



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

# INFRARED SAUNA

## MODEL # : 2504387



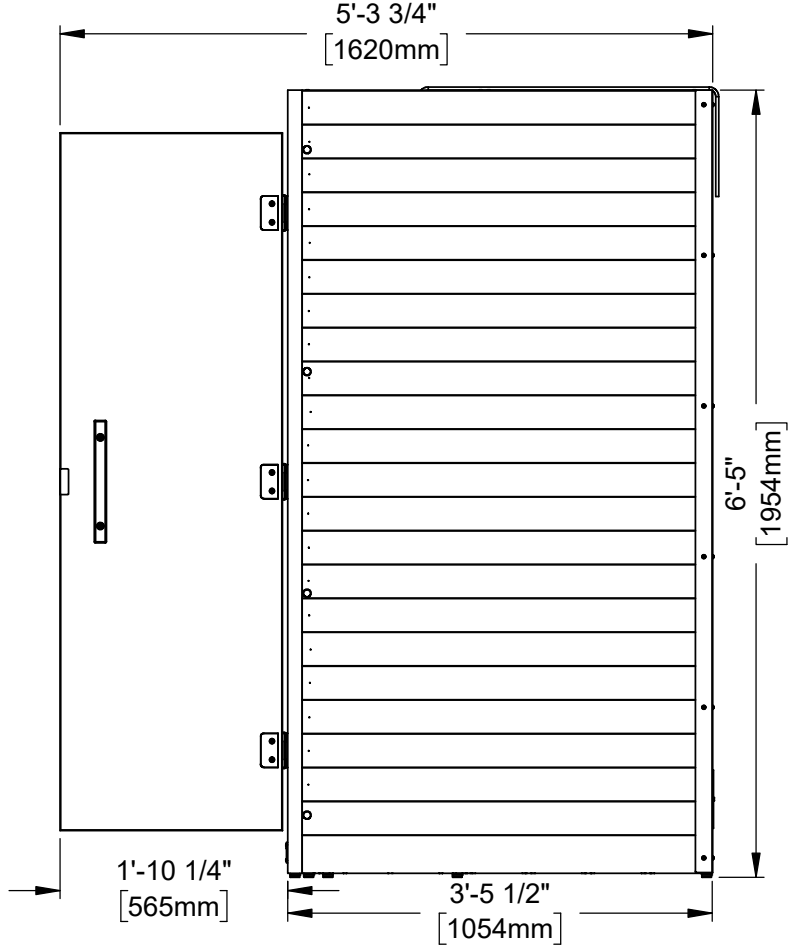
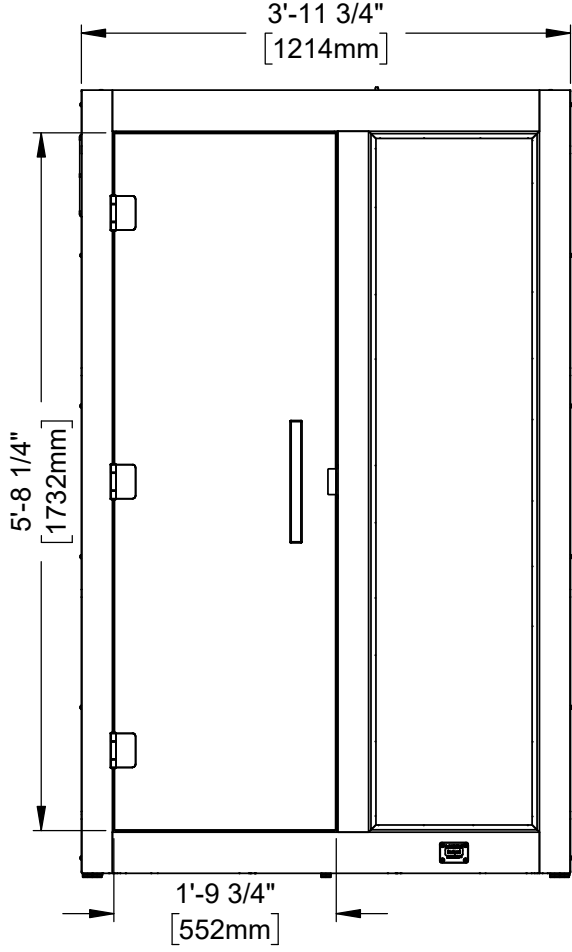
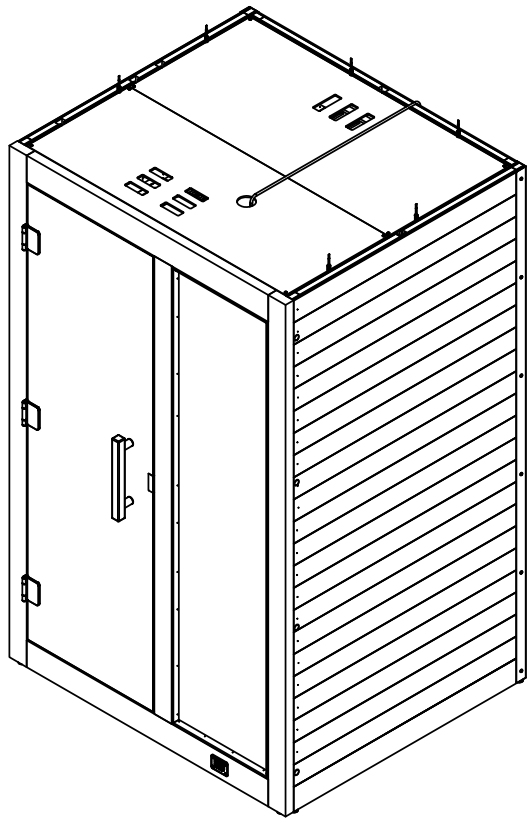
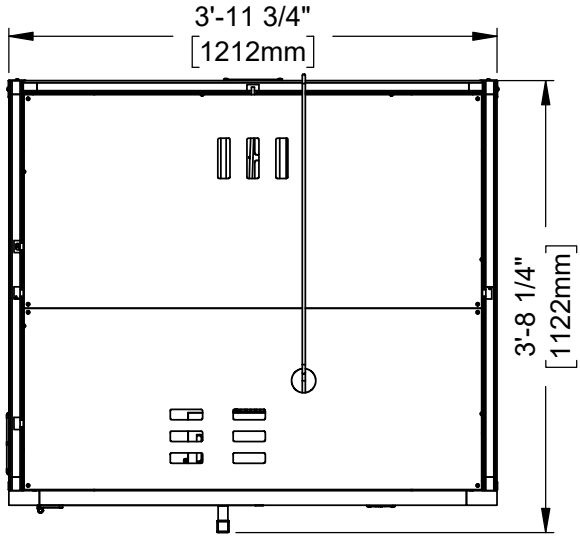
Please visit [www.backyarddiscovery.com](http://www.backyarddiscovery.com)  
For the most up to date assembly manual, to register your product, or to order  
replacement parts *Para obtener instrucciones en español, visite*  
[www.backyarddiscovery.com](http://www.backyarddiscovery.com)



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



# OWNER'S MANUAL - BASIC SETUP DIMENSIONS & ASSEMBLY NOTES



# OWNERS MANUAL - GENERAL INFORMATION

FOR INDOOR USE ONLY  
240V / 15AMP DEDICATED CIRCUIT REQUIRED

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**WARNING:** Before assembly, visually inspect all heaters for any signs of damage. Excessive vibrations during transport may harm the heating elements. **DO NOT START** the sauna if any damage is detected. Contact Backyard Discovery for troubleshooting and replacement parts.

