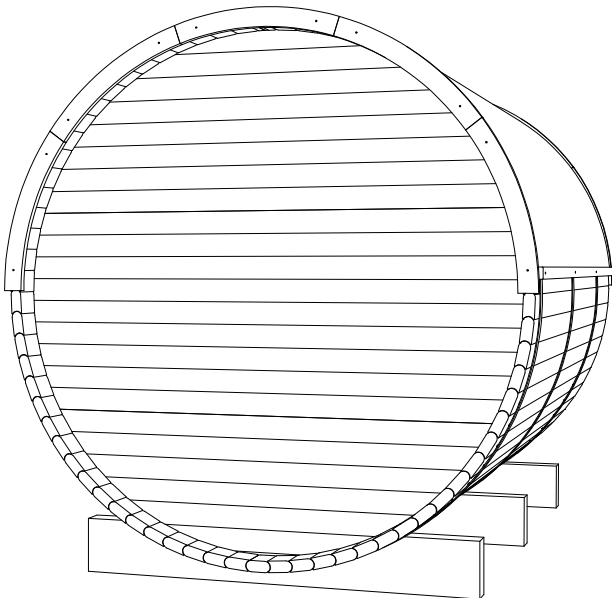
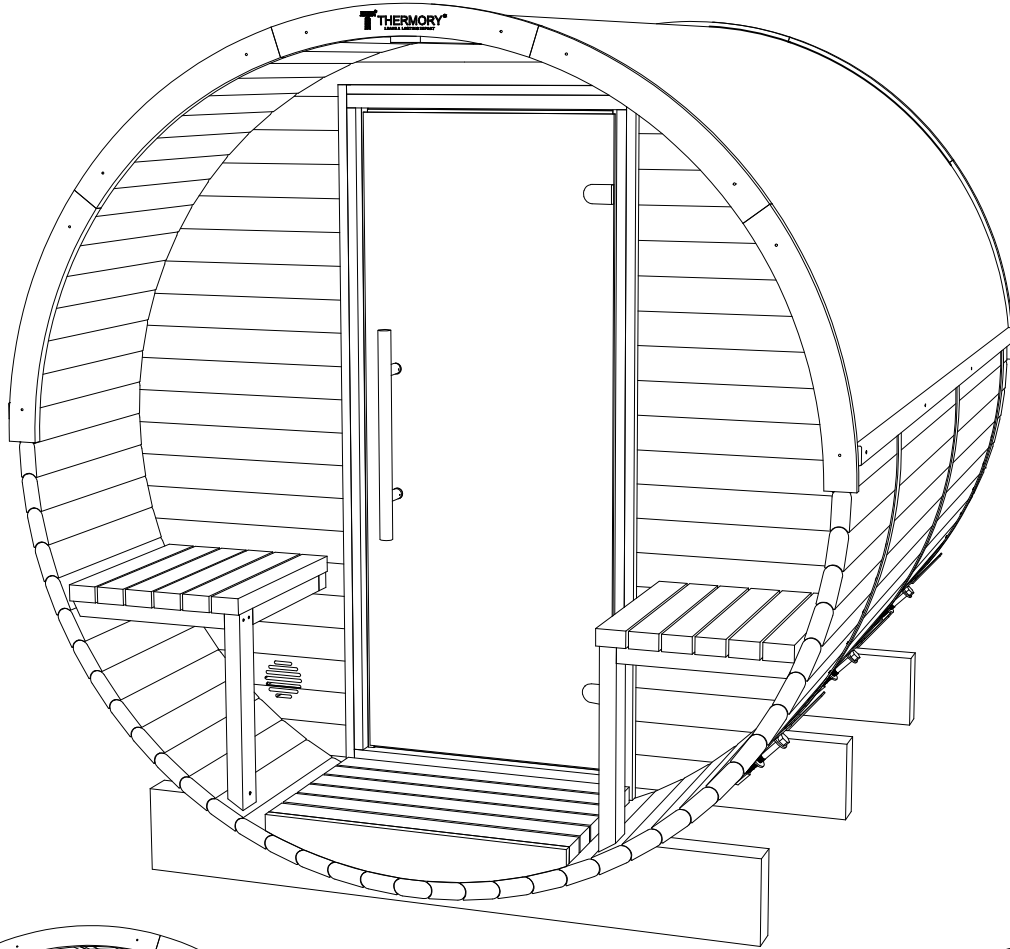
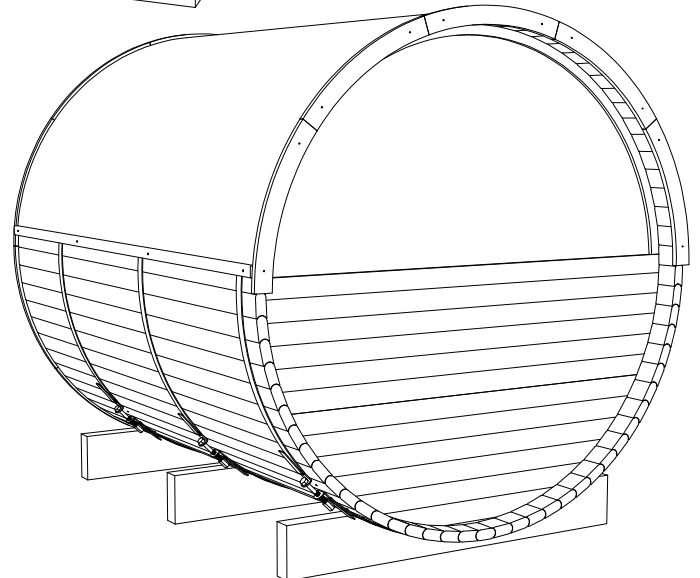


# BARREL SAUNA

## ASSEMBLY INSTRUCTIONS



Model: No61



Model: No60

















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

Rev. 12.05.2026

## 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 $\varnothing^{5/32-25/64}$ in
	Pencil		Battery drill		Wrench $7^{31/64}$
	Level		Nail gun		Vise
	Rubber mallet		Hex keys		Recommended - 2 person
	Hammer		Gloves		
	Stapler		Safety goggles		

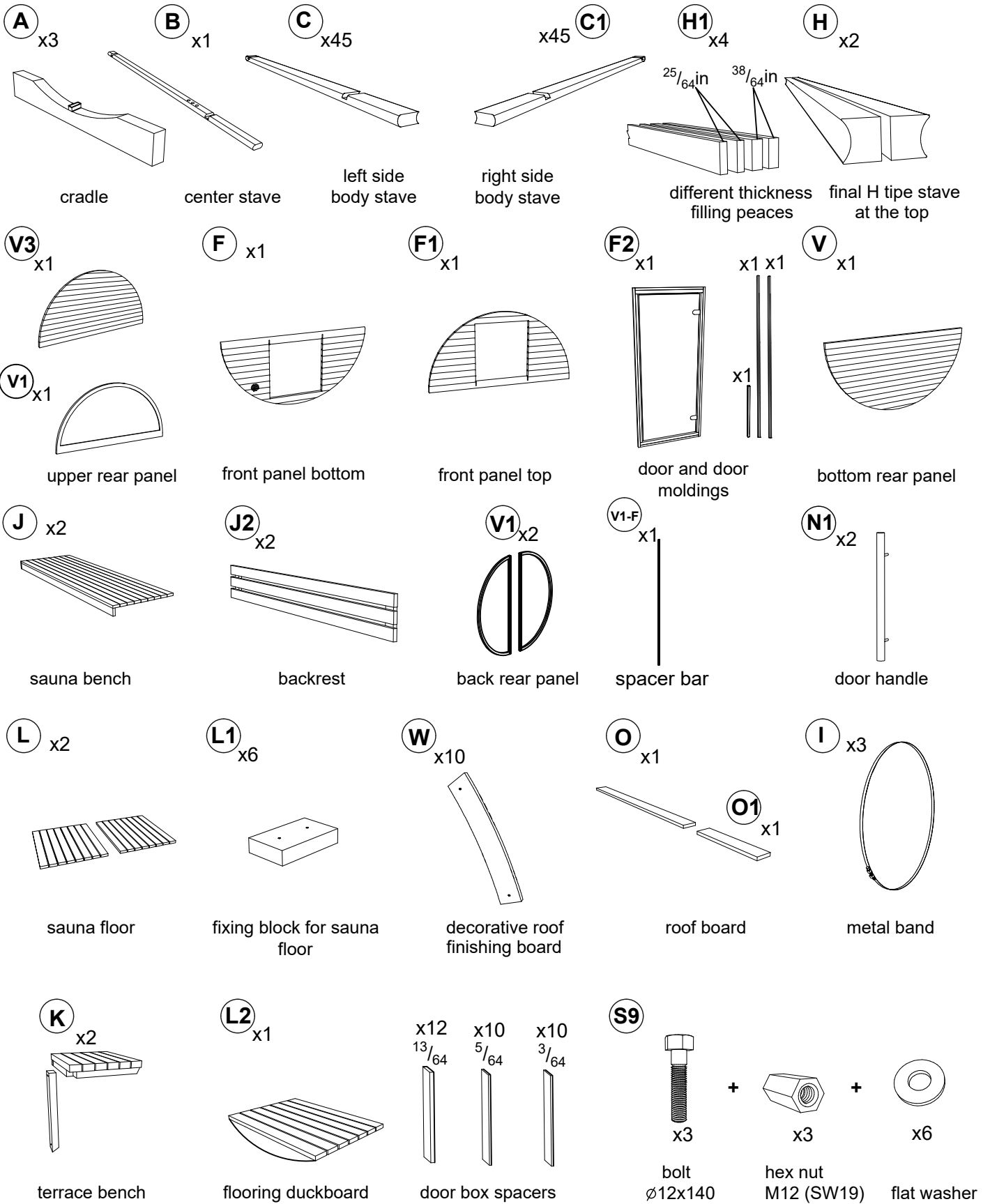
Before you begin, be sure the sauna will fit in your chosen location.

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

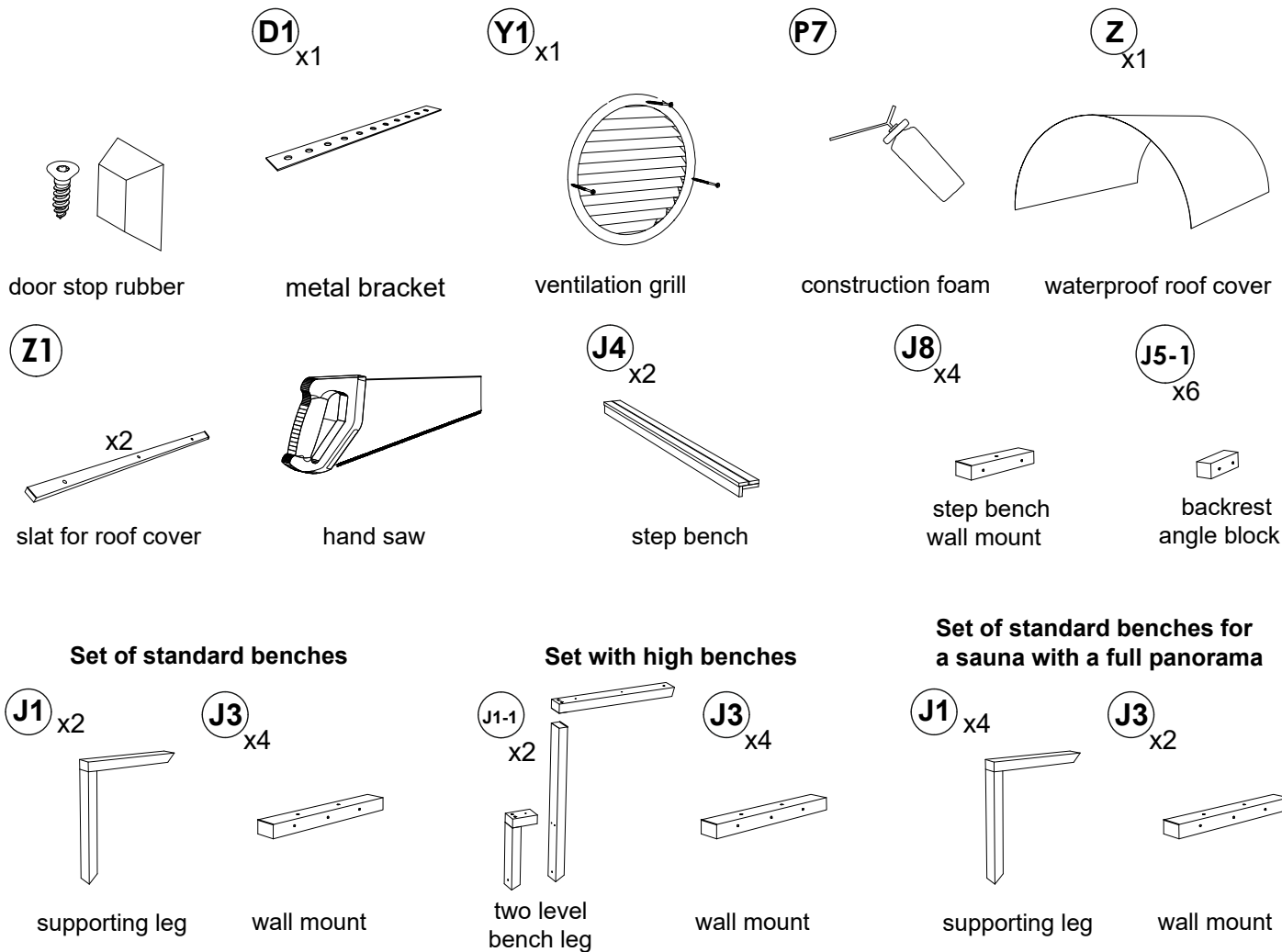
Concrete, pavers or crushed stone is preferred.

Check parts before construction.

# PART LIST



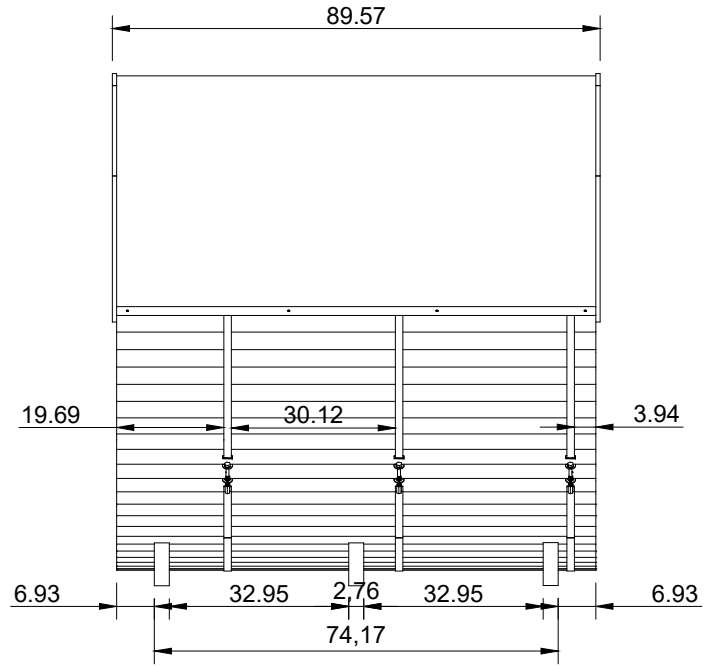
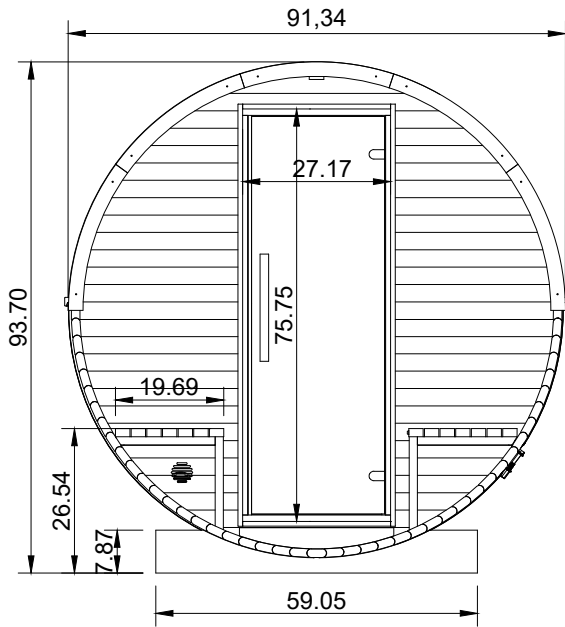
# PART LIST



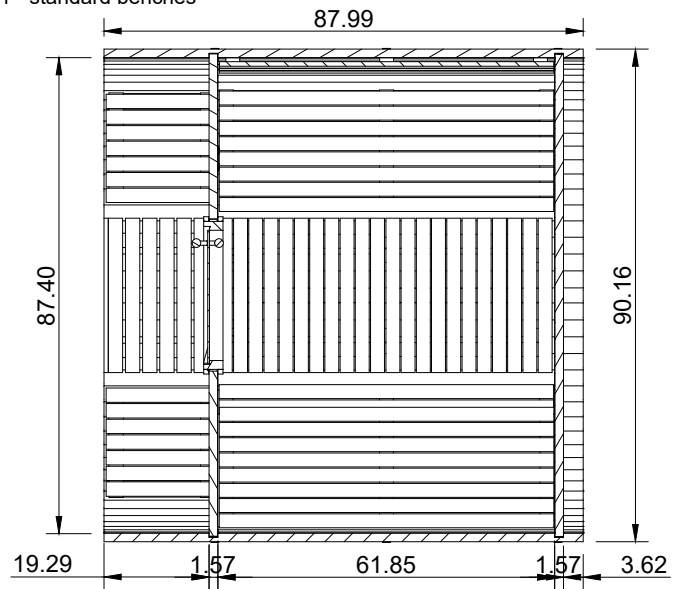
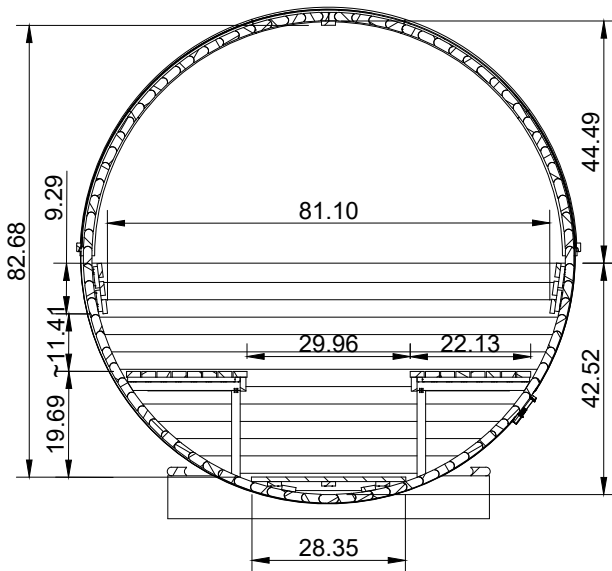
## Steel screws

