



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

2-4 PERSON OUTDOOR BARREL SAUNA

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

THE ASSEMBLY MANUAL MUST BE RETAINED SINCE IT CONTAINS IMPORTANT INFORMATION

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



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



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



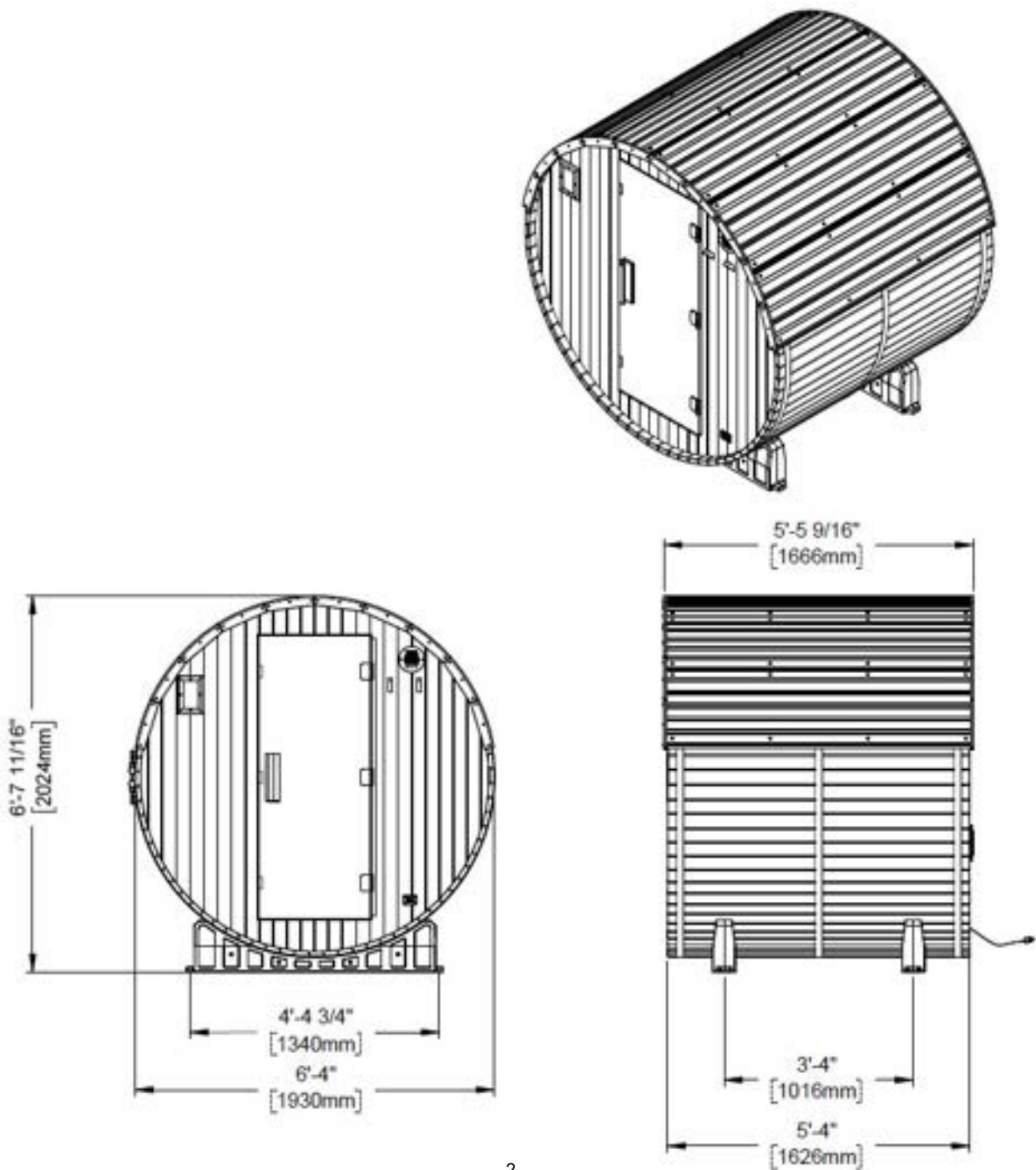
OWNER'S MANUAL - BASIC SETUP DIMENSIONS & ASSEMBLY NOTES

CHOOSE A GOOD LOCATION FOR YOUR SAUNA!

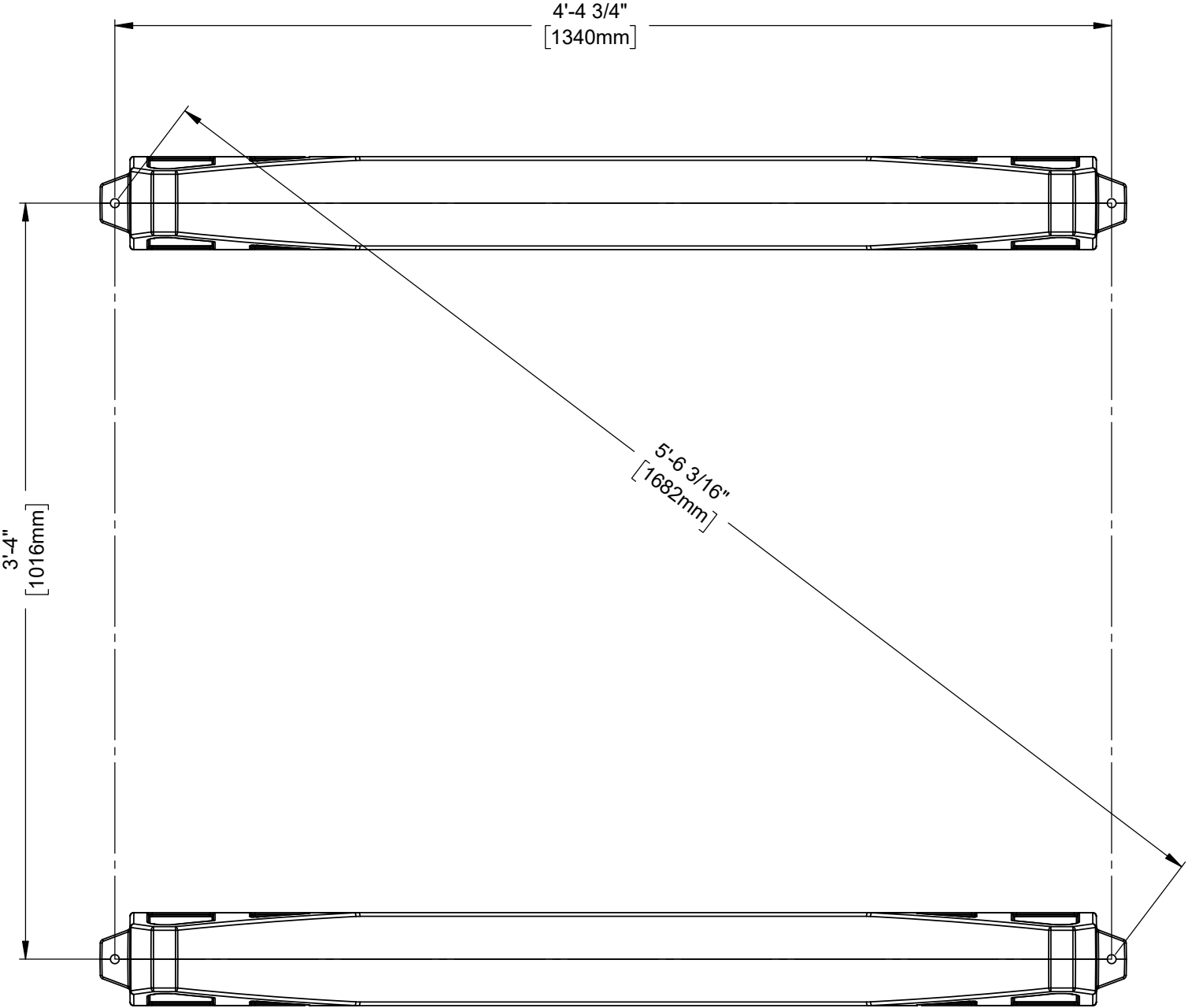
It is critically important the sauna foundation is sturdy and level.
An unstable foundation can cause the sauna to tilt, shift, or fall, leading to injury.

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 situation, 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)



AM02 DOOR HANDLE - W2A04795
(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 - W4L21866
(x20) 13/16"x2 3/8"x10 15/16" (20x60x278)



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



OG01 PERIMETER BOARD - W4L21857
(x61) 1 3/16"x3 3/8"x64" (30x86x1626)



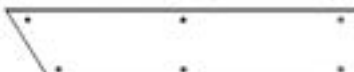
OG02 PERIMETER BOARD - W4L21858
(x1) 64"x3 3/8"x1 3/16" (30x86x1626)



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



OG04 BENCH BRACE - W4L21860
(x2) 1 3/16"x3 3/8"x16 3/8" (30x86x416)



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



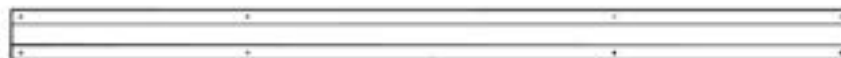
OG06 WALL CLEAT - W4L21863
(x1) 1 3/16"x3 3/8"x17 3/16" (30x86x437)



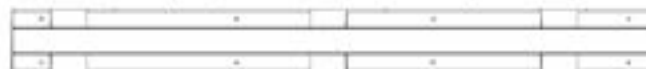
OG07 WALL CLEAT - W4L21867
(x1) 1 3/16"x3 3/8"x83 15/16" (30x86x1624)



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



OG10 WIREWAY BOARD - W4L21877
(x1) 1 3/16"x3 3/8"x55 1/16" (30x86x1398)



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)



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



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



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

OWNER'S MANUAL - PARTS IDENTIFICATION

WOOD COMPONENTS (NOT TO SCALE)



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

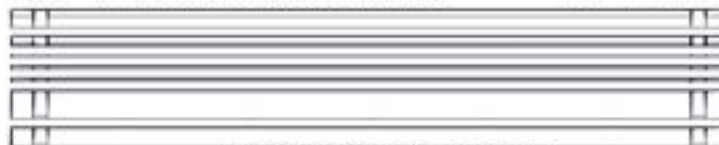


OR01 GUARD MOUNTING BOARD - W4L21873
(x2) 1 3/16"x2 3/8"x23 15/16" (30x60x608)

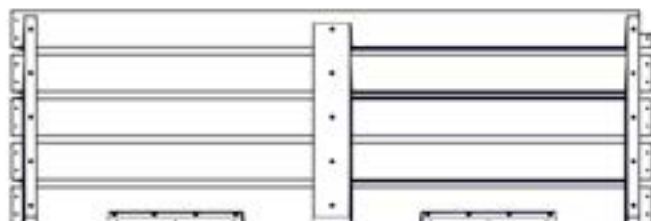
TF01 TRIM FRAME - W2A04797
(x1) 7/8"x5 9/16"x8 1/16" (22x142x204)



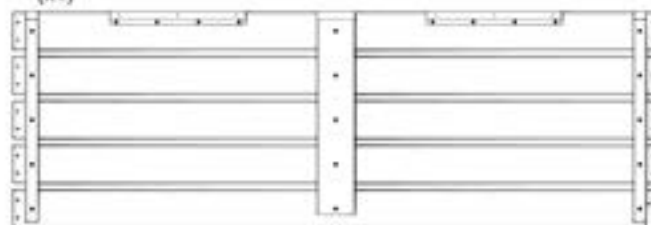
OV01 HEATER GUARD SPACER - W4L21887
(x2) 1 3/16"x4 7/16"x23 15/16" (30x112x608)



BOARD SPACER KIT - W2A04798
(x1)



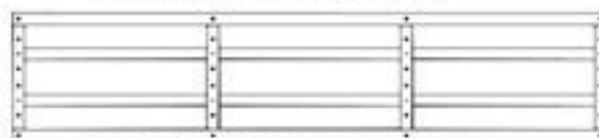
BA01 RIGHT BENCH ASSEMBLY - W2A04788
(x1) 1 15/16"x19 1/8"x57 5/16" (50x486x1456)



BA02 LEFT BENCH ASSEMBLY - W2A04789
(x1) 19 1/8"x57 5/16" (50x486x1456)



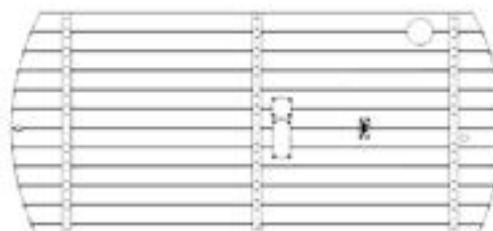
BR01 WALL BACK REST - W2A04790
(x2) 1 15/16"x12 1/16"x14" (50x306x306)



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



WP01 WALL PANEL ASSEMBLY - W2A04784
(x1) 1 3/8"x19 11/16"x65 3/4" (35x500x1169)



WP02 WALL PANEL ASSEMBLY - W2A04785
(x1) 1 3/8"x35 5/8"x74 9/16" (35x906x1894)



WP03 WALL PANEL ASSEMBLY - W2A04786
(x1) 1 3/8"x20 1/8"x66 1/4" (35x512x1199)



WP04 WALL PANEL ASSEMBLY - W2A04794
(x1) 2 3/8"x35 5/8"x74 9/16" (60x906x201)



WP05 WALL PANEL - W2A04792
(x1) 1 3/8"x19 11/16"x65 3/4" (35x500x1337)



WP06 WALL PANEL ASSEMBLY - W2A04809
(x1) 1 3/8"x20 1/8"x66 1/4" (35x512x1491)



FP01 FLOOR PANEL ASSEMBLY - W2A04796
(x1) 1 15/16"x20 7/8"x55 7/8" (50x530x1420)

OWNER'S MANUAL - PARTS IDENTIFICATION

ACCESSORY COMPONENTS (NOT TO SCALE)



A4M05282 29 GA SHEETING
(x6)



A4M05673 BUCKET
(x1)



A4M05596 LADLE
(x1)



W4L21965 THERMOMETER
(x1)



A6P01466 BASE SUPPORT
(x2)



A6P01493-01 REMOTE MODULE
(x1)



A6P01493-02 LED LIGHT
(x1)



A6P01493-03 LED POWER SUPPLY
(x1)



A6P01493-04 LIGHT CLIP
(x2)



A6P01493-05 REMOTE
(x1)



A4M05285 VENT COVER
(x2)



A6P01467 25mm SILICONE GROMMET
(x4)



A6P01468 30mm SILICONE GROMMET
(x1)



A4M05590-01 CONTROL PANEL
(x1)



A4M05590-02 CONTROL PANEL
(x1)



A4M05277 BANDING
(x3)



A4M05671 BANDING CINCH
(x3)



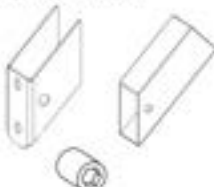
CONTROL PANEL
MOUNTING BRACKET
(x1)



A4M05590-08 TEMPERATURE SENSOR
(x1)



A4M05667 GROUND STAKE REBAR
(x4)



A4M05672 HANGER
(x2)



A4M05590-10 WIRING HARNESS
(x1)



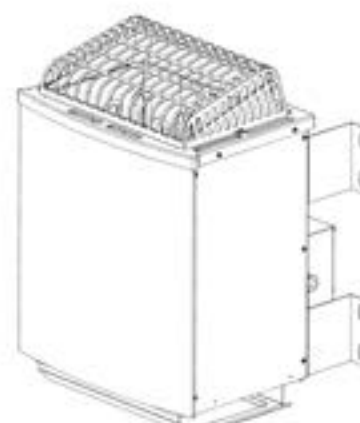
A4M05592 VENT ASSEMBLY
(x1)



A6P01448 ZIP CABLE TIE
(x10)



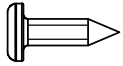
A6P01489 SAUNA POWER WIRE
(x1)



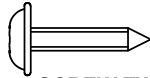
9250253 HEATER
(x1)

OWNER'S MANUAL - PARTS IDENTIFICATION

Hardware Components



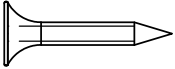
H101409 SCREW PPH 4x1/2 BLK
(x10) 4x1/2



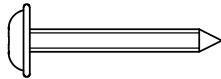
H101437 SCREW TWH 8x5/8 SS-BLK
(x12) 8x5/8



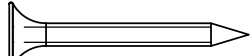
H100627 SCREW PFH BLK
(x2) 6x3/4



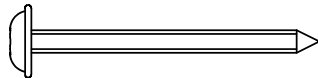
H101423 SCREW TFH 8x7/8 SS-BLK
(x5) 8x7/8



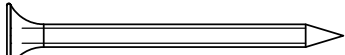
H101440 SCREW TWH 8x1 SS-BLK
(x5) 8x1



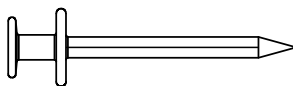
H101426 SCREW TFH 8x1 1/4 SS-BLK
(x3) 8x1-1/4



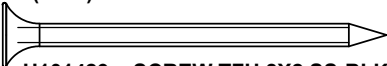
H101443 SCREW TWH 8x1 1/2 SS-BLK
(x4) 8x1-1/2



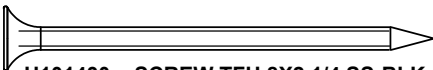
H101428 SCREW TFH 8x1 3/4 SS-BLK
(x102) 8x1-3/4



H101468 SCREW RAISED HEAD 8x1
(x8) 8x1



H101429 SCREW TFH 8x2 SS-BLK
(x212) 8x2



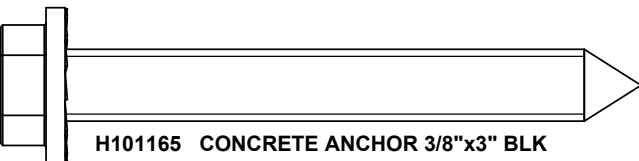
H101430 SCREW TFH 8x2 1/4 SS-BLK
(x16) 8x2 1/4



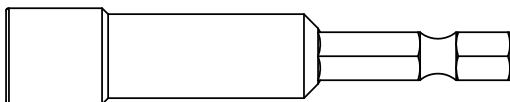
H101431 SCREW TFH 8x2 1/2 SS-BLK
(x10) 8x2-1/2



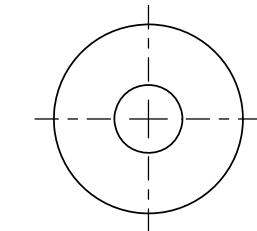
H101434 SCREW TFH 8x3 1/4 SS-BLK
(x14) 8x3 1/4



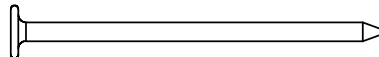
H101165 CONCRETE ANCHOR 3/8"x3" BLK
(x4) 3/8x3



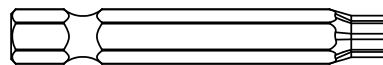
H101106 HEX DRIVER
(x1) 5/16



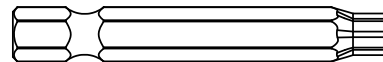
H101403 POLY WASHER
(x4)



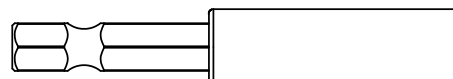
H101413 NAIL STD HD GLV
(x28)



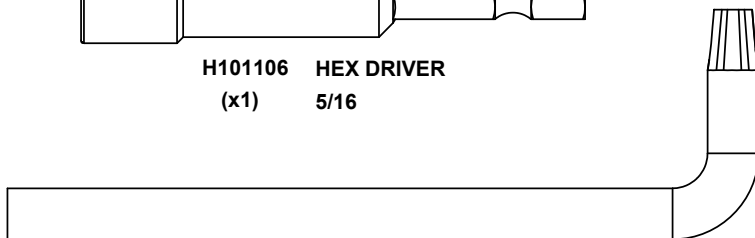
H100147 TORX BIT
(x1) T-30



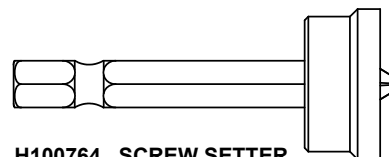
H100879 TORX BIT
(x1) T-20



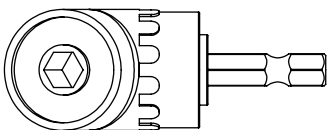
H101100 MAGNETIC DRIVER
(x1)



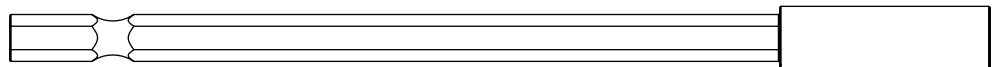
H100114 TORX WRENCH
(x1) T-30



H100764 SCREW SETTER
(x1)



H101114 | RIGHT ANGLE DRILL ADAPTER
(x1)



H101278 MAGNETIC DRIVER EXTENSION
(x1) 6"

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:

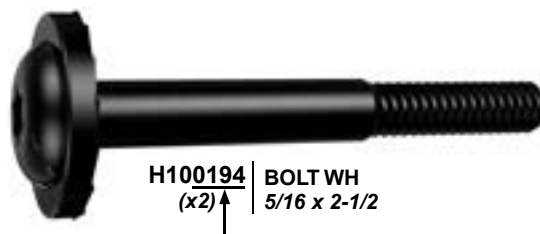
- Organize wood parts by the three-digit, alpha-numeric number stamped on each board (ex. P01).
- If there are multiple boards with the same stamped number, stack those pieces together.
- Stamps can be found on the flat surface of the boards or on the end of the boards.
- Allow yourself plenty of room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



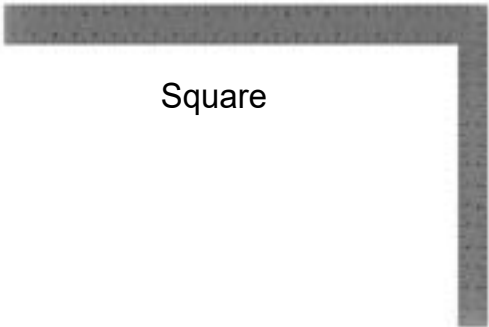
3/8" Drive Ratchet, 1/2" &
7/16" STD Sockets, 1/2" &
7/16" Deep Sockets



Tape Measure



Claw Hammer



Square



Level 24"



Rubber Mallet -
Optional



Rope 25ft [7.62m] long - Optional

PRE-ASSEMBLY STEP 3 - CHOOSE YOUR ASSEMBLY METHOD

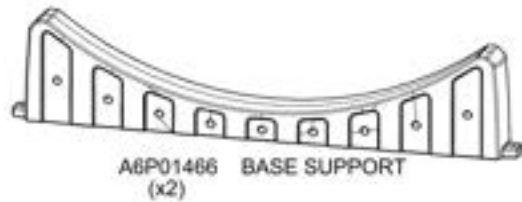
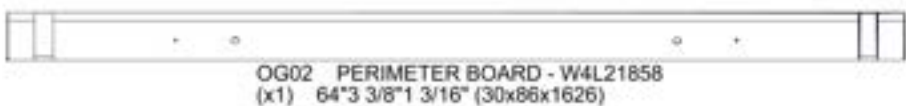
There are several types of assembly instructions available to you.

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)

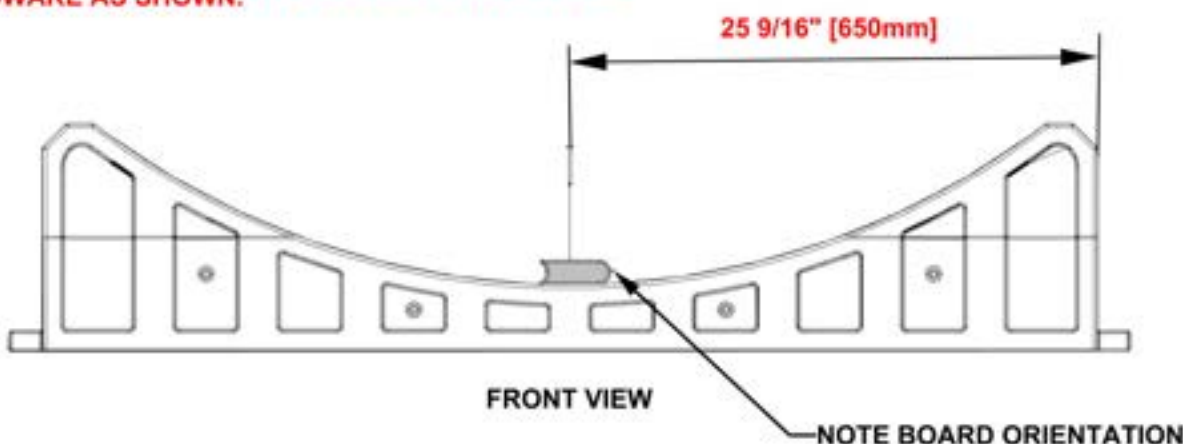
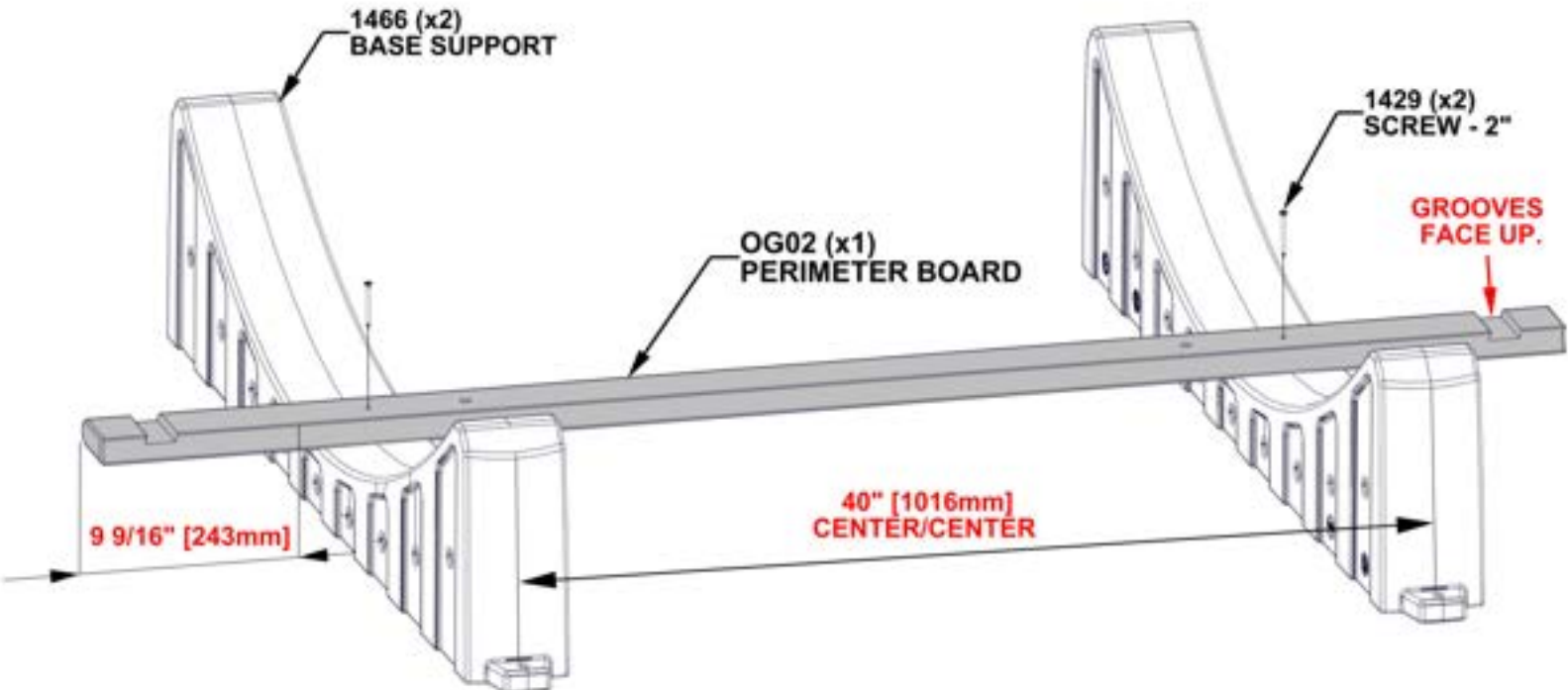


STEP 1 - BARREL ASSEMBLY

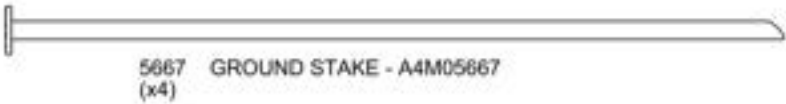
QTY	PART NUMBER	DESCRIPTION
2	H101429	SCREW TFH 8X2 SS-BLK



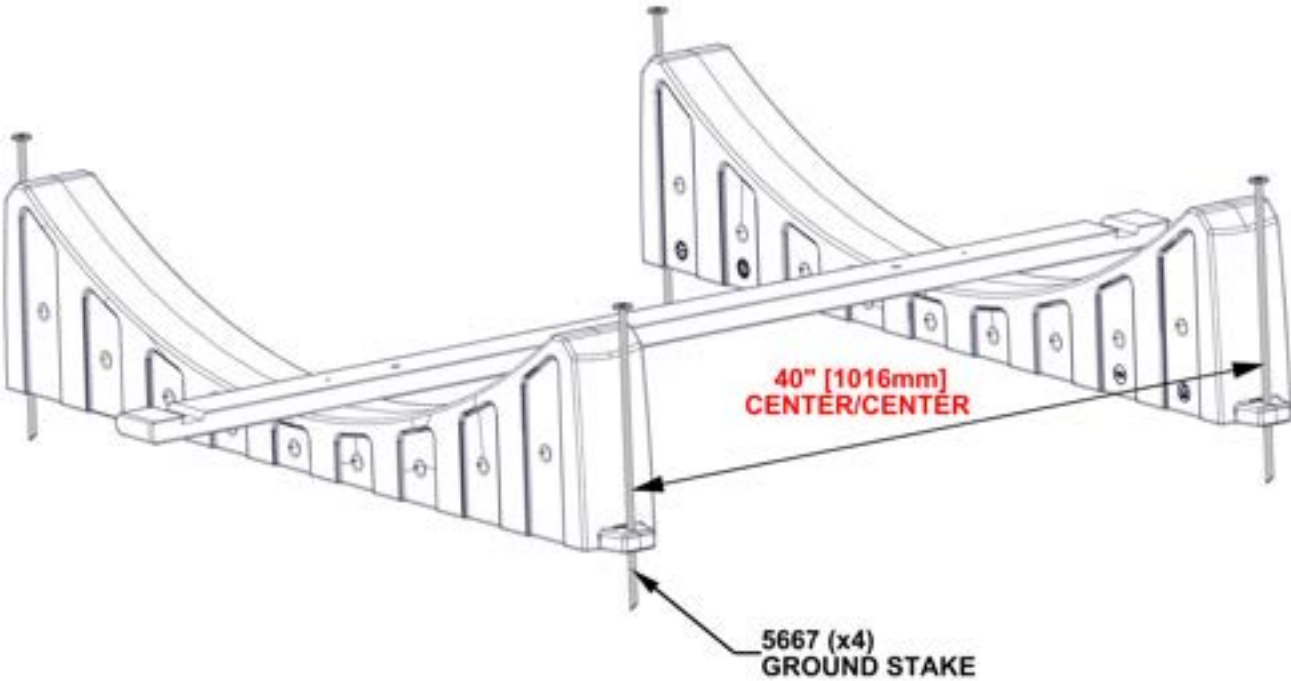
- STAND BASE SUPPORTS UP AND HOLD DIMENSIONS SHOWN.
- ATTACH HARDWARE AS SHOWN.