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Note: Your sauna has been completely assembled and tested prior to packaging.

**TWO adults are needed for assembly.**

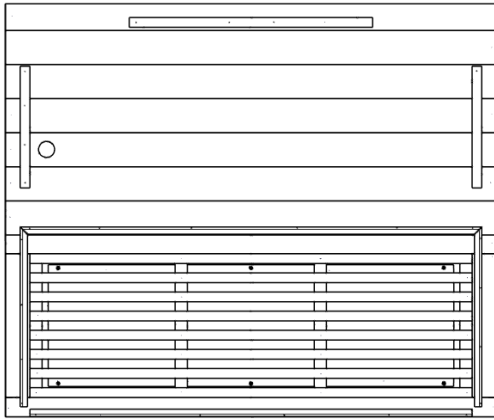
Choose a good indoor location to install the sauna:

- Location should be dry, level and away from any source of water
- Do not install the sauna near water sources such as bathtubs, showers, wet basements, or swimming pools where water may splash on the sauna.
- Main power cord must be easily accessible.
- Ensure the power supply cord does not create a trip hazard and is not pinched by surrounding objects.
- Do not use wall receptacle adapters, surge protectors, or extension cords between the sauna cord and the wall outlet.

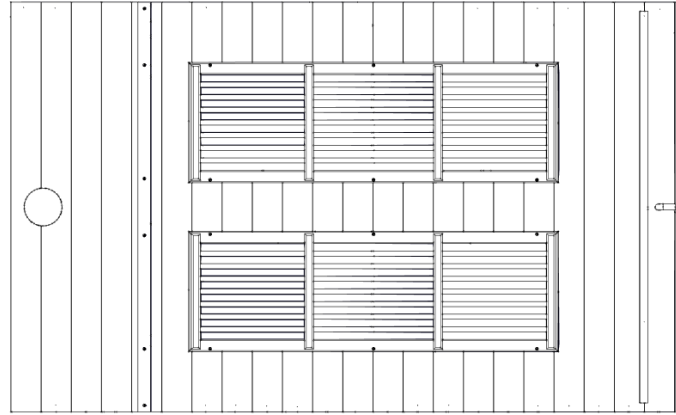
Replacement Parts: When replacement parts are needed, ensure they meet the manufacturer's specified requirements. Unauthorized substitutes may result in fire, electrical shock, or other hazards. Please contact Customer Service directly for the repair parts.

# OWNER'S MANUAL - PARTS IDENTIFICATION

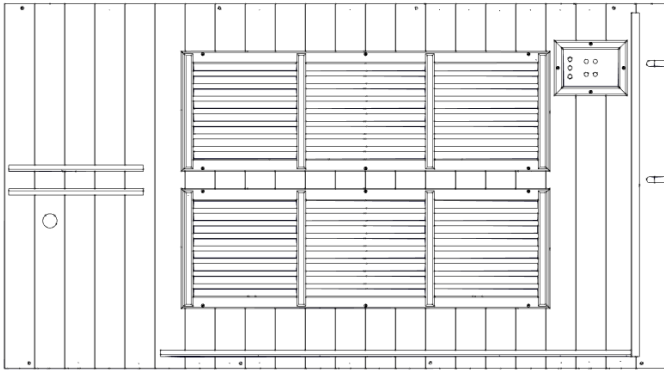
WOOD COMPONENTS (NOT TO SCALE)



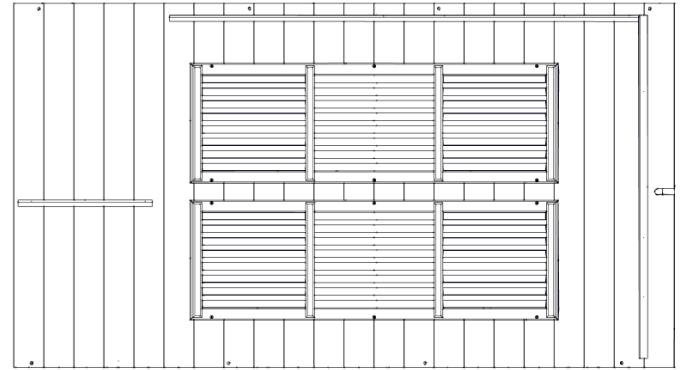
P01 FLOOR PANEL - W2A04760  
(x1) 4 5/8"x40 1/16"x47 11/16" (118x1018x1212)



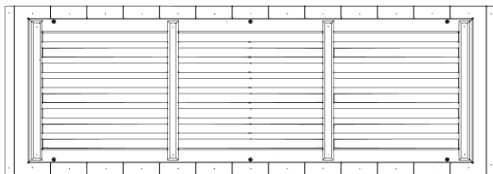
P02 BACK WALL PANEL - W2A04752  
(x1) 2 11/16"x44 7/8"x72 13/16" (69x1140x1850)



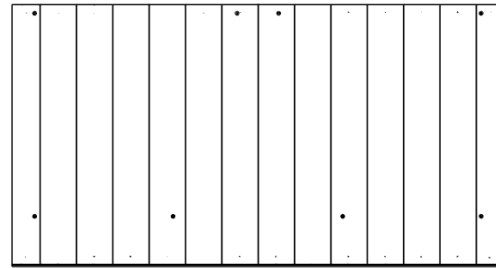
P03 SIDE WALL PANEL - W2A04754  
(x1) 61x40 1/16"x72 13/16" (2 3/8"x1018x1850)



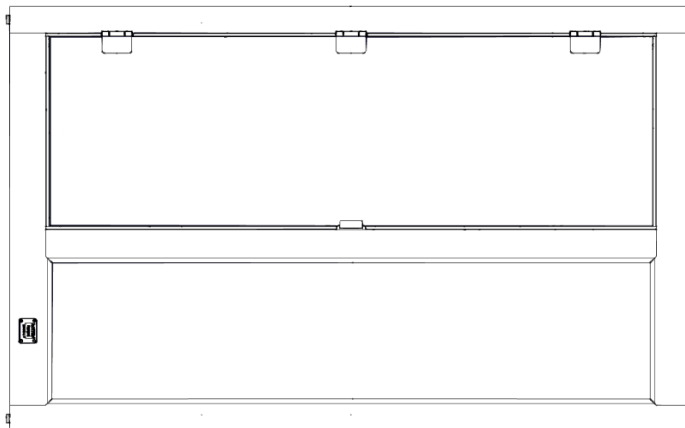
P04 SIDE WALL PANEL - W2A04755  
(x1) 2 3/8"x40 1/16"x72 13/16" (61x1018x1850)



