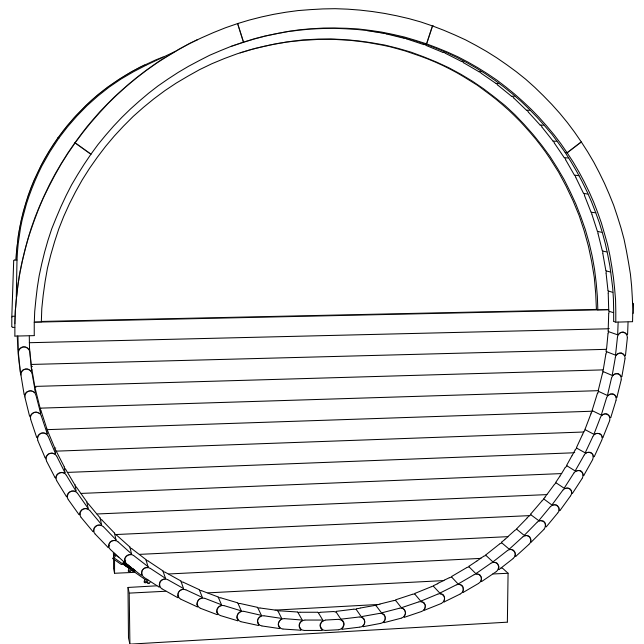
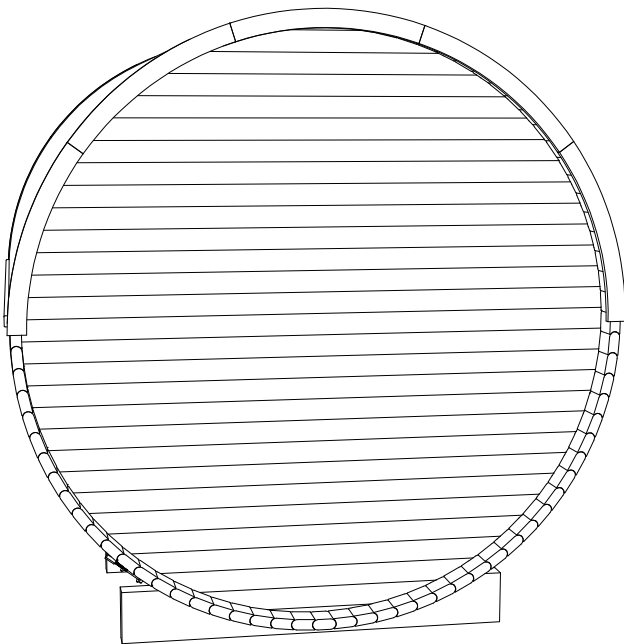
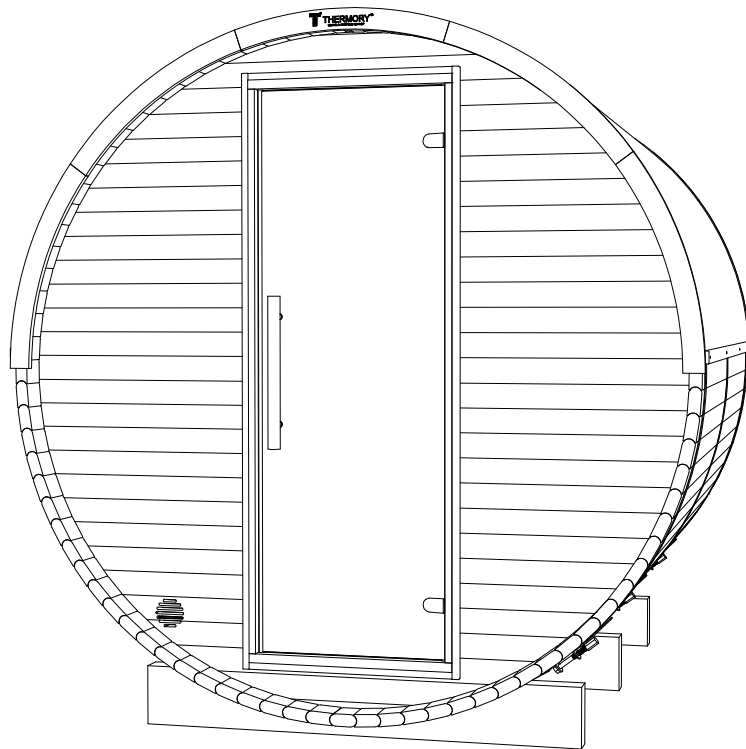


BARREL SAUNA

ASSEMBLY INSTRUCTIONS



Model: No51; No53; No63

Model: No50; No52; No62

















Note: Please read the manual before construction

Rev. 13.05.2026

RECOMMENDATIONS

1. It is recommended to install the sauna above ground level to prevent the base frame of the sauna from coming into direct contact with the ground. Install a water-resistant material, such as bitumen strips, between the base frame and the base surface.
2. Make sure that the surface on which you install the sauna is level and stable before and after installing the sauna. Otherwise, the doors of the sauna may not open and close properly later on.
3. During the first heating of the sauna, it must be constantly supervised, and the doors should be kept open, as the stove emits a specific odor when first heated. Read more from the user manual for the sauna stove.
4. The maximum permitted temperature in the steam room is +90 °C. If heated to a higher temperature, the sauna may become overheated.
5. In order to avoid damage caused by the weight of snow in winter, any snow should be removed from the roof of the sauna. Keep in mind that the roof covering should not be damaged during snow removal.

REQUIRED TOOLS

	Tape measure		Cutting knife		Drills $\text{Ø}^{5/32-25/64}\text{in}$
	Pencil		Battery drill		Wrench $7\ 31/64$
	Level		Nail gun		Vise
	Rubber mallet		Hex keys $1/8\ 9/32$		Recommended - 2 person
	Hammer		Gloves		
	Stapler		Safety goggles		

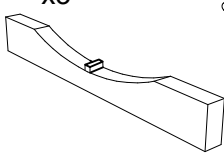
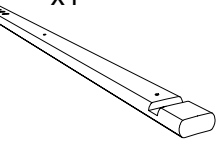
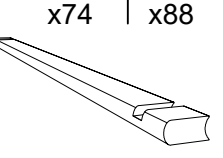
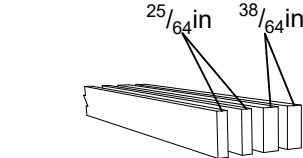
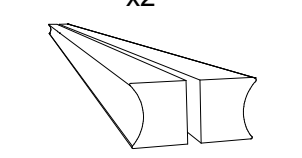
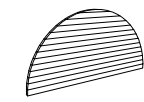

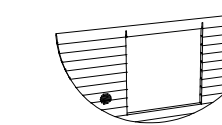
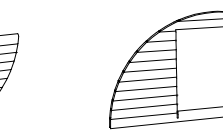
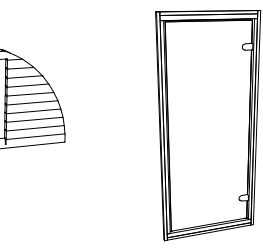


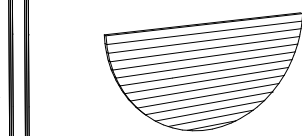
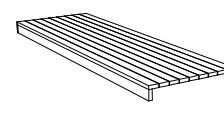
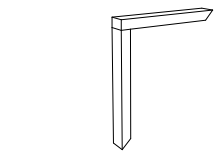
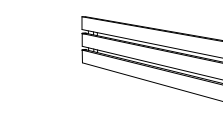
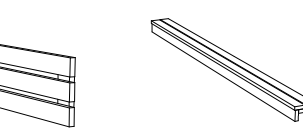
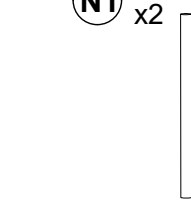
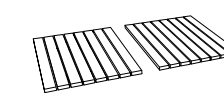
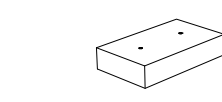
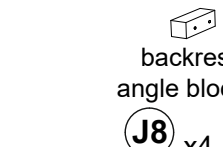
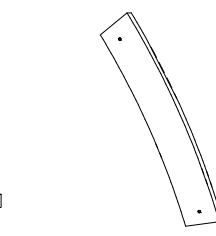

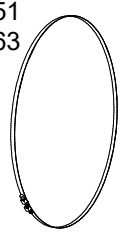
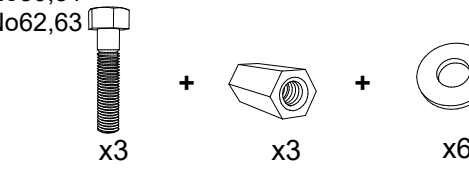
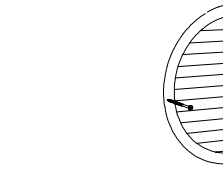
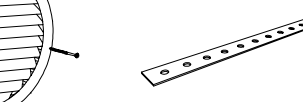
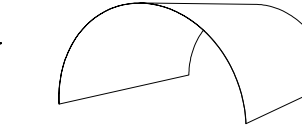
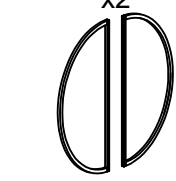

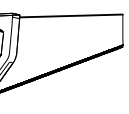
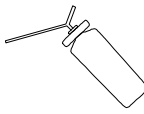
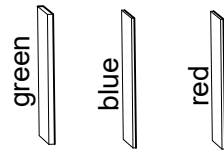

Before you begin, be sure the sauna will fit in your chosen location.

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

Concrete, pavers or crushed stone is preferred.

Check parts before construction.

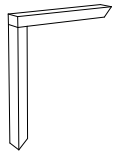
PART LIST

<p>A x3</p> 	<p>B x1</p> 	<p>C No50s No60s x74 x88</p> 	<p>H1 x4 25/64in 38/64in</p> 	<p>H x2</p> 
<p>cradle</p>	<p>center stave</p>	<p>body stave</p>	<p>different thickness filling peaces</p>	<p>final H tipe stave at the top</p>
<p>V3 x1</p>  <p>V1 x1</p> 	<p>F x1</p> 	<p>F1 x1</p> 	<p>F2 x1</p>  <p>x2</p>  <p>x1</p> 	<p>V x1</p> 
<p>upper rear panel</p>	<p>front panel bottom</p>	<p>front panel top</p>	<p>door and door moldings</p>	<p>bottom rear panel</p>
<p>J x2</p> 	<p>J1 x2</p> 	<p>J2 x2</p> 	<p>J4 x2</p> 	<p>N1 x2</p> 
<p>sauna bench</p>	<p>supporting leg</p>	<p>backrest</p>	<p>step bench</p>	<p>door handle</p>
<p>L x2</p> 	<p>L1 x6</p> 	<p>J5-1 x6</p>  <p>backrest angle block</p>	<p>W x10</p> 	<p>O x1</p>  <p>I x3 No53, 52: metal band -2pc No50,51 No62,63</p> 
<p>sauna floor</p>	<p>fixing block for sauna floor</p>	<p>step bench wall mount</p>	<p>decorative roof finishing board</p>	<p>roof board</p>
<p>S9 No53 52: bolt -2pc, hex nut-2pc, flat washer-4pc No50,51 No62,63</p>  <p>x3 x3 x6</p>	<p>Y1 x1</p> 	<p>D1 x1</p> 	<p>Z x1</p> 	
<p>bolt \varnothing12x140</p> <p>V1 x2</p> 	<p>hex nut M12 (SW19)</p> <p>V1-F x1</p> 	<p>flat washer</p> <p>P7</p> 	<p>ventilation grill</p> <p>construction foam</p> 	<p>metal bracket</p> <p>x12 13/64 x10 5/64 x10 3/64</p> <p>green blue red</p> 
<p>back rear panel</p>	<p>spacer bar</p>	<p>hand saw</p>	<p>construction foam</p>	<p>door box spacers</p>
<p>Z1 x2</p> 	<p>slat for roof cover</p>	<p>slat for roof cover</p>	<p>slat for roof cover</p>	<p>slat for roof cover</p>

PART LIST

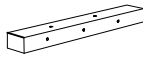
Set of standard benches

J1 x2



supporting leg

J3 x4



wall mount

Set with high benches

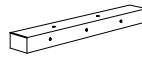
J1-1 x2



two level
bench leg



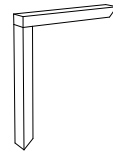
J3 x4



wall mount

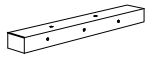
Set of standard benches for a sauna with a full panorama

J1 x4



supporting leg

J3 x2



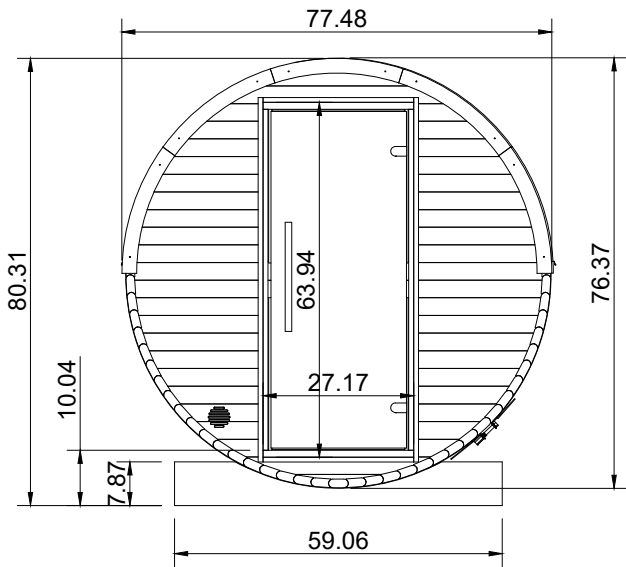
wall mount

Steel screws

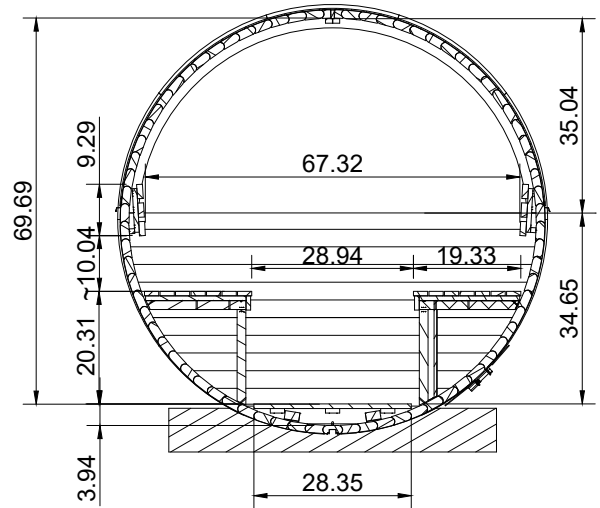
Article	Size,mm	Screws kind	Total quantity,pc №50s/60s
S1	5.0x100	steel	45 / 60
S2	4.0x70	stainless	37 / 12
S4	5.0x120	steel	11
S5	4.0x50	steel	25 / 50
S6	5.0x70	stainless	18
S7	4.2x55	steel	35
S10	4.0x60	steel	135 / 160
S11	4.0x40	stainless	12
S14	5.0x80	steel	10
S16	4.0x60	stainless	22

