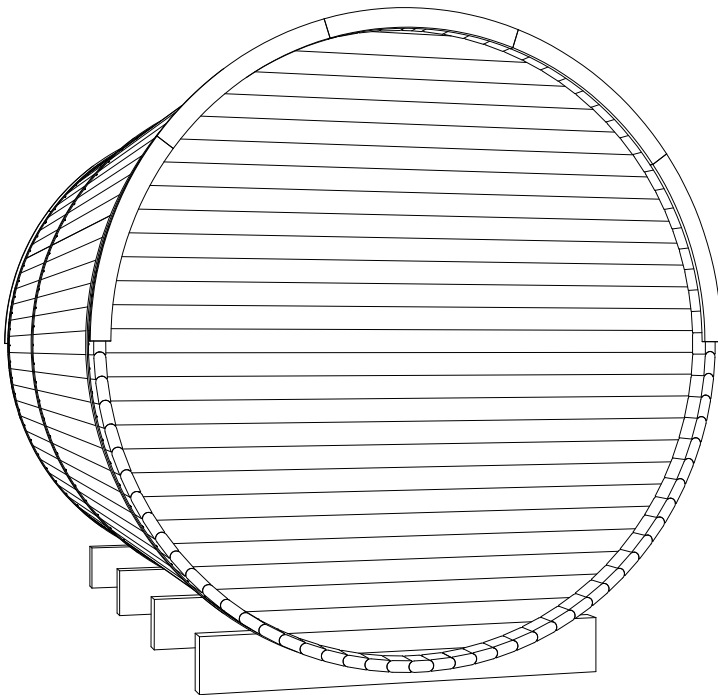
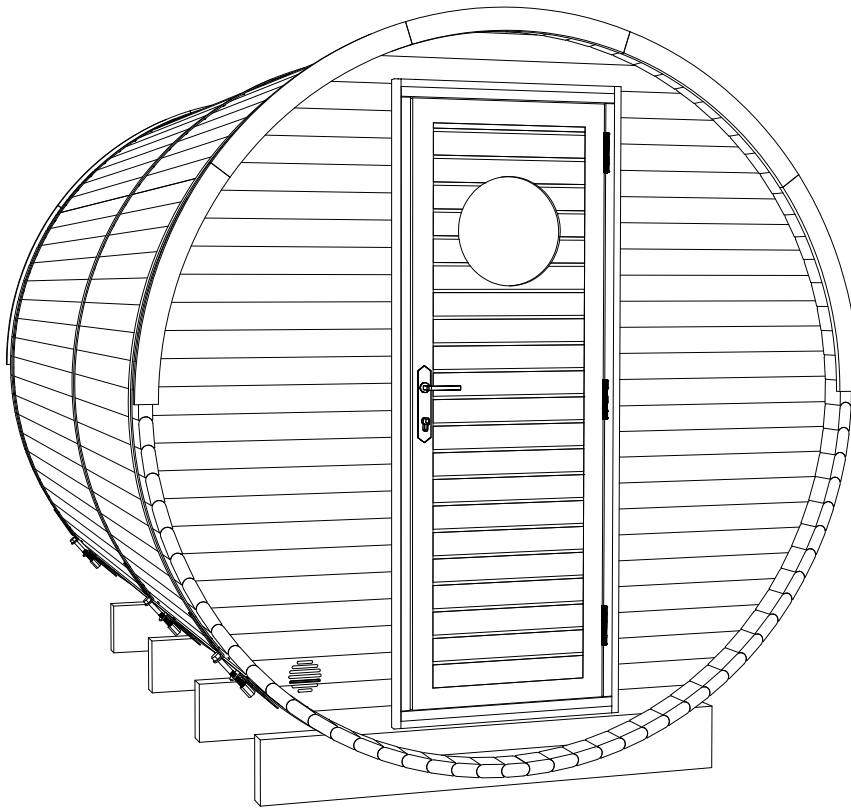
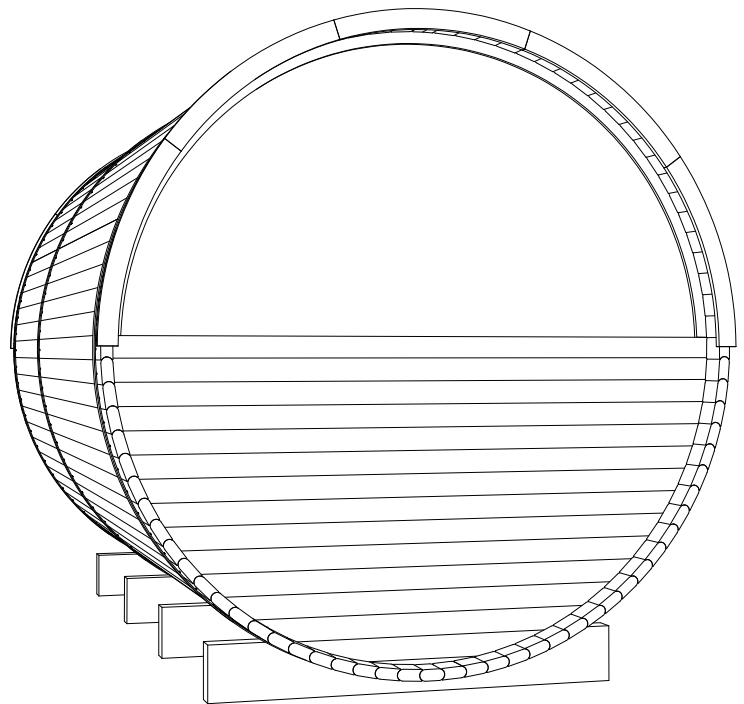


BARREL SAUNA

ASSEMBLY INSTRUCTIONS



Model: No 81

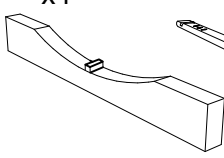
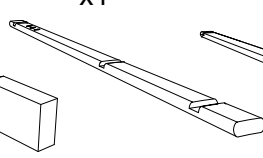
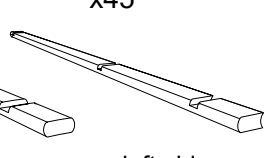
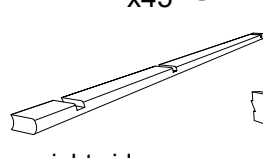
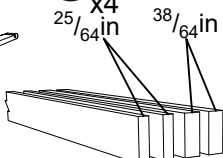
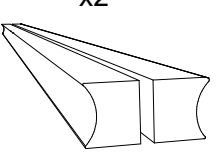
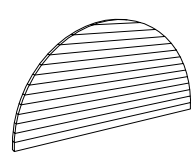
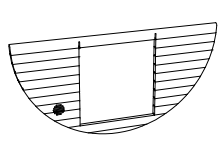
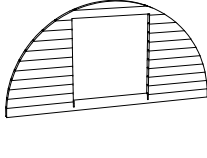
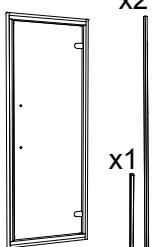
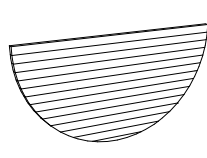
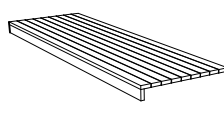
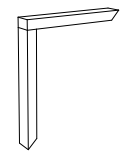
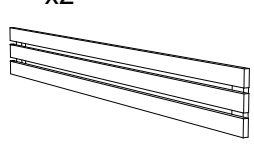
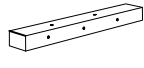

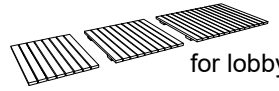
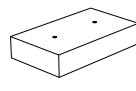
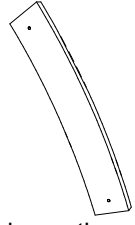
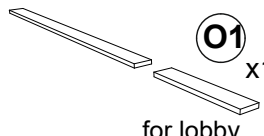
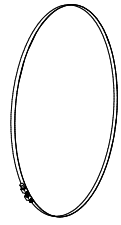












Model: No 80

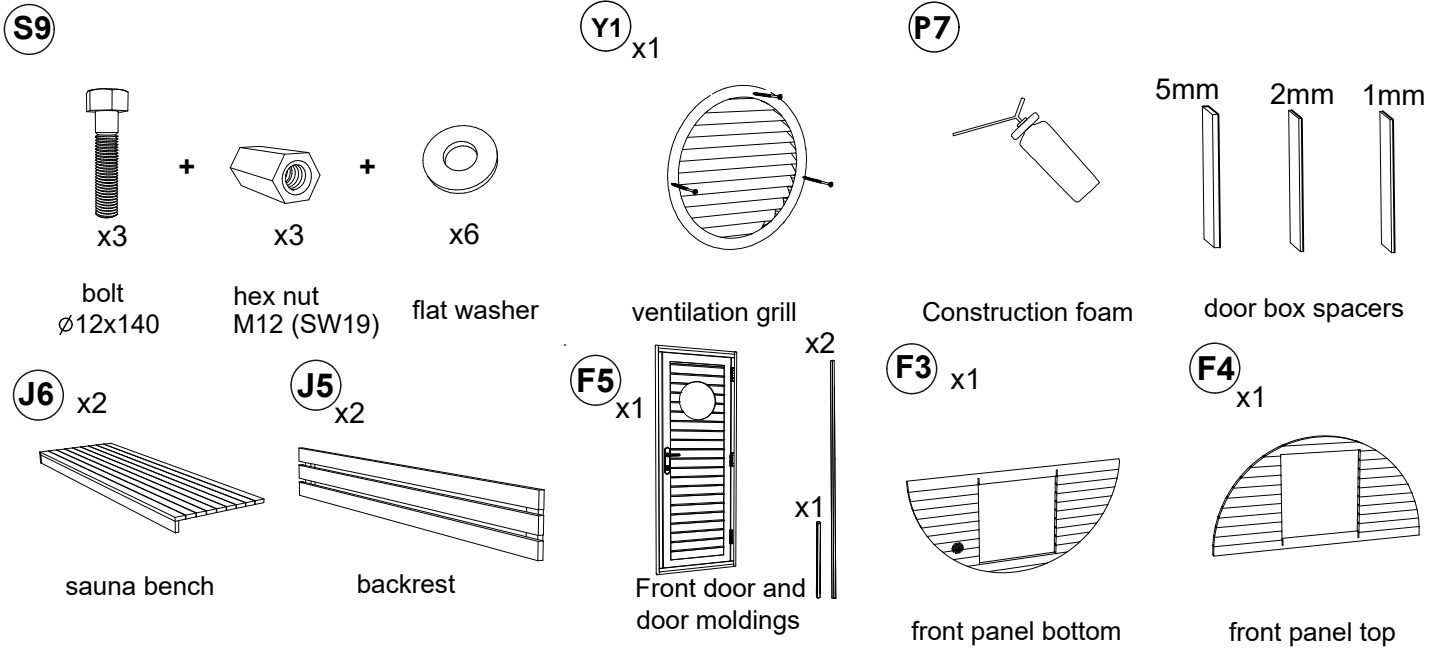
Note: Please read the manual before construction

Rev. 11.11.2024.

PART LIST

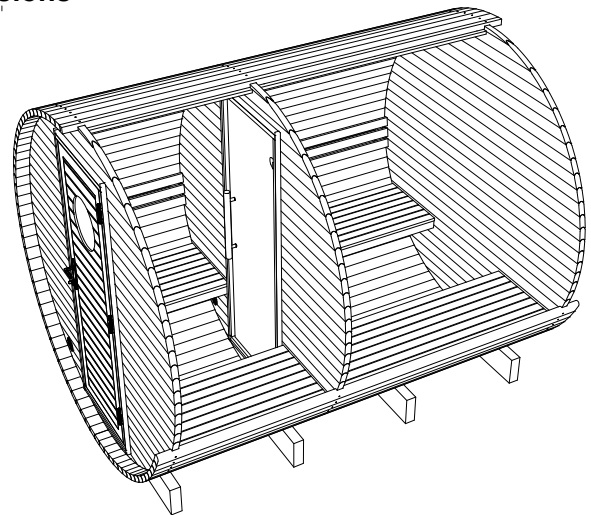
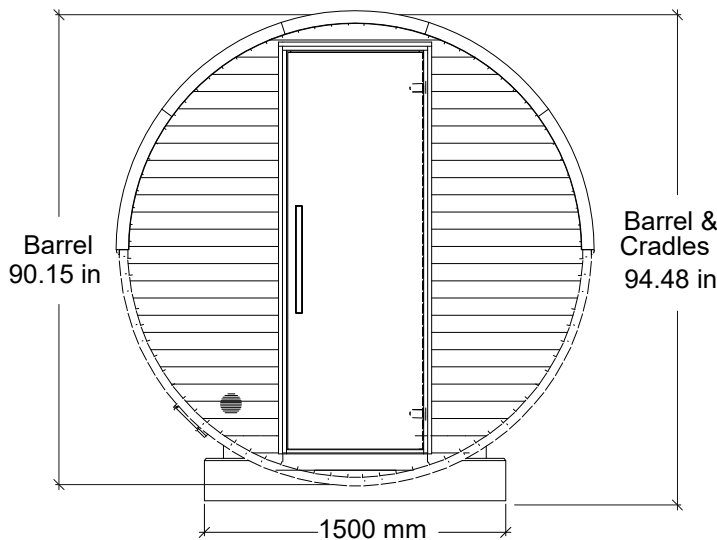
A x4  cradle	B x1  center stave	C x45  left side body stave	C1 x45  right side body stave	H1 x4  different thickness filling peaces	H x2  final H tipe stave at the top
V3 x1  upper rear panel	F x1  inner panel bottom	F1 x1  inner panel top	F2 x1  door and door moldings	V x1  bottom rear panel	
J x2  sauna bench	J1 x4  supporting leg	J2 x2  backrest	J3 x8  wall mount	N1 x2  door handle	
L x3  sauna floor	L1 x10  fixing block for sauna floor	W x10  decorative roof finishing board	O x1  roof board	I x3  metal band	
D x3  Cable canal (for LED option)	S1 x65  screw 5.0x100 SS	S10 x240  screw 4.0x60	S5 x93  screw 4.0x50 SS	S4 x15  screw 5.0x120	
S8 x15  Cable canal nails (for LED option)	S6 x50  screw 5.0x70 SS	S7 x25  screw 4.2x55 brown	S2 x25  screw 4.0x70 SS	S14 x20  screw 5.0x80	

PART LIST



No80s

Barrel Dimensions



RECOMMENDATION



2 person recommended

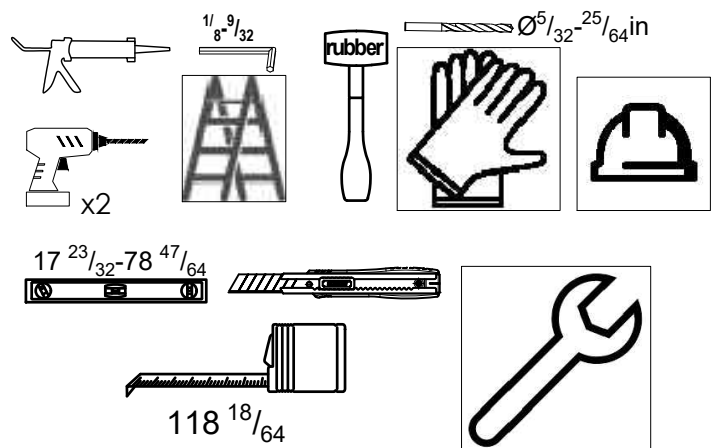
Before you begin, be sure the sauna will fit in your chosen location.

