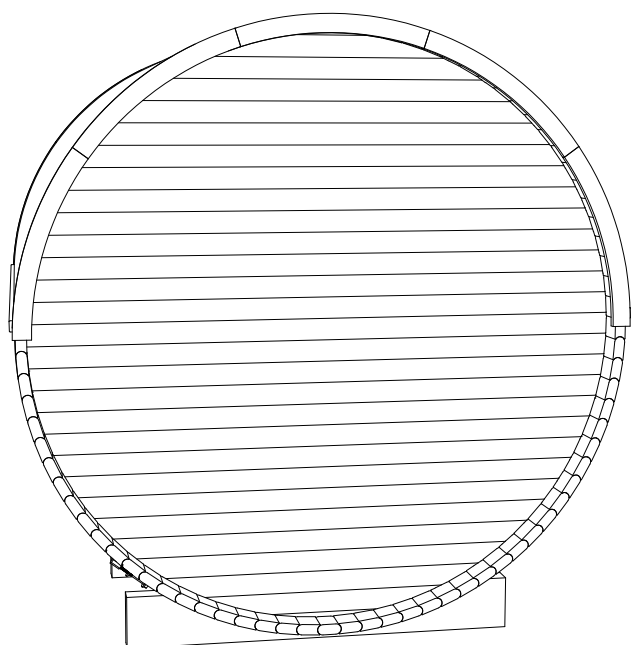
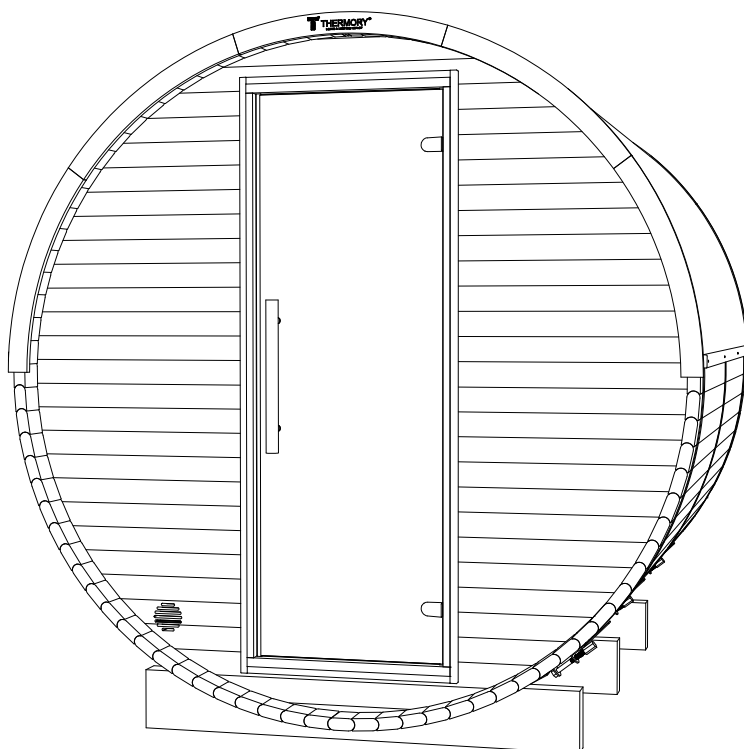
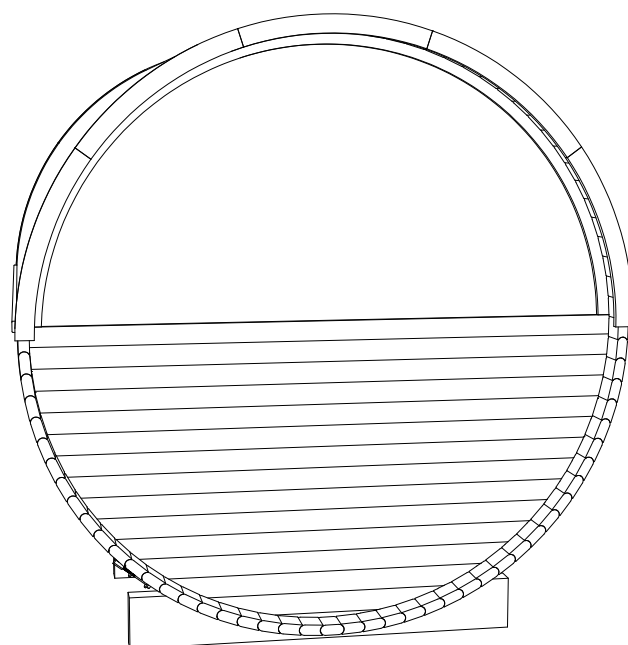


BARREL SAUNA

ASSEMBLY INSTRUCTIONS



Model: No51; No53; No63

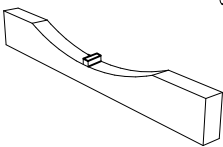
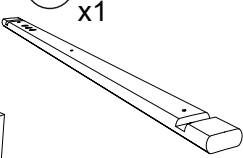
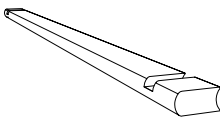
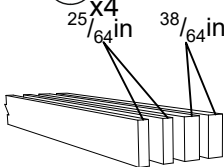
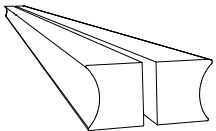
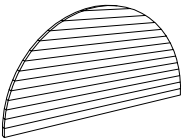
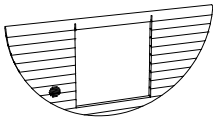
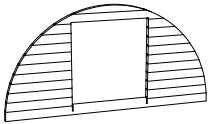

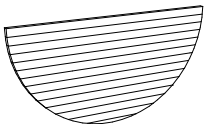
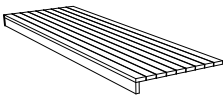
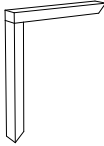
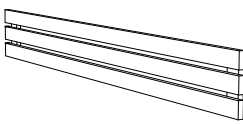
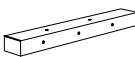


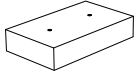
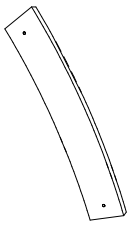

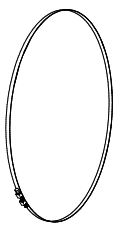




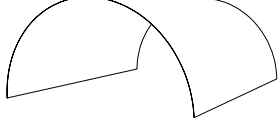




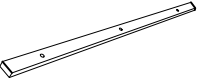


Model: No50; No52; No62

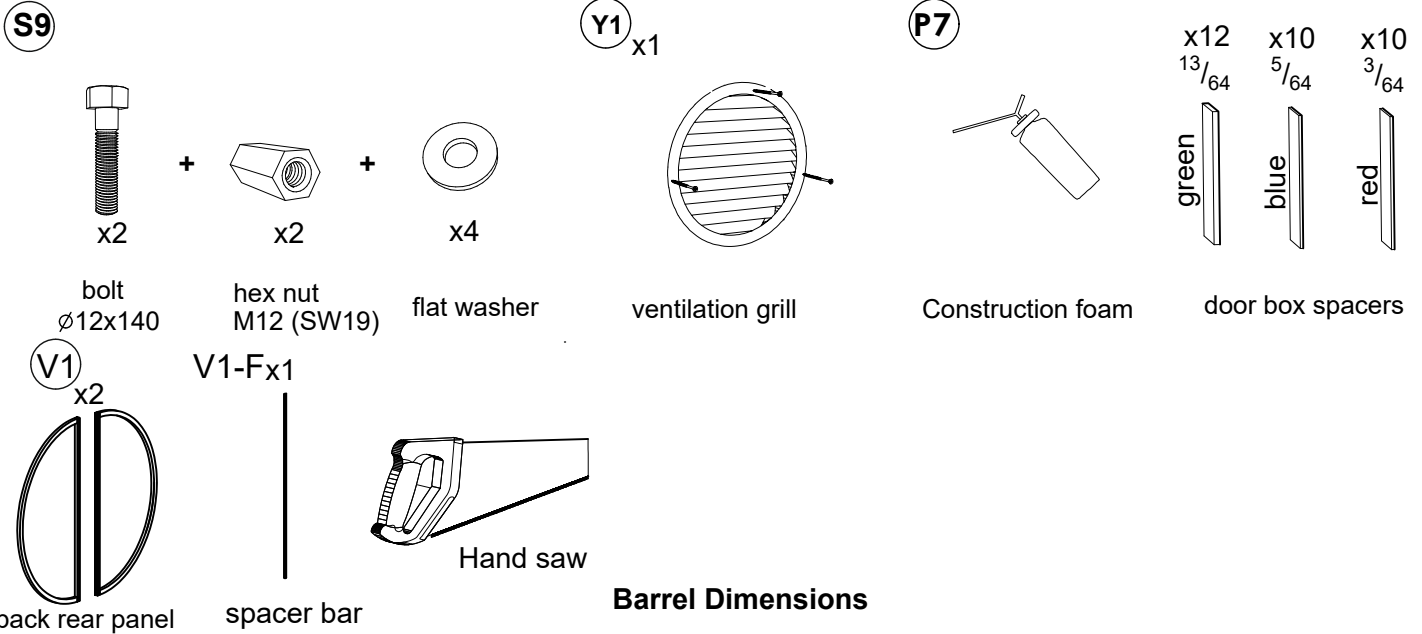
Note: Please read the manual before construction

Rev. 23.09.2024.

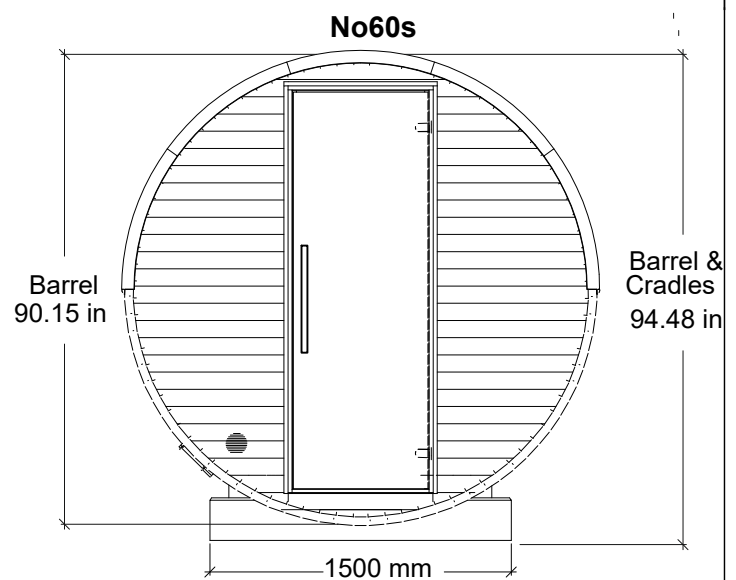
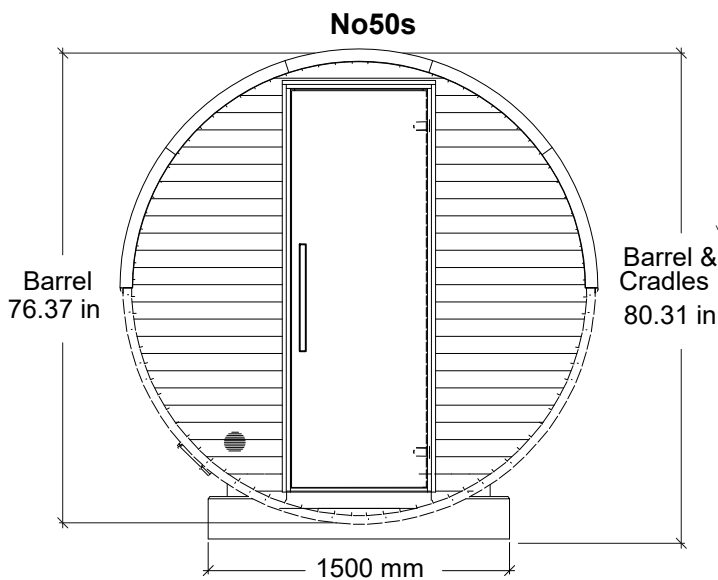
PART LIST

A x3  cradle	B x1  center stave	C No50s No60s x74 x88  body stave	H1 x4 25/64in 38/64in  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 x3  metal band
S1 No50s No60s x45 x50  screw 5.0x100 SS	S10 No50s No60s x135 x160  screw 4.0x60	S5 No50s No60s x25 x50  screw 4.0x50 SS	S4 x11  screw 5.0x120	Z x1  Waterproof roof cover
S6 x30  screw 5.0x70 SS	S7 x35  screw 4.2x55 brown	S2 x25  screw 4.0x70 SS	S14 x10  screw 5.0x80	Z1 x2  Slat for roof cover

PART LIST



Barrel Dimensions



RECOMMENDATION



2 person recommended

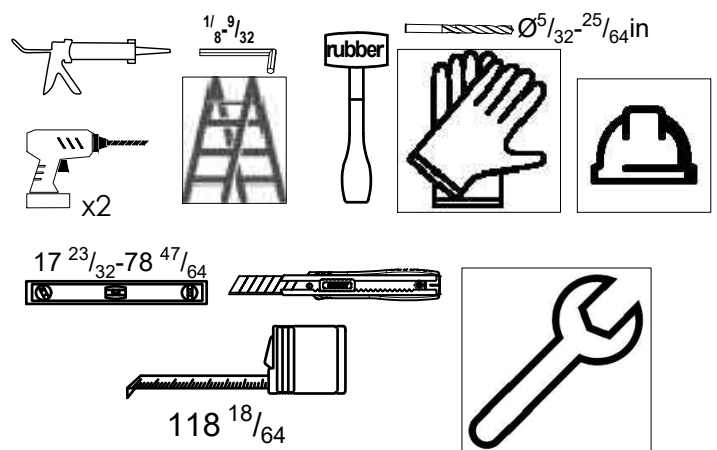
Before you begin, be sure the sauna will fit in your chosen location.