STEP 2 - ANCHORING TO GROUND



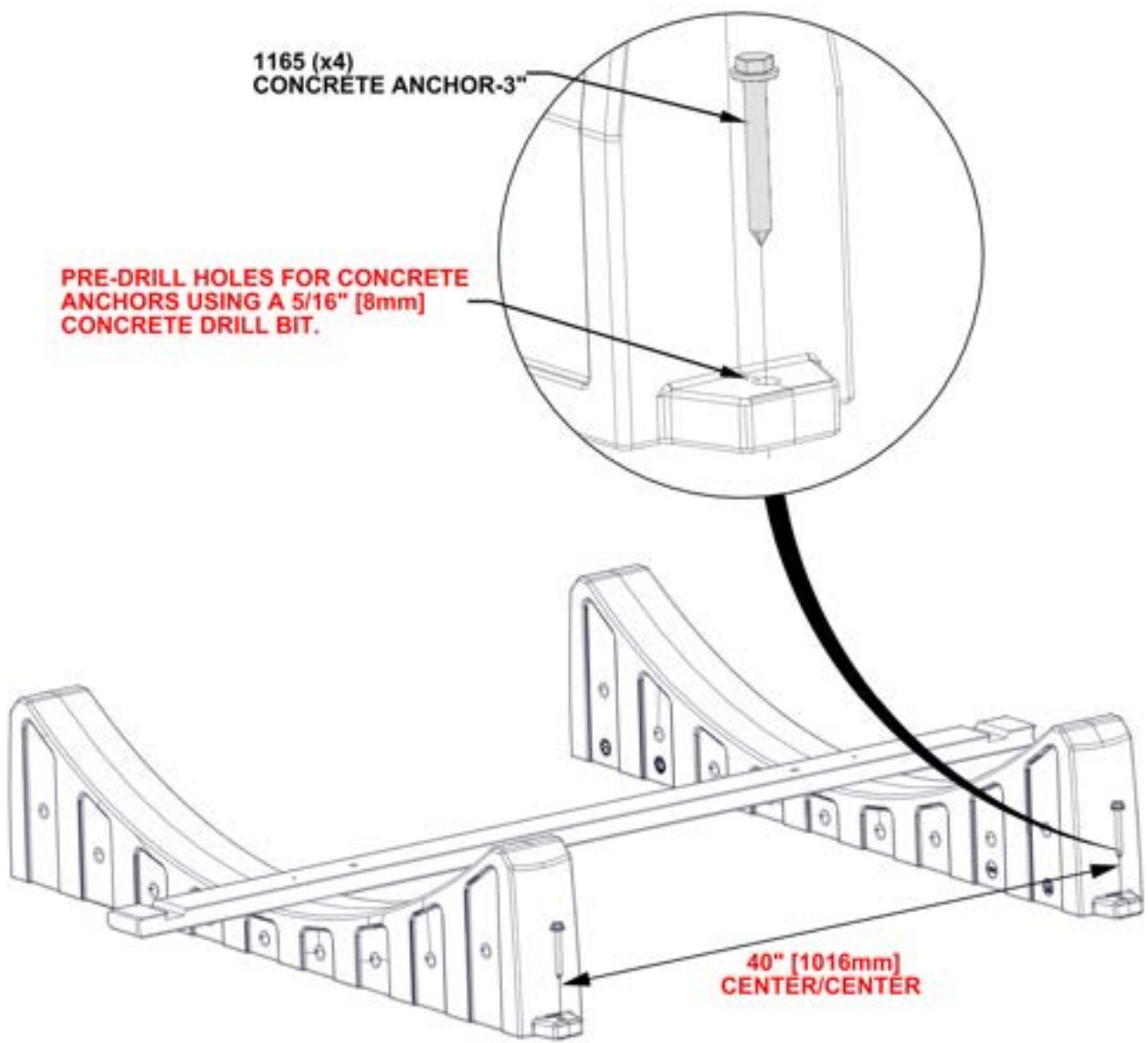
- IF BARREL SAUNA IS TO SIT ON A CONCRETE SURFACE SEE STEP 3.



STEP 3 - ANCHORING TO CONCRETE

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

- IF BARREL SAUNA IS TO SIT ON THE GROUND SEE STEP 2.

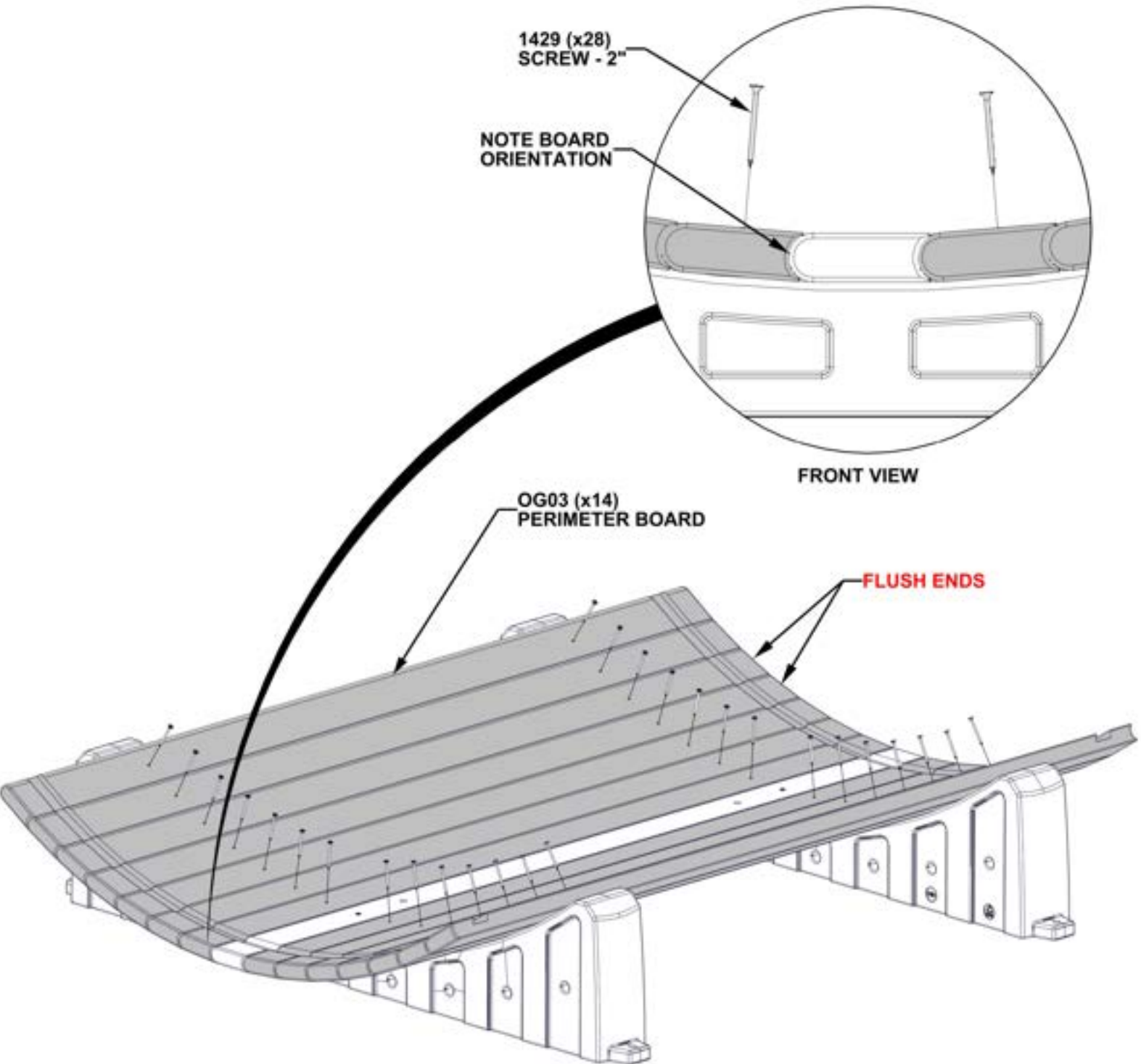


STEP 4 - BARREL ASSEMBLY

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



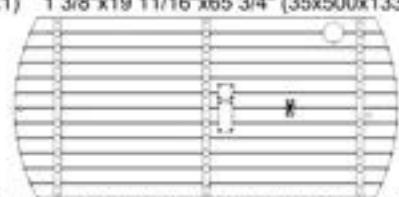
OG03 PERIMETER BOARD - W4L21859
(x14) 1 3/16"x3 3/8"x64" (30x86x1626)



STEP 5A - BACK WALL ASSEMBLY

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

WP01 WALL PANEL ASSEMBLY - W2A04784
(x1) 1 3/8"x19 11/16"x65 3/4" (35x500x1337)



WP02 WALL PANEL ASSEMBLY - W2A04785
(x1) 1 3/8"x35 5/8"x74 9/16" (35x906x1894)

WP03 WALL PANEL ASSEMBLY - W2A04786
(x1) 1 3/8"x20 1/8"x66 1/4" (35x512x1596)

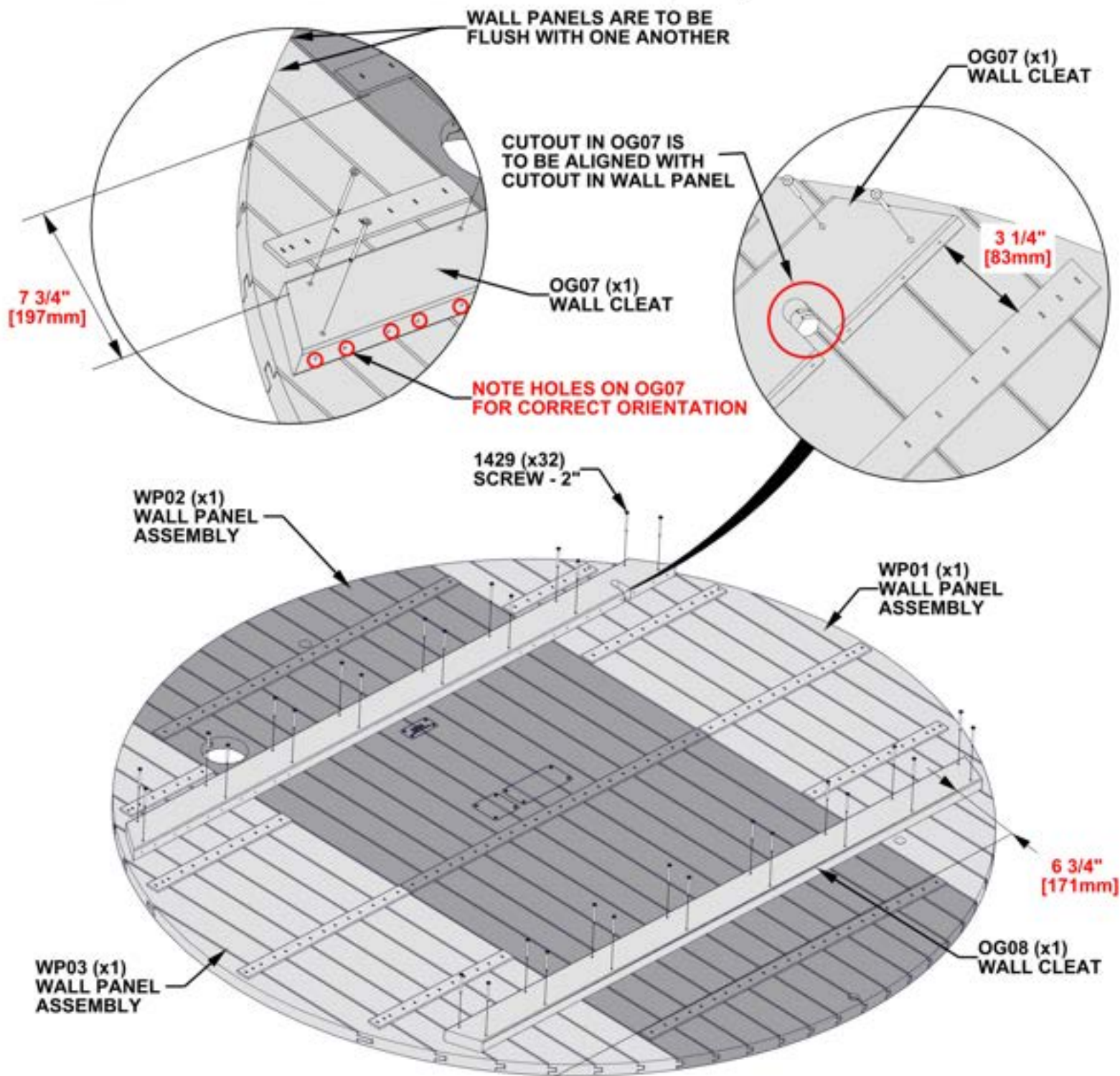


OG07 WALL CLEAT - W4L21867
(x1) 1 3/16"x3 3/8"x63 15/16" (30x86x1624)



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

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

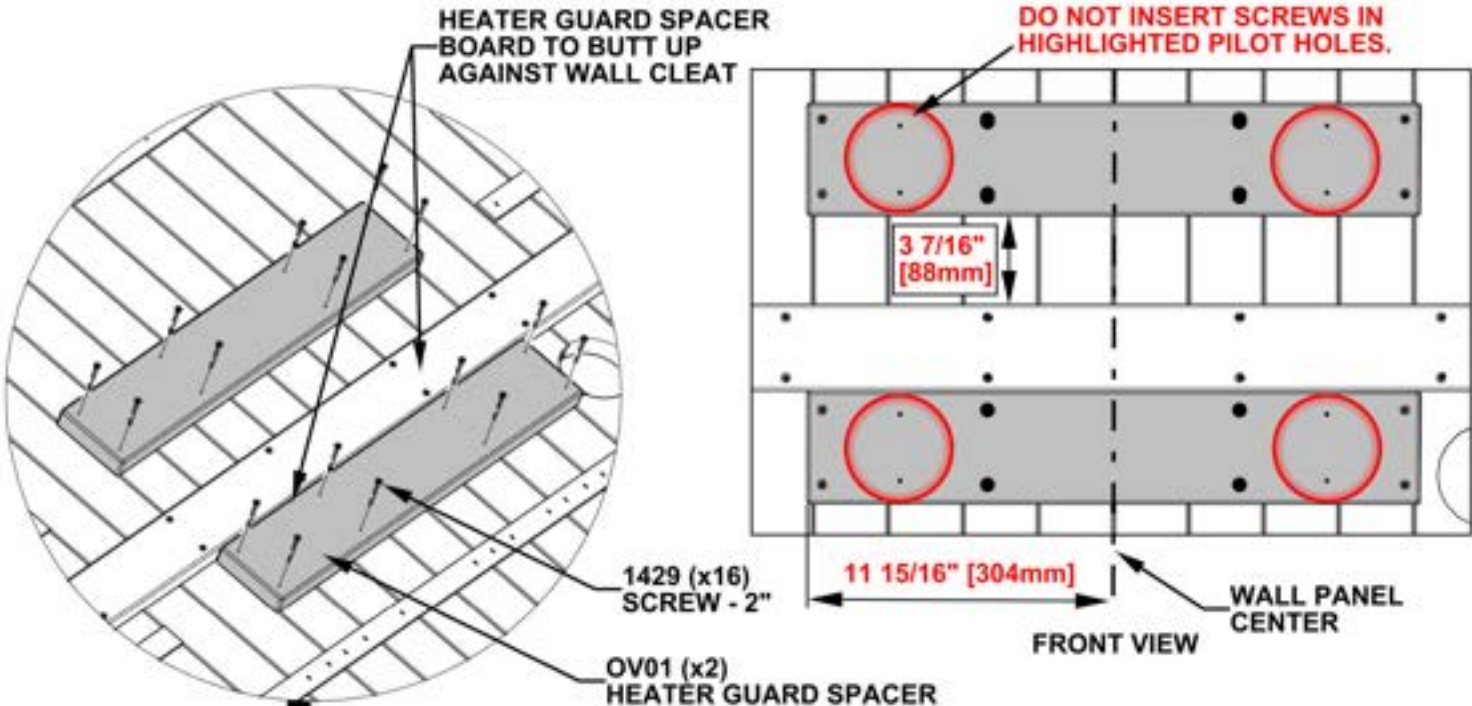
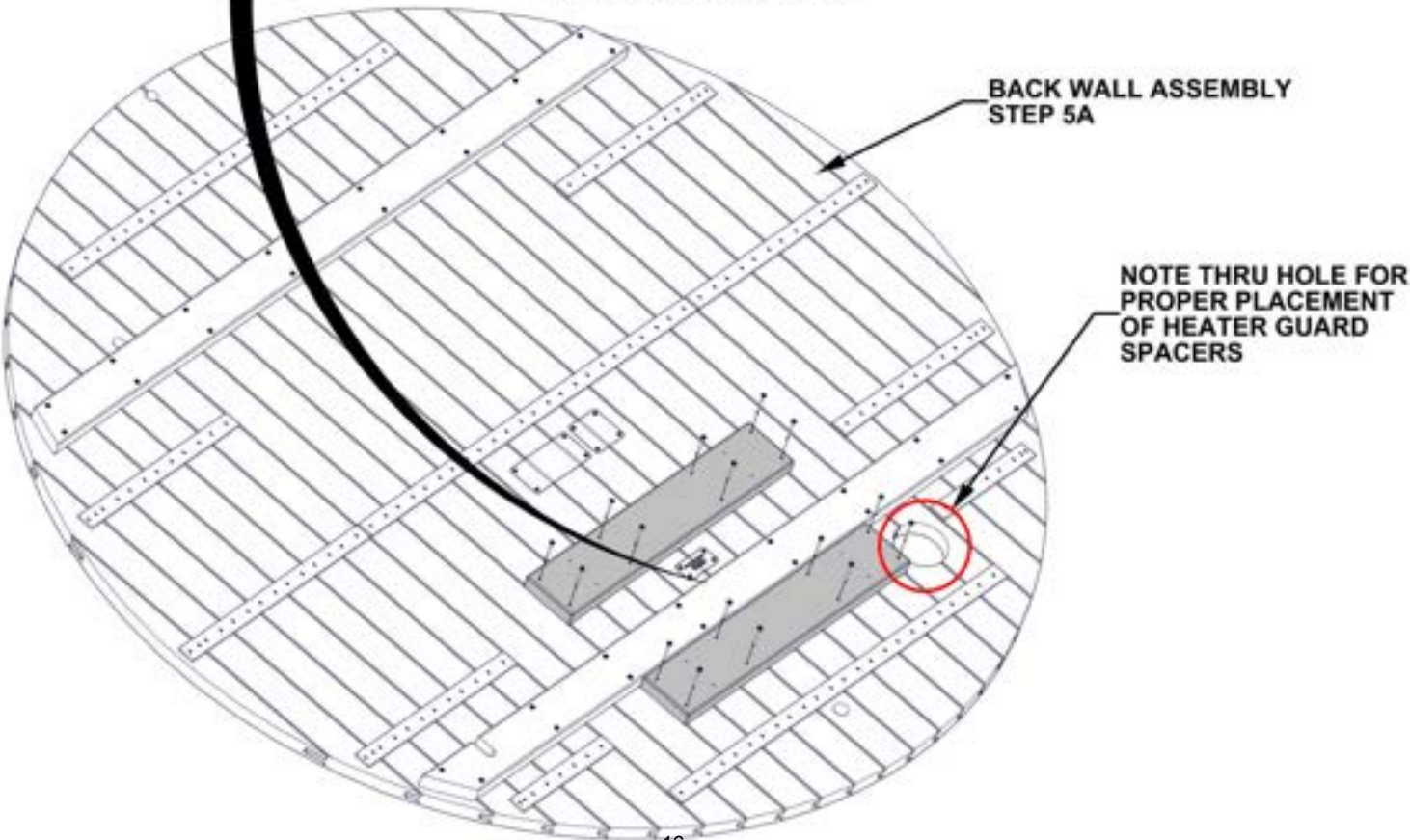


STEP 5B - BACK WALL ASSEMBLY

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



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



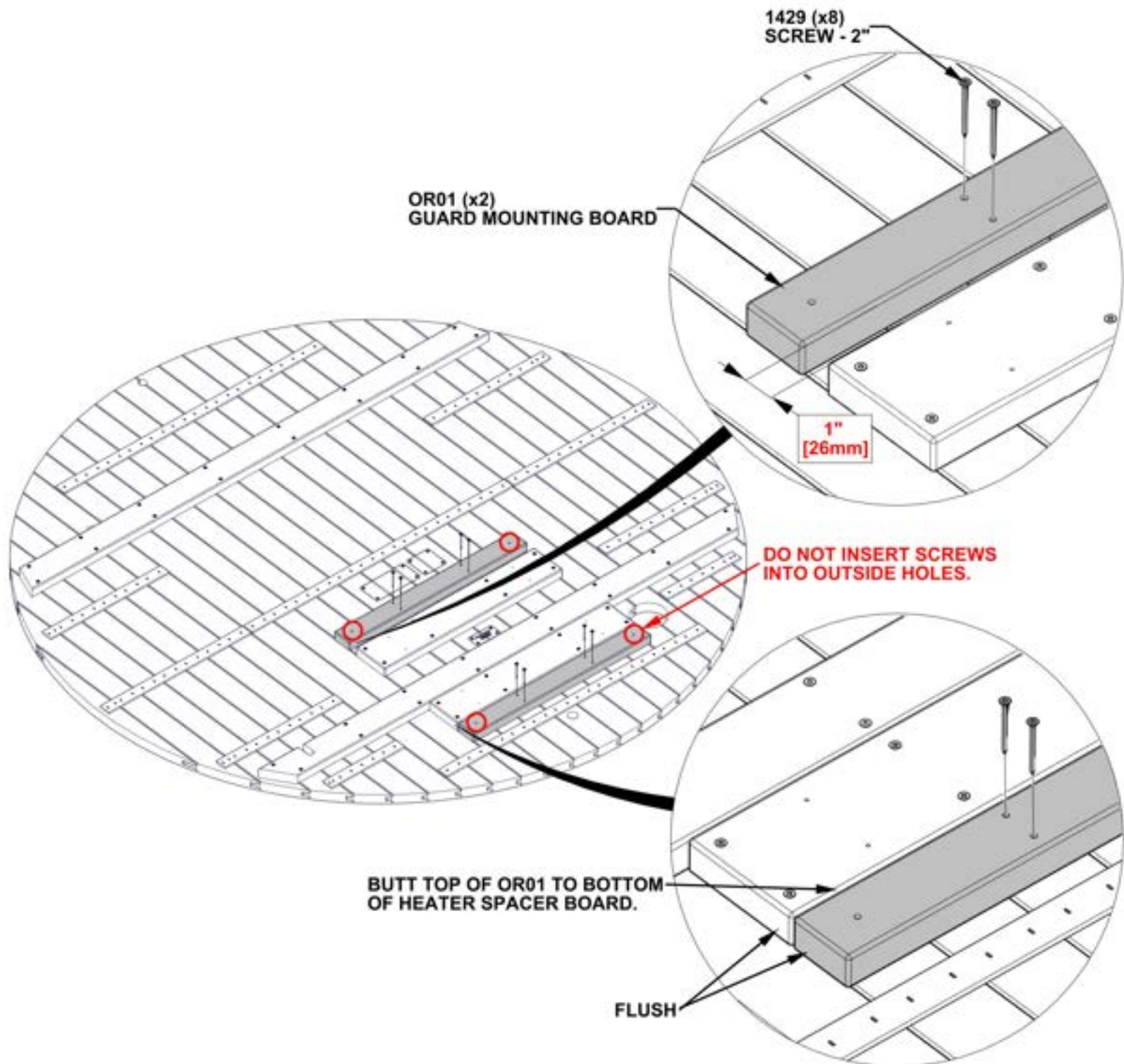
STEP 5C - BACK WALL ASSEMBLY

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



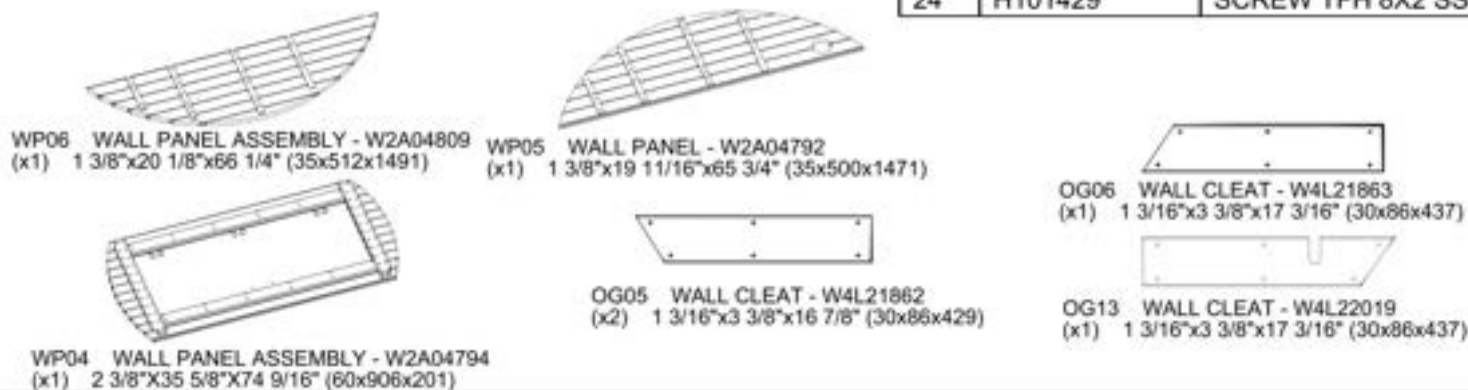
OR01 GUARD MOUNTING BOARD - W4L21873
(x2) 1 3/16"x2 3/8"x23 15/16" (30x60x608)