Article	Size,mm	Screws kind	Total quantity, pc
S1	5.0x100	steel	60
S2	4.0x70	stainless	12
S4	5.0x120	steel	11
S5	4.0x50	steel	52
S6	5.0x70	stainless	42
S7	4.2x55	steel	35
S10	4.0x60	steel	135
S11	4.0x40	stainless	12
S14	5.0x80	steel	10
S16	4.0x60	stainless	22

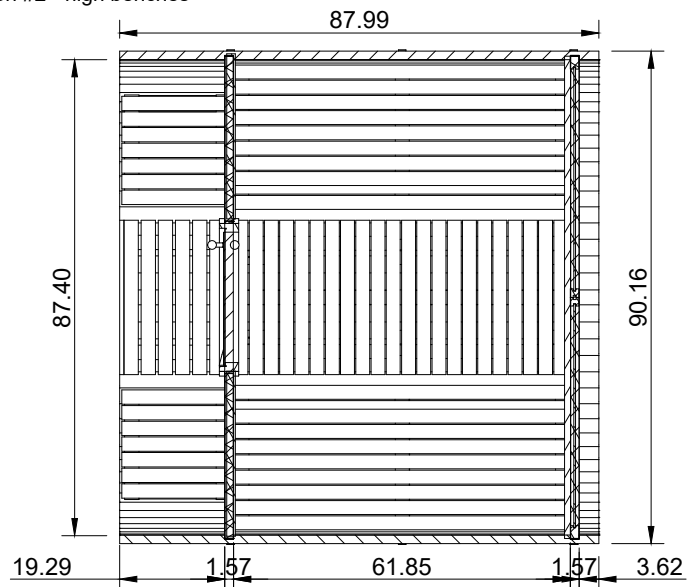
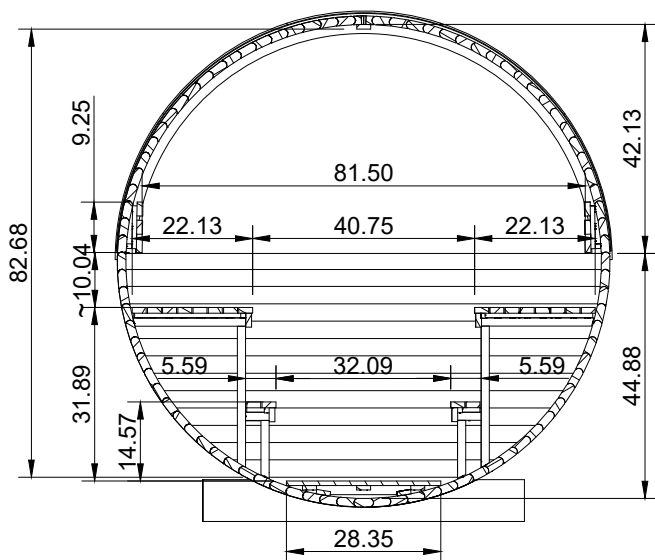
## Barrel dimensions



### Interior option #1 - standard benches

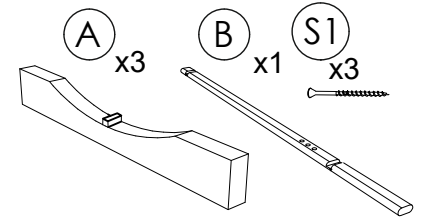
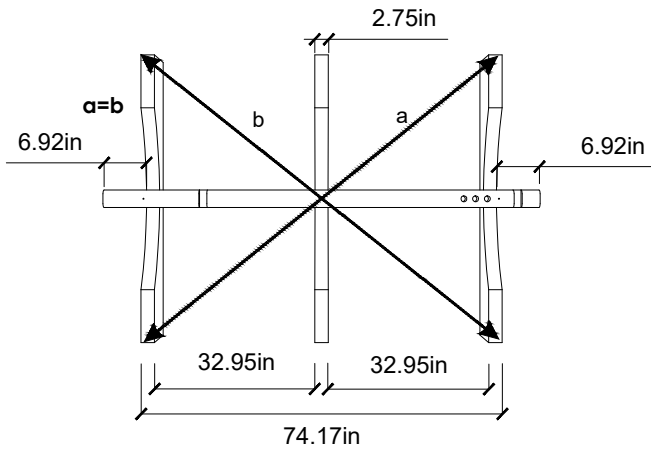


### Interior option #2 - high benches

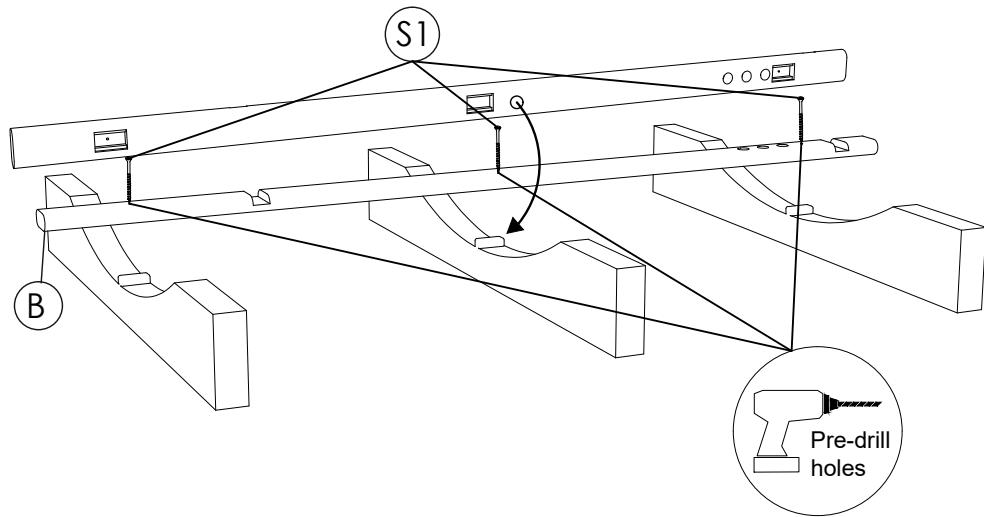
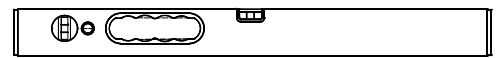


The dimensions on the drawings are informative, rounded values. Units of measurement - inches.

**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.

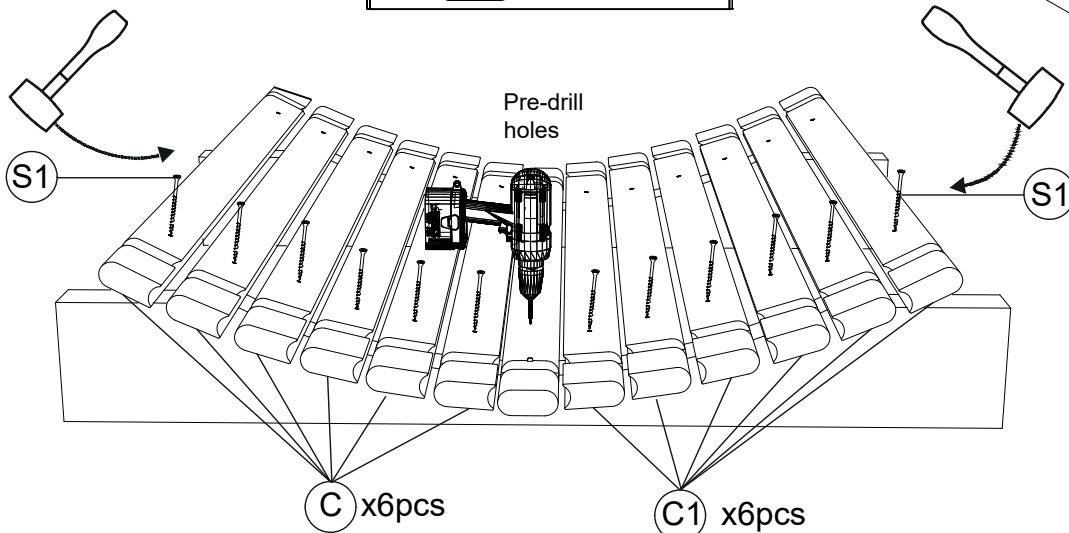
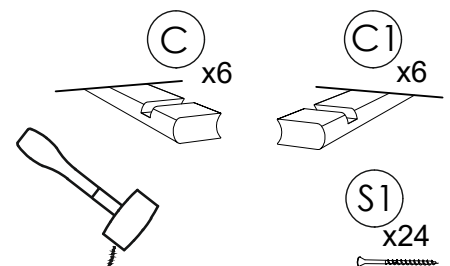


**NB!** use a level

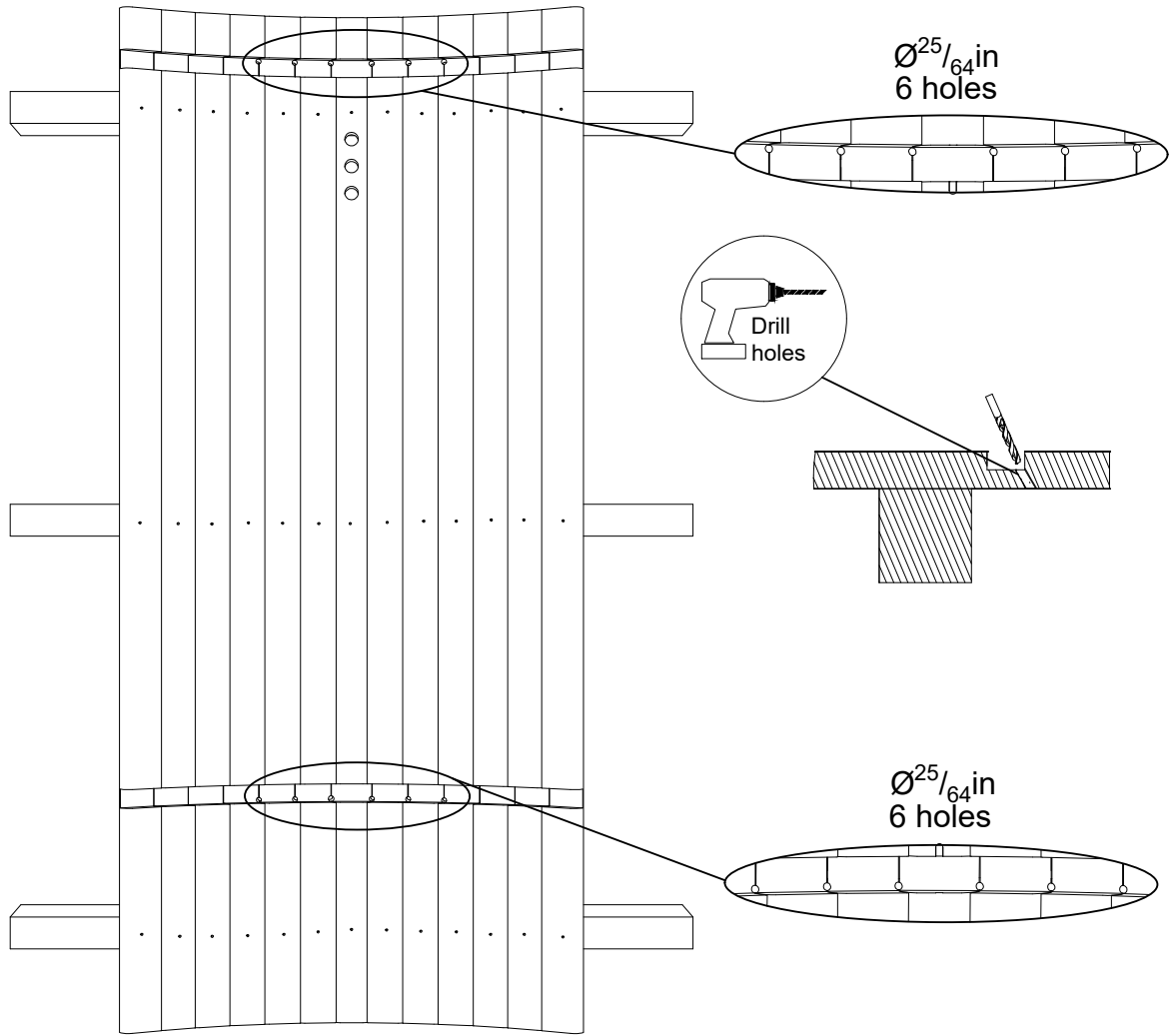


**STEP 2:** Pre-drill holes before fix staves with screws. Place 6 sauna body staves (C) to each side of the center stave (B) and fix with screws (S1). Be sure to align the panel groove on every next body stave, to do that use rubber hammer.

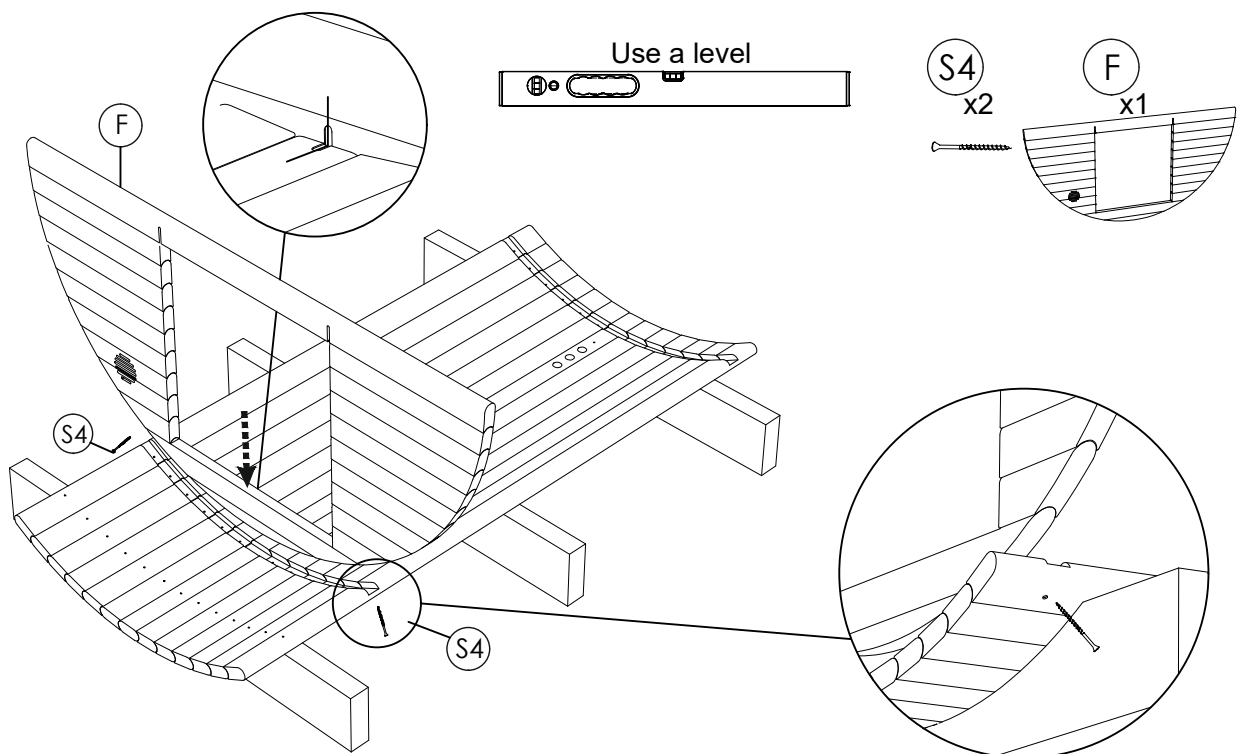
Use a level



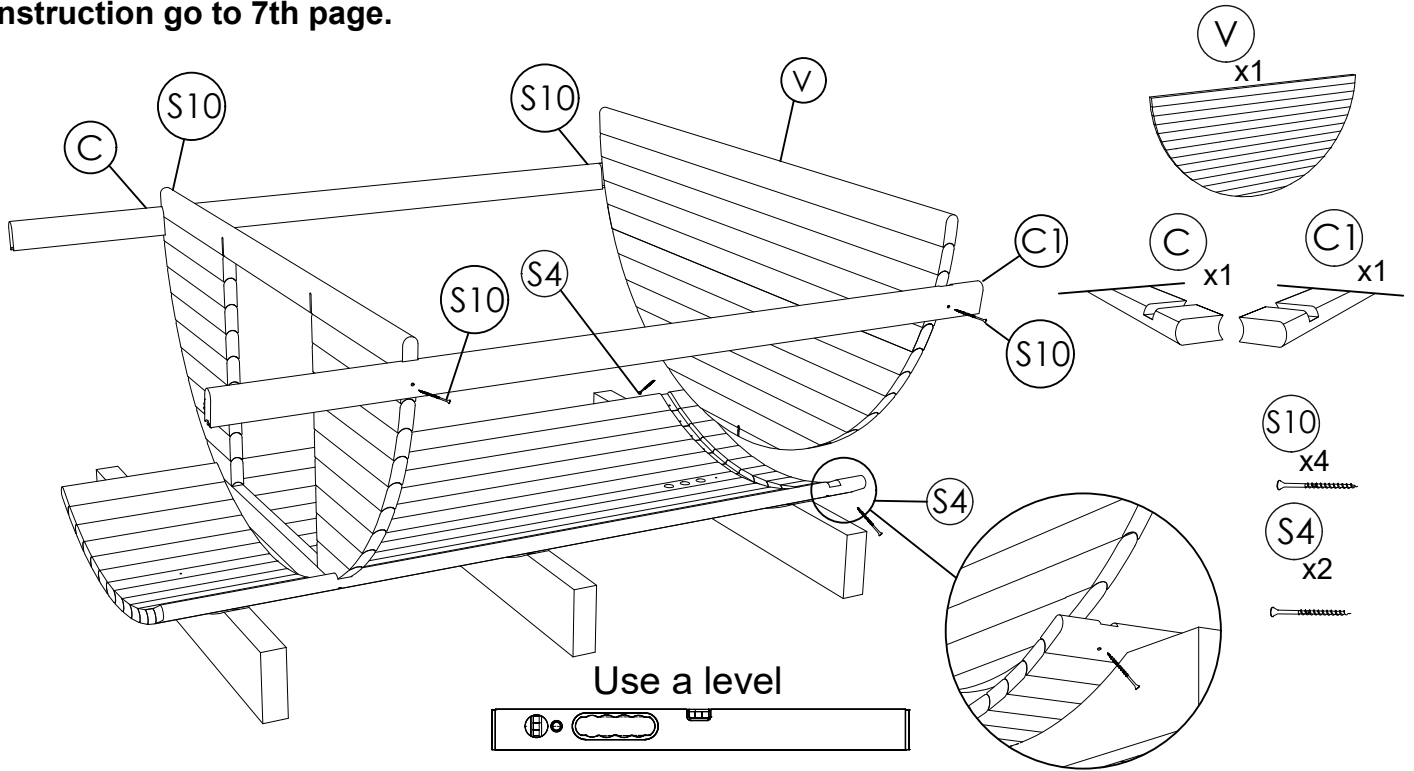
**STEP3:** Drill six  $\frac{25}{64}$ in holes in front and back wall groove to the out-side in board connections as shown in the picture.



