



# BARRELS

by THERMORY®

## Installation Guide

Barrel N°55

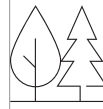
# The Wait Is Over.

Everything you need to build your very own Thermory Barrel Sauna is right there in front of you. If it looks like a lot, it is. If it seems too complicated to assemble, it isn't.

These instructions are specifically written to guide you through each step with ease. And if you need additional encouragement, you can scan the code on the back of this guide to see how it's done.

The Thermory Barrel Sauna No55 is designed for up to two people. That's plenty of room for you and the friends helping you put this together. But if you want to enjoy the first steam all by yourself, we understand.

We truly appreciate the opportunity to share our love of sauna culture with you. And if there's anything we can do to make your sauna experience better, please don't hesitate to let us know. If not, just relax and enjoy.



REAL WOOD  
PRODUCTS



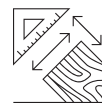
SUSTAINABLE



THERMALLY  
MODIFIED  
WOOD



DURABILITY



DIMENSIONAL  
STABILITY



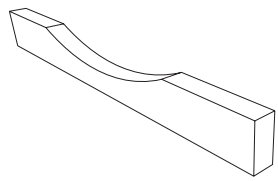
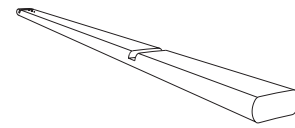
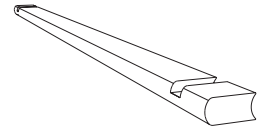
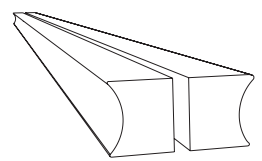
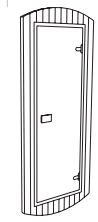
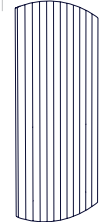
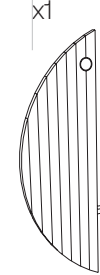
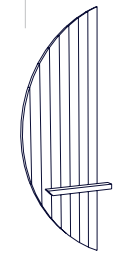
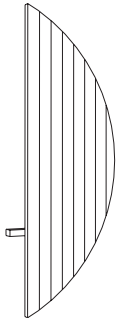
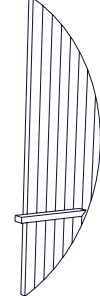
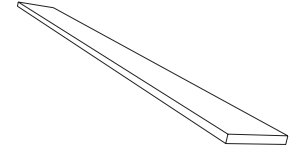
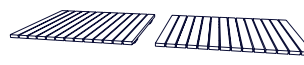
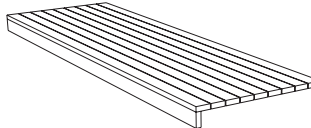
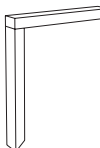
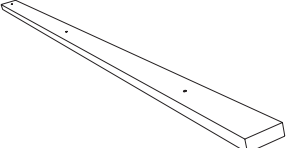
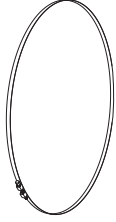
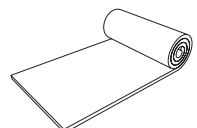

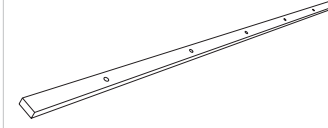
ECO-FRIENDLY  
/ CHEMICAL-  
FREE PROCESS



# BARRELS

Installation guide Barrel N°55

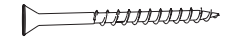
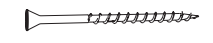
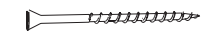
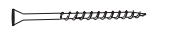
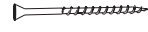

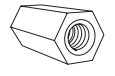

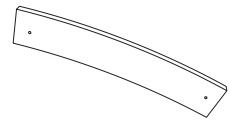


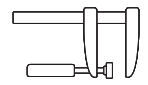
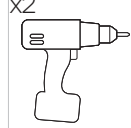
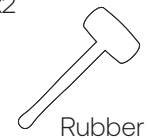

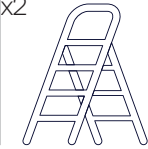
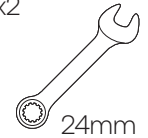


