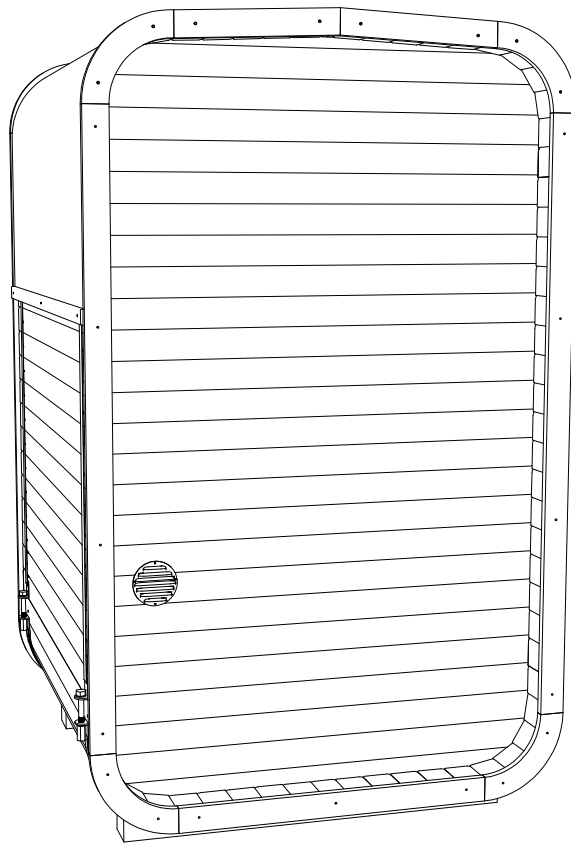


# SQUARE SAUNA ASSEMBLY INSTRUCTIONS



Model: No45

**Note: Please read this manual carefully before starting construction**

Rev. 18.05.2026

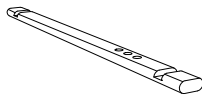
# PARTS LIST

**A** x2



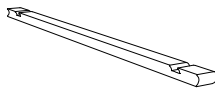
cradle

**B** x1



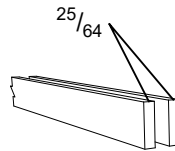
center stave

**C** x78



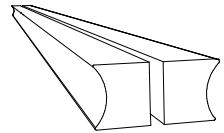
body stave

**H1** x2  
25/64



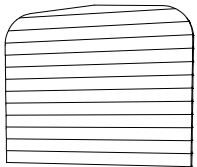
different thickness filling peaces

**H** x2



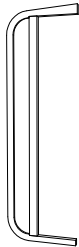
final H tipe stave at the top

**V3** x1



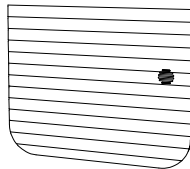
upper rear panel

**F** x2



front panel

**V** x1



bottom rear panel

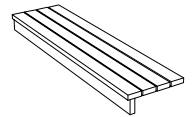
**F2** x1



door and door moldings

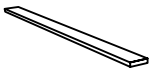
x2  
x1

**J5** x1



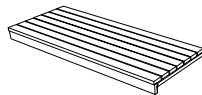
sauna bench step

**O** x1



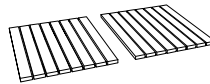
roof board

**J** x1



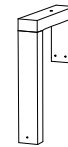
sauna bench

**L** x2



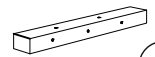
sauna floor

**J1** x1



supporting leg

**J3** x2



support board for sauna bench

**J8** x1

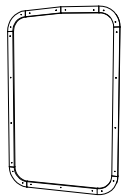


**J2** x1



backrest

**W** x18



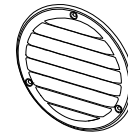
decorative roof finishing boards

**Y** x1



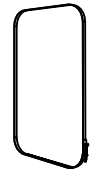
rubber seal for panels

**Y1** x1



screw 3.0x25 brown ventilation grill

**I** x2



metal band

**J9** x1



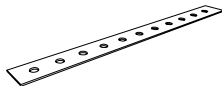
support board for sauna bench

x2



wood pin

**D** x1



metal bracket

**S1** x23



screw 5.0x100 SS

**S10** x140



screw 4.0x60

**S4** x4



screw 5.0x120

**S6** x29



screw 5.0x70 SS

**S7** x47



screw 4.2x55 brown

**S12** x6



screw 4.0x30

**S5** x25



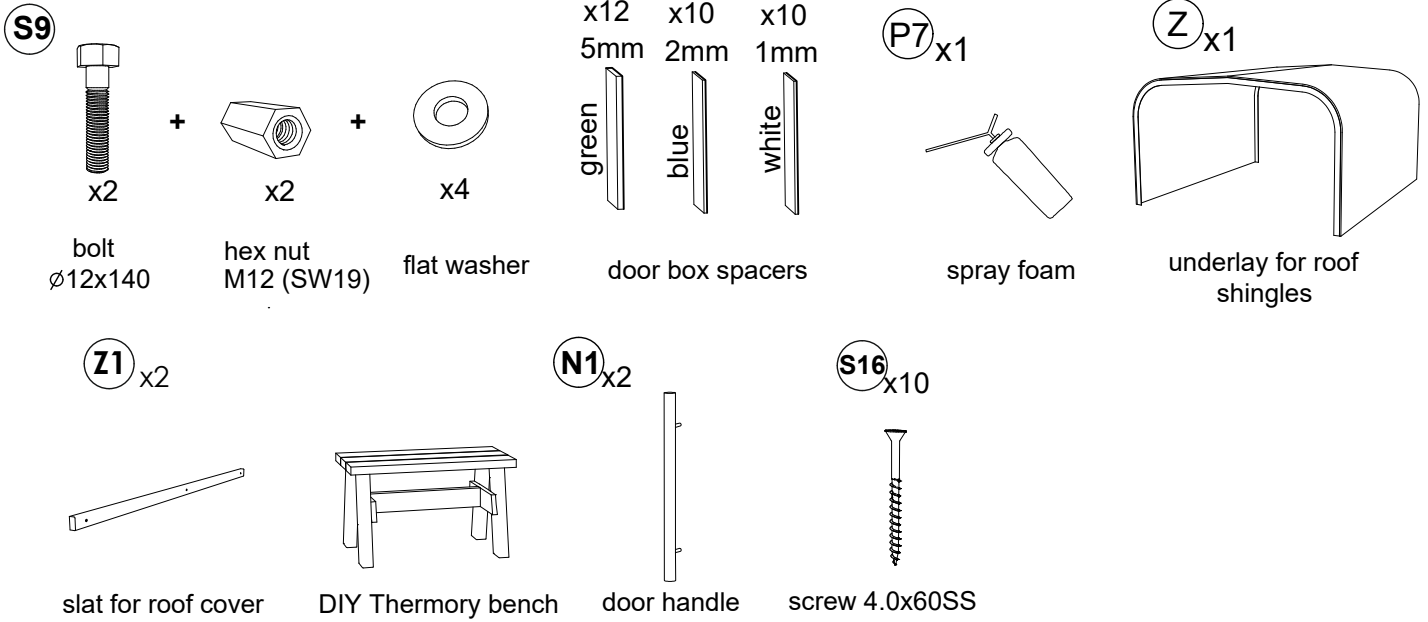
screw 4.0x50 SS

**S14** x8



















screw 5.0x80

# PARTS LIST



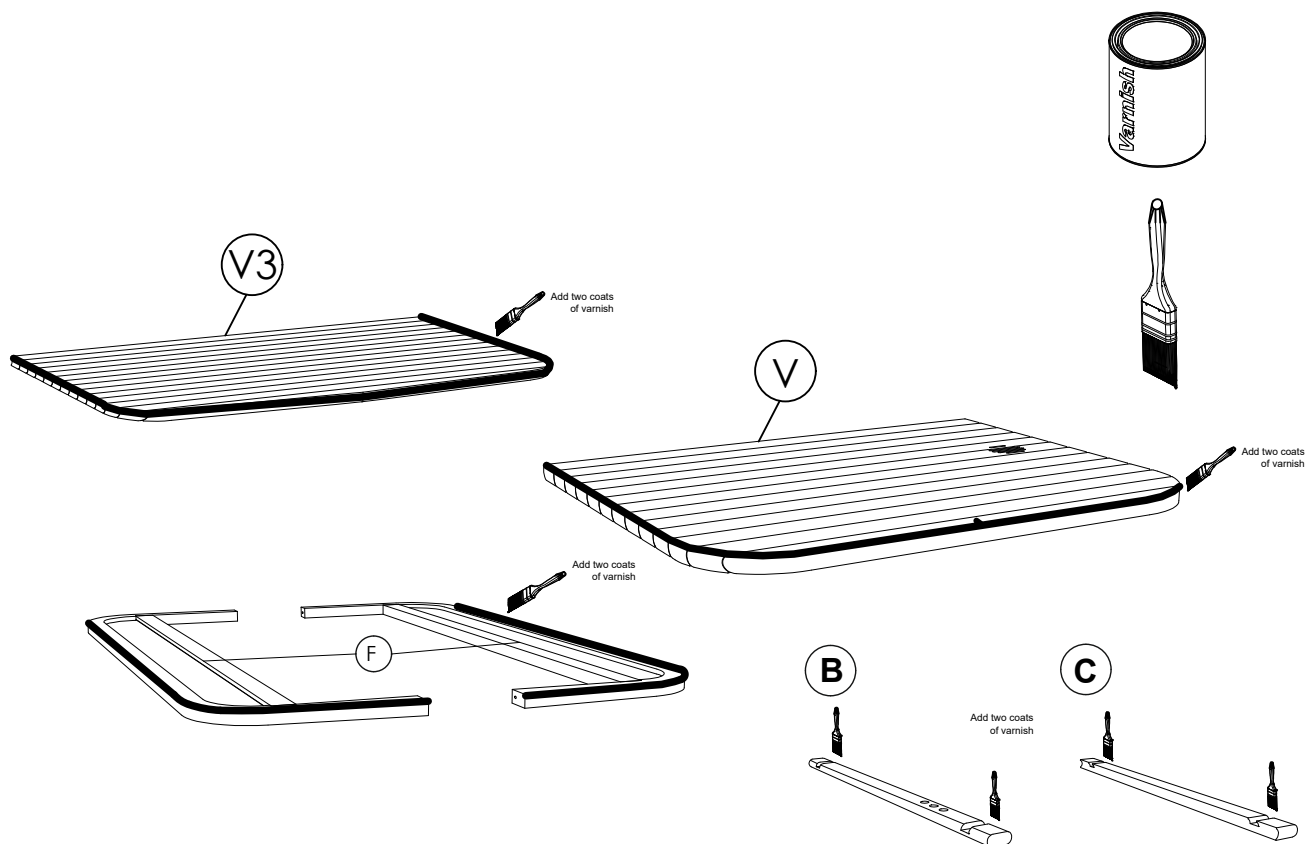
## REQUIRED TOOLS

	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		

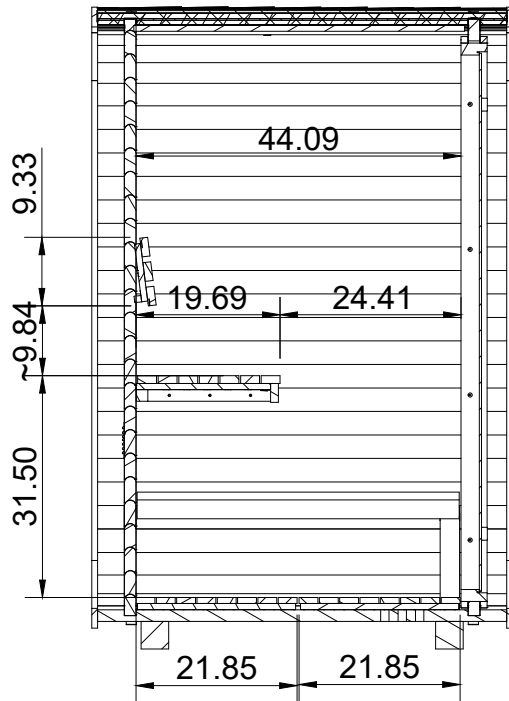
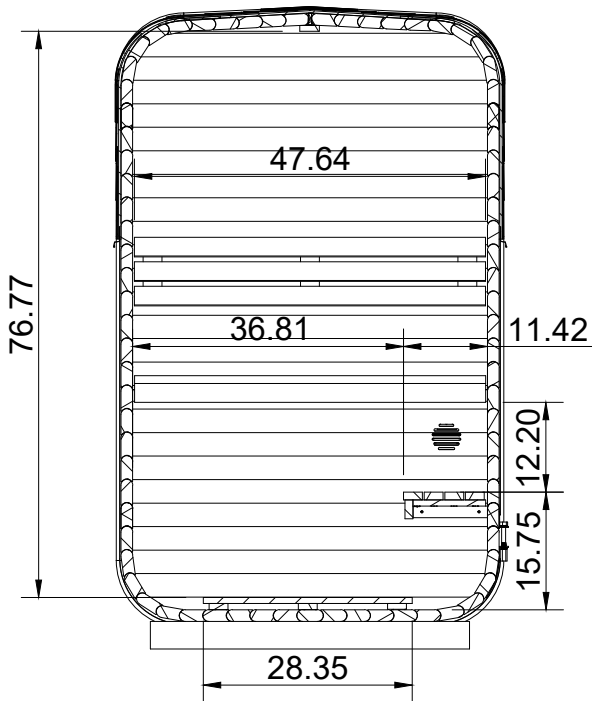
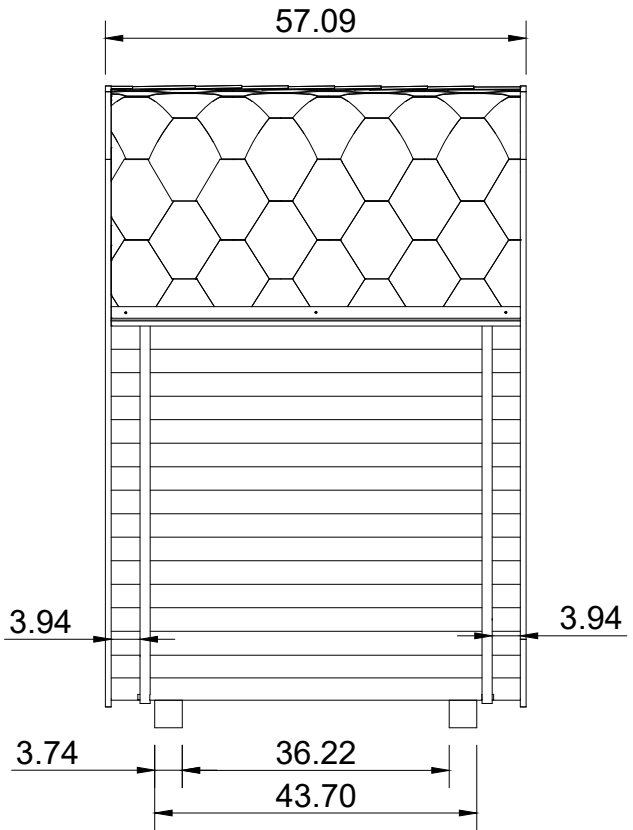
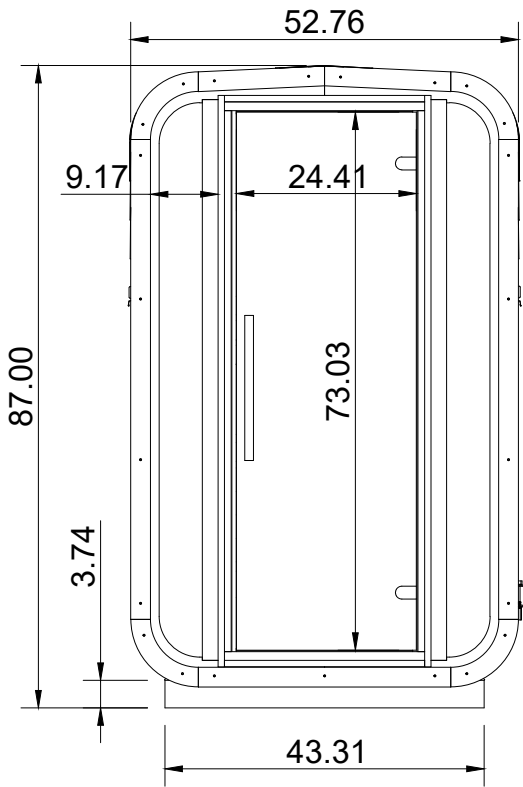
## RECOMENDATION