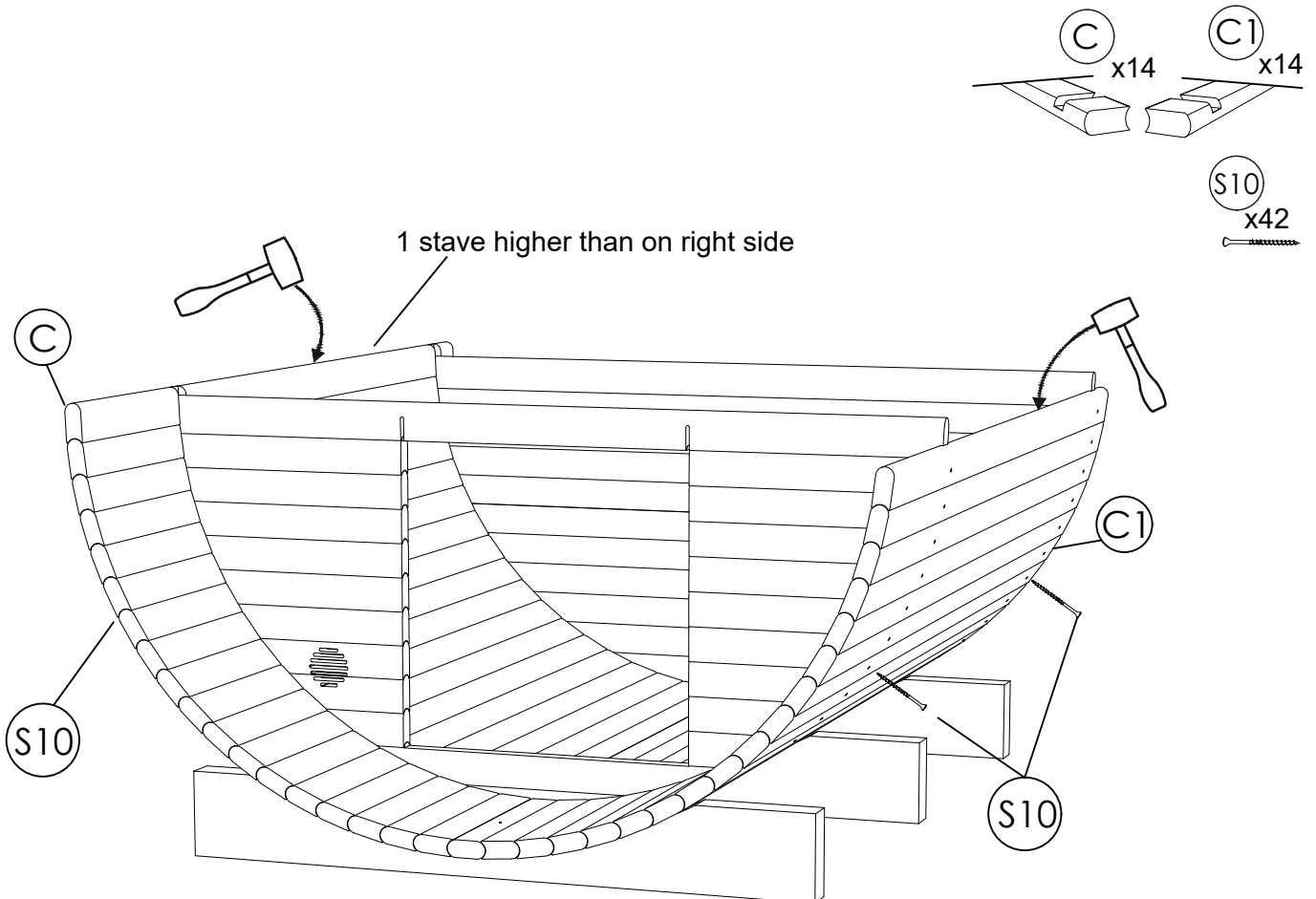
**STEP 4:** Place front bottom panel (F) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides.



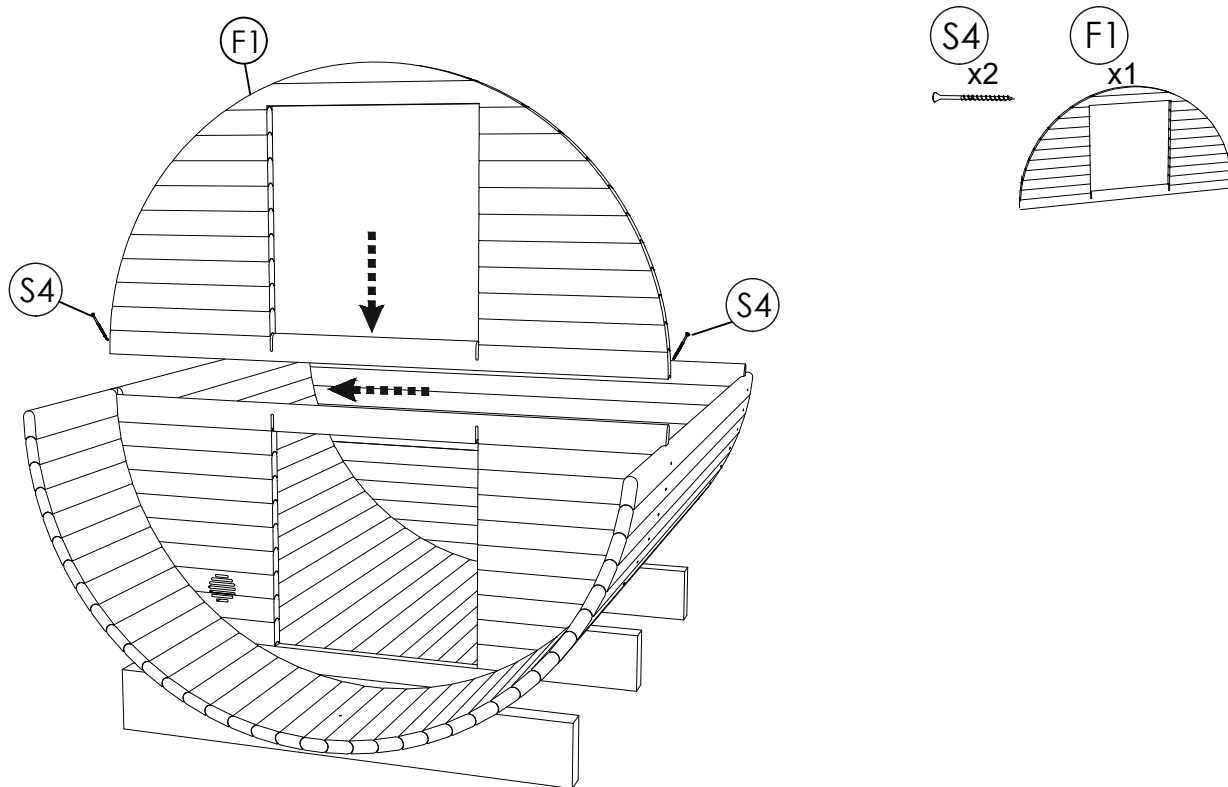
**STEP 5:** Place rear panel (V) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides. **For full panoramic instruction go to 7th page.**



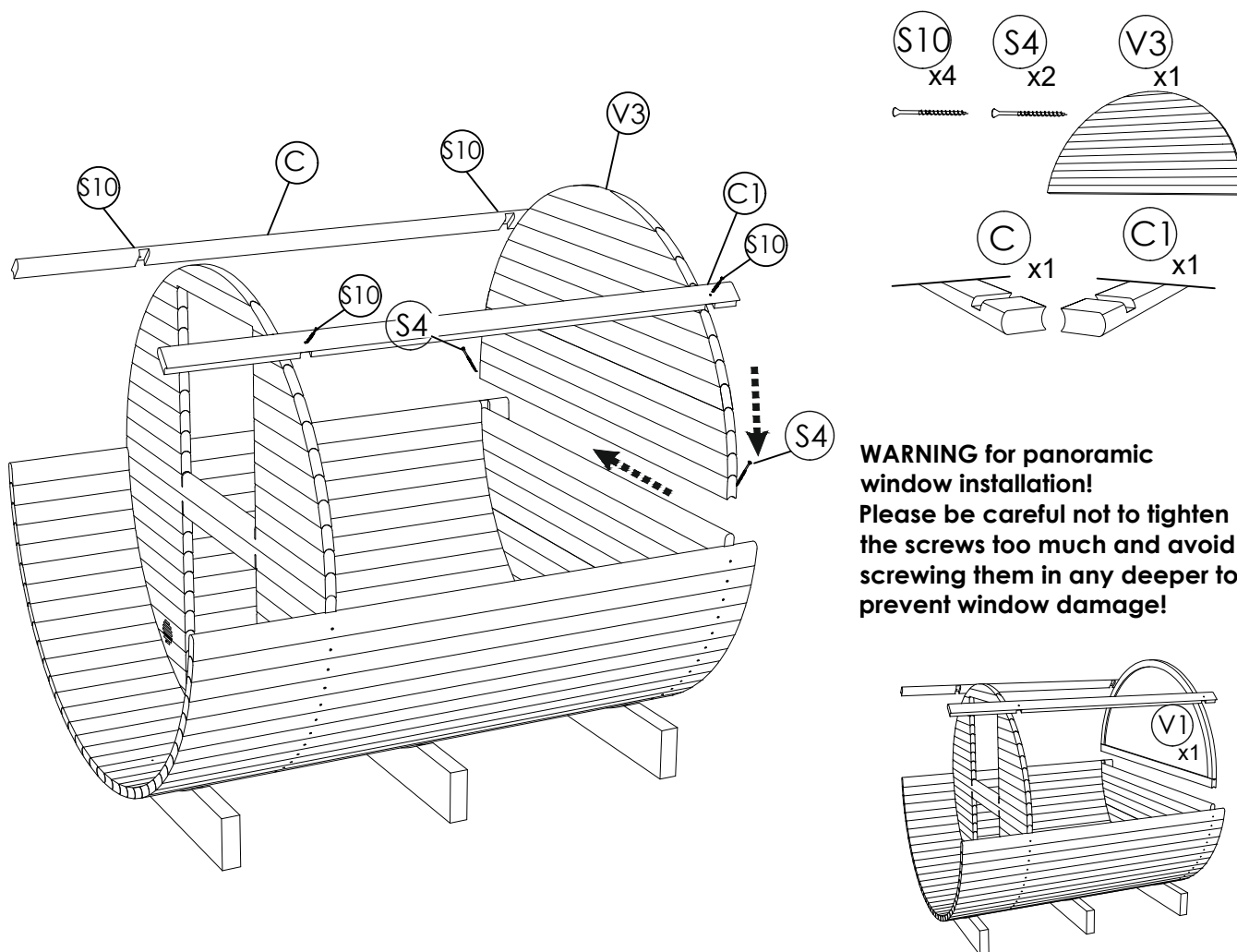
**STEP 6:** Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10) . Fix one stave higher on left side than at right.



**STEP 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.

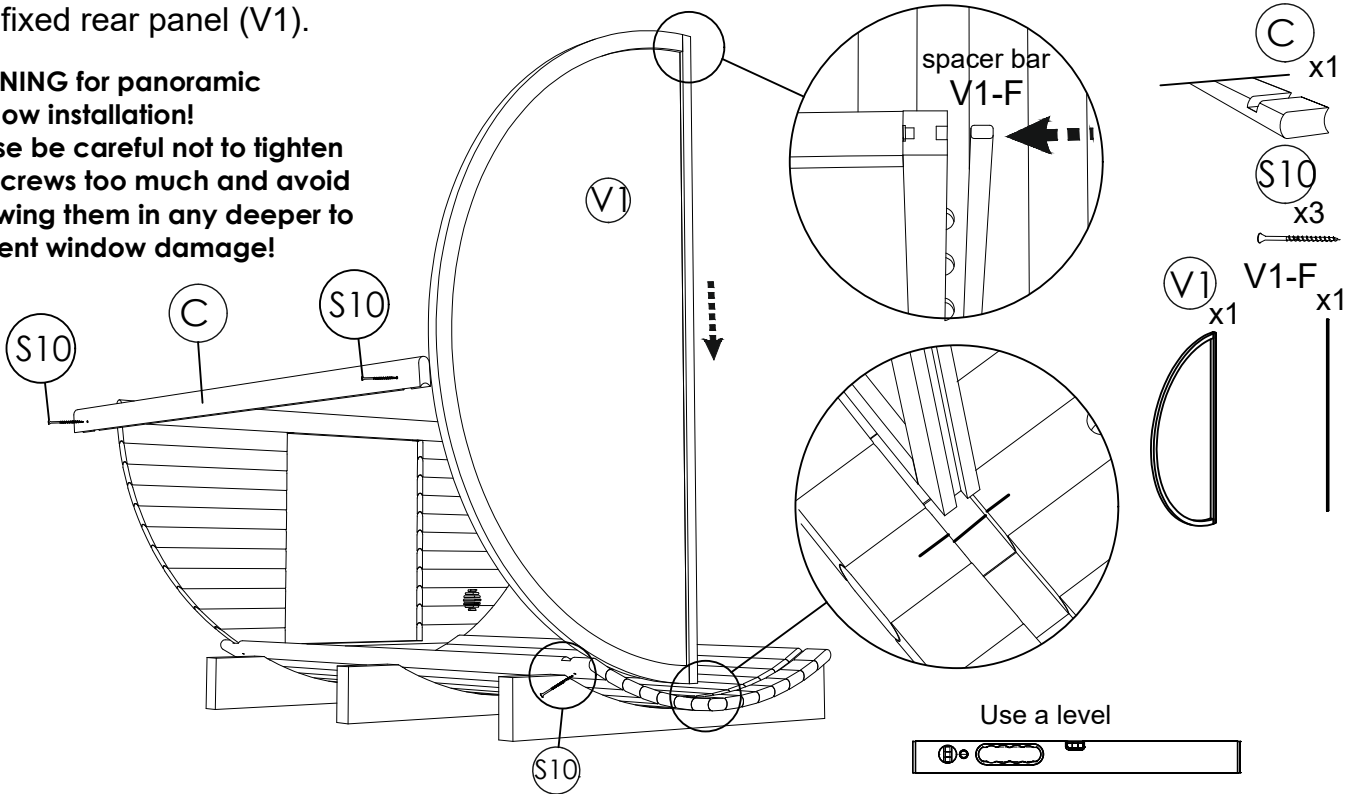


**STEP 8:** Take the upper rear panel (V3 or V1-panoramic window) and place it on the bottom rear panel (V). Secure it by using 2 screws (S4). Connect the panels (F2; V3) together by placing one body staves (C) both sides where you can reach, with (S10) screws.

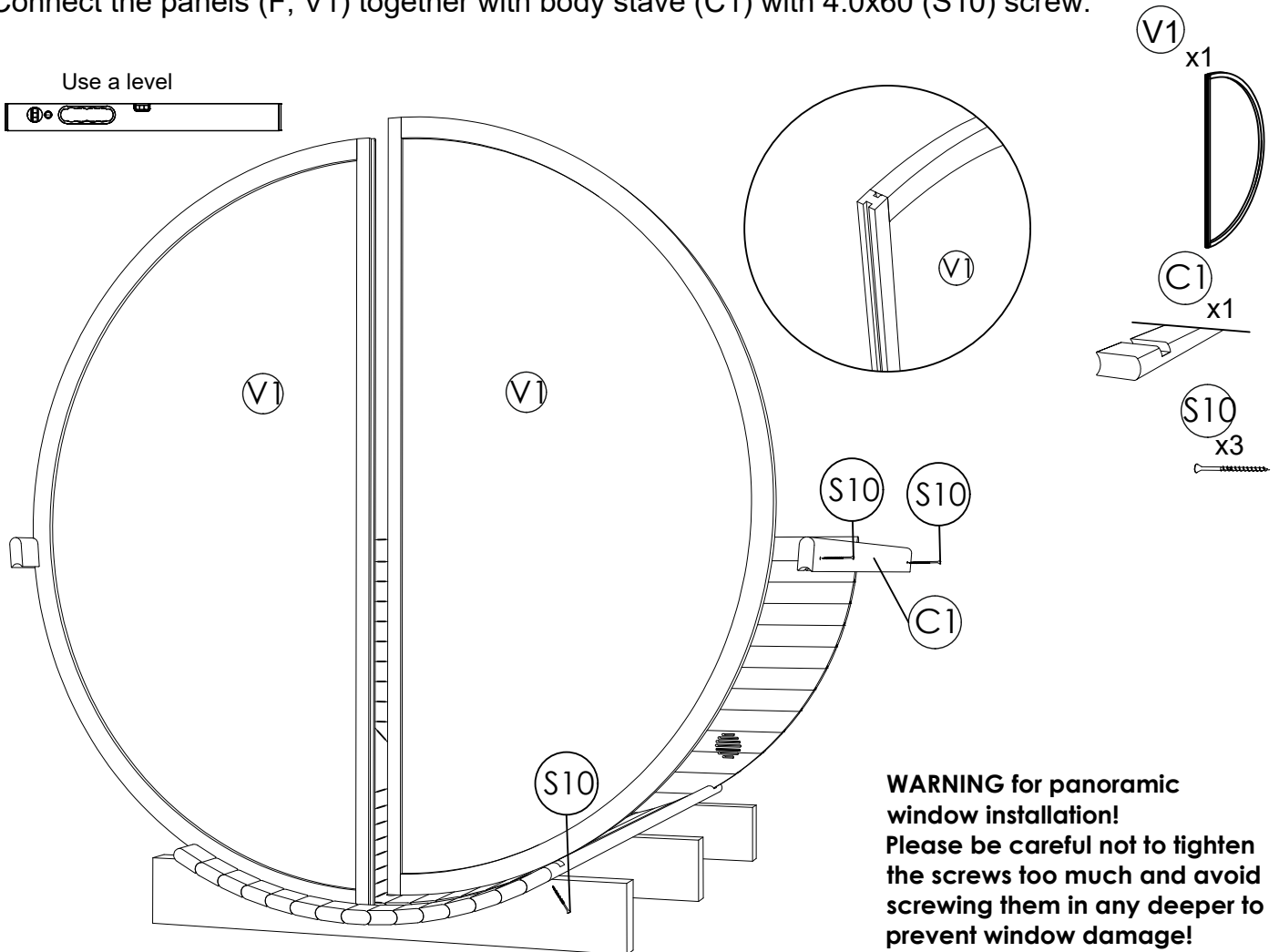


**STEP 5.1:** Place rear panel (V1) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using 4.0 x 60 (S10) screw through last floor stave. Connect the panels (F; V1) together with body stave (C) with 4.0x60 (S10) screw. Insert wood spacer bar (V1-F) in to the fixed rear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