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

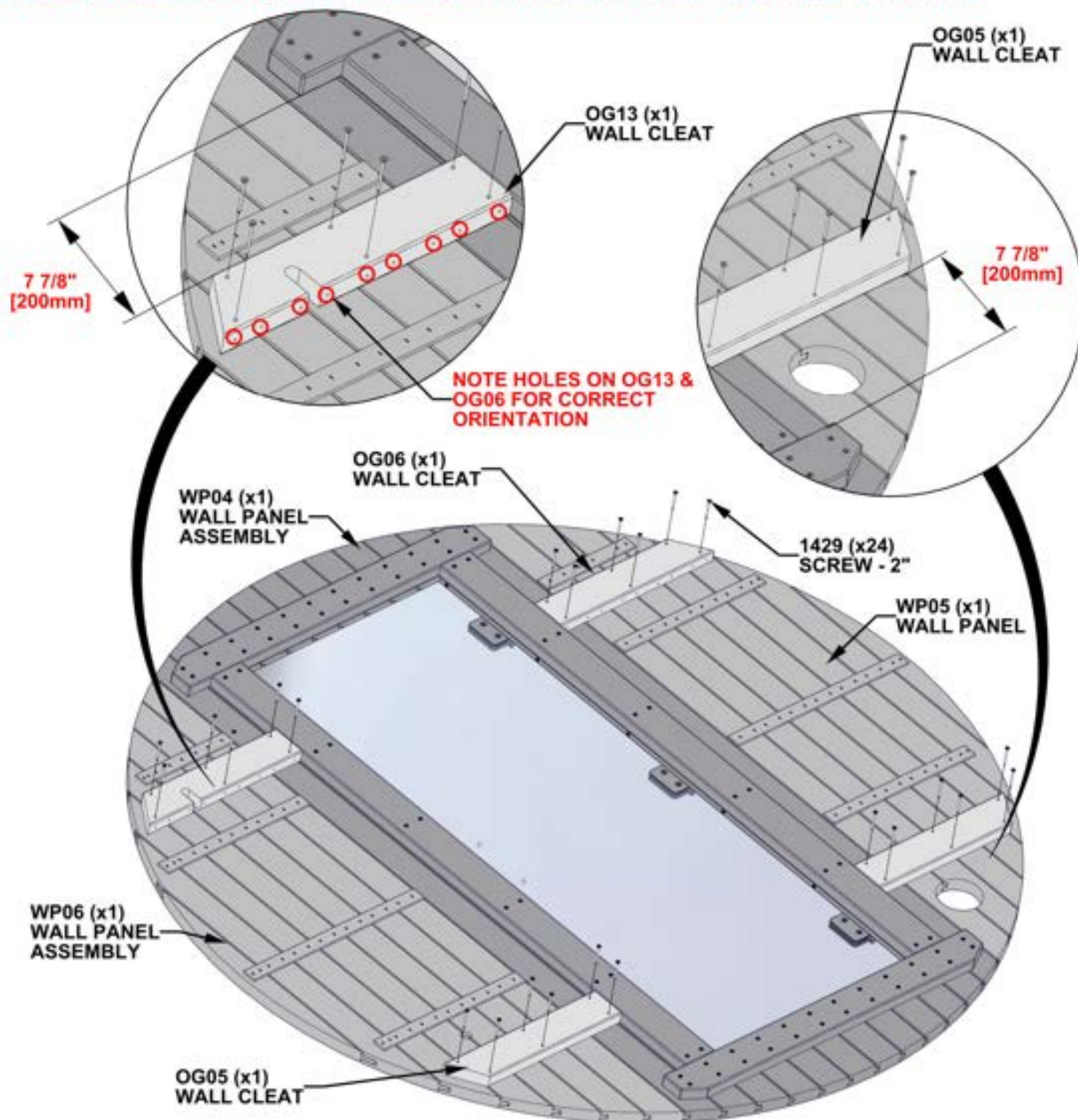


STEP 6 - FRONT WALL ASSEMBLY

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



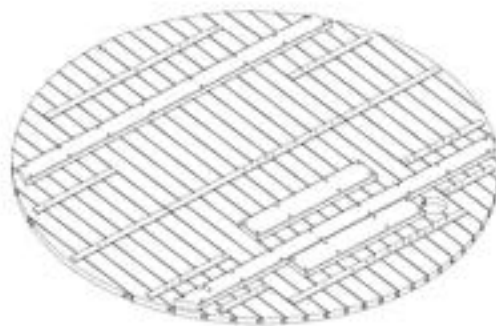
- USING DIMENSION SHOWN CENTER AND ATTACH WALL CLEATS.
- THE FINISHED WALL PANEL ASSEMBLY SHOULD MEASURE 74 9/16" [1894mm] IN DIAMETER.
- CAUTION: SUPPORT GLASS DOOR AT ALL TIMES TO PREVENT ACCIDENTAL OPENING AND BREAKAGE.



STEP 7 - BARREL ASSEMBLY

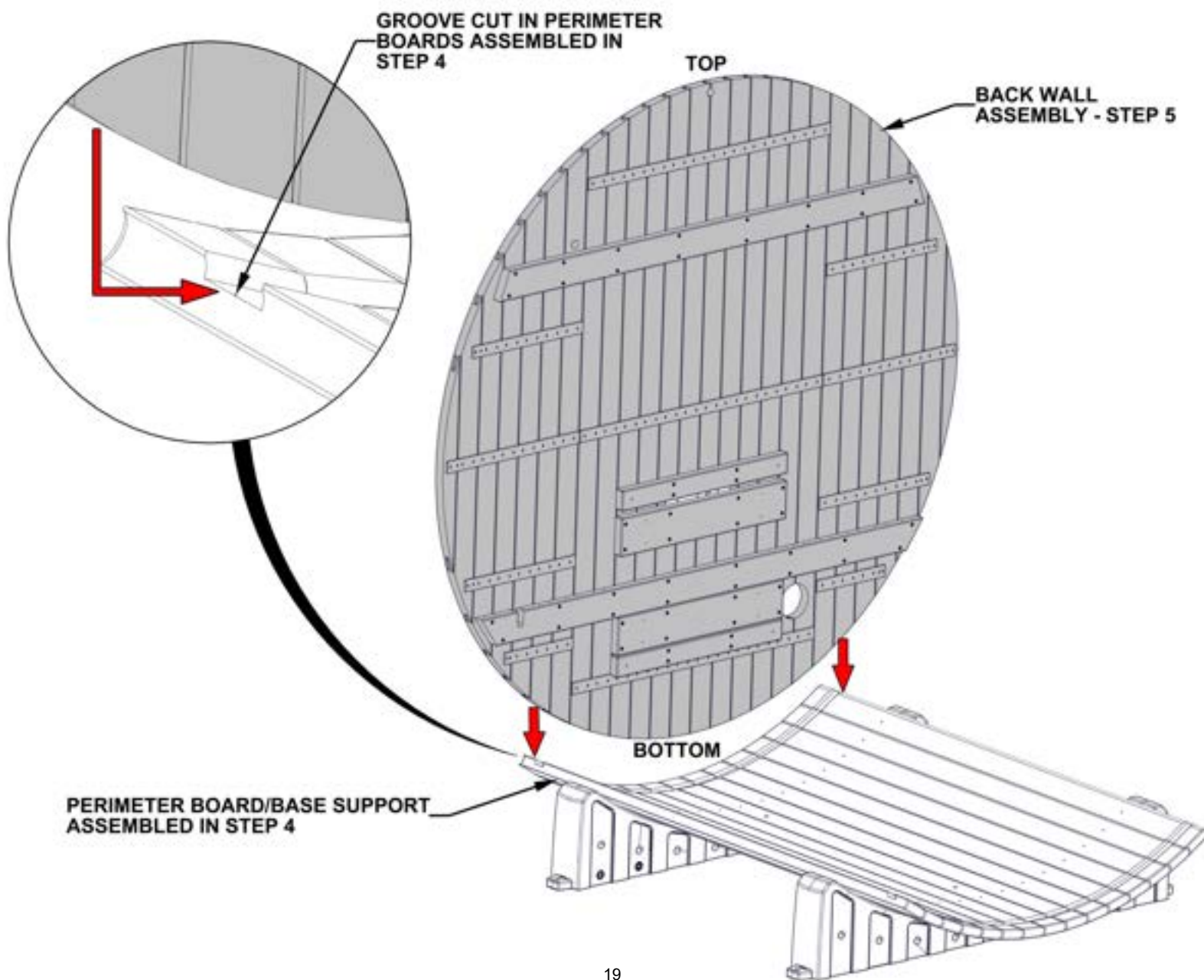


PERIMETER BOARD/BASE SUPPORT
STEP 4



BACK WALL ASSEMBLY - STEP 5

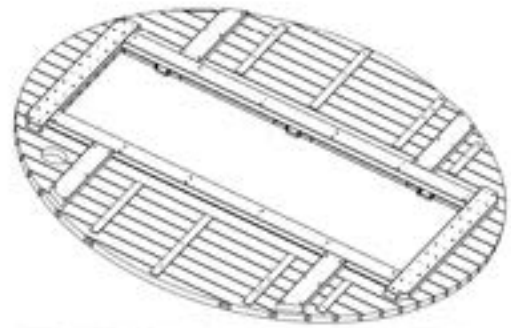
- CAREFULLY LOWER BACK WALL ASSEMBLY INTO THE GROOVES ON THE PERIMETER BOARD/BASE SUPPORT ASSEMBLED IN STEP 4.
- IF THE UNIT IS UNSTABLE, HAVE A SECOND PERSON HOLD THE BACK WALL TO KEEP IT STEADY DURING THE NEXT FEW STEPS.
- WHEN LIFTING THE WALL ASSEMBLY, LIFT BY THE TOP AND BOTTOM NOT THE SIDES.



STEP 8 - BARREL ASSEMBLY



OG01 PERIMETER BOARD - W4L21857
(x1) 1 3/16"x3 3/8"x64" (30x96x1626)



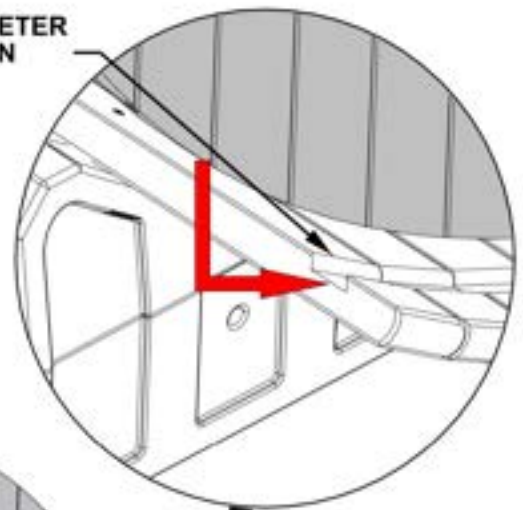
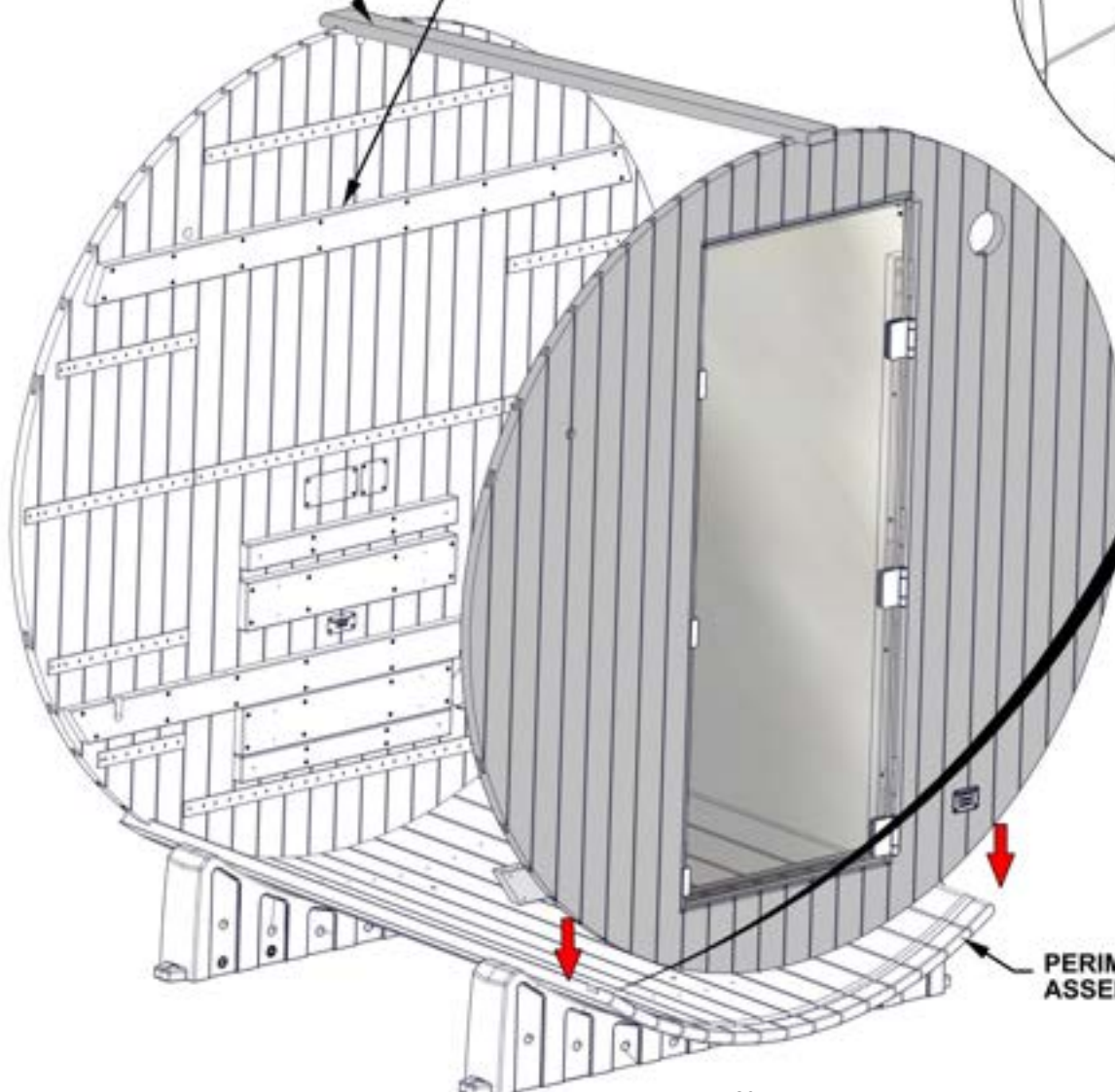
FRONT WALL ASSEMBLY - STEP 6

- 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.**

GROOVE CUT IN PERIMETER
BOARDS ASSEMBLED IN
STEP 4

OG01 (x1)
PERIMETER BOARD

**MAKE SURE ALL WALL CLEATS ARE
HORIZONTAL AND LEVEL BEFORE
ATTACHING PERIMETER BOARD**



PERIMETER BOARD/BASE SUPPORT
ASSEMBLED IN STEP 4

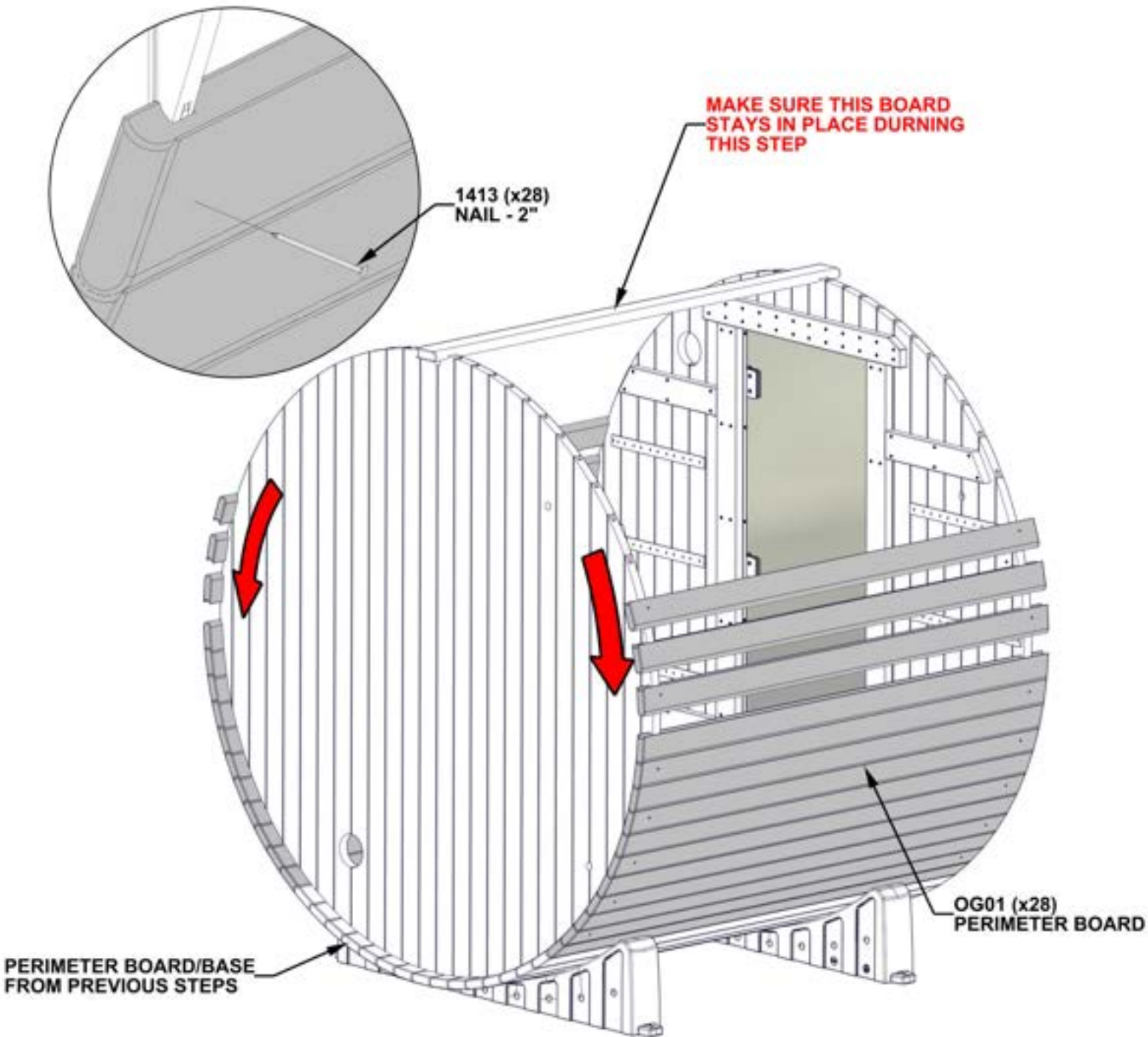
STEP 9 - BARREL ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
28	H101413	NAIL STD 2.5x50 GLV



OG01 PERIMETER BOARD - W4L21857
(x28) 1 3/16"x3 3/8"x64" (30x86x1626)

- ALIGN GROOVE IN PERIMETER BOARDS WITH BOTH FRONT WALL AND BACK WALL ASSEMBLIES.
- WORKING UPWARDS, STACK 14 BOARDS ON EACH SIDE OF THE PERIMETER BOARD/BASE AS SHOWN.
- FASTEN APPROXIMATELY EVERY OTHER PERIMETER BOARD TO THE WALLS WITH H101413 TO HOLD IN PLACE.
- IF YOU HAVE ACCESS TO A PNEUMATIC NAILER, THIS STEP WILL GO FASTER.

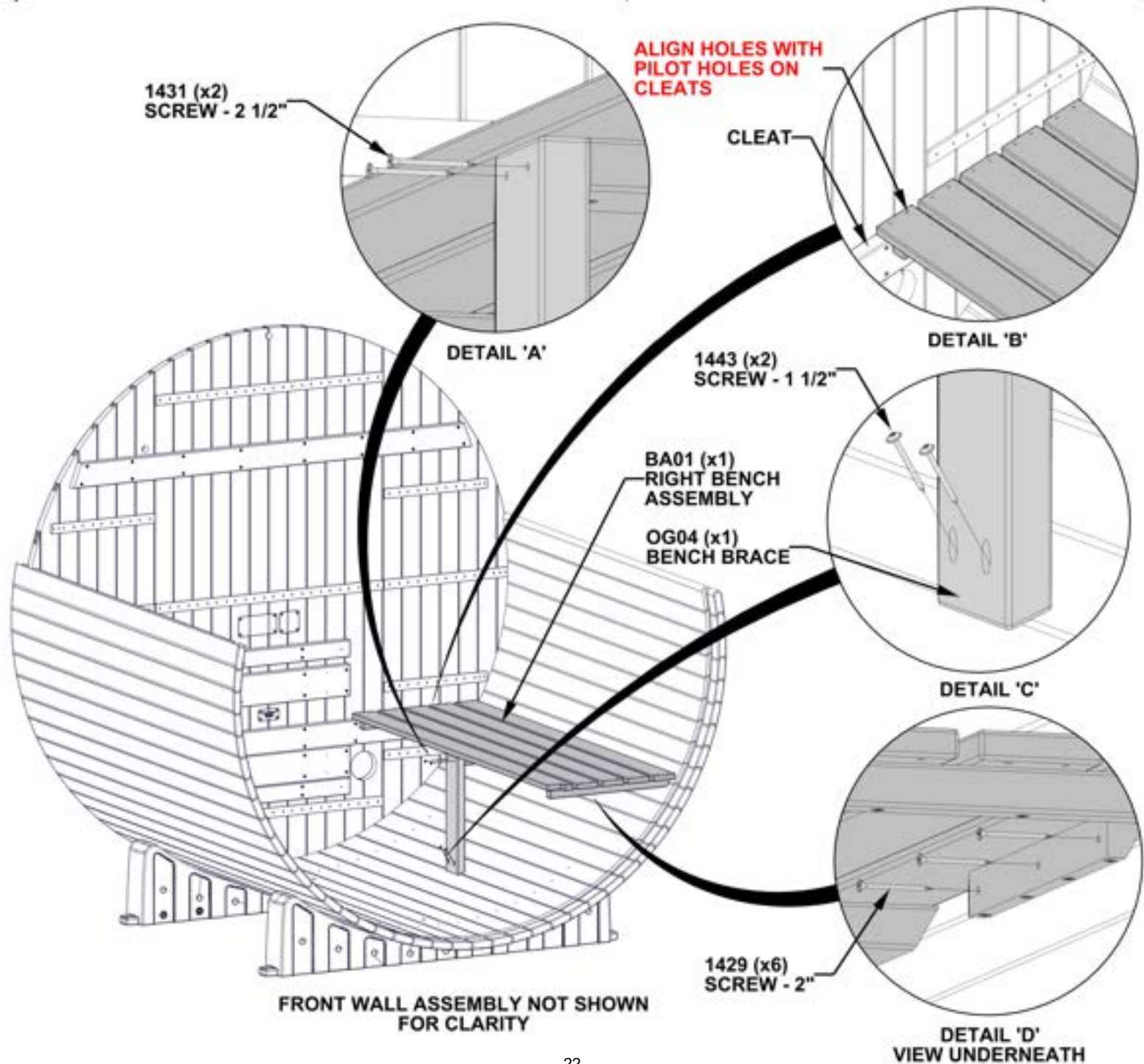


STEP 10 - BENCH ASSEMBLY

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



- 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 11 - 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

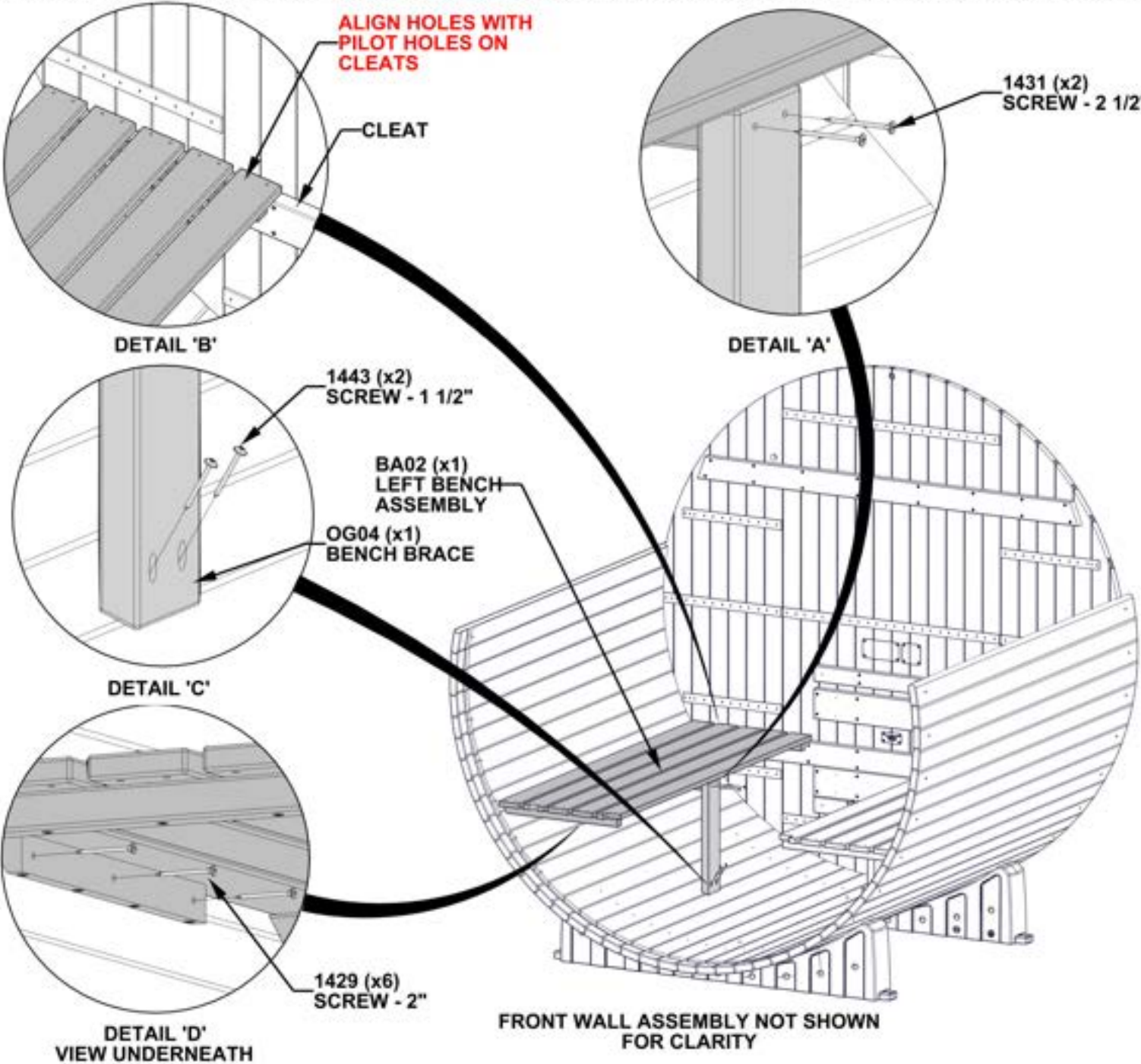


BA02 LEFT BENCH ASSEMBLY - W2A04789
(x1) 19 1/8"57 5/16" (50x486x1456)



