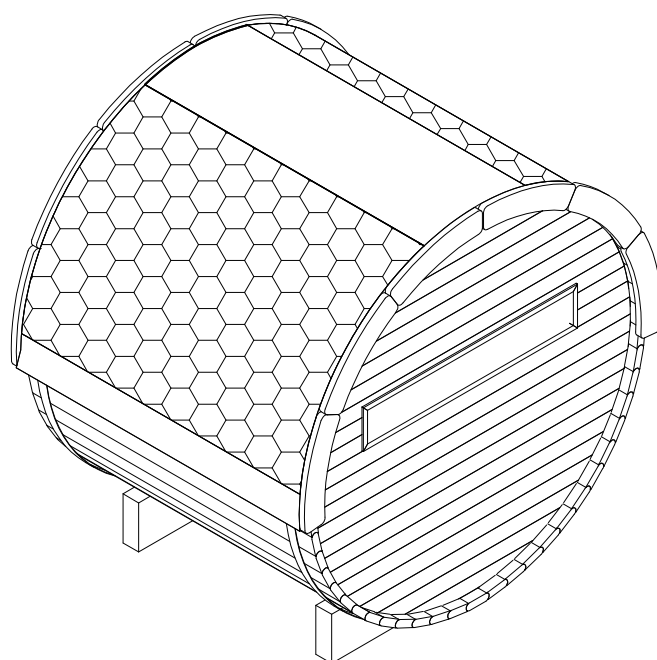
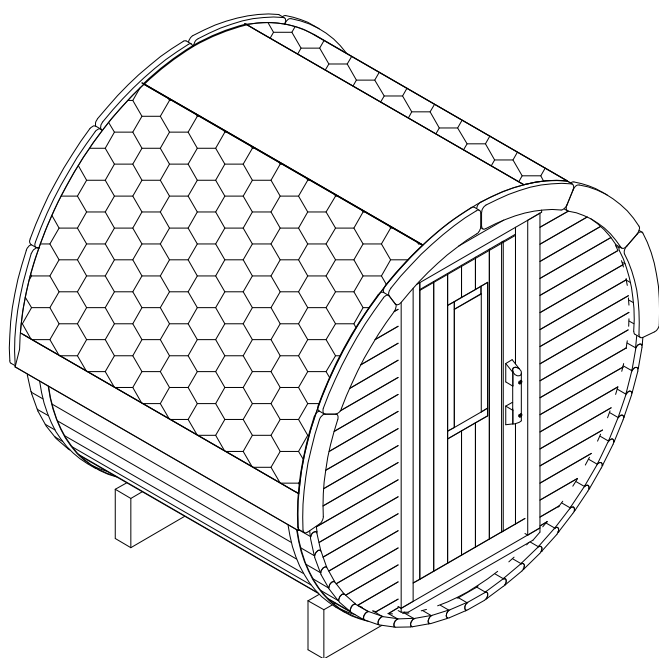


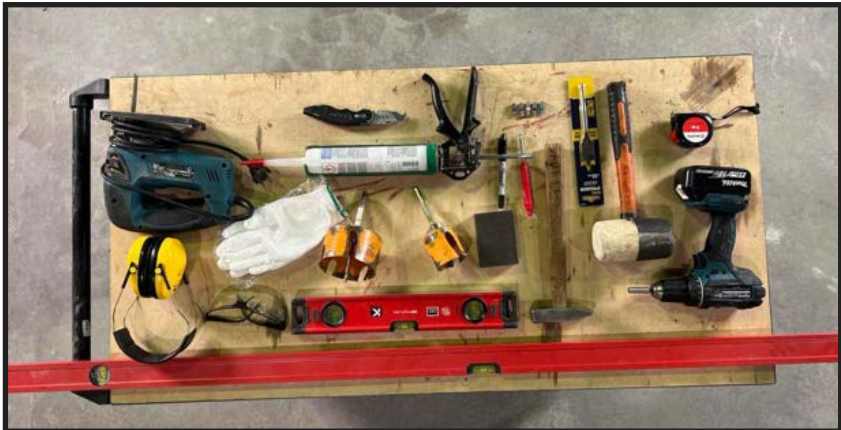
SAUNA BARREL \varnothing 1,9 m / 1,63 m

ASSEMBLY MANUAL



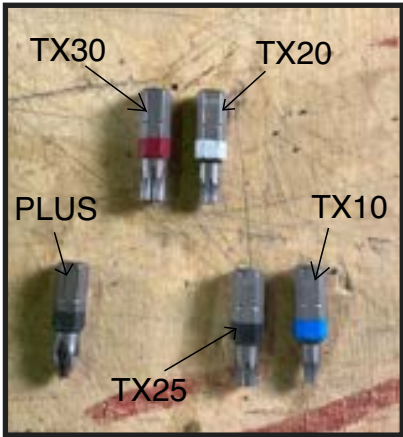
SAUNA UNPACKING PROCESS

1. Necessary tools for sauna assembling process.



| | |
|-------------------------|---|
| Rubber hammer | |
| Metal hammer | |
| Roulette | |
| Hacksaw | |
| Knife | |
| Pliers | |
| Marker | |
| Wood drill Ø22 mm | |
| Crown drill bit Ø107 mm | |
| Crown drill bit Ø60 mm | |
| Wood drill bit Ø8 mm | |
| Screwdriver | |
| The head TX20 | + |
| The head TX10 | + |
| The head (plus) | + |
| The head TX25 | + |
| The head TX30 | + |
| The level (short) | |
| The level (long) | |
| Saw | |
| Hexagon key | |
| Silicone | |

2. Use protective equipment (goggles, gloves)



3. Use proper loading machinery to move the sauna to the assembly location. Follow all safety conditions.



SAUNA UNPACKING PROCESS

4. Remove the screws of the metal corners (use paper box for parts and screws) and unassemble the package (use TX20/ TX25/ TX30).



SAUNA UNPACKING PROCESS

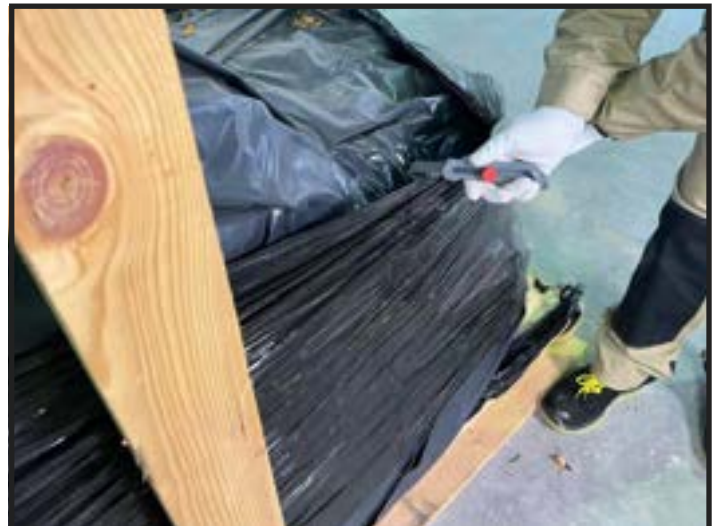
5. The packaging cardboard could be used as a base for laying sauna's parts.



6. **ATTENTION.** Leave marked boards as protection, until you remove all parts from the package.



7. Cut the packing tape and carefully remove the film.



SAUNA UNPACKING PROCESS

8. Find a paper box. There are screws and manual.



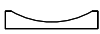


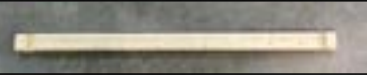


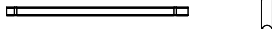


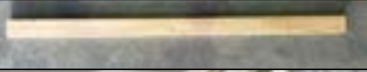

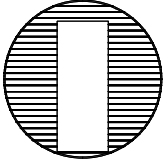

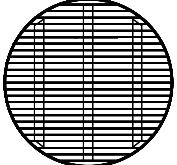



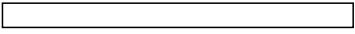
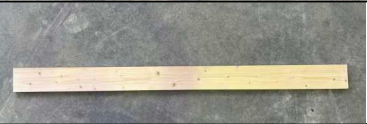
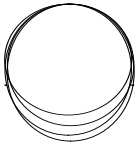



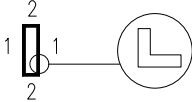



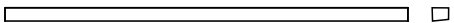

9. Lay out all the parts and screws.



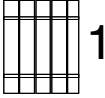


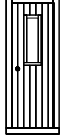


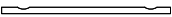
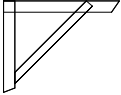



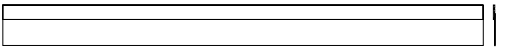

10. Check all parts and screws according list of details.





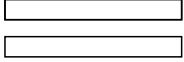



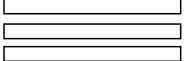
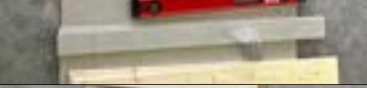


1. SAUNA BARREL - 1,63 m x 1,9 m

| No. | Details | Pcs | Dimension (x,y,z) mm |
|-----|--|---------|----------------------|
| ① |   | 2 | 245 x 1300 x 90 |
| ② |   | 1 | 130 x 1630 x 38 |
| ③ |   | 27 - 35 | 119 x 1630 x 38 |
| ④ |   | 27 - 35 | 119 x 1630 x 38 |
| ⑤ |   | 1 | 76 x 1630 x 38 |
| ⑤.1 | <p data-bbox="293 680 448 710">Extra boards</p>  | 60-80 | 3 1630 x 38 |
| ⑥ |   | 1 | 1900 x 1900 x 38 |
| ⑦ |   | 1 | 1900 x 1900 x 38 |
| ⑦.1 |   | 2 | |
| ⑦.2 |   | 1 | |
| ⑧ |   | 2 | 6070 x 50 |
| ⑧.1 |   | 2 | |
| ⑨ |   | 4 | 1. 1234 x 24 x 24 |
| | | 4 | 2. 219 x 24 x 24 |
| ⑩ |   | 1 | 1200 x 185 x 6 |
| ⑪ |   | 2 | 57 x 1378 x 45 |

1. SAUNA BARREL - 1,63 m x 1,9 m


| No. | Details | Pcs | Dimension (x,y,z) mm |
|------|---|-----|----------------------|
| 12 |  | 1 | 715 x 430 x 46 |
| 13 |  | 1 | 715 x 540 x 46 |
| 13.1 |  | 1 | 715 x 430 x 46 |
| 14 |  | 1 | 1600 x 700 x 65 |
| 16 |  | 3 | 70 x 820 x 18 |
| 16.1 |  | 3 | 70 x 1570 x 18 |
| 16.2 |  | 1 | 70 x 1570 x 18 |
| 17 |  | 6 | 440 x 450 x 45 |
| 18 |  | 2 | 495 x 1378 x 44 |
| 18.1 |  | 2 | 85 x 1378 x 28 |
| 19 |  | 2 | 800 x 1630 x 30 |
| 20 |  | 2 | 118 x 1630 x 18 |
| 20.1 |  | 12 | 125 x 545 x 30 |

1. SAUNA BARREL - 1,63 m x 1,9 m

| No. | Details | | Pcs | Dimension (x,y,z) mm |
|-----|---|--|-----|----------------------|
| ②1 |  |  | 1 | 700 x 600 x 10 |
| ②2 |  |  | 2 | 890 x 120 x 18 |
| ②3 |  |  | 1 | 900 x 600 x 10 |
| ②4 |  |  | 3 | 790 x 70 x 10 |
| ②5 |  |  | 1 | 800 x 600 x 10 |

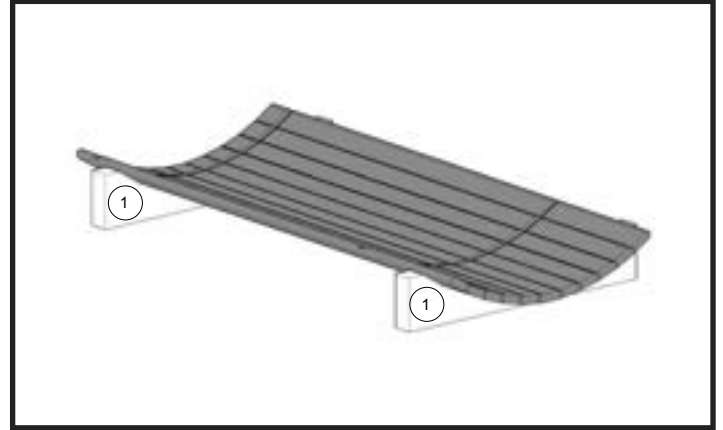
*NOTE. There may be the additional parts not mentioned in the list of Detail depending on set ordered.

1. SAUNA BARREL - 1,63 m x 1,9 m

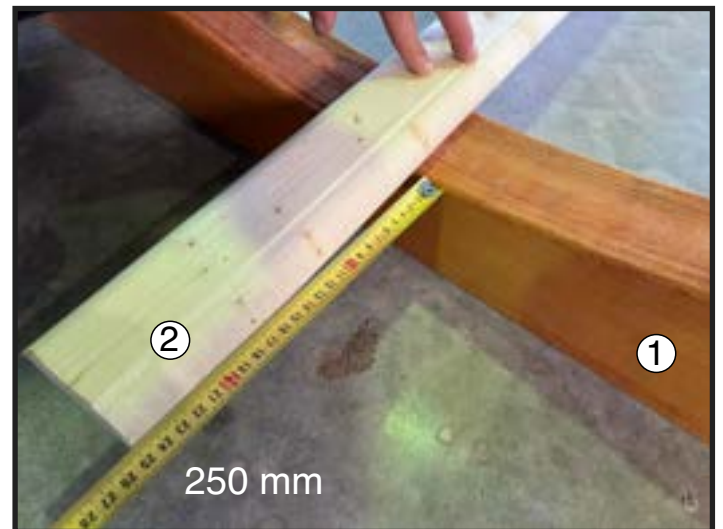
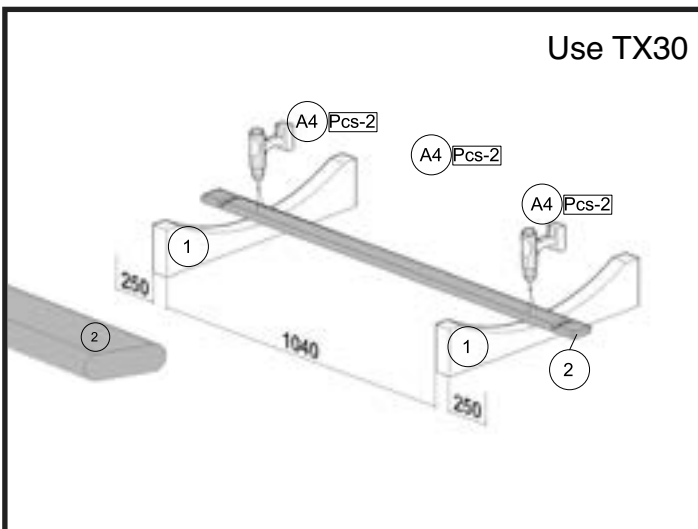
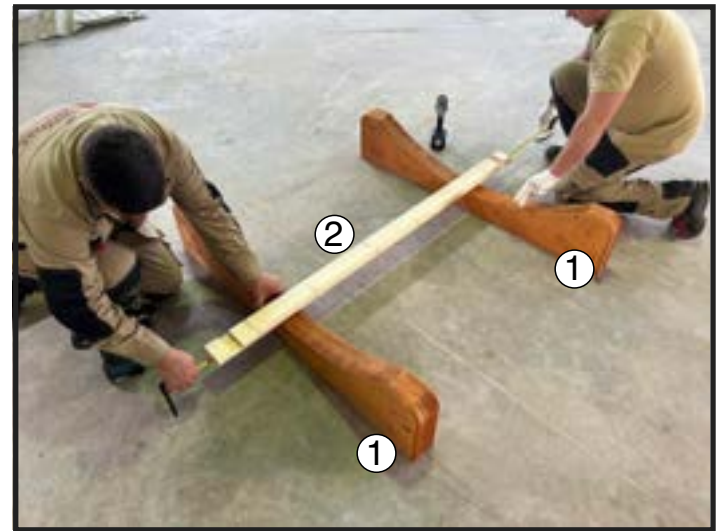
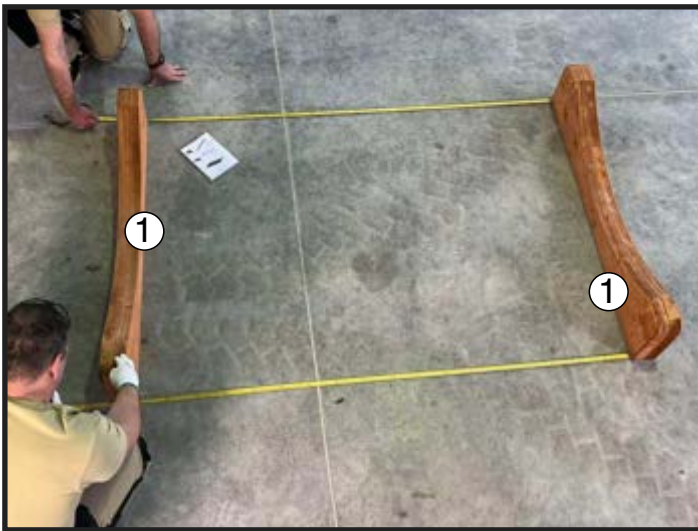
| No. | Details | | Pcs | Dimension (x,y,z) mm |
|-------|---|--|-----|----------------------|
| A0 |  |  | 2 | 50 x 3000 x 3 |
| A1 |  |  | 1 | 500 x 1630 x 3 |
| A2 |  |  | 36 | 317 x 1000 x 3 |
| A3 |  | Tx25 | 10 | 5 x 100 |
| A4 |  | Tx30 | 18 | 6 x 80 |
| A5 |  | Tx20 | 43 | 5 x 30 |
| A6 |  | Tx20 | 92 | 4 x 70 |
| A7 |  | Tx20 | 198 | 4 x 50 |
| A8 |  | Tx20 | 51 | 4 x 35 |
| A9 |  | | 1p | 2.5 x 20 |
| A10 |  | | 56 | 1.55 x 32 |
| A11 |  |  | 1 | — |
| A11.1 |  |  | 2 | 5 x 10 |
| A12 |  |  | 1 | — |
| A13 |  |  | 1 | — |
| A14 |  |  | 2 | 150 x 260 x 18 |
| | | | | |

