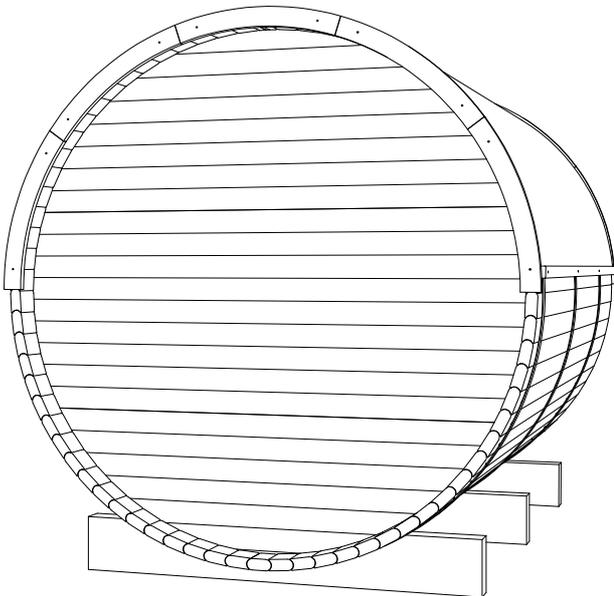
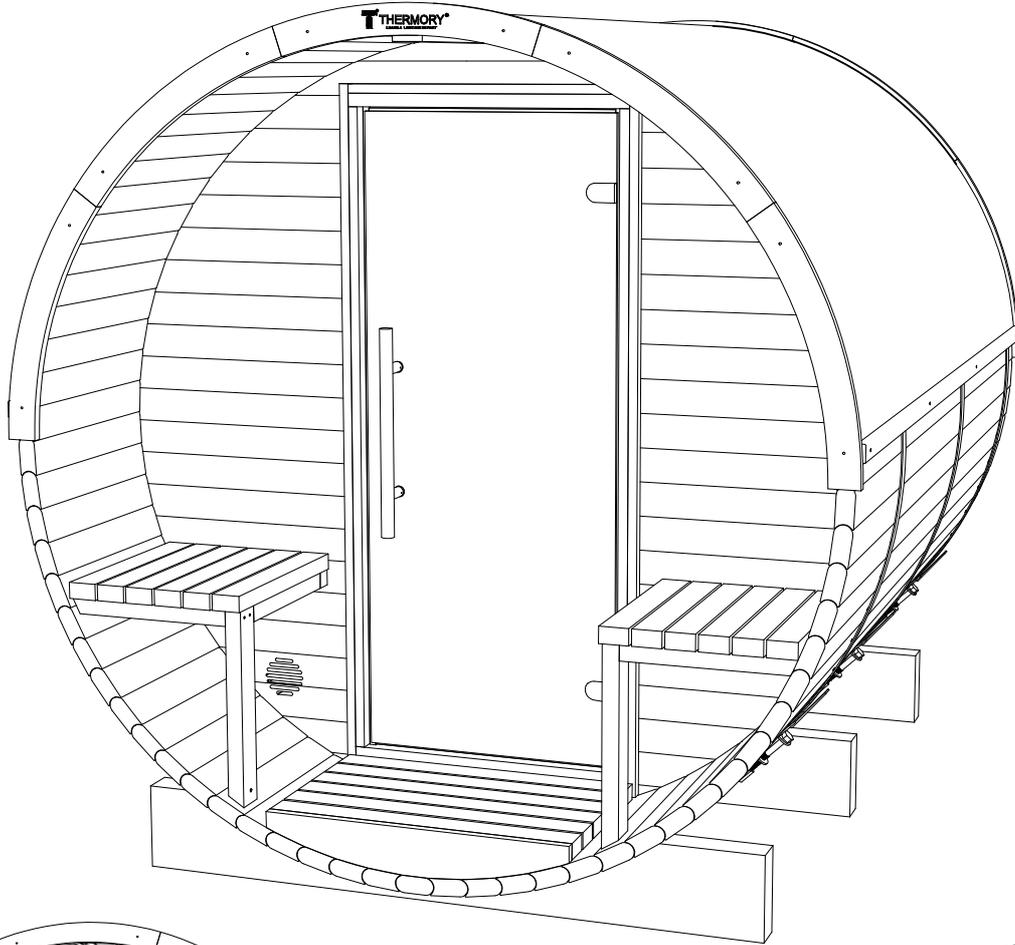
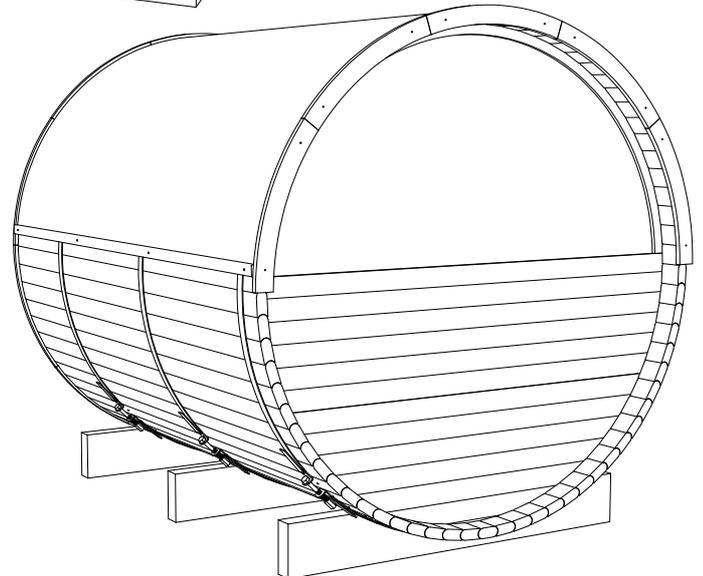


# BARREL SAUNA

## ASSEMBLY INSTRUCTIONS



Model: No61

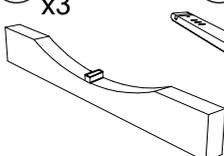
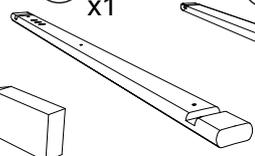
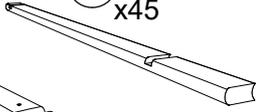
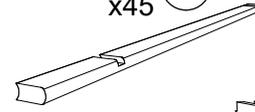
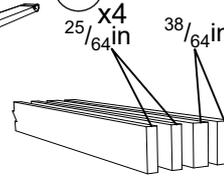
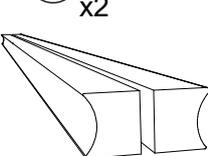
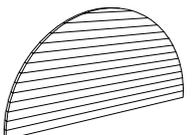
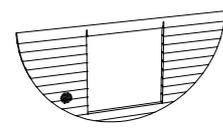
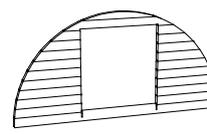
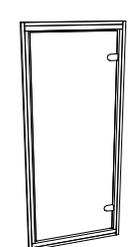
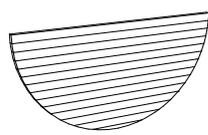
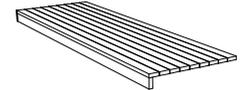
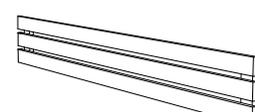
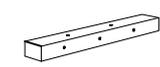
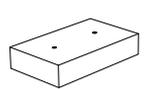
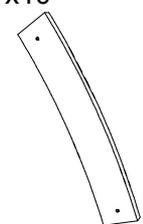
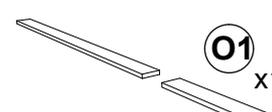
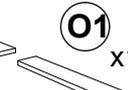
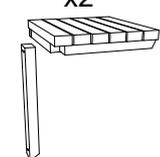
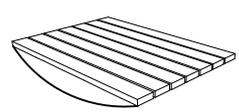
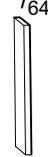


Model: No60

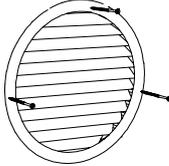
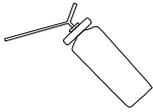
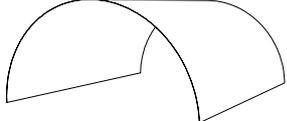
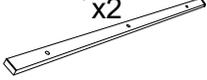
**Note: Please read the manual before construction**

Rev. 25.09.2024.

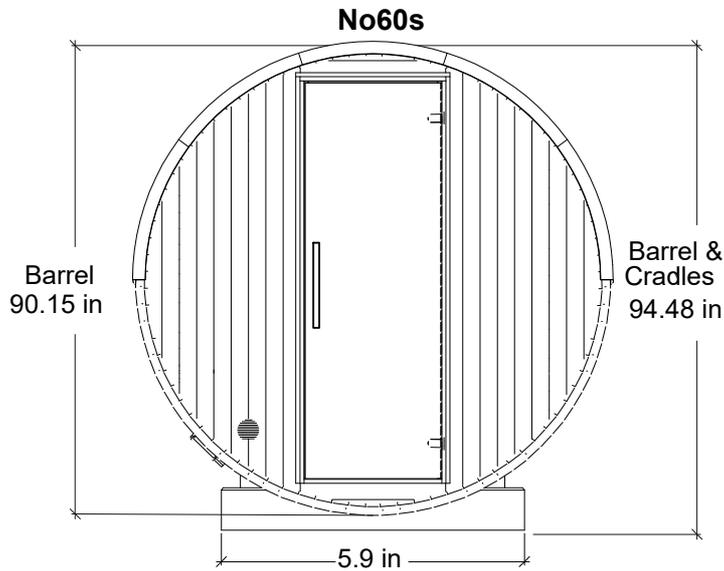
# PART LIST

<p><b>A</b> x3</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 type stave at the top</p>
<p><b>V3</b> x1</p>  <p>upper rear panel</p>	<p><b>F</b> x1</p>  <p>front panel bottom</p>	<p><b>F1</b> x1</p>  <p>front 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>x1 x1</p>  <p>door box spacers</p>
<p><b>J</b> x2</p>  <p>sauna bench</p>	<p><b>J1</b> x2</p>  <p>supporting leg</p>	<p><b>J2</b> x2</p>  <p>backrest</p>	<p><b>J3</b> x4</p>  <p>wall mount</p>	<p><b>N1</b> x2</p>  <p>door handle</p>	
<p><b>L</b> x2</p>  <p>sauna floor</p>	<p><b>L1</b> x6</p>  <p>fixing block for sauna floor</p>	<p><b>W</b> x10</p>  <p>decorative roof finishing board</p>	<p><b>O</b> x1</p>  <p>roof board</p>	<p><b>I</b> x3</p>  <p>metal band</p>	<p><b>O1</b> x1</p> <p>Terrace</p> 
<p><b>K</b> x2</p>  <p>terrace bench</p>	<p><b>L2</b> x1</p>  <p>Flooring duckboard (outside)</p>	<p><b>S1</b> x60</p>  <p>screw 5.0x100 SS</p>	<p><b>S5</b> x52</p>  <p>screw 4.0x50 SS</p>	<p><b>S4</b> x11</p>  <p>screw 5.0x120</p>	
<p><b>S10</b> x160</p>  <p>screw 4.0x60</p>	<p><b>S6</b> x40</p>  <p>screw 5.0x70 SS</p>	<p><b>S7</b> x25</p>  <p>screw 4.2x55 brown</p>	<p><b>S14</b> x10</p>  <p>screw 5.0x80</p>	<p>x12 13/64</p> 	<p>x10 5/64</p> 
				<p>x10 3/64</p> 	<p>door box spacers</p>

# PART LIST

 <b>S9</b> x2 bolt Ø12x140	 + x2 hex nut M12 (SW19)	 + x4 flat washer	 <b>Y1</b> x1 ventilation grill	 <b>P7</b> Construction foam	 <b>Z</b> x1 Waterproof roof cover
 <b>Z1</b> x2 Slat for roof cover	 Hand saw				

## Barrel Dimensions



## RECOMMENDATION



2 person recommended

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.