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

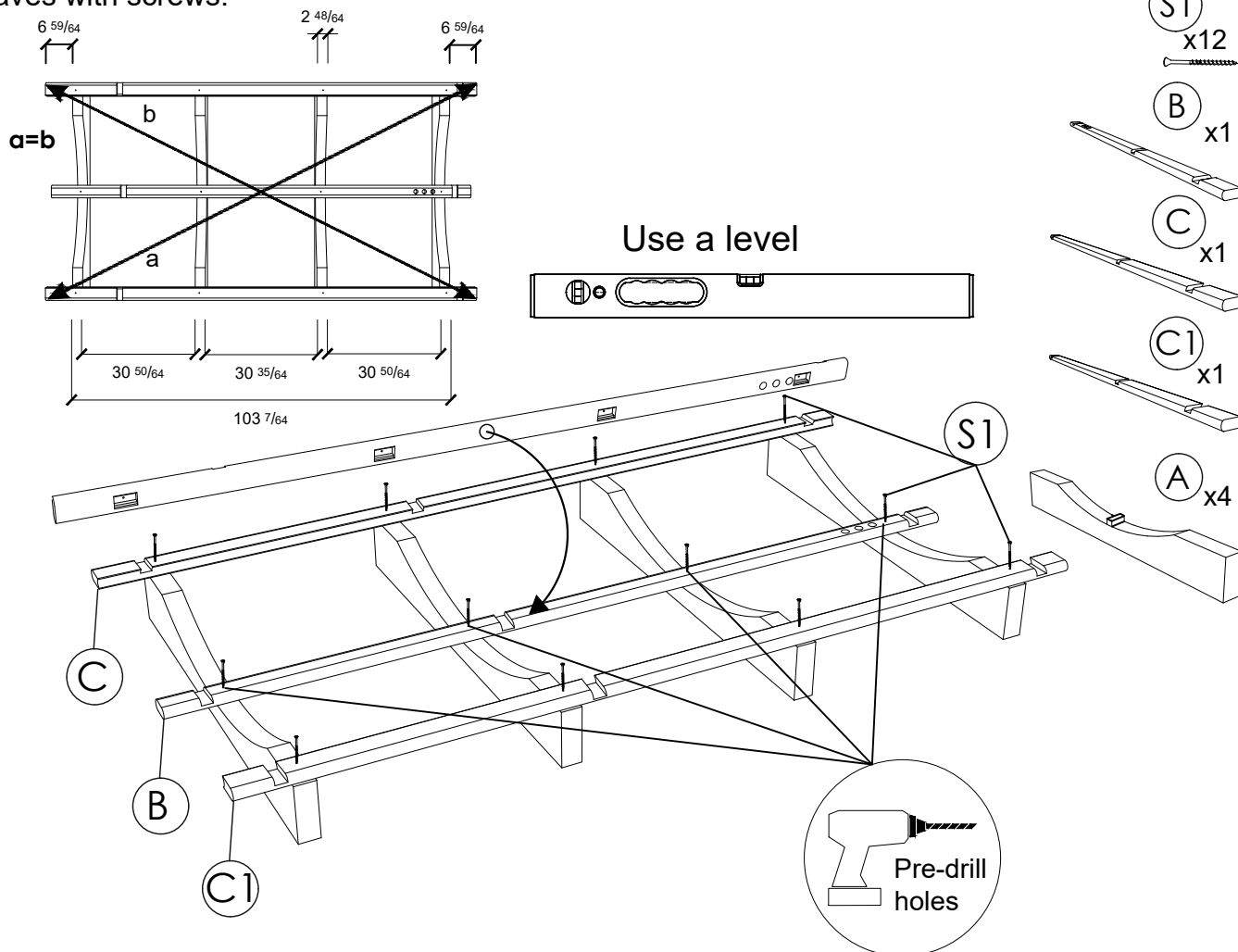
Concrete, pavers or crushed stone is preferred.

Check parts before construction.

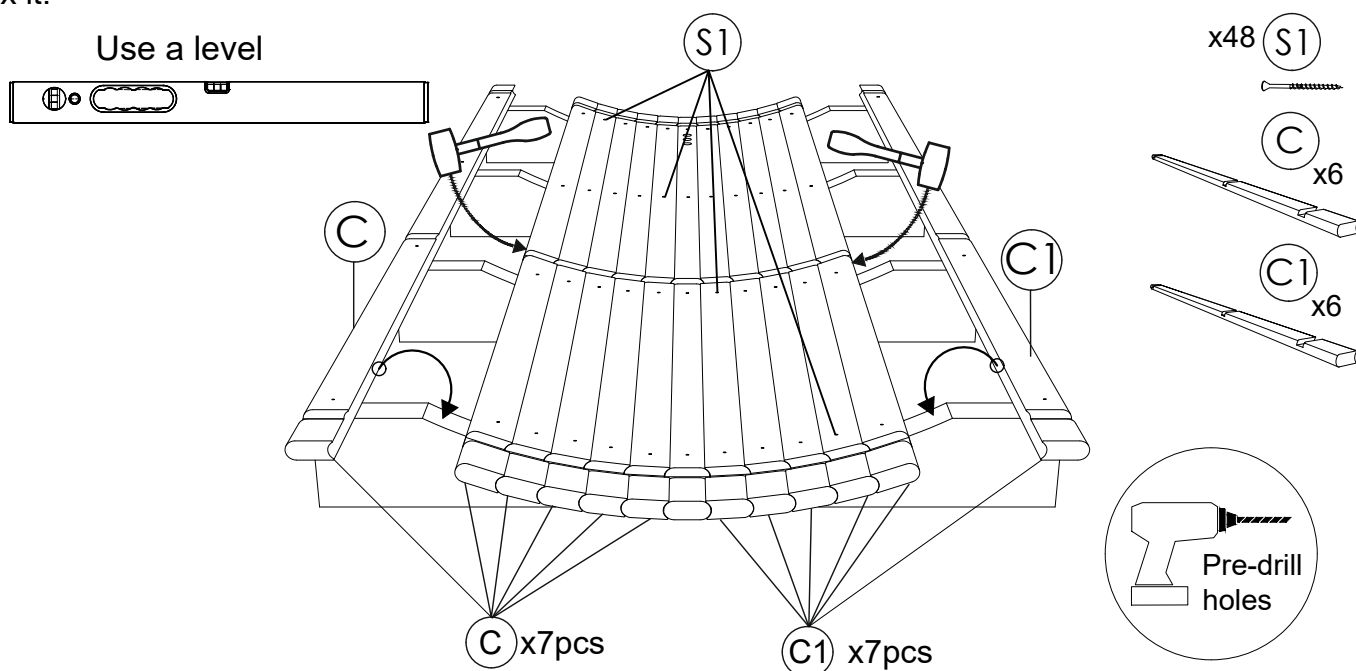
TOOLS REQUIRED



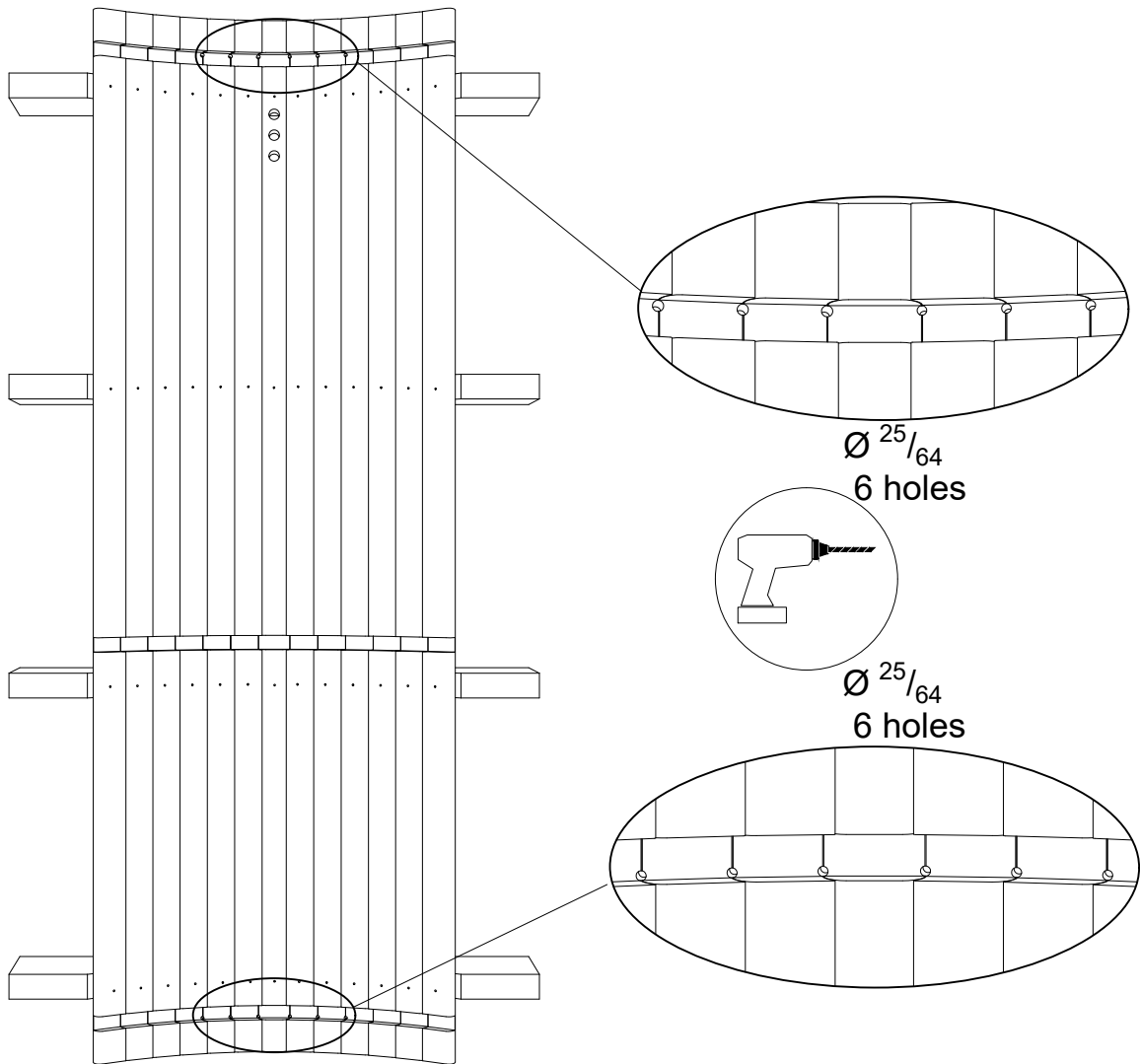
STEP 1: Place the support cradles (A) on level site. Carefully level for better stability. Place the center stave (B) on wooden dowels embedded in outer support cradles (A). Fix the center stave (B) with (S1) screws. Then fix boards on top of the cradles at the side corners. Measure support cradles (A)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



STEP 2: Pre-drill holes before fix staves with screws. Place 7 sauna body staves (C; C1) 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. Take of last board from both sides and fix it.