1. SAUNA ASSEMBLING FIRST STEP

1.1. Place the crossbars at the required distance.



1.2. The distance between the crossbars is 1040 mm. Put part no. 2 on crossbars.

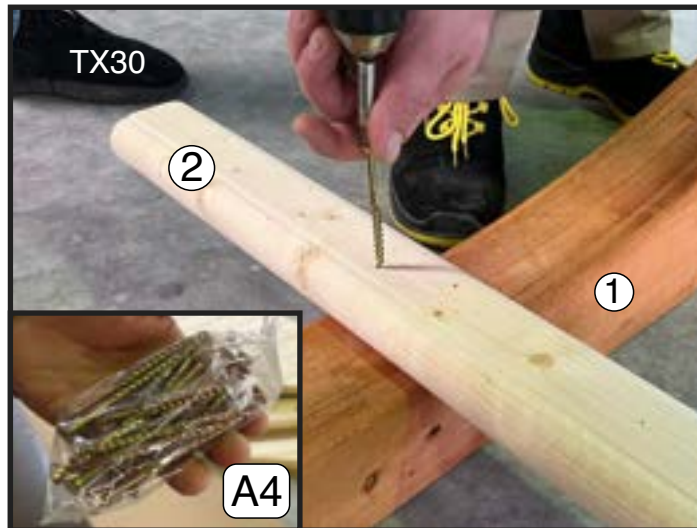


1. SAUNA ASSEMBLING FIRST STEP

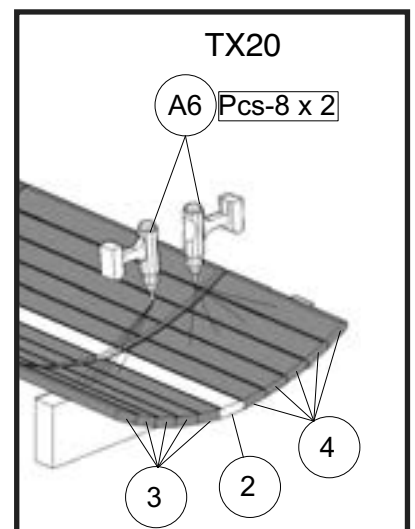
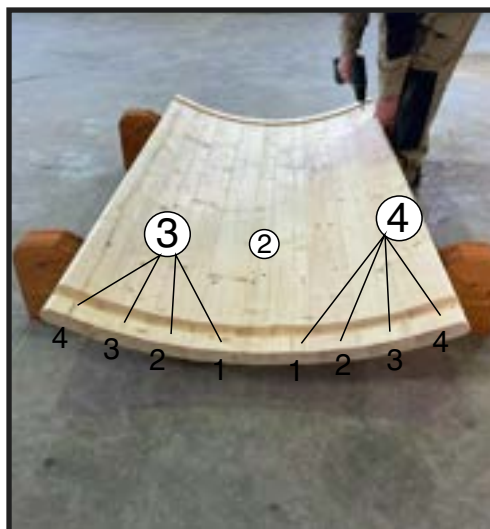
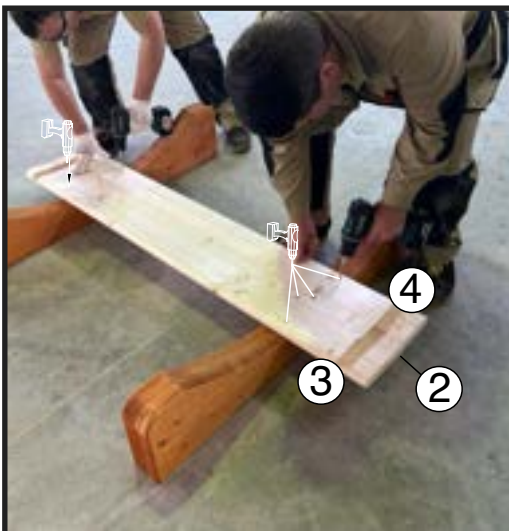
1.3. Measure the distances and find a center.
Measure the diagonals, make sure they are the identical.



1.4. Fix 2 pcs screws to board no. 2 to each side. Screws - A4 (use TX30)

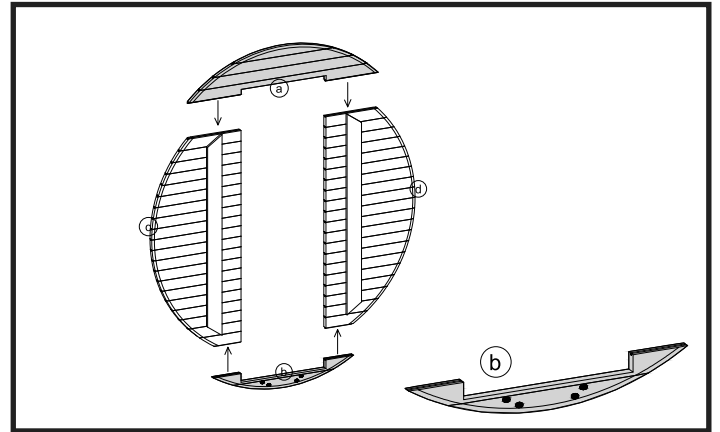
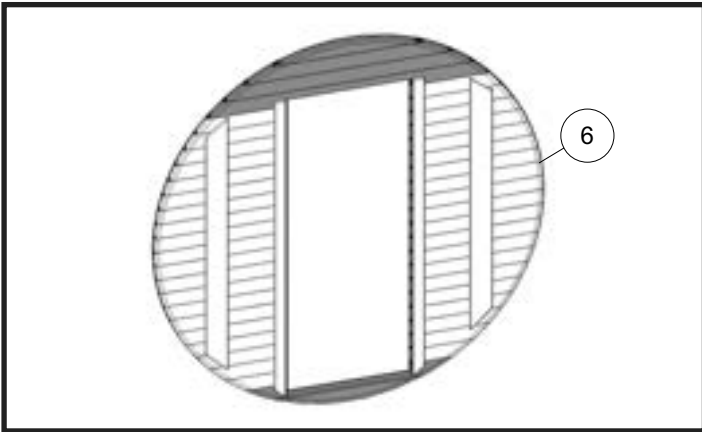


1.5. Fix side boards (4 boards to each side) with screws A6 (use Tx20).
IMPORTANT: not use the extra boards.

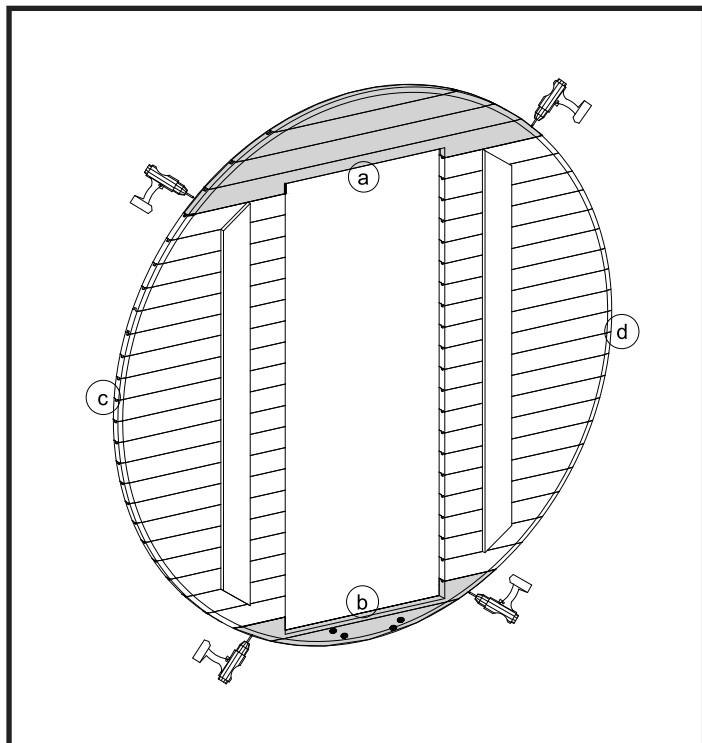
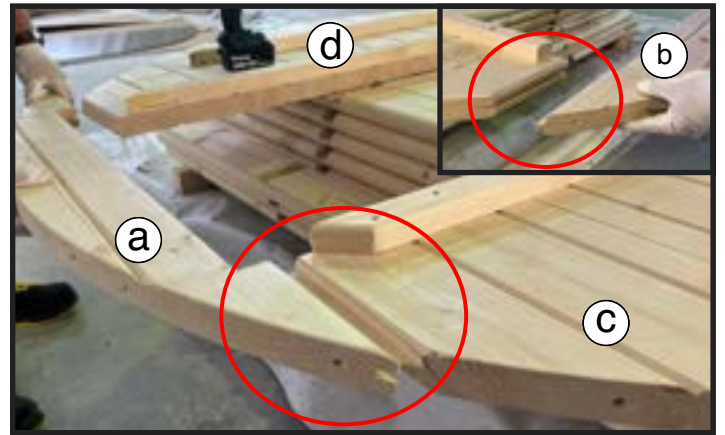
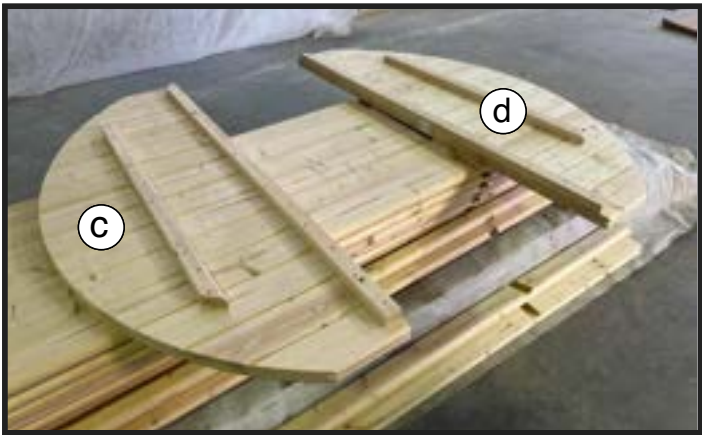


2. ASSEMBLY OF THE FRONT PANEL

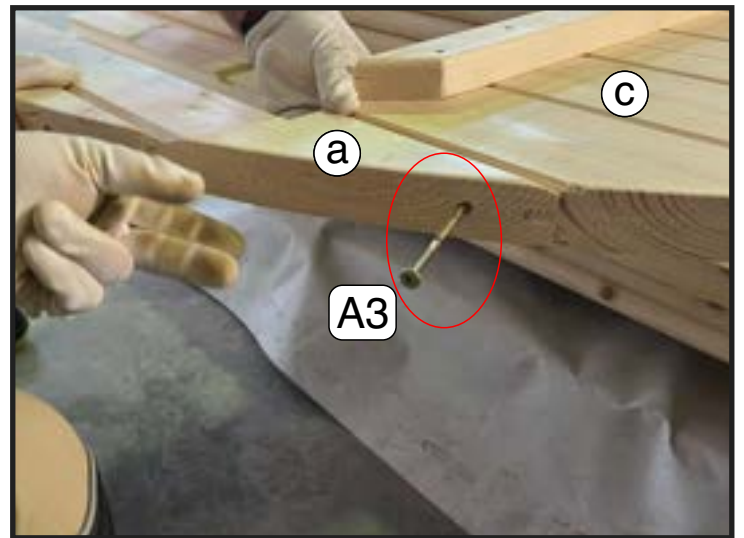
2.1 Take 4 parts (a,b,c, d) of front panel



2.2. Pay attention to parts No. „a“ (for top) and „b“ (for bottom).

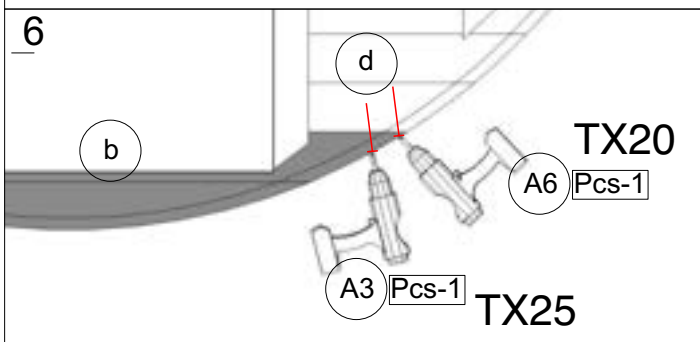
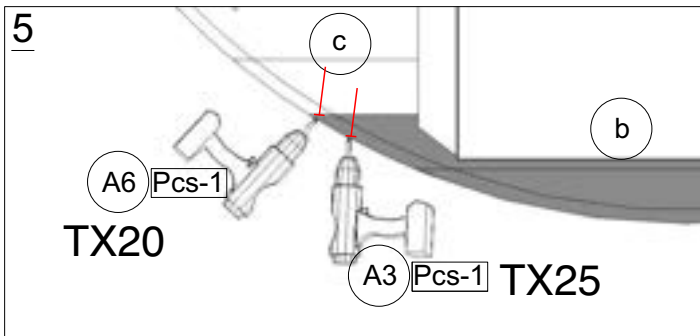
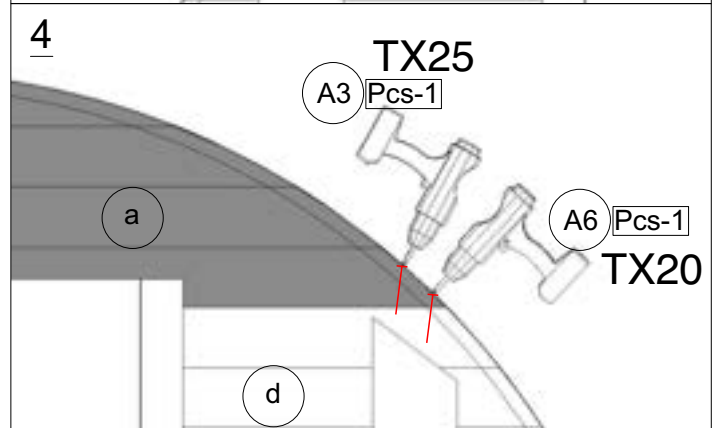
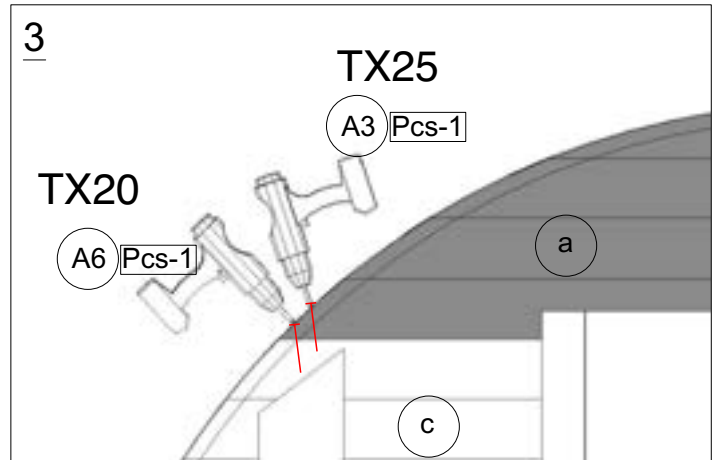
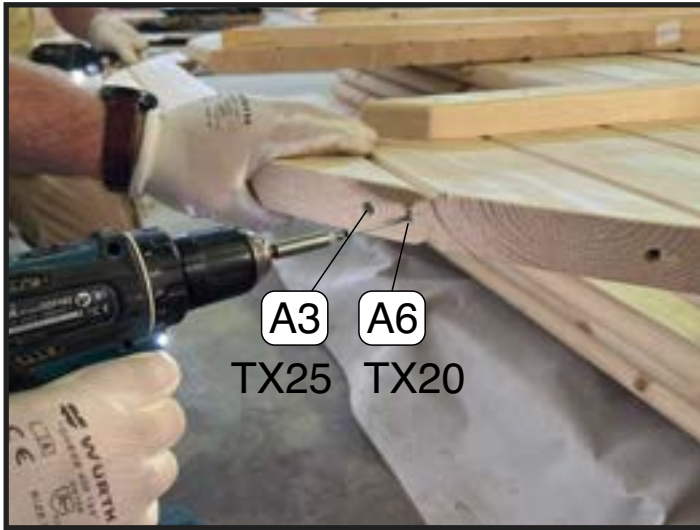


2.3 Conect: Part „a“ with Parts „c“ and „d“.
Part „b“ with parts „c“ and „d“.
(Use Tx25)



2. ASSEMBLY OF THE FRONT PANEL

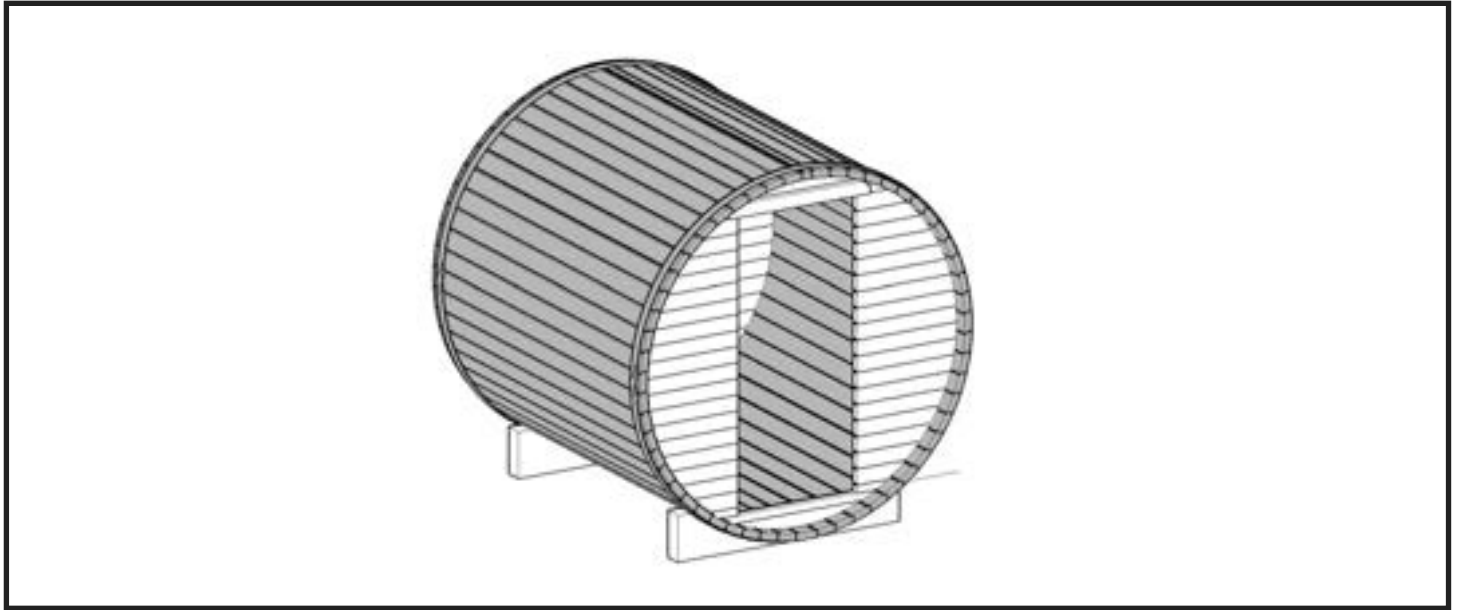
2.3. Each connection should be fixed with two types of screws. First it is screwed with screws A3 into the holes made, then additionally screwed with screws A6.