Barrel dimensions

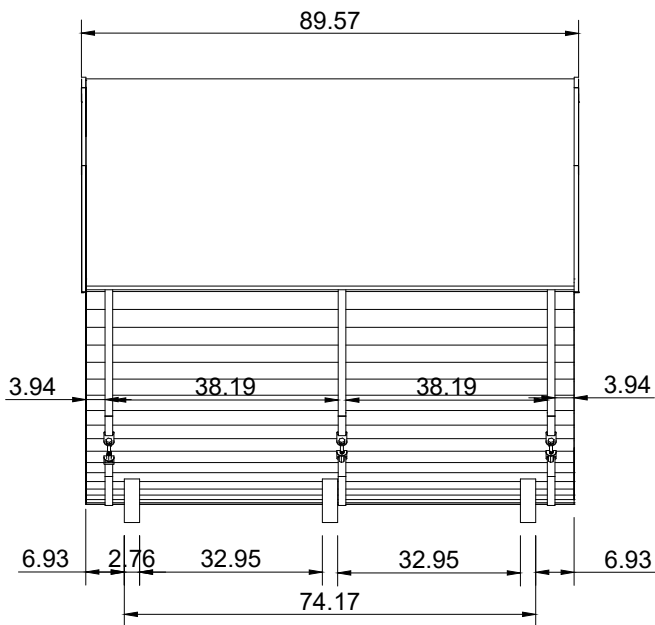
№50,51,52,53



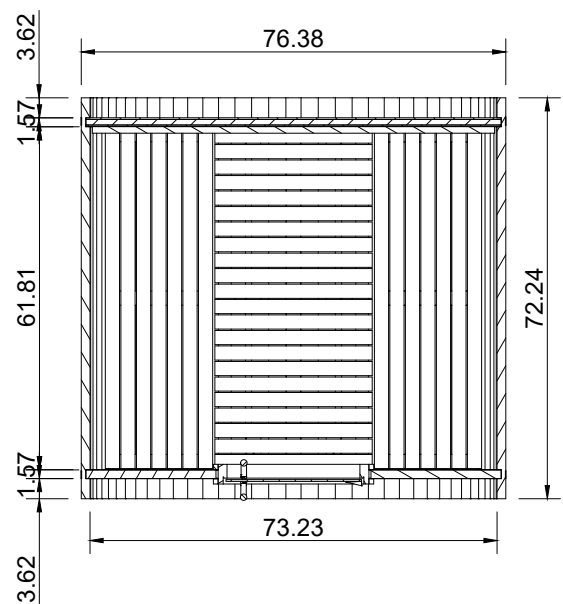
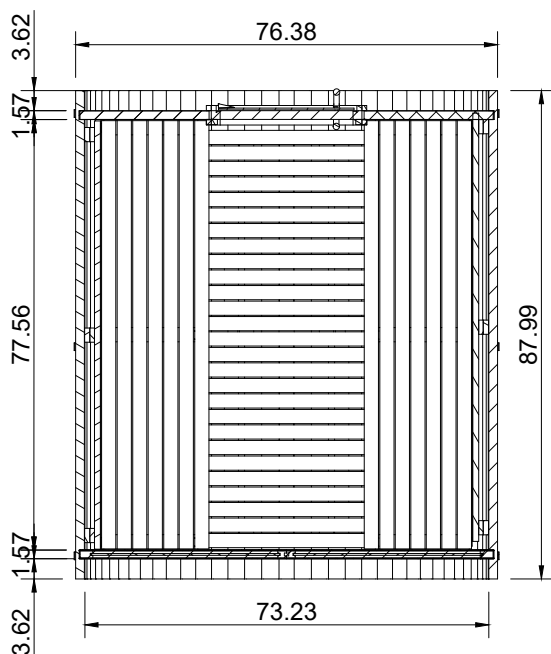
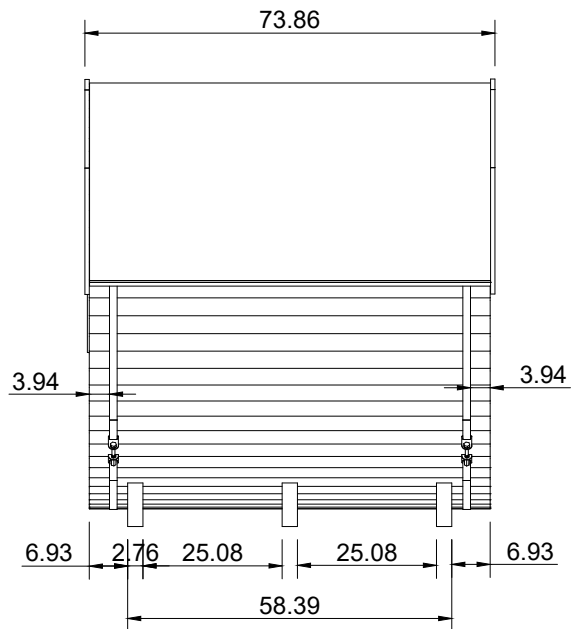
Interior option #1 - standard benches



№50,51



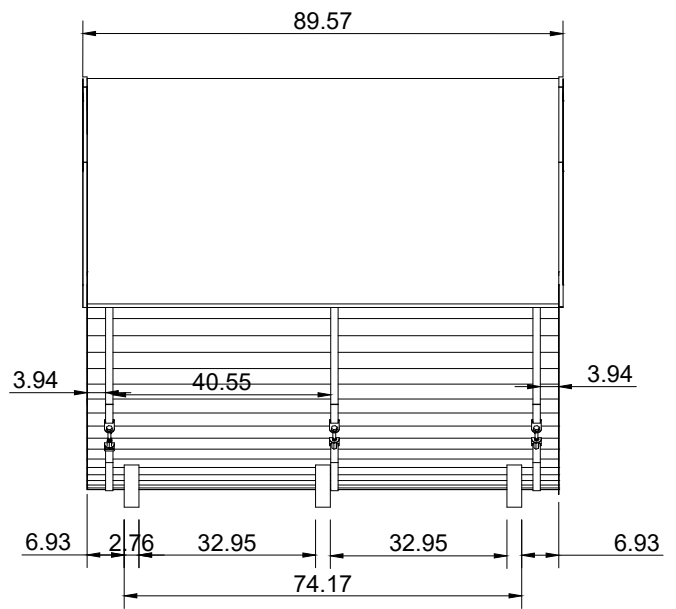
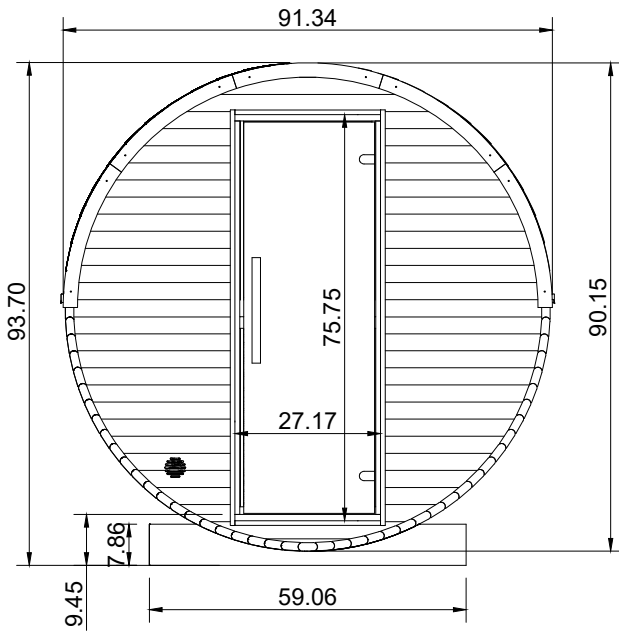
№52,53



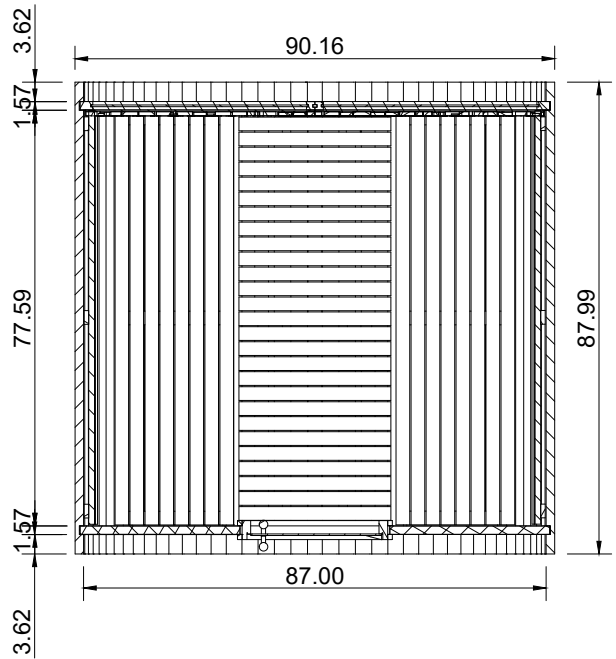
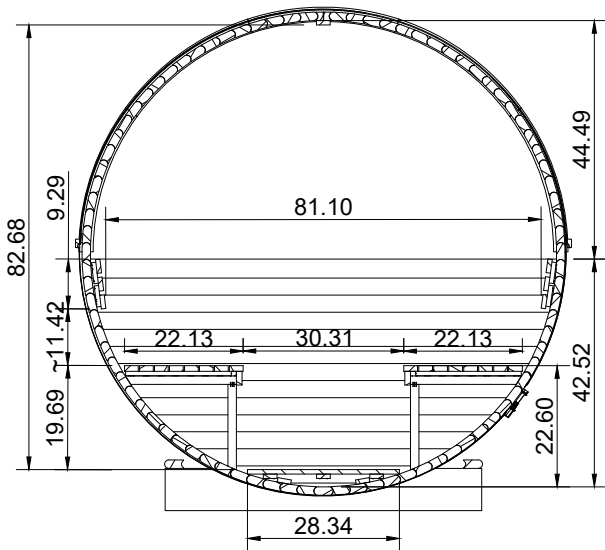
The dimensions on the drawings are informative, rounded values. Units of measurement - inches.

Barrel dimensions

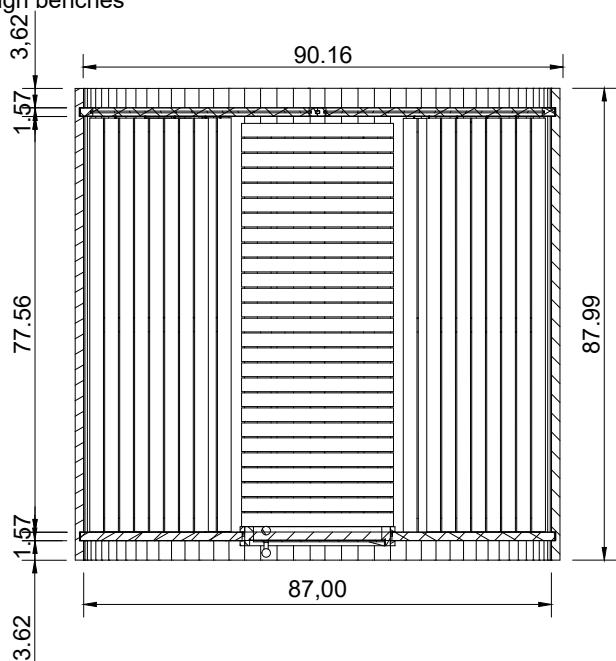
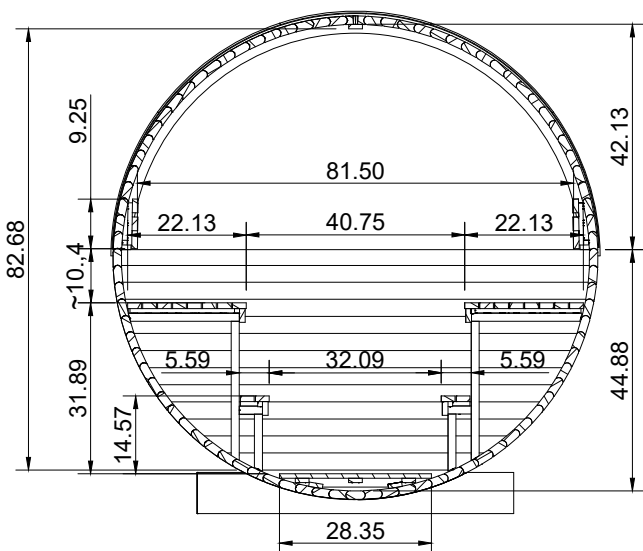
№62,63



Interior option #1 - standard benches

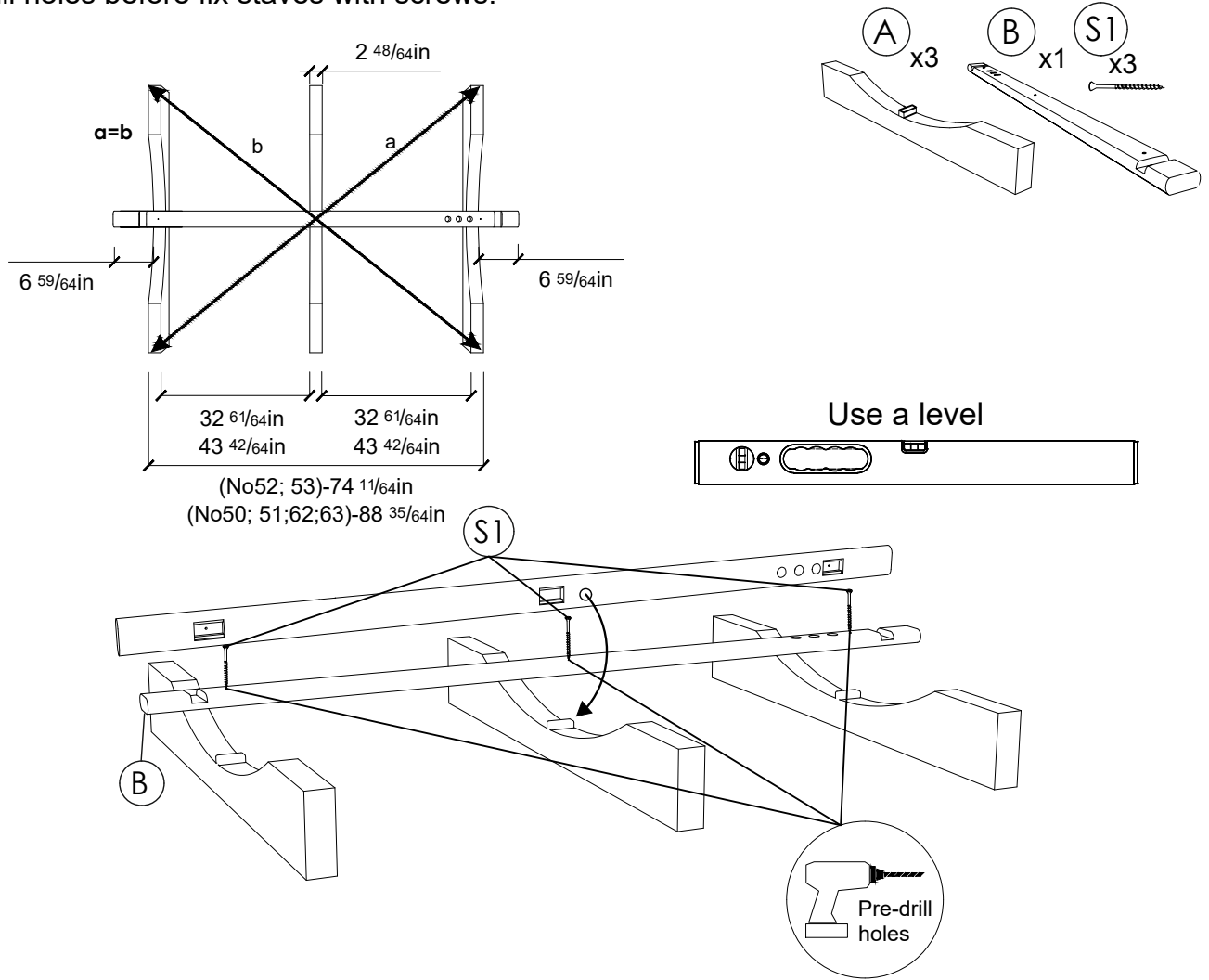


Interior option #2 - high benches

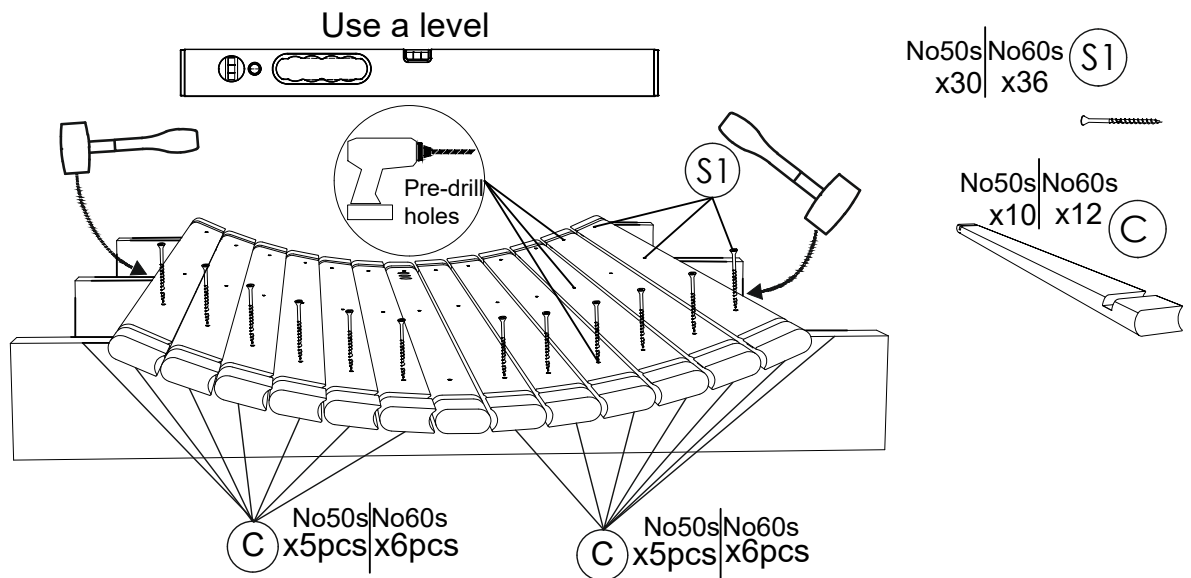


The dimensions on the drawings are informative, rounded values. Units of measurement - inches.

