Manufactured by:
Backyard Discovery
3305 Airport Drive, Pittsburg, KS 66762
800-856-4445

Basepoint Business Centre: Rivermead Drive,Westlea, Swindon SN5 7EX Phone: 0800-118-2476
J.P. Coenstraat 7, The Bridge, The Hague, 2595 WP, Netherlands Phone: 08005678990

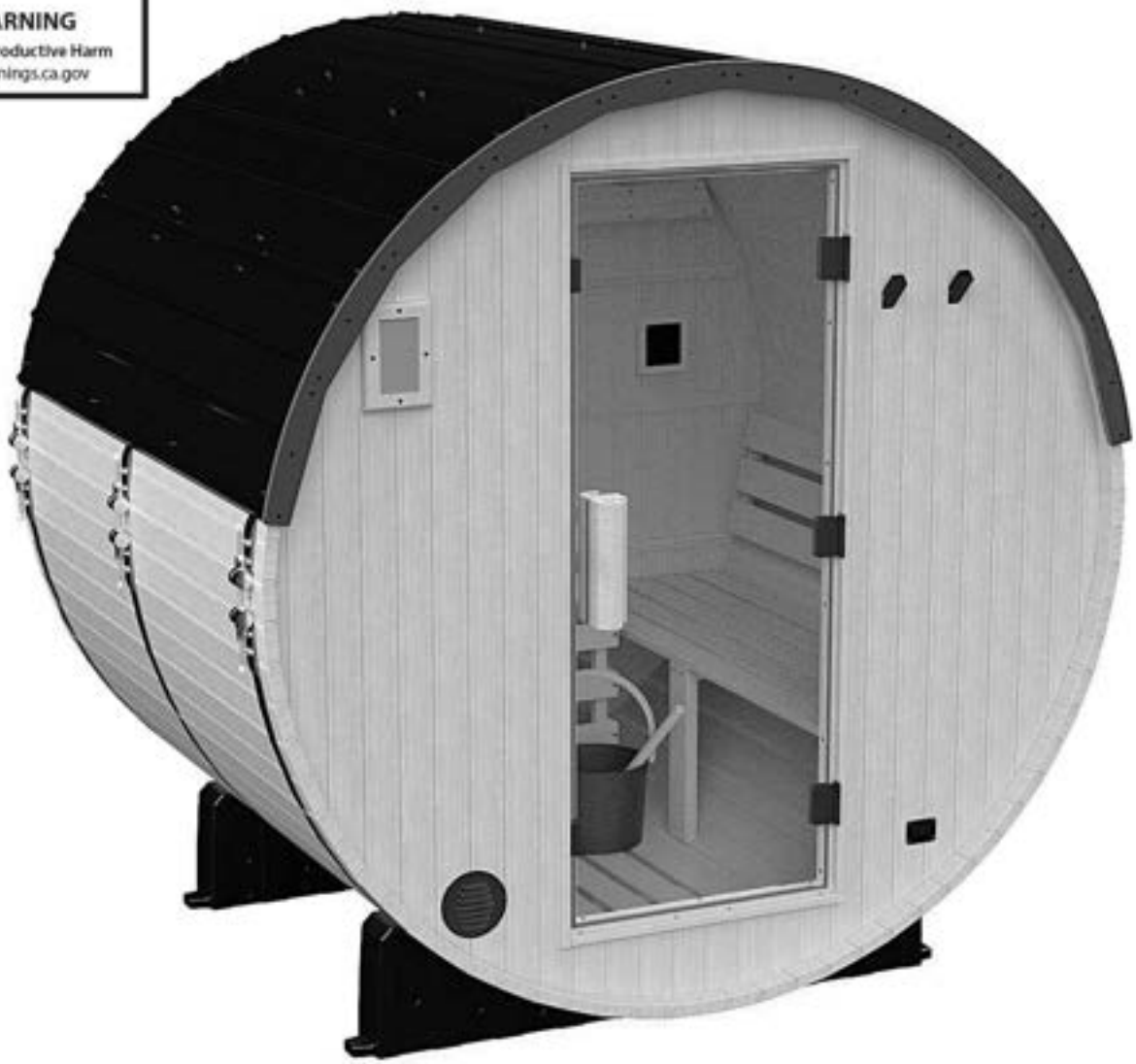
PAXTON 2-4P BARREL SAUNA

MODEL # : 2504417B, 2504417B-V, 2504394B, 2504394B-V

THE ASSEMBLY MANUAL MUST BE RETAINED SINCE IT CONTAINS IMPORTANT INFORMATION

LICENSED ELECTRICIAN WORK IS REQUIRED TO INSTALL A DEDICATED 240V/50AMP CIRCUIT

WARNING
Cancer and Reproductive Harm
www.P65Warnings.ca.gov



Please visit www.backyarddiscovery.com

For the most up to date assembly manual, to register your product, or to order replacement parts *Para obtener instrucciones en español, visite www.backyarddiscovery.com*

BILT®

EASY STEP-BY-STEP
3D INTERACTIVE INSTRUCTIONS
DOWNLOAD THE FREE APP

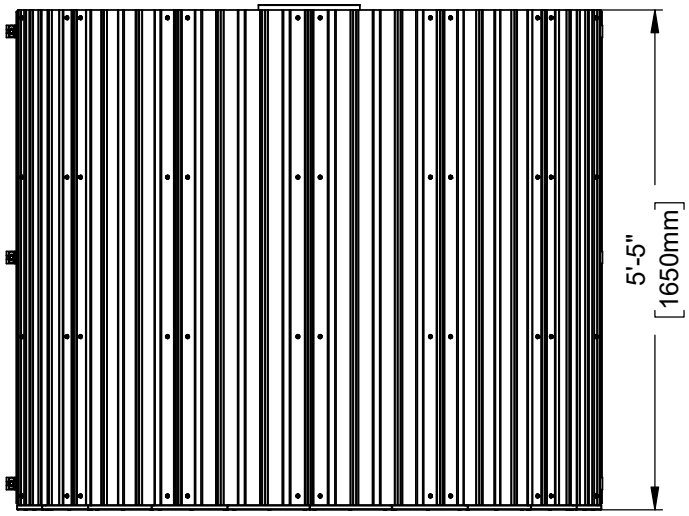
App Store | Google play

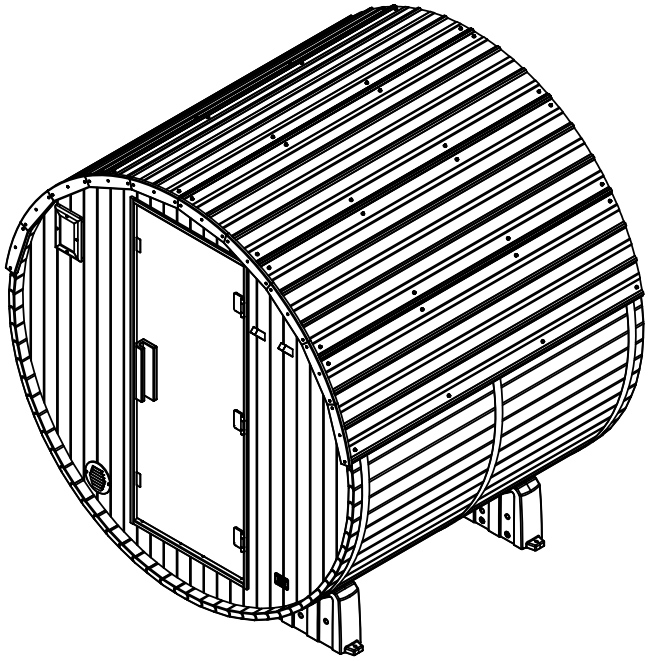
OWNER'S MANUAL - BASIC SETUP DIMENSIONS AND ASSEMBLY NOTES

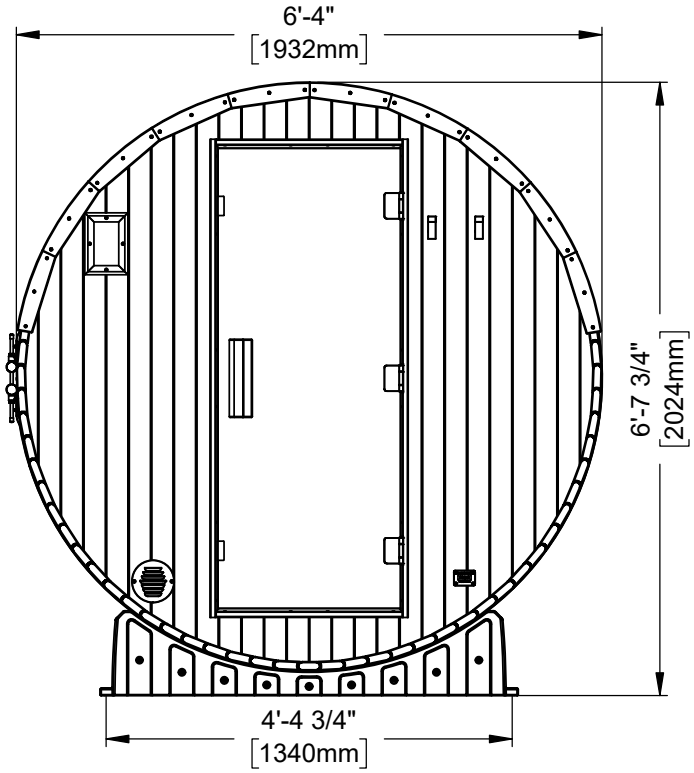
CHOOSE A GOOD LOCATION FOR YOUR SAUNA!

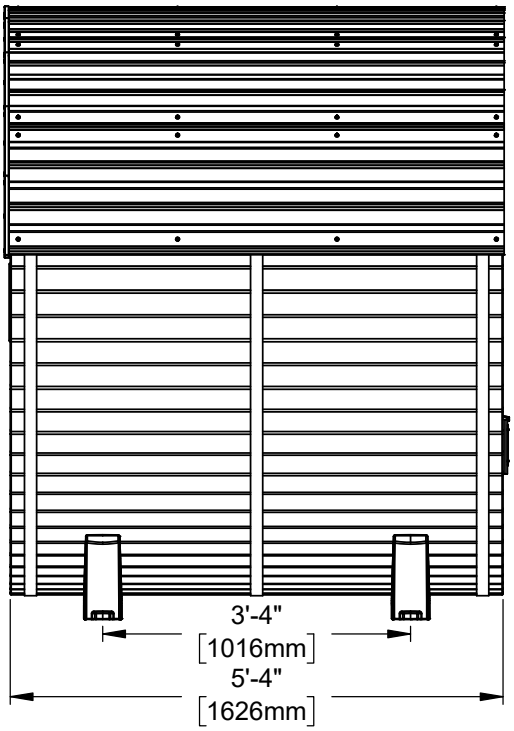
It is critically important the sauna foundation is sturdy and level.
An unstable foundation can cause the sauna to tilt, shift, or fall, leading to injury.
Pay close attention to the items needed for each step. Make sure you are using the correct hardware for each step.

- Using incorrect hardware may result in improper assembly.
- Ensure the surface is firm and level and can support the weight of the sauna and its users. (1000+ lbs.)
- Many garages, basements or deck floors are sloped for drainage. A slight slope will not be an issue. A more pronounced slope will require shimming to make the sauna level.
- Consider a concrete slab, paver stones, or something similar to prevent the cradle supports from settling in the ground. Concrete anchors are provided in the kit.
- If installing on the ground or gravel surface, ground anchors are included in the kit.
- If installing on a deck, confirm there is ample structural support under the deck. The hardware to mount to a wood deck is NOT included and will need to be purchased separately.
- Consider distance from your electrical service box as this can greatly impact the cost of needed electrical work
- If located in an area that tends to receive high winds, it is recommended to take extra precautions to ensure the door does not blow open. In most situations, this should not be a concern.

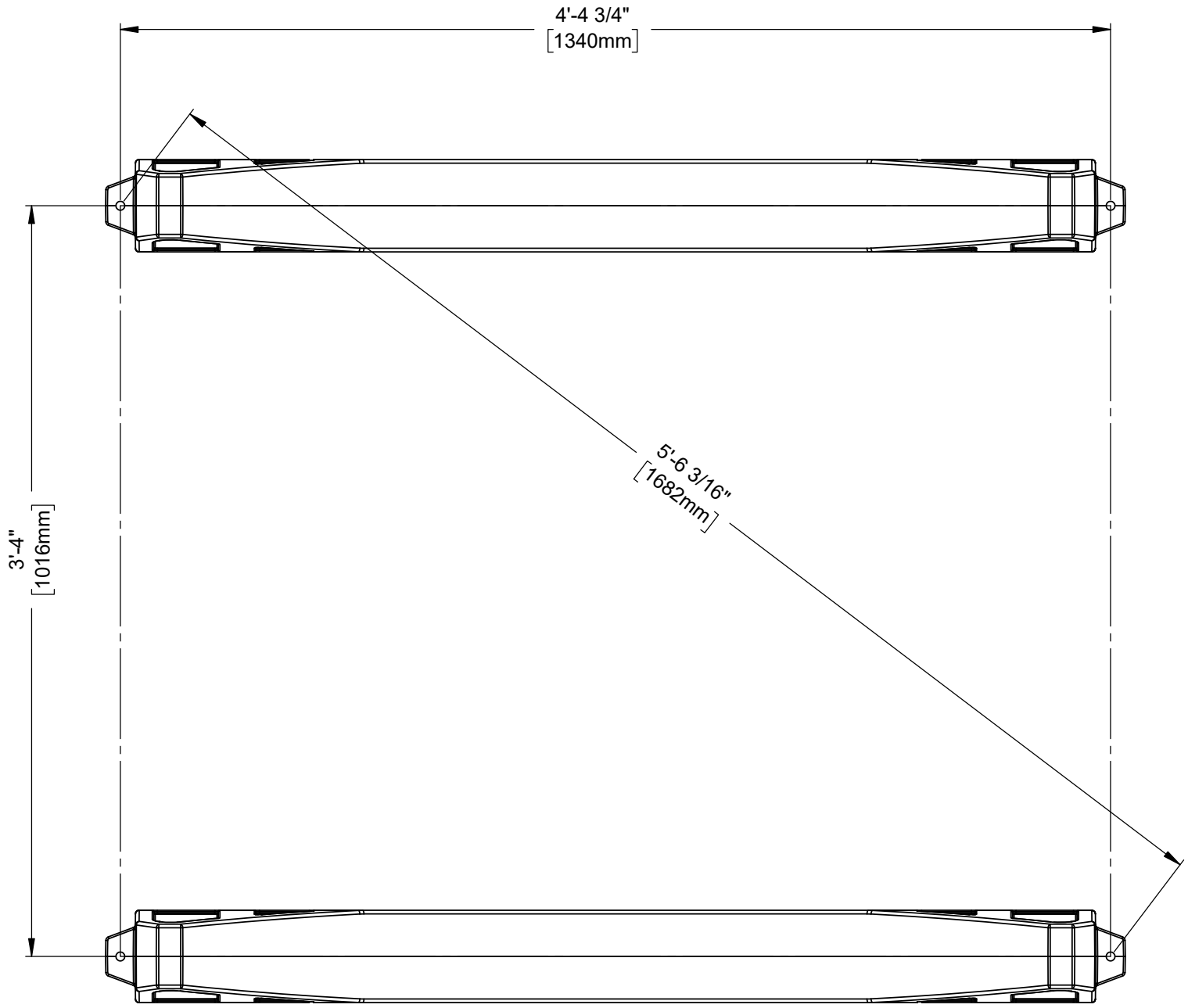






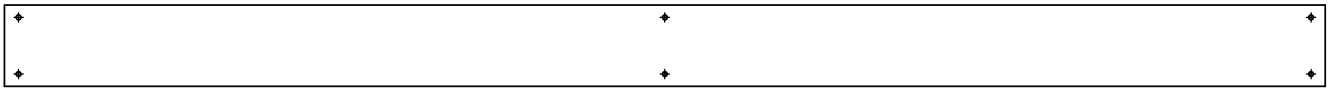


OWNER'S MANUAL - ANCHORING LAYOUT

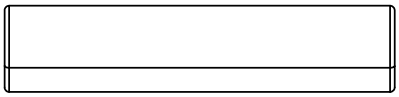


OWNER'S MANUAL - PARTS IDENTIFICATION

WOOD COMPONENTS (NOT TO SCALE)



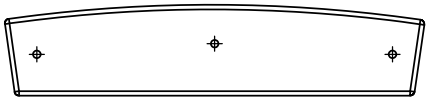
AK01 WIREWAY COVER-W4L21878
(x1) 5/16"x3 3/8"x55 1/16" (8x86x1398)



AM01 DOOR HANDLE-W4L21861
(x1) 2 1/4"x3"x10 3/16" (57x76x258)



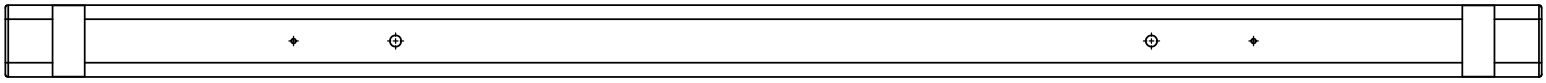
NR01 HEATER GUARD BOARD-W4L21872
(x5) 13/16"x2 3/8"x23 15/16" (20x60x608)



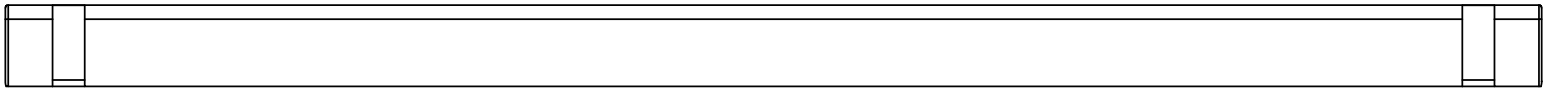
NR02 TRIM BOARD-W4L21866
(x10) 13/16"x2 3/8"x10 15/16" (20x60x278)



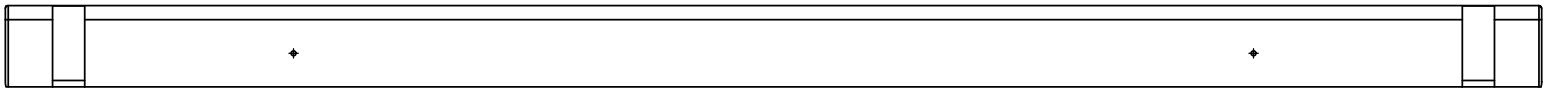
NR03 HEATER GUARD BOARD-W4L21874
(x10) 13/16"x2 3/8"x16 9/16" (20x60x420)



OB01 PERIMETER BOARD-W4L23457
(x1) 1 3/16"x3"x64" (30x76x1626)



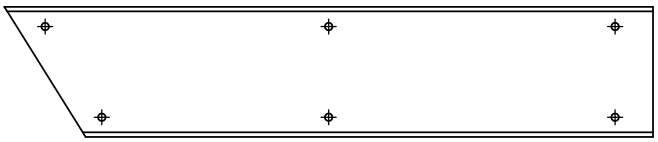
OG01 PERIMETER BOARD-W4L21857
(x46) 1 3/16"x3 3/8"x64" (30x86x1626)



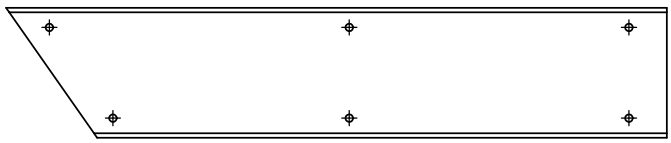
OG03 PERIMETER BOARD-W4L21859
(x14) 1 3/16"x3 3/8"x64" (30x86x1626)



OG04 BENCH BRACE-W4L21860
(x2) 1 3/16"3 3/8"16 3/8" (30x86x416)



OG05 WALL CLEAT-W4L21862
(x2) 1 3/16"x3 3/8"x16 7/8" (30x86x429)



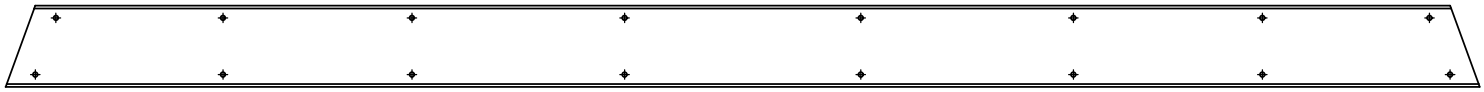
OG06 WALL CLEAT-W4L21863
(x1) 1 3/16"x3 3/8"x17 3/16" (30x86x437)



OG07 WALL CLEAT-W4L21867
(x1) 1 3/16"x3 3/8"x63 15/16" (30x86x1624)

OWNER'S MANUAL - PARTS IDENTIFICATION

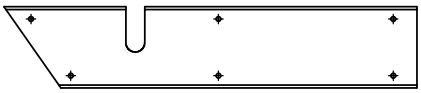
WOOD COMPONENTS (NOT TO SCALE)



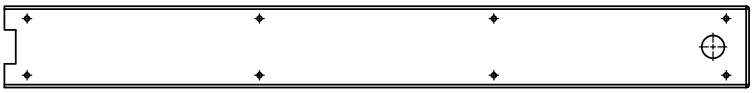
OG08 WALL CLEAT-W4L21868
(x1) 1 3/16"x3 3/8"x61 7/16" (30x86x1560)



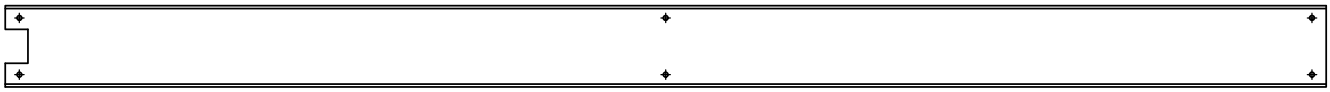
OG12 WIREWAY BOARD-W4L21999
(x1) 1 3/16"x3 3/8"x35 3/16" (30x86x894)



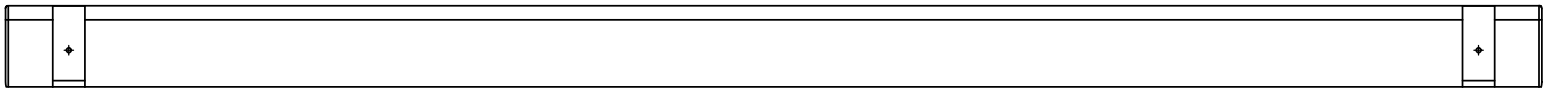
OG13 WALL CLEAT-W4L22019
(x1) 1 3/16"x3 3/8"x17 3/16" (30x86x437)



OG14 WIREWAY BOARD-W4L23471
(x1) 1 3/16"x3 3/8"x31" (30x86x788)



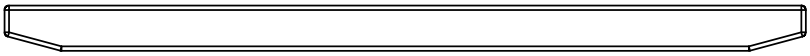
OG15 WIREWAY BOARD-W4L23472
(x1) 1 3/16"x3 3/8"x55 1/16" (30x86x1398)



OG16 PERIMETER BOARD-W4L23556
(x14) 1 3/16"x3 3/8"x64" (30x86x1626)



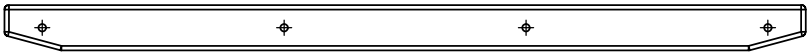
OO02 HEATER GUARD BOARD-W4L21875
(x2) 1 3/16"x1 3/16"x21 7/16" (30x30x544)



OO03 FLOOR CLEAT-W4L21964
(x1) 1 3/16"1 3/16"20 7/8" (30x30x530)



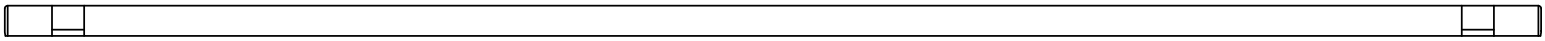
OO04 HEATER GUARD BOARD-W4L21871
(x2) 1 3/16"x1 3/16"x21 7/16" (30x30x544)



OO05 FLOOR SUPPORT-W4L21963
(x2) 1 3/16"x1 3/16"x20 7/8" (30x30x530)



OR01 GUARD MOUNTING BOARD-W4L21873
(x2) 1 3/16"x2 3/8"x23 15/16" (30x60x608)



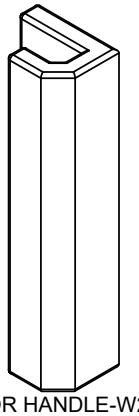
OR02 PERIMETER BOARD-W4L23458
(x2) 1 3/16"x1 1/4"x64" (30x32x1626)



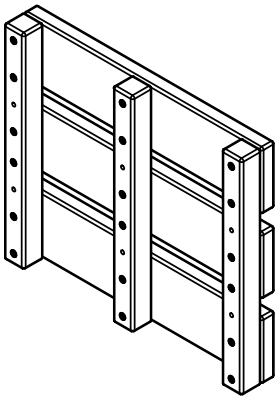
OV01 HEATER GUARD SPACER-W4L21887
(x2) 1 3/16"x4 7/16"x23 15/16" (30x112x608)

OWNER'S MANUAL - PARTS IDENTIFICATION

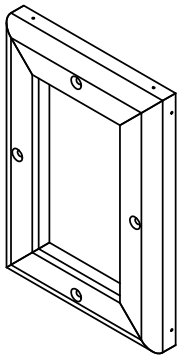
WOOD COMPONENTS (NOT TO SCALE)



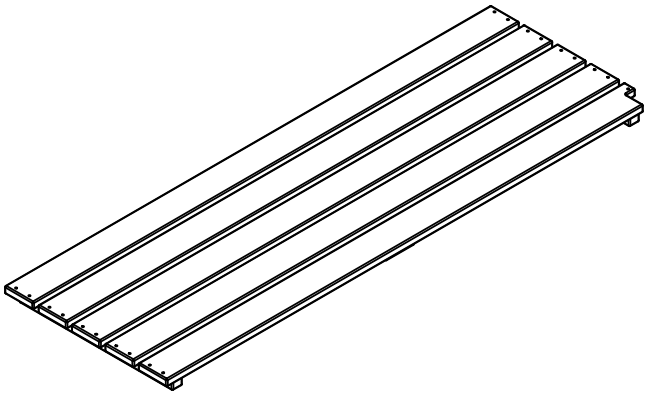
AM02 DOOR HANDLE-W2A04795
(x1) 2 1/4"x3"x10 3/16" (57x76x258)



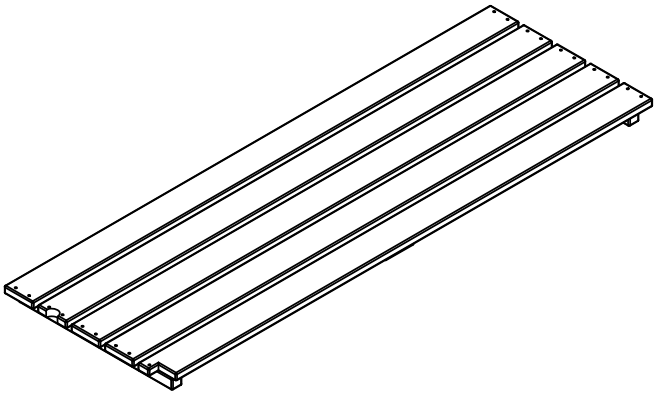
BR01 WALL BACK REST-W2A04790
(x2) 1 15/16"X12 1/16"X14" (50x306x356)



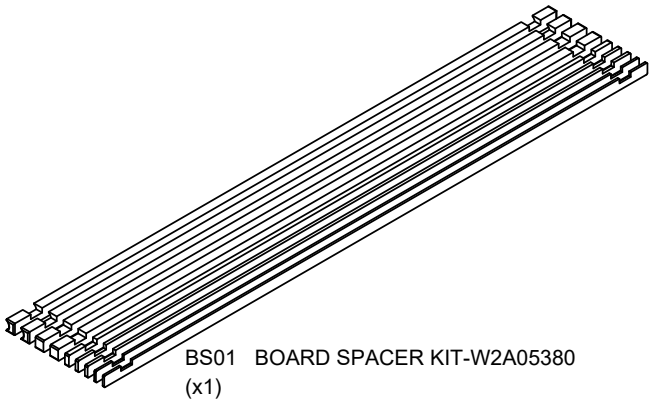
TF01 TRIM FRAME-W2A04797
(x1) 7/8"x5 9/16"x8 1/16" (22x142x204)



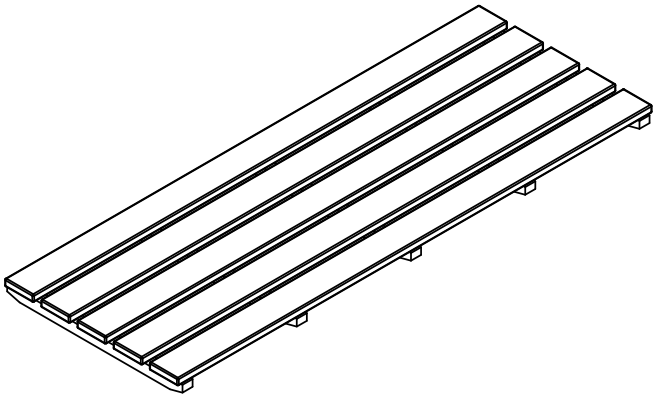
BA01 RIGHT BENCH ASSEMBLY-W2A04788
(x1) 1 15/16"x19 1/8"x57 5/16" (50x486x1456)



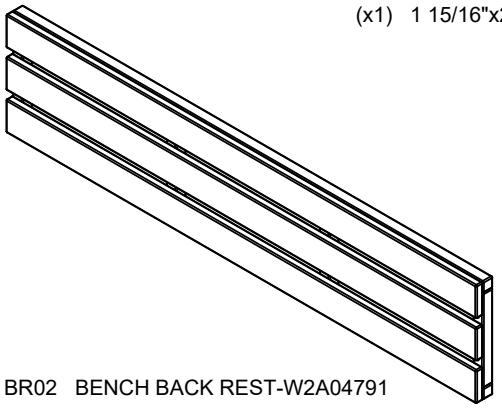
BA02 LEFT BENCH ASSEMBLY-W2A04789
(x1) 19 1/8"57 5/16" (50x486x1456)



BS01 BOARD SPACER KIT-W2A05380
(x1)



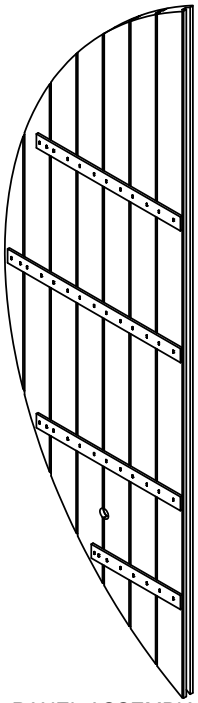
FP01 FLOOR PANEL ASSEMBLY-W2A04796
(x1) 1 15/16"x20 11/16"x55 7/8" (50x525x1420)



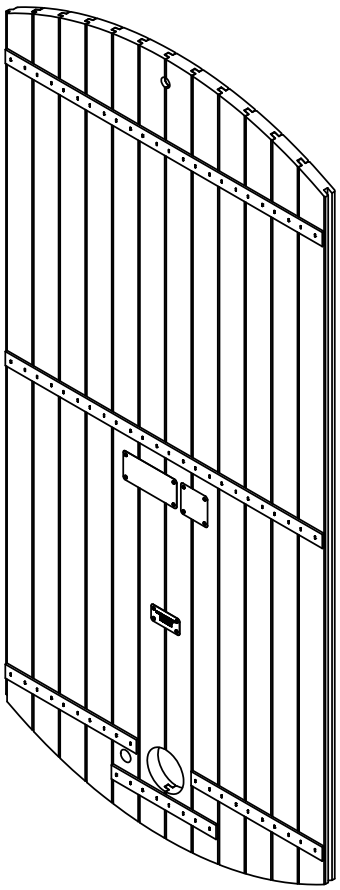
BR02 BENCH BACK REST-W2A04791
(x2) 1 15/16"x12 1/16"x55 7/16" (50x306x1408)

OWNER'S MANUAL - PARTS IDENTIFICATION

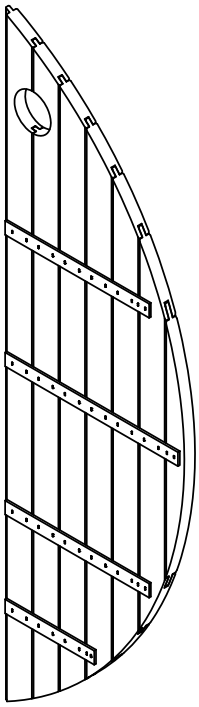
WOOD COMPONENTS (NOT TO SCALE)



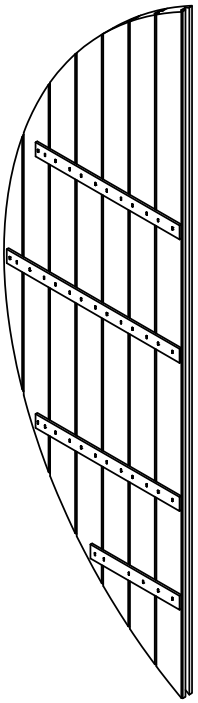
WP01 WALL PANEL ASSEMBLY-W2A05379
(x1) 1 3/8"x19 11/16"x65 3/4" (35x500x1669)



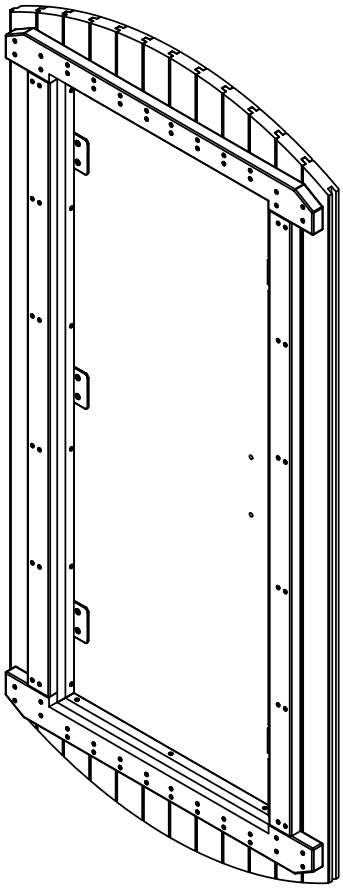
WP02 WALL PANEL ASSEMBLY-W2A05377
(x1) 1 3/8"x35 5/8"x74 9/16" (35x906x1894)



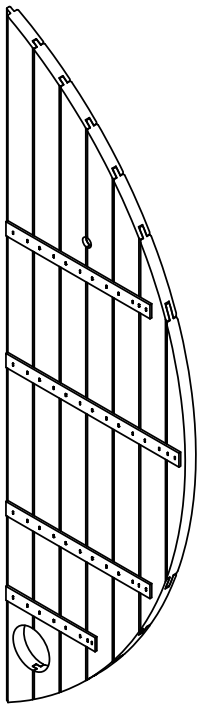
WP03 WALL PANEL ASSEMBLY-W2A05384
(x1) 1 3/8"x20 1/8"x66 1/4" (35x512x1682)



WP05 WALL PANEL ASSEMBLY-W2A05385
(x1) 1 3/8"x19 11/16"x65 3/4" (35x500x1669)



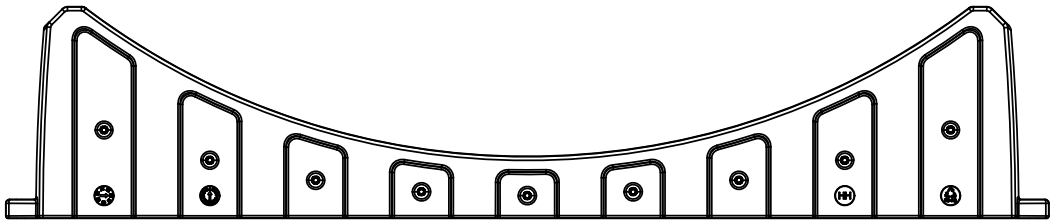
WP04 WALL PANEL ASSEMBLY-W2A04794
(x1) 3 11/16"X35 5/8"X74 9/16" (78x906x1894)



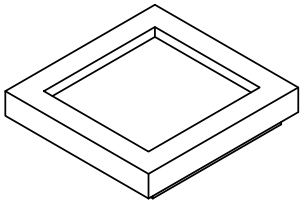
WP06 WALL PANEL ASSEMBLY-W2A05378
(x1) 1 3/8"x20 1/8"x66 1/4" (35x512x1682)

OWNER'S MANUAL - PARTS IDENTIFICATION

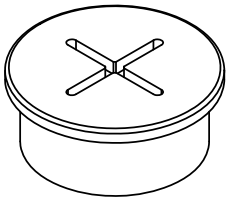
ACCESSORY COMPONENTS (NOT TO SCALE)



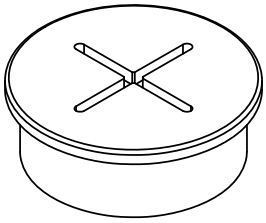
1466 BASE SUPPORT-A6P01466
(x2)



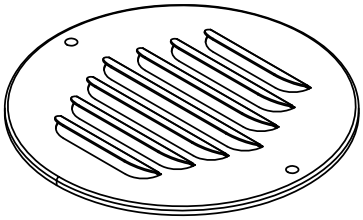
1698 HYGROMETER-A6P01698
(x1)



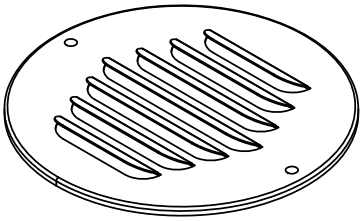
1467 25mm SILICONE GROMMET-A6P01467
(x3)



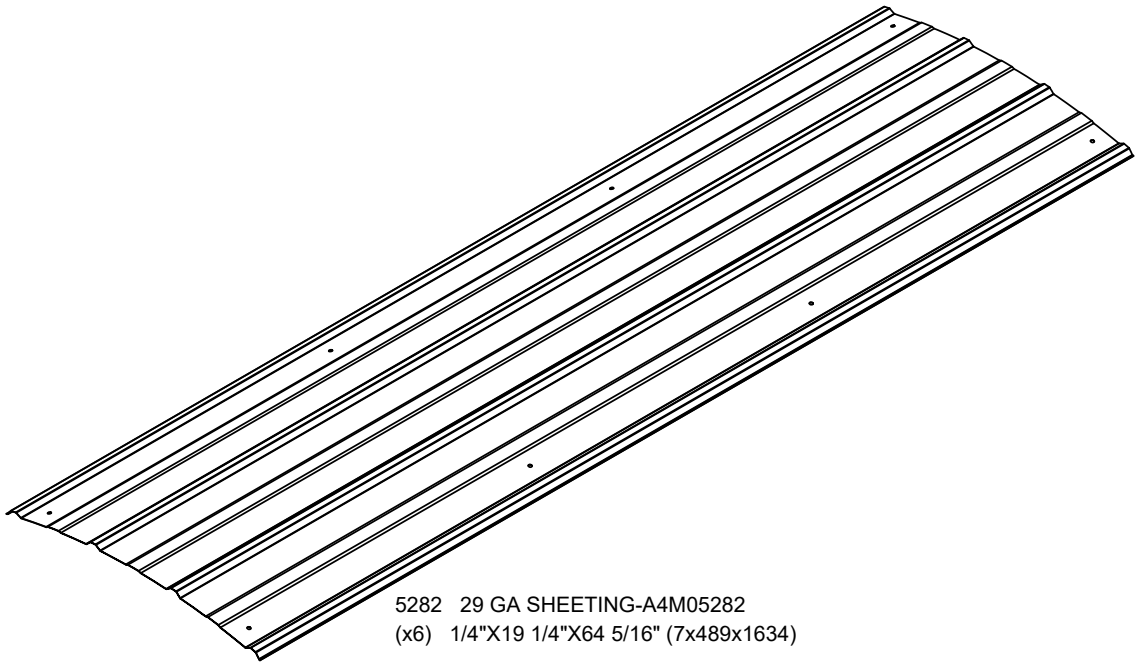
1468 30mm SILICONE GROMMET-A6P01468
(x1)



5285 VENT COVER-A4M05285
(x2)



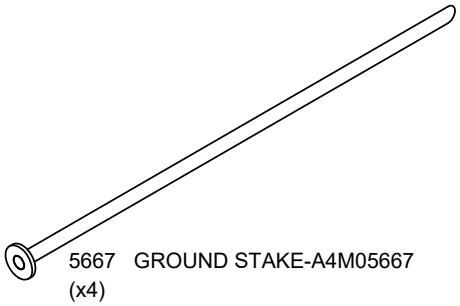
7415 VENT COVER-A4M07415
(x1)