## PARTS 1

<b>CRADLES</b> x2 <b>A</b> 	<b>CENTER STAVE</b> x1 <b>B</b> 	<b>BODY STAVES</b> x70 (+2 reserve) <b>C</b> 	<b>FINAL H-TYPE TOP STAVE</b> x2 <b>H</b> 
<b>FRONT PANEL</b> x1 <b>F2</b> 	<b>REAR PANEL</b> x1 <b>E2</b> 	<b>LEFT PANEL SECTION (FRONT)</b> x1 <b>F</b> 	<b>LEFT PANEL SECTION (BACK)</b> x1 <b>E</b> 
<b>RIGHT PANEL SECTION (FRONT)</b> x1 <b>F1</b> 	<b>RIGHT PANEL SECTION (BACK)</b> x1 <b>E1</b> 	<b>ASPEN ROOF BOARD</b> x1 <b>O</b> 	<b>FLOORING DUCKBOARD</b> x2 <b>L</b> 
<b>INTERIOR BENCHES</b> x2 <b>J</b> 	<b>BENCH SUPPORTING LEGS</b> x2 <b>J1</b> 	<b>BACKREST STAVES</b> x6 <b>J2</b> 	<b>METAL BANDS</b> x2 <b>I</b> 
<b>ADHESIVE ROOF TAPE</b> x1 <b>R</b> 	<b>WATERPROOF ROOF COVER</b> x1 <b>Z</b> 	<b>WOODEN SLAT FOR ROOF COVER</b> x2 <b>Z1</b> 	

# BARRELS

Installation guide Barrel N°55

## PARTS 2

<b>SCREW 5.0X120</b> x10 <b>M</b> 	<b>SCREW 4.2X70</b> x160 <b>N</b> 	<b>STAINLESS STEEL SCREW 4.2X70</b> x18 <b>N1</b> 	<b>SCREW 4.0X50</b> x35 <b>P</b> 
<b>STAINLESS STEEL SCREW 4.0X50</b> x25 <b>P1</b> 	<b>Ø BOLT 16X140</b> x2 	<b>HEX NUT M16 (SW24)</b> x2 	<b>FLAT WASHER</b> x4 <b>U</b> 
<b>DECORATIVE ROOF NISHING BOARDS</b> x10 <b>W</b> 	<b>3 People Recommended</b> 	<b>6'</b> x2 	
<b>TOOLS REQUIRED:</b> x2 	<b>Rubber</b> x2 	<b>Hard Hat</b> x3 	<b>Ladder</b> x2 
	<b>Wrench 24mm</b> x2 	<b>Tape Measure 10'</b> x2 	<b>Gloves</b> x3 

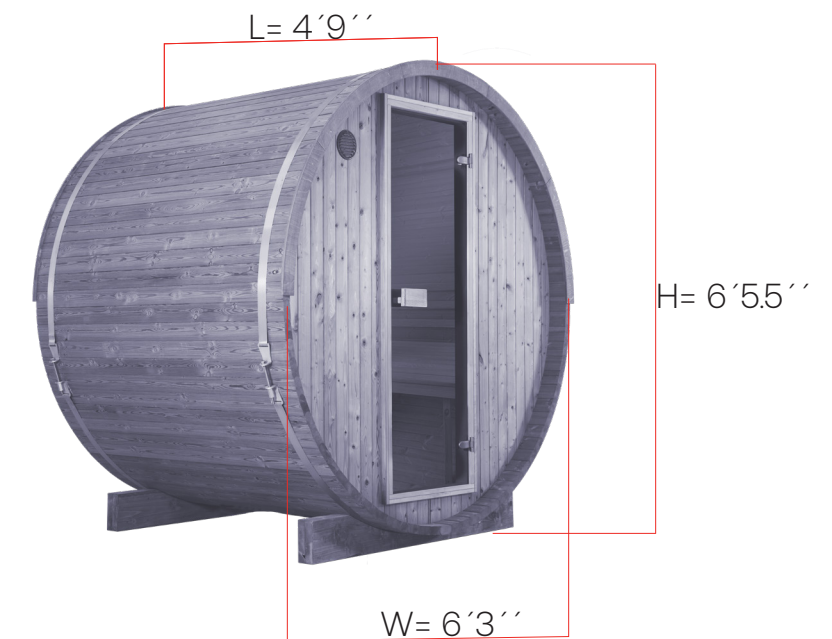
## STEP ZERO

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

Approximately L x W x H of 6' x 7' x 7' is ideal. Overall dimensions are shown here.