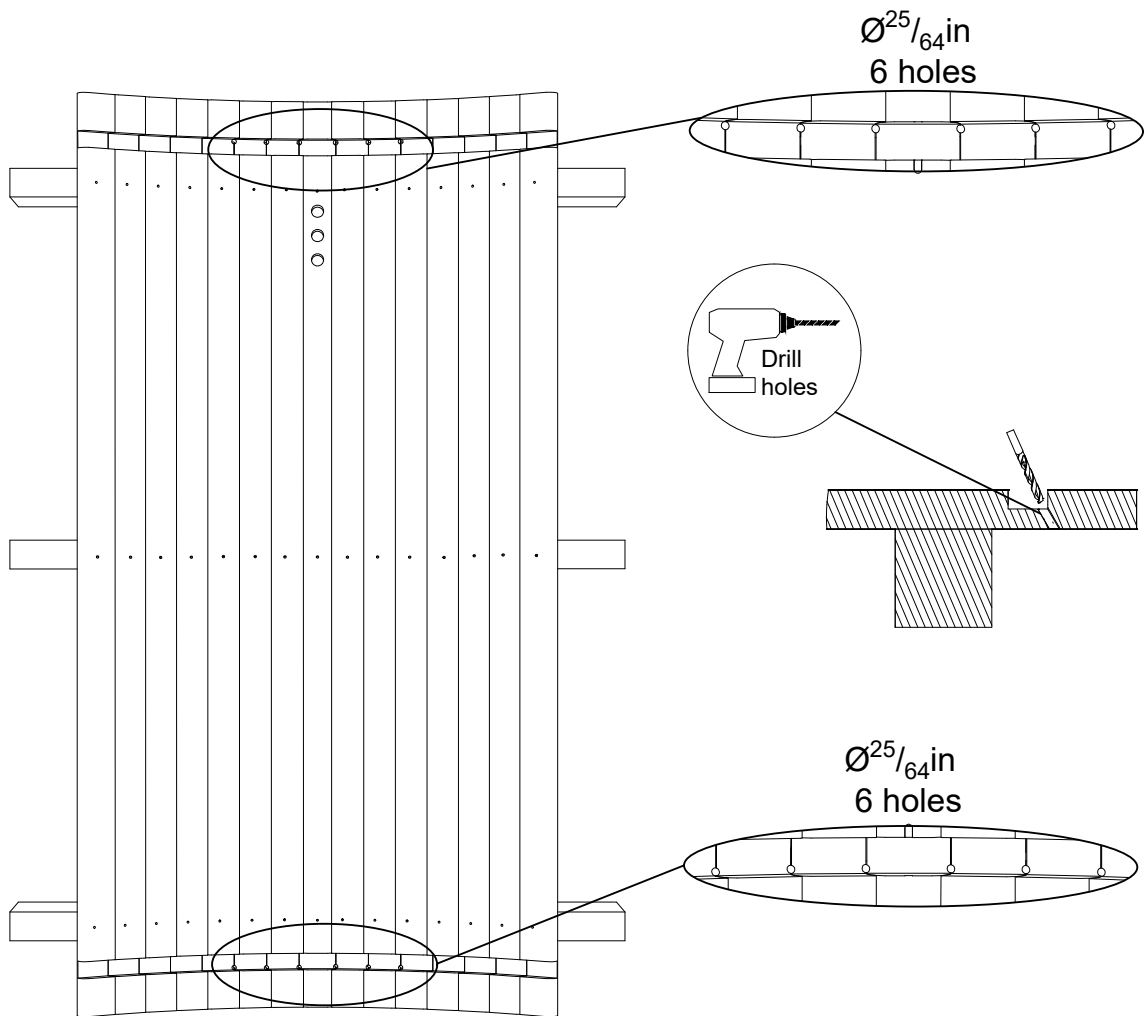
STEP 1: Measure support cradles (A) diagonally from corner to corner. Measurements “a” and “b” should be equal to ensure the cradles are square. Be sure cradles remain level. Place the support cradles (A) on level site. Carefully level for better stability. Place the center stave (B) on wooden dowels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



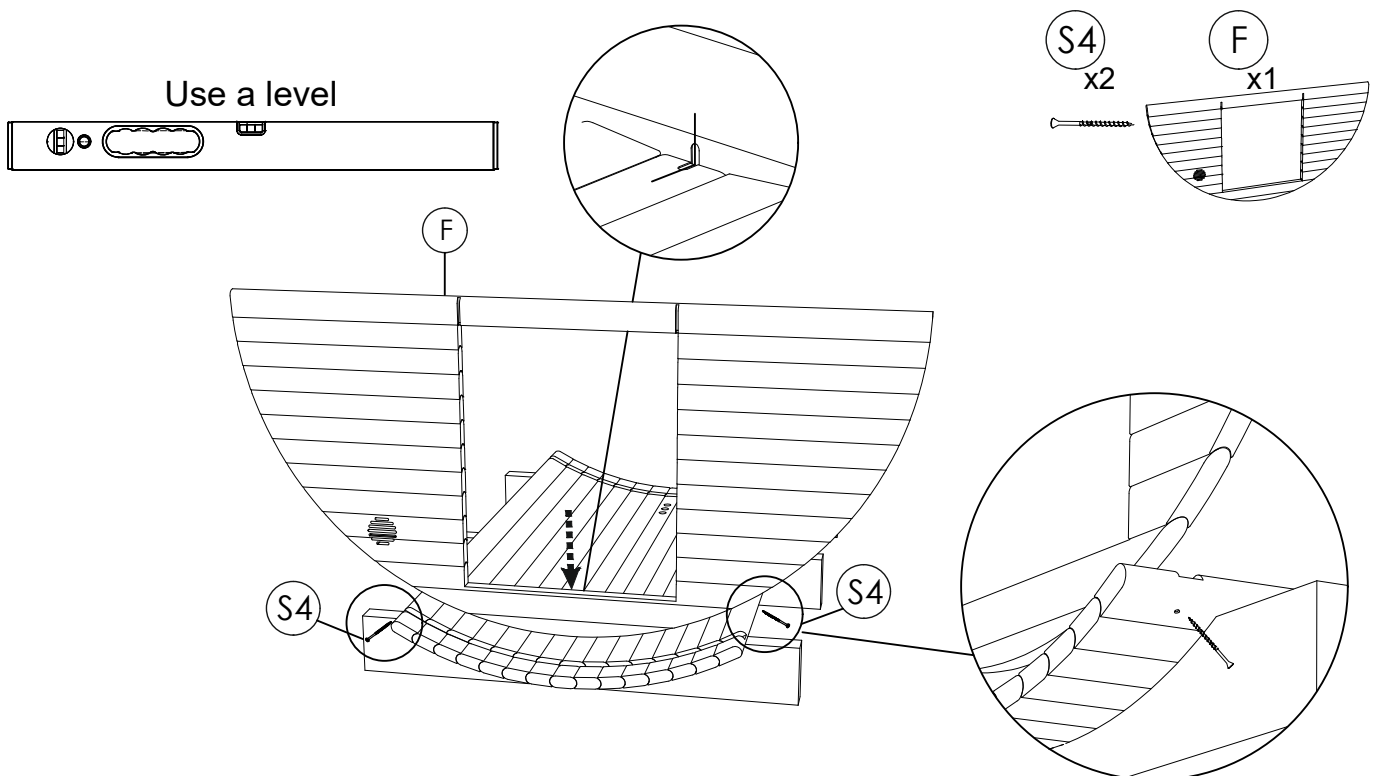
STEP 2: Pre-drill holes before fix staves with screws. Place 5 (No50s) or 6 (No60s) sauna body staves (C) to each side of the center stave (B) and fix with screws (S1). Be sure to align the panel groove on every next body stave, to do that use rubber hammer.



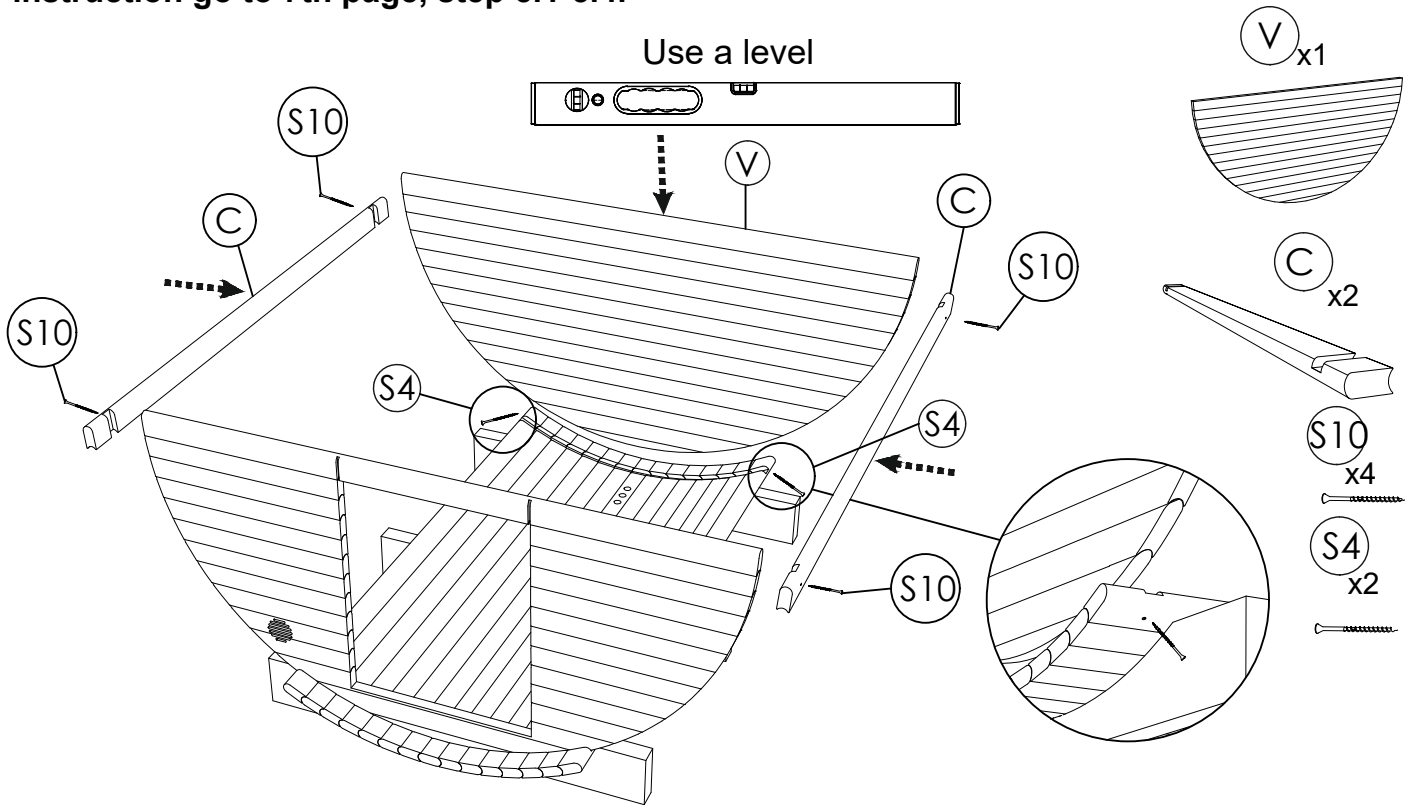
STEP3: Drill six $\frac{25}{64}$ in holes in front and back wall groove to the out-side in board connections as shown in the picture. This will help drain excess water faster.



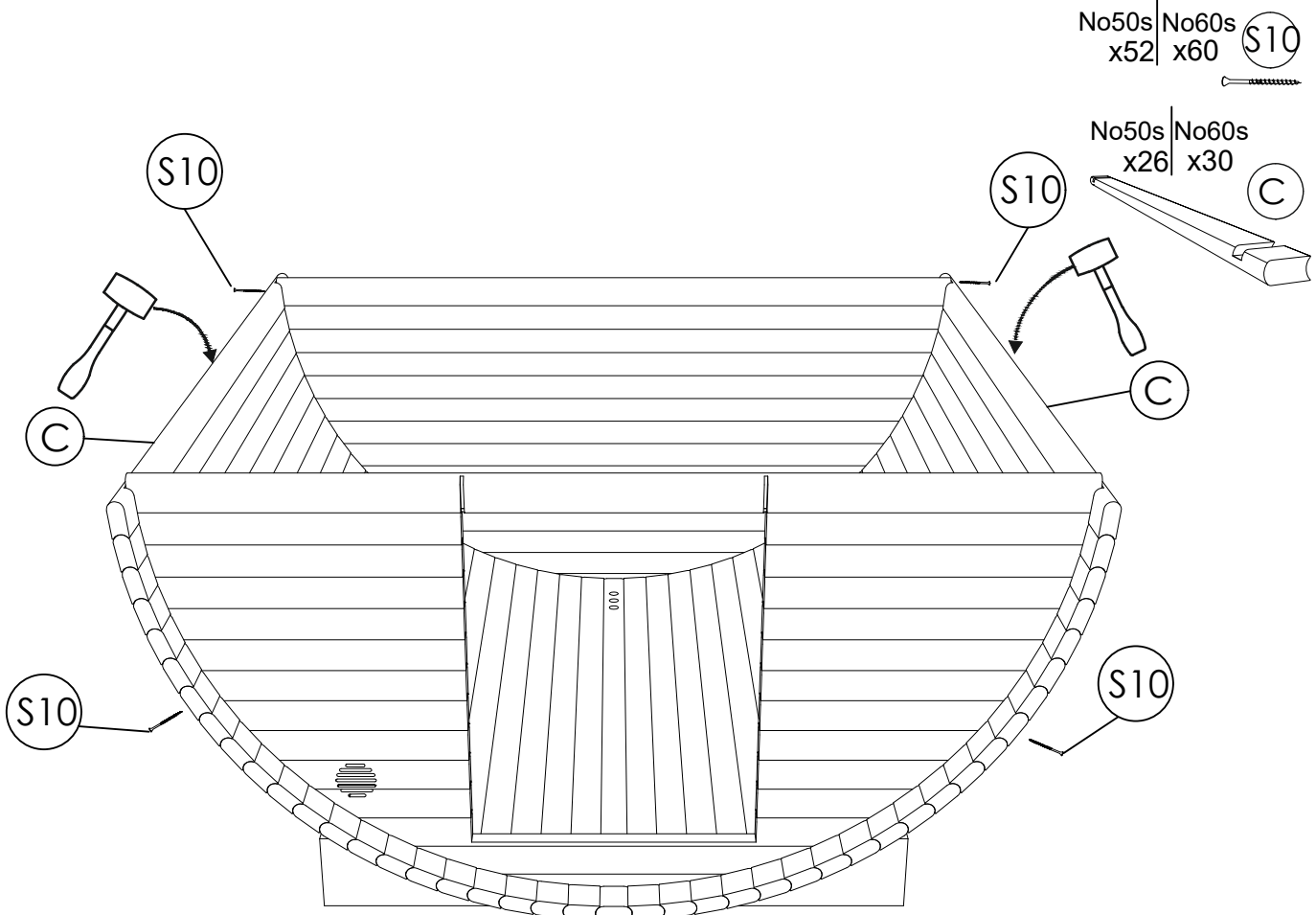
STEP 4: Place front bottom panel (F) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides.



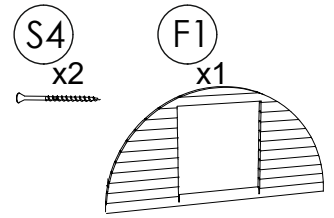
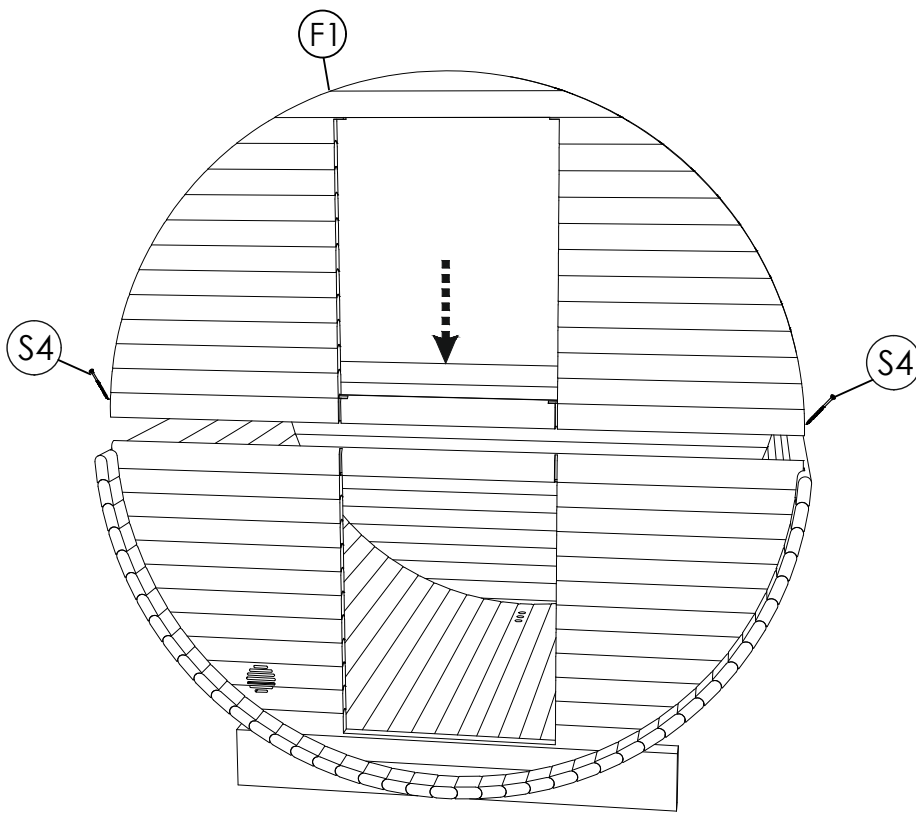
STEP 5: Place rear panel (F) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides. **For full panoramic instruction go to 7th page, step 5.1-5.4.**



