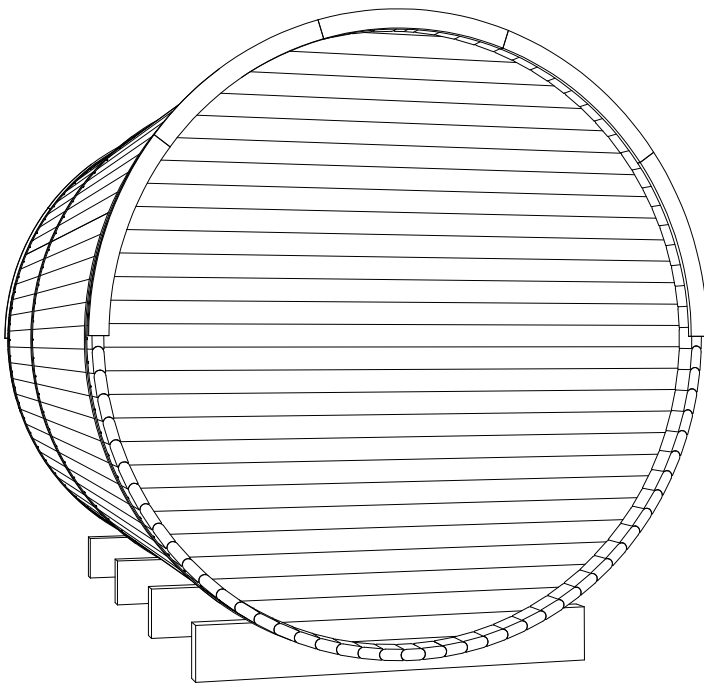
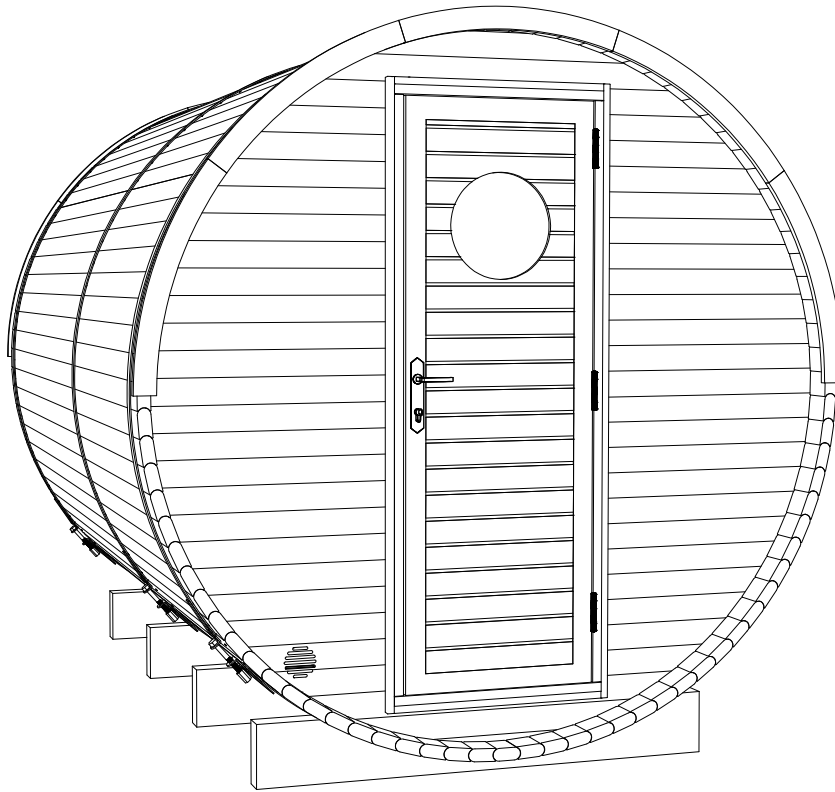
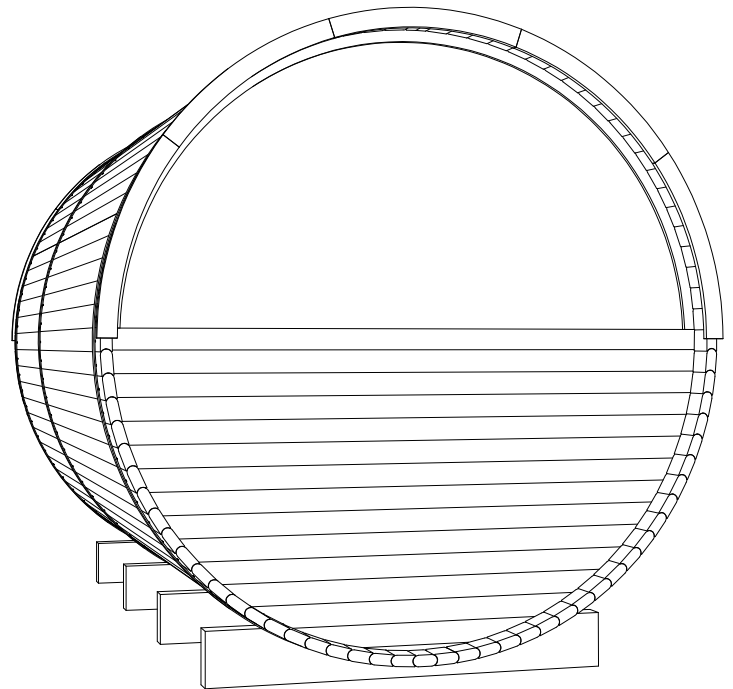


# BARREL SAUNA

## ASSEMBLY INSTRUCTIONS



Model: No 81

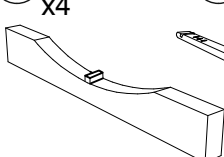
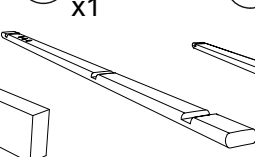
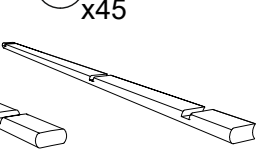
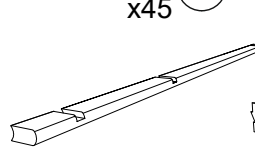
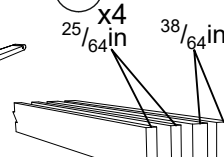
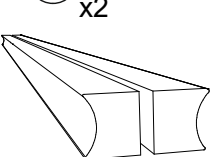
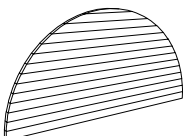
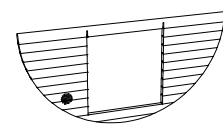
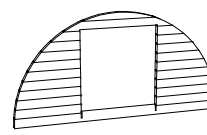
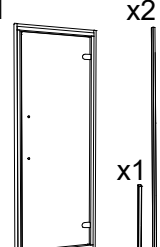
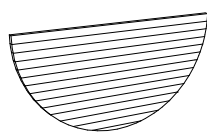
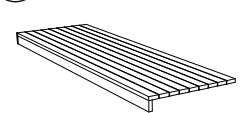
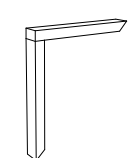

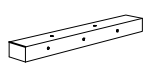

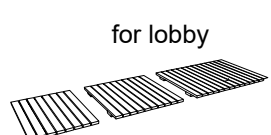
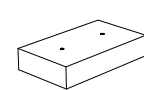
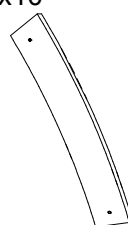
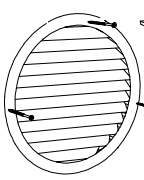
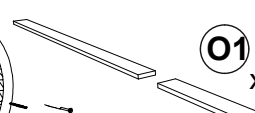
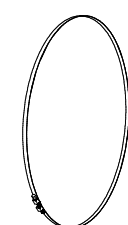

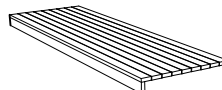

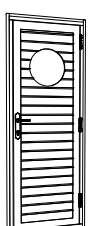
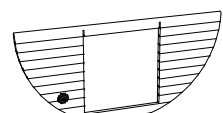
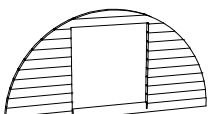



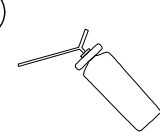
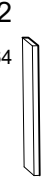

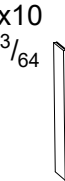


Model: No 80

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

Rev. 14.05.2026

# PART LIST

<p><b>A</b> x4</p>  <p>cradle</p>	<p><b>B</b> x1</p>  <p>center stave</p>	<p><b>C</b> x45</p>  <p>left side body stave</p>	<p><b>C1</b> x45</p>  <p>right side body stave</p>	<p><b>H1</b> x4 25/64in</p>  <p>different thickness filling peaces</p>	<p><b>H</b> x2</p>  <p>final H tipe stave at the top</p>
<p><b>V3</b> x1</p>  <p>upper rear panel</p>	<p><b>F</b> x1</p>  <p>inner panel bottom</p>	<p><b>F1</b> x1</p>  <p>inner panel top</p>	<p><b>F2</b> x1</p>  <p>door and door moldings</p>	<p><b>V</b> x1</p>  <p>bottom rear panel</p>	
<p><b>J</b> x2</p>  <p>sauna bench</p>	<p><b>J1</b> x4</p>  <p>supporting leg</p>	<p><b>J2</b> x2</p>  <p>backrest</p>	<p><b>J3</b> x8</p>  <p>wall mount</p>	<p><b>N1</b> x2</p>  <p>door handle</p>	
<p><b>L</b> x3</p>  <p>sauna floor</p>	<p><b>L1</b> x10</p>  <p>fixing block for sauna floor</p>	<p><b>W</b> x10</p>  <p>decorative roof finishing board</p>	<p><b>Y1</b> x1</p>  <p>ventilation grill</p>	<p><b>O</b> x1</p>  <p>roof board</p>	<p><b>I</b> x3</p>  <p>metal band</p>
<p><b>D</b> x3</p>  <p>Cable canal (for LED option)</p>	<p><b>J6</b> x2</p>  <p>sauna bench</p>	<p><b>J5</b> x2</p>  <p>backrest</p>	<p><b>F5</b> x1</p>  <p>front door and door moldings</p>	<p><b>F3</b> x1</p>  <p>front panel bottom</p>	
<p><b>F4</b> x1</p>  <p>front panel top</p>	<p><b>S9</b> x3</p>  <p>bolt <math>\varnothing 12 \times 140</math></p>	<p>x3</p>  <p>hex nut M12 (SW19)</p>	<p>x6</p>  <p>flat washer</p>	<p><b>P7</b></p>  <p>construction foam</p>	<p>x12 <math>\frac{13}{64}</math></p>  <p>door box spacers</p>
				<p>x10 <math>\frac{5}{64}</math></p>  <p>door box spacers</p>	<p>x10 <math>\frac{3}{64}</math></p>  <p>door box spacers</p>

















## PART LIST

Steel screws			
Article	Size,mm	Screws kind	Total quantity, pc
S1	5.0x100	steel	65
S4	5.0x120	steel	15
S5	4.0x50	steel	93
S6	5.0x70	stainless	30
S7	4.2x55	steel	35
S10	4.0x60	steel	240
S14	5.0x80	steel	10
S16	4.0x60	stainless	30

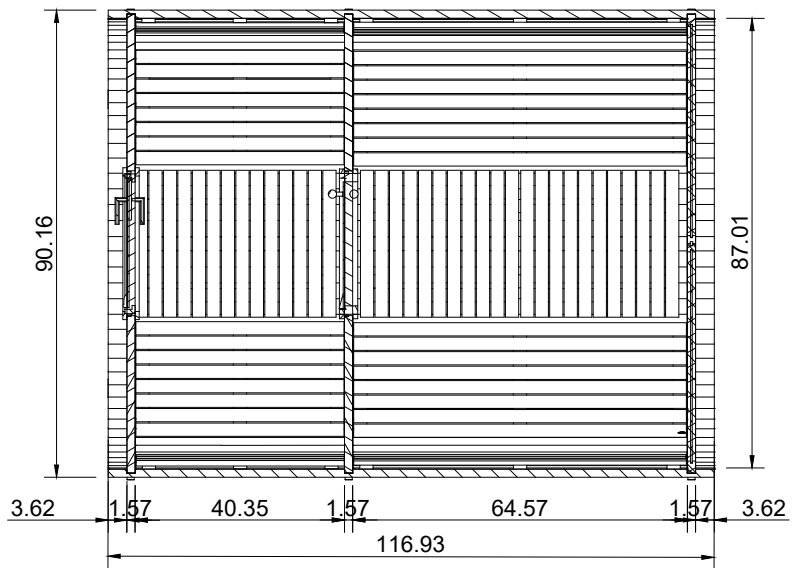
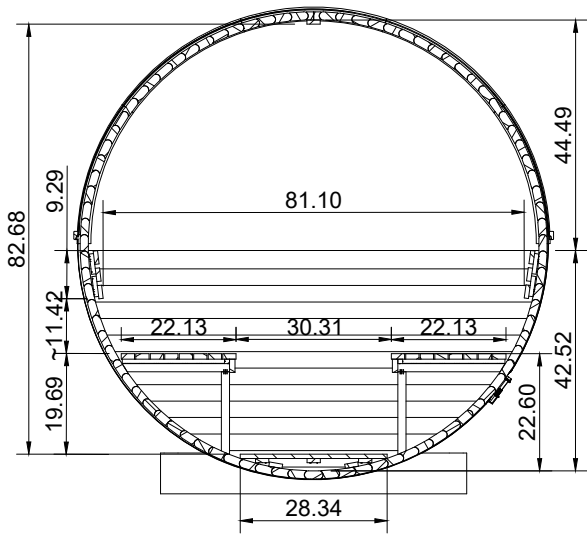
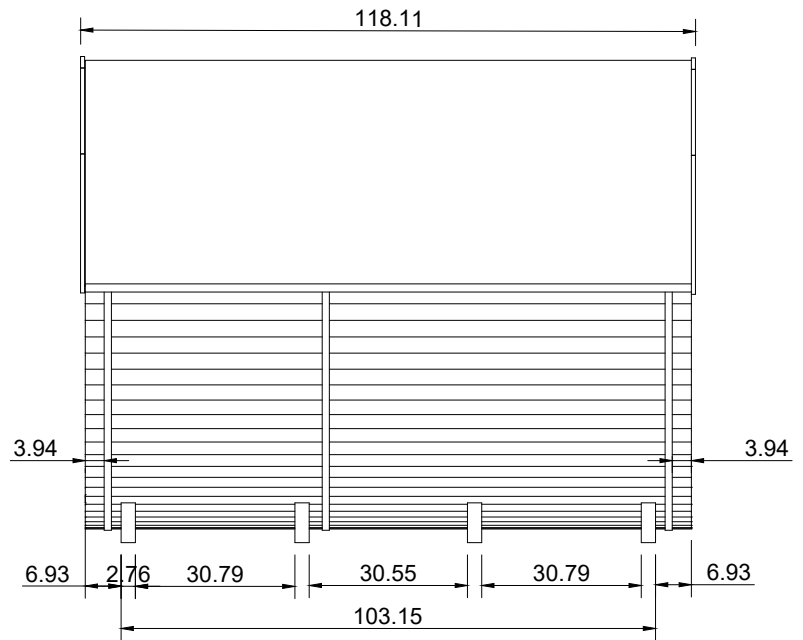
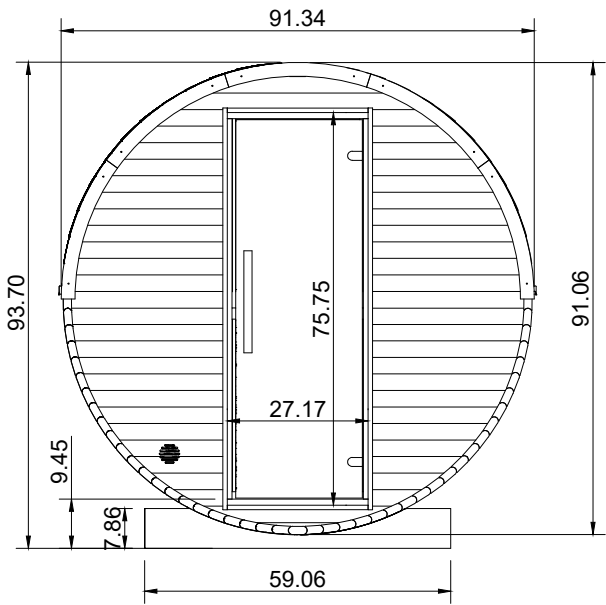
## RECOMMENDATIONS