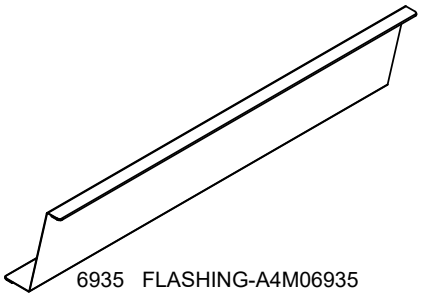
5282 29 GA SHEETING-A4M05282
(x6) 1/4"X19 1/4"X64 5/16" (7x489x1634)

OWNER'S MANUAL - PARTS IDENTIFICATION

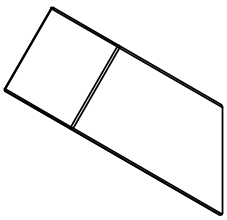
ACCESSORY COMPONENTS (NOT TO SCALE)



5667 GROUND STAKE-A4M05667
(x4)



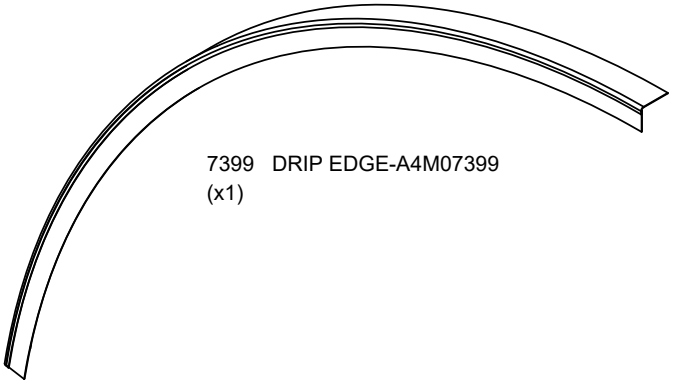
6935 FLASHING-A4M06935
(x1)



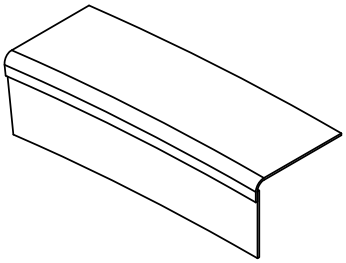
5672 TOWEL HANGER-A4M05672
(x2)



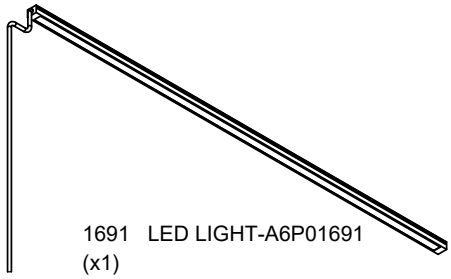
7398 DRIP EDGE-A4M07398
(x1)



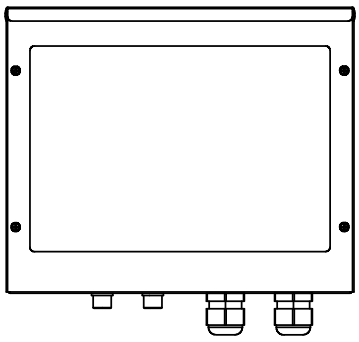
7399 DRIP EDGE-A4M07399
(x1)



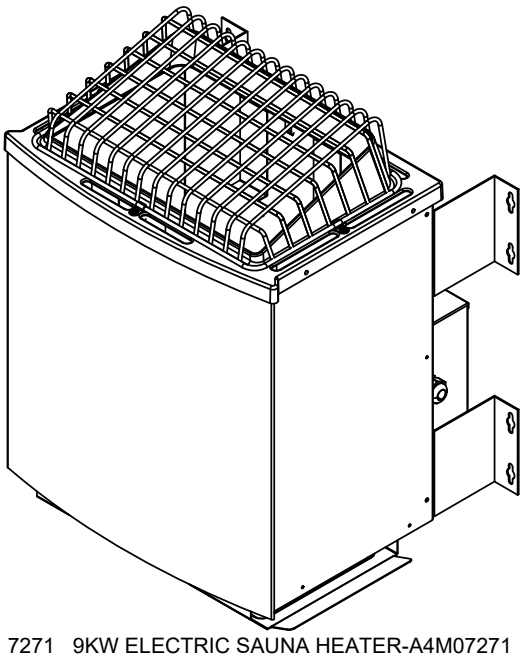
7400 DRIP EDGE SPLICE-A4M07400
(x1)



1691 LED LIGHT-A6P01691
(x1)



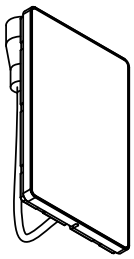
7170 CONTROL BOX-A4M07170
(x1)



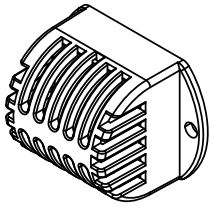
7271 9KW ELECTRIC SAUNA HEATER-A4M07271
(x1)

OWNER'S MANUAL - PARTS IDENTIFICATION

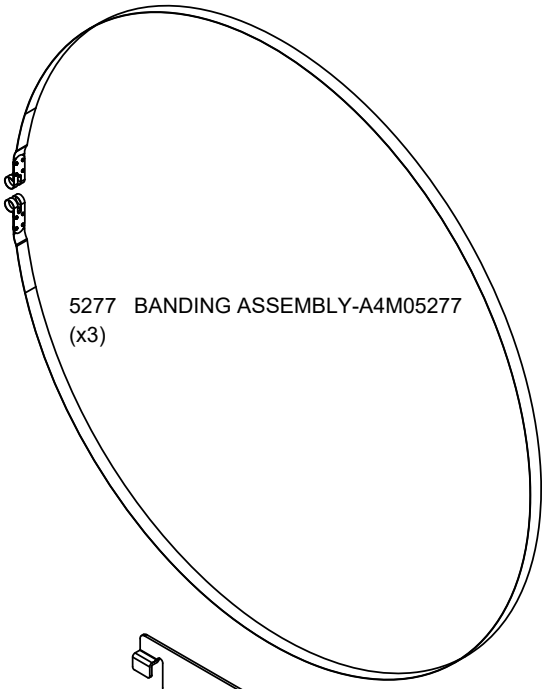
ACCESSORY COMPONENTS (NOT TO SCALE)



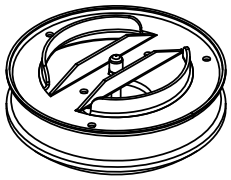
7172 SCREEN CONTROLLER-A4M07172
(x1)



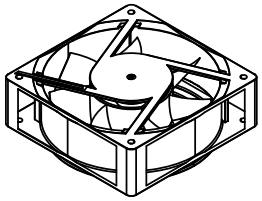
1714 TEMPERATURE SENSOR-A6P01714
(x1)



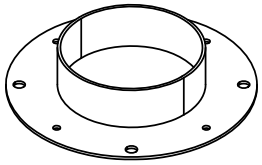
5277 BANDING ASSEMBLY-A4M05277
(x3)



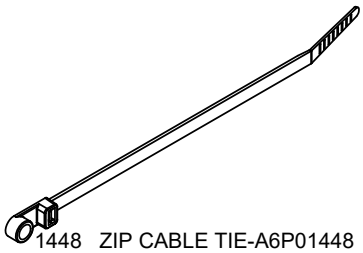
5592 VENT ASSEMBLY-A4M05592
(x1)



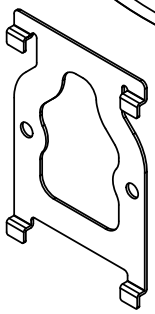
7272 SAUNA FAN-A4M07272
(x1)



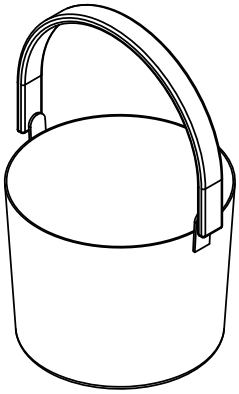
7417 SAUNA FAN BRACKET-A4M07417
(x1)



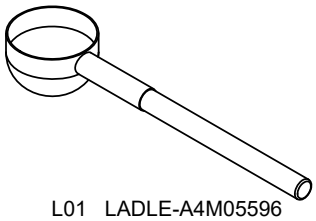
1448 ZIP CABLE TIE-A6P01448
(x10)



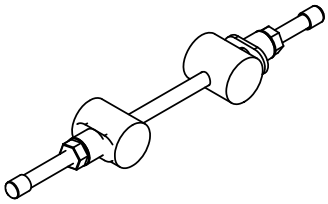
5590-03 CONTROL PANEL MOUNTING BRACKET-A4M05590-03
(x1)



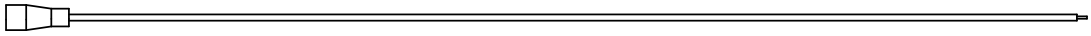
B01 BUCKET-A4M05673
(x1)



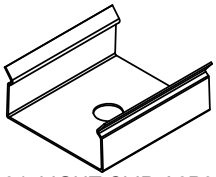
L01 LADLE-A4M05596
(x1)



5671 BANDING CINCH-A4M05671
(x3)



1712 LED LIGHT EXTENSION CABLE-A6P01712
(x1)



1493-04 LIGHT CLIP-A6P01493-04
(x2)



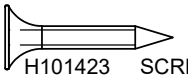
5590-10 WIRING HARNESS-A4M05590-10
(x1)



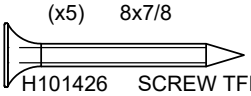
1732 SAUNA POWER WIRE-A6P01732
(x1)

OWNER'S MANUAL - PARTS IDENTIFICATION

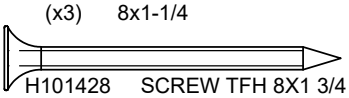
HARDWARE COMPONENTS



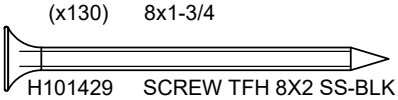
H101423 SCREW TFH 8X7/8 SS-BLK
(x5) 8x7/8



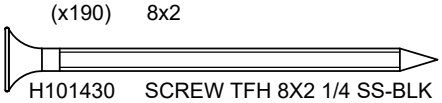
H101426 SCREW TFH 8X1 1/4 SS-BLK
(x3) 8x1-1/4



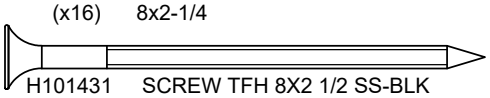
H101428 SCREW TFH 8X1 3/4 SS-BLK
(x130) 8x1-3/4



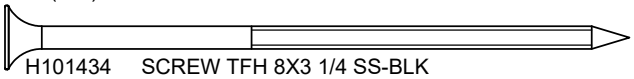
H101429 SCREW TFH 8X2 SS-BLK
(x190) 8x2



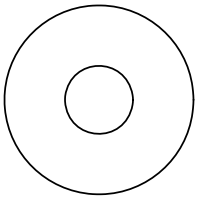
H101430 SCREW TFH 8X2 1/4 SS-BLK
(x16) 8x2-1/4



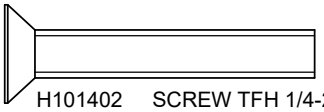
H101431 SCREW TFH 8X2 1/2 SS-BLK
(x10) 8x2-1/2



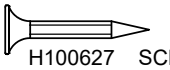
H101434 SCREW TFH 8X3 1/4 SS-BLK
(x14) 8x3 1/4



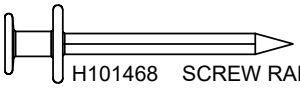
H101403 POLY WASHER
(x4)



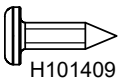
H101402 SCREW TFH 1/4-20 X 1 5/8 SS
(x2) 1/4-20 X 1 5/8



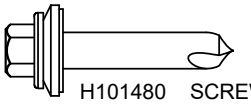
H100627 SCREW PFH BLK
(x2) 6x3/4



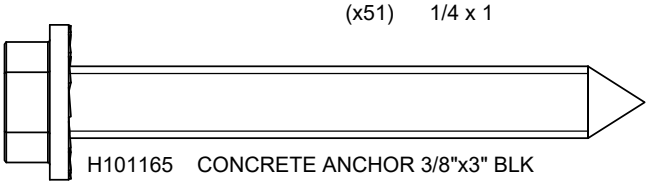
H101468 SCREW RAISED HEAD 8X1 BLK
(x8)



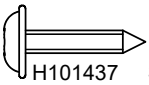
H101409 SCREW PPH 4x1/2 BLK
(x10) 4x1/2



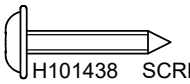
H101480 SCREW SELF TAPPING #9x1 BLK
(x51) 1/4 x 1



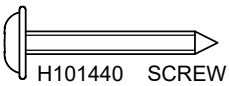
H101165 CONCRETE ANCHOR 3/8"x3" BLK
(x4) 3/8x3



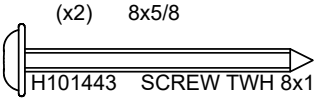
H101437 SCREW TWH 8x5/8 SS-BLK
(x2) 8x5/8



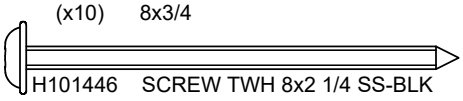
H101438 SCREW TWH 8x3/4 SS-BLK
(x10) 8x3/4



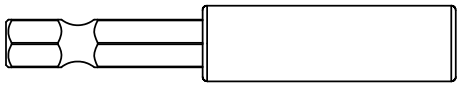
H101440 SCREW TWH 8x1 SS-BLK
(x5) 8x1



H101443 SCREW TWH 8x1 1/2 SS-BLK
(x4) 8x1-1/2

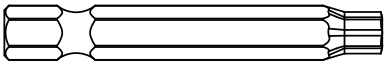


H101446 SCREW TWH 8x2 1/4 SS-BLK
(x4) 8x21/4

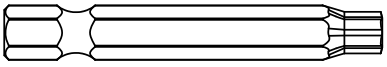


H101100 MAGNETIC DRIVER
(x1)

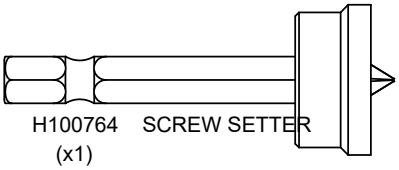
H100114 TORX WRENCH
(x1)



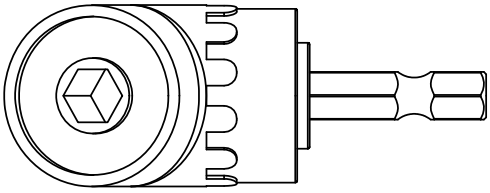
H100147 TORX BIT
(x1) T-30



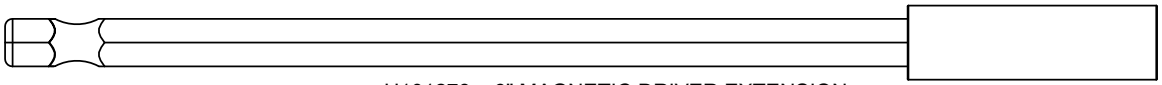
H100879 TORX BIT
(x1) T-20



H100764 SCREW SETTER
(x1)



H101114 RIGHT ANGLE DRILL ADAPTER
(x1)



H101278 6" MAGNETIC DRIVER EXTENSION
(x1)

PRE-ASSEMBLY STEP 1 - SORTING PARTS

It is critical for ease of assembly that you take the time to sort and organize the wood and hardware.

WOOD PARTS:

- Organize wood parts by the three-digit, alpha-numeric number stamped on each board (ex. P01).
- If there are multiple boards with the same stamped number, stack those pieces together.
- Stamps can be found on the flat surface of the boards or on the end of the boards.
- Allow yourself plenty of room - the wood pieces can take up a significant amount of space.

NOTE: CARTONS ARE NOT ORGANIZED BY BOARD NUMBER.



HARDWARE PARTS:

- We recommend that you have a separate table to organize the hardware.
- Hardware bags are printed with a seven-digit, alpha-numeric part number.
- You can organize your hardware by part number or group by hardware type (i.e. bolts, nuts, etc.).
- During assembly you only need to reference the last four digits of the number.



PRE-ASSEMBLY STEP 2 - TOOLS REQUIRED



Cordless Drill or
Electric Drill



Drill Attachments:
Phillips Head



1/8", 3/16", 3/8" &
7/16" Drill Bits



Phillips Screw Driver



Open End
Wrench 11/16"



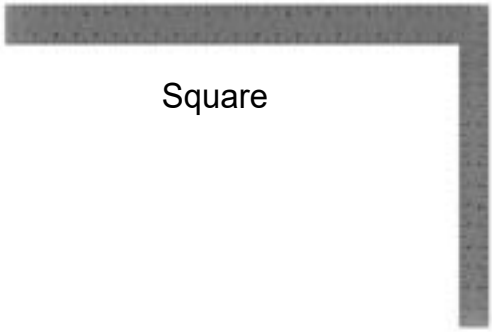
3/8" Drive Ratchet, 1/2" &
7/16" STD Sockets, 1/2" &
7/16" Deep Sockets



Tape Measure



Claw Hammer



Square



Level 24"



Rubber Mallet -
Optional



Rope 25ft [7.62m] long - Optional

PRE-ASSEMBLY STEP 3 - CHOOSE YOUR ASSEMBLY METHOD

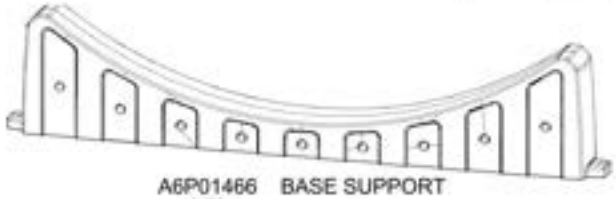
There are several types of assembly instructions available to you.

1. Printed Assembly Manual included with your set
2. BILT APP - 3D interactive instructions
3. Combination of the Printed Manual and BILT APP (Note: Step numbers can differ between the two methods)



STEP 1 - BASE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
2	H101429	SCREW TFH 8X2 SS-BLK

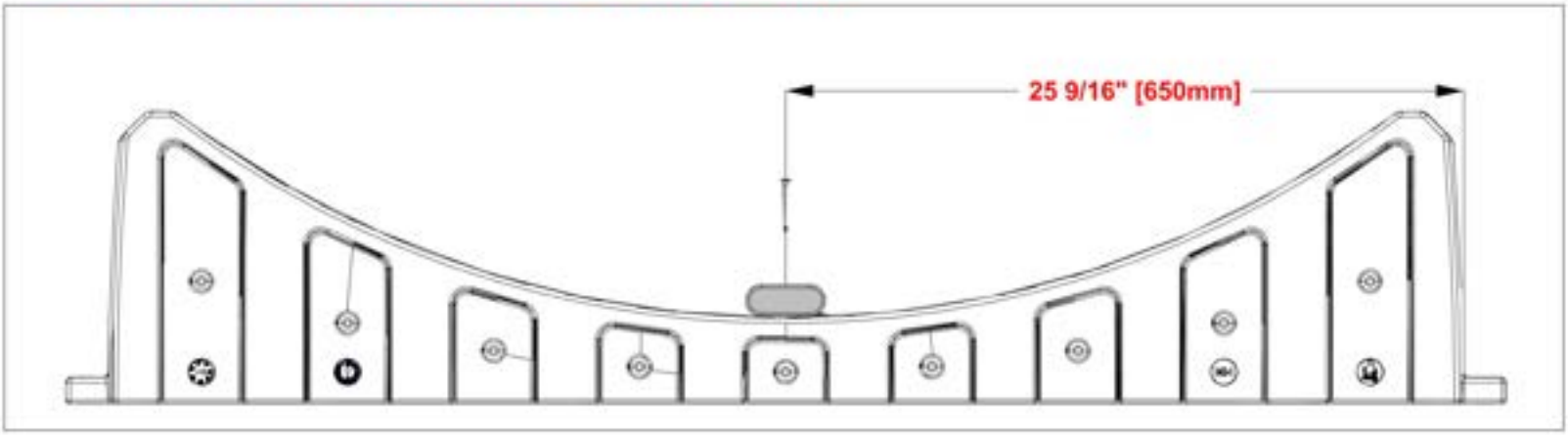


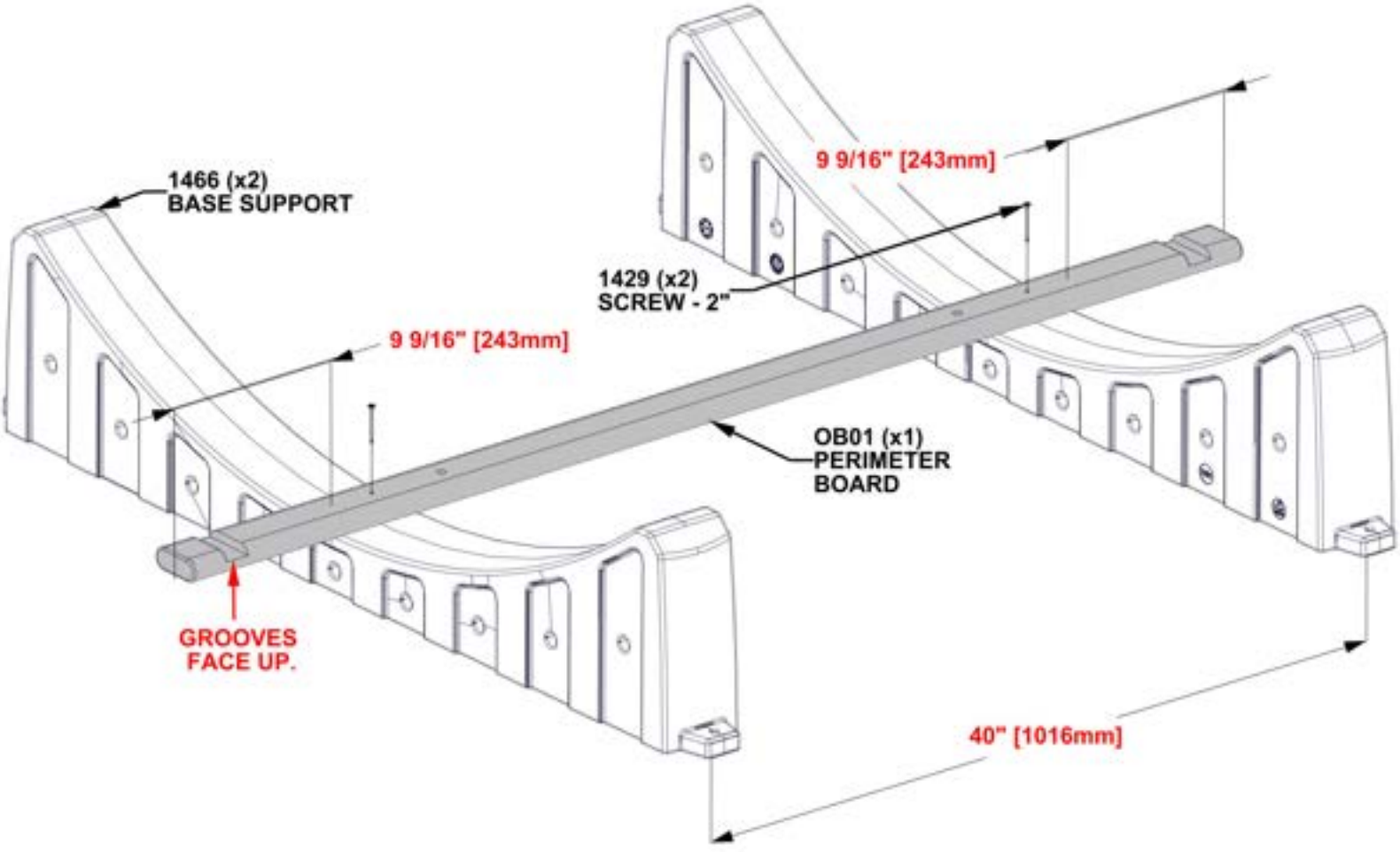
A6P01466 BASE SUPPORT
(x2)



OB01 PERIMETER BOARD - W4L23457
(x1) 1 3/16"x3"x64" (30x76x1626)

- STAND BASE SUPPORTS UP AND HOLD DIMENSIONS SHOWN.
- ATTACH HARDWARE AS SHOWN.
- ONCE HARDWARE IS INSTALLED, SQUARE UP BASE SUPPORTS.



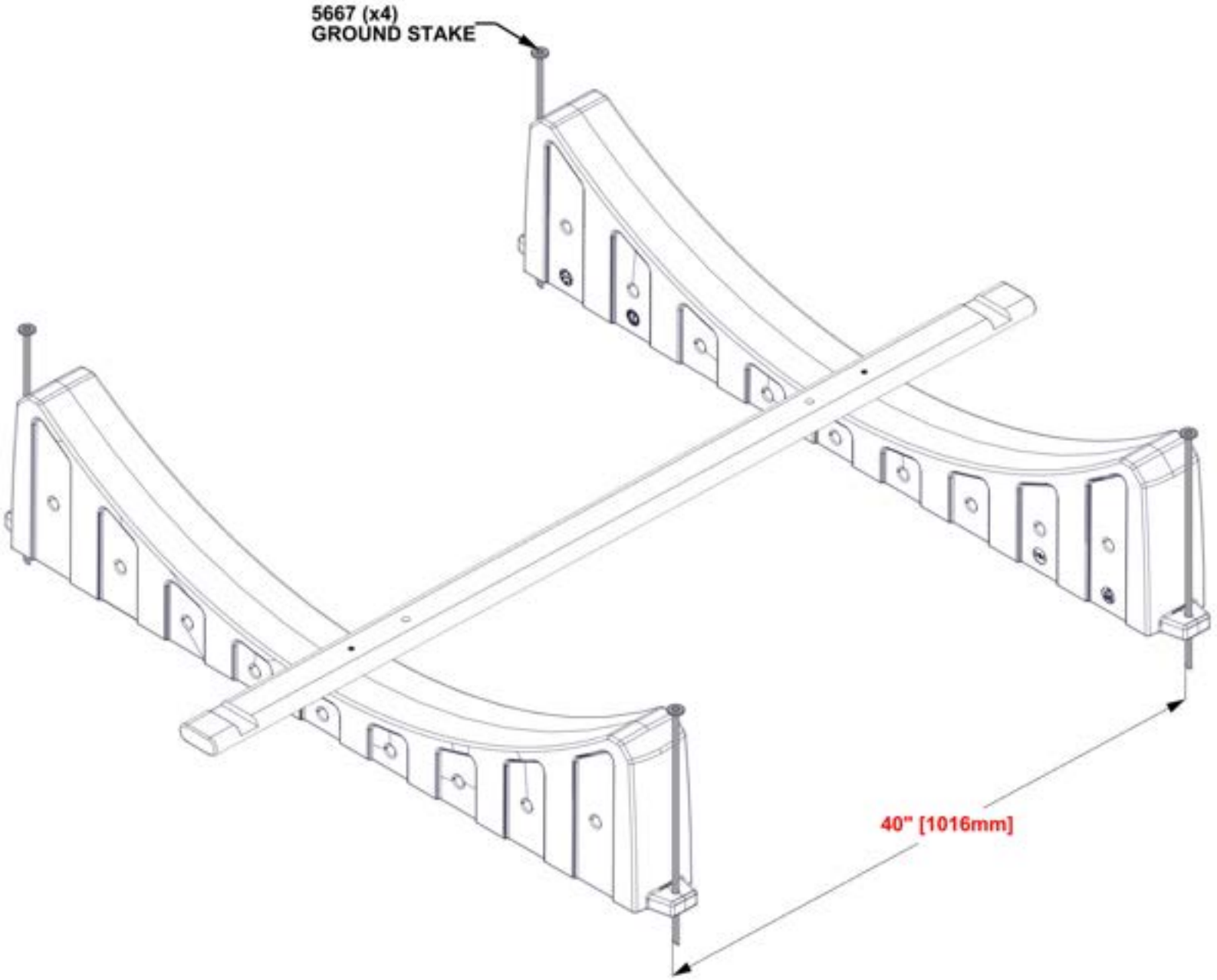


STEP 2 - ANCHORING TO GROUND



A4M05667 GROUND STAKE
(x4)

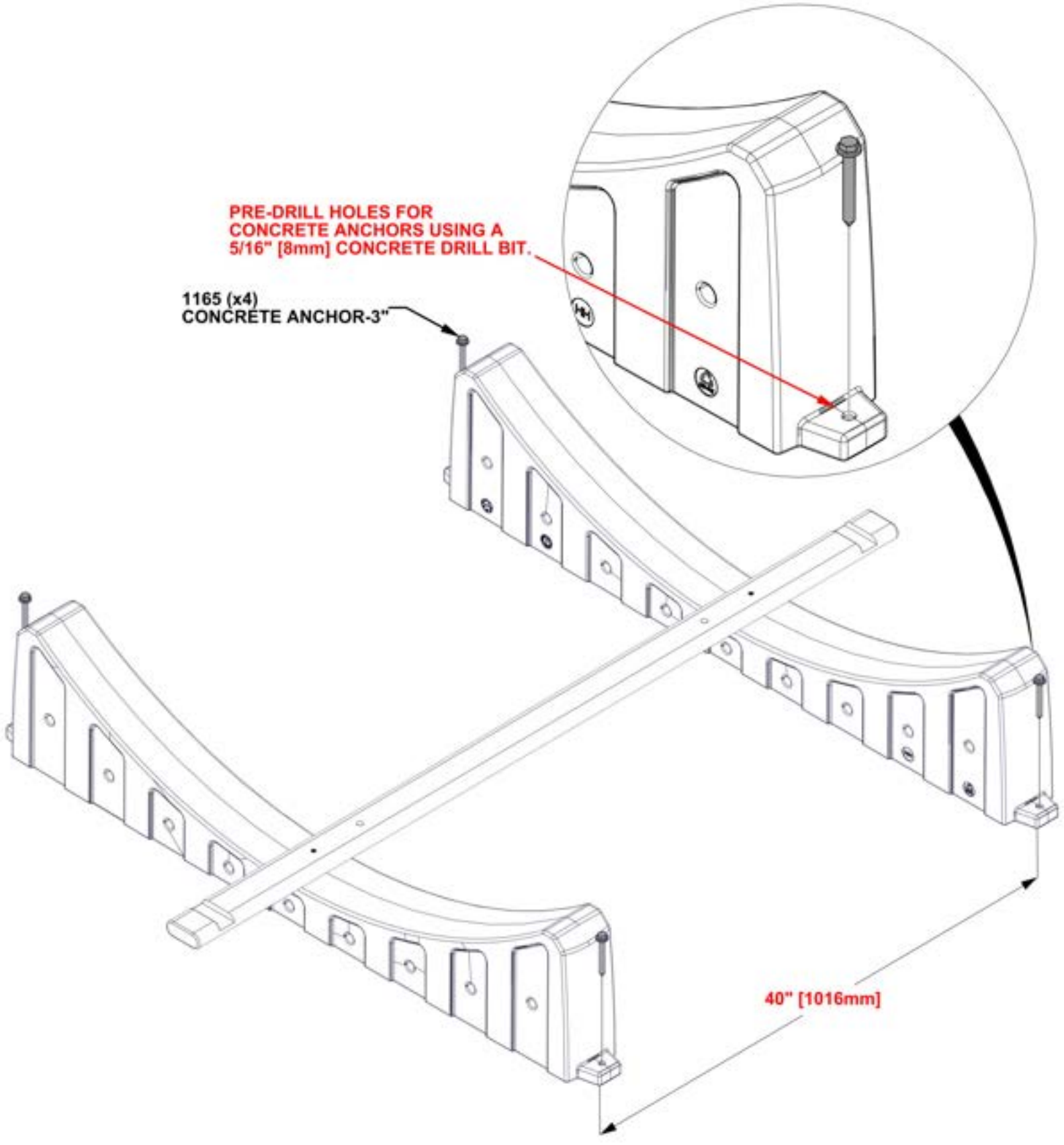
- IF SAUNA IS TO SIT ON A CONCRETE SURFACE, SEE STEP 3.
- BEFORE ANCHORING, ENSURE THERE IS A SLIGHT DOWNWARD SLOPE FROM THE FRONT TO THE BACK OF THE SAUNA.
- THE FRONT OF THE SAUNA SHOULD BE APPROXIMATELY 1" HIGHER THAN THE BACK.
- THIS WILL ENSURE THAT WATER WILL RUN OFF THE BACK.
- ADDING SHIMS UNDER THE FRONT SAUNA BASE MAY BE NECESSARY TO ACHIEVE THIS SLOPE.



STEP 3 - ANCHORING TO CONCRETE

QTY	PART NUMBER	DESCRIPTION
4	H101165	CONCRETE ANCHOR 3/8x3" BLK

- IF SAUNA IS TO SIT ON THE GROUND, SEE STEP 2.
- BEFORE ANCHORING, ENSURE THERE IS A SLIGHT DOWNWARD SLOPE FROM THE FRONT TO THE BACK OF THE SAUNA.
- THE FRONT OF THE SAUNA SHOULD BE APPROXIMATELY 1" HIGHER THAN THE BACK.
- THIS WILL ENSURE THAT WATER WILL RUN OFF THE BACK.
- ADDING SHIMS UNDER THE FRONT SAUNA BASE MAY BE NECESSARY TO ACHIEVE THIS SLOPE.

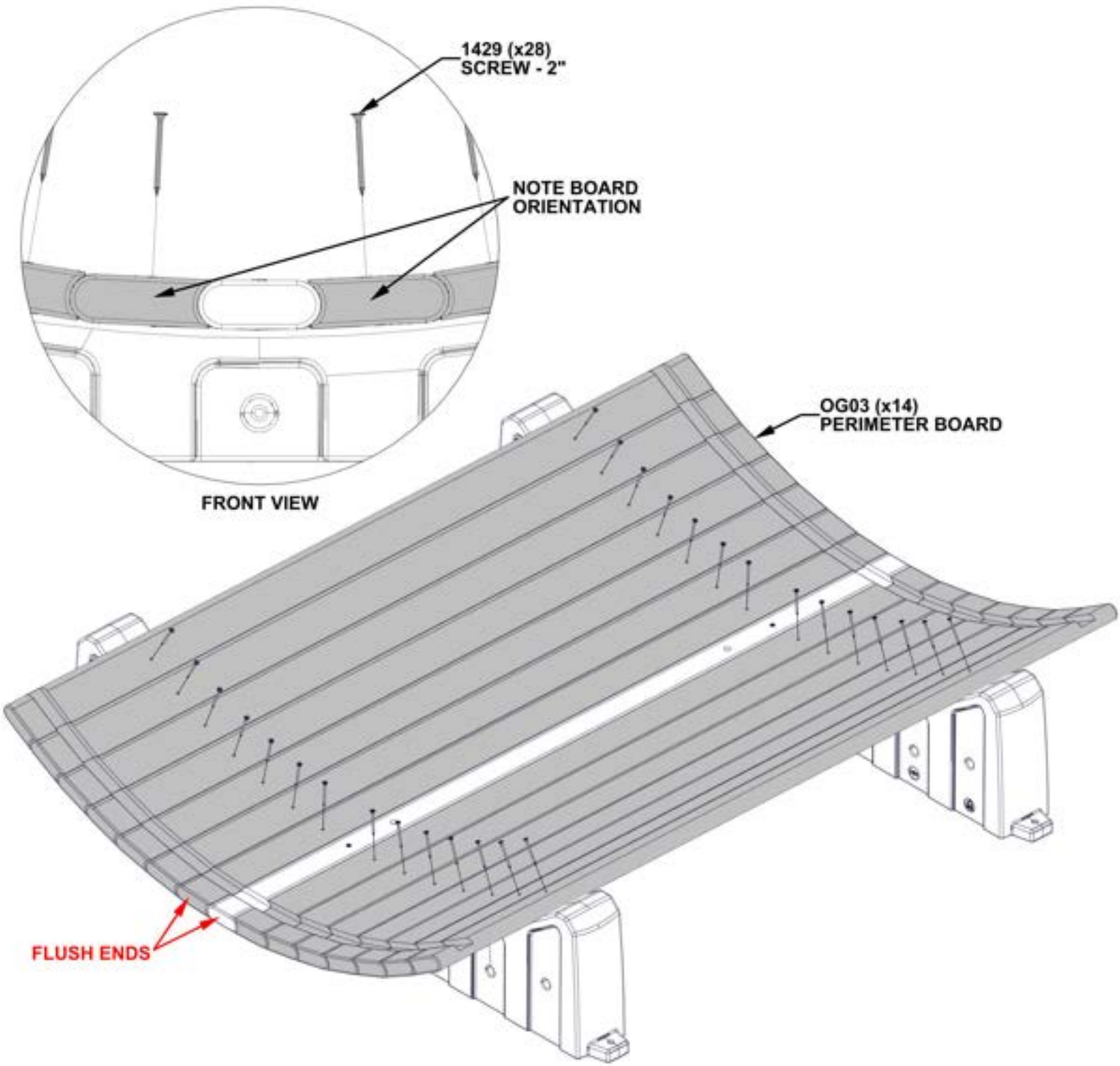


STEP 4 - BASE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
28	H101429	SCREW TFH 8X2 SS-BLK

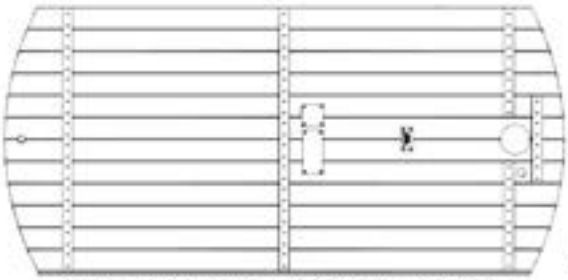


OG03 (x14) PERIMETER BOARD - W4L21859
1 3/16"x3 3/8"x64" (30x86x1626)

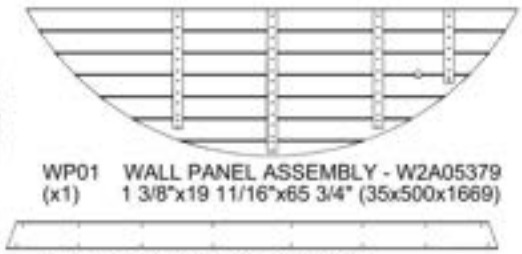


STEP 5 - BACK WALL ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
32	H101429	SCREW TFH 8X2 SS-BLK

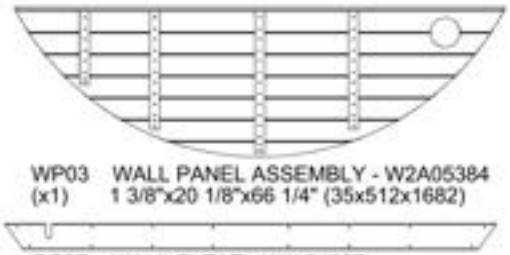


WP02 (x1) WALL PANEL ASSEMBLY - W2A05377
1 3/8"x35 5/8"x74 9/16" (35x906x1894)



WP01 (x1) WALL PANEL ASSEMBLY - W2A05379
1 3/8"x19 11/16"x65 3/4" (35x500x1669)

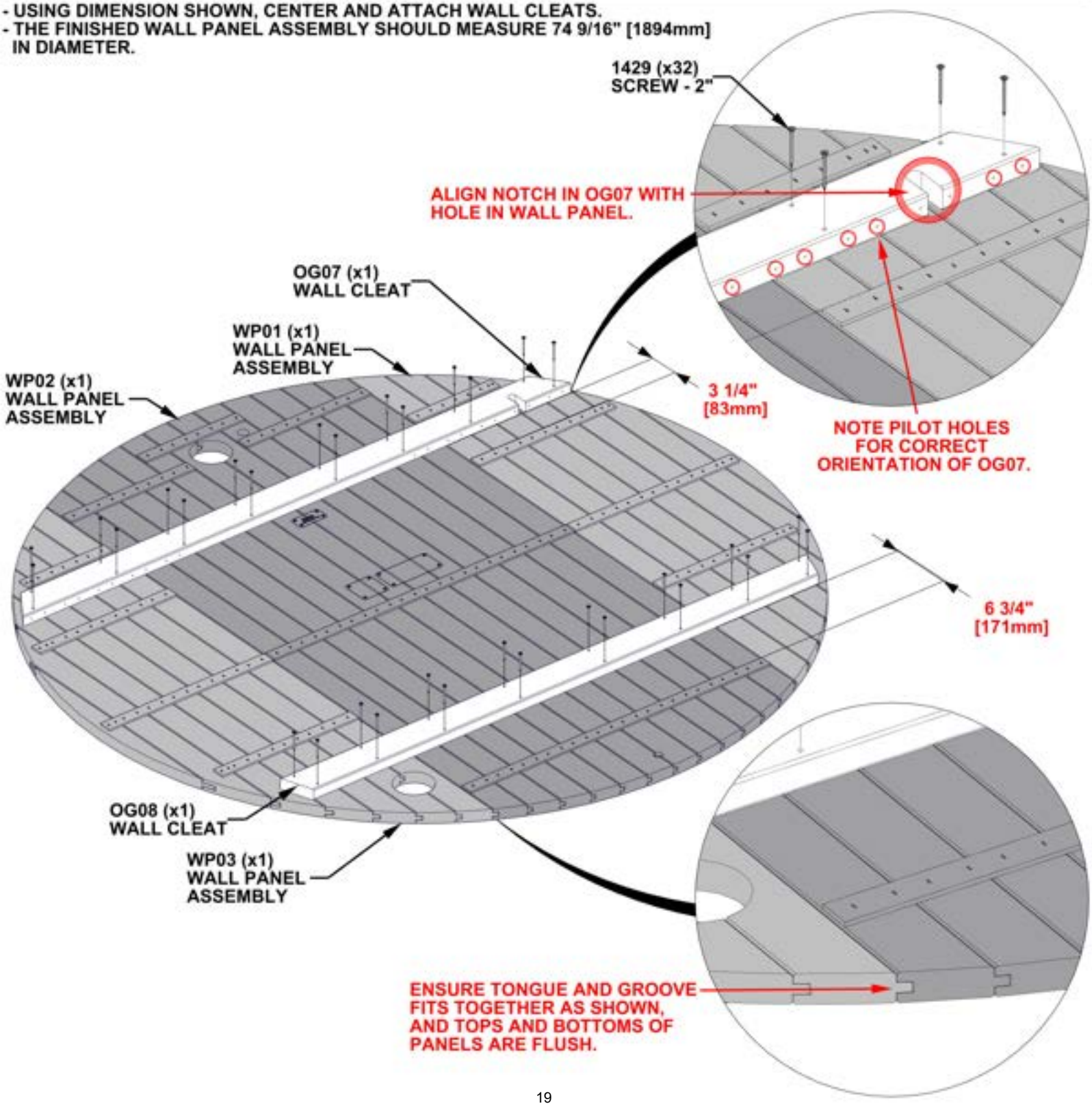
OG08 (x1) WALL CLEAT - W4L21868
1 3/16"x3 3/8"x61 7/16" (30x86x1560)



WP03 (x1) WALL PANEL ASSEMBLY - W2A05384
1 3/8"x20 1/8"x66 1/4" (35x512x1682)

OG07 (x1) WALL CLEAT - W4L21867
1 3/16"x3 3/8"x63 15/16" (30x86x1624)

- USING DIMENSION SHOWN, CENTER AND ATTACH WALL CLEATS.
- THE FINISHED WALL PANEL ASSEMBLY SHOULD MEASURE 74 9/16" [1894mm] IN DIAMETER.