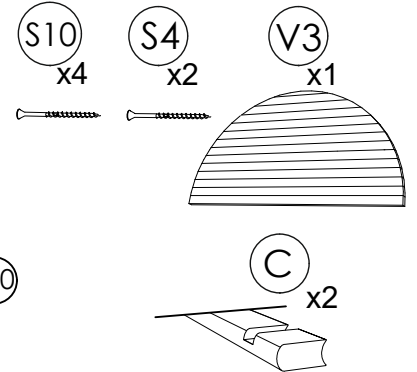
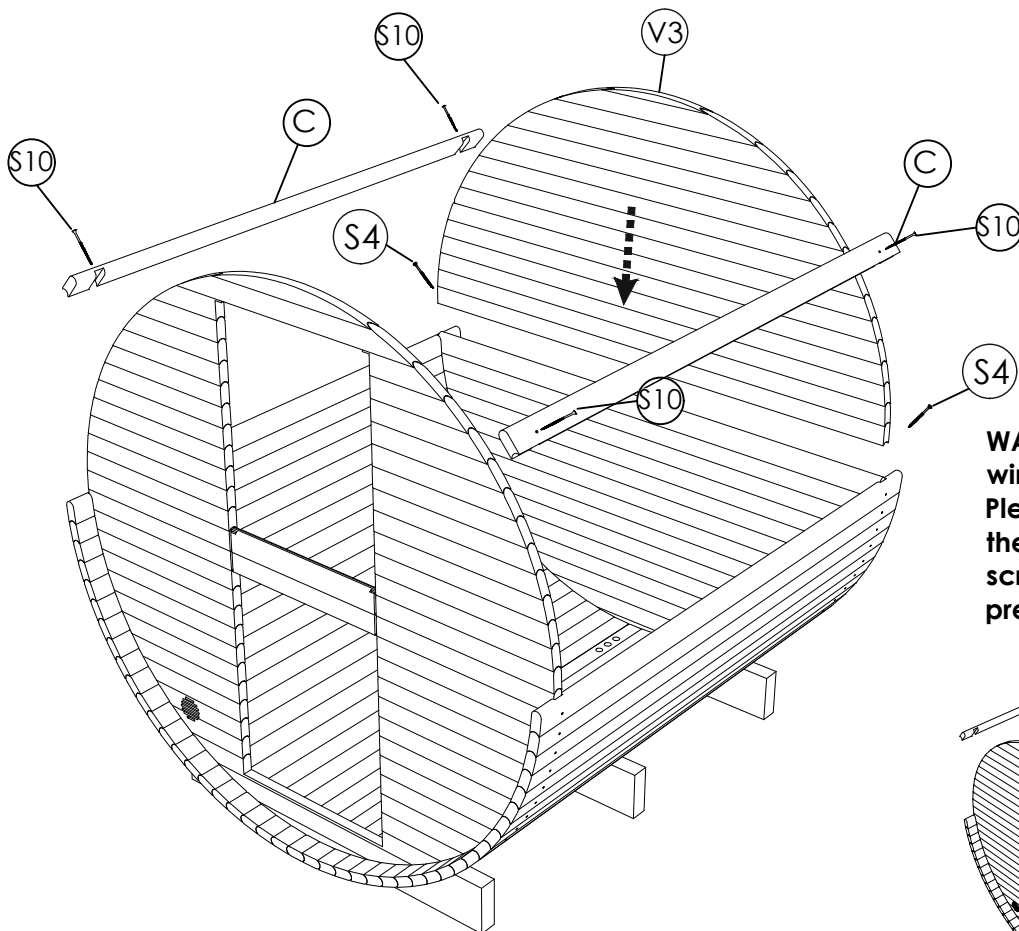
STEP 6: Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10). Fix one stave higher on left side than at right.



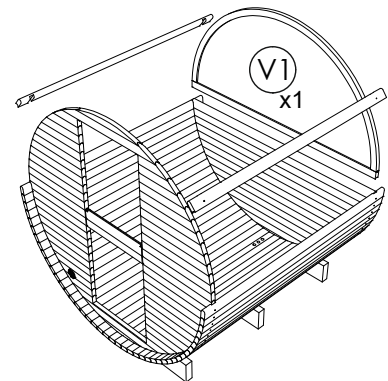
STEP 7: Place front top panel (F1) on front bottom panel (F), be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws on both sides.



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.

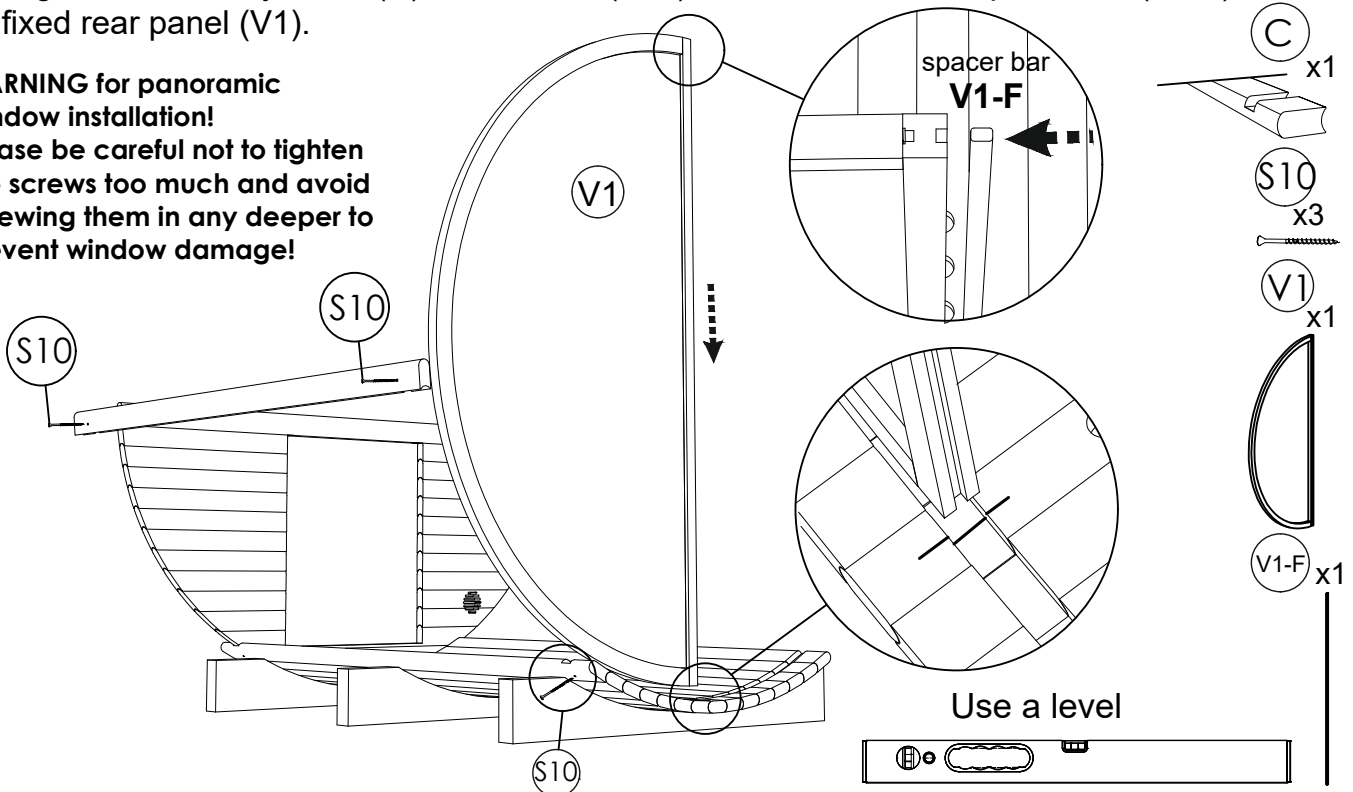


WARNING for panoramic window installation!
Please be careful not to tighten the screws too much and avoid screwing them in any deeper to prevent window damage!

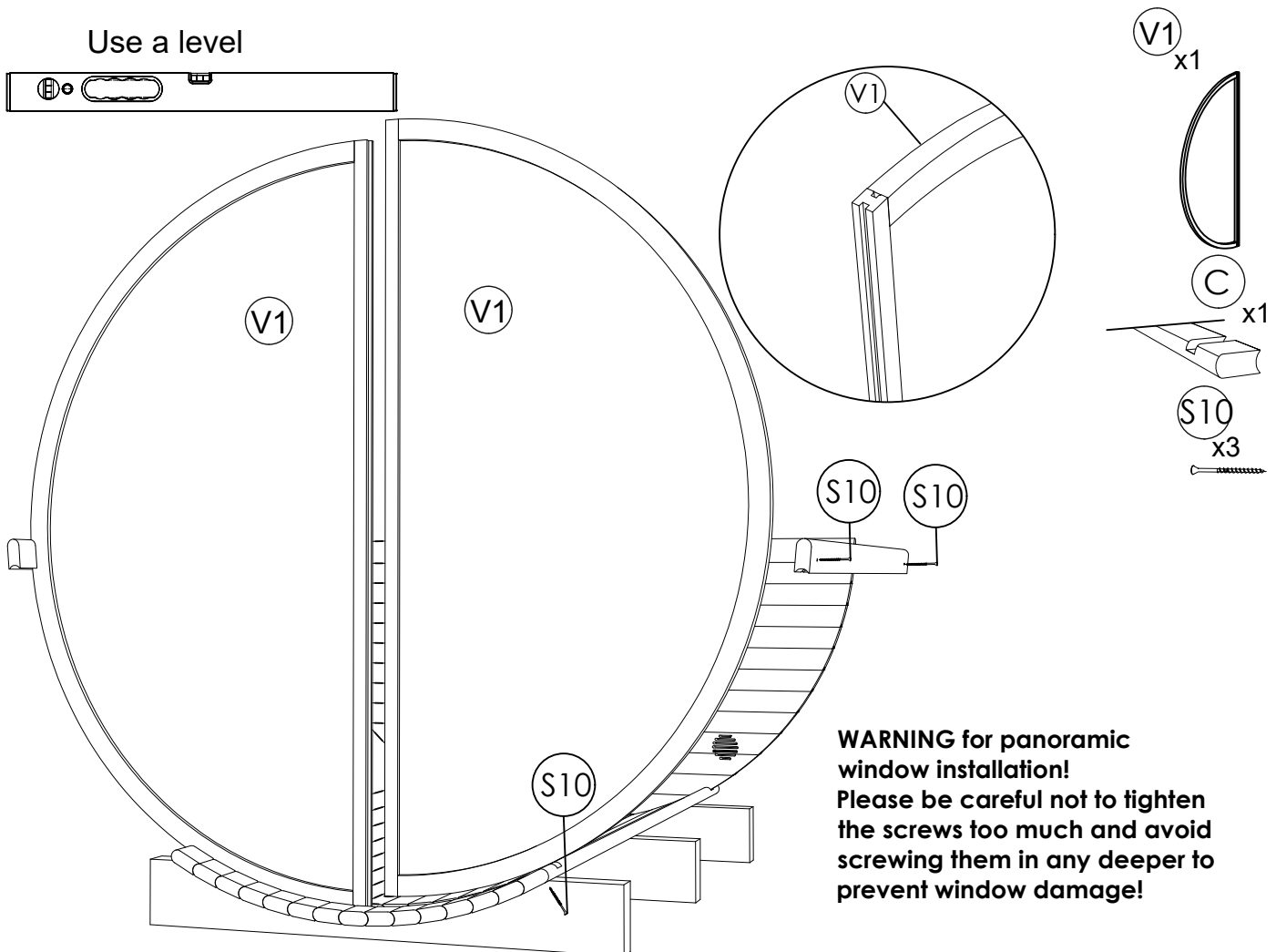


STEP 5.1: Place rear panel (V1) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using 4.0 x 60 (S10) screw through last floor stave. Connect the panels (F; V1) together with body stave (C) with 4.0x60 (S10) screw. Insert wood spacer bar (V1-F) in to the fixed rear panel (V1).

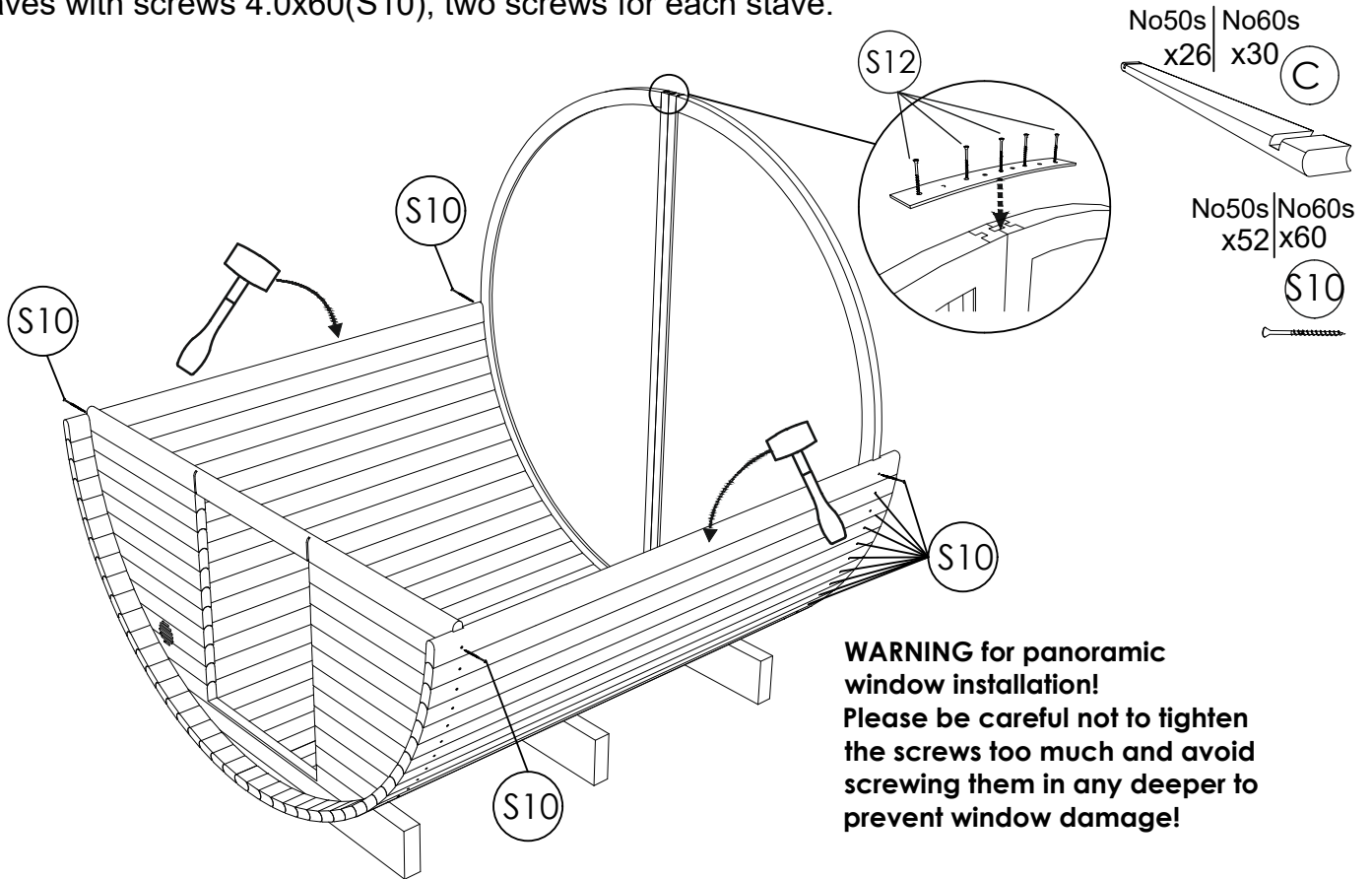
WARNING for panoramic window installation!
Please be careful not to tighten the screws too much and avoid screwing them in any deeper to prevent window damage!