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

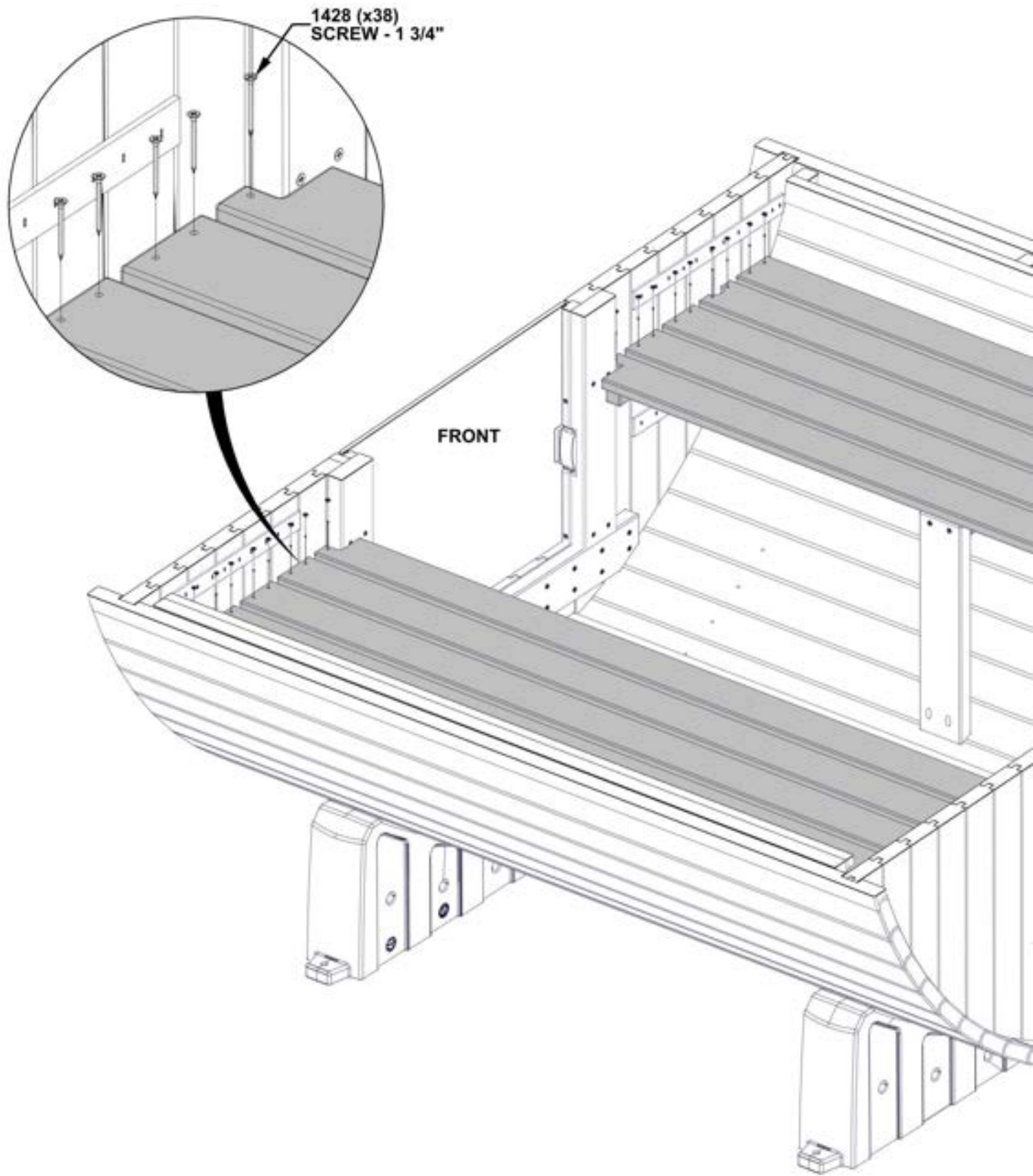
- 1) INSTALL BENCH BRACE OG04 TO BENCH ASSEMBLY. (DETAIL 'A')
- 2) PUSH THE BENCH WITH BENCH BRACE BOARD AGAINST THE WALL UNTIL IT MAKES CONTACT WITH THE SIDEWALL.
- 3) CHECK THE ALIGNMENT OF THE HOLES ON EACH END OF THE BENCH WITH THE PILOT HOLES ON THE CLEATS MOUNTED TO THE WALL. (DETAIL 'B')
- 4) 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 12 - BENCH INSTALLATION

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.



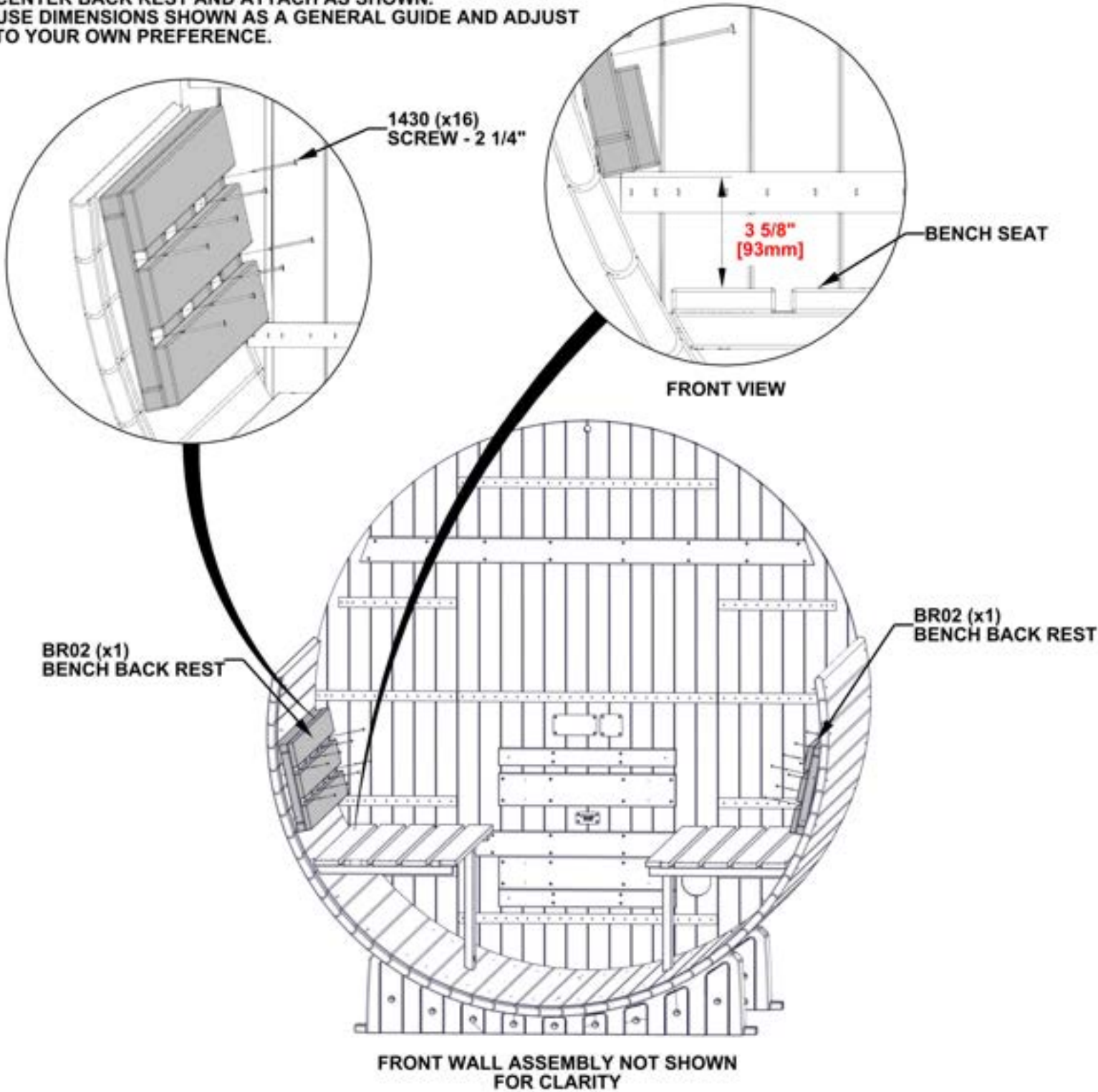
STEP 13 - BACK REST INSTALLATION

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



BR02 BENCH BACK REST - W2A04791
(x2) 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.



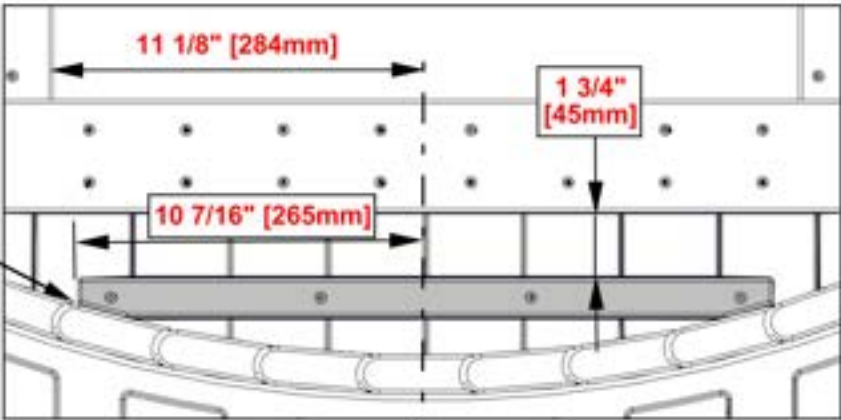
STEP 14 - FLOOR CLEAT INSTALLATION

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



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

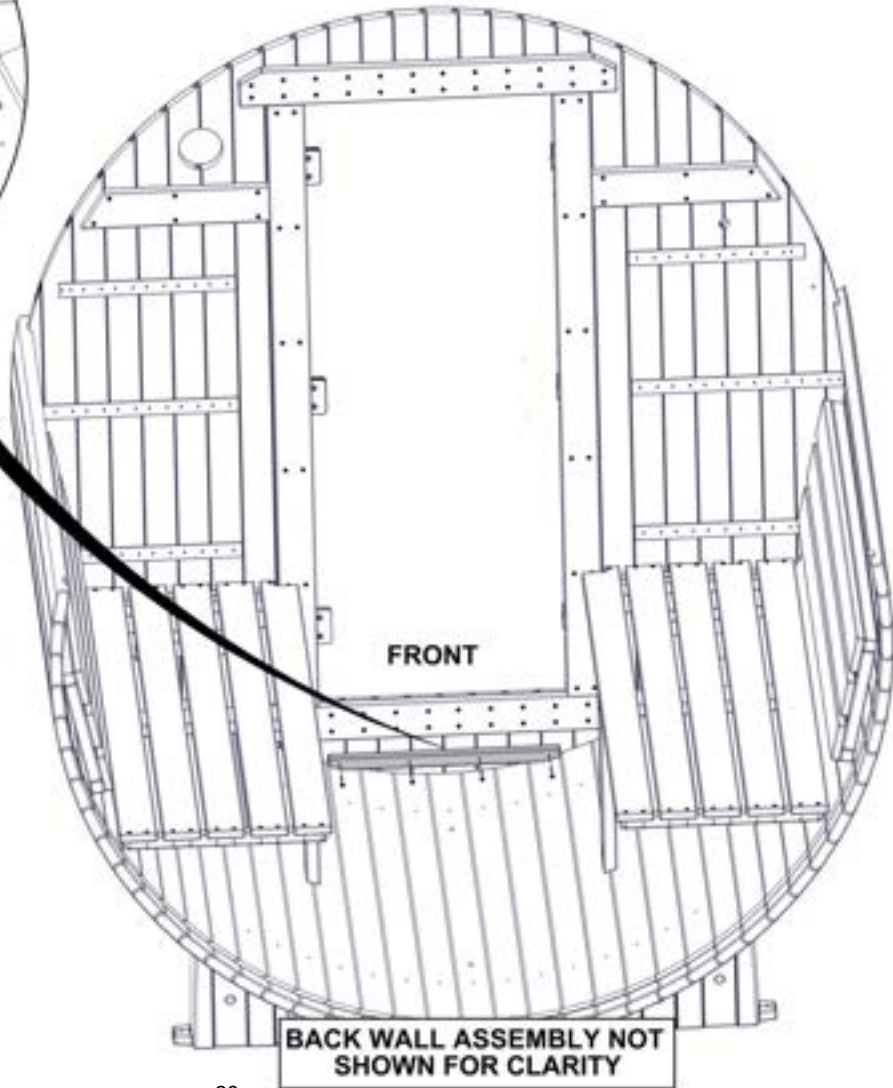
- CENTER OO05 FLOOR SUPPORT BOARD IN SAUNA.
- USE THE DIMENSION SHOWN FROM THE DOOR OPENING TO MARK THE CENTER OF THE OO05 BOARD.
- MAKE SURE THE BOARD IS LEVEL AND ATTACH AS SHOWN.



SUPPORT BOARD WILL
REST ON FLOOR

OO05 (x1)
FLOOR SUPPORT

1429 (x4)
SCREW - 2"



STEP 15 - FLOOR CLEAT INSTALLATION

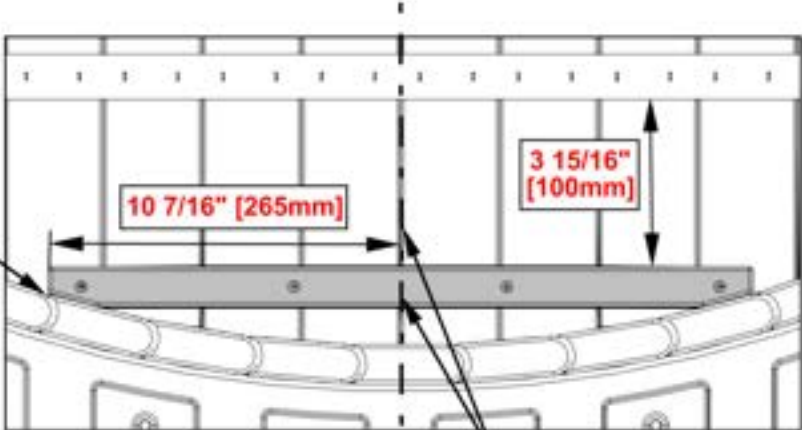
QTY	PART NUMBER	DESCRIPTION
4	H101429	SCREW TFH 8X2 SS-BLK



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

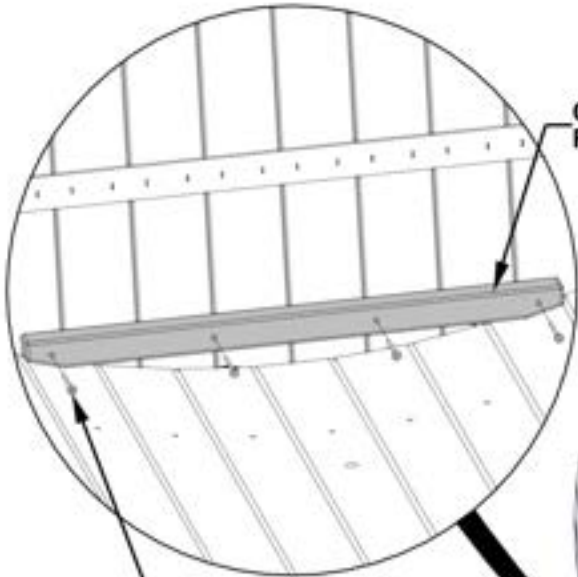
- CENTER OO05 FLOOR SUPPORT BOARD IN SAUNA.
- USE THE DIMENSION SHOWN FROM THE CENTER SEAM OF THE WALL PANEL TO MARK THE CENTER OF THE OO05 BOARD.
- MAKE SURE THE BOARD IS LEVEL AND ATTACH AS SHOWN.

SUPPORT BOARD WILL REST ON FLOOR



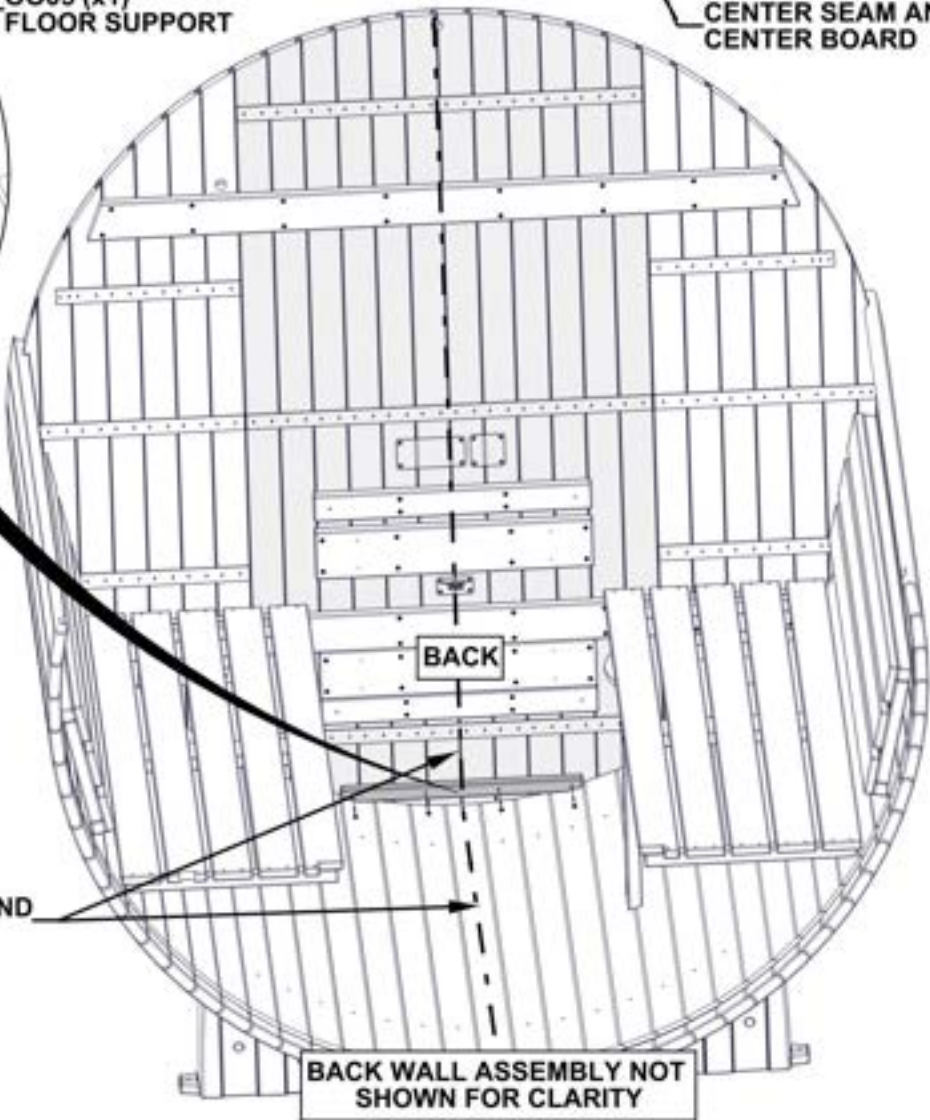
OO05 (x1)
FLOOR SUPPORT

CENTER SEAM AND
CENTER BOARD



1429 (x4)
SCREW - 2"

CENTER SEAM AND
CENTER BOARD



BACK WALL ASSEMBLY NOT
SHOWN FOR CLARITY

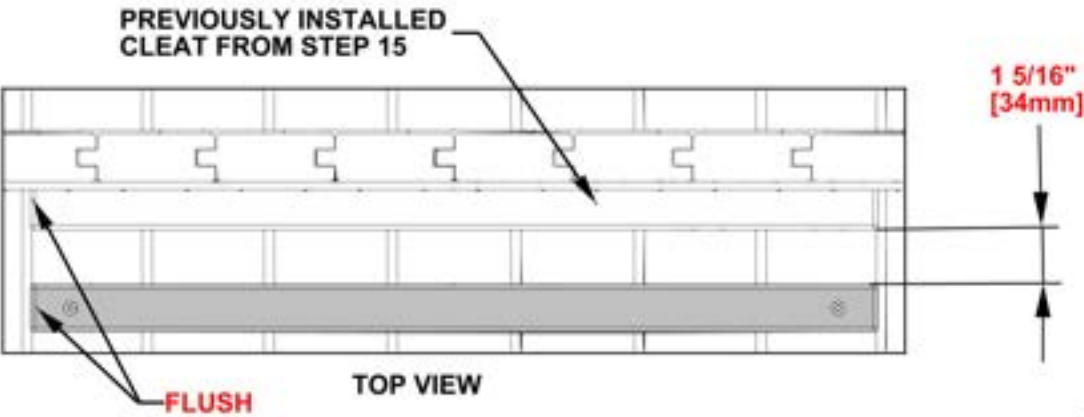
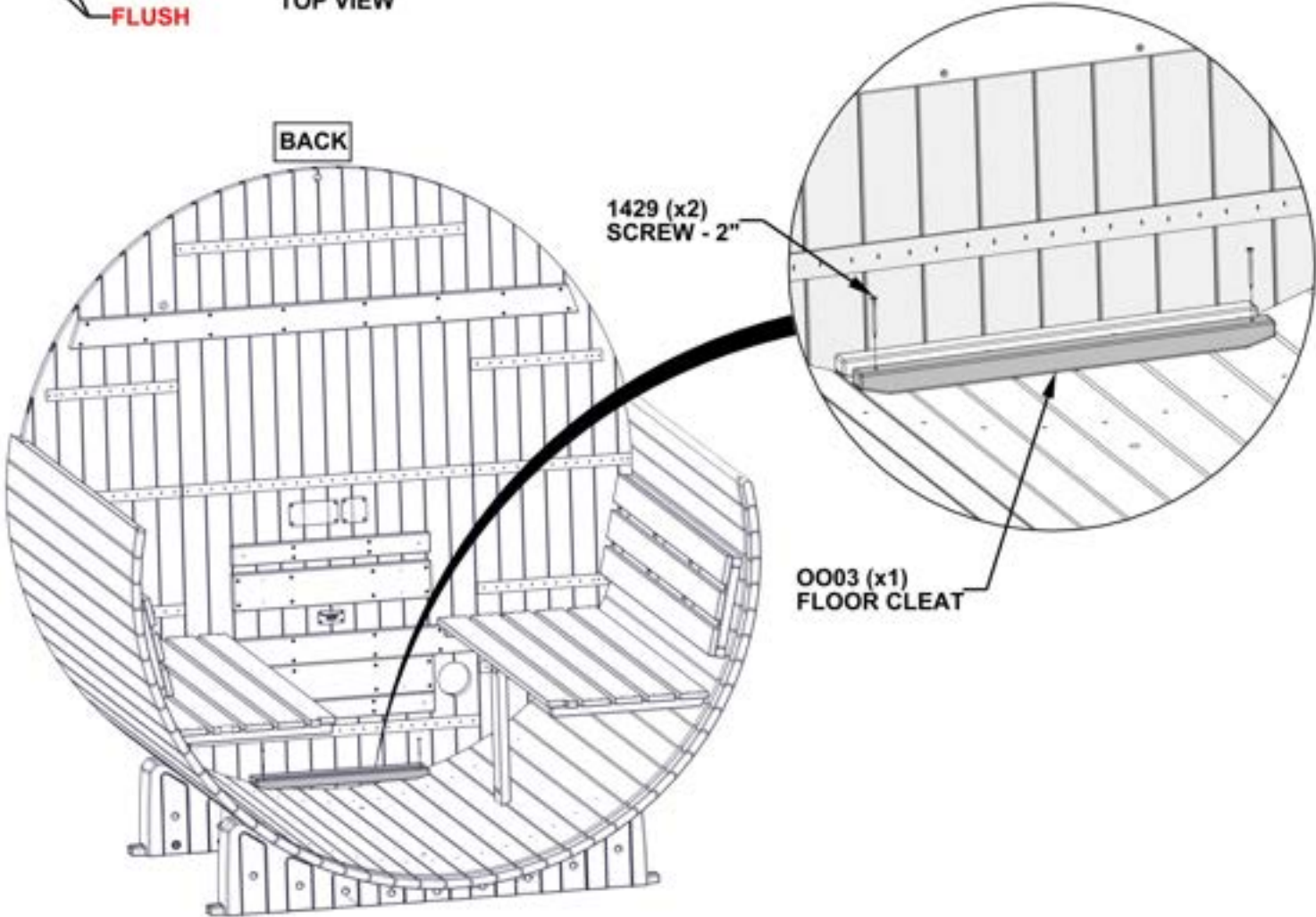
STEP 16 - FLOOR CLEAT INSTALLATION

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



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

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

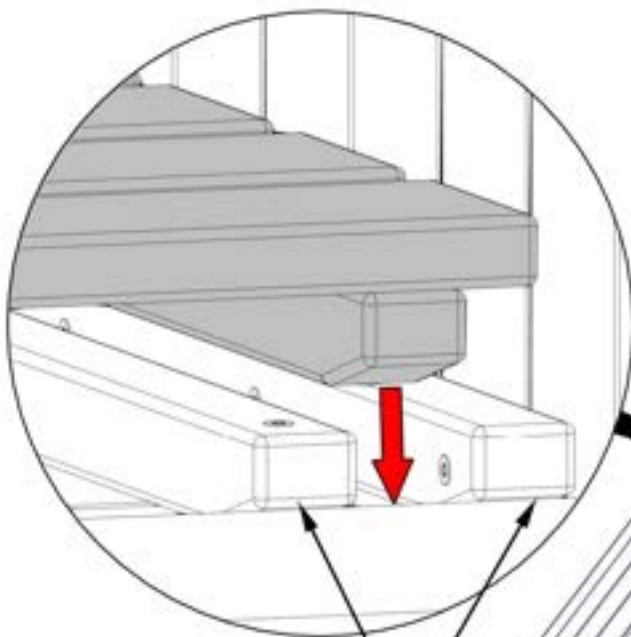


STEP 17 - FLOOR INSTALLATION

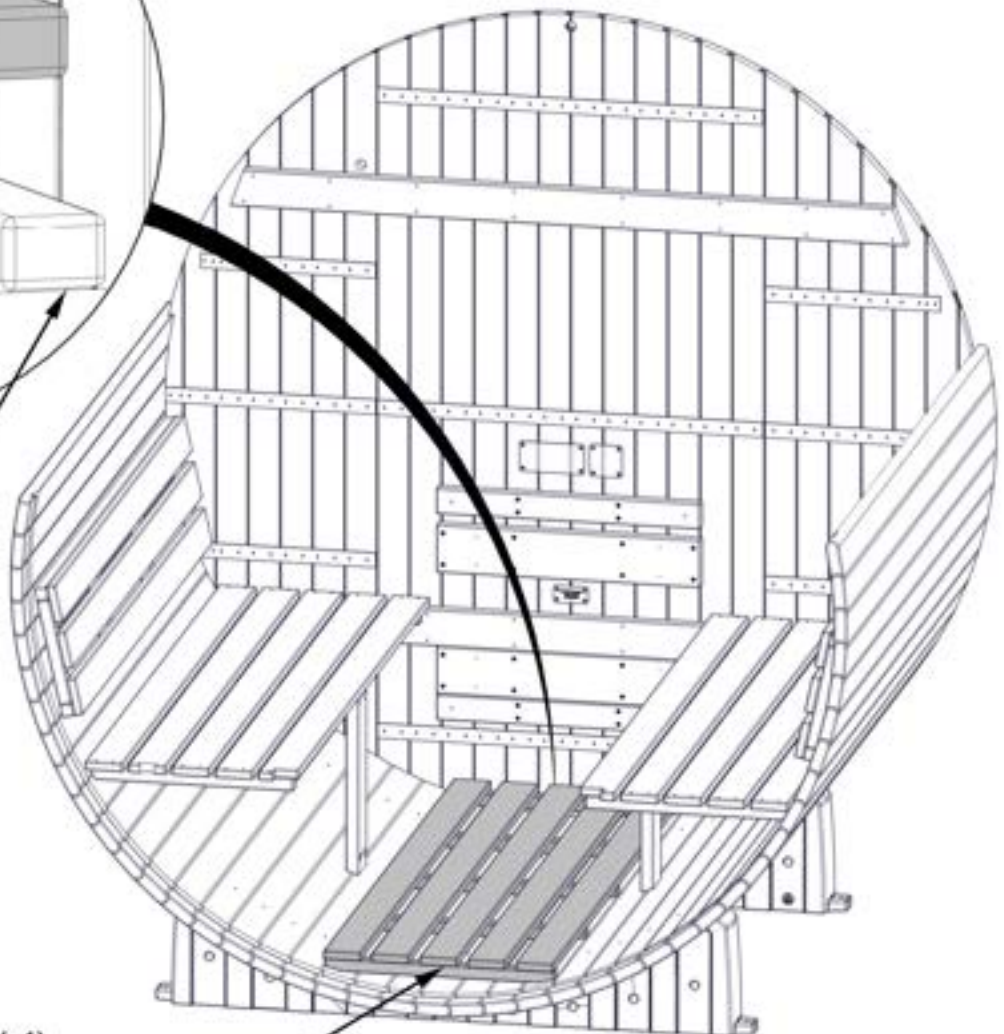


FP01 FLOOR PANEL ASSEMBLY - W2A04796
(x1) 1 15/16"x20 7/8"x55 7/8" (50x530x1420)

- 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



PREVIOUSLY INSTALLED
CLEATS



FP01 (x1)
FLOOR PANEL ASSEMBLY

FRONT WALL ASSEMBLY NOT SHOWN
FOR CLARITY

STEP 18 - CONTROL PANEL

QTY	PART NUMBER	DESCRIPTION
2	H101440	SCREW TWH 8 X 1 SS-BLK

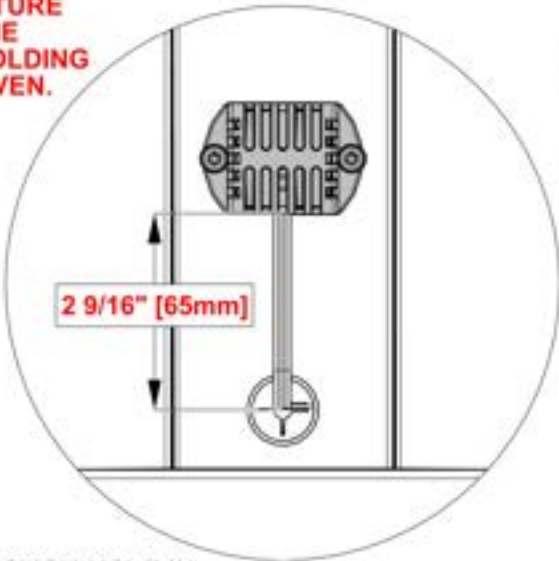


A4M05590-08 TEMPERATURE SENSOR (x1)



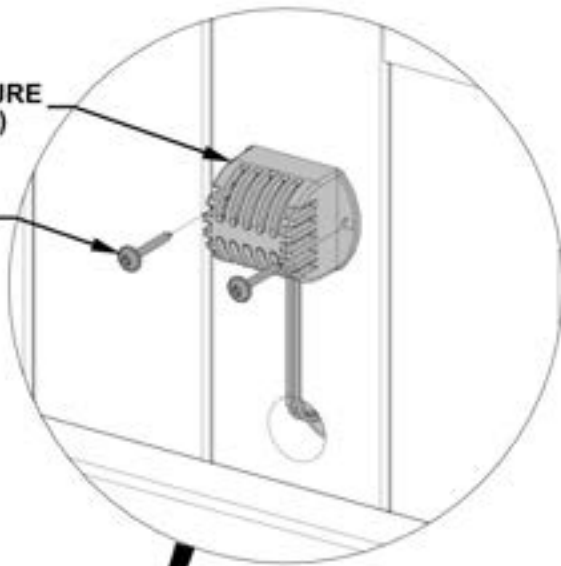
A6P01467 25mm SILICONE GROMMET (x1)

ATTACH TEMPERATURE SENSOR ABOVE THE THROUGH HOLE HOLDING THE DIMENSION GIVEN.