2.4. Assembled front panel. Note that part no. „b“ with holes is the bottom part of the panel.



3. FRONT PANEL INSTALLATION



3.1. Front panel installation. Put the assembled front panel to the groove of the bottom boards. Use the level to make sure that front panel stands strictly vertical.



3.2. Fix the front panel with screws A6.
(use TX20)

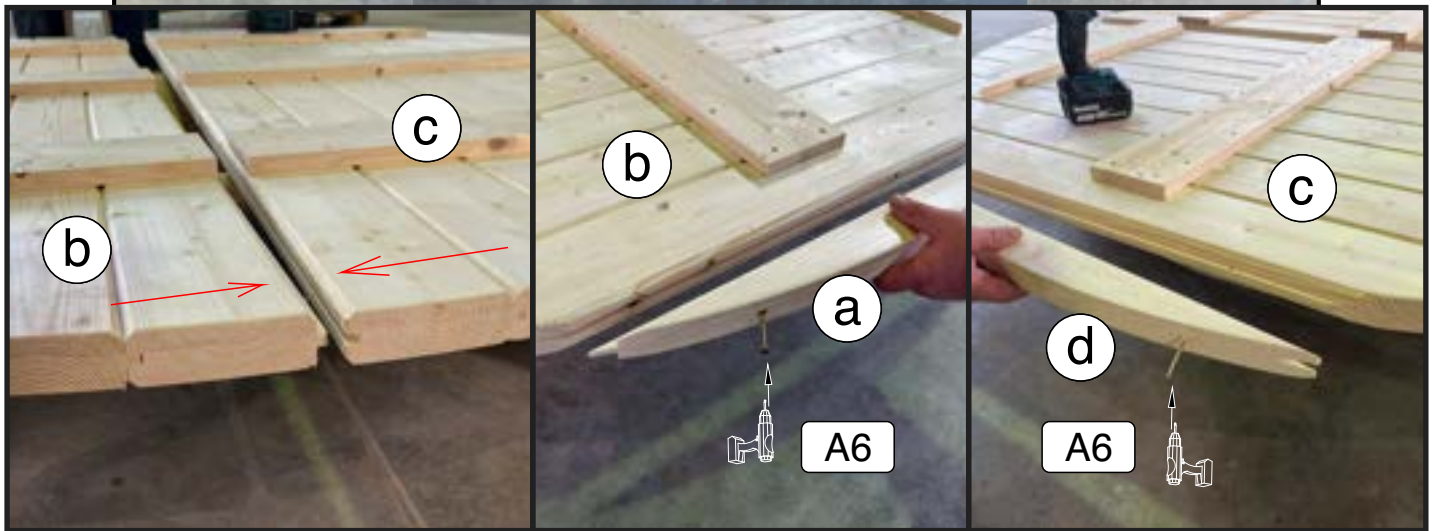
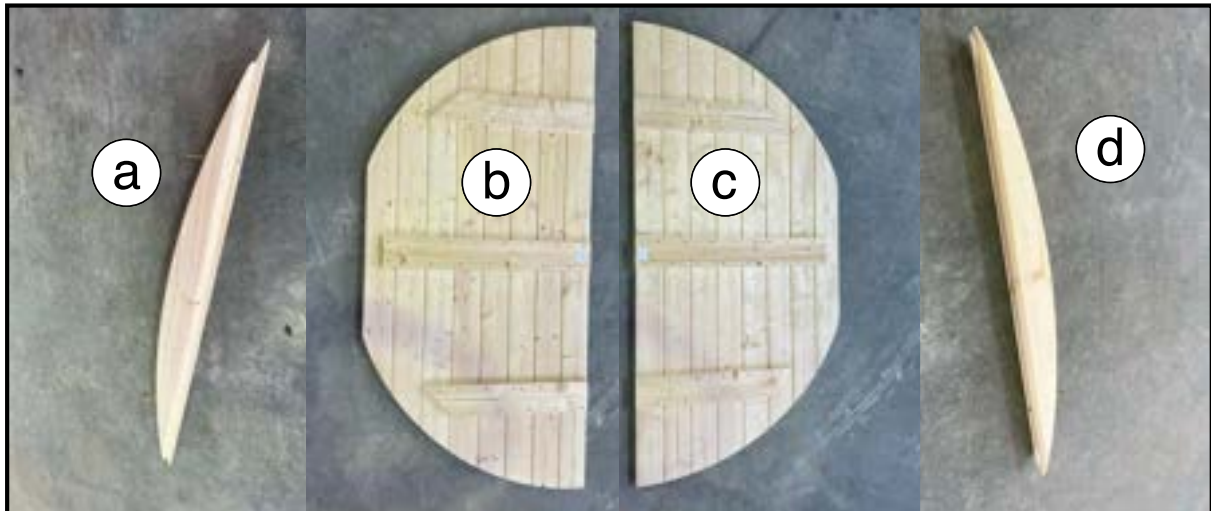


3.3. **Note.** Use a board (used for the packing box) and attach it to the front panel and the bottom of the sauna. This board will ensure that the panel will stand stably. This is a temporary safety feature.

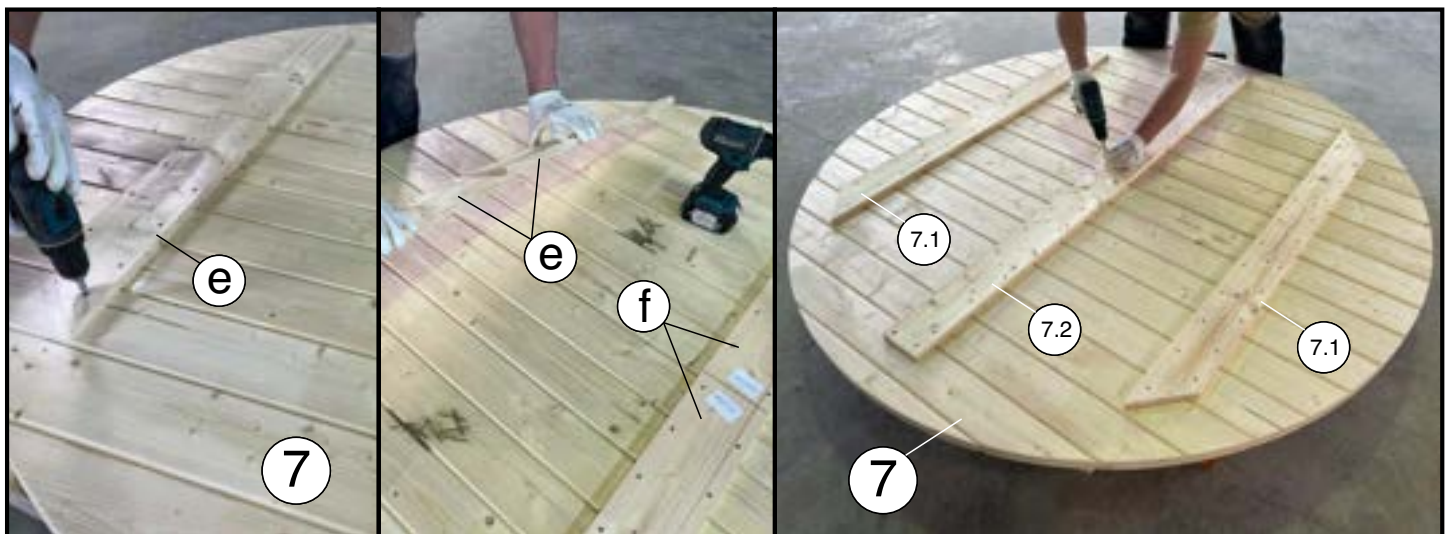


4. ASSEMBLY OF THE REAR PANEL

4.1 Find a level place for rear panel assembling.
Put parts "a", "b", "c" and "d" together. Parts "b" and "c" fix together without screws, parts "a" and "d" fix with screws A6. Use Tx20.



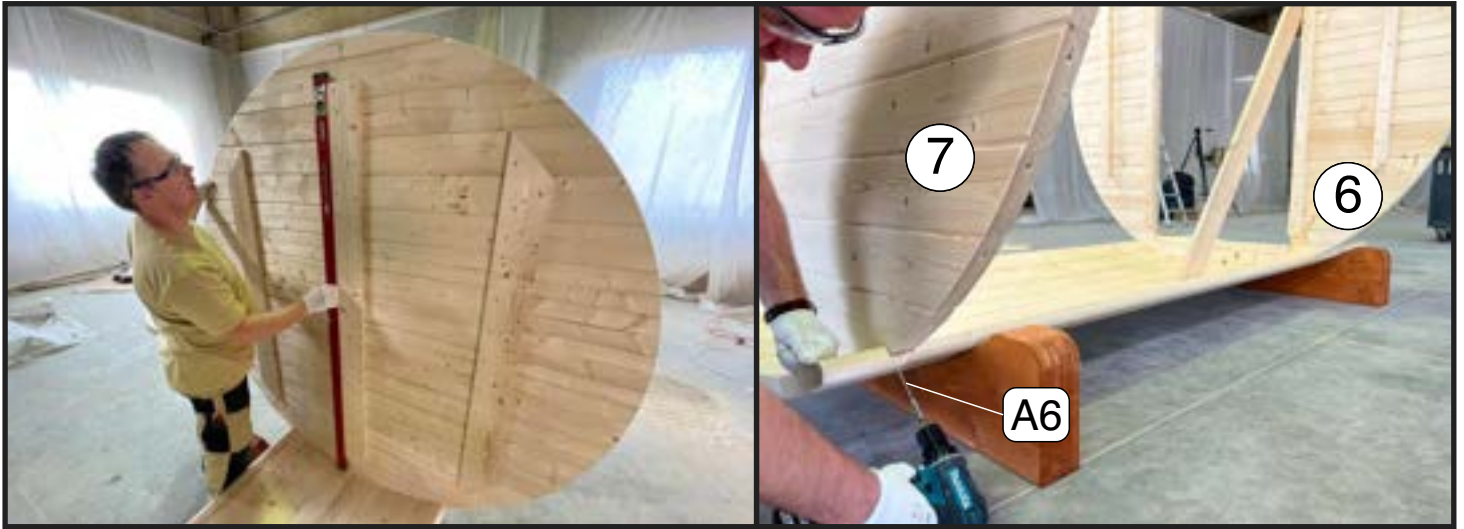
- After assembling, first of all unscrew the boards "e" and "f".
- Put boards (7.1) and (7.2) on rear panel and fix it with screws A6. Use the same screws.



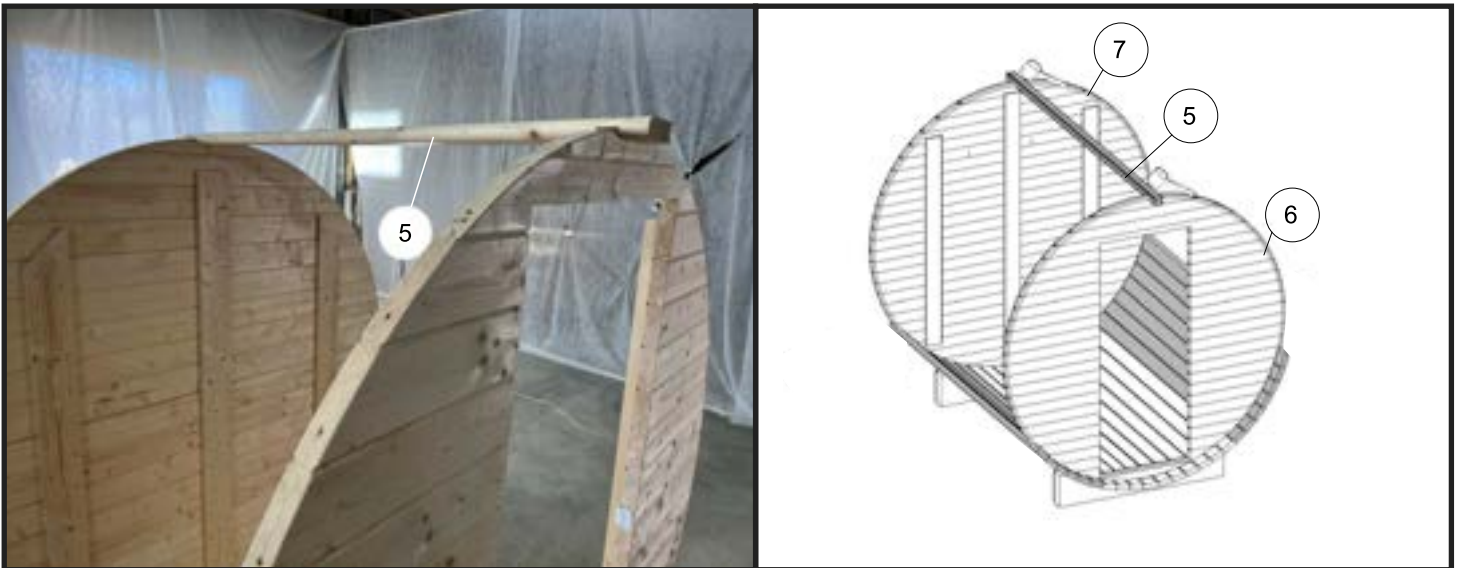
5. REAR PANEL INSTALLATION

5.1. Put the rear panel to the groove of the bottom boards. Use the level to make sure that rear panel stands strictly horizontal.

Fix the rear panel with screws A6 (use TX20)

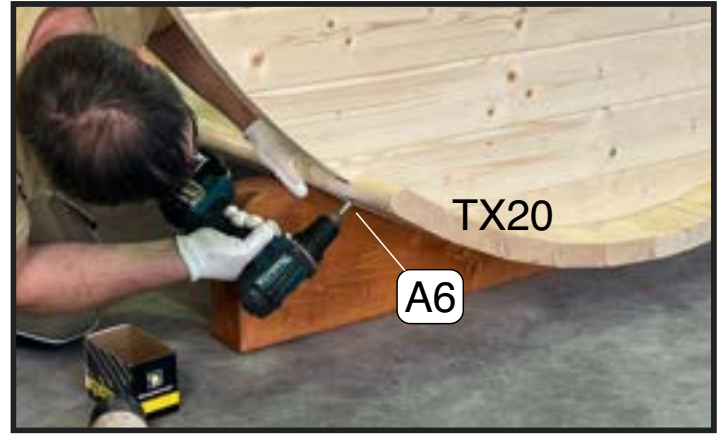


5.2. **Attention.** After installing the rear panel, put the board no. 5 on top of the front and rear panels.



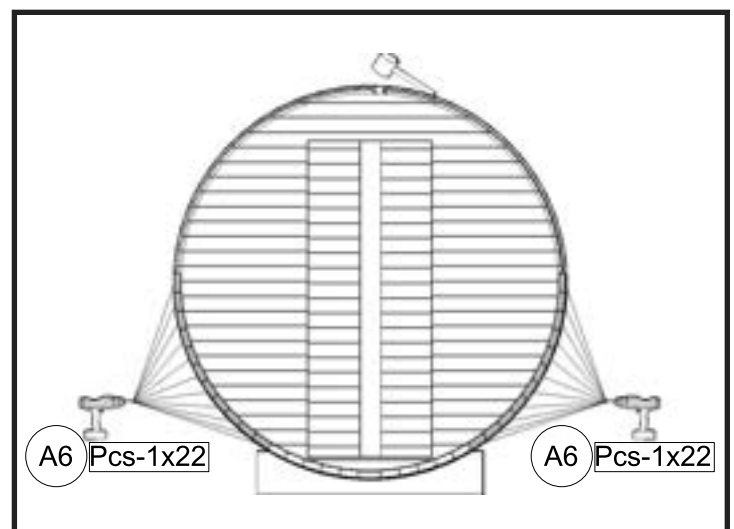
6. SIDE BOARDS ASSEMBLING

6.1. Put the side boards one by one. Use a rubber hammer, to tight the boards to each other. And fix to the front and rear panels with screw A6 at the same time in both front and rear panels.