1. It is recommended to install the sauna above ground level to prevent the base legs of the sauna from coming into direct contact with the ground.
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. Keep in mind that the roof covering should not be damaged during snow removal.

**Before start to build the sauna, first apply two coats of wood varnish to the sides of each panel**

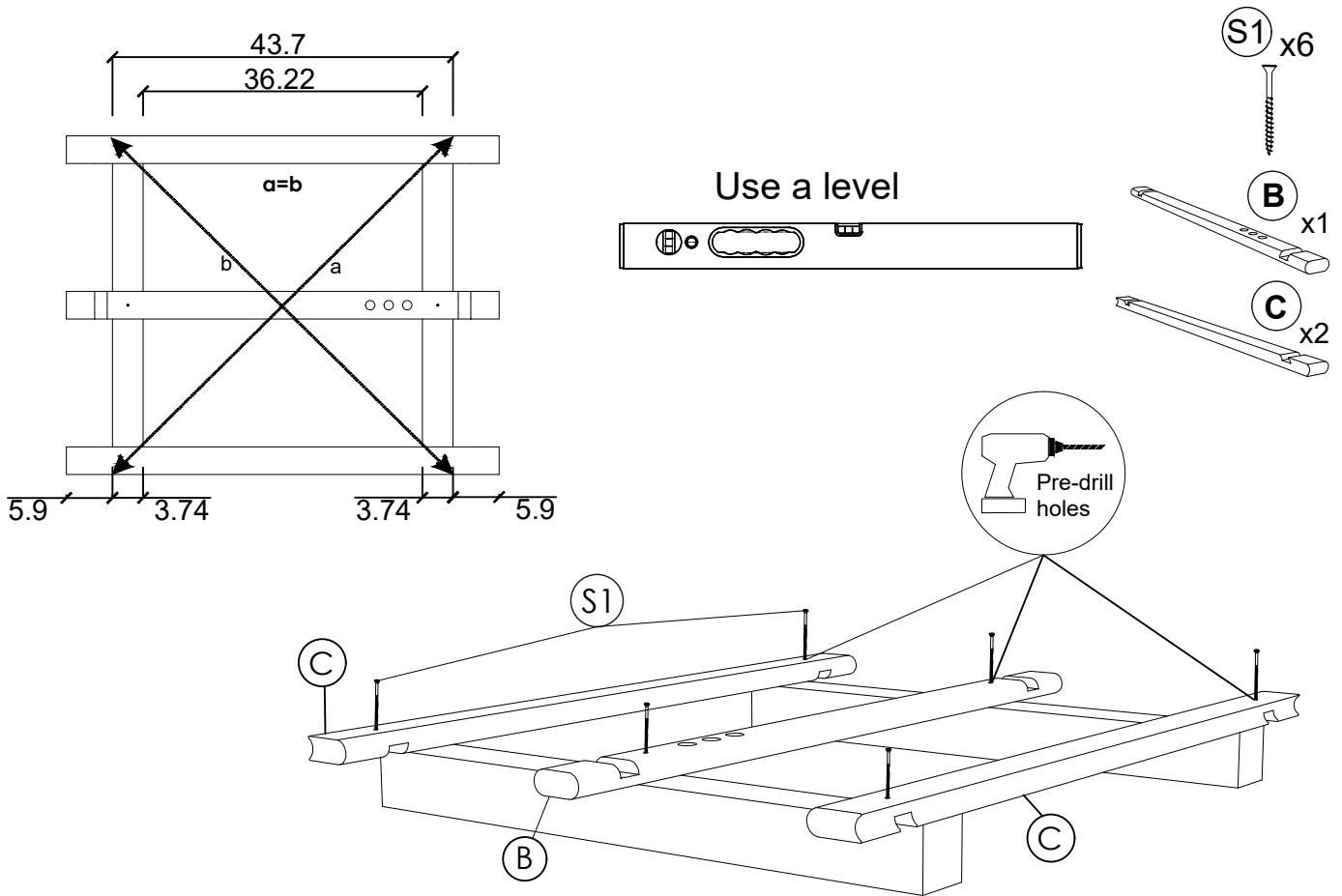


### Barrel dimensions

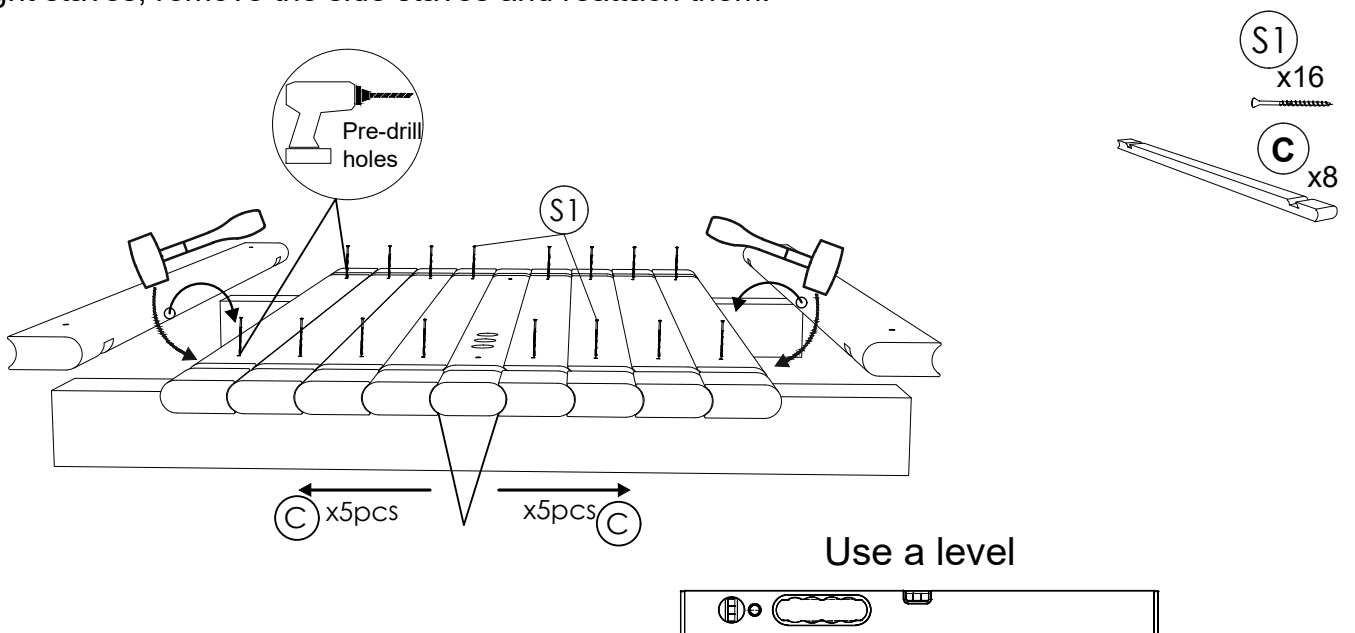


The dimensions on the drawings are informative, rounded values. Units of measurement-inches.

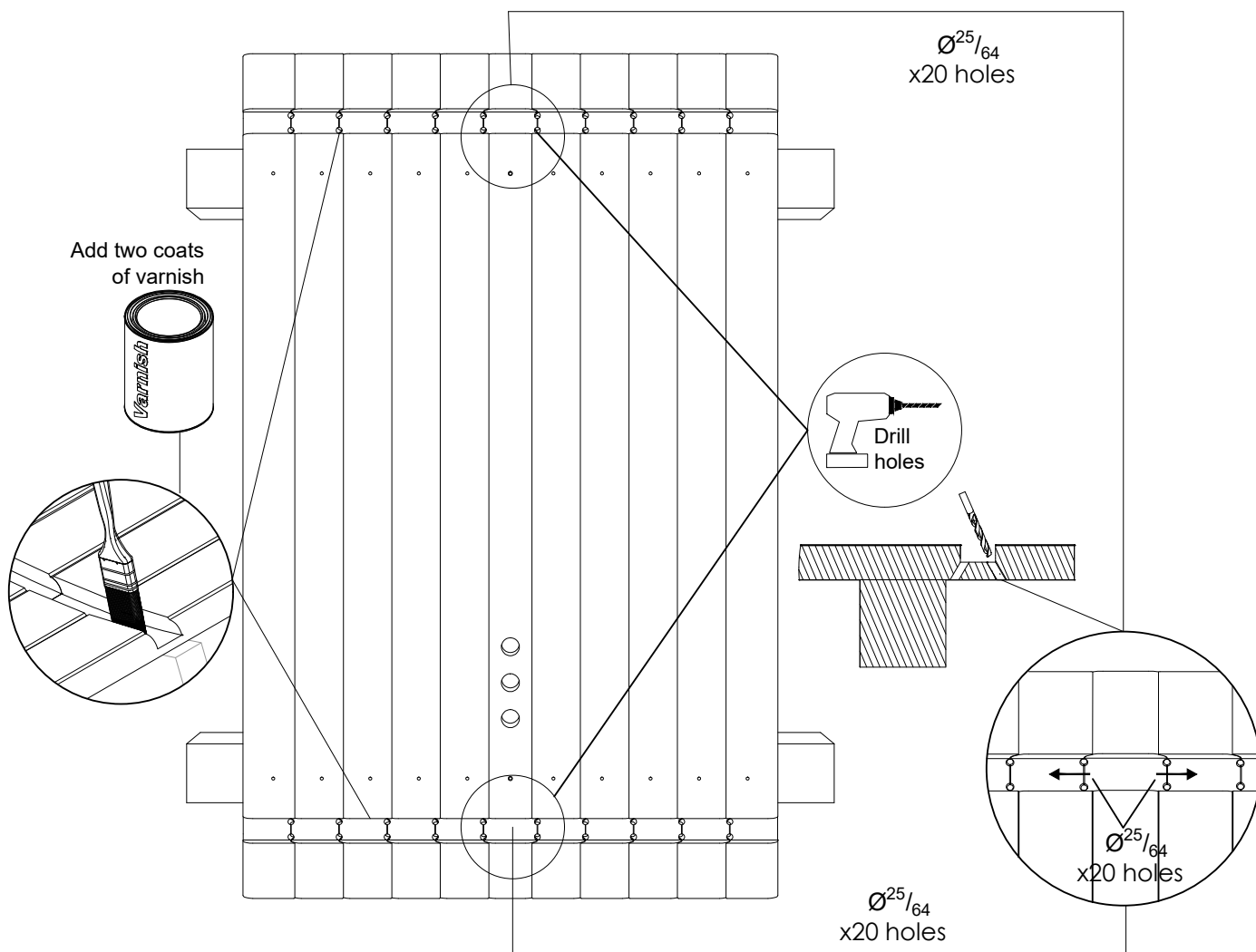
**STEP 1:** Place cradles on prepared surface. The base for the sauna cradles must be level and sturdy. Measure diagonally from corner to corner, ensuring measurements 'a' and 'b' are equal. The distance between cradles are in picture. Fix staves on both sides of the cradles to prevent any change in measurements. Check the levels again. Pre-drill holes before fixing the staves with screws. Fix the center stave (B) in the middle of the cradles. Leave the stave 5.9in over the cradle on both sides.