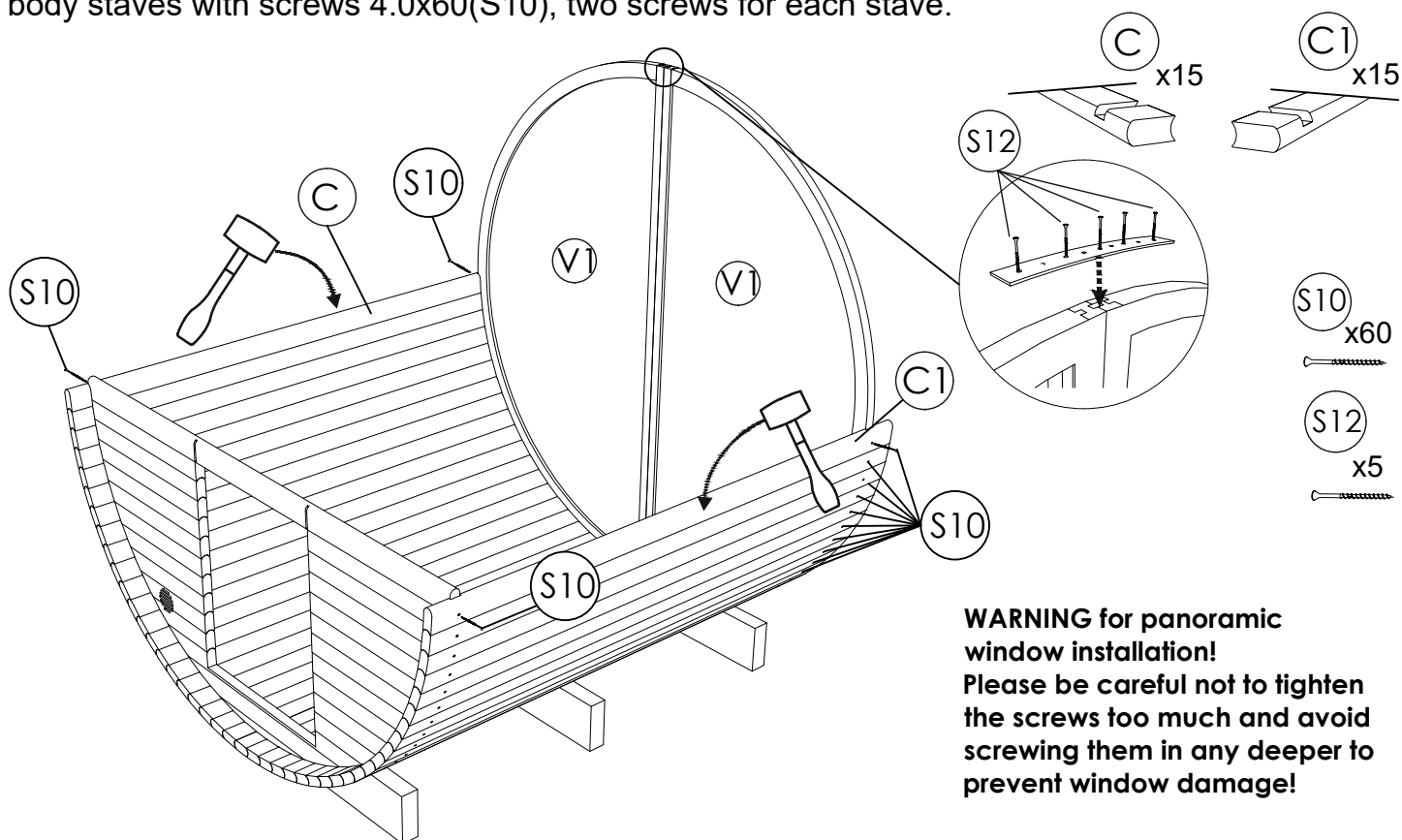


**STEP 5.2:** Place second rear panel (V1) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using 4.0 x 60 (S10) screw through last floor stave. Connect the panels (F; V1) together with body stave (C1) with 4.0x60 (S10) screw.



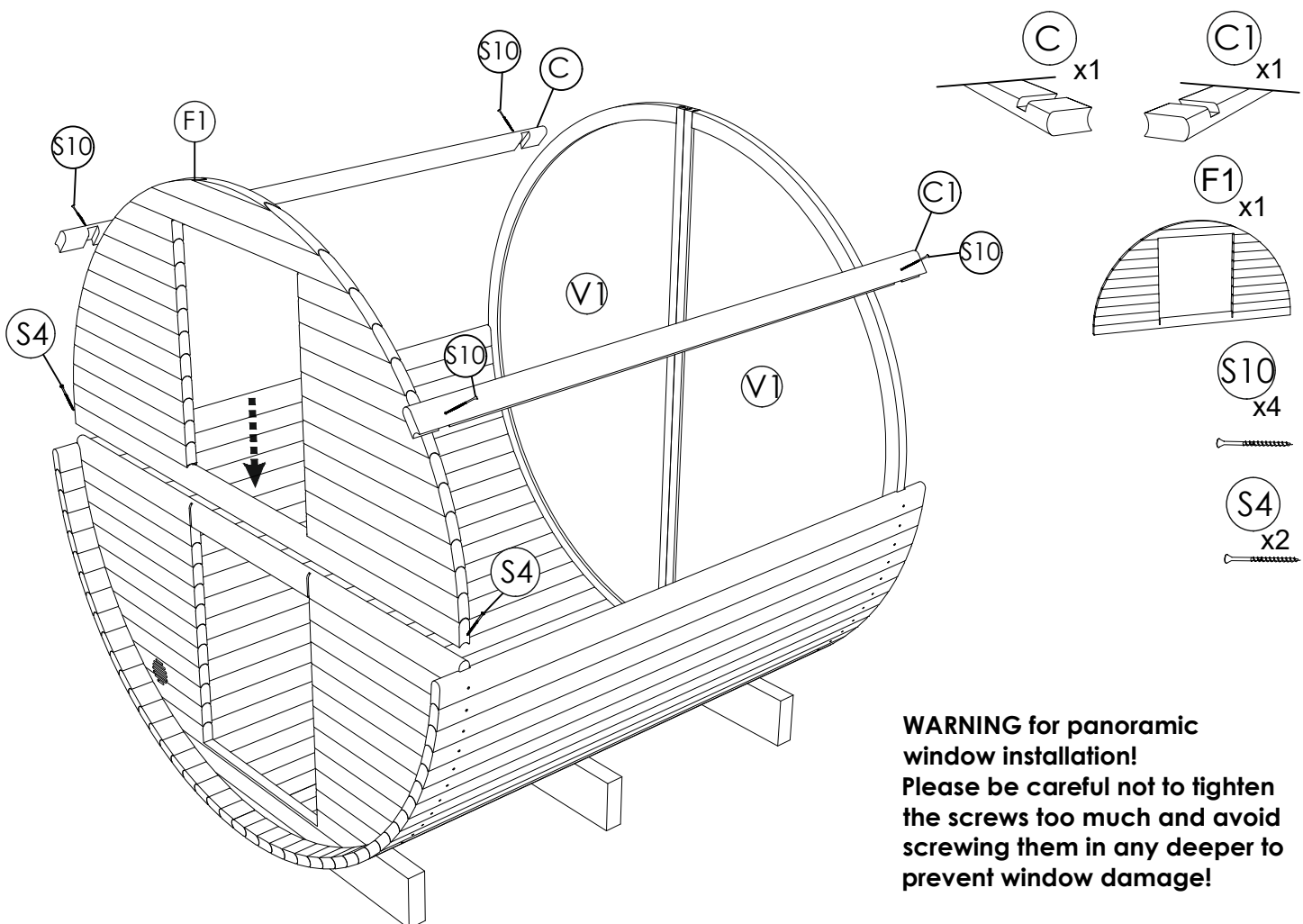
**WARNING for panoramic window installation!**  
Please be careful not to tighten the screws too much and avoid screwing them in any deeper to prevent window damage!

**STEP 5.3:** Fix assembly tape with five 4x30 screws (S12) to fix both panels together. Continue placing body staves (C), (C1) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws 4.0x60(S10), two screws for each staff.



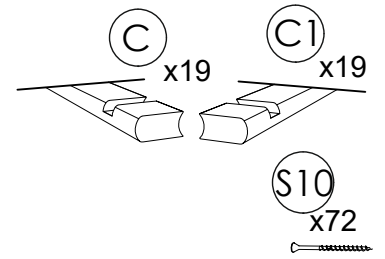
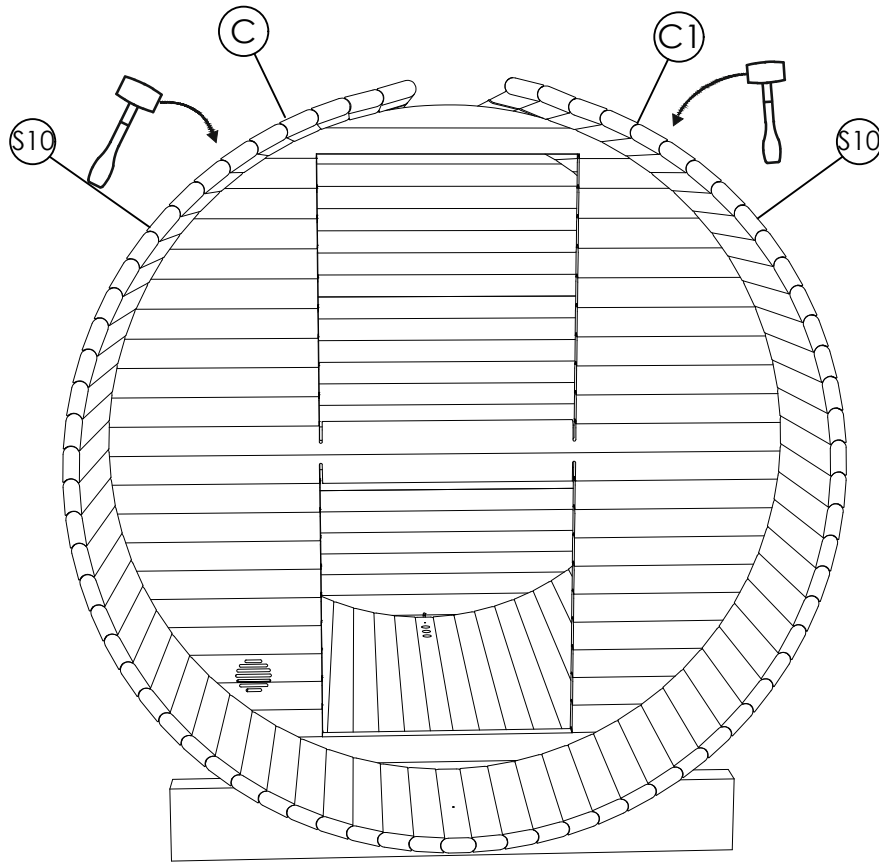
**WARNING for panoramic window installation!**  
Please be careful not to tighten the screws too much and avoid screwing them in any deeper to prevent window damage!

**STEP 5.4:** 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.

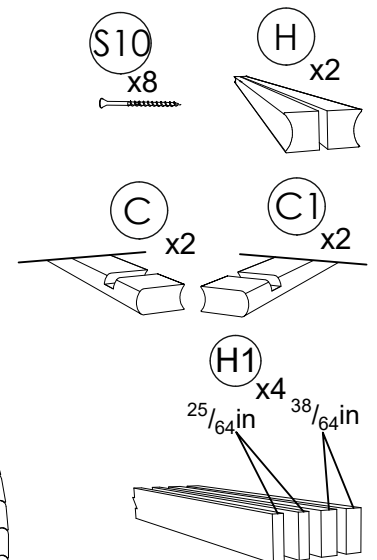
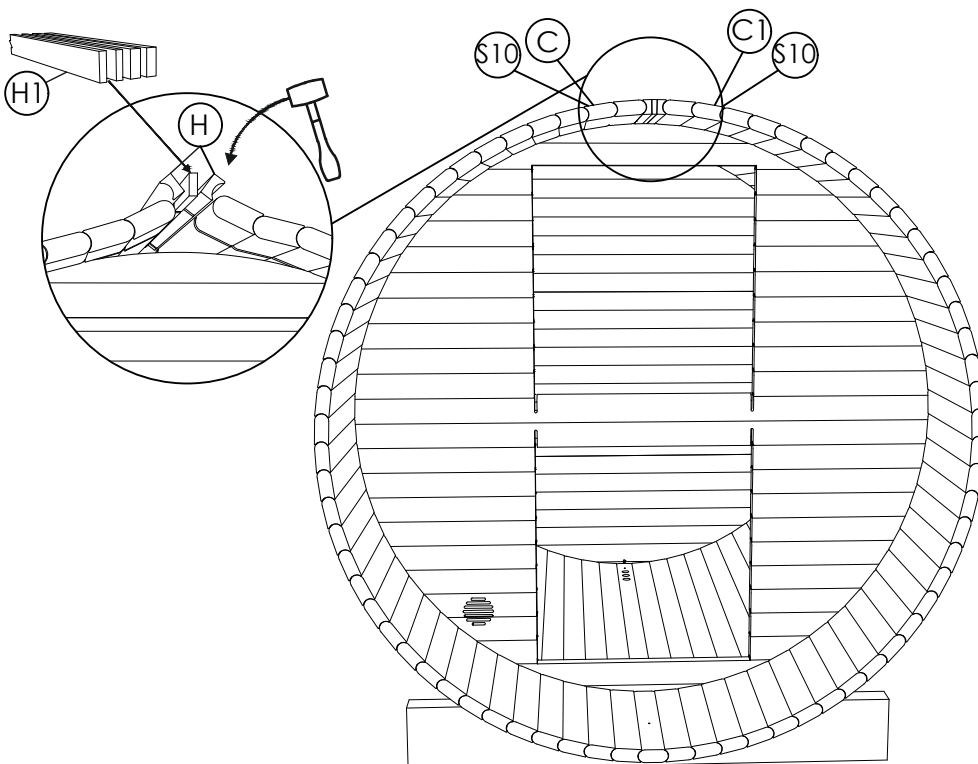


**WARNING for panoramic window installation!**  
Please be careful not to tighten the screws too much and avoid screwing them in any deeper to prevent window damage!

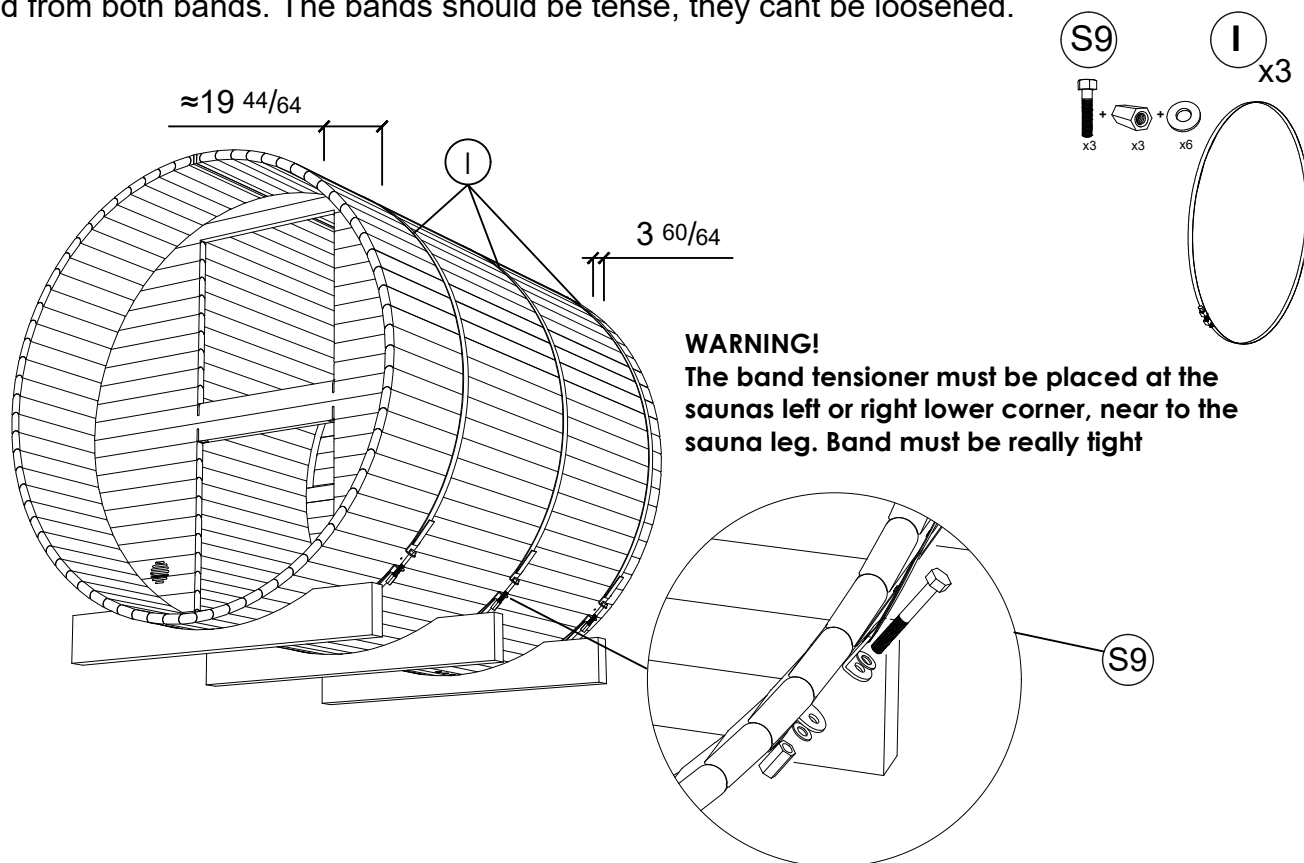
**STEP 9:** Continue placing body staves (C), (C1) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10).