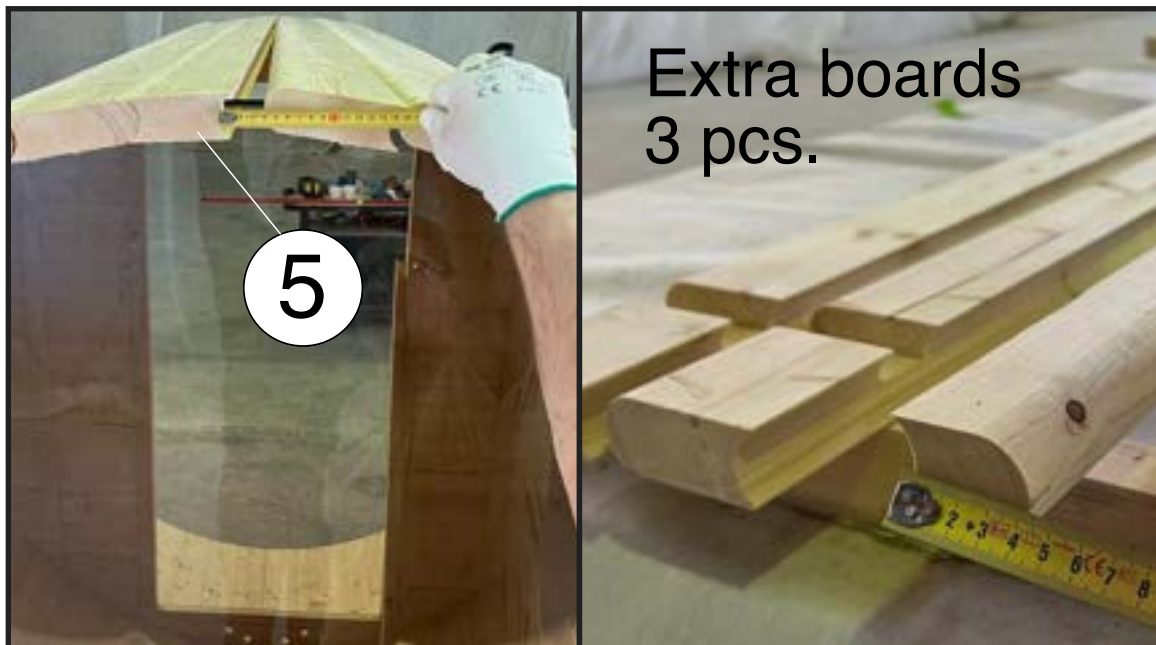
- Put side boards one by one. Use a rubber hammer to tight the boards to each other and fix each of the board with screws A6 (both sides) until You will reach the line as shown in the picture.
- Put the rest side boards (from both sides one by one) until will be reached board 5.

IMPORTANT. Do not fix with the screws

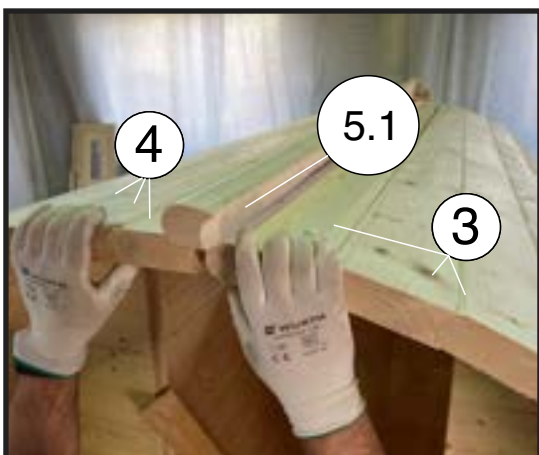


6. SIDE BOARDS ASSEMBLING

6.2 Measure the gap on top. The package includes three extra additional boards of different widths (5.1), which are designed to fill the necessary gap. Use the board wider than gap (closest to the gap).



6.3 Lift one board and insert the one of the extra boards (5.1) with the correct width.



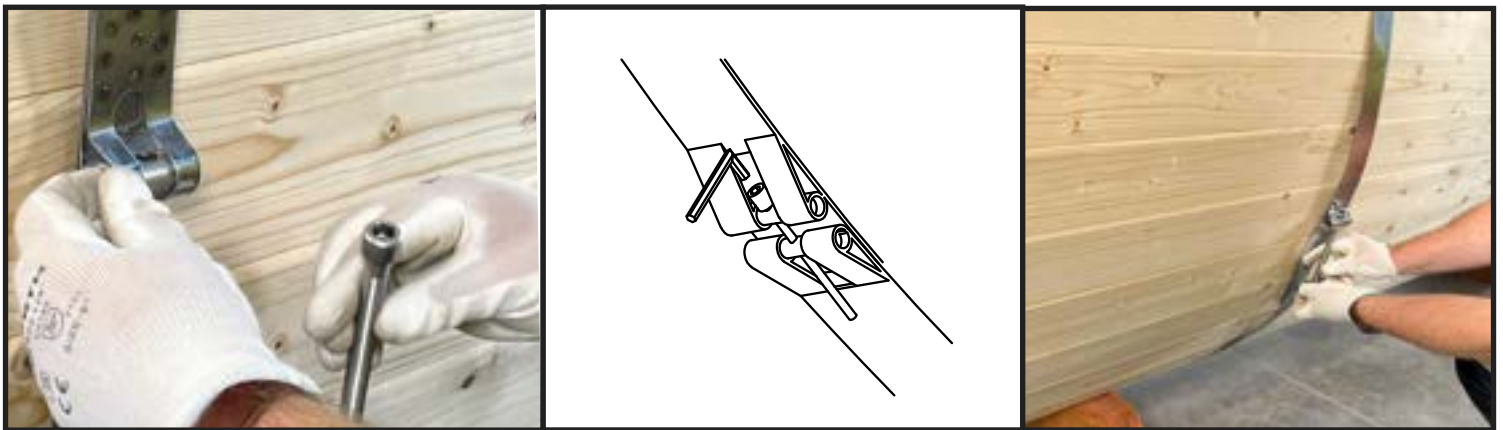
7. TIGHTENING BANDS

7.1 Prepare tightening bands and bolts

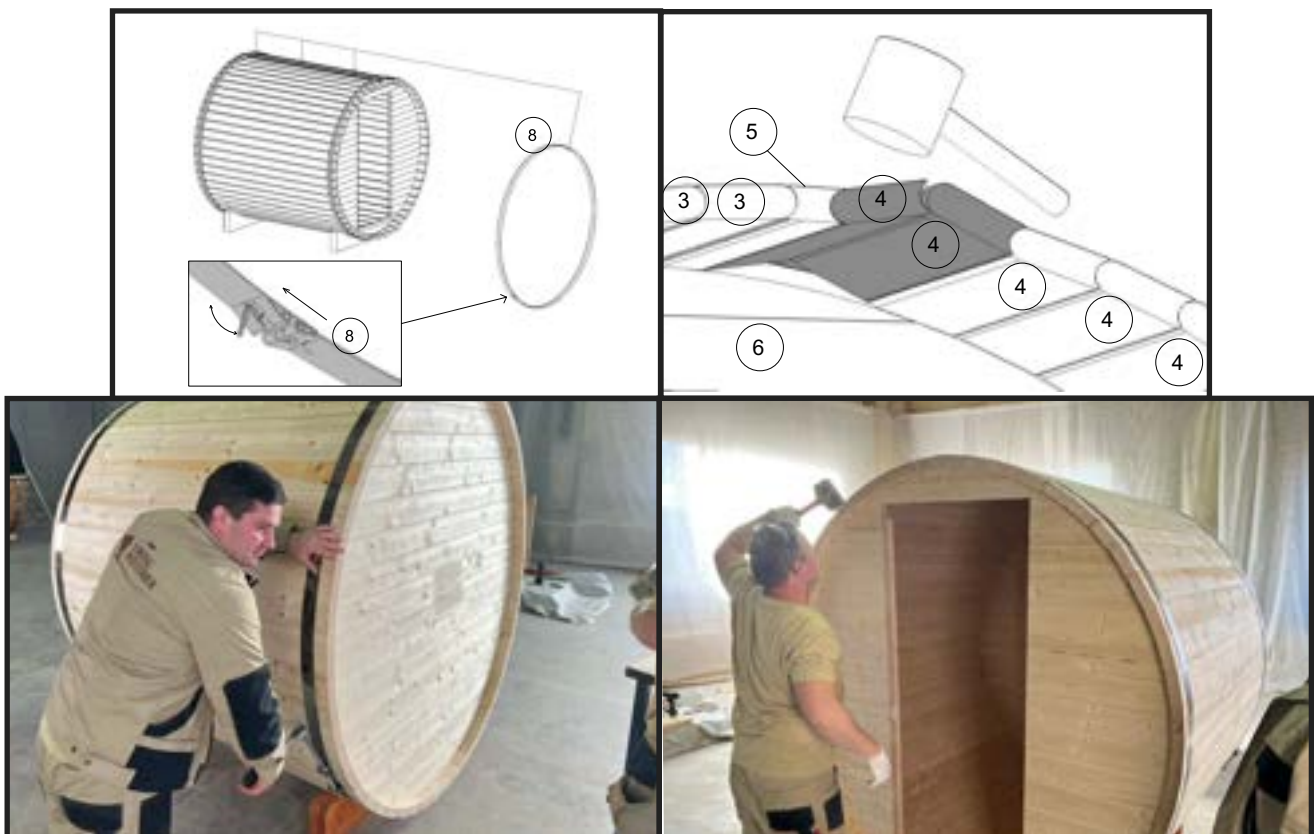
7.2 Put tightening bands 50 mm from both edges.



7.3 Tighten the bands with the help of a hex key.



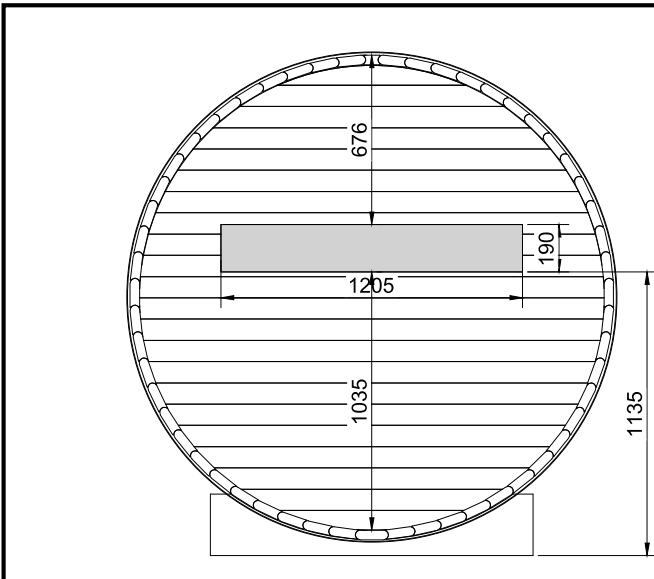
7.4 Use the rubber hammer for top boards, at the same time tighten the bands with hex key.



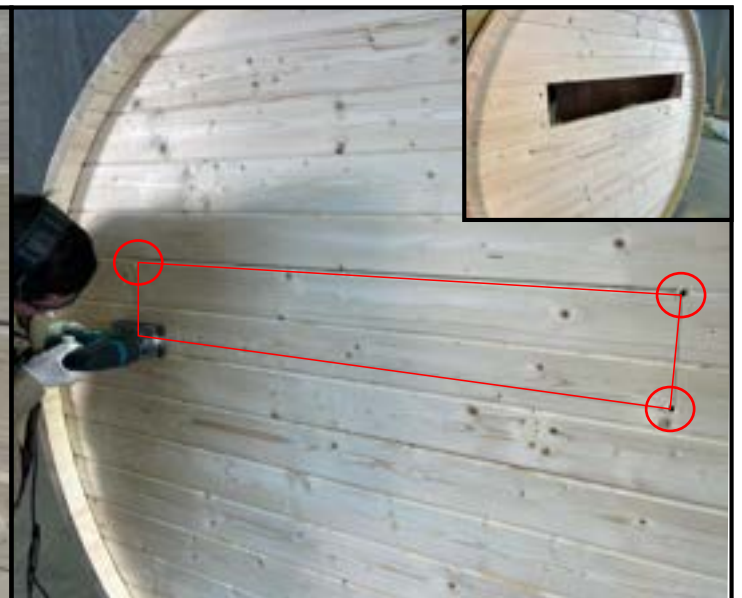
8. WINDOW INSTALLATION

8.1. Glass installation into rear panel.

- Find a vertical center on rear panel;
- Put the glass on the rear panel and mark all around the glass with the pencil. This will be cutting lines.



- Drill 4 holes in each corner (8mm drill);
- Cut a right hole with hacksaw according the marked lines;

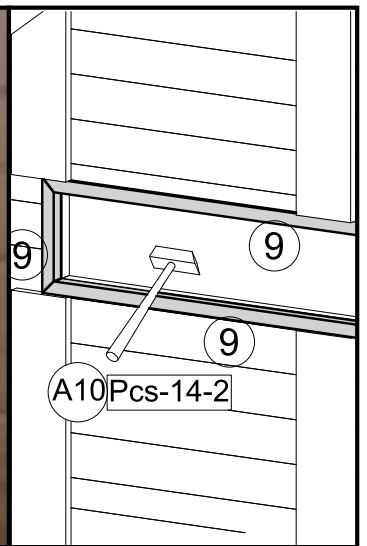
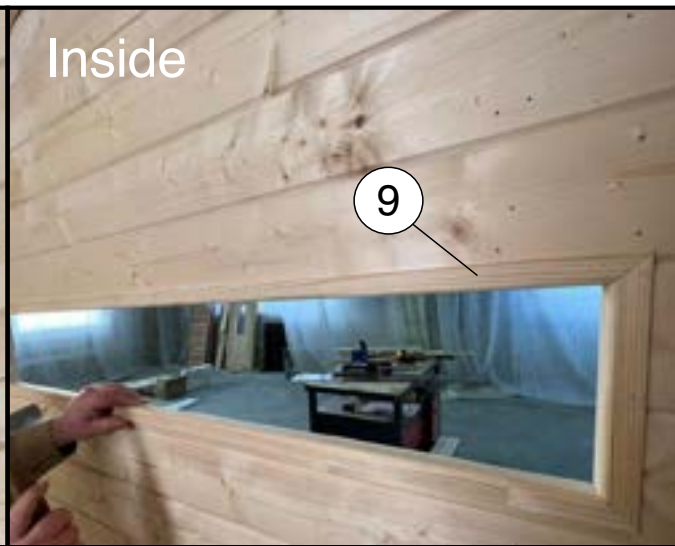


8. WINDOW INSTALLATION

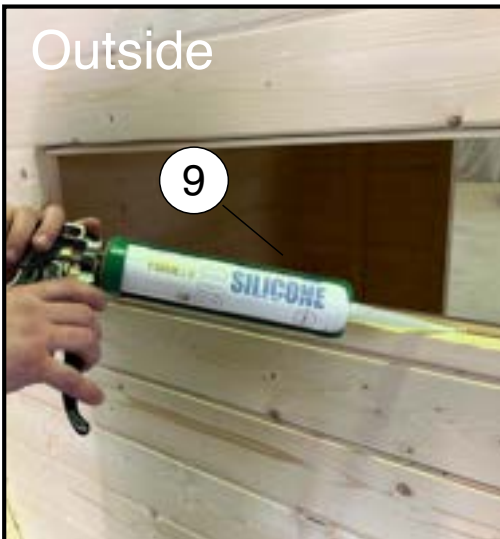
- Unscrew the boards inside the sauna;(7.1 and 7.2);



- From the inside of the sauna put the parts (9) in the cutted hole and fix it with the nails.

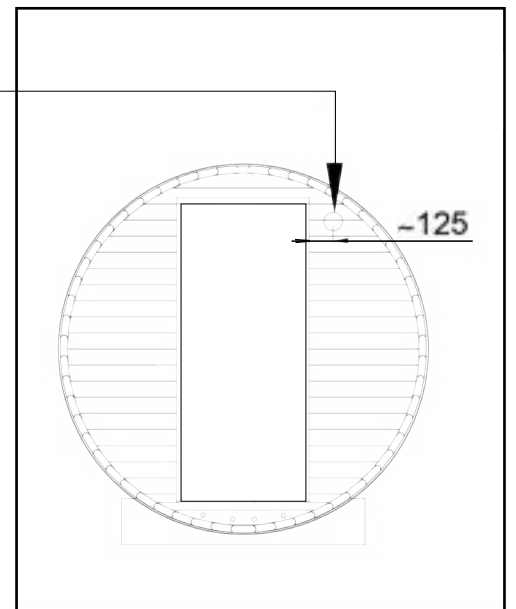
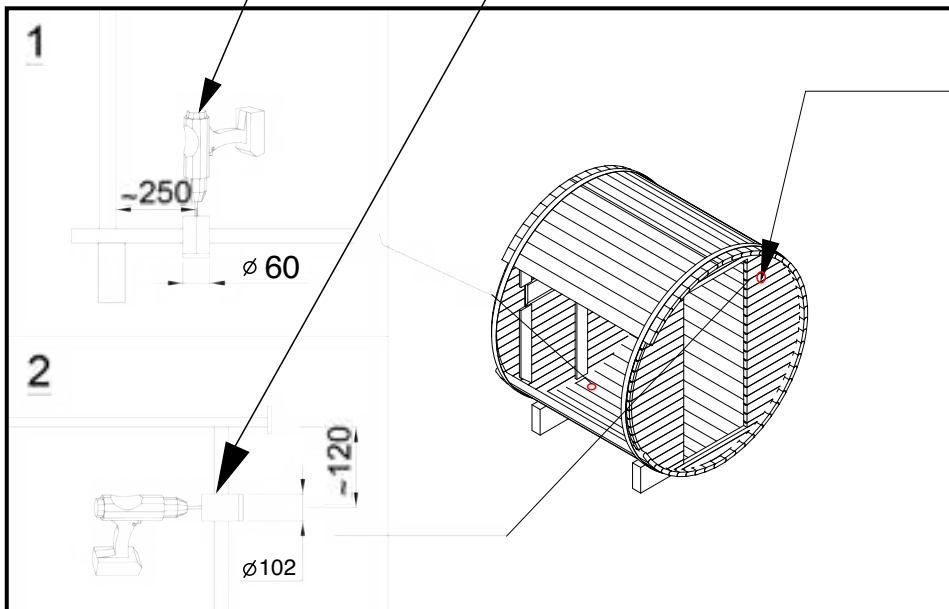
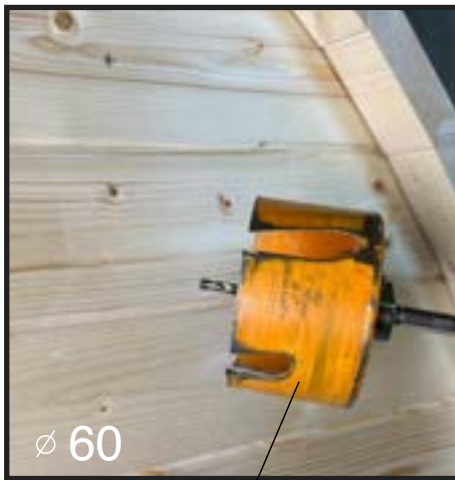
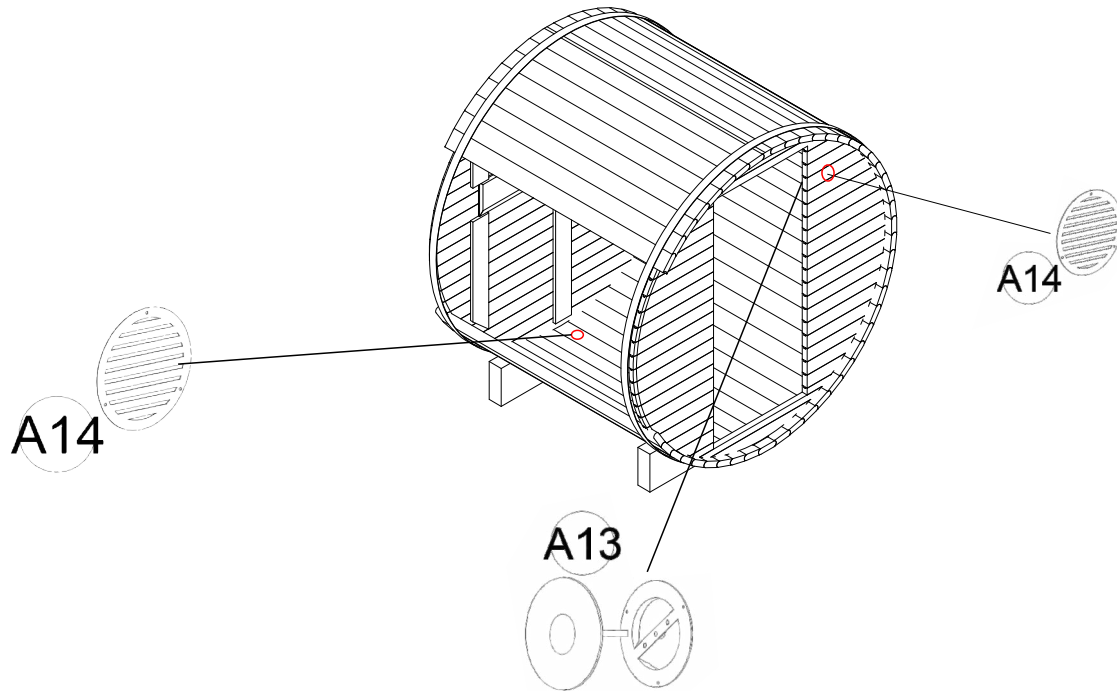


- From the outside the sauna apply the silicone on the edge of the parts no. 9 around the entire perimeter.
- Put the glass in the hole from outside;
- Put the parts (9) and fix them with nails from outside.