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

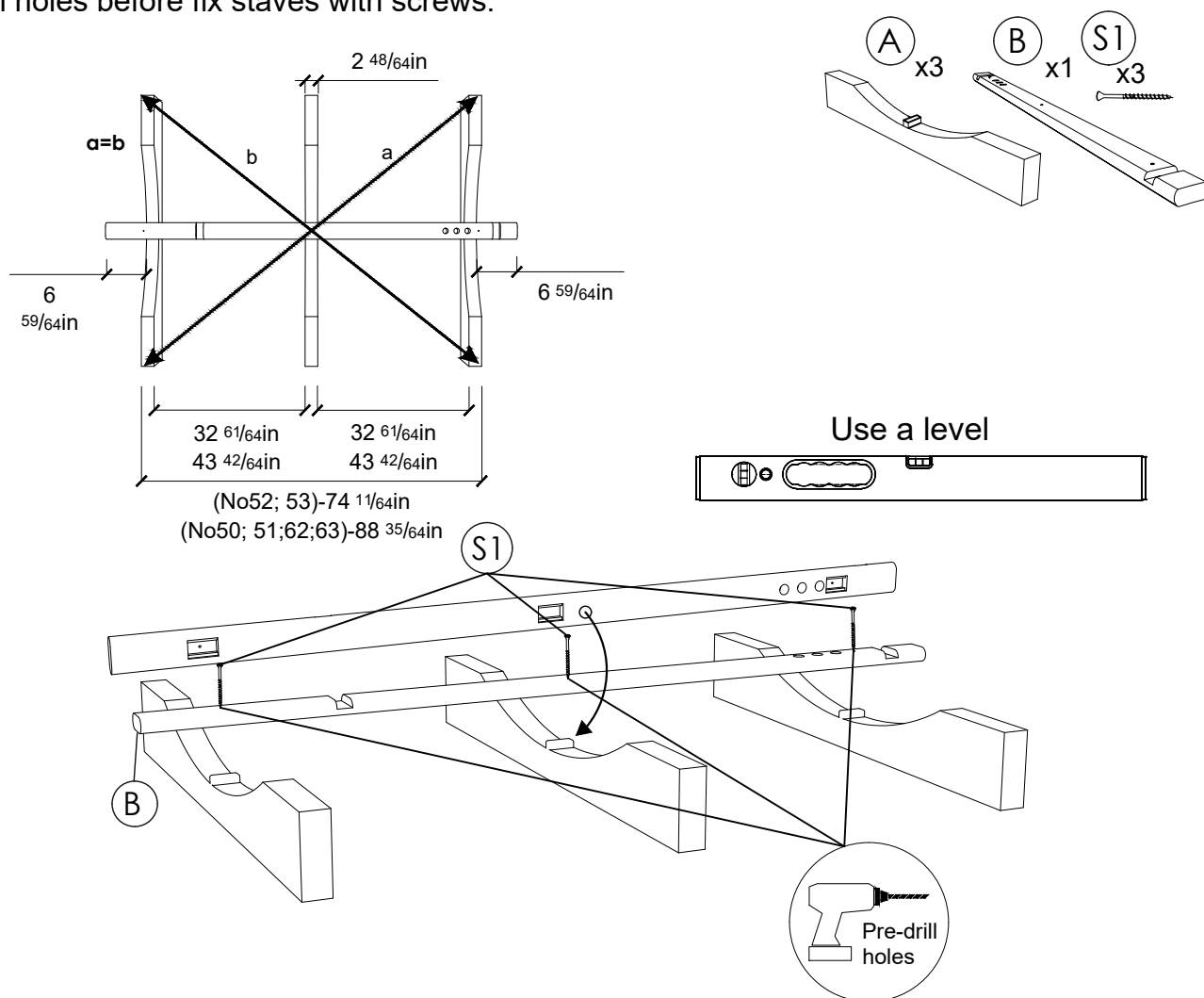
Concrete, pavers or crushed stone is preferred.

Check parts before construction.

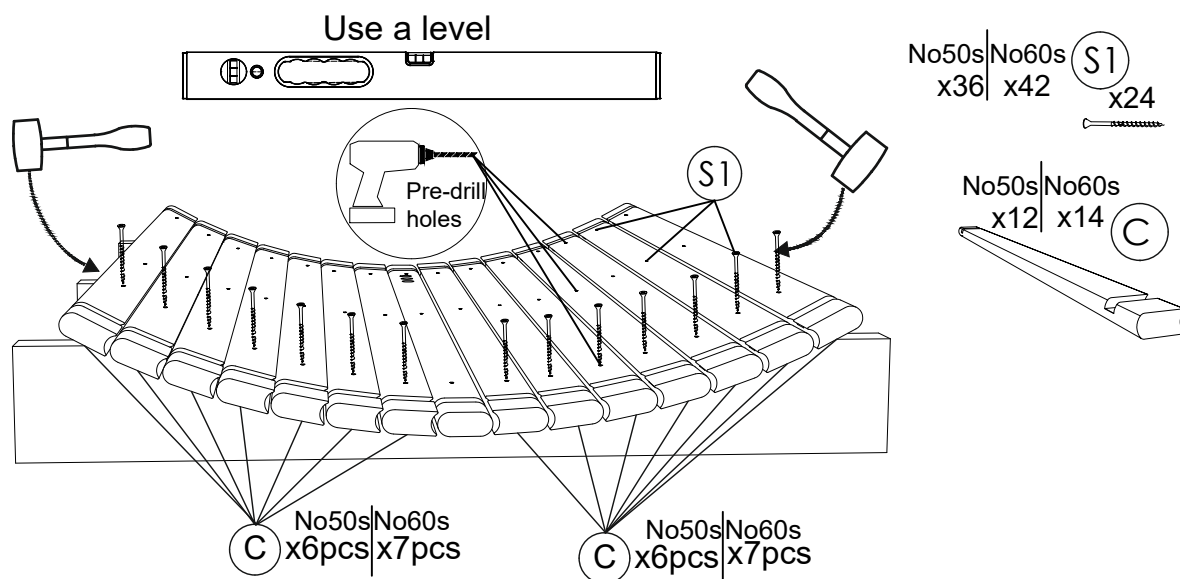
TOOLS REQUIRED



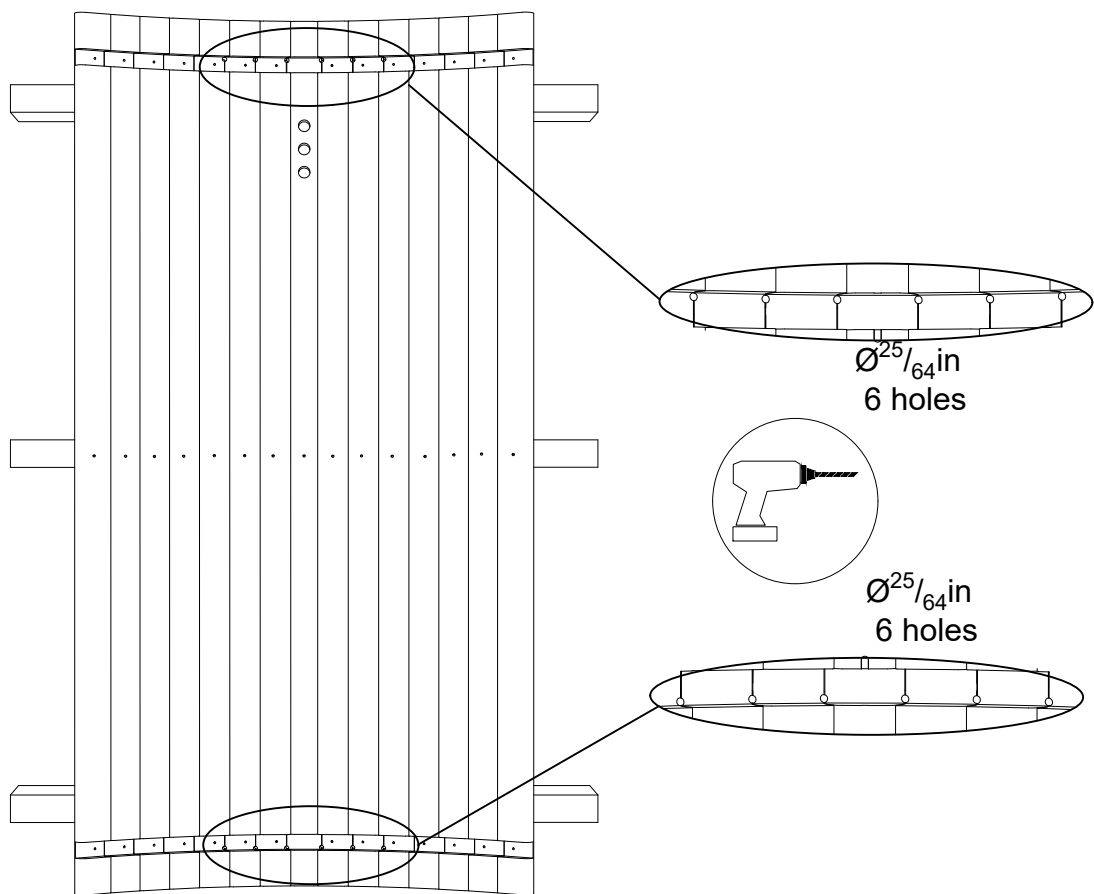
STEP 1: Measure support cradles (A) diagonally from corner to corner. Measurements “a” and “b” should be equal to ensure the cradles are square. Be sure cradles remain level. Place the support cradles (A) on level site. Carefully level for better stability. Place the center stave (B) on wooden dowels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



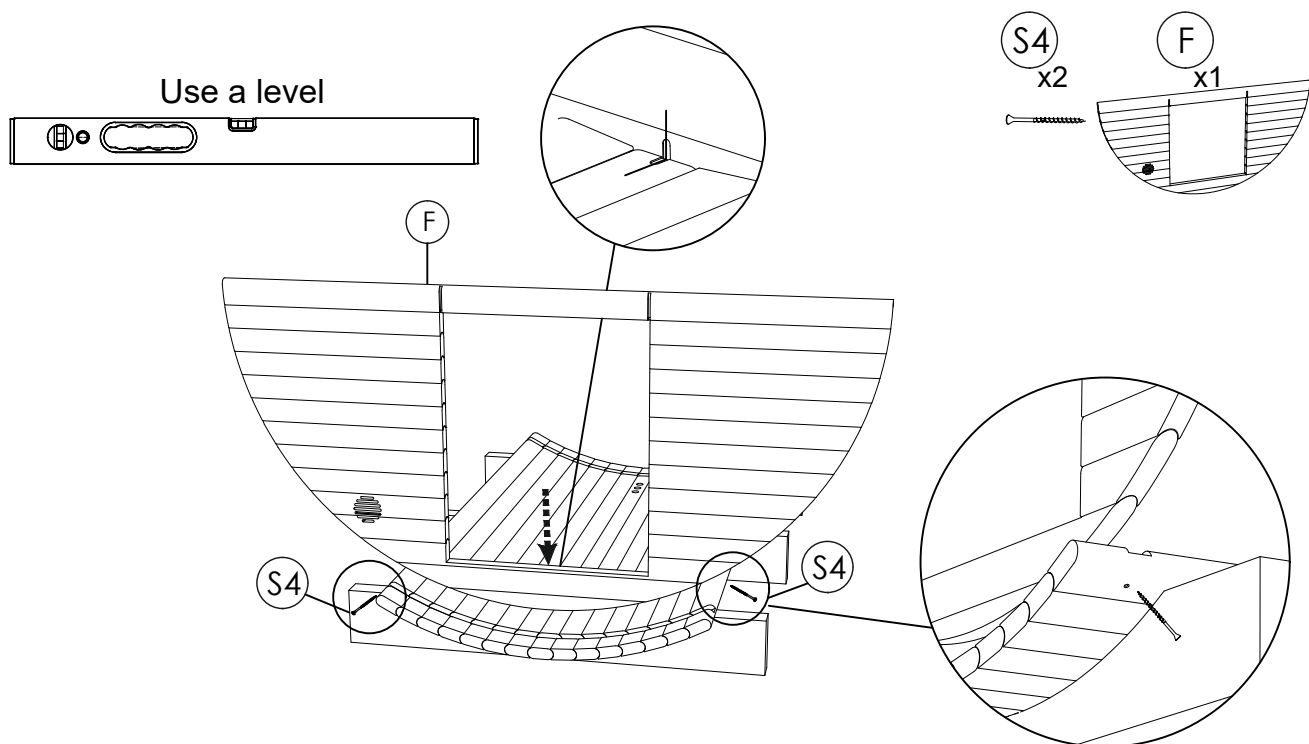
STEP 2: Pre-drill holes before fix staves with screws. Place 6 (No50s) or 7 (No60s) sauna body staves (C) to each side of the center stave (B) and fix with screws (S1). Be sure to align the panel groove on every next body stave, to do that use rubber hammer.



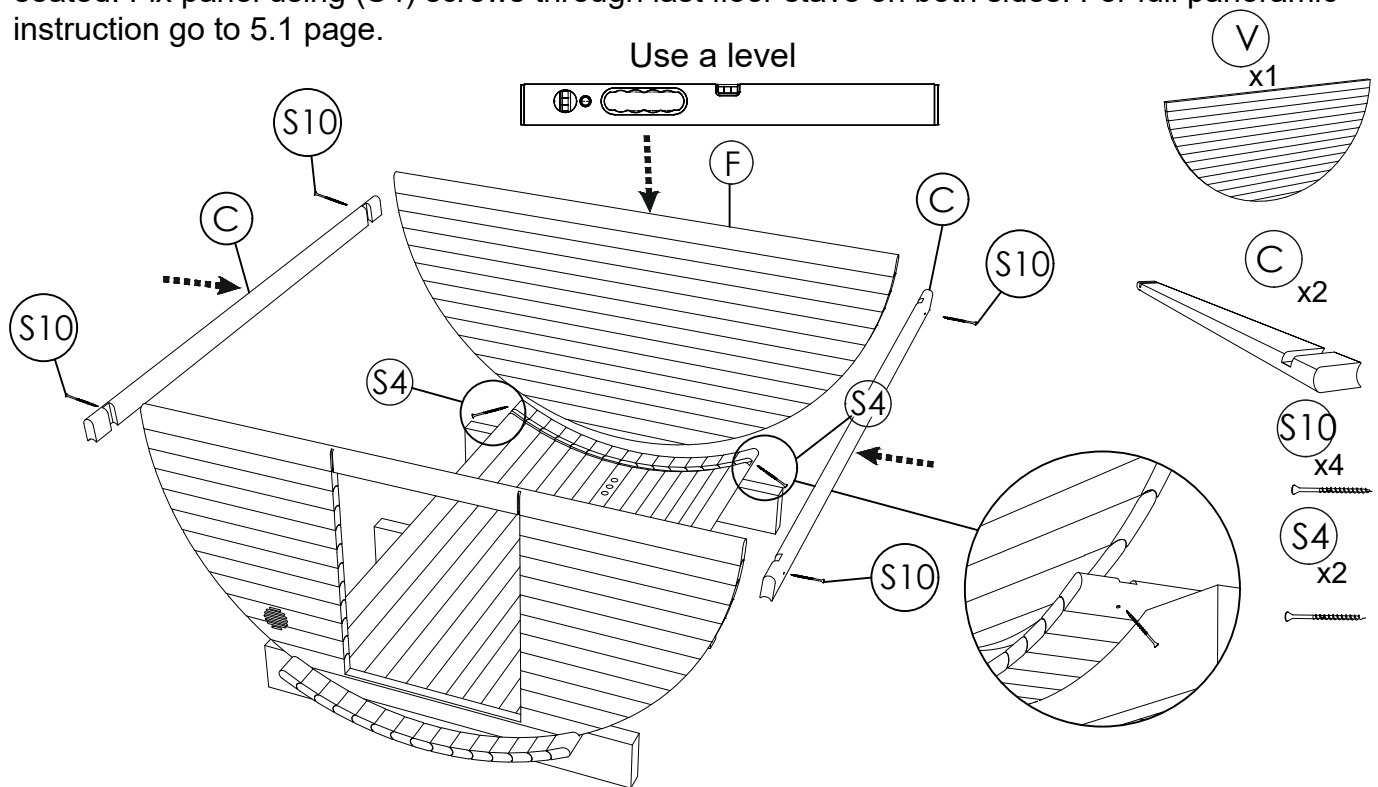
STEP3: Drill six $\frac{25}{64}$ in holes in front and back wall groove to the out-side in board connections as shown in the picture. This will help drain excess water faster.