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

Concrete, pavers or crushed stone is preferred.

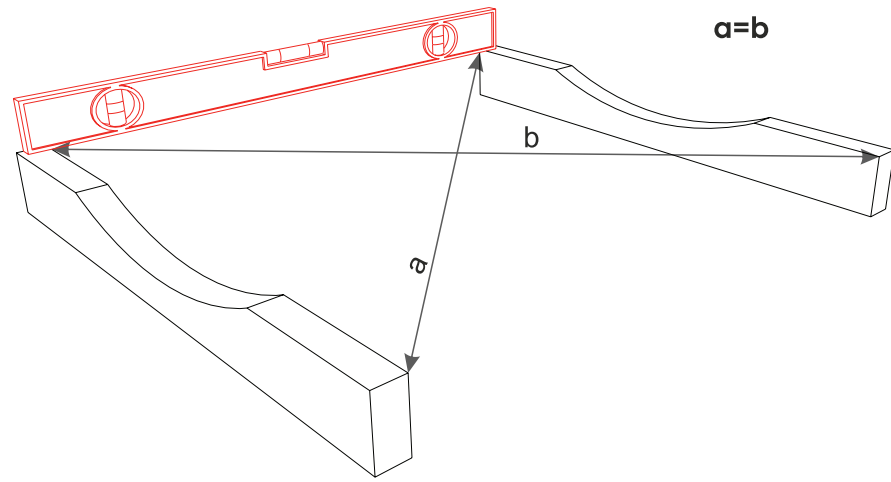


STEP ONE

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.

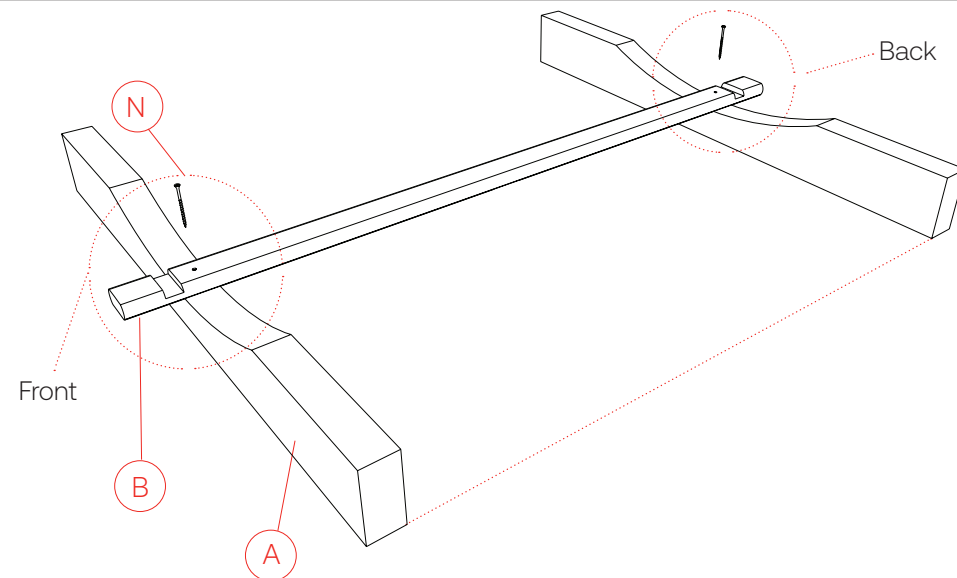


STEP TWO

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).