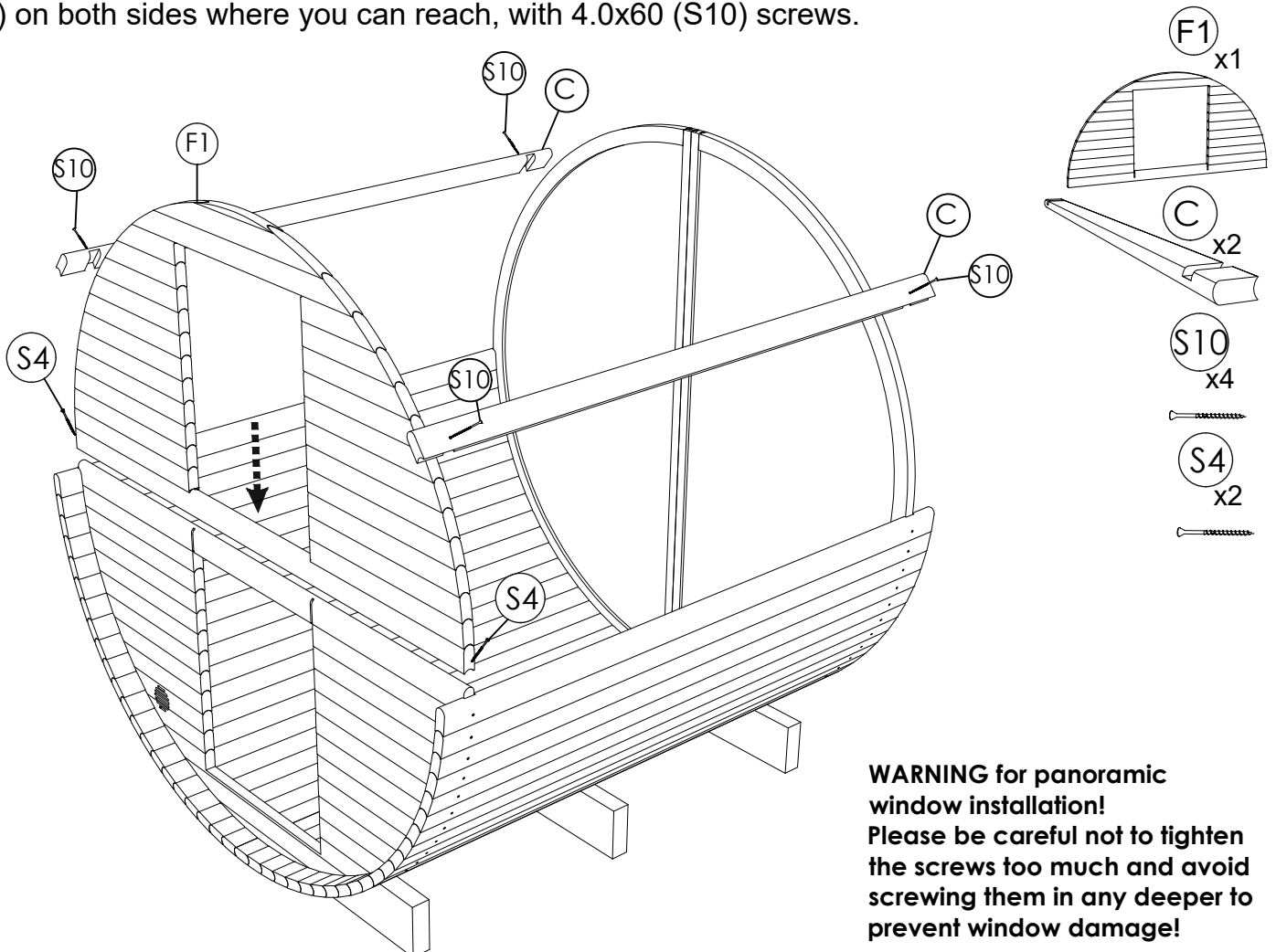
STEP 5.2: Place second rear panel (V1) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using 4.0 x 60 (S10) screw through last floor stave. Connect the panels (F; V1) together with body stave (C) with 4.0x60 (S10) screw.



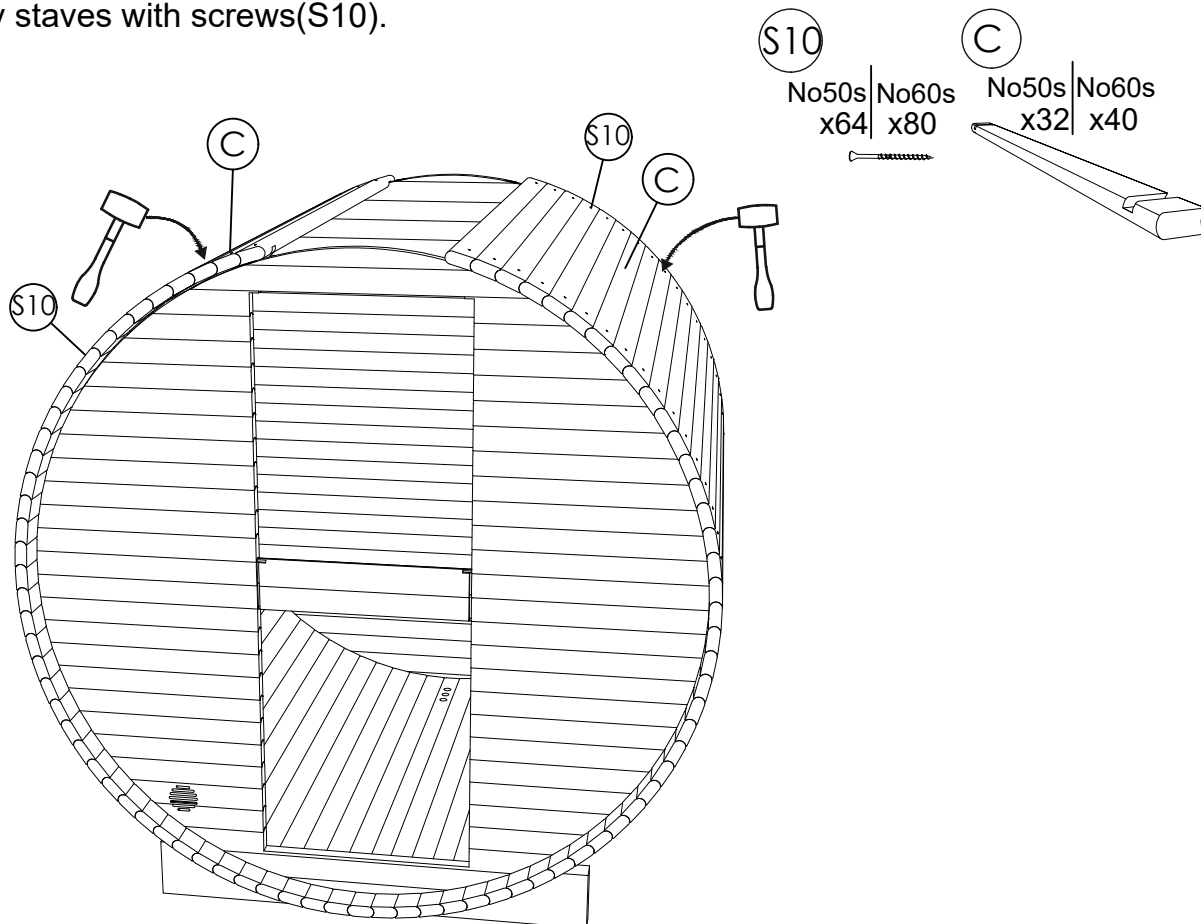
STEP 5.3: Fix Assembly tape with five 4x30 screws (S12) to fix both panels together. Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws 4.0x60(S10), two screws for each staff.



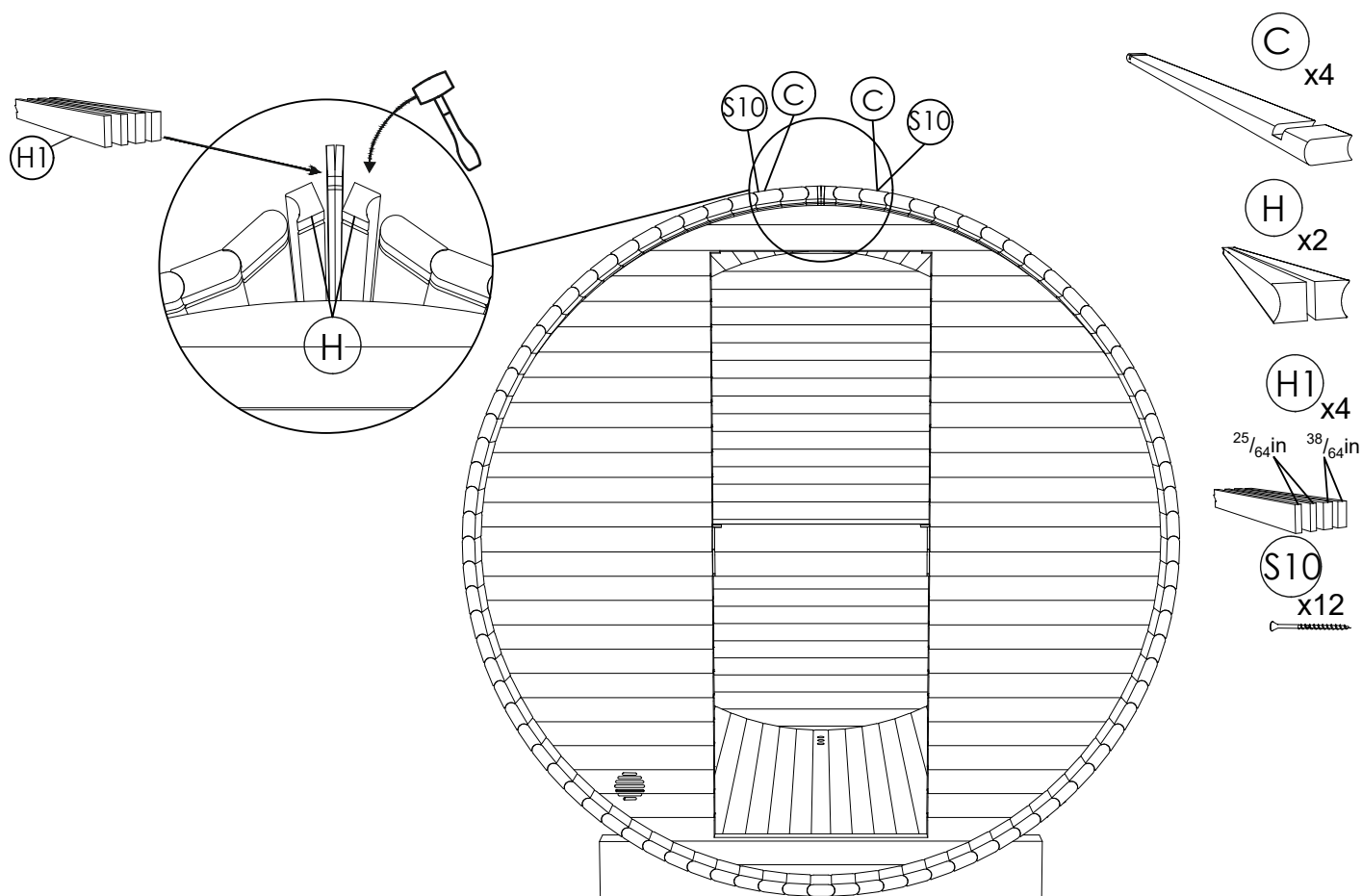
STEP 5.4: Take the upper front panel (F1) and place it on top of the front panel (F). Secure it by using 2 screws 5.0 x 120 (S4). Connect the panels (F1; V1) together by placing one body staff (C) on both sides where you can reach, with 4.0x60 (S10) screws.



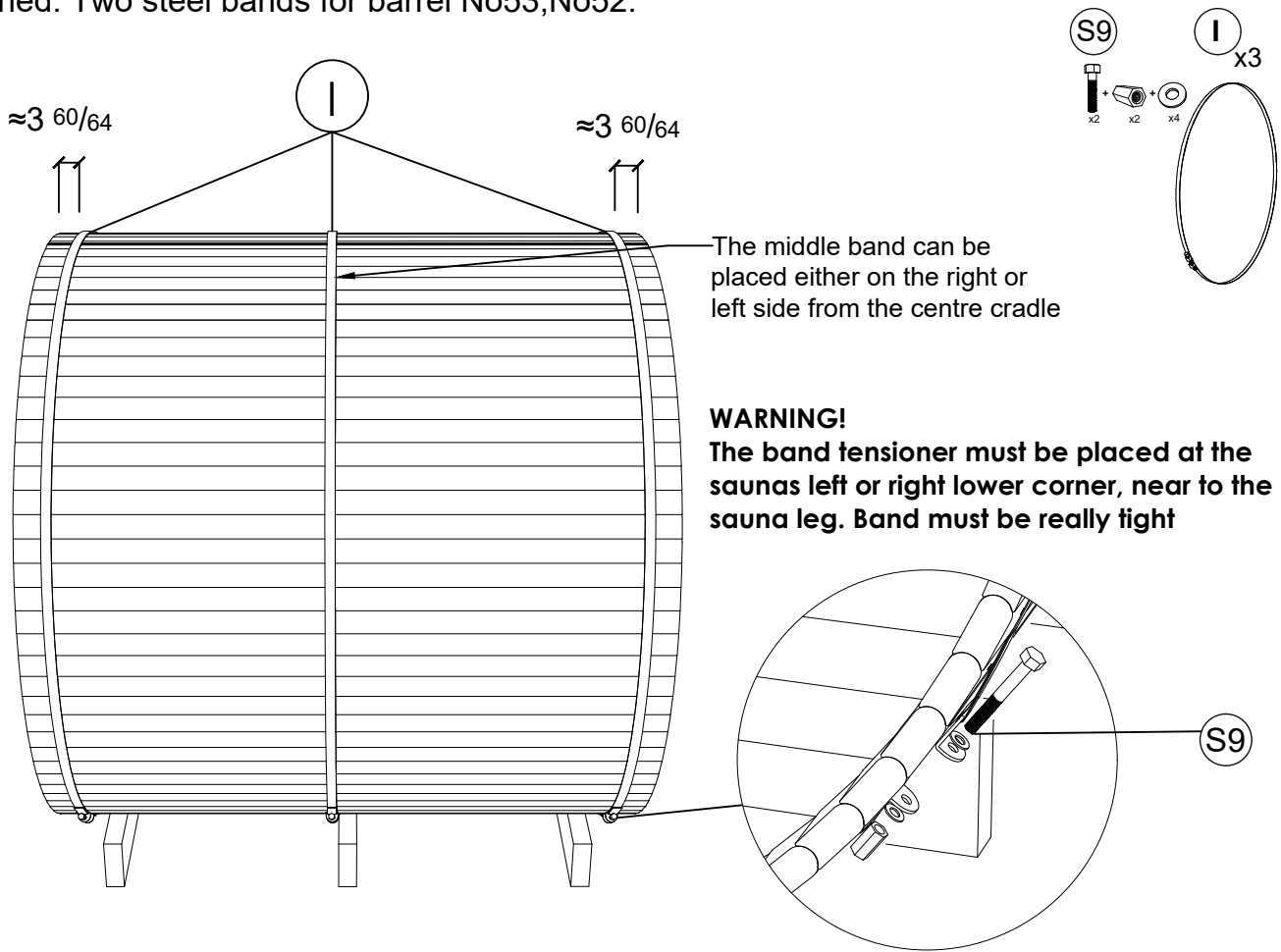
STEP 9: Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws(S10).



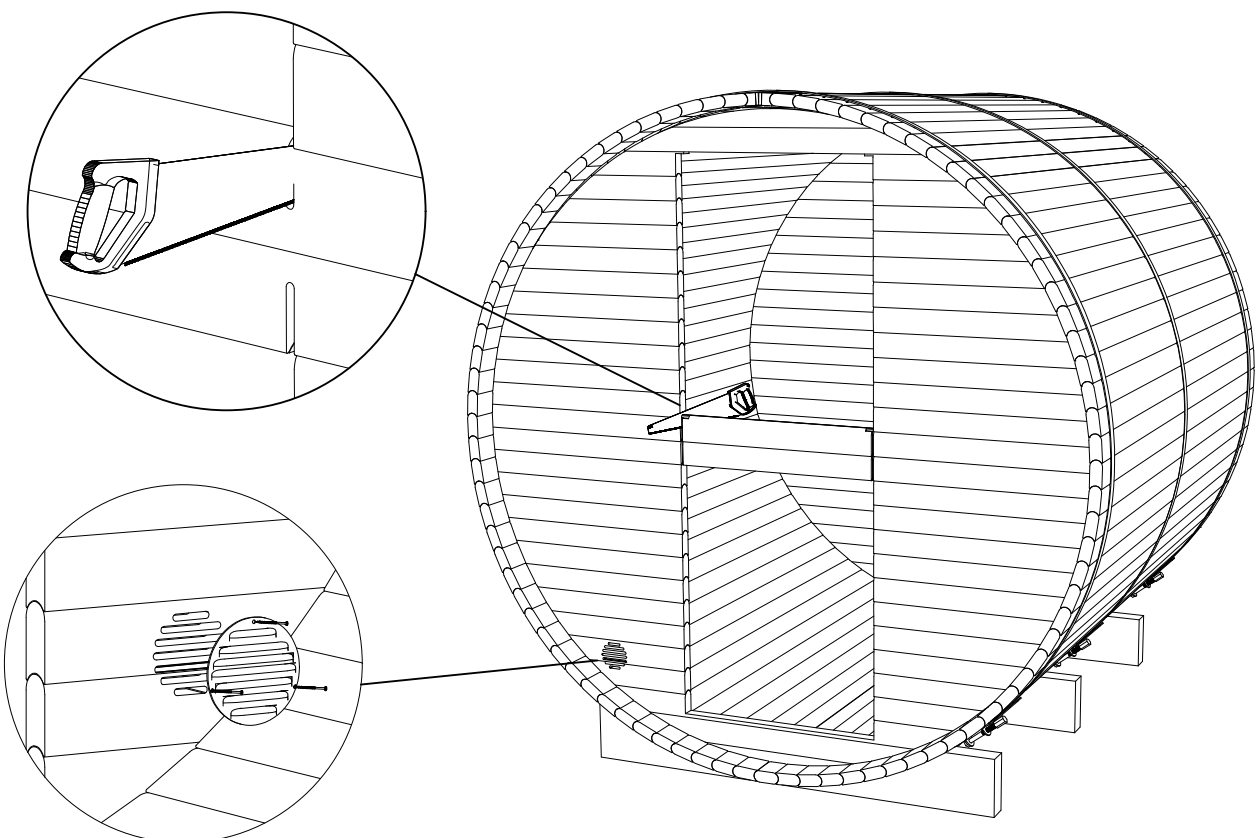
STEP 10: To finish the roof top joint, don't screw about last 2-3 boards (C) to each side, use roof finishing item (H). Different thickness filling pieces (H1) are provided to completely fill the gap. Once necessary parts are in, fix last boards with screws.