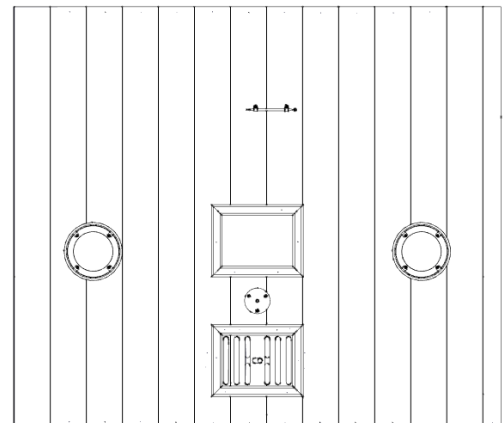
P05 SEAT SUPPORT PANEL - W2A04759  
(x1) 2 15/16"x15 3/8"x44 3/4" (74x390x1136)



P06 SEAT PANEL - W2A04758  
(x1) 1 3/4"x23 13/16"x44 3/4" (44x605x1136)



P07 DOOR PANEL - W2A04762  
(x1) 1 7/16"x47 11/16"x76 9/16" (36x1212x1944)



P08 ROOF PANEL - W2A04757  
(x1) 3 11/16"x18 9/16"x44 3/4" (93x472x1136)

# OWNER'S MANUAL - PARTS IDENTIFICATION

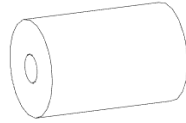
## WOOD COMPONENTS (NOT TO SCALE)



OO01 HANDLE BAR - W4L21815  
(x1) 1 3/16"x1 3/16"x11 15/16" (30x30x304)



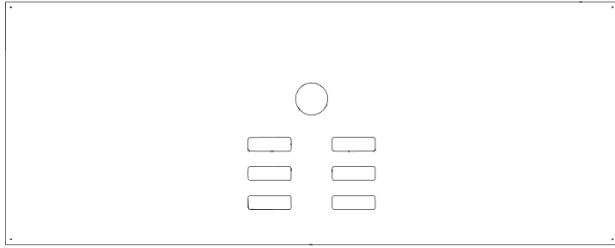
H01 HANDLE ASSEMBLY - W2A04763  
(x1) 1 3/16"x1 3/16"x11 15/16" (30x30x304)



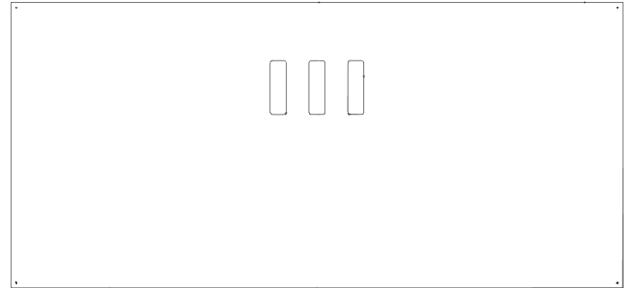
HS01 HANDLE STANDOFF - W4L21813  
(x2) 15/16"x1 5/8" (x24x42)



HS02 HANDLE STANDOFF - W4L21814  
(x2) 15/16"x1 5/8" (x24x42)

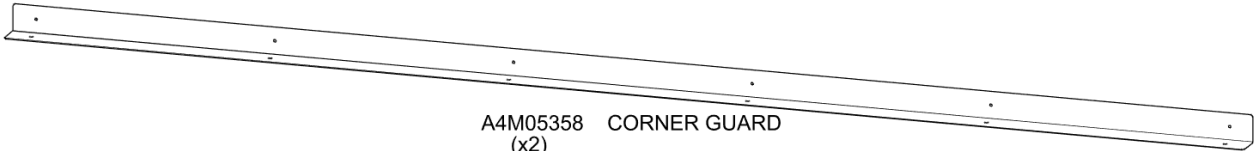


R01 ROOF COVER - W4L21811  
(x1) 3/16"x17 11/16"x44 3/4" (5x450x1136)



R02 ROOF COVER - W4L21812  
(x1) 3/16"x20 7/8"x44 3/4" (5x530x1136)

## ACCESSORY COMPONENTS



A4M05358 CORNER GUARD  
(x2)



A4M05585 VENT  
(x1)

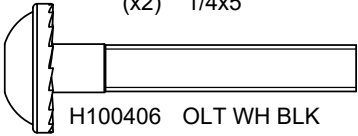


A6P01507 PLUG  
(x8)

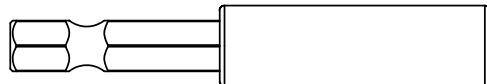
## HARDWARE COMPONENTS



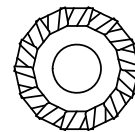
H101450 BOLT WH BLK  
(x2) 1/4x5



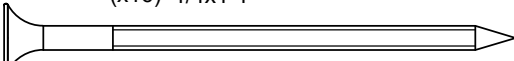
H100406 BOLT WH BLK  
(x16) 1/4x1-1



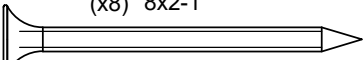
H101100 MAGNETIC DRIVER  
(x1)



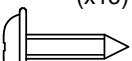
H100405 WASHER LOCK EXT BLK  
(x18) 6x15



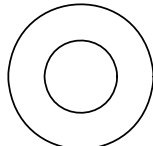
H100201 SCREW PFH B  
(x8) 8x2-1



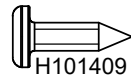
H100382 SCREW PFH B  
(x15) 8x1-3



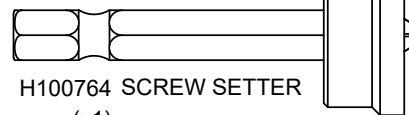
H100408 SCREW PWH B  
(x24) 8x1



H101403 POLY WASHER  
(x4)

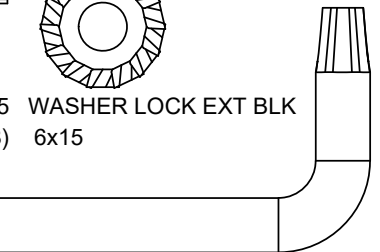


H101409 SCREW PPH BLK  
(x10) 4x1/2



H100764 SCREW SETTER  
(x1)