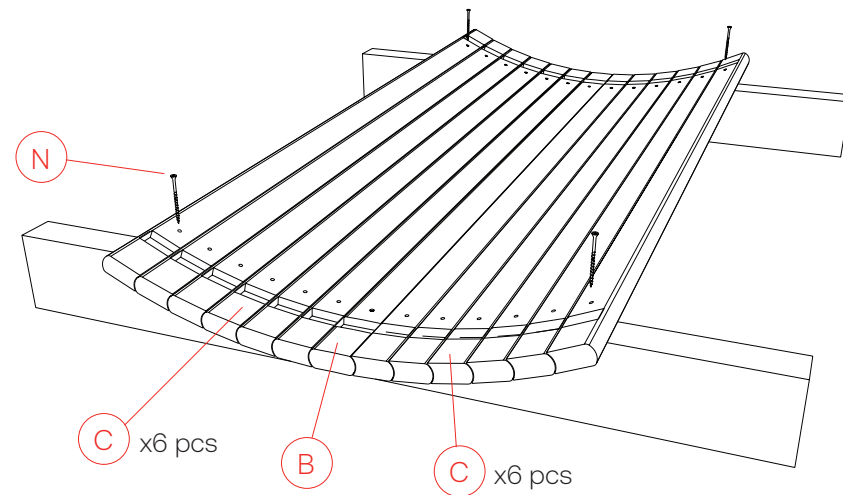
Fix center stave (B) to cradles with screws 4.2 x 70 (N).



STEP THREE

Place 6 sauna body staves (C) to each side of the center stave (B) and fix with screws 4.2 x 70 (N).

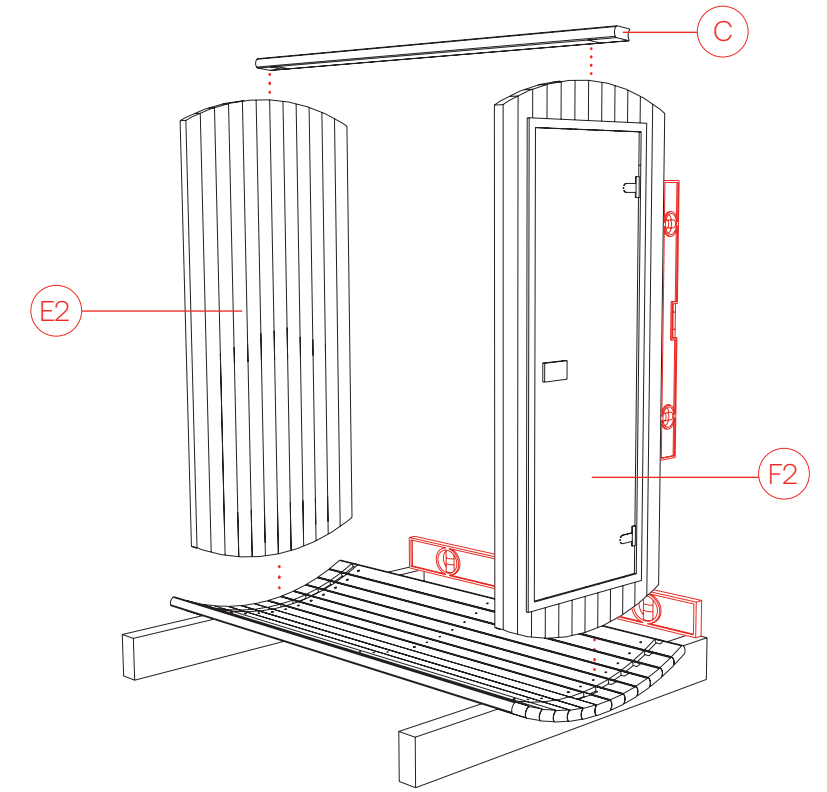
Be sure to align the panel groove on every next body stave.



STEP FOUR

Place front panel with sauna doors (F2) and rear panel (E2) into the trimmed grooves. Be sure each panel is centered, leveled, and completely seated into the floor panel.

Bind these panels together by temporarily placing one or two body stave (C) on top of them.