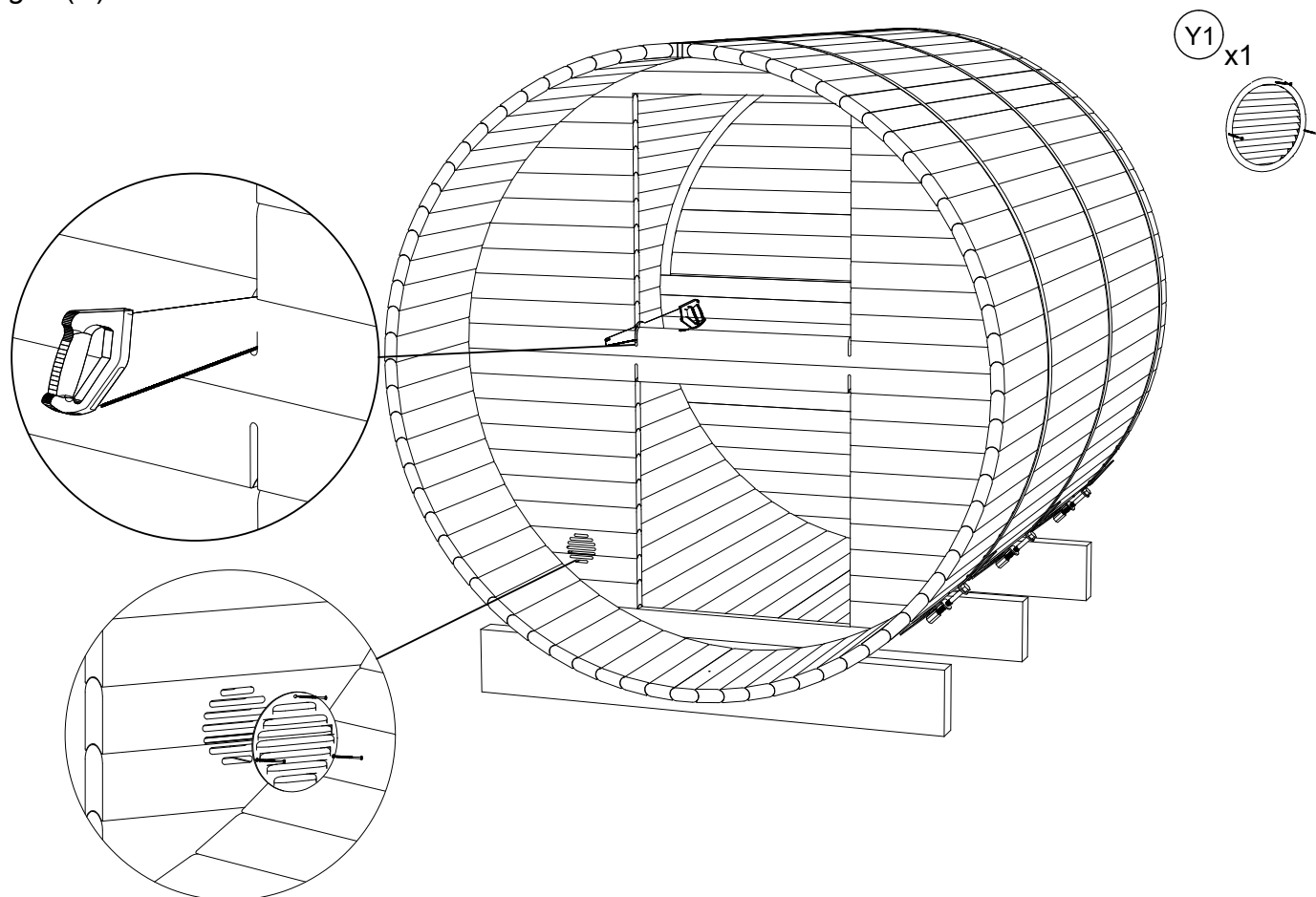
**STEP 10:** To finish the roof top joint, don't screw about last 3 boards (C), (C1) to each side, use roof finishing item (H). Different thickness filling pieces (H1) are provided to completely fill the gap. Once necessary parts are in, fix last boards with screws.



**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  $3 \frac{60}{64}$ 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.

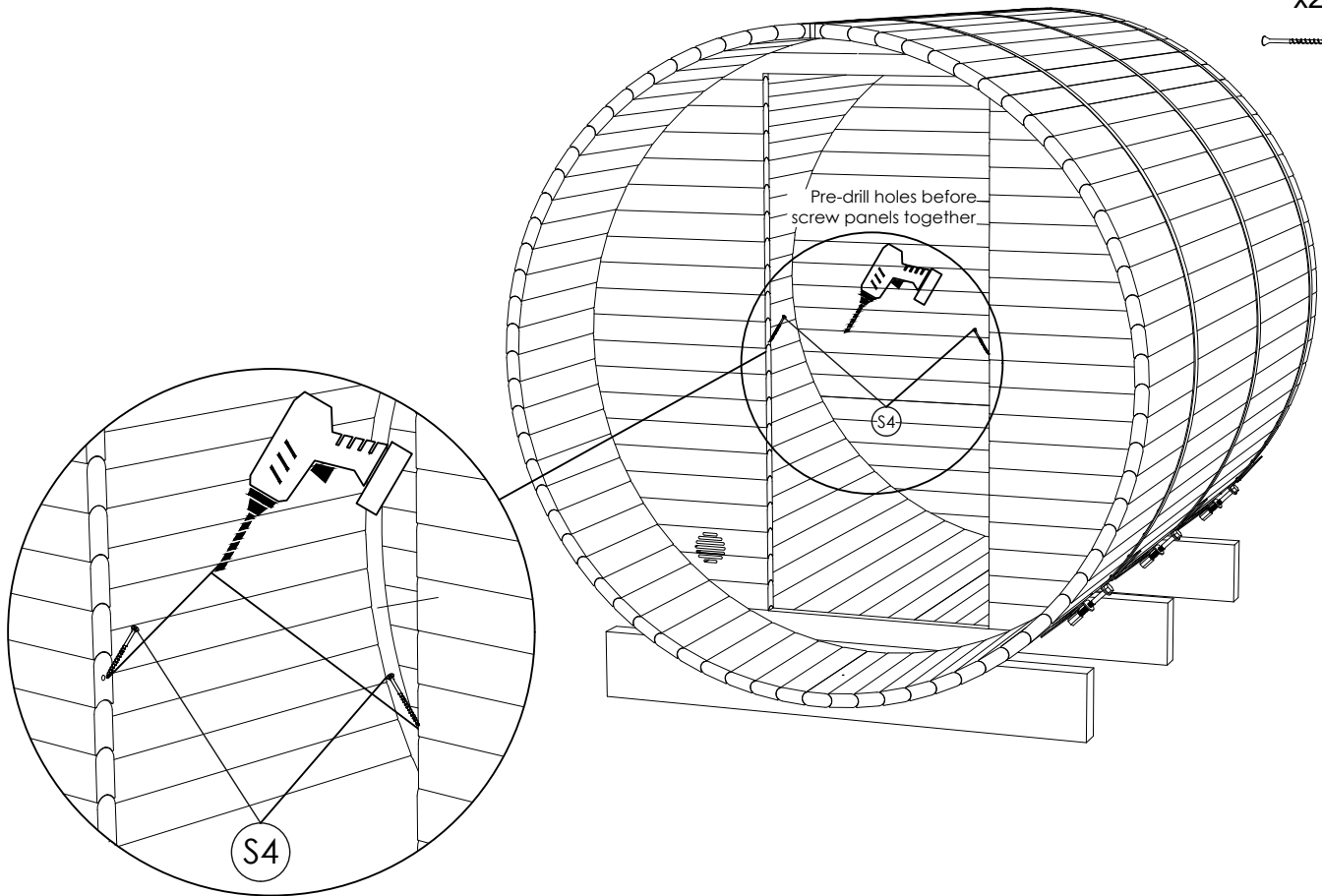


**STEP 12:** Draw straight line to connect both cuts. Use hand saw or other cutting machine to saw out excess boards for door box. It's recommended to saw out boards from inside. Fix ventilation grill (Y) from inside on ventilation cuts.



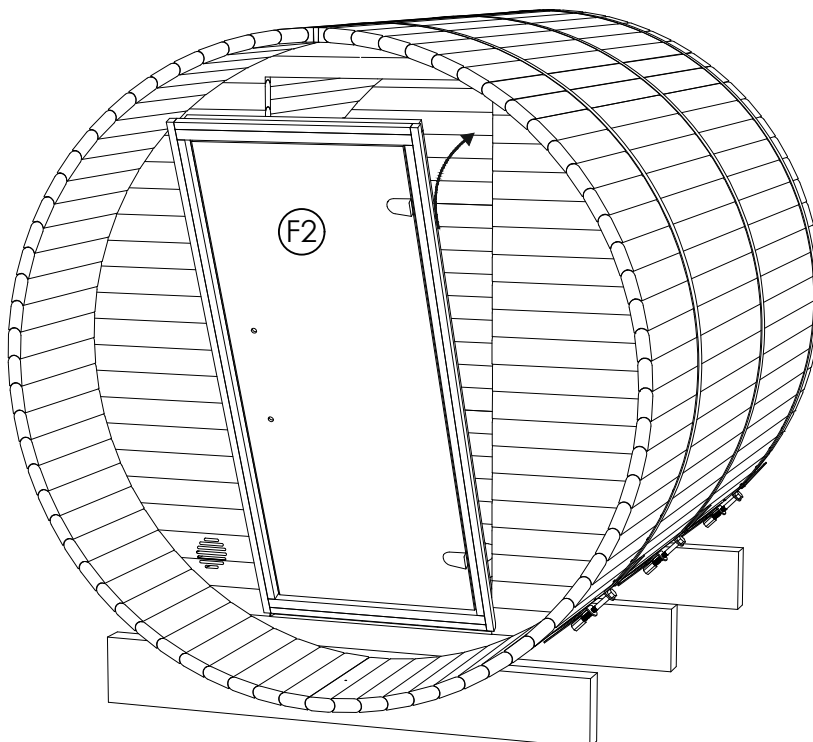
**STEP 13:** Pre-drill holes for screws. Fix both panels together using (S4) screws.

(S4)  
x2

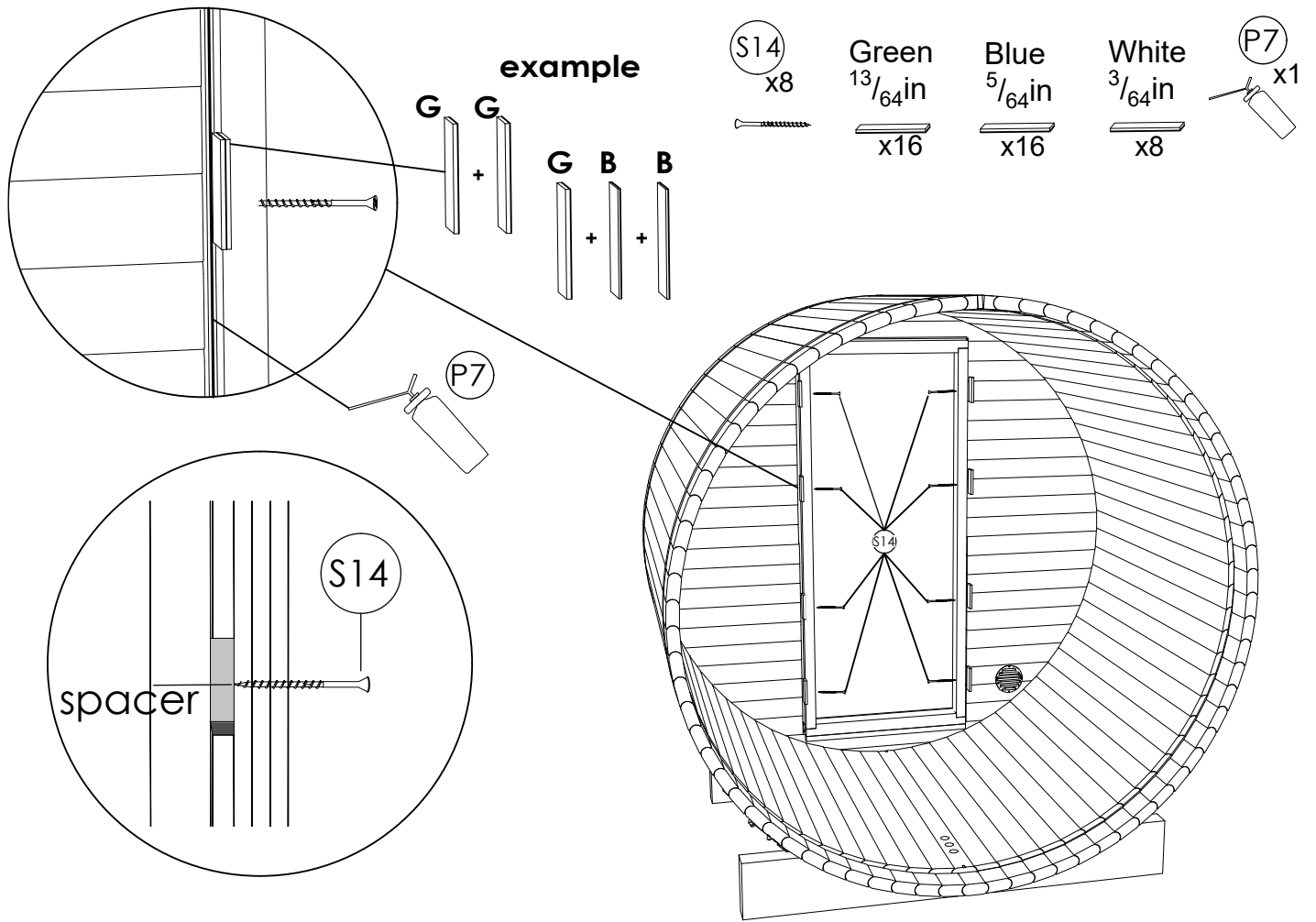


**STEP 14:** Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.

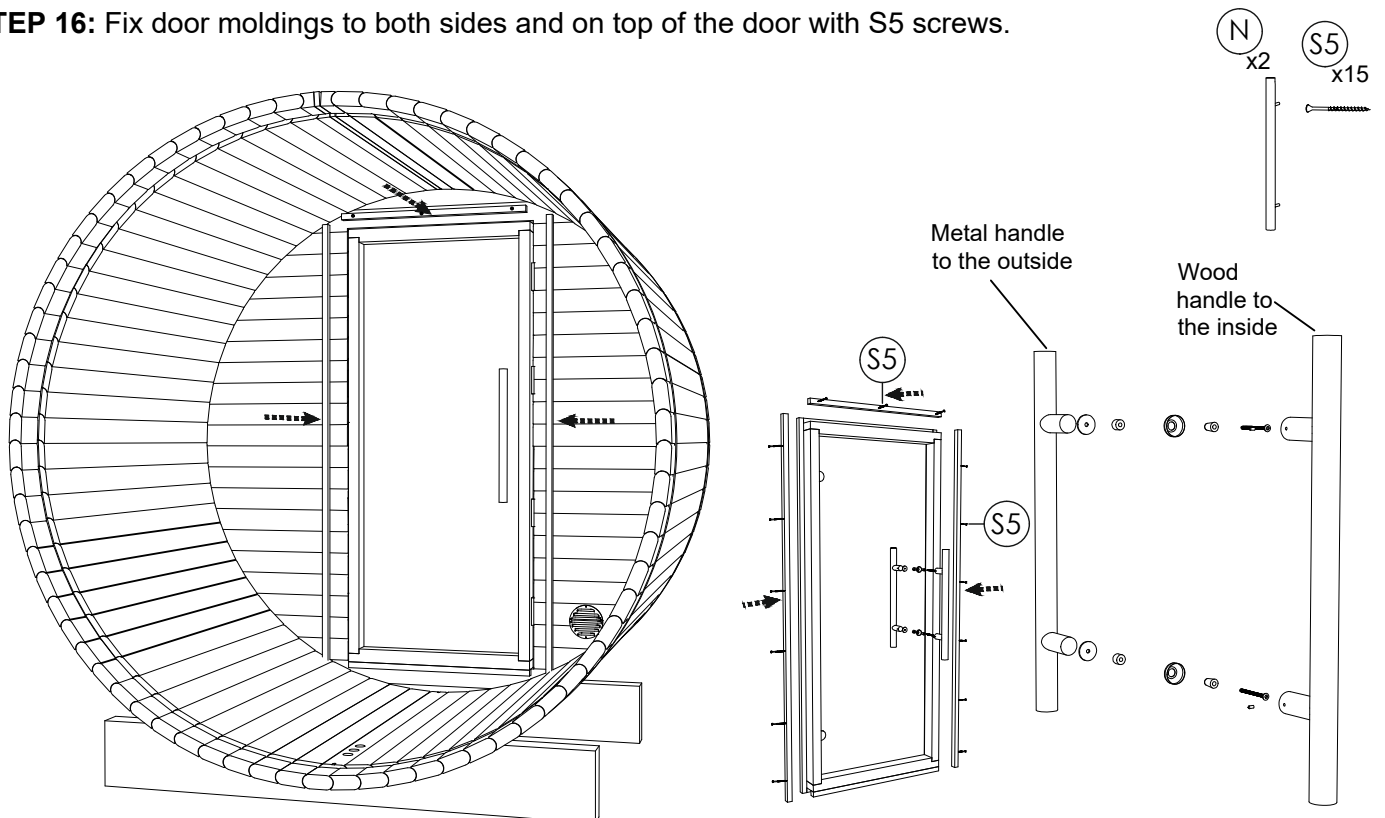
(F2)  
x1



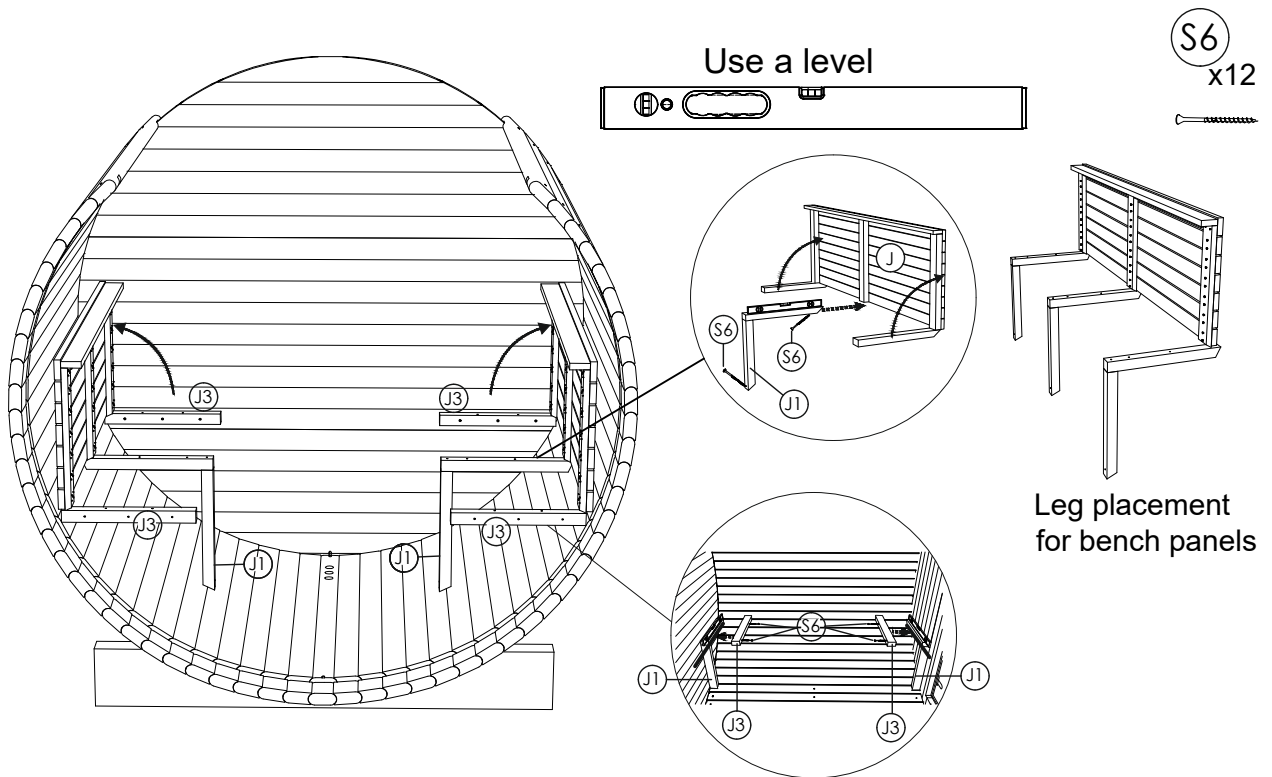
**STEP 15:** Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. First, fix one side of the door box with screws (S14) through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly,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