H100114 TORX WRENCH  
(x1) T-30

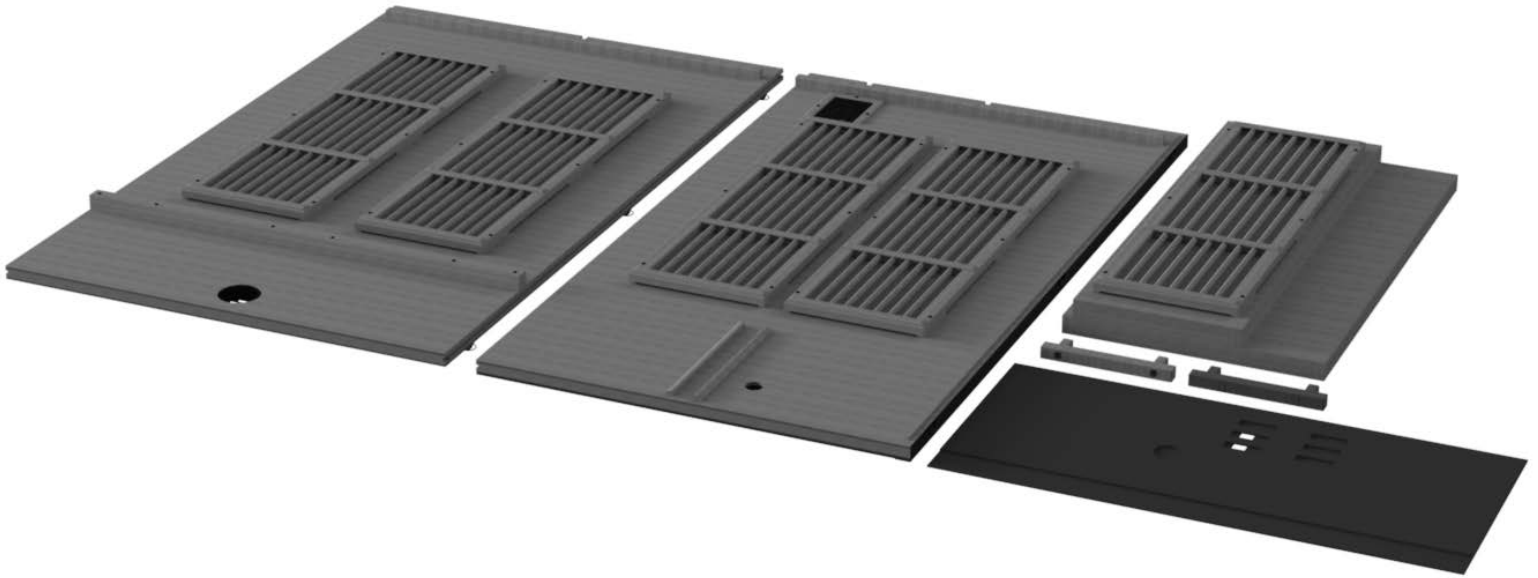


H100147 TORX BIT  
(x1) T-30

## WOOD PARTS:

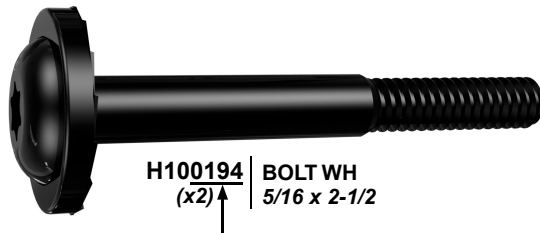
- Organize wood parts by the three-digit, alpha-numeric number stamped on each board (ex. P01).
- If there are multiple boards with the same stamped number, stack those pieces together.
- Stamps can be found on the flat surface of the boards or on the end of the boards.
- Allow yourself plenty of room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

**NOTE: CARTONS ARE NOT ORGANIZED BY BOARD OR STEP 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 (e.g. bolts, nuts, etc.).
- During assembly you only need to reference the last four digits of the number.

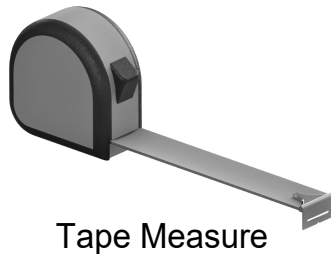


H100194 | BOLT WH  
(x2) ↑ 5/16 x 2-1/2

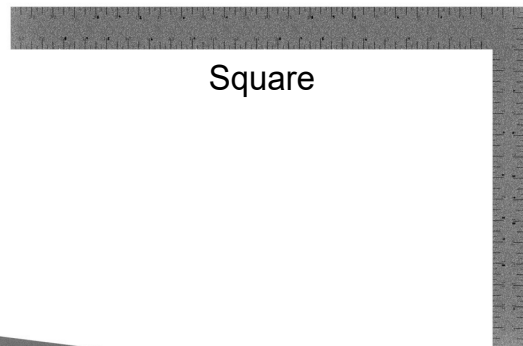
## **PRE-ASSEMBLY STEP 1 - TOOLS REQUIRED**



Cordless Drill  
or Electric Drill



Tape Measure



Square




Level 24"