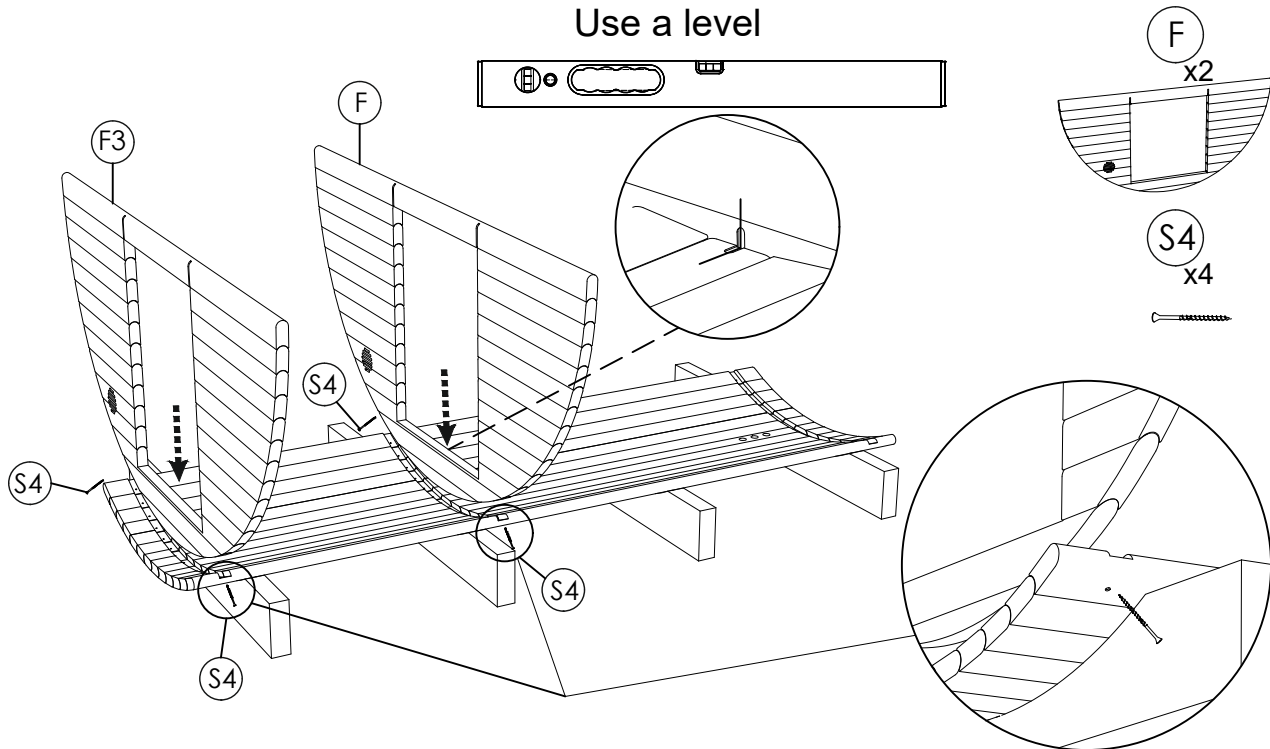


STEP3: Drill six $\frac{25}{64}$ in holes in front and back wall groove to the out-side in board connections as shown in the picture. This will help drain excess water faster.

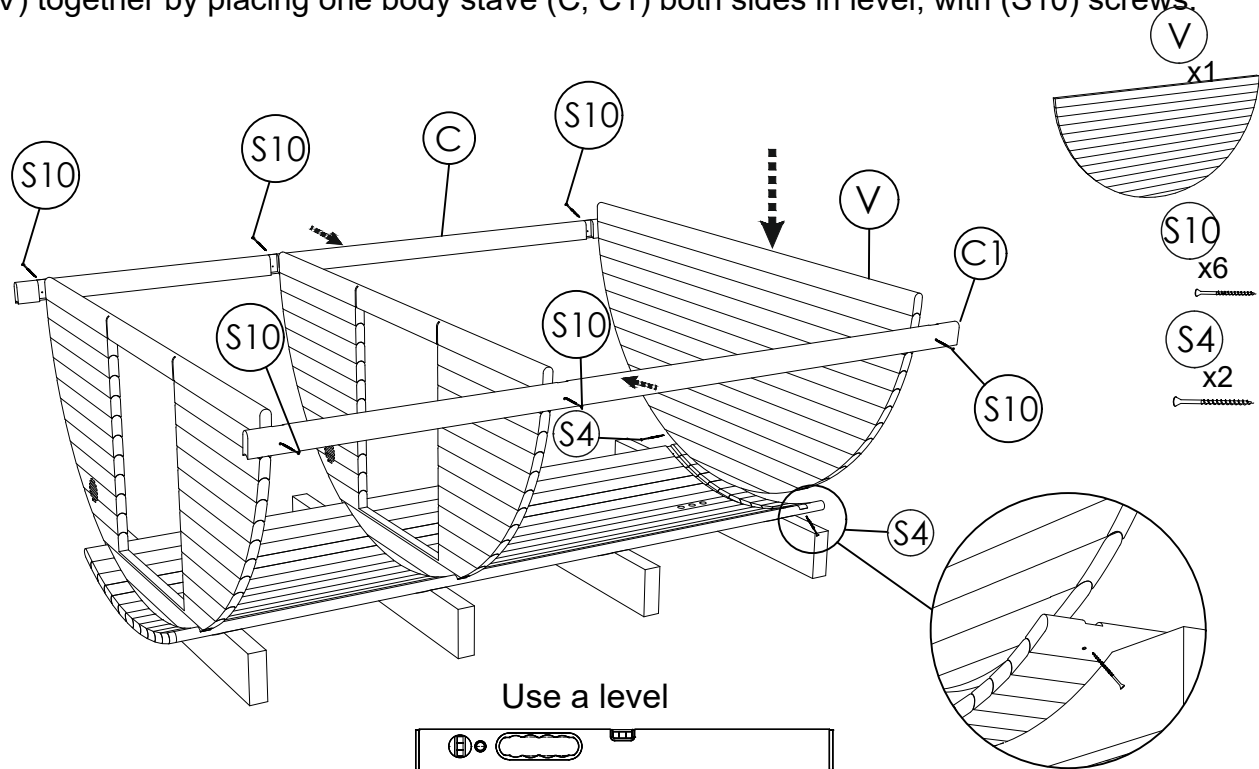


STEP 4: Place front bottom panel (F) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides.

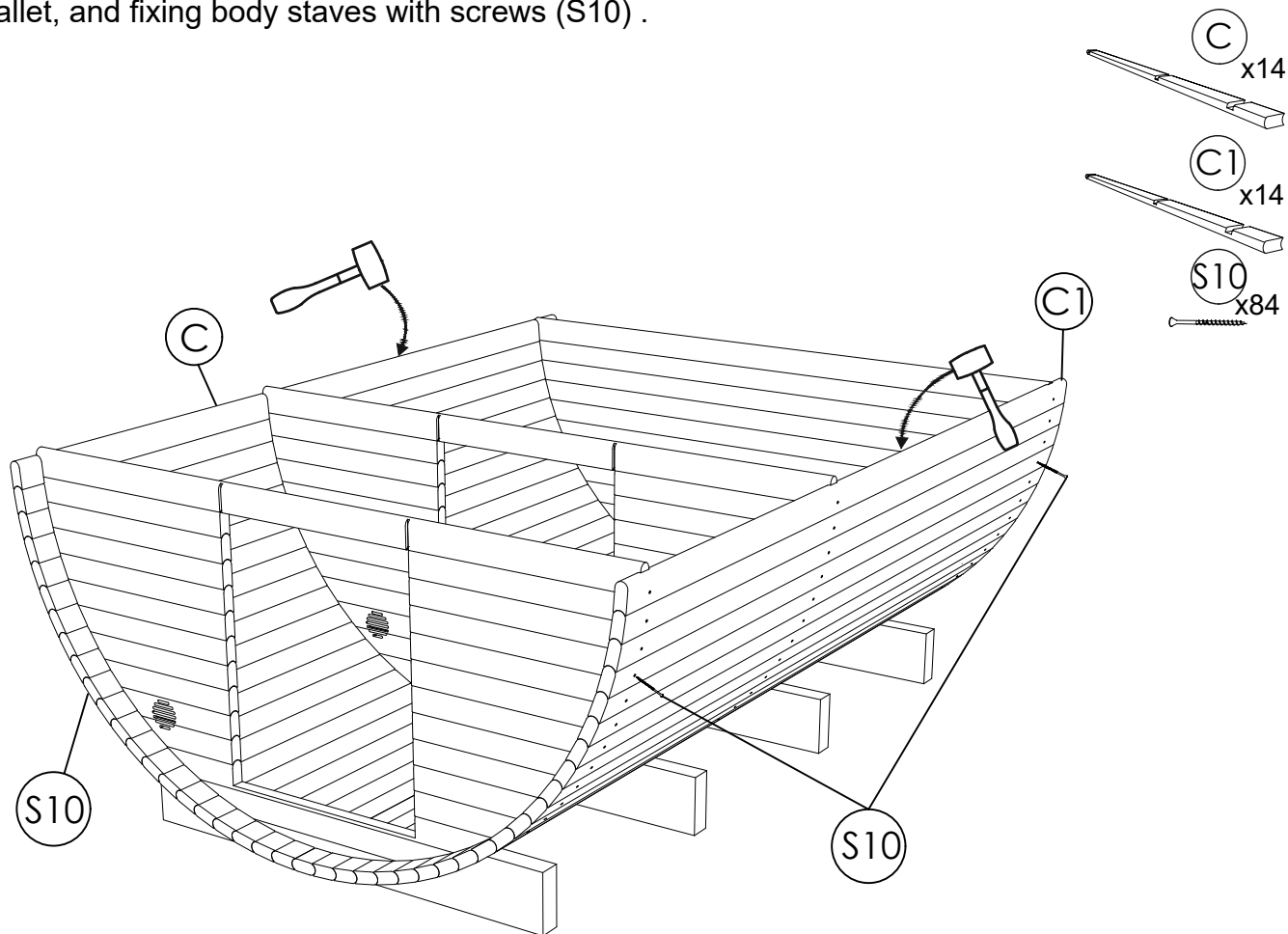
Use a level



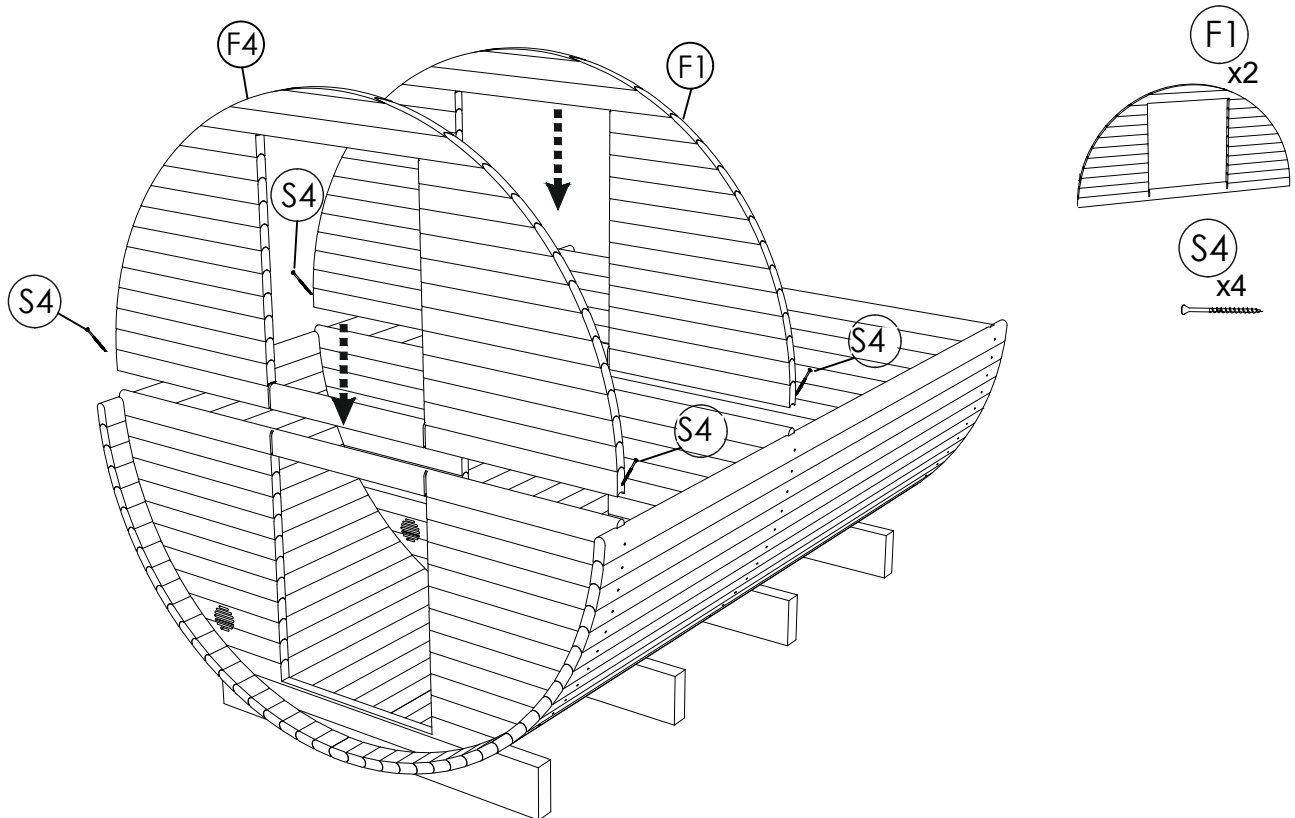
STEP 5: Place rear panel (V) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides. Connect the panels (F; F3; V) together by placing one body stave (C; C1) both sides in level, with (S10) screws.



