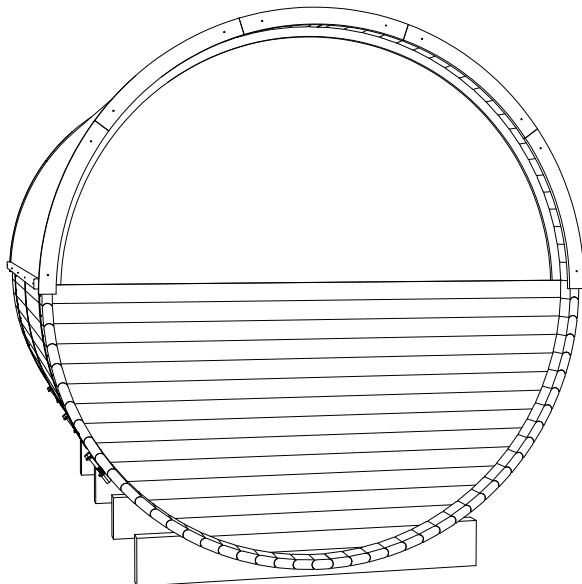
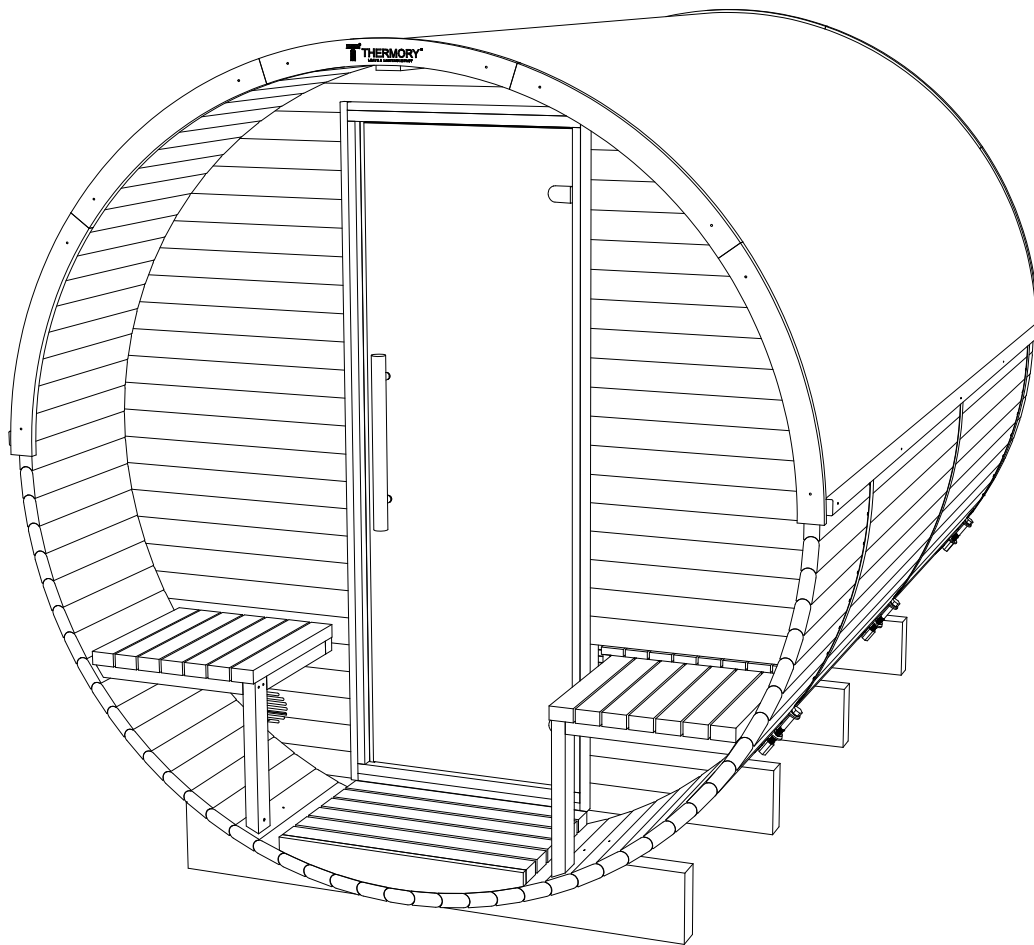
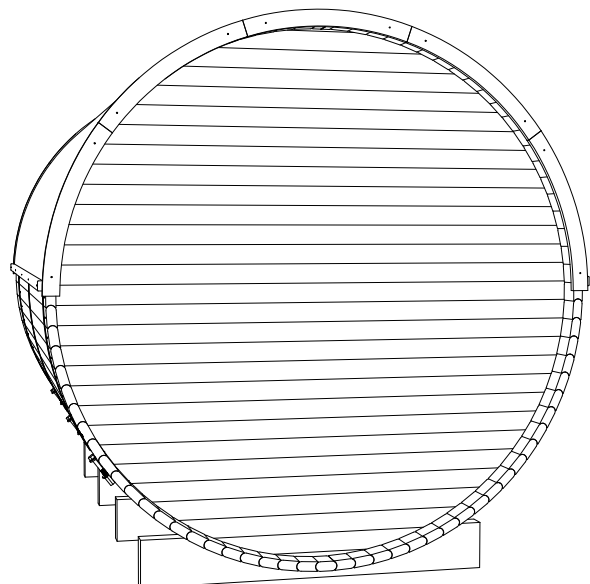


# BARREL SAUNA

## ASSEMBLY INSTRUCTIONS



Model: No82

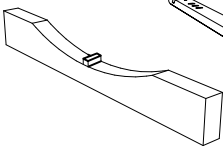
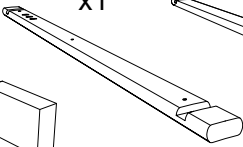

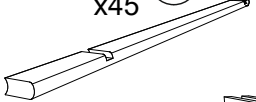
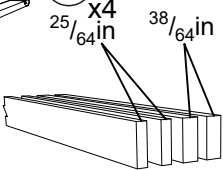
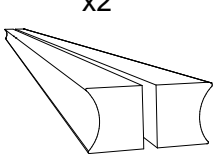
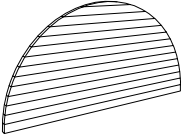
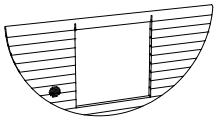
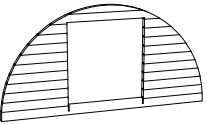

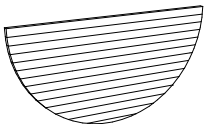
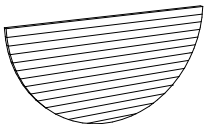
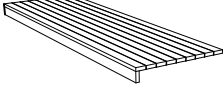
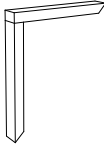

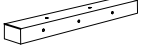


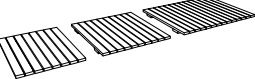
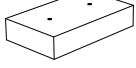
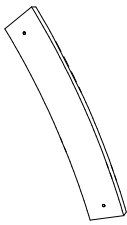
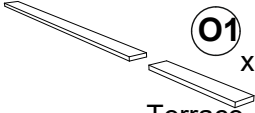
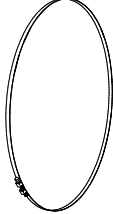
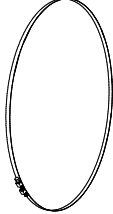














Model: No83

**Note: Please read the manual before construction**


Rev. 07.10.2024.

## PART LIST


<b>A</b> x4  cradle	<b>B</b> x1  center stave	<b>C</b> x45  left side body stave	<b>C1</b> x45  right side body stave	<b>H1</b> x4  different thickness filling peaces	<b>H</b> x2  final H tipe stave at the top
<b>V3</b> x1  upper rear panel	<b>F</b> x1  front panel bottom	<b>F1</b> x1  front panel top	<b>F2</b> x1  door and door moldings	<b>V</b> x1  bottom rear panel	<b>V</b> x1  bottom rear panel
<b>J</b> x2  sauna bench	<b>J1</b> x4  supporting leg	<b>J2</b> x2  backrest	<b>J3</b> x4  wall mount	<b>N1</b> x2  door handle	<b>N1</b> x2  door handle
<b>L</b> x3  sauna floor	<b>L1</b> x6  fixing block for sauna floor	<b>W</b> x10  decorative roof finishing board	<b>O</b> x1  roof board	<b>I</b> x3  metal band	<b>I</b> x3  metal band
<b>D</b> x3  Cable canal (for LED option)	<b>S1</b> x75  screw 5.0x100 SS	<b>S10</b> x160  screw 4.0x60	<b>S5</b> x50  screw 4.0x50 SS	<b>S4</b> x11  screw 5.0x120	<b>S4</b> x11  screw 5.0x120
<b>S8</b> x15  Cable canal nails (for LED option)	<b>S6</b> x40  screw 5.0x70 SS	<b>S7</b> x35  screw 4.2x55 brown	<b>S2</b> x25  screw 4.0x70 SS	<b>S14</b> x10  screw 5.0x80	<b>S14</b> x10  screw 5.0x80

PART LIST

S9


  
x2

bolt  
ø12x140

+ 

x2

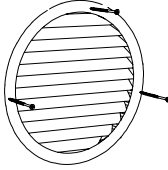
hex nut  
M12 (SW19)

+ 

x4

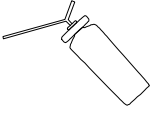
flat washer

Y1

  
x1


ventilation grill

P7




Construction foam


x12  
13/64

  
green


x10  
5/64

  
blue


x10  
3/64

  
red


x12  
13/64

  
green

x10  
5/64

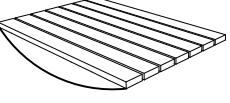
  
blue

x10  
3/64

  
red

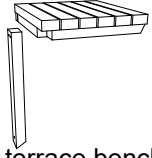
door box spacers

L2

  
x1

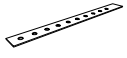
Flooring duckboard  
(outside)

K

  
x2


terrace bench

D

  
x1

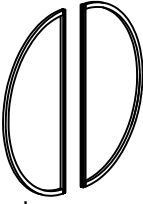
metal bracket

S12

  
x7


screw 4.0x30

V1

  
x2

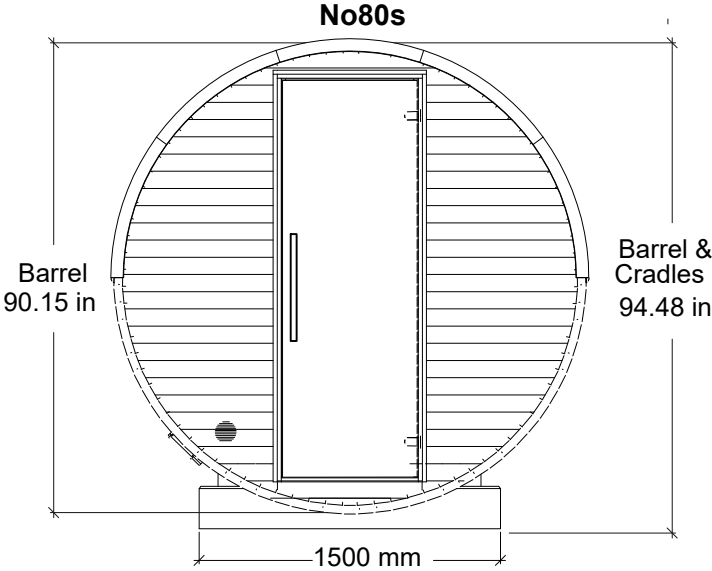
back rear panel

V1-Fx1

  
x1

spacer bar

Barrel Dimensions




No80s

Barrel 90.15 in

Barrel & Cradles 94.48 in

1500 mm

RECOMMENDATION



2 person recommended

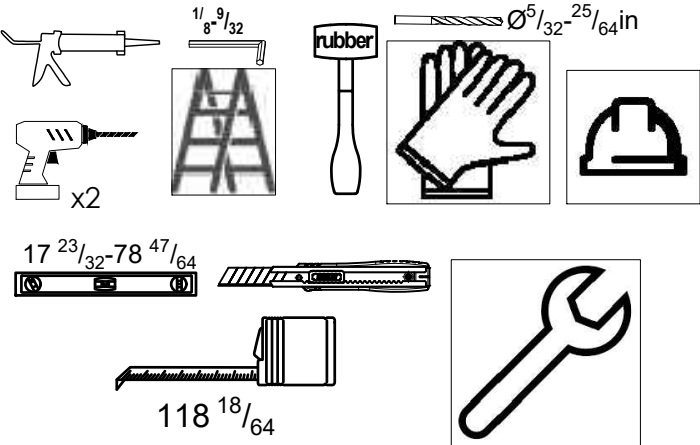
Before you begin, be sure the sauna will fit in your chosen location.