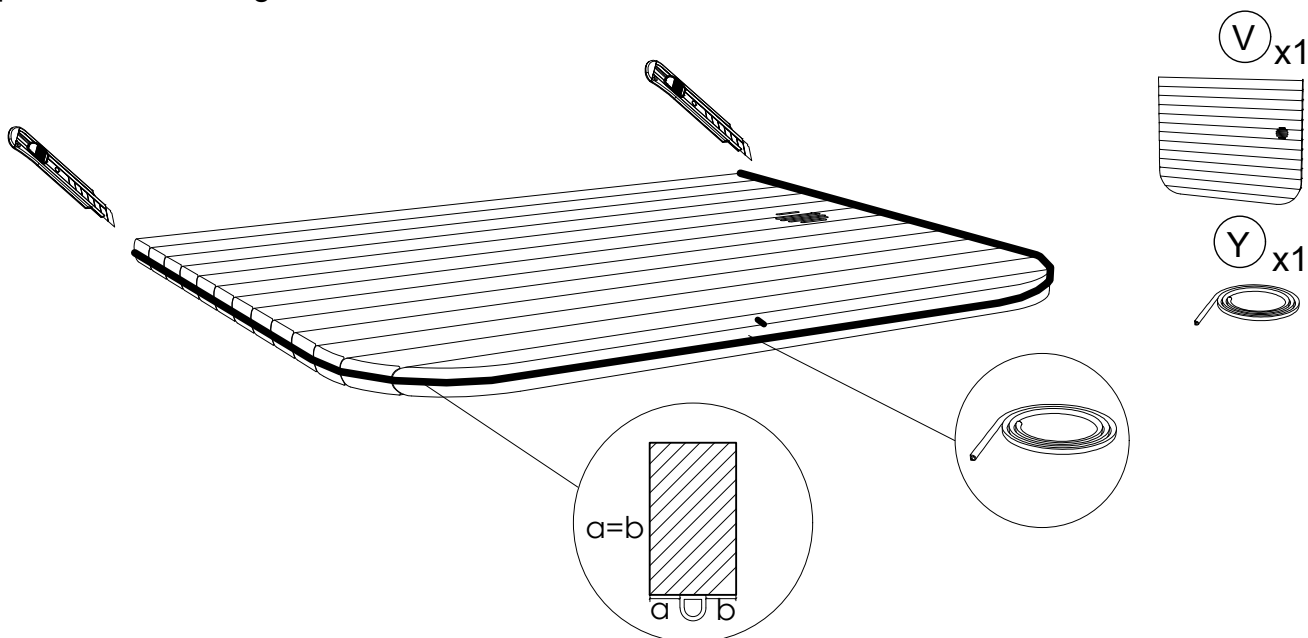
**STEP 2:** Attach five staves (C) on each side of the center stave. Check the level while installing the staves and use a rubber hammer for a tighter fit. Pre-drill holes for the screws. After fixing eight staves, remove the side staves and reattach them.



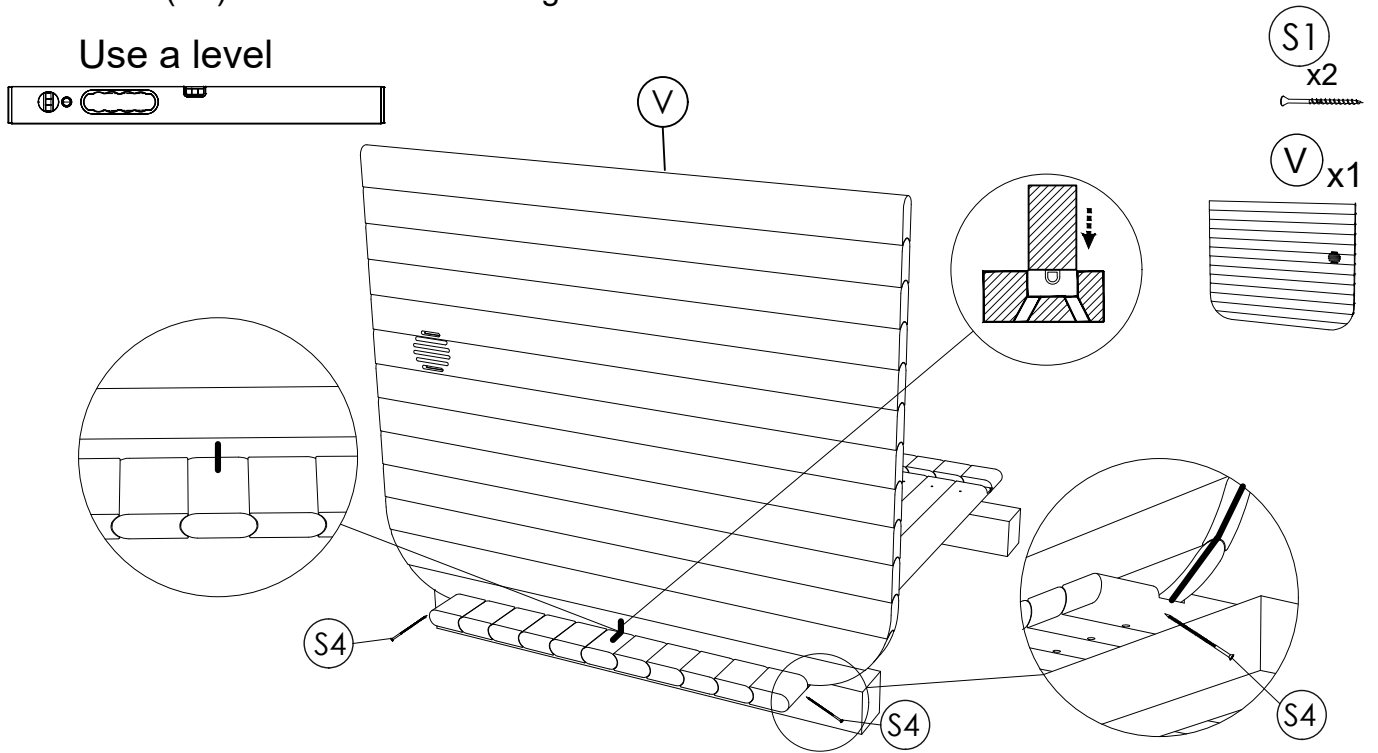
**STEP3:** Drill twenty 25/64-inch holes in front and back wall groove to the out-side in board connections as shown in the picture. Drill them in  $\approx 30^\circ$  angle. This will help drain excess water faster. Clean the groove from wood waste and other dirt. Cover the grooves with varnish.



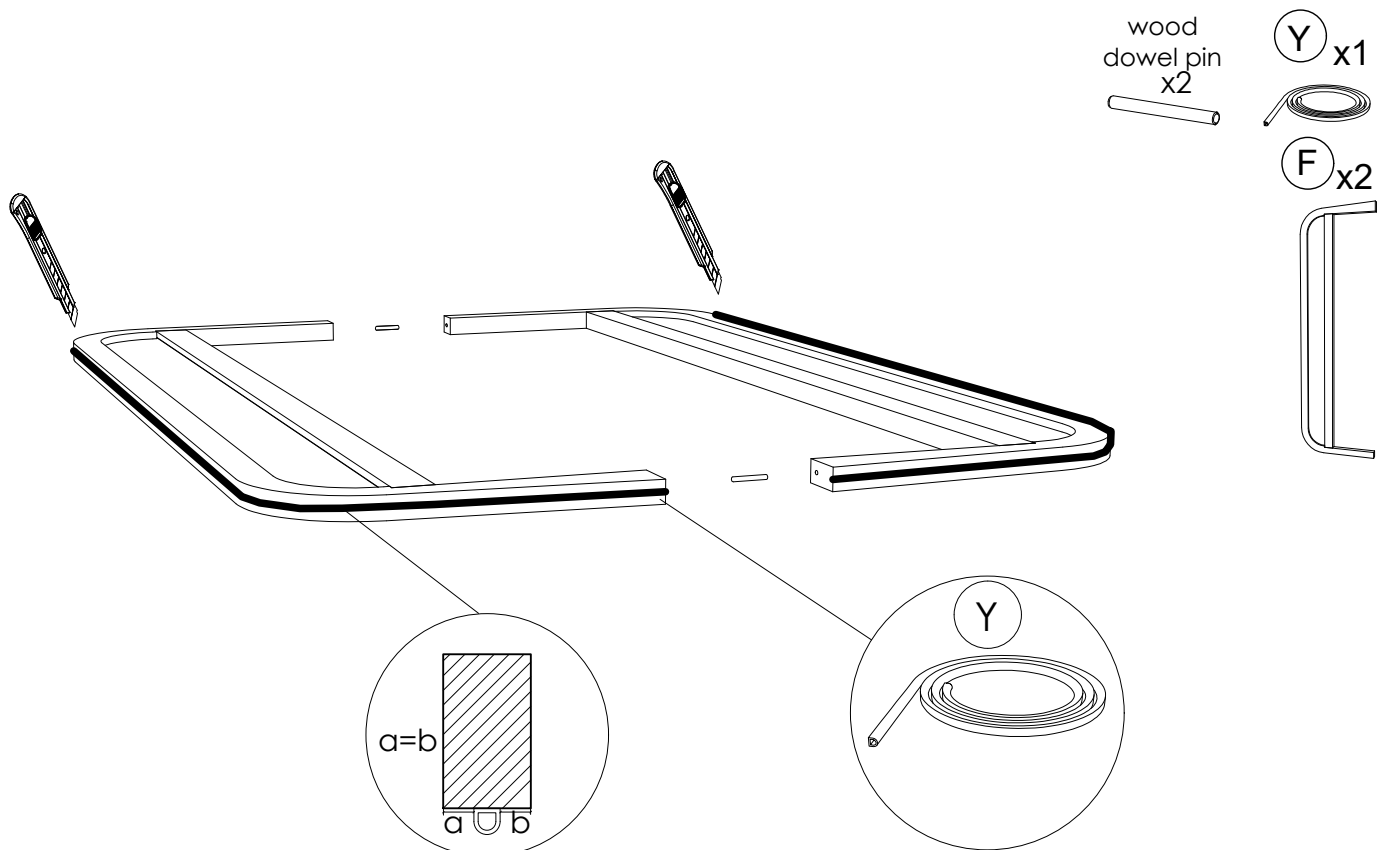
**STEP 4:** Attach rubber seal on the middle of the rear panel side edge and cut it at the end of the panel top. See next step to understand panel placement. At the bottom of the rear panel (V), draw a line where the centre of the panel is. Do the same on the centre stave of the floor, where the panel will be sitting.



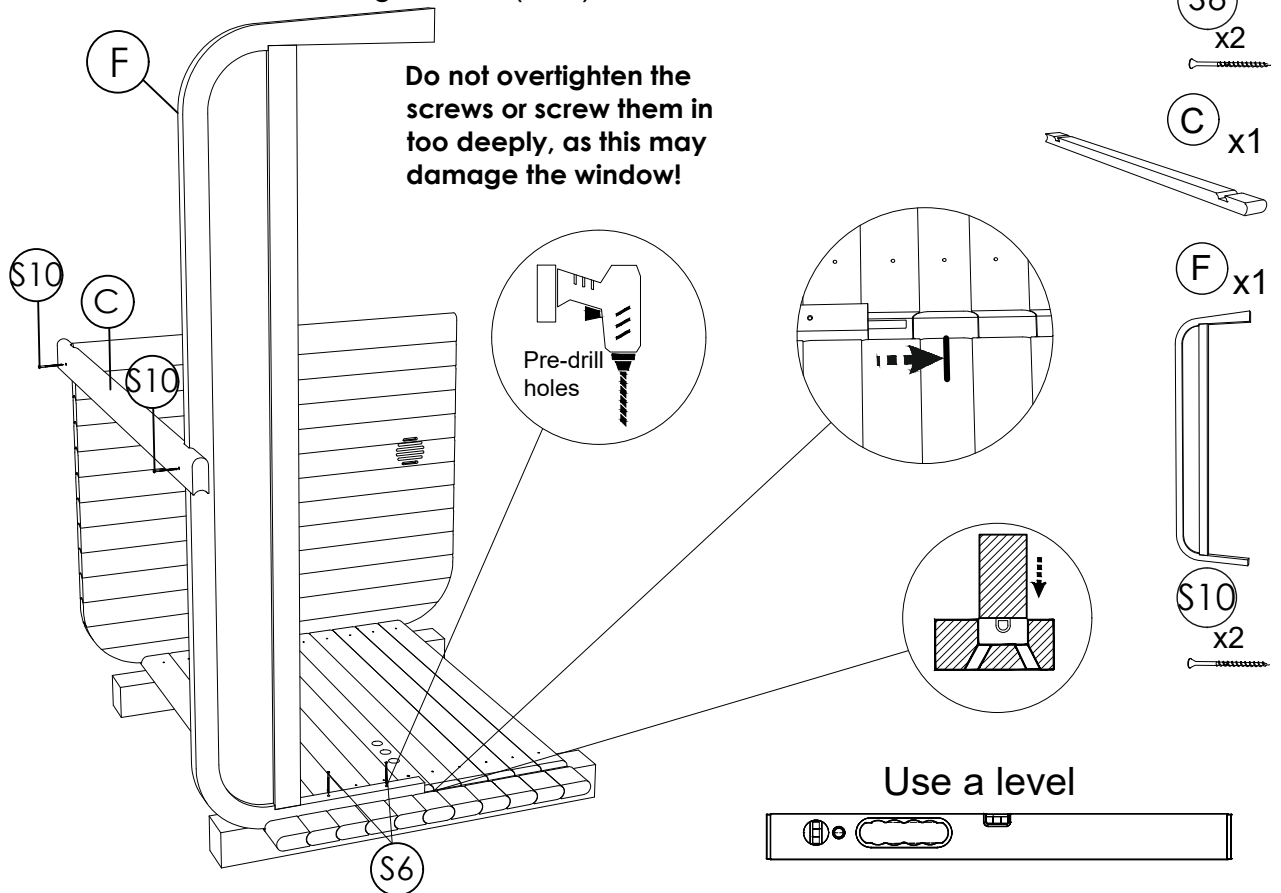
**STEP 5:** Place the rear bottom panel (V) into the board groove. Ensure the panel is level. Secure it with screws (S4) at both corners through the stave.