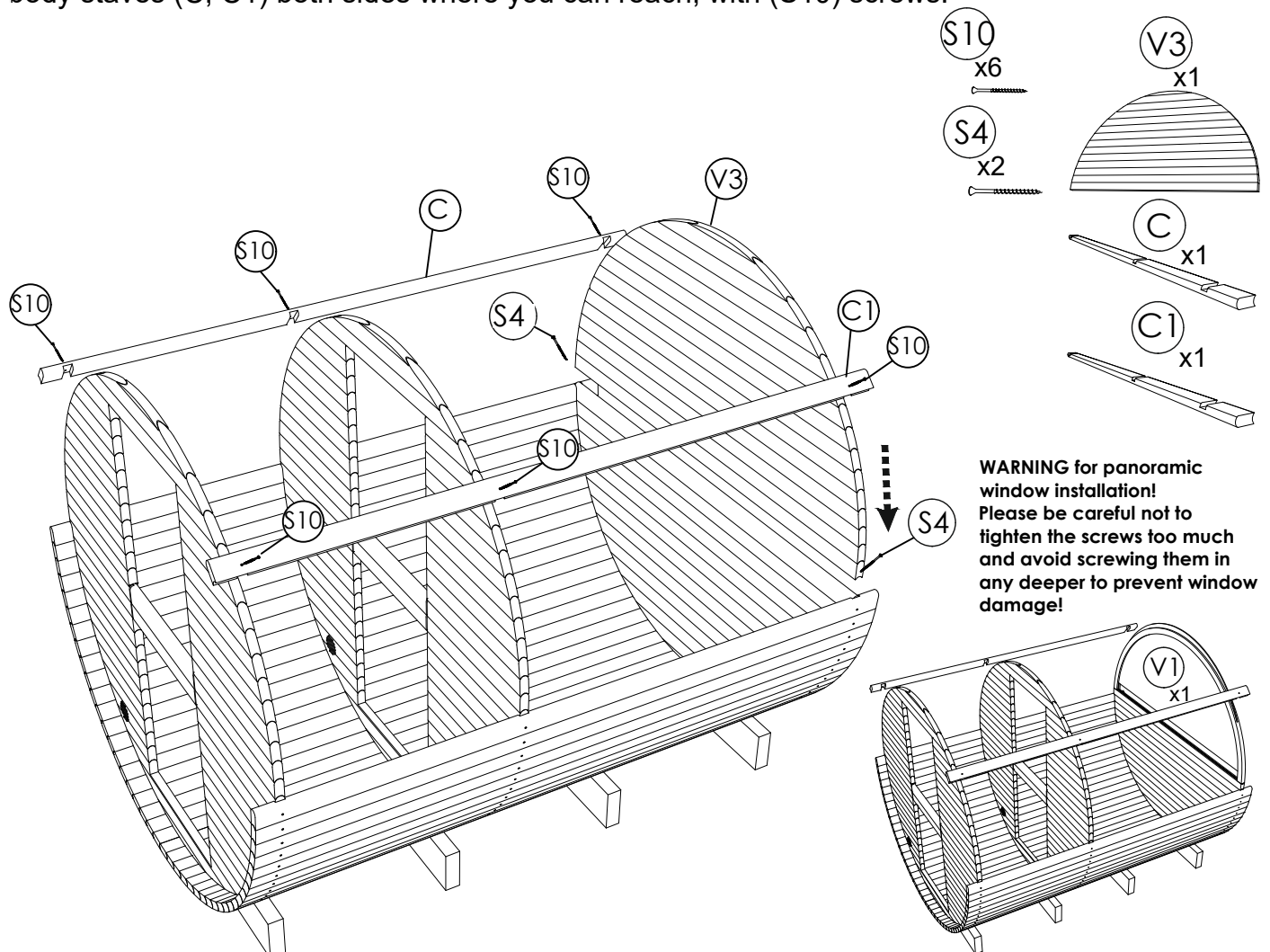
STEP 6: Continue placing body staves (C;C1) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10) .



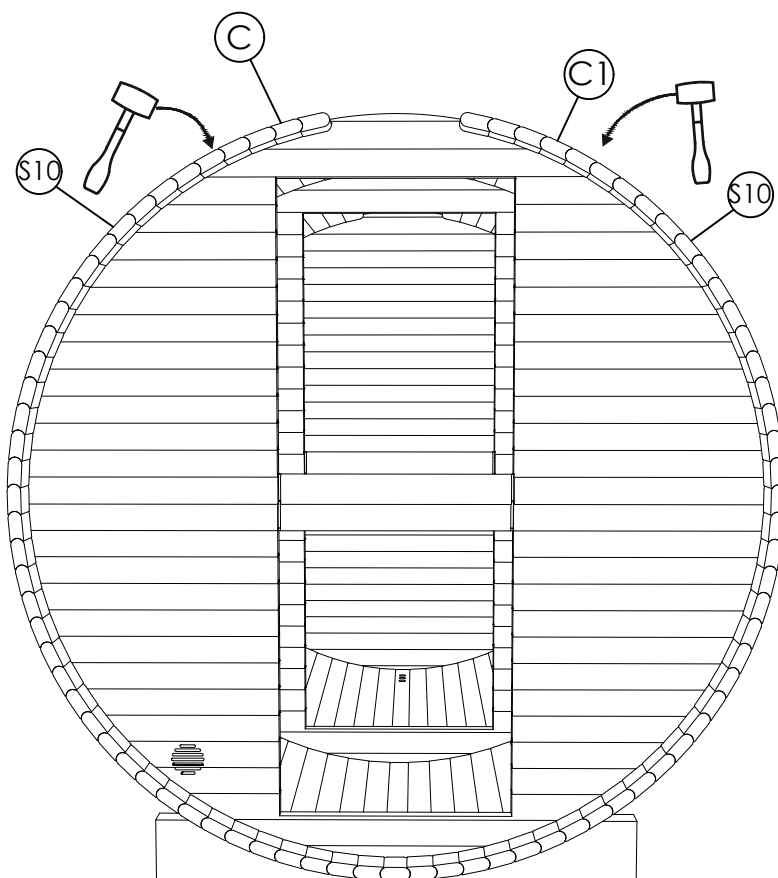
STEP 7: Place front top panel (F1) on front bottom panel (F), be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws on both sides.



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; C1) both sides where you can reach, with (S10) screws.



STEP 9: Continue placing body staves (C; C1) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10).

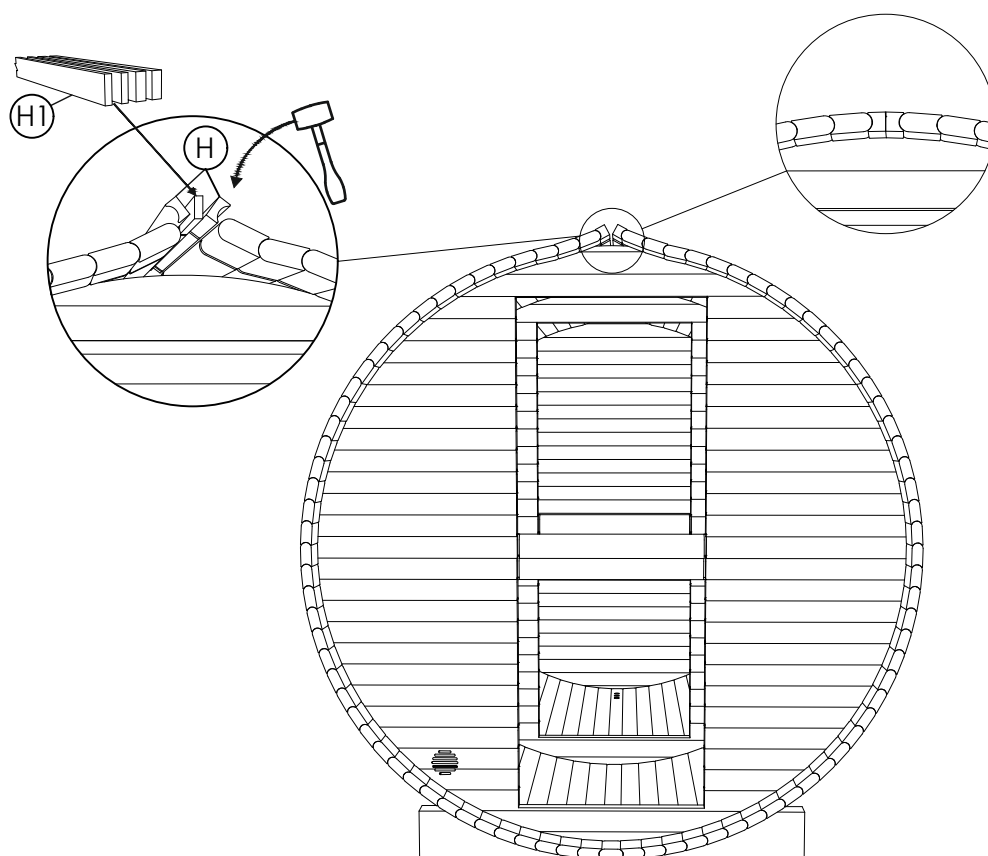


S10
x72

C
x19

C1
x19

STEP 10: To finish the roof top joint, don't screw about last 2 boards (C; C1) 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.



S10
x16

C
x2

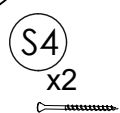
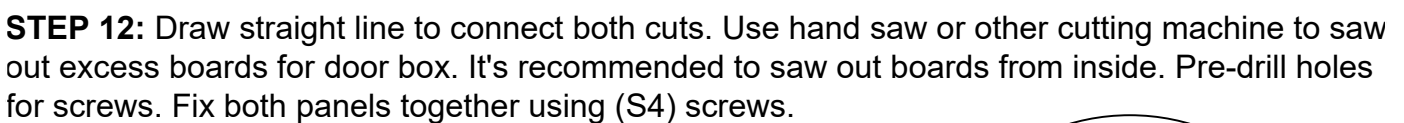
C1
x2