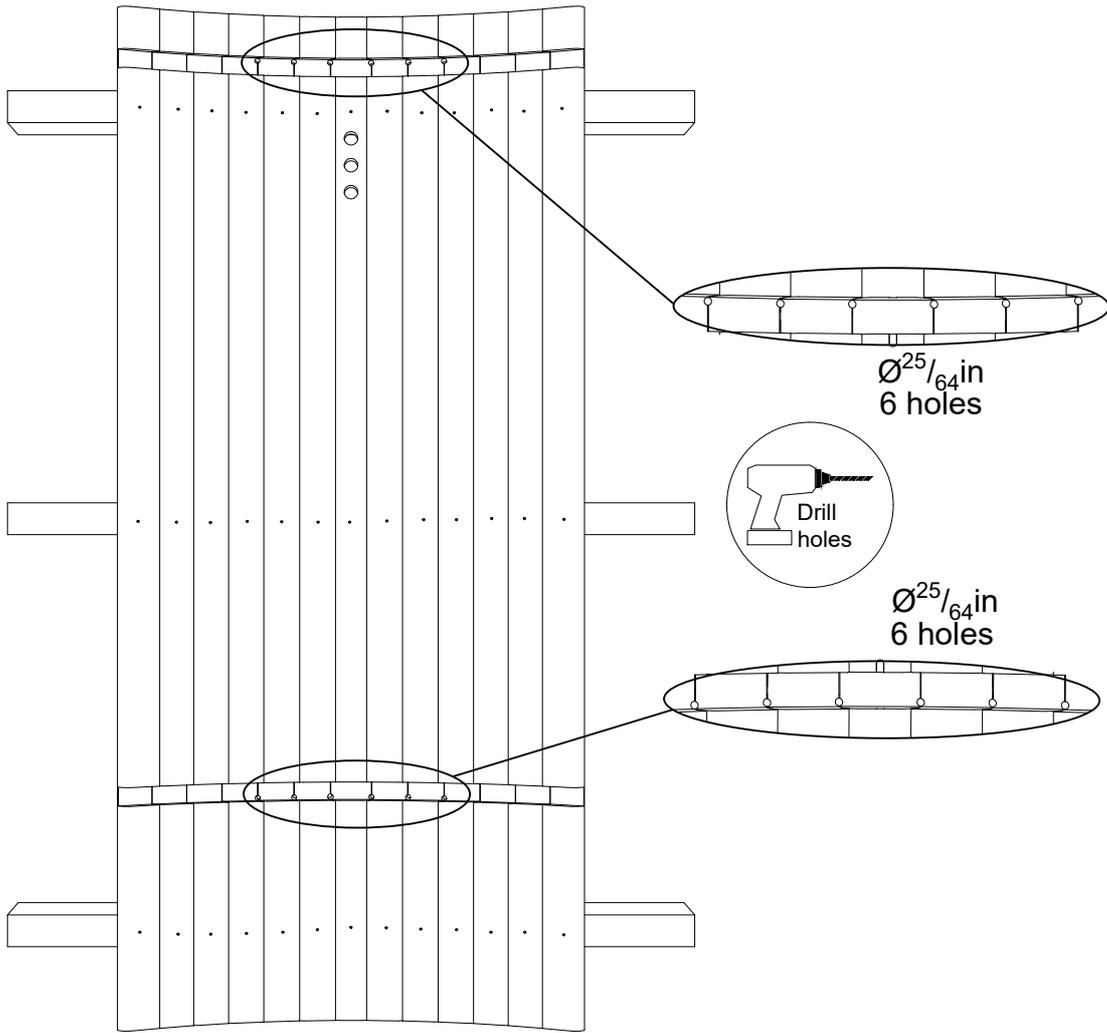
Check parts before construction.

## TOOLS REQUIRED

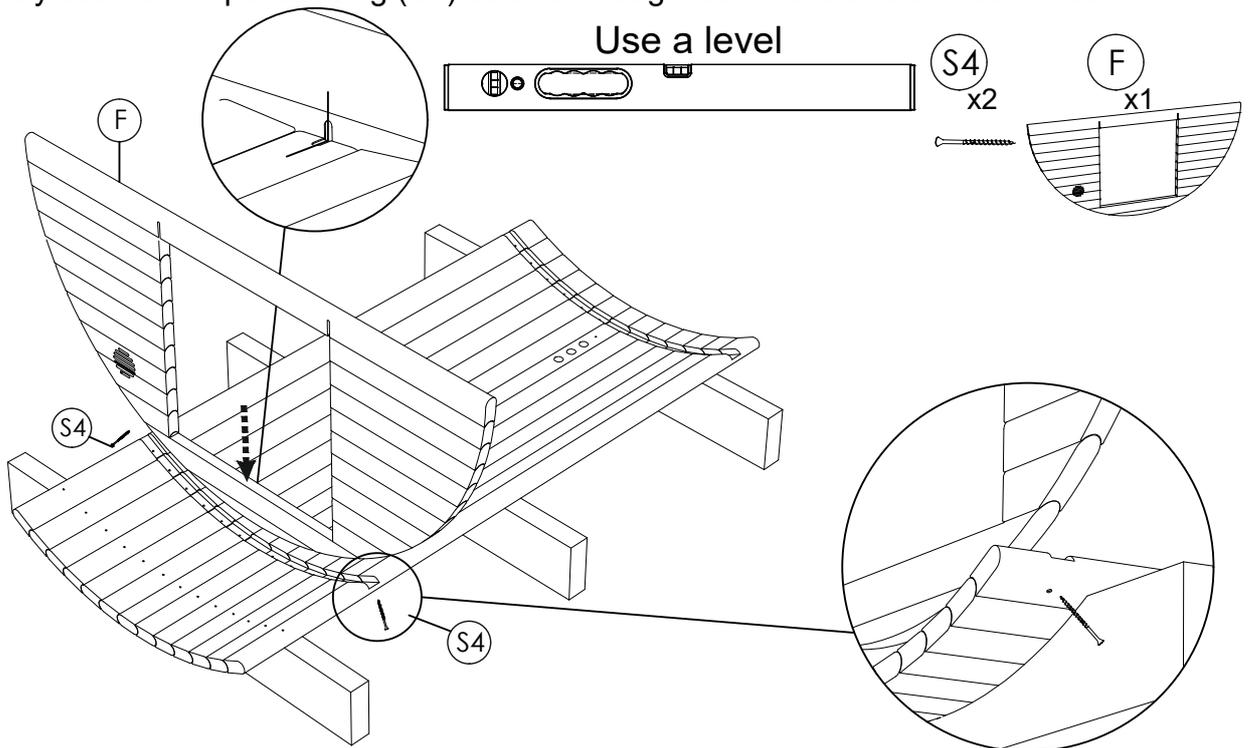
$17 \frac{23}{32} - 78 \frac{47}{64}$   
 $118 \frac{18}{64}$   
 $\text{Ø} \frac{5}{32} - \frac{25}{64} \text{in}$



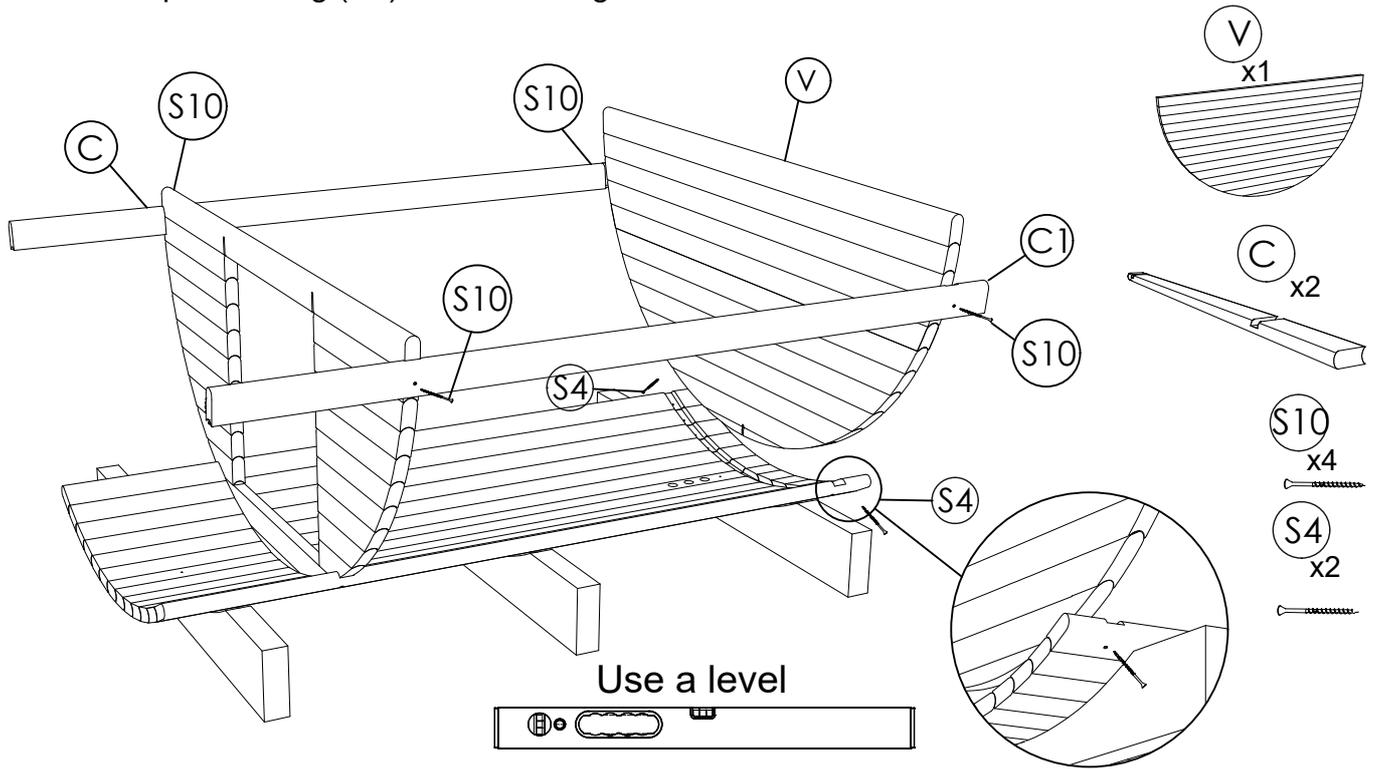
**STEP3:** Drill six  $\frac{25}{64}$ in holes in front and back wall groove to the out-side in board connections as shown in the picture.