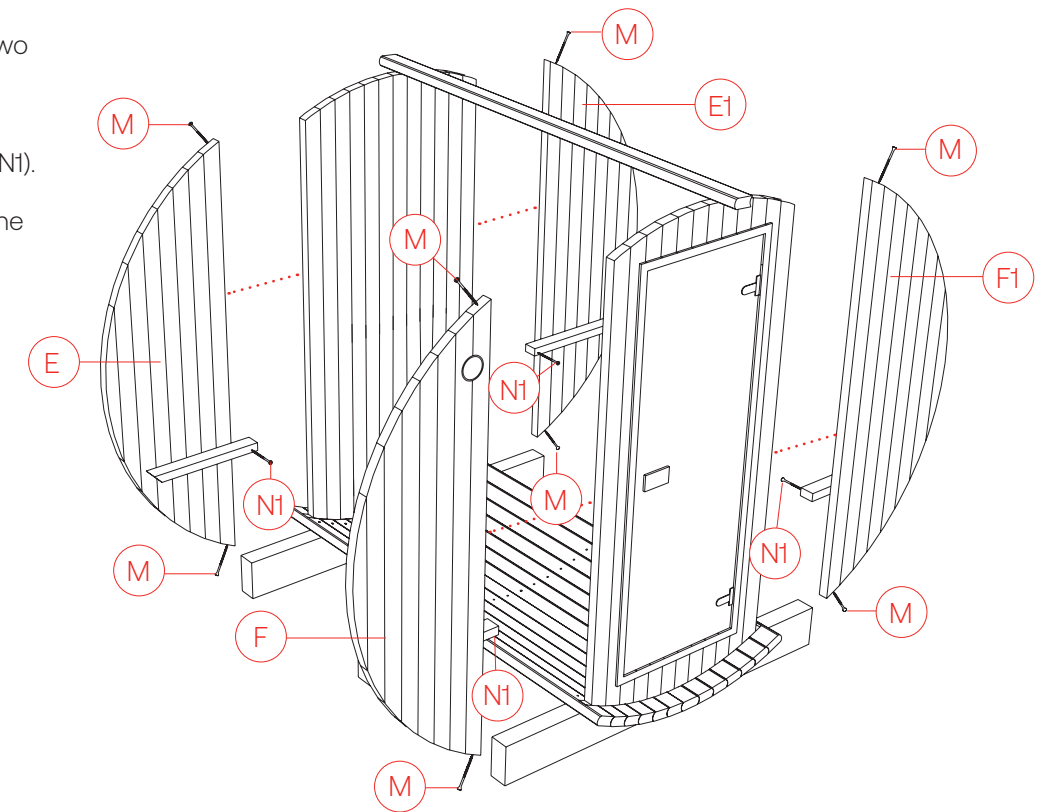


STEP FIVE

Two front side panels (F, F1) attach to the front panel (F2) and two back side panels (E, E1) attach to the rear panel (E2) by 4 screws 5.0 x 120 (M) and 4 stainless steel screws 4.20 x 70 (N1).

Be sure the bench supports face the interior of the sauna.

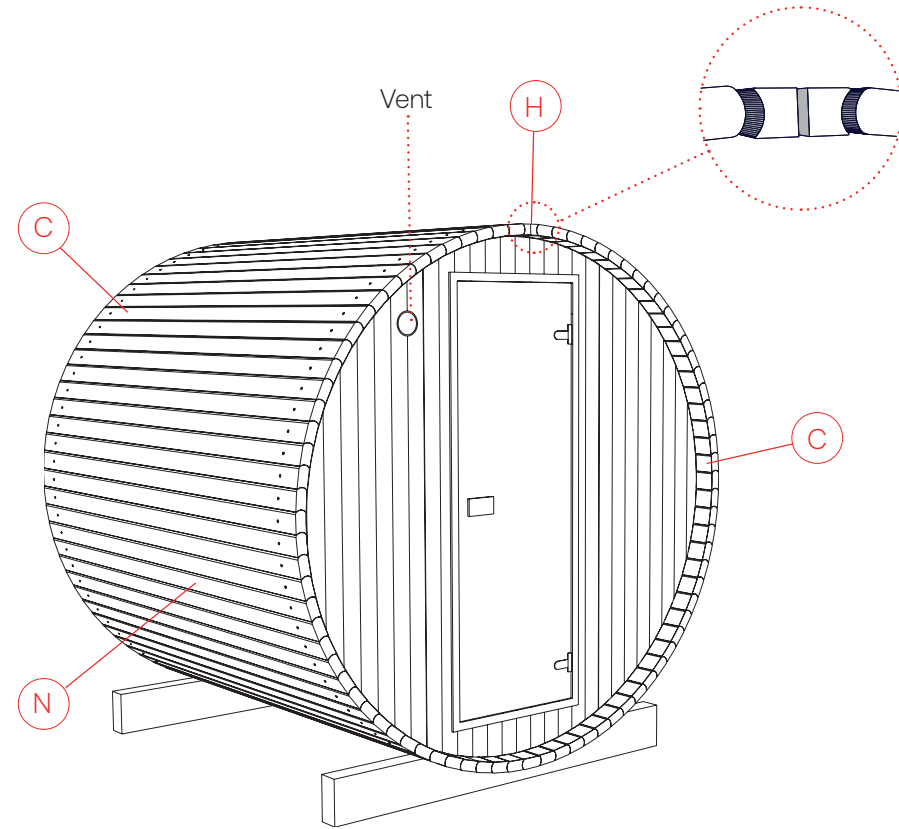
Confirm that the combined width of the rear wall (E, E2, E1) matches the combined width of the front wall (F, F2, F1).