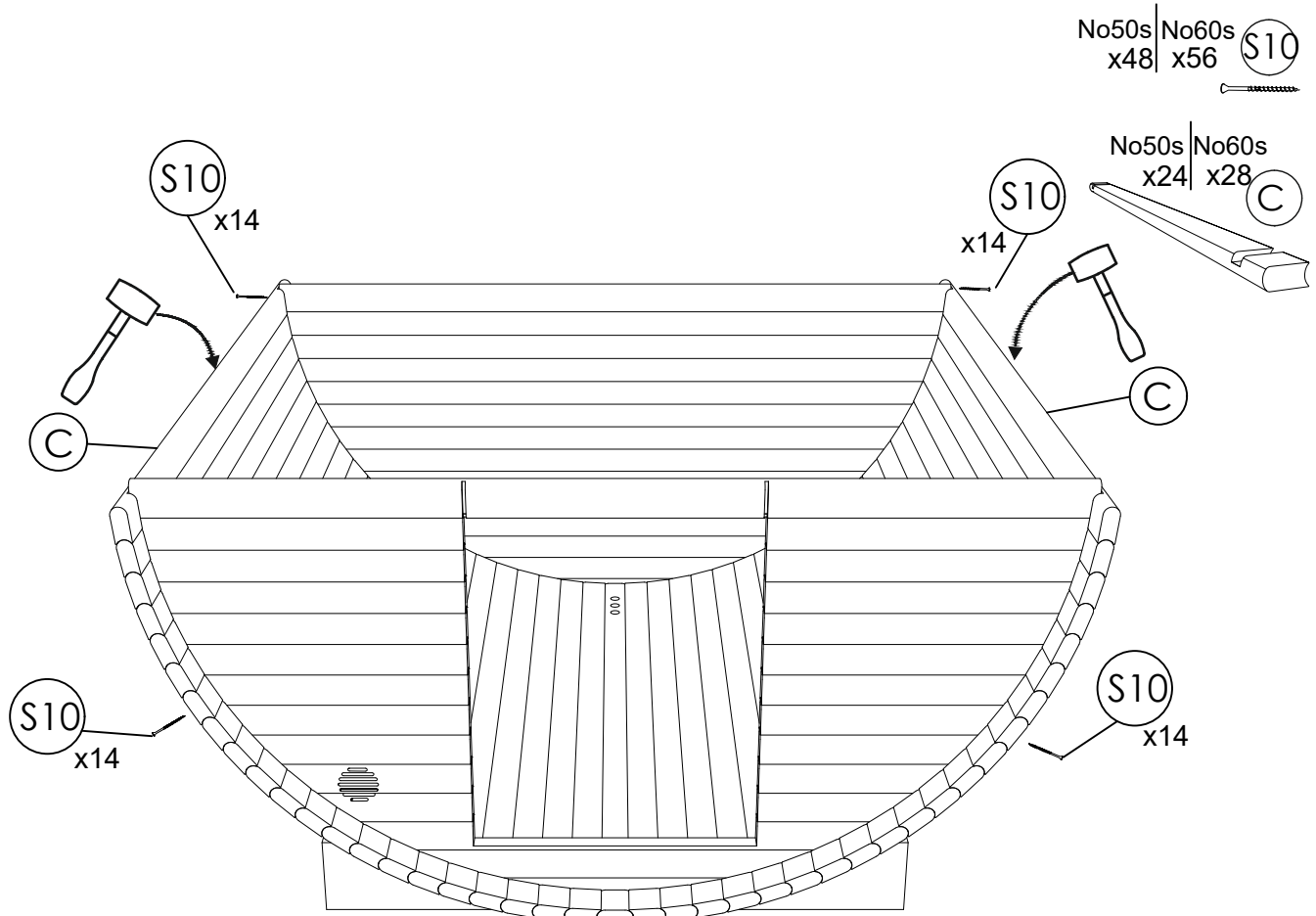
STEP 4: Place front bottom panel (F) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides.



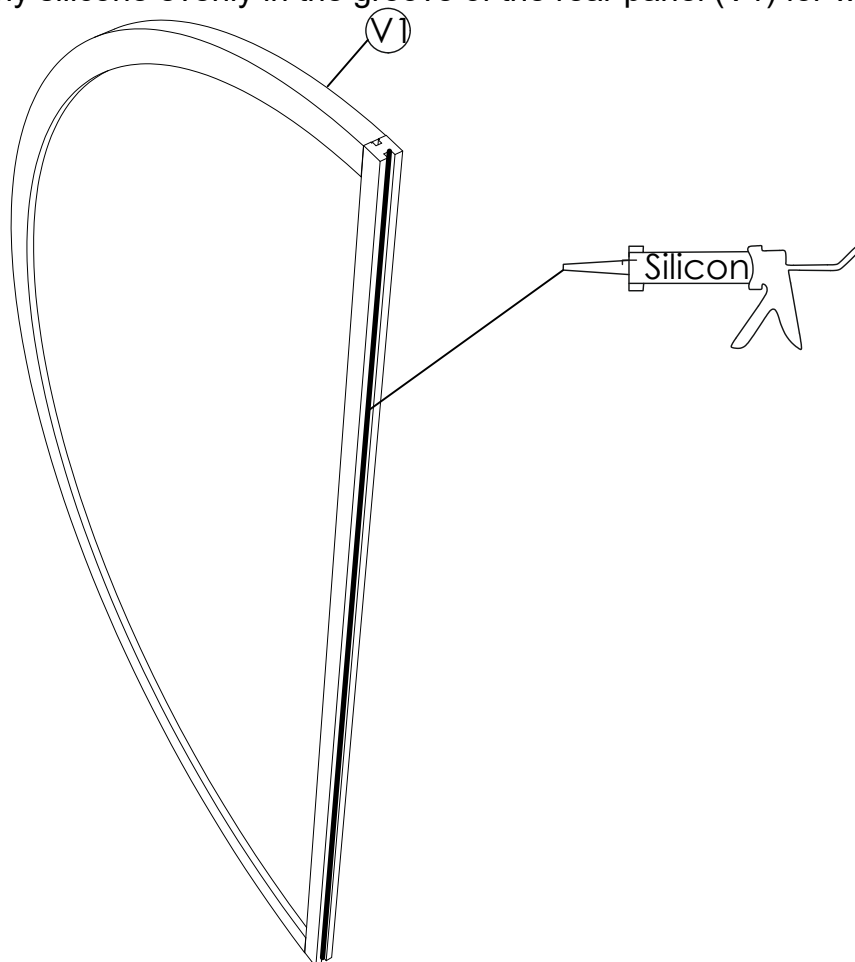
STEP 5: Place rear panel (V) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides. For full panoramic instruction go to 5.1 page.



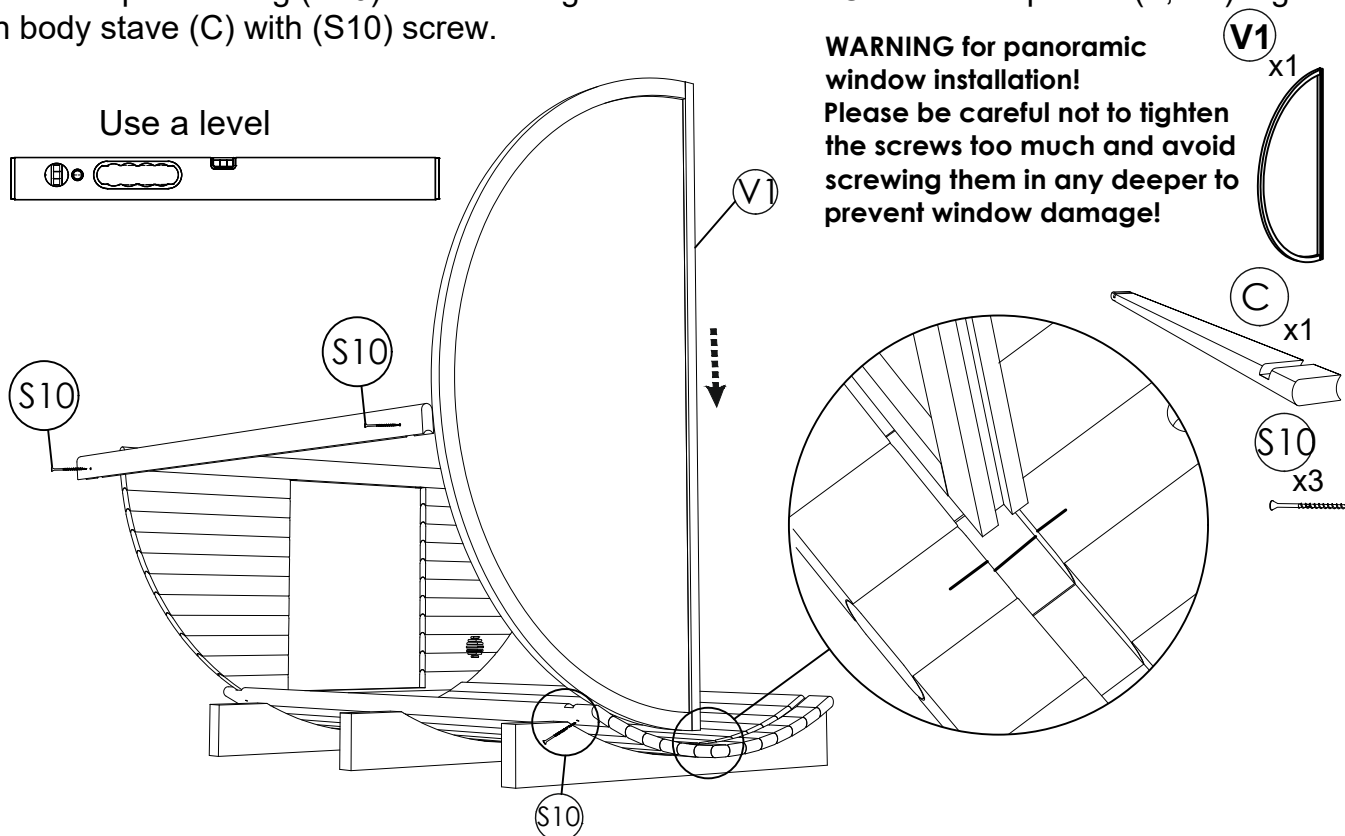
STEP 6: Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10) . Fix one stave higher on left side than at right.



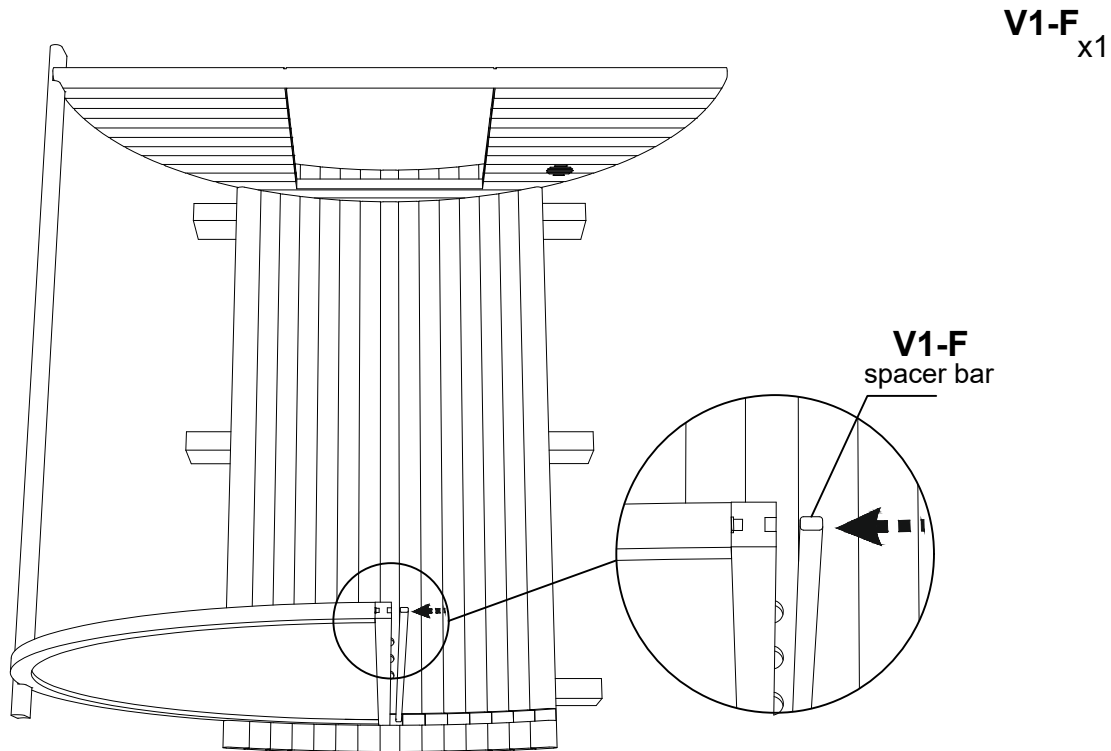
STEP 1: Apply silicone evenly in the groove of the rear panel (V1) for wood spacer bar (V1-F).