# PRE-ASSEMBLY STEP 2 - 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)



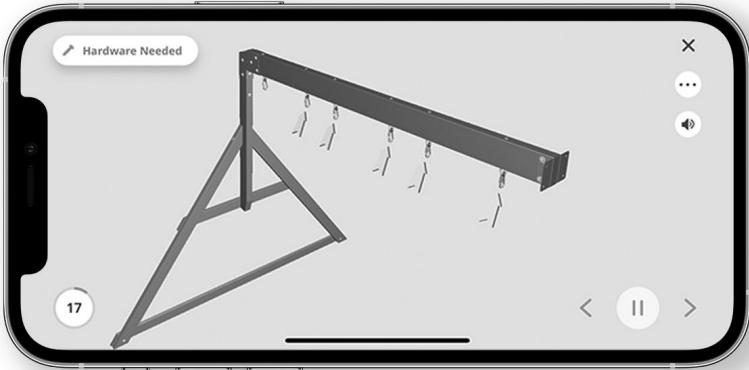
**BILT.**<sup>®</sup>

Scan for easy  
**3D instructions**

Download the BILT app  
before you begin

Download on the  
App Store

GET IT ON  
Google Play



Hardware Needed

17

< || >

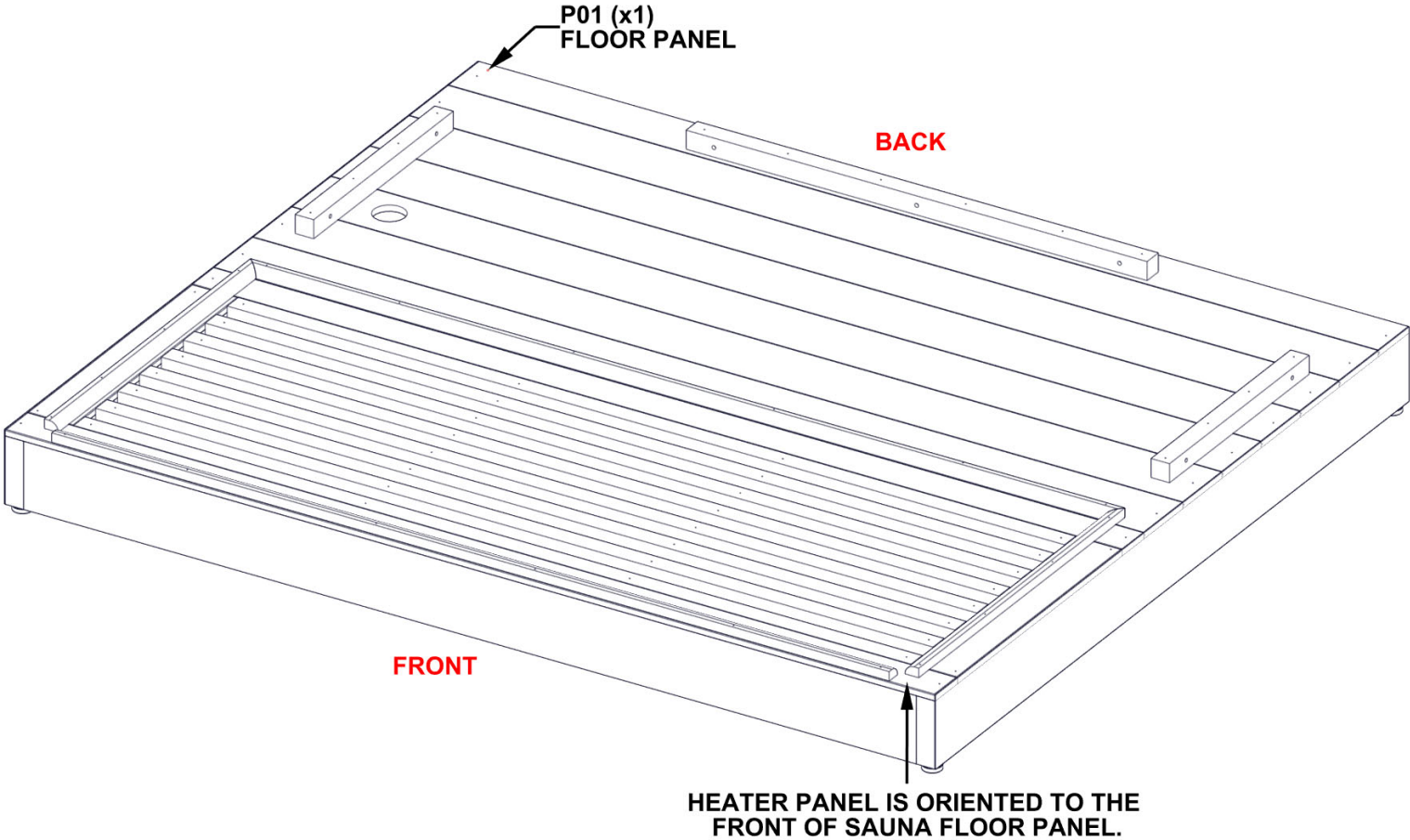
The image shows a smartphone screen displaying a 3D assembly instruction. The screen features a 3D model of a metal frame with a horizontal bar and several hanging components. A 'Hardware Needed' button is visible in the top left corner. The step number '17' is shown in a circle in the bottom left corner. Navigation controls, including a back arrow, a pause button, and a forward arrow, are located at the bottom of the screen.

# STEP 1 - SAUNA ASSEMBLY

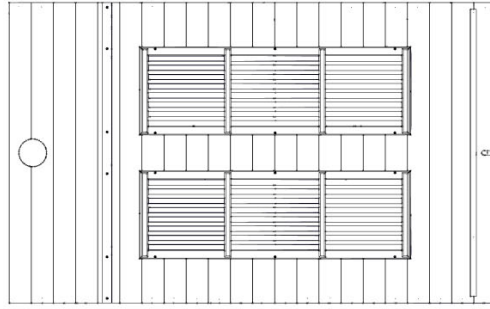


P01 FLOOR PANEL - W2A04760  
(x1) 4 5/8"x40 1/16"x47 11/16" (118x1018x1212)

- PLACE FLOOR PANEL IN DESIRED LOCATION OF SAUNA.



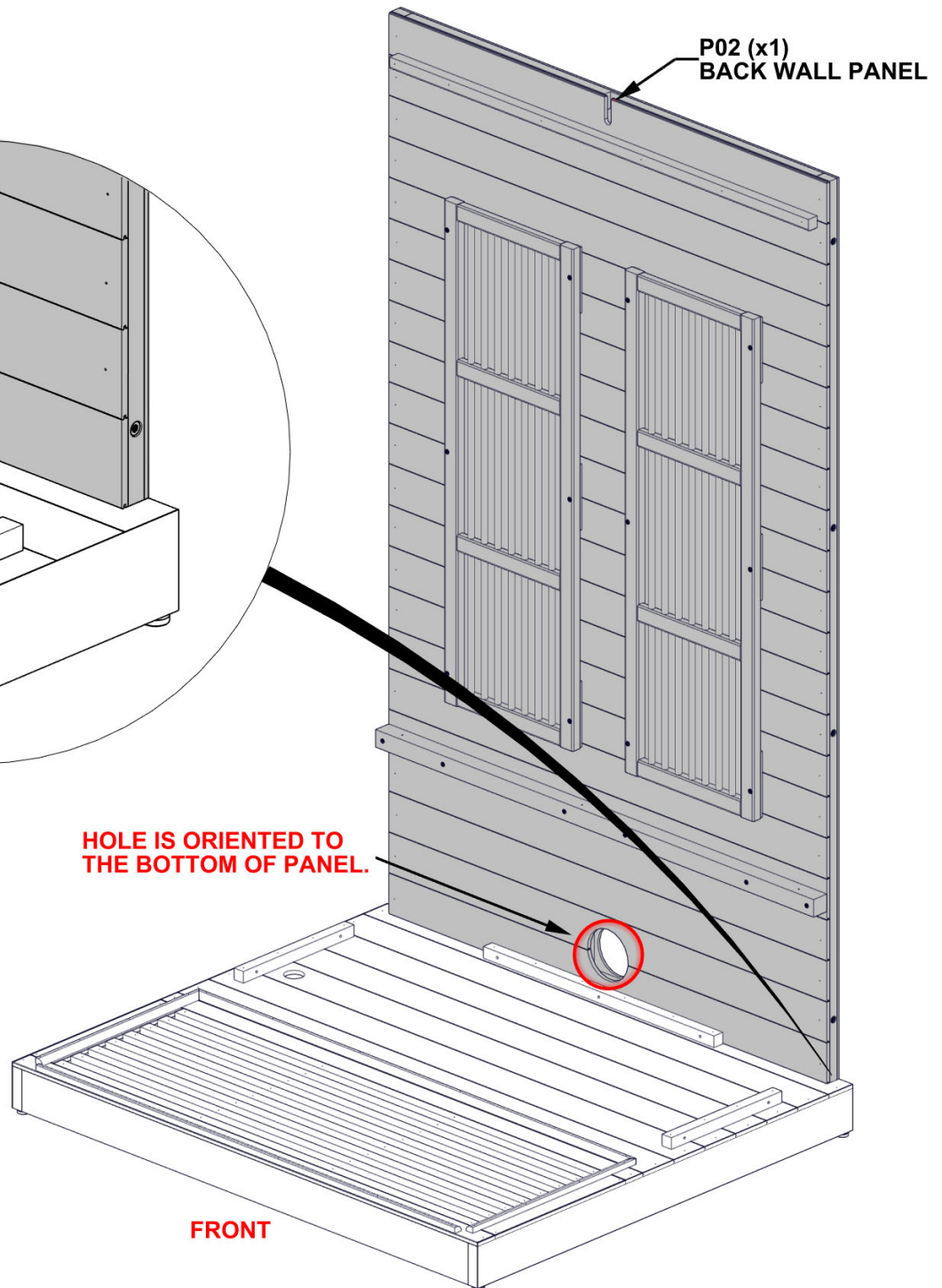
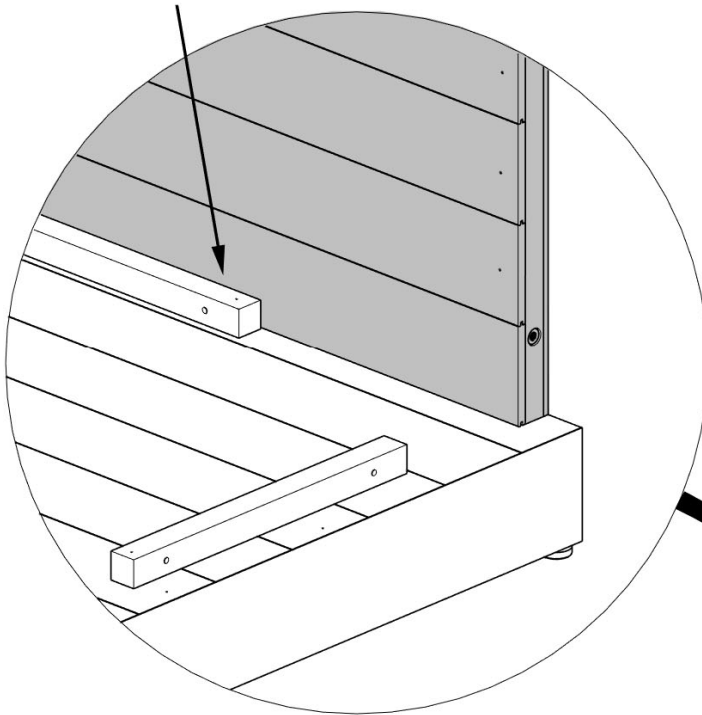
## STEP 2 - SAUNA ASSEMBLY