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



1/8" 9/32

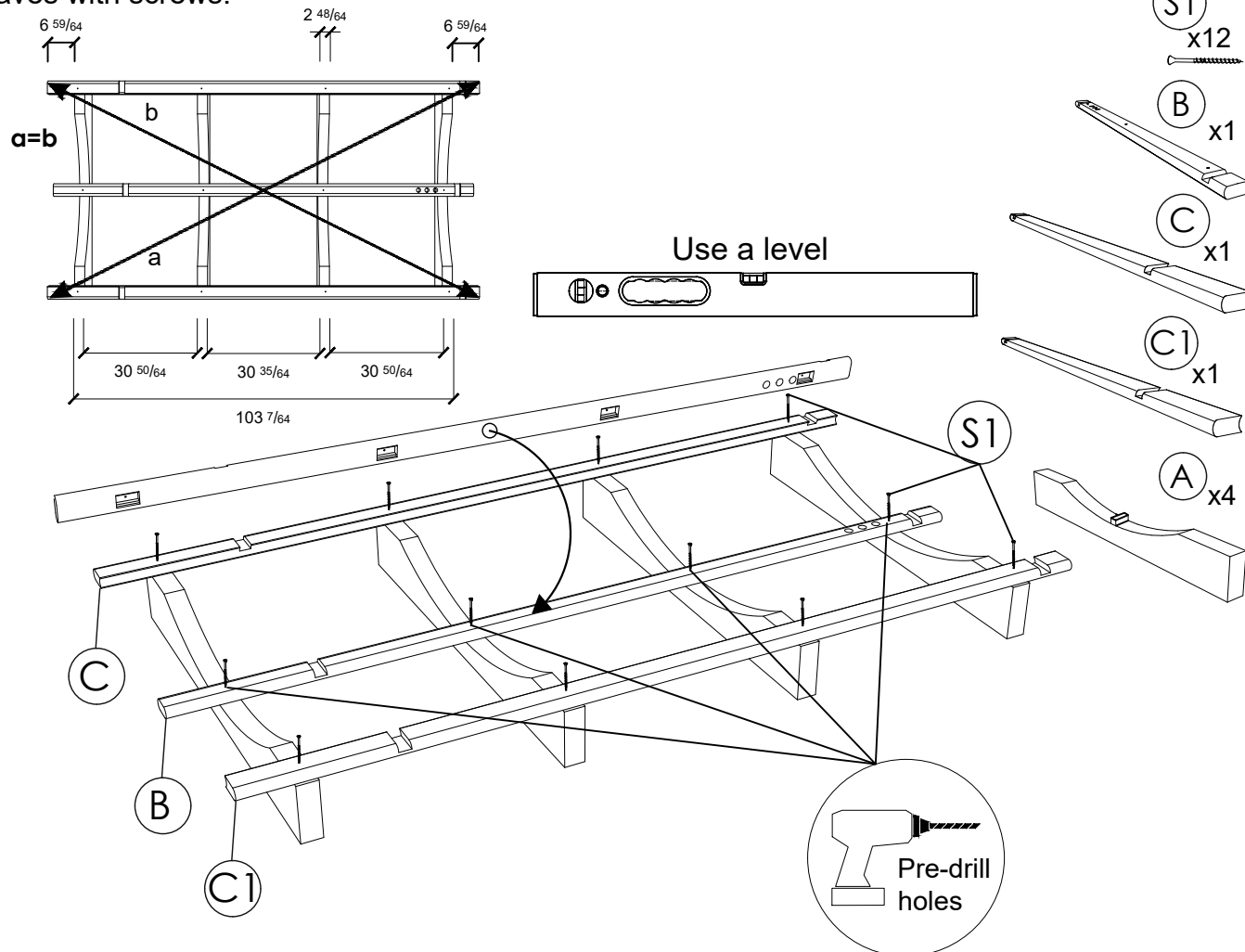
Ø5/32"-25/64in

rubber

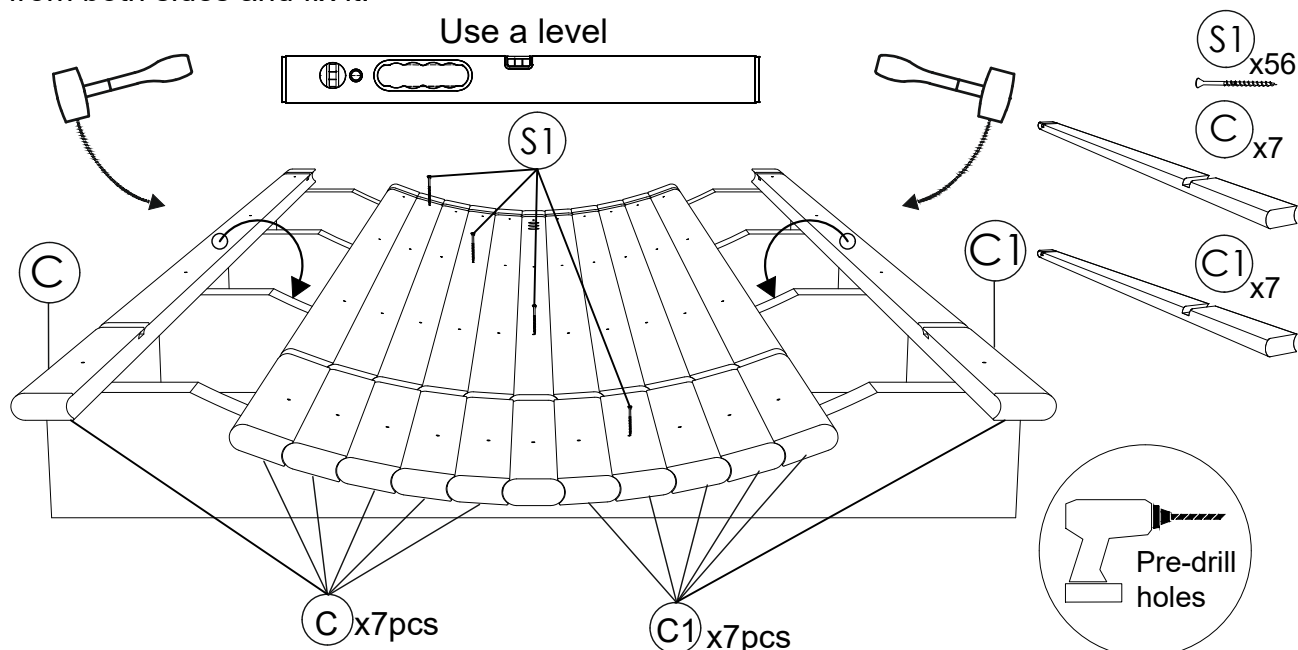
17 23/32"-78 47/64

118 18/64

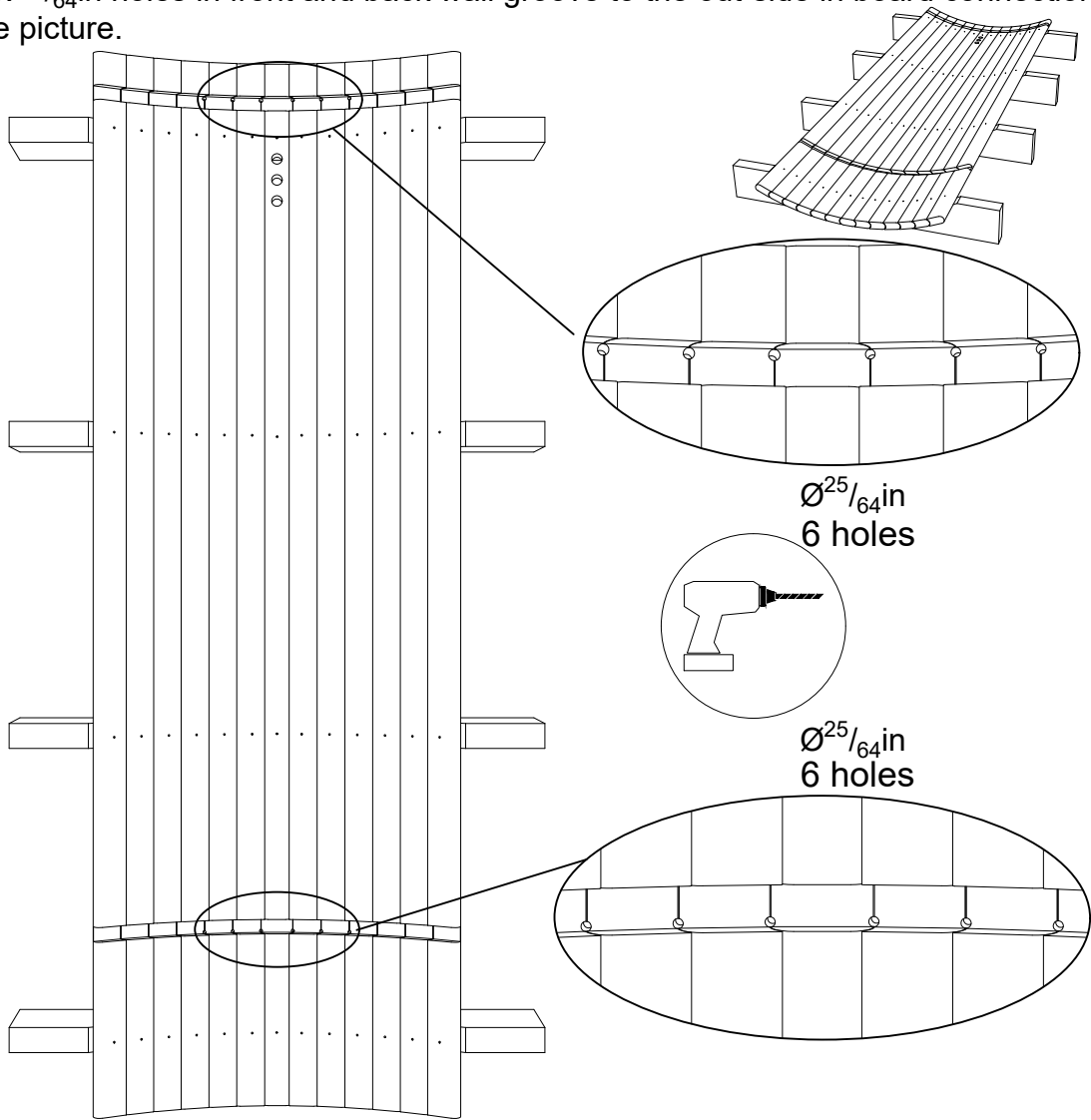
**STEP 1:** Place the support cradles (A) on level site. Carefully level for better stability. Place the center stave (B) on wooden dowels embedded in outer support cradles (A). Fix the center stave (B) with screws(S1). Then fix boards on top of the cradles at the side corners. Measure support cradles (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.



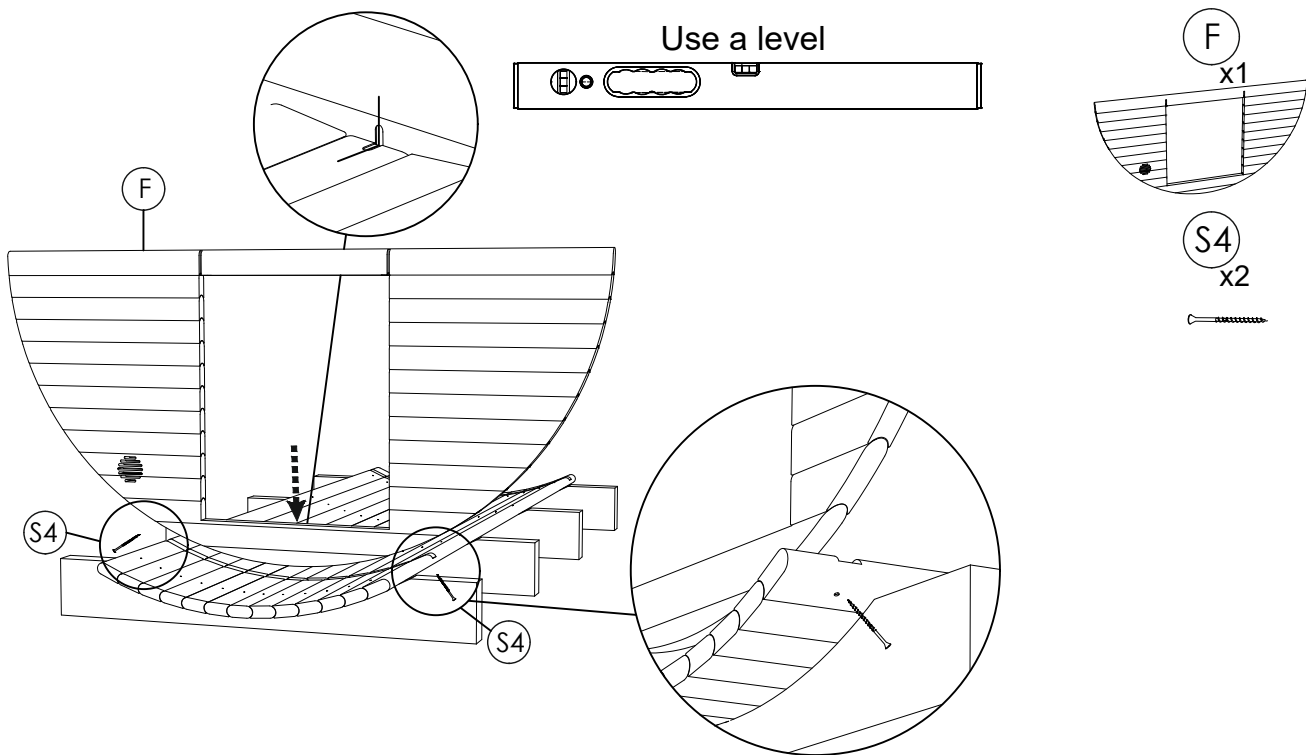
**STEP 2:** Pre-drill holes before fix staves with screws. Place 6 (R190) or 7 (No60s) sauna body staves (C) to each side of the center stave (B) and fix with screws 5.0x100 SS (S1). Be sure to align the panel groove on every next body stave, to do that use rubber hammer. Take of last board from both sides and fix it.



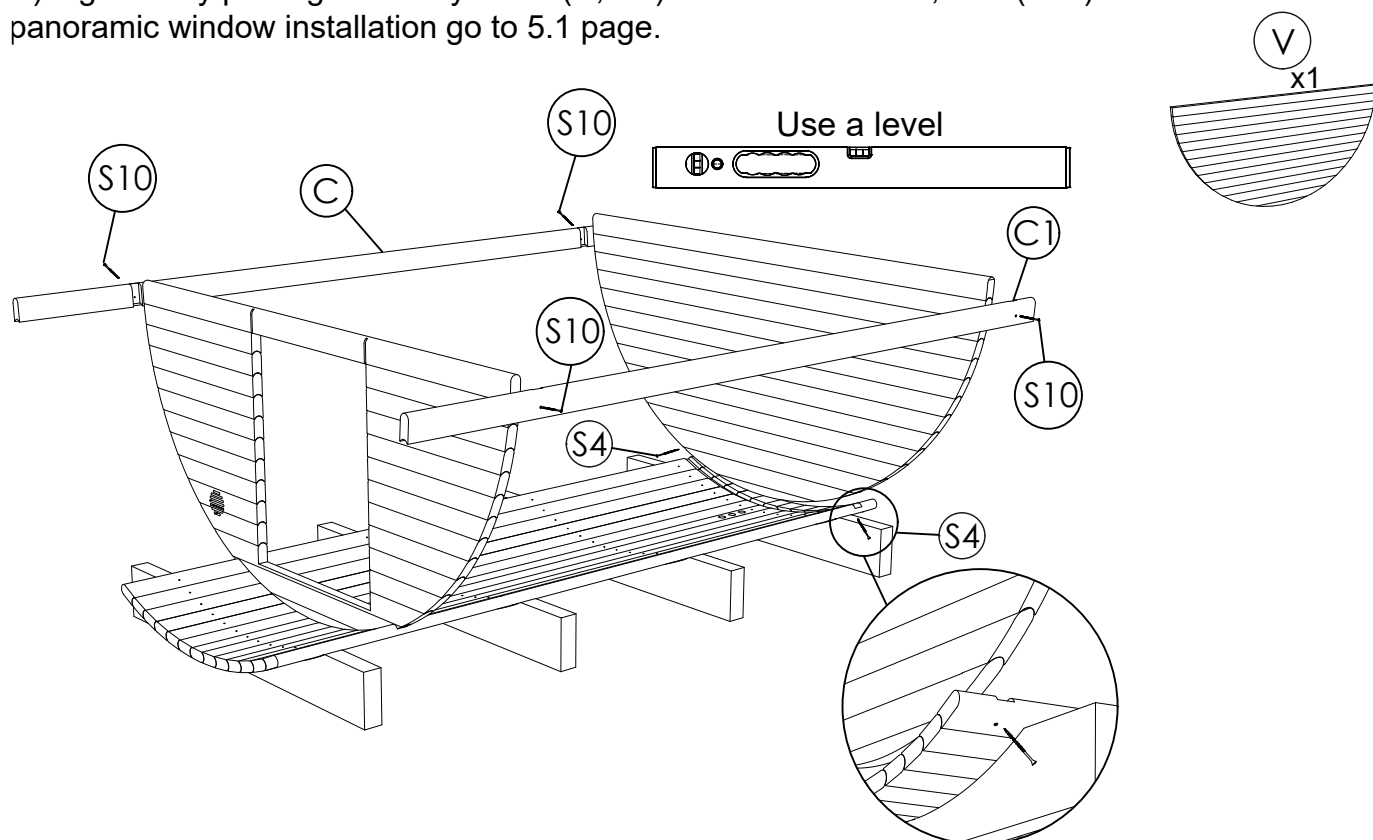
**STEP3:** Drill six  $\frac{25}{64}$ in holes in front and back wall groove to the out-side in board connections as shown in the picture.