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

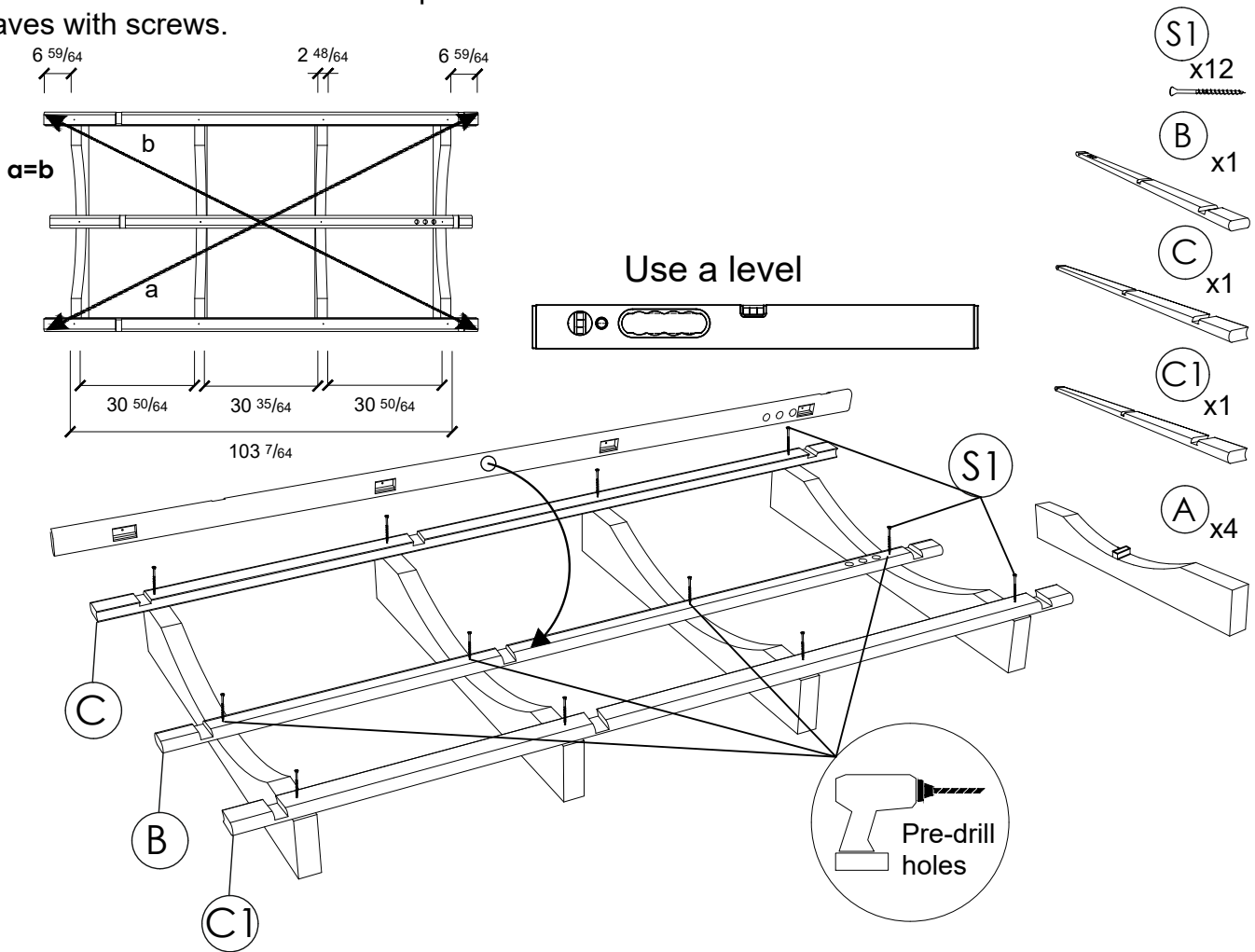
	Tape measure		Cutting knife		Drills $\varnothing^{5/32}-^{25/64}$ in
	Pencil		Battery drill		Wrench $7^{31/64}$
	Level		Nail gun		Vise
	Rubber mallet		Hex keys $1/8"-9/32"$		Recommended - 2 person
	Hammer		Gloves		
	Stapler		Safety goggles		

## Barrel dimensions

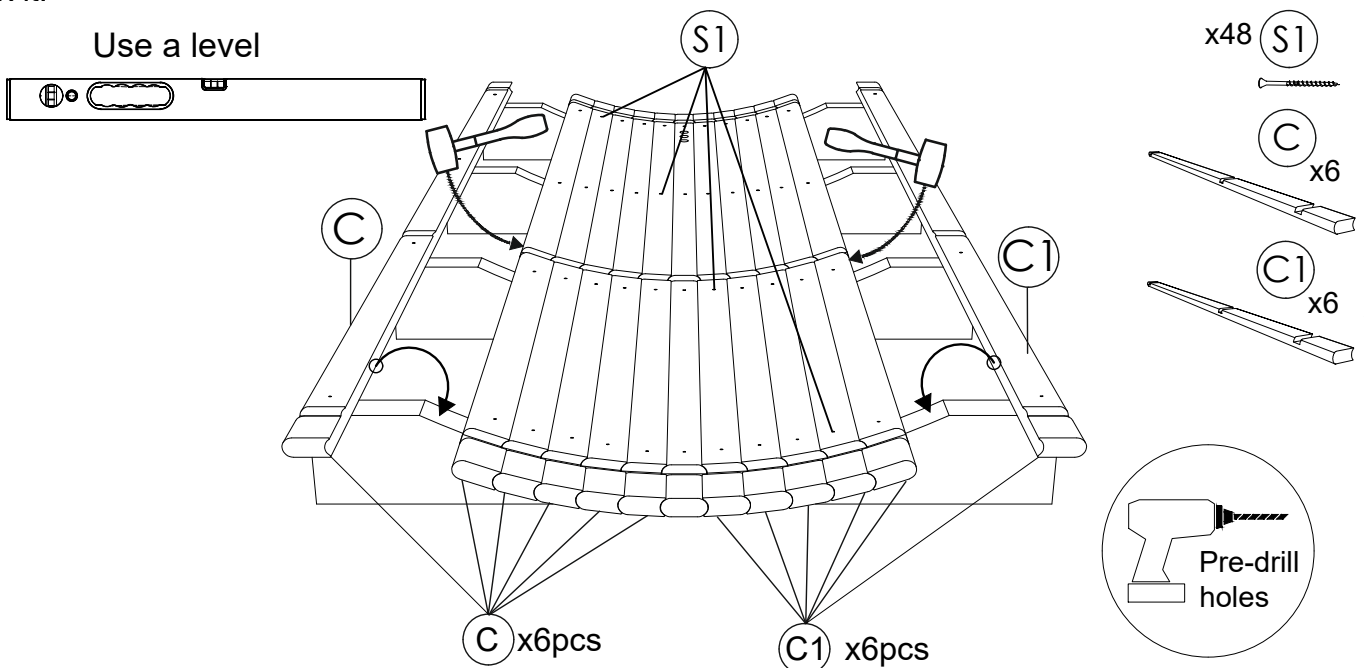


The dimensions on the drawings are informative, rounded values. Units of measurement - inches.

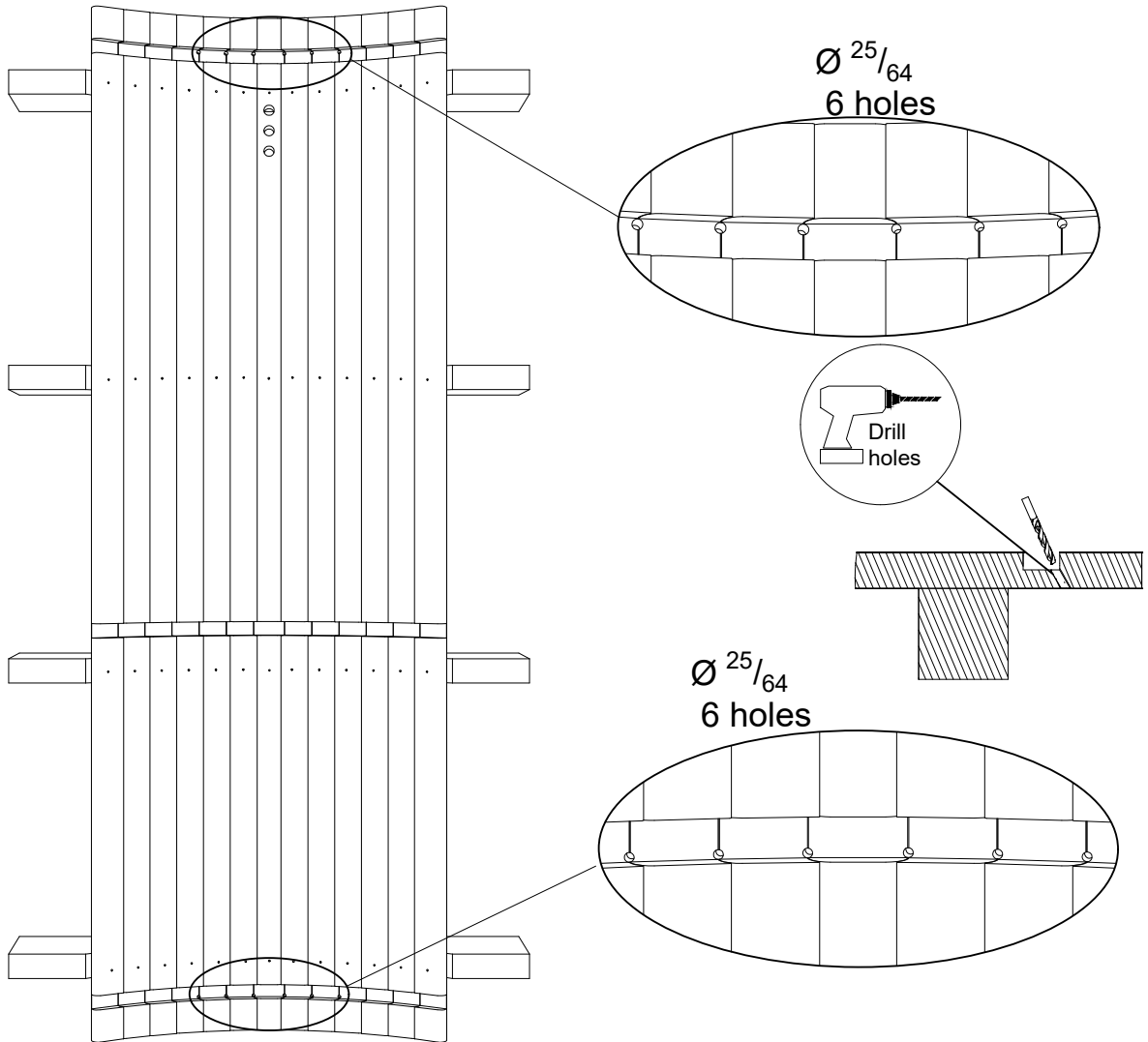
**STEP 1:** Place the support cradles (A) on level site. Carefully level for better stability. Place the center stave (B) on wooden dowels embedded in outer support cradles (A). Fix the center stave (B) with (S1) screws. Then fix boards on top of the cradles at the side corners. Measure support cradles (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 6 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.

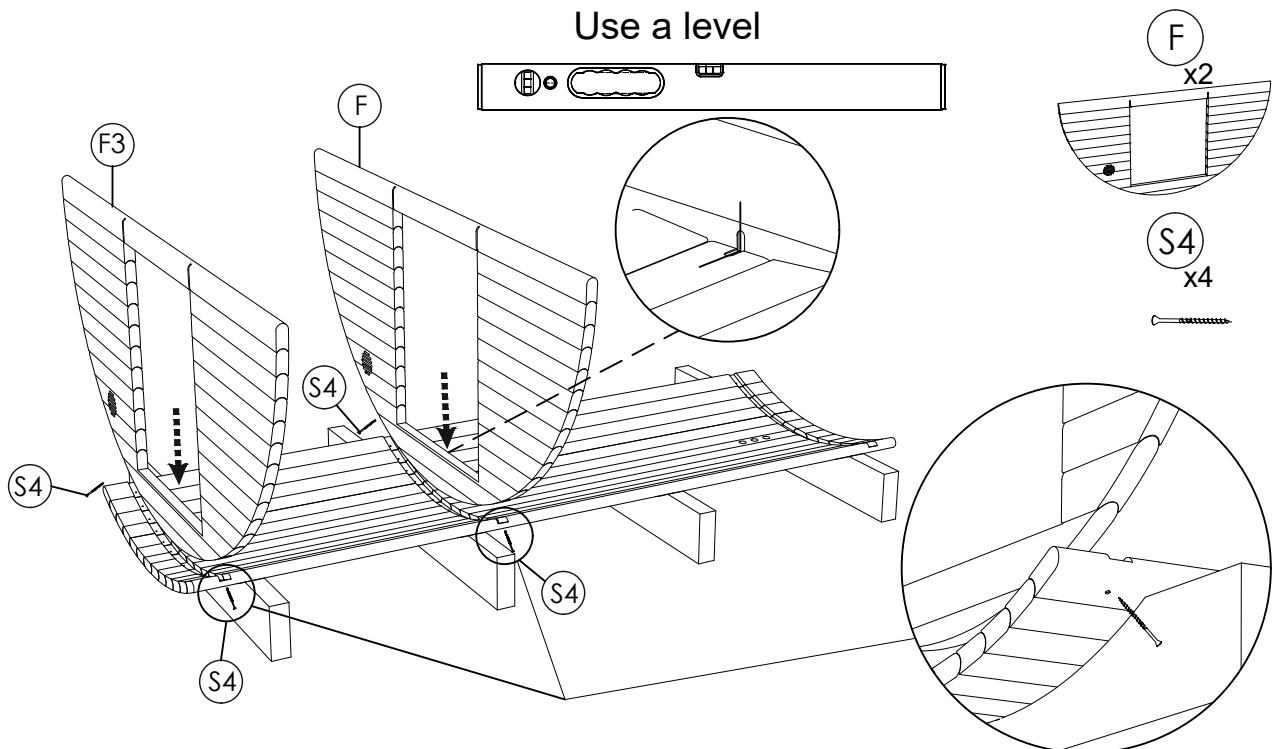


**STEP3:** Drill six  $\frac{25}{64}$ in holes in front and back wall groove to the out-side in board connections as shown in the picture. This will help drain excess water faster.