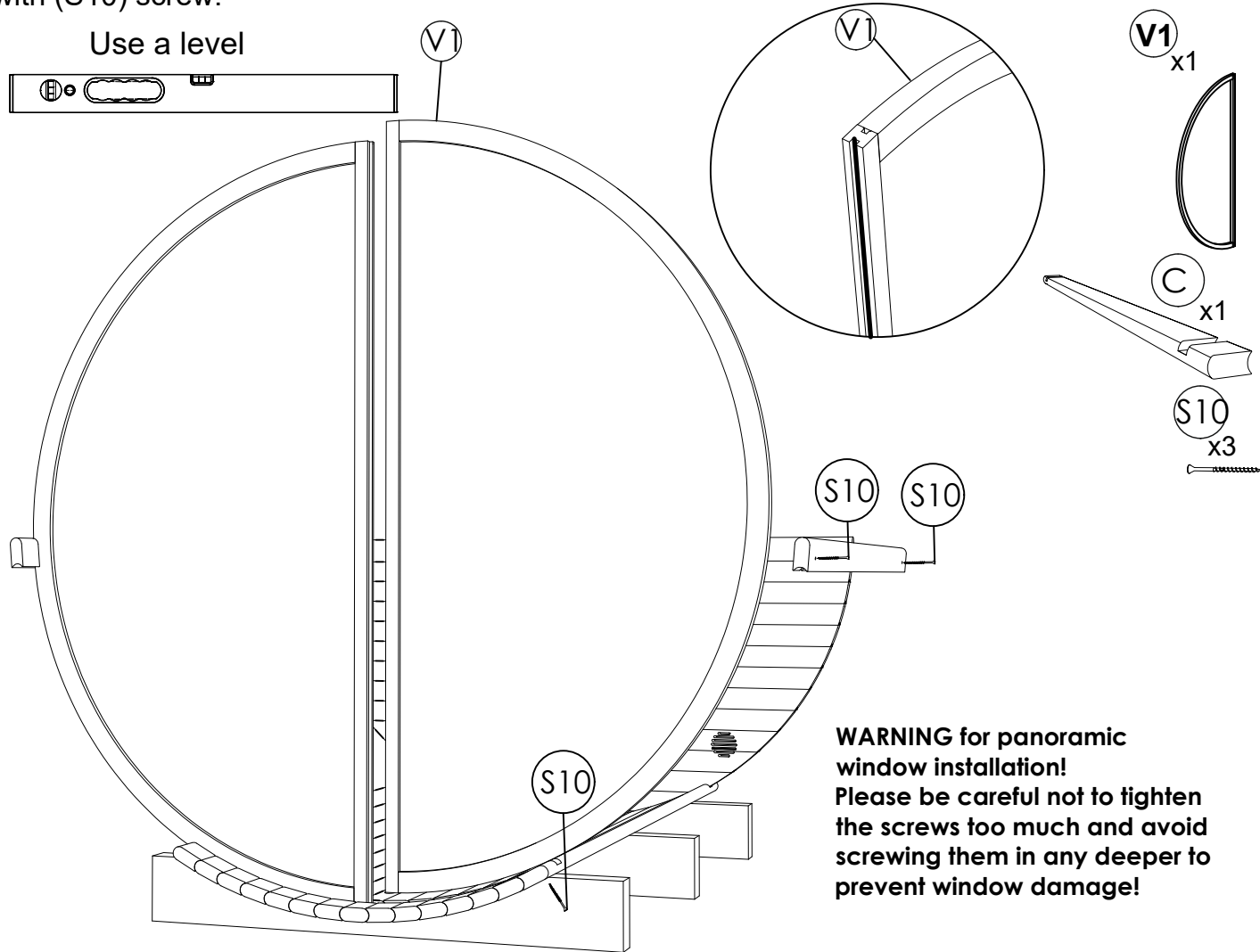
STEP 2: Place rear panel (V1) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S10) screw through last floor stave. Connect the panels (F; V1) together with body stave (C) with (S10) screw.



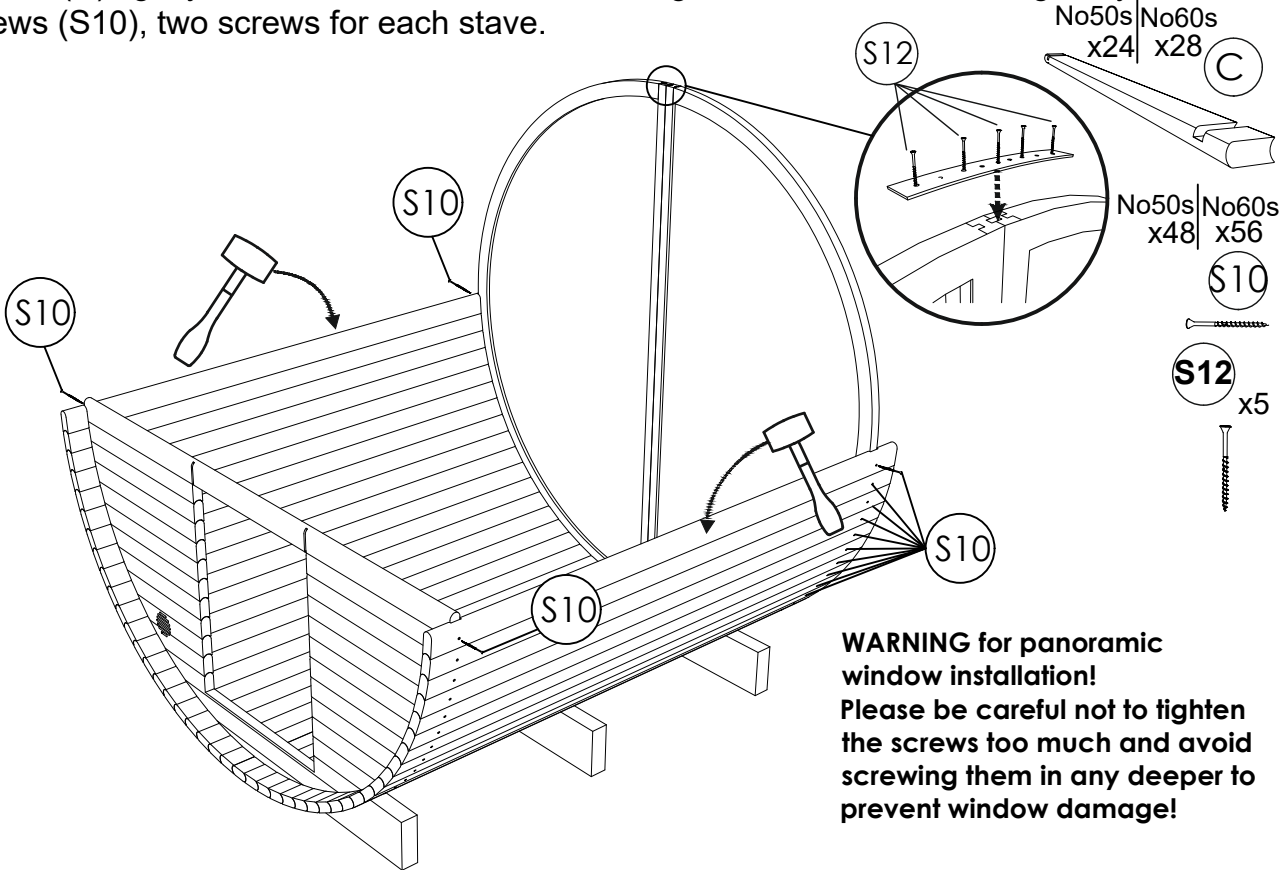
STEP 3: Insert wood spacer bar (V1-F) in to the fixed rear panel (V1).



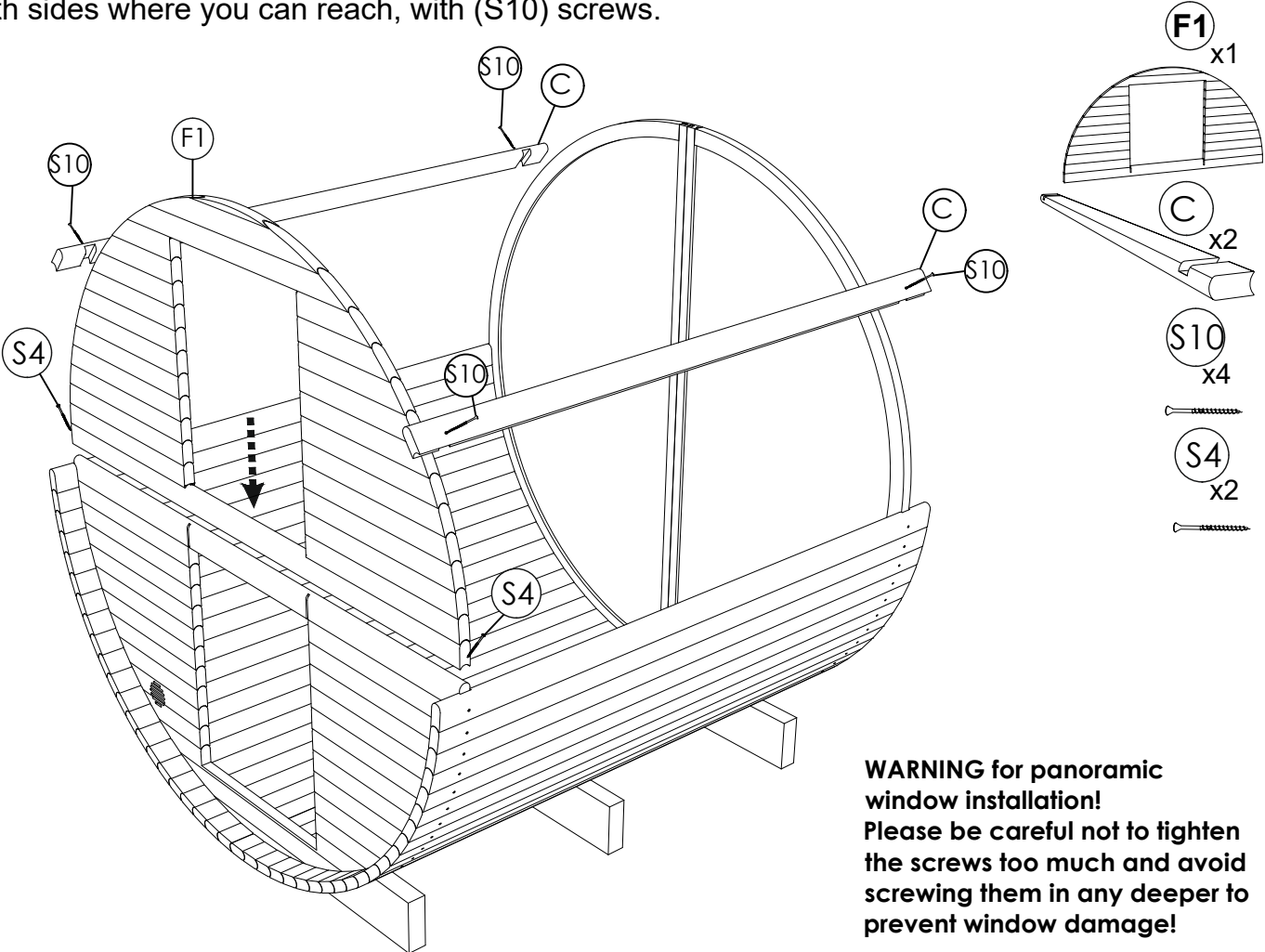
STEP 4: Apply silicone evenly in the groove of the second rear panel (V1). Place second rear panel (V1) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S10) screw through last floor stave. Connect the panels (F; V1) together with body stave (C) with (S10) screw.



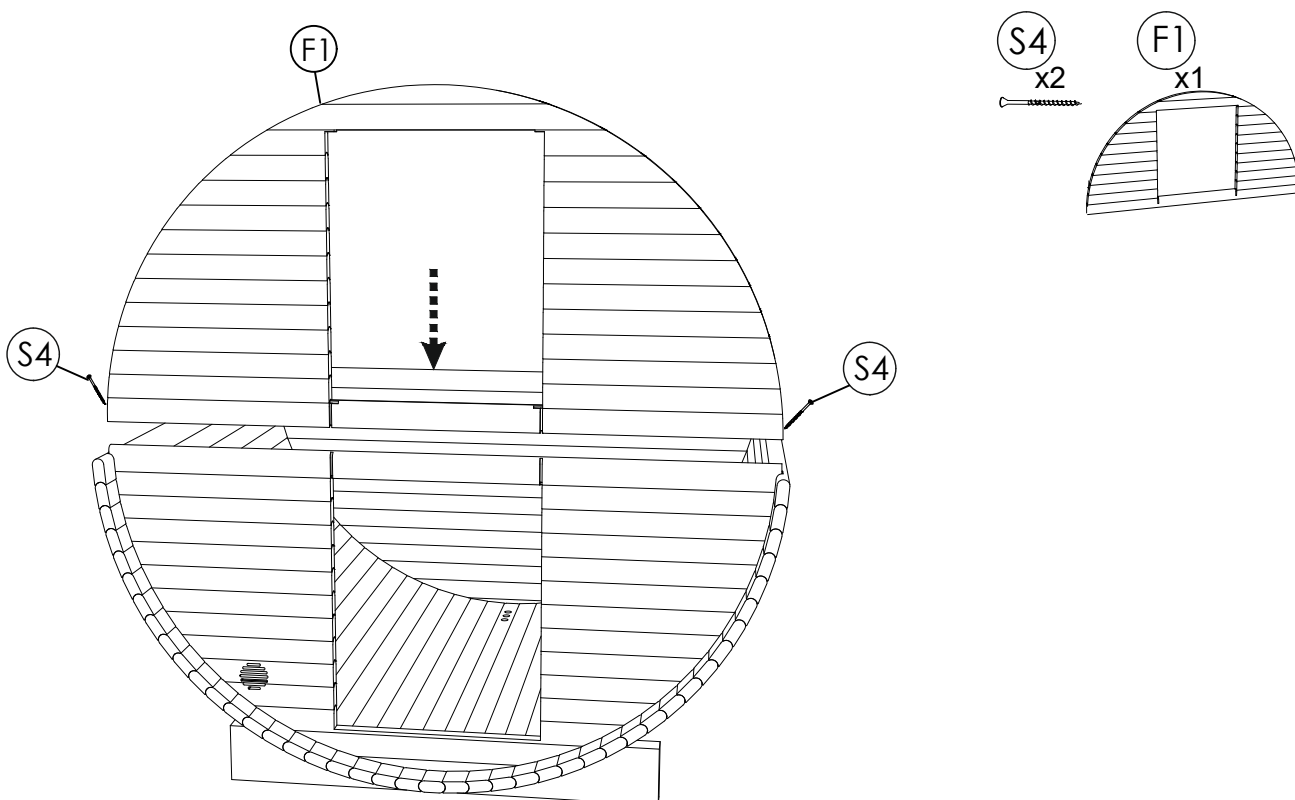
STEP 5: Fix Assembly tape with five screws (S12) to fix both panels together. Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10), two screws for each stave.