H
x2

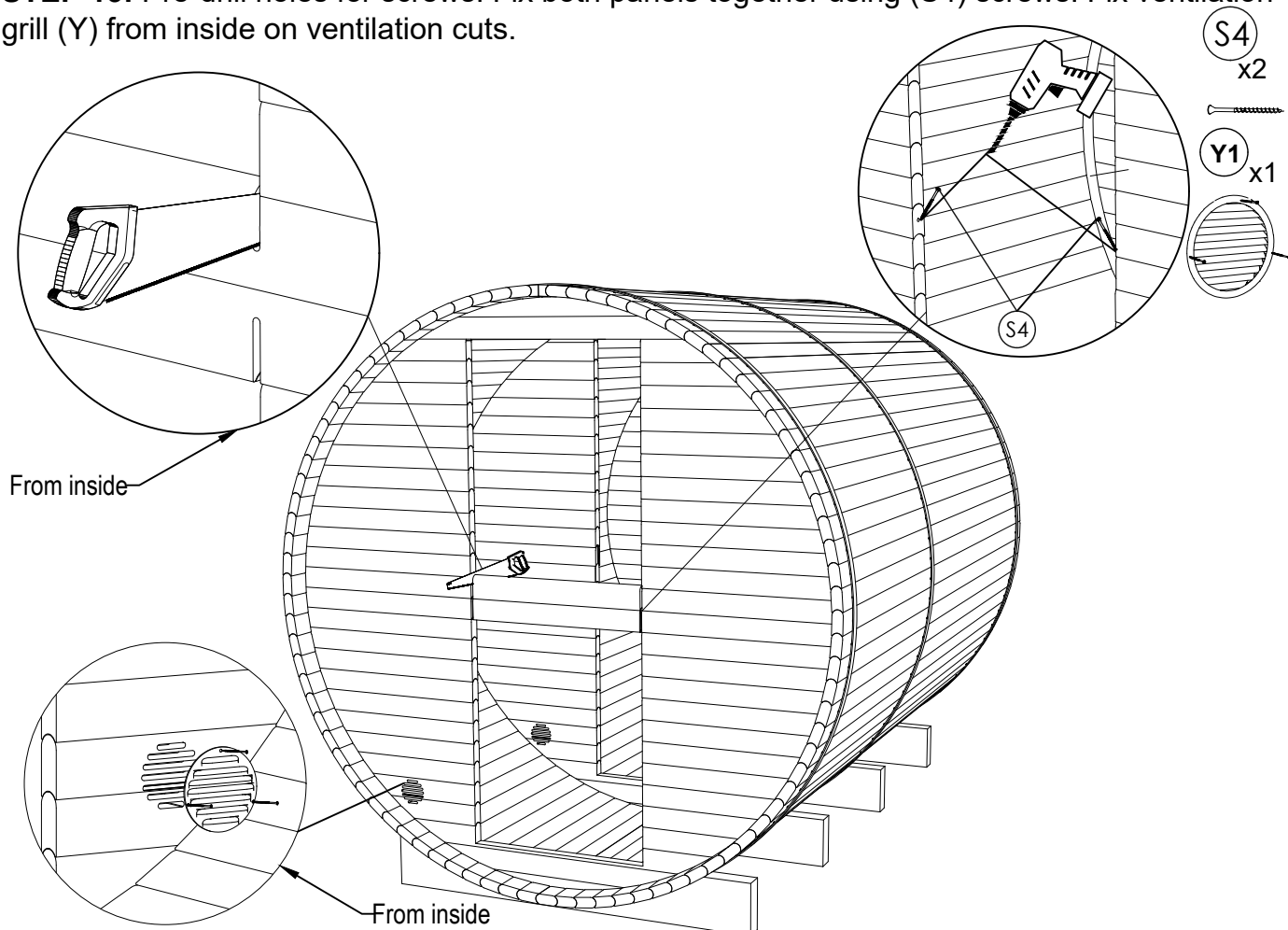
H1
x4
10mm 15mm

S9 **I** x3

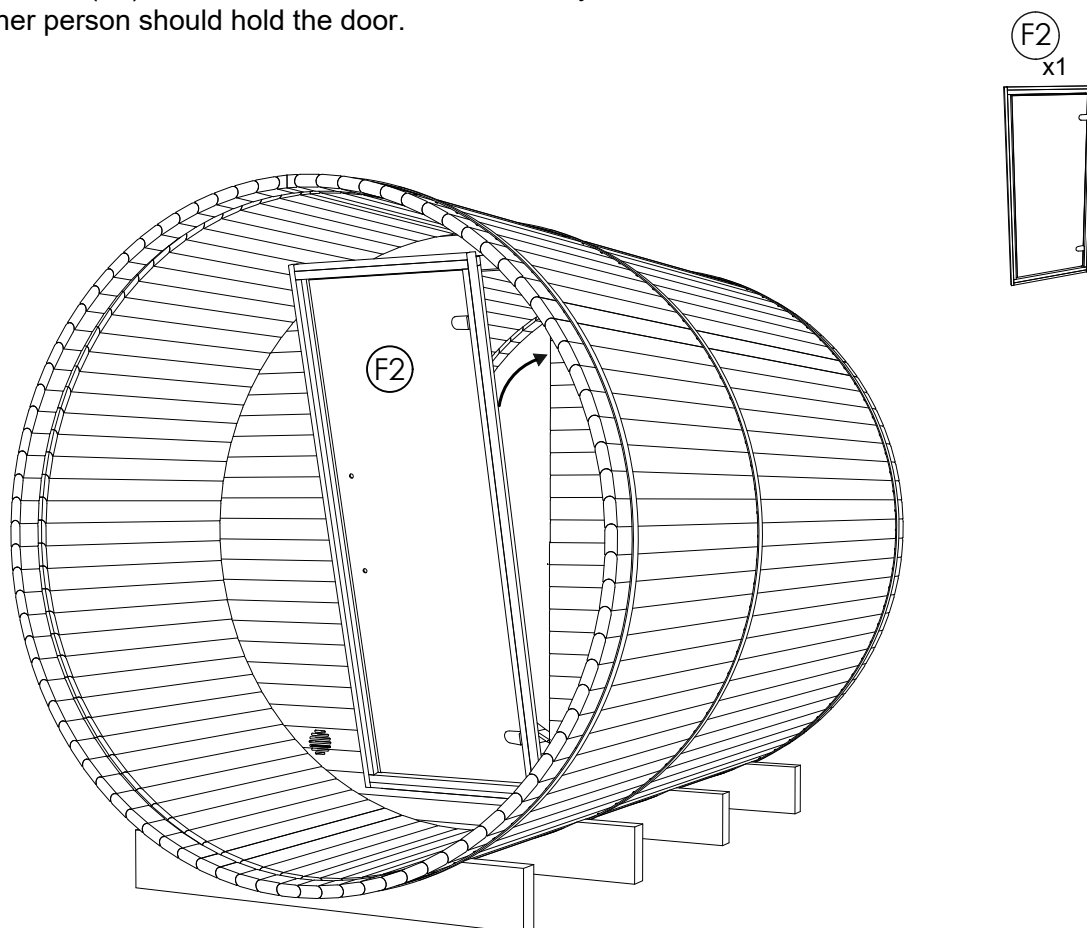
x3 x3 x6



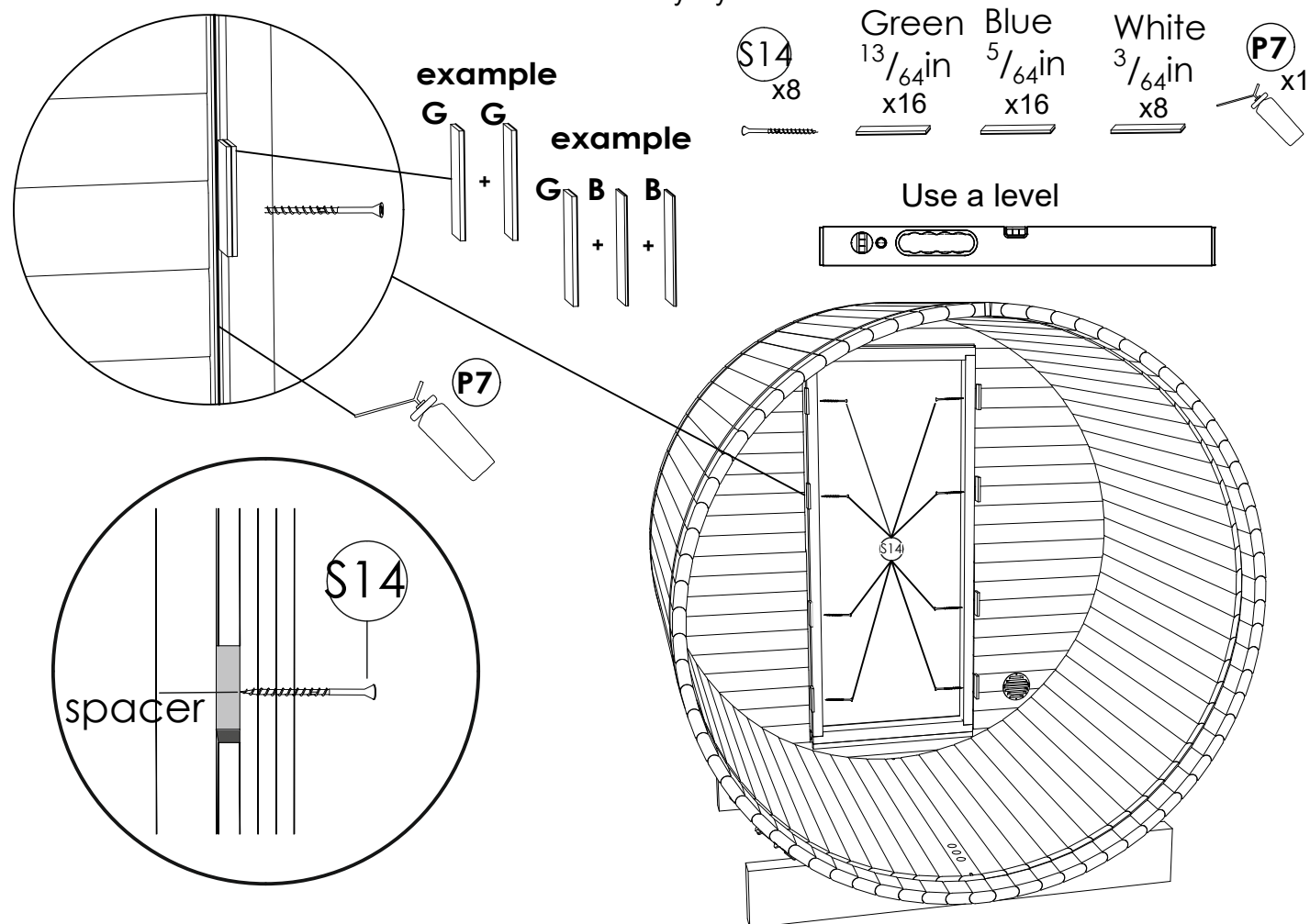
STEP 13: Pre-drill holes for screws. Fix both panels together using (S4) screws. Fix ventilation grill (Y) from inside on ventilation cuts.



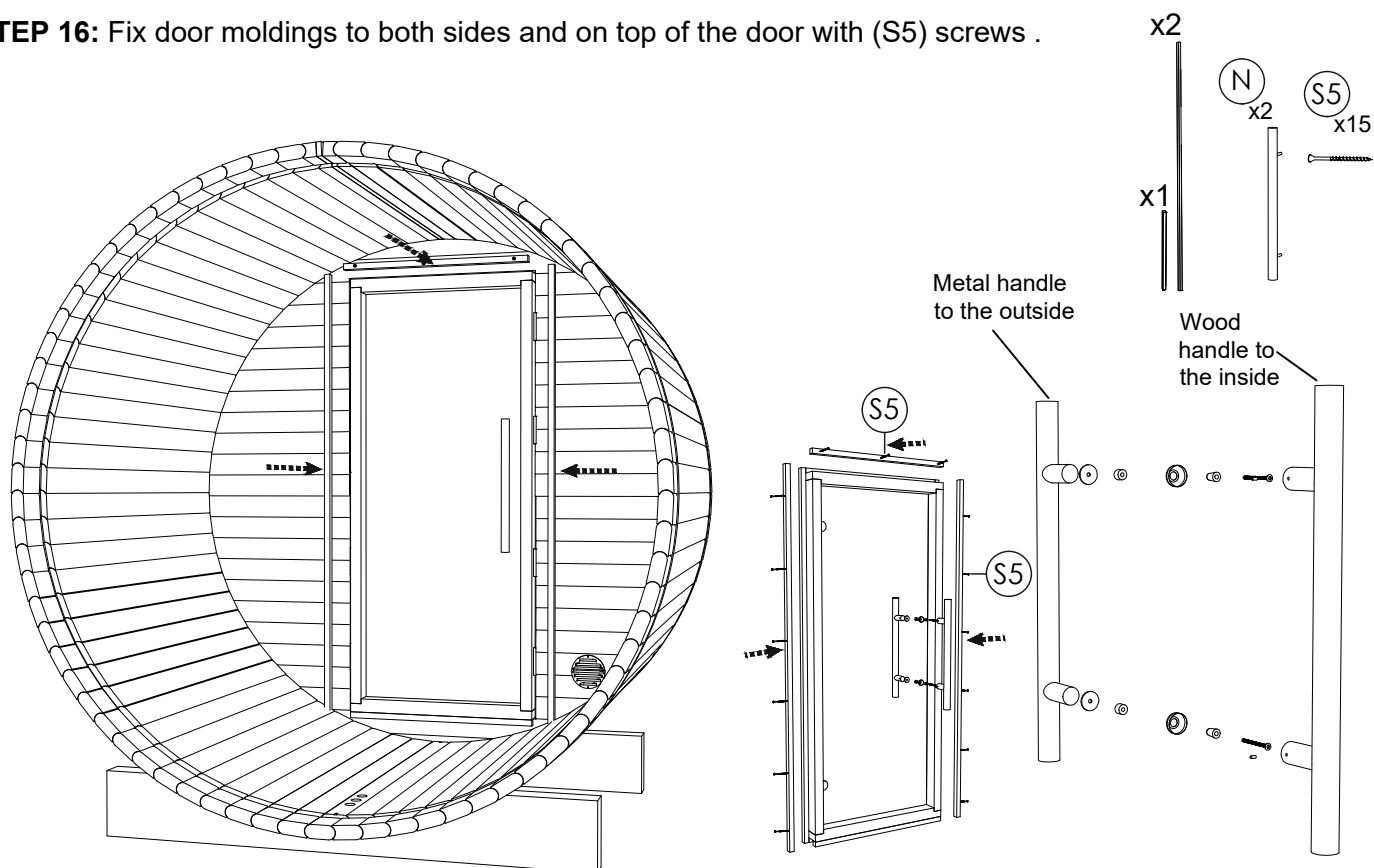
STEP 14: Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.



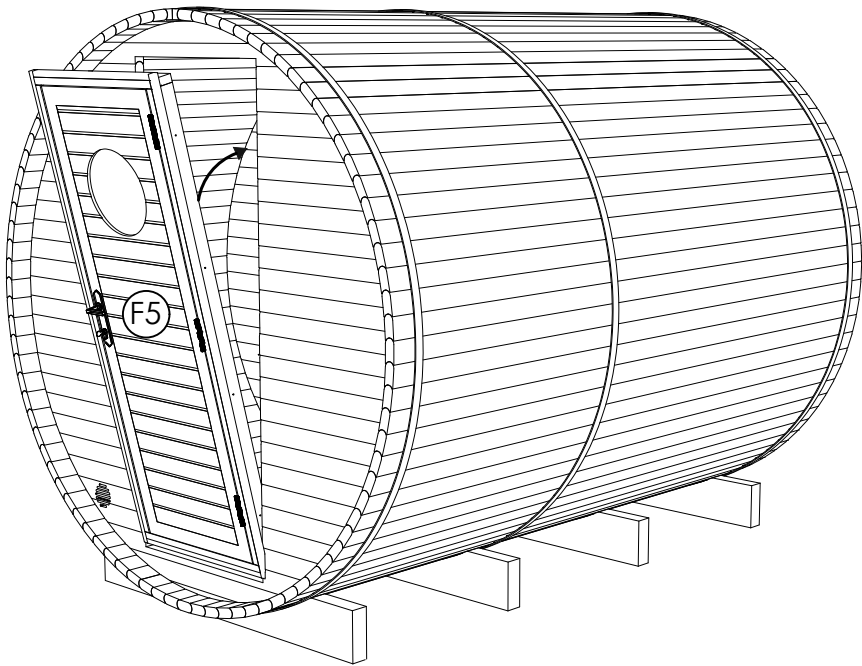
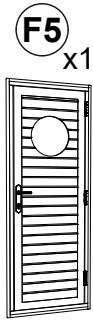
STEP 15: Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. First, fix one side of the door box with screws (S14) through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly, they 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 spray foam around door box. Don't clean up the spray foam until it's dried out. The excess amount will come off easily if you don't touch it while it's wet.