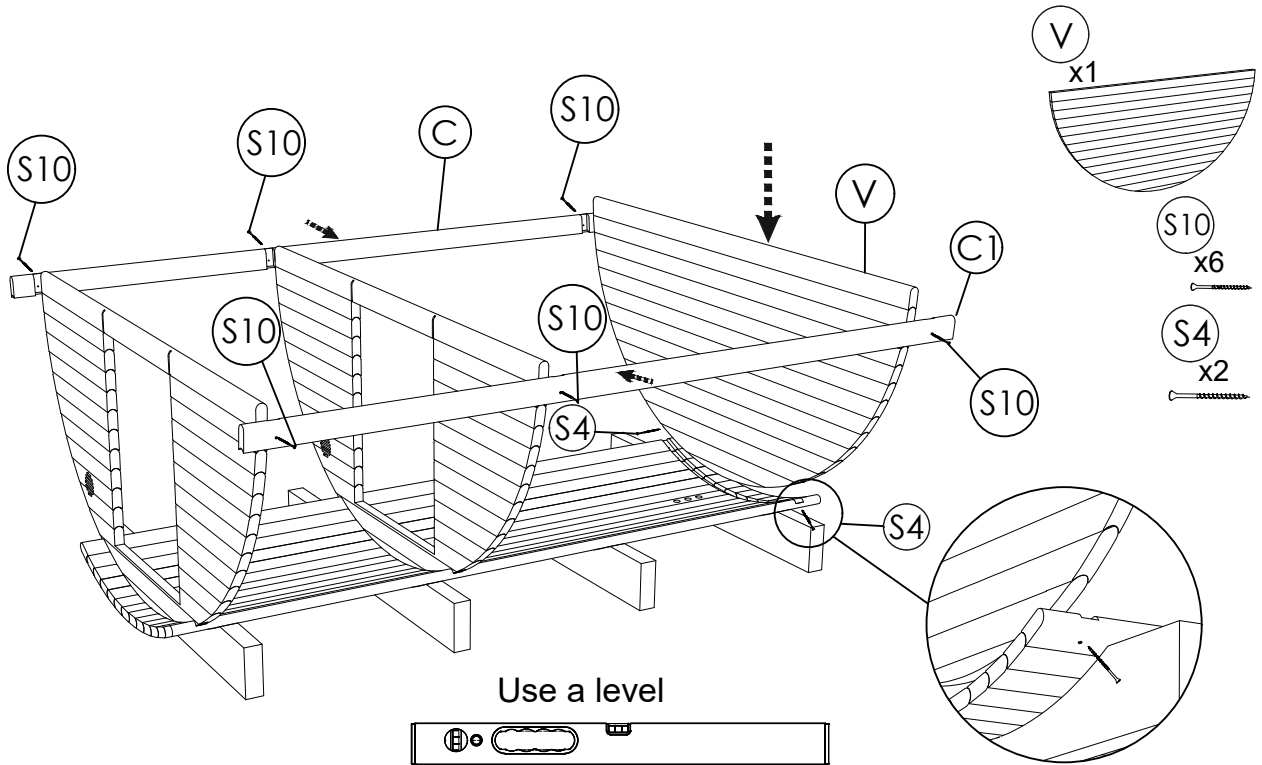


**STEP 4:** Place front bottom panel (F) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides.

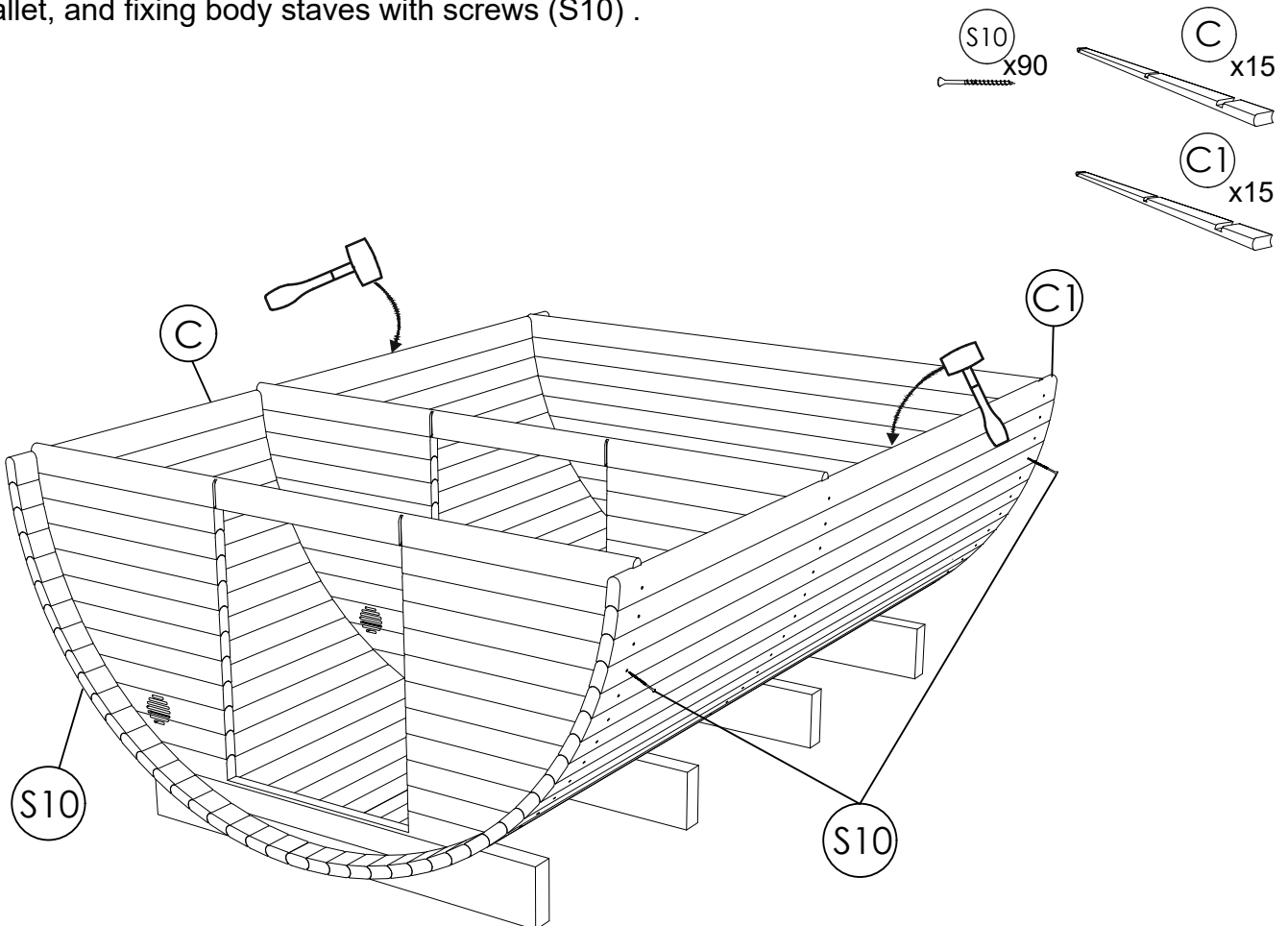
Use a level



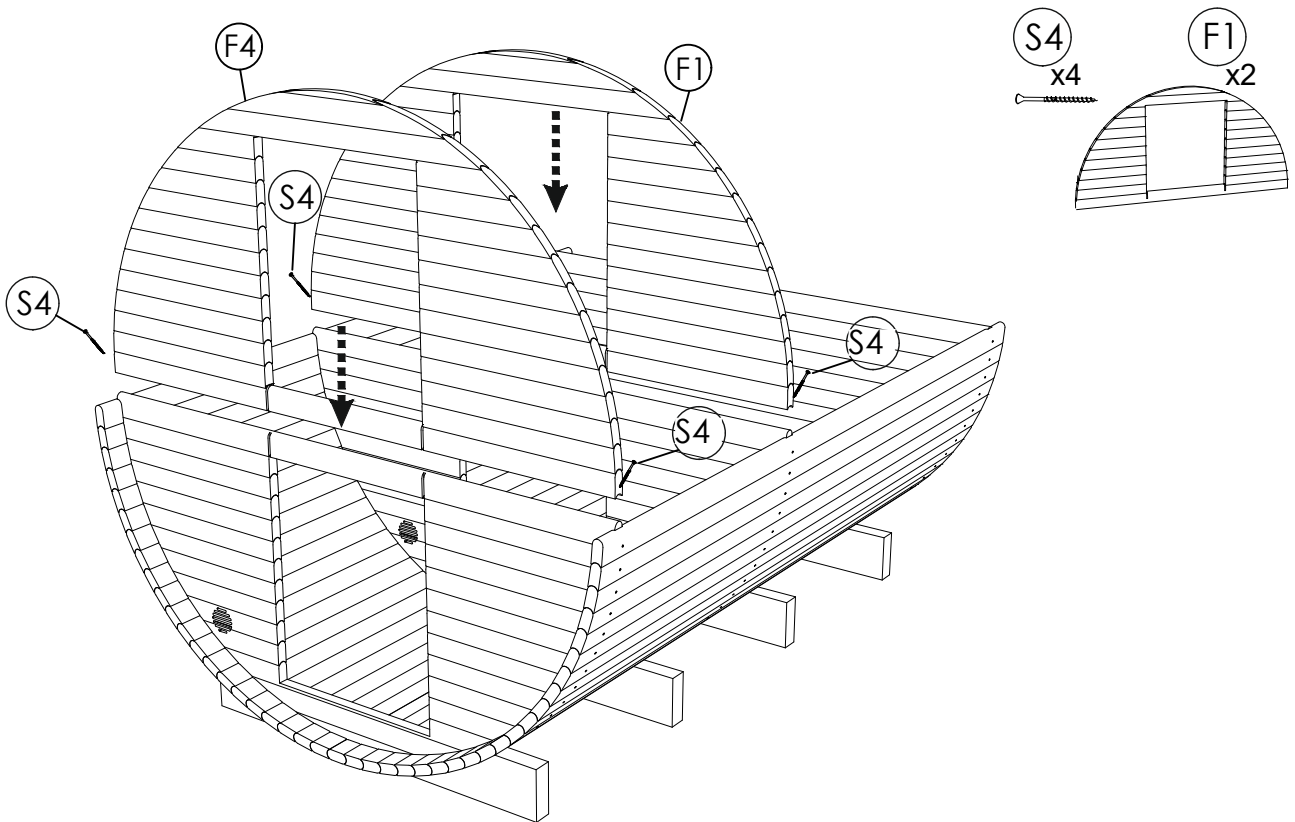
**STEP 5:** Place rear panel (V) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides. Connect the panels (F; F3; V) together by placing one body stave (C; C1) both sides in level, with (S10) screws.



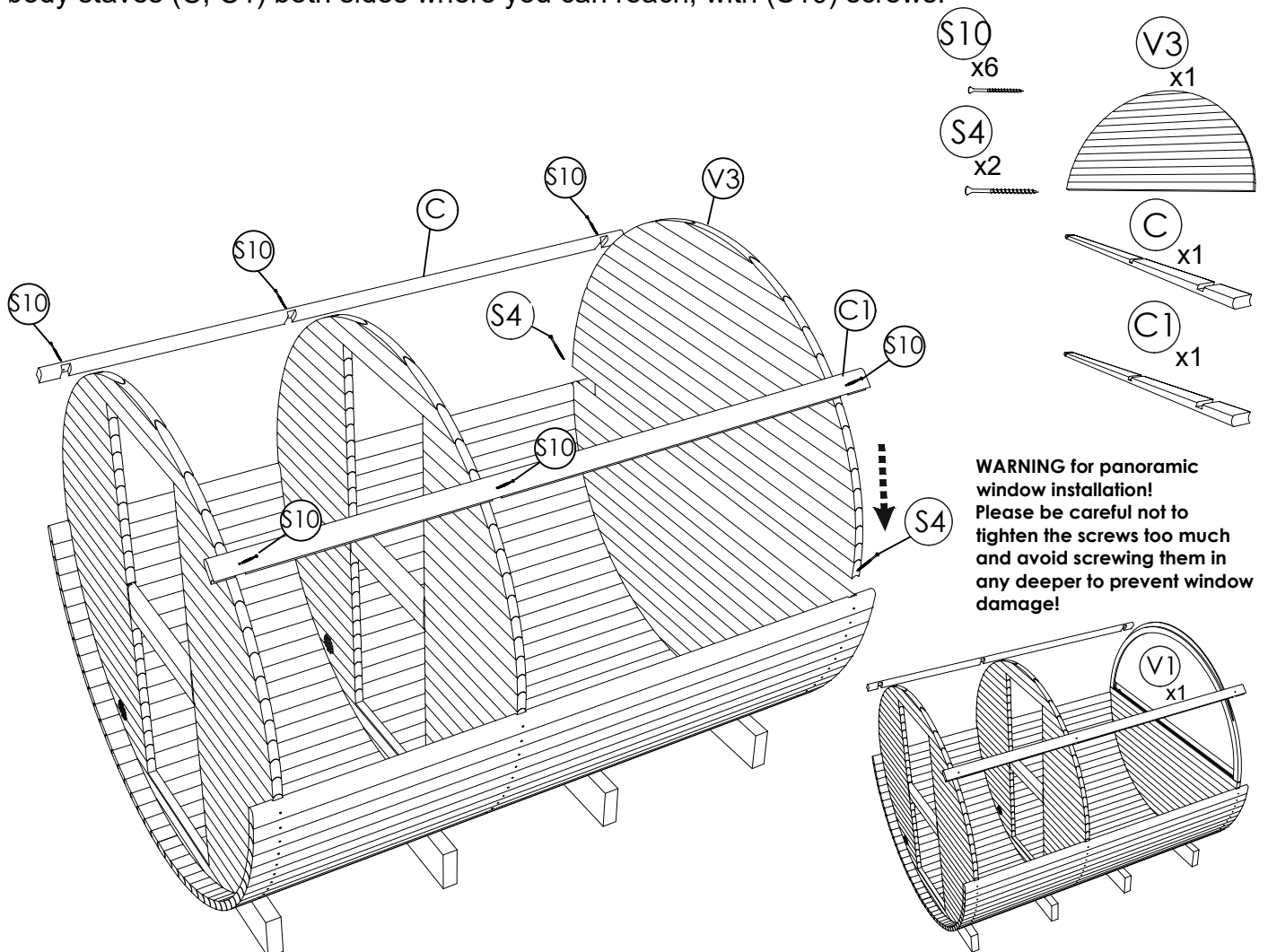
**STEP 6:** Continue placing body staves (C;C1) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10) .