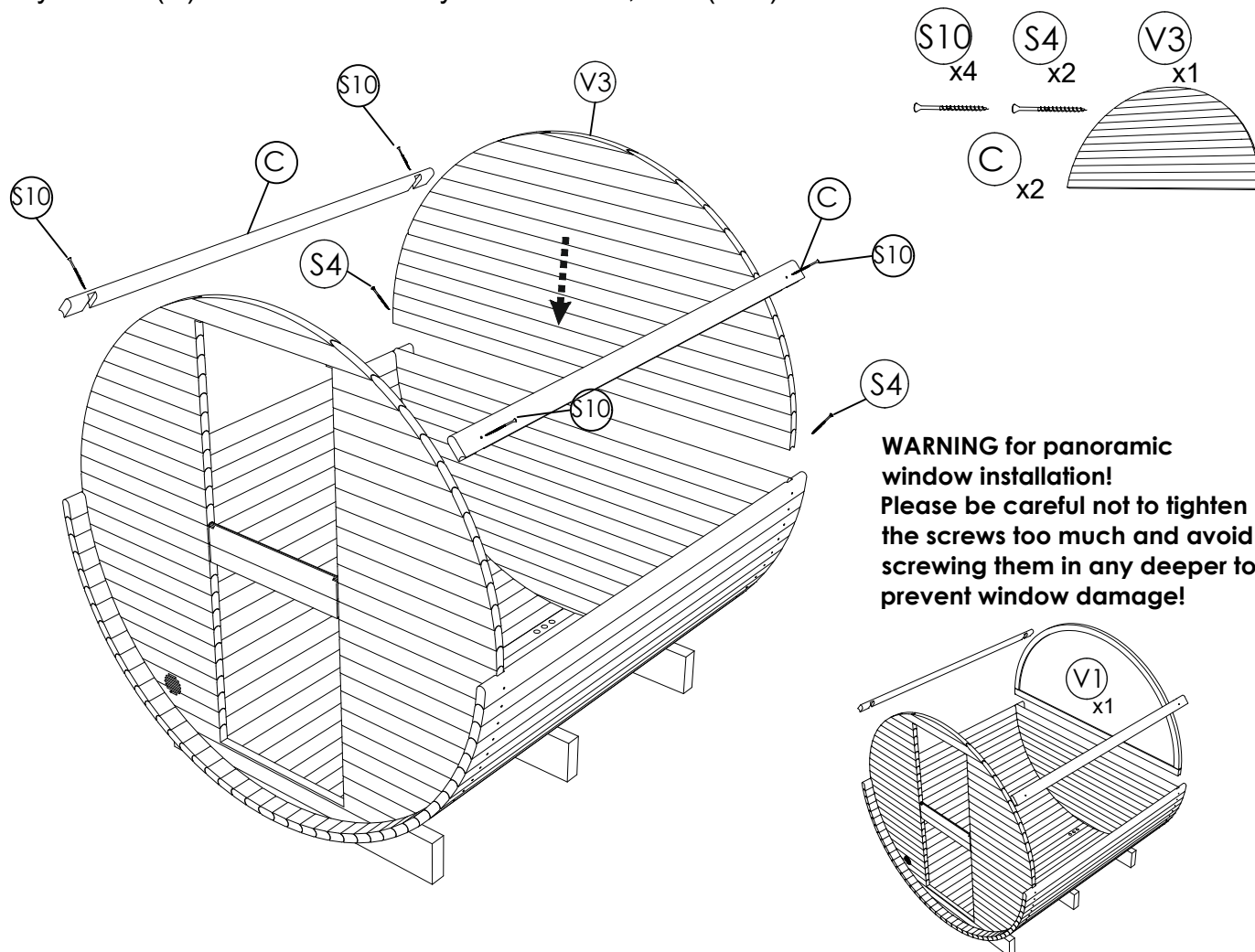
STEP 6: Take the upper front panel (F1) and place it on top of the front panel (F). Secure it by using 2 screws (S4). Connect the panels (F1; V1) together by placing one body stave (C) on both sides where you can reach, with (S10) screws.



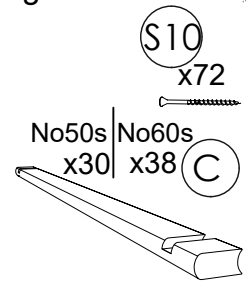
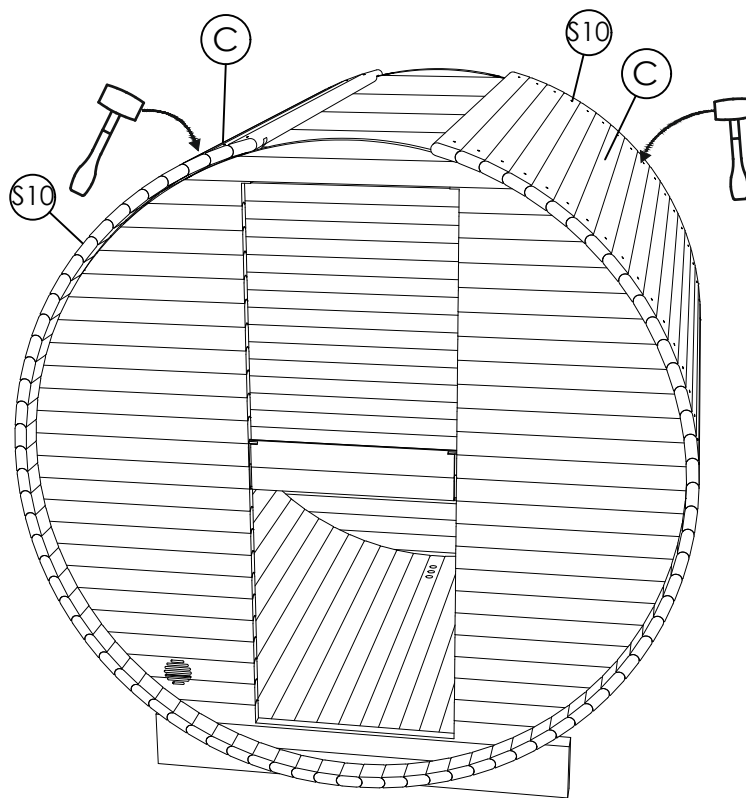
STEP 7: Place front top panel (F1) on front bottom panel (F), be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws on both sides.



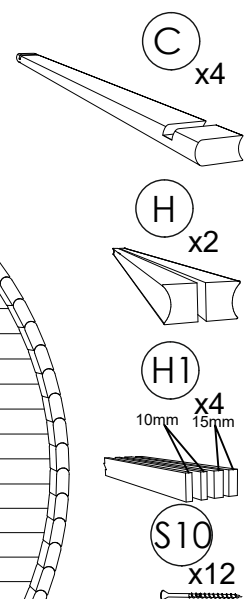
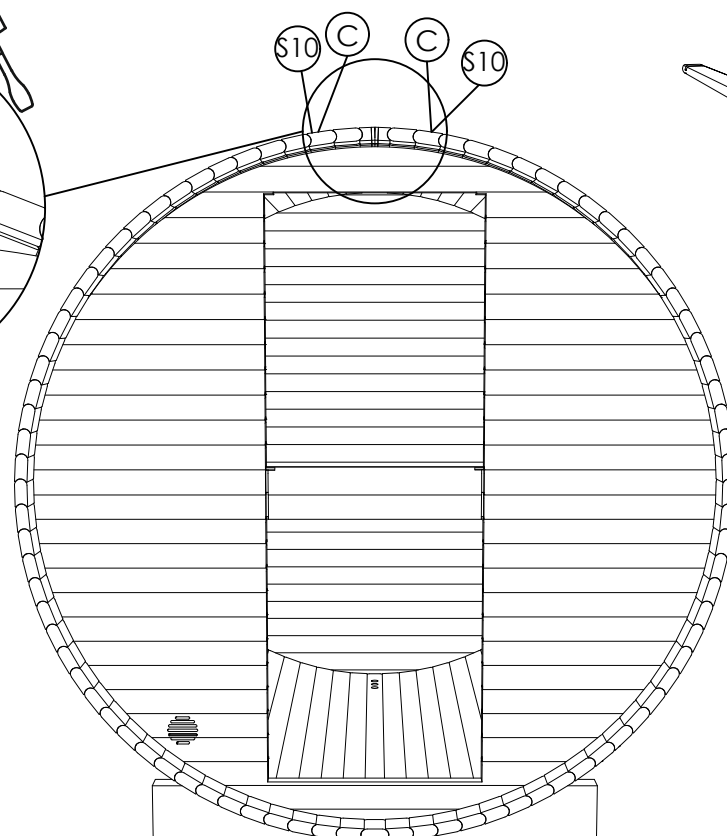
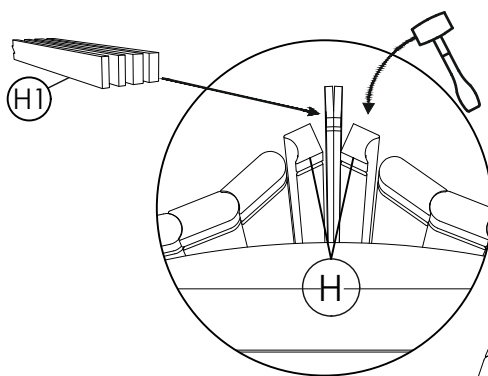
STEP 8: Take the upper rear panel (V3 or V1-panoramic window) and place it on the bottom rear panel (V). Secure it by using 2 screws (S4). Connect the panels (F2; V3) together by placing one body staves (C) both sides where you can reach, with (S10) screws.



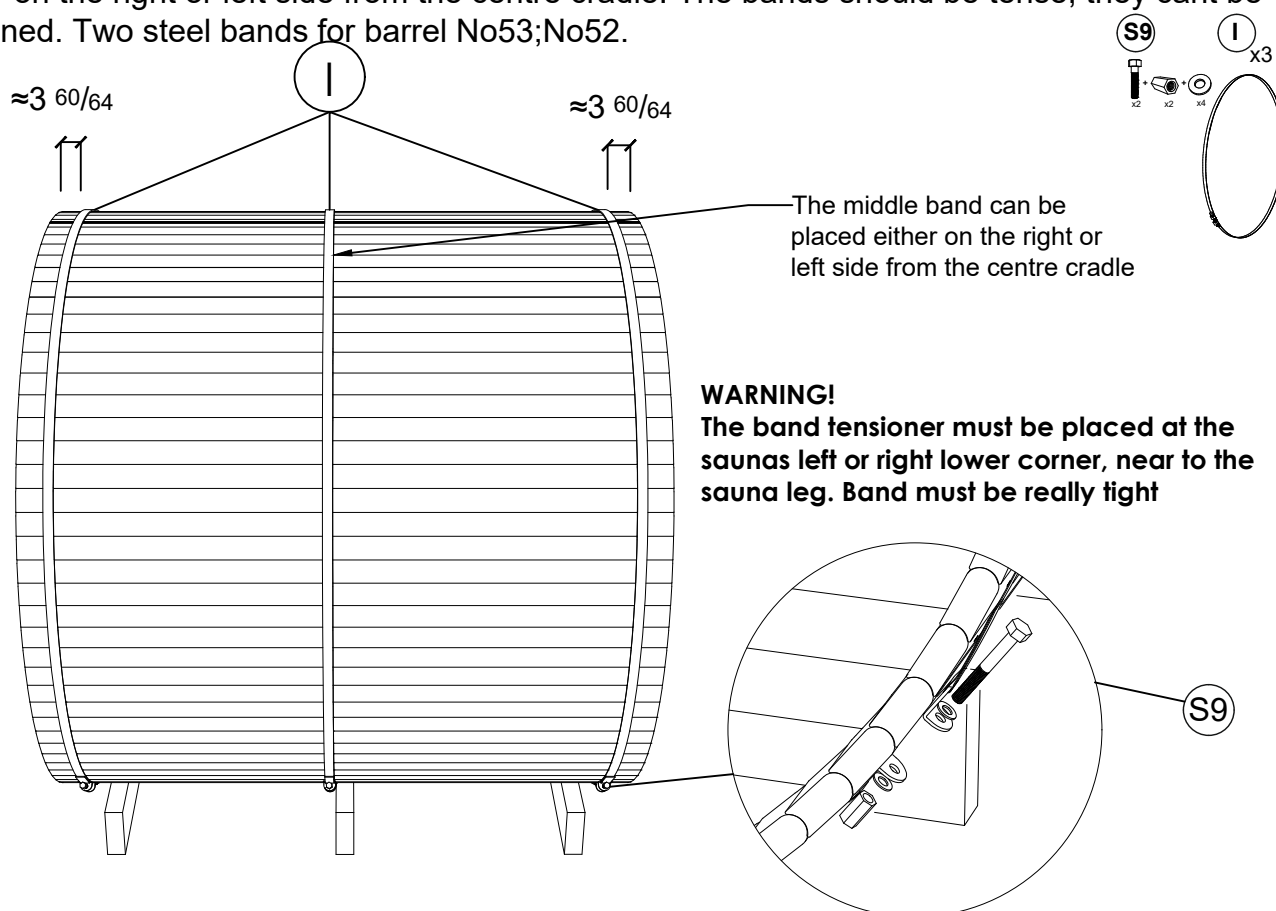
STEP 9: Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws(S10).