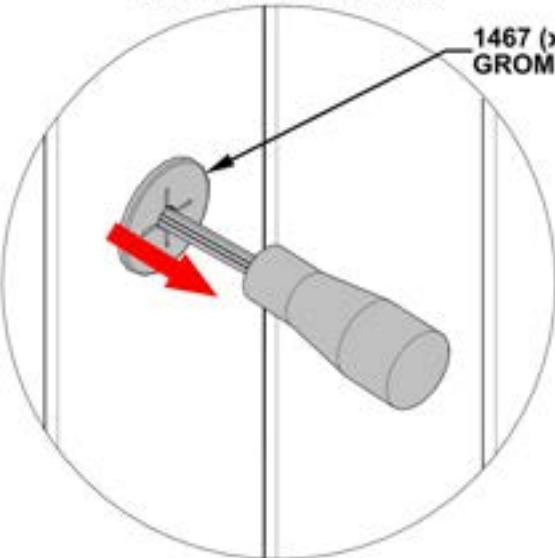


TEMPERATURE SENSOR (x1)

1440 (x2) SCREW - 1"

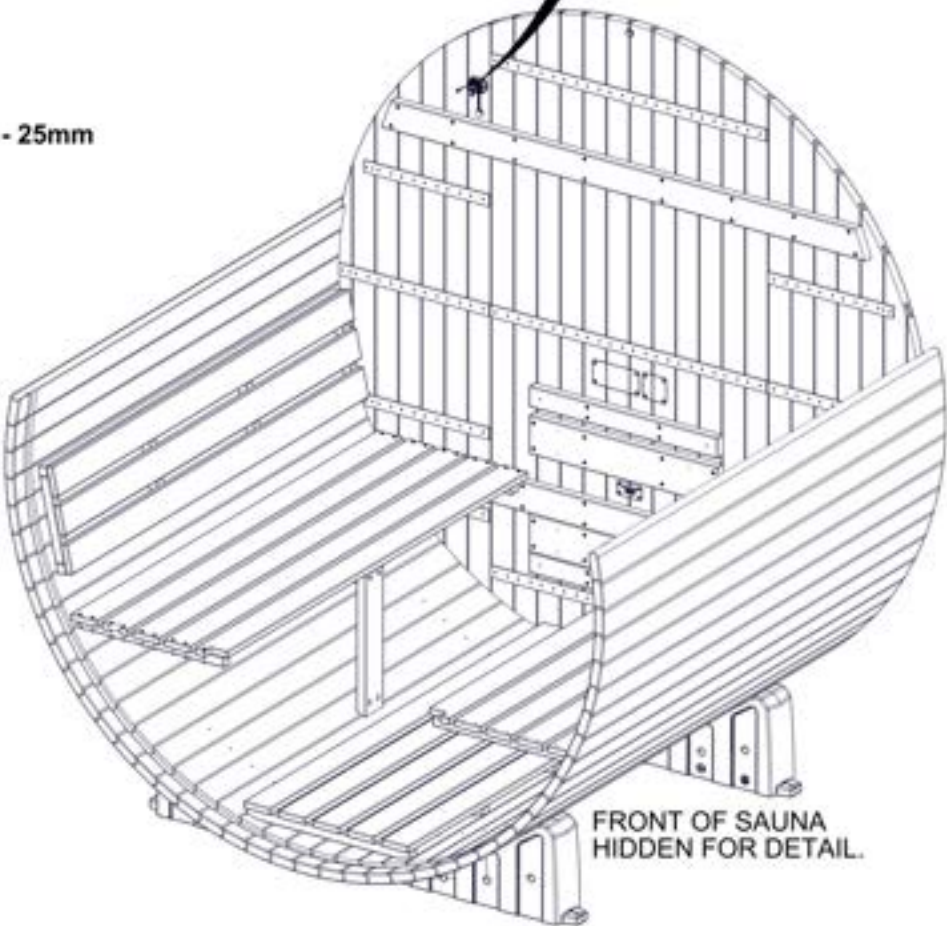


RUN CABLE THROUGH HOLE IN WALL PANEL AND THROUGH GROMMET AS SHOWN.



1467 (x1) GROMMET - 25mm

BACK VIEW



STEP 19 - CONTROL PANEL

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

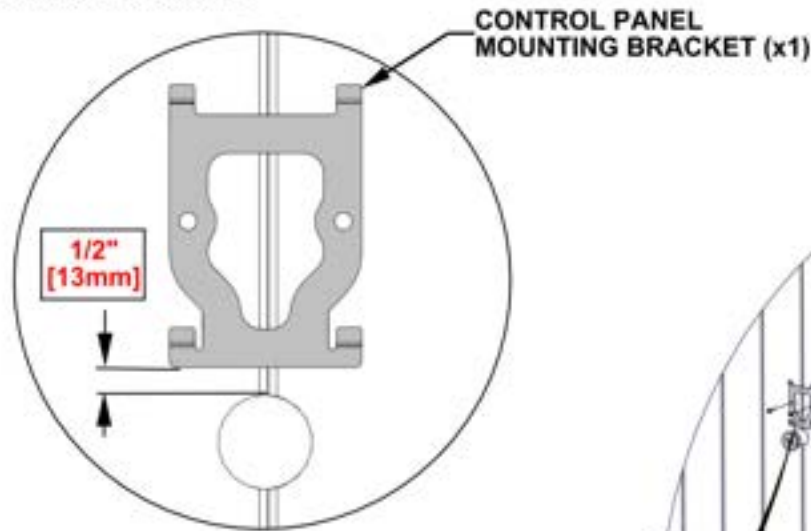
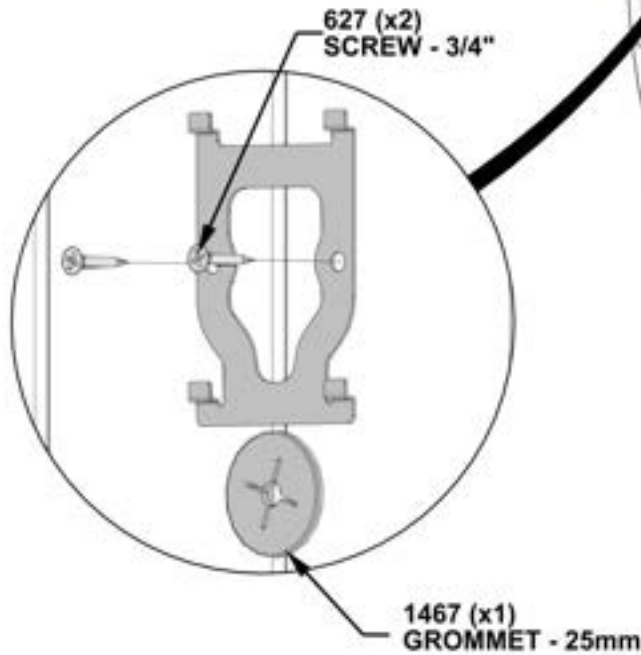
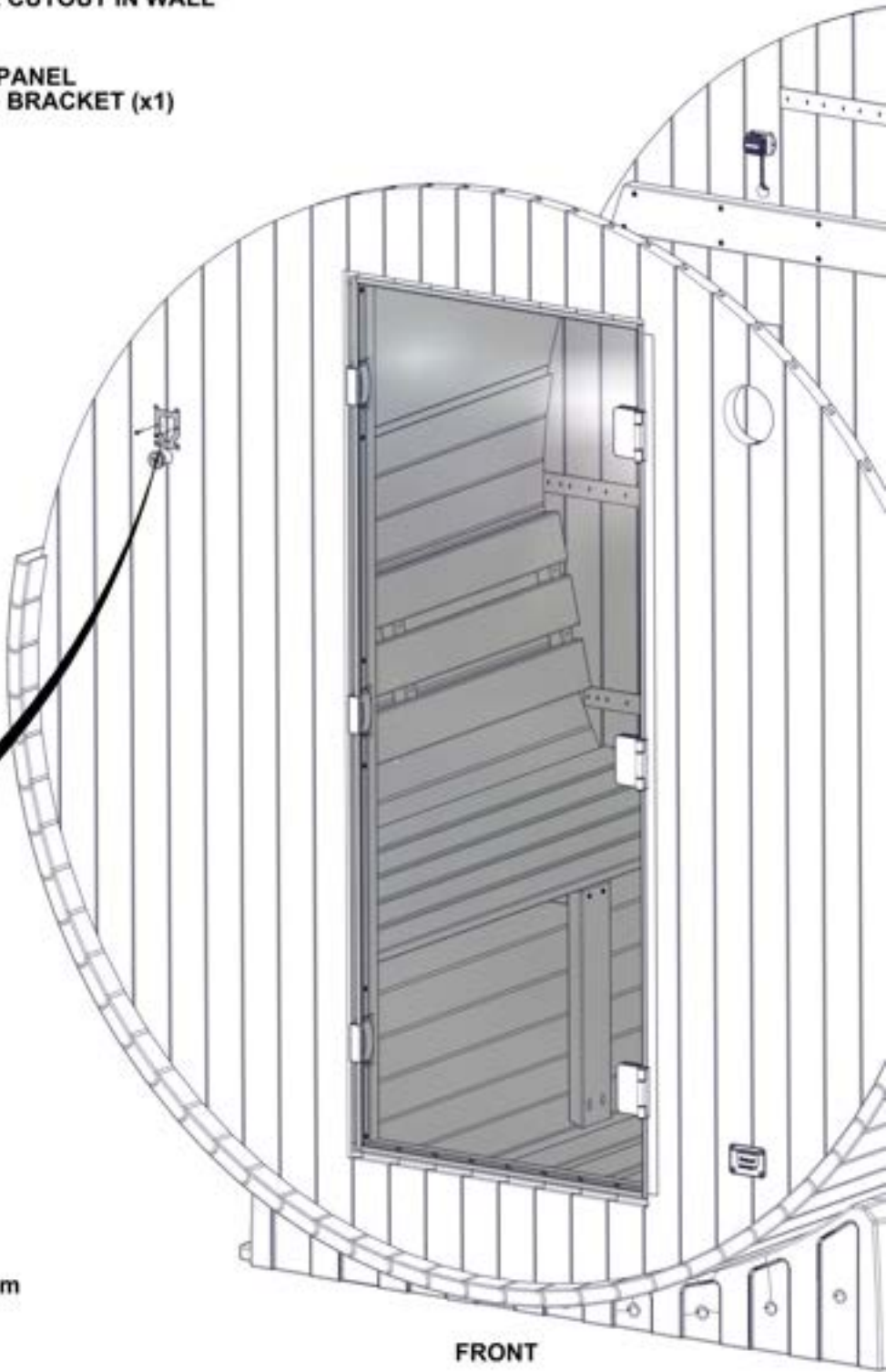


A4M05590-03 CONTROL PANEL MOUNTING BRACKET (x1)



A6P01467 25mm SILICONE GROMMET (x1)

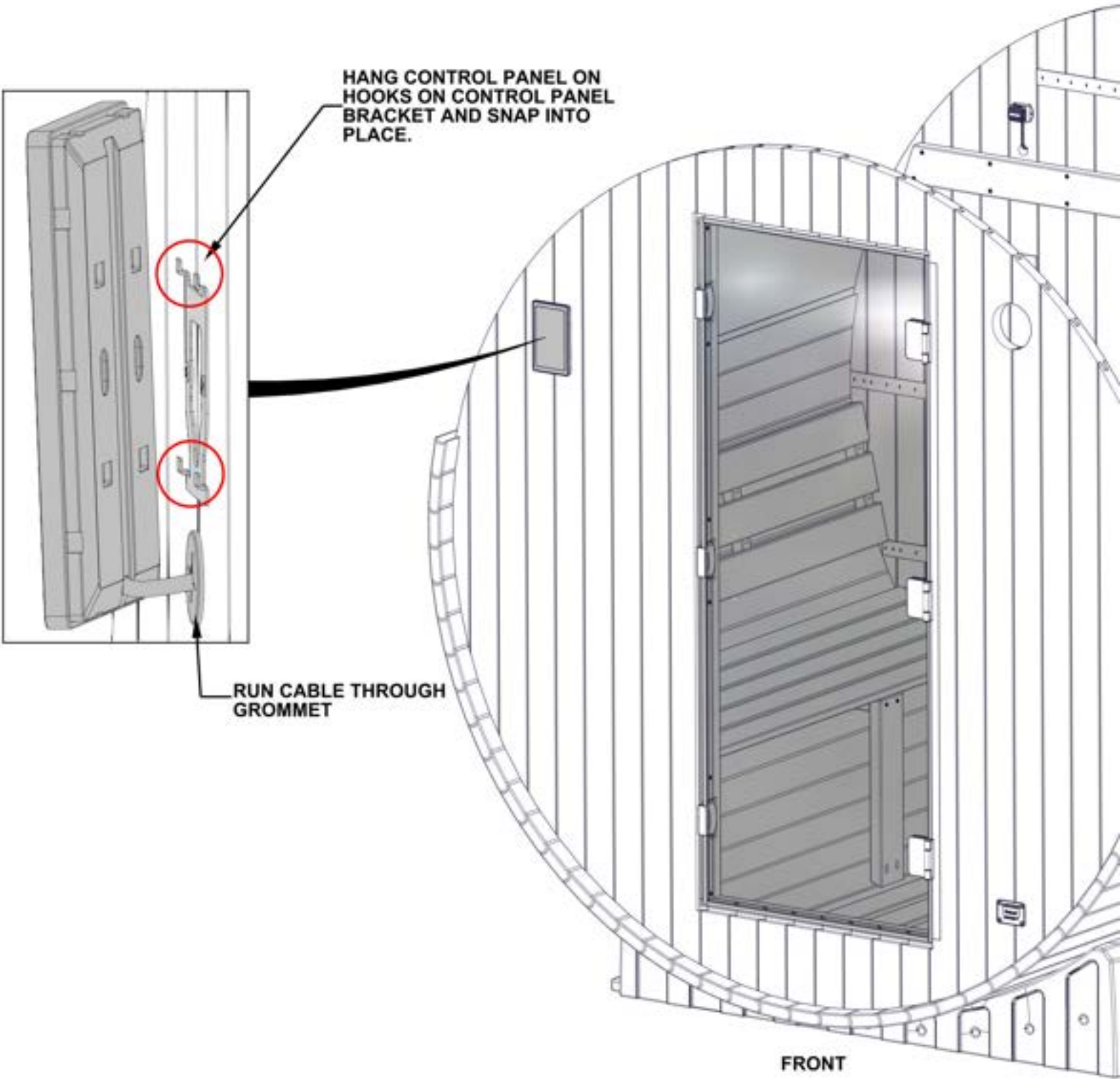
- CENTER MOUNTING BRACKET SLIGHTLY OVER CUTOUT IN WALL PANEL AND ATTACH AS SHOWN.
- INSERT GROMMET.



STEP 20 - CONTROL PANEL



A4M05590-02 CONTROL PANEL
(x1)



HANG CONTROL PANEL ON
HOOKS ON CONTROL PANEL
BRACKET AND SNAP INTO
PLACE.

RUN CABLE THROUGH
GROMMET

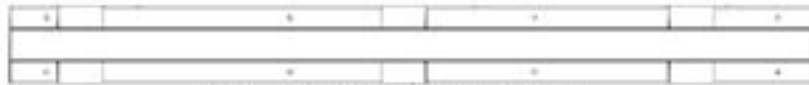
FRONT

STEP 21 - CONTROL PANEL

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

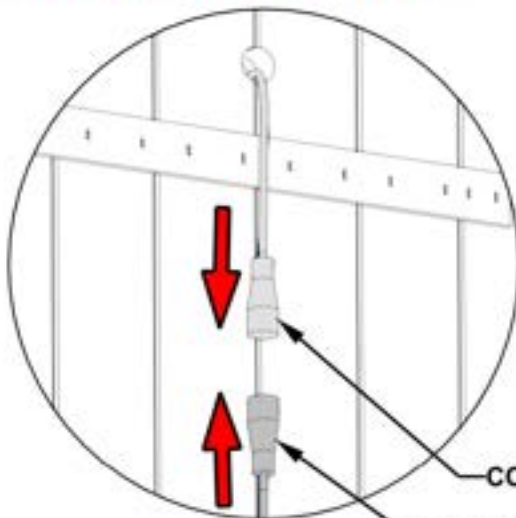


A4M05590-10 WIRING HARNESS
(x1)



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

- CONNECT CABLE 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')
- **TAKE CAUTION WHEN ATTACHING SCREWS TO PREVENT PINCHING OR PENETRATING CABLE.**

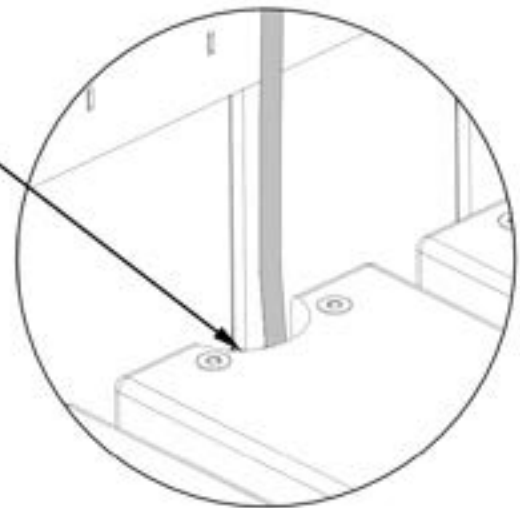


DETAIL 'A'

CONNECT CABLES

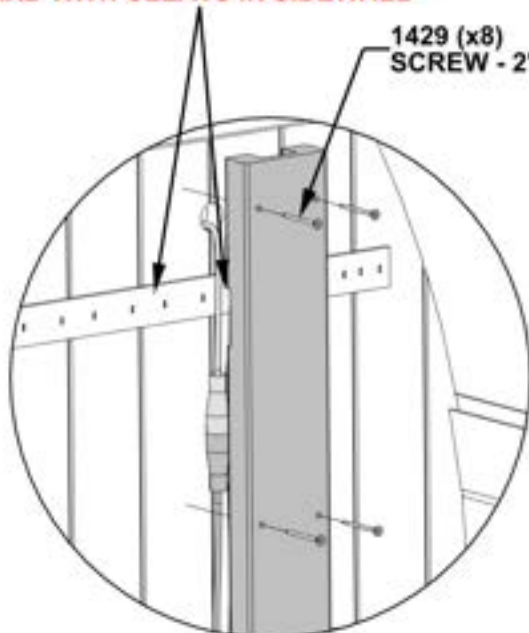
WIRING HARNESS
(x1)

CUTOUT IN
BENCH ASSEMBLY



DETAIL 'B'

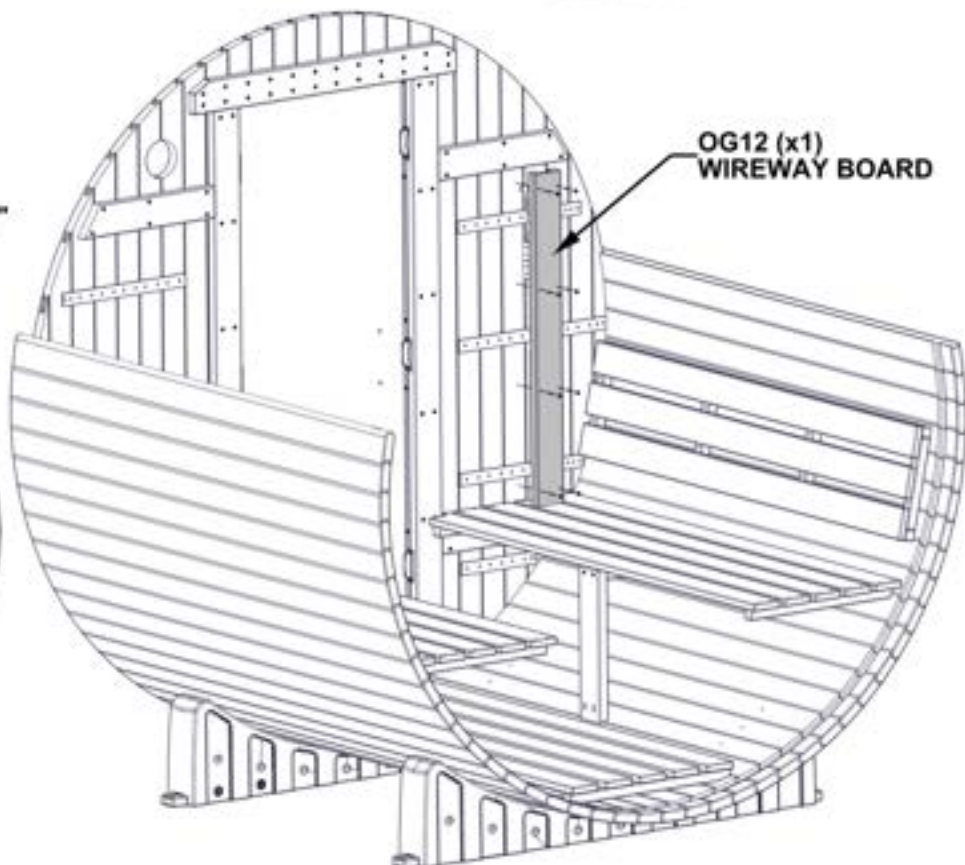
WIREWAY BOARD WILL ONLY FIT ONE WAY. ALIGN NOTCHES IN WIREWAY BOARD WITH CLEATS IN SIDEWALL



DETAIL 'C'

1429 (x8)
SCREW - 2"

OG12 (x1)
WIREWAY BOARD



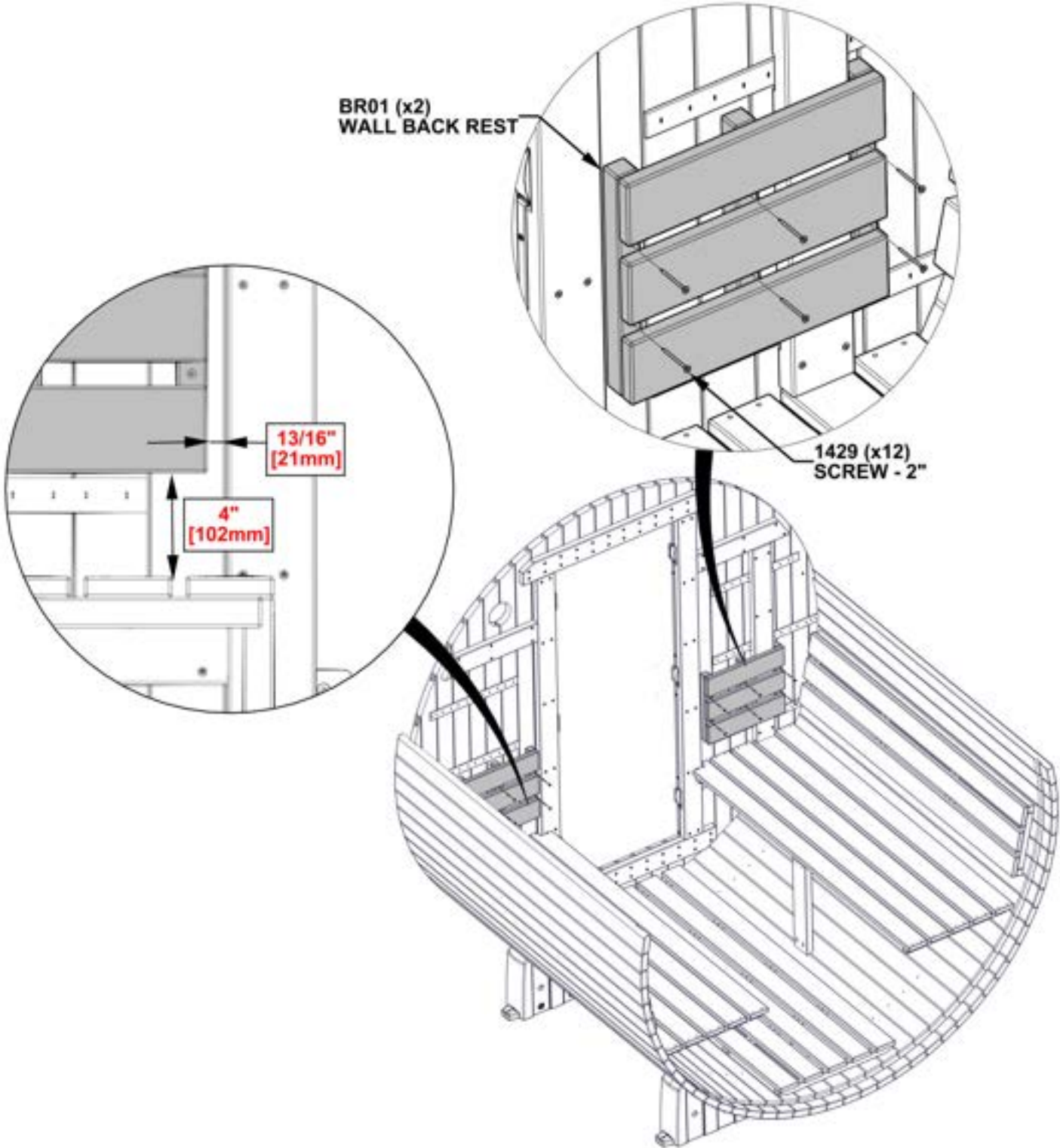
STEP 22 - BACK REST INSTALLATION

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



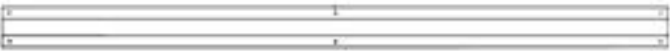
BR01 WALL BACK REST - W2A04790
(x2) 1 15/16"X12 1/16"X14" (50x306x356)

