on top of the door with S5 screws.



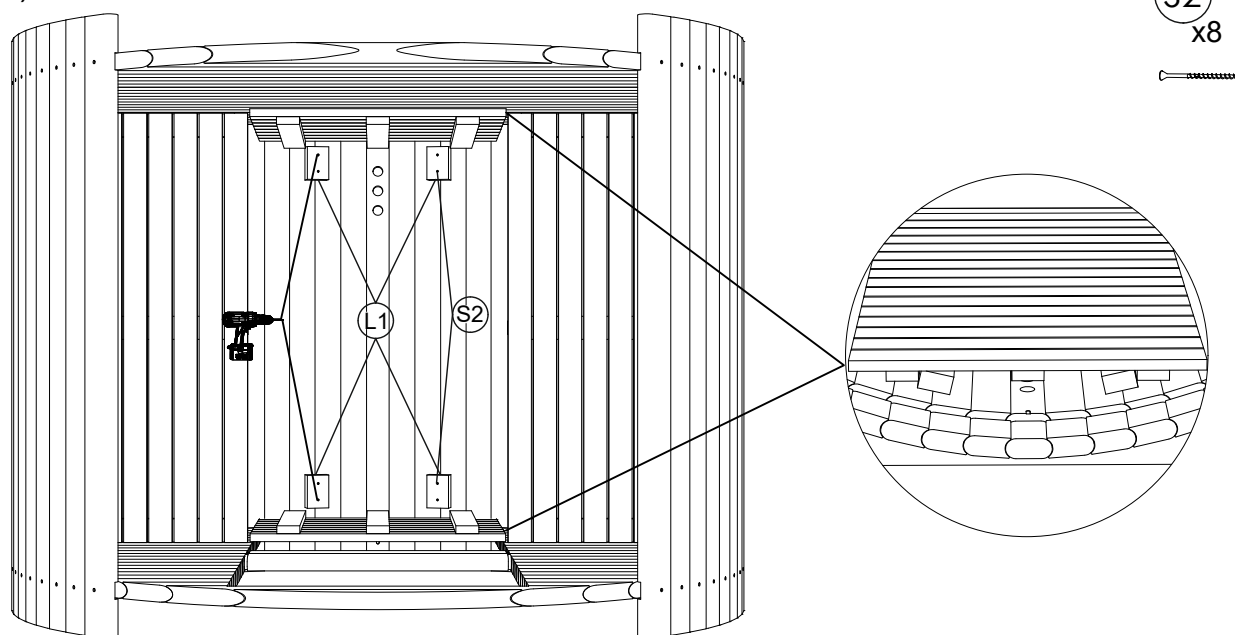
**STEP 17:** To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, mark a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall mounts. Place J1 in the center and check the level. Using screw (S6) fix bench leg to the wall and floor.



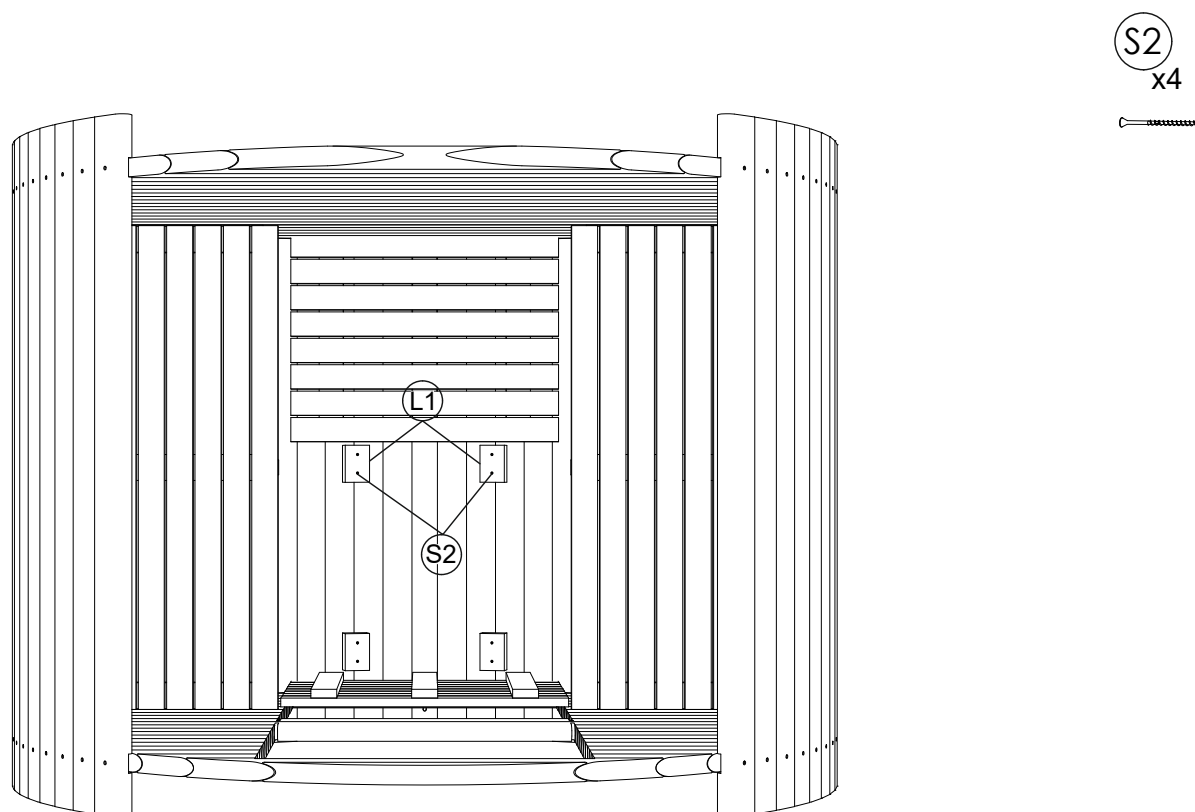
**STEP 18:** Pre-drill holes before fix backrest with screws, install backrests (J2) using screw (S2). Fix sauna bench (J) to wall mounts and support leg using (S6) screws.