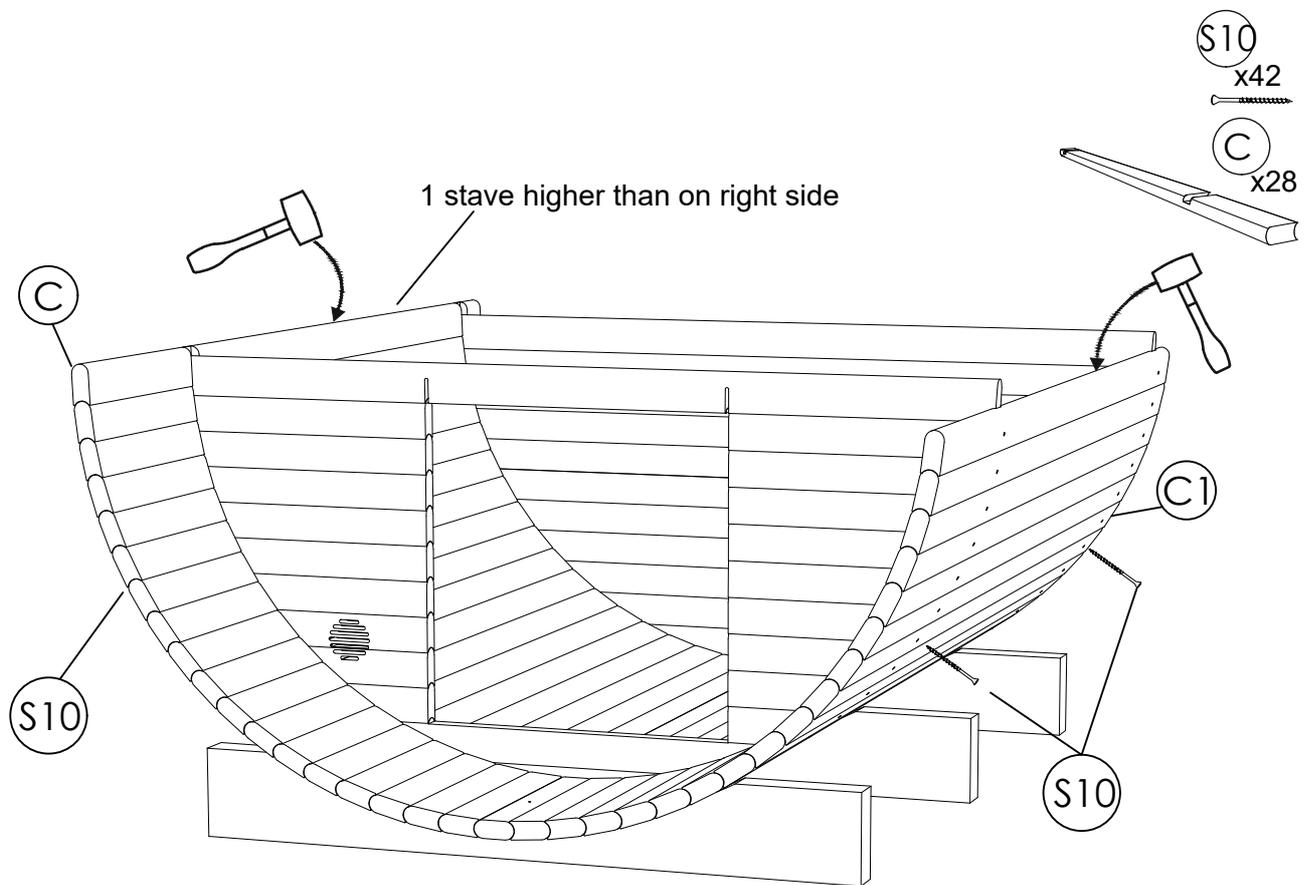
**STEP 4:** Place front bottom panel (F) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides.



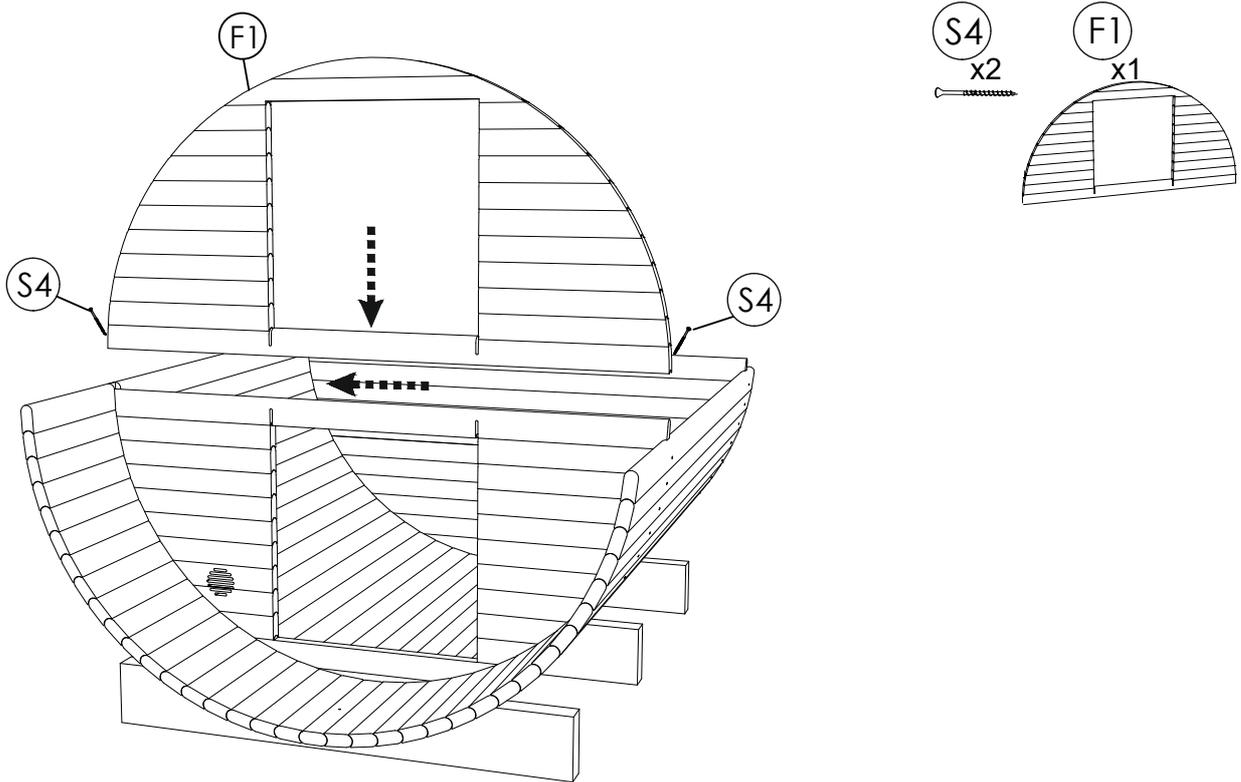
**STEP 5:** Place rear panel (V) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws through last floor stave on both sides.



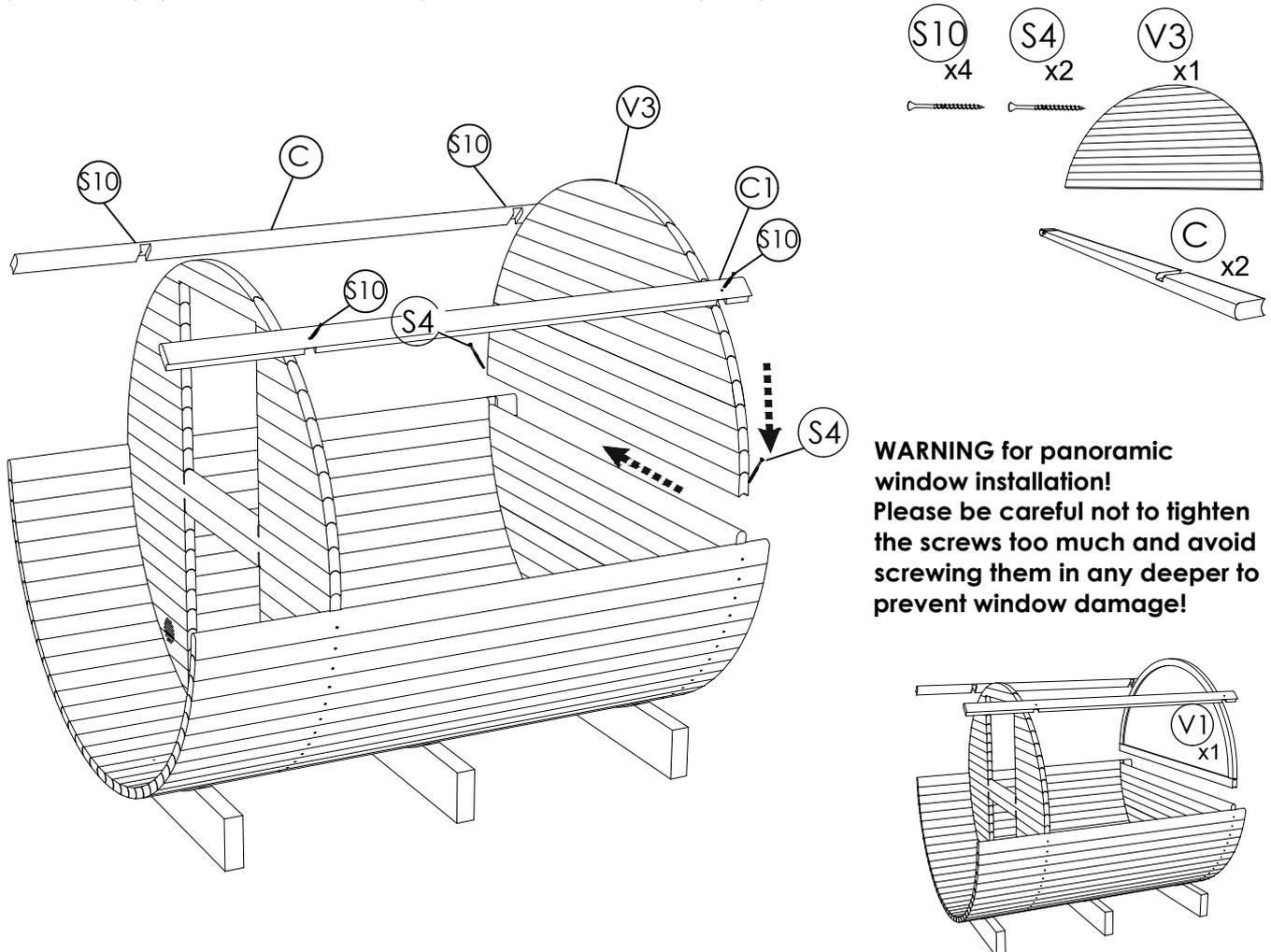
**STEP 6:** Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10) . Fix one stave higher on left side than at right.



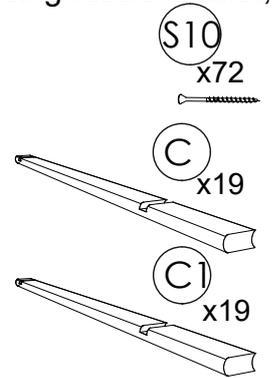
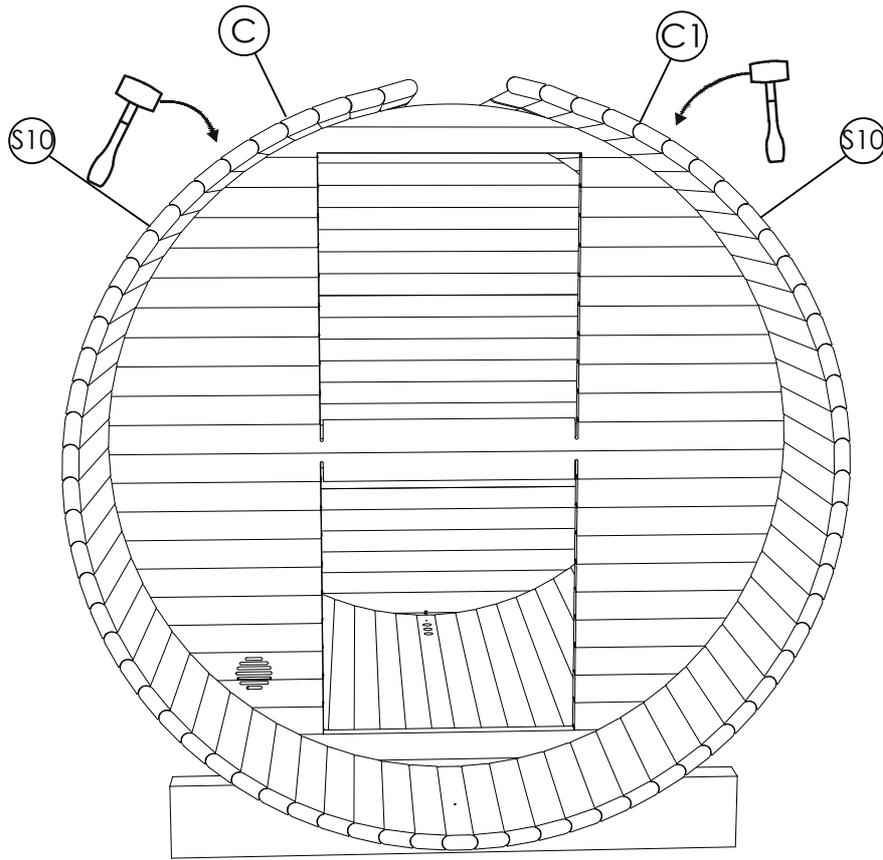
**STEP 7:** Place front top panel (F1) on front bottom panel (F), be sure panel is centered, leveled, completely seated. Fix panel using (S4) screws on both sides.