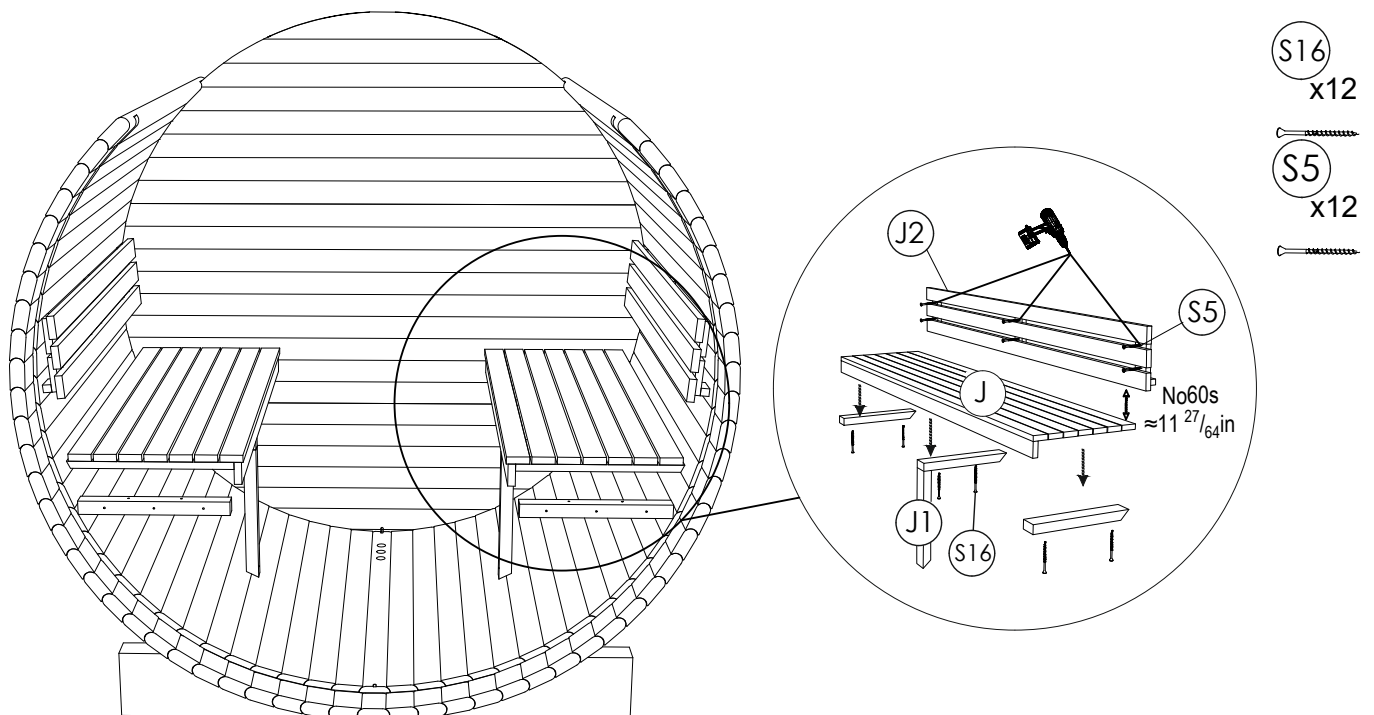
**STEP 16:** Fix door moldings to both sides and on top of the door with S5 screws.



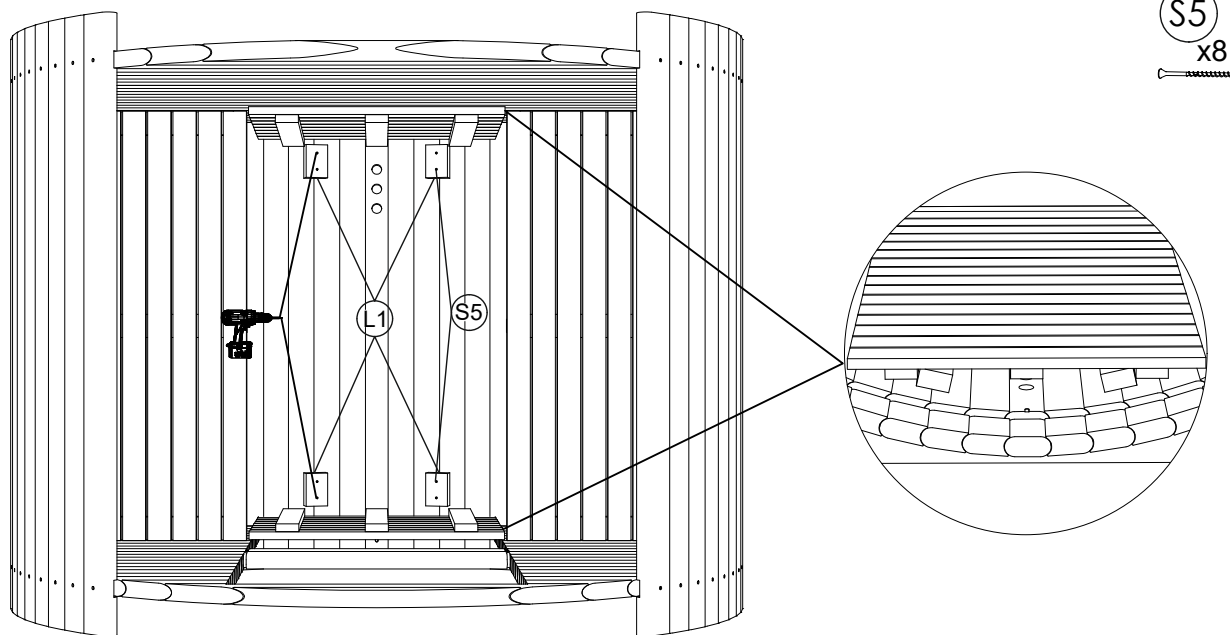
**STEP 17:** To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, mark a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall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



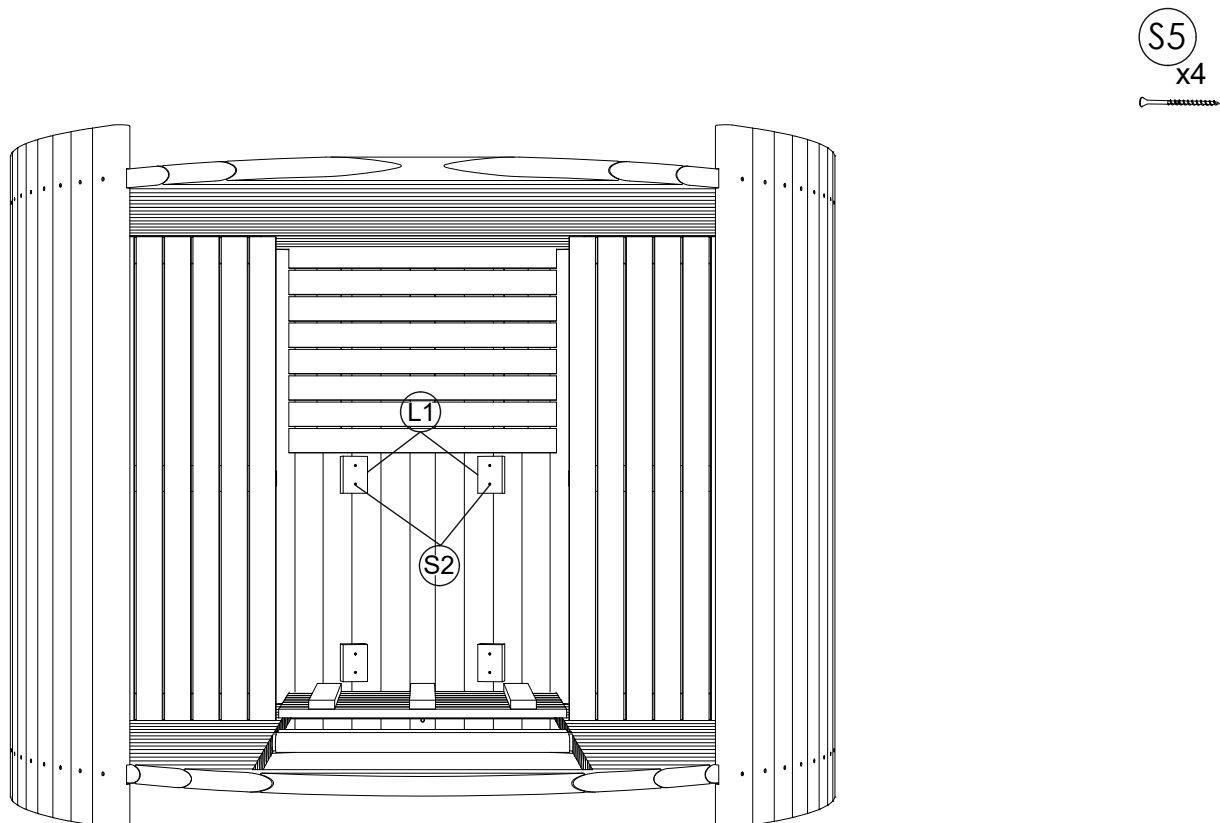
**STEP 18:** Pre-drill holes before fix backrest with screws, install backrests (J2) using screw (S2). Fix sauna bench (J) to wall mounts and support leg using (S16) screws. Fix bench panel (if ordered) with screws (S5).



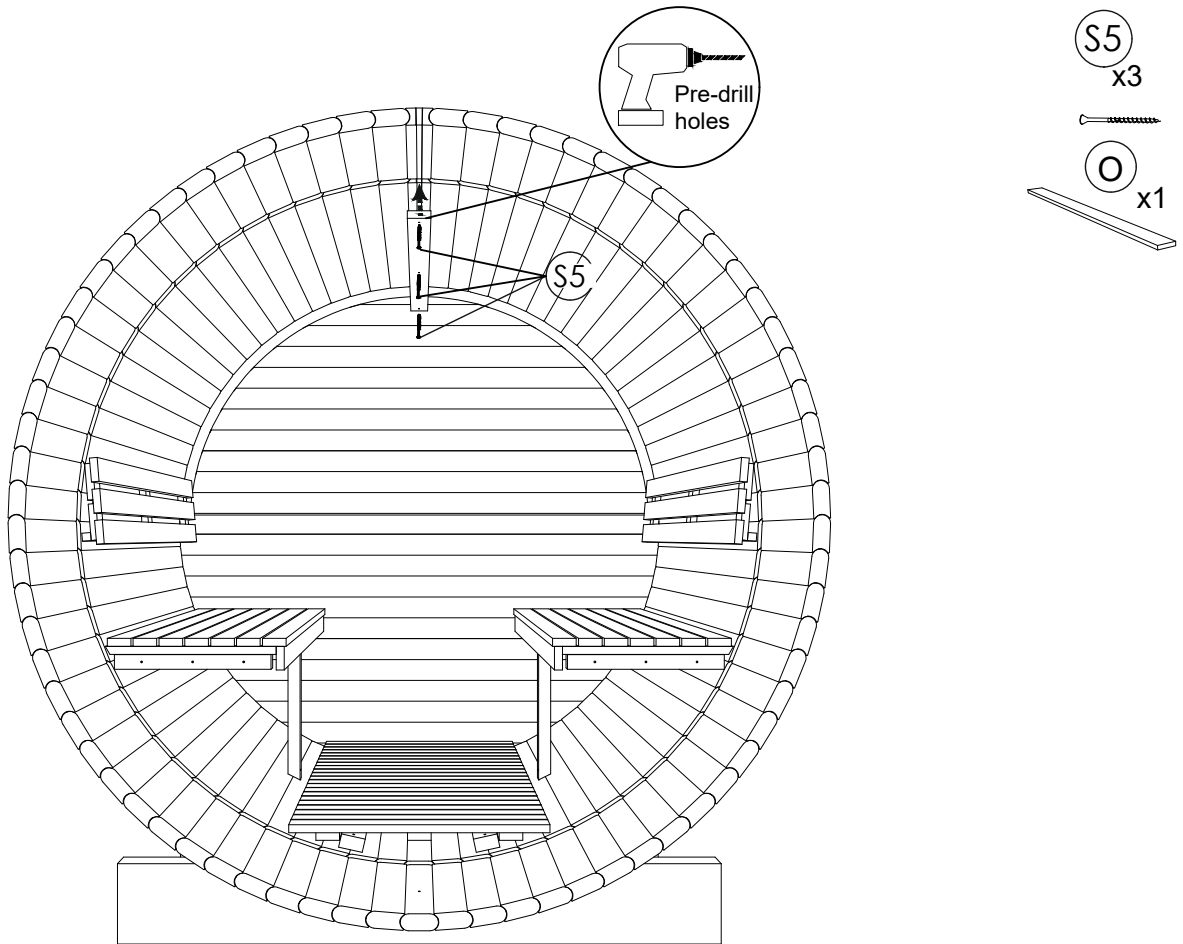
**STEP 19:** Place floor duckboards (L) to the both sides upwards and place fixing blocks next to the flooring cross boards. Pre-drill holes before fix with screws, install fixing blocks (L1) using screw or (S5).



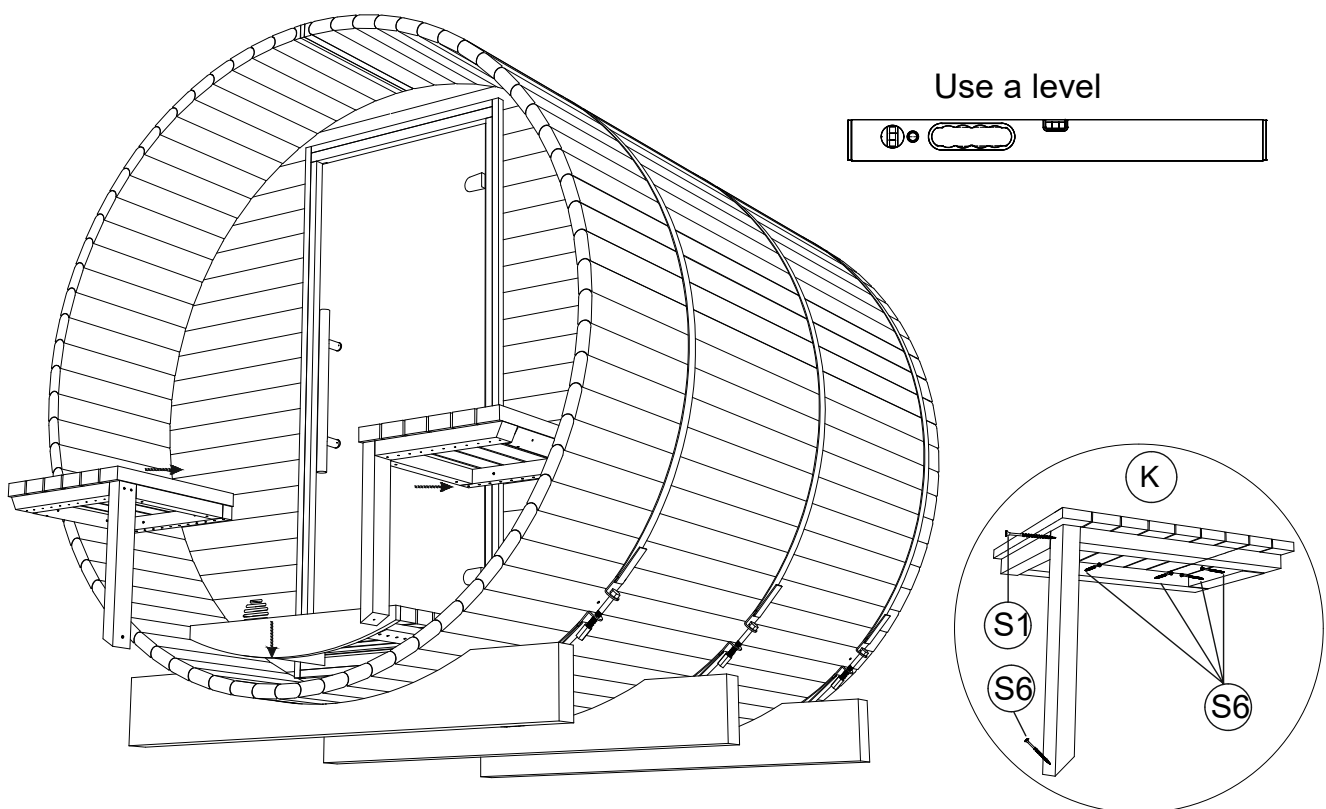
**STEP 20:** Pre-drill holes before fix with screws, install fixing blocks (L1) under floor duckboard using screw (S5). Place floor duckboards (L) on the floor and fix fixing blocks next to both flooring crossboards.