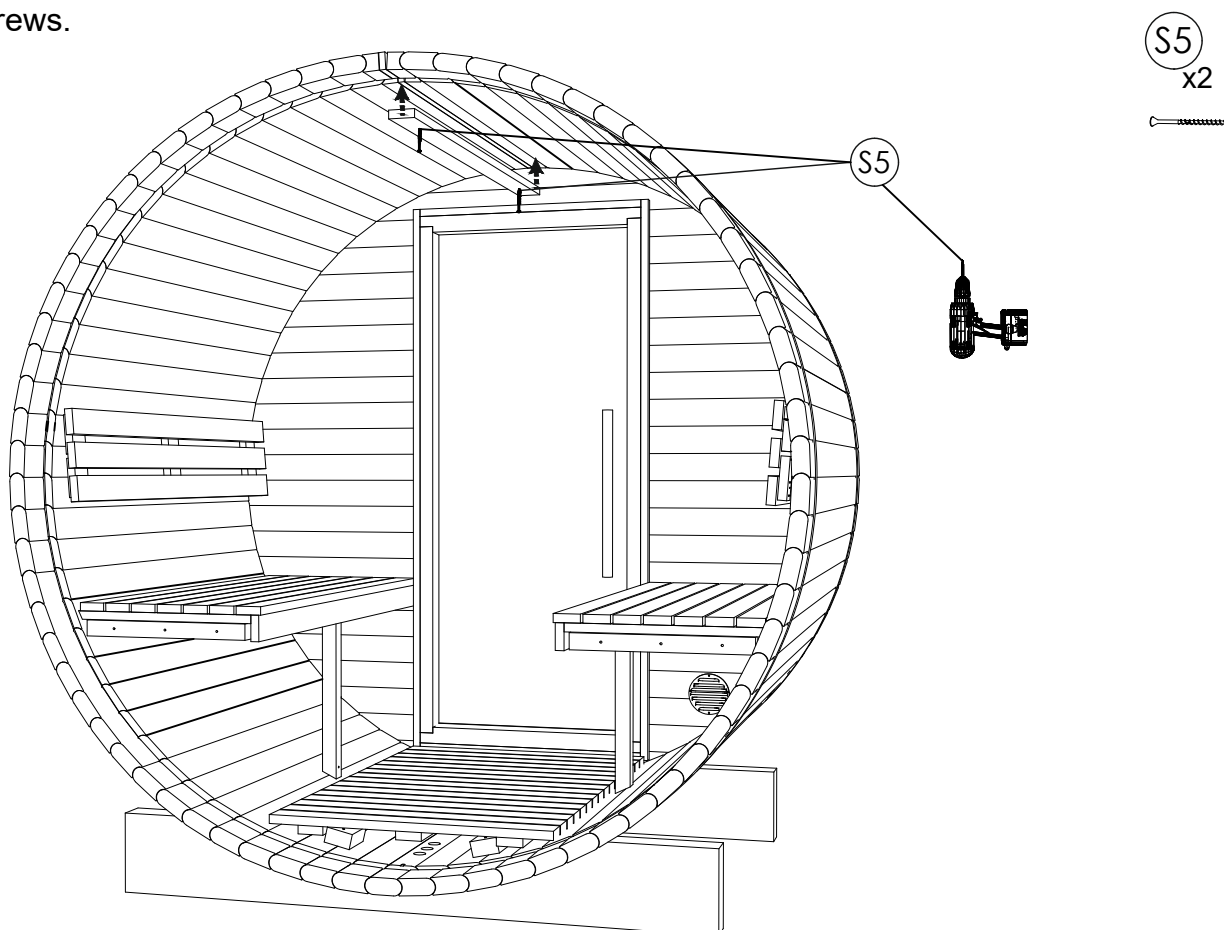
**STEP 19:** Place floor duckboards (L) to the both sides upwards and place fixing blocks next to the flooring cross boards. Pre-drill holes before fix with screws, install fixing blocks (L1) using screw (S2).