STEP SIX

Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, while fixing body staves on the front panel with 4.2 x 70 screws.

To finish the roof top joint, use top stave (H).



STEP SEVEN

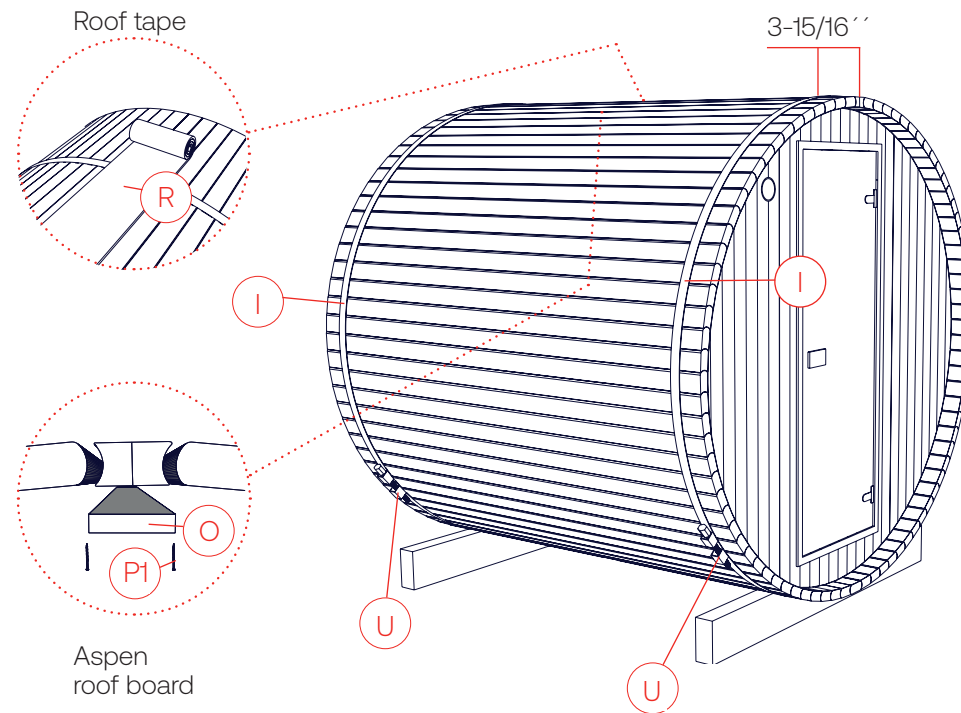
Install steel bands (I) by wrapping bands around barrel prior to connecting with bolts and nuts (U).

Place steel bands evenly around barrel, covering screw heads.

Measure from steel band to barrel edge to ensure the steel band is even.

Cover roof with roof tape. Rub and smooth with pressure to ensure adhesion.

Install interior aspen roof trim (O) with 4.0 x 50 (P1) stainless steel screws.