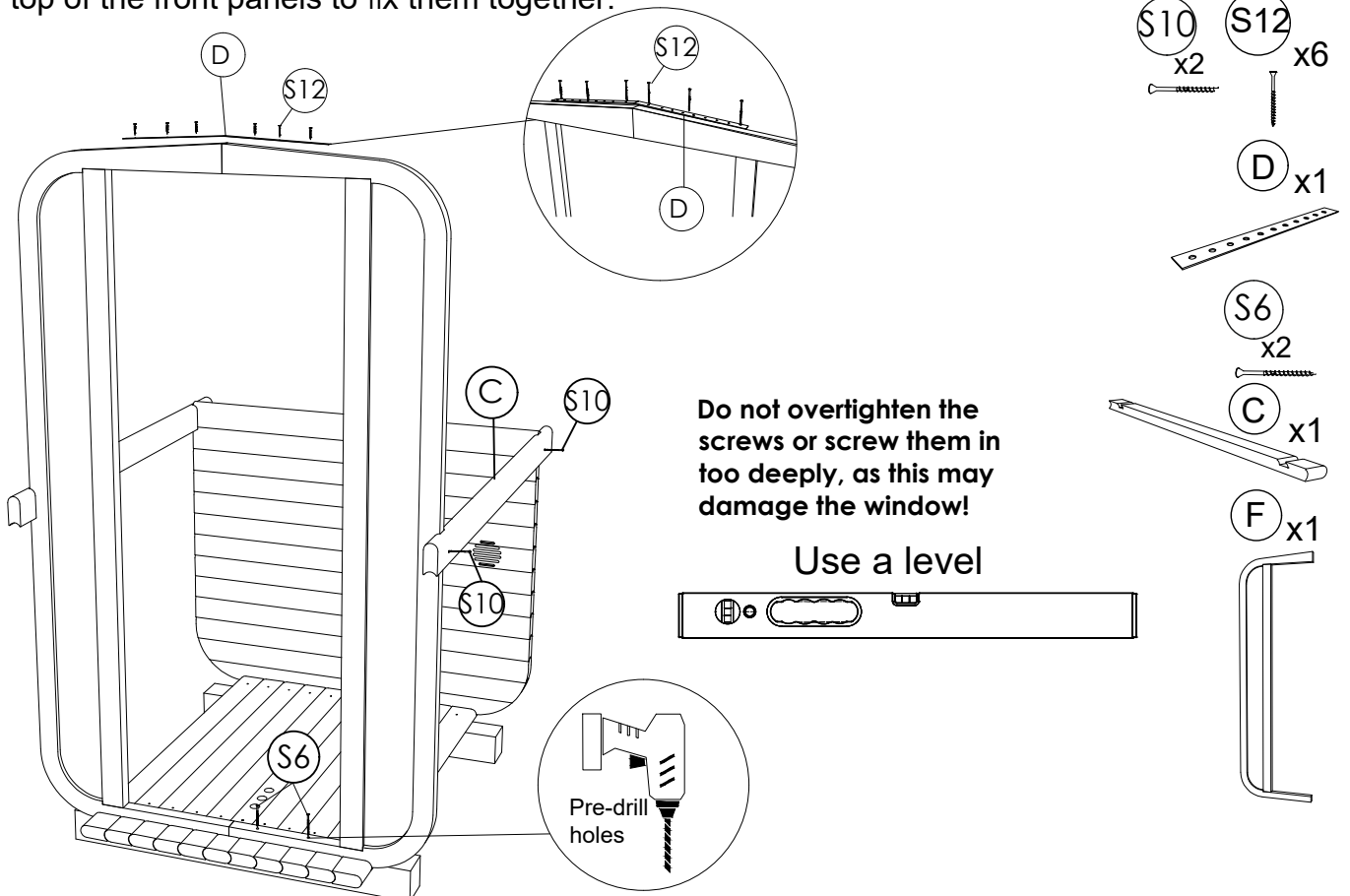
**STEP 6:** Attach rubber seal along the middle of the side edge for front panels (F) and cut it at the start of the corner. Insert wood pin in both holes of the front panel top and bottom.



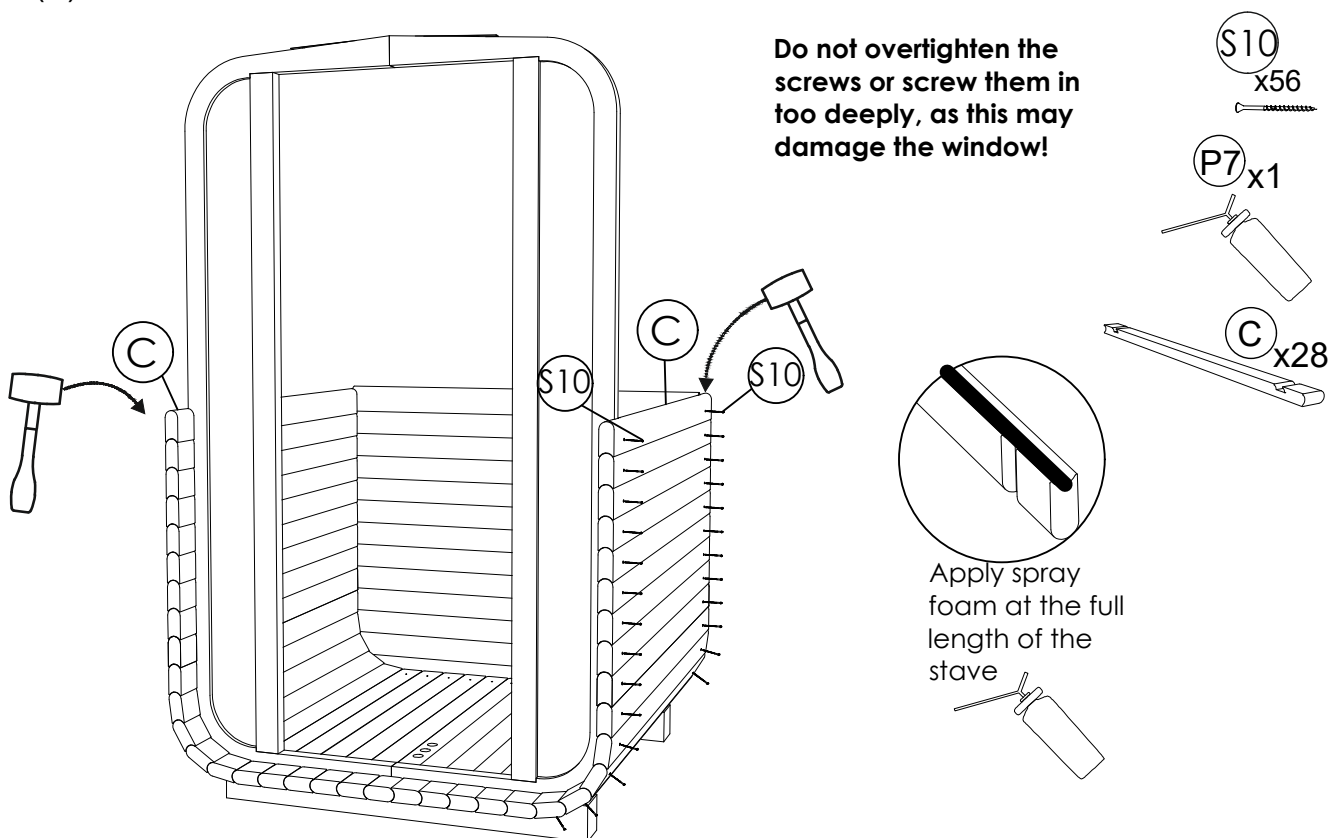
**STEP 7:** Draw a line on the center stave where the middle is. Take one of the panels (F) and put it directly next to the middle line. Fix it at the panel threshold with screws (S6). Pre-drill holes in the panel threshold, evenly spaced and not too close to the sides. Connect both panels with (C) stave, front and back, and fix using screws (S10). Make sure it's leveled.



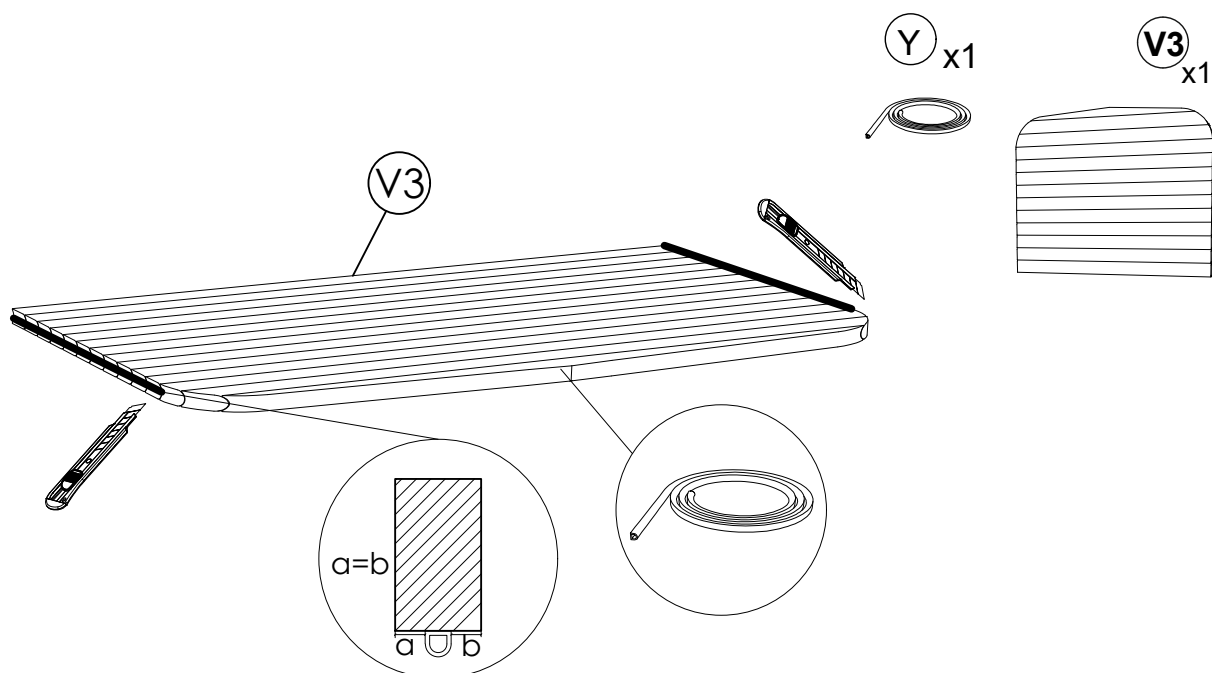
**STEP 8:** Place the second front panel (F). Slide it together that the top and bottom connects. Fix it at the panel threshold with screws (S6) pre-drill holes. Make sure it's level. Use metal bracket on top of the front panels to fix them together.



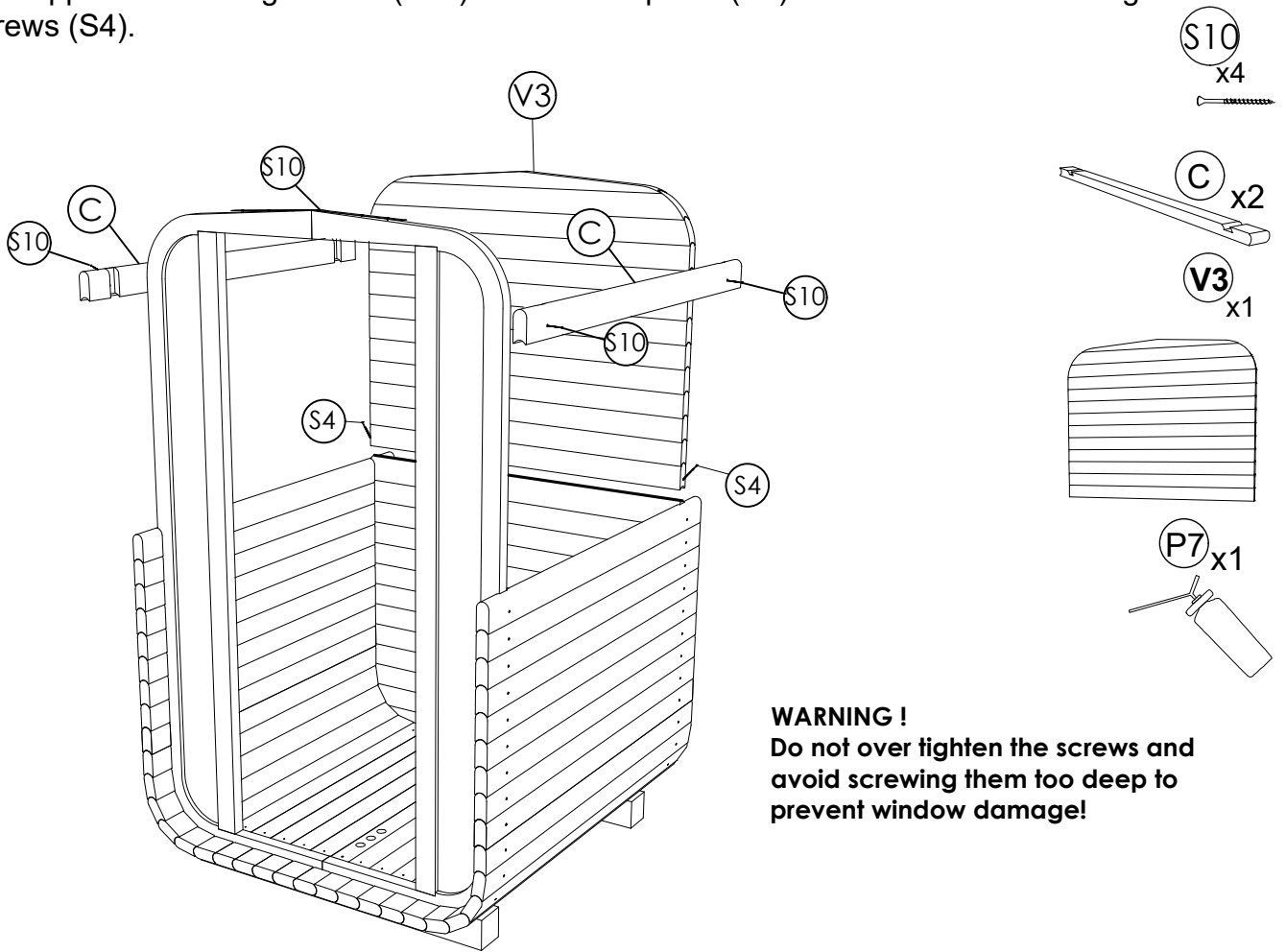
**STEP 9:** Fix 14 staves (C) on both sides with screws (S10). Use rubber hammer for tighter placement. Use spray foam between every staff. Keep fixing staves till reach top of the rear panel (V).