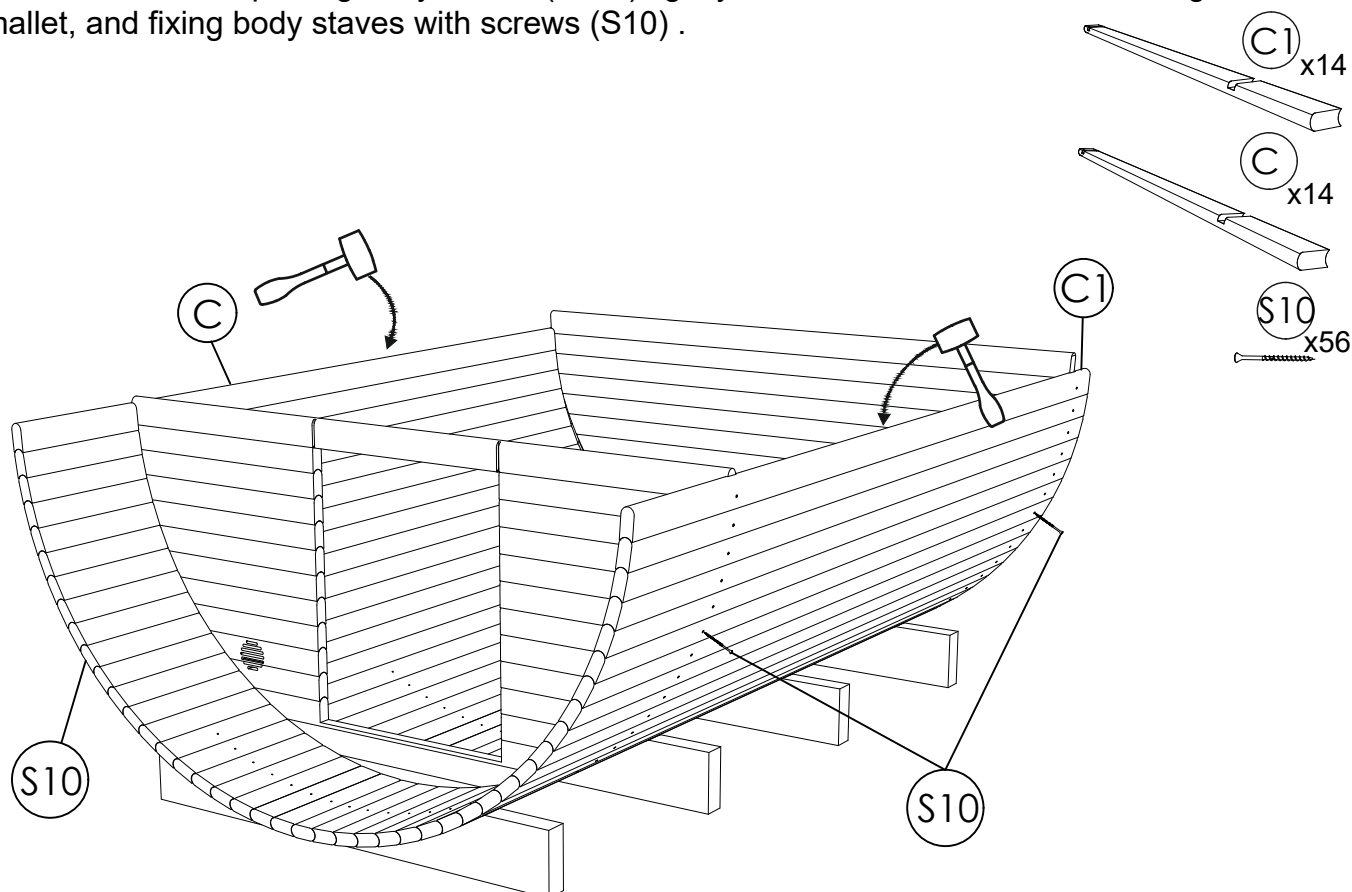
**STEP 4:** Place front bottom panel (F) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides.



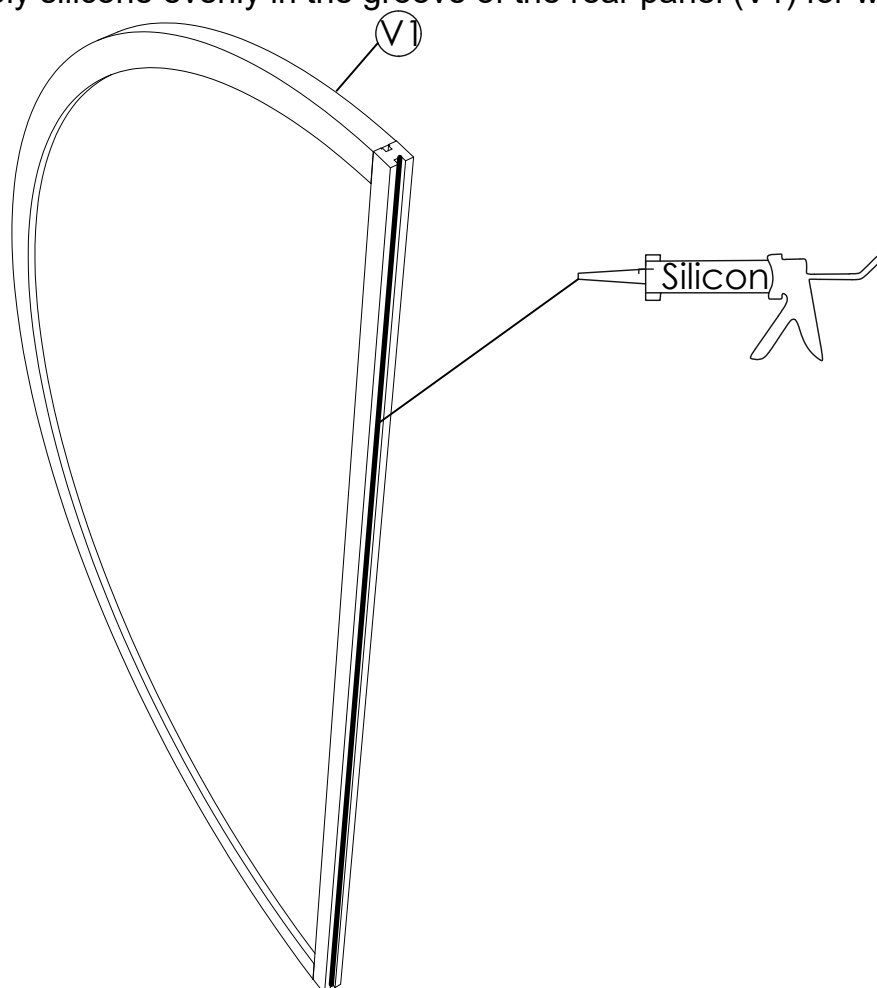
**STEP 5:** Place rear panel (V) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides. Connect the panels (F; V) together by placing one body stave (C; C1) both sides in level, with (S10) screws. For full panoramic window installation go to 5.1 page.



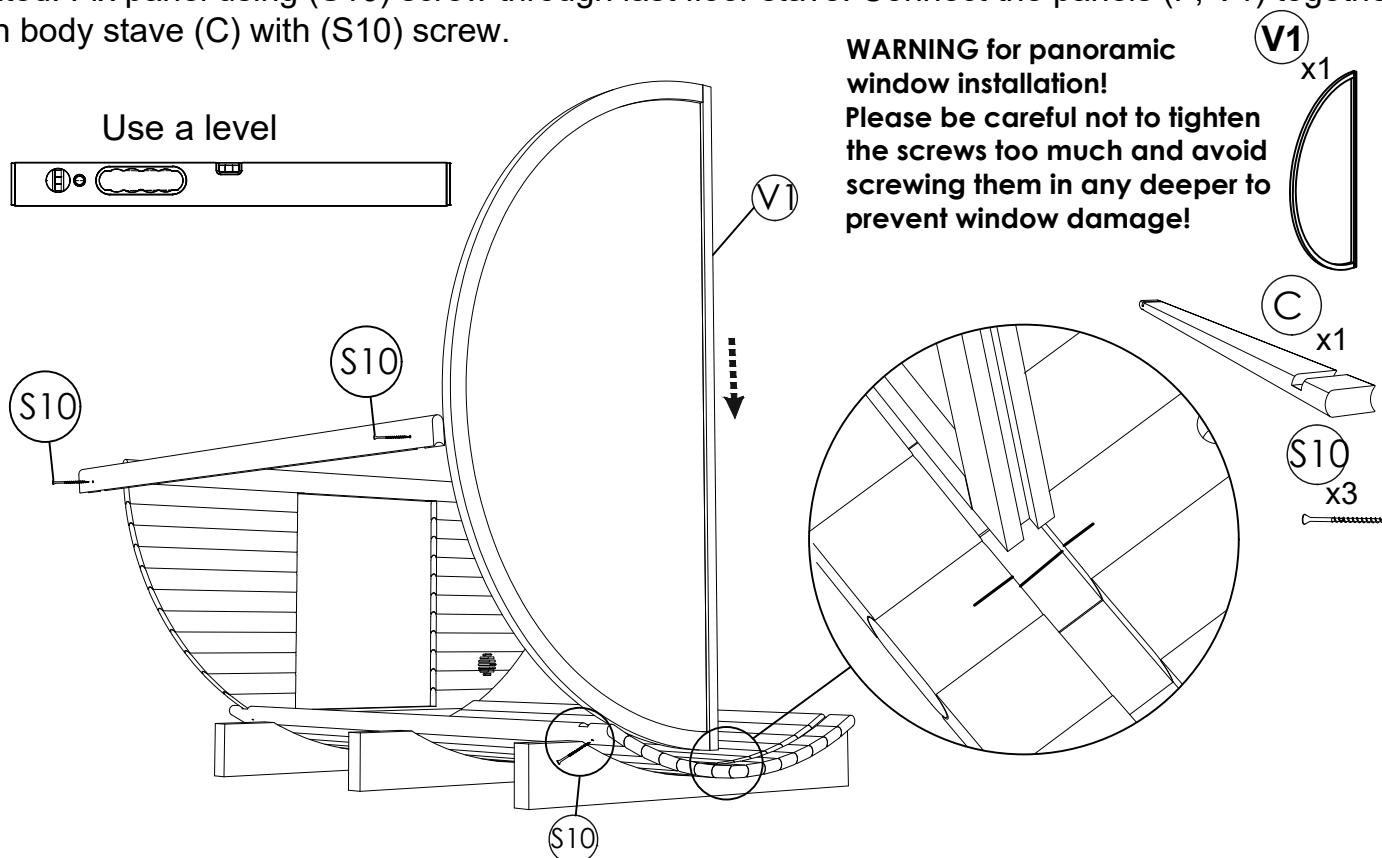
**STEP 6:** Continue placing body staves (C;C1) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10) .



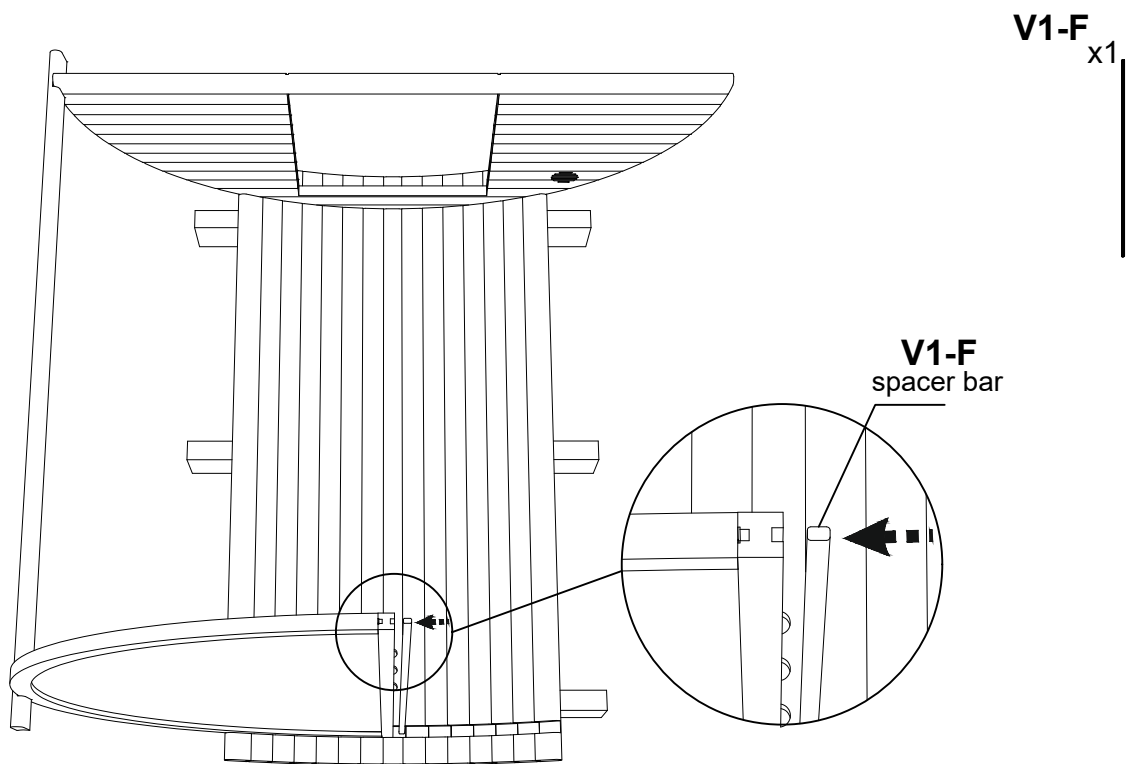
**STEP 1:** Apply silicone evenly in the groove of the rear panel (V1) for wood spacer bar (V1-F).