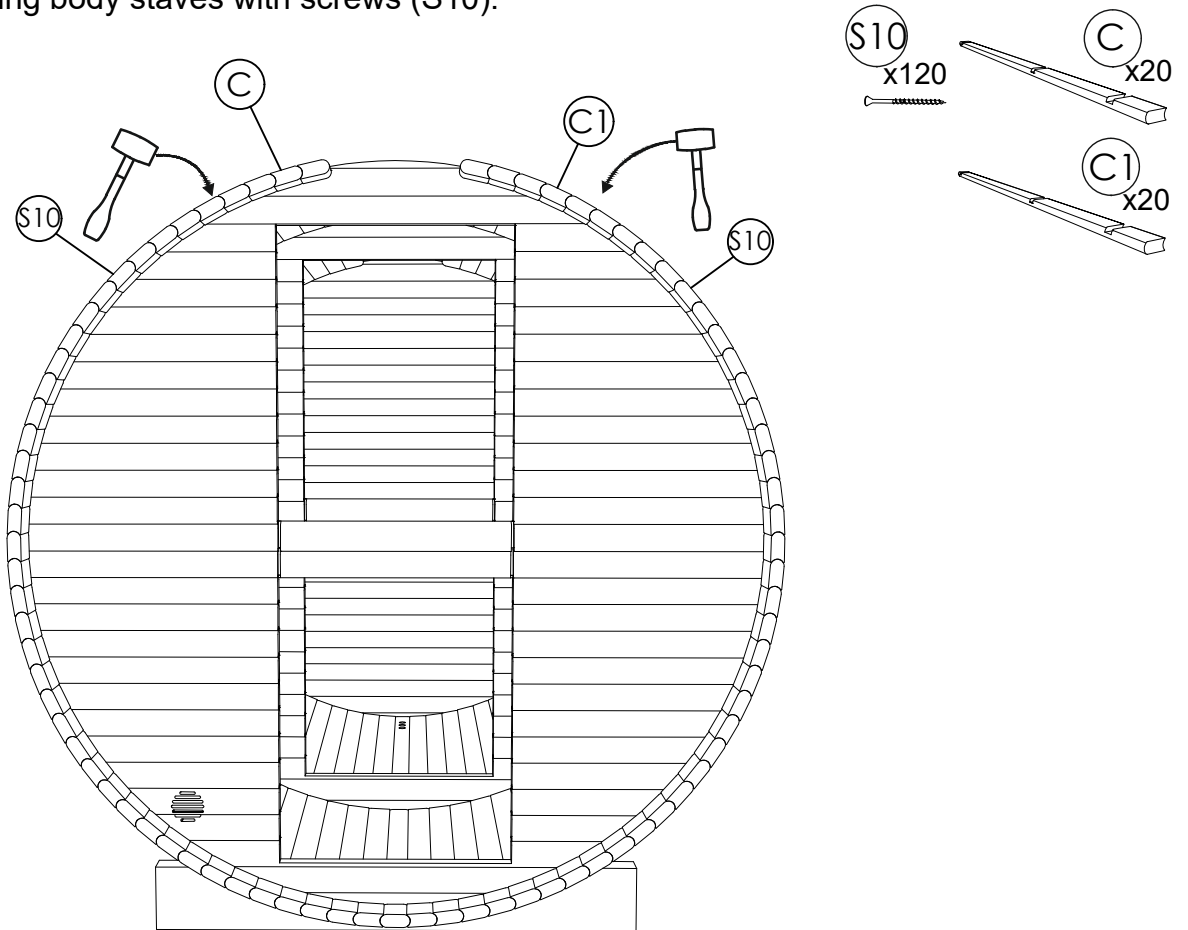
**STEP 7:** Place front top panel (F1) on front bottom panel (F), be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws on both sides.



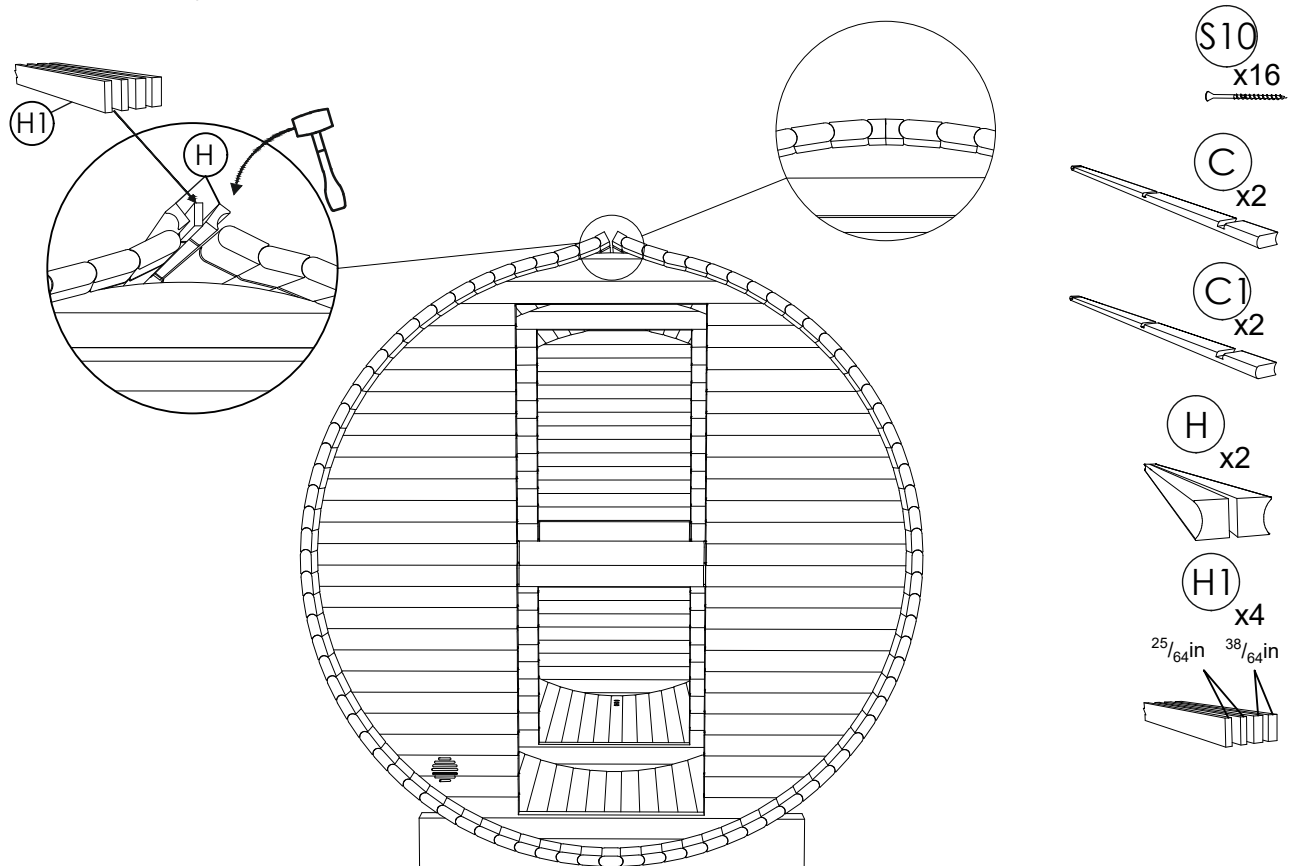
**STEP 8:** Take the upper rear panel (V3 or V1-panoramic window) and place it on the bottom rear panel (V). Secure it by using 2 screws (S4). Connect the panels (F2; V3) together by placing one body staves (C; C1) both sides where you can reach, with (S10) screws.



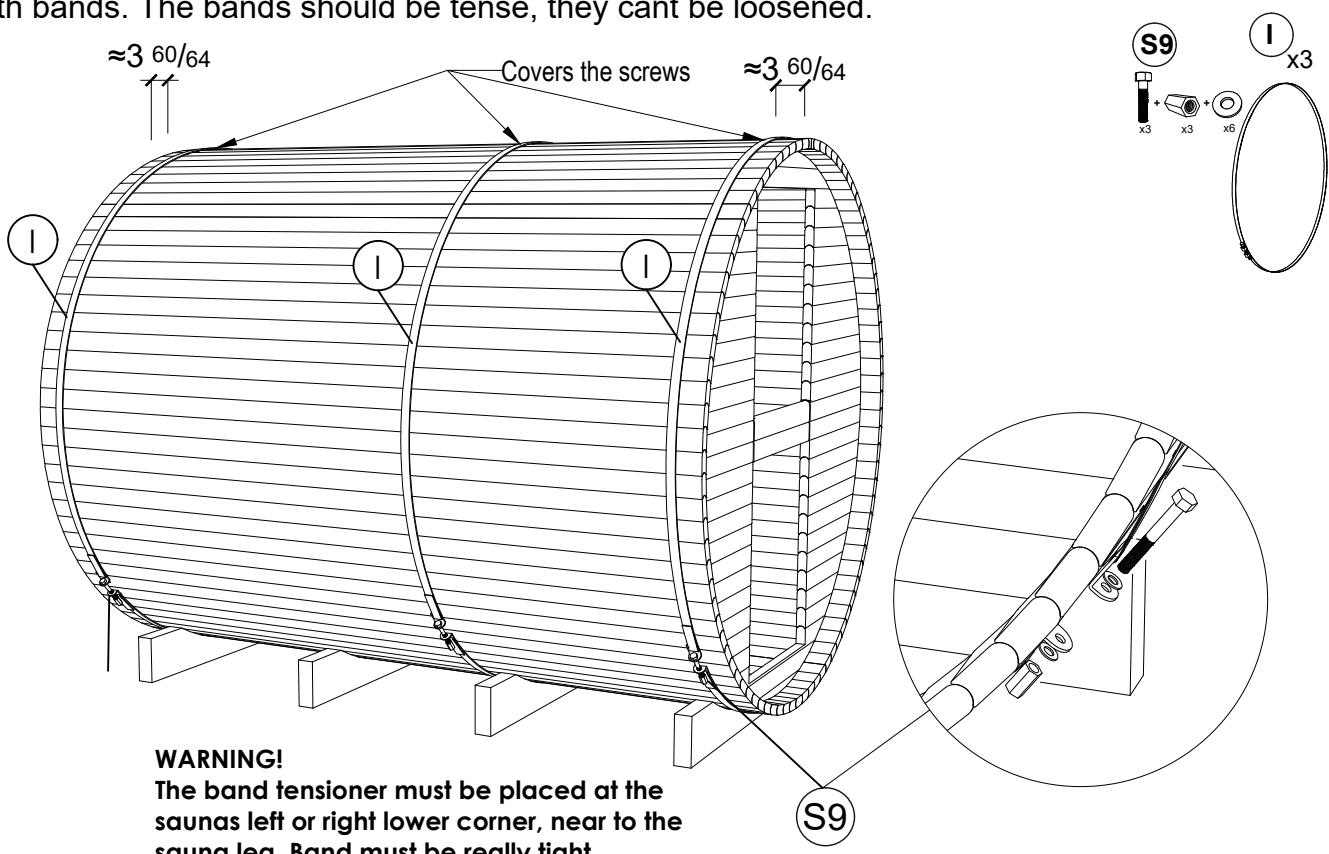
**STEP 9:** Continue placing body staves (C; C1) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10).



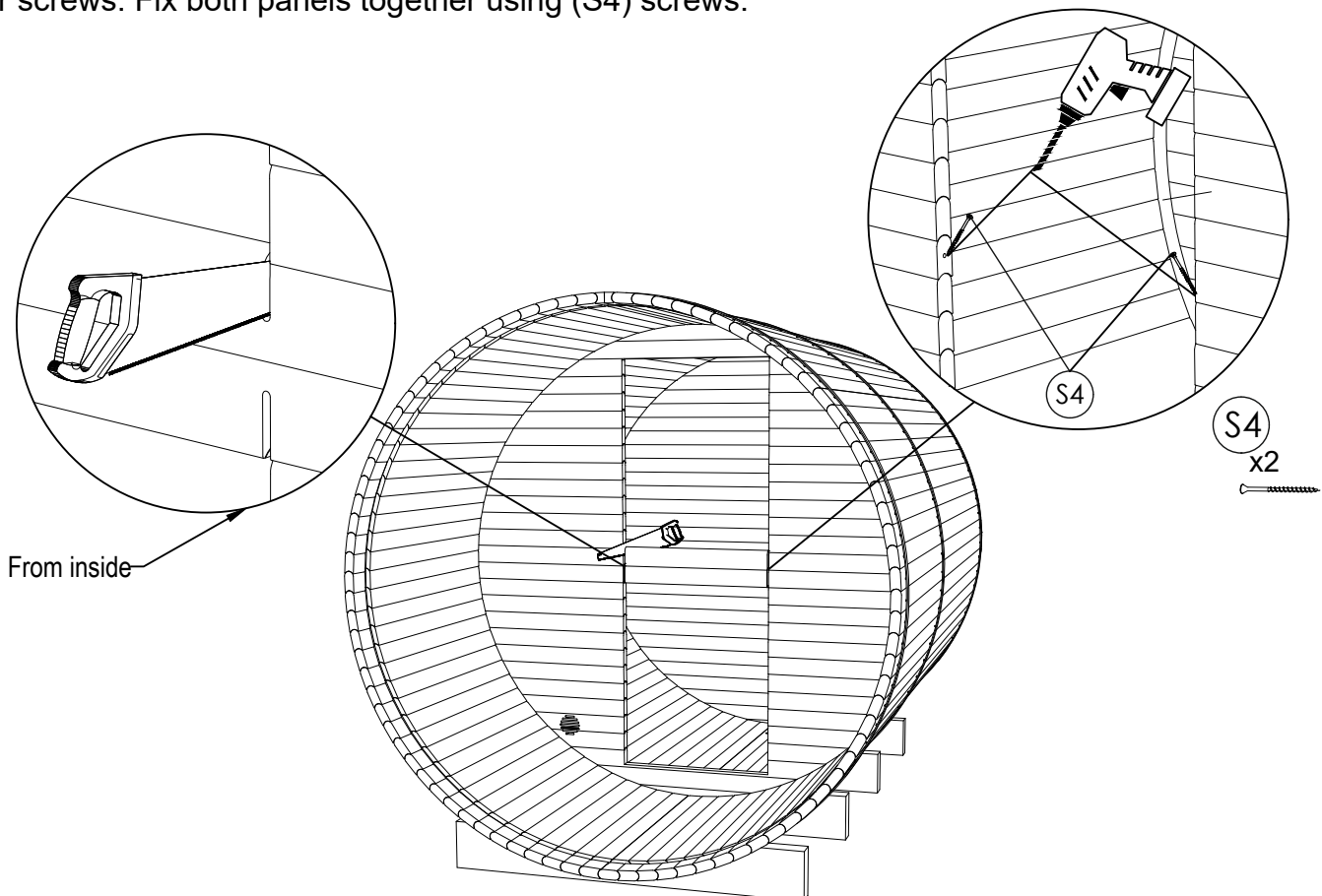
**STEP 10:** To finish the roof top joint, don't screw about last 2 boards (C; C1) to each side, use roof finishing item (H). Different thickness filling pieces (H1) are provided to completely fill the gap. Once necessary parts are in, fix last boards with screws.