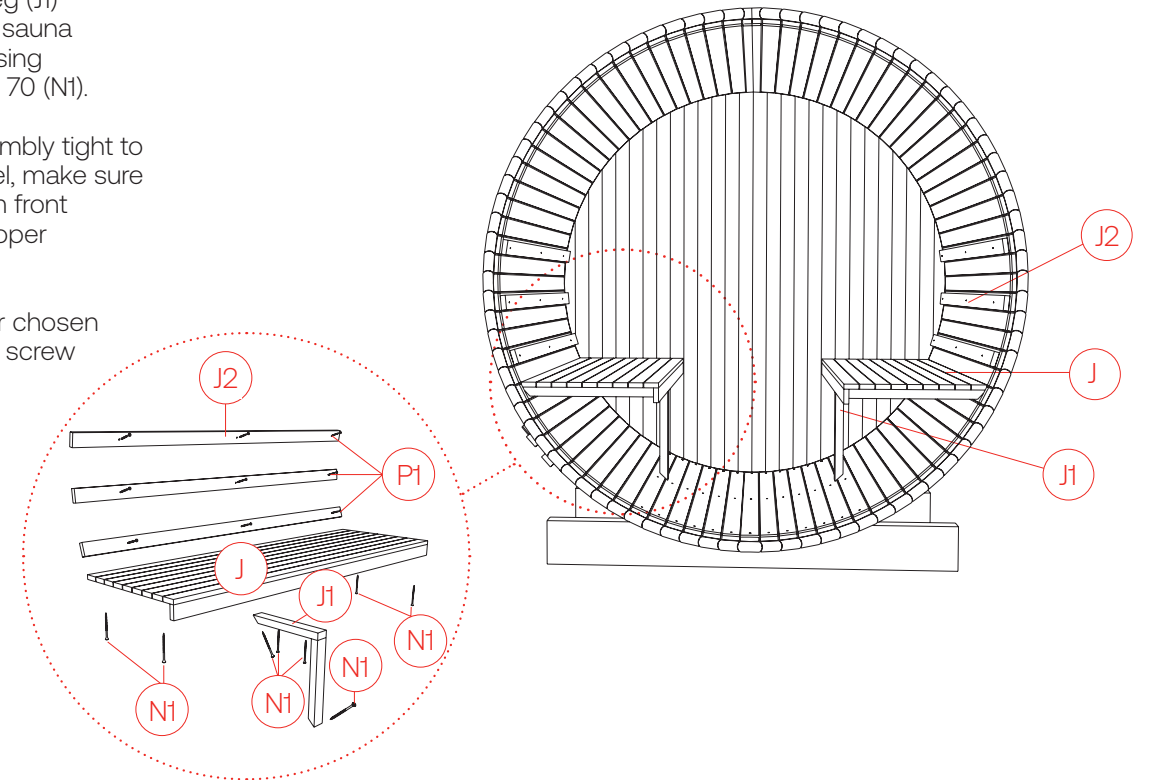


STEP EIGHT

Attach bench supporting leg (J1) to the bench (J), install two sauna benches on wall mounts using stainless steel screws 4.2 x 70 (N1).

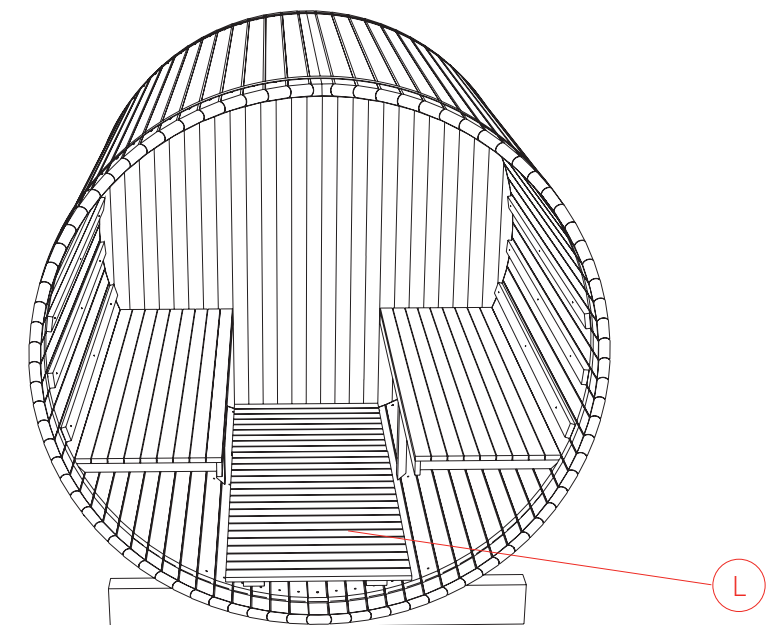
Hold the seat and leg assembly tight to the sauna wall. Using a level, make sure the bench seat is level from front to back. This will ensure proper placement.