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



STEP 23 - CONTROL PANEL

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



OG10 WIREWAY BOARD - W4L21877
(x1) 1 3/16"x3 3/8"x55 1/16" (30x86x1398)

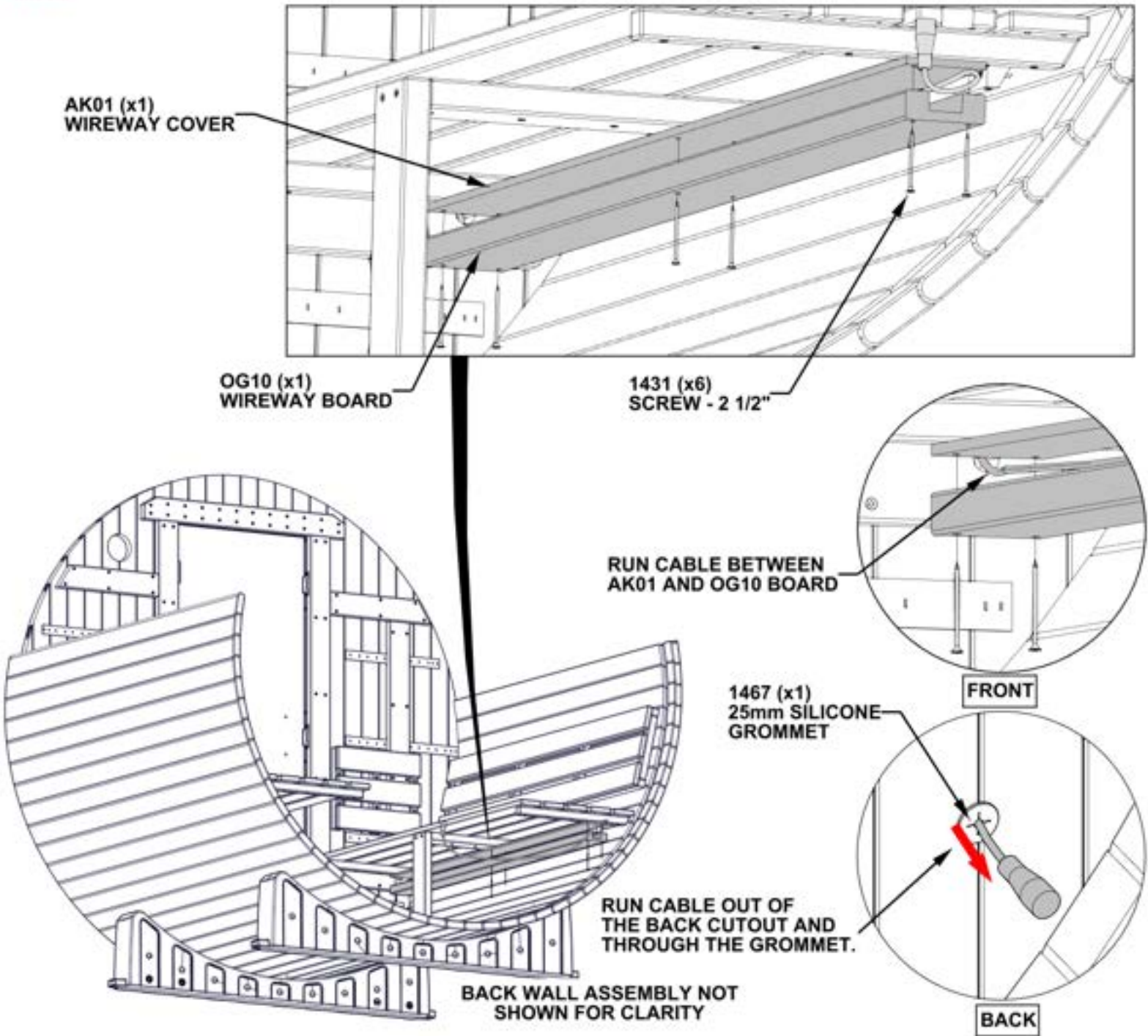


AK01 WIREWAY COVER - W4L21878
(x1) 5/16"x3 3/8"x55 1/16" (8x86x1398)



A6P01467 25mm SILICONE GROMMET
(x1)

- RUN CABLE BETWEEN AK01 AND OG10.
- ENSURE CABLE RUNS IN CHanneled PORTION OF OG10.
- NOTE, THE WIRING HARNESS EXCESS CAN BE BUNDLED WITH PROVIDED ZIP CABLE TIES.
- USE RIGHT ANGLE DRILL ADAPTER TO INSERT BACK SCREWS.
- **TAKE CAUTION WHEN ATTACHING SCREWS TO PREVENT PINCHING OR PENETRATING CABLE.**



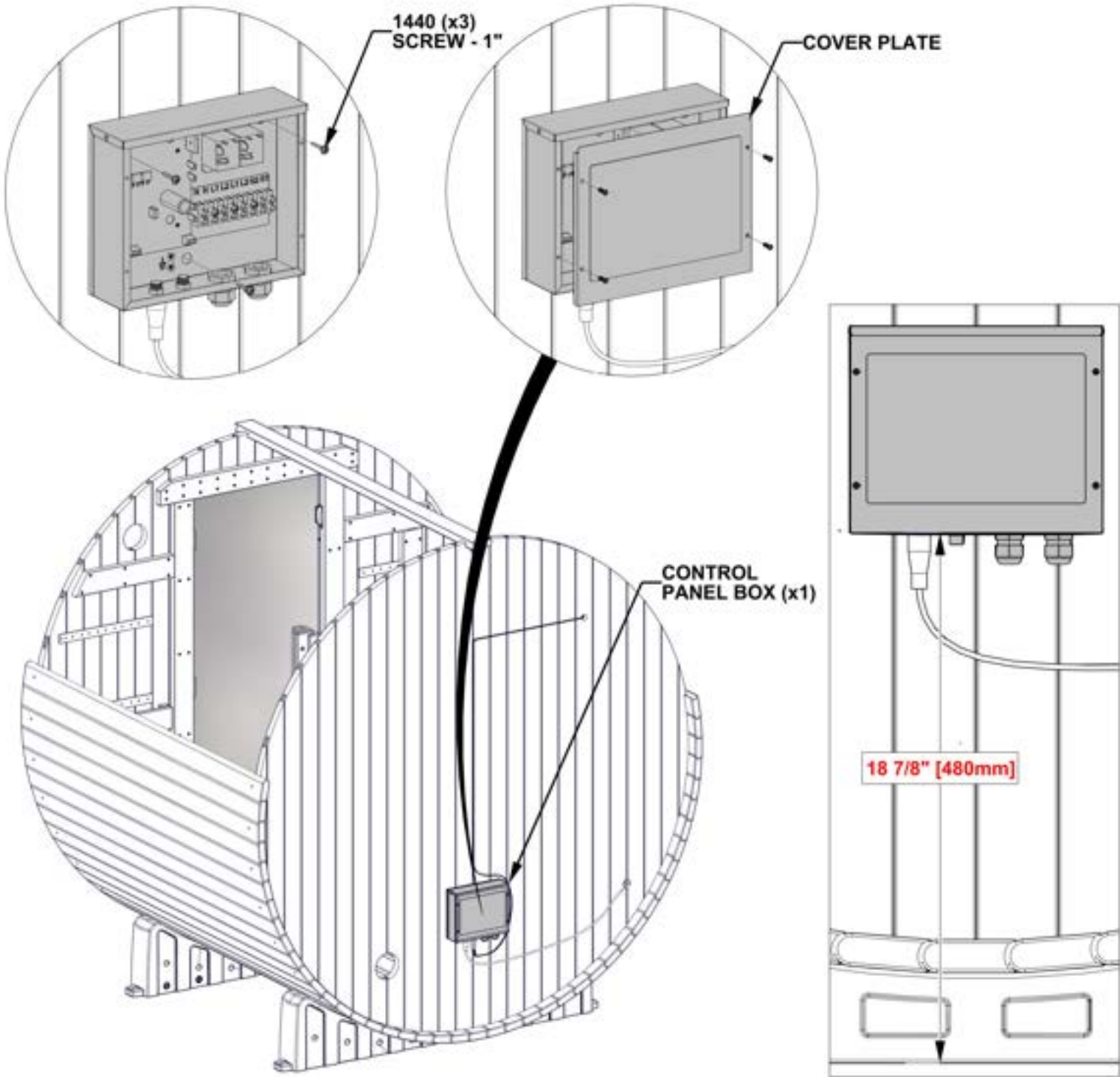
STEP 24 - CONTROL PANEL

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



A4M05590-01 CONTROL PANEL BOX
(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



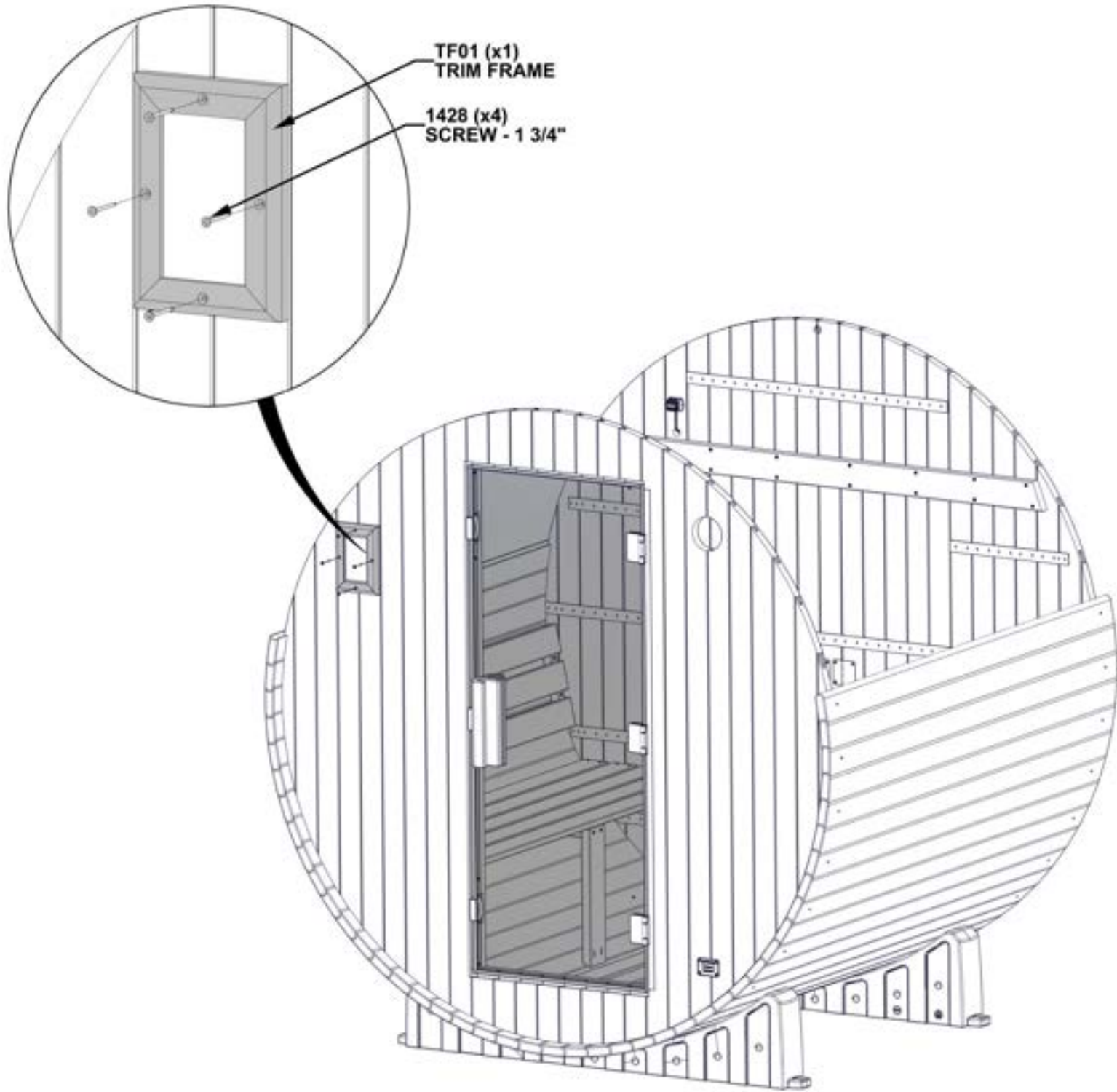
STEP 25 - CONTROL PANEL TRIM

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



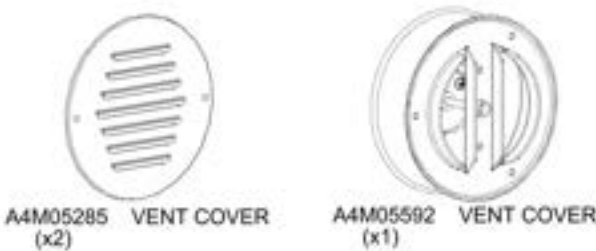
TF01 TRIM FRAME - W2A04797
(x1) 7/8"x5 9/16"x8 1/16" (22x142x142)

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

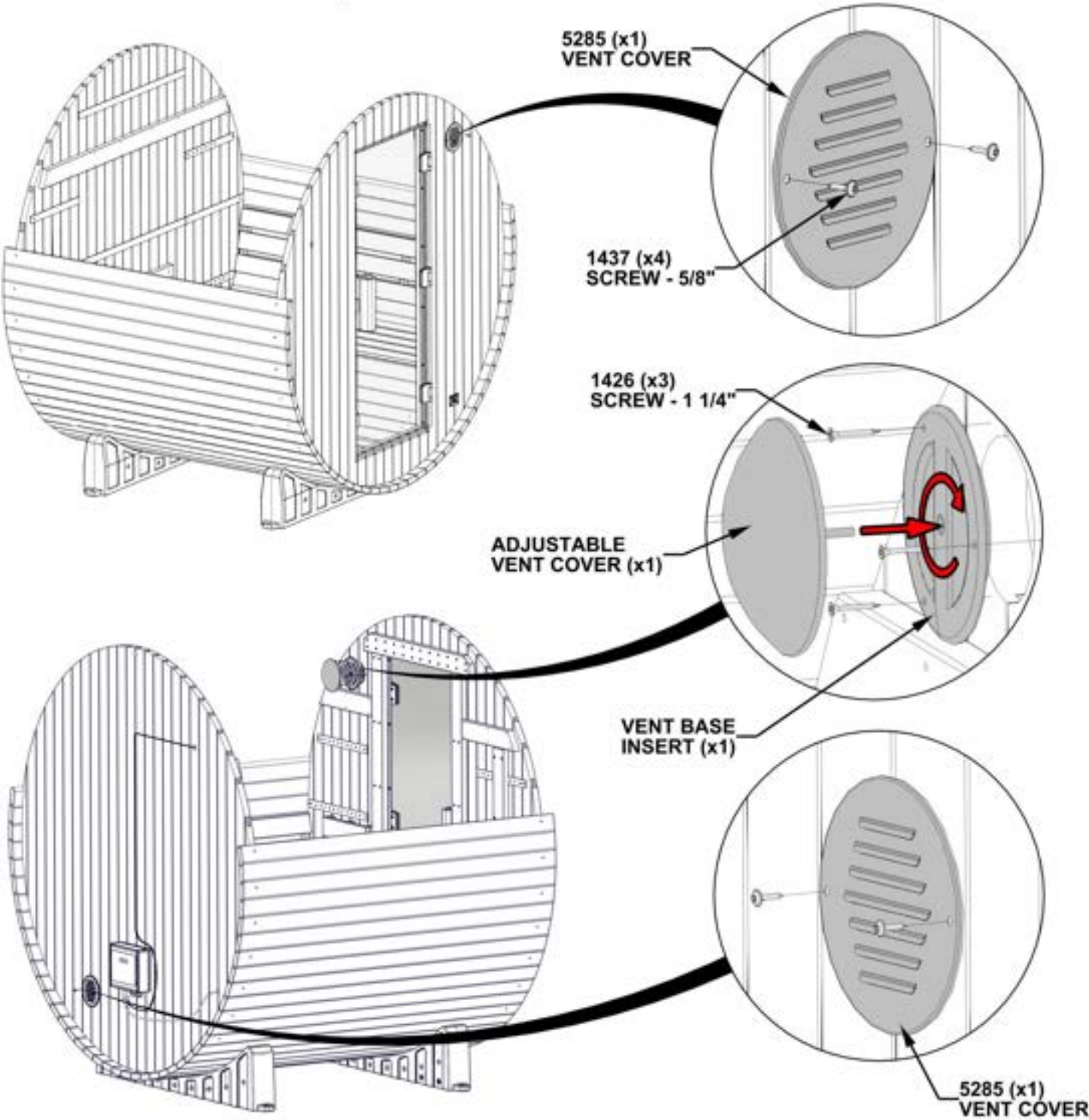


STEP 26 - VENT INSTALLATION

QTY	PART NUMBER	DESCRIPTION
3	H101426	SCREW TFH 8X1 1/4 SS-BLK
4	H101437	SCREW TWH 8x5/8 SS-BLK



- 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 27 - BARREL ASSEMBLY

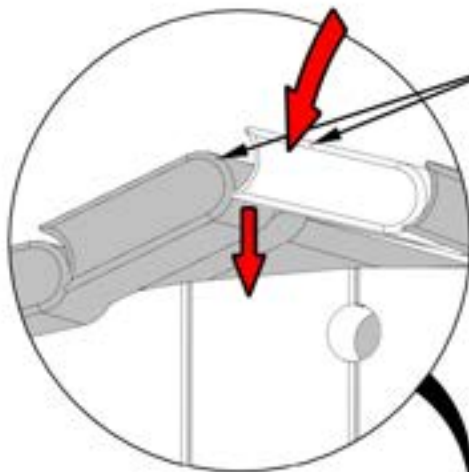


OG01 PERIMETER BOARD - W4L21857
(x33) 1 3/16"x3 3/8"x64" (30x86x1626)



BOARD SPACER KIT - W2A04798
(x1)

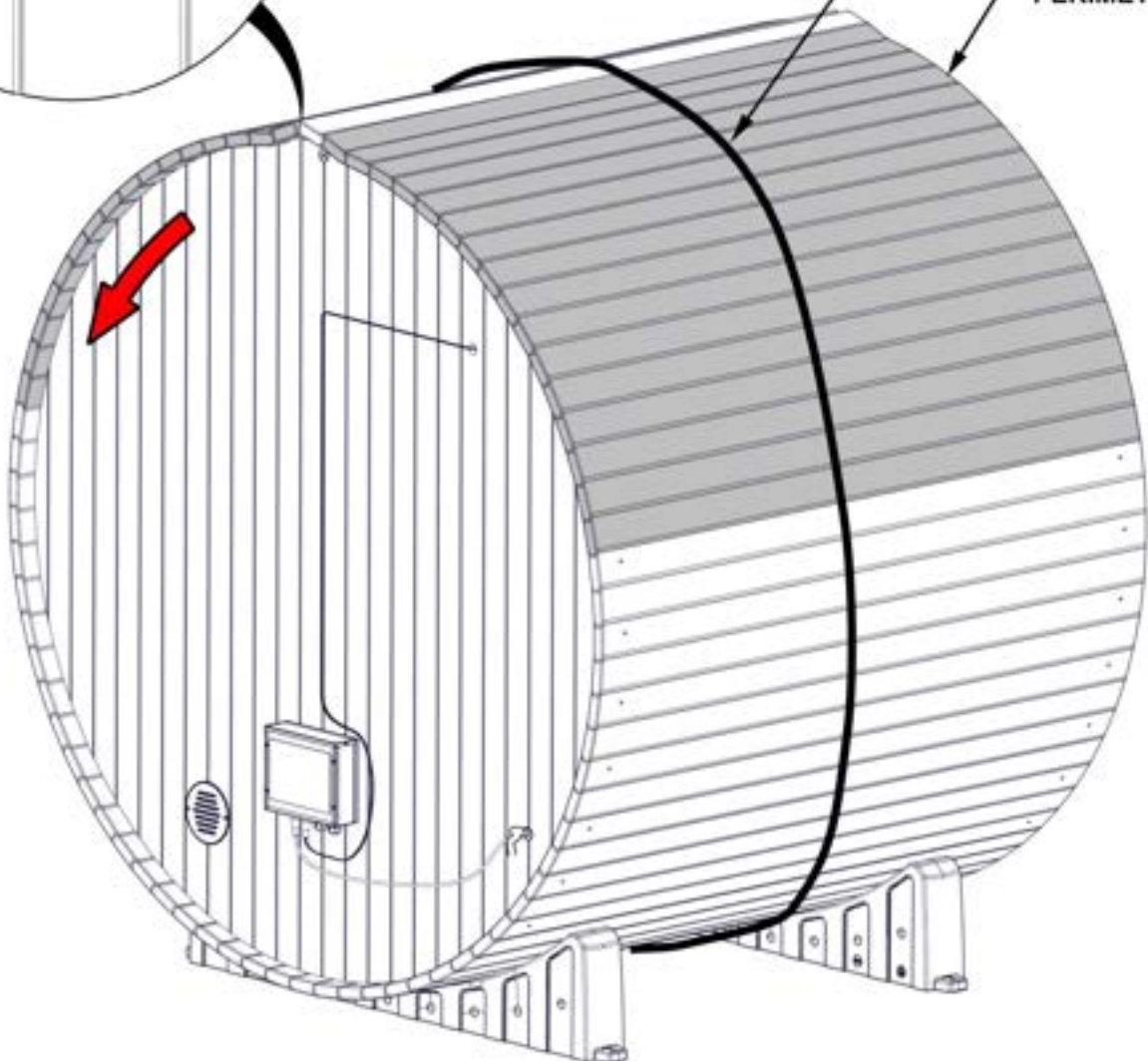
- A ROPE OR STRAP IS SUGGESTED TO BE LOOSELY TIED/ATTACHED AROUND THE BARREL TO HELP HOLD BOARDS IN PLACE.
- ALIGN GROOVE IN PERIMETER BOARDS WITH BOTH FRONT WALL AND BACK WALL ASSEMBLIES.
- WORKING UPWARDS, STACK PERIMETER BOARDS TO BOTH SIDES UNTIL THEY MEET AT THE TOP
- REMOVE TOP BOARD THAT WAS INSTALLED EARLIER TO HOLD THE WALLS AND REATTACH WHERE IT FITS BEST TO COMPLETE THE BARREL PERIMETER.
- FASTEN ONE OR TWO OF THE PERIMETER BOARDS TO THE WALLS WITH A SMALL NAIL TO HOLD IN PLACE.
- IT IS POSSIBLE THAT SOME SPACER BOARDS WILL BE NEEDED TO FILL ANY GAPS BETWEEN PERIMETER BOARDS.



LAST FEW BOARDS MAY REQUIRE TO ROLL
OUTWARDS AND PUSH BACK DOWN IN PLACE
AS SHOWN

LOOSELY TIED ROPE
OR STRAP
(NOT INCLUDED)

OG01 (x33)
PERIMETER BOARD



STEP 28 - BARREL ASSEMBLY

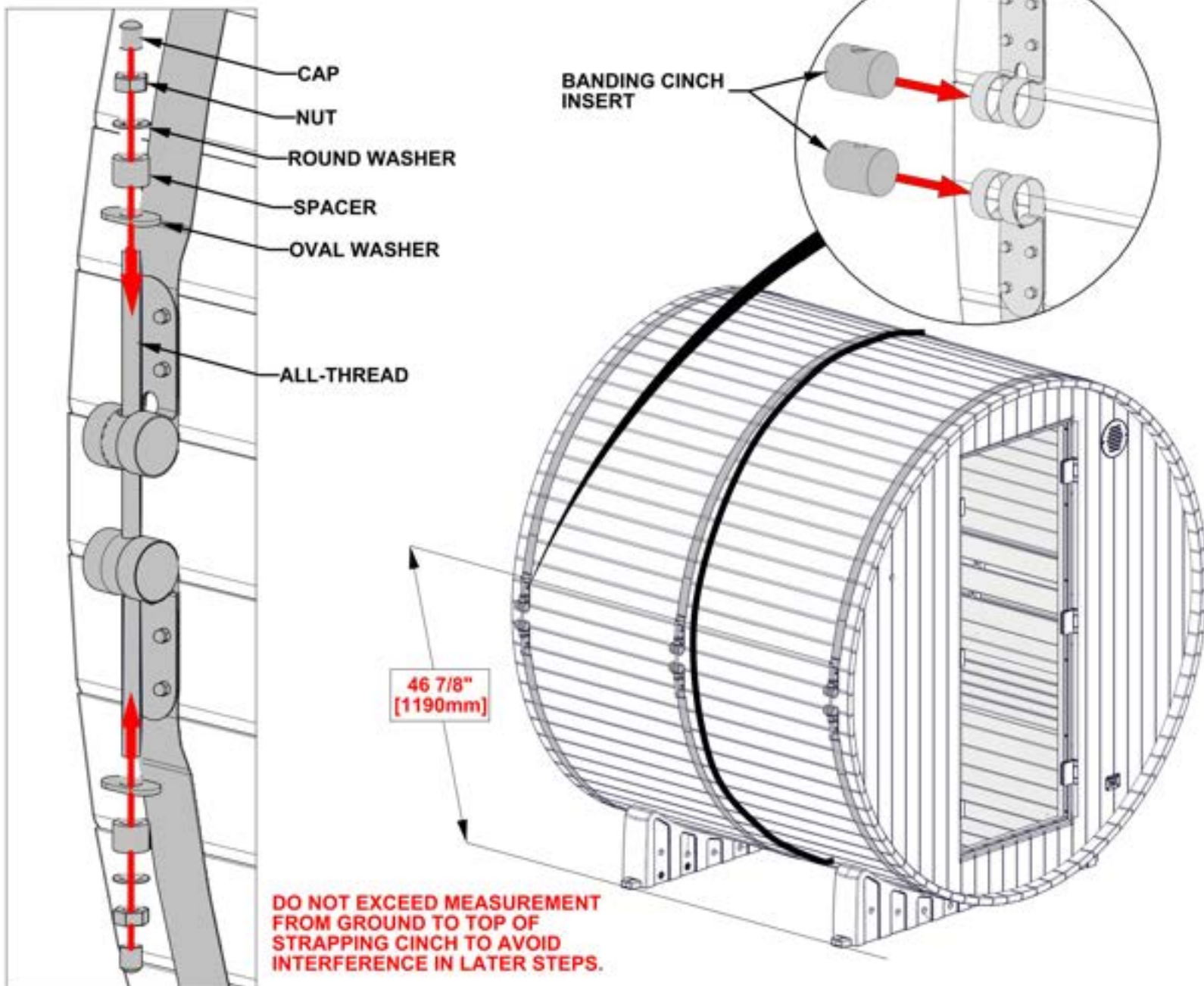


A4M05671 STRAPPING CINCH
(x3)



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 NAILS INSTALLED IN STEP 9.
- 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 NAILS 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.