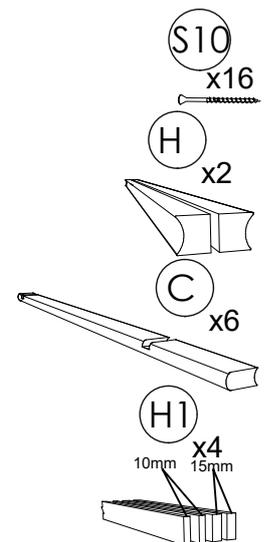
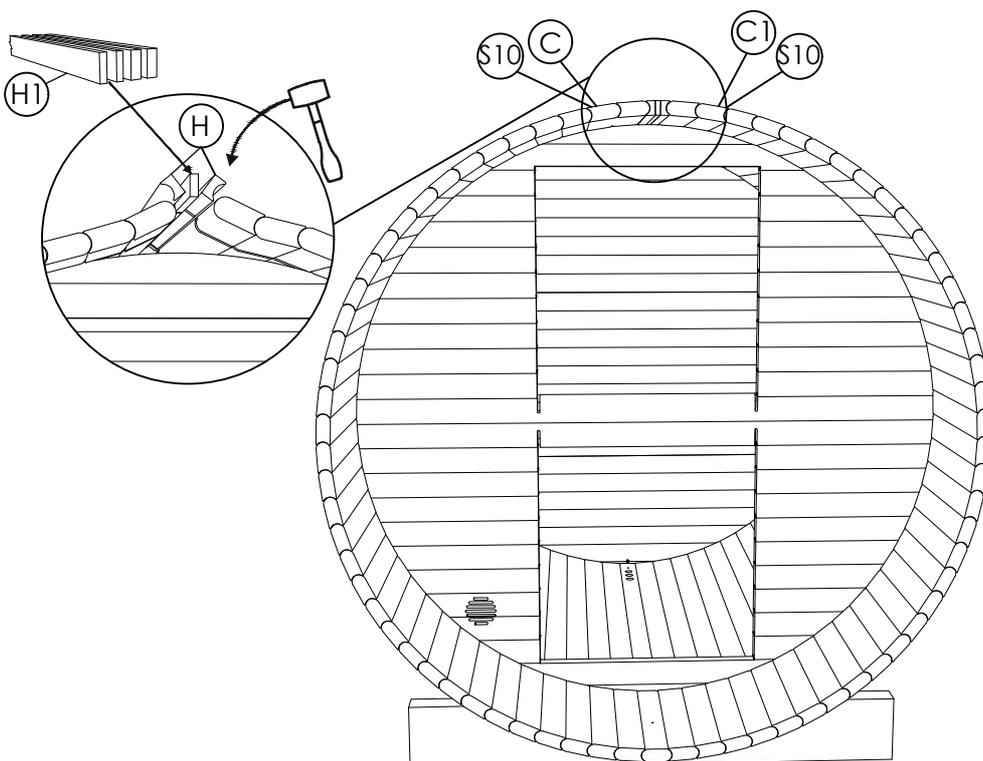
**STEP 8:** Take the upper rear panel (V3 or V1-panoramic window) and place it on the bottom rear panel (V). Secure it by using 2 screws (S4). Connect the panels (F2; V3) together by placing one body staves (C) both sides where you can reach, with (S10) screws.



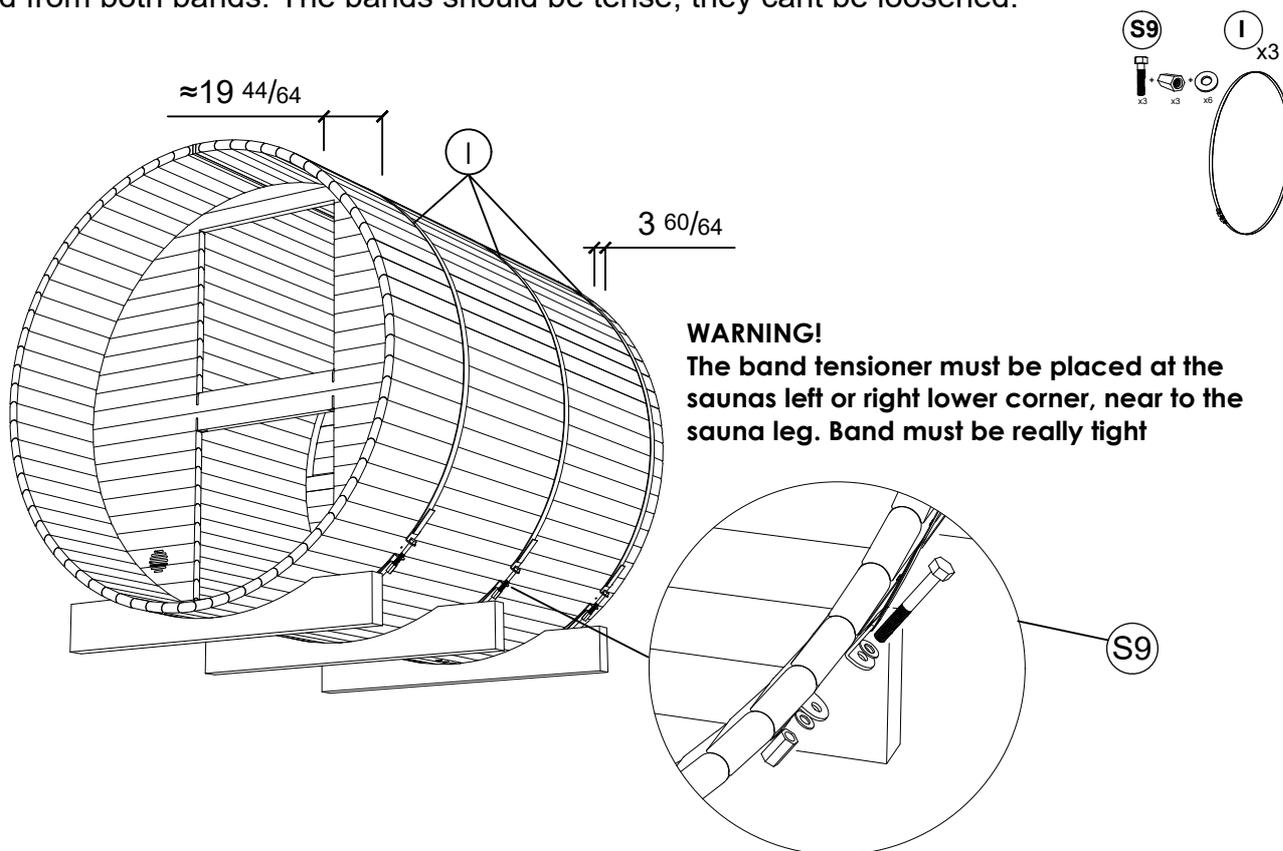
**STEP 9:** Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws (S10).



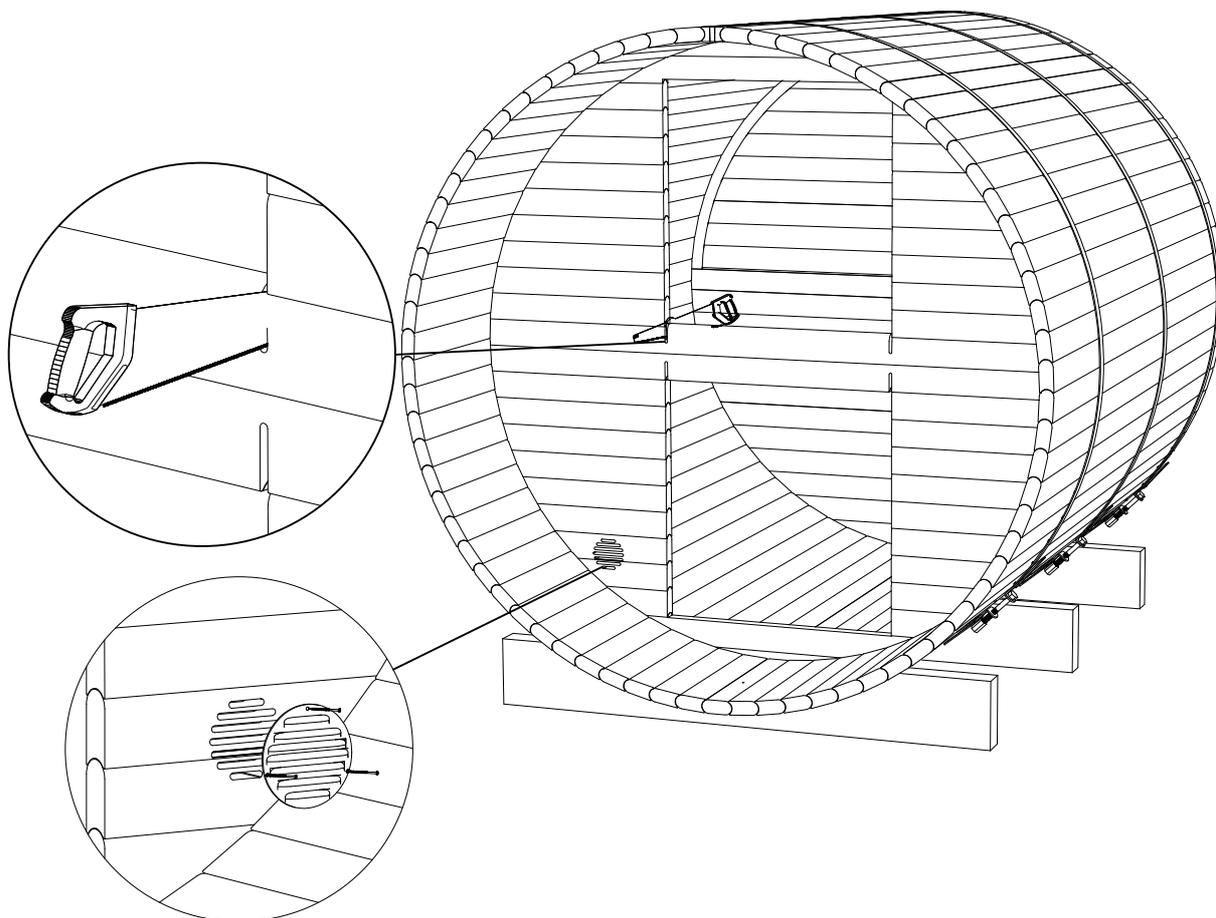
**STEP 10:** To finish the roof top joint, don't screw about last 3 boards (C) to each side, use roof finishing item (H). Different thickness filling pieces (H1) are provided to completely fill the gap. Once necessary parts are in, fix last boards with screws.