9. VENTILATION AND DRAINAGE

9.1. Two ventilation holes should be made in the sauna. One in front panel and one in the floor. The ventilation openings are covered with protective grills.

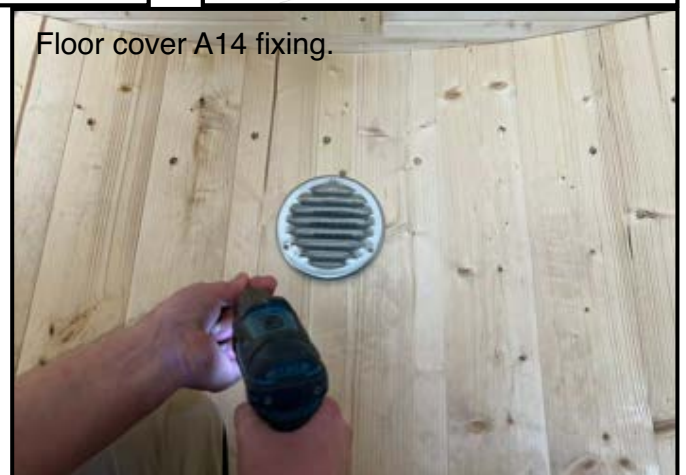
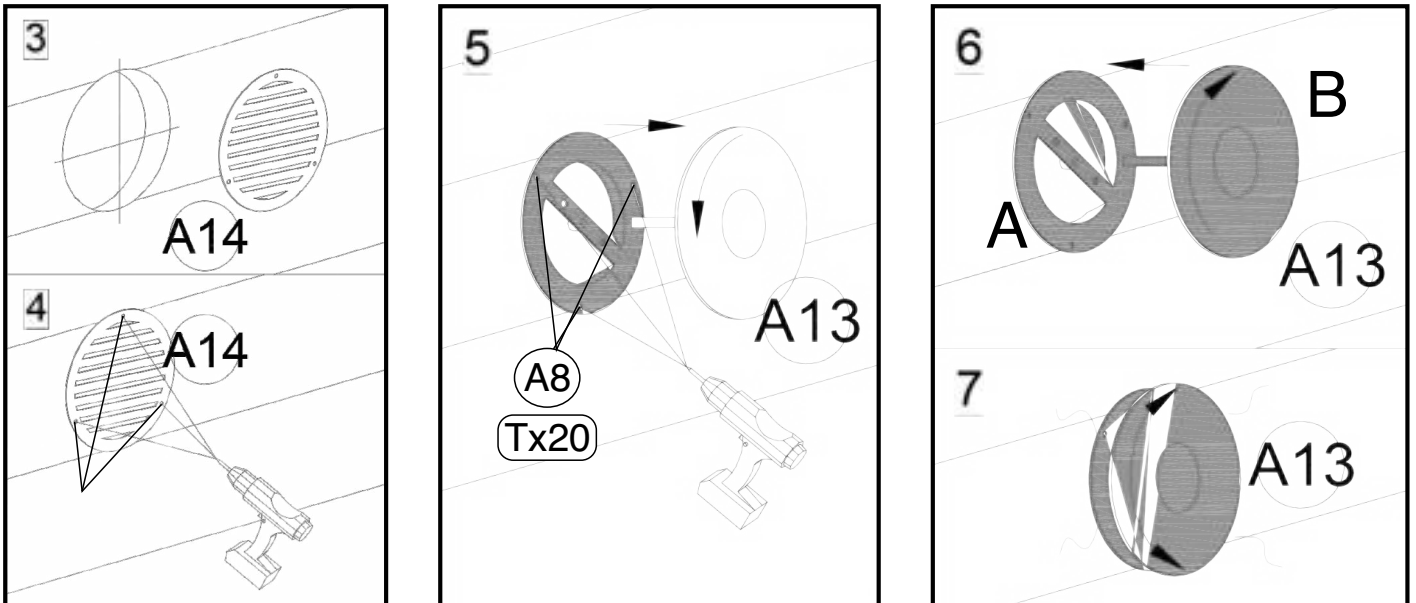


9. VENTILATION AND DRAINAGE

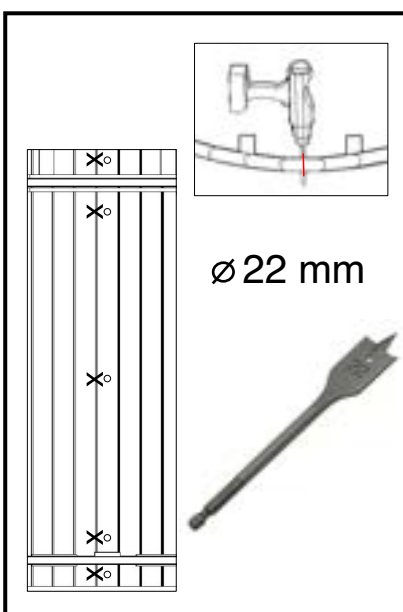
9.2. The ventilation cover A14 installation.

9.2.1 Put the cover A14 on both holes (in front panel - outside the panel, in floor - inside of the sauna).

9.2.2 The cover A13 consist from 2 parts (A and B). Divide A13 to A and B. Put A13 - A on hole from inside of front panel and fix with screw A8. Connect A13 - B with A13 - A from inside of sauna.

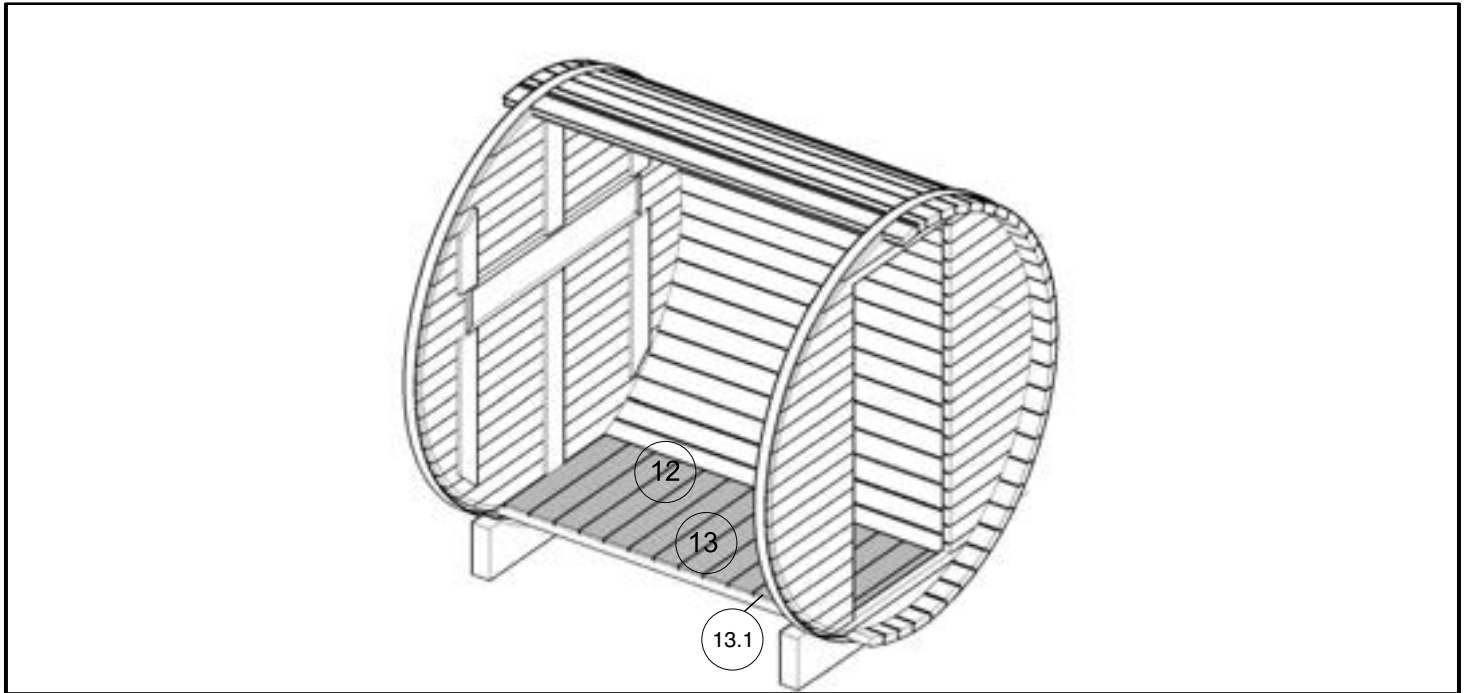


9.3. Five drainage holes should be drilled in the bottom of the sauna. Use wood drill $\varnothing 22$ mm

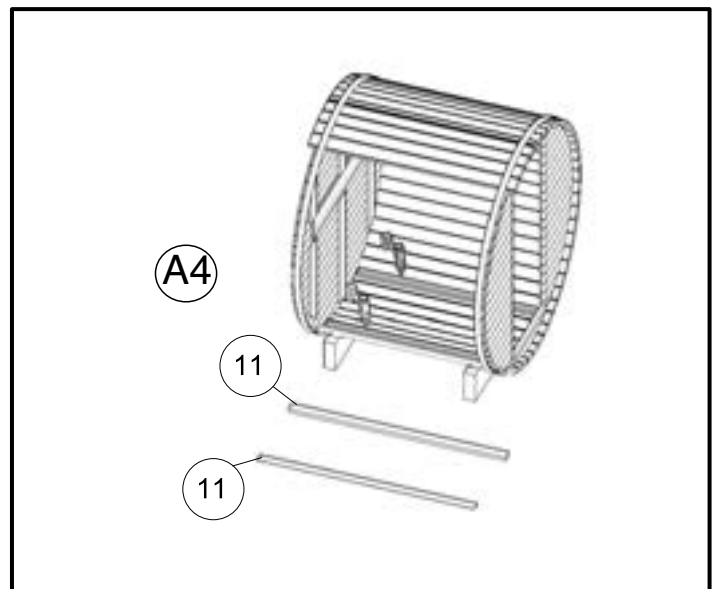
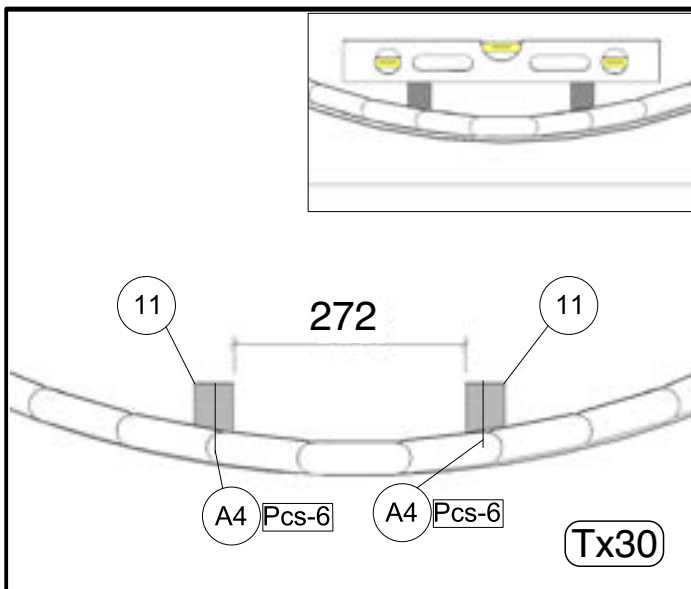


10. SAUNA FLOOR INSTALLATION

10.1 Sauna floor panels installation process.

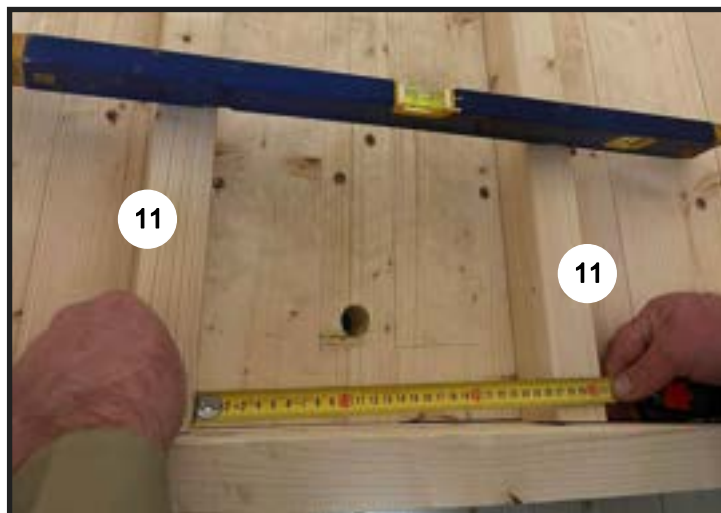


10.2. Two long boards (11) mounted inside the sauna. Use A4 screws.

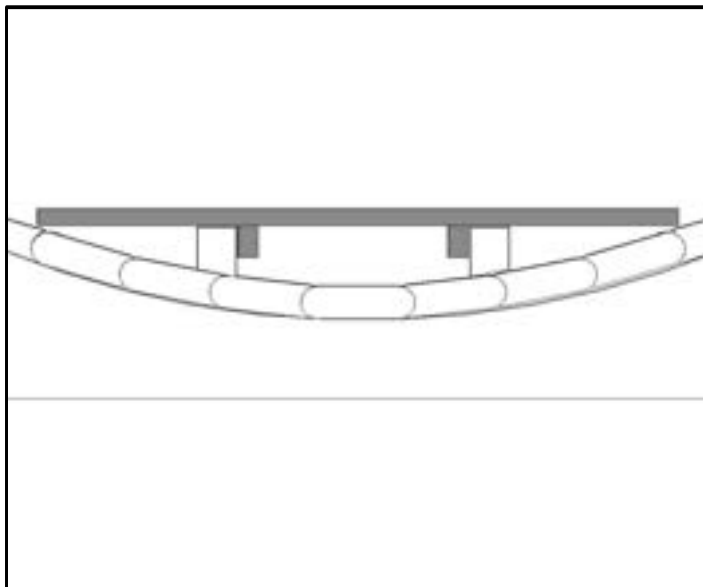


10. SAUNA FLOOR PANELS

Fix the boards no. 11 with screws A4.