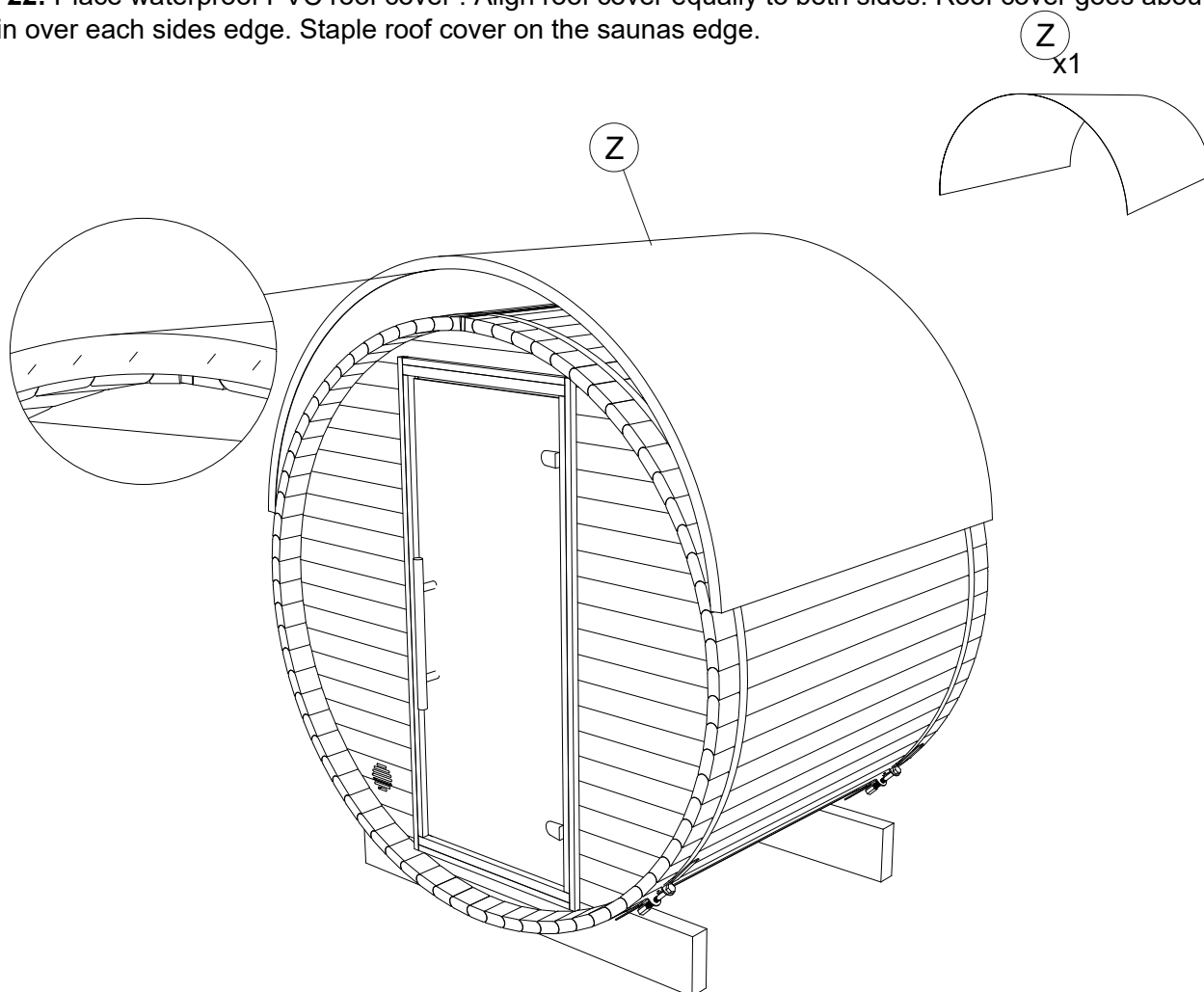
**STEP 20:** Pre-drill holes before fix with screws, install fixing blocks (L1) under floor duckboard using screw (S2). Place floor duckboards (L) on the floor and fix fixing blocks next to both flooring crossboards.