P02 BACK WALL PANEL - W2A04752  
(x1) 2 11/16"x44 7/8"x72 13/16" (69x1140x1850)

- STAND UP P02 AND ORIENT AS SHOWN.
- BACK OF P02 WILL BE FLUSH WITH BACK OF P01.
- CENTER P02 FROM SIDE TO SIDE ON P01.
- ONE PERSON WILL HOLD UP AND SUPPORT P02 GOING TO THE NEXT STEP.

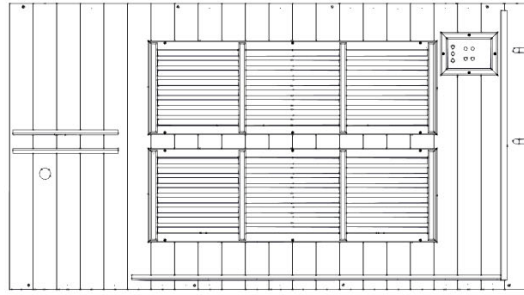
P02 SITS AGAINST CLEAT ON FLOOR PANEL AS SHOWN.



HOLE IS ORIENTED TO THE BOTTOM OF PANEL.

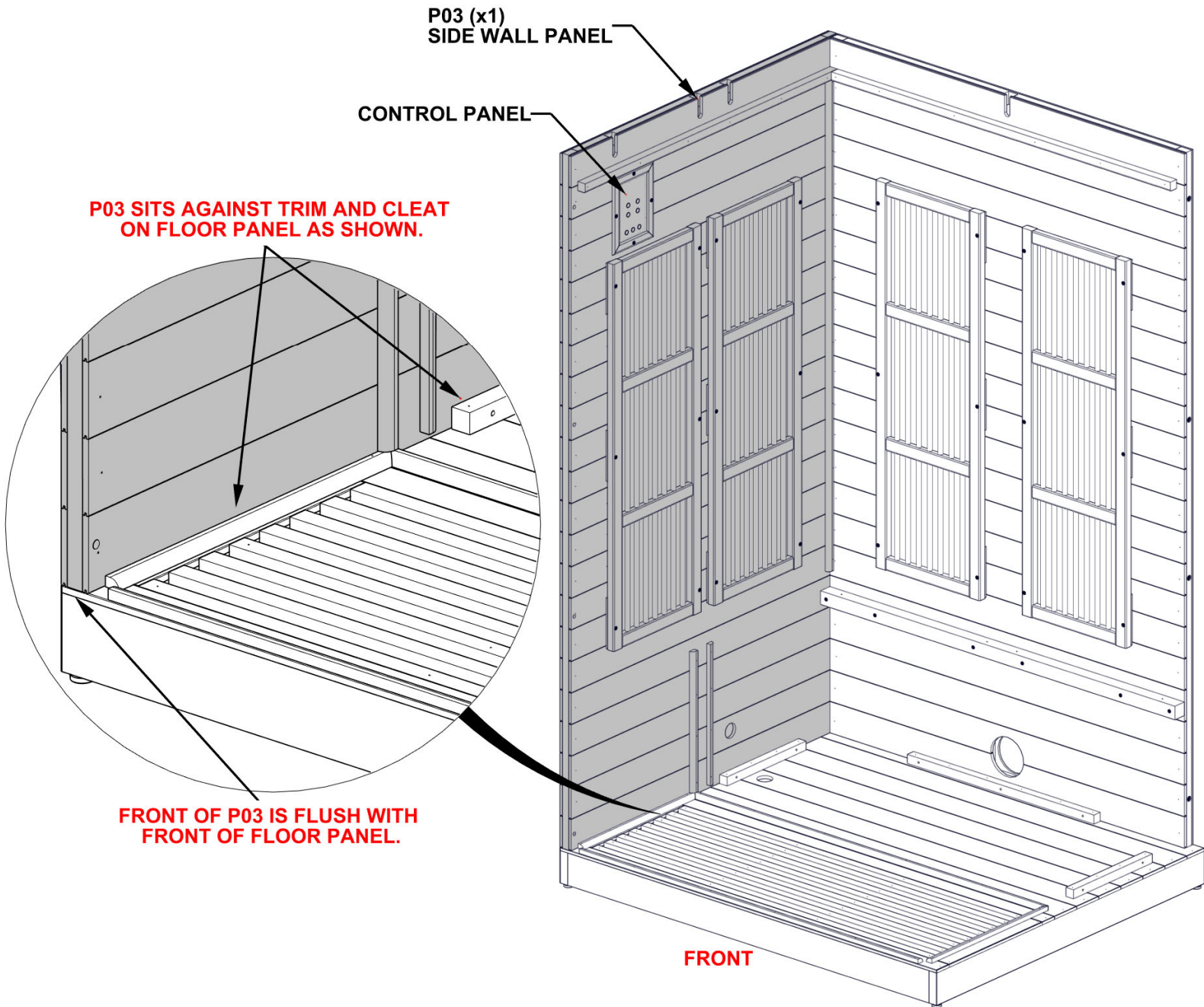
FRONT

# STEP 3 - SAUNA ASSEMBLY



P03 SIDE WALL PANEL - W2A04754  
(x1) 61x40 1/16"x72 13/16" (2 3/8"x1018x1850)