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.

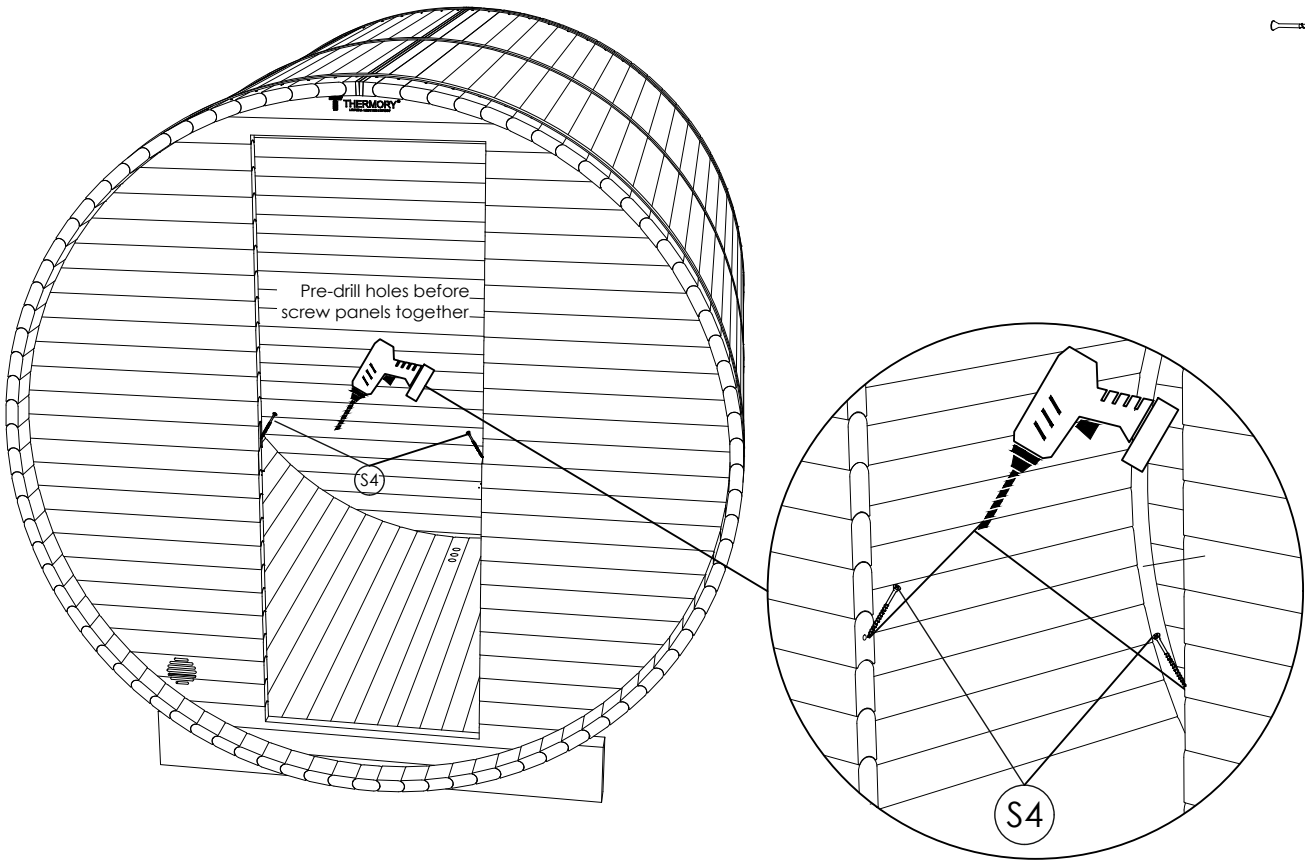


STEP 12: Draw straight line to connect both cuts. Use hand saw or other cutting machine to saw out excess boards for door box. It's recommended to saw out boards from inside. Fix ventilation grill (Y) from inside on ventilation cuts.



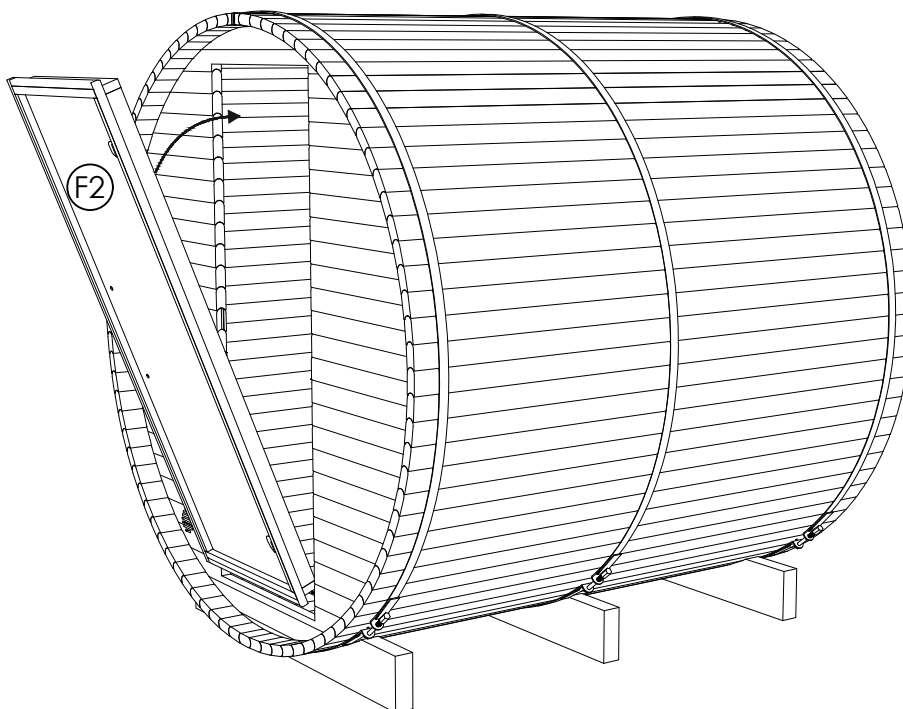
STEP 13: Pre-drill holes for screws. Fix both panels together using (S4) screws.

(S4)
x2

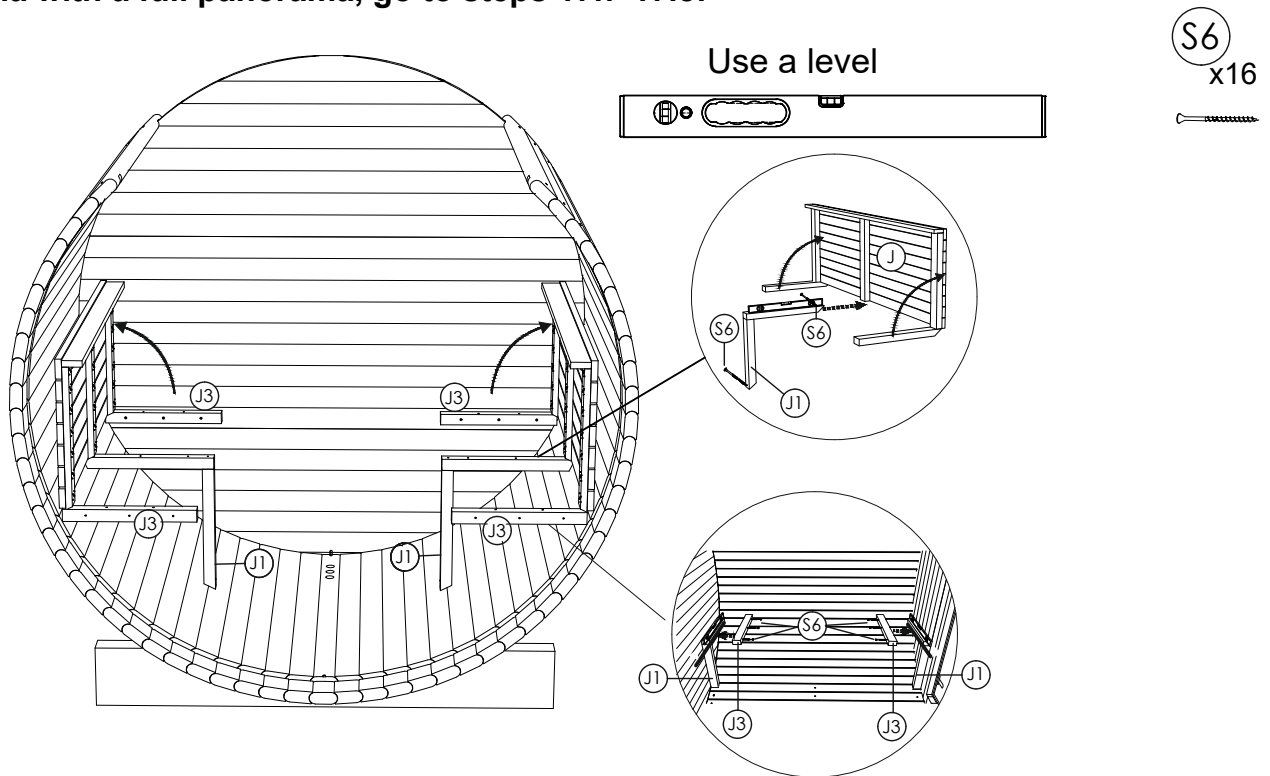


STEP 14: Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.

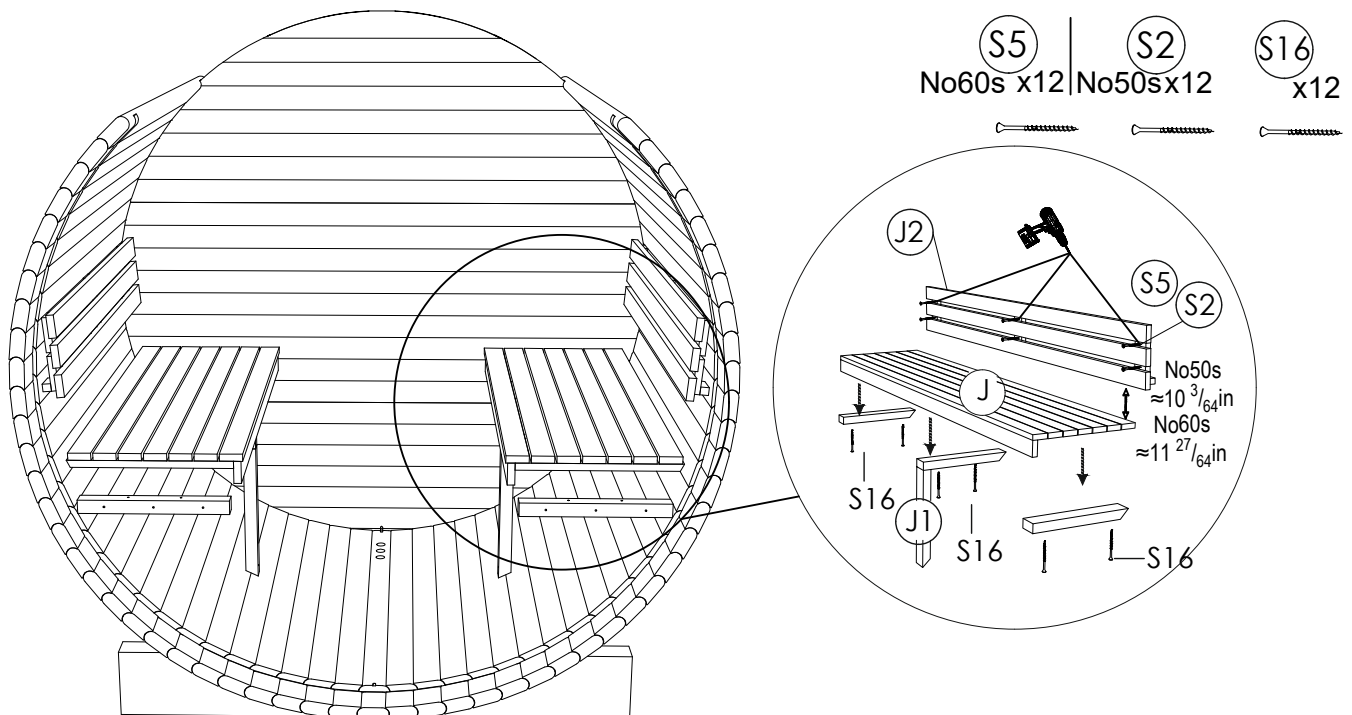
(F2)
x1



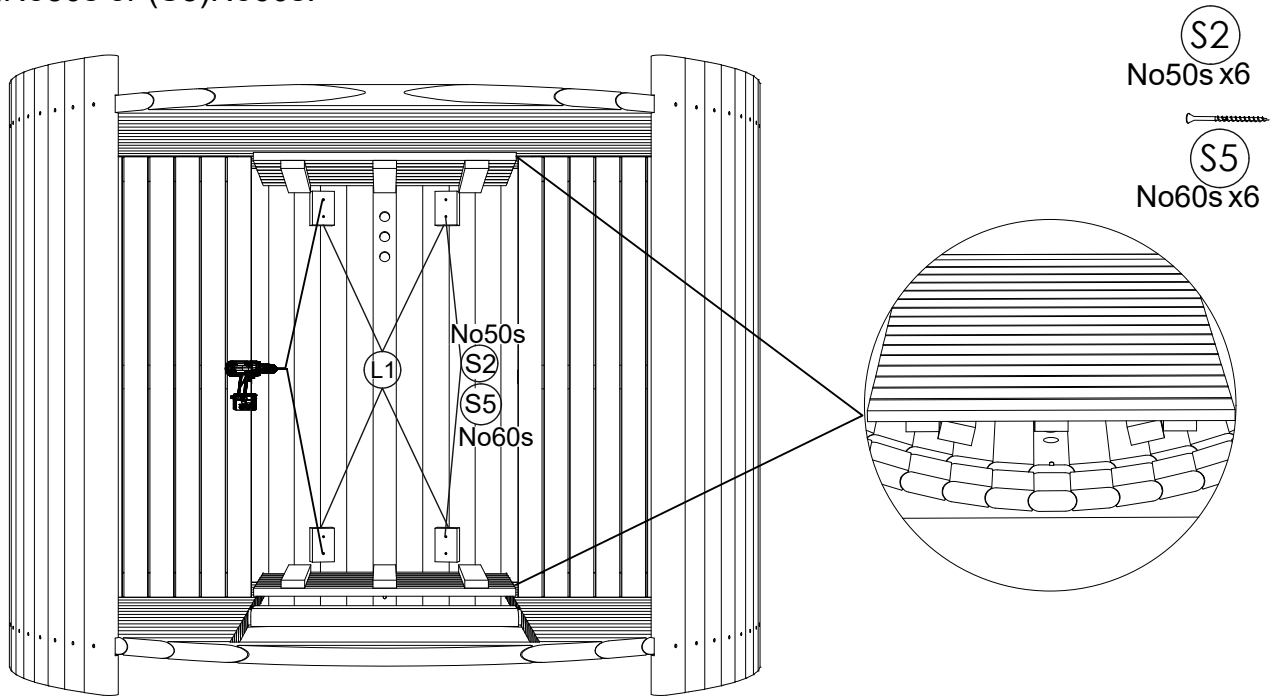
STEP 17: To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, mark a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall mounts. Place J1 in the center and check the level. Using screw (S6) fix bench leg to the wall and floor. **For 2 level bench installation go to steps 17.1-17.6! To install benches in the sauna with a full panorama, go to steps 17.7-17.8!**



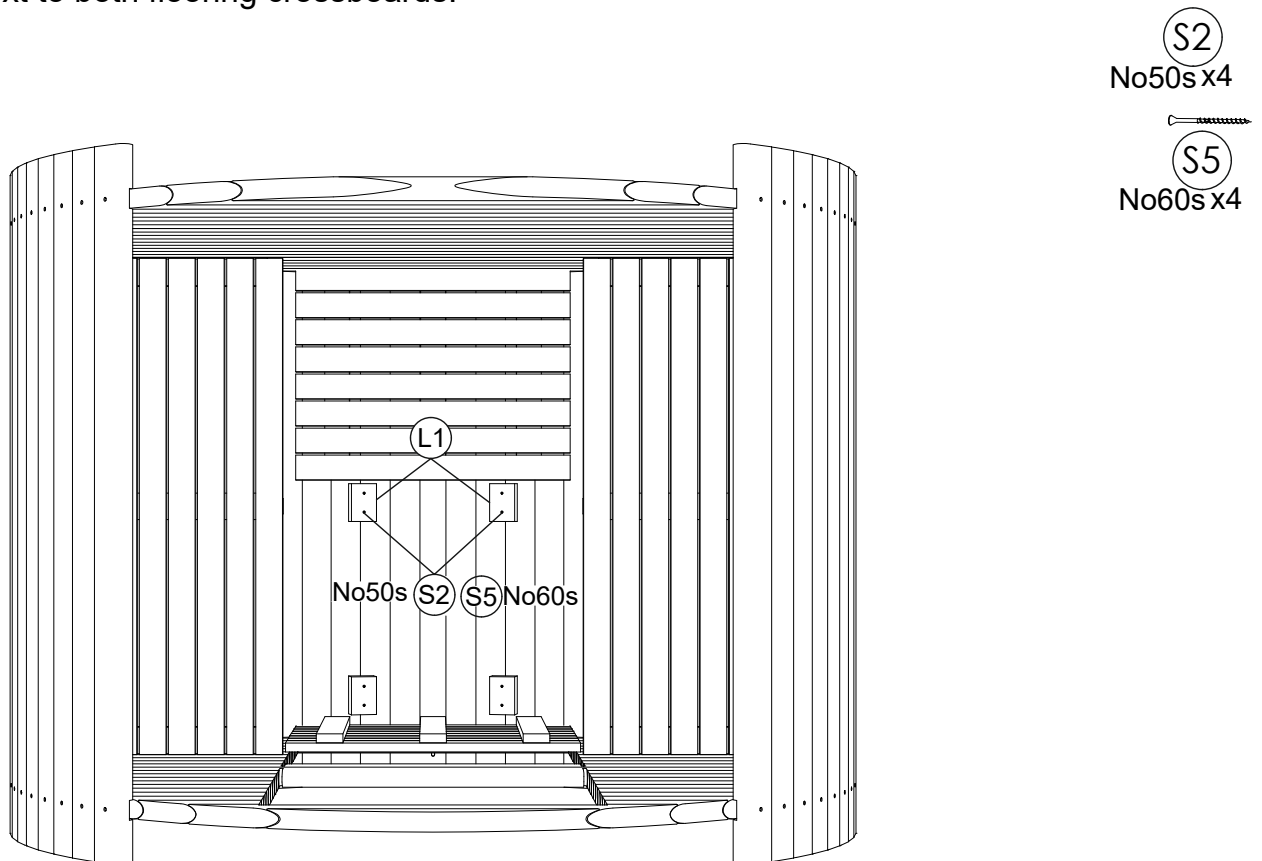
STEP 18: Pre-drill holes before fix backrest with screws, install backrests (J2) using screw (S2). Fix sauna bench (J) to wall mounts and support leg using (S6) screws.