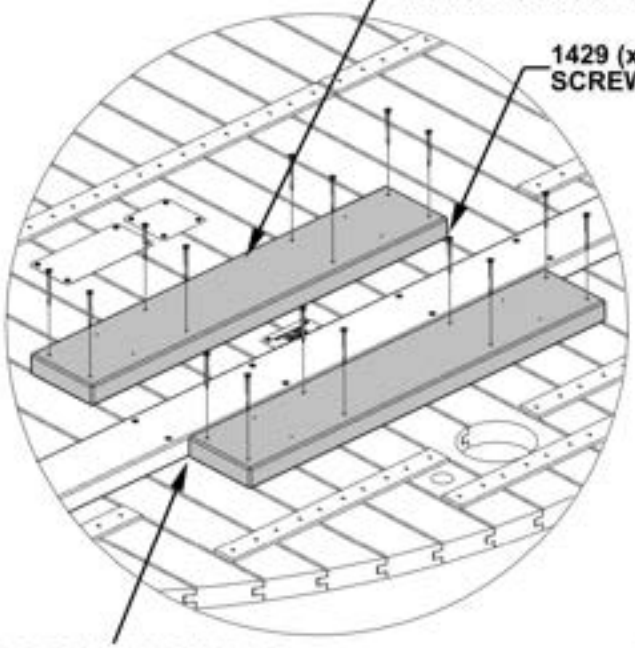


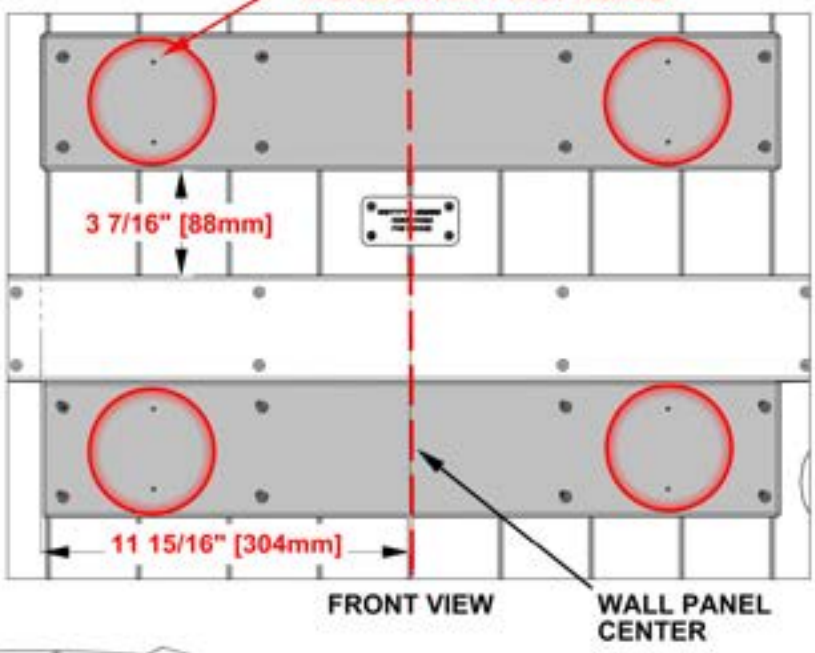
STEP 6 - BACK WALL ASSEMBLY

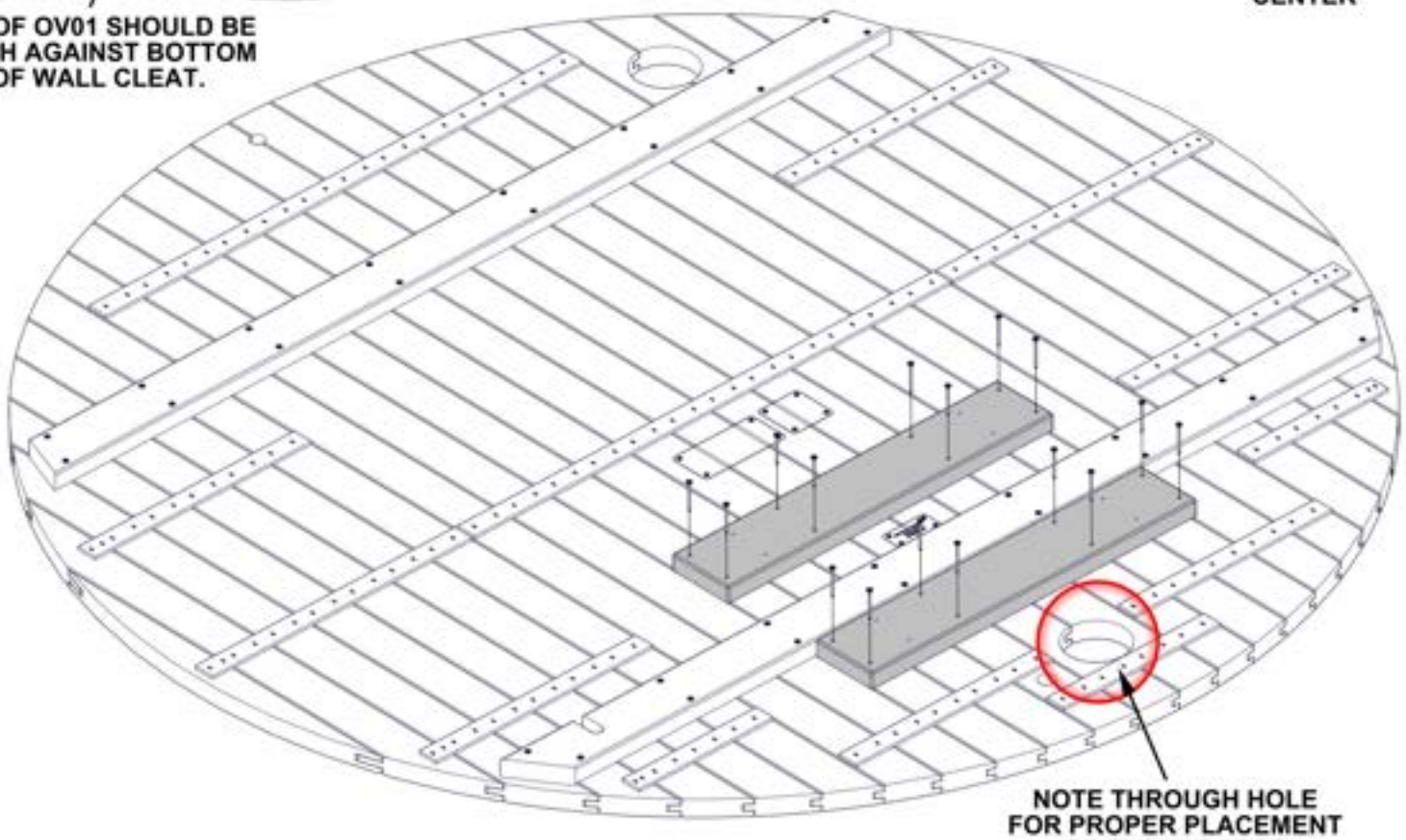
QTY	PART NUMBER	DESCRIPTION
16	H101429	SCREW TFH 8X2 SS-BLK



OV01 (x2) HEATER GUARD SPACER - W4L21887
1 3/16"x4 7/16"x23 15/16" (30x112x608)







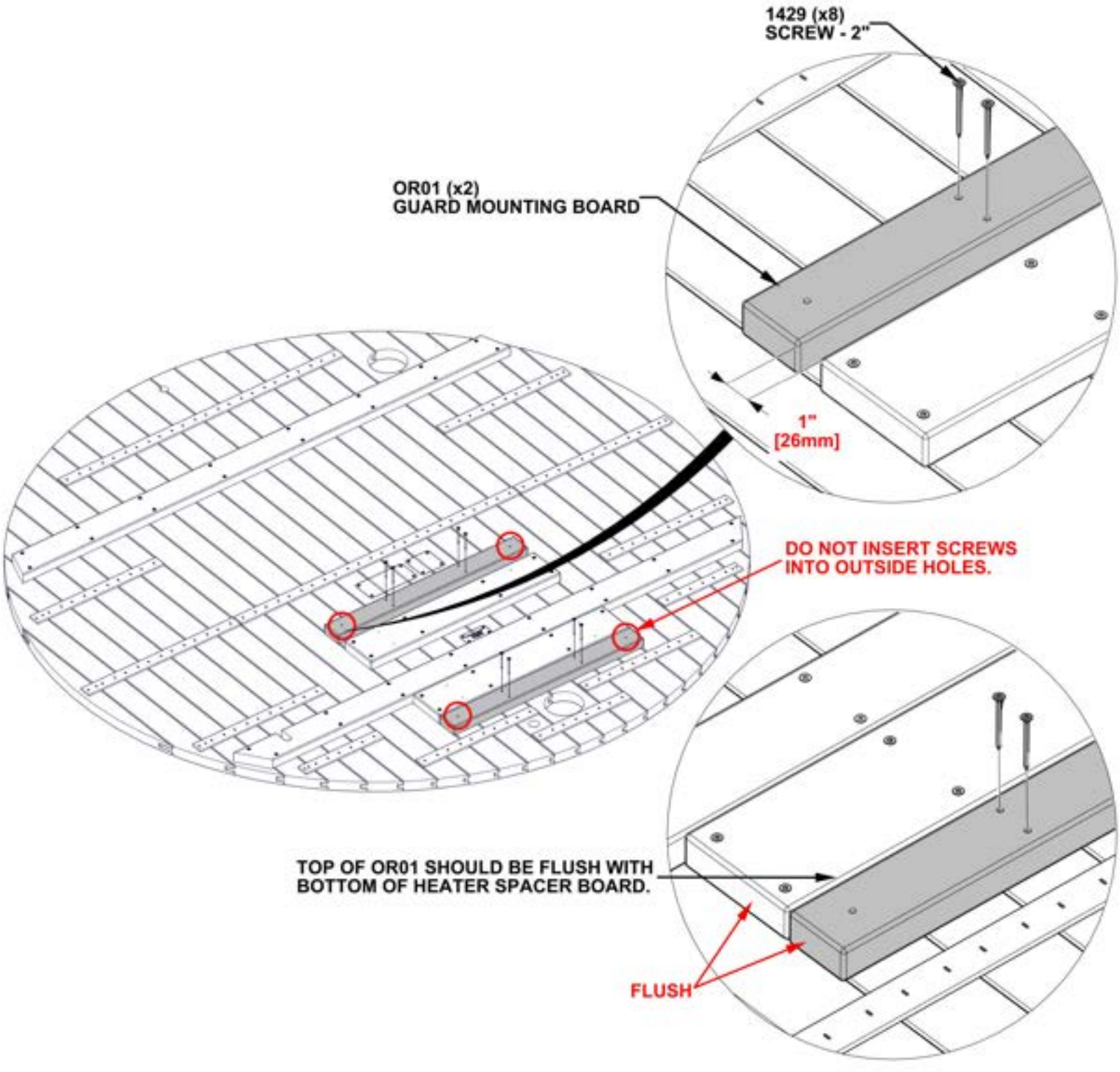
STEP 7 - BACK WALL ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
8	H101429	SCREW TFH 8X2 SS-BLK



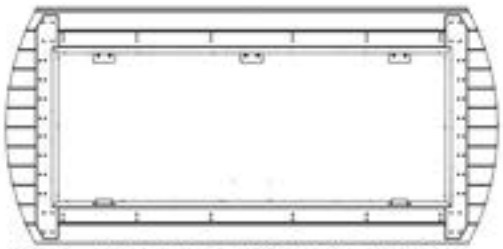
OR01 (x2) GUARD MOUNTING BOARD - W4L21873
1 3/16"x2 3/8"x23 15/16" (30x60x608)

- FLUSH ENDS OF OR01 MOUNTING BOARDS WITH ENDS OF HEATER SPACER BOARDS.
- HOLD TOP OR01 TO SHOWN DIMENSION.

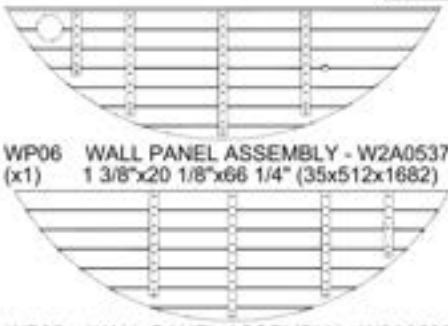


STEP 8 - FRONT WALL ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
24	H101429	SCREW TFH 8X2 SS-BLK

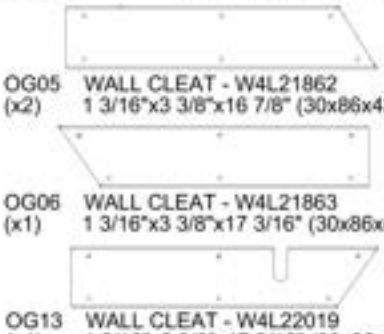


WP04 (x1) WALL PANEL ASSEMBLY - W2A04794
3 11/16"X35 5/8"X74 9/16" (78x906x1894)



WP06 (x1) WALL PANEL ASSEMBLY - W2A05378
1 3/8"x20 1/8"x66 1/4" (35x512x1682)

WP05 (x1) WALL PANEL ASSEMBLY - W2A05385
1 3/8"x19 11/16"x65 3/4" (35x500x1669)

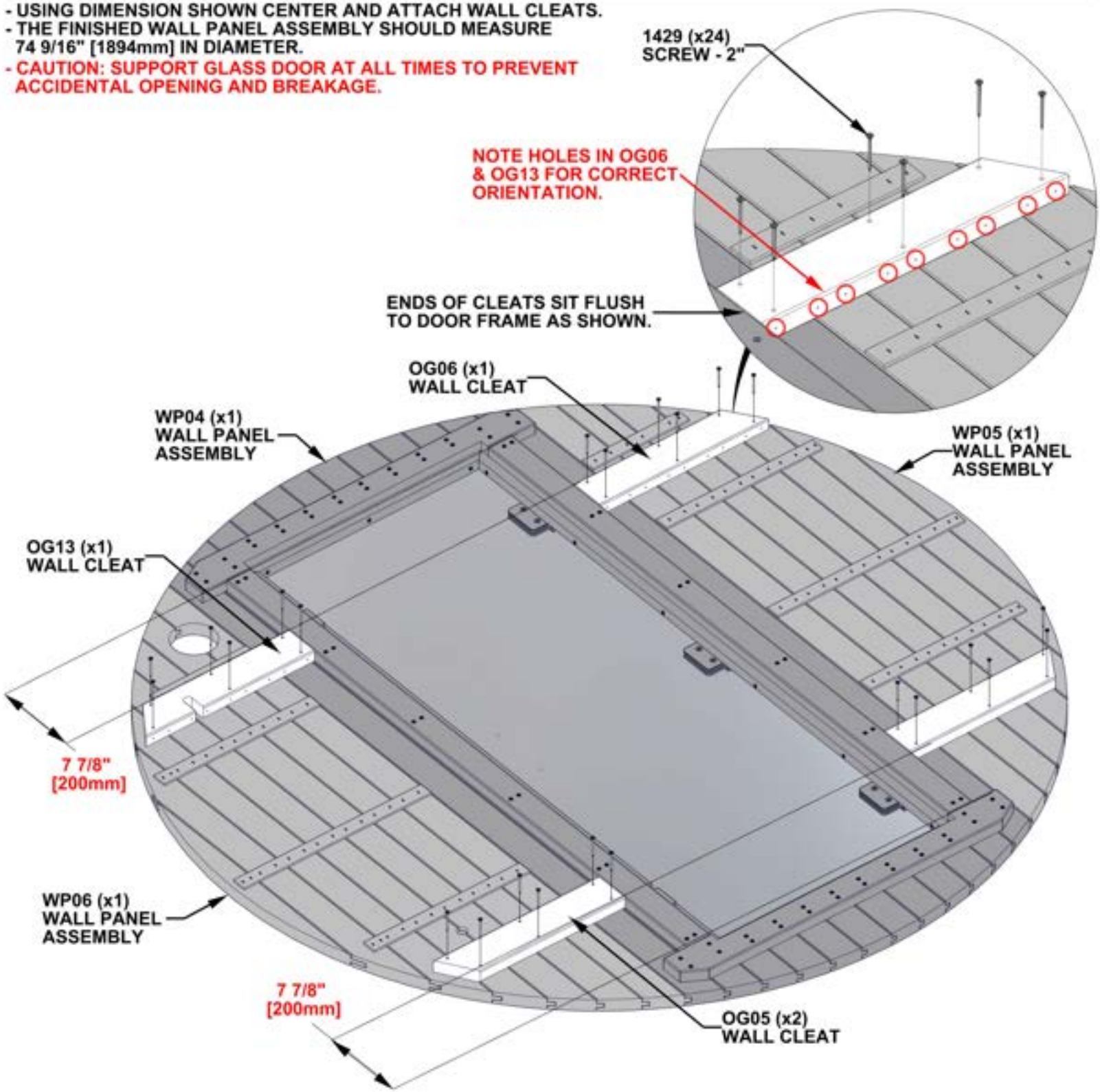


OG05 (x2) WALL CLEAT - W4L21862
1 3/16"x3 3/8"x16 7/8" (30x86x429)

OG06 (x1) WALL CLEAT - W4L21863
1 3/16"x3 3/8"x17 3/16" (30x86x437)

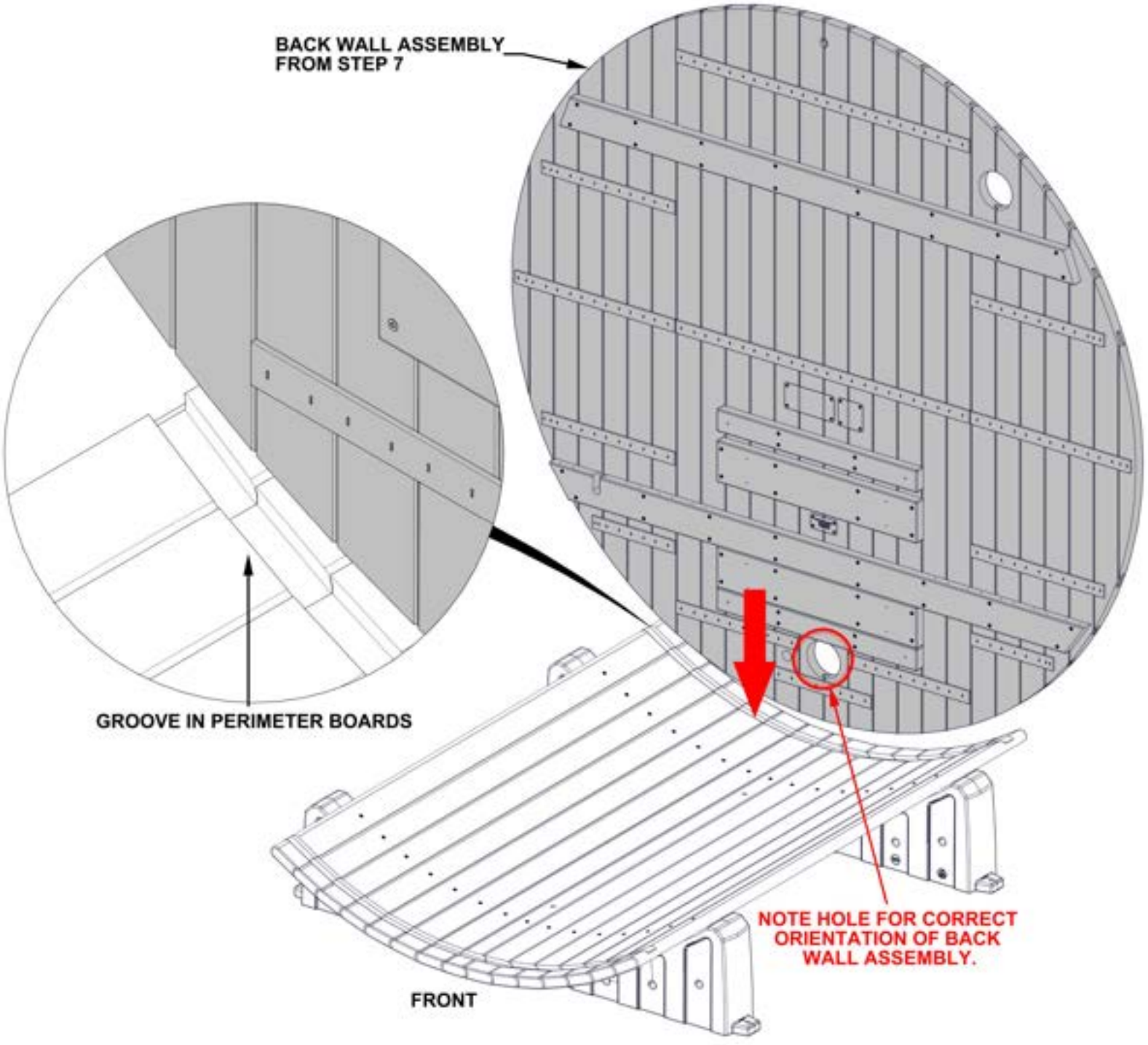
OG13 (x1) WALL CLEAT - W4L22019
1 3/16"x3 3/8"x17 3/16" (30x86x437)

- USING DIMENSION SHOWN CENTER AND ATTACH WALL CLEATS.
- THE FINISHED WALL PANEL ASSEMBLY SHOULD MEASURE 74 9/16" [1894mm] IN DIAMETER.
- CAUTION: SUPPORT GLASS DOOR AT ALL TIMES TO PREVENT ACCIDENTAL OPENING AND BREAKAGE.



STEP 9 - SAUNA ASSEMBLY

- CAREFULLY LOWER BACK WALL ASSEMBLY INTO THE GROOVES ON THE PERIMETER BOARD/BASE SUPPORT ASSEMBLED IN STEP 4.
- HAVE A SECOND PERSON HOLD THE BACK WALL TO KEEP IT STEADY DURING THE NEXT FEW STEPS.
- WHEN LIFTING THE WALL ASSEMBLY, LIFT BY THE TOP AND BOTTOM NOT THE SIDES.



STEP 10 - SAUNA ASSEMBLY



OG01 (x1) PERIMETER BOARD - W4L21857
1 3/16"x3 3/8"x64" (30x86x1626)

- CAREFULLY LOWER FRONT WALL ASSEMBLY INTO THE GROOVES ON THE PERIMETER BOARD/BASE SUPPORT ASSEMBLED IN STEP 4.
- POSITION THE PERIMETER BOARD ON THE TOP OF THE WALL ASSEMBLIES TO HOLD THE WALLS IN PLACE.
- WHEN LIFTING WALL ASSEMBLY, LIFT BY TOP AND BOTTOM NOT THE SIDES.
- CAUTION: SUPPORT GLASS DOOR AT ALL TIMES TO PREVENT ACCIDENTAL OPENING AND BREAKAGE.

OG01 (x1)
PERIMETER BOARD

ENSURE ALL WALL CLEATS ARE HORIZONTAL AND LEVEL BEFORE ATTACHING PERIMETER BOARD.

FRONT WALL ASSEMBLY FROM STEP 8

NOTE HOLE FOR CORRECT ORIENTATION OF FRONT WALL ASSEMBLY.

STEP 11 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
14	H101428	SCREW TFH 8X1 3/4 SS-BLK

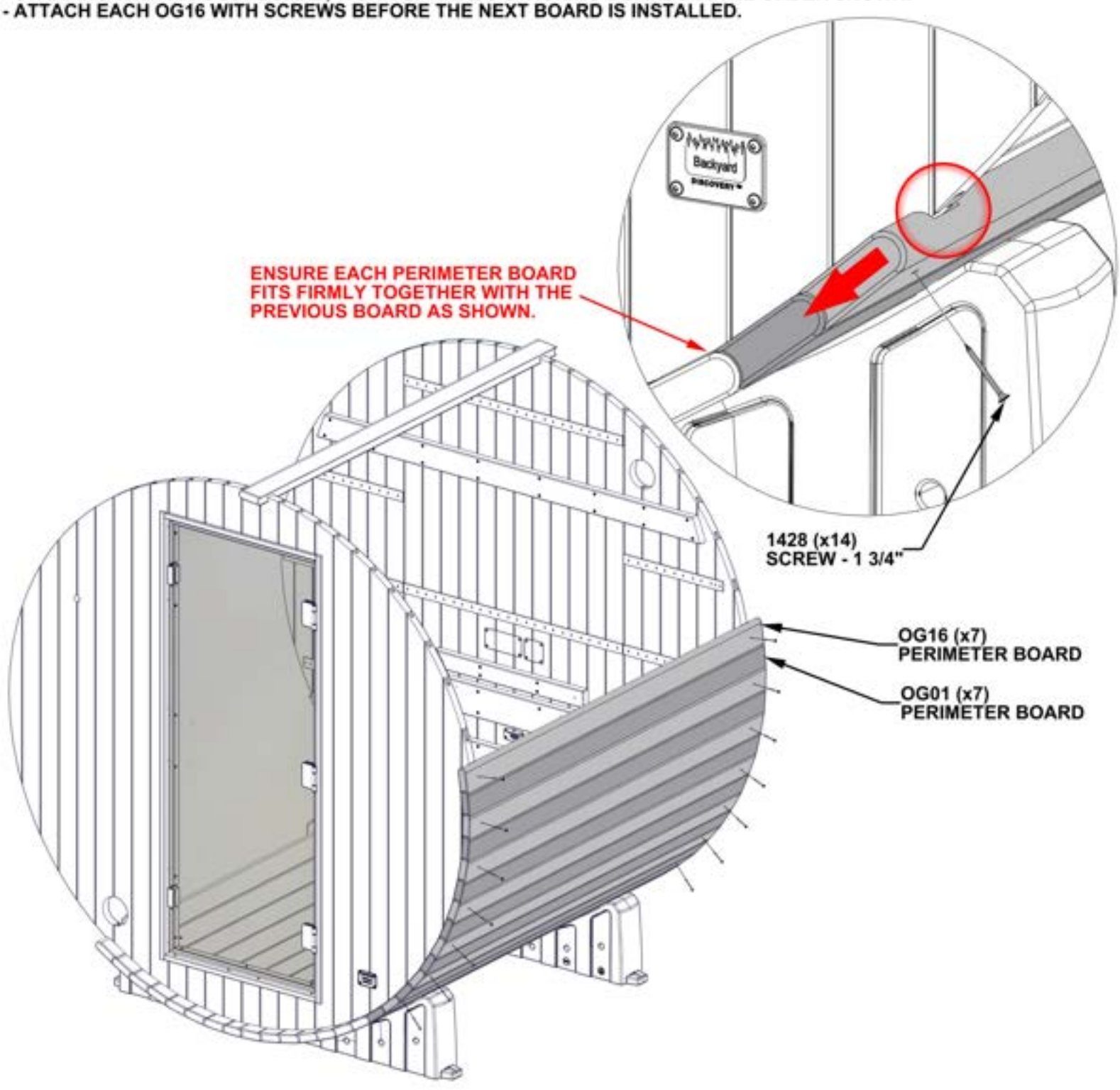


OG01 (x7) PERIMETER BOARD - W4L21857
1 3/16"x3 3/8"x64" (30x86x1626)



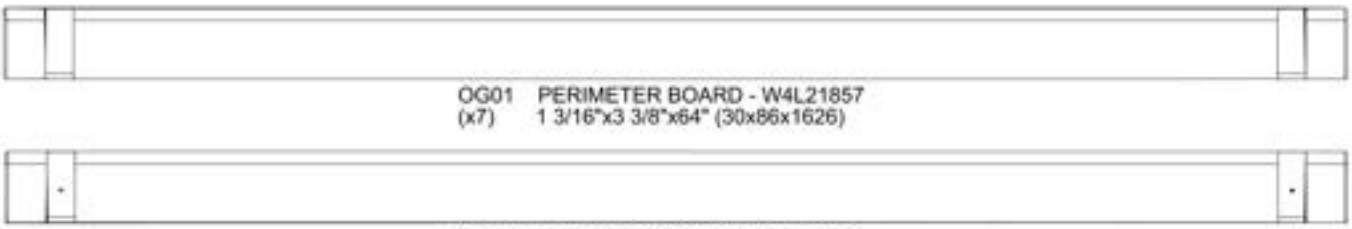
OG16 (x7) PERIMETER BOARD - W4L23556
1 3/16"x3 3/8"x64" (30x86x1626)

- ALIGN GROOVE IN PERIMETER BOARDS WITH BOTH FRONT WALL AND BACK WALL ASSEMBLIES.
- STARTING WITH AN OG01 BOARD, WORK UPWARDS STACKING BOARDS IN THE ORDER SHOWN.
- ATTACH EACH OG16 WITH SCREWS BEFORE THE NEXT BOARD IS INSTALLED.



STEP 12 - SAUNA ASSEMBLY

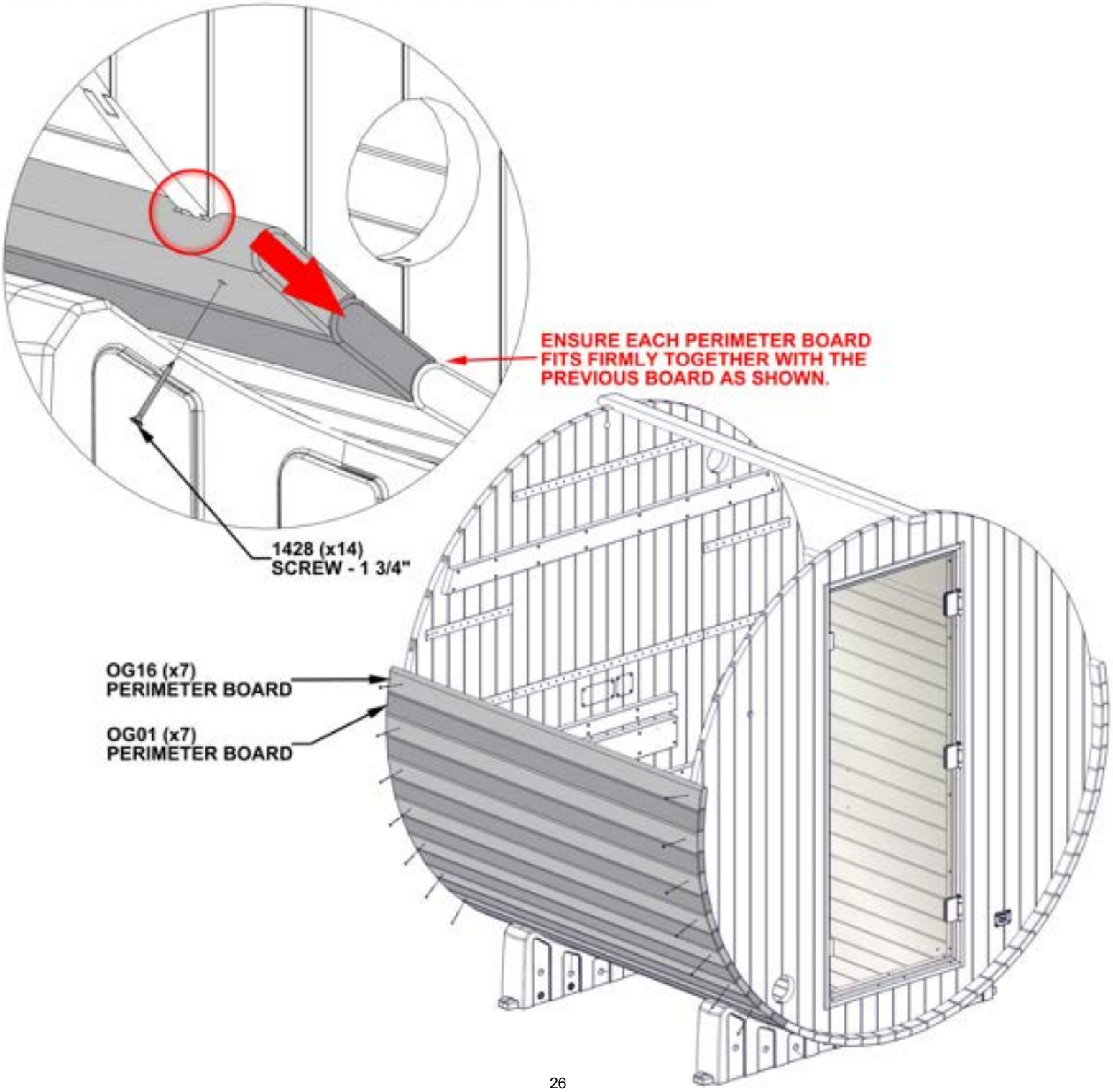
QTY	PART NUMBER	DESCRIPTION
14	H101428	SCREW TFH 8X1 3/4 SS-BLK



OG01 (x7) PERIMETER BOARD - W4L21857
1 3/16"x3 3/8"x64" (30x86x1626)

OG16 (x7) PERIMETER BOARD - W4L23556
1 3/16"x3 3/8"x64" (30x86x1626)

- ALIGN GROOVE IN PERIMETER BOARDS WITH BOTH FRONT WALL AND BACK WALL ASSEMBLIES.
- STARTING WITH AN OG01 BOARD, WORK UPWARDS STACKING BOARDS IN THE ORDER SHOWN.
- ATTACH EACH OG16 WITH SCREWS BEFORE THE NEXT BOARD IS INSTALLED.



STEP 13 - HANDLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
2	H101402	SCREW TFH 1/4-20 X 1 5/8 SS
4	H101403	POLY WASHER

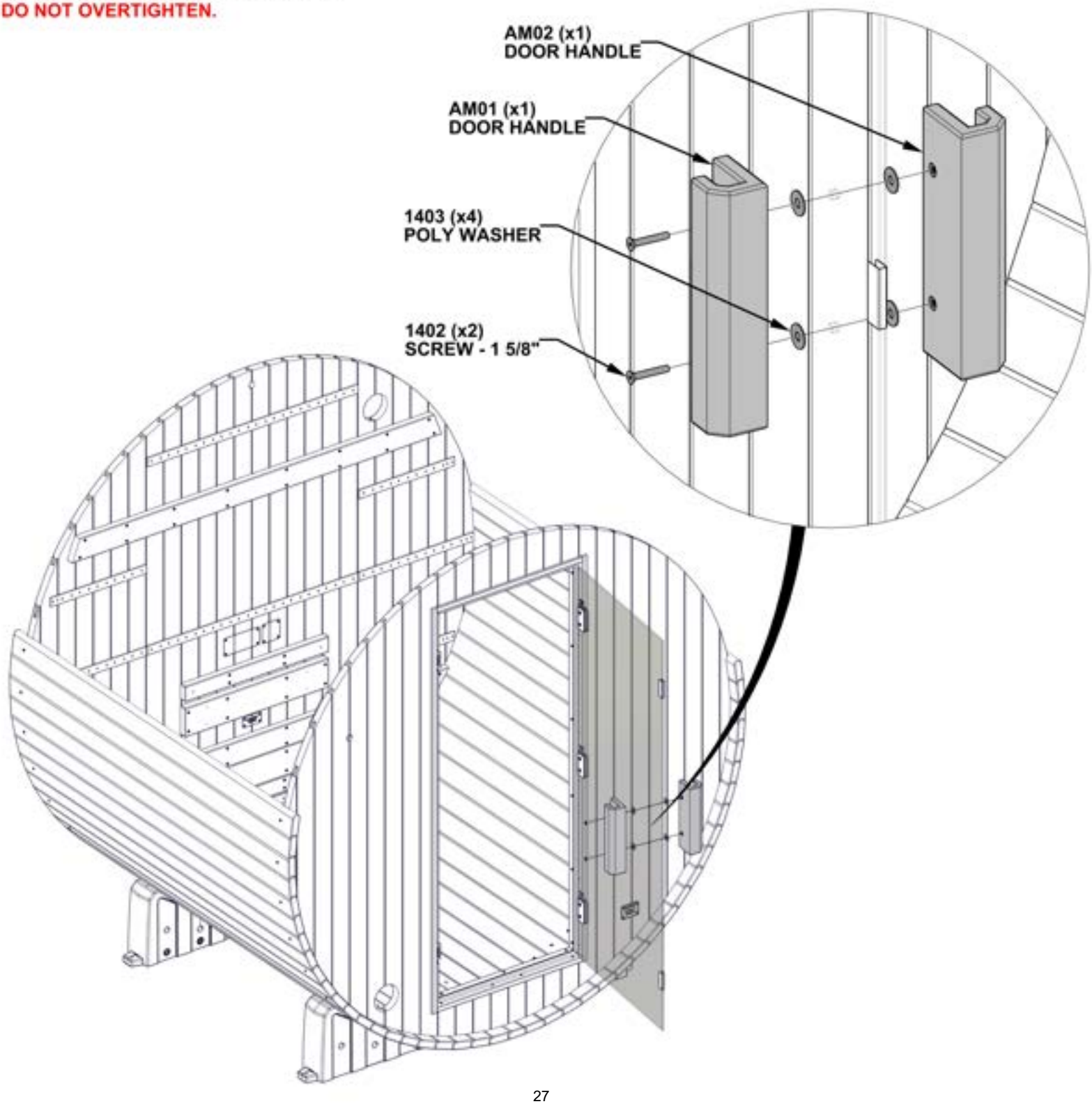


AM01 (x1) DOOR HANDLE - W4L21861
2 1/4"x3"x10 3/16" (57x76x258)



AM02 (x1) DOOR HANDLE - W2A04795
2 1/4"x3"x10 3/16" (57x76x258)

- ATTACH DOOR HANDLES AS SHOWN.
- DO NOT OVERTIGHTEN.