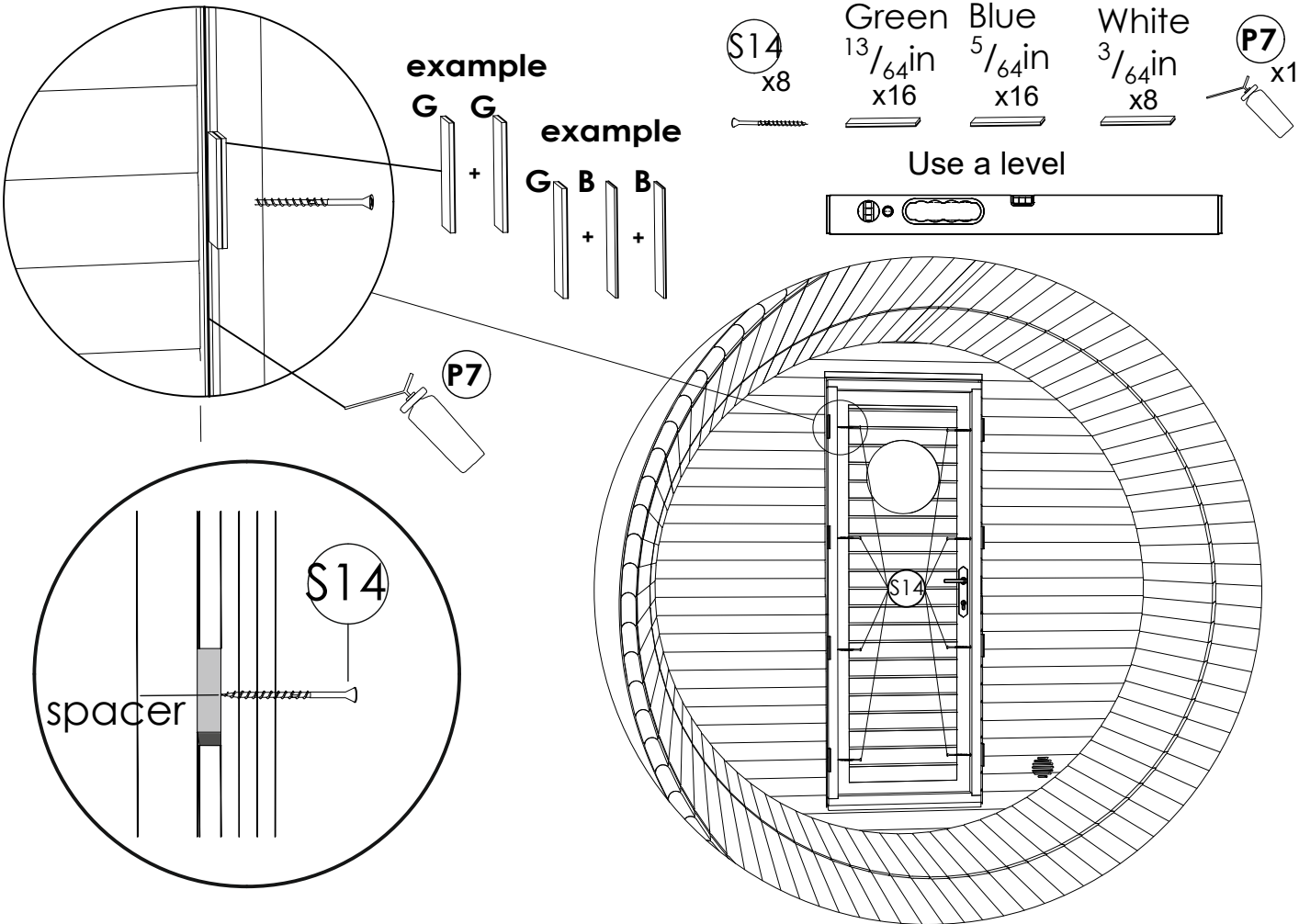
STEP 16: Fix door moldings to both sides and on top of the door with (S5) screws .



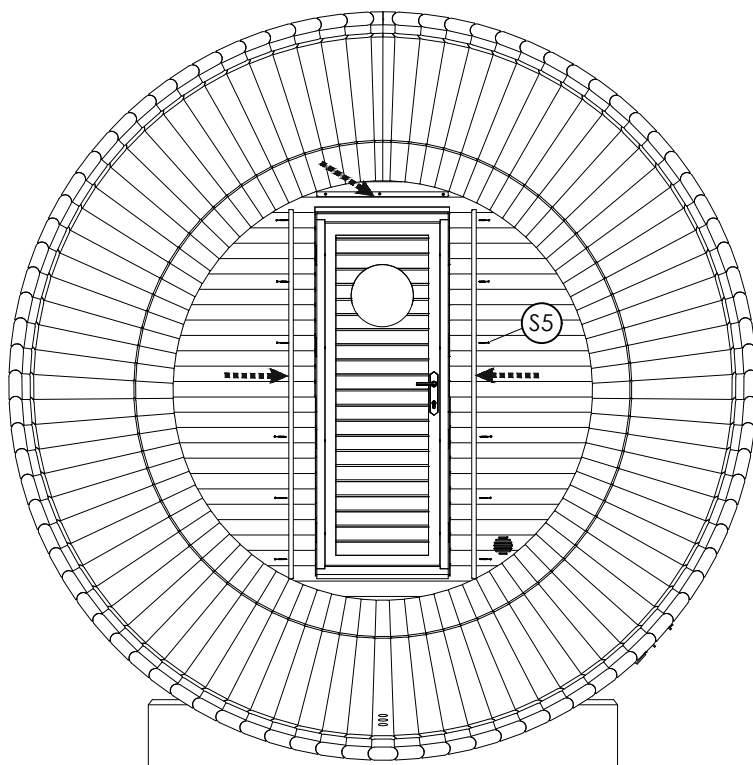
STEP 17: Install the doors (F5). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.



STEP 18: 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 19: Fix door moldings to both sides and on top of the door with (S5) screws.



(S5)
x15

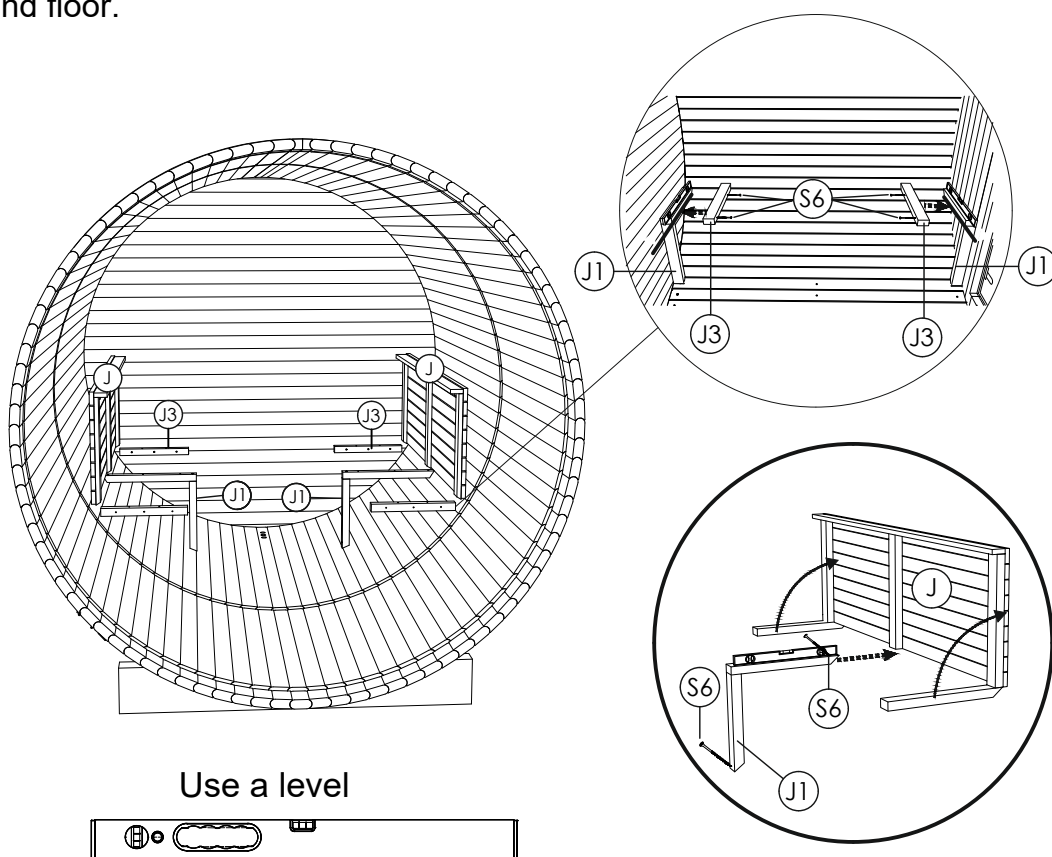


x2

x1



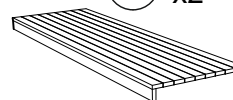
STEP 20: To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, draw a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall mounts. Place J1 in the center and check the level. Using screw (S6) fix bench leg to the wall and floor.