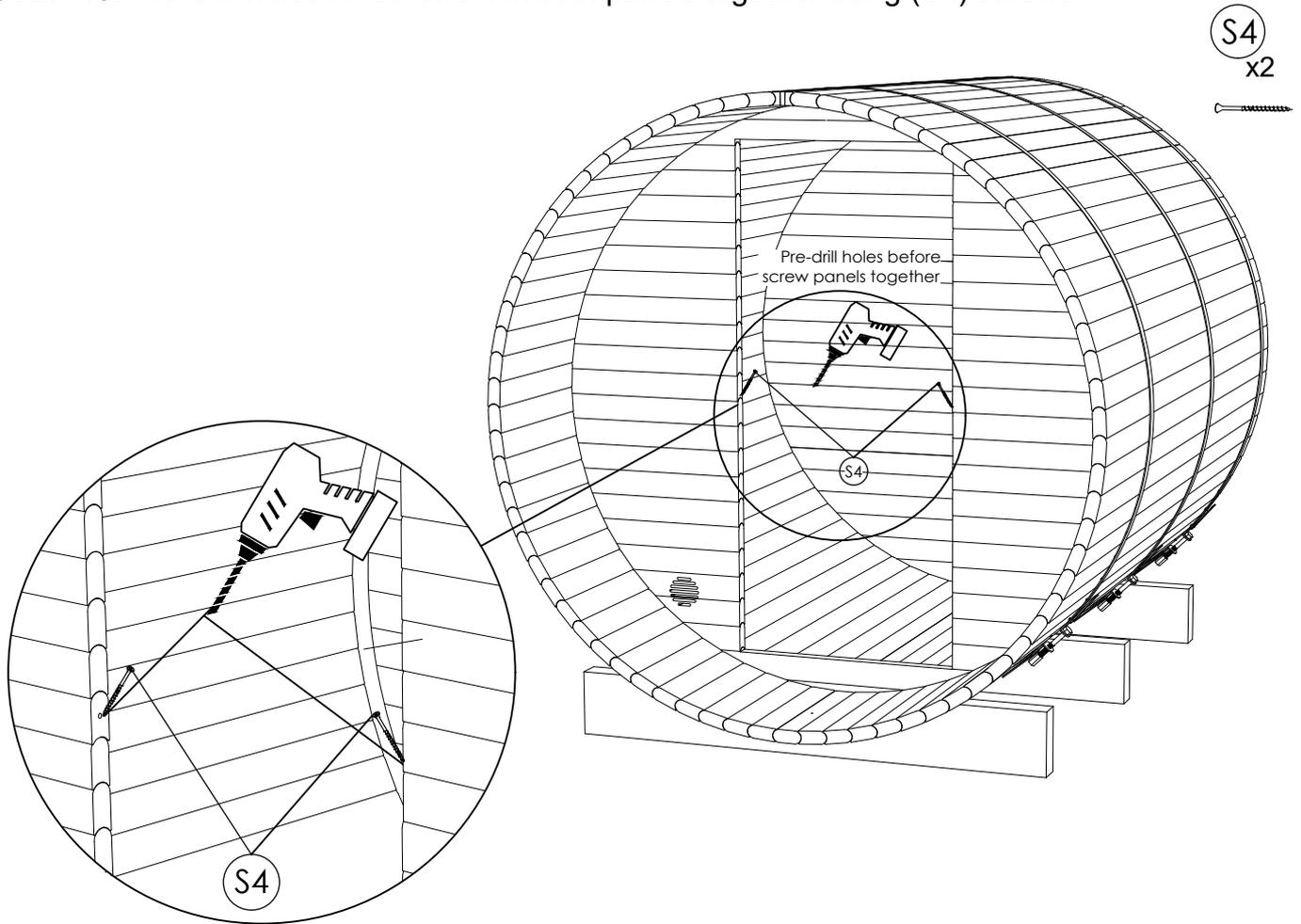
**STEP 11:** Install steel bands (I) by wrapping bands around the barrel, then connect with bolts and nuts (S9). Place steel bands evenly around the barrel approx  $\approx 19 \frac{44}{64}$ in from terrace and  $3 \frac{60}{64}$ in from sauna back. Bands should cover screw heads evenly. The middle band should be evenly placed from both bands. The bands should be tense, they cant be loosened.



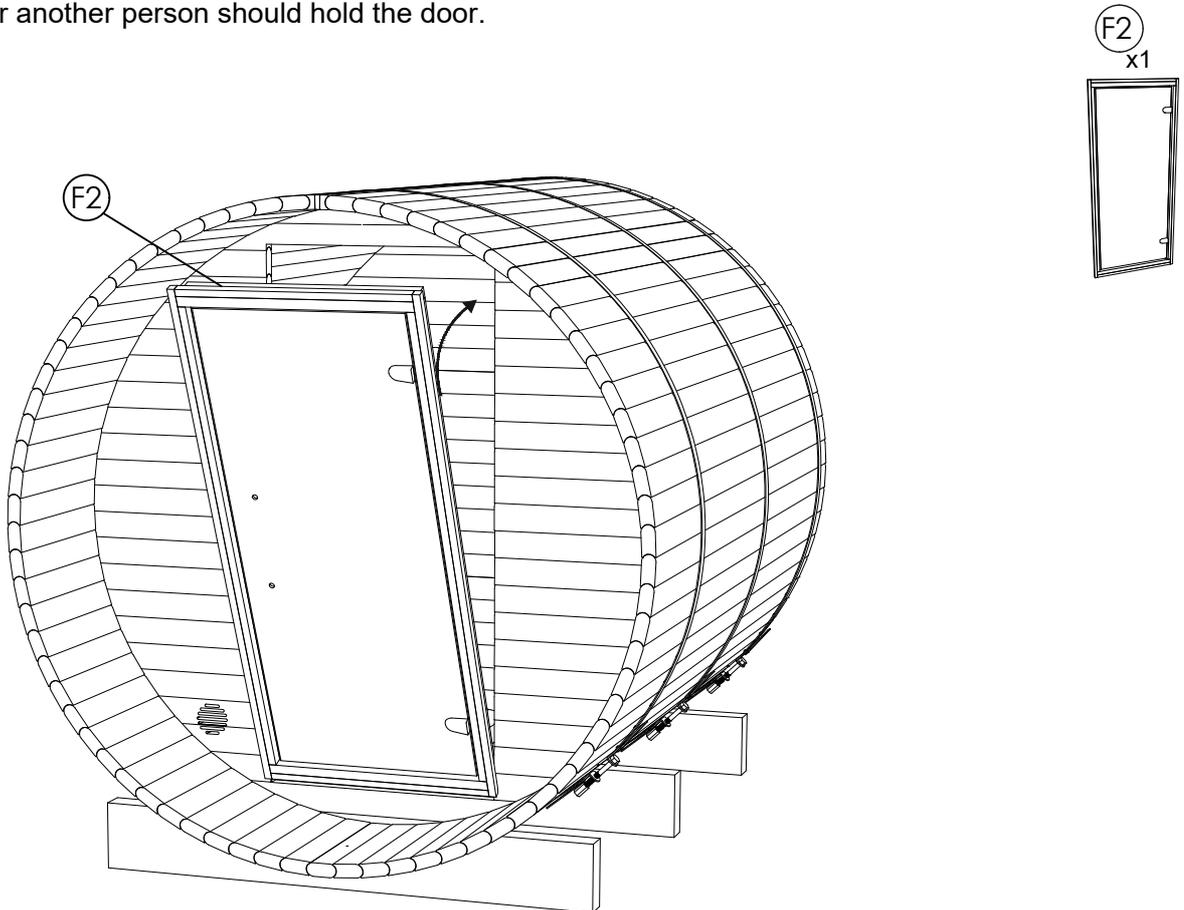
**STEP 12:** Draw straight line to connect both cuts. Use hand saw or other cutting machine to saw out excess boards for door box. It's recommended to saw out boards from inside. Fix ventilation grill (Y) from inside on ventilation cuts.



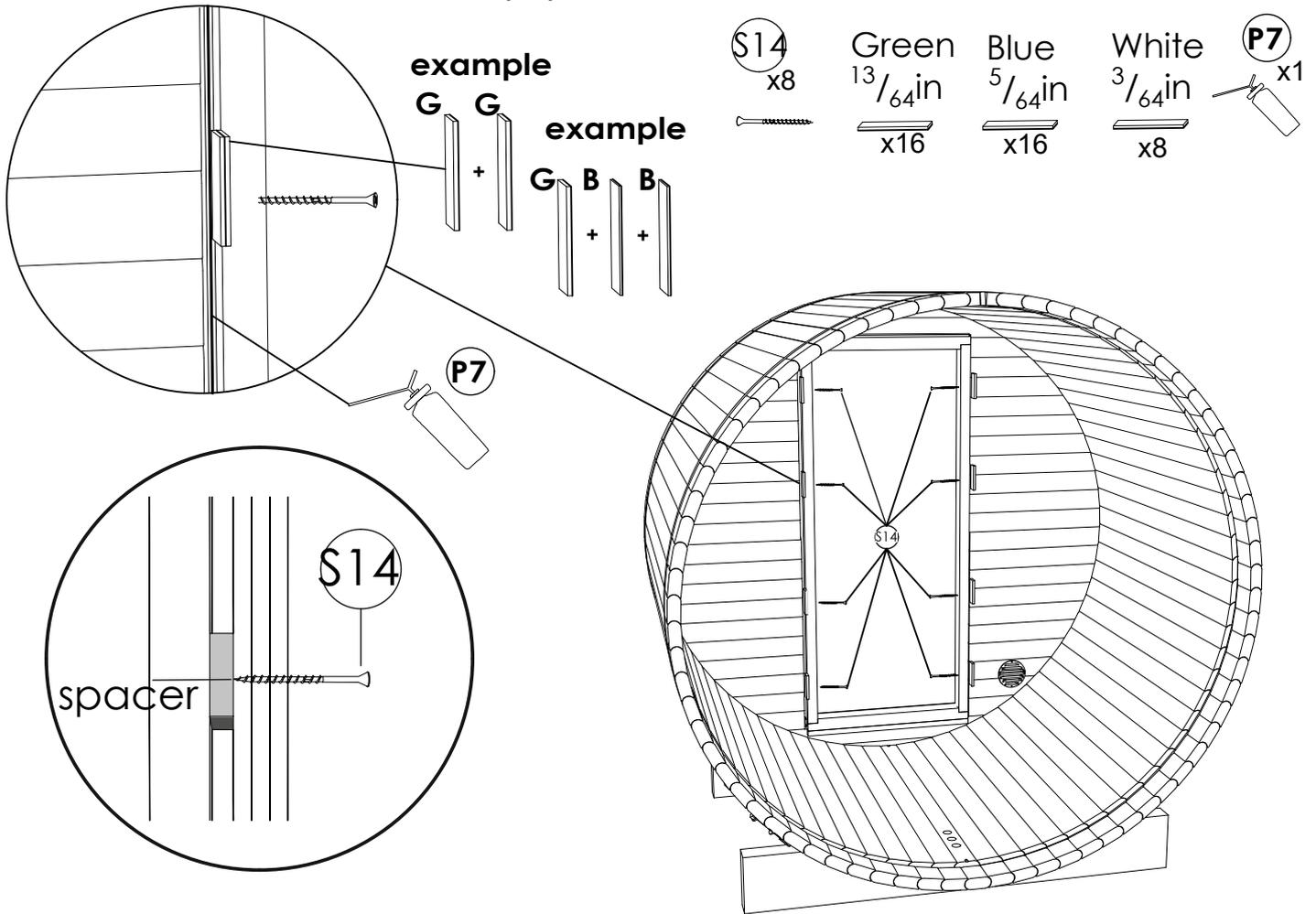
**STEP 13:** Pre-drill holes for screws. Fix both panels together using (S4) screws.