**STEP 10:** Attach rubber seal along the middle of the side edge for front panels (F) and cut it at the start of the corner. Insert wood pin in both holes of the front panel top and bottom.

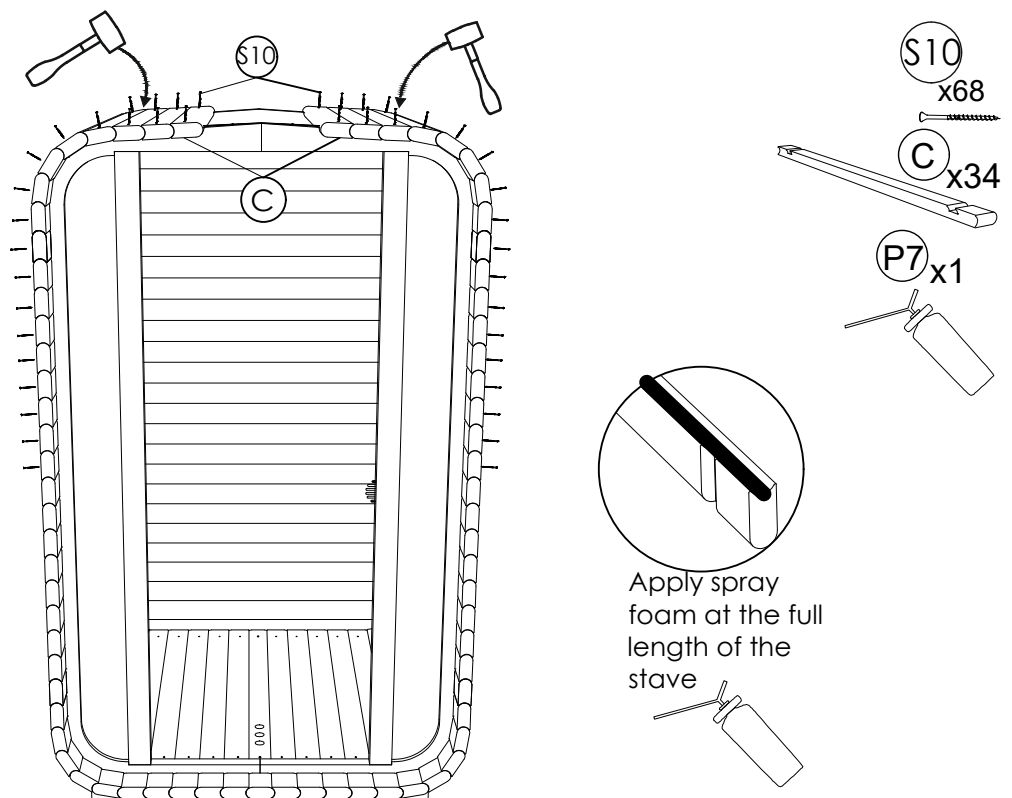


**STEP 11:** Install the panel (V3) with caution. Use spray foam between panels for better insulation. Place it on top of the lower back panel (V). Check level and that side edges are aligned with bottom panel. One keeps holding the panel, and the other is fixing the side stave on a upper curve using screws (S10). Secure the panel (V3) at the both corners using two screws (S4).



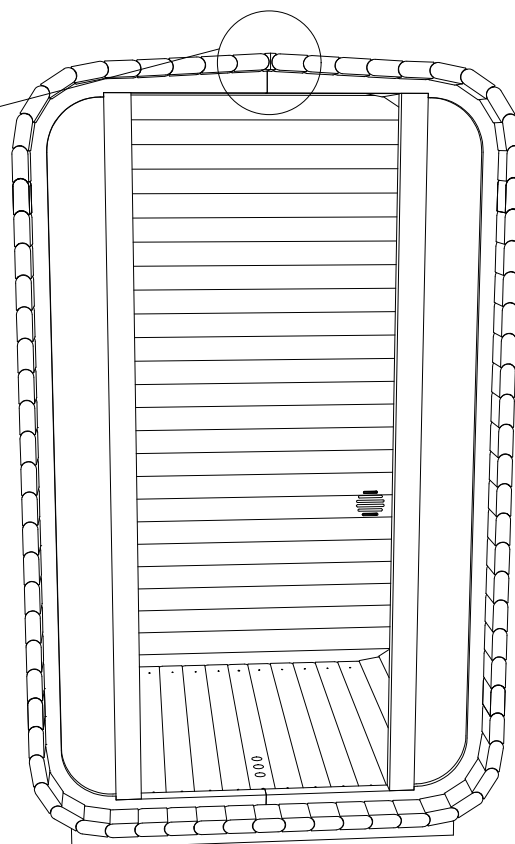
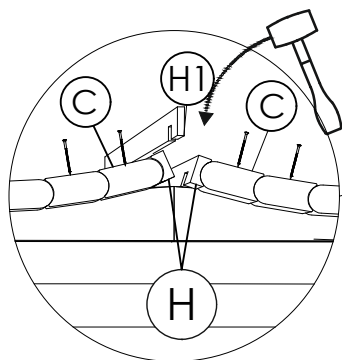
**WARNING !**  
Do not over tighten the screws and avoid screwing them too deep to prevent window damage!





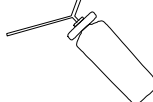
**STEP 12:** Fix 17 staves (C) on both sides with screws (S10). Use rubber hammer for tighter placement. Use spray foam between every stave. Keep fixing staves till reach top of the roof.



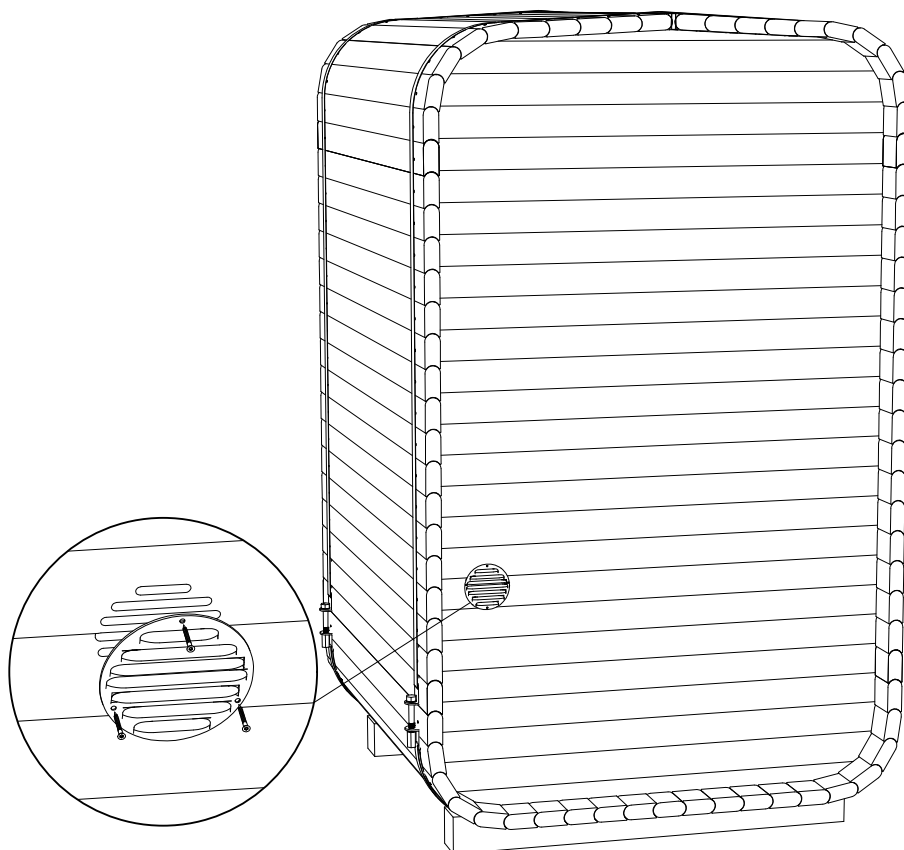
Do not over tighten the screws or screw them in too deeply, as this may damage the window!


**STEP 13:** Finish roof with (C) staves and final staves (H). If needed, use thinner staves (H1) to fill the gap between (H) staves and apply spray foam between staves. Make sure that centre of the roof is tightly filled, then fix with screws (S10). It's possible that at the roof center wont be place for (H) staves and it finishes with just (C) boards.