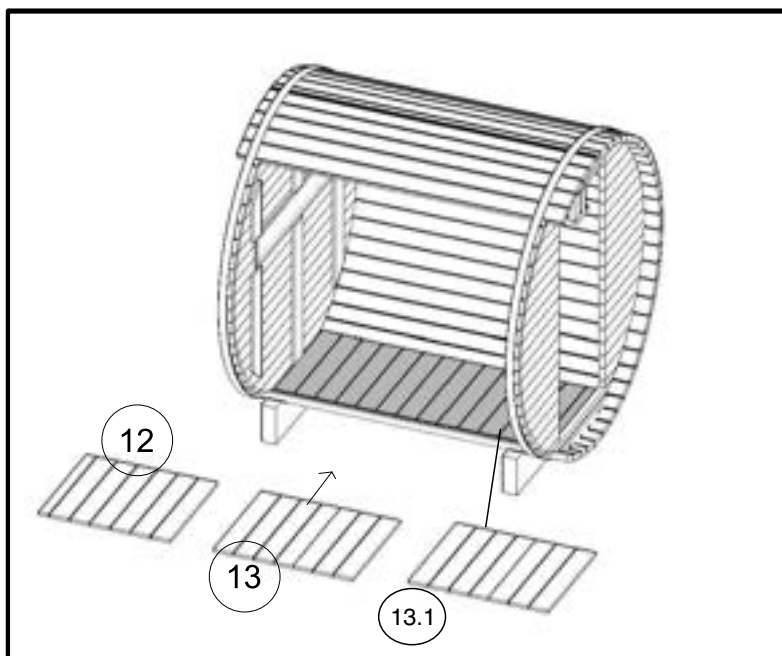


10.3 Floor panel installation.

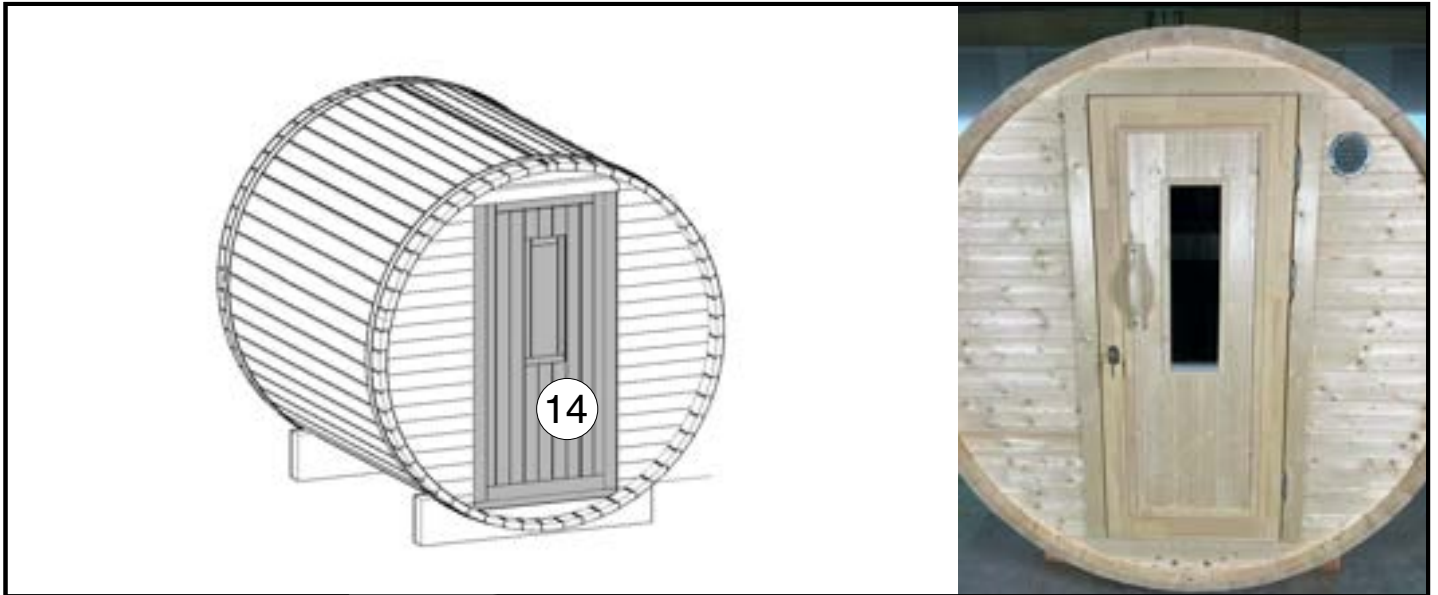


NOTE.
Check the number on the floor panels and put panels according to the numbering.

Advice.
To keep panels clean in time of the installation, do not remove the plastic film. Take of the film after completing all work.



11. SAUNA DOOR INSTALLATION



- 11.1. Remove door from door frame.
- Put the door lock cylinder in the hole and unlock door at first .
 - Open the door, lift up and remove the door from frame (from hinges).



11. SAUNA DOOR INSTALLATION

11.2 First install the door frame. Put the door frame at the edge of the front panel (hinges on the right side, looking from the outside). Check the alignment of the frame with the level both vertically and horizontally.

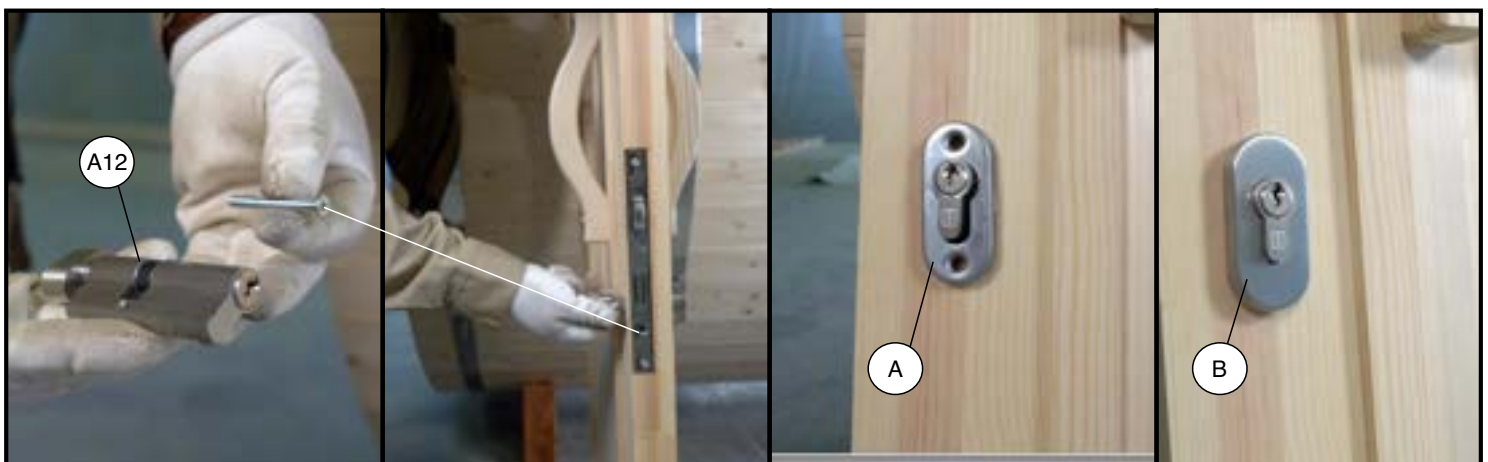


11.3 Fix the door frame with screws A3 (6 pcs).



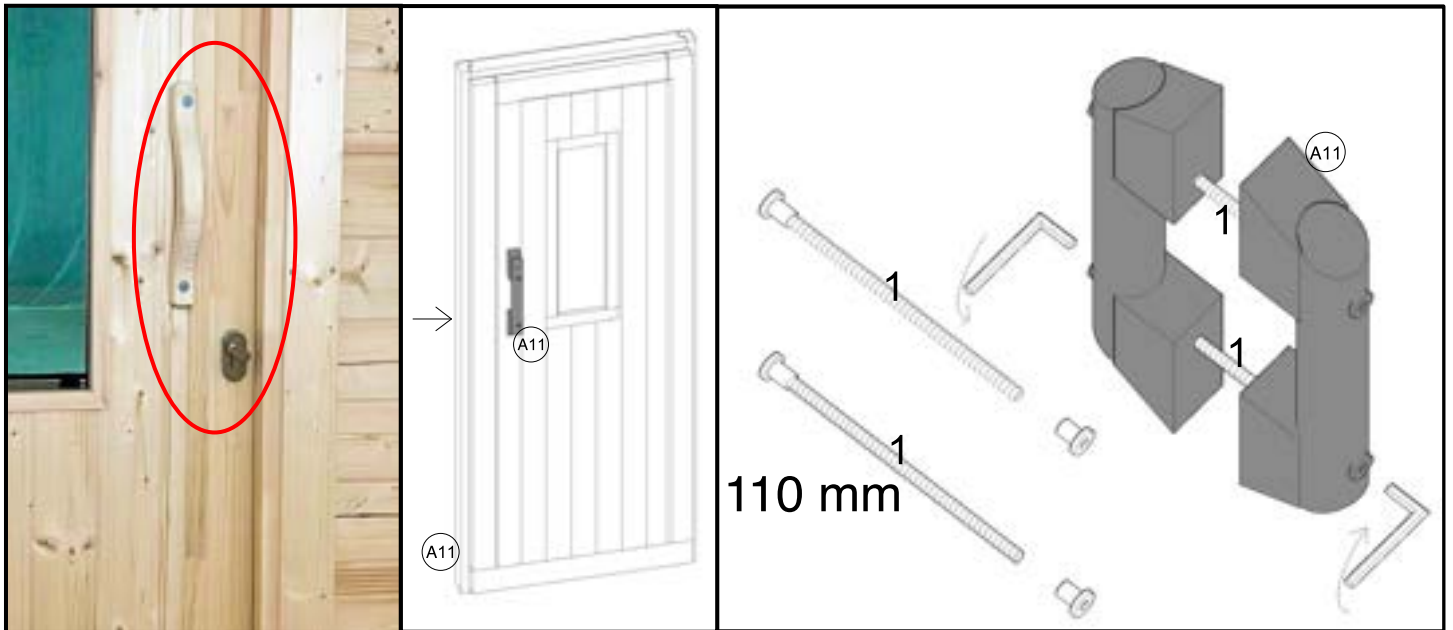
11.4 Install the cylinder and covers.

- Put the cylinder (A12) in the place (key should be from outside).
- Fix the cylinder with bolt.
- Cylinder cover consist of two parts (A and B). Fix the part A from both sides with 2 screws each. Then put parts B on top from both sides.

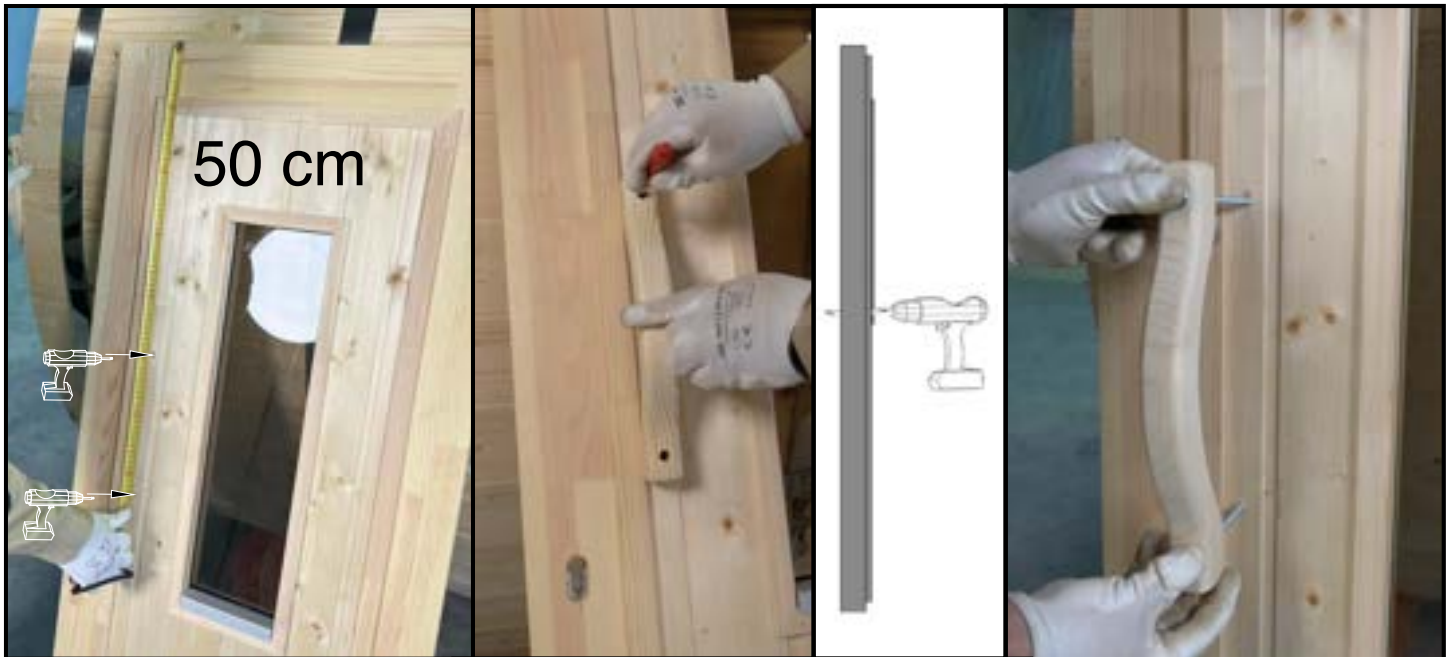


11. SAUNA DOOR INSTALLATION

11.5 Installation of the door handle. Measure up 50 cm from the top edge of the door and this will be the position of the top screw mounting hole for the door handle.



- Use the handle for measuring the position of the bottom mounting hole.
- Drill top and bottom holes. Use 8mm drill.
- Put handles from both sides of the door and fix with bolts A11.1.



11. SAUNA DOOR INSTALLATION

11.6 Insert the door in the door frame and check if it opening smoothly.
If needed, adjust the door position with adjustable hinges.

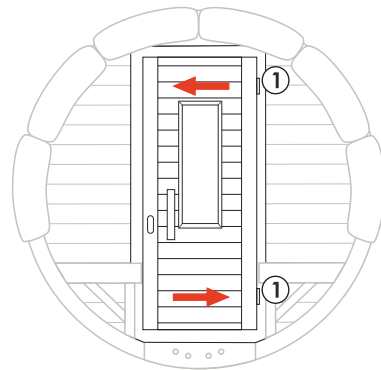
DOOR ADJUSTMENT

- 1 st bolt adjust the direction of the door.
- 2 nd bolt adjust the height of the door.
- 3 rd bolt adjust the distance between door and frame.

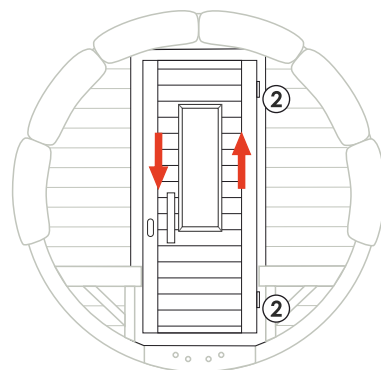


ADJUSTING THE HINGES

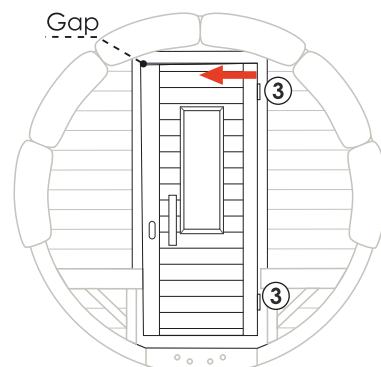
If the door is turned, then adjust hinge bolt 1.



If the door is lowered or raised, adjust hinge bolt 2.



If the door does not close tightly, you need to adjust the hinge bolt 3.



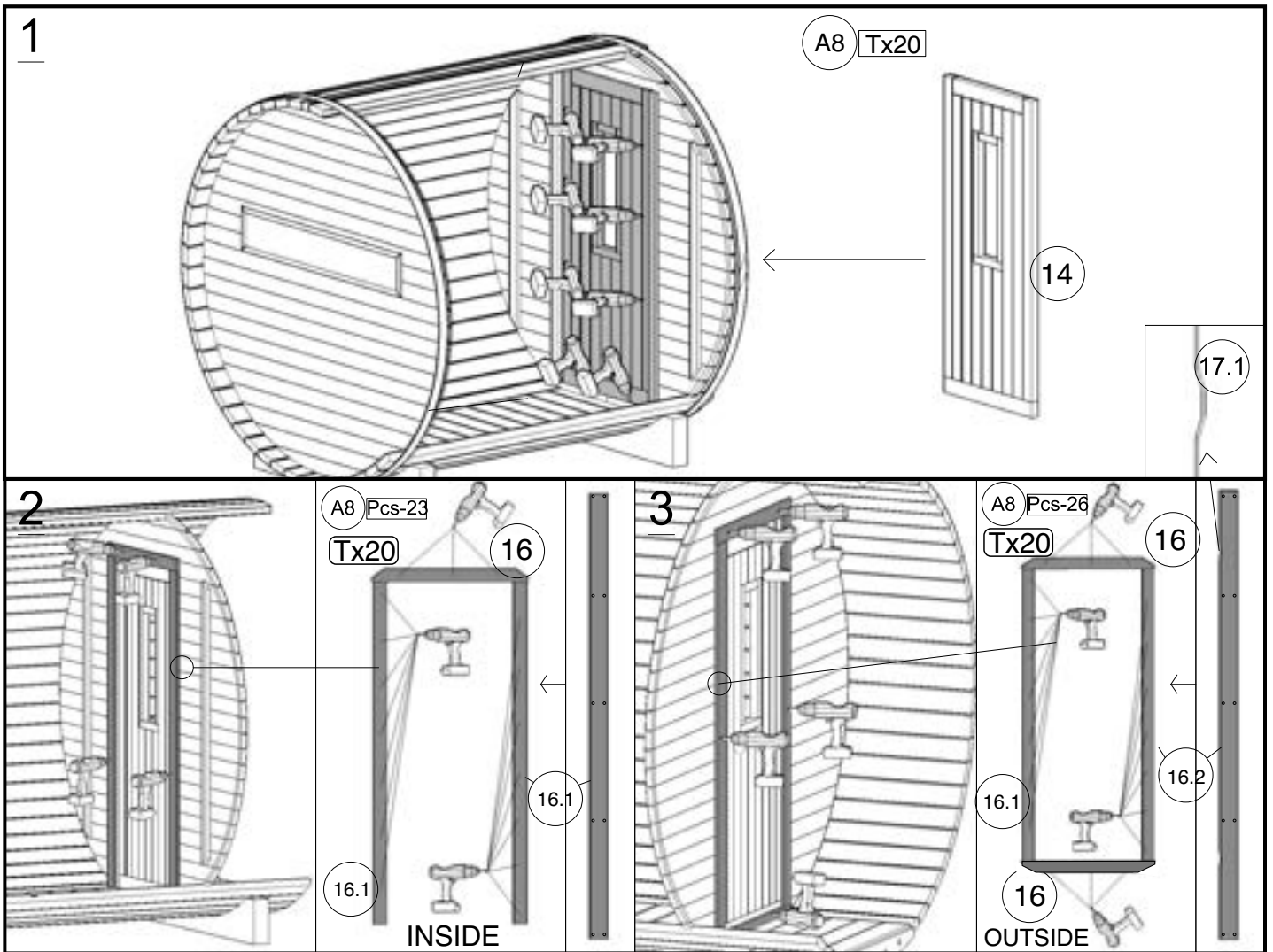
11. SAUNA DOOR TRIMS INSTALLATION

11.7. Put the top trim 17 and fix with one screw A8 in the middle.

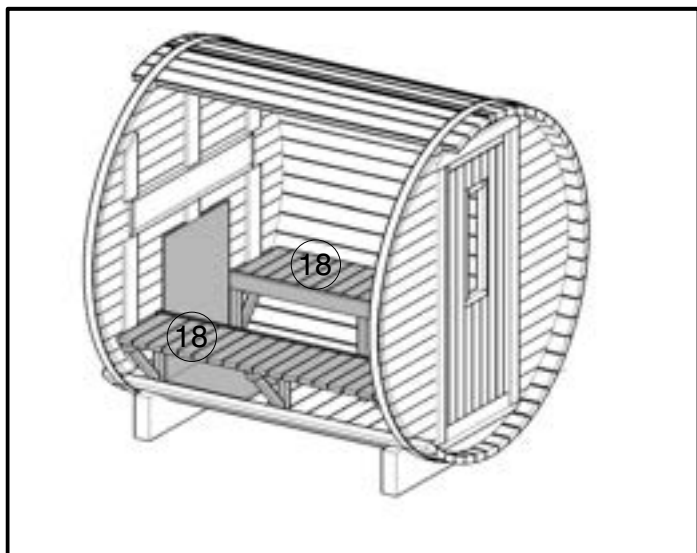
Fix the side trims 17.1 with one screw A8 on top of each trim.