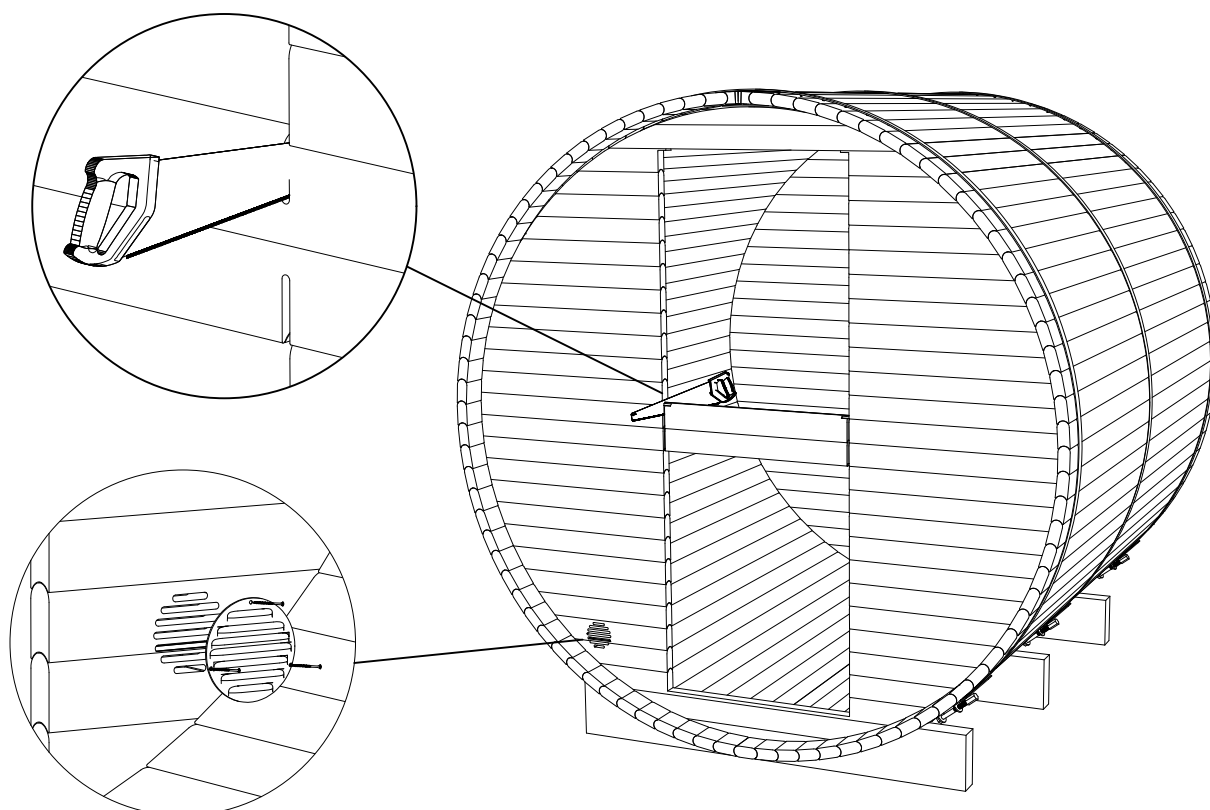
STEP 10: To finish the roof top joint, don't screw about last 2-3 boards (C) to each side, use roof finishing item (H). Different thickness filling pieces (H1) are provided to completely fill the gap. Once necessary parts are in, fix last boards with screws.



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 no more than $3 \frac{60}{64}$ in from sauna front and back edges. Bands should cover screw heads evenly. The middle band can be placed either on the right or left side from the centre cradle. The bands should be tense, they cant be loosened. Two steel bands for barrel No53;No52.

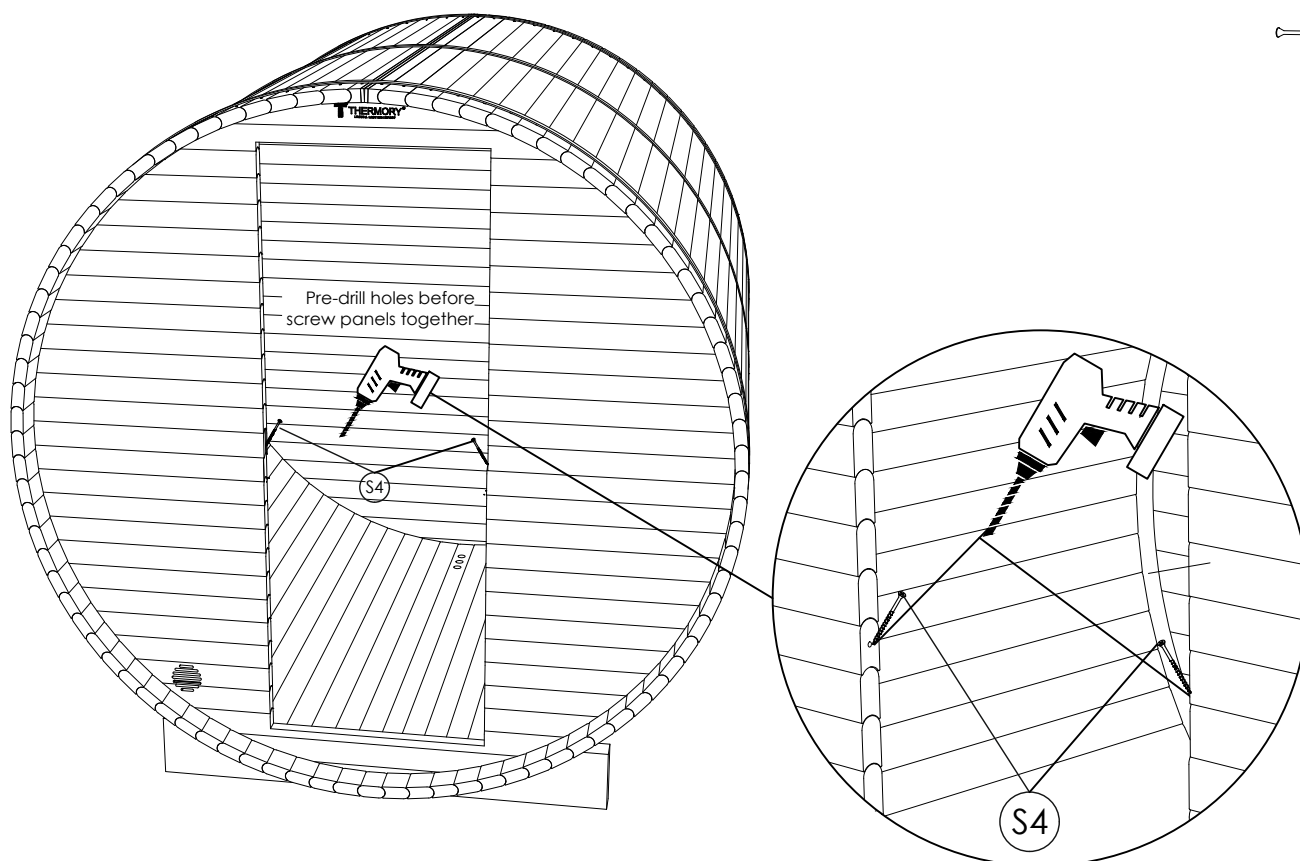


STEP 12: Draw straight line to connect both cuts. Use hand saw or other cutting machine to saw out excess boards for door box. It's recommended to saw out boards from inside. Fix ventilation grill (Y) from inside on ventilation cuts.



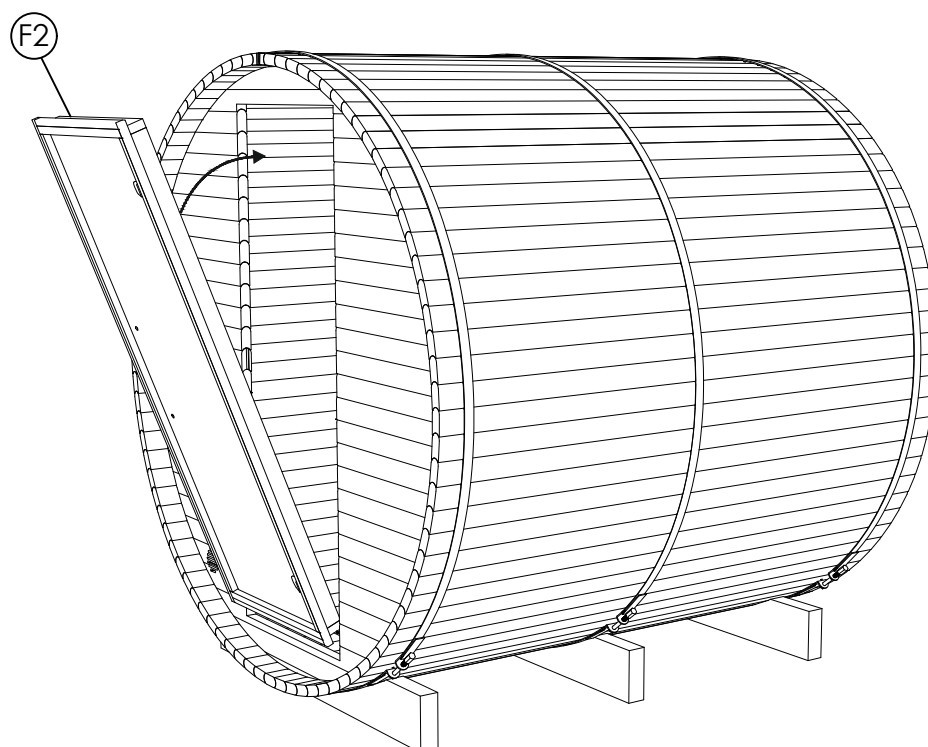
STEP 13: Pre-drill holes for screws. Fix both panels together using (S4) screws.

(S4)
x2

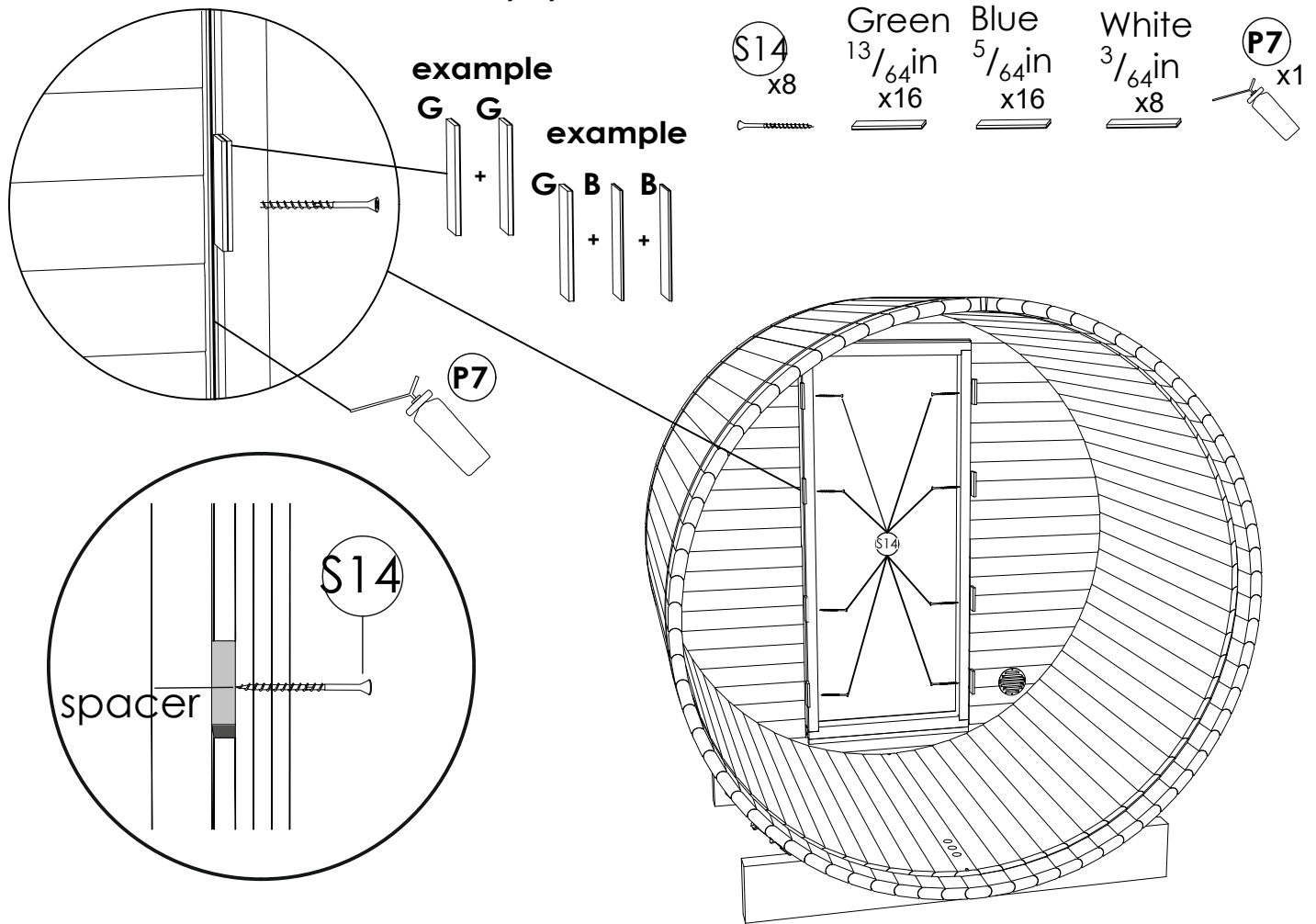


STEP 14: Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.