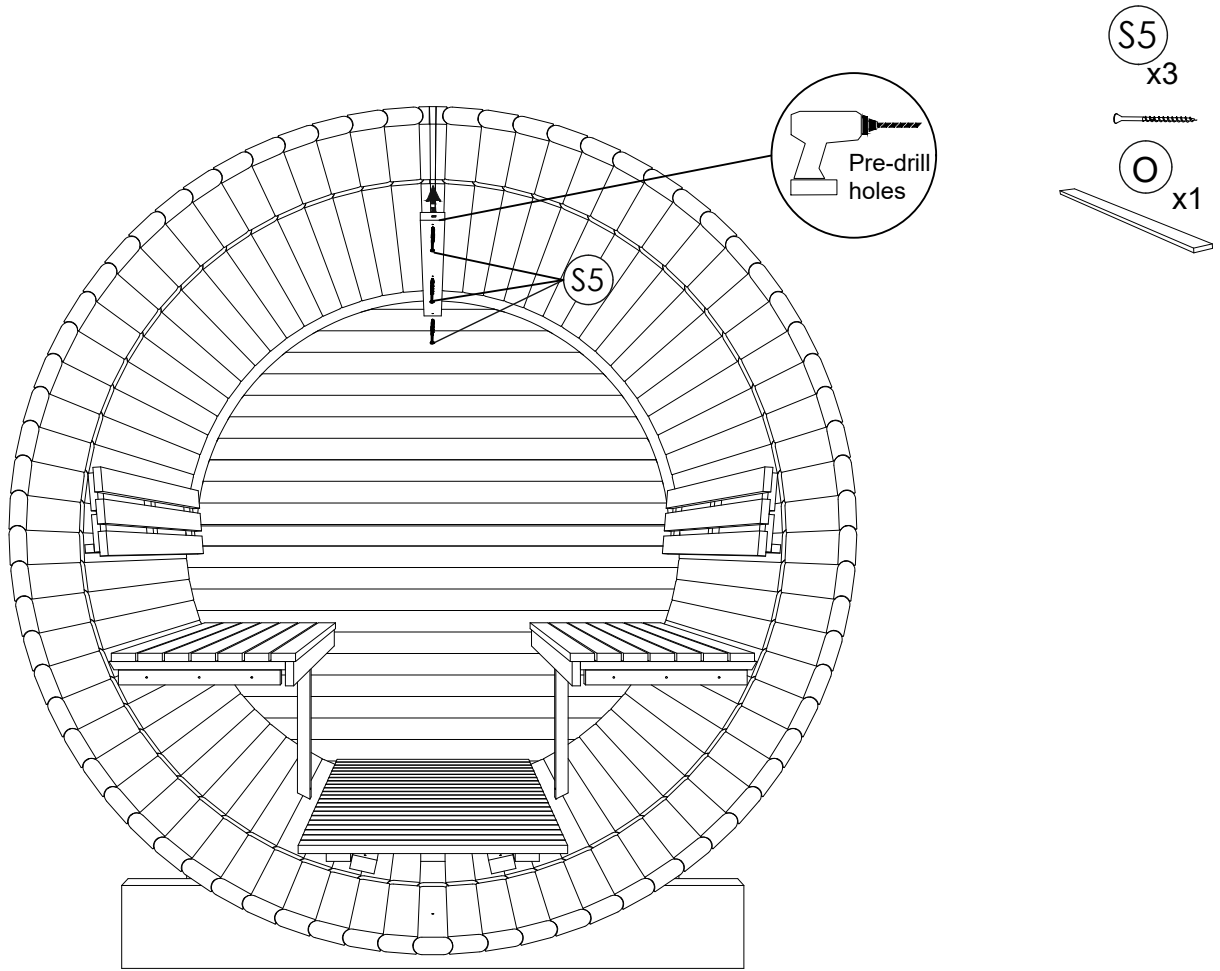
STEP 19: Place floor duckboards (L) to the both sides upwards and place fixing blocks next to the flooring cross boards. Pre-drill holes before fix with screws, install fixing blocks (L1) using screw(S2)No50s or (S5)No60s.



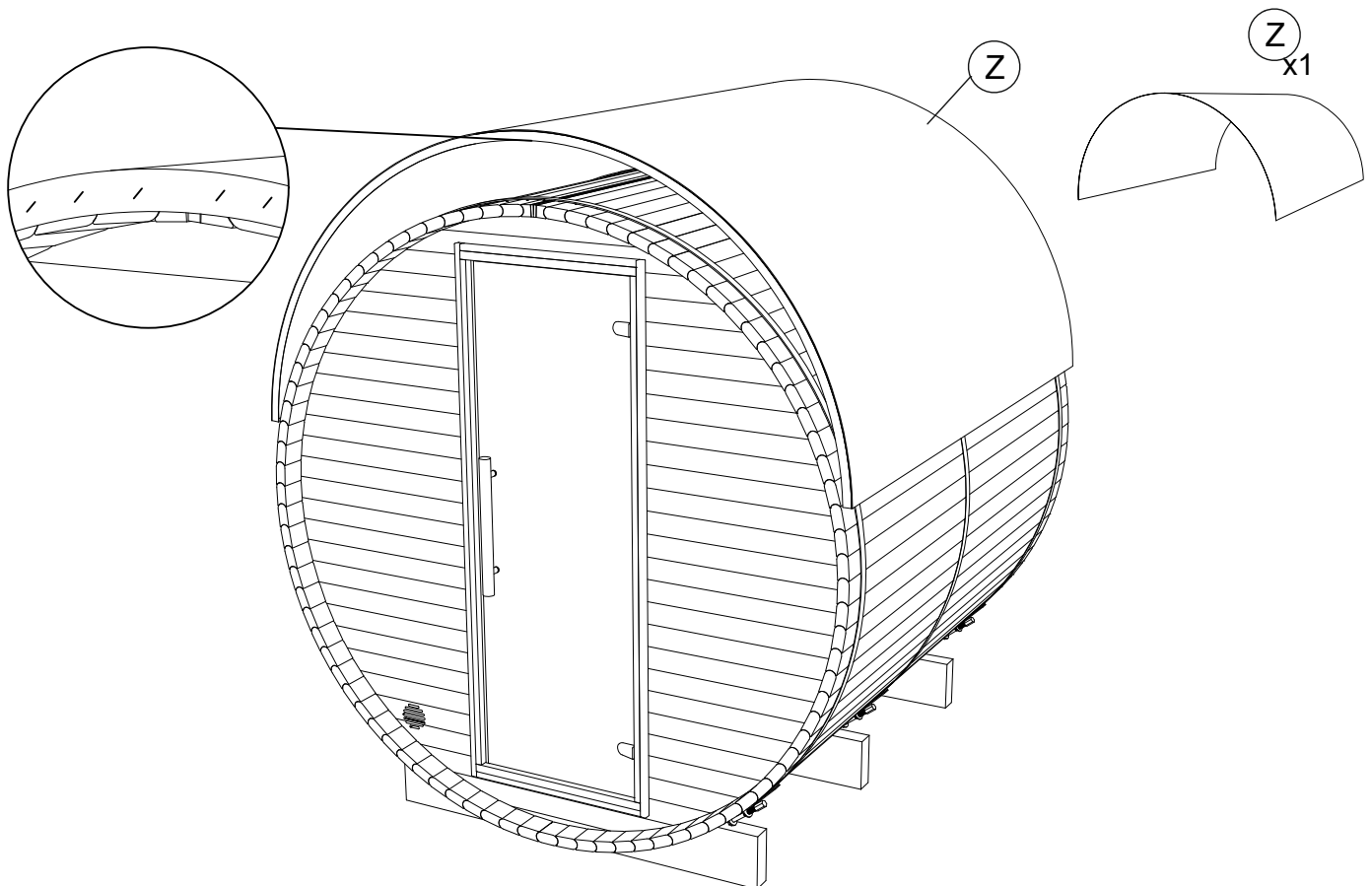
STEP 20: Pre-drill holes before fix with screws, install fixing blocks (L1) under floor duckboard using screw (S2) No50s or (S5) No60s. Place floor duckboards (L) on the floor and fix fixing blocks next to both flooring crossboards.



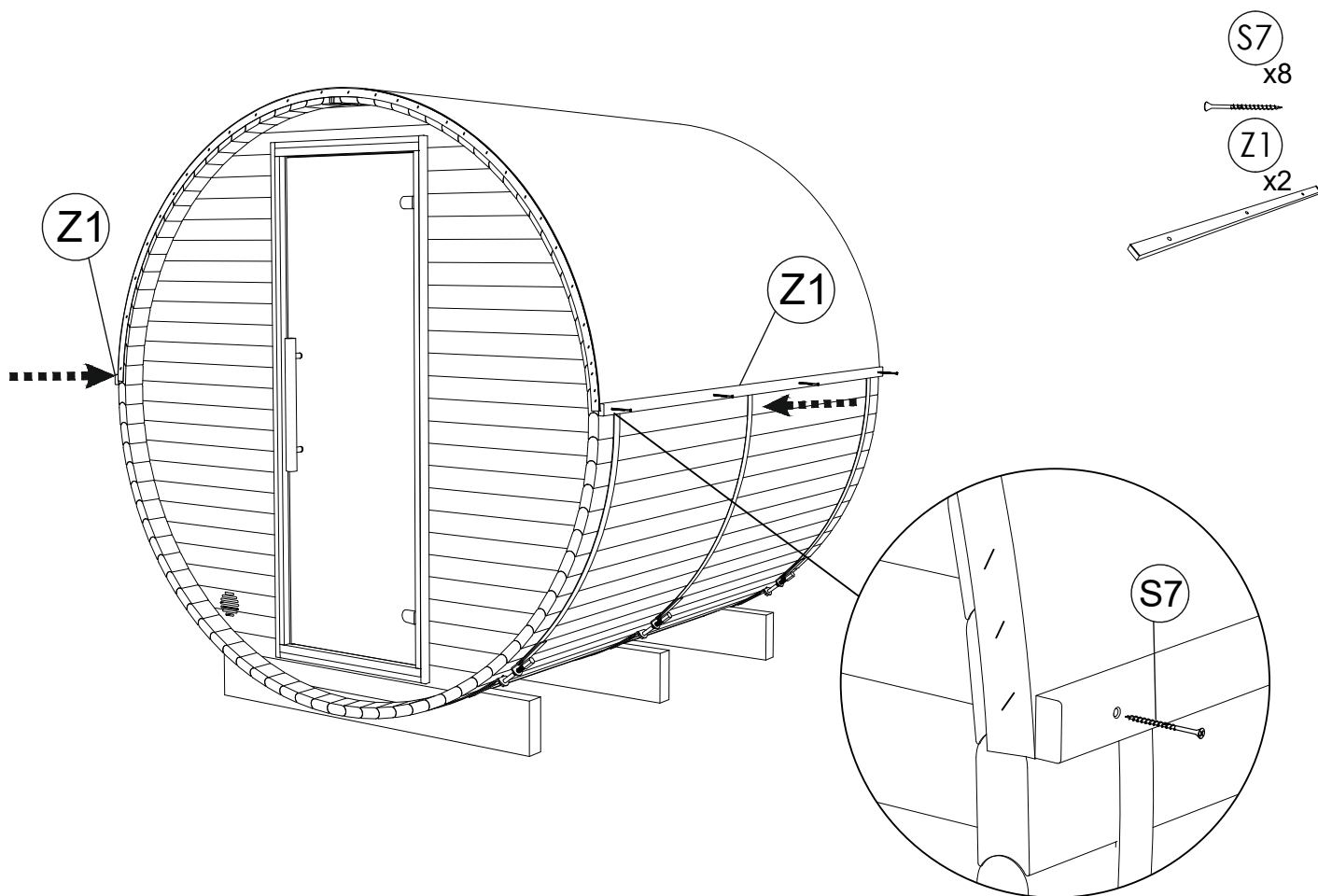
STEP 21: Pre-drill holes before fix stave with screws, install interior roof trim (O) in sauna with (S5) screws.



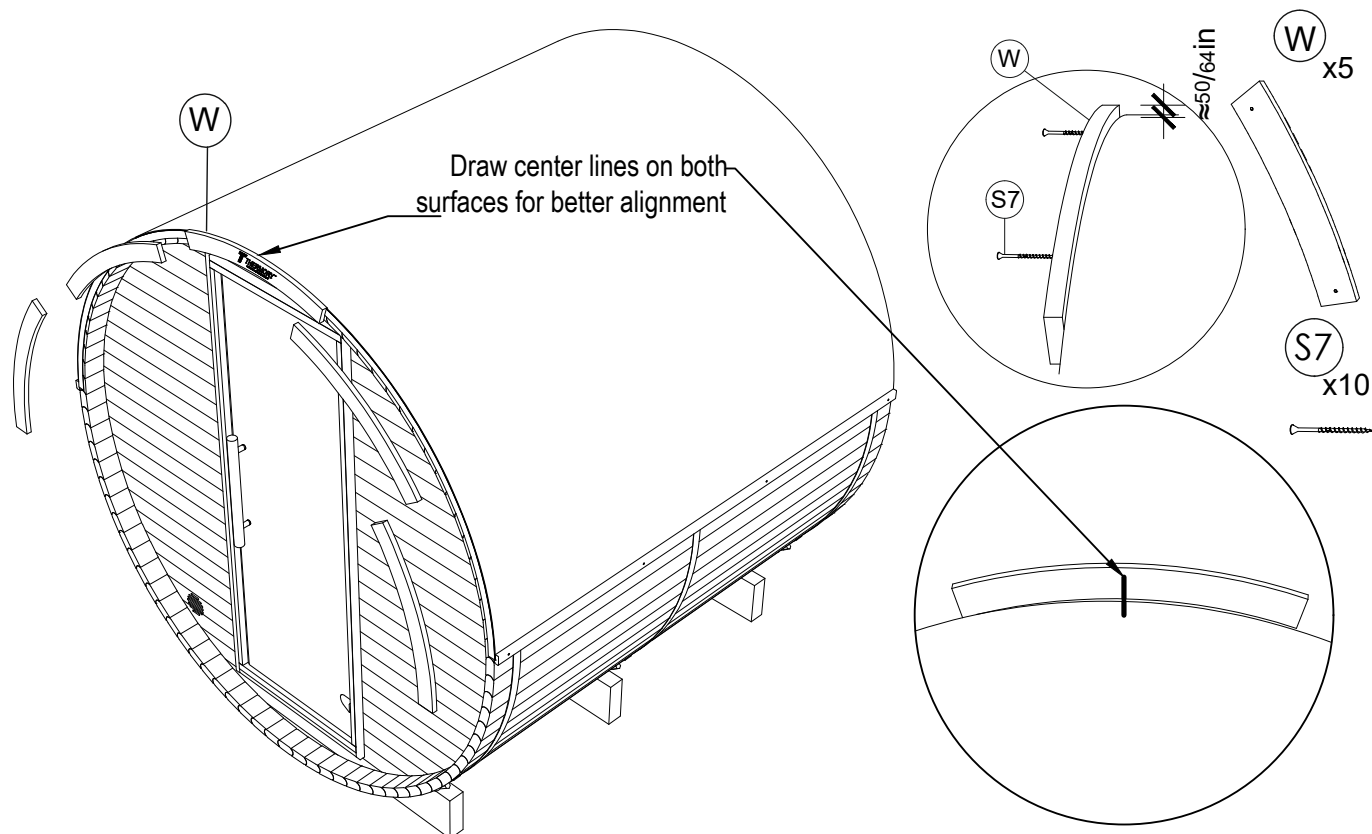
STEP 22: Place waterproof PVC roof cover . Align roof cover equally to both sides. Roof cover goes about $\approx 1 \frac{37}{64}$ in over each sides edge. Staple roof cover on the saunas edge.