If the top trim is not in the center, unscrew and center it.

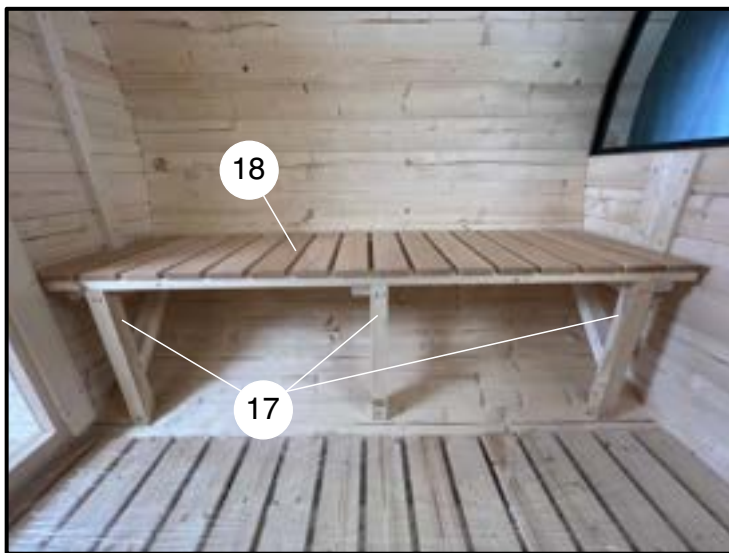
Repeat the process in other side of the door. Fix the rest screws as shown in the picture.



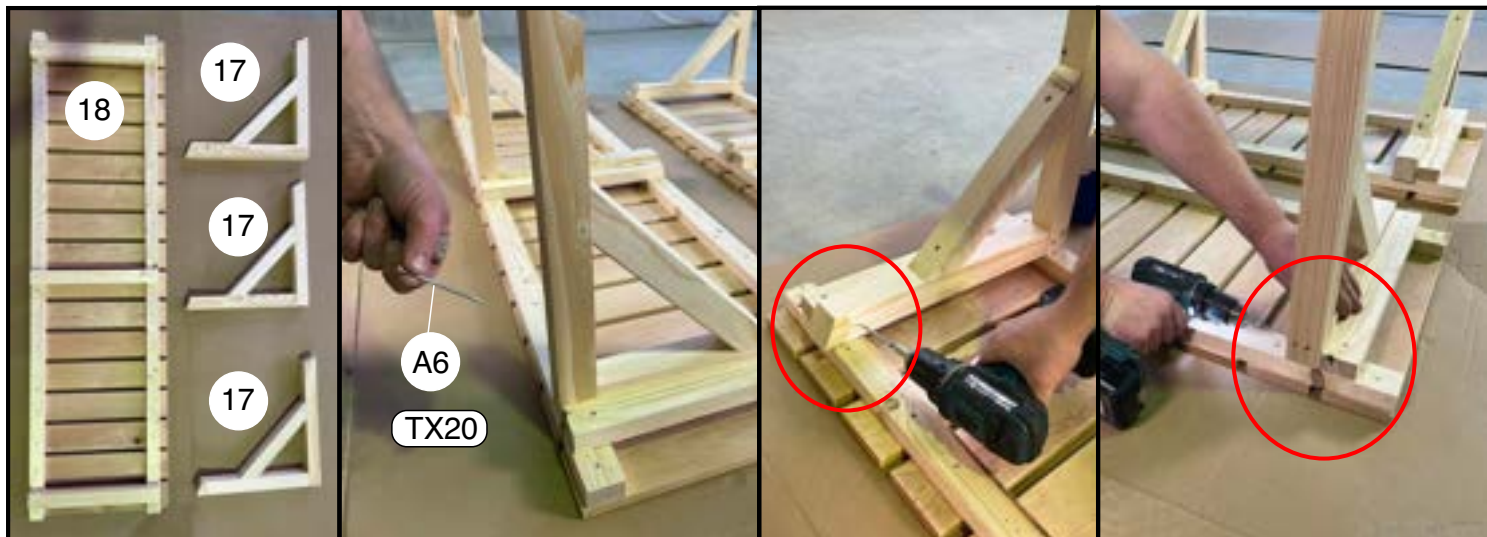
12. SAUNA BENCHES INSTALLATION



12.1. Assemble the benches of the sauna.
Fix parts no. 17 to part no. 18.



12.2. NOTE. Part 17 has different length of sides.
Longer side should be used for connection with part 18.



12. SAUNA BENCHES INSTALLTION

12.3. Put the assembled benches to the sauna.
Check with the level.
Fix benches to the sauna floor and side wall. Use screws no. A6.



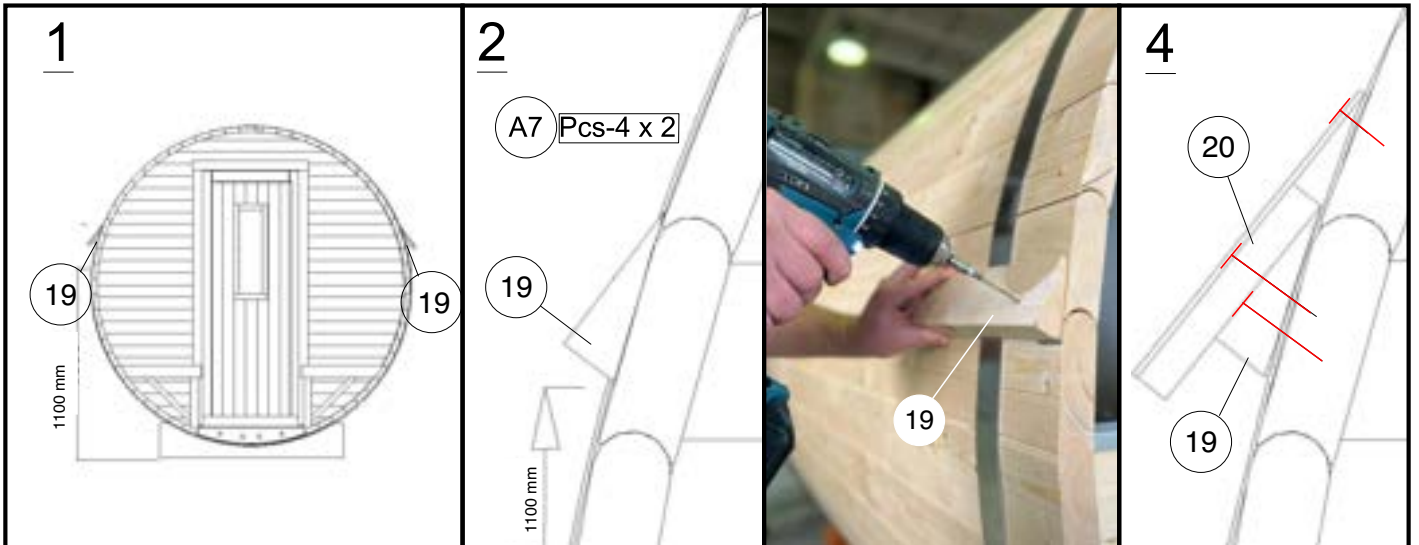
12.4. After fixing the benches, install additional bench boards - no. 19.1. Use screws A7.



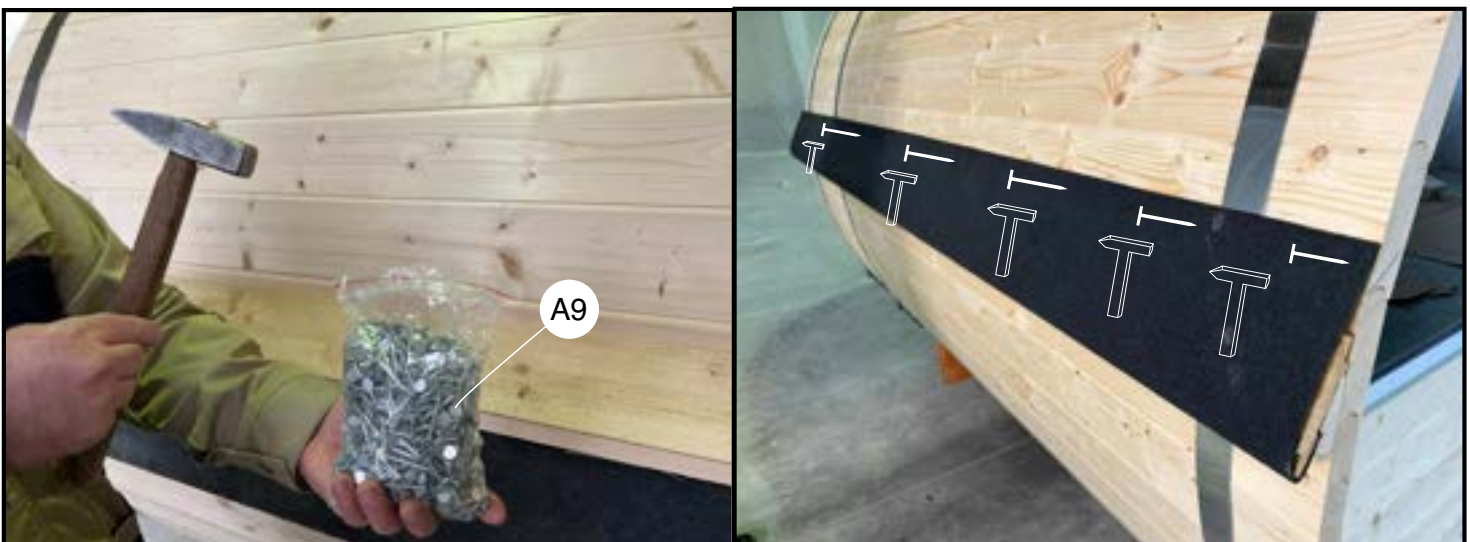
13. SAUNA ROOF COVER INSTALLATION

13.1 Preparing for the covering

- Put the part 19 - 1100 mm from the ground (in both edges) and fix with screws A7.
- Put the part 20 on the top of the part 19 and fix with screws A7.

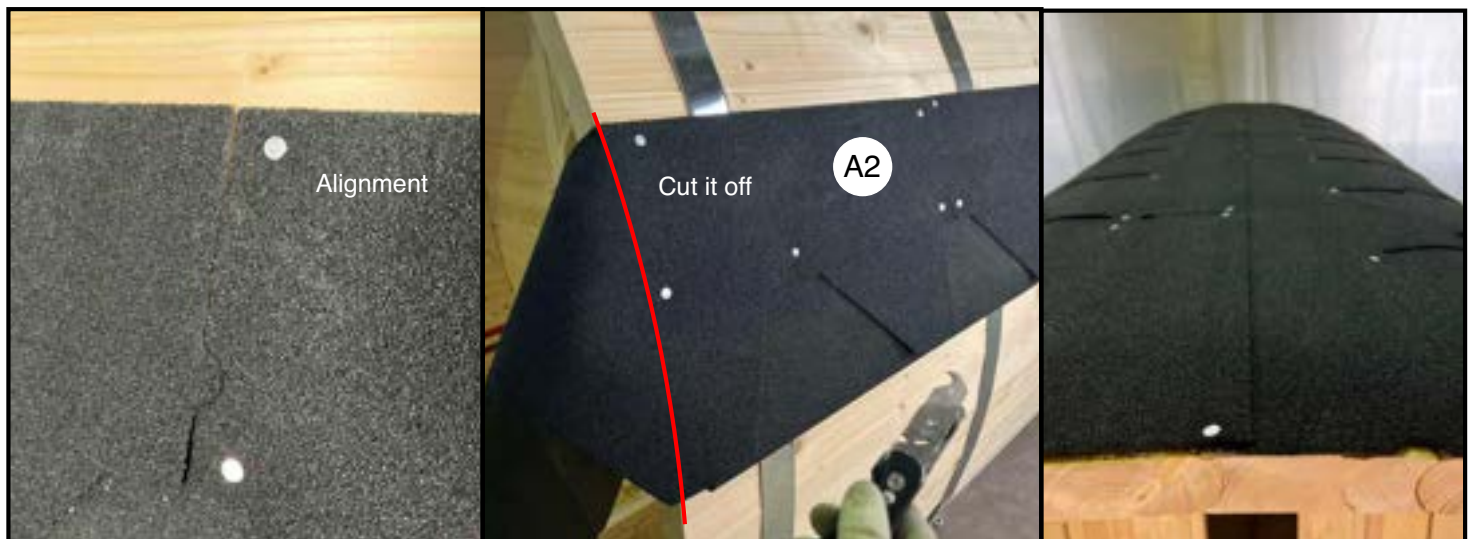
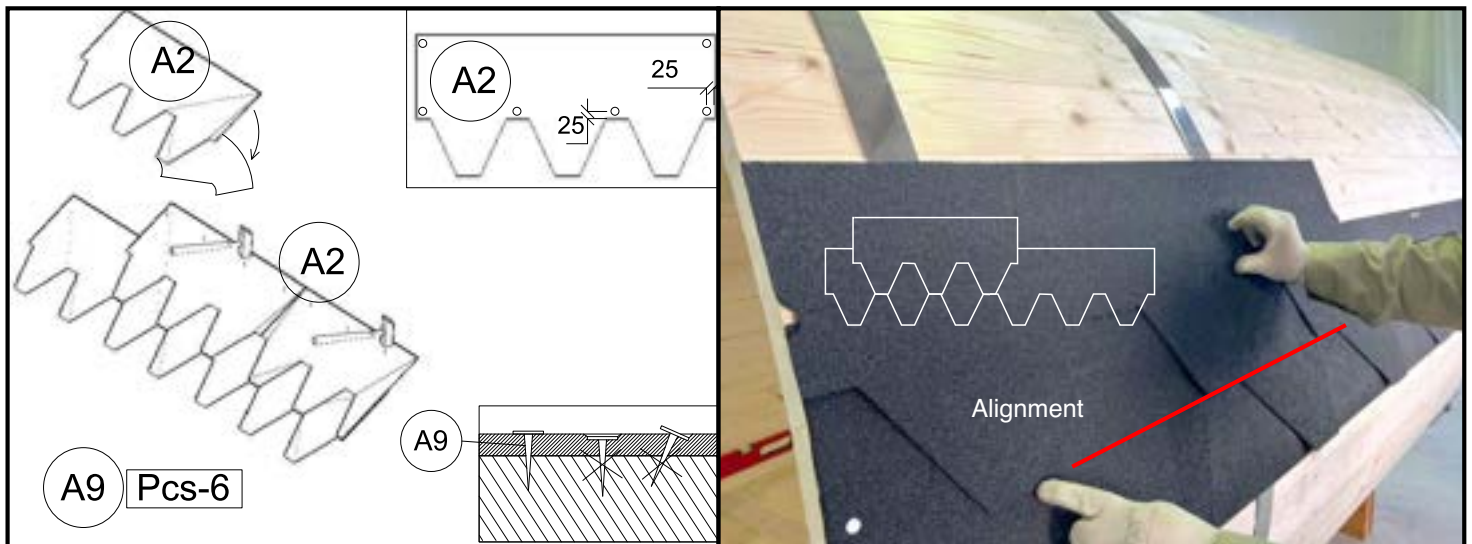


- Fold up the bitumen tape and fix it with nails A9.



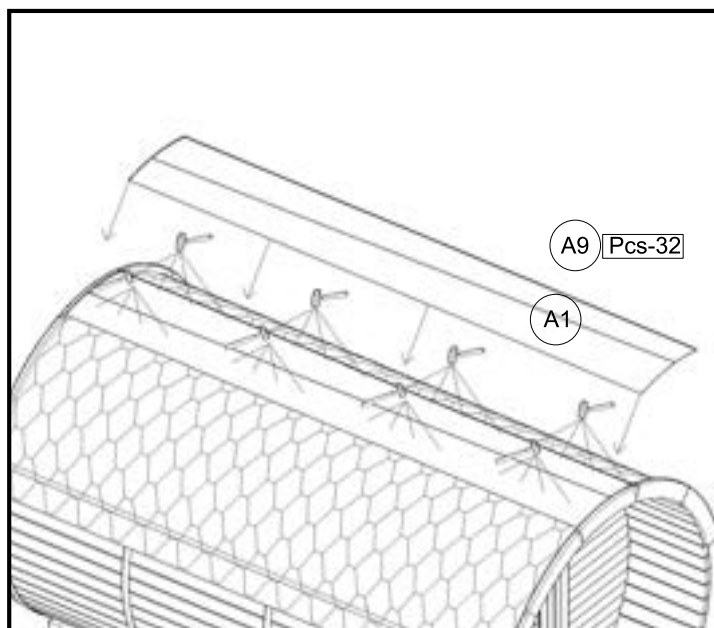
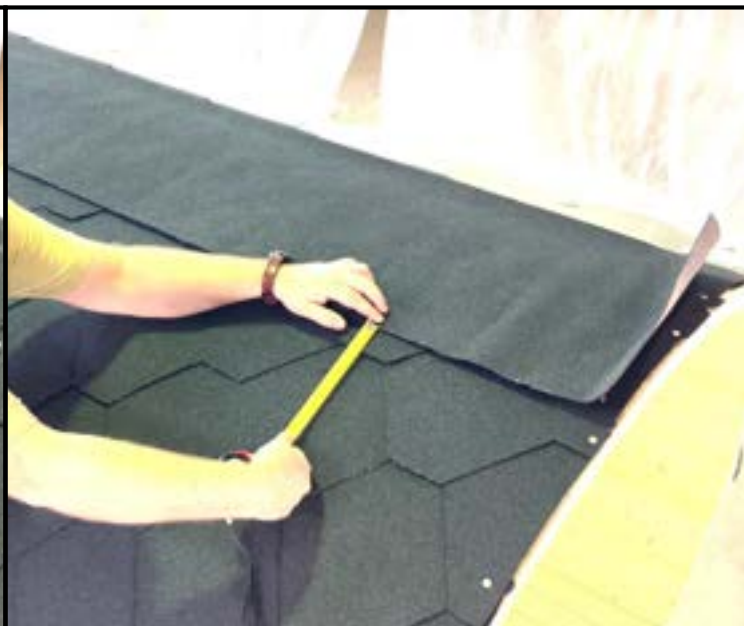
13. SAUNA ROOF COVER INSTALLATION

- 10 rows of shingles should be installed from the both sides (20 in total).
- Each second row should be overlapped (to each other) to form “honeycomb” shape. To get the result it would be needed to cut at some parts of the shingles.
- For each shingle (A2) the film from the back side should be removed before installation.
- Each shingle A2 should be fixed with nails A9 to the right sports.