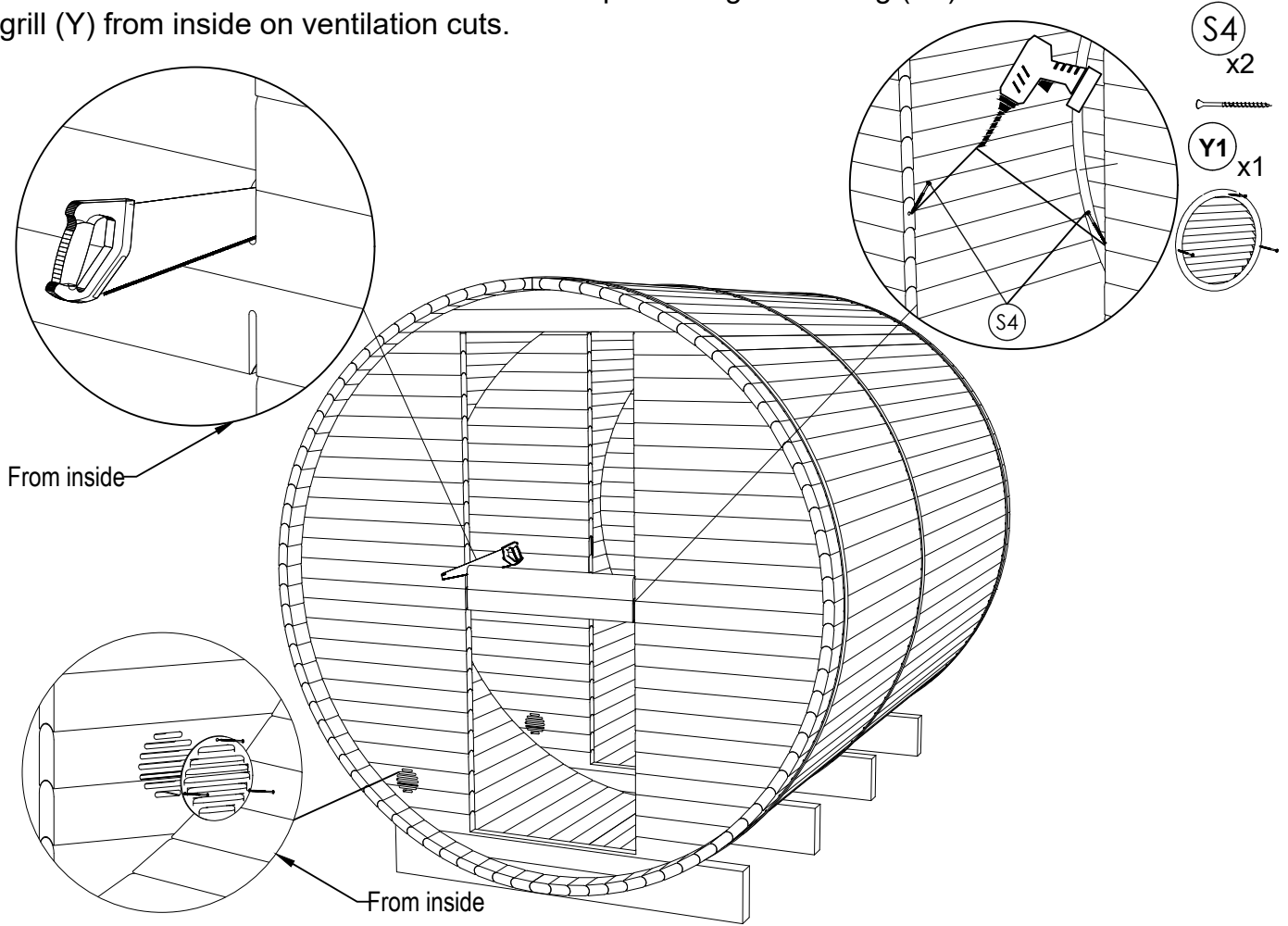
**STEP 11:** Install steel bands (I) by wrapping bands around the barrel, then connect with bolts and nuts (S9). Place steel bands evenly around the barrel approx  $\approx 3 \frac{60}{64}$  from sauna back and front. Bands should cover screw heads evenly. The middle band should be evenly placed from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



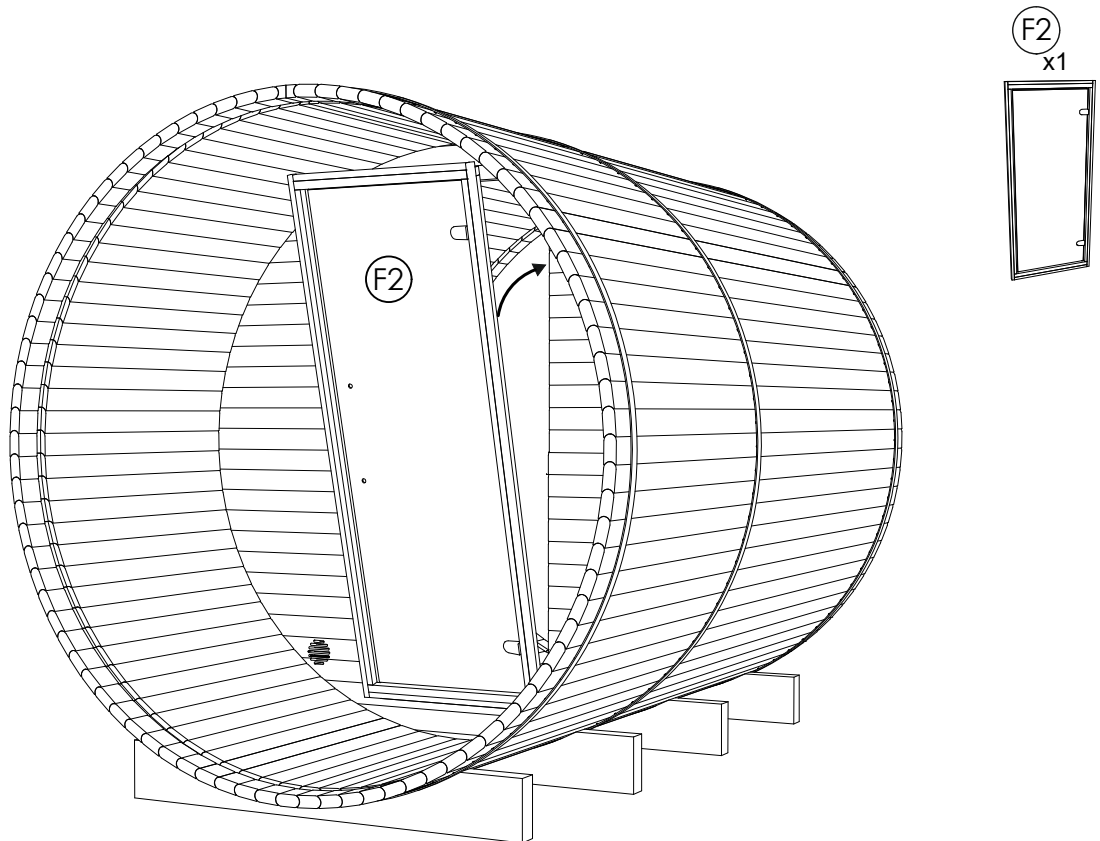
**STEP 12:** Draw straight line to connect both cuts. Use hand saw or other cutting machine to saw out excess boards for door box. It's recommended to saw out boards from inside. Pre-drill holes for screws. Fix both panels together using (S4) screws.



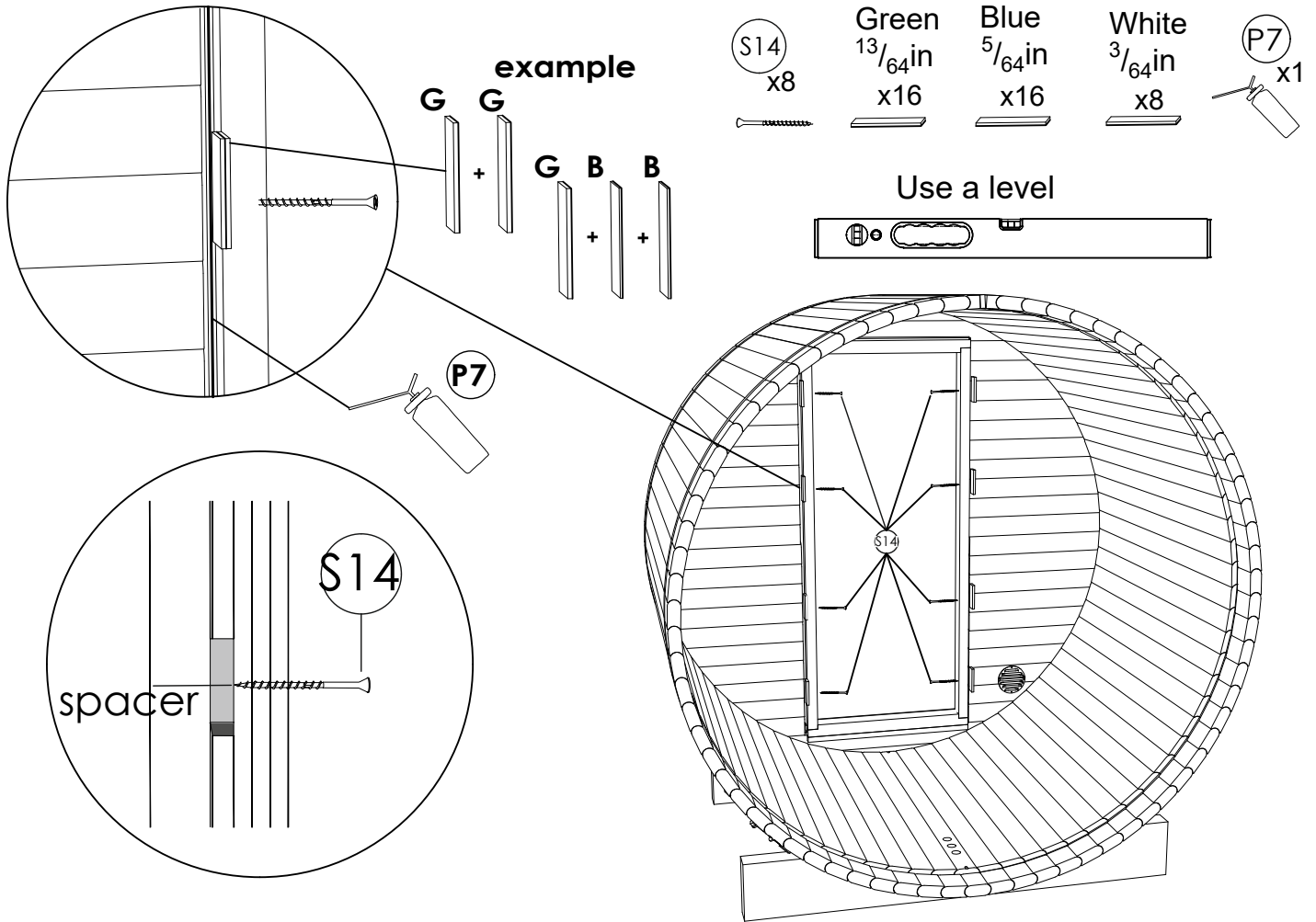
**STEP 13:** Pre-drill holes for screws. Fix both panels together using (S4) screws. Fix ventilation grill (Y) from inside on ventilation cuts.



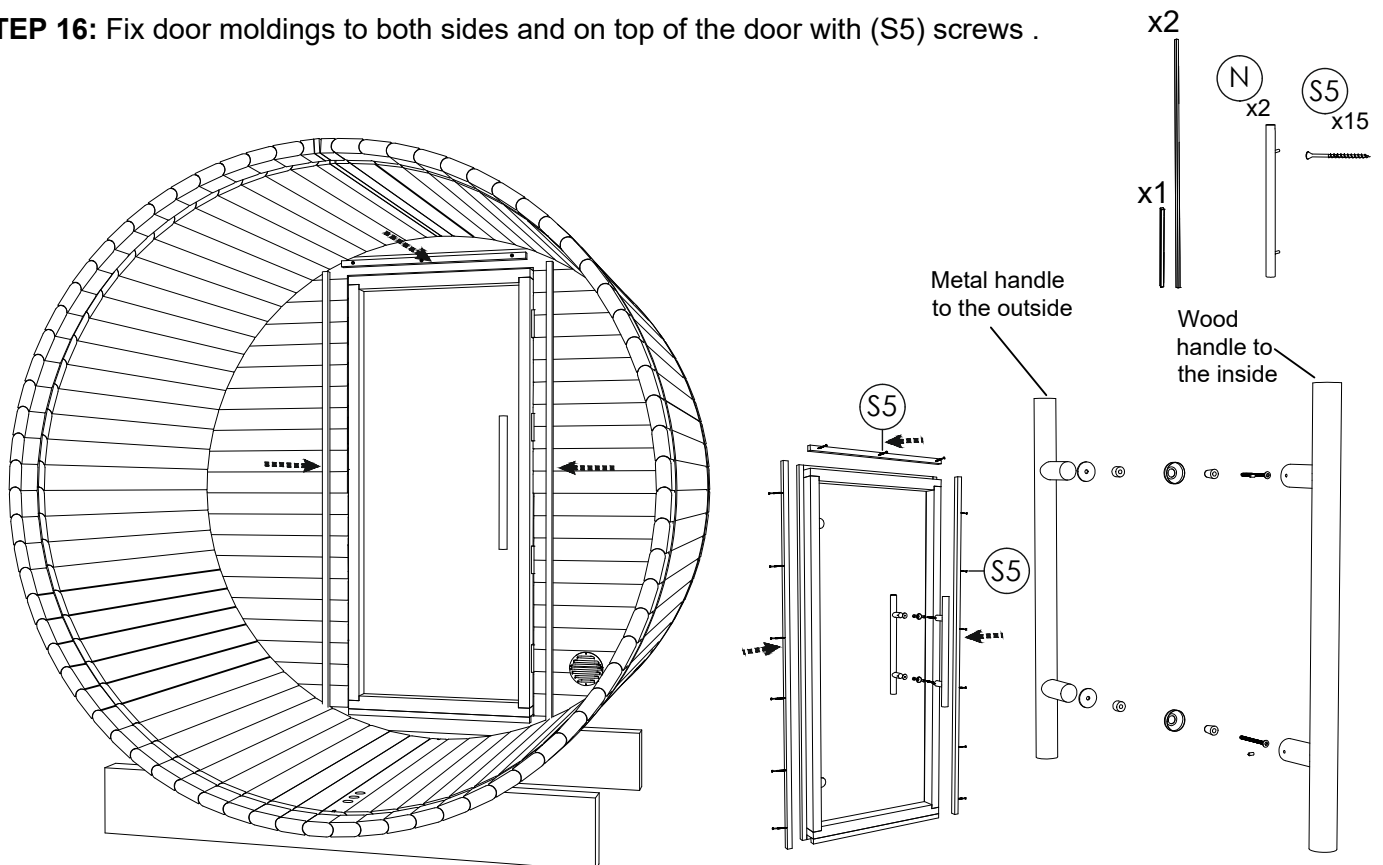
**STEP 14:** Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.