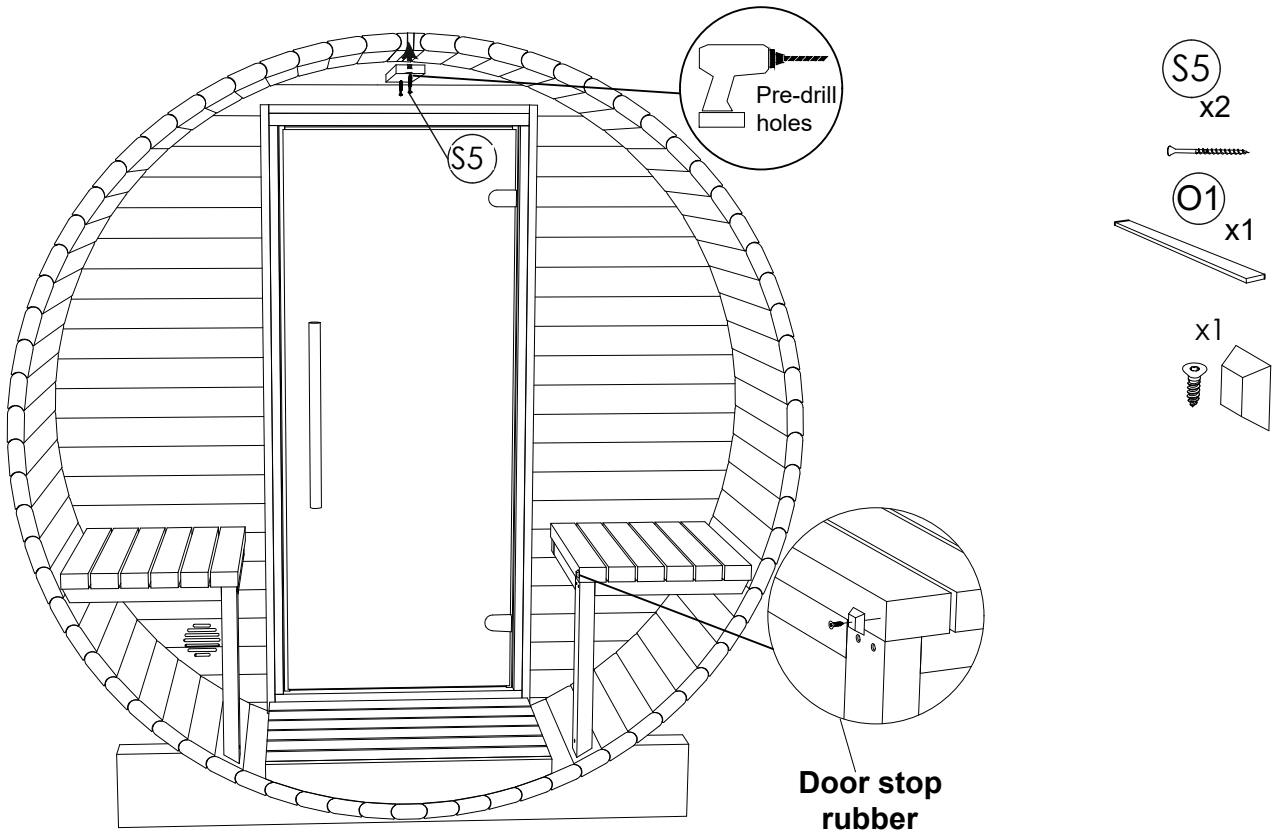
**STEP 21:** Pre-drill holes before fix stave with screws, install interior roof trim (O) in sauna with (S5) screws.



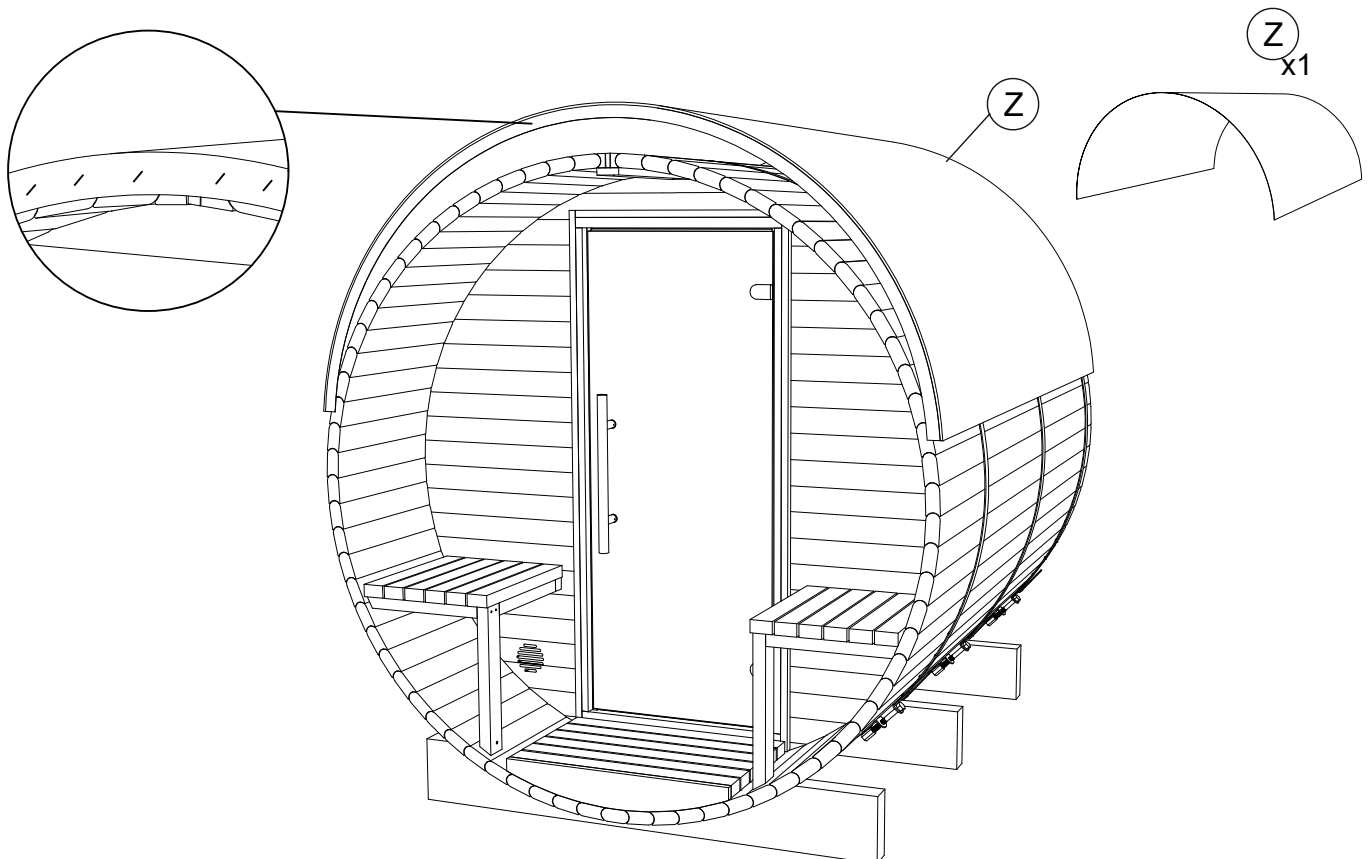
**STEP 22:** Install front and rear decorative roof finishing boards (W), fixing by screws (S7). Install porch benches (K), using screws (S6) and (S1). Hold the seat and leg assembly tight to the sauna wall. Using a level, make sure the bench seat is level from front to back. This will ensure proper placement.



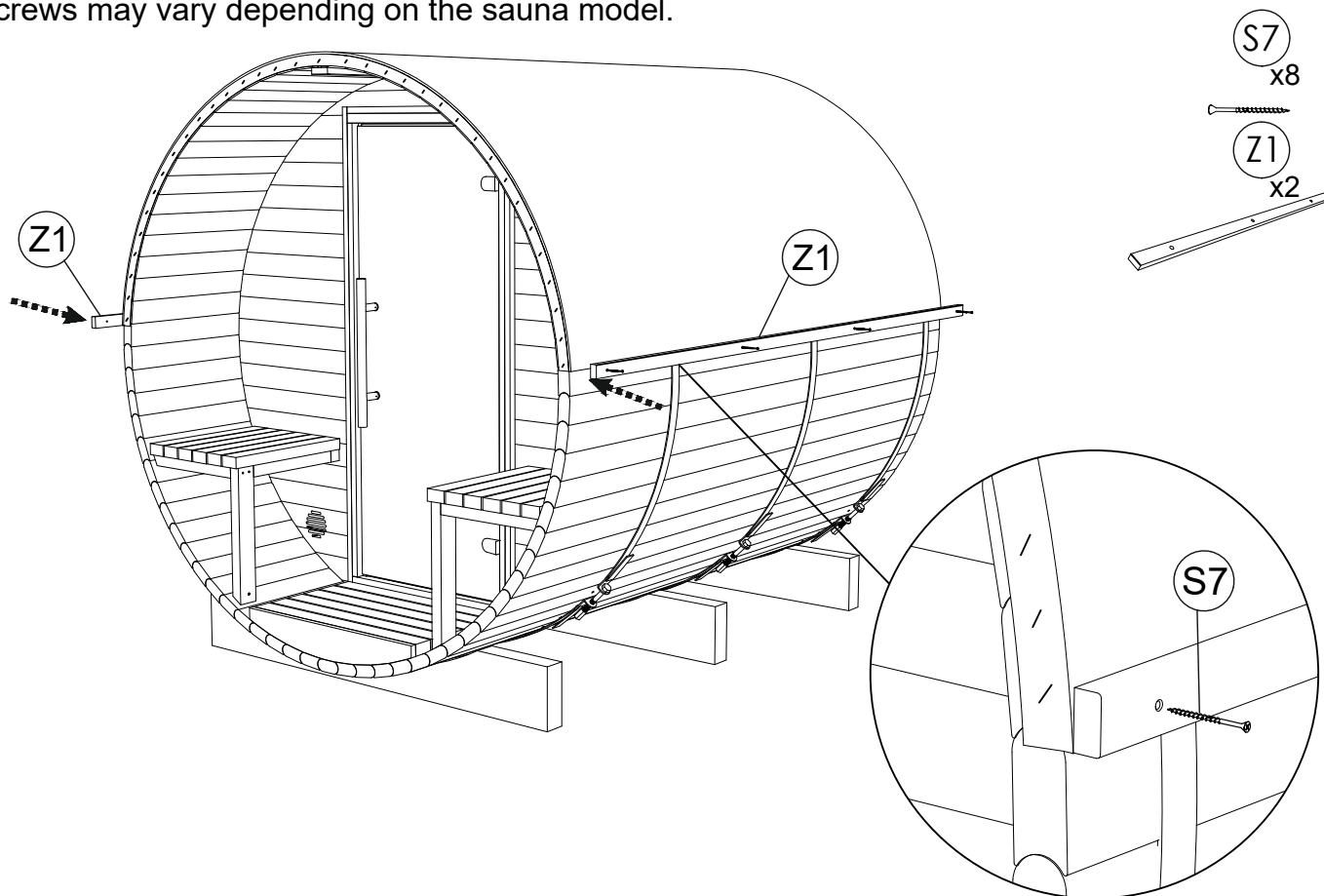
**STEP 23:** Pre-drill holes before fix stave with screws, install terrace roof trim (O1) in sauna with (S5) screws.



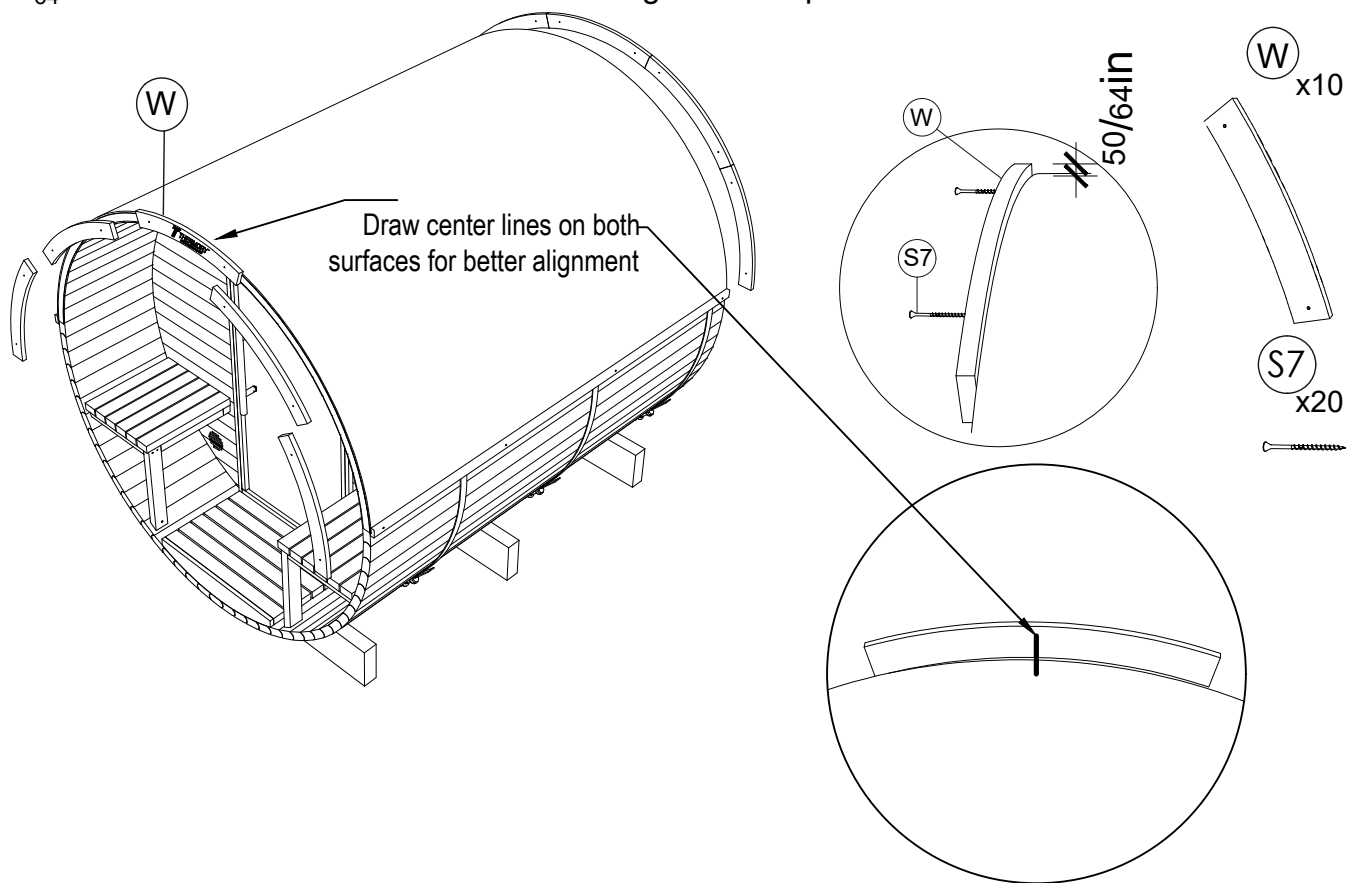
**STEP 24:** Place waterproof PVC roof cover . Align roof cover equally to both sides. Roof cover goes about  $1\frac{37}{64}$  over each sides edge. Staple roof cover on the saunas edge.



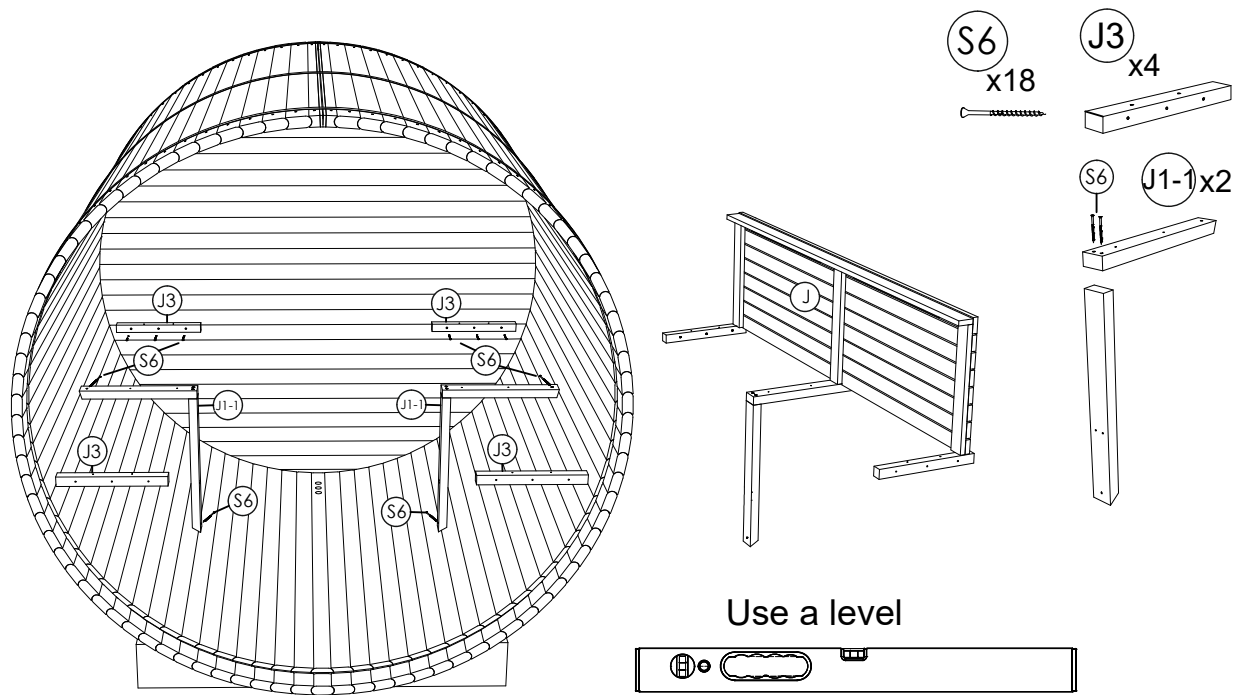
**STEP 25:** Fix wooden slats (Z1) with screws (S7) on the rain jacket bottom. The number of screws may vary depending on the sauna model.