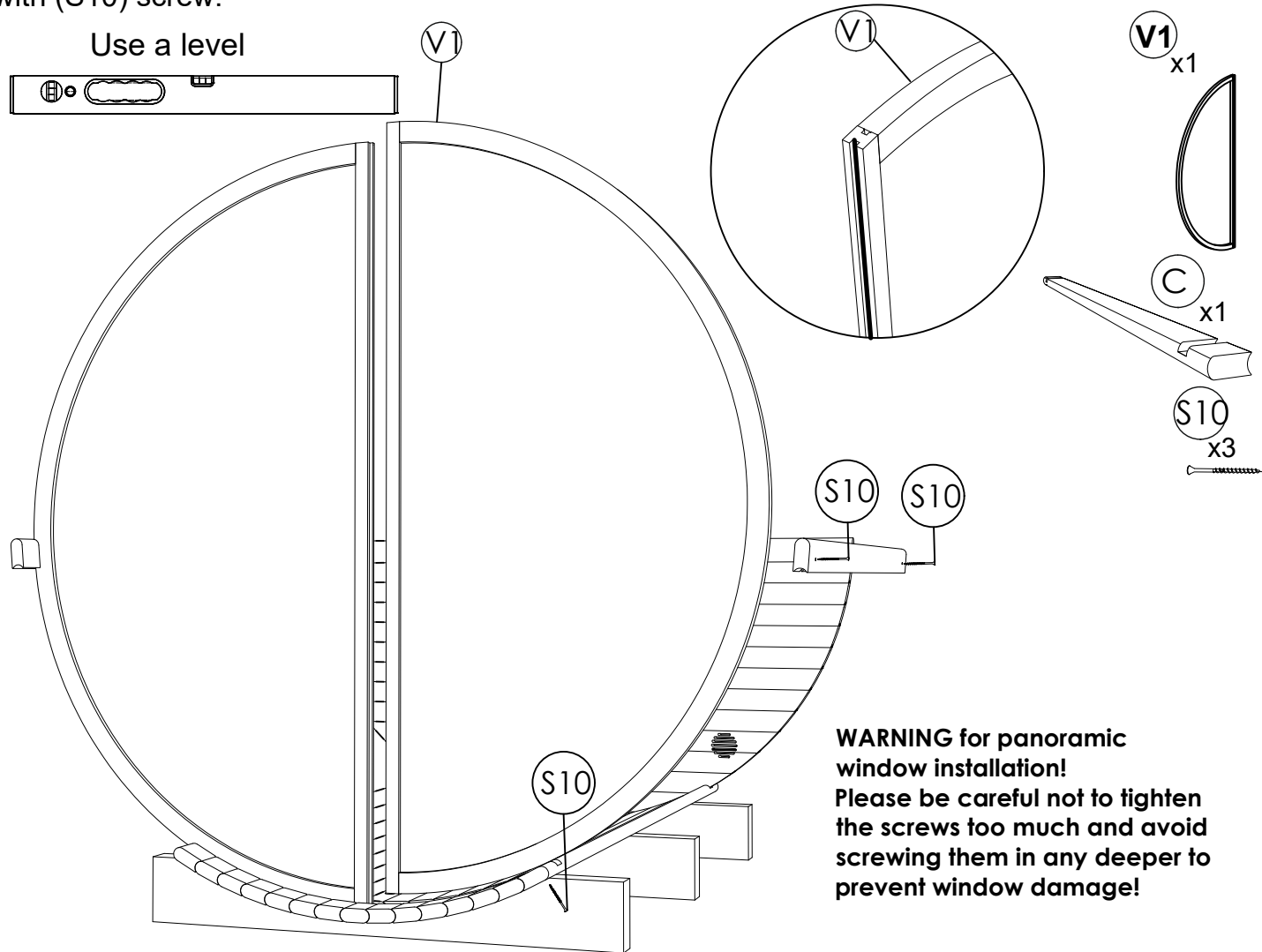
**STEP 2:** Place rear panel (V1) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S10) screw through last floor stave. Connect the panels (F; V1) together with body stave (C) with (S10) screw.



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



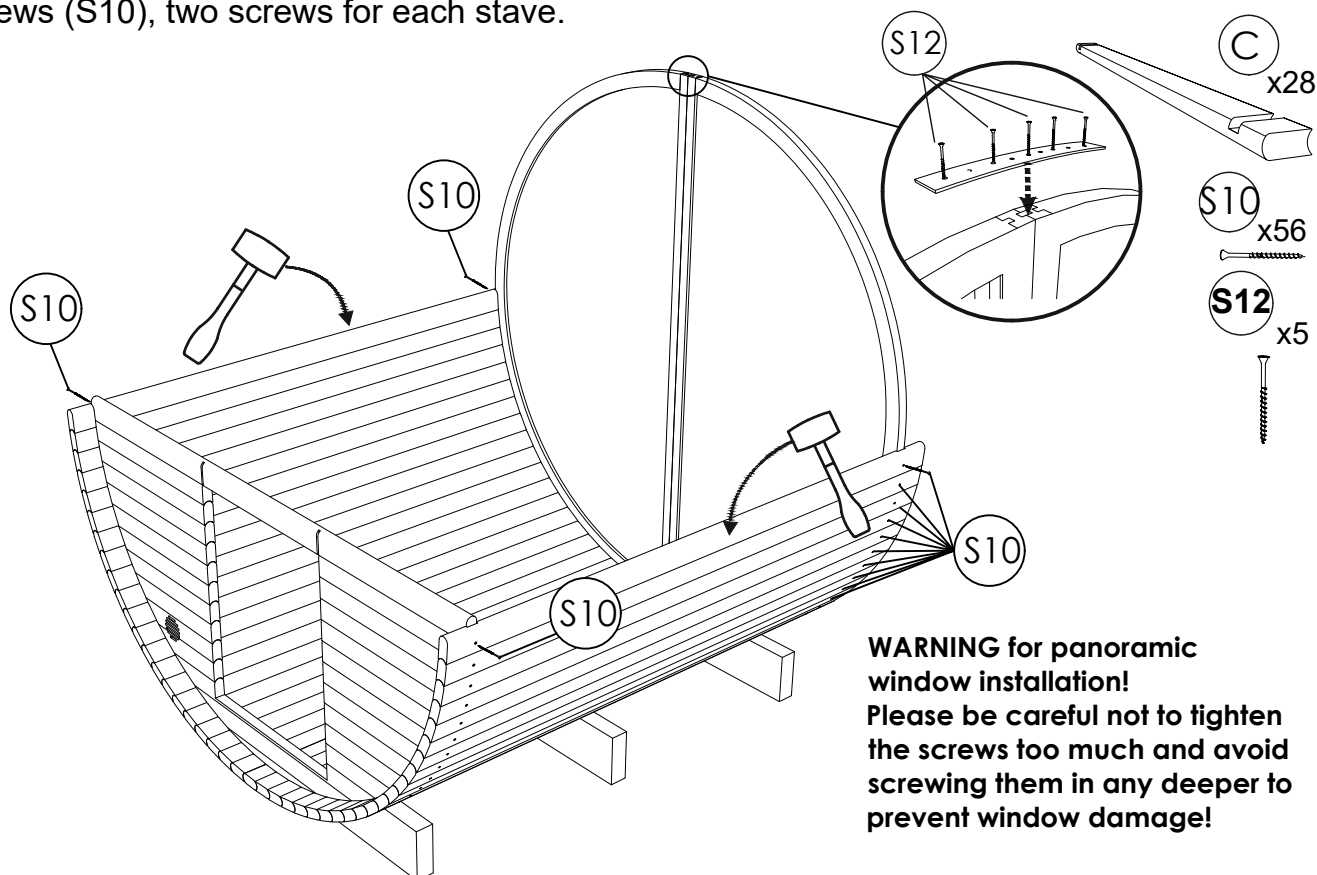
**STEP 4:** Apply silicone evenly in the groove of the second rear panel (V1). Place second rear panel (V1) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S10) screw through last floor stave. Connect the panels (F; V1) together with body stave (C) with (S10)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



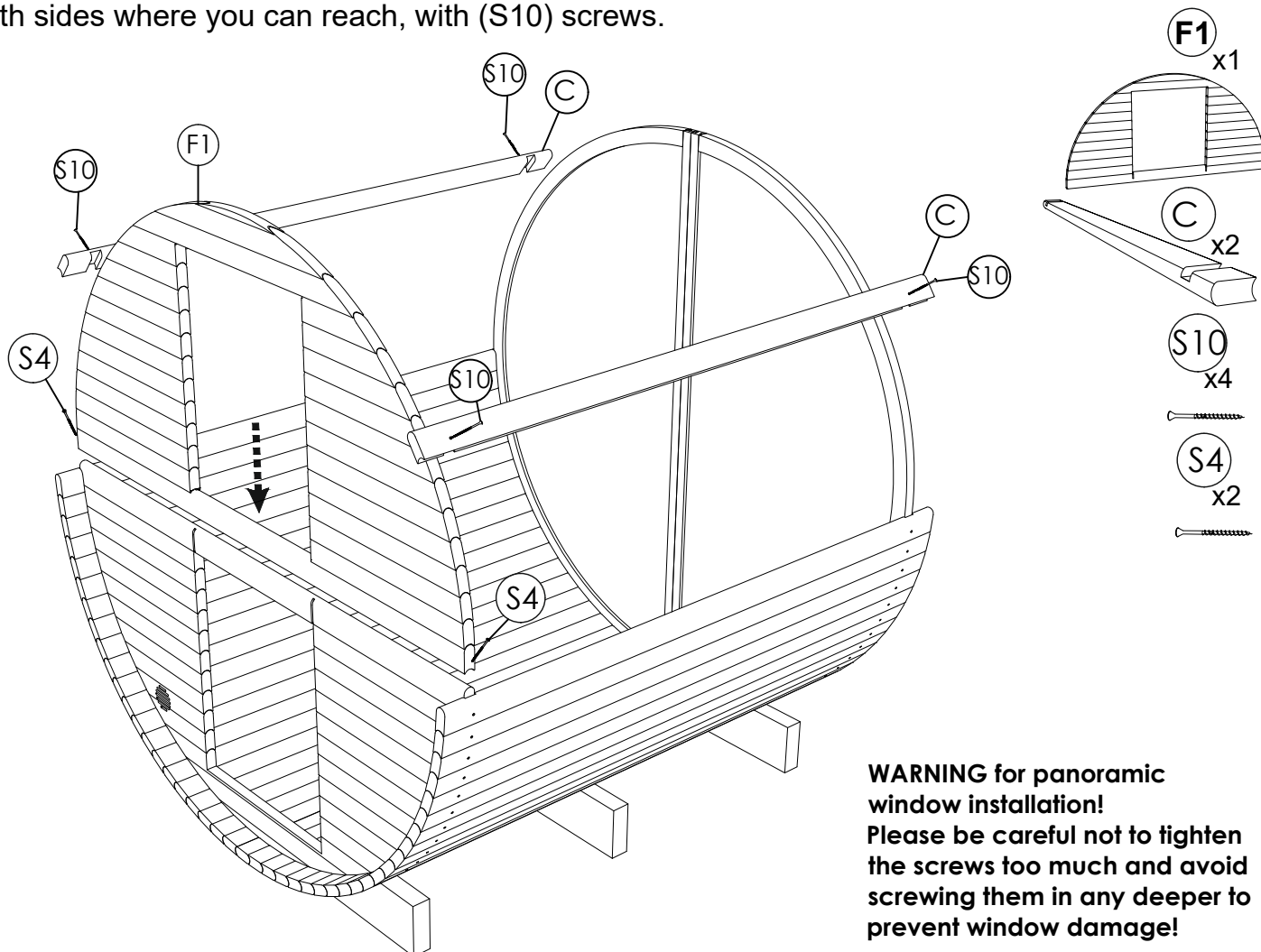
**WARNING for panoramic window installation!**  
Please be careful not to tighten the screws too much and avoid screwing them in any deeper to prevent window damage!



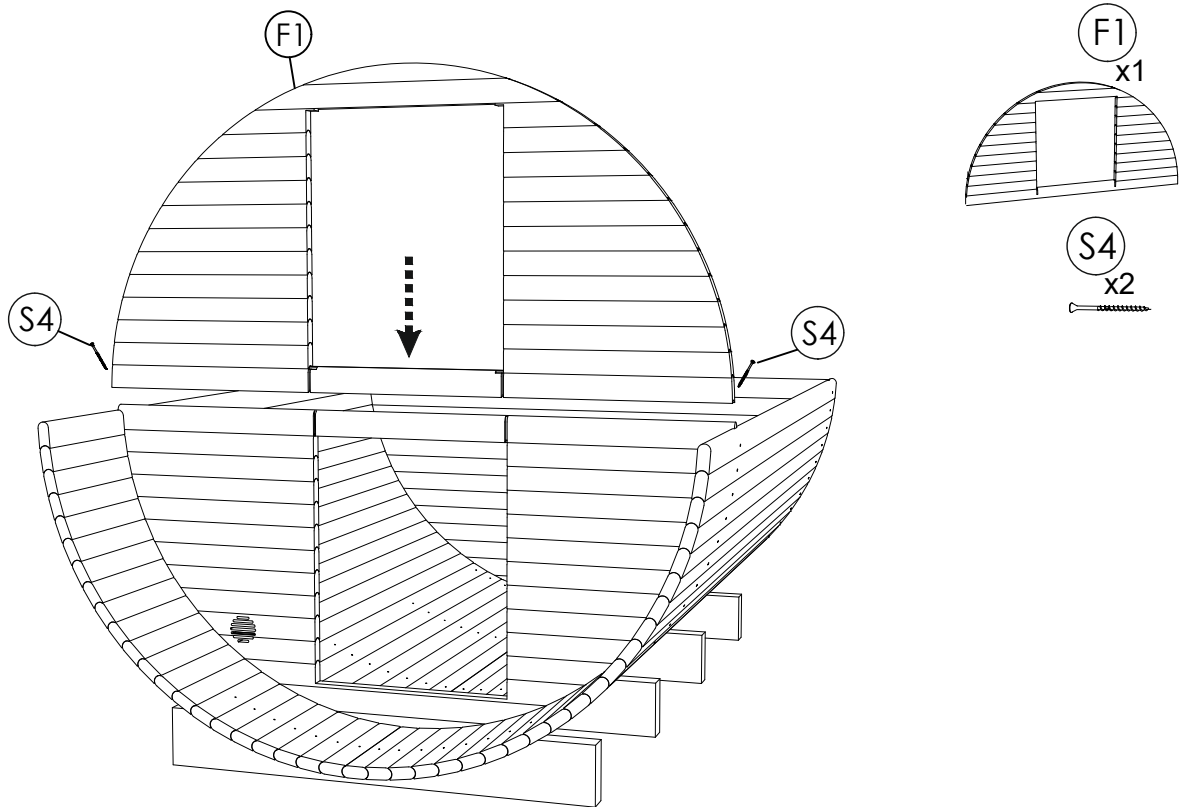
**STEP 5:** Fix Assembly tape with five screws (S12) to fix both panels together. Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10), two screws for each stave.