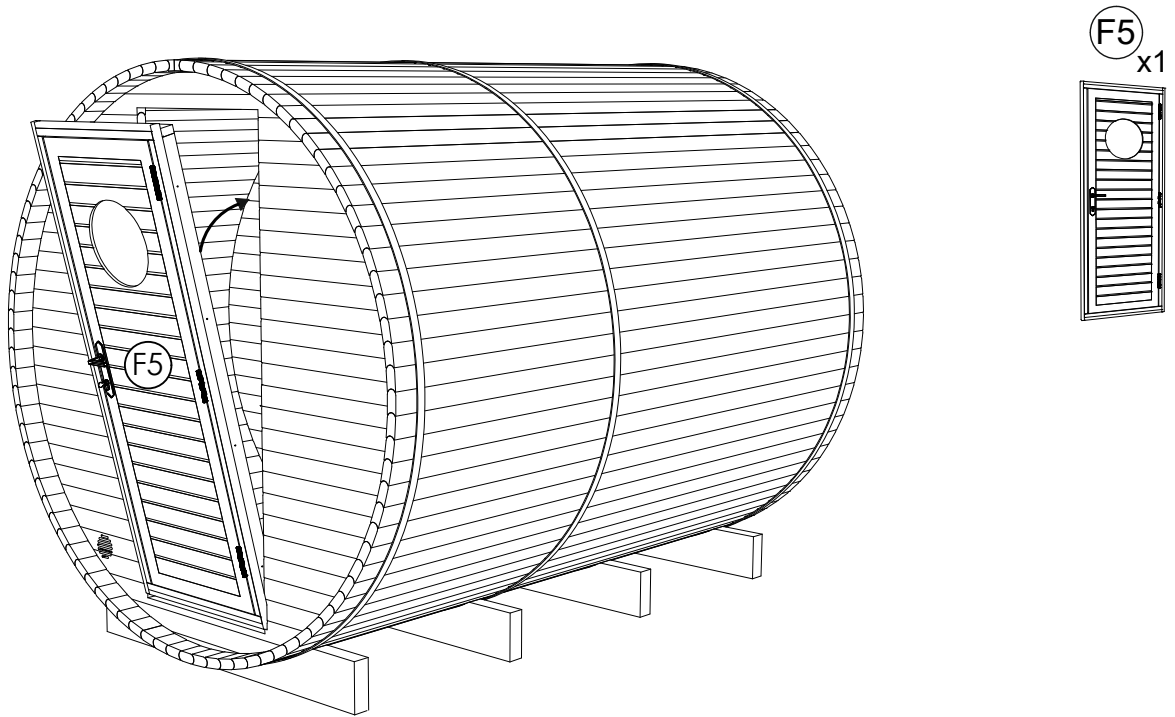
**STEP 15:** Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. First, fix one side of the door box with screws (S14) through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly,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



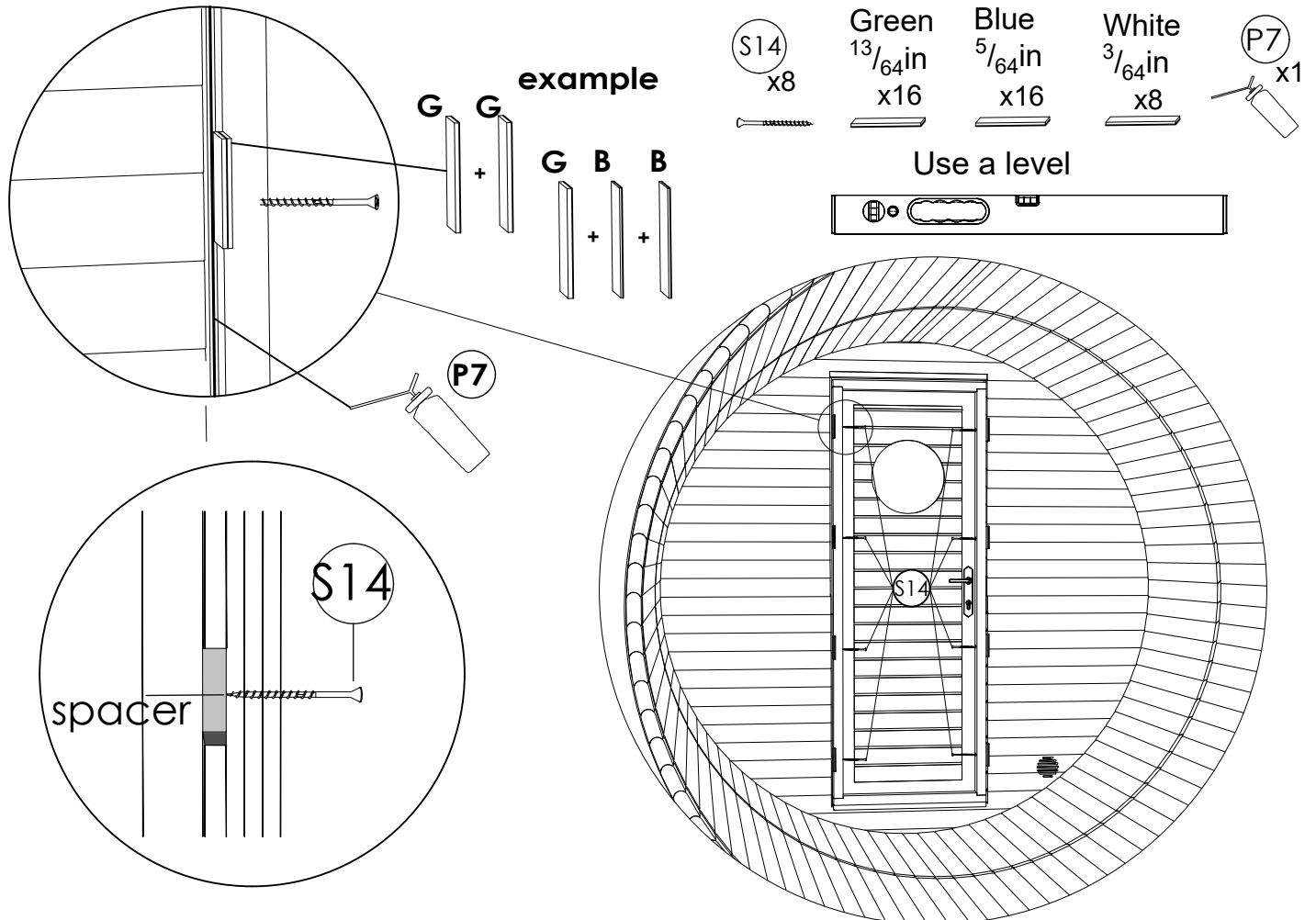
**STEP 16:** Fix door moldings to both sides and on top of the door with (S5) screws .



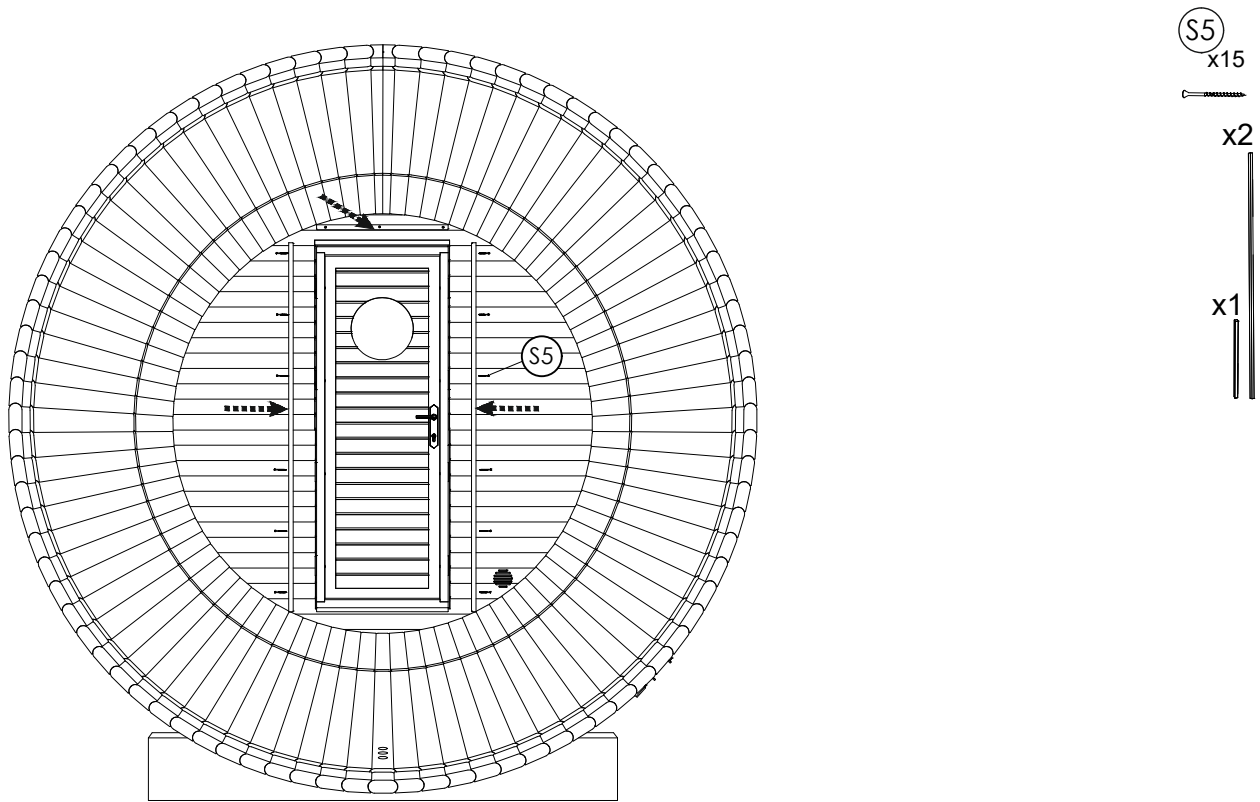
**STEP 17:** Install the doors (F5). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.



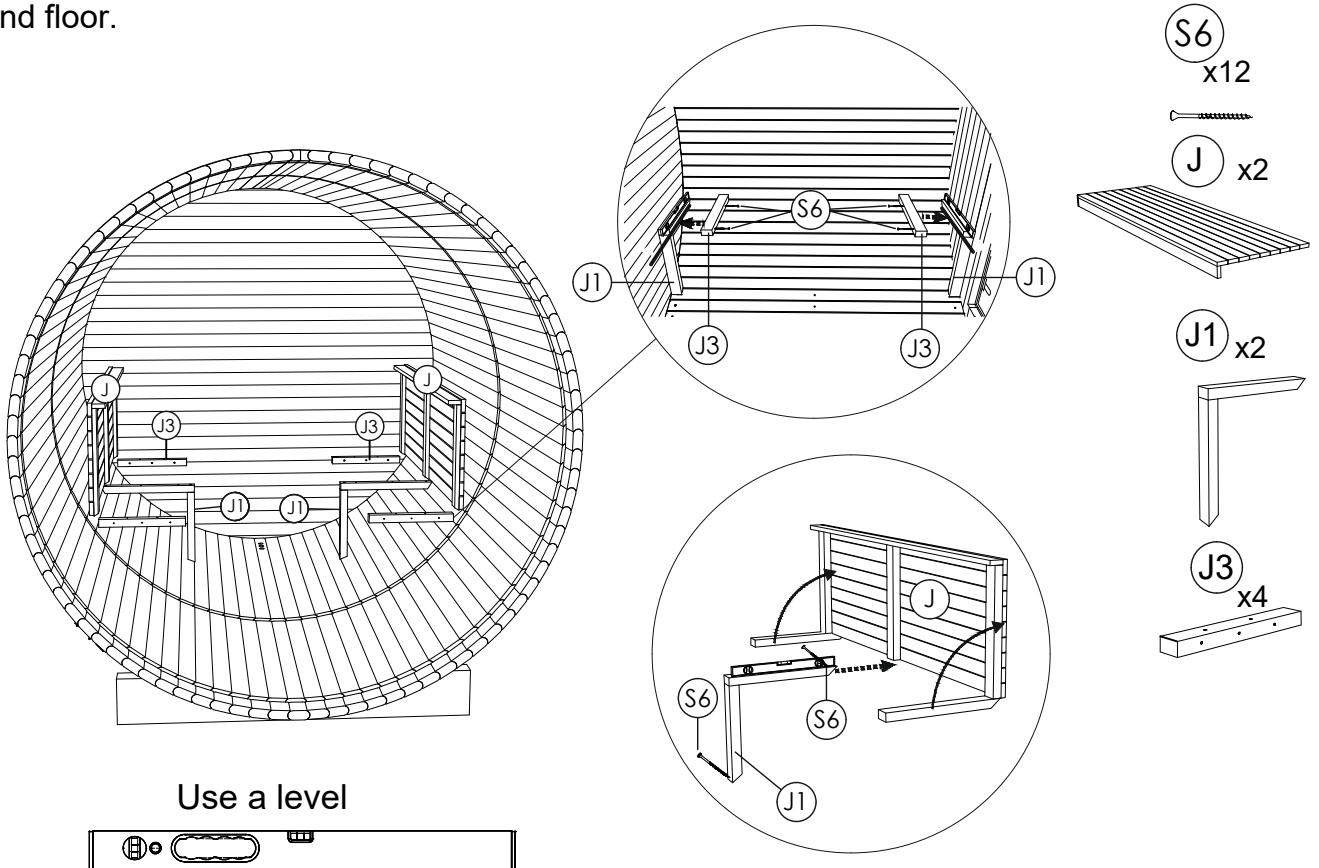
**STEP 18:** Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. First, fix one side of the door box with screws (S14) through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly, 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.