STEP 14 - BENCH ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
6	H101429	SCREW TFH 8X2 SS-BLK
2	H101431	SCREW TFH 8X2 1/2 SS-BLK
2	H101443	SCREW TWH 8x1 1/2 SS-BLK

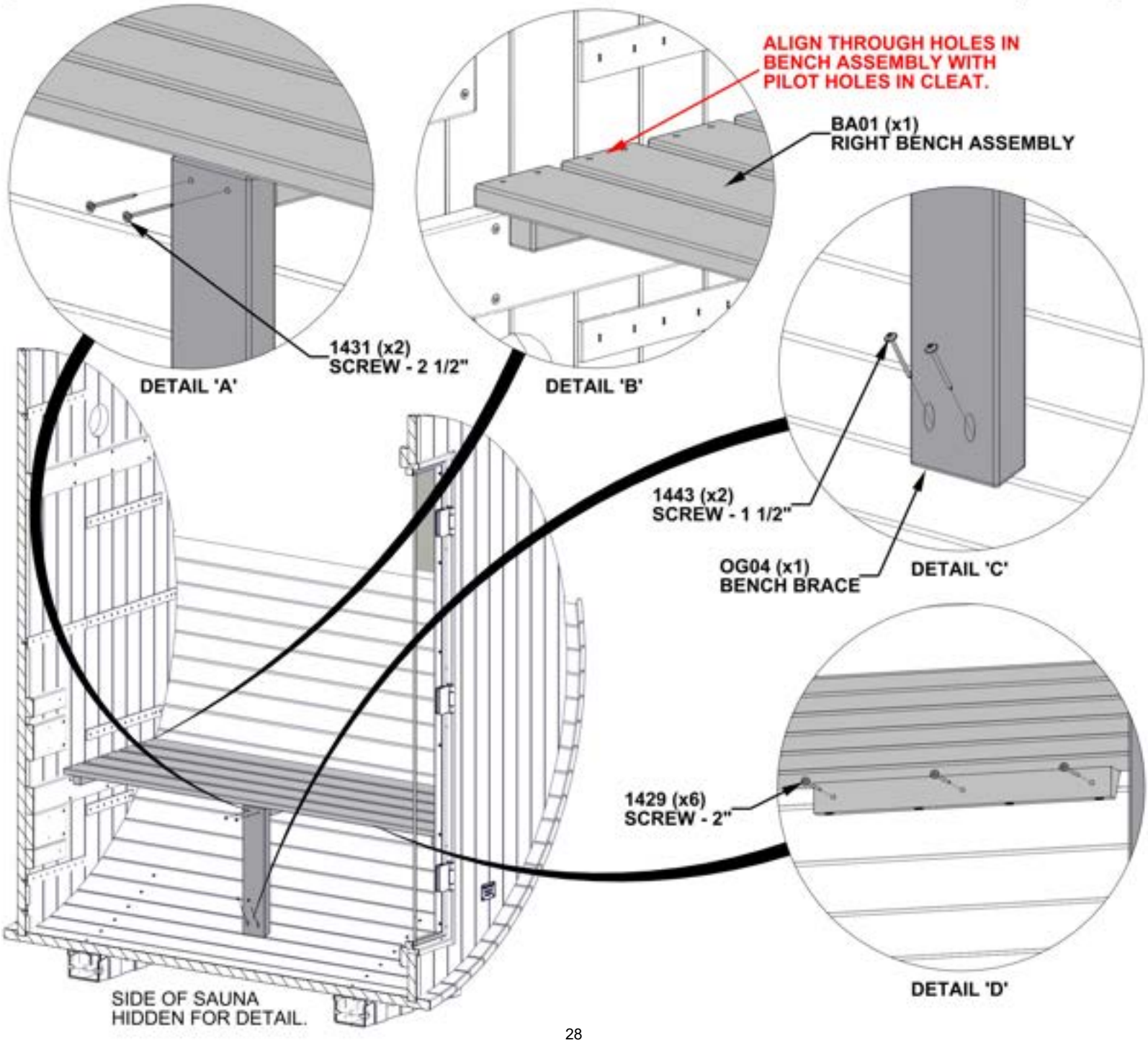


BA01 (x1) RIGHT BENCH ASSEMBLY - W2A04788
1 15/16"x19 1/8"x57 5/16" (50x486x1456)



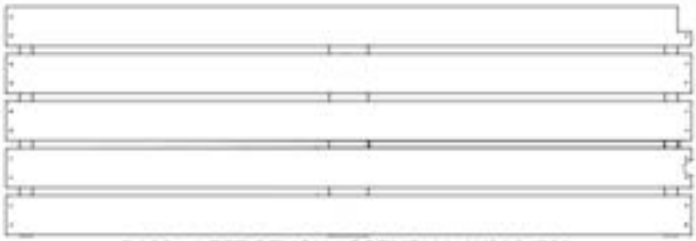
OG04 (x1) BENCH BRACE - W4L21860
1 3/16"x3 3/8"x16 3/8" (30x86x416)

1) INSTALL BENCH BRACE OG04 TO BENCH ASSEMBLY. (DETAIL 'A')
2) PUSH THE BENCH WITH BENCH BRACE BOARD AGAINST THE WALL UNTIL IT MAKES CONTACT WITH THE SIDEWALL.
3) CHECK THE ALIGNMENT OF THE HOLES ON EACH END OF THE BENCH WITH THE PILOT HOLES ON THE CLEATS MOUNTED TO THE WALL. (DETAIL 'B')
4) ENSURE BENCH BRACE IS SQUARE WITH BENCH AND INSTALL (2) 1443 SCREWS. (DETAIL 'C')
5) LEVEL THE BENCH BOTH FRONT-TO-BACK AND SIDE-TO-SIDE; THEN ATTACH TO SIDEWALL AS SHOWN. (DETAIL 'D')



STEP 15 - BENCH ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
6	H101429	SCREW TFH 8X2 SS-BLK
2	H101431	SCREW TFH 8X2 1/2 SS-BLK
2	H101443	SCREW TWH 8x1 1/2 SS-BLK

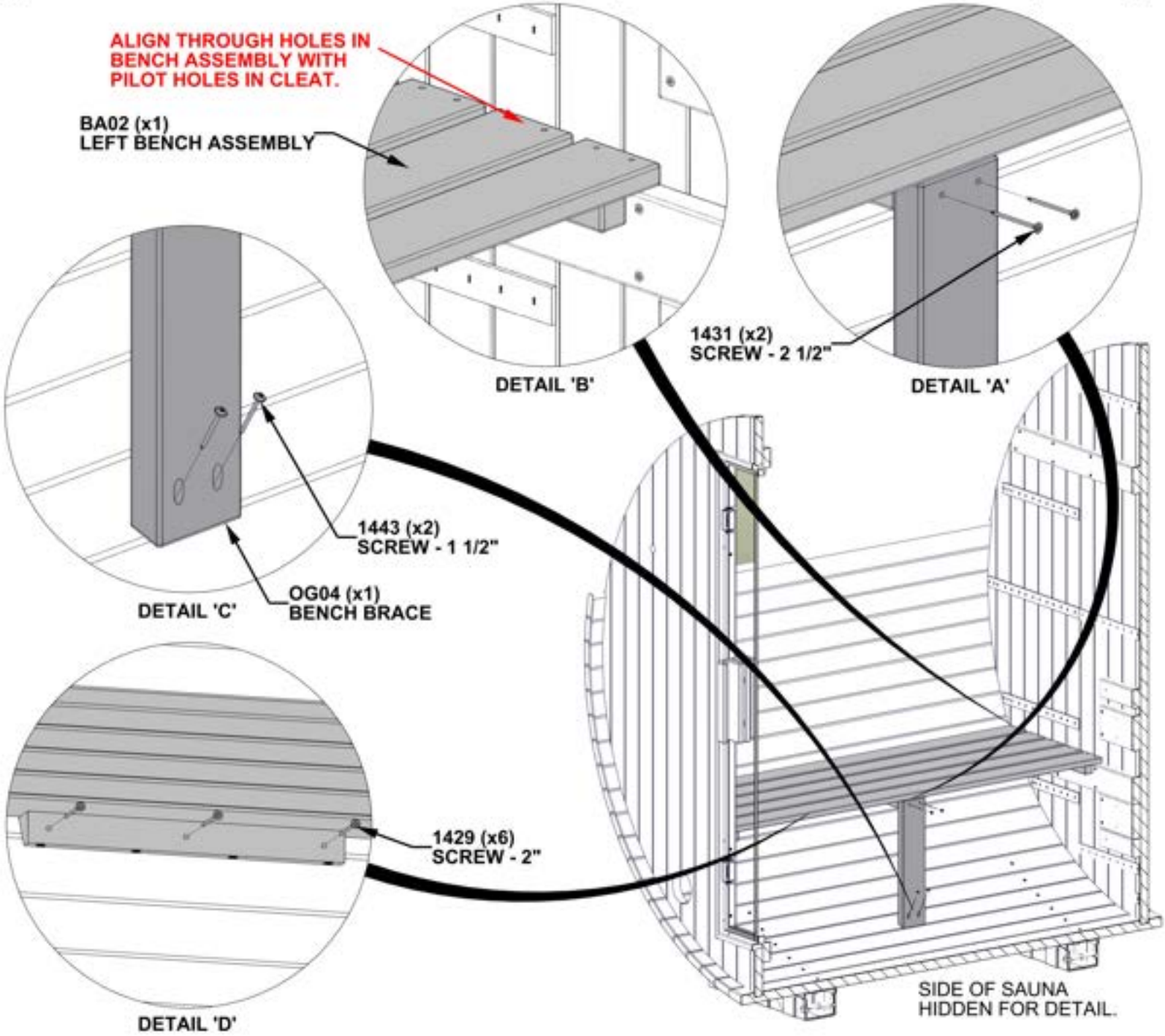


BA02 (x1) LEFT BENCH ASSEMBLY - W2A04789
19 1/8"57 5/16" (50x486x1456)



OG04 (x1) BENCH BRACE - W4L21860
1 3/16"x3 3/8"x16 3/8" (30x86x416)

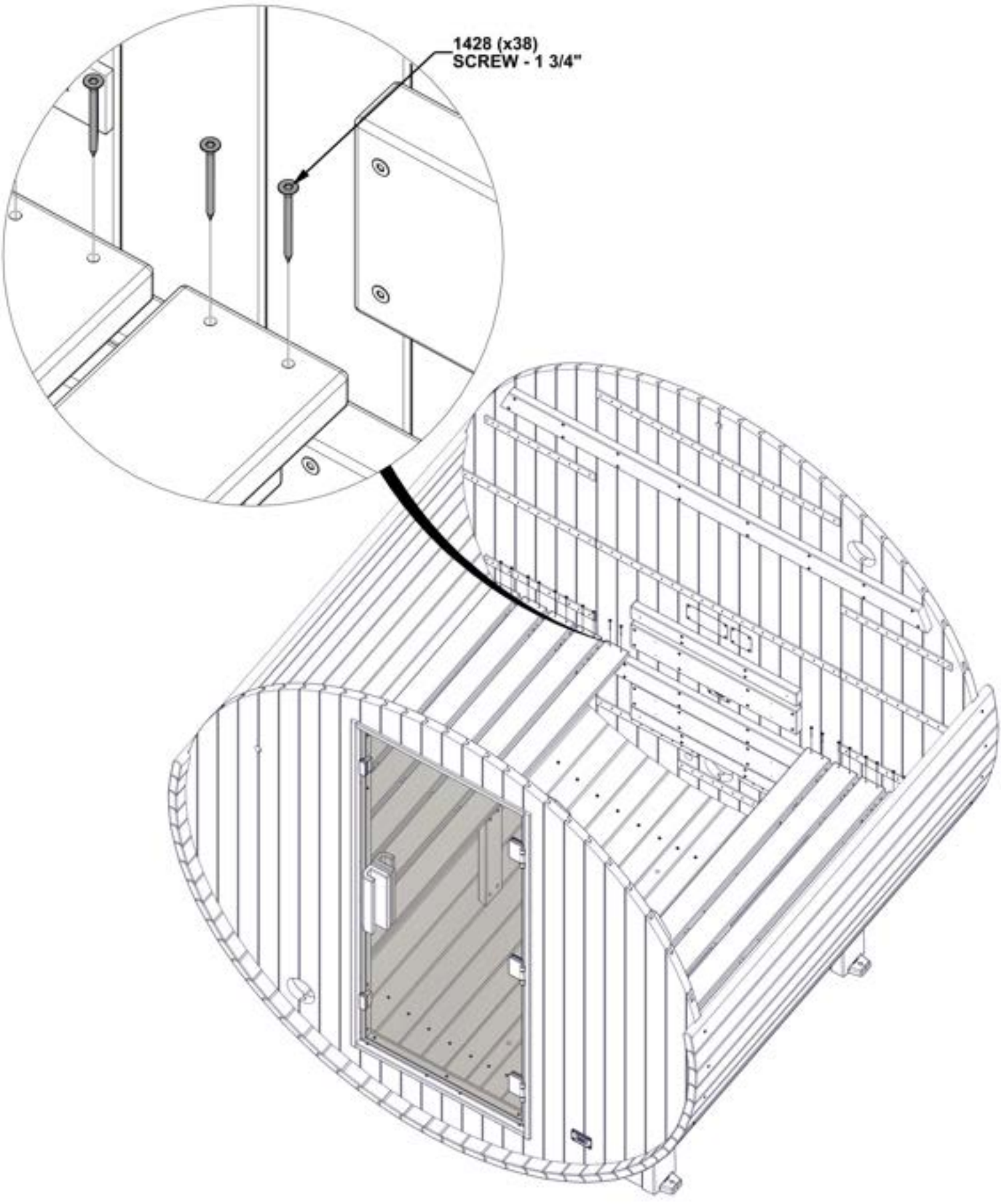
1) INSTALL BENCH BRACE OG04 TO BENCH ASSEMBLY. (DETAIL 'A')
2) PUSH THE BENCH WITH BENCH BRACE BOARD AGAINST THE WALL UNTIL IT MAKES CONTACT WITH THE SIDEWALL.
3) CHECK THE ALIGNMENT OF THE HOLES ON EACH END OF THE BENCH WITH THE PILOT HOLES ON THE CLEATS MOUNTED TO THE WALL. (DETAIL 'B')
4) ENSURE BENCH BRACE IS SQUARE WITH BENCH AND INSTALL (2) 1443 SCREWS. (DETAIL 'C')
5) LEVEL THE BENCH BOTH FRONT-TO-BACK AND SIDE-TO-SIDE; THEN ATTACH TO SIDEWALL AS SHOWN. (DETAIL 'D')



STEP 16 - BENCH ASSEMBLY

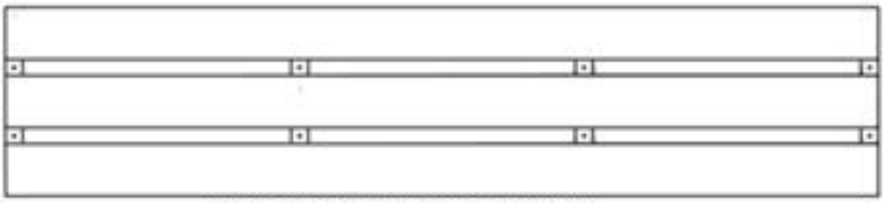
QTY	PART NUMBER	DESCRIPTION
38	H101428	SCREW TFH 8X1 3/4 SS-BLK

- ATTACH BENCHES TO CLEATS ON BOTH FRONT AND BACK WALLS AS SHOWN.



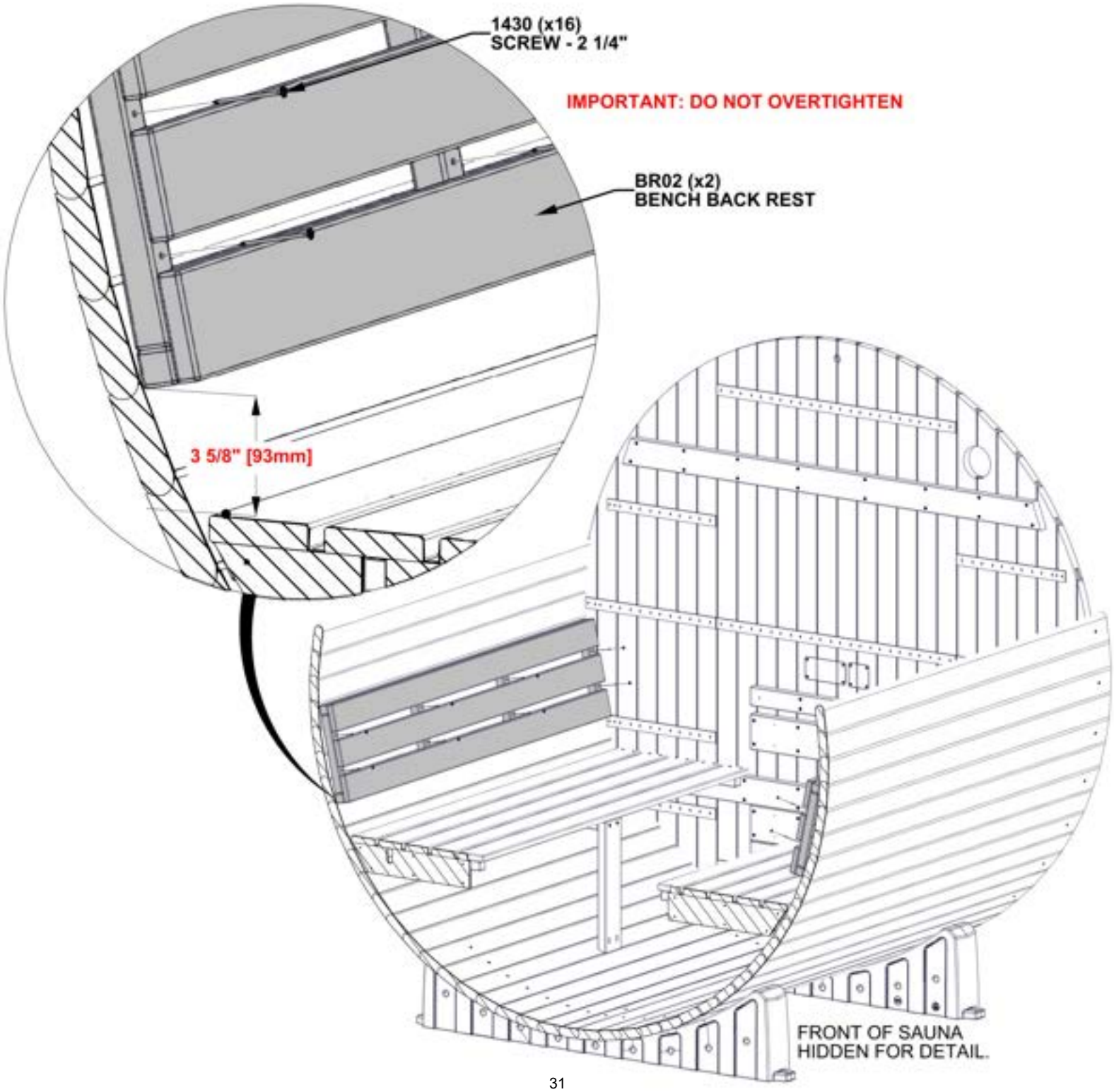
STEP 17 - BENCH ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
16	H101430	SCREW TFH 8X2 1/4 SS-BLK



BR02 (x2) BENCH BACK REST - W2A04791
1 15/16"x12 1/16"x55 7/16" (50x306x1408)

- CENTER BACK REST AND ATTACH AS SHOWN.
- USE DIMENSIONS SHOWN AS A GENERAL GUIDE AND ADJUST TO YOUR OWN PREFERENCE.



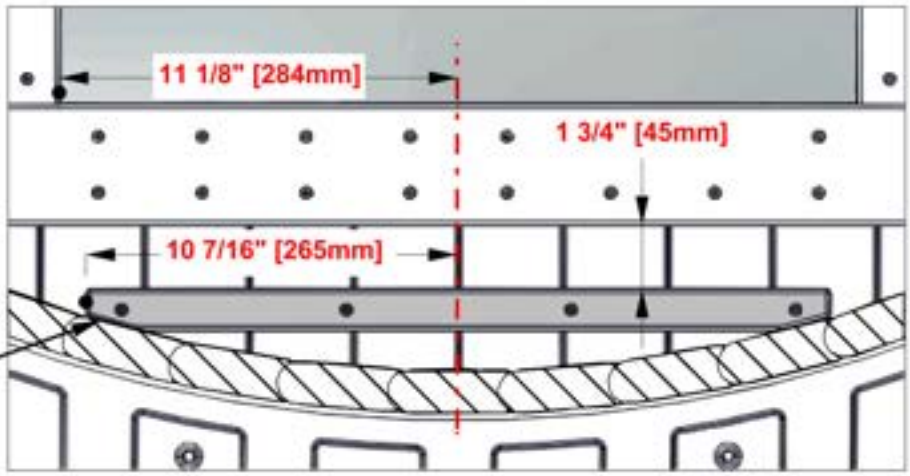
STEP 18 - FLOOR CLEAT INSTALLATION

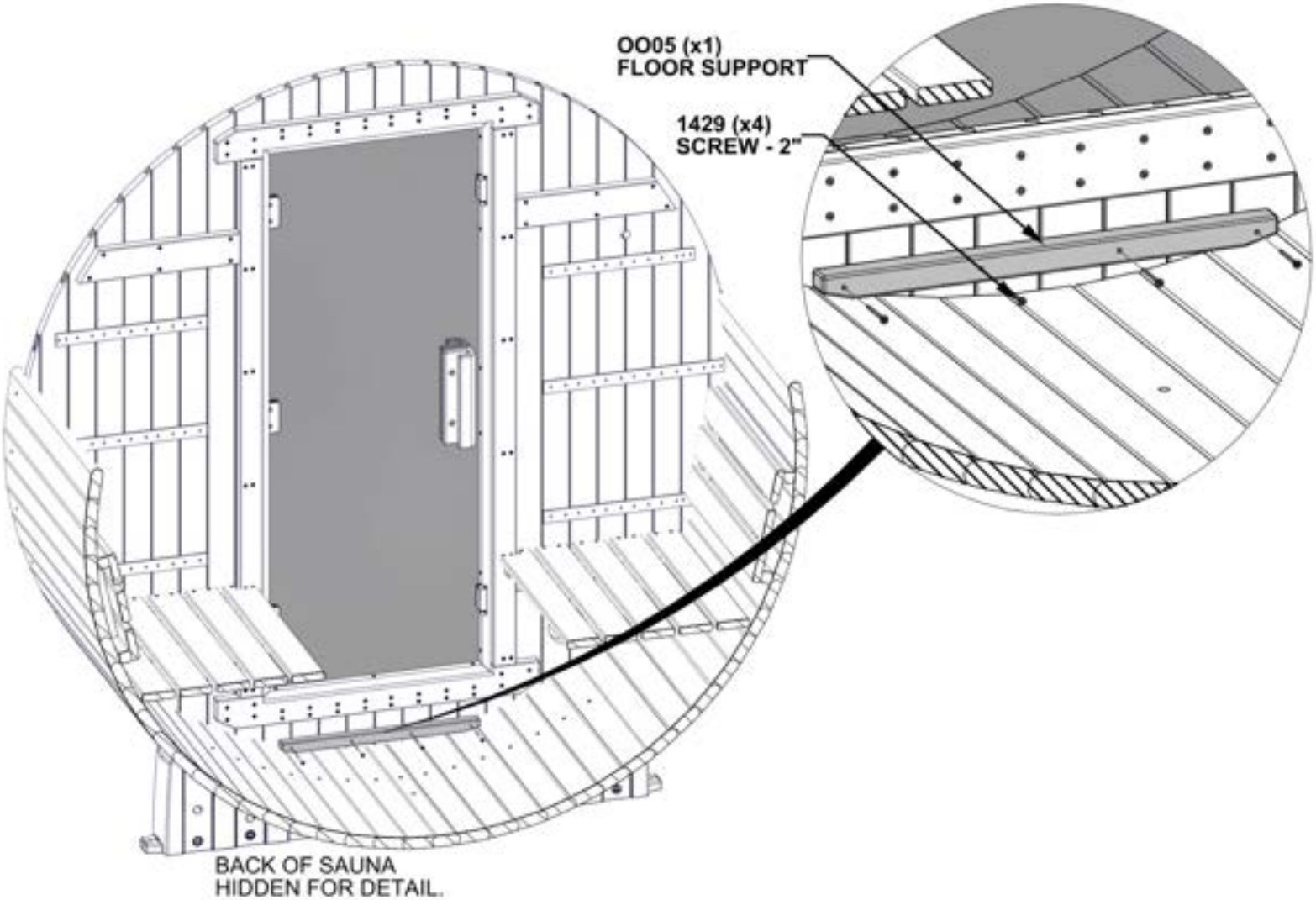
QTY	PART NUMBER	DESCRIPTION
4	H101429	SCREW TFH 8X2 SS-BLK



OO05 (x1) FLOOR SUPPORT - W4L21963
1 3/16"x1 3/16"x20 7/8" (30x30x530)

- CENTER FLOOR SUPPORT BOARD IN SAUNA.
- USE THE DIMENSION SHOWN FROM THE DOOR OPENING TO MARK THE CENTER OF THE OO05 BOARD.
- MAKE SURE THE BOARD IS LEVEL AND ATTACH AS SHOWN.





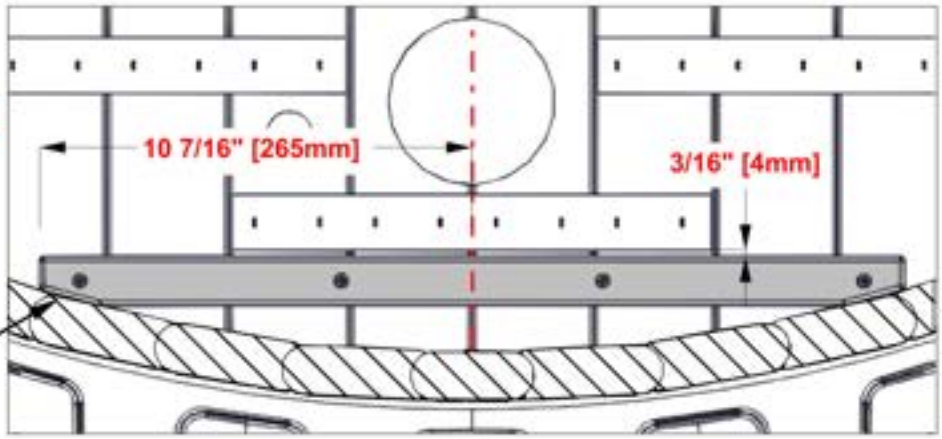
STEP 19 - FLOOR CLEAT INSTALLATION

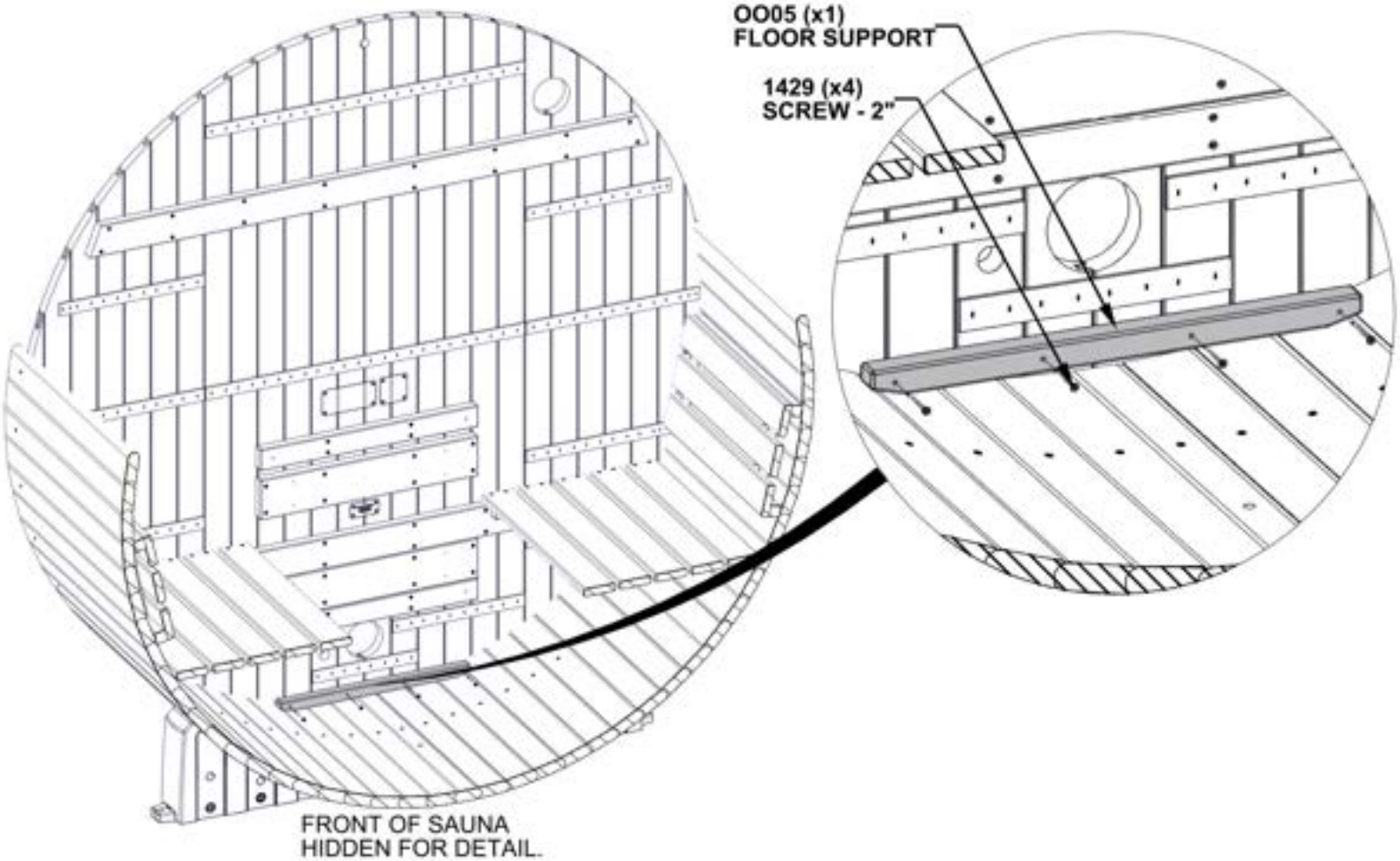
QTY	PART NUMBER	DESCRIPTION
4	H101429	SCREW TFH 8X2 SS-BLK



OO05 (x1) FLOOR SUPPORT - W4L21963
1 3/16"x1 3/16"x20 7/8" (30x30x530)

- CENTER FLOOR SUPPORT BOARD IN SAUNA.
- USE THE DIMENSION SHOWN FROM THE DOOR OPENING TO MARK THE CENTER OF THE OO05 BOARD.
- MAKE SURE THE BOARD IS LEVEL AND ATTACH AS SHOWN.





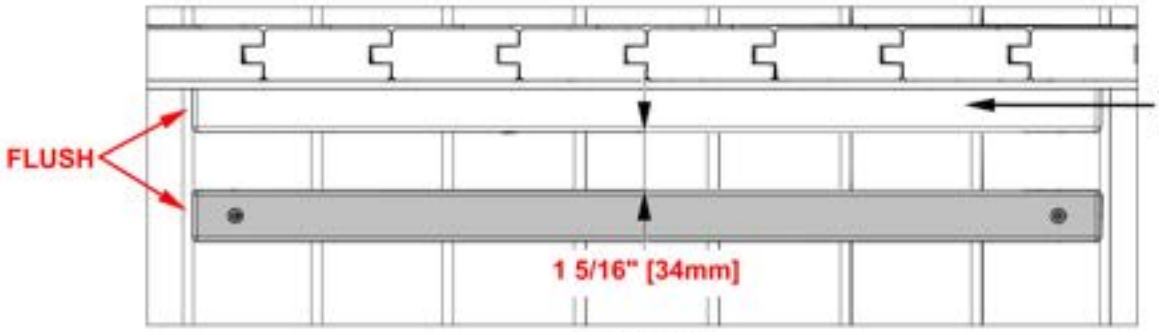
STEP 20 - FLOOR CLEAT INSTALLATION

QTY	PART NUMBER	DESCRIPTION
2	H101429	SCREW TFH 8X2 SS-BLK

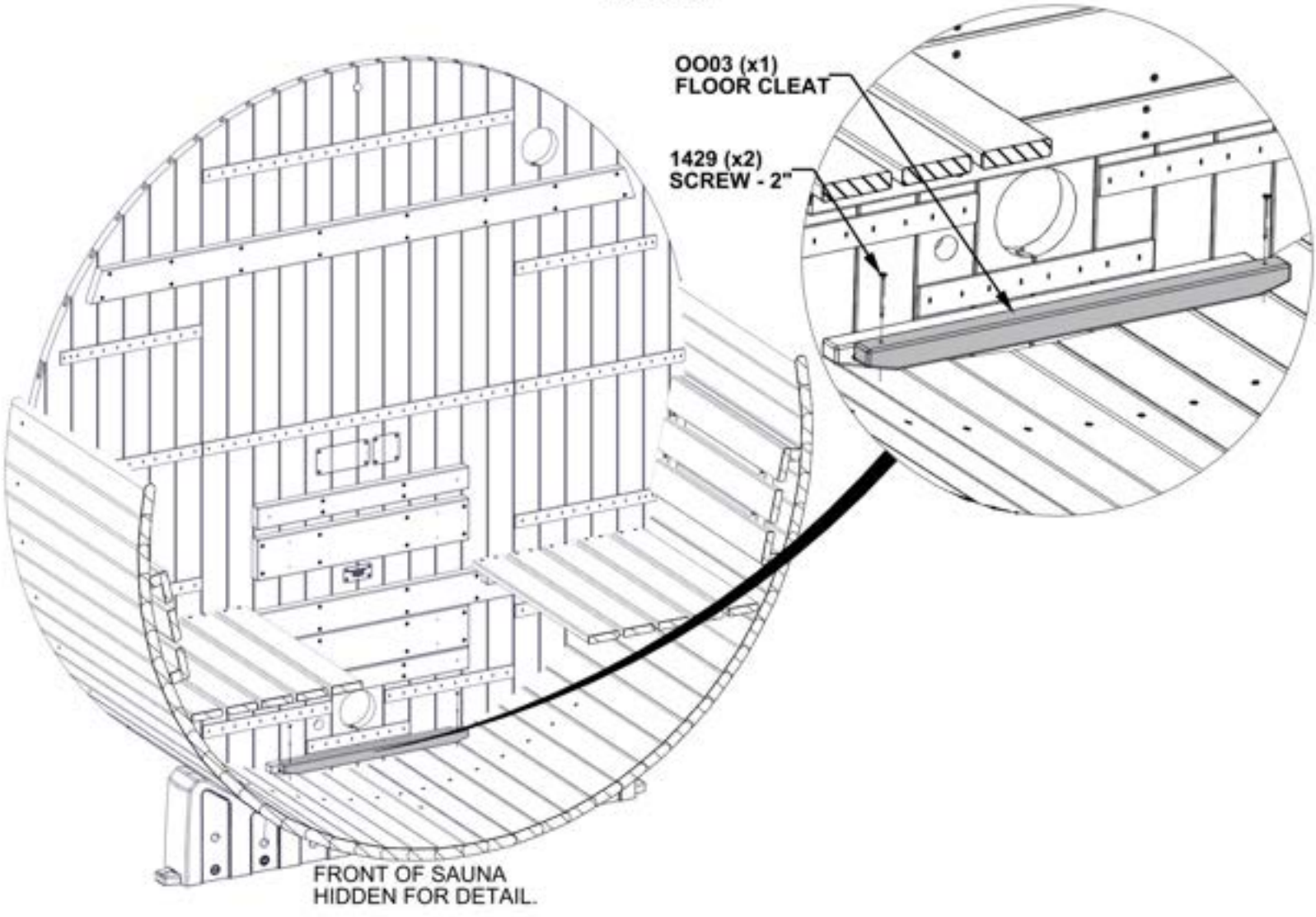


OO03 FLOOR CLEAT - W4L21964
(x1) 1 3/16"x1 3/16"x20 7/8" (30x30x530)

- LOCATE OO03 BOARD USING DIMENSION SHOWN.
- ENDS ARE TO BE FLUSH WITH PREVIOUSLY INSTALLED CLEAT.



TOP VIEW

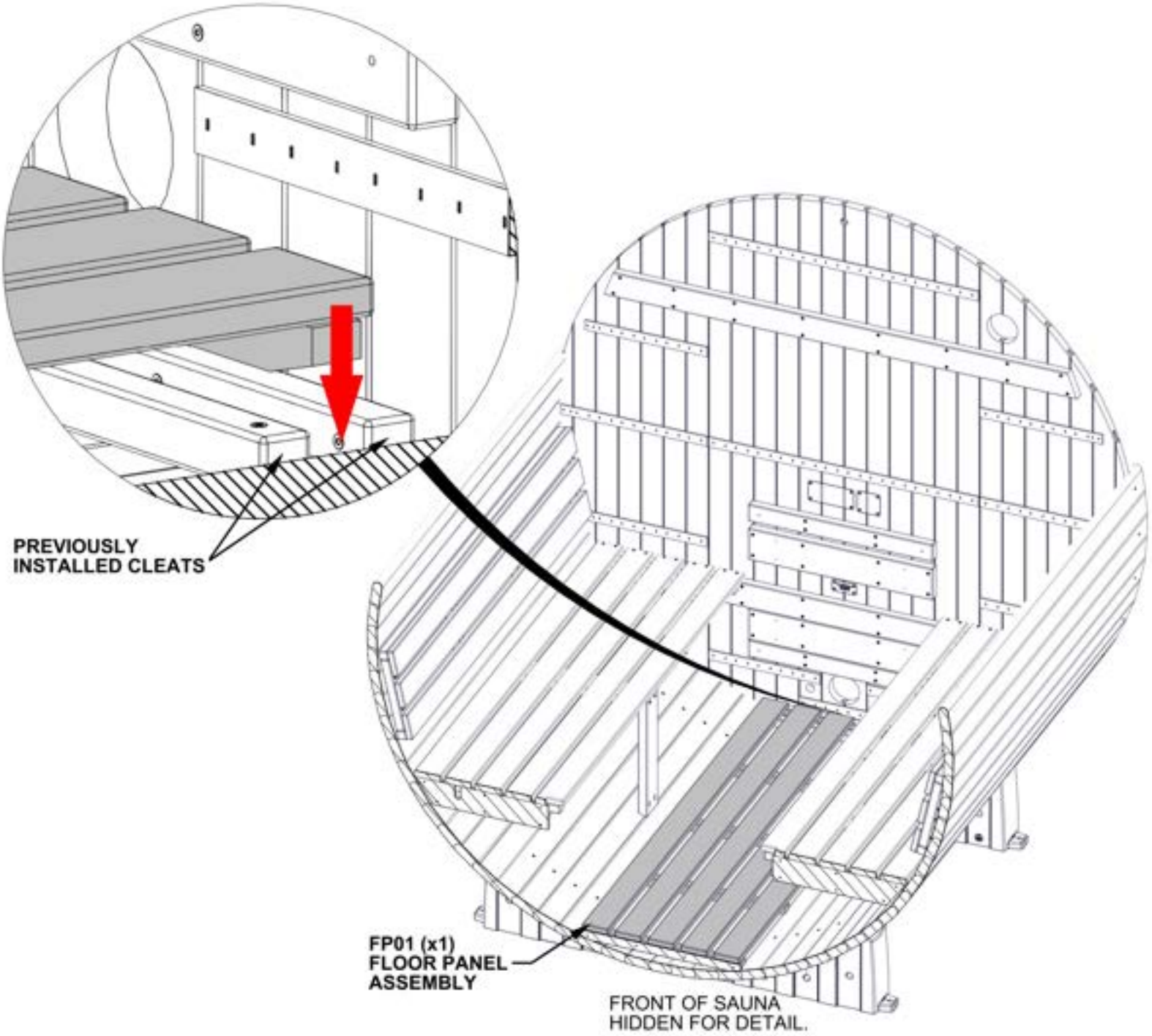


STEP 21 - FLOOR INSTALLATION



FP01 FLOOR PANEL ASSEMBLY - W2A04796
(x1) 1 15/16"x20 11/16"x55 7/8" (50x525x1420)

- SLIDE FLOOR PANEL ASSEMBLY AND CENTER IN SAUNA.
- FLOOR PANEL SHOULD SEAT BETWEEN TWO PREVIOUSLY INSTALLED CLEATS.
- FLOOR PANEL WILL NOT BE FASTENED DOWN. IT'S DESIGNED TO BE REMOVABLE TO ALLOW FOR CLEANING UNDERNEATH THE FLOOR PANEL.