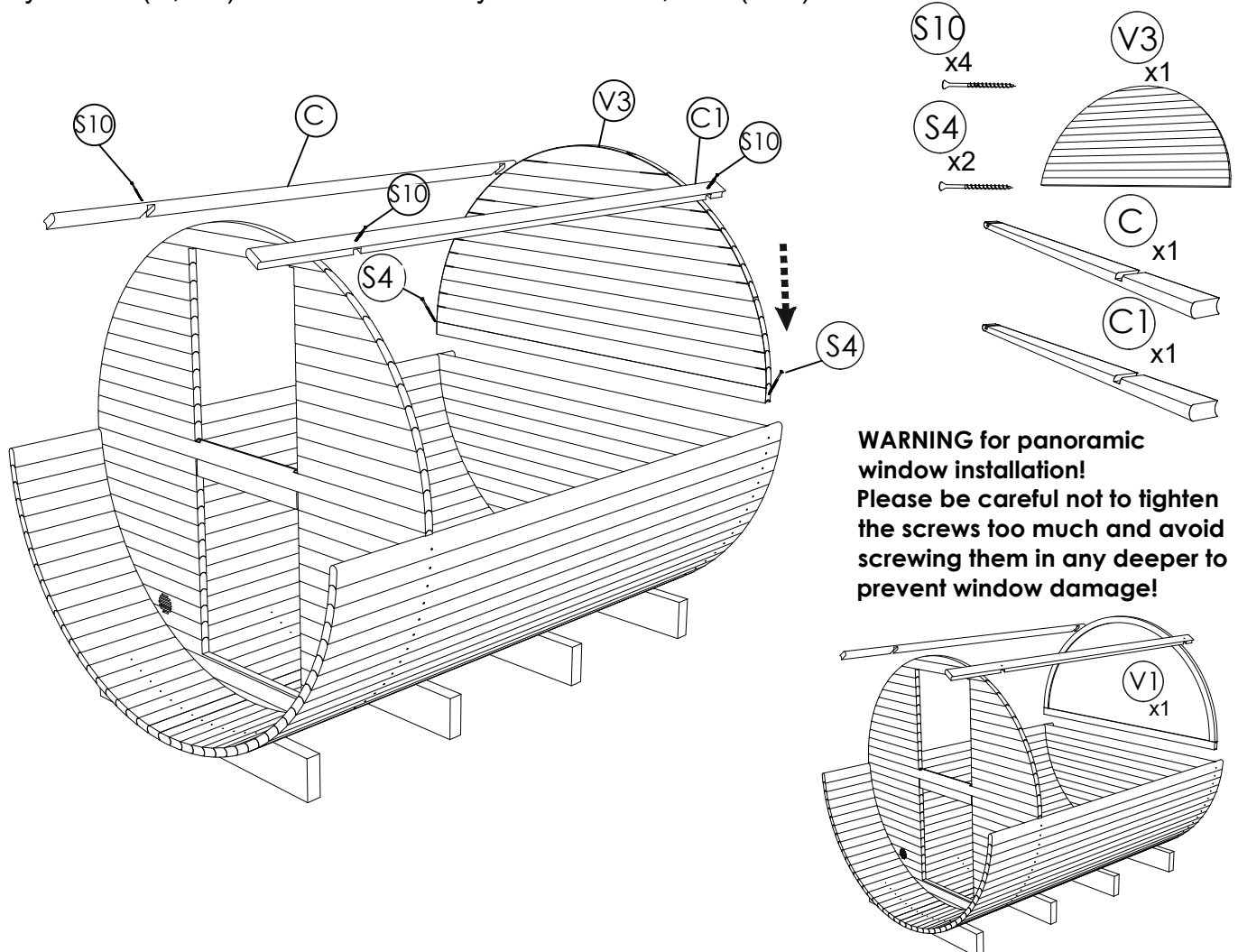
**STEP 6:** Take the upper front panel (F1) and place it on top of the front panel (F). Secure it by using 2 screws (S4). Connect the panels (F1; V1) together by placing one body stave (C) on both sides where you can reach, with (S10) screws.



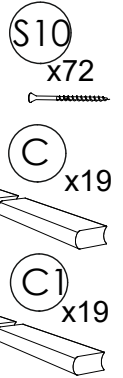
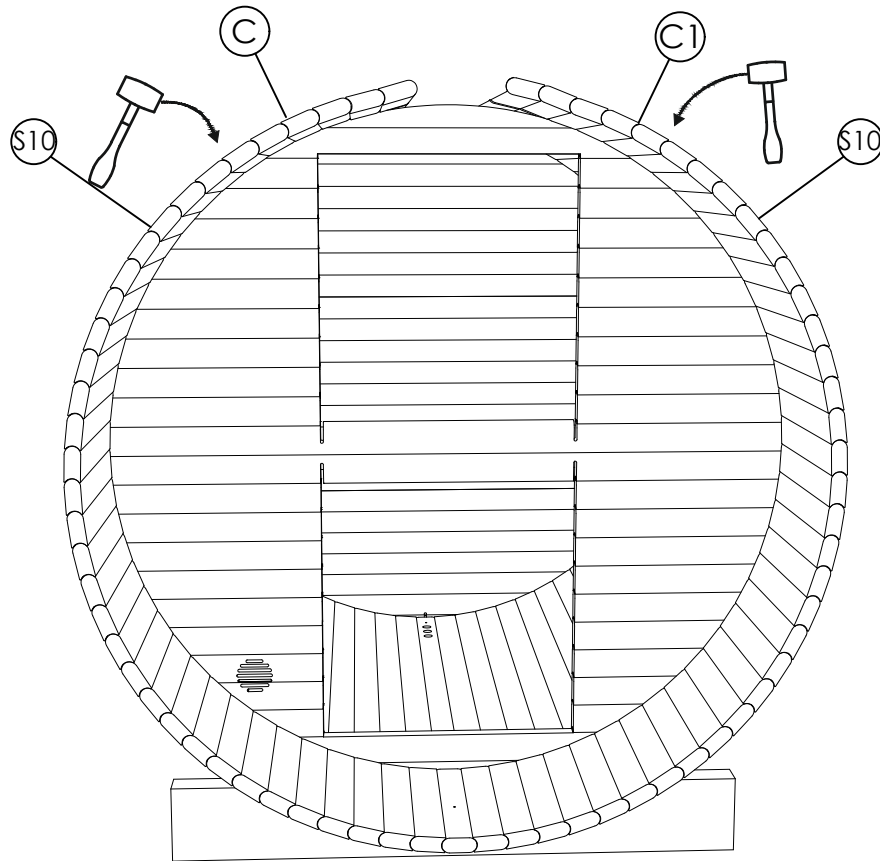
**STEP 7:** Place front top panel (F1) on front bottom panel (F), be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws on both sides.



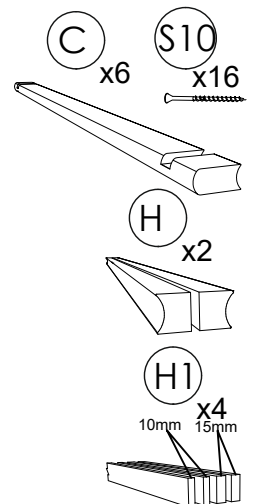
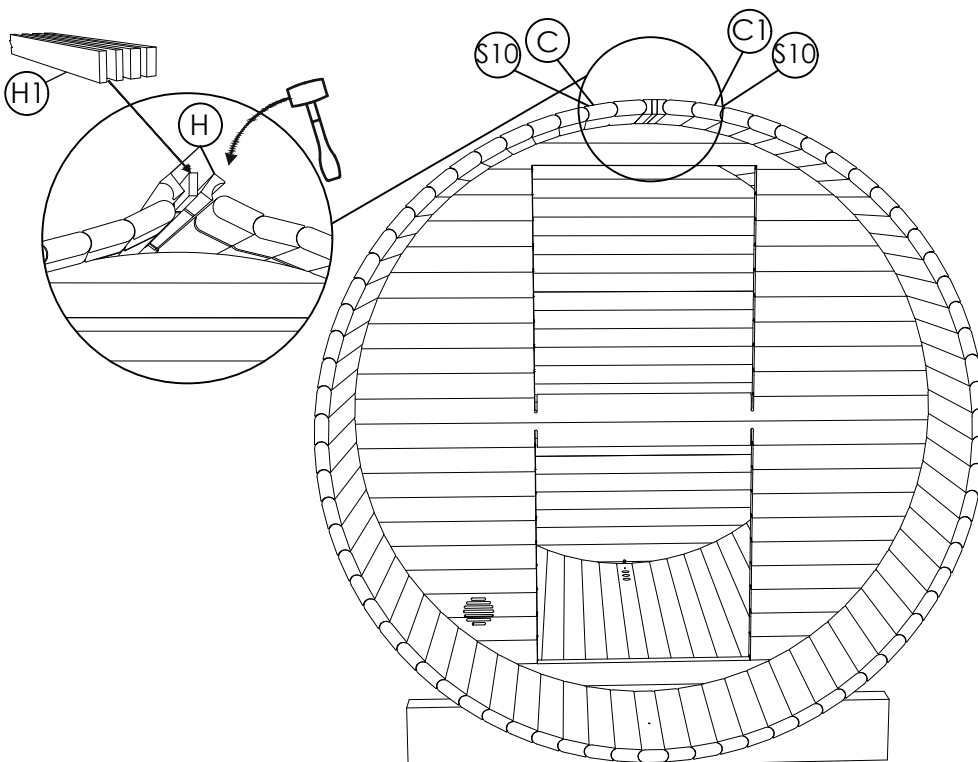
**STEP 8:** Take the upper rear panel (V3 or V1-panoramic window) and place it on the bottom rear panel (V). Secure it by using 2 screws (S4). Connect the panels (F2; V3) together by placing one body staves (C; C1) both sides where you can reach, with (S10) screws.



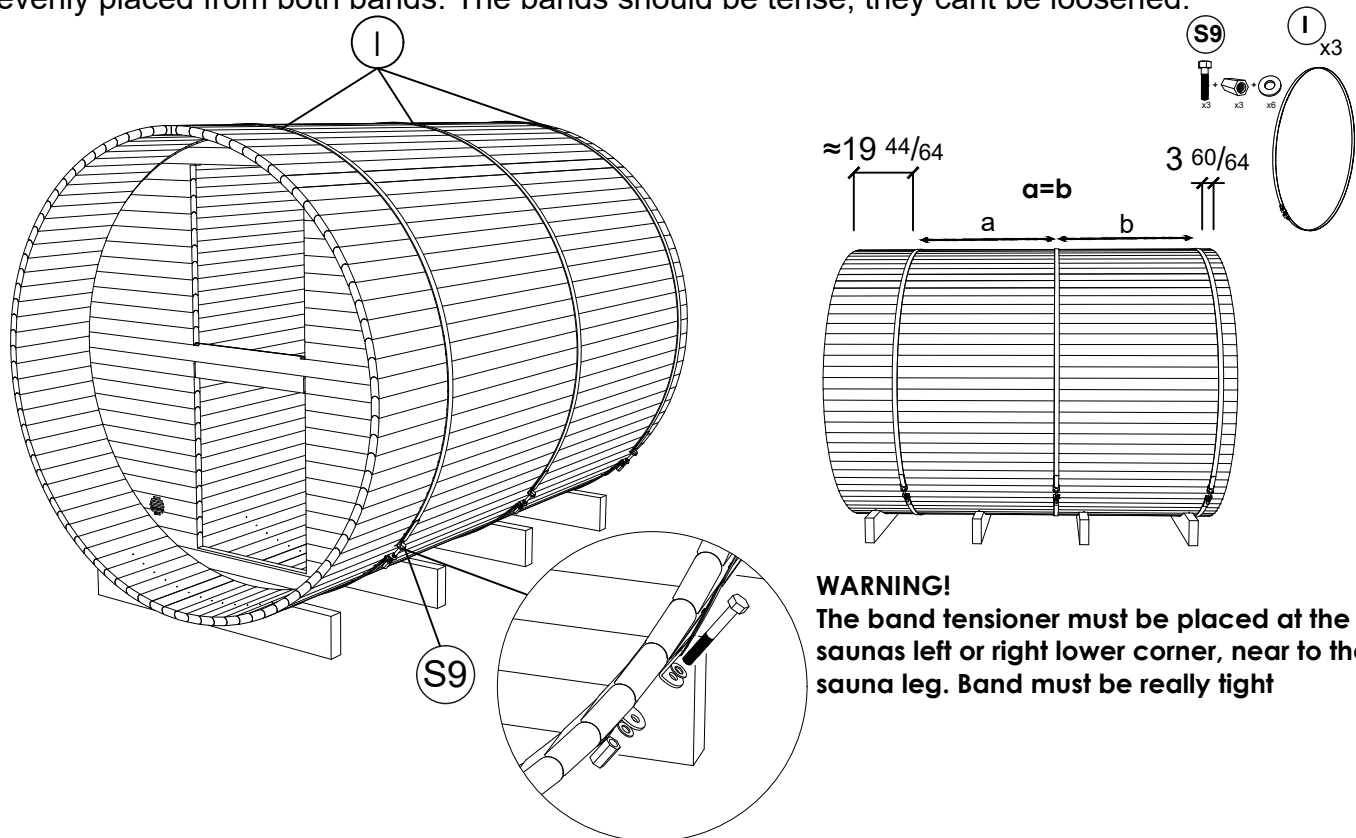
**STEP 9:** Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10).



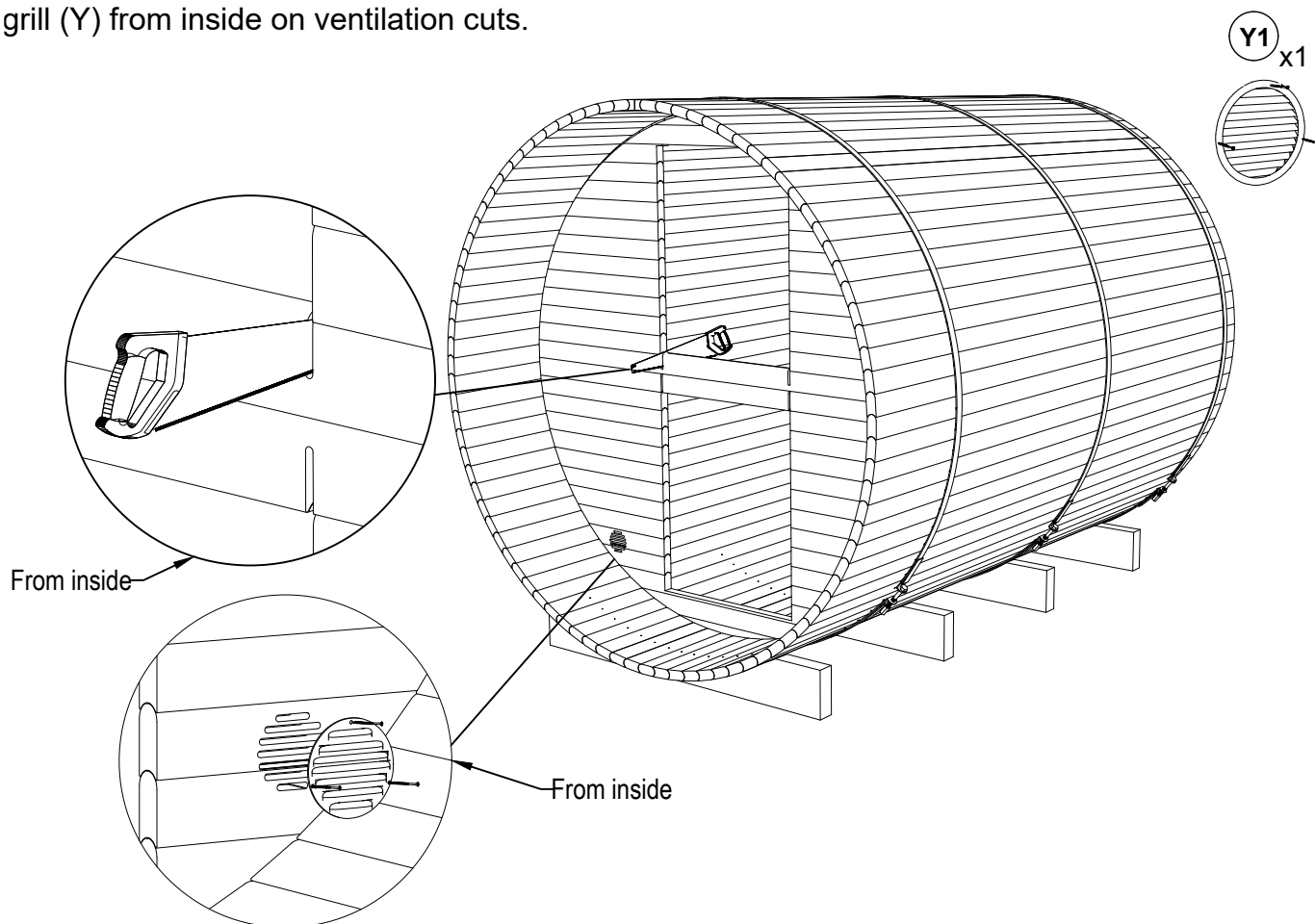
**STEP 10:** To finish the roof top joint, don't screw about last 3 boards (C) to each side, use roof finishing item (H). Different thickness filling pieces (H1) are provided to completely fill the gap. Once necessary parts are in, fix last boards with screws (S10).