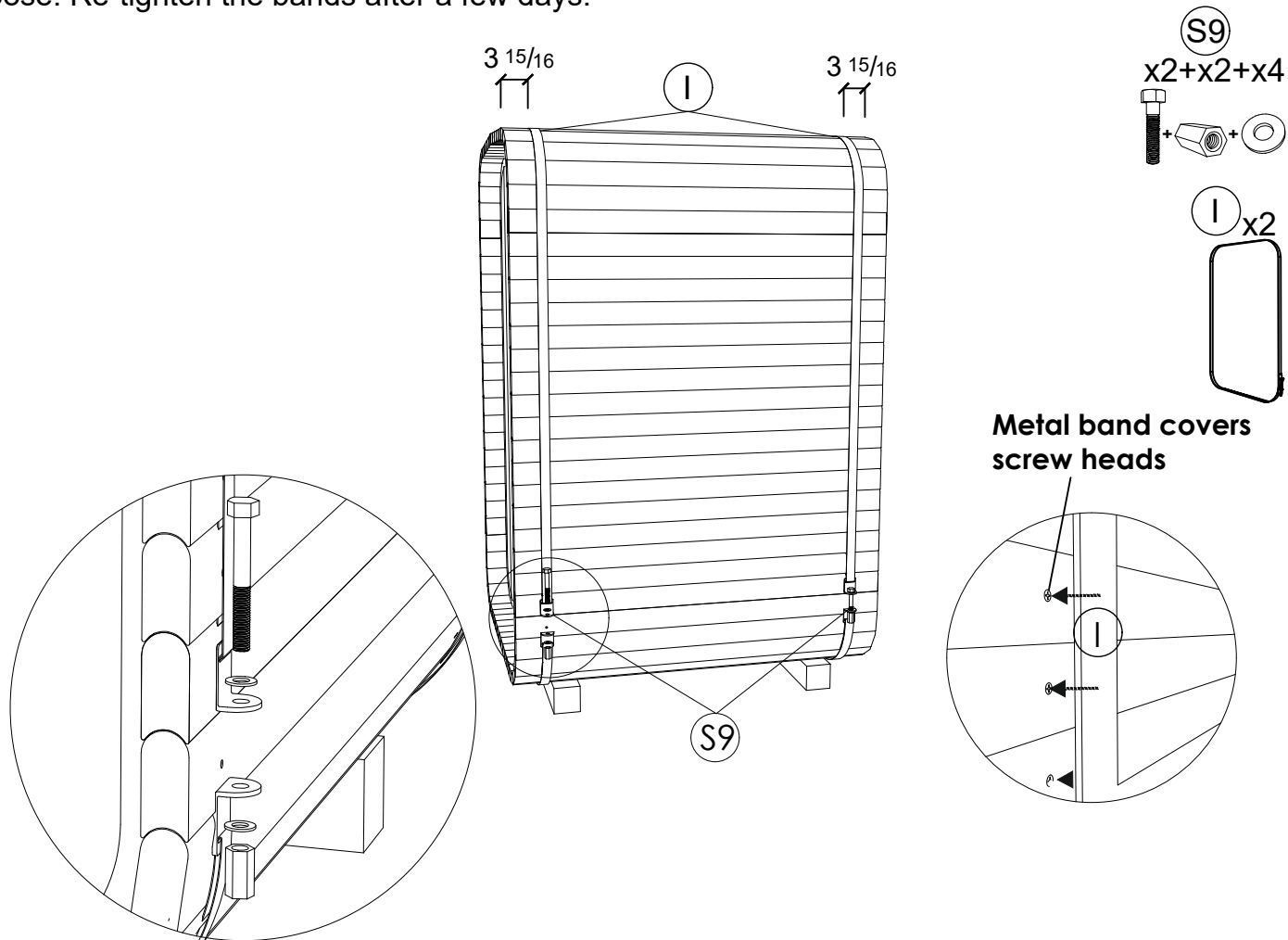
- (S10) x12  

- (C) x4  

- (H1) x2  

- (H) x2  

- (P7) x1  


**STEP 14** Install ventilation grill from outside over the ventilation cuts.

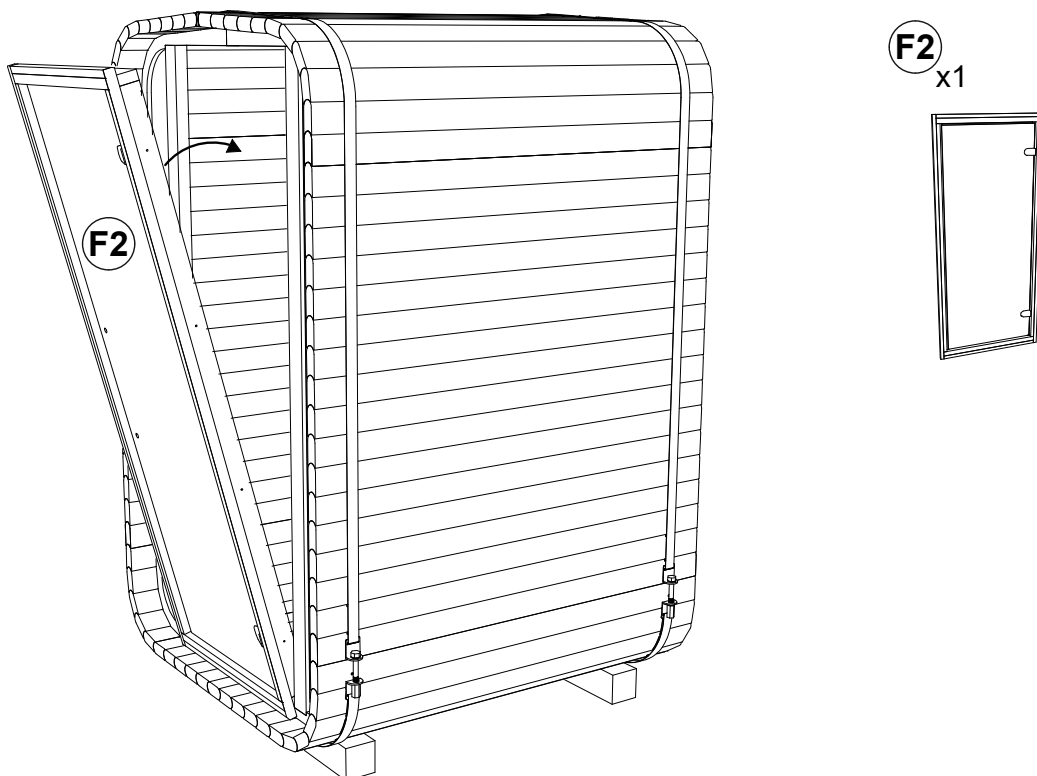


- (Y1) x1  


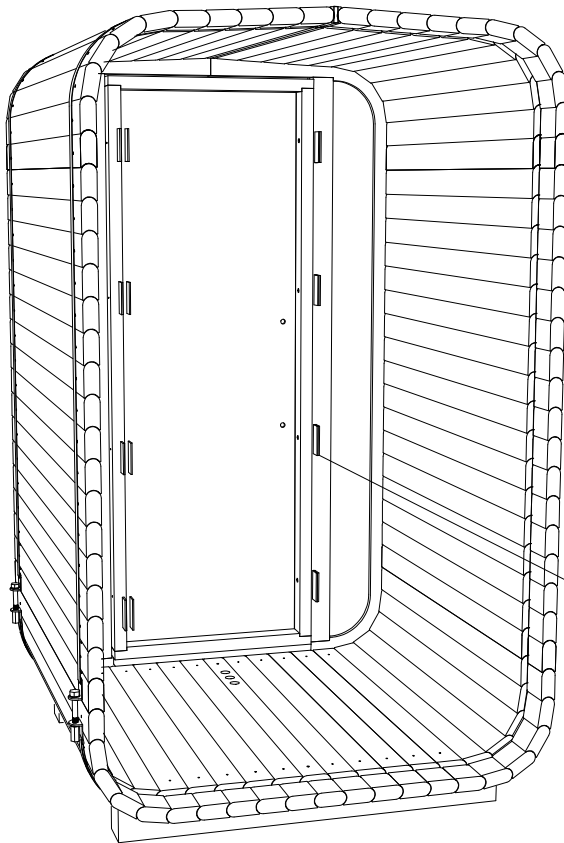
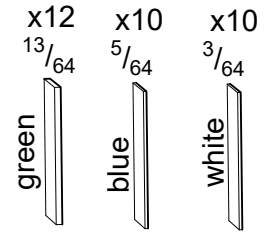
**STEP 15:** Install metal bands over the screw heads. **Screws (S9) must be placed as shown in picture**, then tighten the screws. Check the bands align evenly all around the sauna  $3\frac{15}{16}$ in from the back and front. Keep tightening bands till you feel strong resistance, bands can't be loose. Re-tighten the bands after a few days.



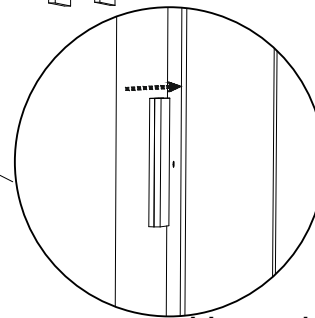
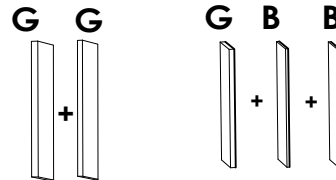
**STEP 16:** Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix the doors with clamps, or have another person hold the door in place.



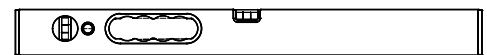
**STEP 17:** Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. Spacer must fit tightly.



example



Use a level

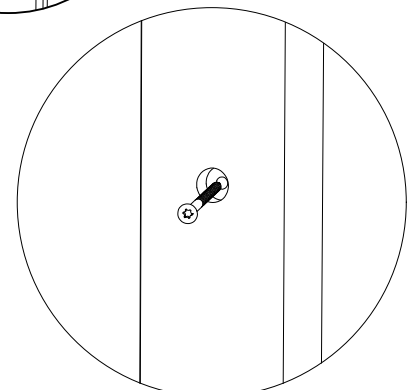
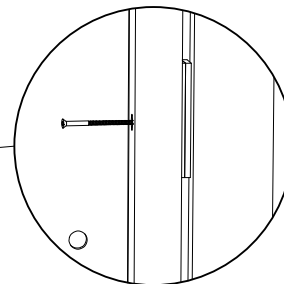
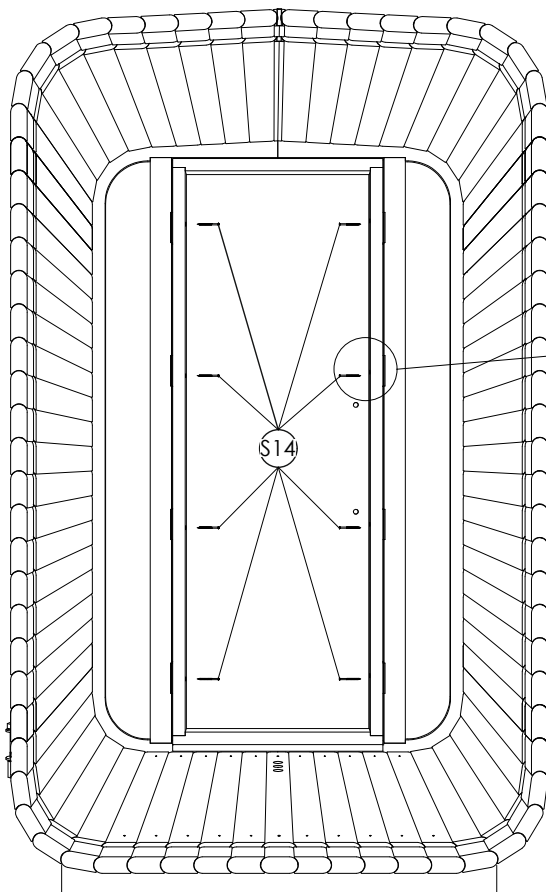
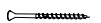


**STEP 18:** Fix one side of the door box with screws (S14) slightly to the outside through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly, they can't slip down before door is fixed with screws. Use screws (S14) to fix doors. Check door box, both sides should be straight, they must not be bent inwards or outwards.