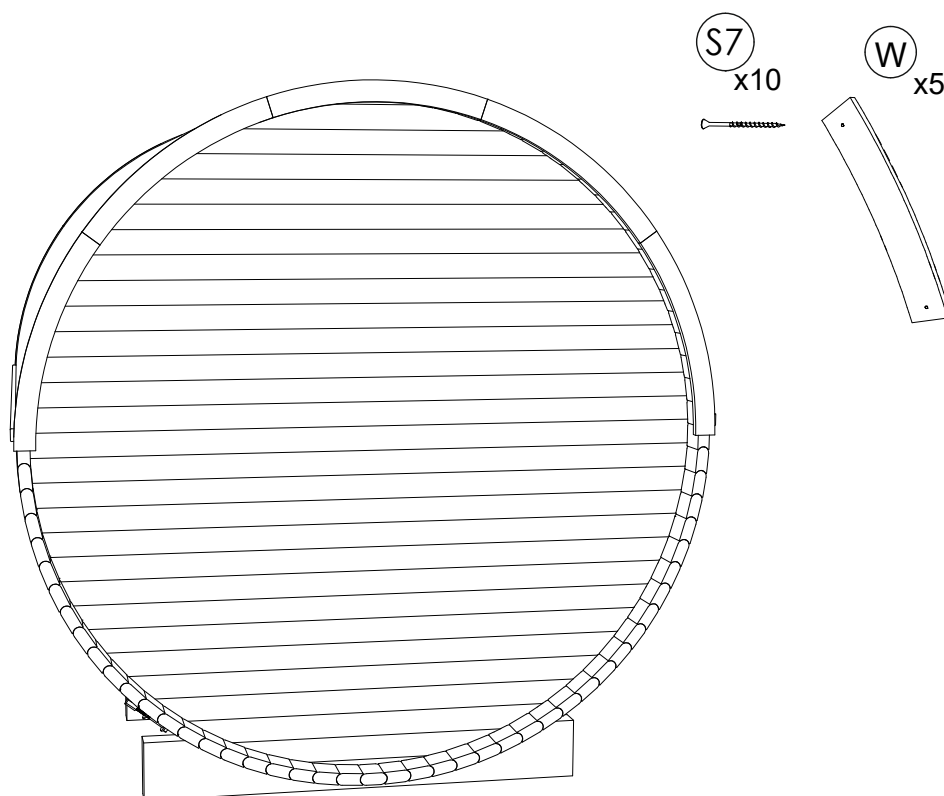
STEP 23: Fix with wooden slats (Z1) with screws (S7) on the rain jacket bottom. The number of screws may vary depending on the sauna model.



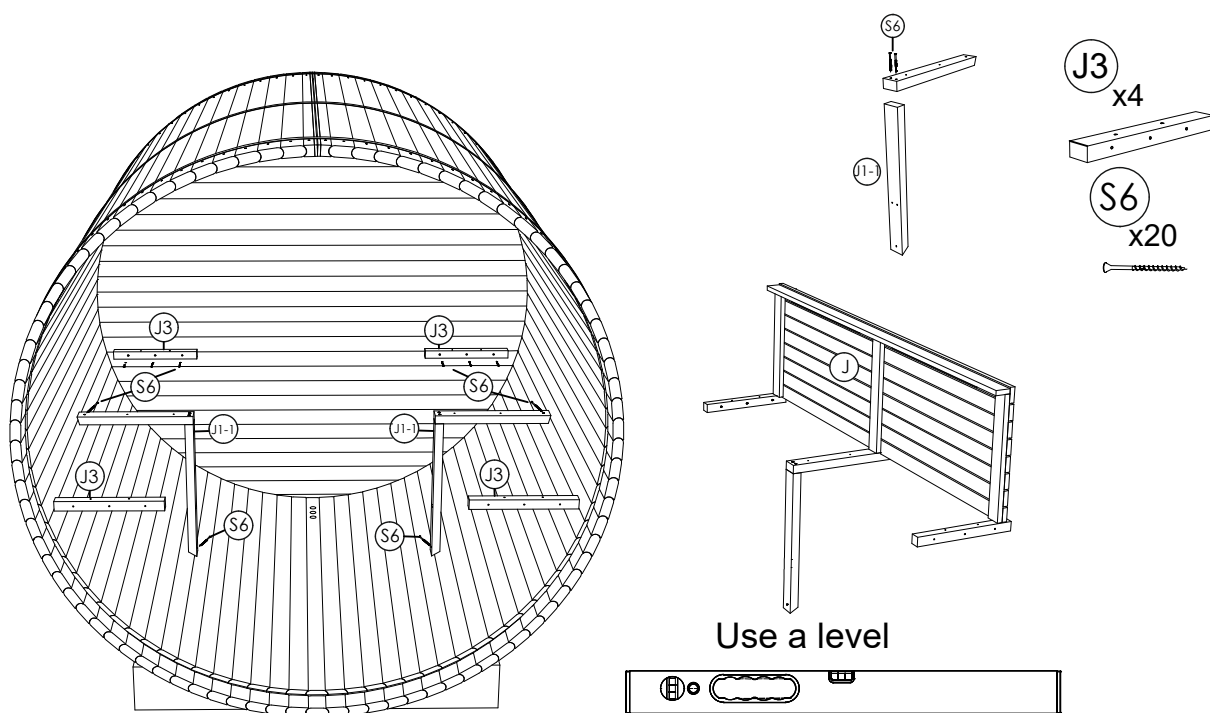
STEP 24: Install front and rear decorative roof finishing boards (W), fixing by screws (S7). Start with a center board placing it at the top of the middle of the sauna, approx. $\frac{50}{64}$ in above roof or $\frac{13}{64}$ in under the roof. Then fix next boards right next to previous board.



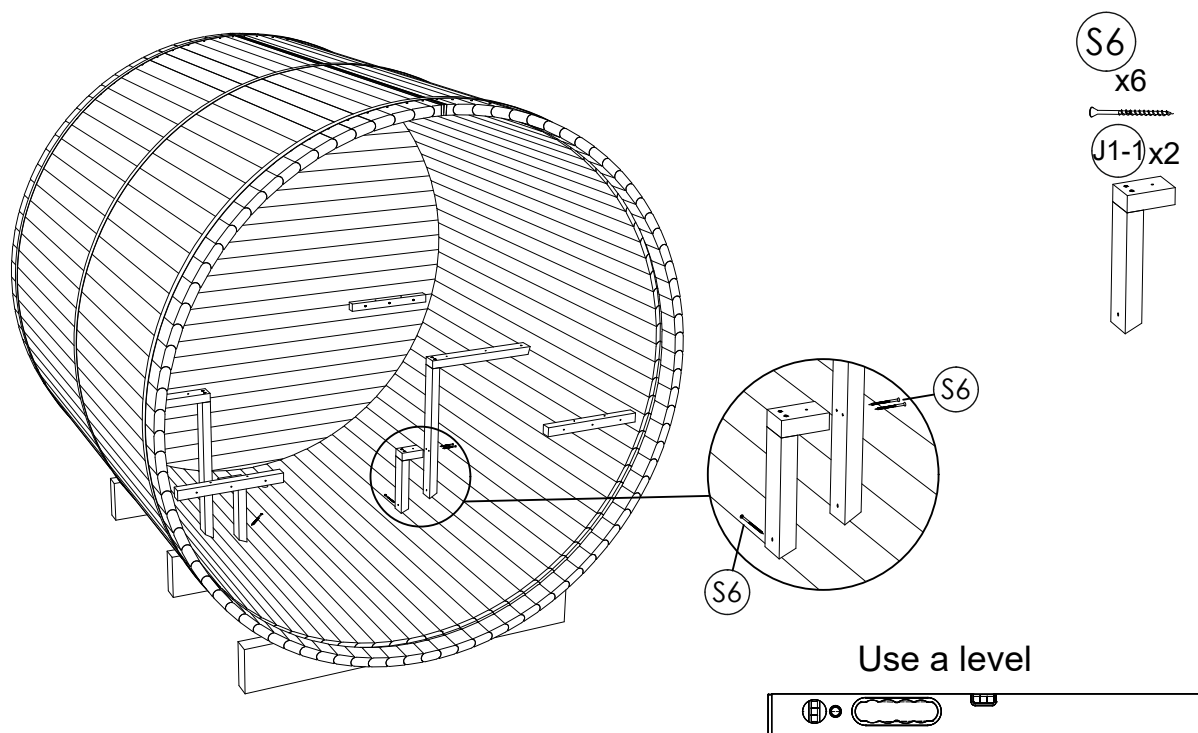
STEP 25: Repeat step 24 to apply roof finishing boards at the back of the sauna roof edge.



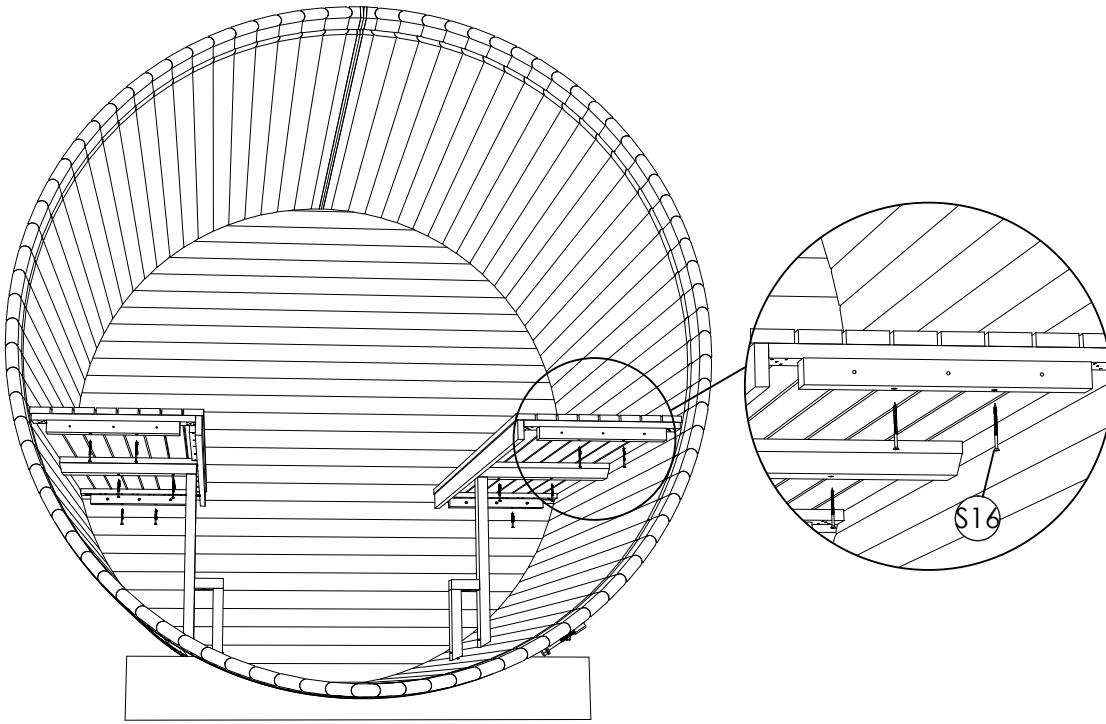
STEP 17.1: Assemble first half of the long bench leg(J1) with (S6) screws. To install wall mounts (J3) use long bench leg (J1). Put it on the sauna wall in level, mark a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) 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 17.2: Fix second part for the long bench leg using (S6) screws. Use level.

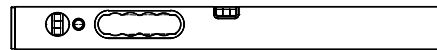


STEP 17.3: Fix sauna bench (J) to wall mounts and support leg using (S6) screws.



STEP 17.4: To install small wall mounts use (J4) step bench. Put it on the middle leg faced upwards in level, mark a line where wall mounts will stand. Using screw (S6) fix wall mounts on the marked lines.

Use a level



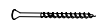
J8

x4



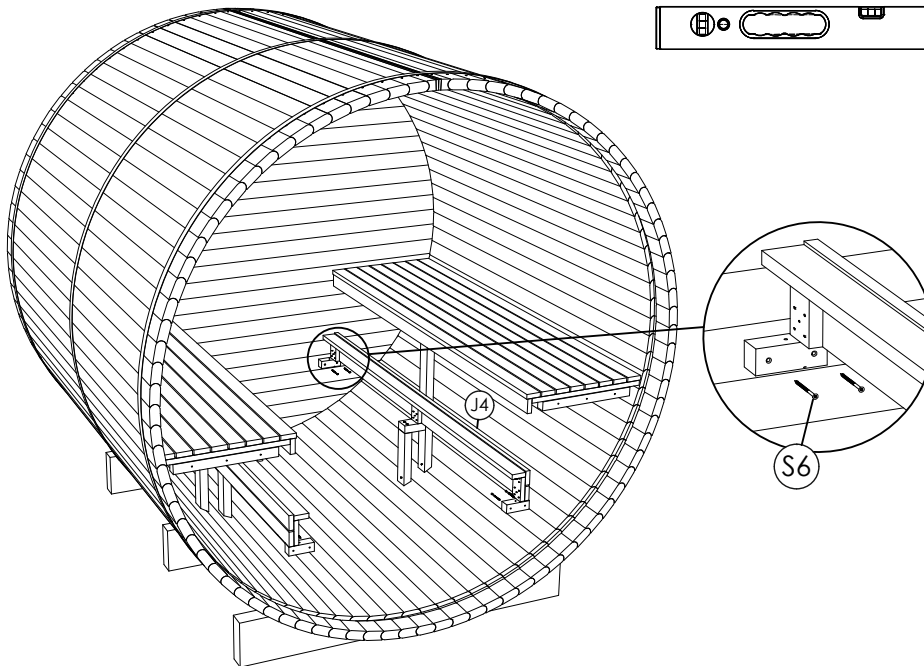
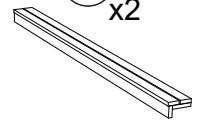
S6

x8

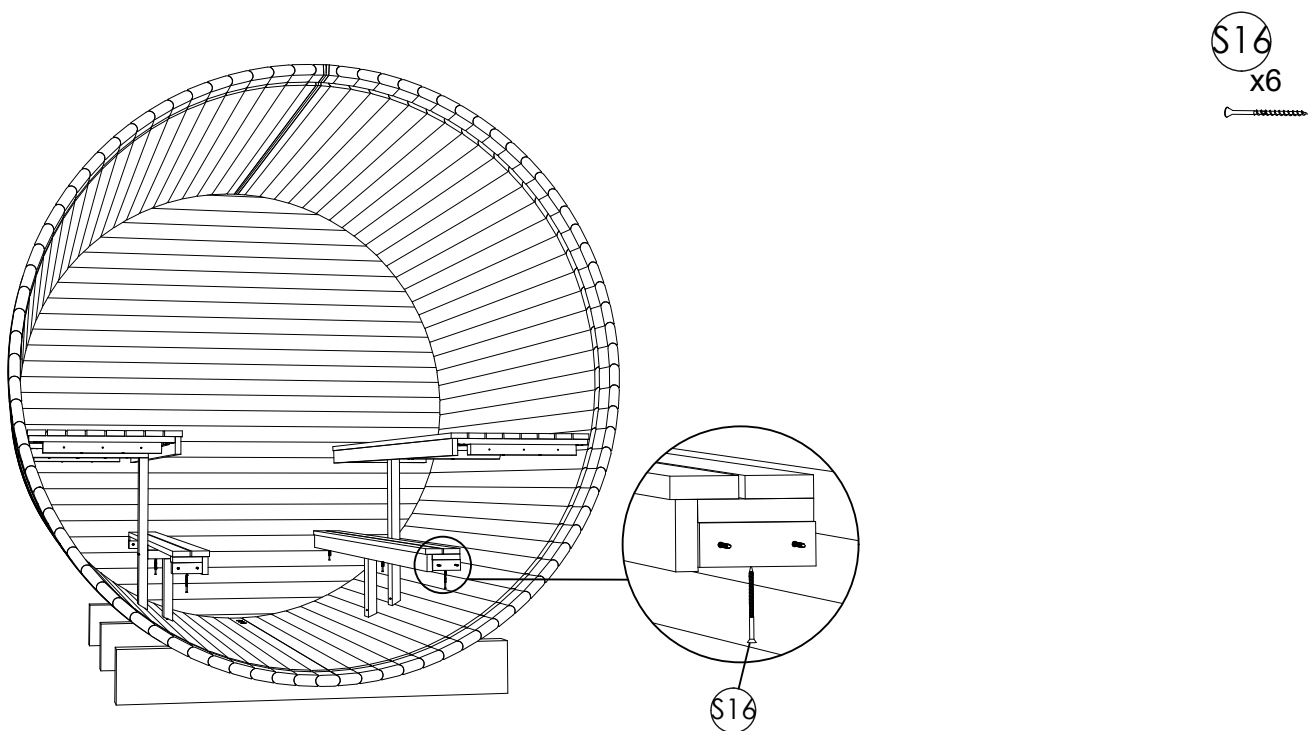


J4

x2



STEP 17.5: Fix sauna step bench (J4) to wall mounts and support leg using (S6) screws.



STEP 17.6: Fix small blocks at the bottom on the backrest crossboard (J2) using (S11) screws. Fix backrest about 255mm from bench using (S2) screws.