STEP 22 - CONTROL PANEL ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
2	H100627	SCREW PFH 6x3/4 BLK

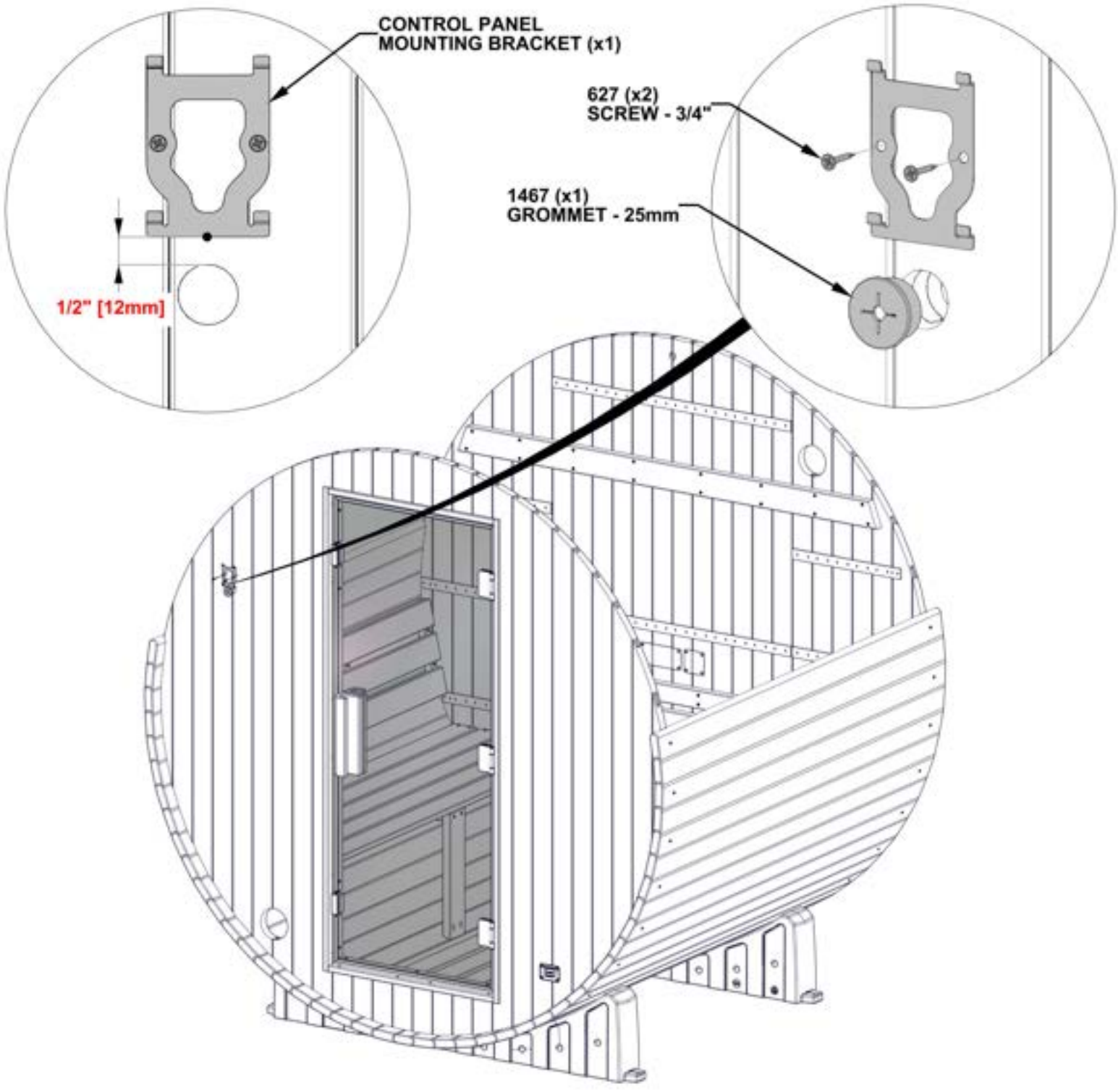


A4M05590-03 (x1) CONTROL PANEL MOUNTING BRACKET



A6P01467 (x1) SILICONE GROMMET 25mm

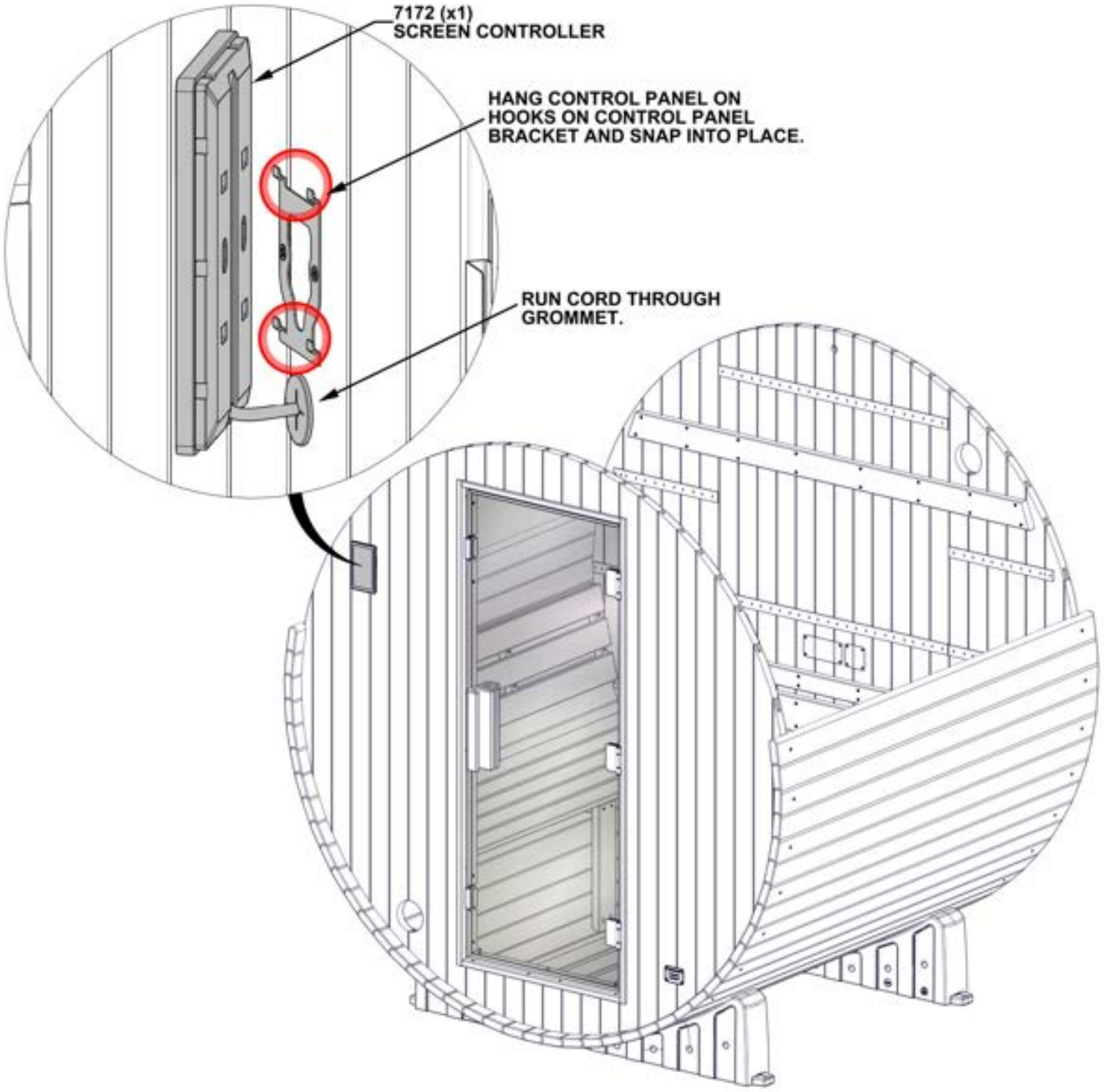
- CENTER MOUNTING BRACKET SLIGHTLY OVER CUTOUT IN WALL PANEL AND ATTACH AS SHOWN.
- INSERT GROMMET.



STEP 23 - CONTROL PANEL ASSEMBLY



A4M07172 (x1) SCREEN CONTROLLER

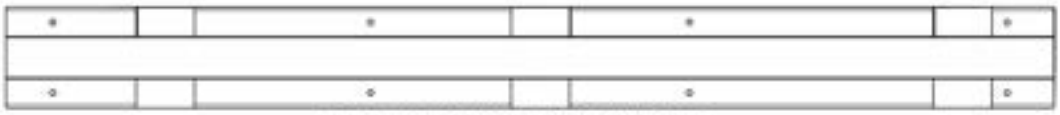


STEP 24 - WIREWAY ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
8	H101429	SCREW TFH 8X2 SS-BLK

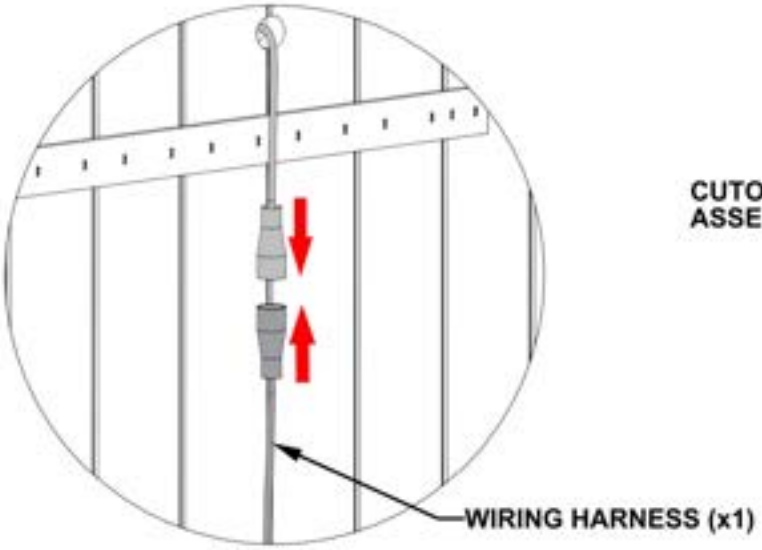


A4M05590-10 (x1) WIRING HARNESS

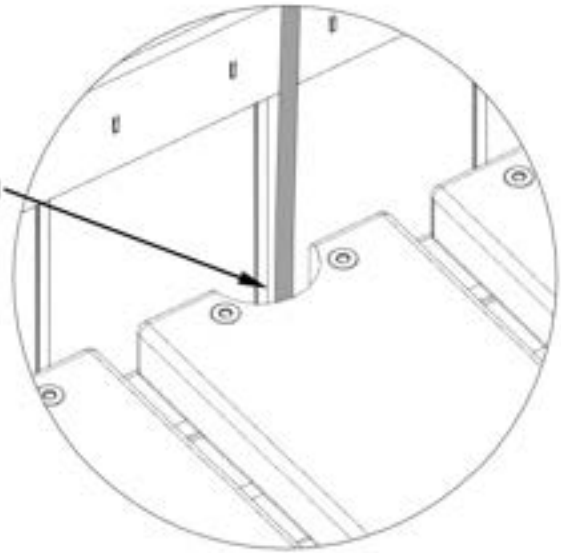


OG12 (x1) WIREWAY BOARD - W4L21999
1 3/16"x3 3/8"x35 3/16" (30x86x894)

- CONNECT WIRING HARNESS TO CONTROL PANEL CABLE FROM PREVIOUS STEP. (DETAIL 'A')
- RUN CABLE THROUGH CUTOUT IN BENCH ASSEMBLY AS SHOWN. (DETAIL 'B')
- CENTER WIRE WAY BOARD OVER CABLE AND CUTOUT IN BENCH AND ATTACH AS SHOWN. (DETAIL 'C')
- BE CAUTIOUS WHEN INSERTING SCREWS TO PREVENT PINCHING OR PENETRATING CORDS.

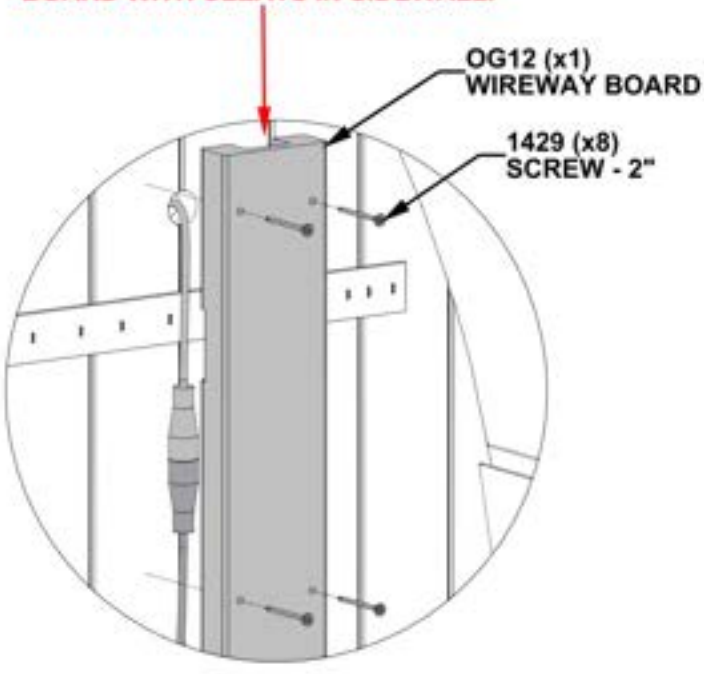


DETAIL 'A'

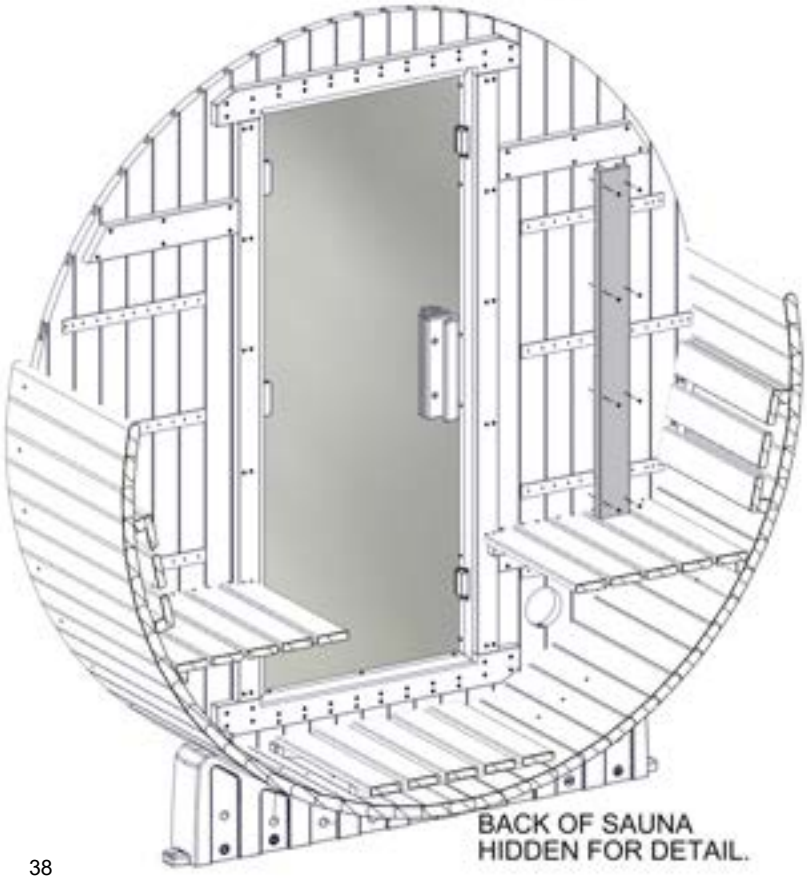


DETAIL 'B'

WIREWAY BOARD WILL ONLY FIT ONE WAY. ALIGN NOTCHES IN WIREWAY BOARD WITH CLEATS IN SIDEWALL.

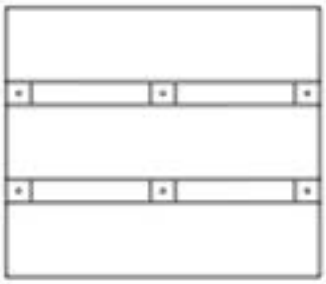


DETAIL 'C'



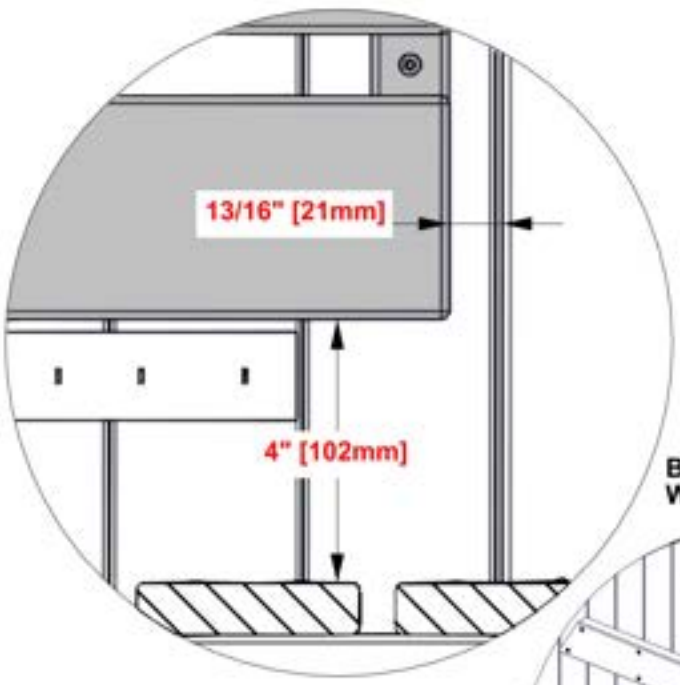
STEP 25 - BACK REST ASSEMBLY

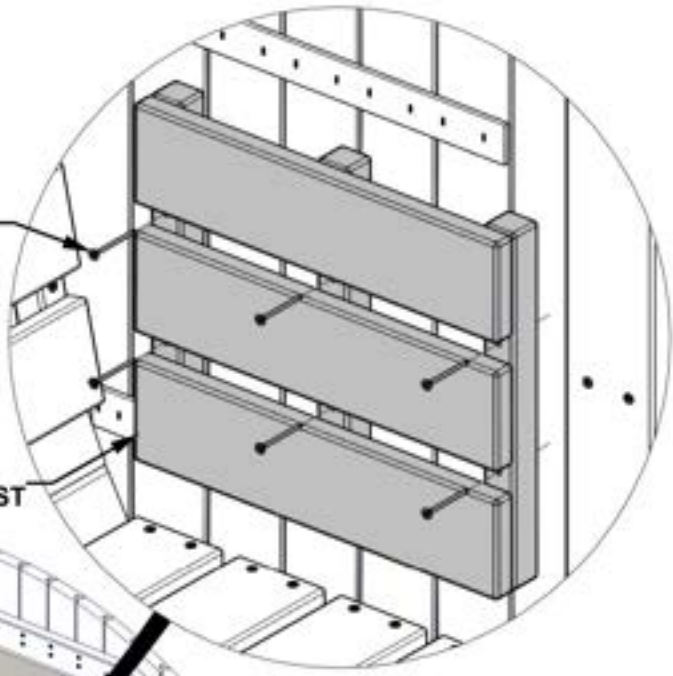
QTY	PART NUMBER	DESCRIPTION
12	H101429	SCREW TFH 8X2 SS-BLK

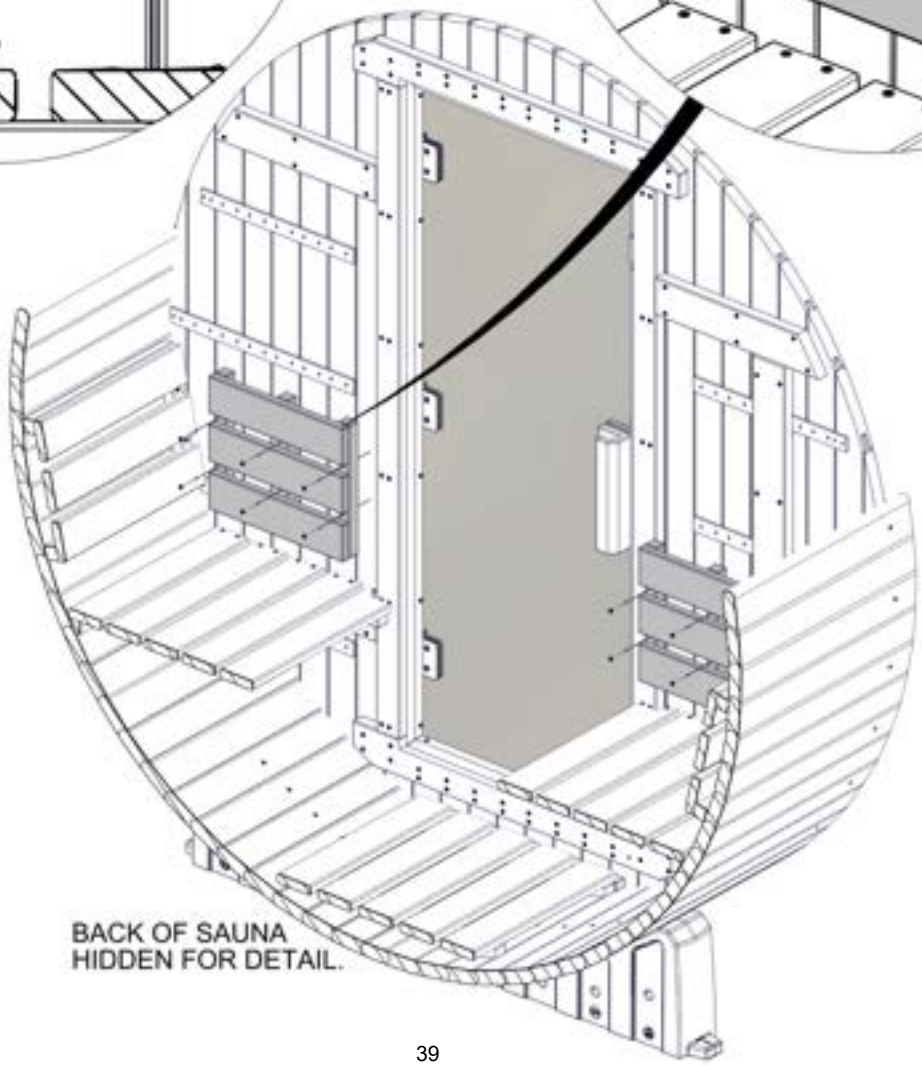


BR01 (x2) WALL BACK REST - W2A04790
1 15/16"X12 1/16"X14" (50x306x356)

- USE DIMENSIONS SHOWN AS A GENERAL GUIDE AND ADJUST TO YOUR OWN PREFERENCE.

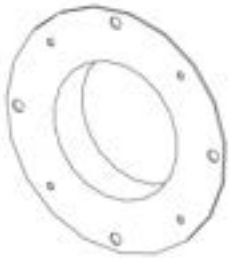






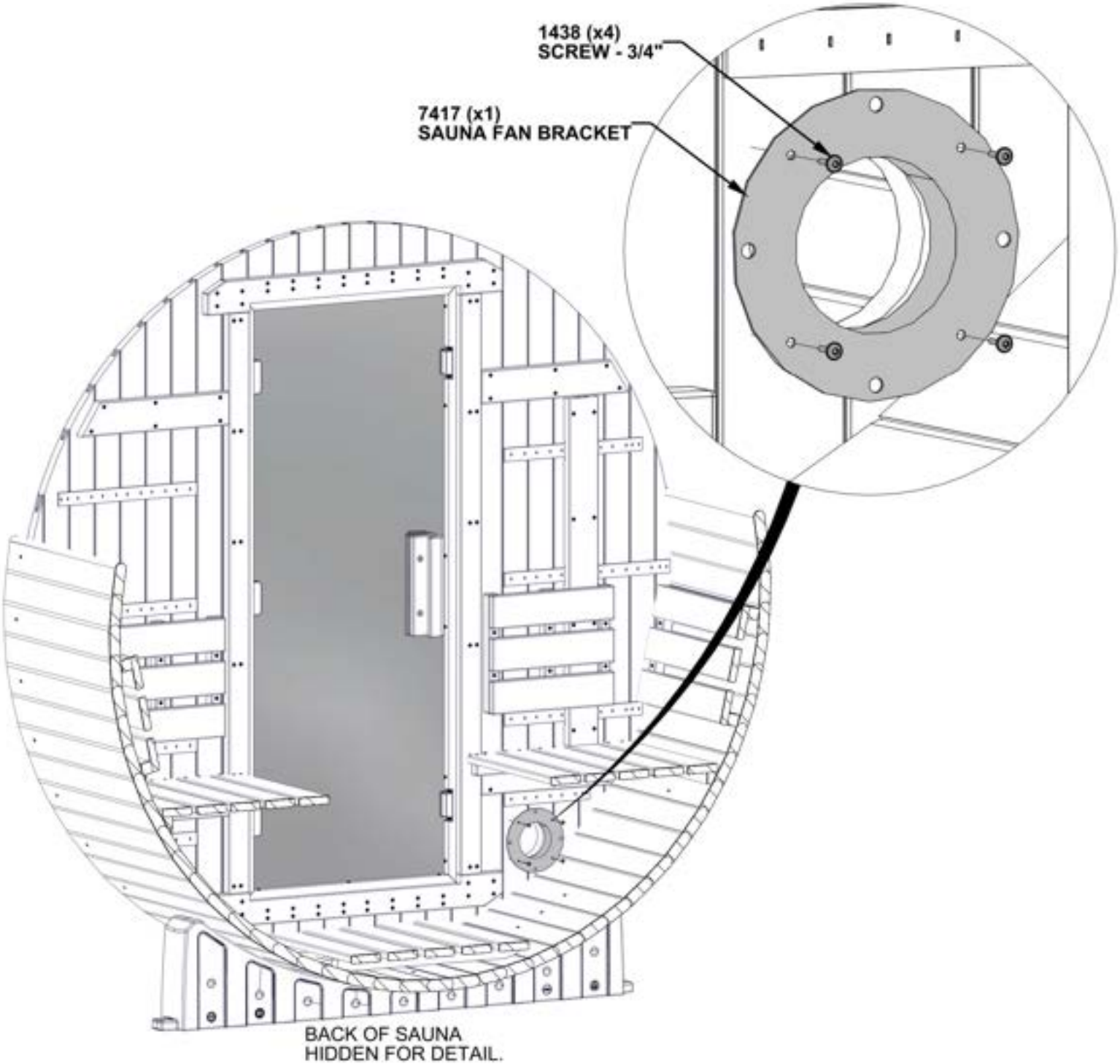
STEP 26 - FAN ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
4	H101438	SCREW TWH 8x3/4 SS-BLK



A4M07417 SAUNA FAN BRACKET
(x1)

- CENTER BRACKET IN WALL PANEL HOLE AND ATTACH AS SHOWN.
- ENSURE SCREWS ARE INSERTED INTO SMALLER HOLES IN BRACKET.



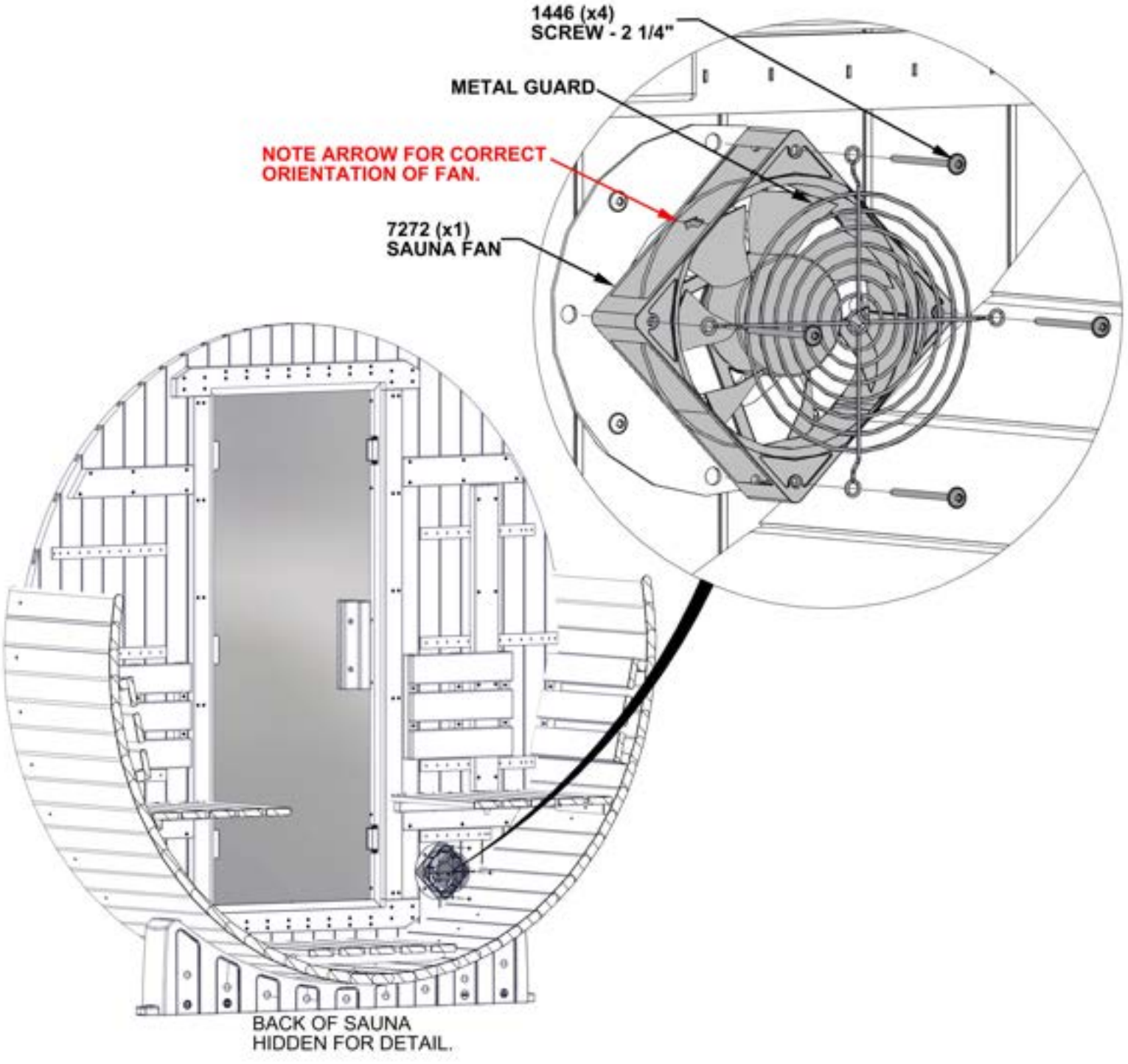
STEP 27 - FAN ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
4	H101446	SCREW TWH 8x2 1/4 SS-BLK



A4M07272 SAUNA FAN
(x1)

- ALIGN HOLES IN SAUNA FAN WITH LARGER HOLES IN BRACKET AND ATTACH AS SHOWN.
- FOR SAFETY, ATTACH METAL GUARD AS SHOWN.

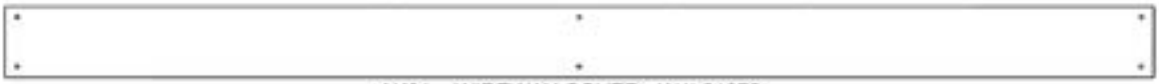


STEP 28 - WIREWAY ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
6	H101431	SCREW TFH 8X2 1/2 SS-BLK

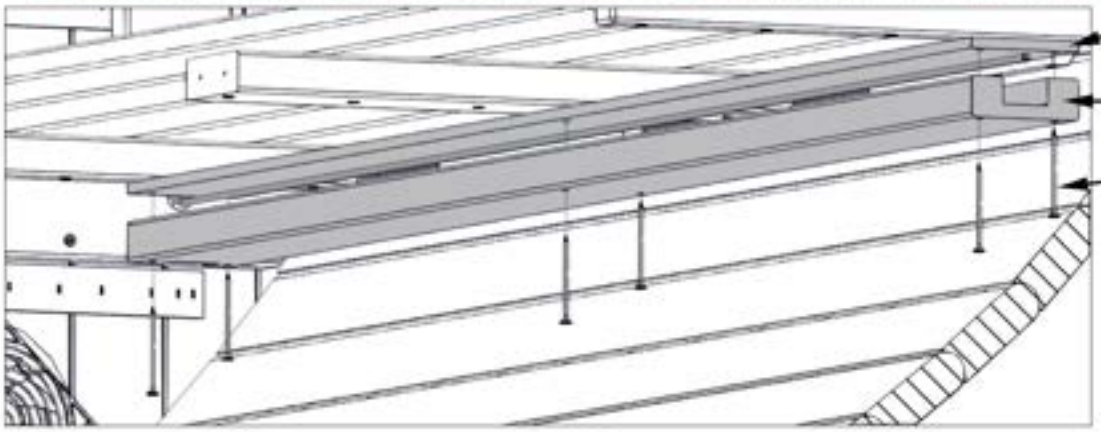


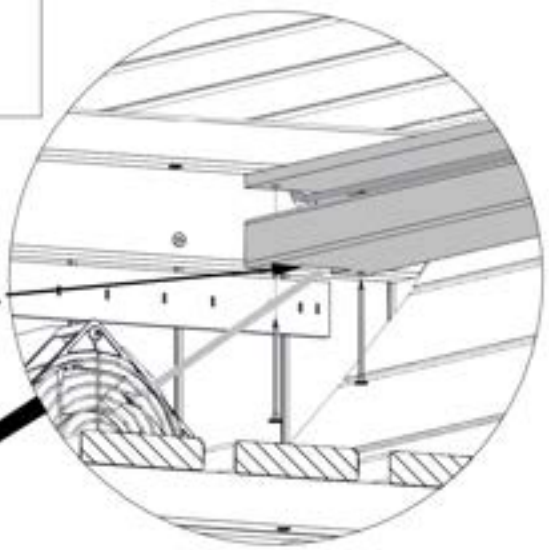
OG15 WIREWAY BOARD - W4L23472
(x1) 1 3/16"x3 3/8"x55 1/16" (30x86x1398)

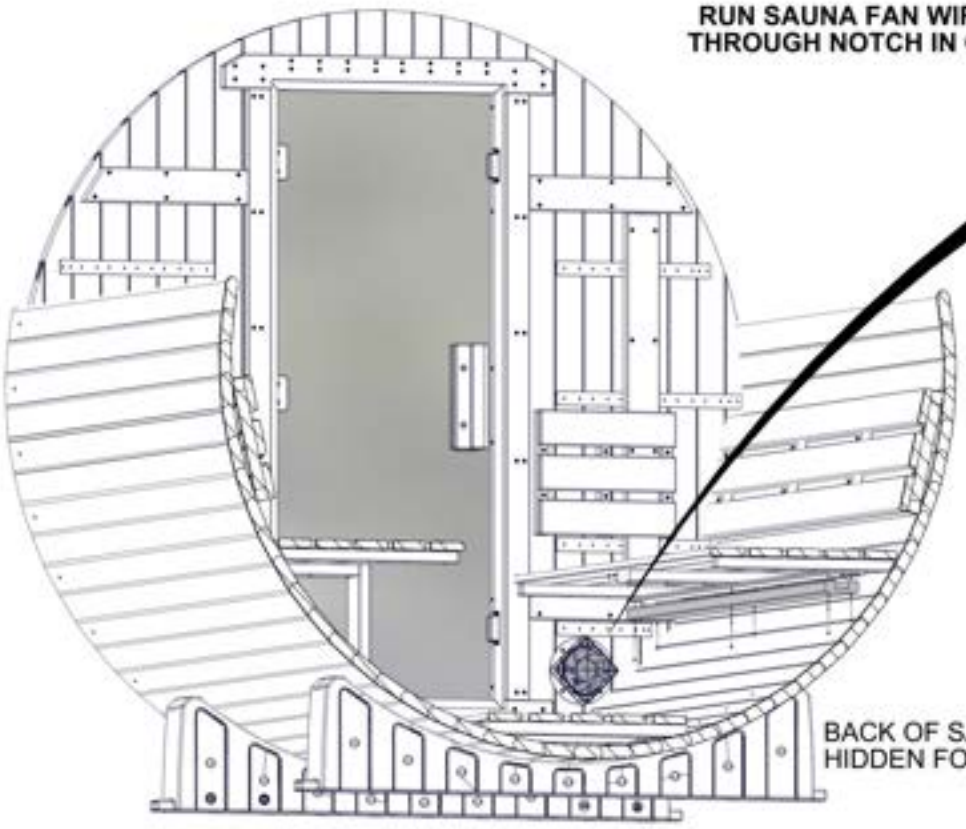


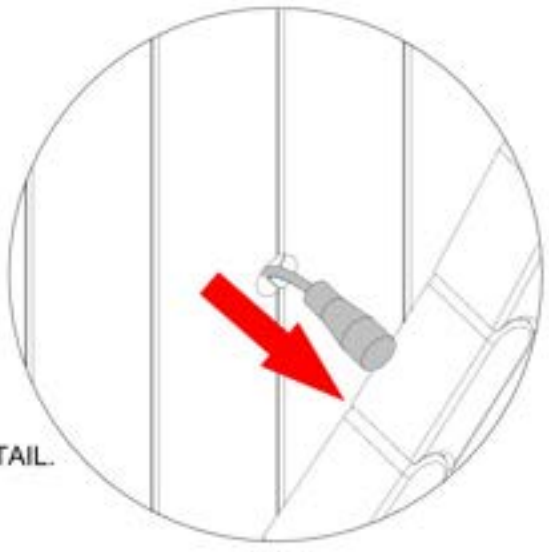
AK01 WIREWAY COVER - W4L21878
(x1) 5/16"x3 3/8"x55 1/16" (8x86x1398)

- RUN WIRING HARNESS CABLE BETWEEN AK01 AND OG15 ENSURING THAT CABLE RUNS IN CHANNELED PORTION.
- RUN WIRING FOR SAUNA FAN THROUGH NOTCH AND CHANNELED PORTION OF OG15.
- NOTE, THE WIRING HARNESS EXCESS CAN BE BUNDLED WITH PROVIDED ZIP CABLE TIES.
- USE RIGHT ANGLE DRILL ADAPTER TO INSERT BACK SCREWS.
- RUN ALL WIRING THROUGH HOLE IN BACK WALL.
- BE CAUTIOUS WHEN INSERTING SCREWS TO PREVENT PINCHING OR PENETRATING CORDS.









STEP 29 - CONTROL PANEL INSTALLATION

QTY	PART NUMBER	DESCRIPTION
3	H101440	SCREW TWH 8x1 SS-BLK

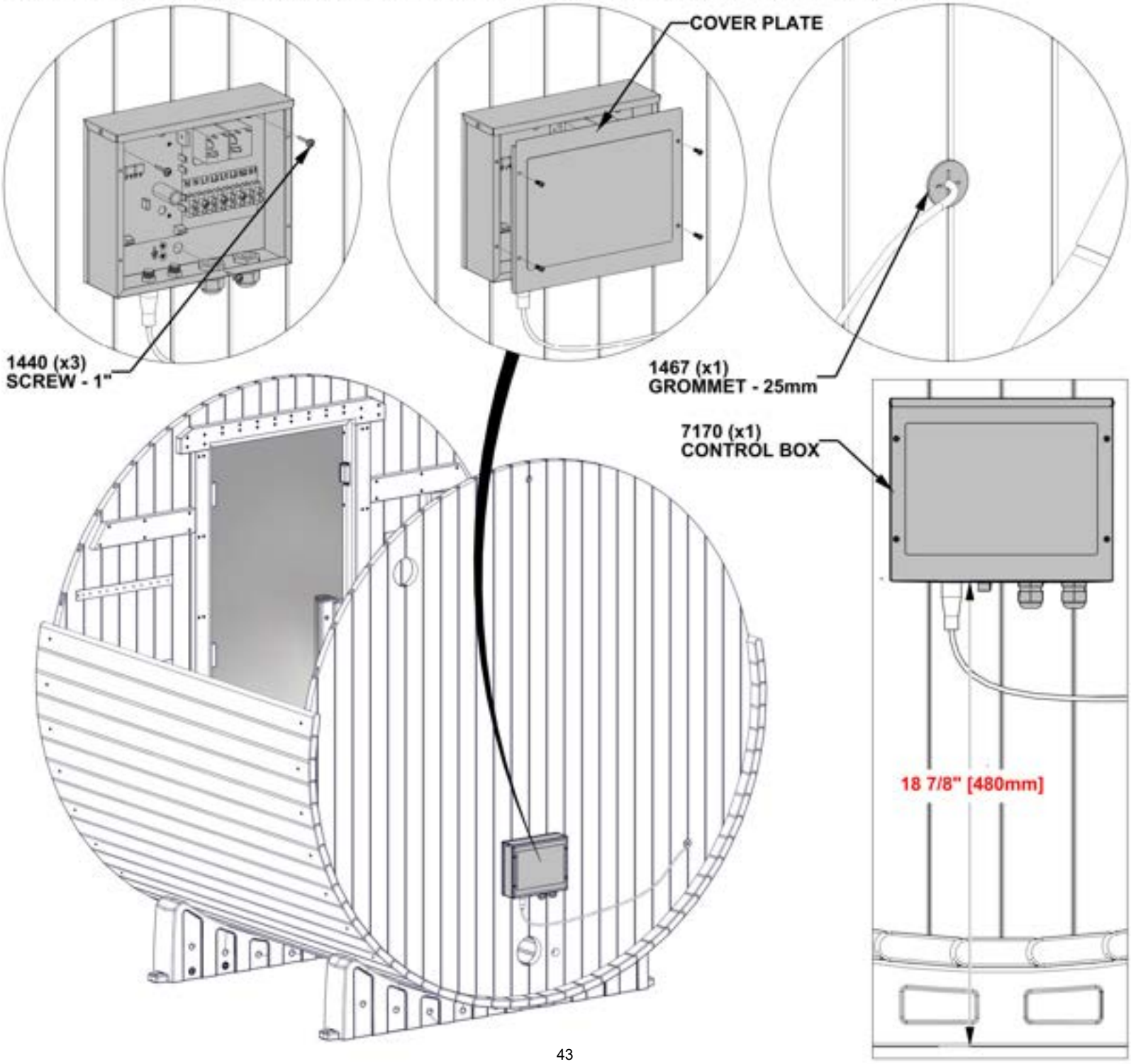


A4M07170 CONTROL BOX
(x1)



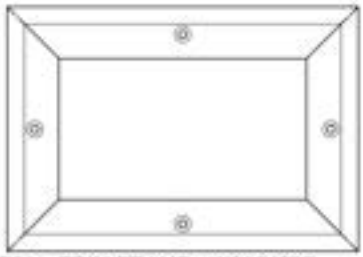
A6P01467 SILICONE GROMMET 25mm
(x1)

- REMOVE COVER PLATE FROM CONTROL PANEL BOX.
- CENTER CONTROL PANEL BOX ON BACK WALL APPROXIMATELY 18 7/8" ABOVE THE GROUND AS SHOWN.
- REATTACH COVER PLATE.
- SLIDE GROMMET OVER WIRING INSTALLED IN PREVIOUS STEP AND INSERT INTO HOLE IN BACK WALL.