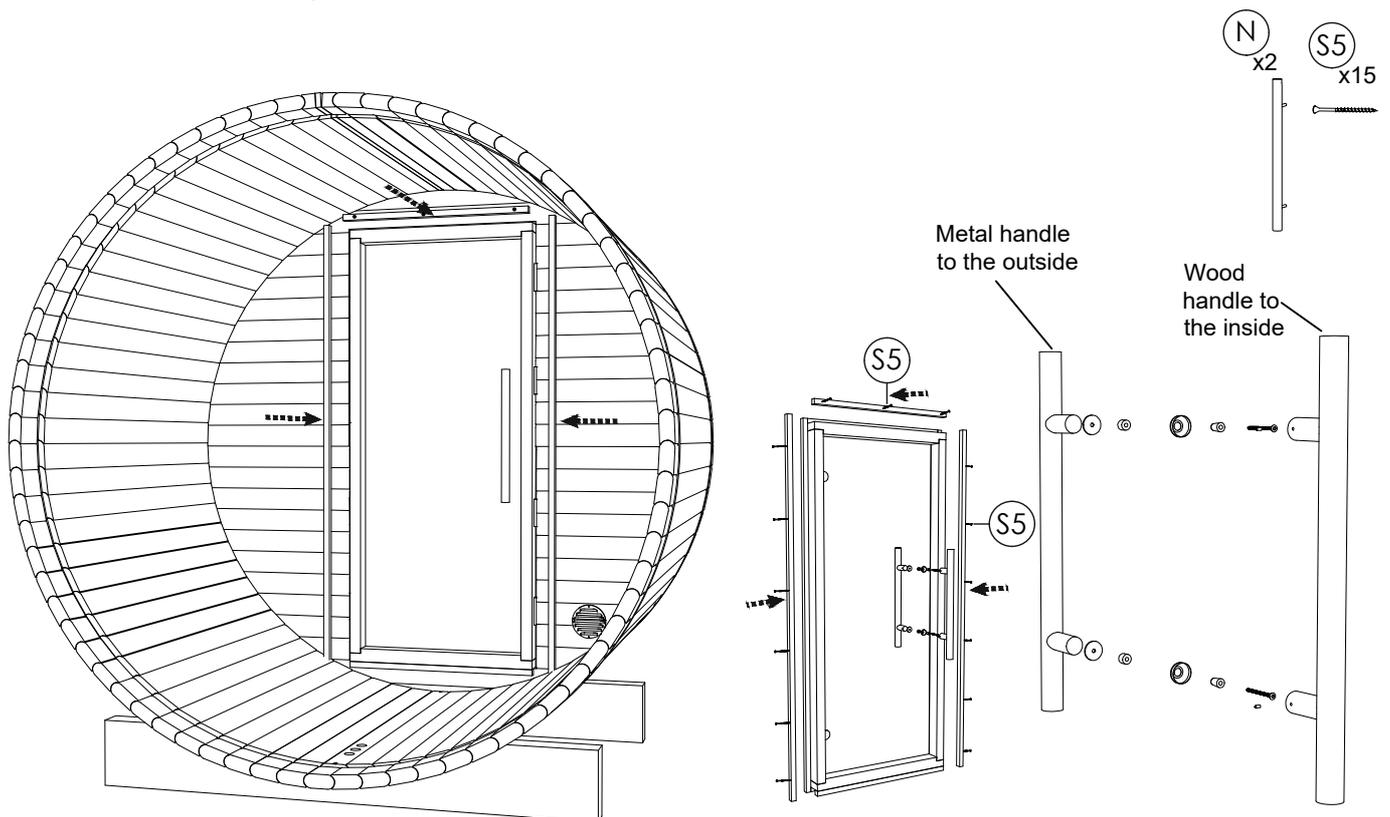
**STEP 14:** Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.



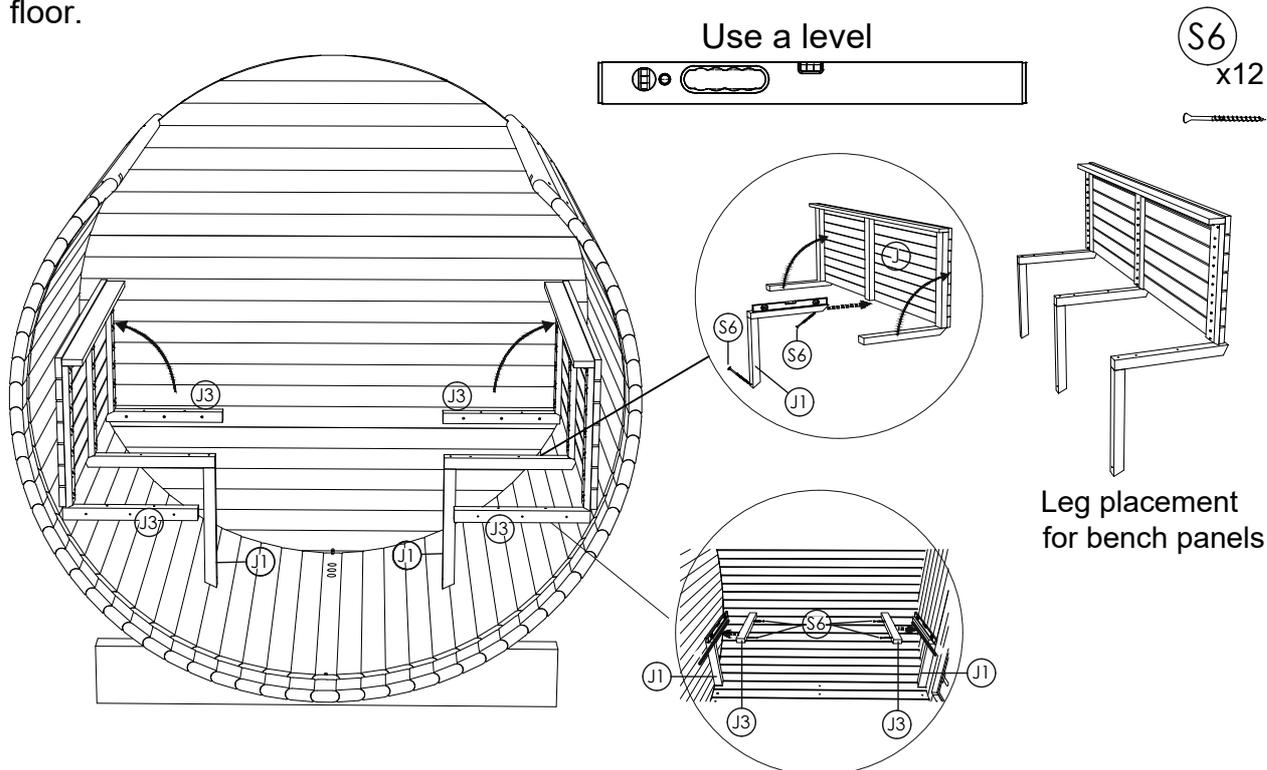
**STEP 15:** Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. First, fix one side of the door box with screws (S14) through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly,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



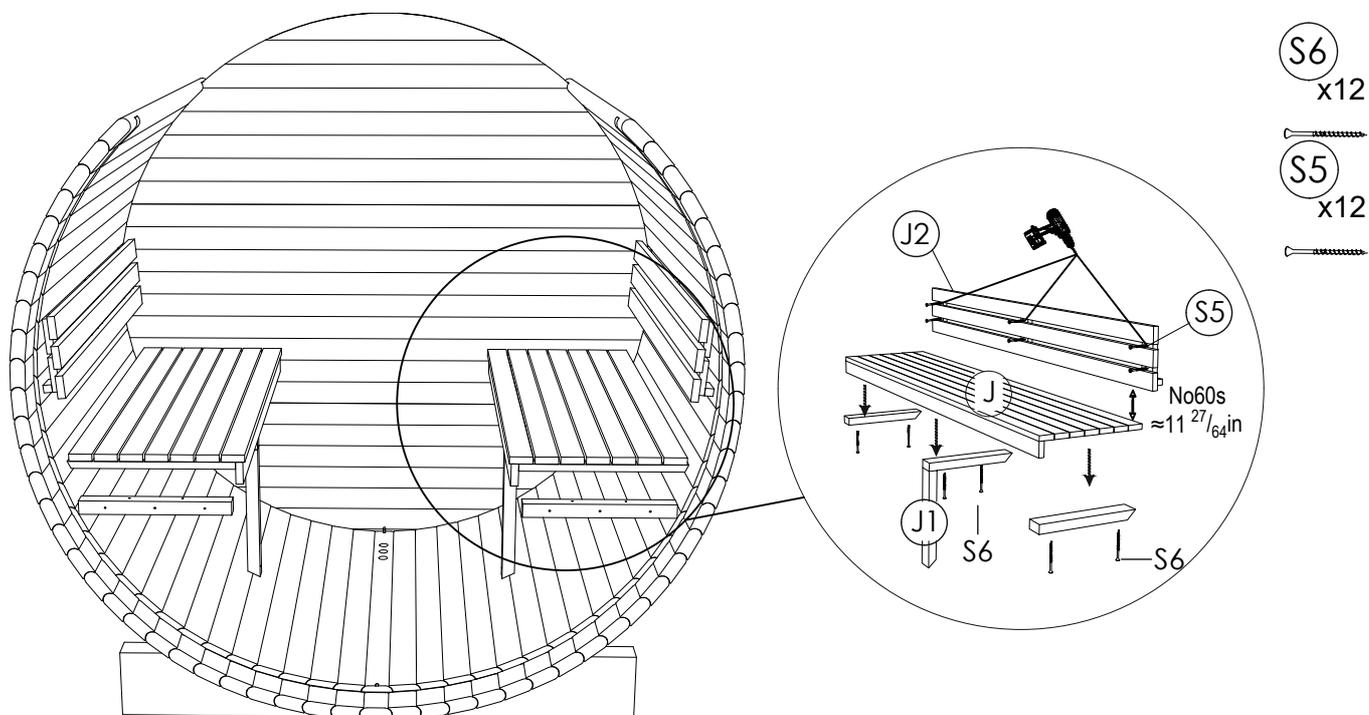
**STEP 16:** Fix door moldings to both sides and on top of the door with S5 screws.