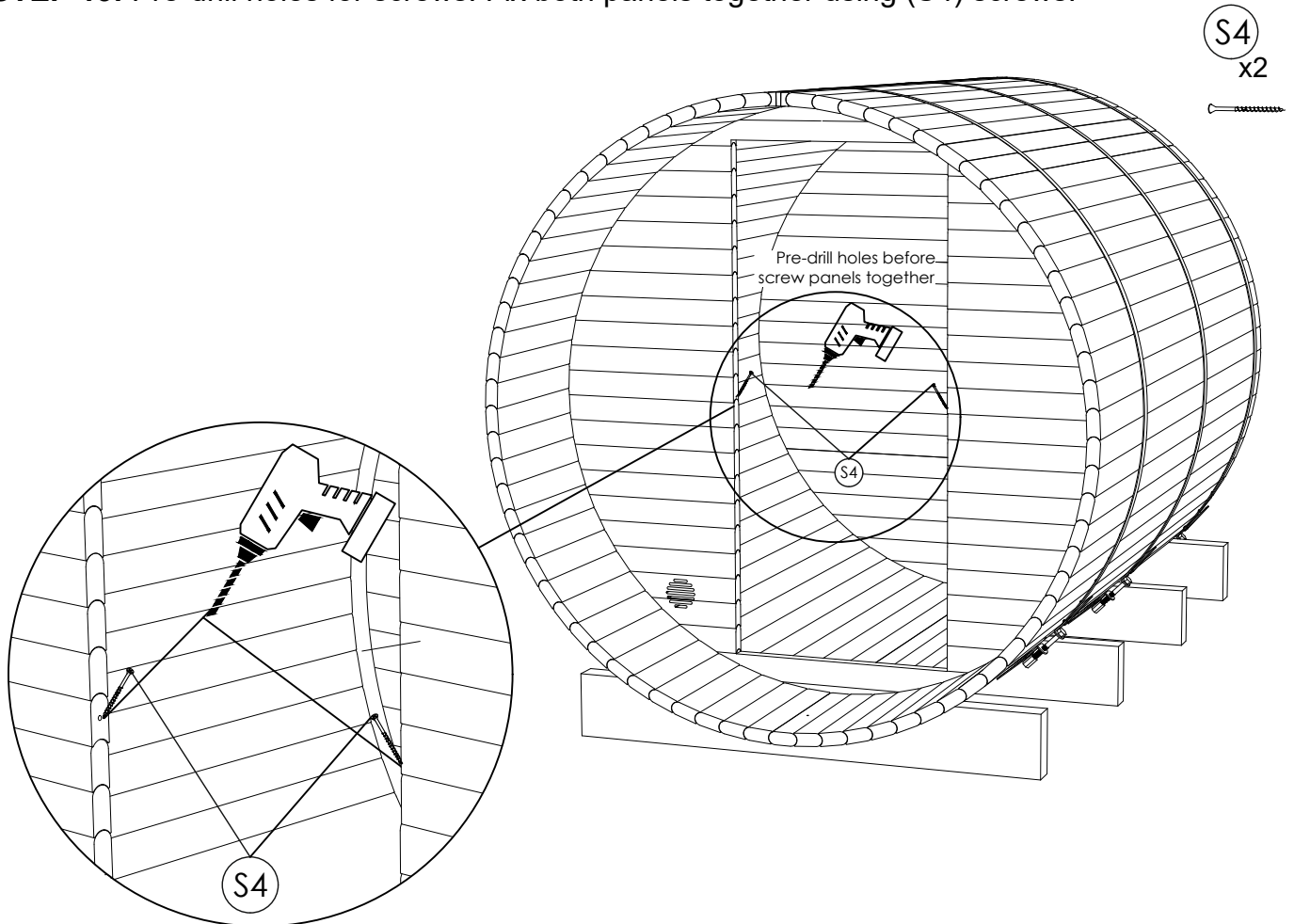
**STEP 11:** Install steel bands (I) by wrapping bands around the barrel, then connect with bolts and nuts (S9). Place steel bands evenly around the barrel approx  $\approx 19 \frac{44}{64}$  in from terrace and  $\approx 3 \frac{60}{64}$  in from sauna back. Bands should cover screw heads evenly. The middle band should be evenly placed from both bands. The bands should be tense, they cant be loosened.



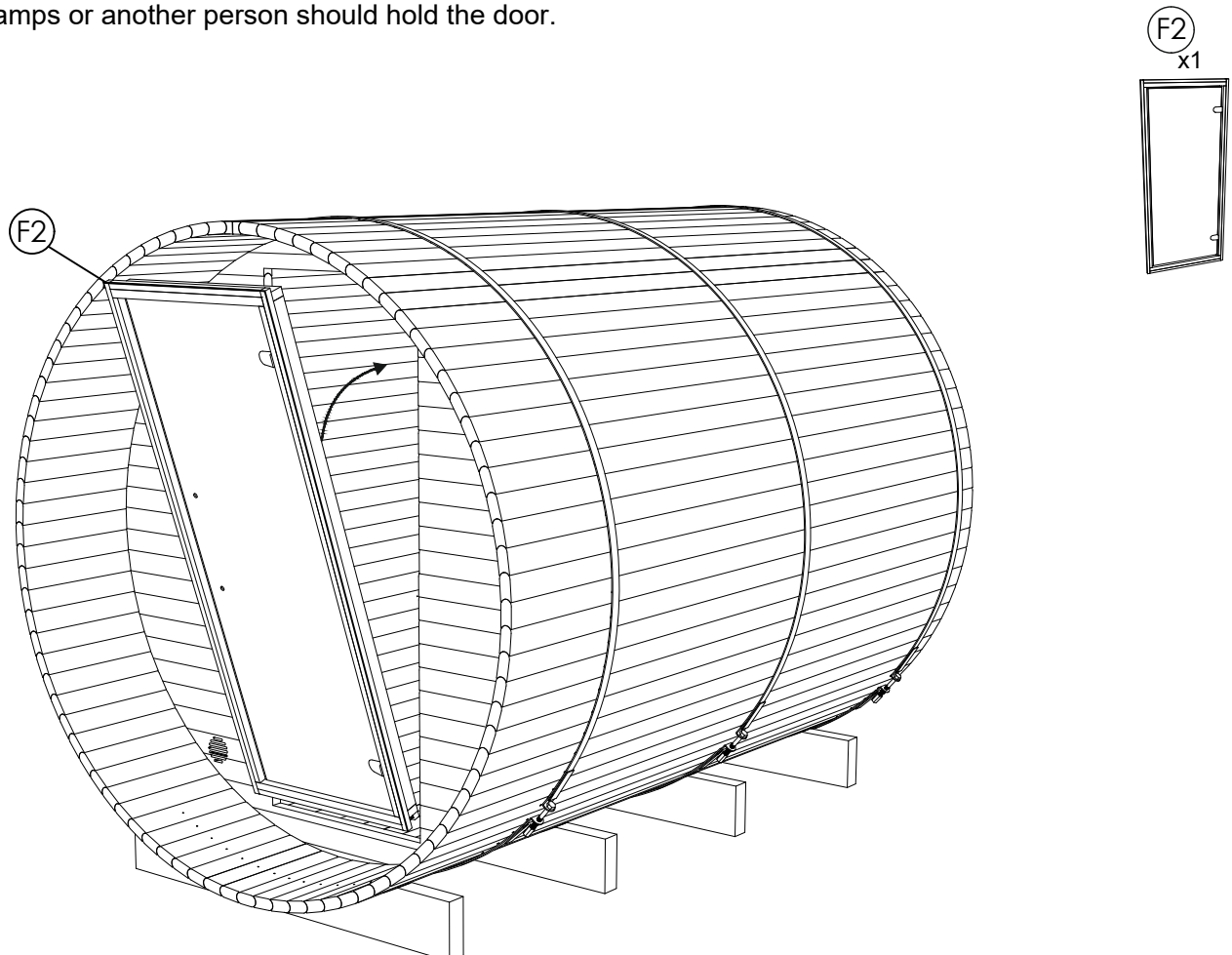
**STEP 12:** Draw straight line to connect both cuts. Use hand saw or other cutting machine to saw out excess boards for door box. It's recommended to saw out boards from inside. Fix ventilation grill (Y1) from inside on ventilation cuts.