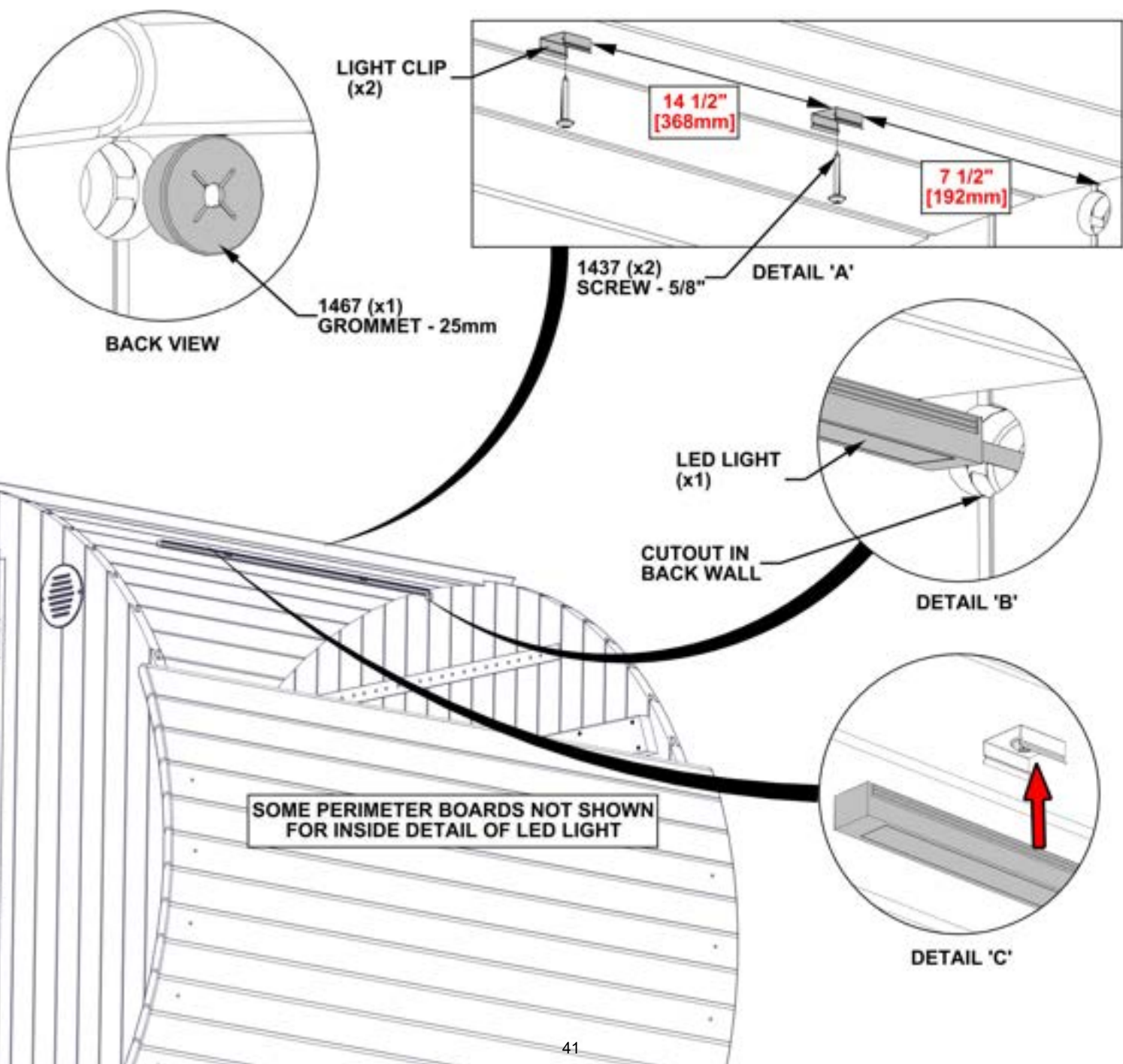


STEP 29 - LED LIGHT

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

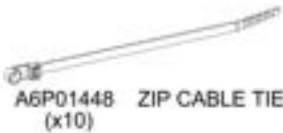
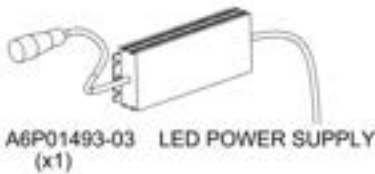


- INSTALL GROMMET IN THE TOP OF THE BACK WALL PANEL ASSEMBLY AS SHOWN.
- INSTALL CLIPS ON THE TOP CENTER BOARD AS SHOWN USING APPROXIMATE DIMENSIONS. (DETAIL 'A')
- THREAD CHORD THROUGH CUTOUT AND GROMMET. (DETAIL 'B')
- SNAP LED LIGHT INTO LIGHT CLIPS. (DETAIL 'C')

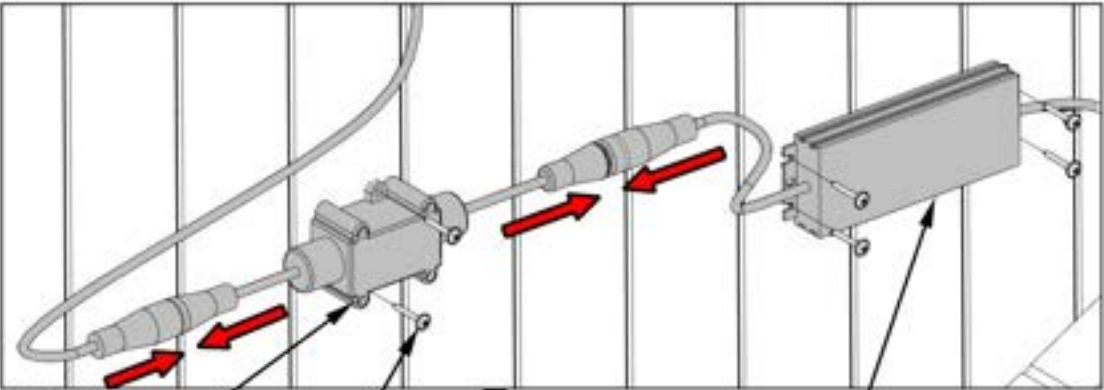
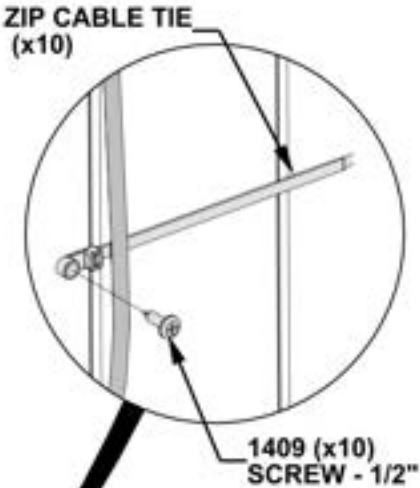
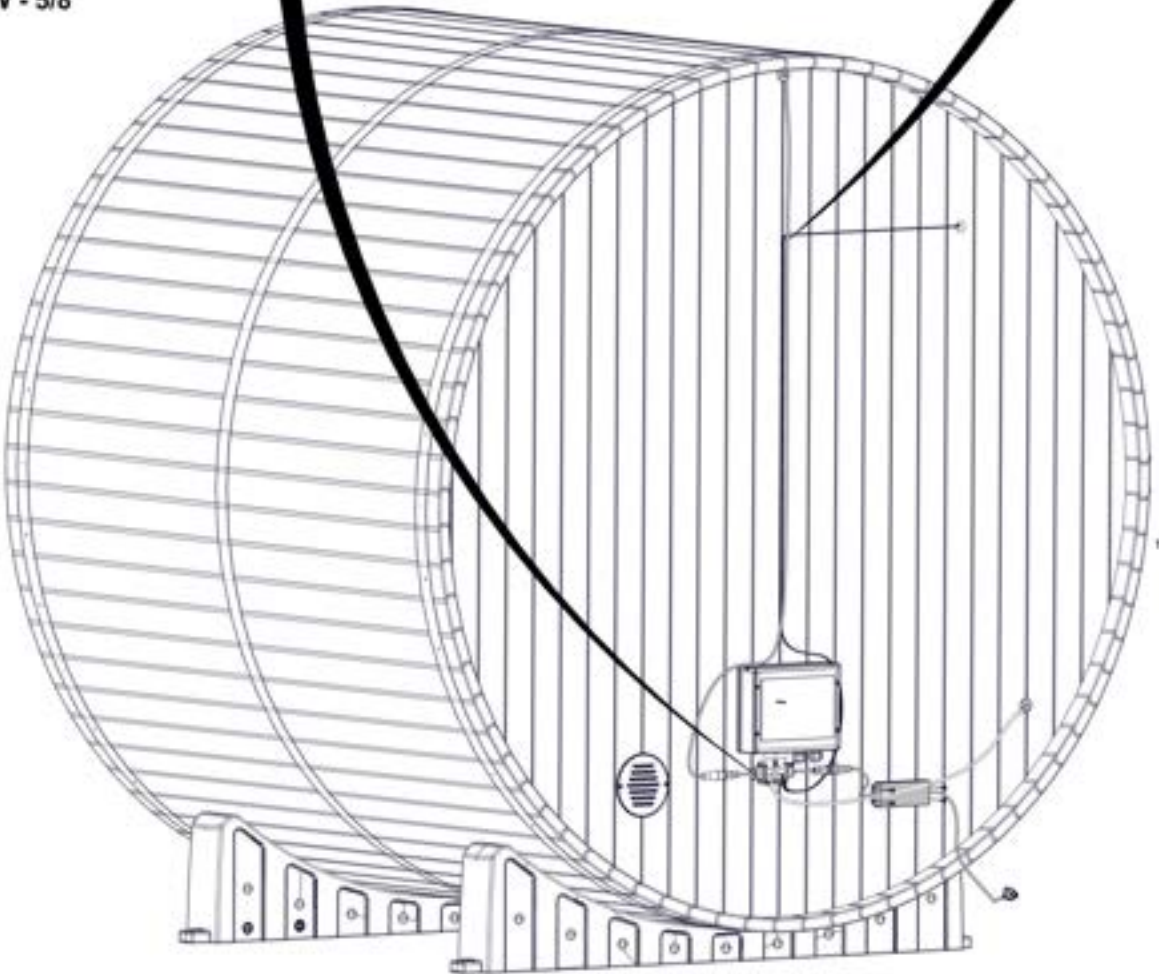


STEP 30 - LED LIGHT

QTY	PART NUMBER	DESCRIPTION
10	H101409	SCREW PPH 4x1/2 BLK
6	H101437	SCREW TWH 8x5/8 SS-BLK



- LOCATE REMOTE MODULE AND LED POWER SUPPLY IN THE APPROXIMATE LOCATION.
- KEEP BOTH MODULE AND POWER SUPPLY HORIZONTAL WHEN ATTACHING.
- USE ZIP TIES AT OWN PREFERRED LOCATIONS TO ATTACH CABLE



STEP 31 - DOOR HANDLE

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

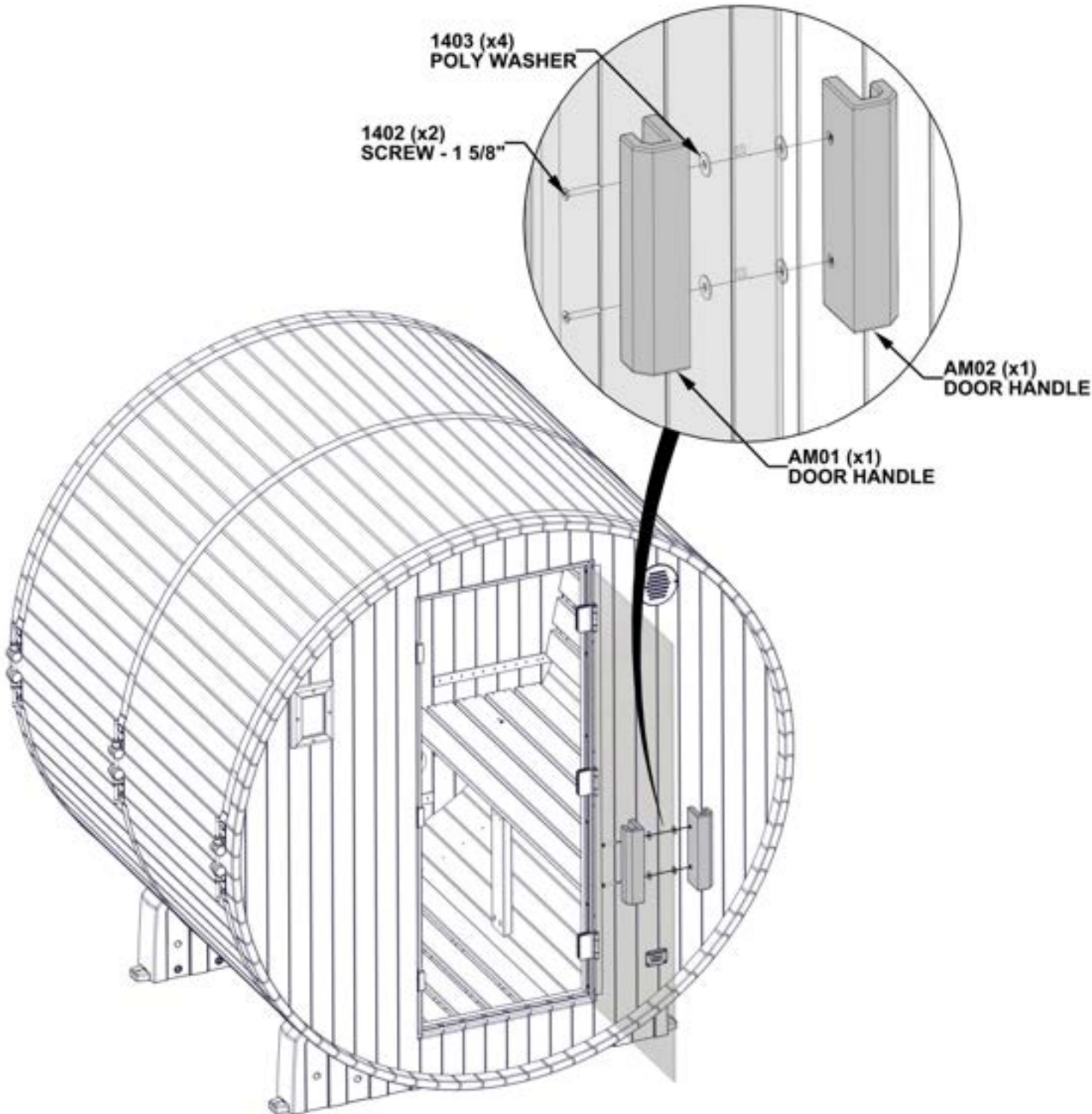


AM01 DOOR HANDLE - W4L21861
(x1) 2 1/4"x3"x10 3/16" (57x76x258)



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

- THE UNFINISHED HANDLE WILL BE LOCATED ON THE INSIDE



STEP 32 - TRIM

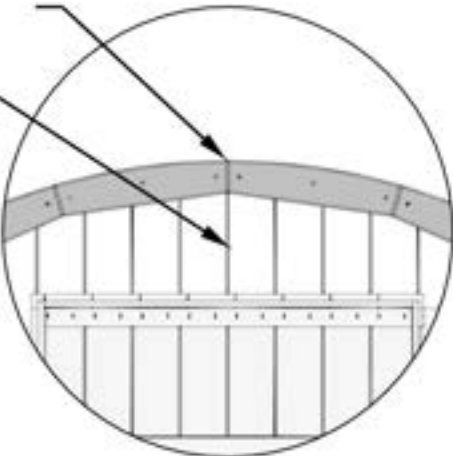
QTY	PART NUMBER	DESCRIPTION
60	H101429	SCREW TFH 8X2 SS-BLK



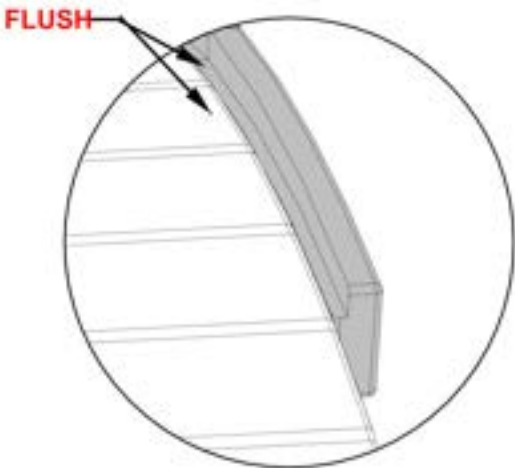
NR02 TRIM - W4L21866
(x20) 13/16"x2 3/8"x10 15/16" (20x60x278)

START TRIM AT CENTER OF BARREL
AND WORK DOWNWARDS IN
BOTH DIRECTIONS FOR BOTH
FRONT AND BACK OF UNIT

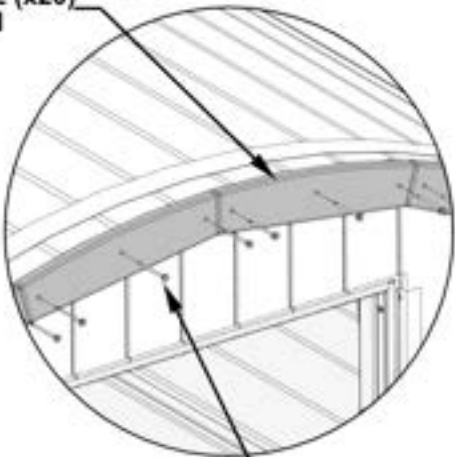
NOTE WALL SEAM TO
FIND CENTER OF BARREL



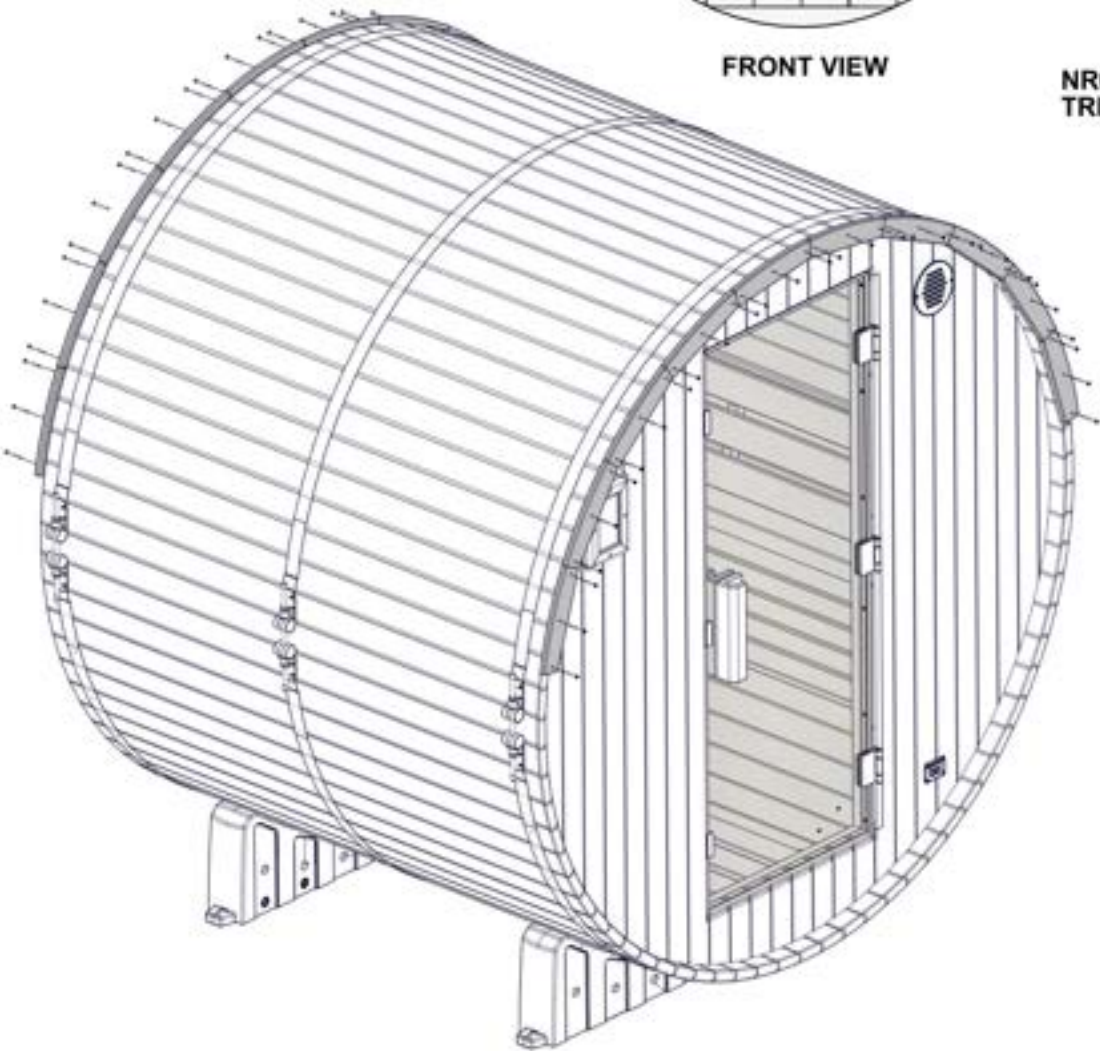
FRONT VIEW



NR02 (x20)
TRIM



1429 (x60)
SCREW - 2"



STEP 33 - METAL SHEETING

QTY	PART NUMBER	DESCRIPTION
48	H101117	SCREW WOODGRIP 10-16x3/4" 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.**
- **THE TOP SHEET SHOULD OVERLAP THE SECOND SHEETS ON BOTH SIDES. THE OVERLAP IS CRITICAL TO AVOID LEAKING.**

5282 (x6)
29GA SHEETING

TRIM FROM
PREVIOUS STEP

**CENTER TOP
RIB AS SHOWN.**

1117 (x48)
SCREW WOODGRIP

**ENSURE CORRECT
OVERLAP.**

STEP 34 - HEATER GUARD

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



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

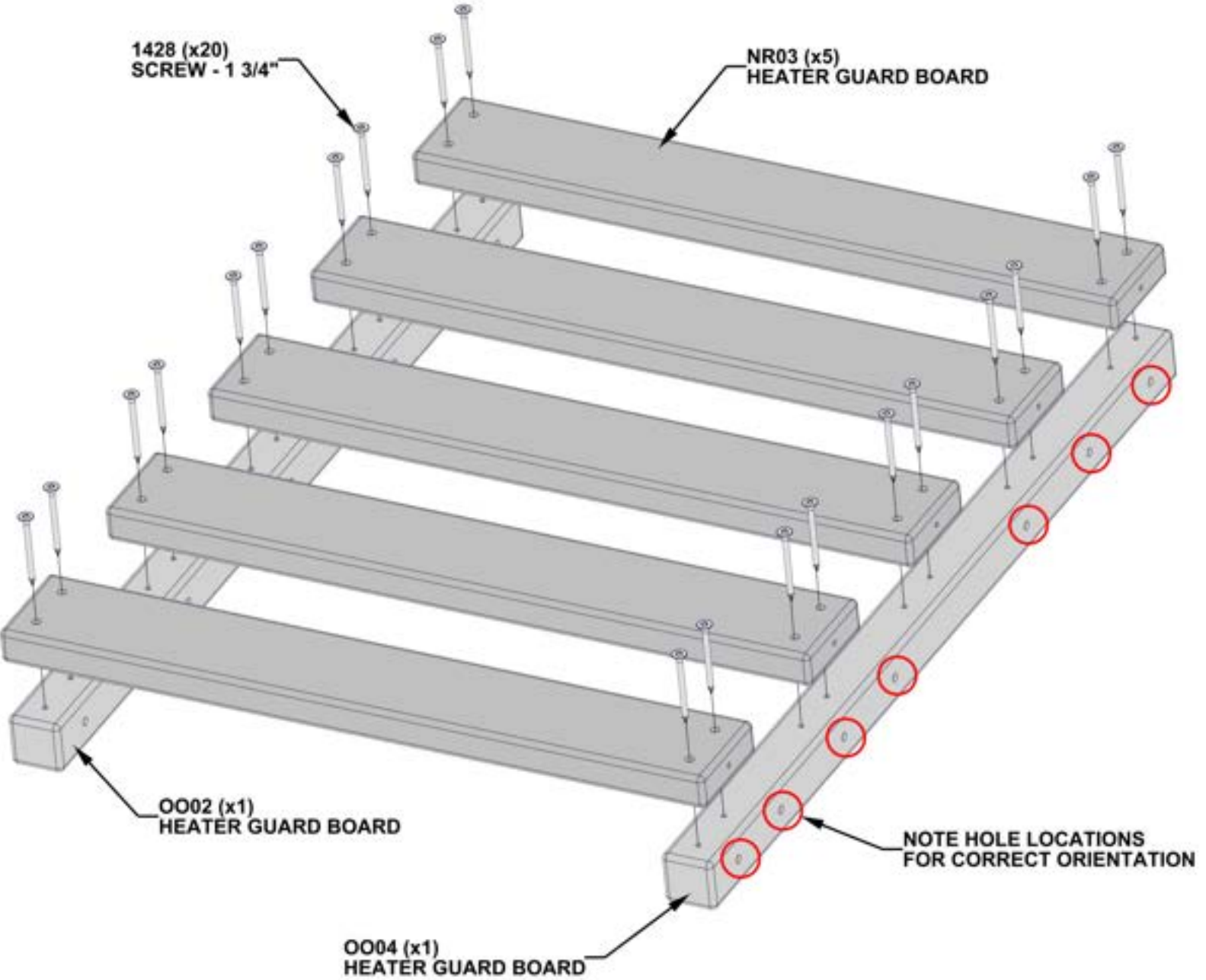


OO04 HEATER GUARD BOARD - W4L21871
(x1) 1 3/16"x1 3/16"x21 7/16" (30x30x544)



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

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



STEP 35 - HEATER GUARD

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



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

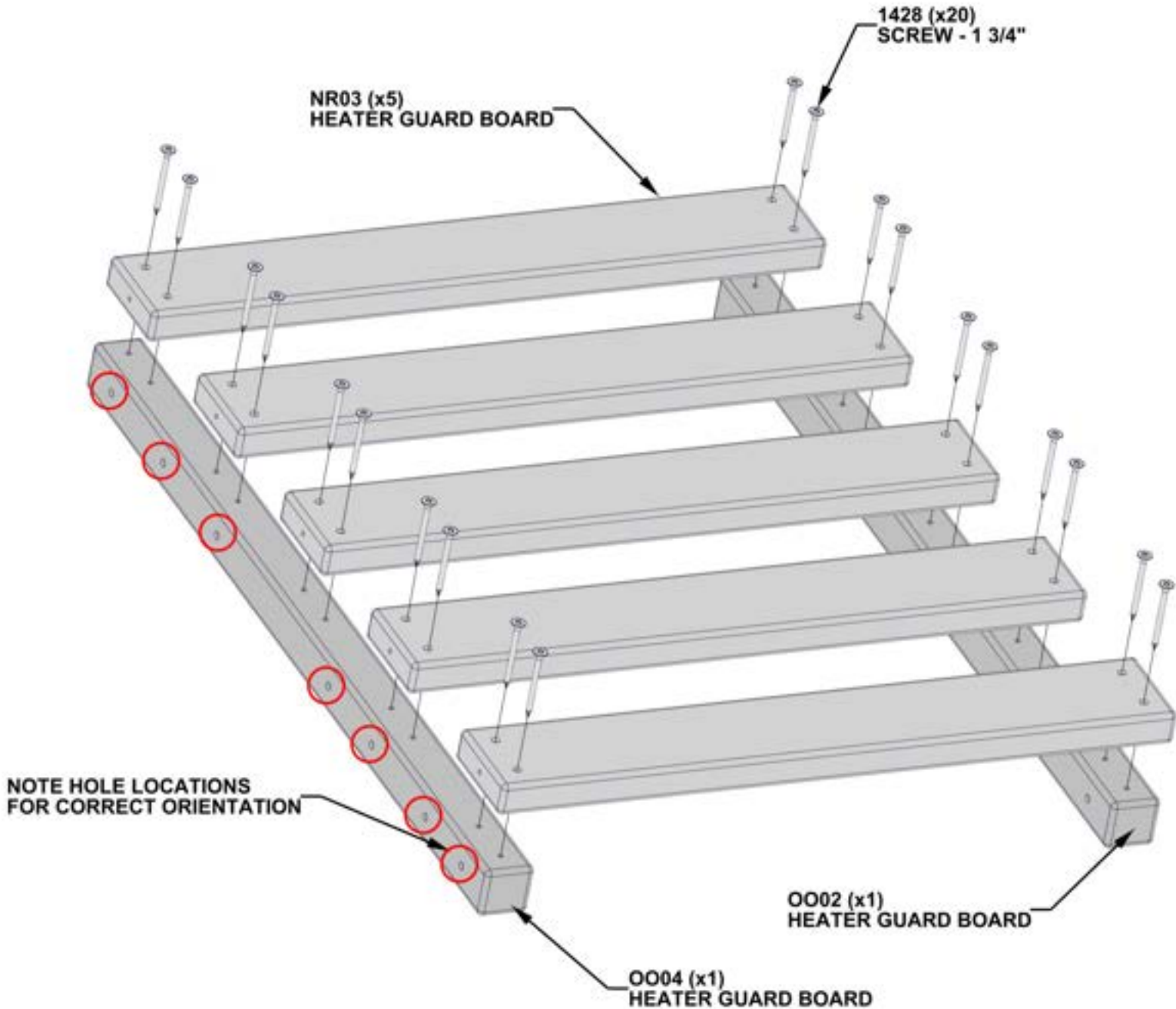


OO02 HEATER GUARD BOARD - W4L21875
(x1) 1 3/16"x1 3/16"x21 7/16" (30x30x544)