13. SAUNA ROOF COVER INSTALLATION

- Put the bitumen tape A1 on the top of the roof (in center along the sauna length) and fix with nails A9 along the entire perimeter.



13. SAUNA ROOF COVER INSTALLATION

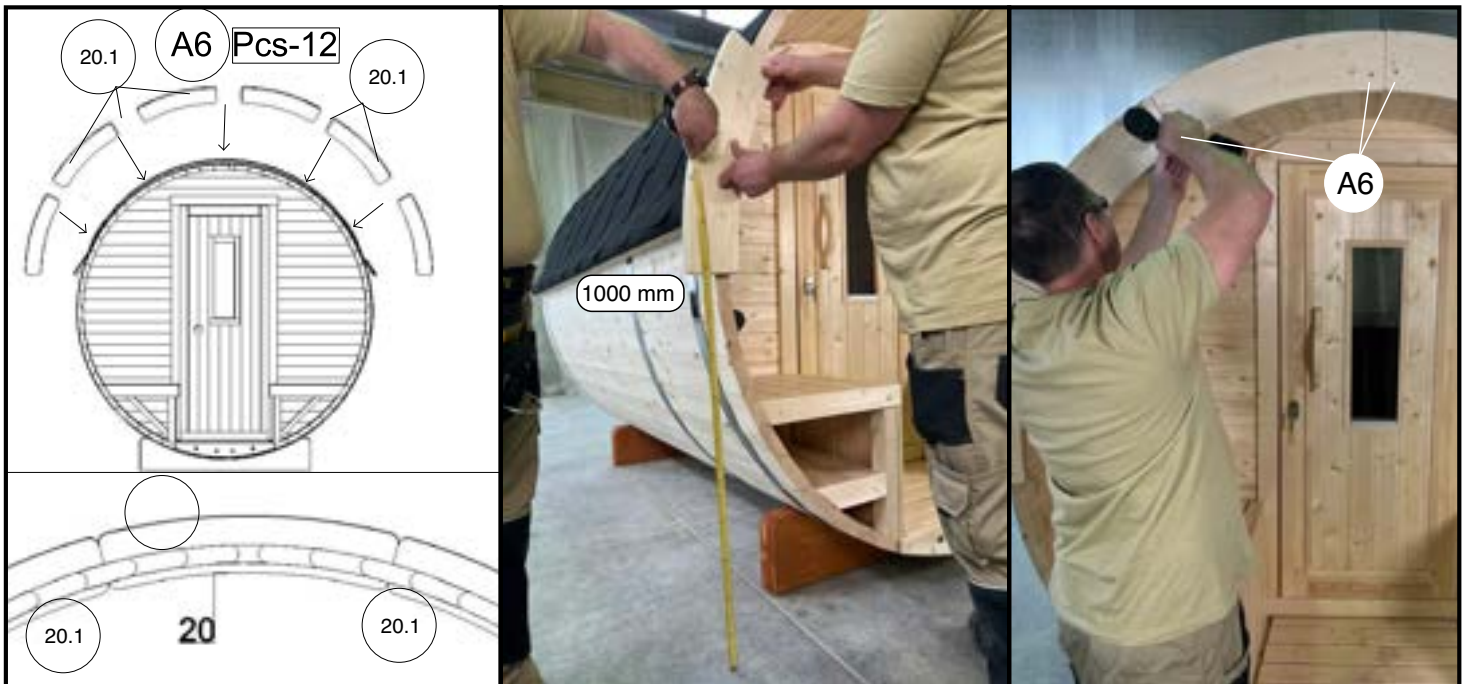
13.2 Installing roof trim details

NOTE. All roof trim details 20.1 are the same size.

- The rounded side of the detail is the front side.



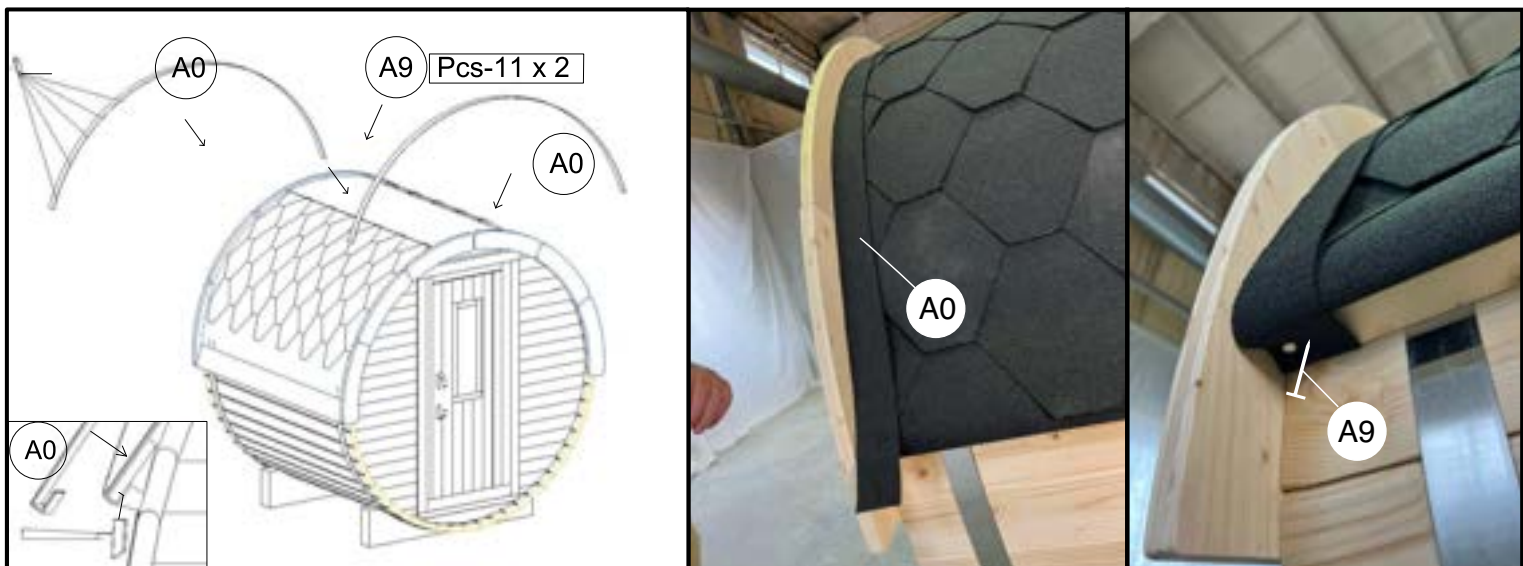
- Put the first trim (20.1) - 1000 mm from ground and fix with screws A6.
- Put and fix 5 more trims 20.1 in the same way.
- Instal rest trims 20.1 (in other side of the sauna) in the same way.



13. SAUNA ROOF COVER INSTALLATION

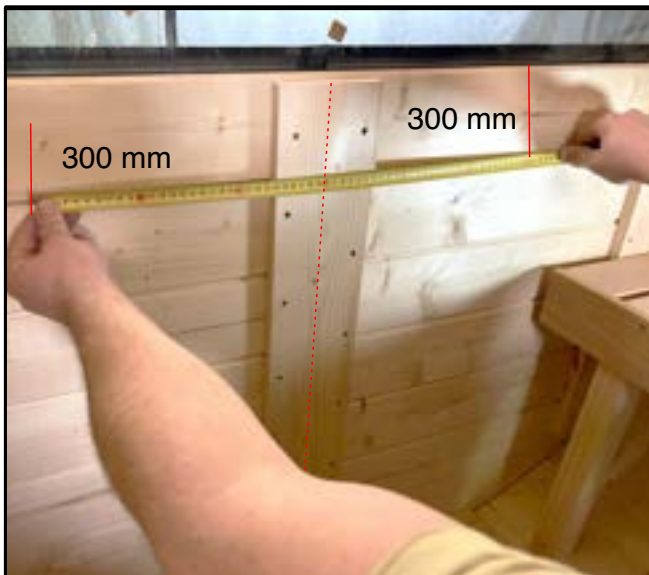
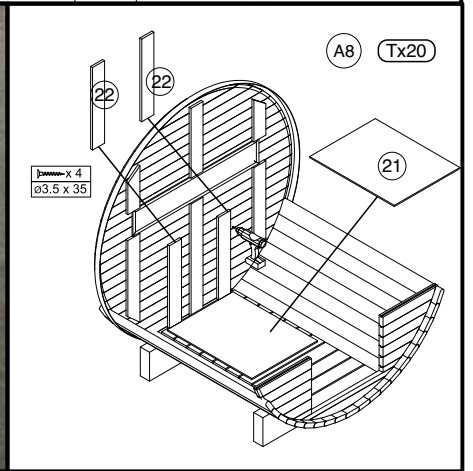
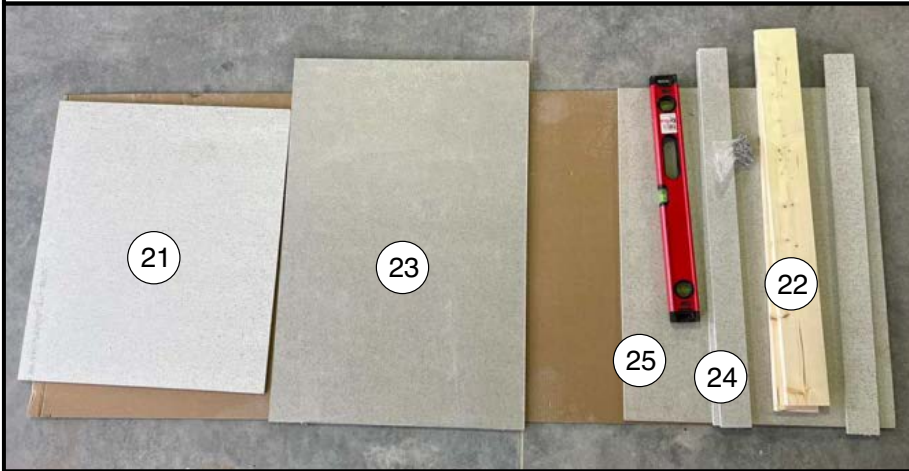
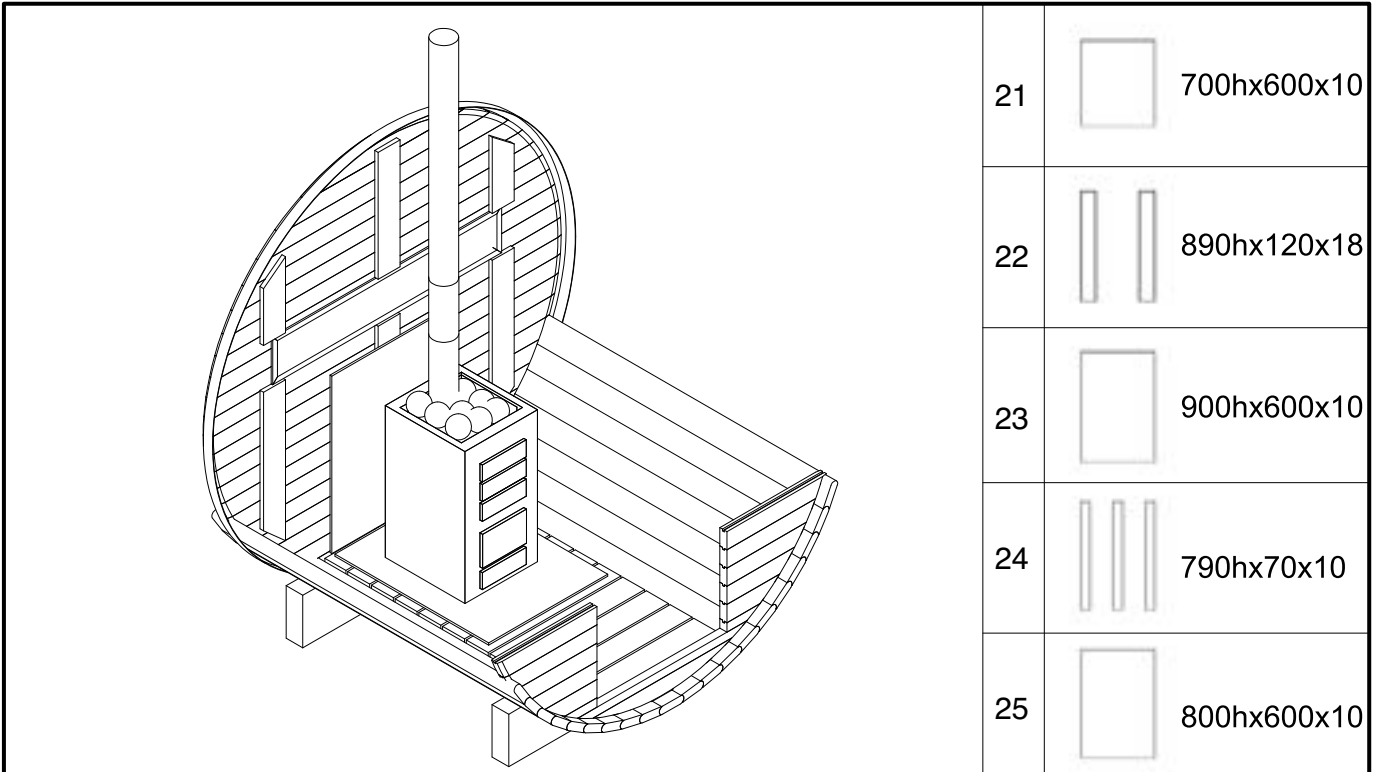
13.3 Bitumen tape installation.

- Put bitumen tape A0 at the edges of the sauna and fix with nails A9.



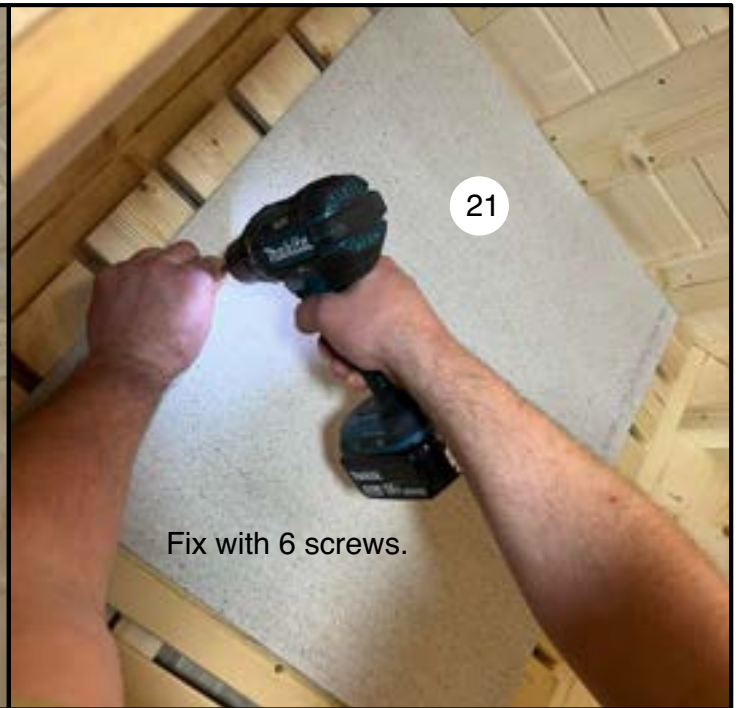
14. HEAT RESISTANT PLATES INSTALLATION

14.1 Put and fix with screws A8 two boards (22) to the sauna wall. The boards are screwed 30 cm apart from the central board.



14. HEAT RESISTANT PANEL

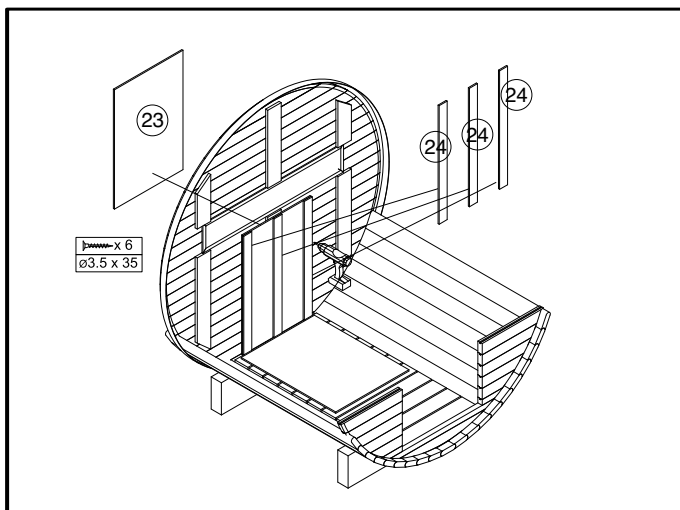
14.2 Put the part 21 on the floor and align with part 21. Fix with screws A8.



14.3 Put the part 23 on the top of the parts 22 and fix with screws A8.



14.4 Put the part 24 on the top of part 23 and fix with screws A8.



14. HEAT RESISTANT PANEL

14.5 Put the part 25 on the top of parts 24 and fix with screws A8.
NOTE. Top of part 25 should be aligned with top of part 24.