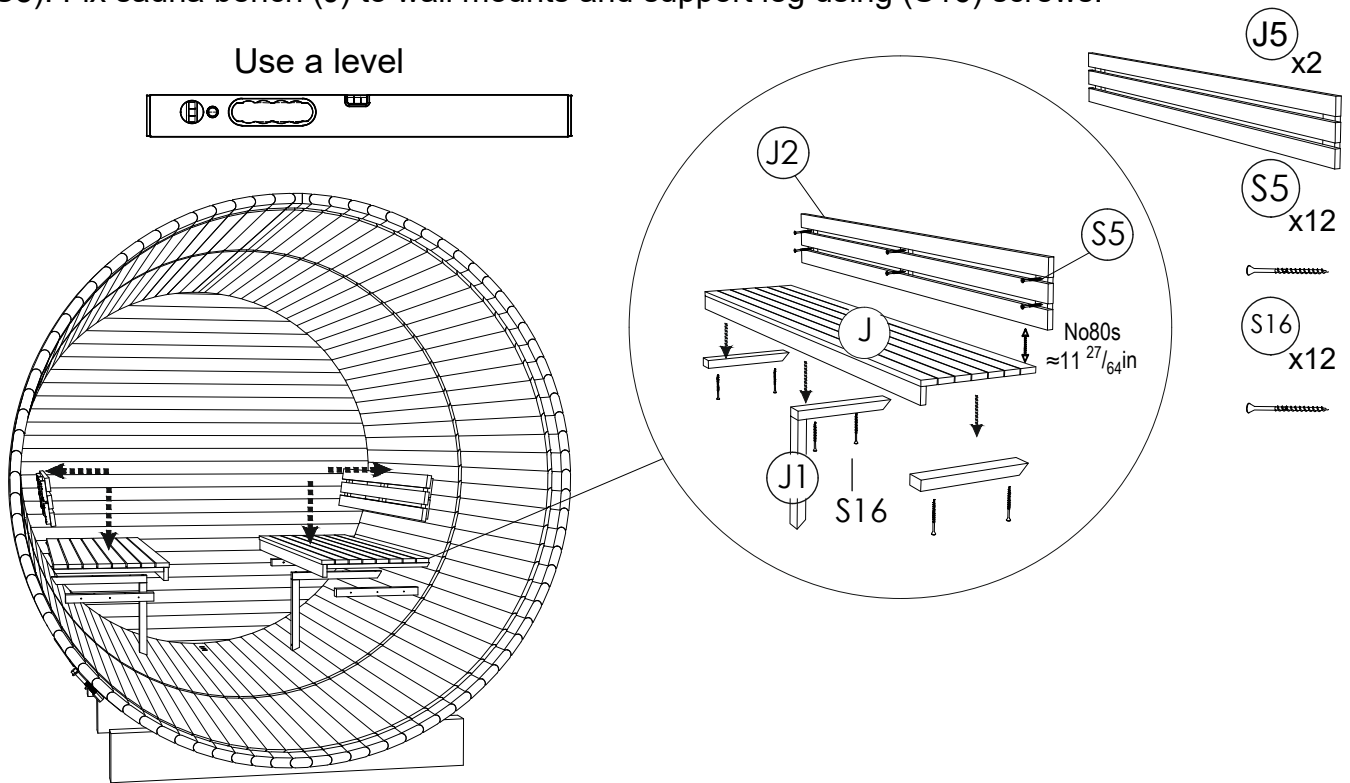
**STEP 19:** Fix door moldings to both sides and on top of the door with (S5) screws.



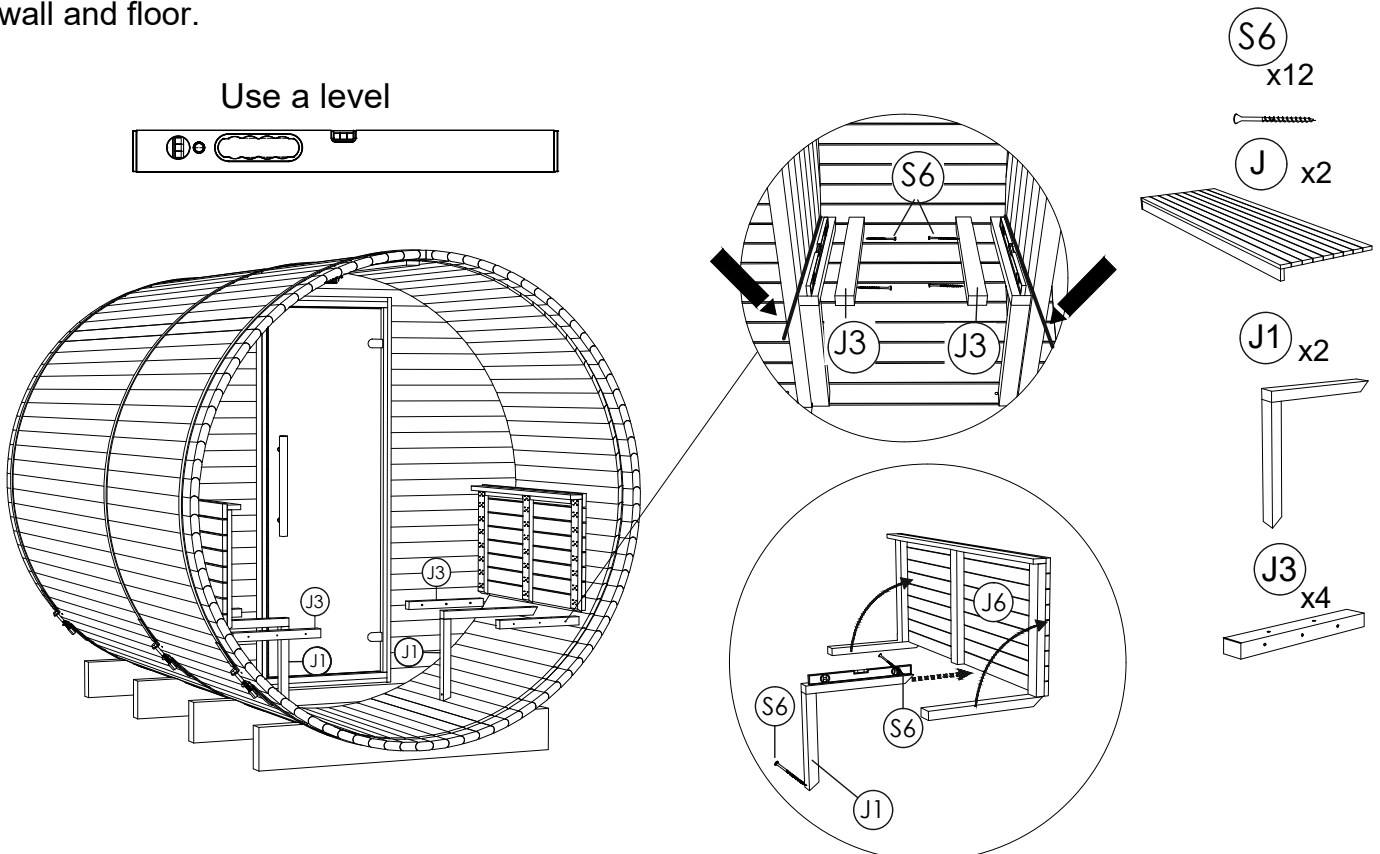
**STEP 20:** To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, draw a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall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



**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 (S16) screws.



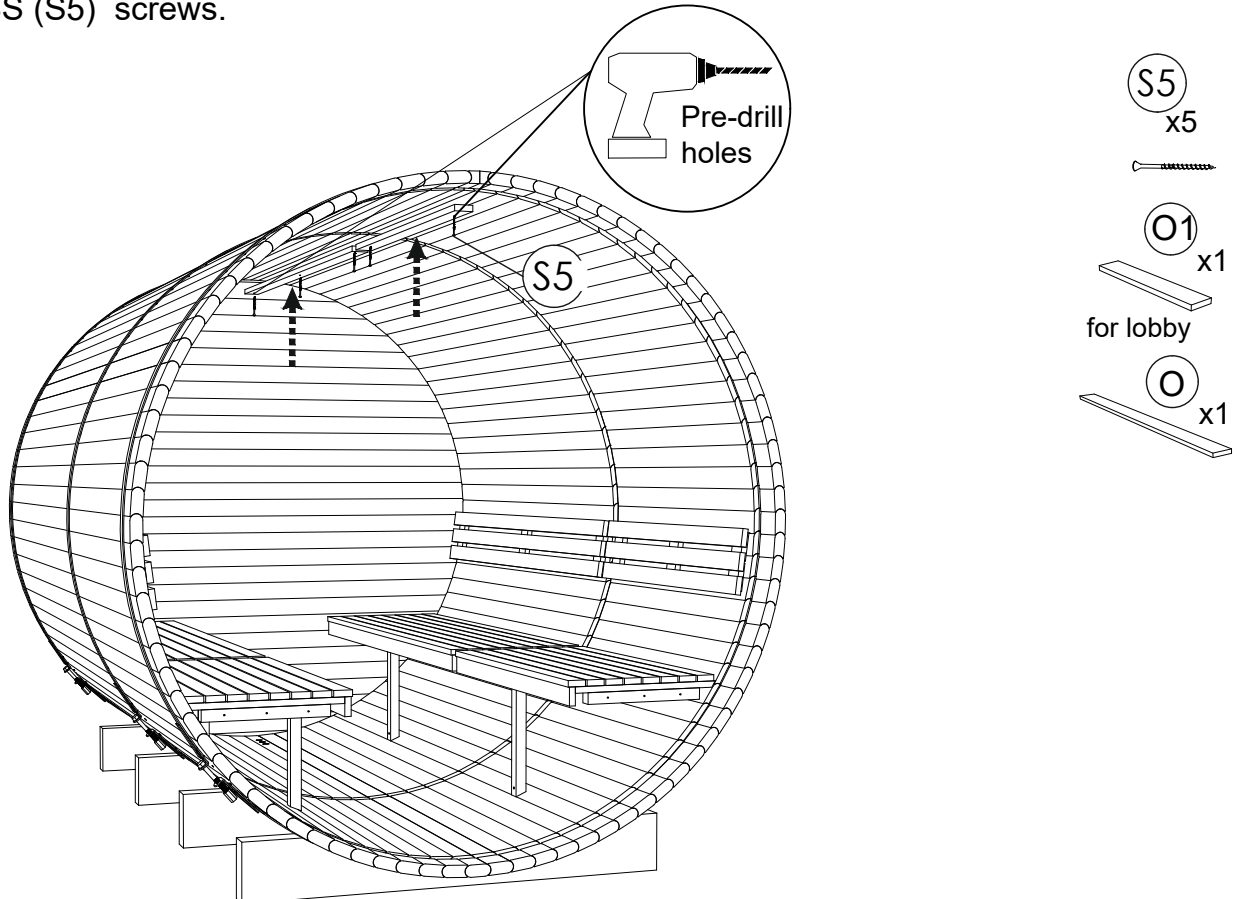
**STEP 22:** To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, draw a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall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



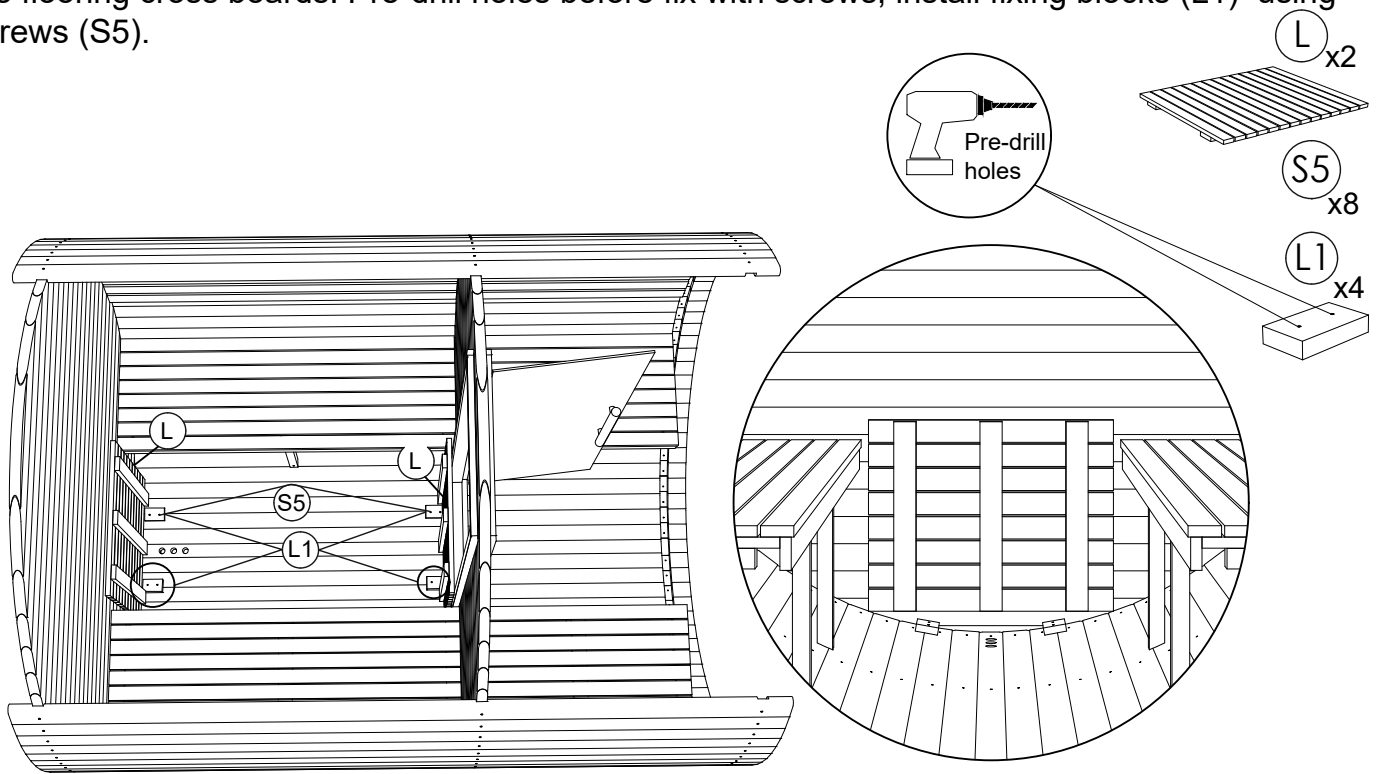
**STEP 23:** Pre-drill holes before fix backrest with screws, install backrests (J5) using screw (S5). Fix sauna bench (J6) to wall mounts and support leg using (S16) screws.