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

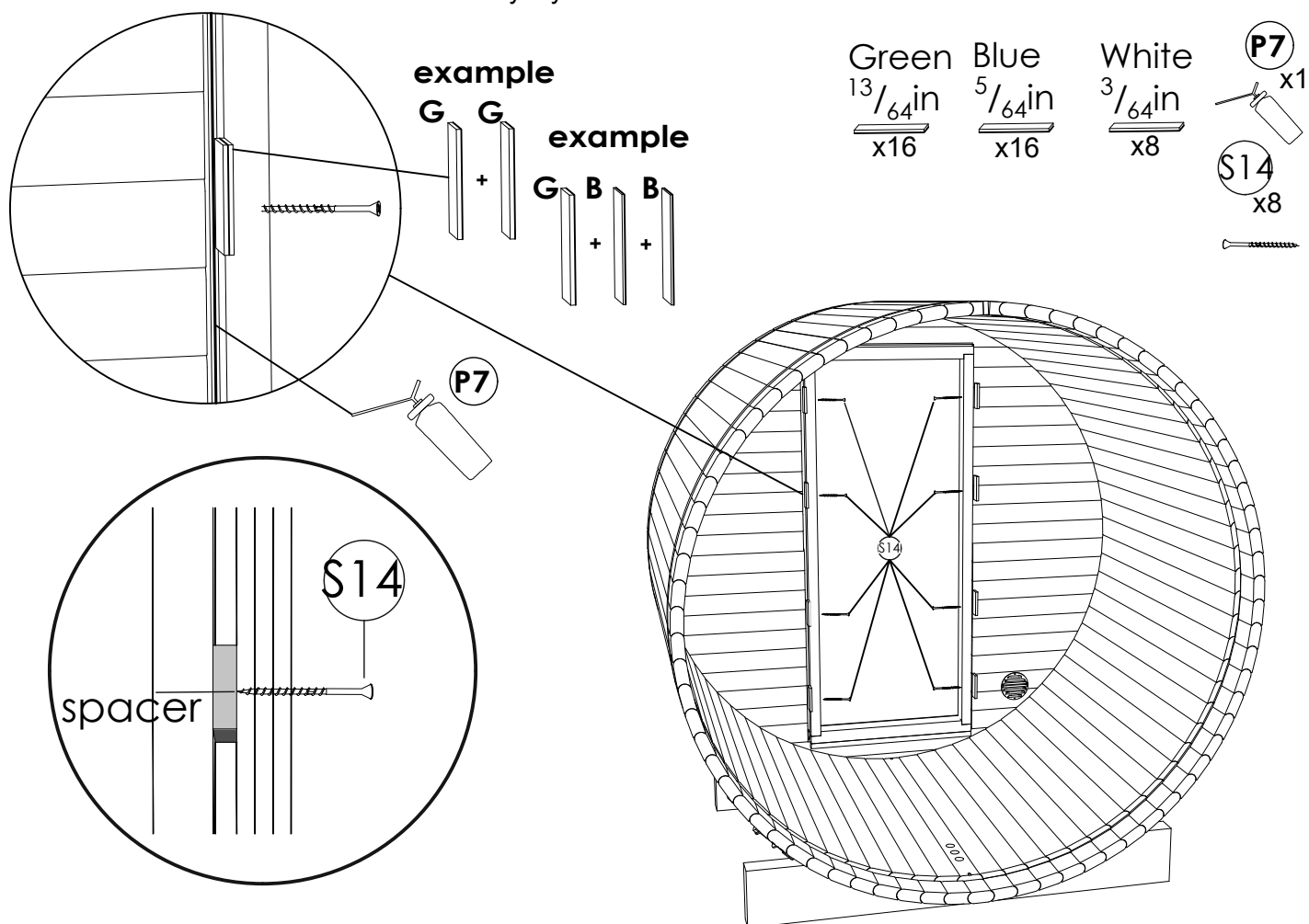


**STEP 14:** Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.

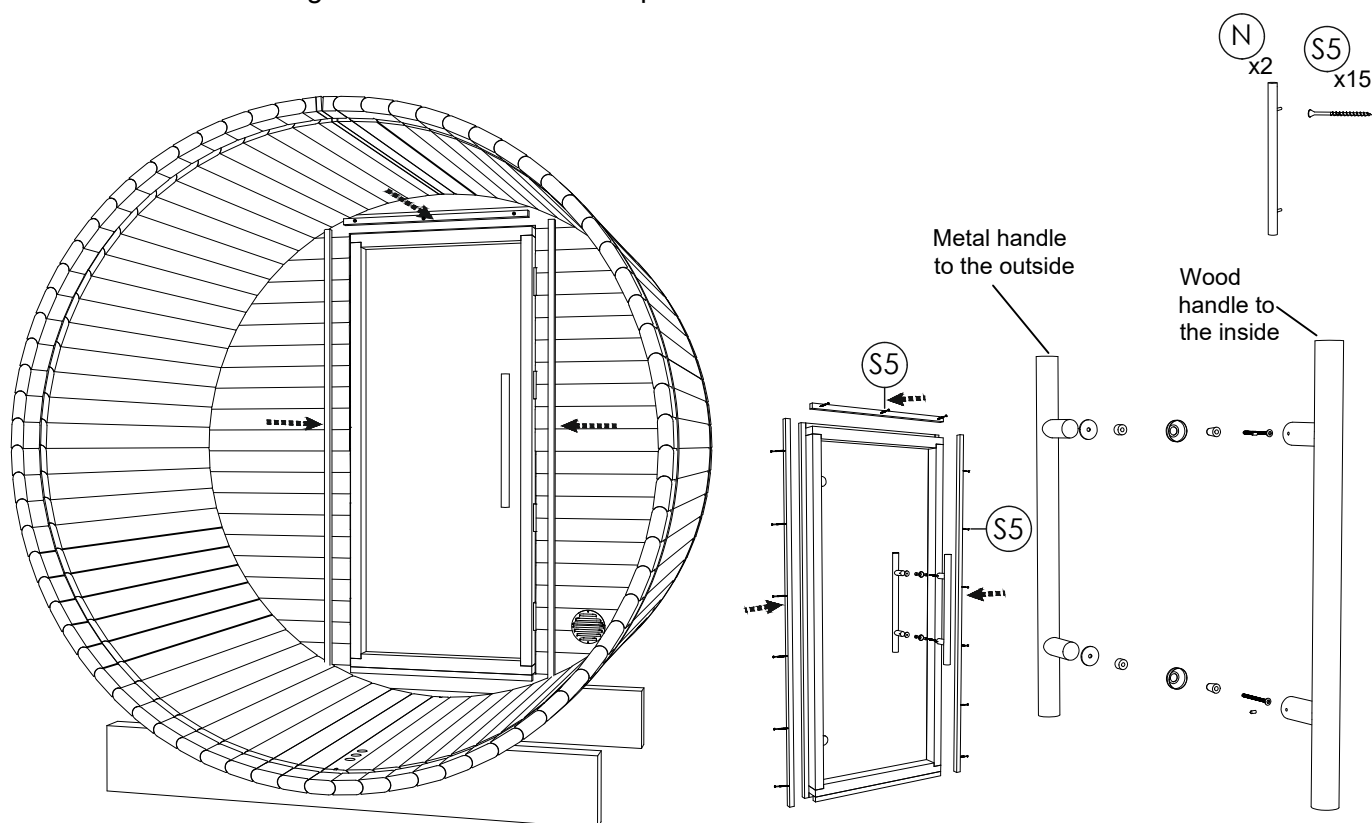




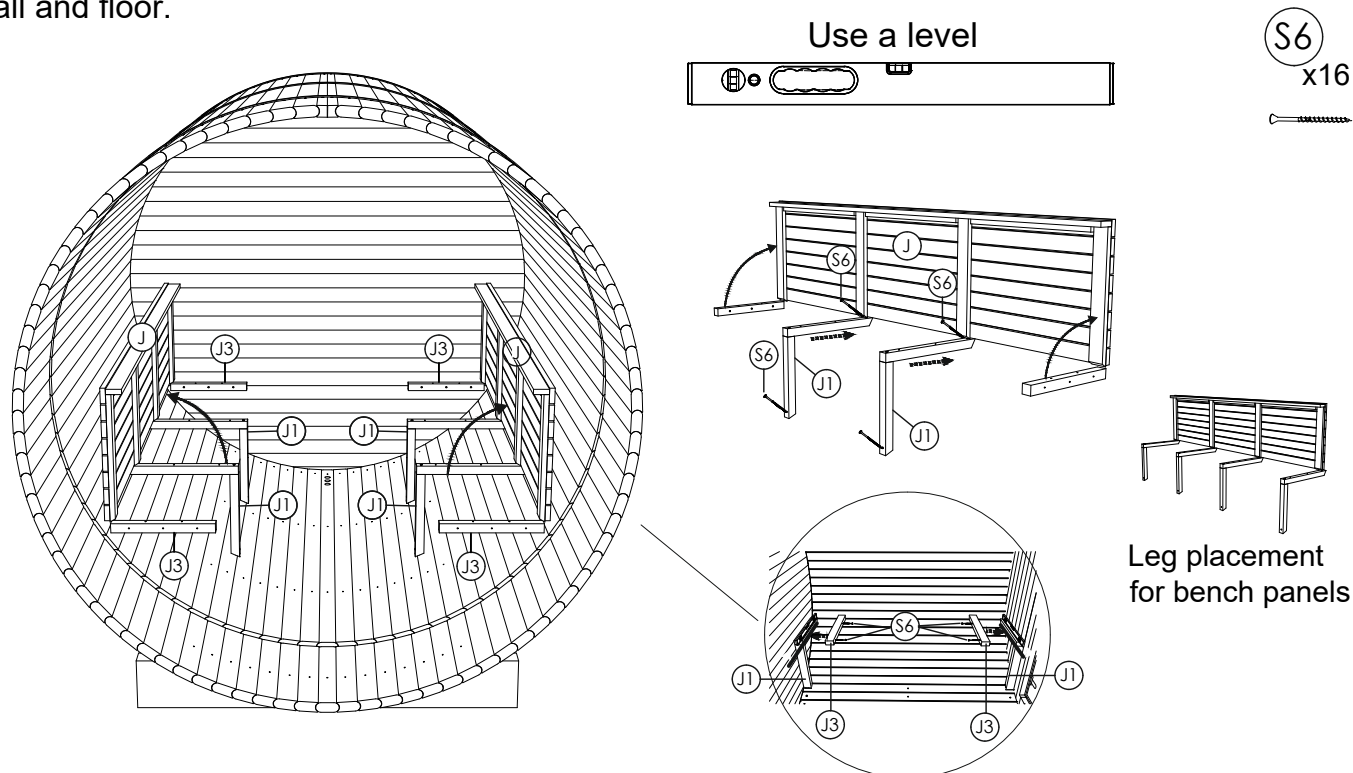
**STEP 15:** Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. First, fix one side of the door box with screws (S14) through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly,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



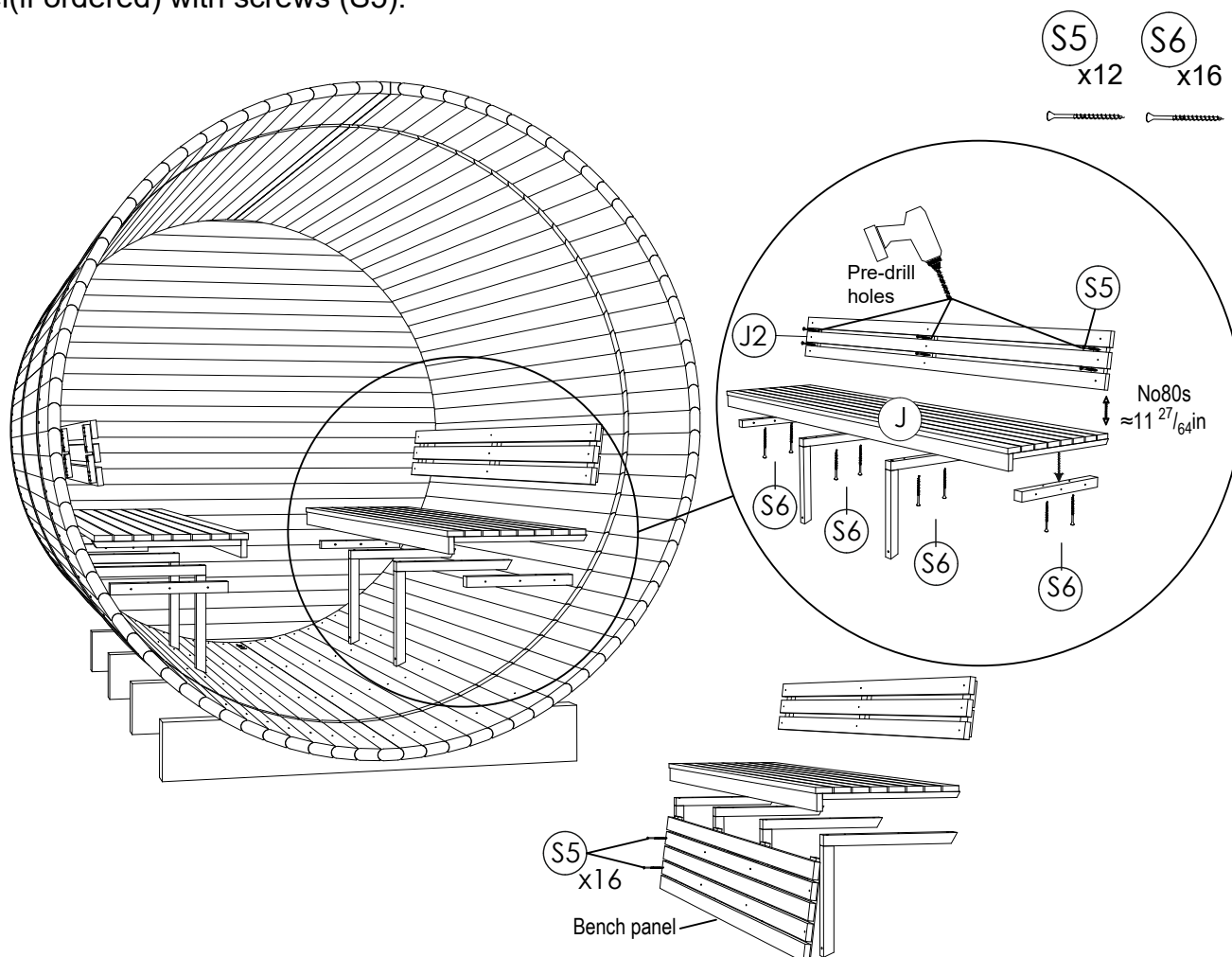
**STEP 16:** Fix door moldings to both sides and on top of the door with S5 screws.



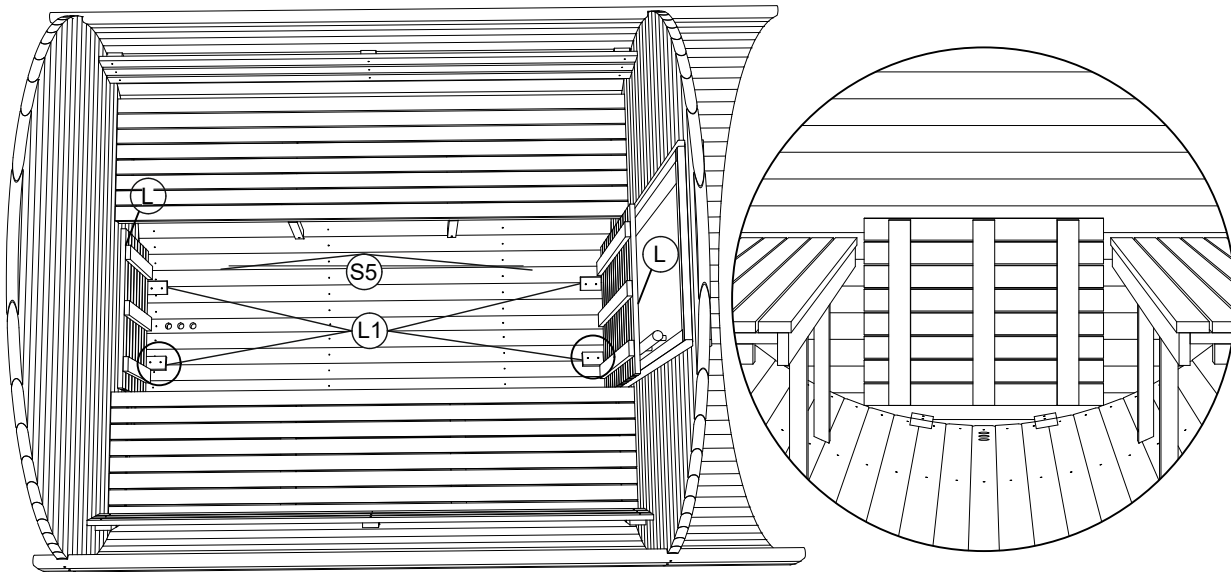
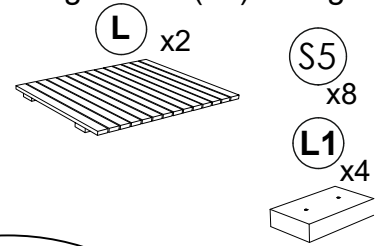
**STEP 17:** To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, mark a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall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



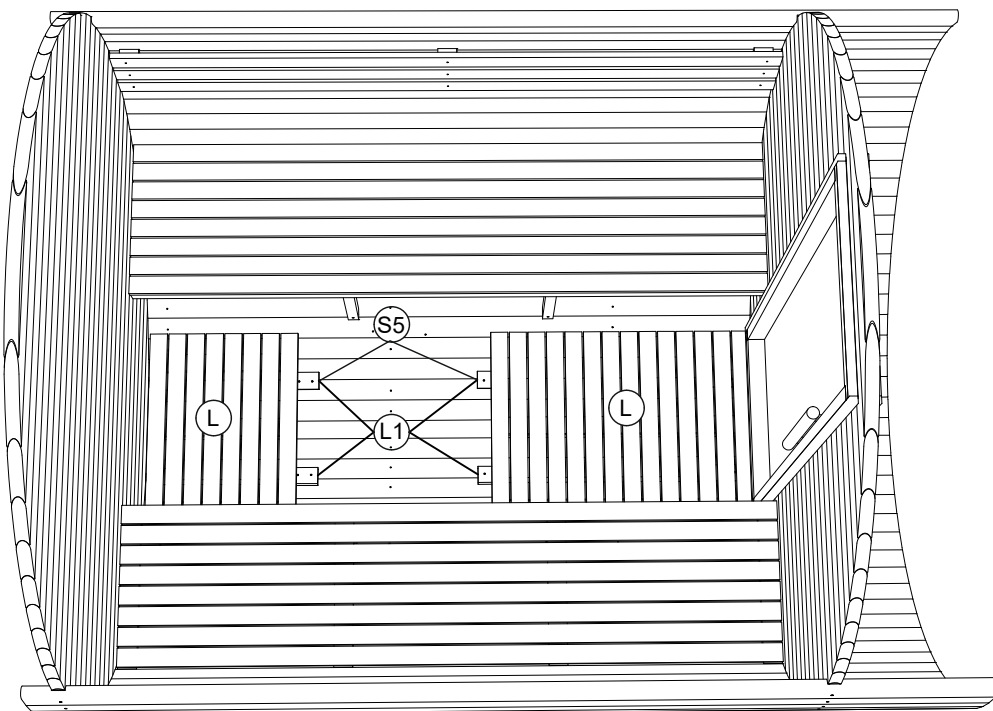
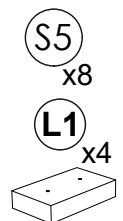
**STEP 18:** Pre-drill holes before fix backrest with screws, install backrests (J2) using screw (S2). Fix sauna bench (J) to wall mounts and support leg using (S6) screws. Fix bench panel(if ordered) with screws (S5).



**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 (S5).

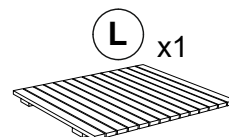
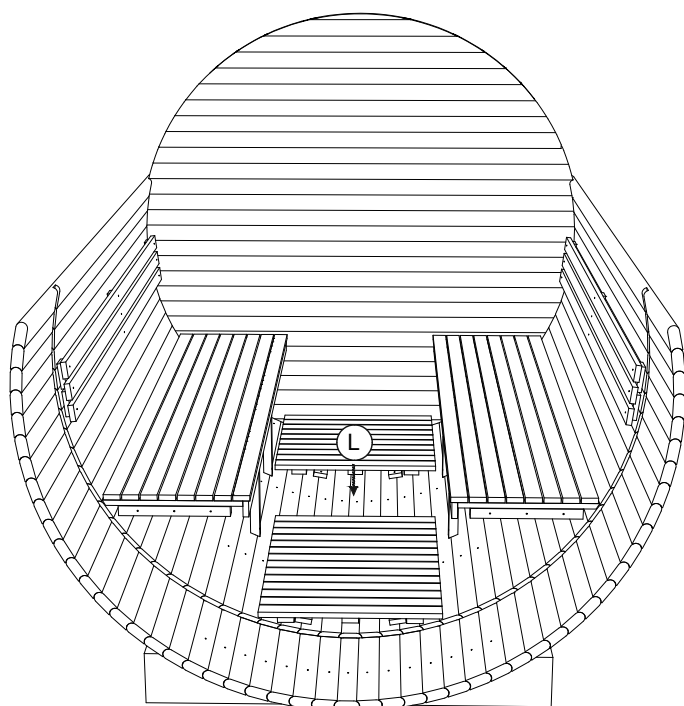


**STEP 20:** Pre-drill holes before fix with screws, install fixing blocks (L1) under floor duckboard using screw (S5) Place floor duckboards (L) on the floor and fix fixing blocks next to both flooring crossboards.