Install backrests (J2) at your chosen height using stainless steel screw 4.0 x 50 (P1).



STEP NINE

Flooring duckboards (L) can be used for wiring runs, confirm specific wiring runs needed for chosen stove.

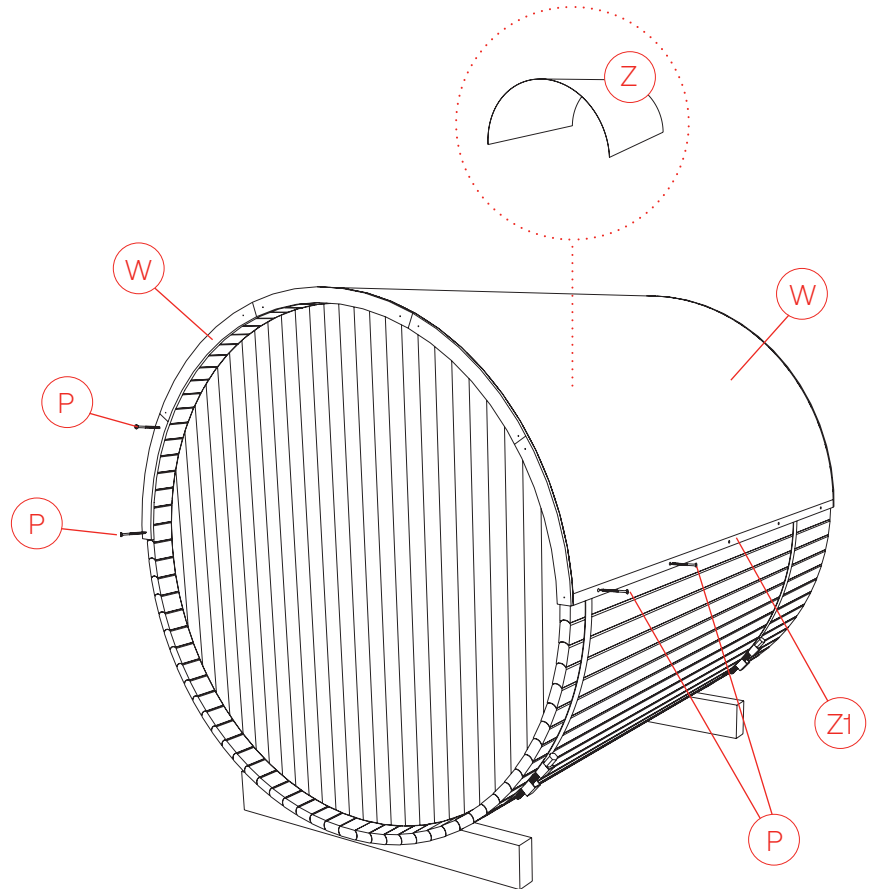


## STEP TEN

Place waterproof roof cover (Z) and fix it with wooden slat (Z1) and screws 4.0 x 50 (P).

Install front and rear decorative roof finishing boards (W), fixing by screws 4.0 x 50 (P).

WATCH THE VIDEO



SEE HOW ASSEMBLY WILL LOOK [HERE](#).



### Thermory USA - Denver

537 W. Highlands Ranch Pkwy, Ste. 114  
Highlands Ranch, CO 80129  
720.759.7268  
support@thermoryusa.com

### Thermory USA - Buffalo

56 Harvester Ave, Ste. 1-201  
Batavia, NY 14020  
585.591.6590  
support@thermoryusa.com

→ [SaunaByThermory.com](https://SaunaByThermory.com)



**THERMORY**<sup>®</sup>  
LEAVE A LASTING IMPACT