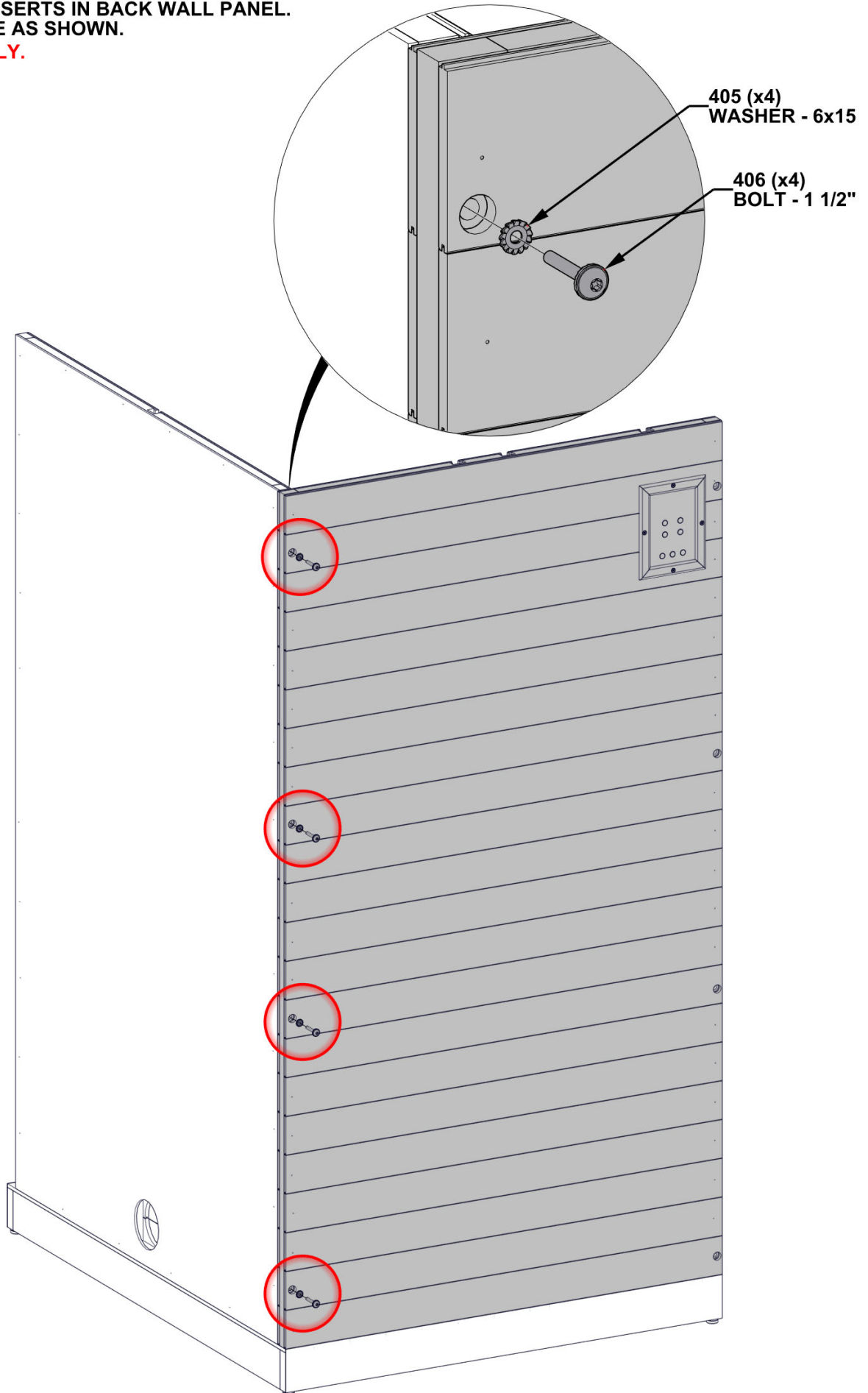
- STAND UP P03 AND ORIENT AS SHOWN.
- CONTROL PANEL SHOULD BE ORIENTED TO THE TOP.
- KEEP SUPPORTING P03 AND P02 AS PANELS ARE ATTACHED IN NEXT STEP.



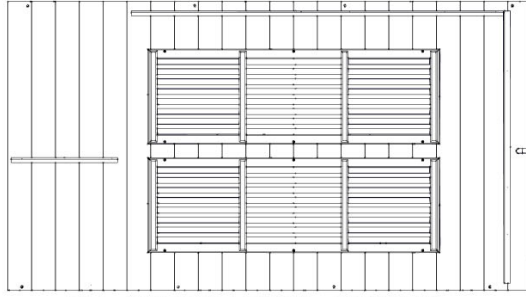
# STEP 4 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
4	H100405	WASHER LOCK EXT 6x15
4	H100406	BOLT WH 1/4x1 1/2 BLK

- ALIGN THROUGH HOLES IN SIDE WALL PANEL WITH THREADED INSERTS IN BACK WALL PANEL.
- INSERT HARDWARE AS SHOWN.
- **HAND TIGHTEN ONLY.**