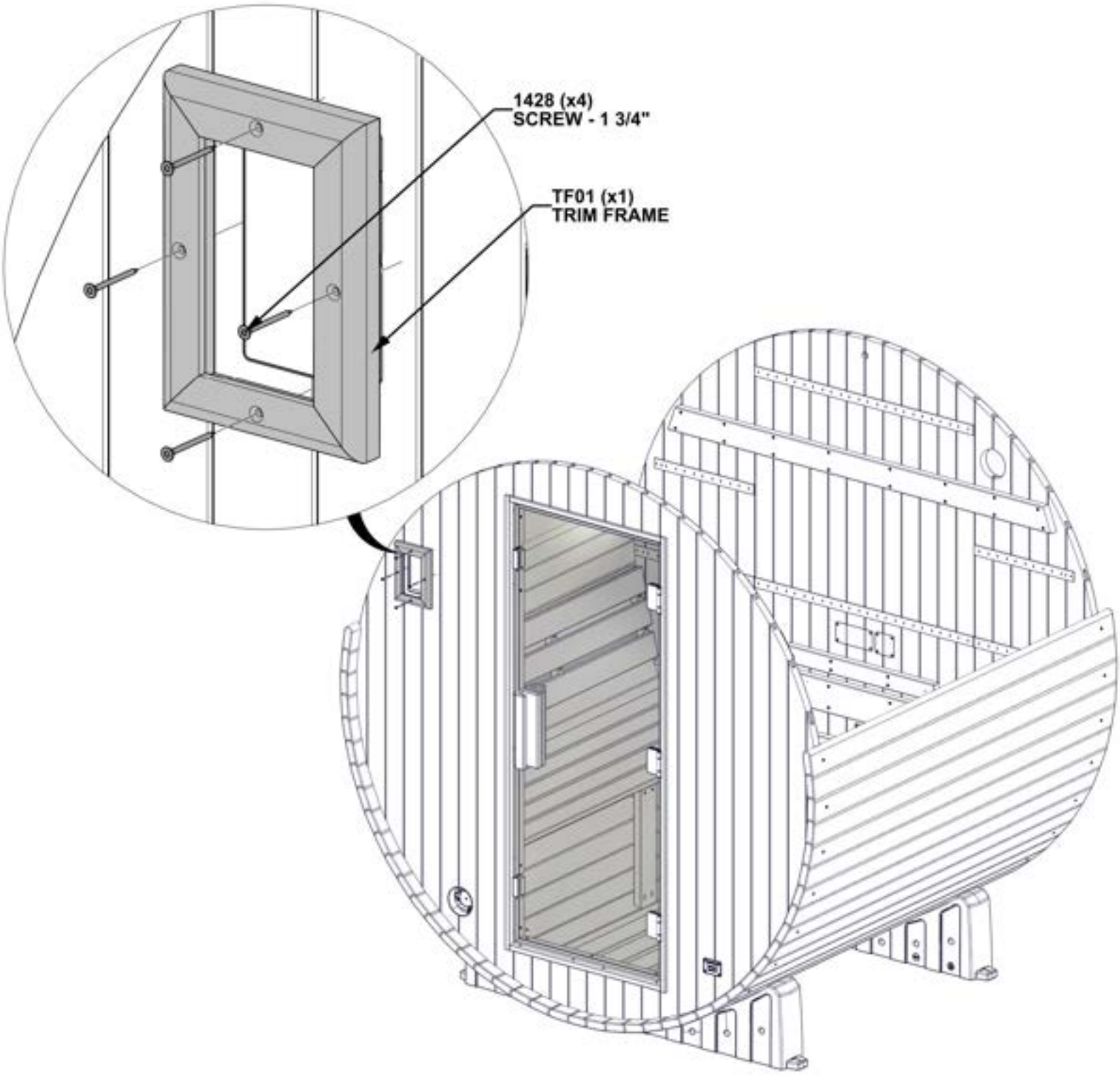
STEP 30 - CONTROL PANEL ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
4	H101428	SCREW TFH 8X1 3/4 SS-BLK



TF01 (x1) TRIM FRAME - W2A04797
7/8"x5 9/16"x8 1/16" (22x142x204)

- PLACE TRIM FRAME ON CONTROL PANEL ENSURING IT SEATS AROUND THE CONTROL PANEL AND ATTACH AS SHOWN.



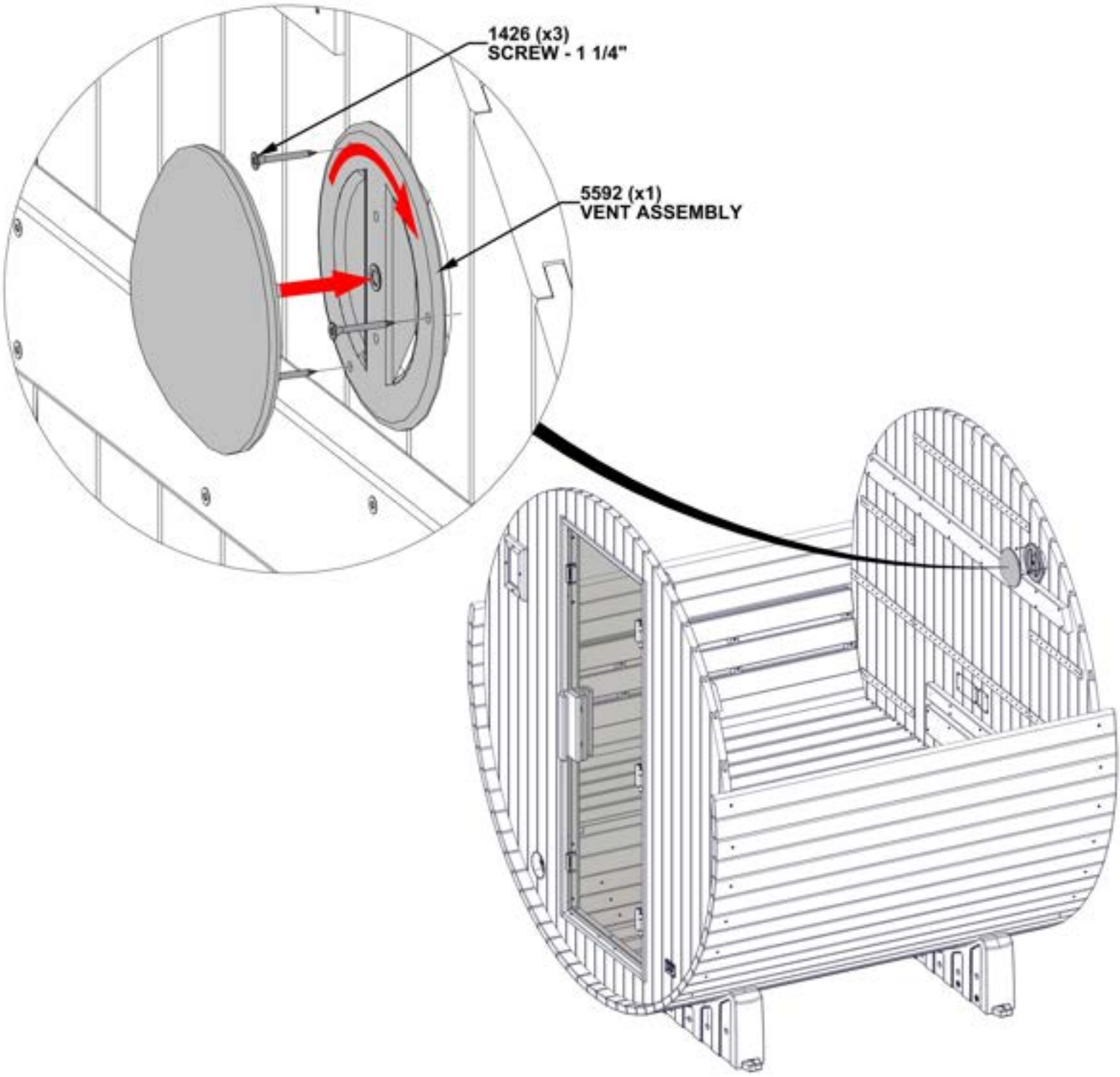
STEP 31 - VENT INSTALLATION

QTY	PART NUMBER	DESCRIPTION
3	H101426	SCREW TFH 8X1 1/4 SS-BLK



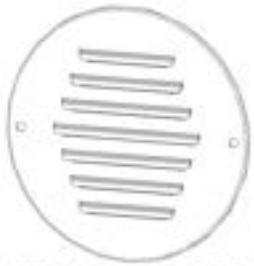
A4M05592 VENT ASSEMBLY
(x1)

- BEFORE ATTACHING VENT COVER, UNSCREW ADJUSTABLE VENT COVER FROM VENT BASE INSERT.
- ONCE VENT BASE INSERT IS ATTACHED, SCREW ADJUSTABLE VENT COVER BACK IN.



STEP 32 - VENT INSTALLATION

QTY	PART NUMBER	DESCRIPTION
6	H101438	SCREW TWH 8x3/4 SS-BLK

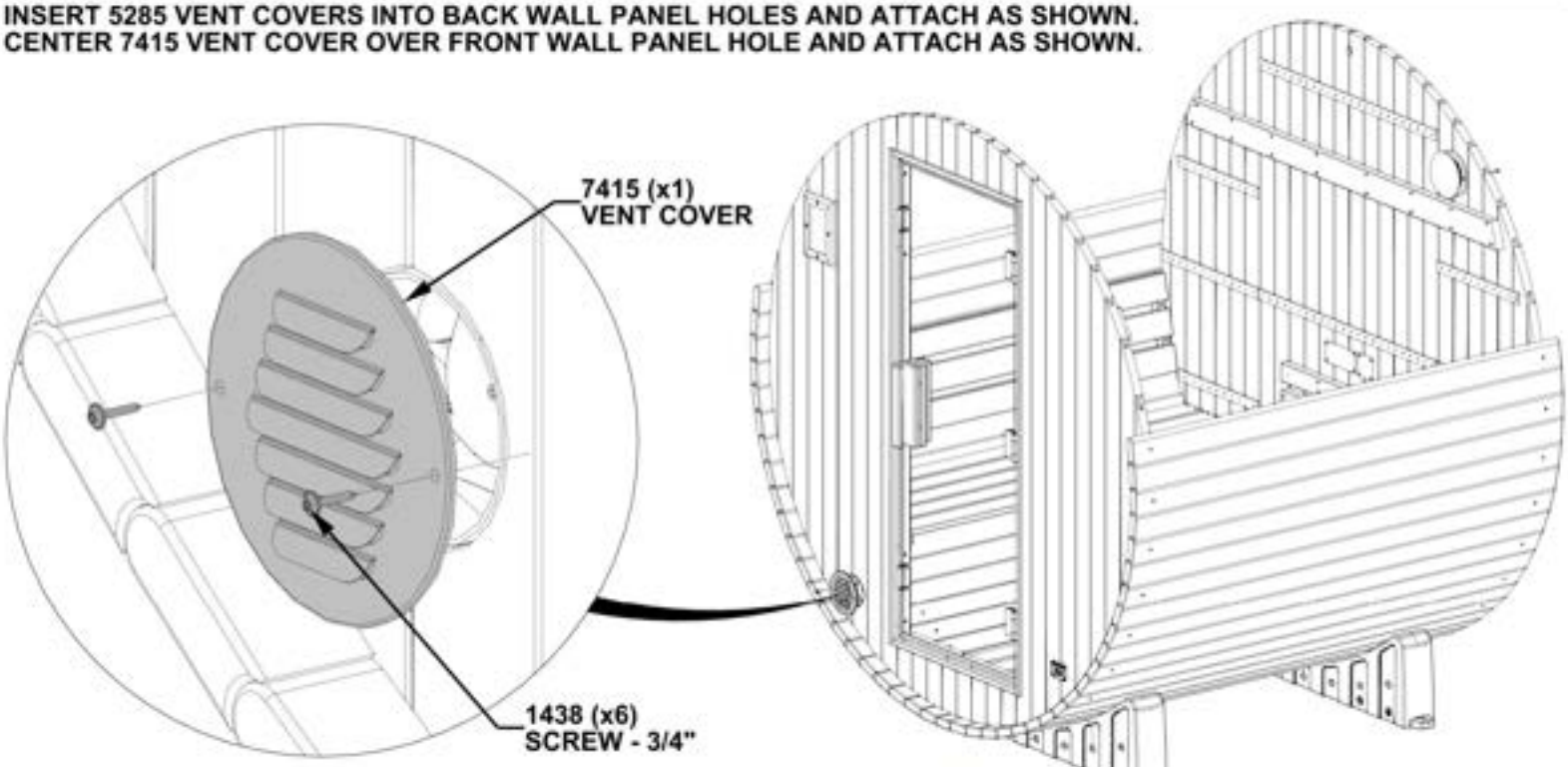


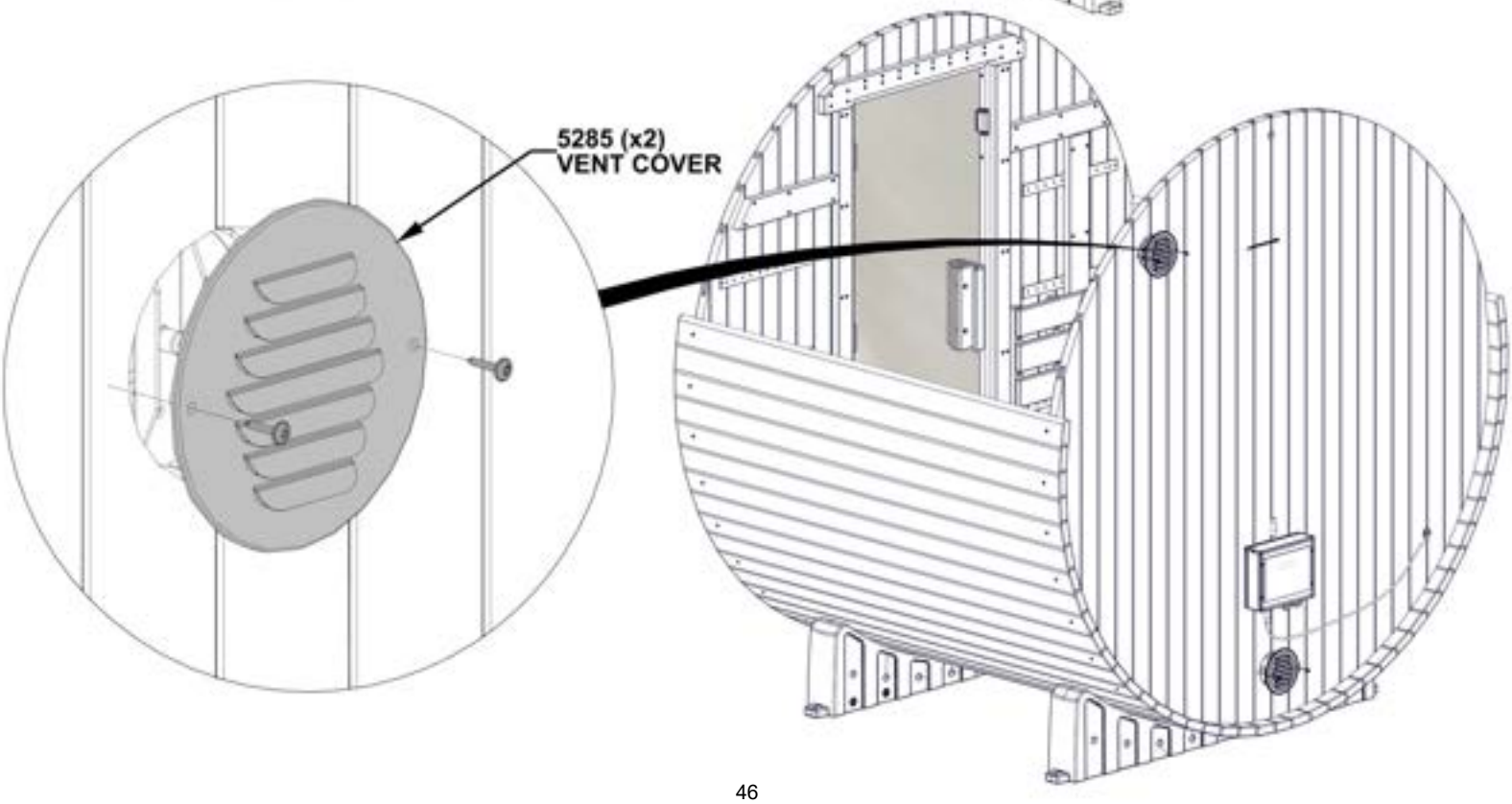
A4M05285 VENT COVER
(x2)



A4M07415 VENT COVER
(x1)

- INSERT 5285 VENT COVERS INTO BACK WALL PANEL HOLES AND ATTACH AS SHOWN.
- CENTER 7415 VENT COVER OVER FRONT WALL PANEL HOLE AND ATTACH AS SHOWN.



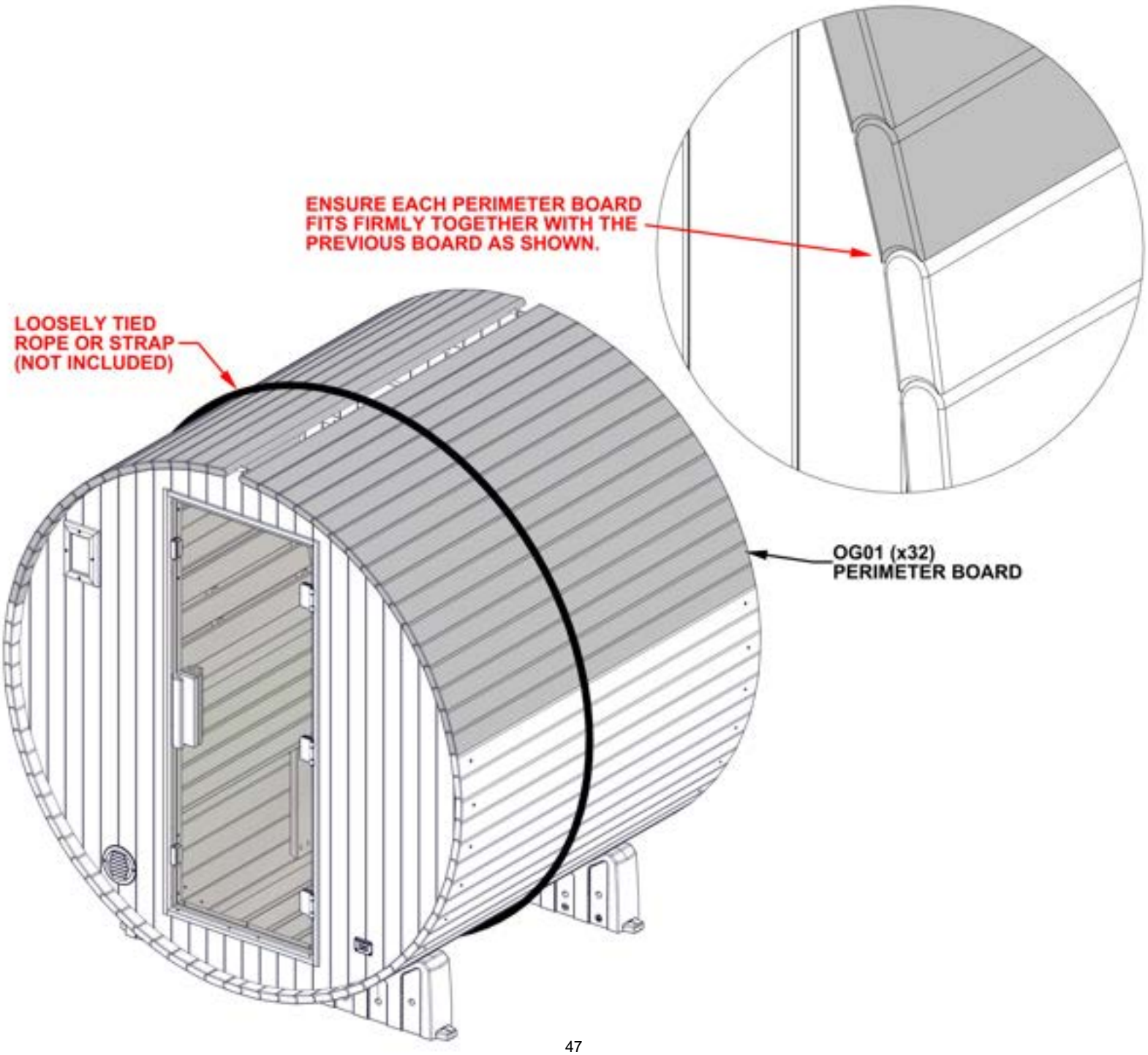


STEP 33 - SAUNA ASSEMBLY

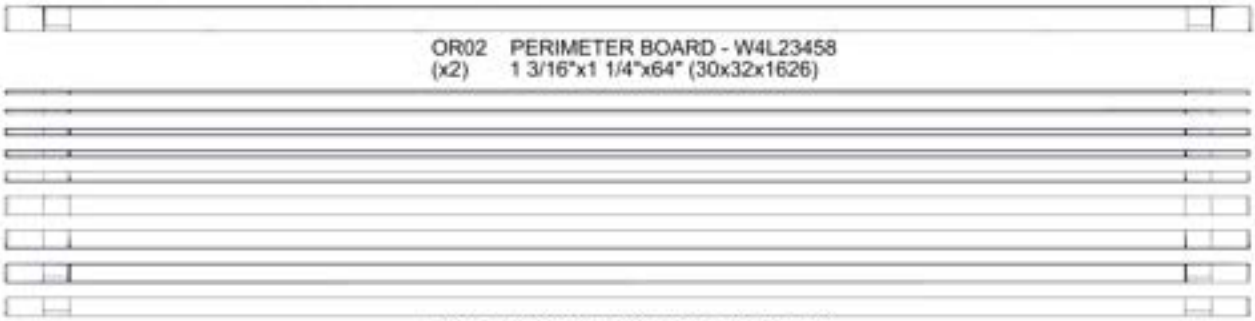


OG01 (x32) PERIMETER BOARD - W4L21857
1 3/16"x3 3/8"x64" (30x86x1626)

- A ROPE OR STRAP IS SUGGESTED TO BE LOOSELY TIED/ATTACHED AROUND THE SAUNA TO HELP HOLD BOARDS IN PLACE.
- ALIGN GROOVE IN PERIMETER BOARDS WITH BOTH FRONT WALL AND BACK WALL ASSEMBLIES.
- WORKING UPWARDS, STACK PERIMETER BOARDS UP BOTH SIDES.
- FASTEN ONE OR TWO OF THE PERIMETER BOARDS TO THE WALLS WITH A SMALL NAIL TO HOLD IN PLACE.



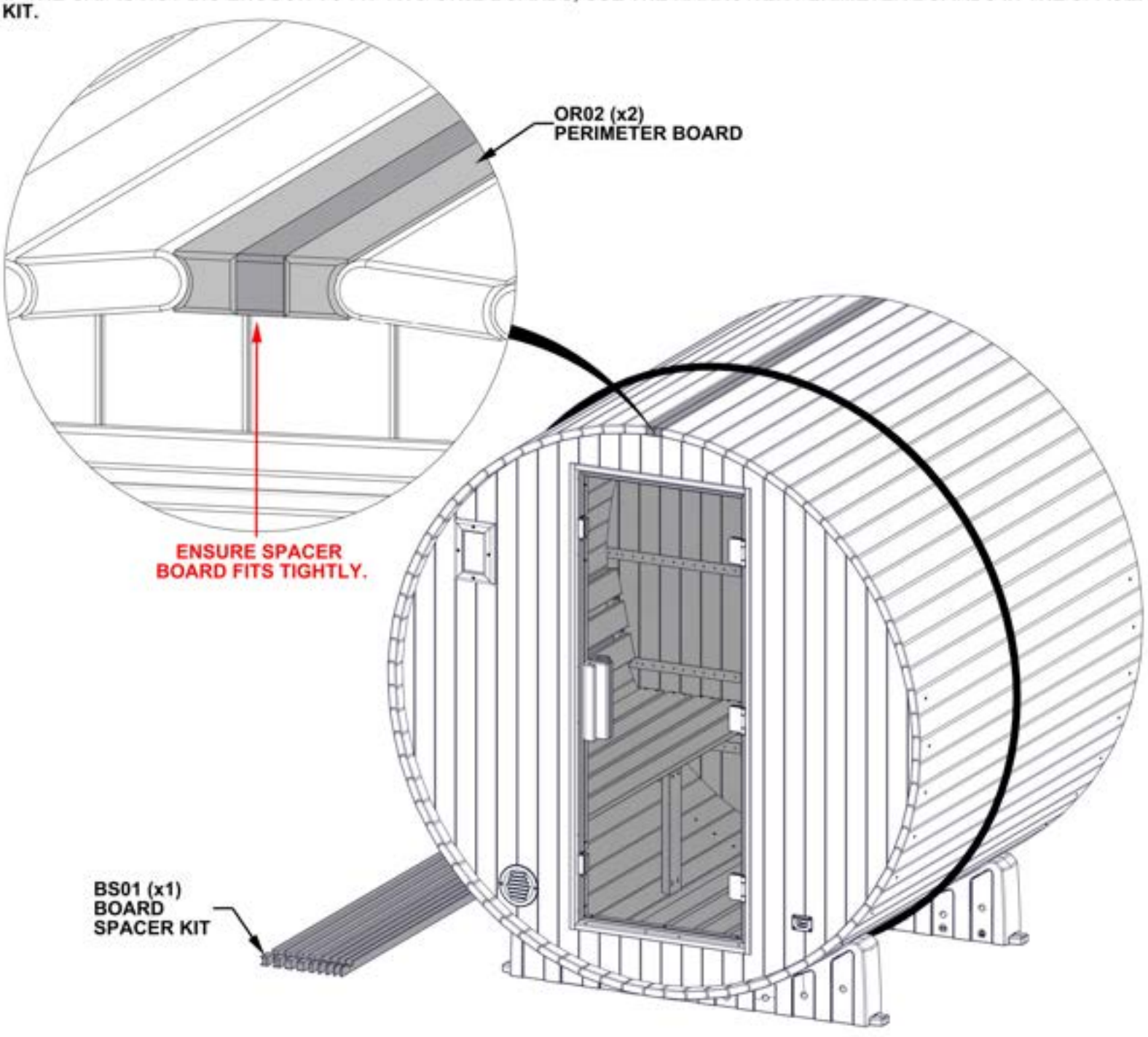
STEP 34 - SAUNA ASSEMBLY



OR02 (x2) PERIMETER BOARD - W4L23458
1 3/16"x1 1/4"x64" (30x32x1626)

BS01 (x1) BOARD SPACER KIT - W2A05380

- INSTALL OR02 BOARDS AS SHOWN ENSURING THEY FIT FIRMLY TOGETHER WITH PREVIOUSLY INSTALLED BOARDS.
- IT IS CRITICAL THE BOARDS FIT TIGHTLY TOGETHER.
- USE THE BOARD SPACER KIT AS NEEDED TO ACHIEVE A TIGHT FIT.
- FILL ANY GAP LEFT BETWEEN OR02 BOARDS WITH A PROPERLY SIZED SPACER BOARD FROM THE SPACER KIT.
- IF THE GAP IS NOT BIG ENOUGH TO FIT TWO OR02 BOARDS, USE THE NARROWER PERIMETER BOARDS IN THE SPACER KIT.



STEP 35 - BARREL ASSEMBLY

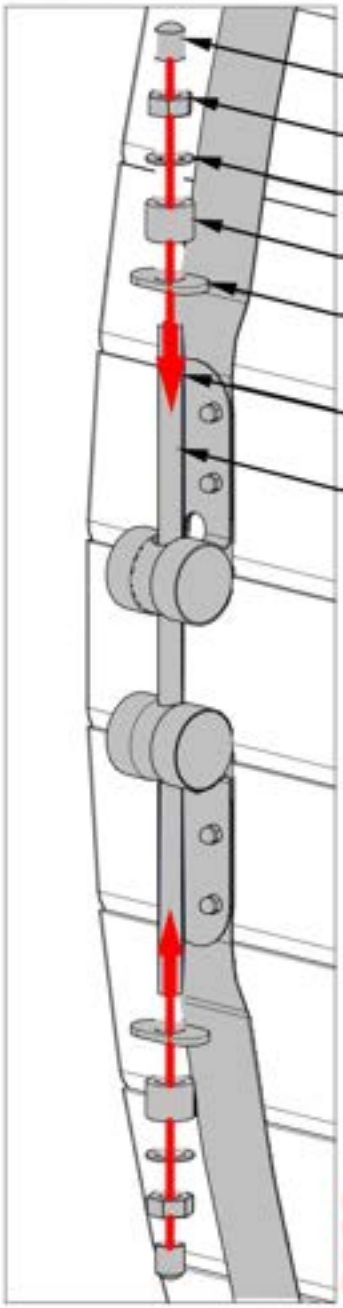


A4M05671 STRAPPING CINCH
(x3)

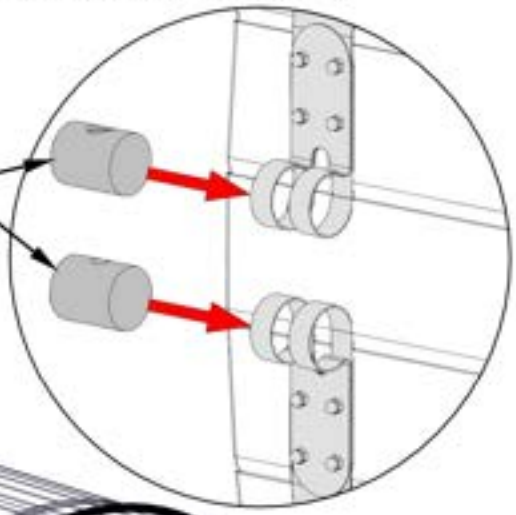


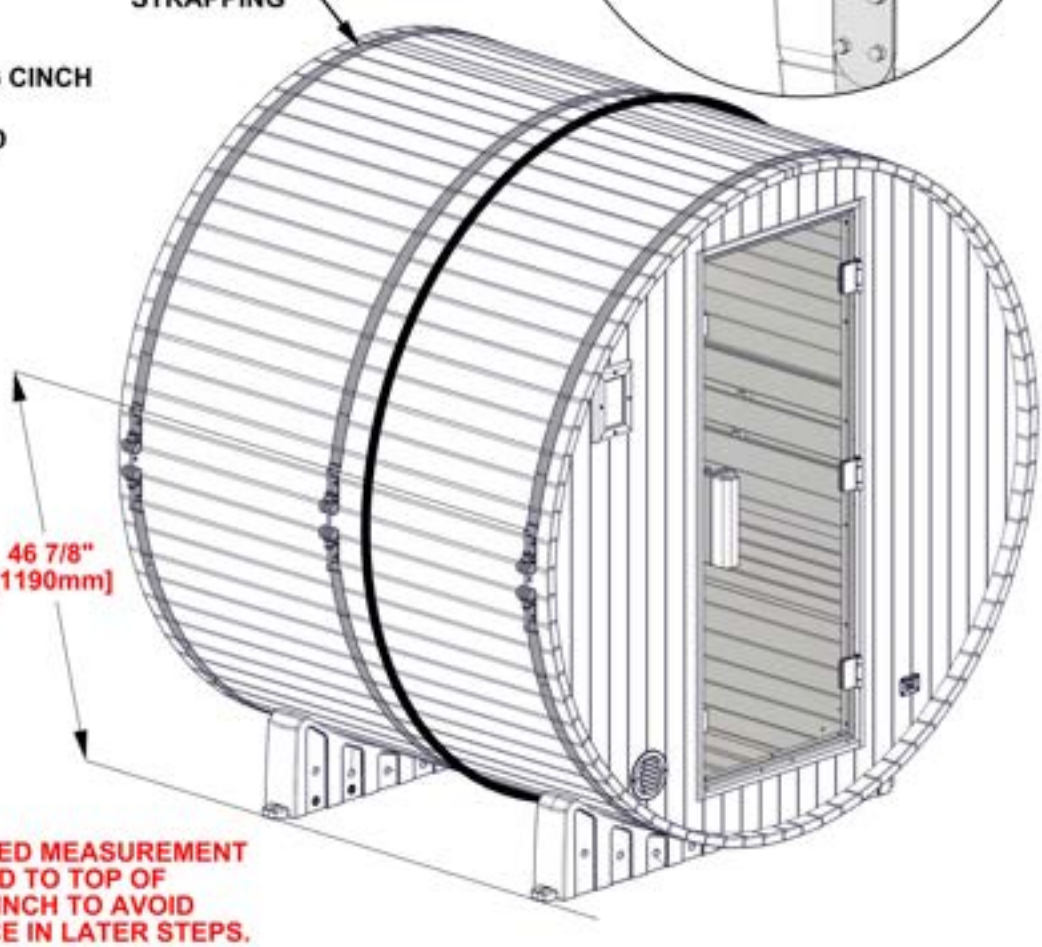
A4M05277 STRAPPING
(x3)

- WRAP STRAPPING AROUND BARREL AS SHOWN.
- CENTER ONE STRAP AND LOCATE THE OTHER TWO TOWARDS THE END OF THE BARREL.
- THE TWO ON THE ENDS SHOULD COVER THE SCREWS INSTALLED IN STEPS 11 AND 12.
- INSERT STRAPPING CINCH INSERTS INTO THE EYES ON STRAPPING.
- INSERT THE ALL THREAD THROUGH THE INSERTS AND CONNECT HARDWARE AS SHOWN.
- BEFORE TIGHTENING, VERIFY THAT STRAPPING IS LOCATED OVER THE SCREWS AND ONE IS CENTERED AND THAT STRAPPING IS STRAIGHT.
- THE STRAPPING CINCHES CAN BE EITHER ALIGNED OR STAGGERED BASED ON PERSONAL PREFERENCE.
- TIGHTEN ALL NUTS EVENLY.
- REMOVE STRAP/ROPE IF USED FROM EARLIER STEPS.



IMPORTANT: DO NOT OVERTIGHTEN





DO NOT EXCEED MEASUREMENT FROM GROUND TO TOP OF STRAPPING CINCH TO AVOID INTERFERENCE IN LATER STEPS.

STEP 36 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
2	H101437	SCREW TWH 8x5/8 SS-BLK



OG14 (x1) WIREWAY BOARD - W4L23471
1 3/16"x3 3/8"x31" (30x86x788)



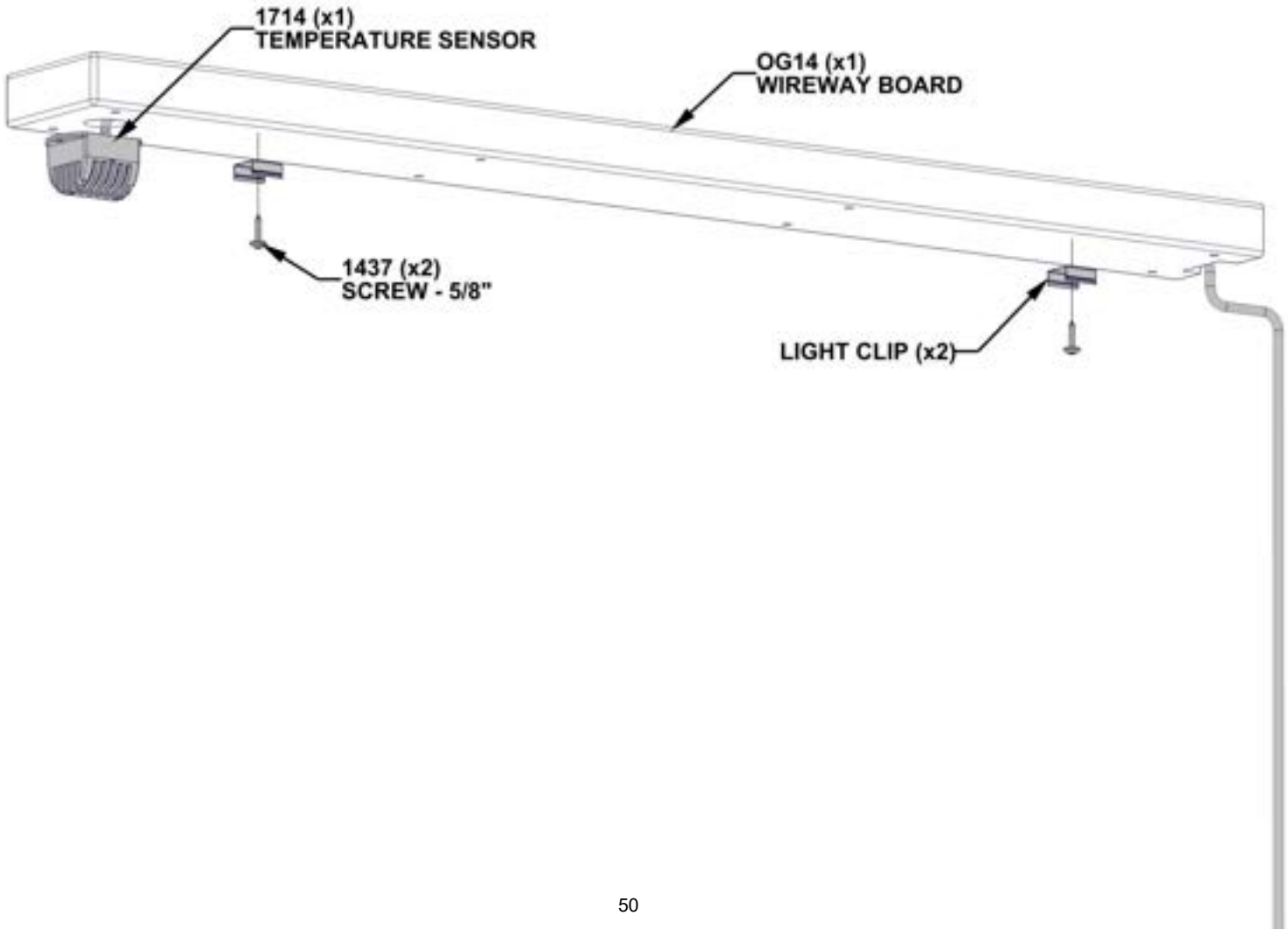
A6P01493-04 (x2) LIGHT CLIP



A6P01714 (x1) TEMPERATURE SENSOR

- ATTACH LIGHT CLIPS IN LOCATIONS SHOWN.
- RUN TEMPERATURE SENSOR CORD THROUGH HOLE IN OG14 AND CHANNELED PORTION.