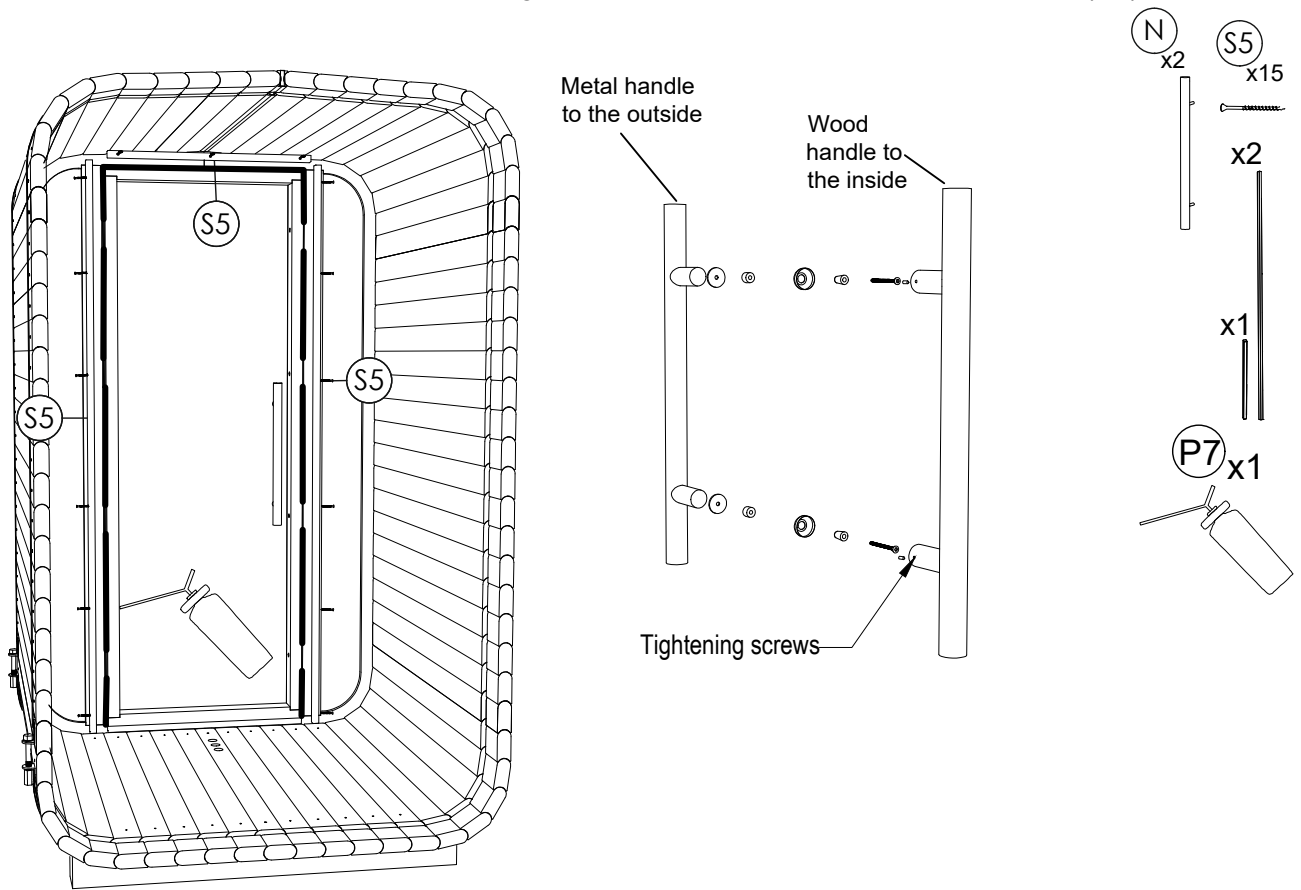
Use a level



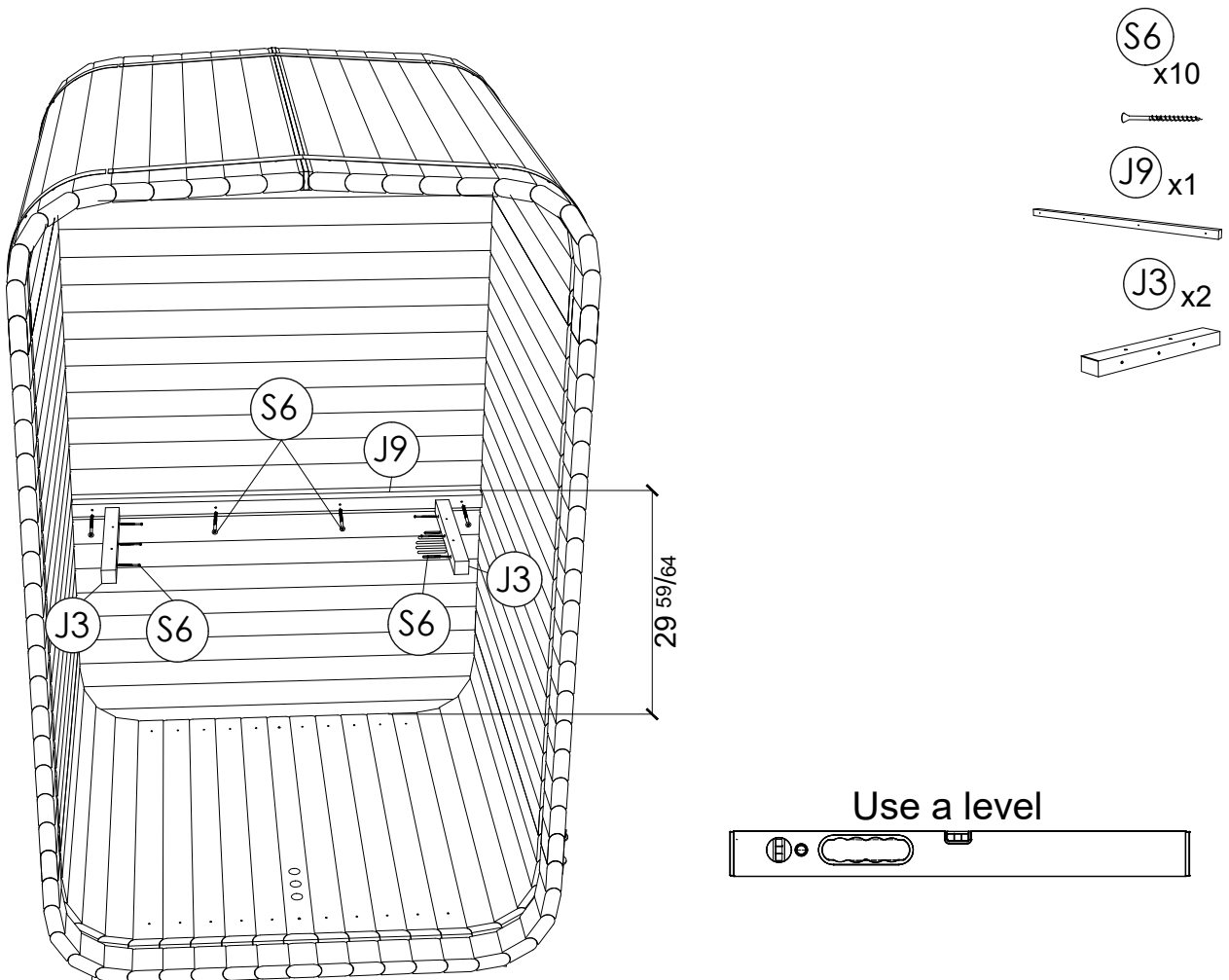
S14  
x8



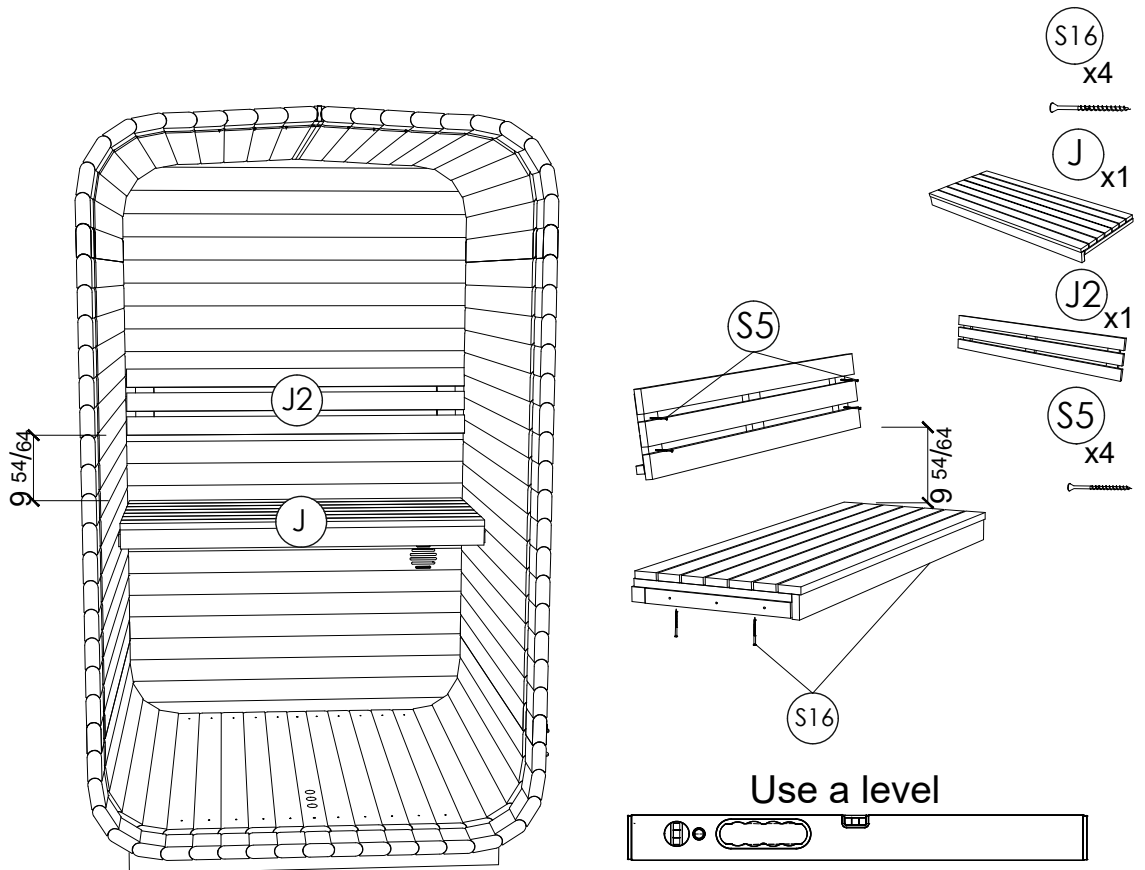
**STEP 19:** Use spray foam around door box. Let the spray foam dry. The excess amount will come off easily if you don't touch it while it's wet. Fix door moldings to both sides and on top of the door with (S5) screws.



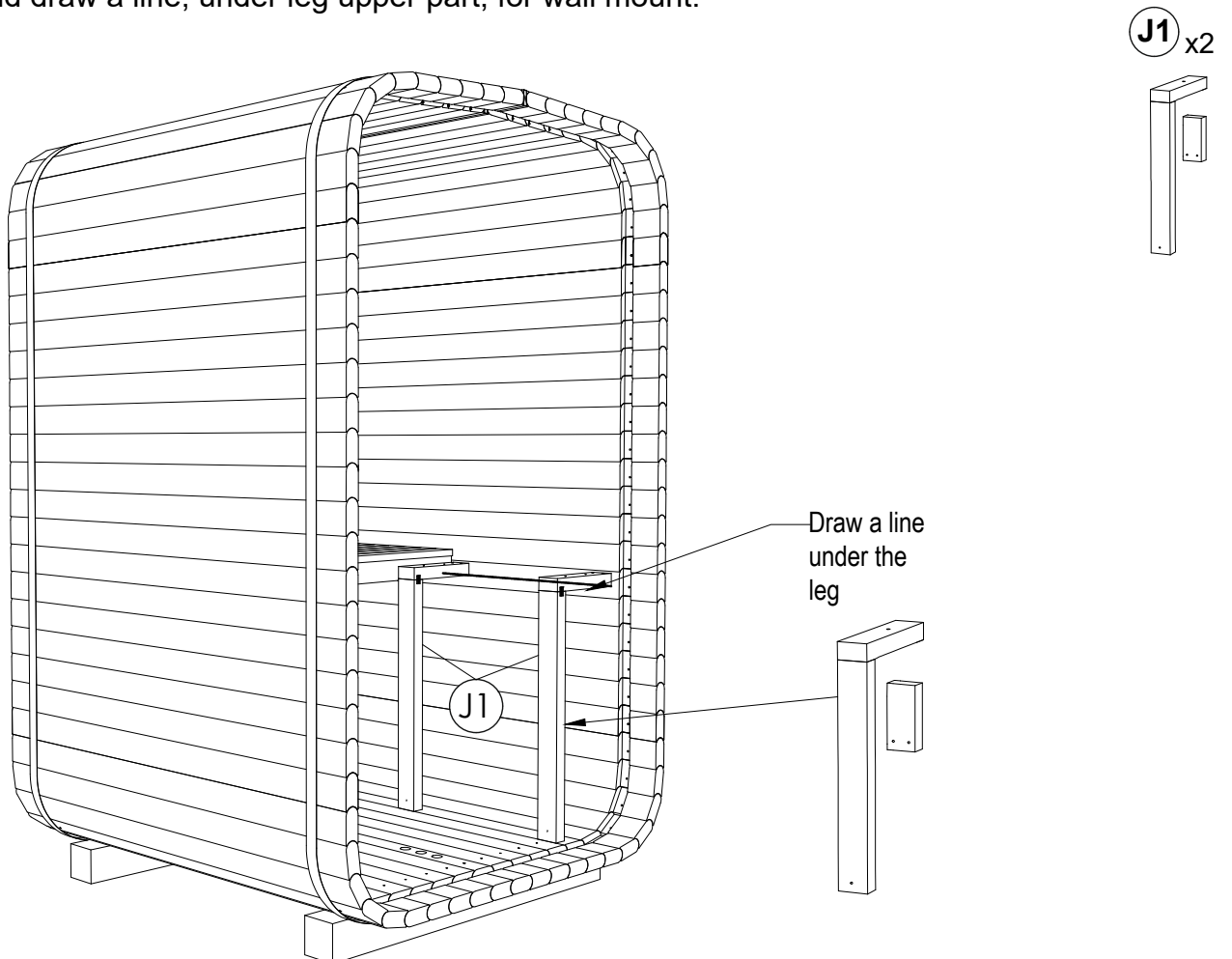
**STEP 20:** Install bench supports (J9;J3) with (S6) screws. Take measurements as in the picture. Check the the supports to ensure they are straight from all angles.



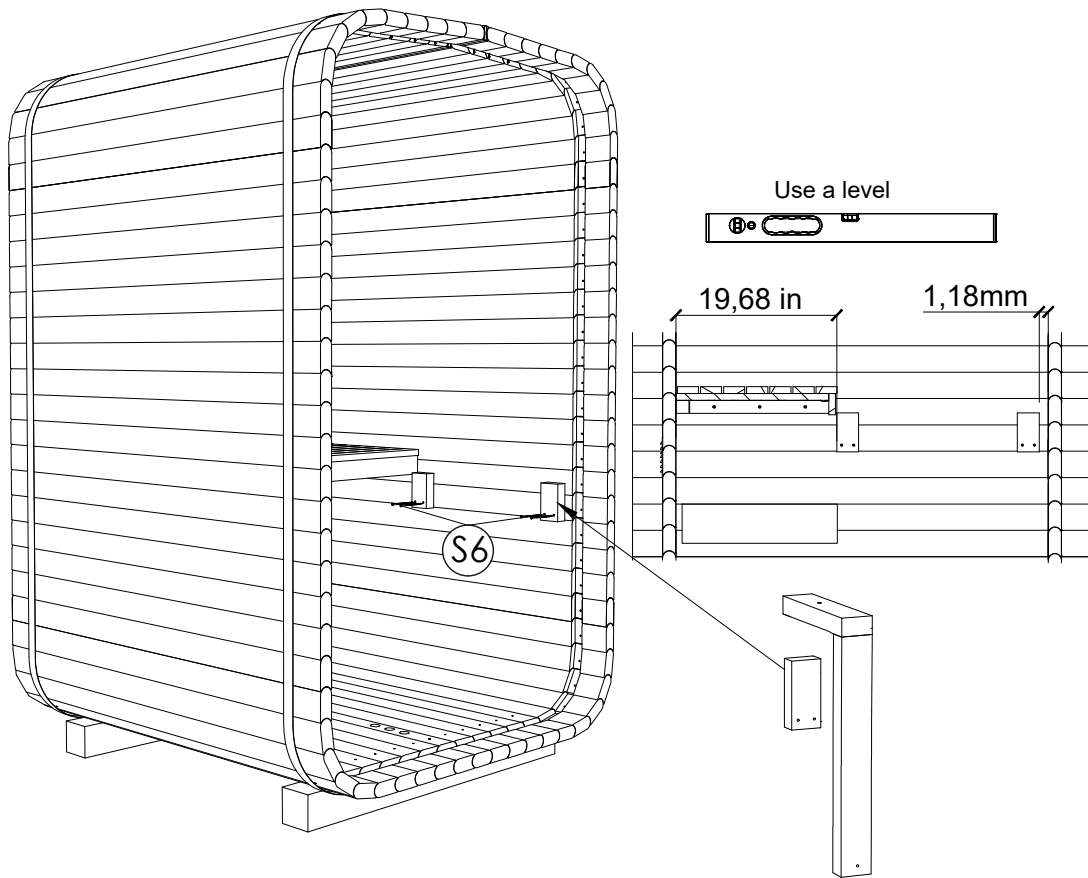
**STEP 21:** Fix bench (J) using (S6) screws. Fix backrest 9 <sup>54</sup>/<sub>64</sub> above bench using (S5) screws.