**STEP 21:** Pre-drill holes before fix stave with screws, install interior roof trim (O) in sauna with (S5) screws.

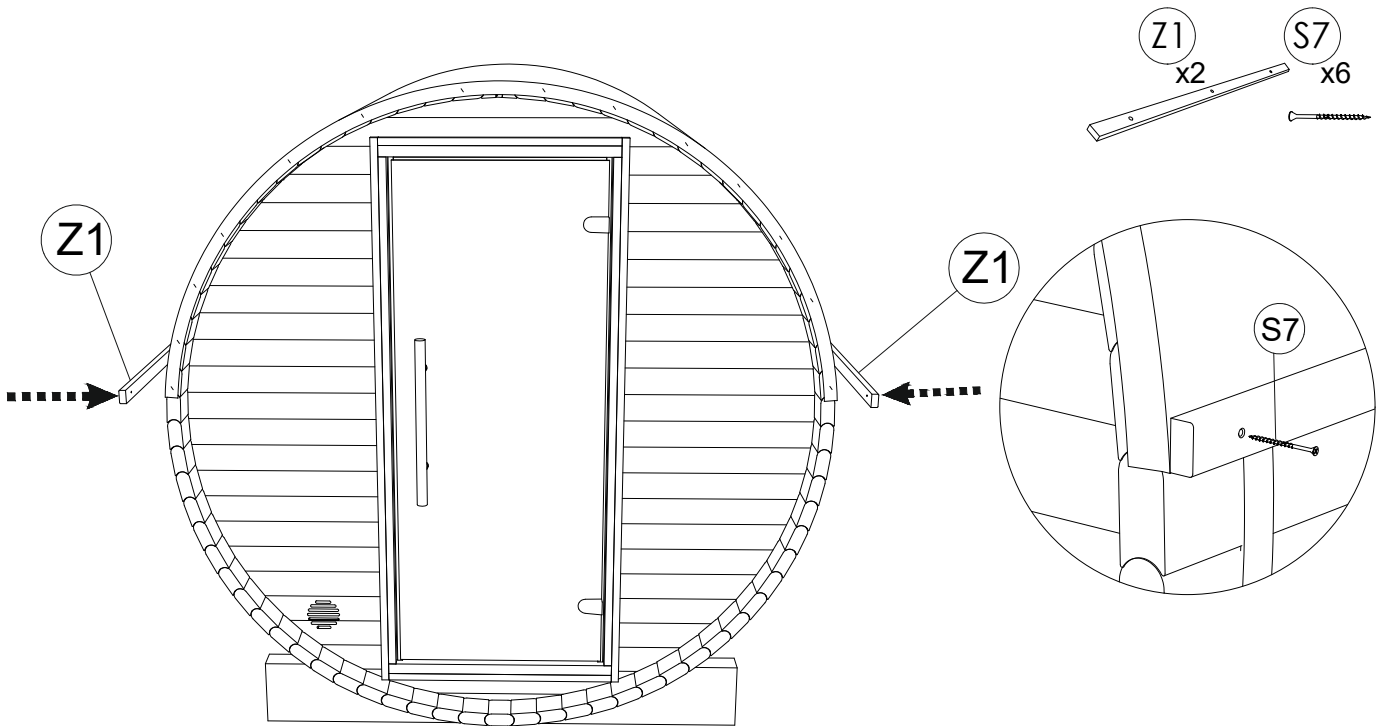


**STEP 22:** Place waterproof PVC roof cover . Align roof cover equally to both sides. Roof cover goes about  $1 \frac{12}{64}$  in over each sides edge. Staple roof cover on the saunas edge.





**STEP 23:** Fix with wooden slats (Z1) with screws (S7) on the rain jacket bottom.



**STEP 24:** Install front and rear decorative roof finishing boards (W), fixing by screws (S7). Start with a center board placing it at the top of the middle of the sauna, aprox.  $\frac{50}{64}$ in above roof. Then fix next boards right next to previous board.