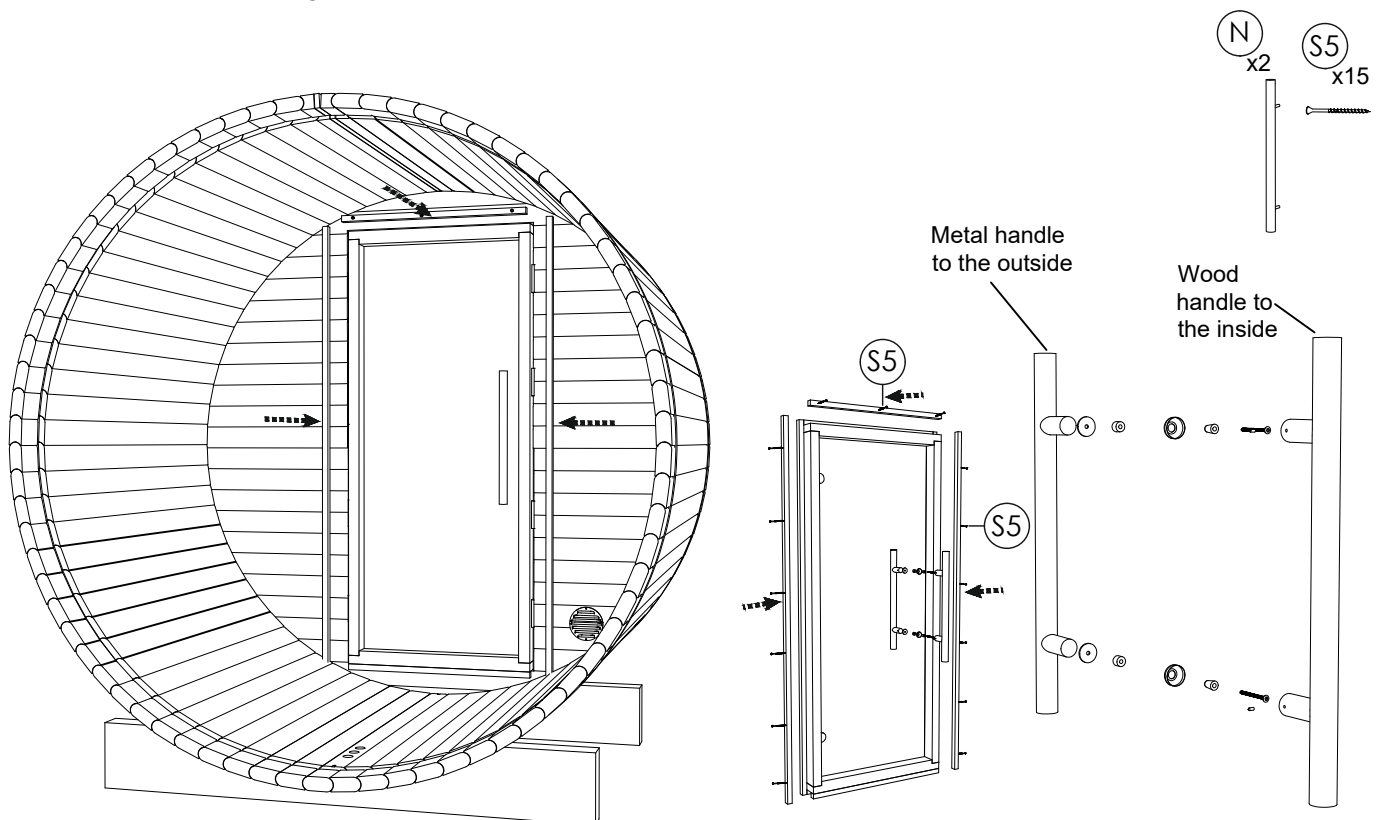
(F2)
x1



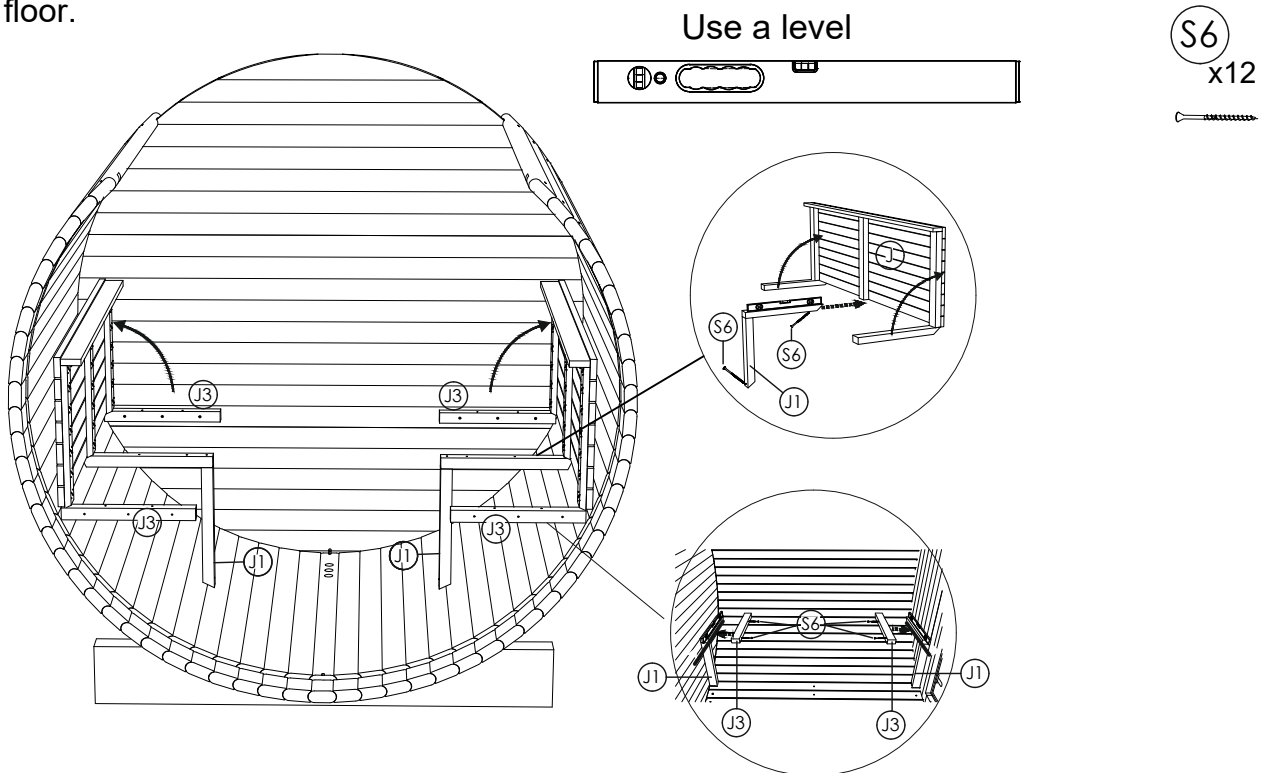
STEP 15: Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. First, fix one side of the door box with screws (S14) through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly, they 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.



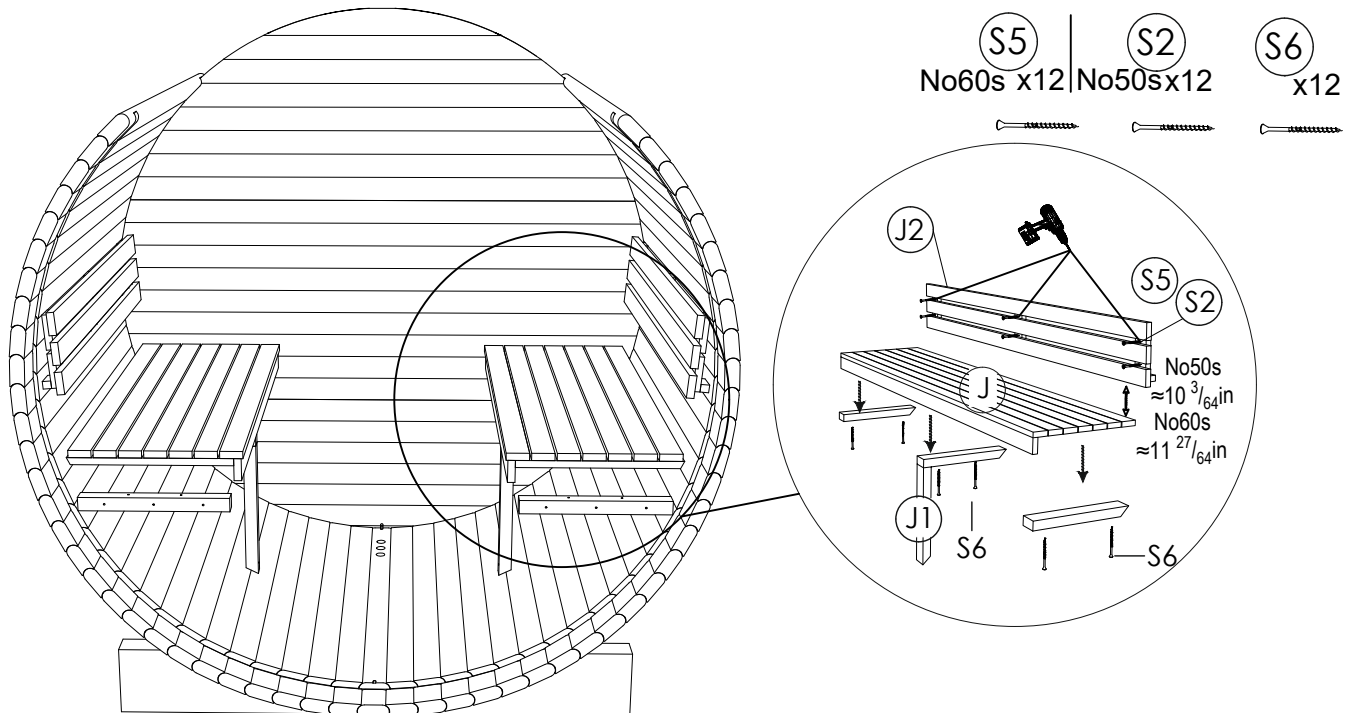
STEP 16: Fix door moldings to both sides and on top of the door with S5 screws 4x50ss.



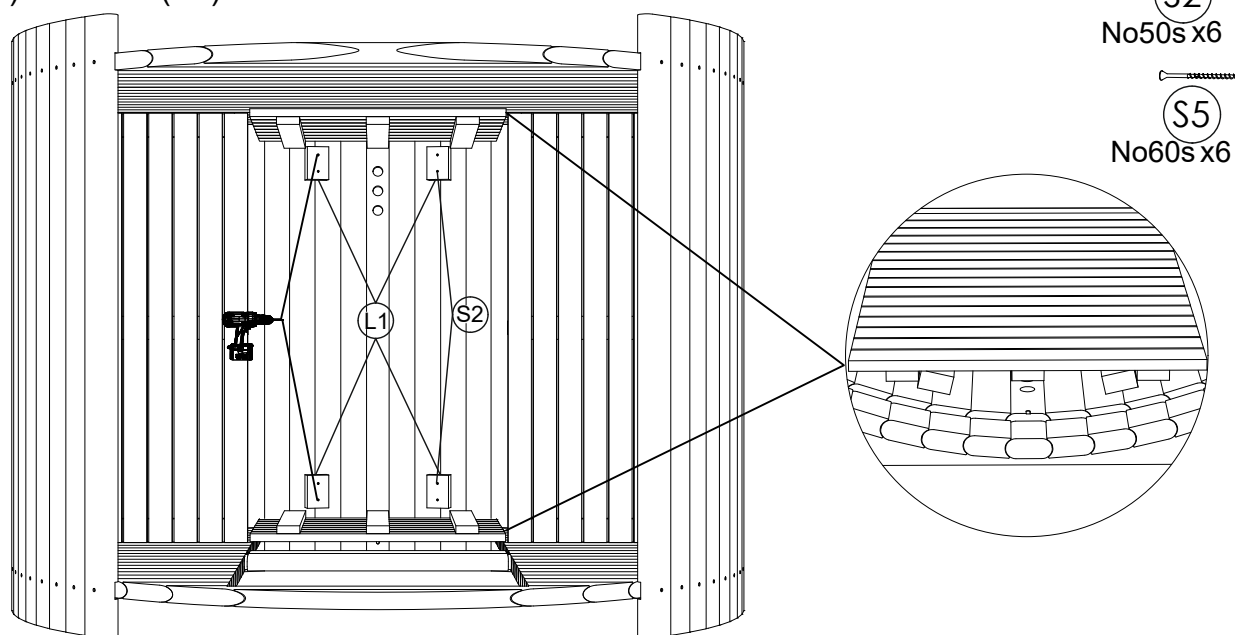
STEP 17: To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, mark a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall mounts.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



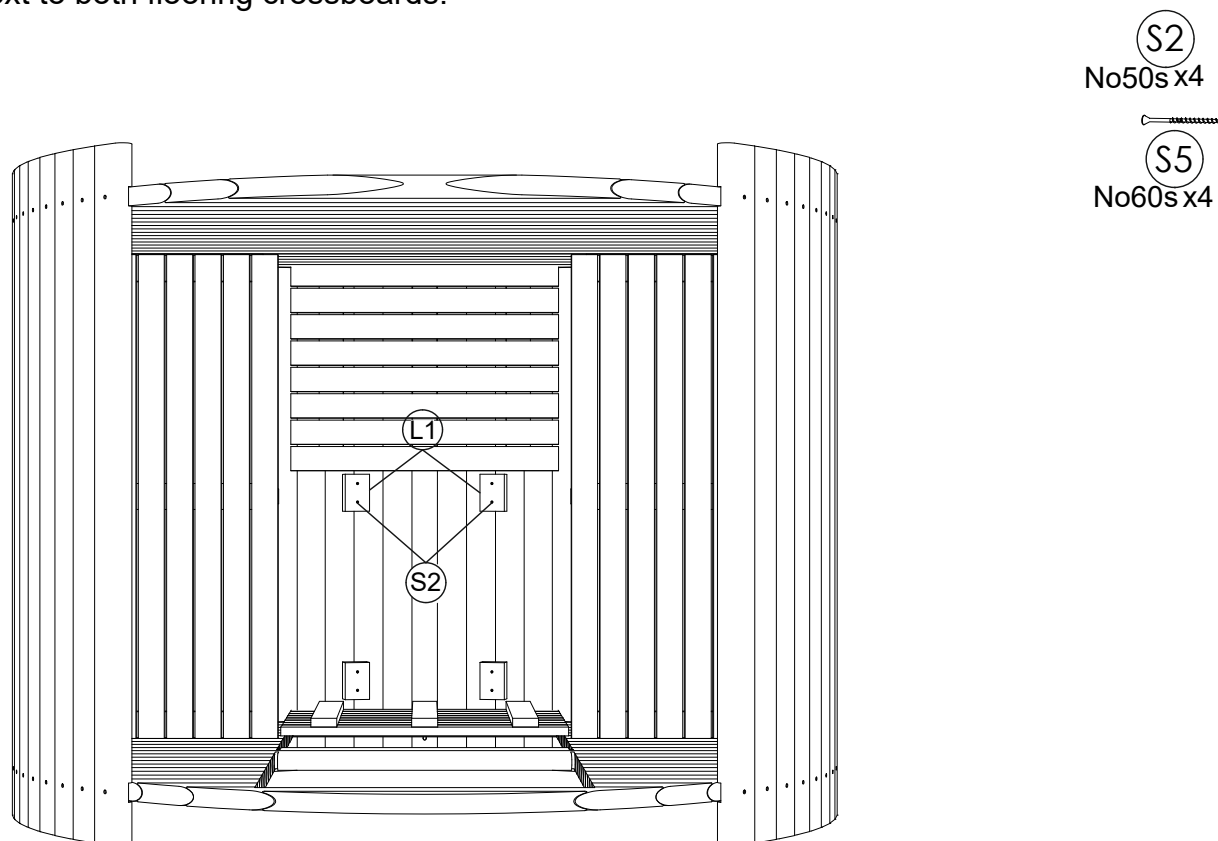
STEP 18: Pre-drill holes before fix backrest with screws, install backrests (J2) using screw (S2). Fix sauna bench (J) to wall mounts and support leg using (S6) screws.