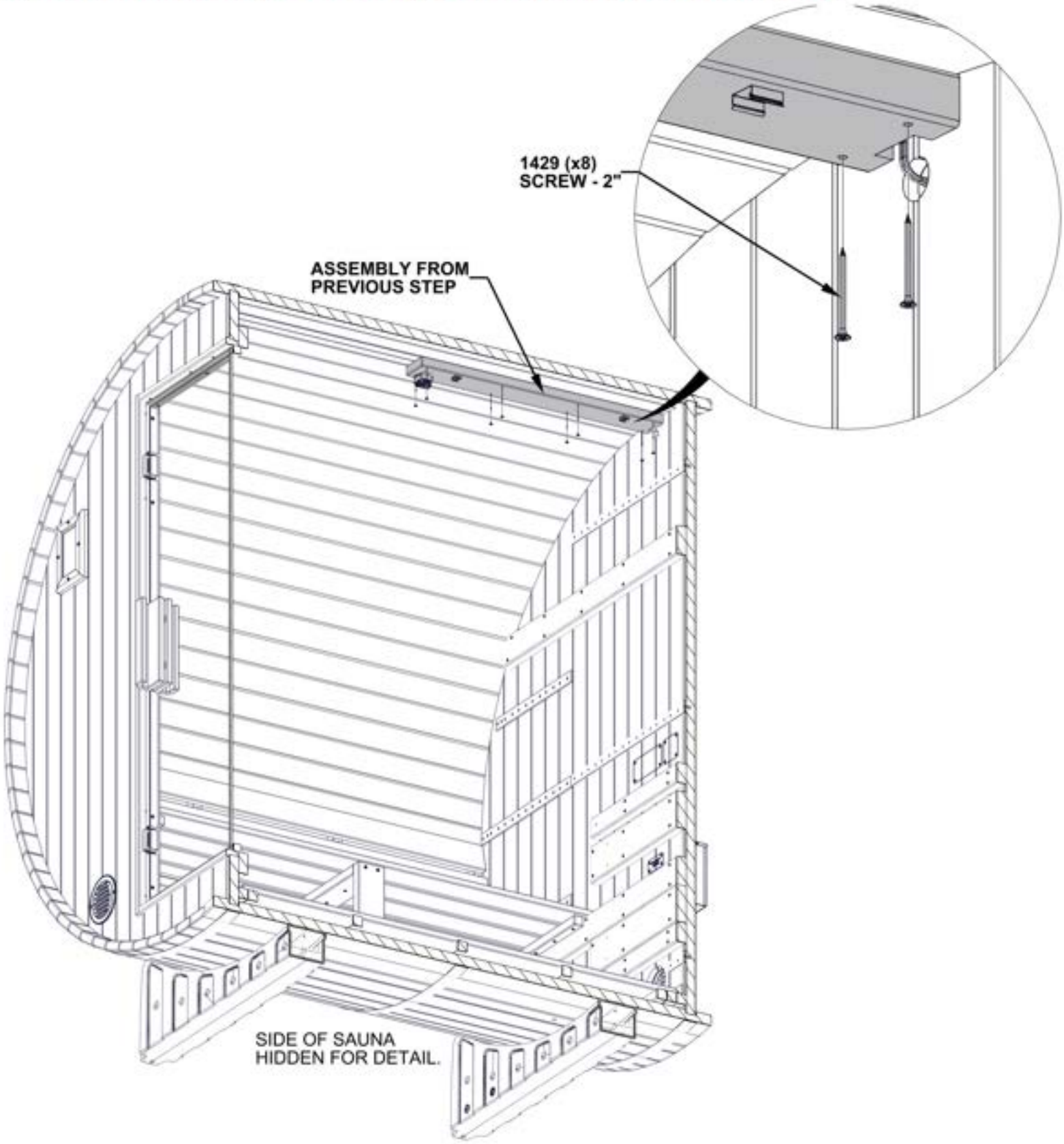




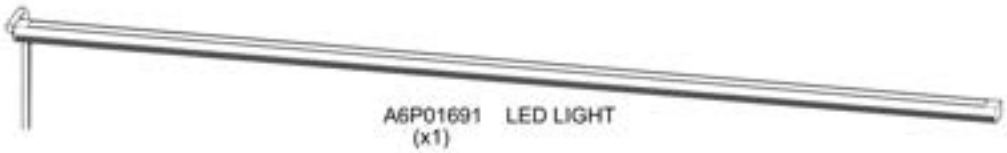
STEP 37 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
8	H101429	SCREW TFH 8X2 SS-BLK

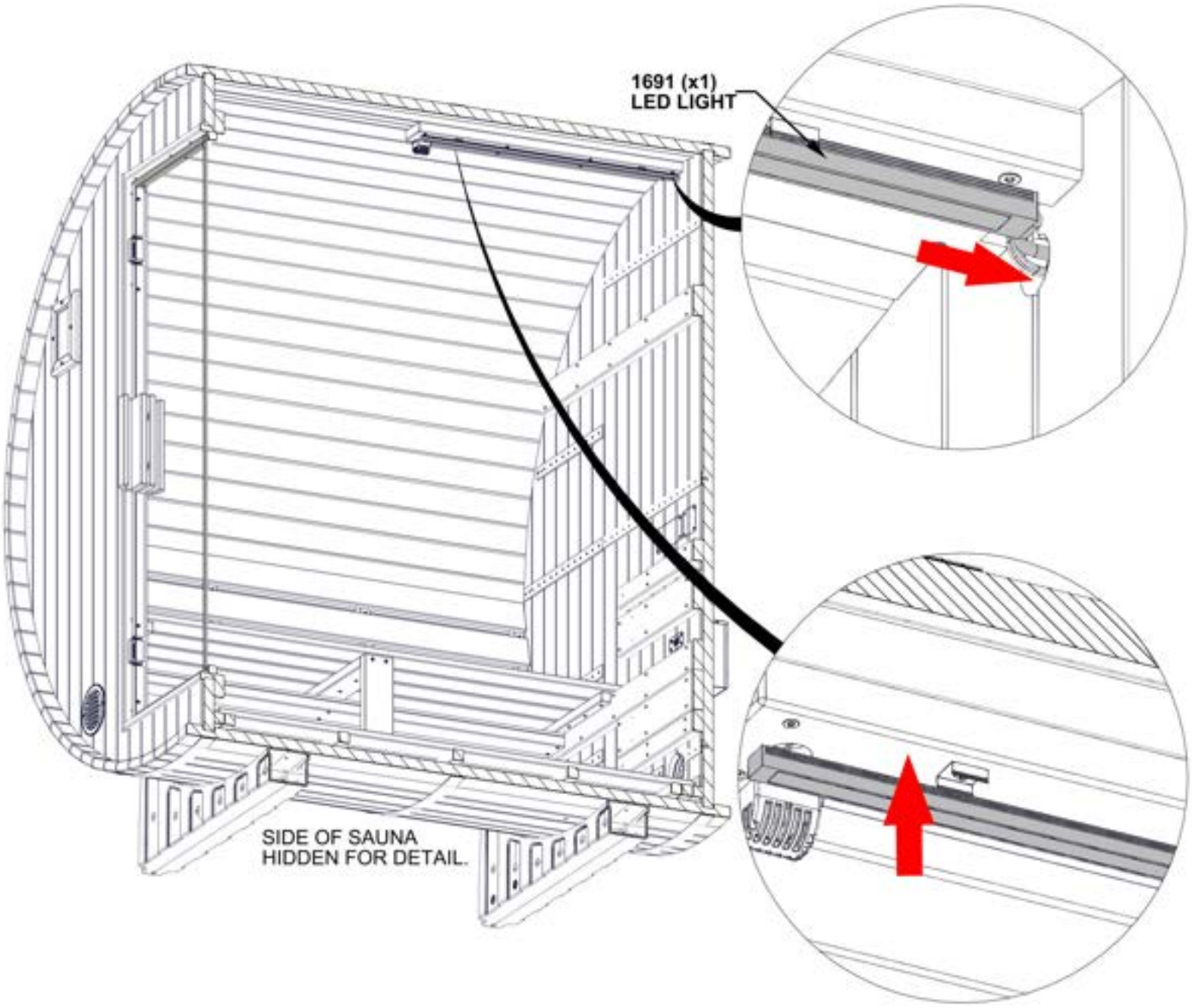
- RUN TEMPERATURE SENSOR OUT THE HOLE IN THE BACK WALL AND ENSURE ASSEMBLY IS FLUSH AGAINST THE BACK WALL.
- HOLDING THE TEMPERATURE SENSOR OUT OF THE WAY, ATTACH ASSEMBLY WITH SCREWS AS SHOWN.
- BE CAUTIOUS WHEN INSERTING SCREWS TO PREVENT PINCHING OR PENETRATING CORDS.



STEP 38 - SAUNA ASSEMBLY



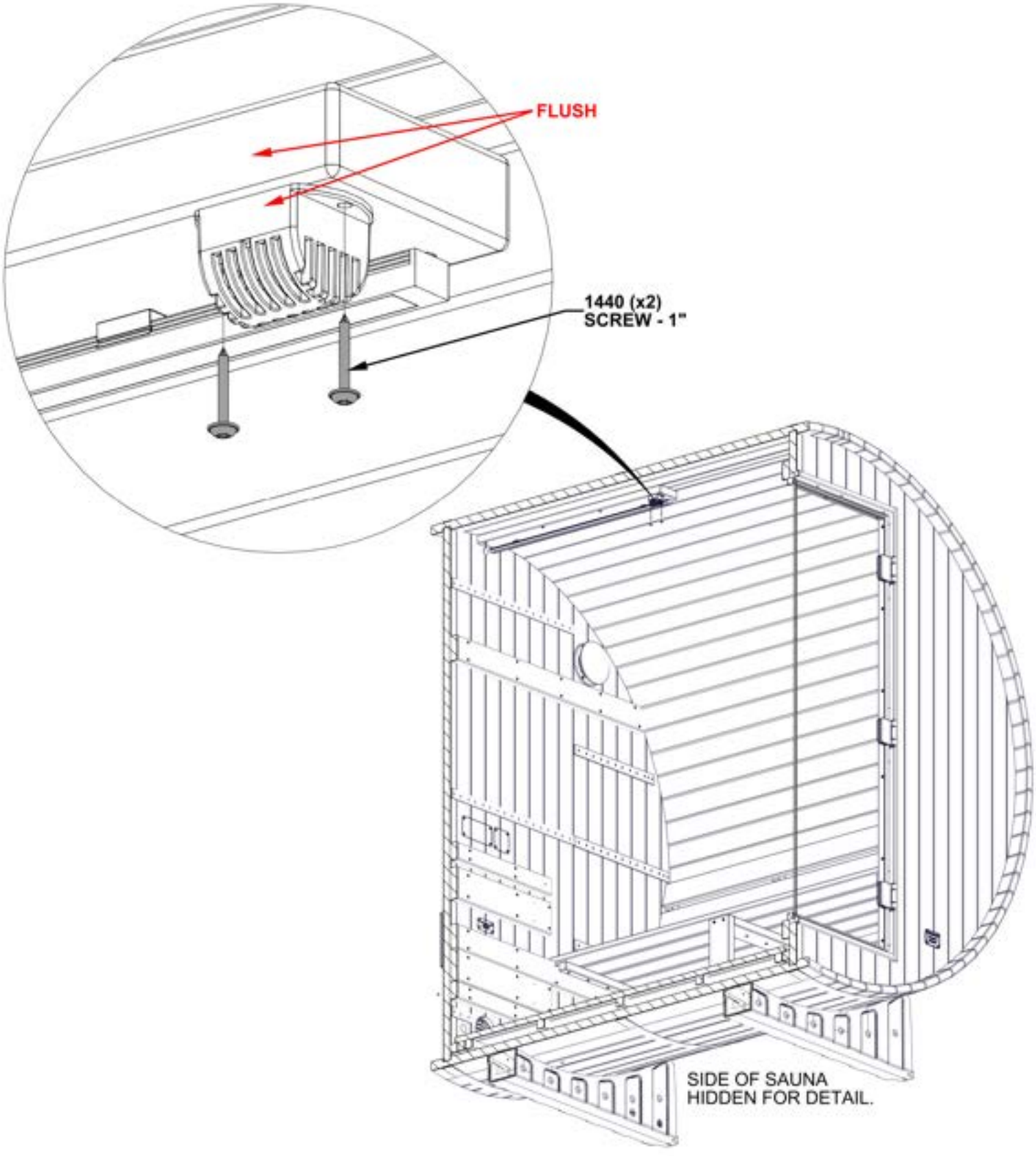
- BEFORE CLIPPING LIGHT INTO PLACE, RUN CORD THROUGH HOLE IN BACK WALL.
- SNAP LED LIGHT INTO LIGHT CLIPS.



STEP 39 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
2	H101440	SCREW TWH 8x1 SS-BLK

- IMPORTANT: INSTALL THE TEMPERATURE SENSOR EXACTLY AS SHOWN IN THESE INSTRUCTIONS. THE SENSOR LOCATION HAS BEEN SPECIFICALLY ENGINEERED AND TESTED TO ENSURE SAFE OPERATION AND ACCURATE TEMPERATURE CONTROL. RELOCATING THE SENSOR OR INSTALLING IT IN AN INCORRECT POSITION MAY RESULT IN INACCURATE TEMPERATURE READINGS, POOR HEATING PERFORMANCE, NUISANCE SHUTOFFS, OR OVERHEATING CONDITIONS.
- BE CAUTIOUS WHEN INSERTING SCREWS TO PREVENT PINCHING OR PENETRATING CORDS.

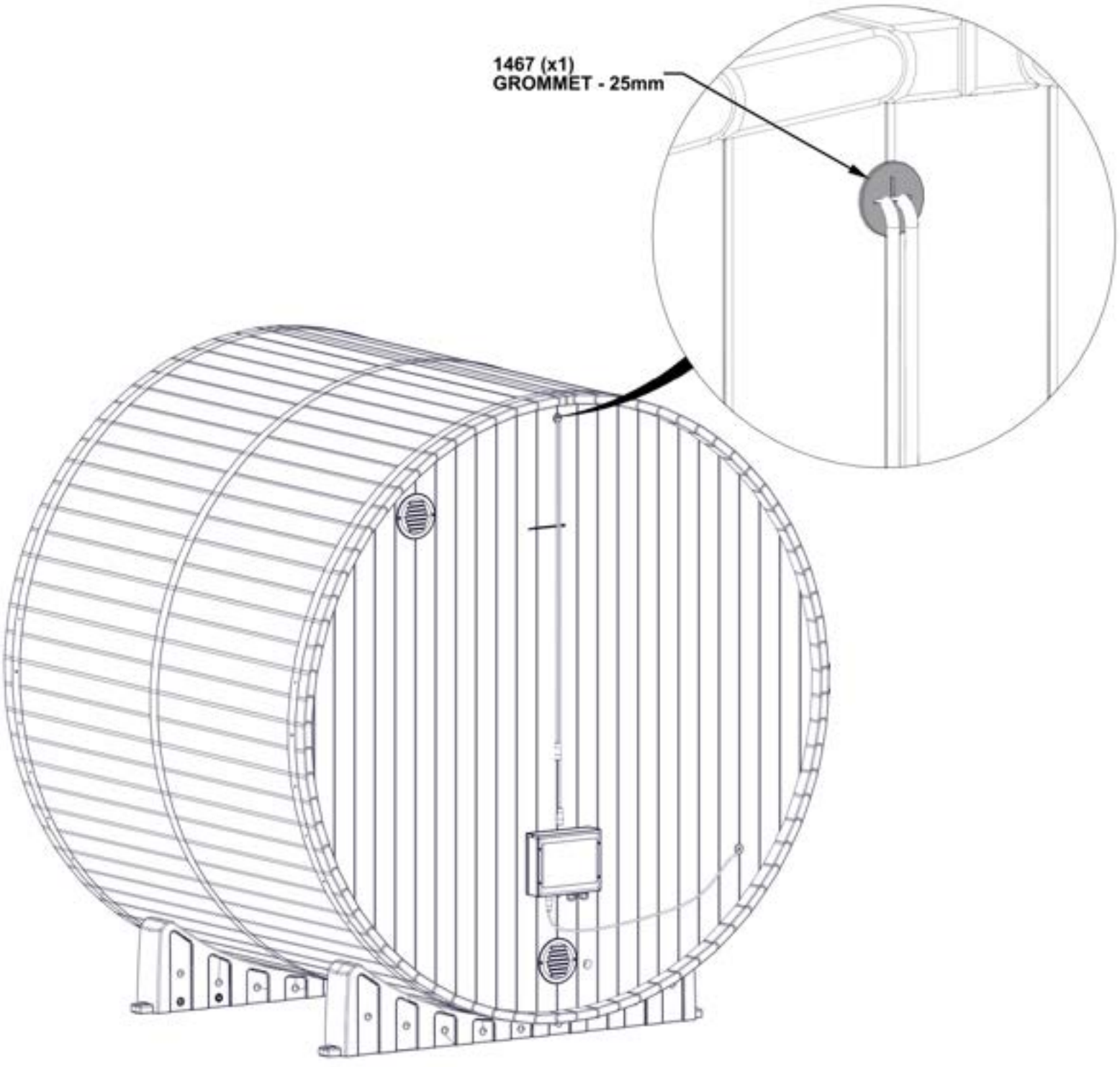


STEP 40 - WIRING



A6P01467 SILICONE GROMMET 25mm
(x1)

- SLIDE GROMMET OVER WIRING INSTALLED IN PREVIOUS STEP AND INSERT INTO HOLE IN BACK WALL.



STEP 41 - WIRING

QTY	PART NUMBER	DESCRIPTION
5	H101409	SCREW PPH 4x1/2 BLK

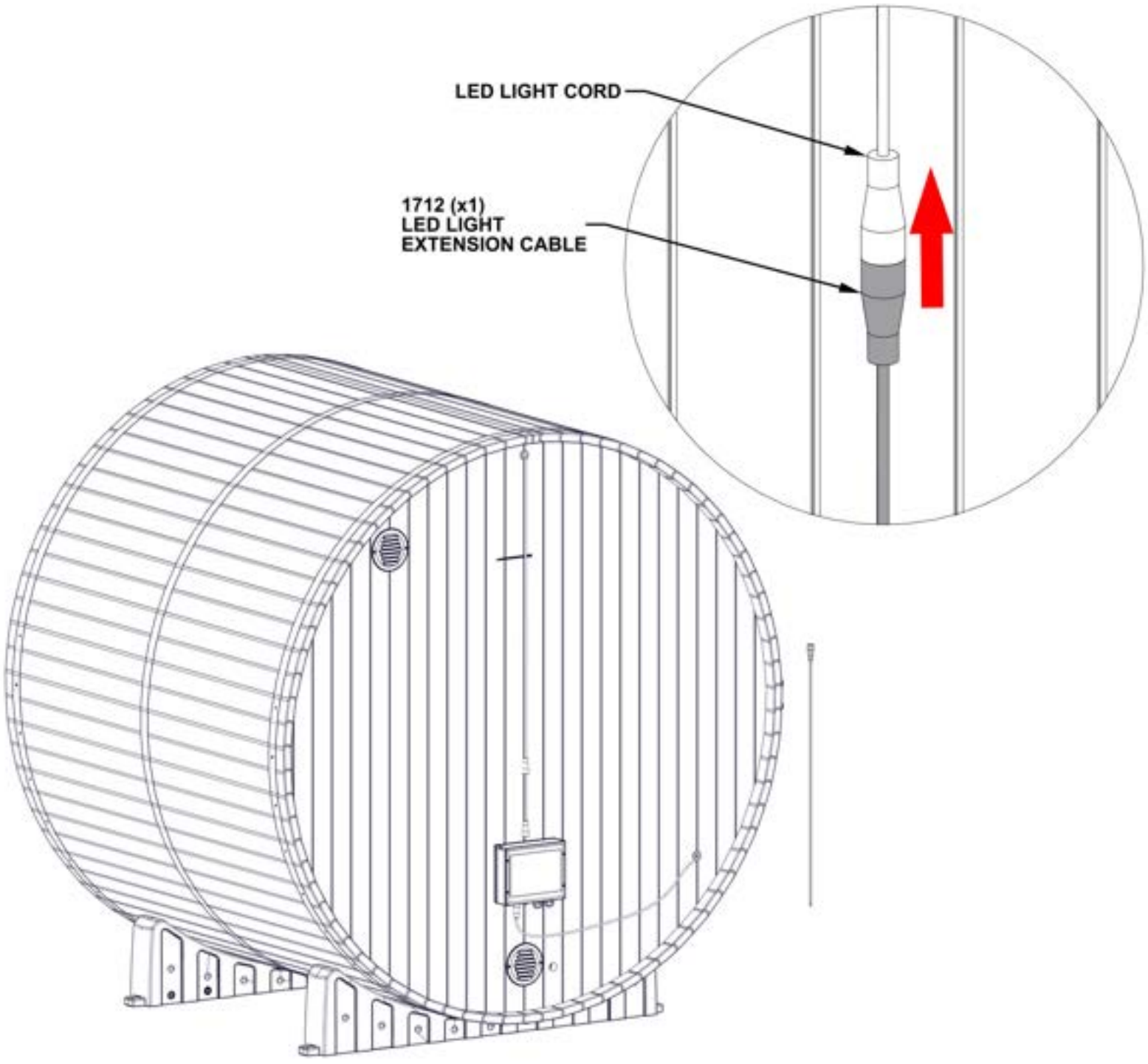


A6P01712 LED LIGHT EXTENSION CABLE
(x1)



A6P01448 ZIP CABLE TIE
(x5)

- ATTACH LIGHT CORD TO 1712 AND PLUG INTO THE CONTROL BOX.
- USE ZIP CABLE TIES TO ORGANIZE ALL WIRING ON BACK OF SAUNA.

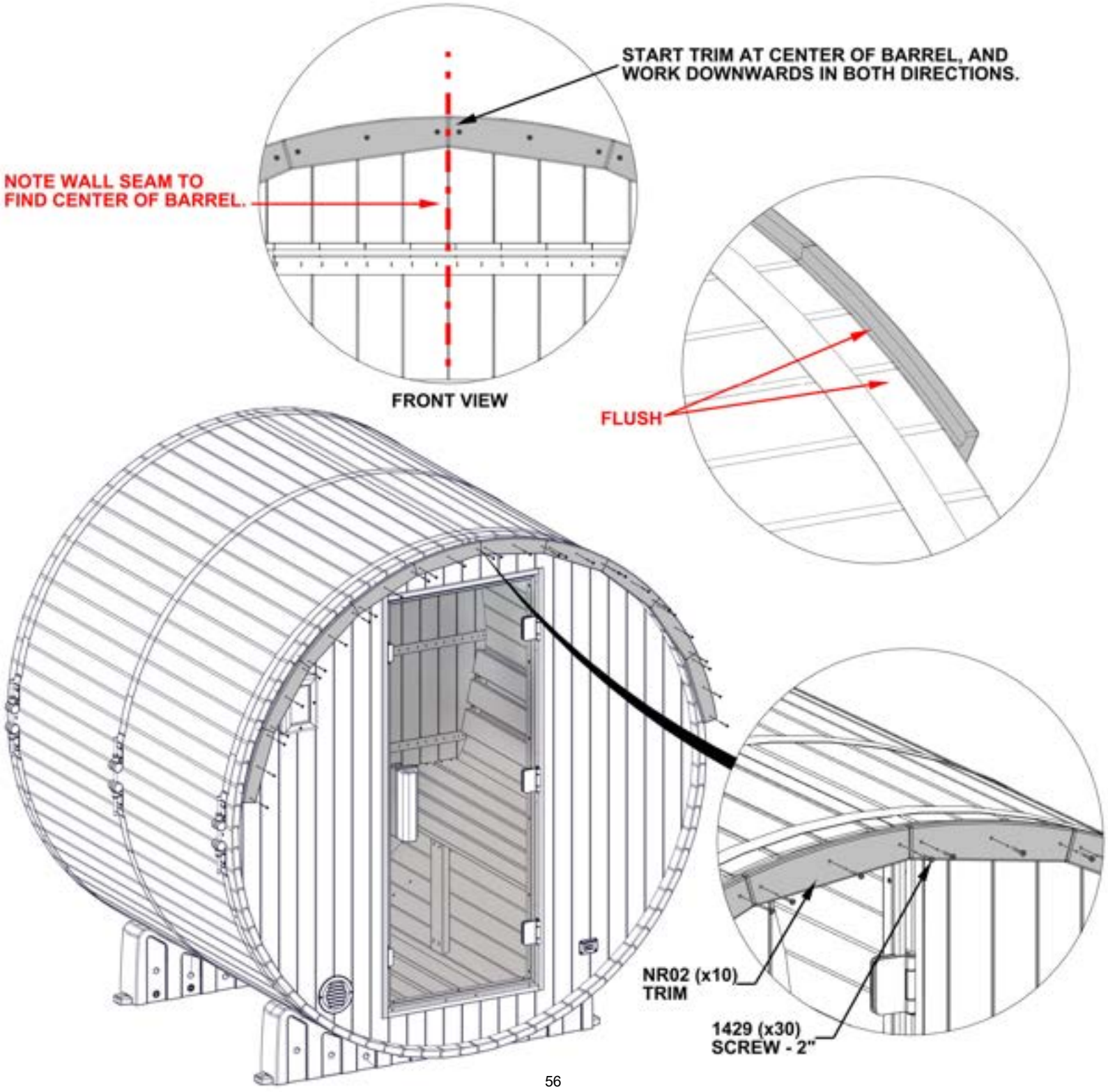


STEP 42 - TRIM ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
30	H101429	SCREW TFH 8X2 SS-BLK

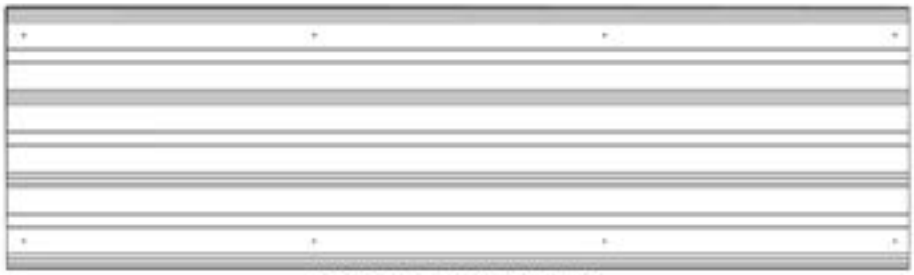


NR02 (x10) TRIM - W4L21866
13/16"x2 3/8"x10 15/16" (20x60x278)



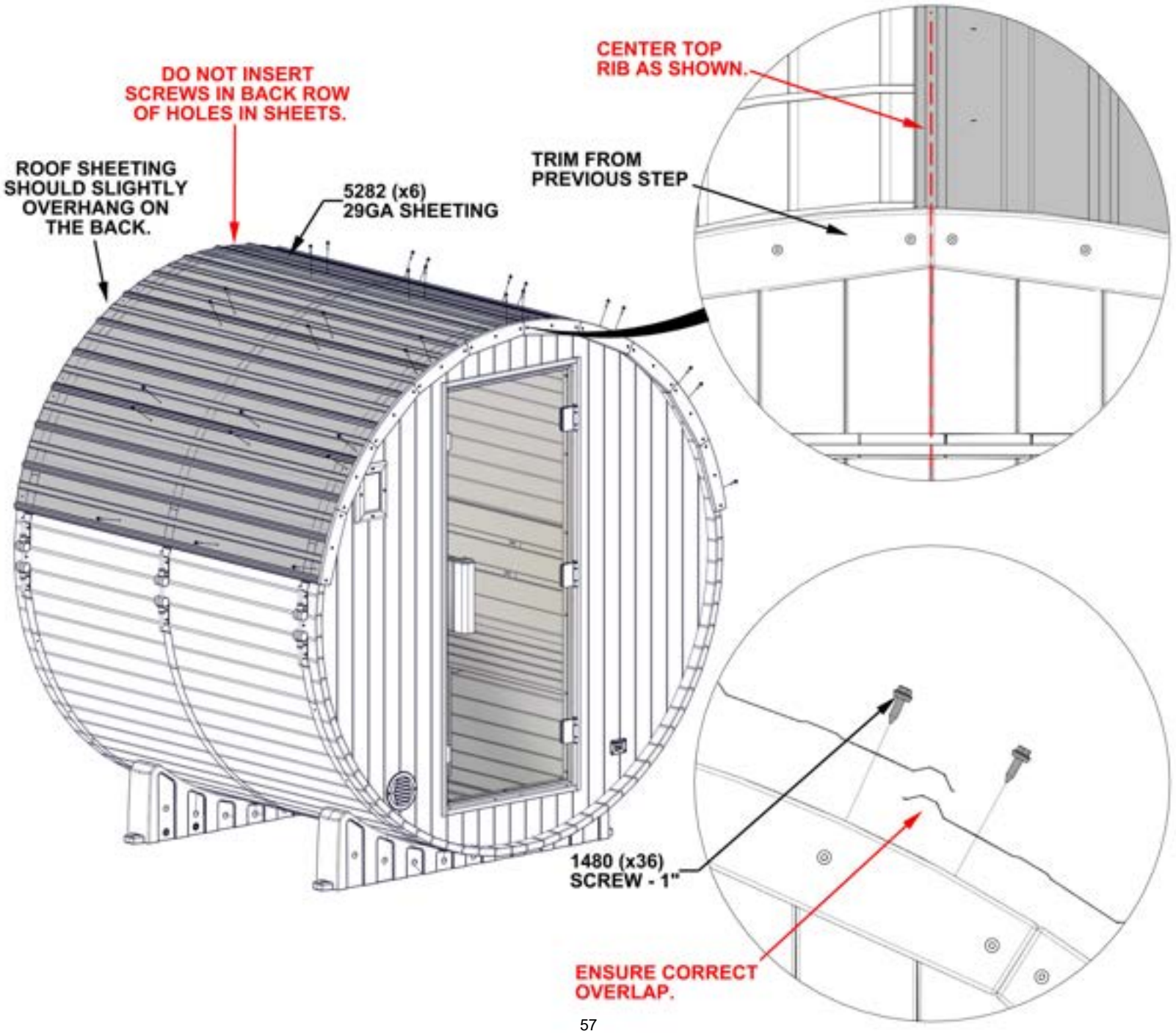
STEP 43 - METAL SHEETING

QTY	PART NUMBER	DESCRIPTION
36	H101480	SCREW SELF TAPPING #9x1 BLK



A4M05282 - 29GA SHEETING
(x6)

- WARNING: USE GLOVES WHEN HANDLING STEEL SHEETING.
- IMPORTANT: REMOVE BLUE FILM BEFORE INSTALLATION.
- INSTALL SHEETS STARTING WITH THE TOP RIGHT SHEET AS SHOWN.
- ENSURE THAT THE FIRST RIB IS CENTERED ON TOP OF THE SAUNA.
- CONTINUE INSTALLING SHEETS ON THE RIGHT SIDE OF SAUNA ENSURING CORRECT OVERLAP.
- AFTER RIGHT 3 SHEETS HAVE BEEN INSTALLED, INSTALL THE THREE LEFT SHEETS.
- IMPORTANT: EACH UPPER SHEET MUST OVERLAP THE LOWER SHEET. THIS IS CRITICAL TO AVOID LEAKING.



STEP 44 - DRIP EDGE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
12	H101480	SCREW SELF TAPPING #9x1 BLK



7398 DRIP EDGE - A4M07398
(x1) 1 9/16"x9 15/16"x49 1/4" (40x253x1251)

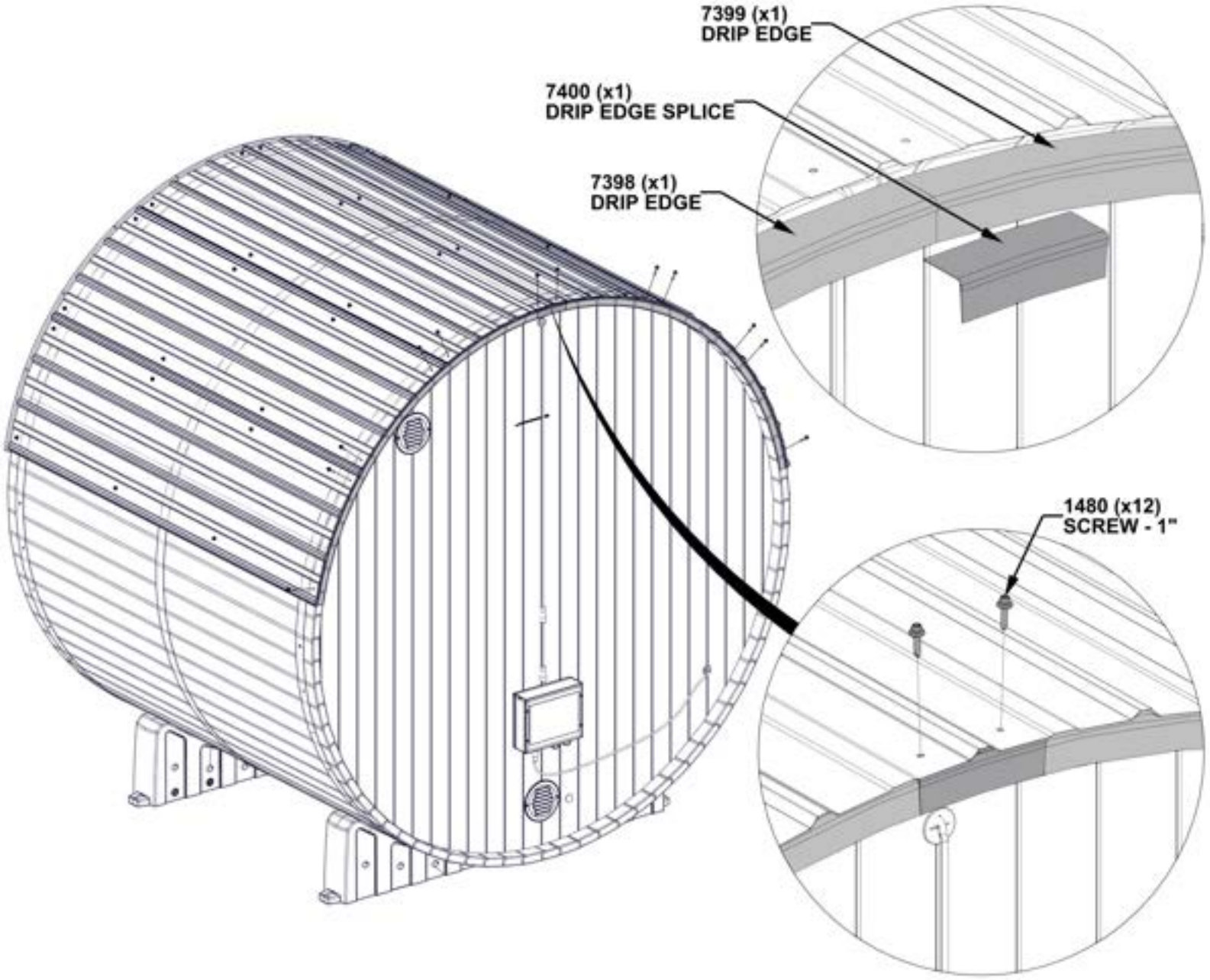


7399 DRIP EDGE - A4M07399
(x1) 1 9/16"x9 15/16"x49 1/4" (40x253x1251)



7400 DRIP EDGE SPLICE - A4M07400
(x1) 1 5/16"x1 9/16"x4 5/8" (33x40x118)

- WARNING: USE GLOVES WHEN HANDLING STEEL SHEETING.
- ENSURE 7400 IS OVERLAPPED OVER 7398 AND 7399 TO SHED WATER PROPERLY.
- SLIDE DRIP EDGE UNDER ROOF SHEETS AND ATTACH AS SHOWN.



STEP 45 - HEATER GUARD ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
20	H101428	SCREW TFH 8X1 3/4 SS-BLK



NR03 (x5) HEATER GUARD BOARD - W4L21874
13/16"x2 3/8"x16 9/16" (20x60x420)

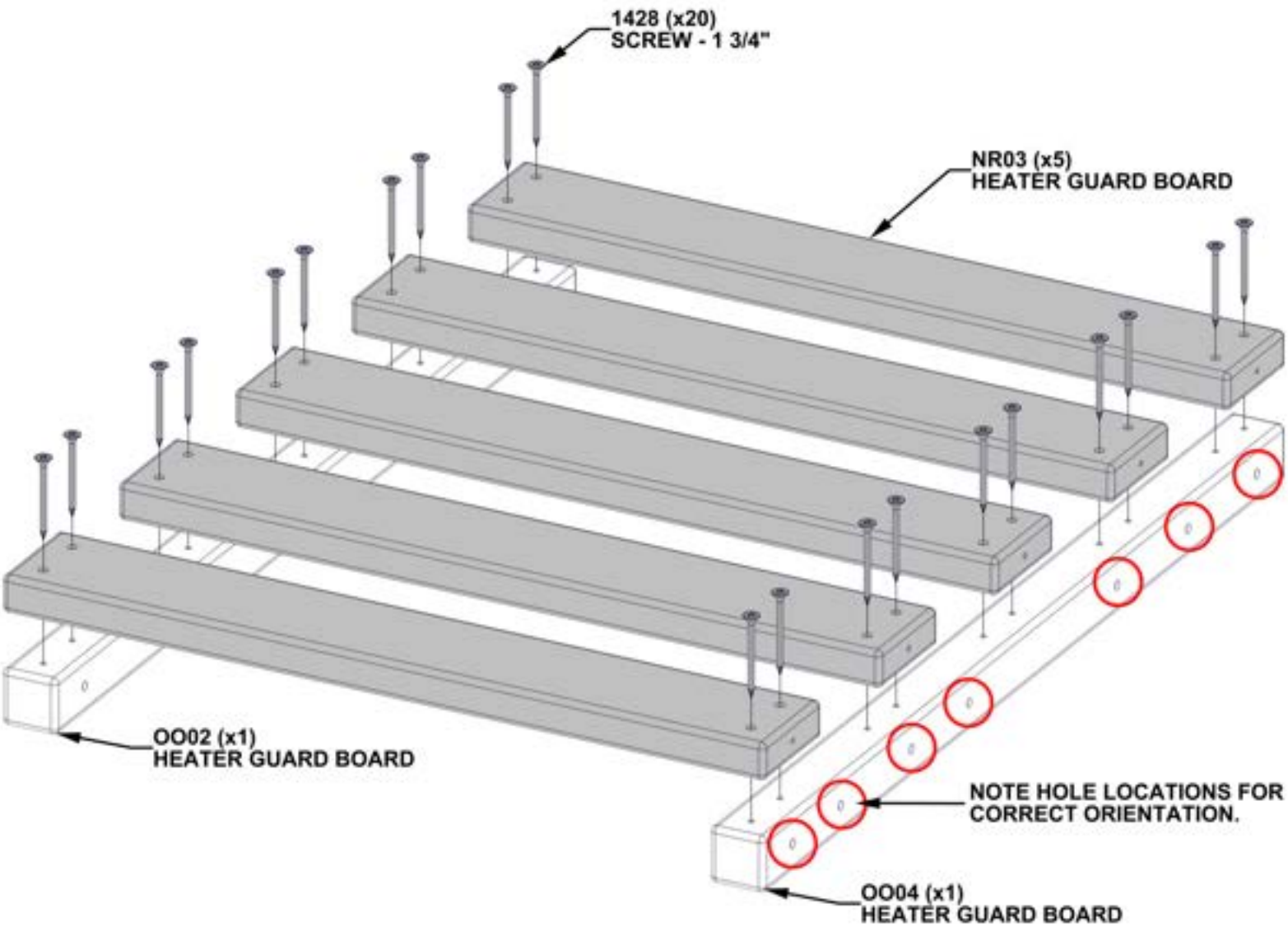


OO02 (x1) HEATER GUARD BOARD - W4L21875
1 3/16"x1 3/16"x21 7/16" (30x30x544)



OO04 (x1) HEATER GUARD BOARD - W4L21871
1 3/16"x1 3/16"x21 7/16" (30x30x544)

- ALIGN HOLES IN NR03 WITH PILOT HOLES IN OO02 AND OO04.