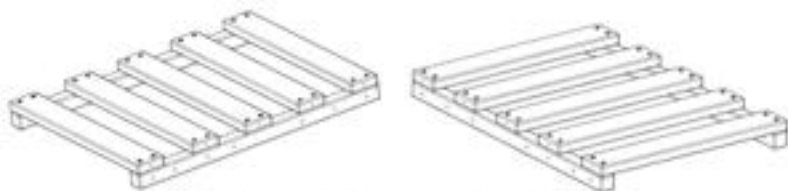
OO04 HEATER GUARD BOARD - W4L21871
(x1) 1 3/16"x1 3/16"x21 7/16" (30x30x544)

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



STEP 36 - HEATER GUARD

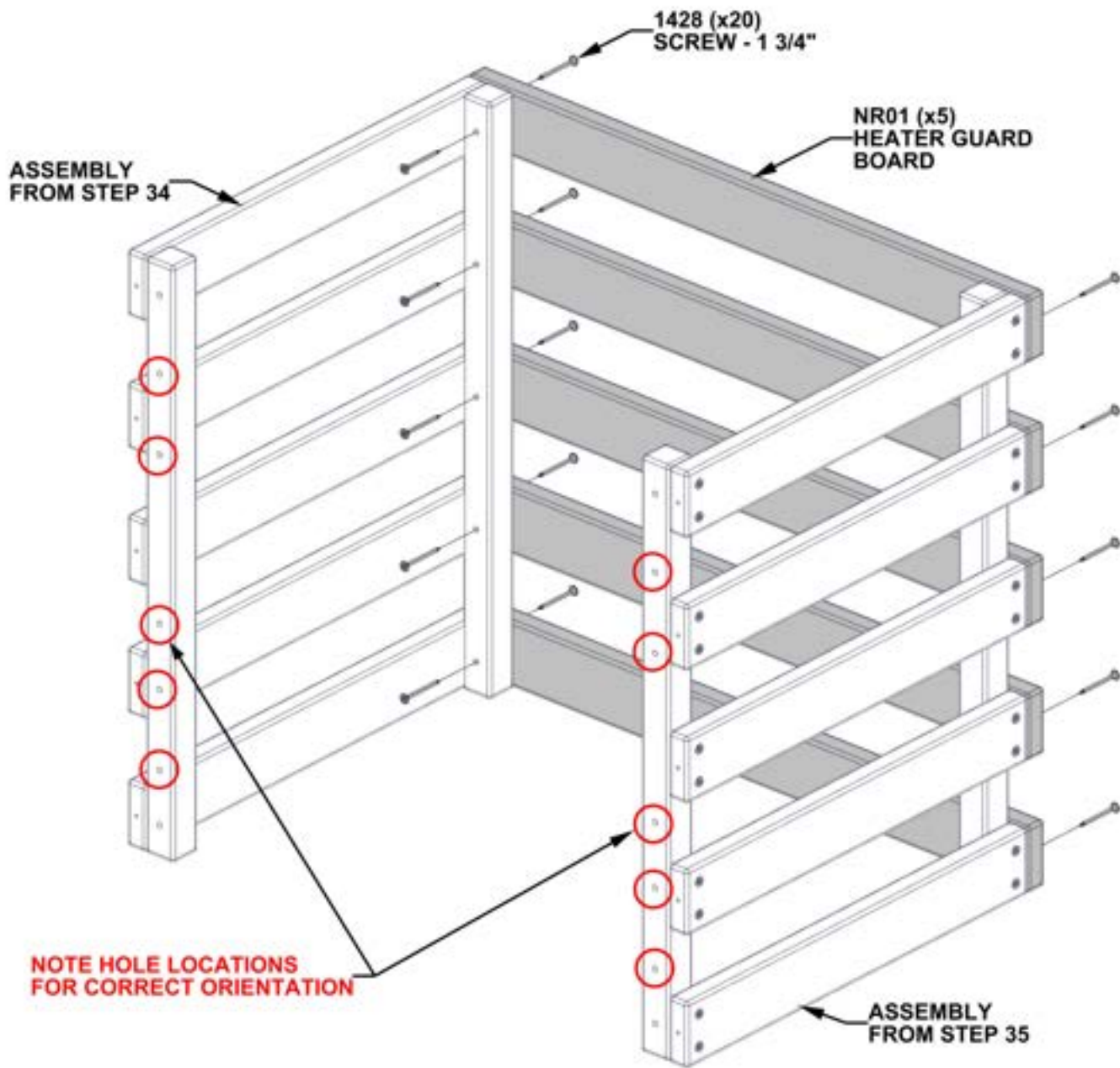
QTY	PART NUMBER	DESCRIPTION
20	H101428	SCREW TFH 8X1 3/4 SS-BLK



ASSEMBLIES FROM STEPS 34 & 35



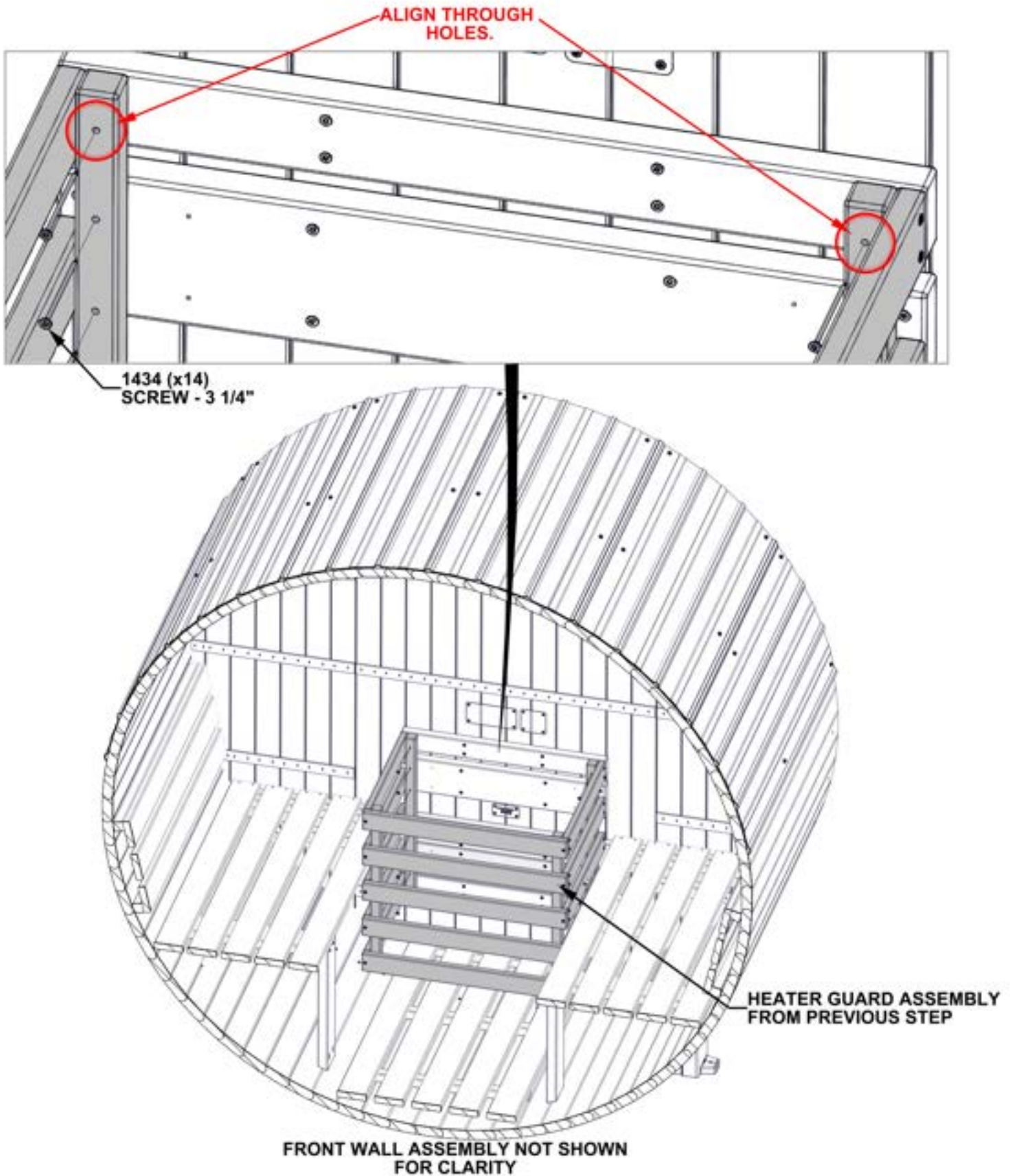
NR01 HEATER GUARD BOARD - W4L21872
(x5) 13/16"x2 3/8"x23 15/16" (20x60x808)



STEP 37 - HEATER GUARD

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.



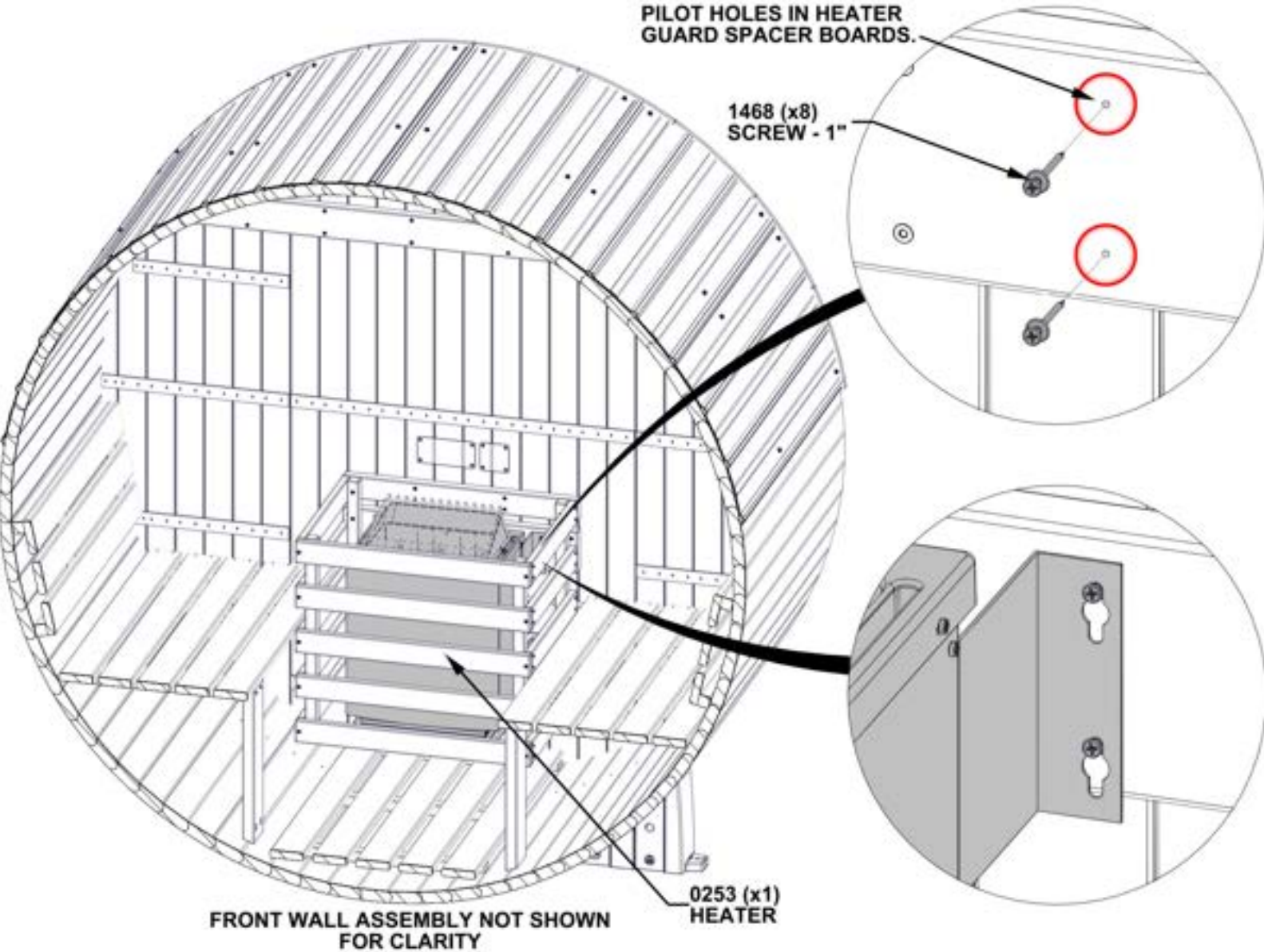
STEP 38 - HEATER

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



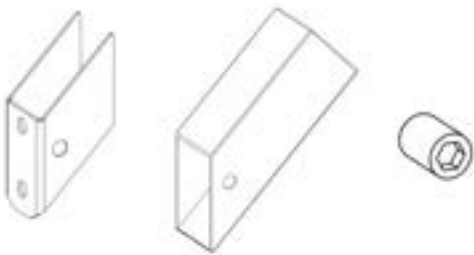
9250253 HEATER
(x1)

- 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.
- SEE HEATER INSTRUCTIONS FOR INSTALLATION.
- INSERT SCREWS INTO PILOT HOLES IN HEATER GUARD SPACER BOARDS.
- HANG HEATER ONTO SCREWS, ENSURING ALL 8 SCREWS ARE ALIGNED INTO THE SLOTS IN THE HEATER AS SHOWN.



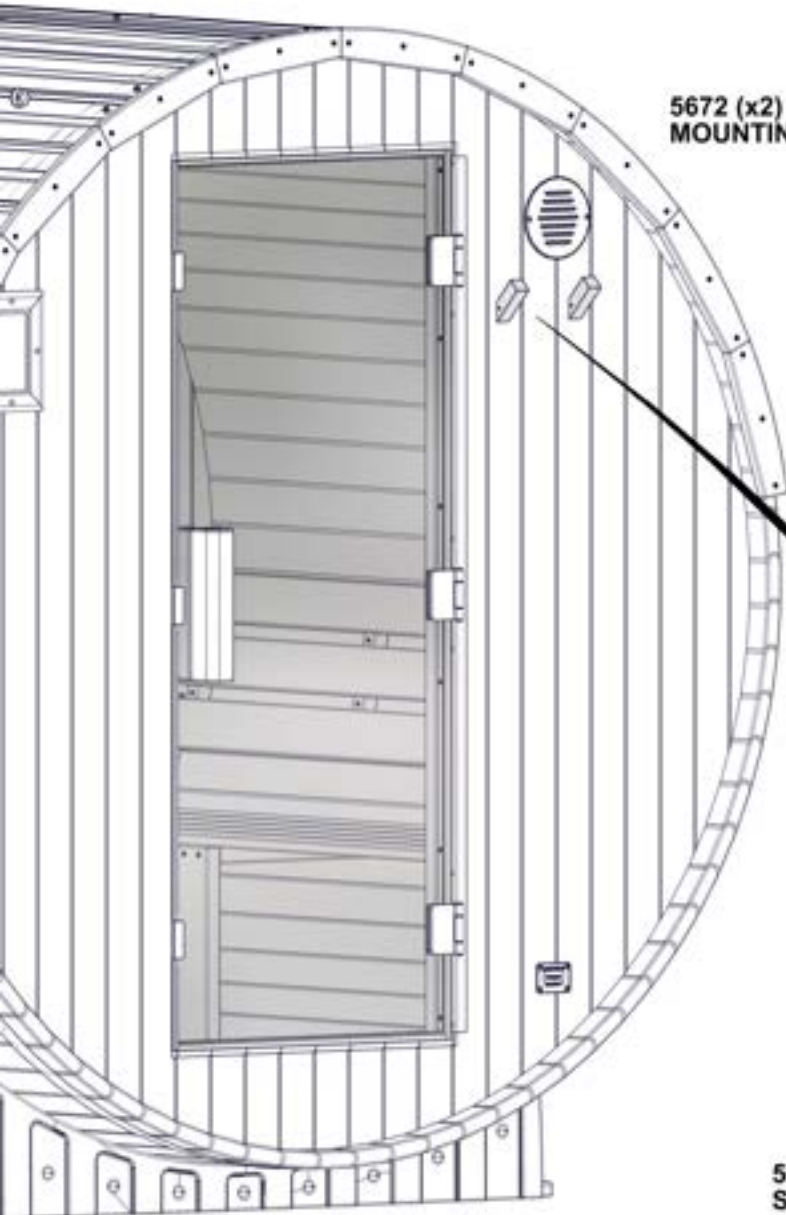
STEP 39 - TOWEL HANGER

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



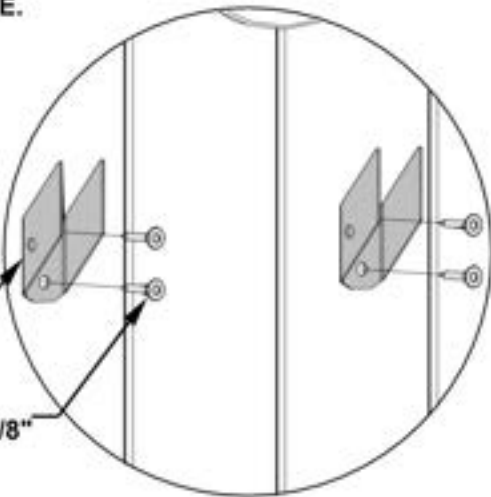
A4M05672 TOWEL HANGER
(x2)

- 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.

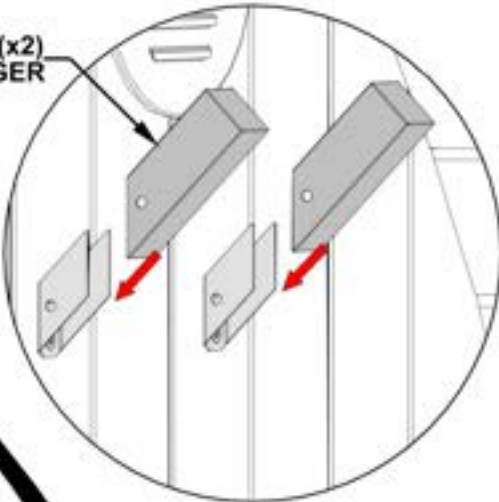


5672 (x2)
MOUNTING BRACKET

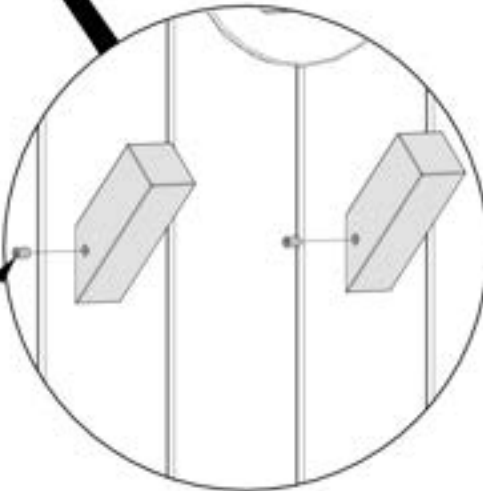
1423 (x4)
SCREW - 7/8"



5672 (x2)
HANGER



5672 (x2)
SET SCREW

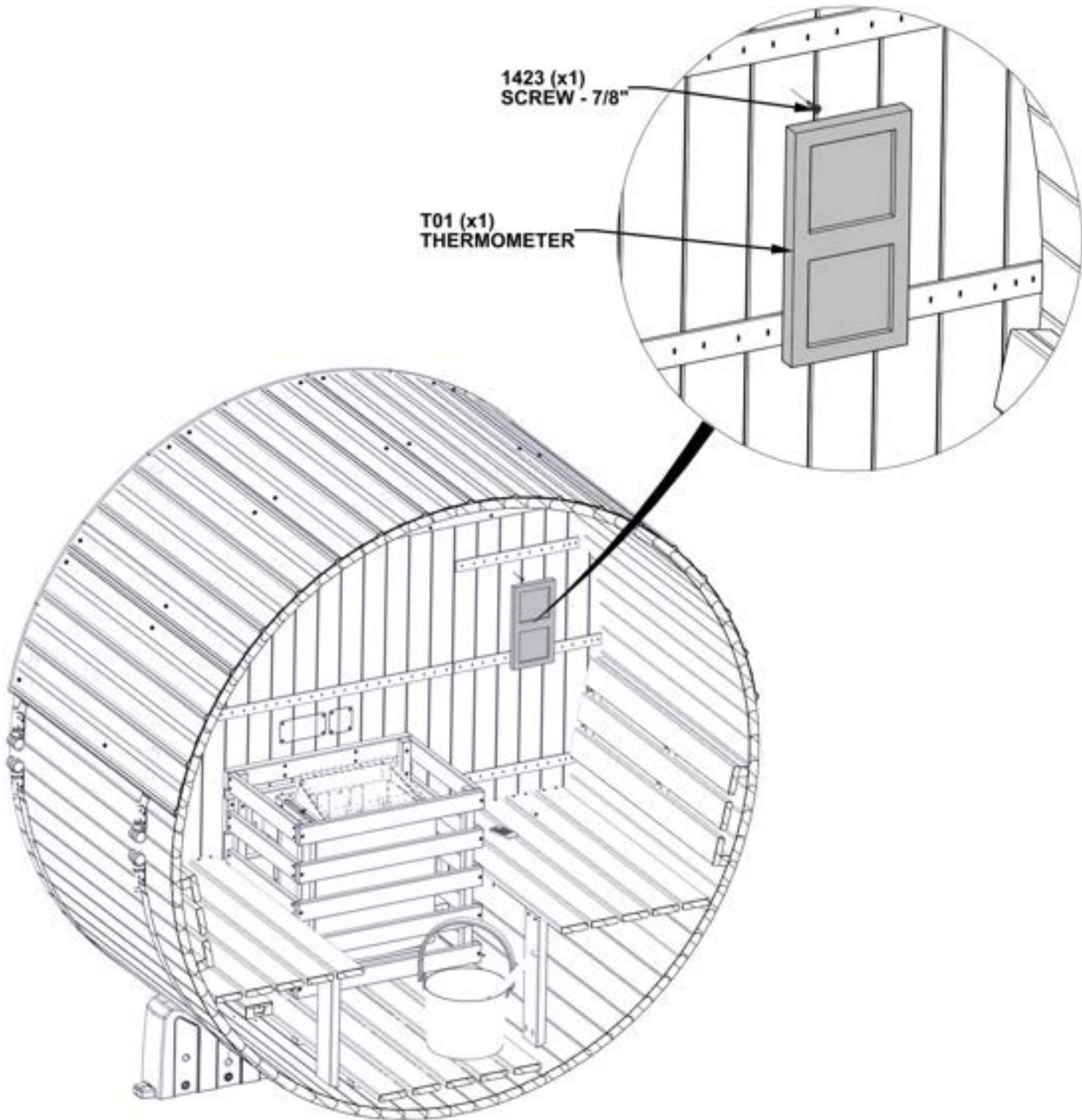


STEP 40 - THERMOMETER INSTALLATION

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



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



STEP 41 - ELECTRICAL

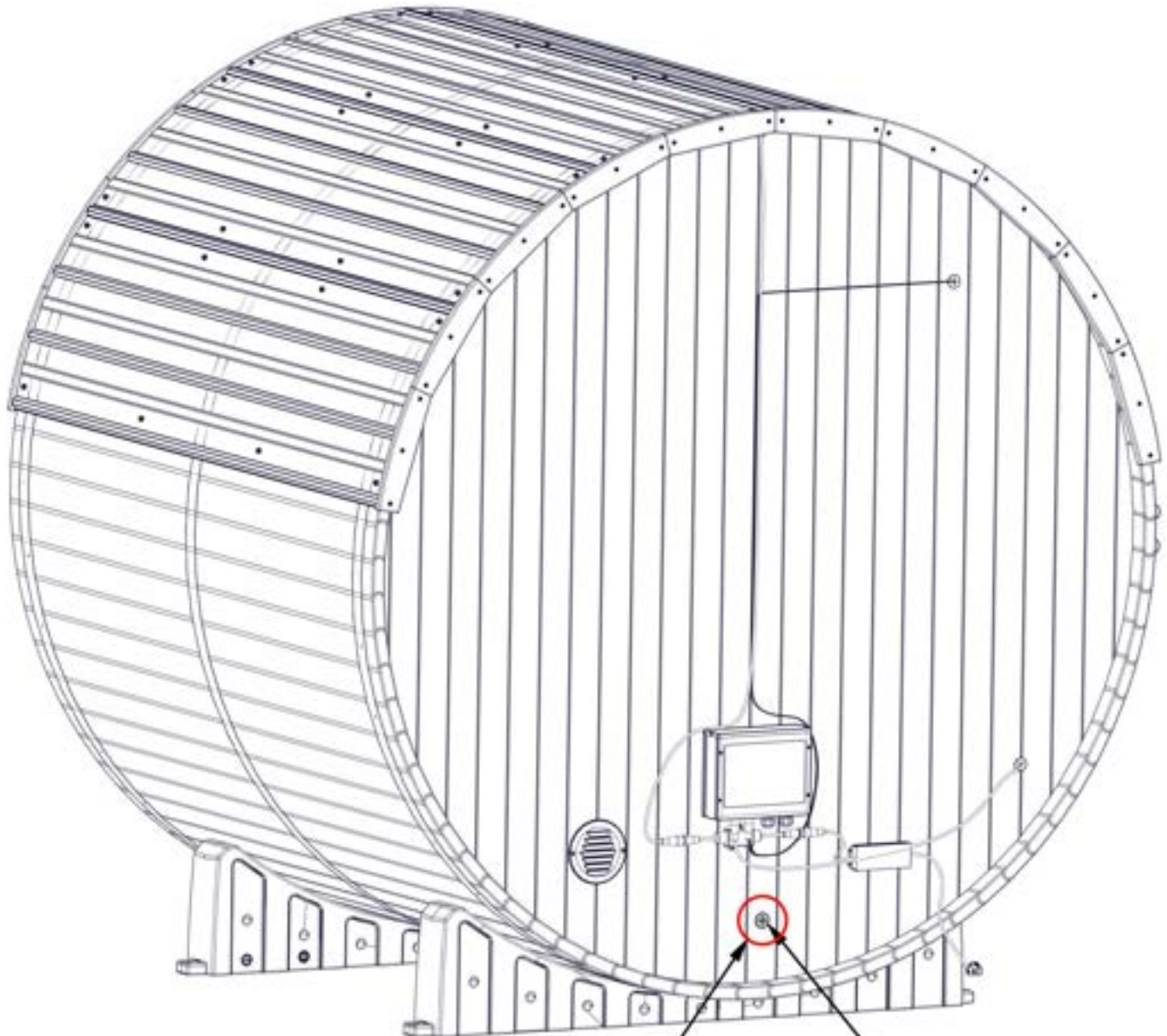


A6P01468 30mm SILICONE GROMMET
(x1)



A6P01489 SAUNA POWER WIRE
(x1)

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



RUN SAUNA POWER WIRE
THROUGH HOLE IN BACK WALL.

1468 (x1)
GROMMET - 30mm

STEP 42 - 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.