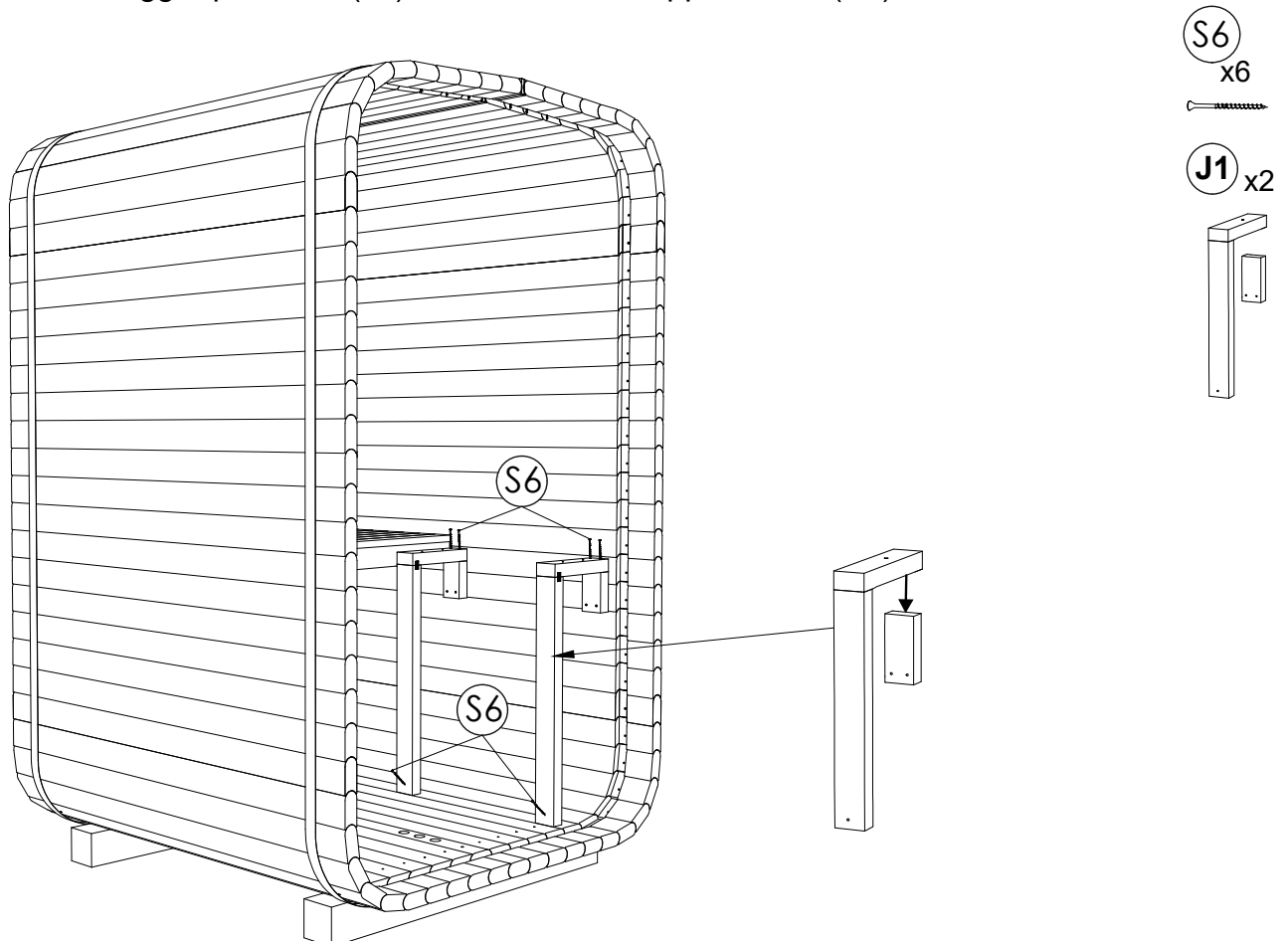
**STEP 22:** Bench leg comes in two parts. start with bigger one. Put bench leg(J1) on the side wall and draw a line, under leg upper part, for wall mount.



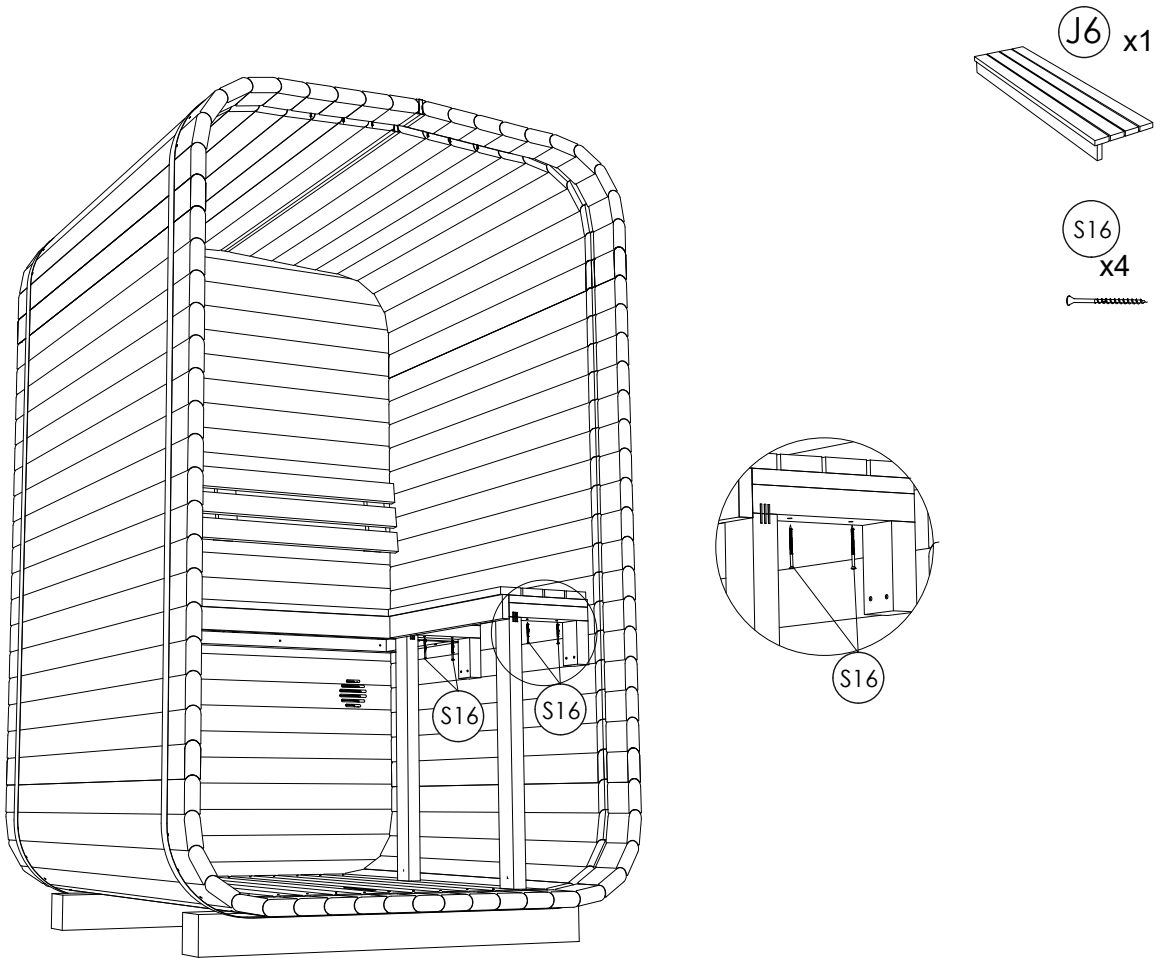
**STEP 23:** Fix smaller part from (J1) on marked line using (S6) screws. Measure necessary distances from back and front panels.



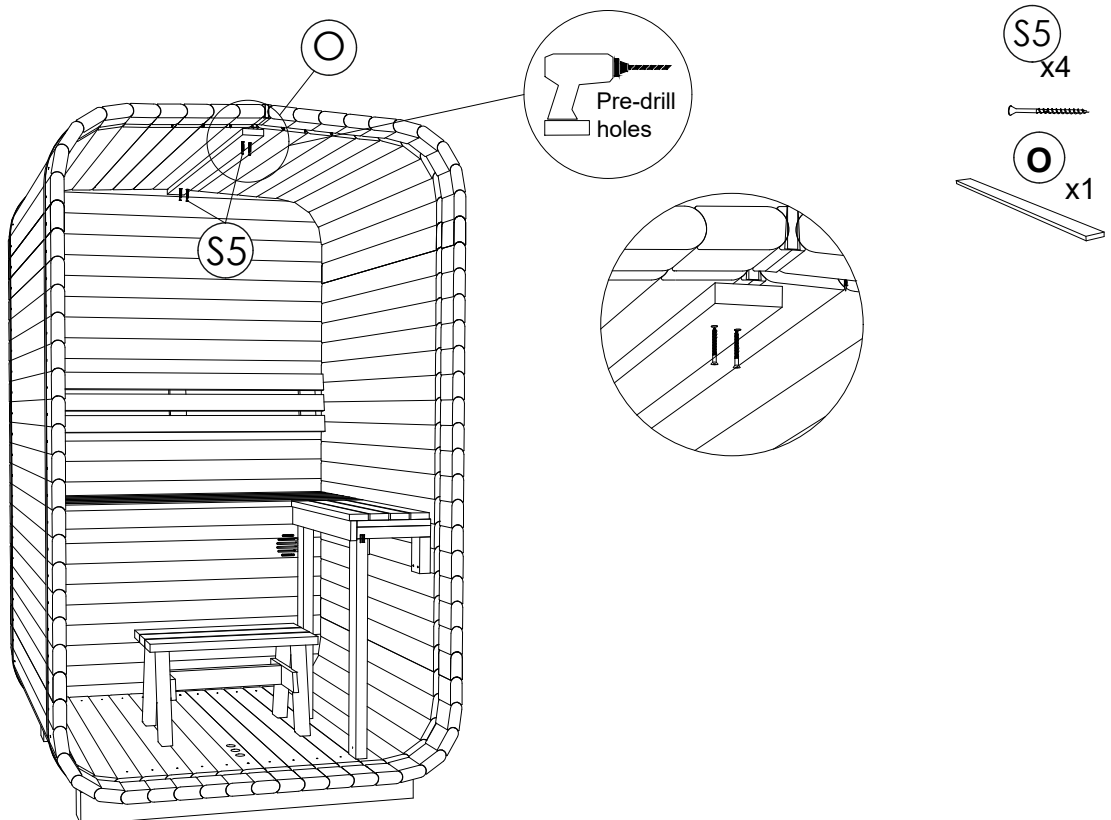
**STEP 24:** Fix bigger part from (J1) on fixed bench supports with (S6) screws as shown.



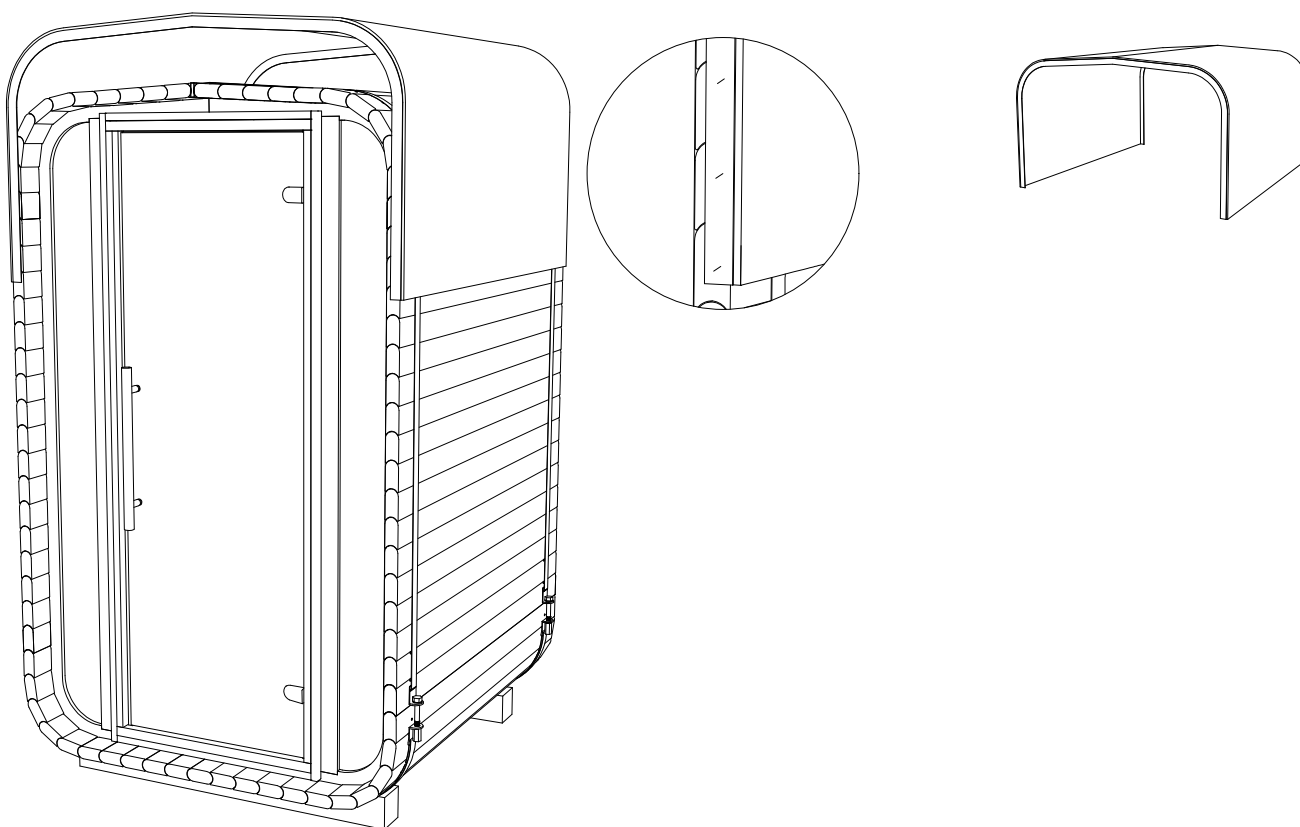
**STEP 25:** Fix step bench (J5) on top of the legs (J6) using (S6). Bench cross boards have to match the tops of the bench legs. Fix Bench step (J7) using (S6) screws.



**STEP 26:** Install the ceiling board (O) in the middle of the ceiling, pre-drill holes for screws (S5). Assemble step bench and put it in the sauna.



**STEP 27:** Lay out rain cover on the roof evenly to both sides. Leave about  $1\frac{37}{64}$  over the front and back edges. Staple underlay at the front and back edges. Cut excess underlay if necessary.



**STEP 28:** Pre-drill holes for screws. Fix wooden slats (Z1) with screws (S7) on the rain jacket bottom.