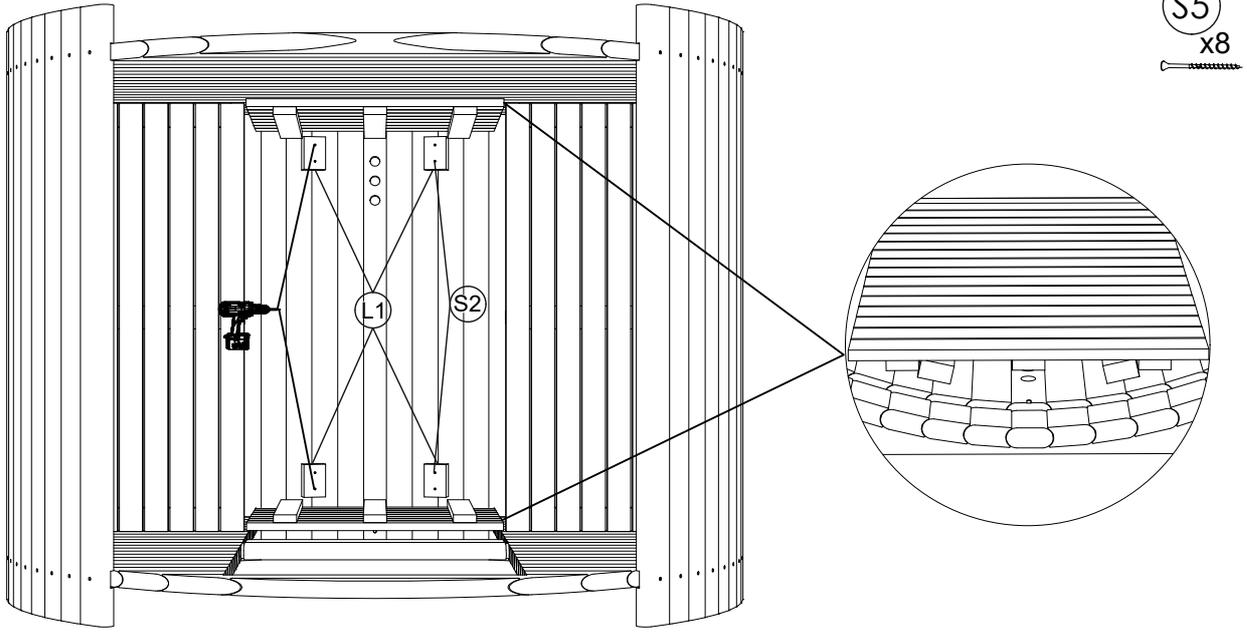
**STEP 17:** To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, mark a line where wall mounts will stand. Using screw (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall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



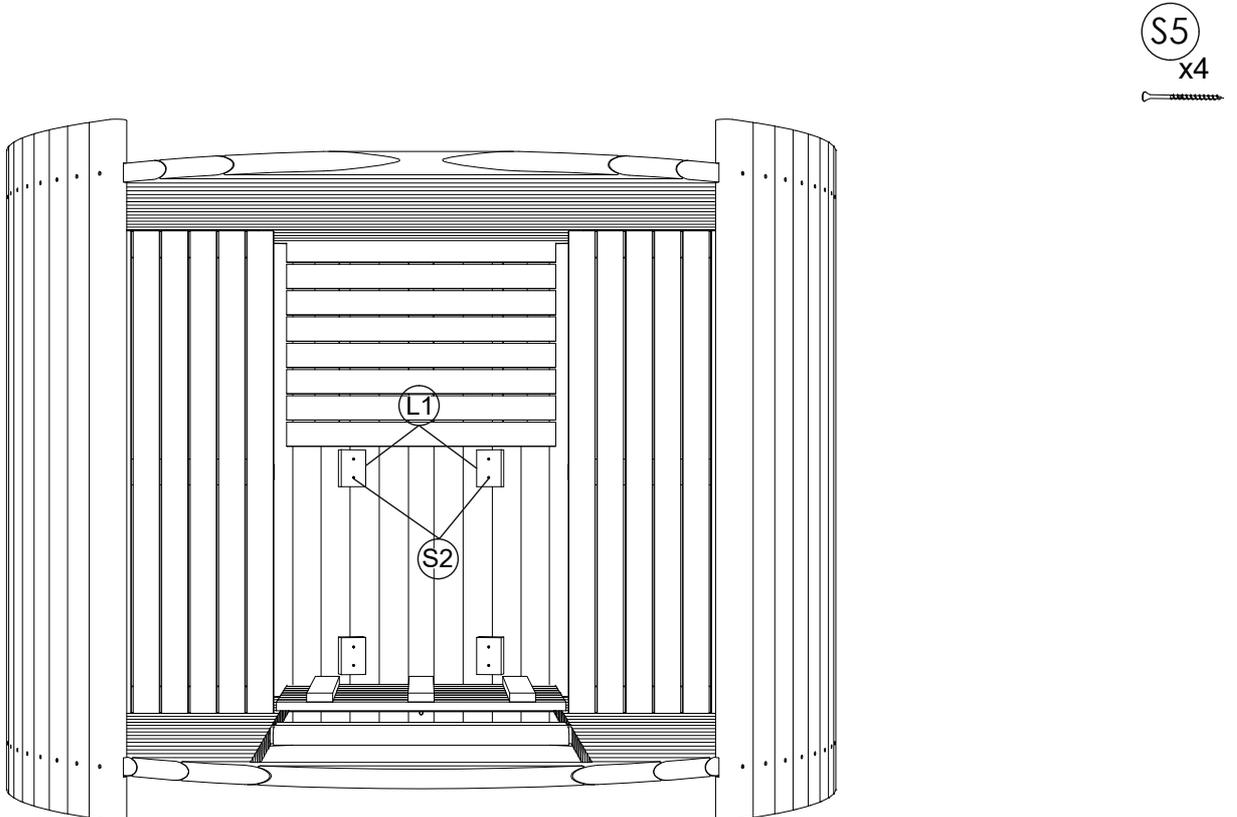
**STEP 18:** Pre-drill holes before fix backrest with screws, install backrests (J2) using screw (S2). Fix sauna bench (J) to wall mounts and support leg using (S6) screws. Fix bench panel (if ordered) with screws (S5).



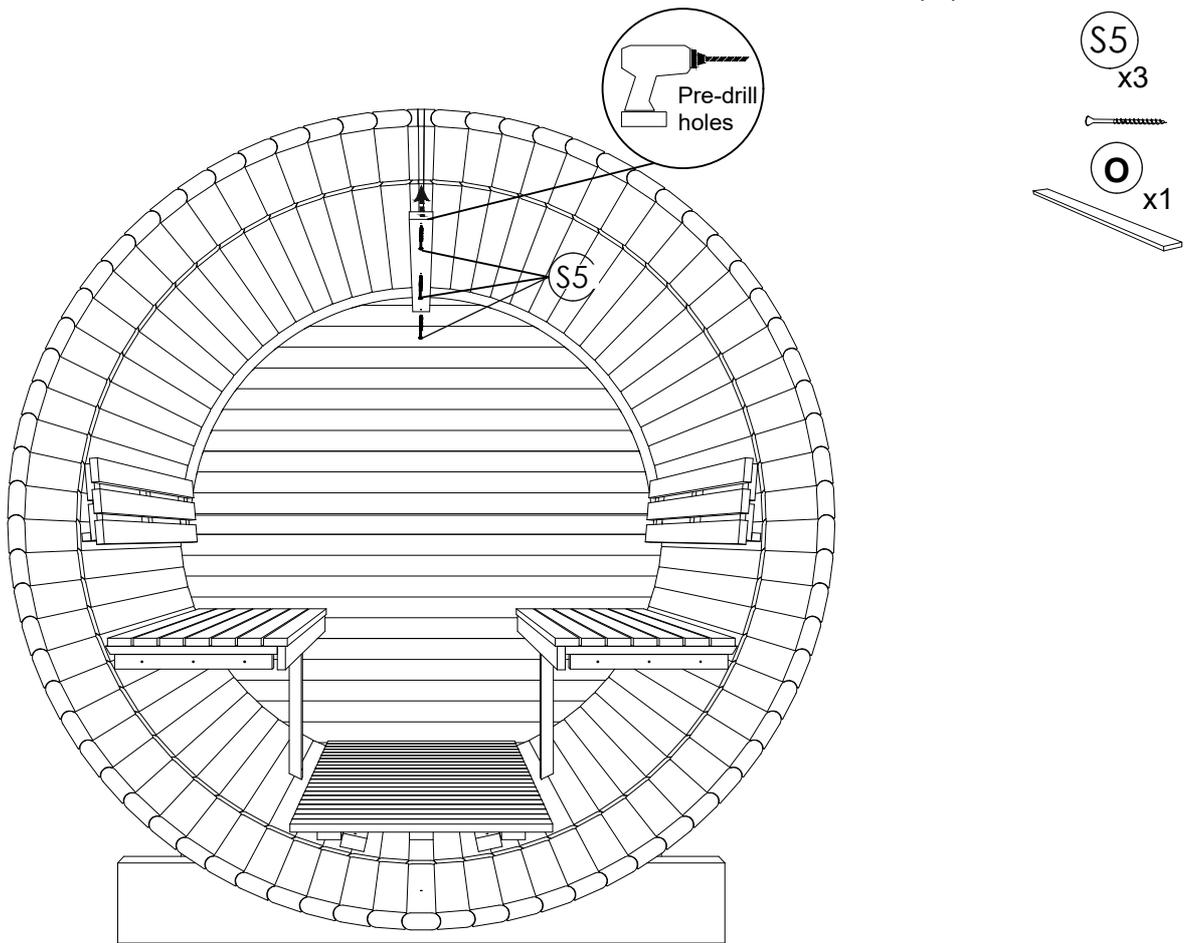
**STEP 19:** Place floor duckboards (L) to the both sides upwards and place fixing blocks next to the flooring cross boards. Pre-drill holes before fix with screws, install fixing blocks (L1) using screw or (S5).



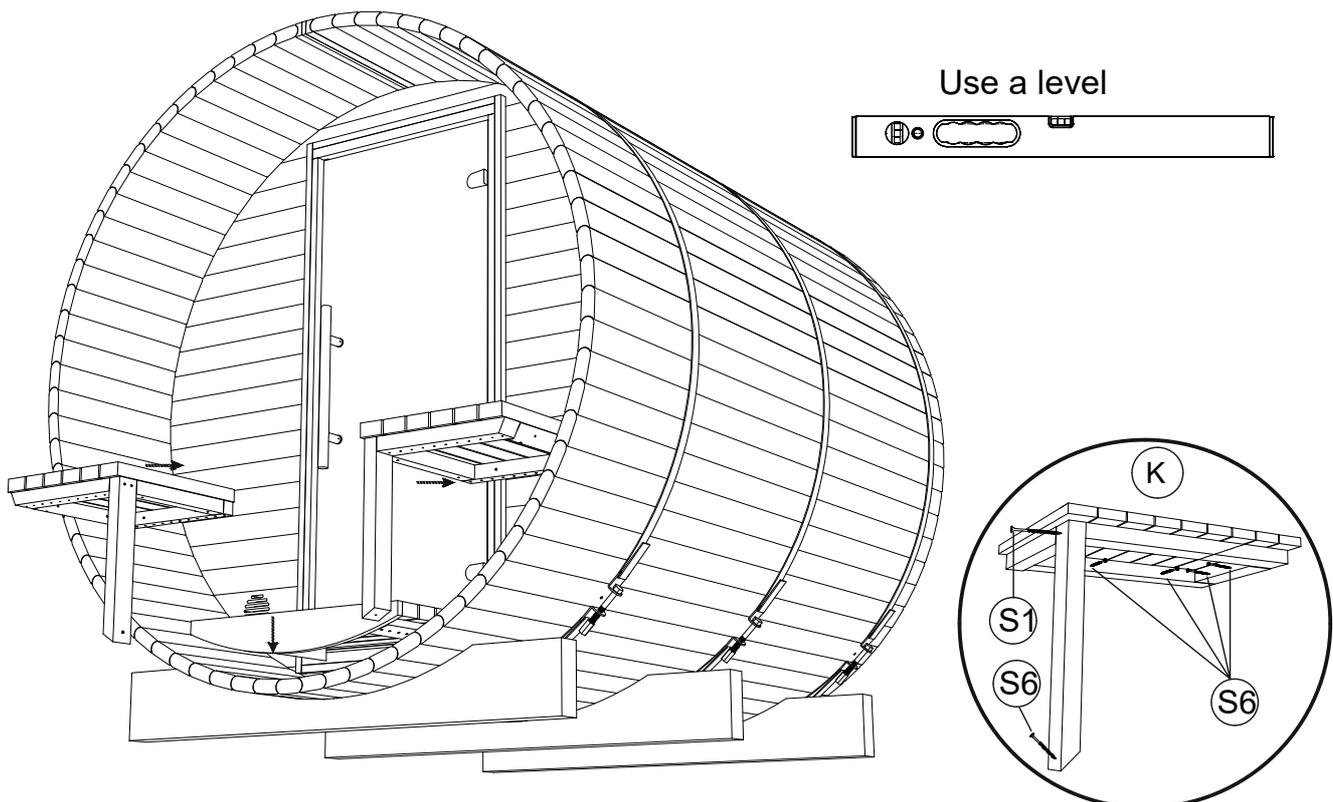
**STEP 20:** Pre-drill holes before fix with screws, install fixing blocks (L1) under floor duckboard using screw (S5). Place floor duckboards (L) on the floor and fix fixing blocks next to both flooring crossboards.