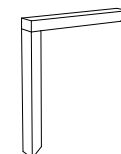
(S6)
x12



(J) x2



(J1) x2



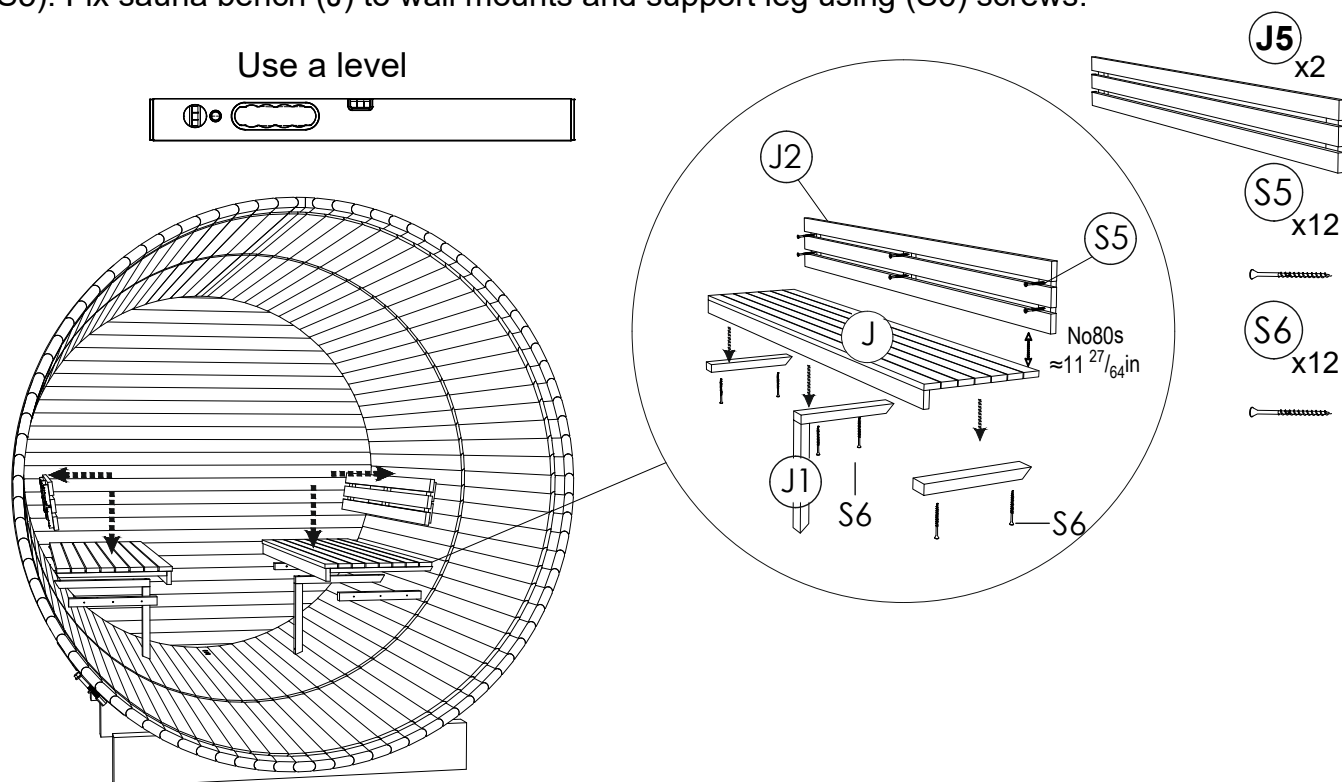
(J3) x4



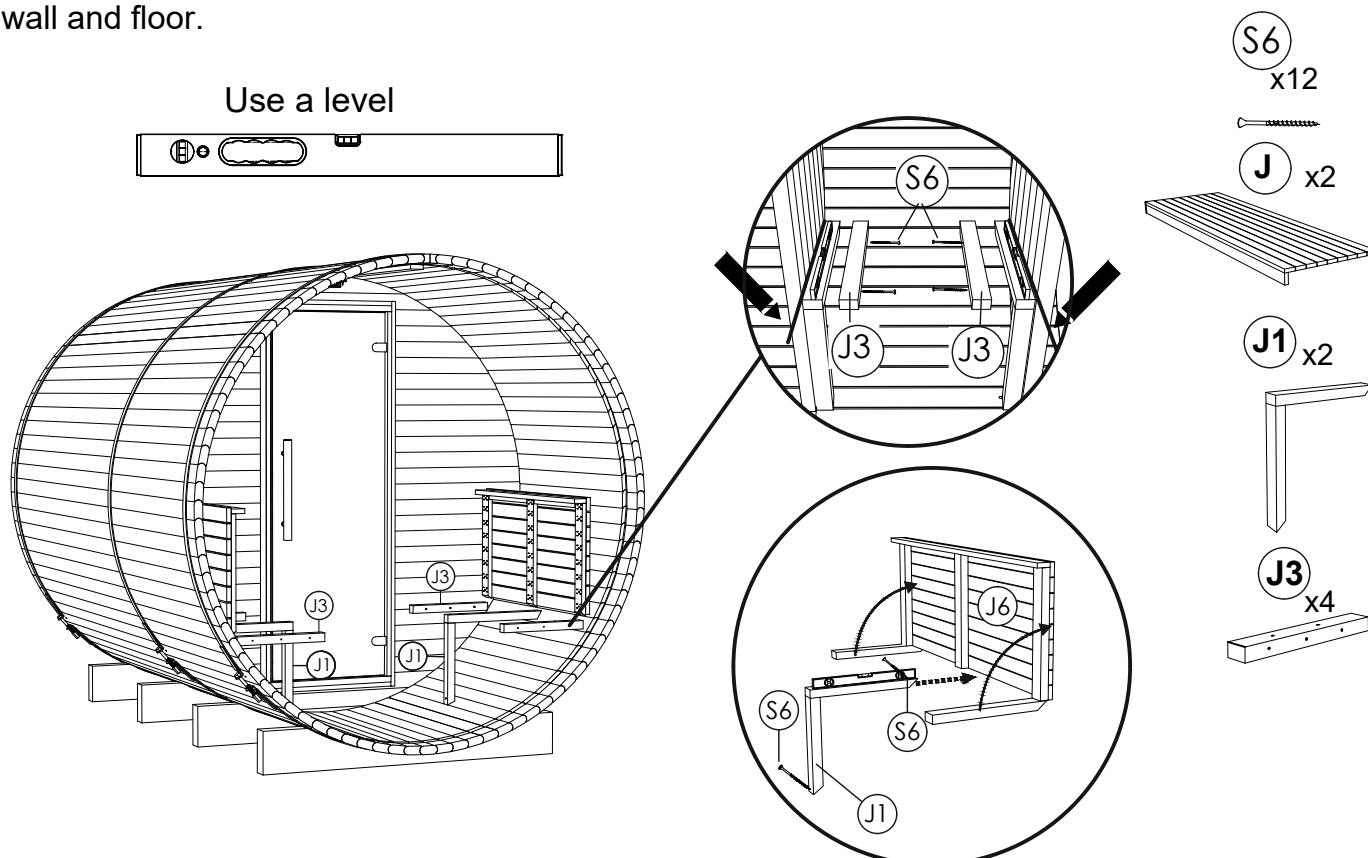
Use a level



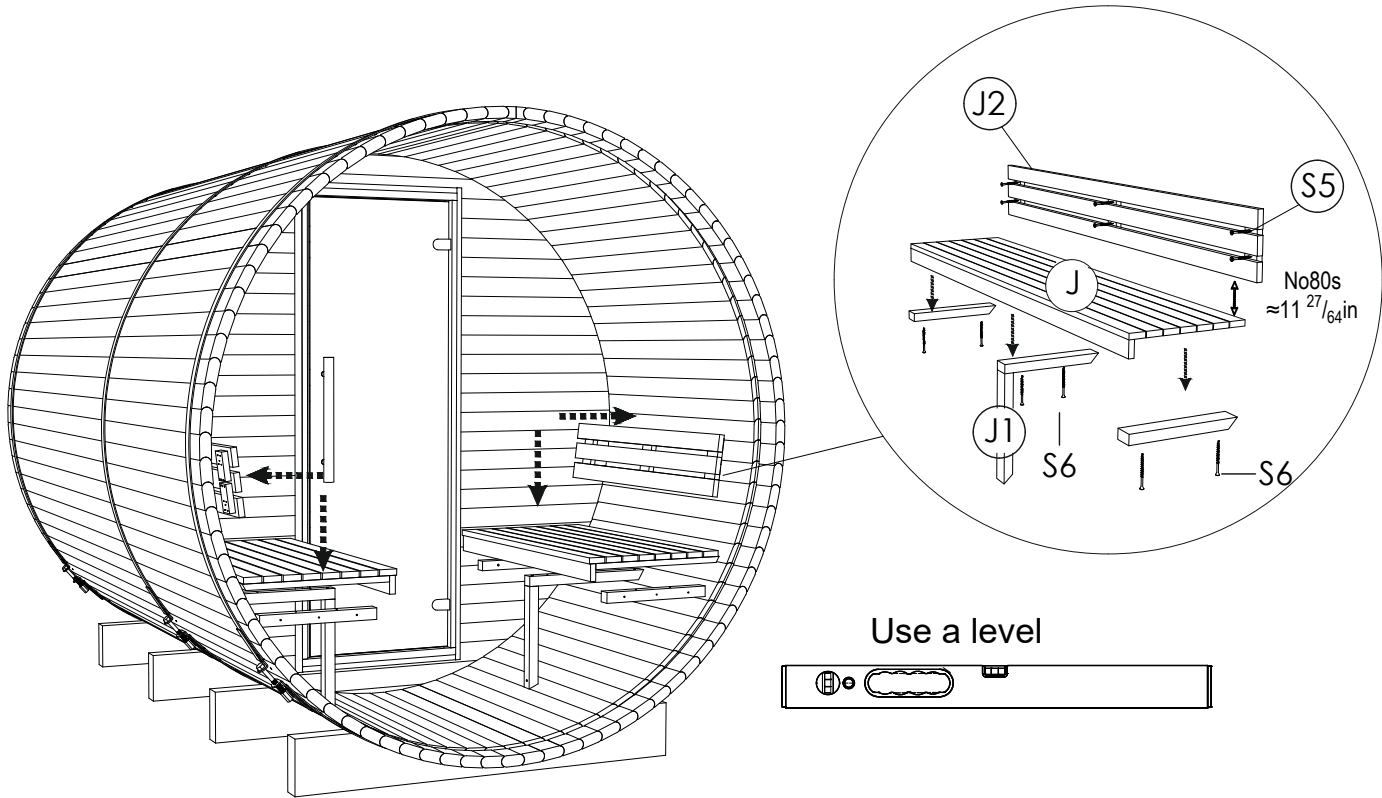
STEP 21: Pre-drill holes before fix backrest with screws, install backrests (J2) using screw (S5). Fix sauna bench (J) to wall mounts and support leg using (S6) screws.



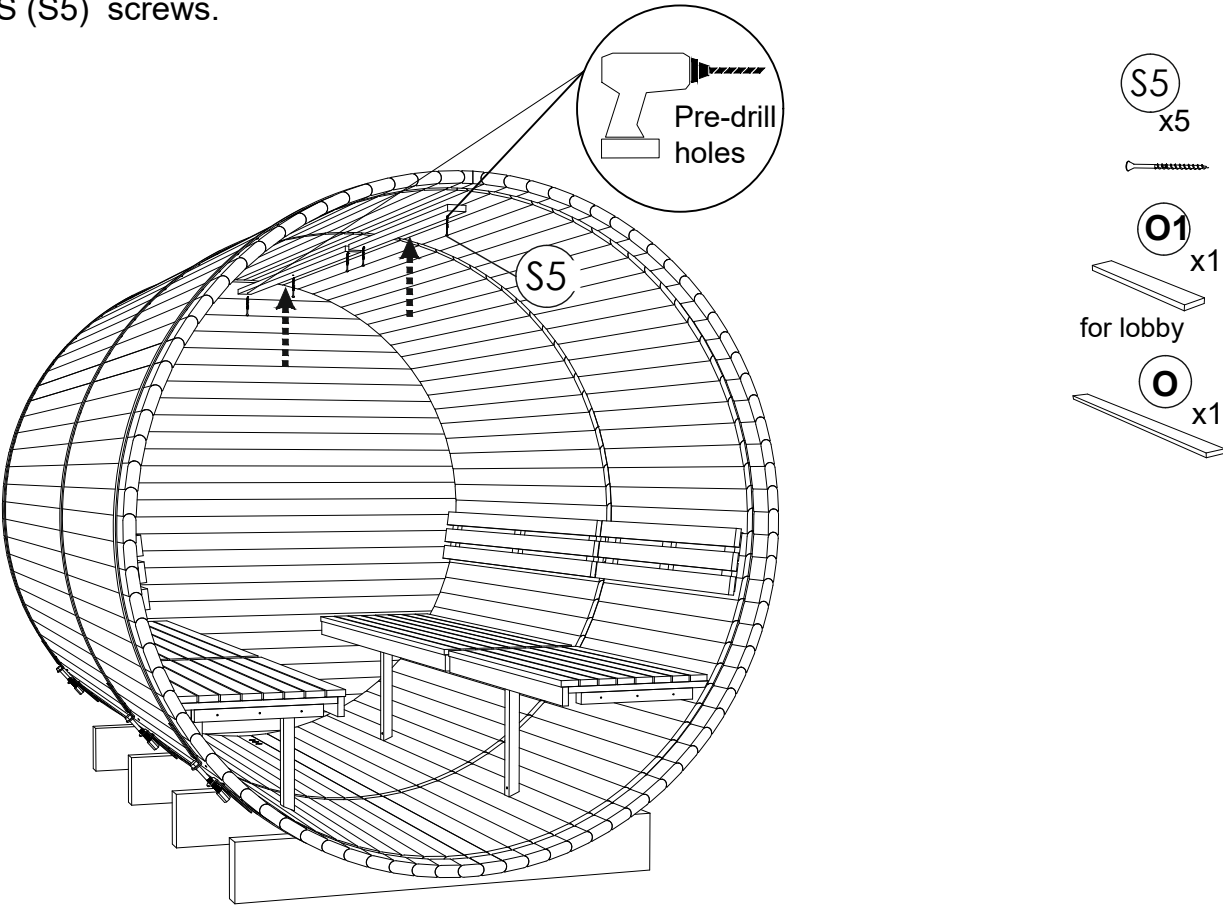
STEP 22: To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, draw a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall mounts. Place J1 in the center and check the level. Using screw (S6) fix bench leg to the wall and floor.



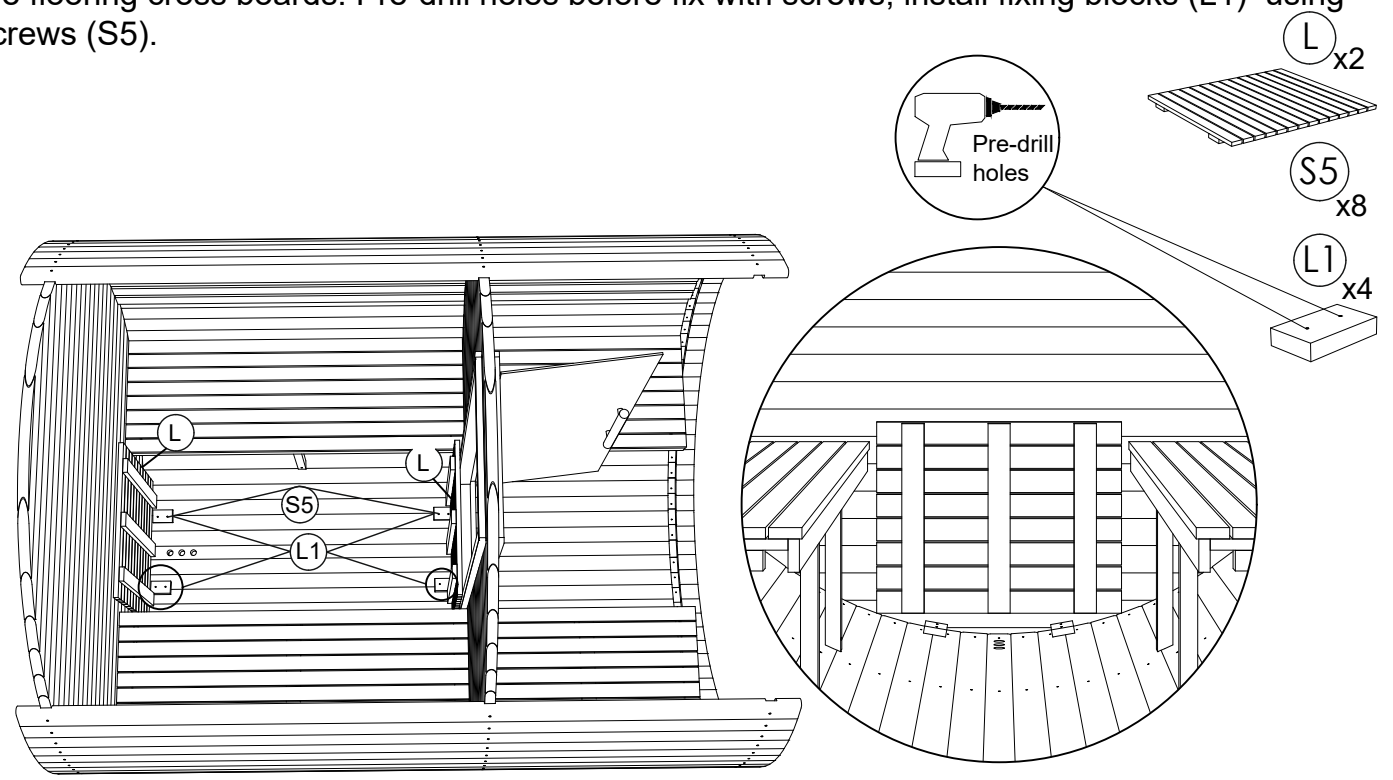
STEP 23: Pre-drill holes before fix backrest with screws, install backrests (J5) using screw (S5). Fix sauna bench (J6) to wall mounts and support leg using (S6) screws.



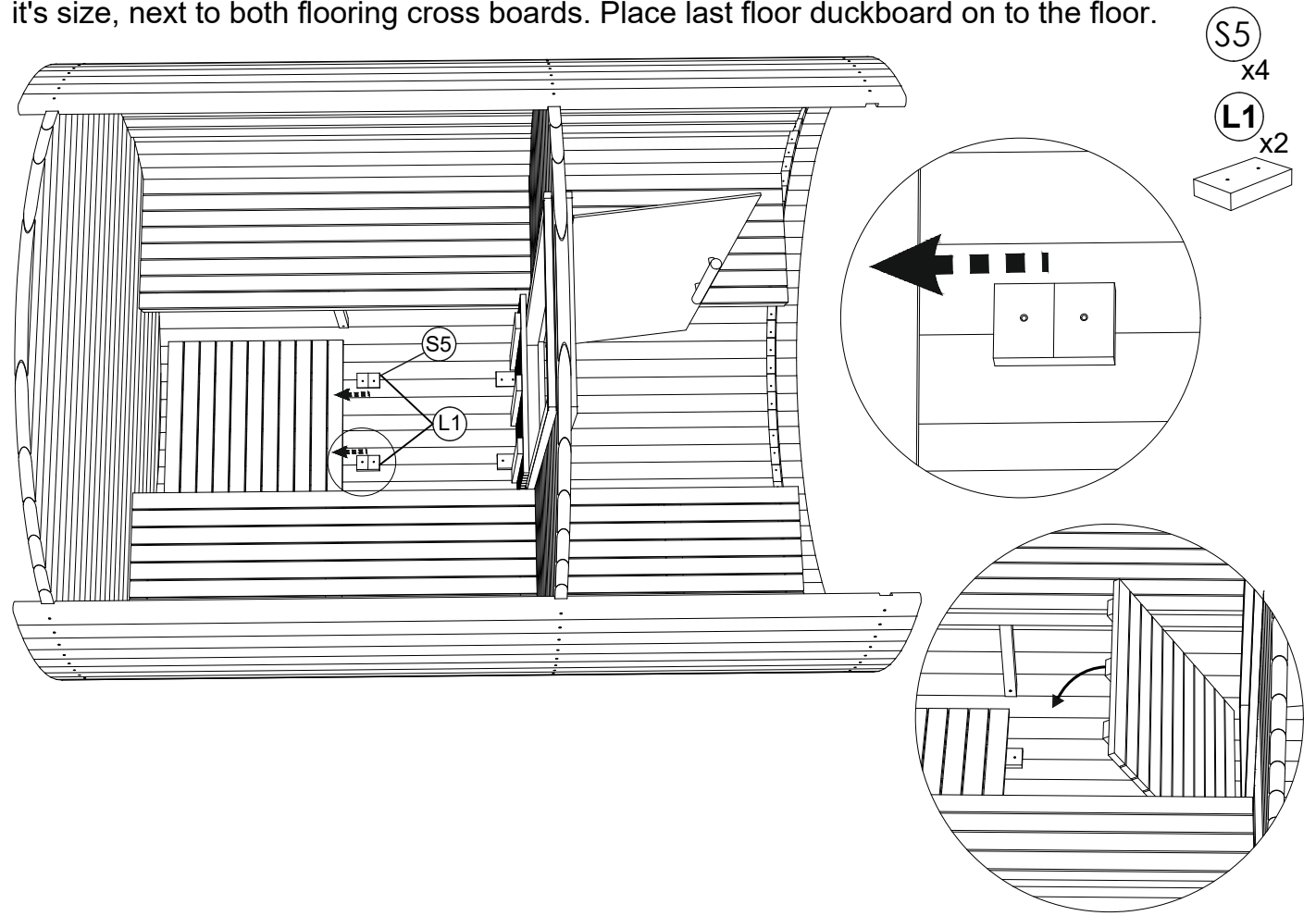
STEP 24: Pre-drill holes before fix staves with screws, install interior roof trim (O) in sauna with 4.0 x 50 SS (S5) screws.