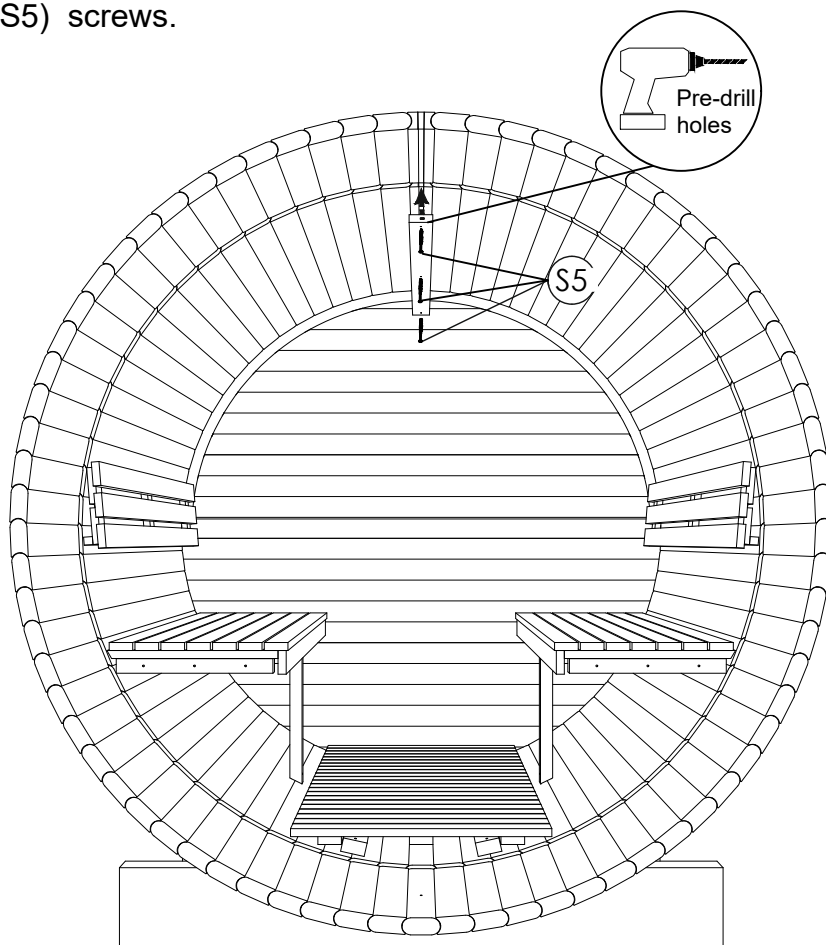




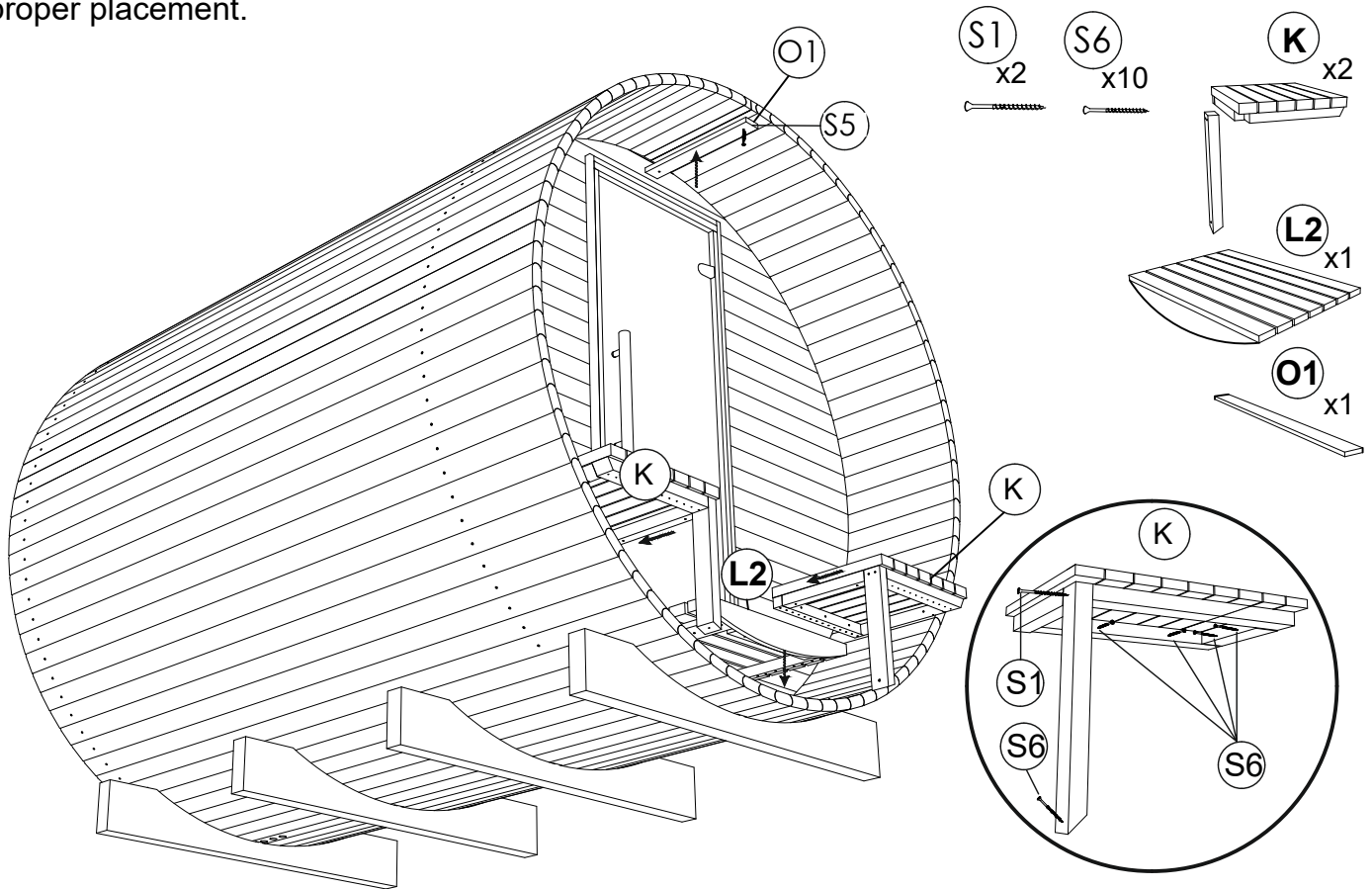
**STEP 21:** Place last floor duckboard (L) between both floors.



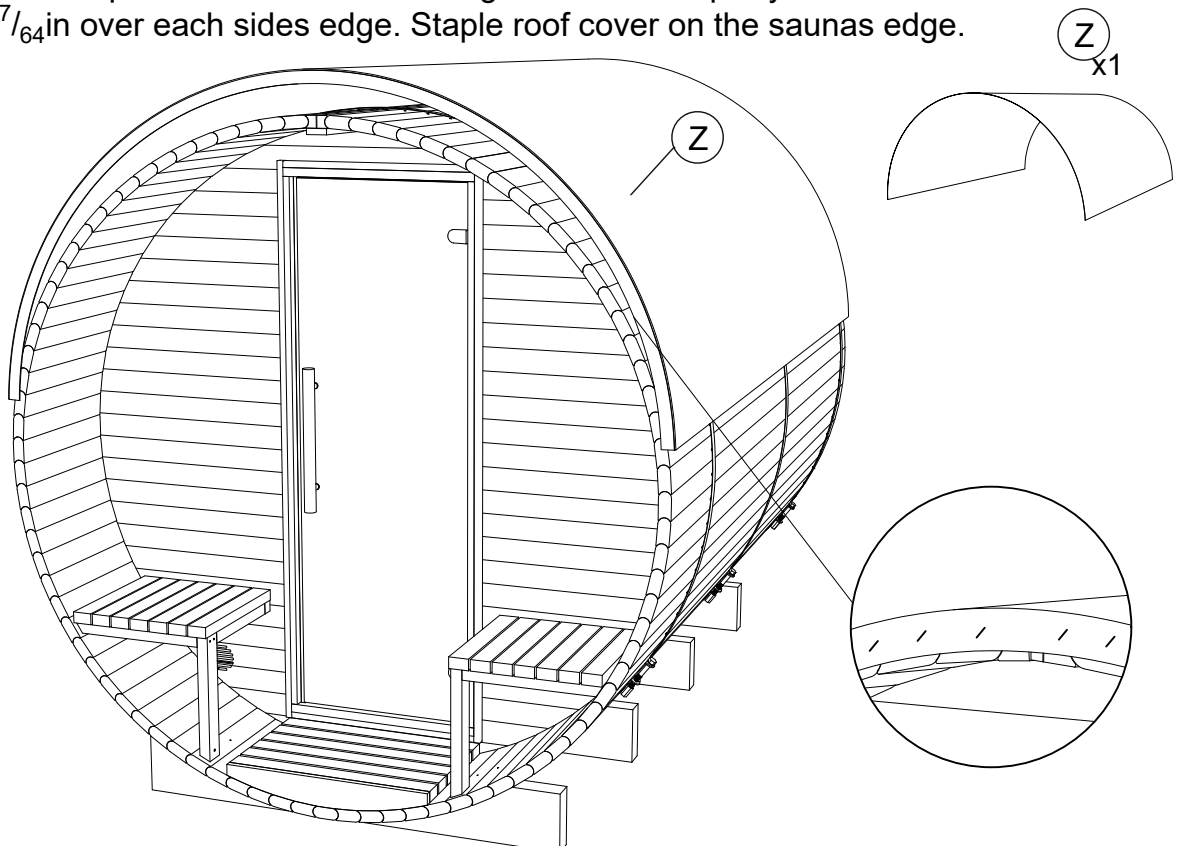
**STEP 22:** Pre-drill holes before fix stave with screws, install interior roof trim (O) in sauna with 4.0 x 50 SS (S5) screws.



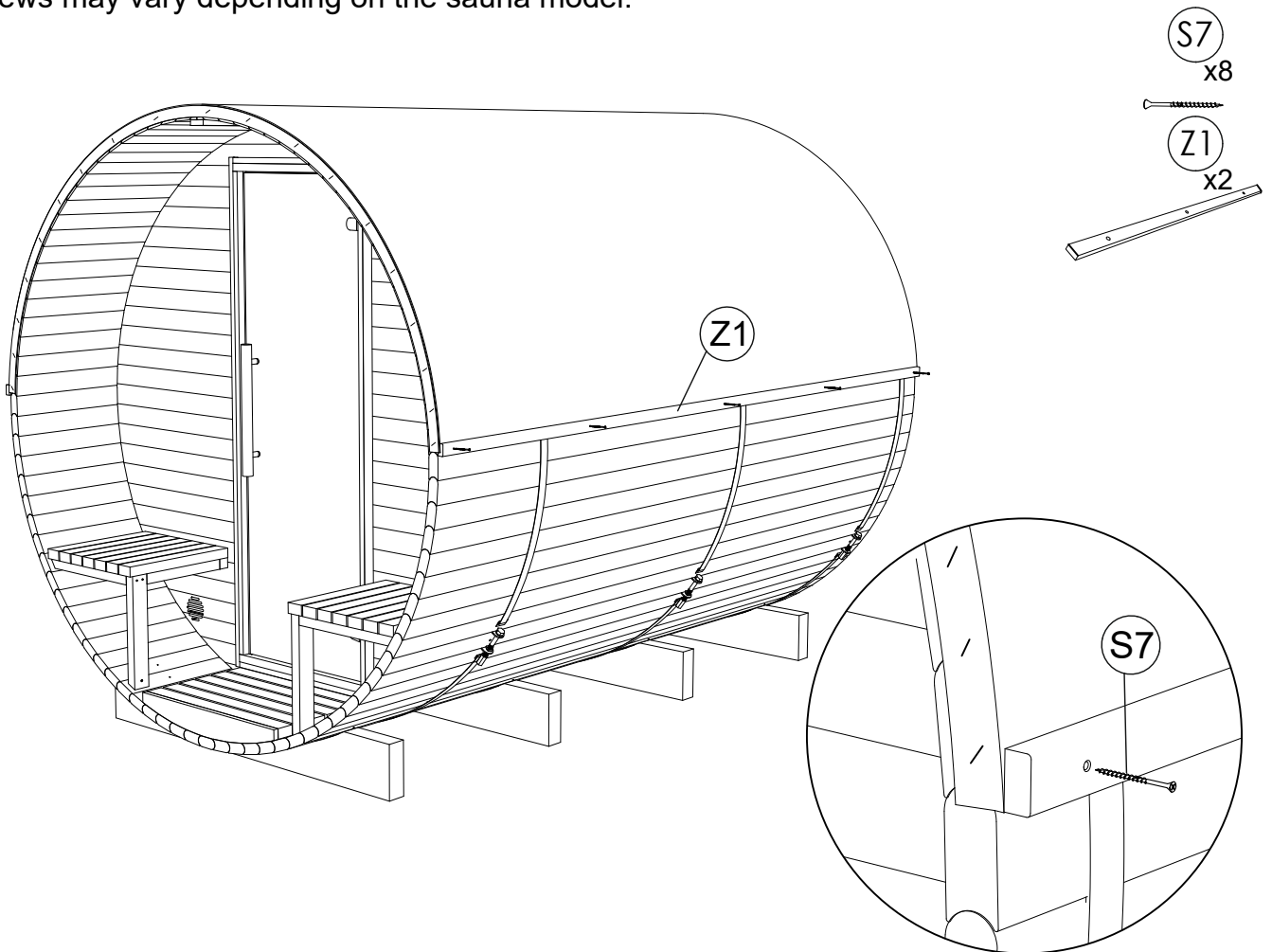
**STEP 23:** Install front and rear decorative roof finishing boards (W), fixing by screws (S7). Install porch benches (K), using screws (S6) and (S1). Hold the seat and leg assembly tight to the sauna wall. Using a level, make sure the bench seat is level from front to back. This will ensure proper placement.



**STEP 24:** Place waterproof PVC roof cover . Align roof cover equally to both sides. Roof cover goes about  $1\frac{37}{64}$ in over each sides edge. Staple roof cover on the saunas edge.



**STEP 25:** Fix wooden slats (Z1) with screws (S7) on the rain jacket bottom. The number of screws may vary depending on the sauna model.



**STEP 26:** 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.