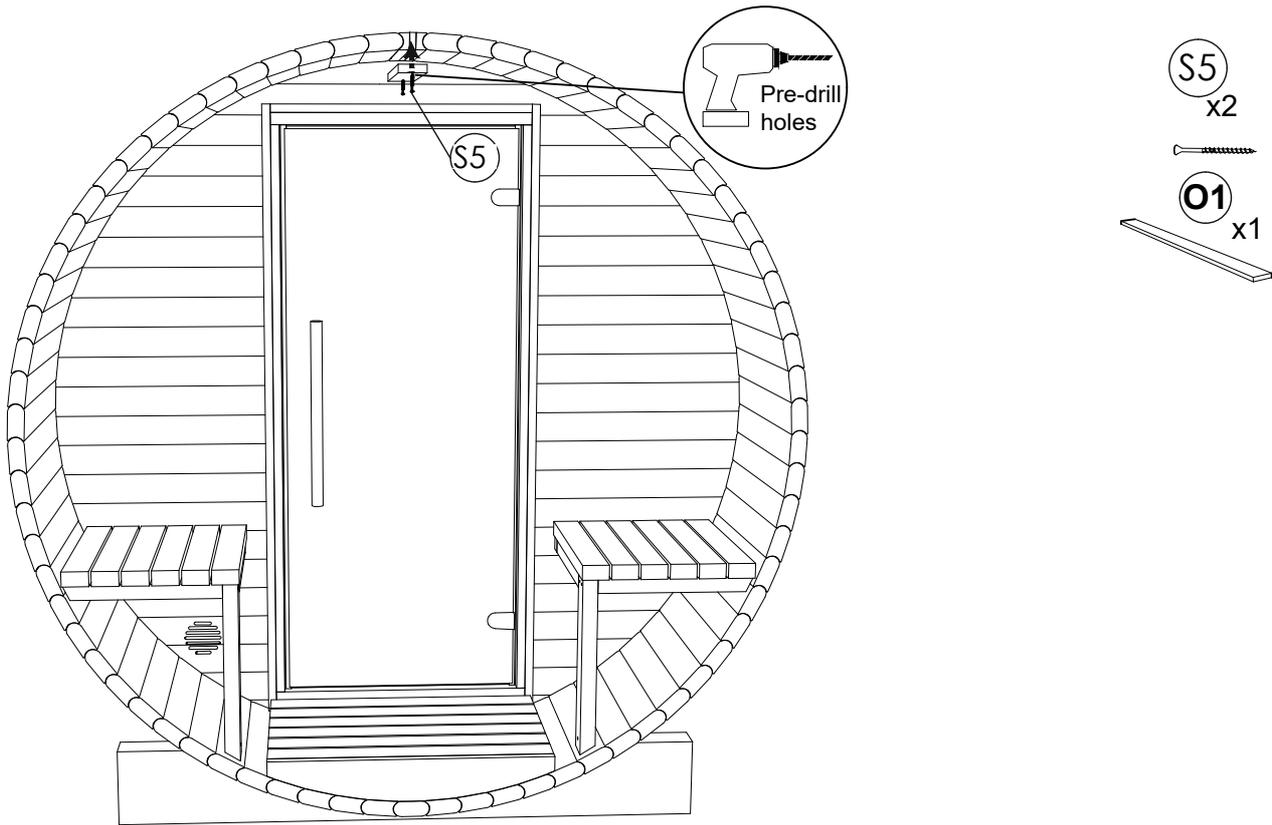
**STEP 21:** Pre-drill holes before fix stave with screws, install interior roof trim (O) in sauna with (S5) screws.



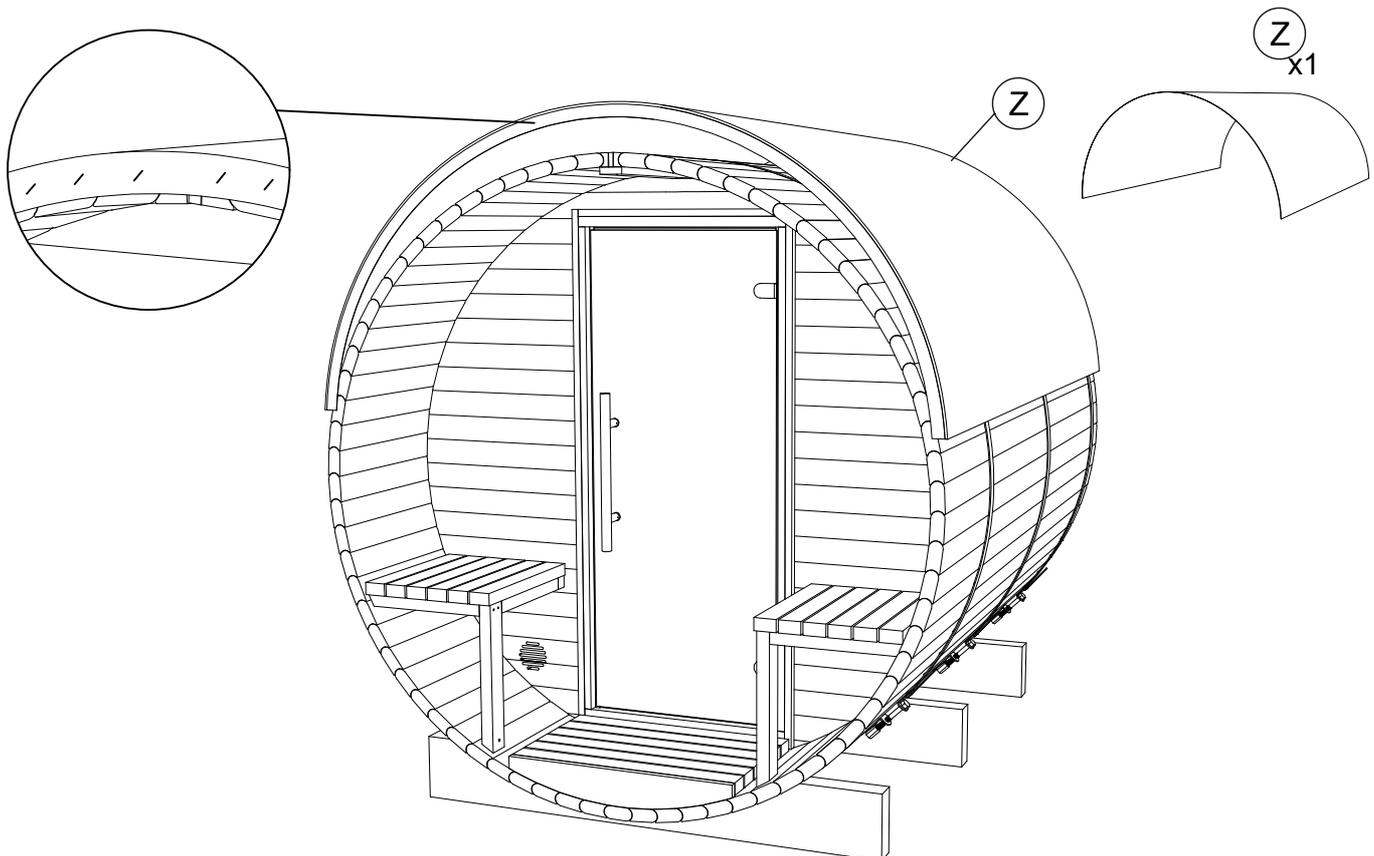
**STEP 22:** Install front and rear decorative roof finishing boards (W), fixing by screws (S7). Install porch benches (K), using screws (S6) and (S1). Hold the seat and leg assembly tight to the sauna wall. Using a level, make sure the bench seat is level from front to back. This will ensure proper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



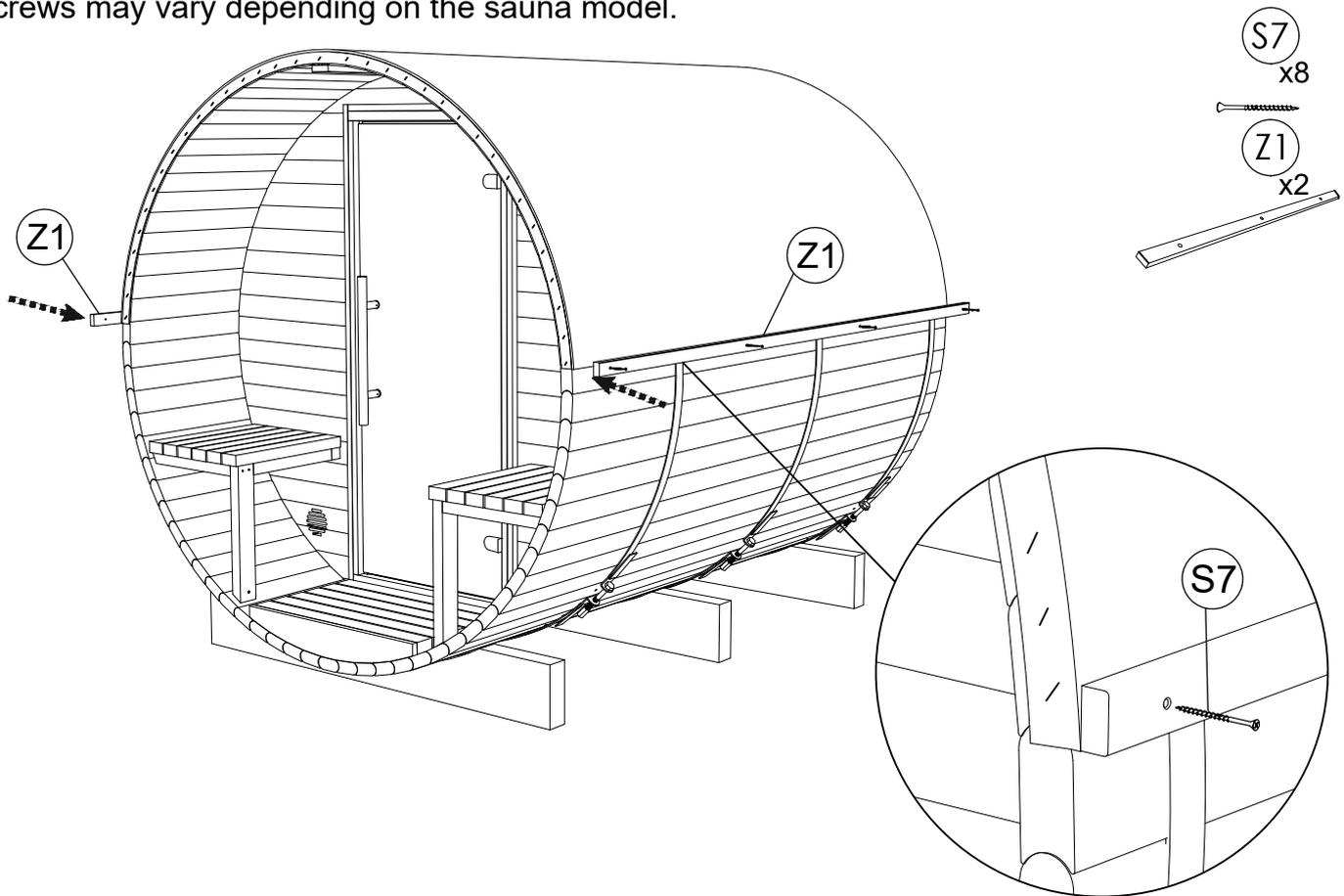
**STEP 23:** Pre-drill holes before fix stave with screws, install terrace roof trim (O1) in sauna with (S5) screws.



**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.