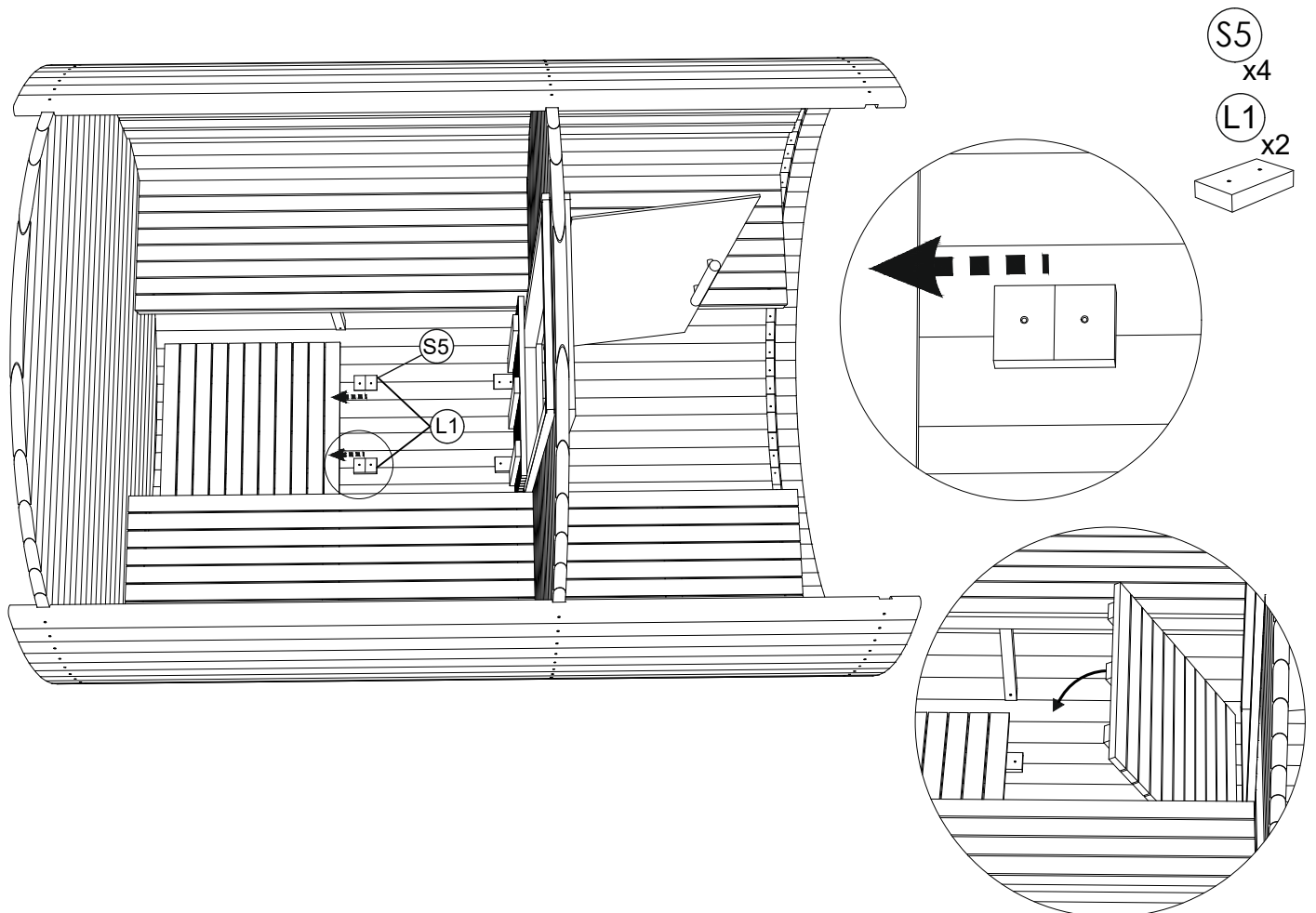
**STEP 24:** Pre-drill holes before fix staves with screws, install interior roof trim (O) in sauna with 4.0 x 50 SS (S5) screws.



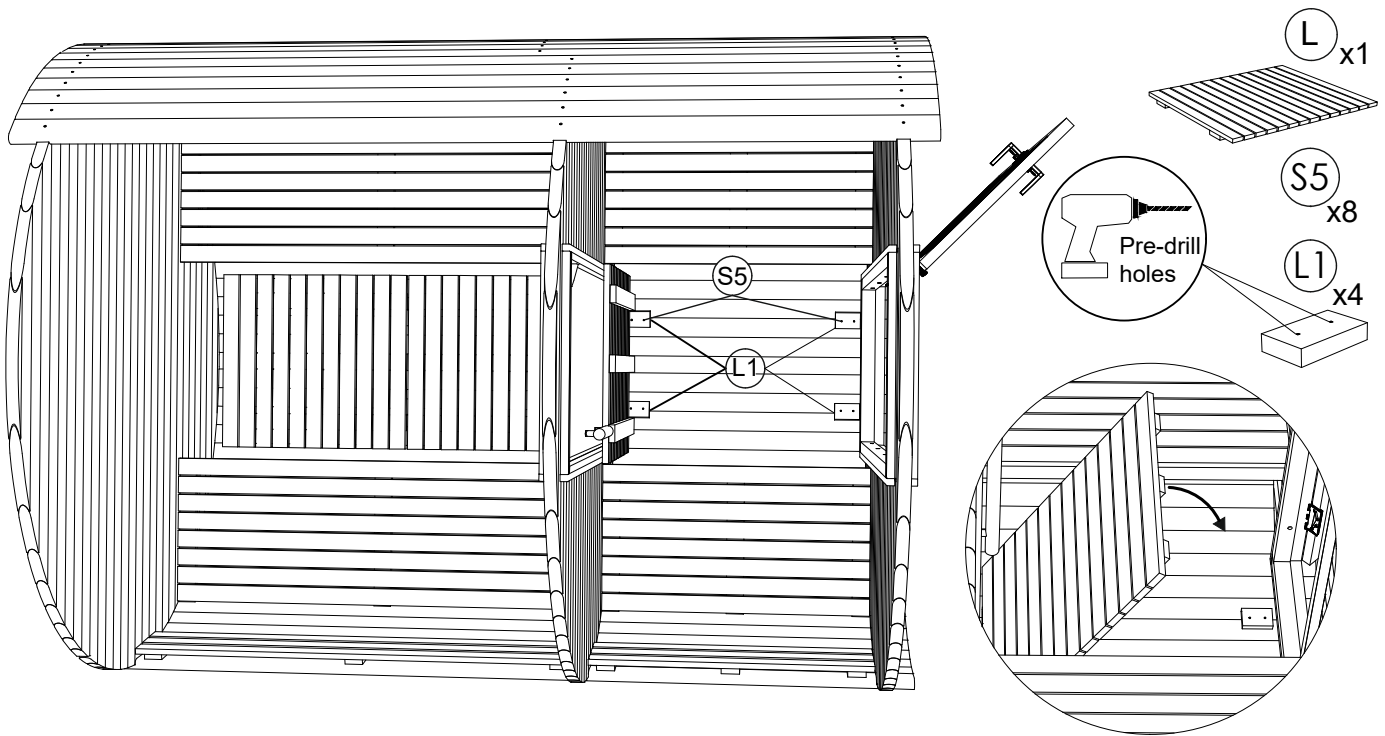
**STEP 25:** Place floor duckboards (L) to the both sides upwards and place fixing blocks next to the flooring cross boards. Pre-drill holes before fix with screws, install fixing blocks (L1) using screws (S5).



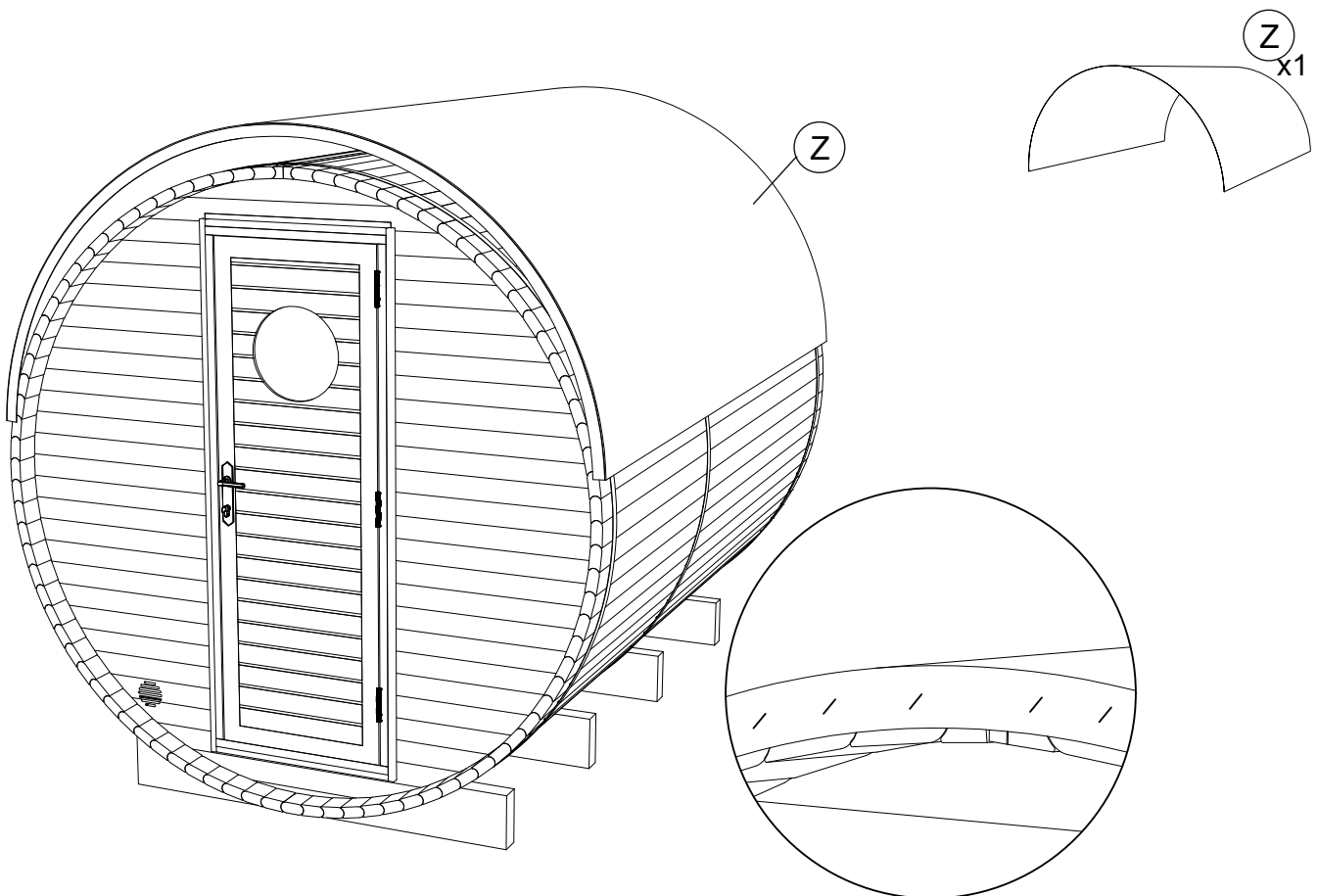
**STEP 26:** Pre-drill holes before fix with screws, install fixing blocks (L1) under floor duckboard using screws (S5). Place floor duckboards (L) on the floor and fix fixing blocks (L1), about half it's size, next to both flooring cross boards. Place last floor duckboard on to the floor.



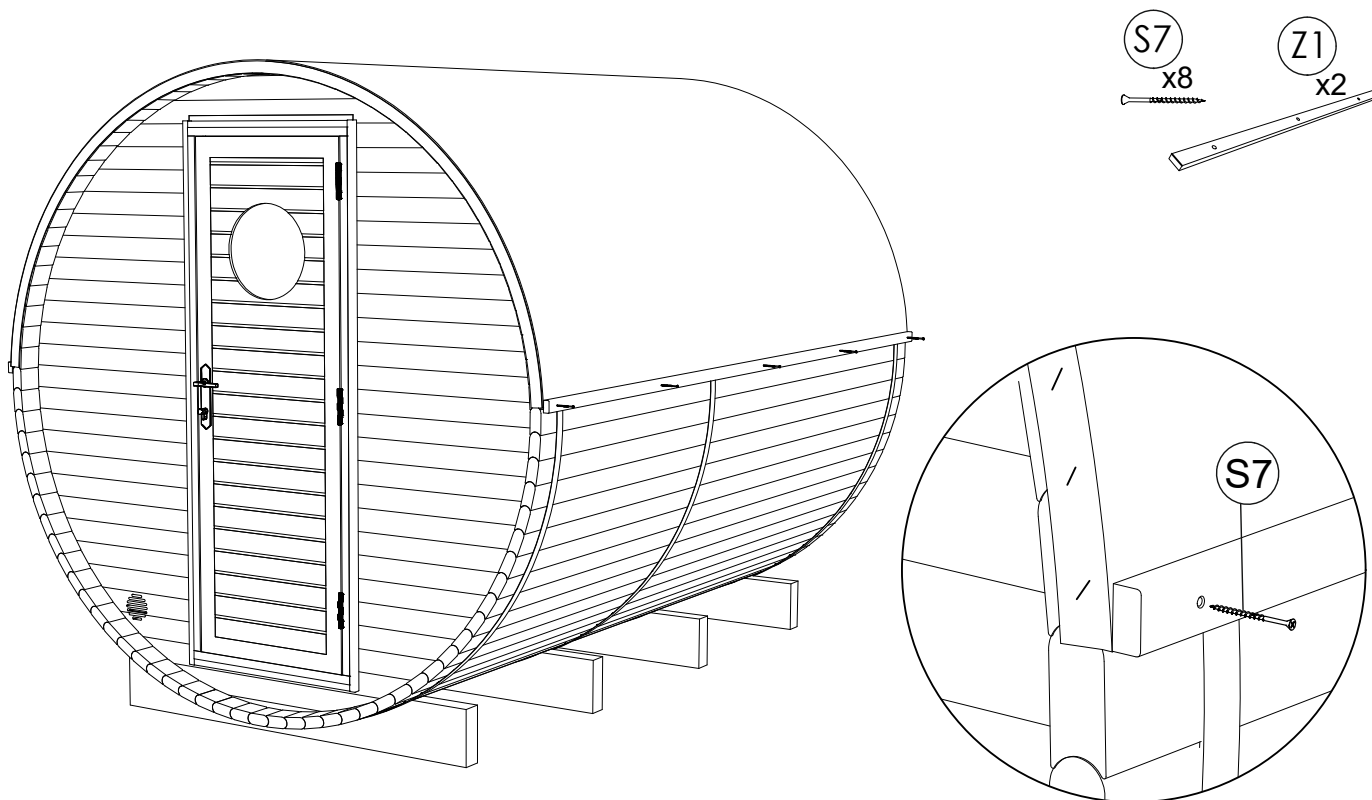
**STEP 27:** Place floor duckboards (L) to the one side upwards and place fixing blocks next to the flooring cross boards. Pre-drill holes before fix with screws, install fixing blocks (L1) using screws (S5). Place floor duckboard on the floor.



**STEP 28:** Place waterproof PVC roof cover . Align roof cover equally to both sides. Roof cover goes about  $1 \frac{37}{64}$ in 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.