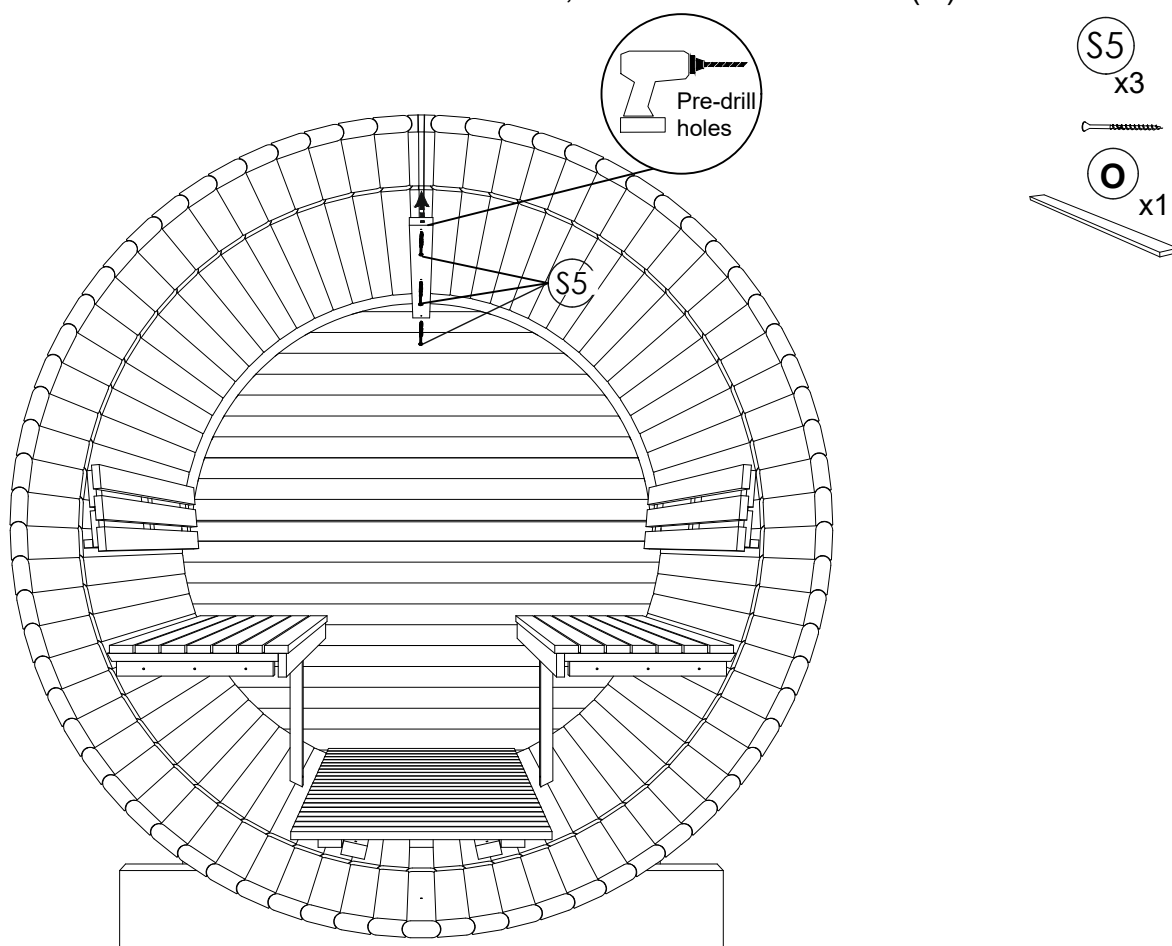
STEP 19: Place floor duckboards (L) to the both sides upwards and place fixing blocks next to the flooring cross boards. Pre-drill holes before fix with screws, install fixing blocks (L1) using screw(S2)No50s or (S5)No60s.



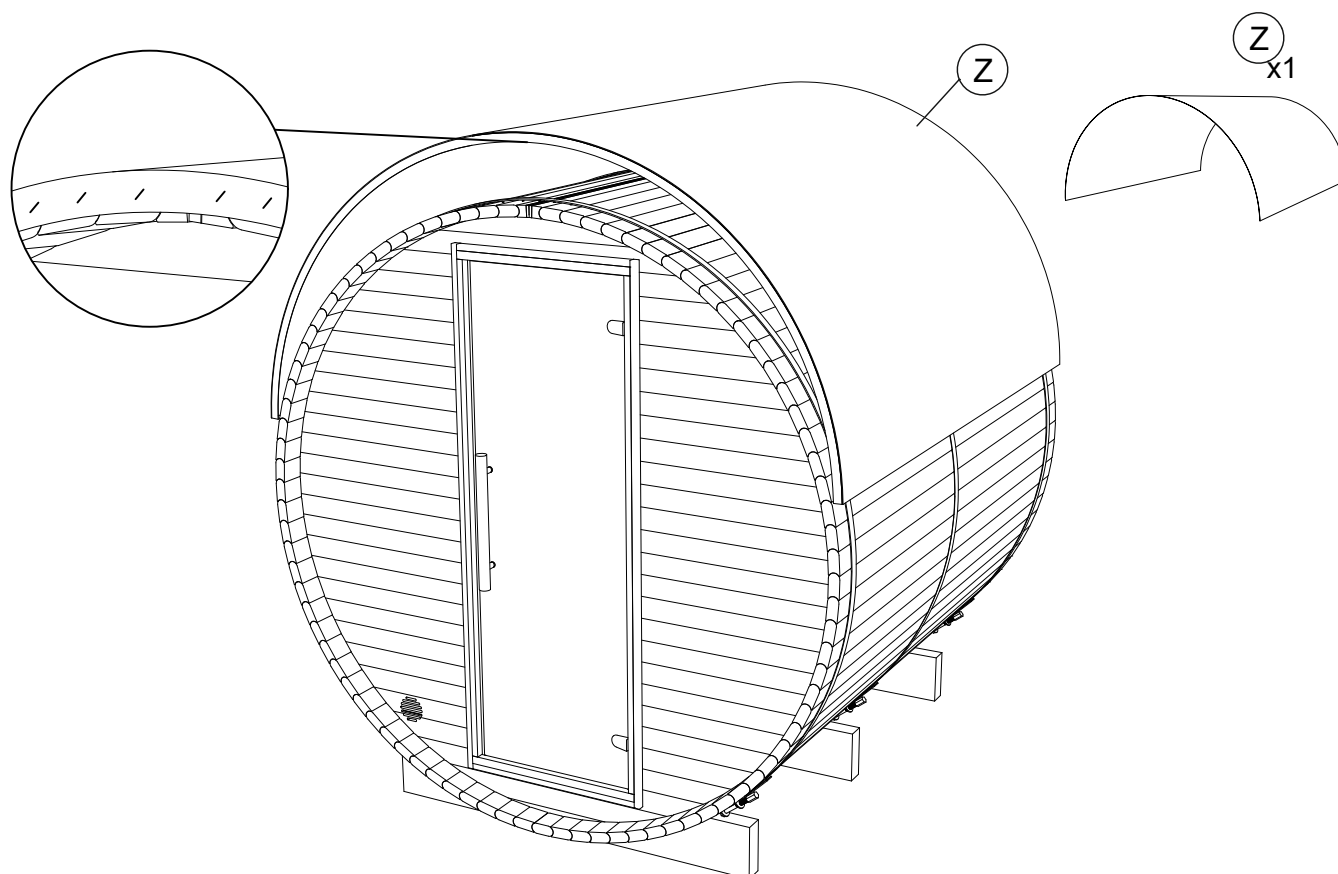
STEP 20: Pre-drill holes before fix with screws, install fixing blocks (L1) under floor duckboard using screw (S2) No50s or (S5) No60s. Place floor duckboards (L) on the floor and fix fixing blocks next to both flooring crossboards.



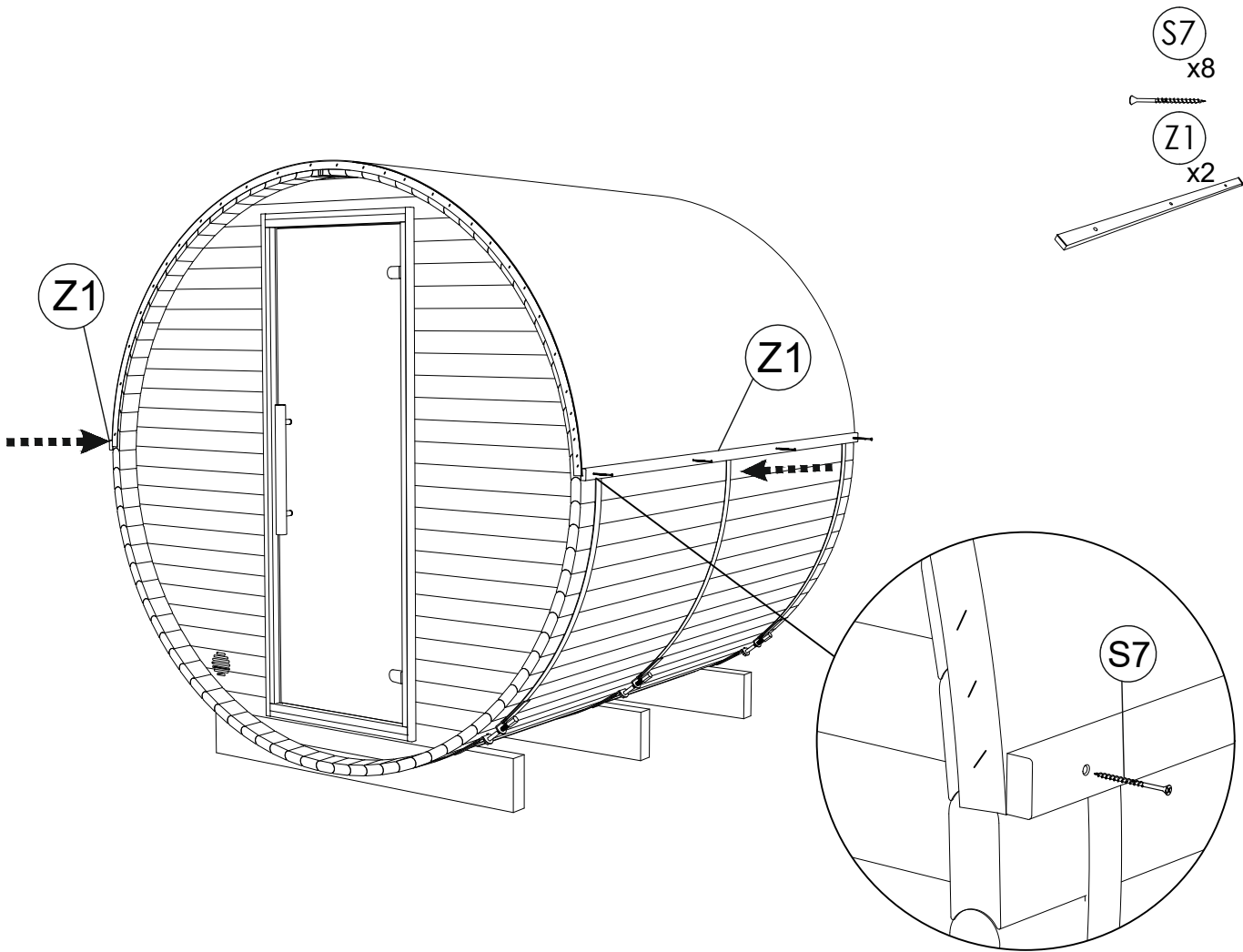
STEP 21: Pre-drill holes before fix stave with screws, install interior roof trim (O) in sauna with (S5) screws.



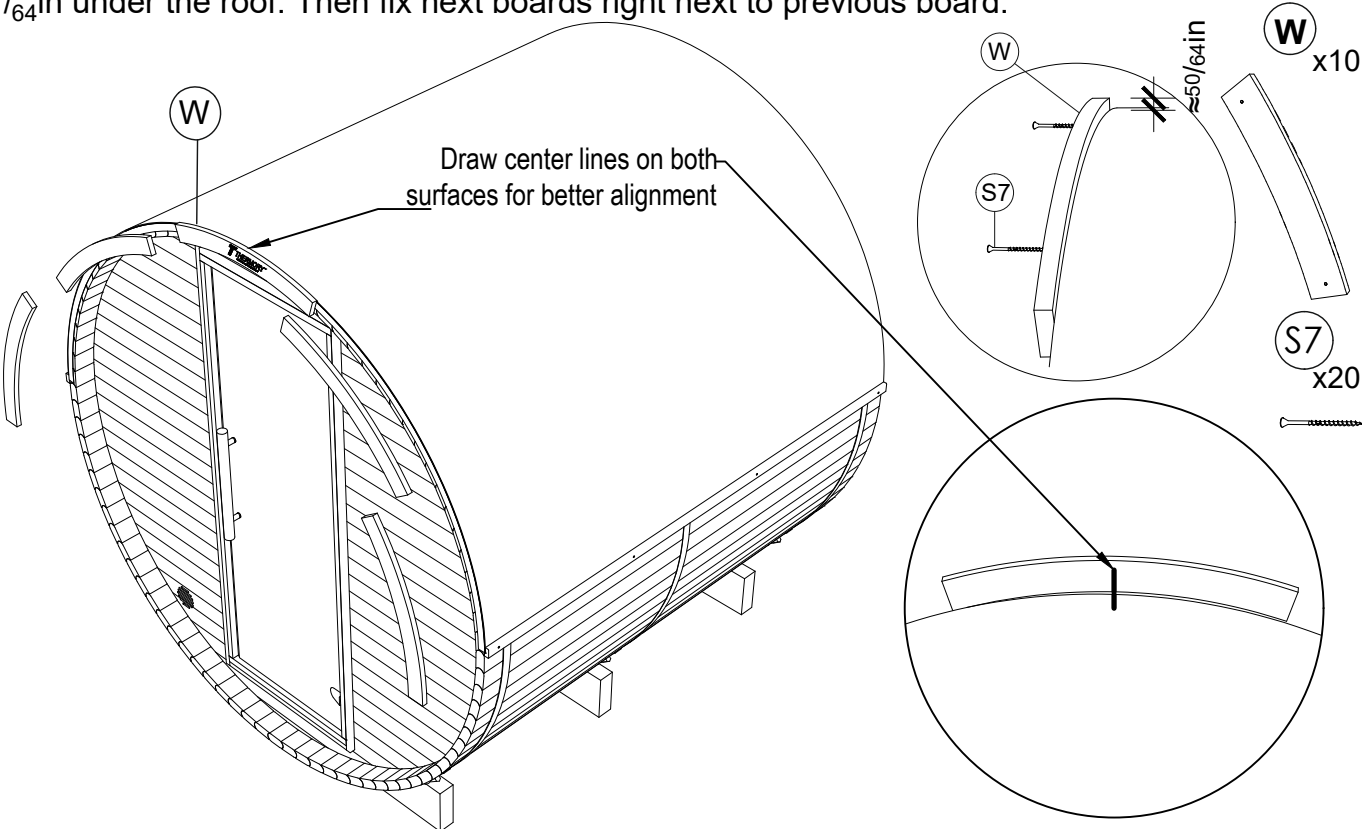
STEP 22: Place waterproof PVC roof cover . Align roof cover equally to both sides. Roof cover goes about $\approx 1 \frac{37}{64}$ in over each sides edge. Staple roof cover on the saunas edge.



STEP 23: Fix with wooden slats (Z1) with screws (S7) on the rain jacket bottom. The number of screws may vary depending on the sauna model.



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 or $\frac{13}{64}$ in under the roof. Then fix next boards right next to previous board.



STEP 25: Repeat step 24 to apply roof finishing boards at the back of the sauna roof edge.