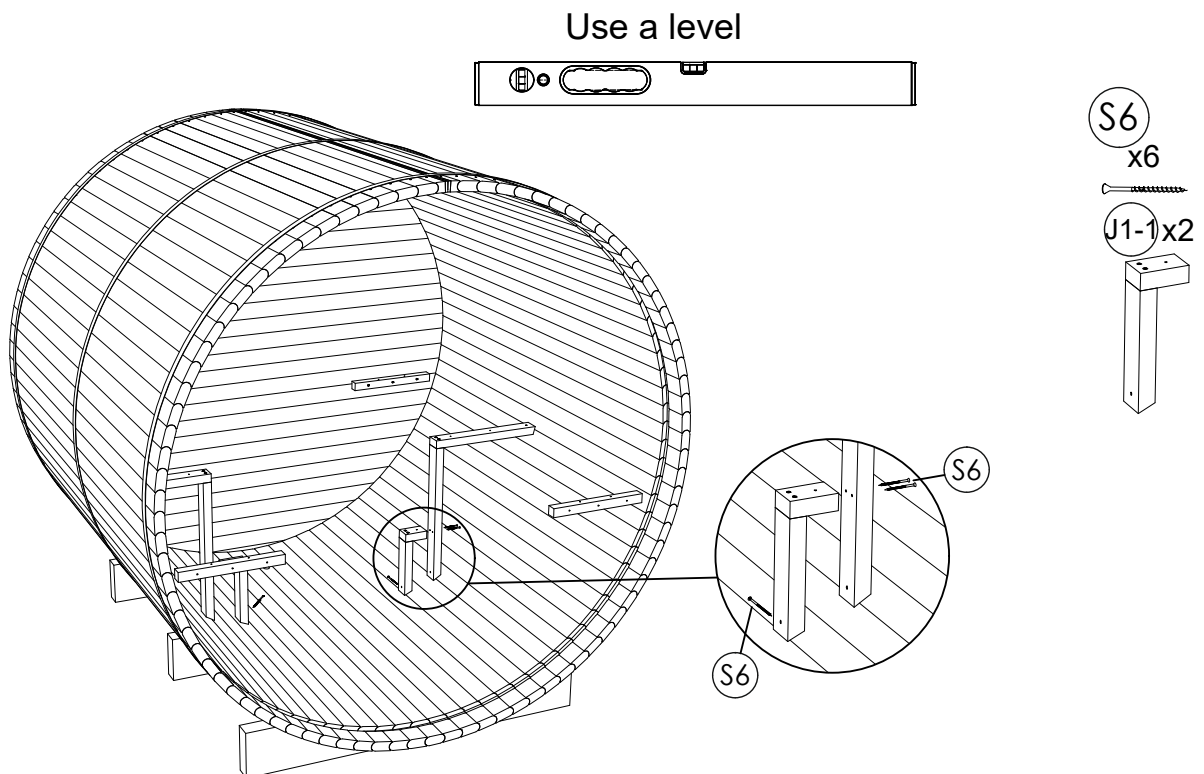
**STEP 26:** Install front and rear decorative roof finishing boards (W), fixing by screws (S7). Start with a center board placing it at the top of the middle of the sauna, approx.  $50/64$ in above roof or  $13/64$ in under the roof. Then fix next boards right next to previous board.



**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.

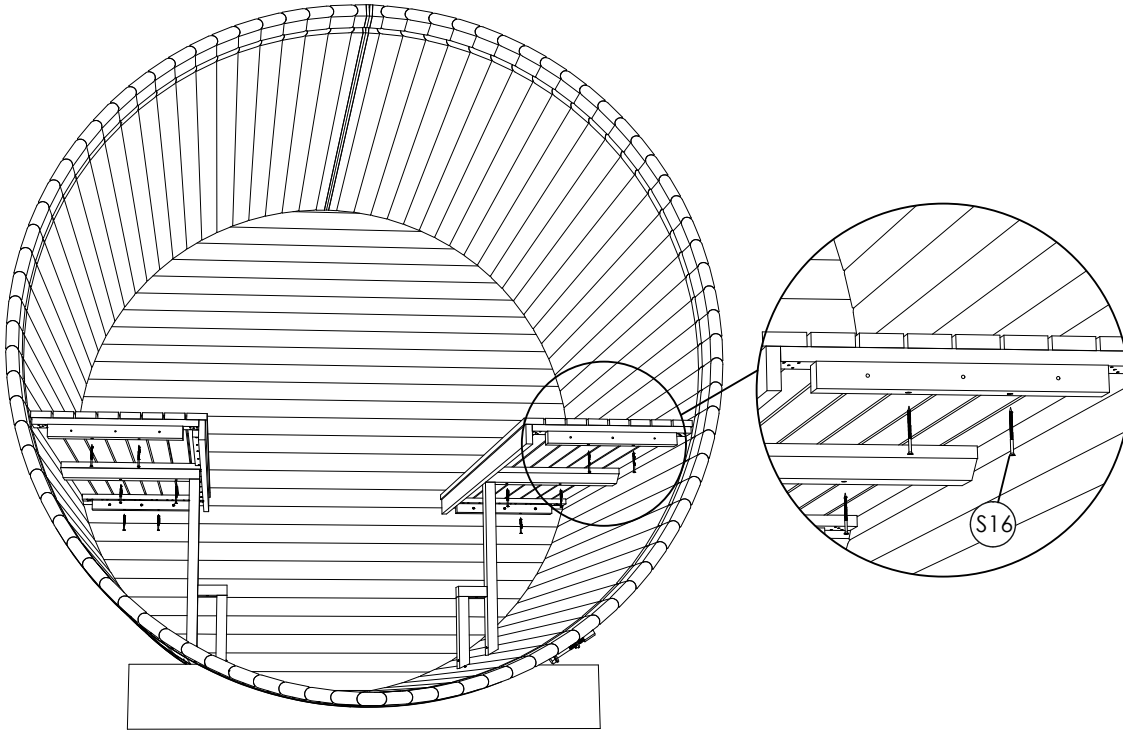


**STEP 17.2:** Fix second part for the long bench leg using (S6) screws. Use level.



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

(S16)  
x12

**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. Using screw (S6) fix wall mounts on the marked lines.

Use a level



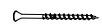
(J8)

x4



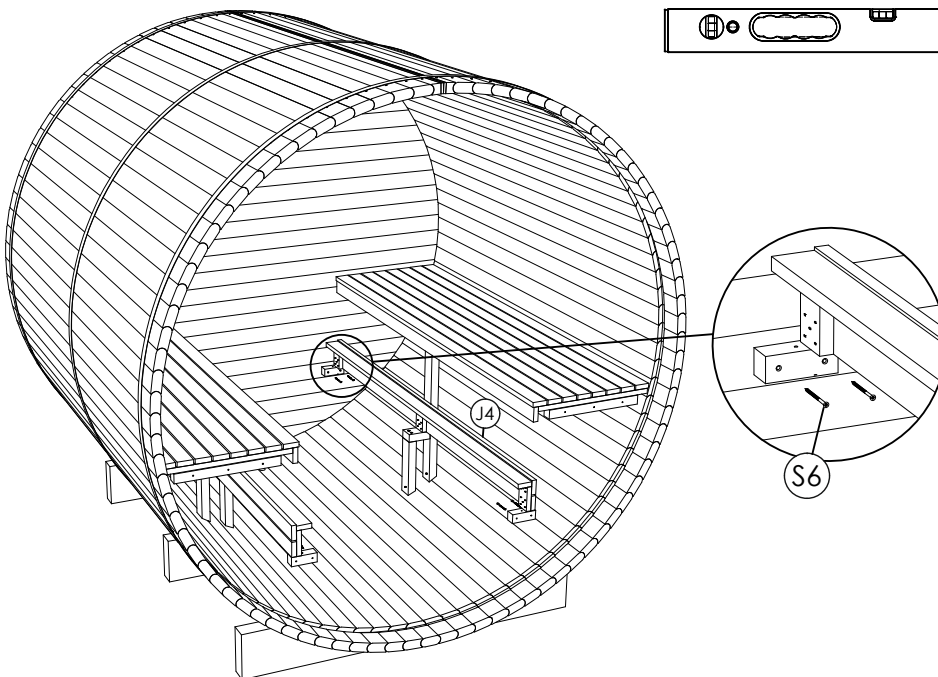
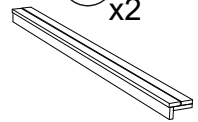
(S6)

x8

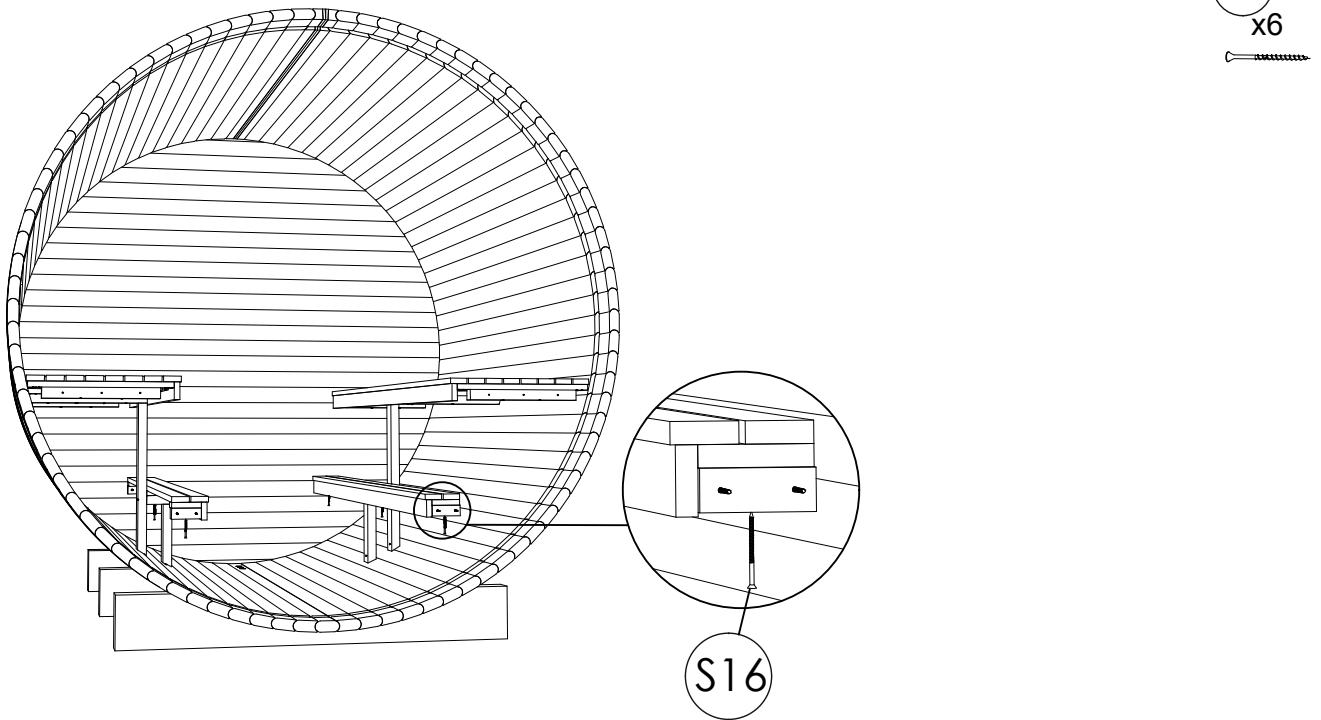


(J4)

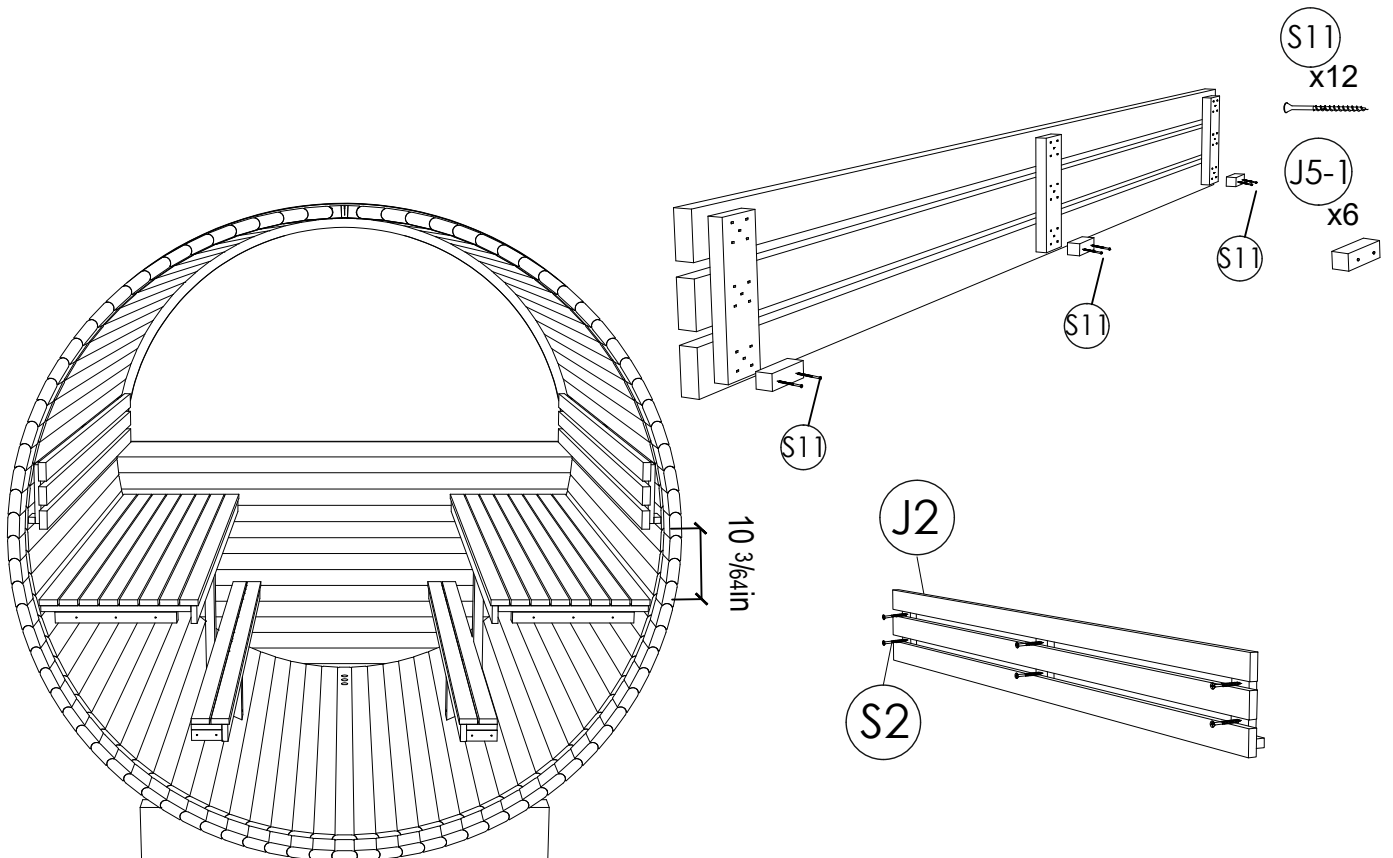
x2



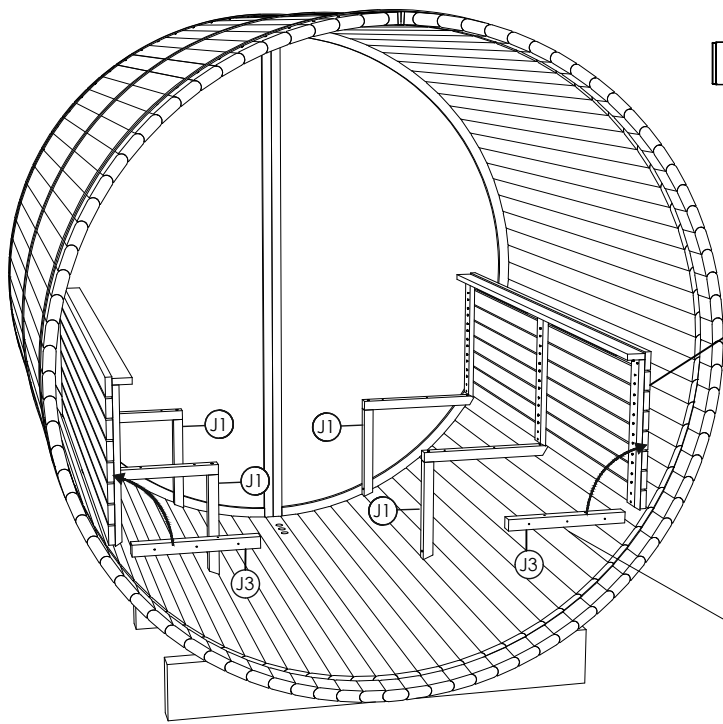
**STEP 17.5:** Fix sauna step bench (J4) to wall mounts and support leg using (S16) screws.



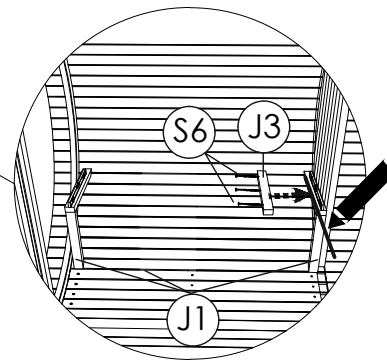
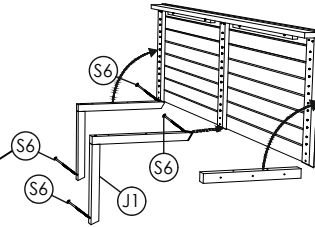
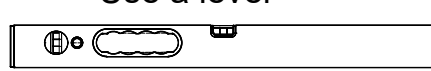
**STEP 17.6:** Fix small blocks at the bottom on the backrest crossboard (J2) using (S11) screws. Fix backrest about 10 <sup>3</sup>/<sub>64</sub>in from bench using (S2) screws.



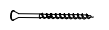
**STEP 17.7:** To install wall mount (J3) use interior supporting leg (J1). Put it on the sauna wall in level, mark a line where wall mounts will stand. Using screw 5.0x70 SS (S6) fix wall mount (J3) on the marked line. Install interior supporting legs (J1) in the center of bench (J) and next to panoramic panel. Stand bench on side wall mounts. Place J1 in the center and check the level. Using screw 5.0 x 70 SS (S6) fix bench leg to the wall and floor.



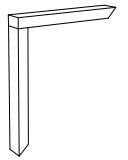
Use a level



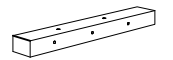
S6  
x14



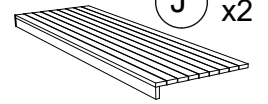
J1 x4



J3 x2



J x2



**STEP 17.8:** Fix sauna bench (J) to wall mounts and support leg using 4 x60 SS (S16) screws. Pre-drill holes before fix backrest with screws, install backrests (J2) using screws 4.0 x 50 SS (S5).

S5  
x12



S16  
x12