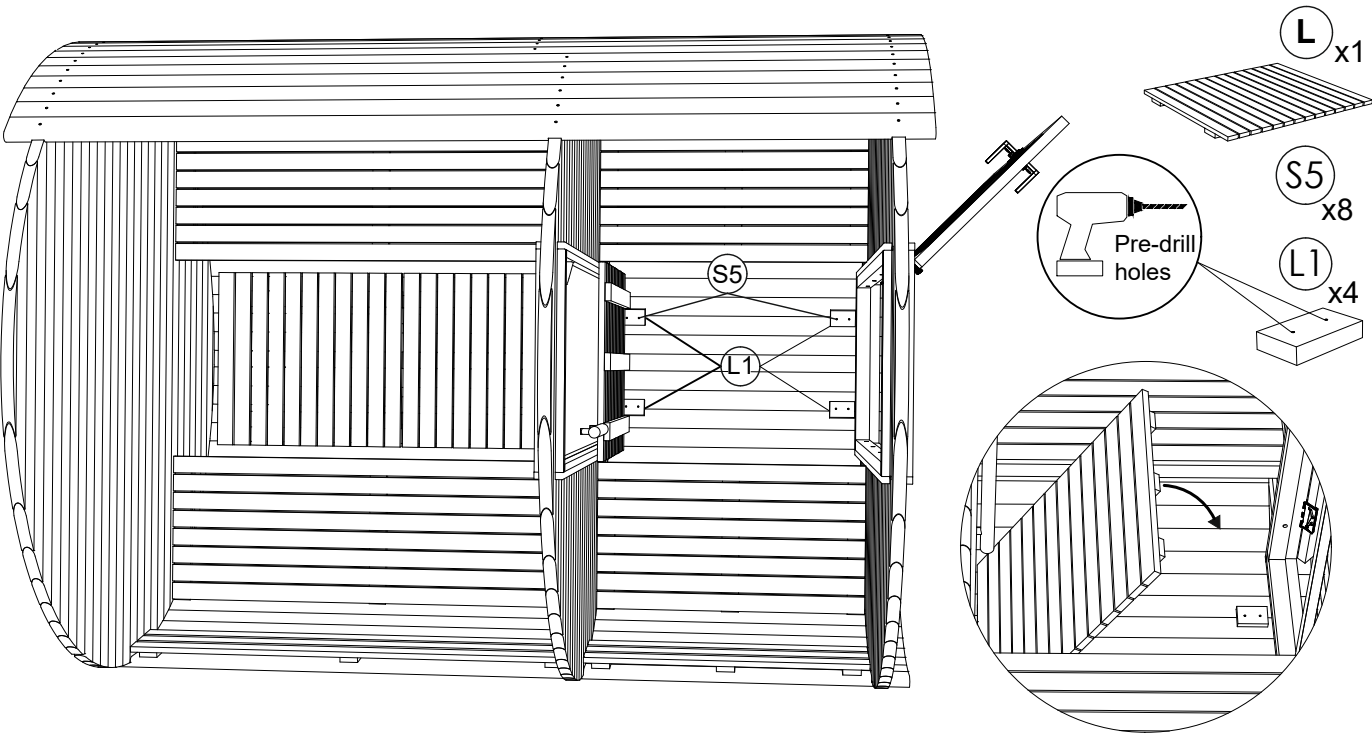
STEP 25: Place floor duckboards (L) to the both sides upwards and place fixing blocks next to the flooring cross boards. Pre-drill holes before fix with screws, install fixing blocks (L1) using screws (S5).



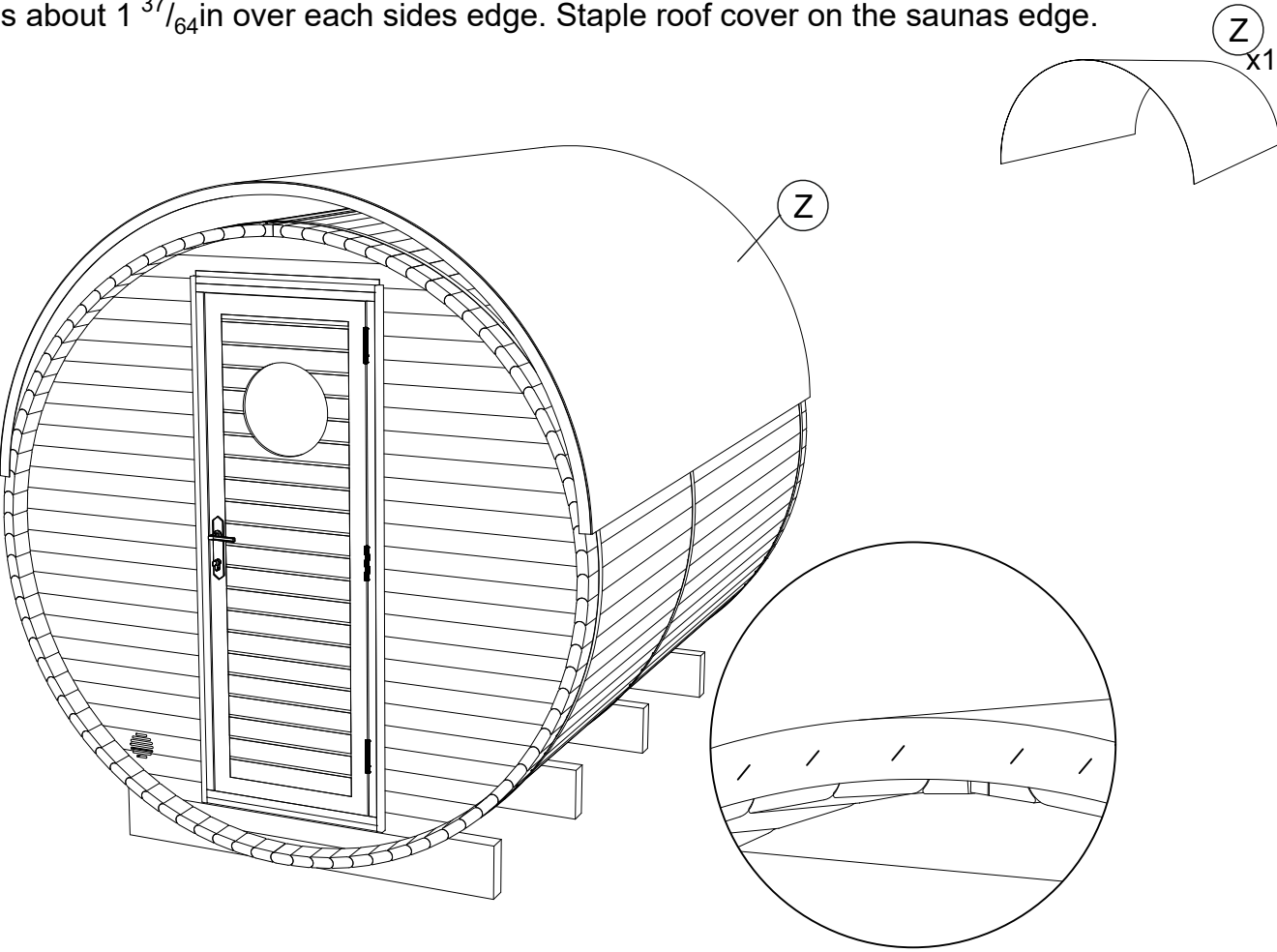
STEP 26: Pre-drill holes before fix with screws, install fixing blocks (L1) under floor duckboard using screws (S5). Place floor duckboards (L) on the floor and fix fixing blocks(L1), about half it's size, next to both flooring cross boards. Place last floor duckboard on to the floor.



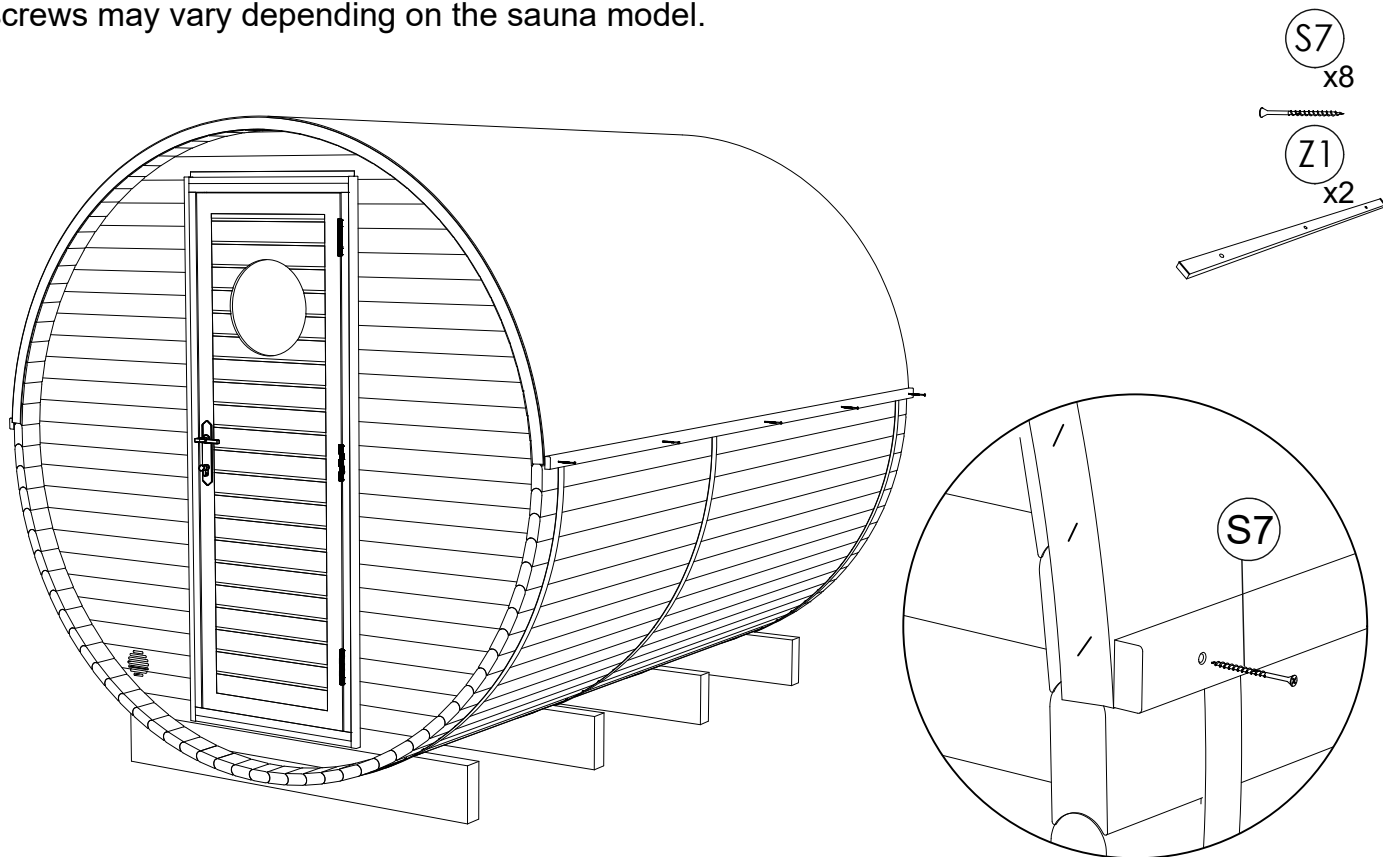
STEP 27: Place floor duckboards (L) to the one side upwards and place fixing blocks next to the flooring cross boards. Pre-drill holes before fix with screws, install fixing blocks (L1) using screws (S5). Place floor duckboard on the floor.



STEP 28: Place waterproof PVC roof cover . Align roof cover equally to both sides. Roof cover goes about 1 ³⁷/₆₄in over each sides edge. Staple roof cover on the saunas edge.



STEP 29: Fix wooden slats (Z1) with screws (S7) on the rain jacket bottom. The number of screws may vary depending on the sauna model.



STEP 30: 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, approx. $\frac{50}{64}$ in above roof or $\frac{13}{64}$ in under the roof. Then fix next boards right next to previous board.