STEP 46 - HEATER GUARD ASSEMBLY

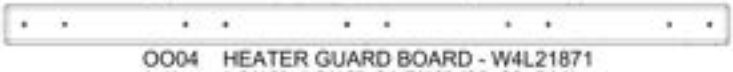
QTY	PART NUMBER	DESCRIPTION
20	H101428	SCREW TFH 8X1 3/4 SS-BLK



NR03 (x5) HEATER GUARD BOARD - W4L21874
13/16"x2 3/8"x16 9/16" (20x60x420)

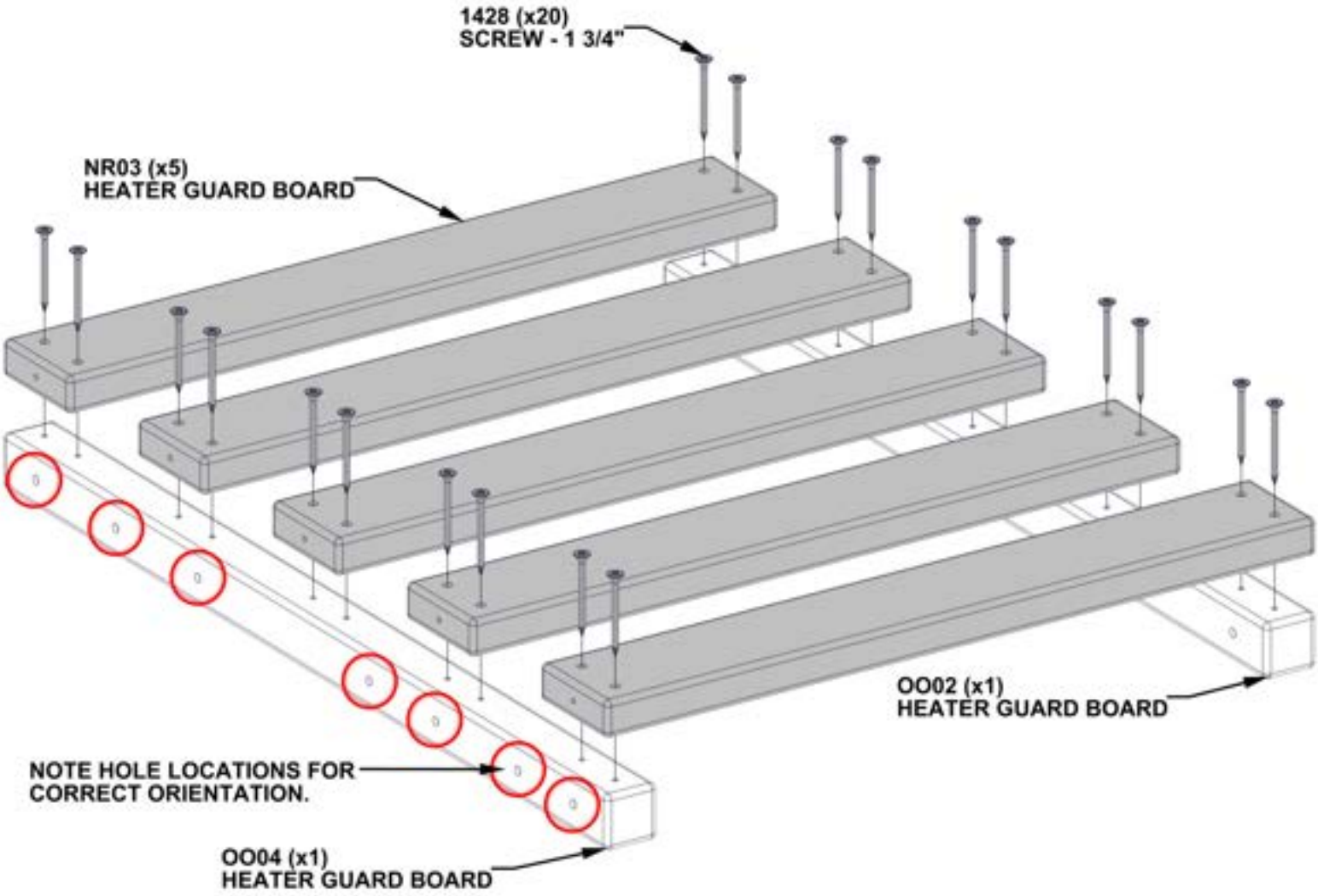


OO02 (x1) HEATER GUARD BOARD - W4L21875
1 3/16"x1 3/16"x21 7/16" (30x30x544)



OO04 (x1) HEATER GUARD BOARD - W4L21871
1 3/16"x1 3/16"x21 7/16" (30x30x544)

- ALIGN HOLES IN NR03 WITH PILOT HOLES IN OO02 AND OO04.



STEP 47 - HEATER GUARD ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
20	H101428	SCREW TFH 8X1 3/4 SS-BLK



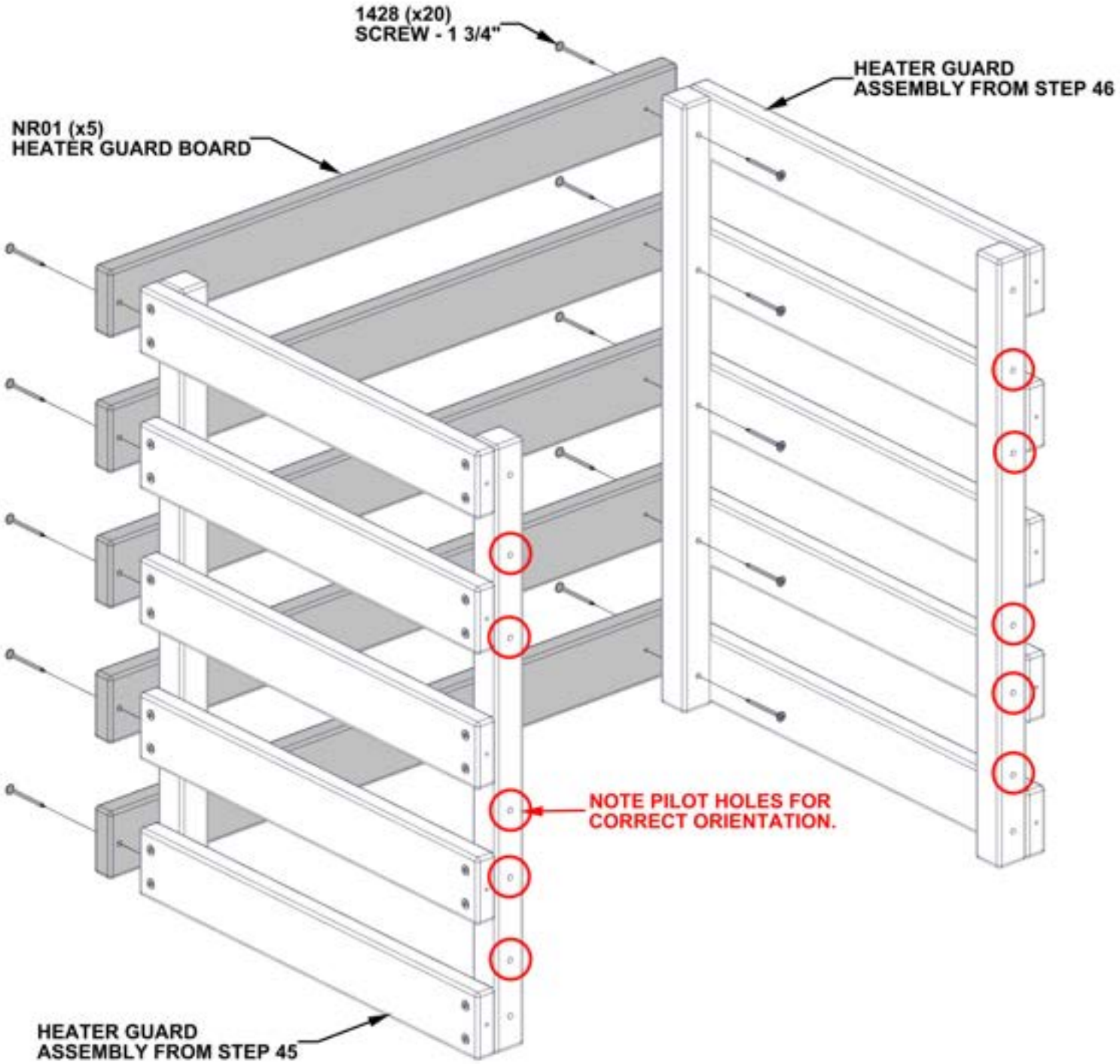
HEATER GUARD ASSEMBLY FROM STEP 45



HEATER GUARD ASSEMBLY FROM STEP 46



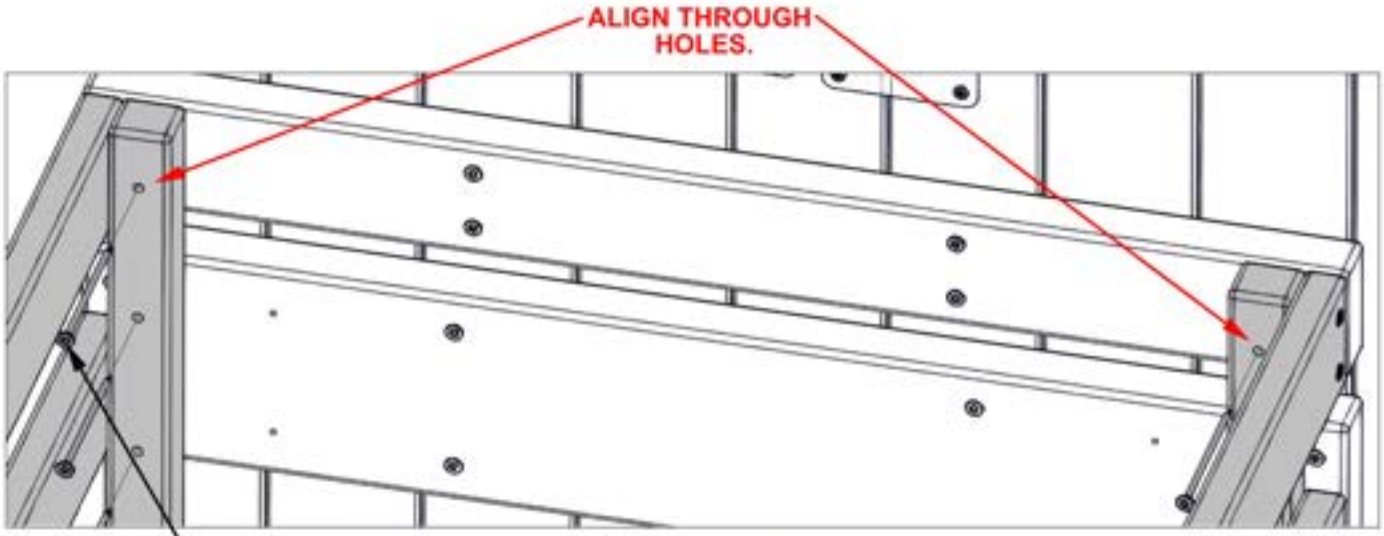
NR01 (x5) HEATER GUARD BOARD - W4L21872
13/16"x2 3/8"x23 15/16" (20x60x608)

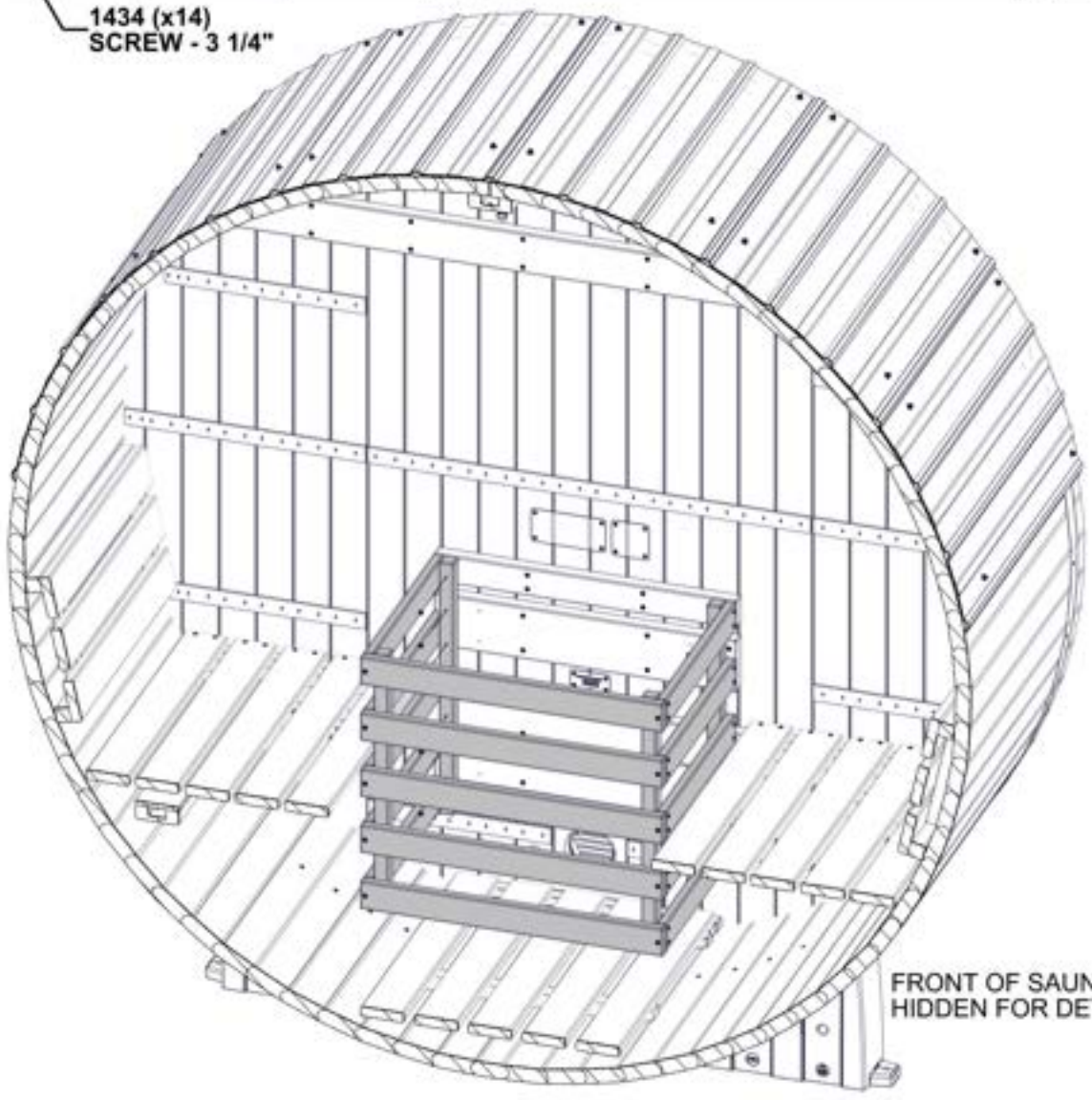


STEP 48 - HEATER GUARD ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
14	H101434	SCREW TFH 8X3 1/4 SS-BLK

- POSITION HEATER GUARD ASSEMBLY AS SHOWN.
- ALIGN TOP AND BOTTOM THROUGH HOLES WITH THROUGH HOLES IN PREVIOUSLY INSTALLED GUARD MOUNTING BOARDS AND ATTACH.
- ENSURE SIDES OF THE HEATER GUARD ASSEMBLY ARE FLUSH WITH THE ENDS OF THE PREVIOUSLY INSTALLED HEATER SPACER BOARDS.

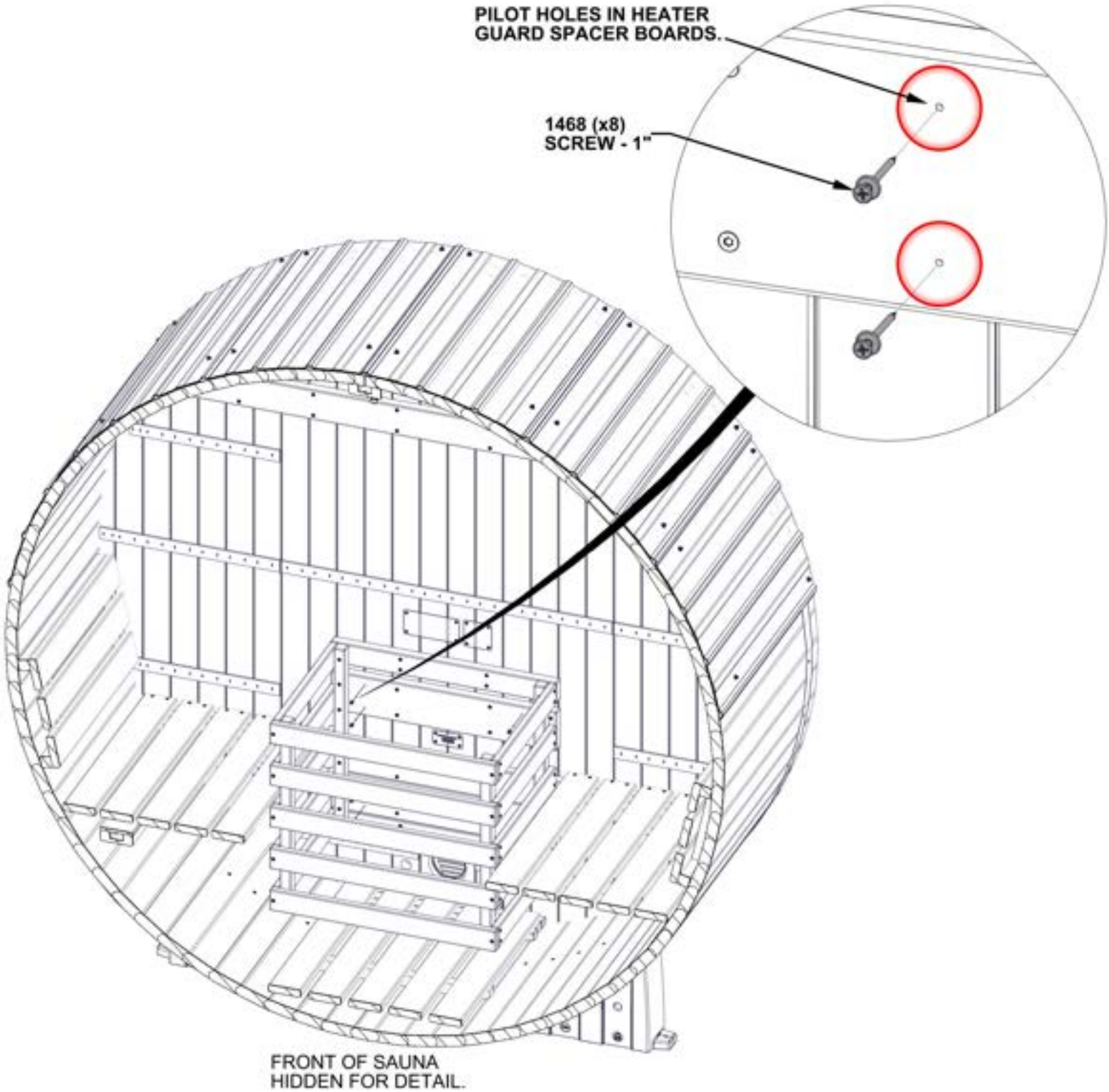




STEP 49 - HEATER MOUNT INSTALLATION

QTY	PART NUMBER	DESCRIPTION
8	H101468	SCREW RAISED HEAD 8x1 BLK

- INSERT SCREWS INTO PILOT HOLES IN HEATER GUARD SPACER BOARDS.



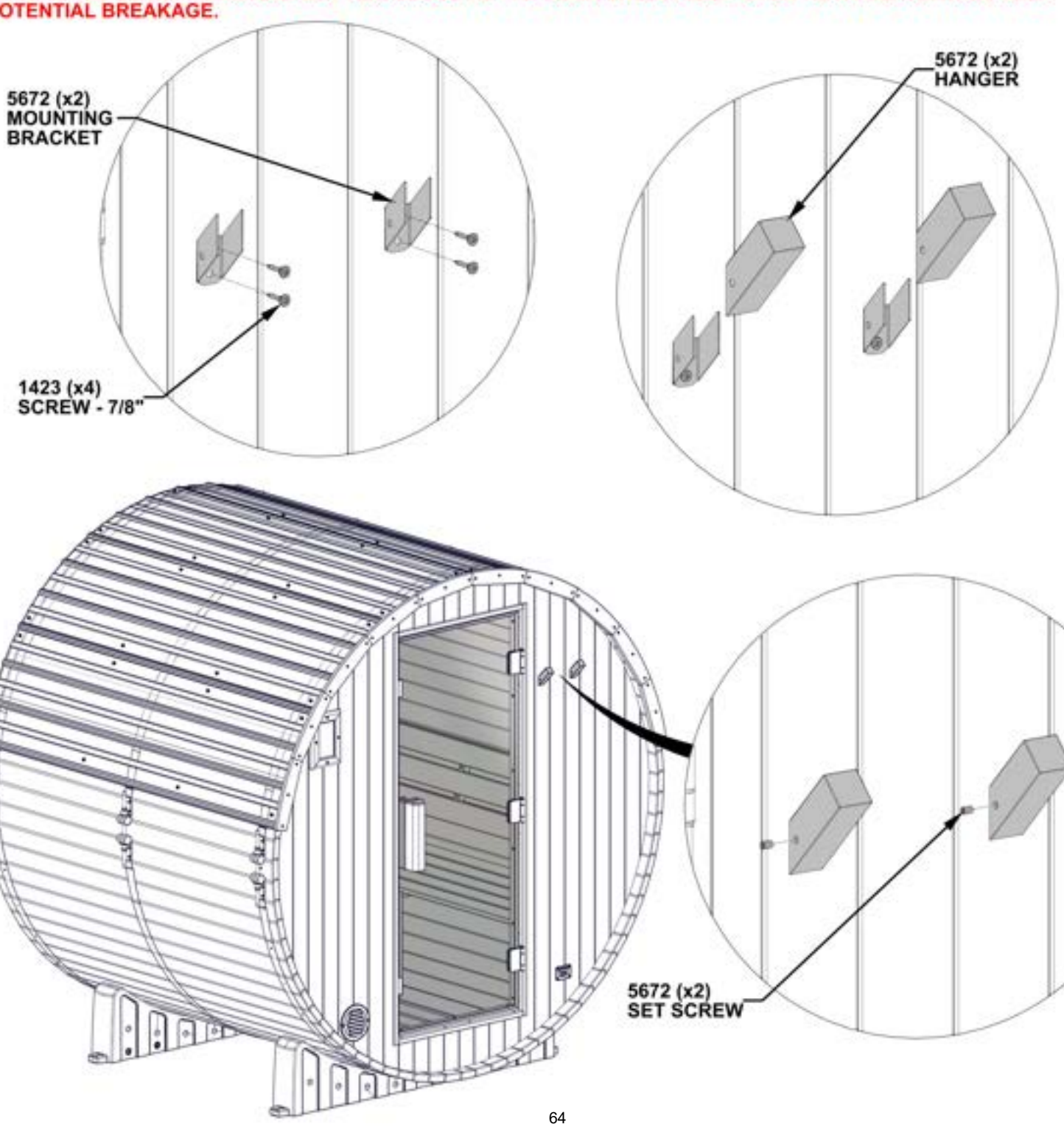
STEP 50 - TOWEL HANGER INSTALLATION

QTY	PART NUMBER	DESCRIPTION
4	H101423	SCREW TFH 8X7/8 SS-BLK



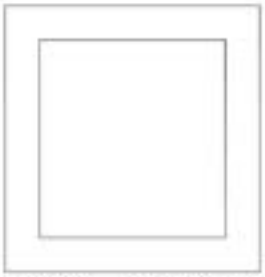
A4M05672 (x2) TOWEL HANGER

- INSTALL TOWEL HANGERS AT ANY DESIRED LOCATION ON THE RIGHT SIDE.
- HOWEVER, DO NOT INSTALL SCREWS AT THE SEAMS OF PANEL BOARDS.
- ENSURE TOWEL HANGERS ARE NOT TOO CLOSE TO THE DOOR WHEN FULLY OPEN TO AVOID CONTACT AND POTENTIAL BREAKAGE.



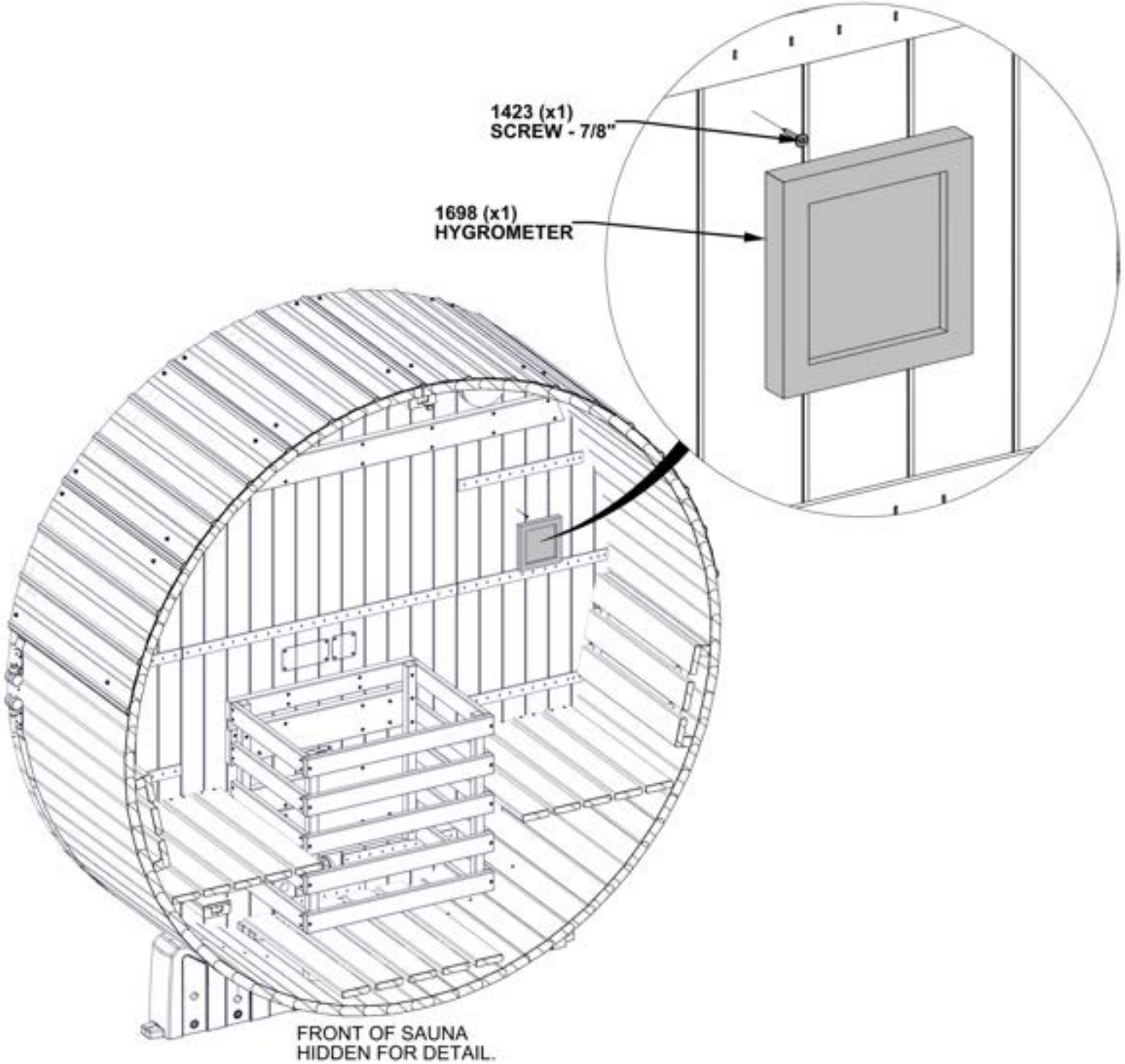
STEP 51 - HYGROMETER INSTALLATION

QTY	PART NUMBER	DESCRIPTION
1	H101423	SCREW TFH 8X7/8 SS-BLK



A6P01698 (x1) HYGROMETER

- INSERT SCREW INTO BACK WALL IN APPROXIMATE LOCATION SHOWN AND HANG HYGROMETER ON IT.

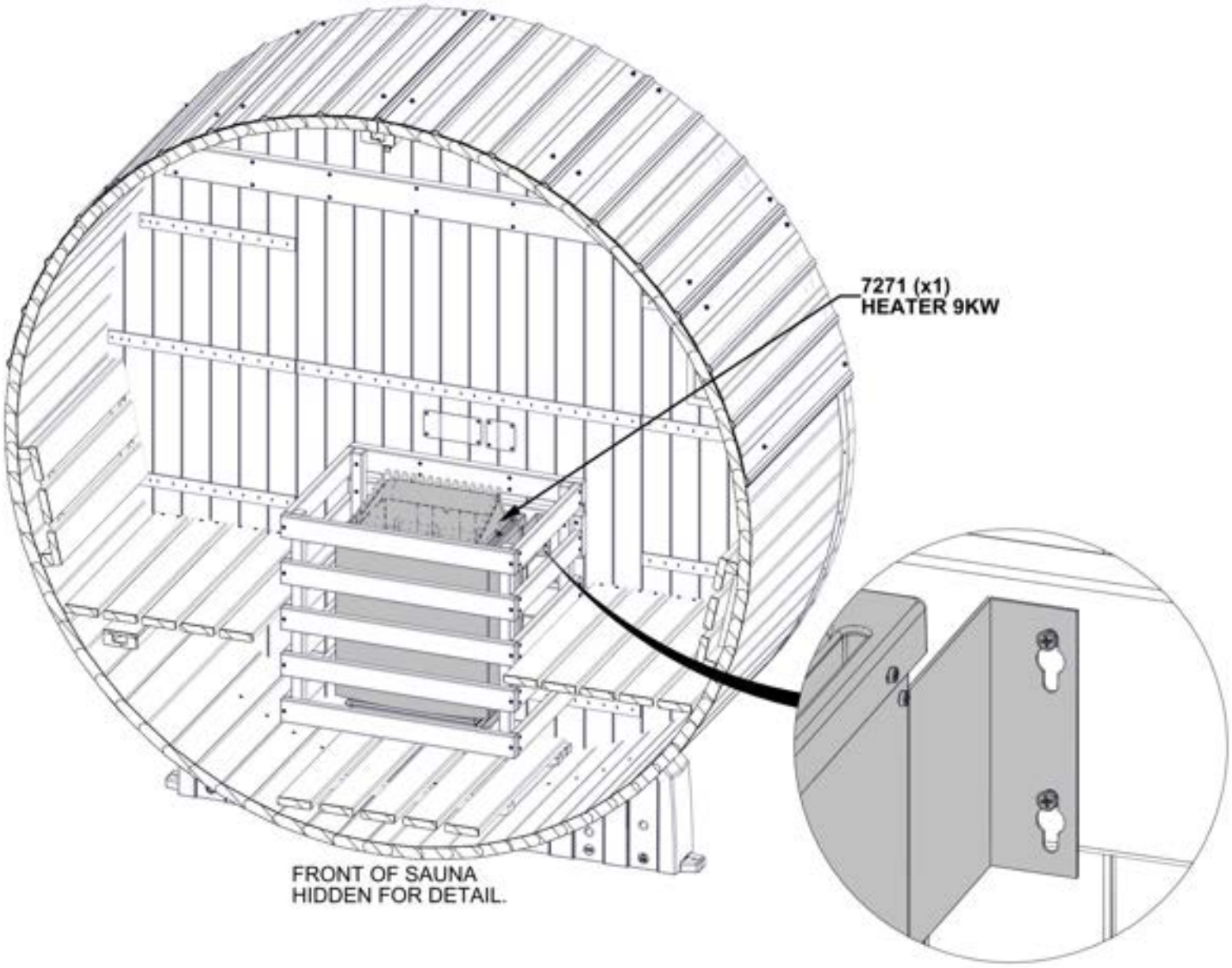


STEP 52 - HEATER INSTALLATION



A4M07271 HEATER 9KW
(x1)

- CAUTION: IMPROPER INSTALLATION OF THE HEATER COULD CAUSE HEATER TO FALL CAUSING BURNS OR OTHER INJURIES.
- DANGER! TURN OFF POWER TO THE HEATER AT THE BREAKER BEFORE BEGINNING INSTALLATION OR PERFORMING ANY MAINTENANCE. FAILURE TO TURN OFF THE POWER CAN RESULT IN ELECTROCUTION AND EVEN DEATH.
- LICENSED ELECTRICIAN REQUIRED FOR HEATER INSTALLATION - SEE HEATER INSTRUCTIONS.
- HANG HEATER ONTO SCREWS, ENSURING ALL 8 SCREWS ARE ALIGNED INTO THE SLOTS IN THE HEATER AS SHOWN.



STEP 53 - ELECTRICAL

QTY	PART NUMBER	DESCRIPTION
5	H101409	SCREW PPH 4x1/2 BLK



A6P01468 30mm SILICONE GROMMET
(x1)

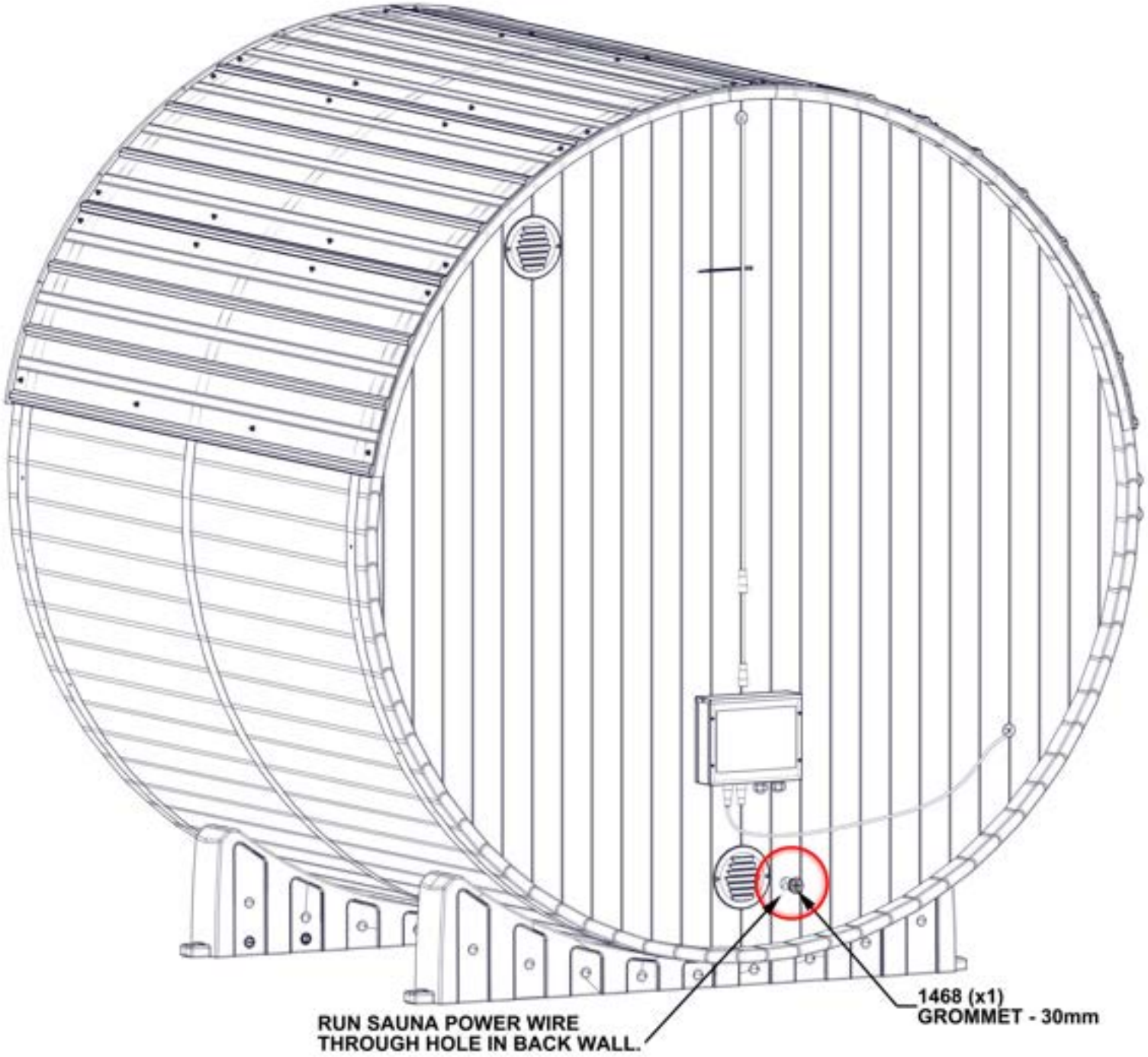


A6P01732 SAUNA POWER WIRE
(x1)



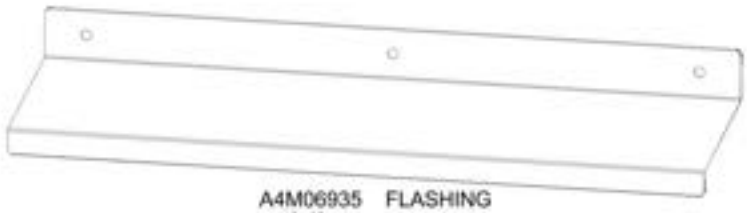
A6P01448 ZIP CABLE TIE
(x5)

- USE PROVIDED GROMMET FOR POWER WIRE.
- SEE HEATER INSTRUCTIONS FOR INSTALLATION.
- WILL NEED TO REMOVE CONDUIT FITTING TO FEED SAUNA POWER WIRE THROUGH GROMMET.



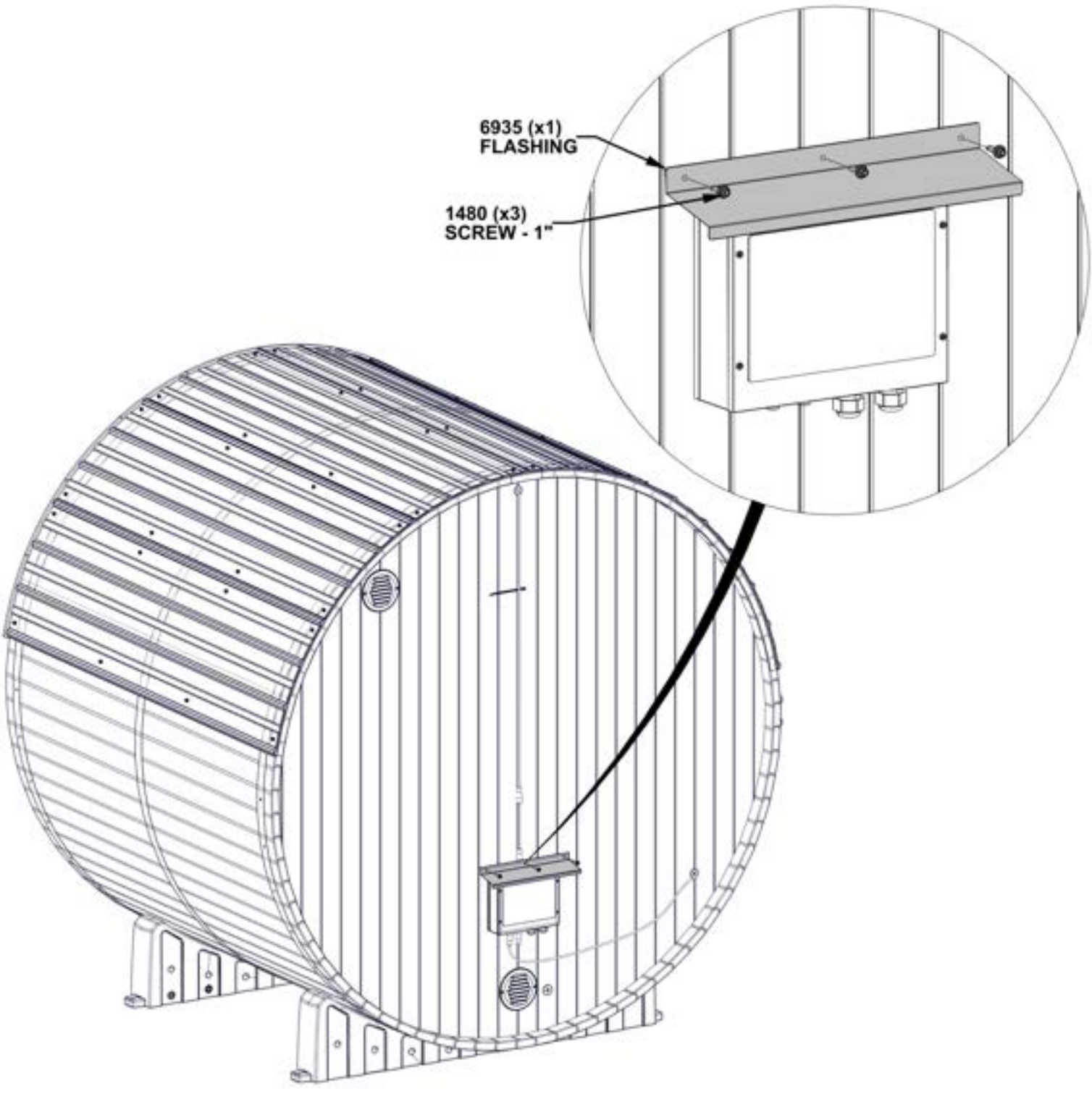
STEP 54 - FLASHING INSTALLATION

QTY	PART NUMBER	DESCRIPTION
3	H101480	SCREW SELF TAPPING #9x1 BLK



A4M06935 FLASHING
(x1)

- CENTER FLASHING OVER THE CONTROL BOX AND ATTACH AS SHOWN.



STEP 55 - FINISH

ONCE THE ASSEMBLY IS COMPLETE, SWEEP AND VACUUM THE INSIDE OF THE SAUNA. WIPE DOWN THE ENTIRE SAUNA WITH A DAMP CLOTH TO REMOVE ANY REMAINING DIRT, DUST, AND DEBRIS. DO NOT USE CHEMICAL-BASED CLEANING AGENTS INSIDE THE SAUNA.