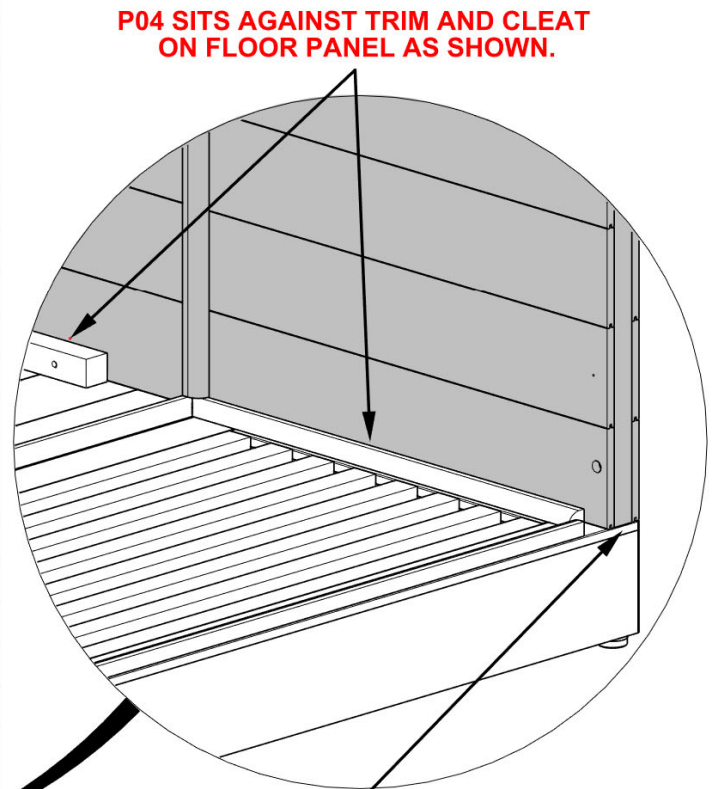
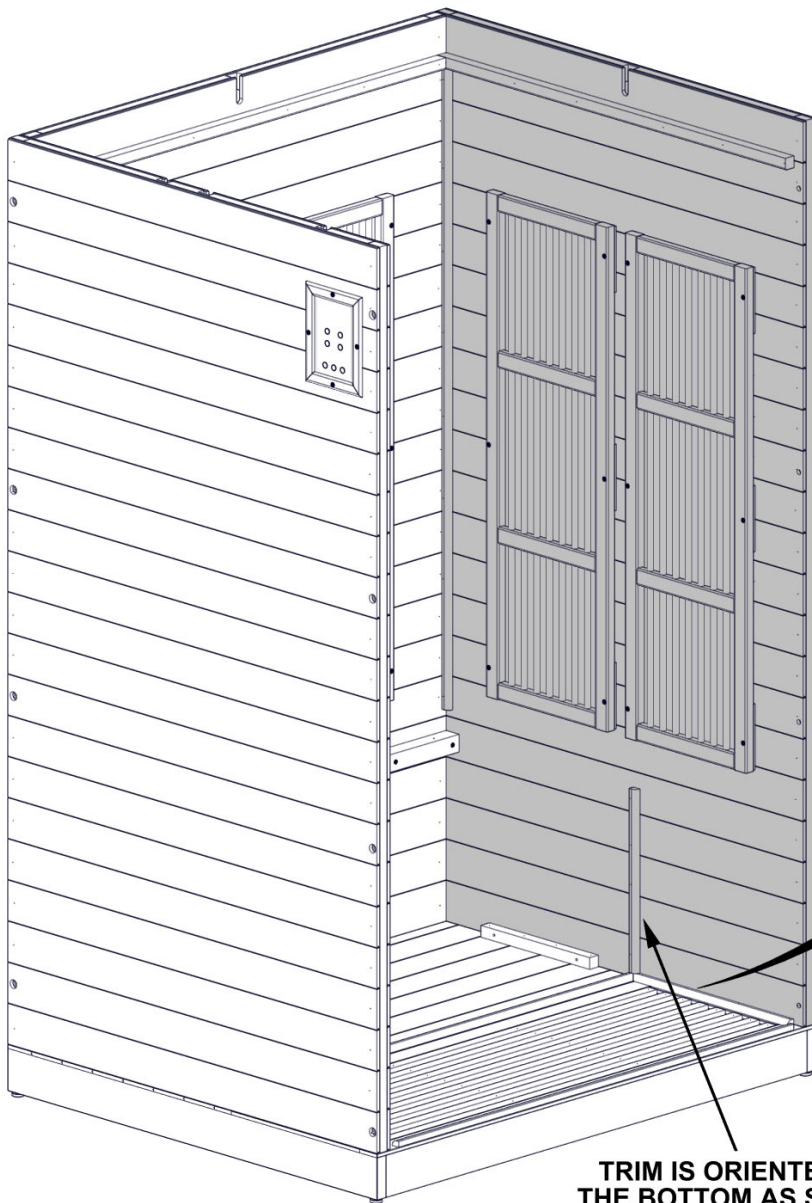


# STEP 5 - SAUNA ASSEMBLY



P04 SIDE WALL PANEL - W2A04755  
(x1) 2 3/8"x40 1/16"x72 13/16" (61x1018x1850)

- STAND UP P04 AND ORIENT AS SHOWN.
- KEEP P04 SUPPORTED UNTIL ATTACHED IN NEXT STEP.



**P04 SITS AGAINST TRIM AND CLEAT ON FLOOR PANEL AS SHOWN.**

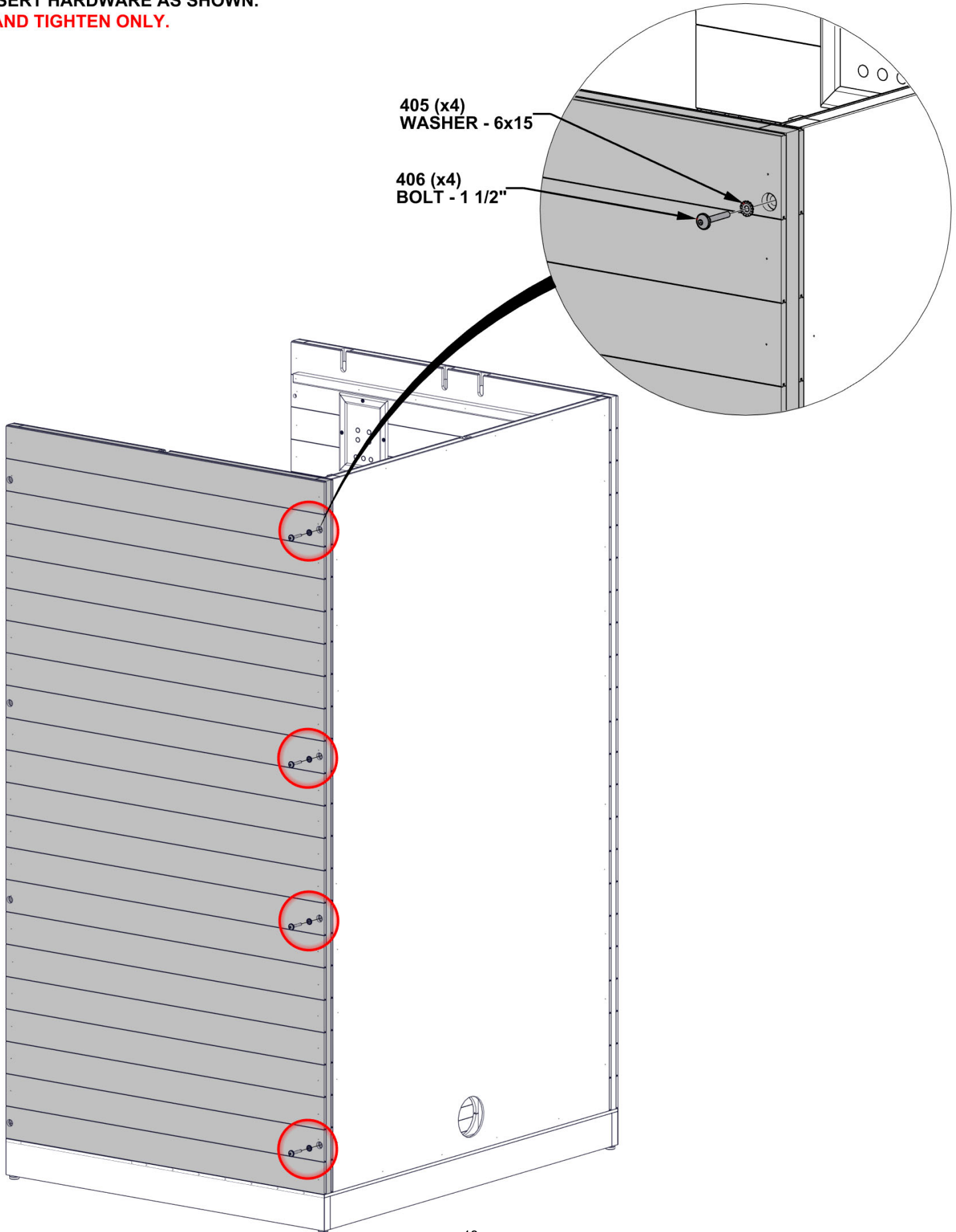
**FRONT OF P04 IS FLUSH WITH FRONT OF FLOOR PANEL.**

**TRIM IS ORIENTED TO THE BOTTOM AS SHOWN.**

# STEP 6 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
4	H100405	WASHER LOCK EXT 6x15
4	H100406	BOLT WH 1/4x1 1/2 BLK

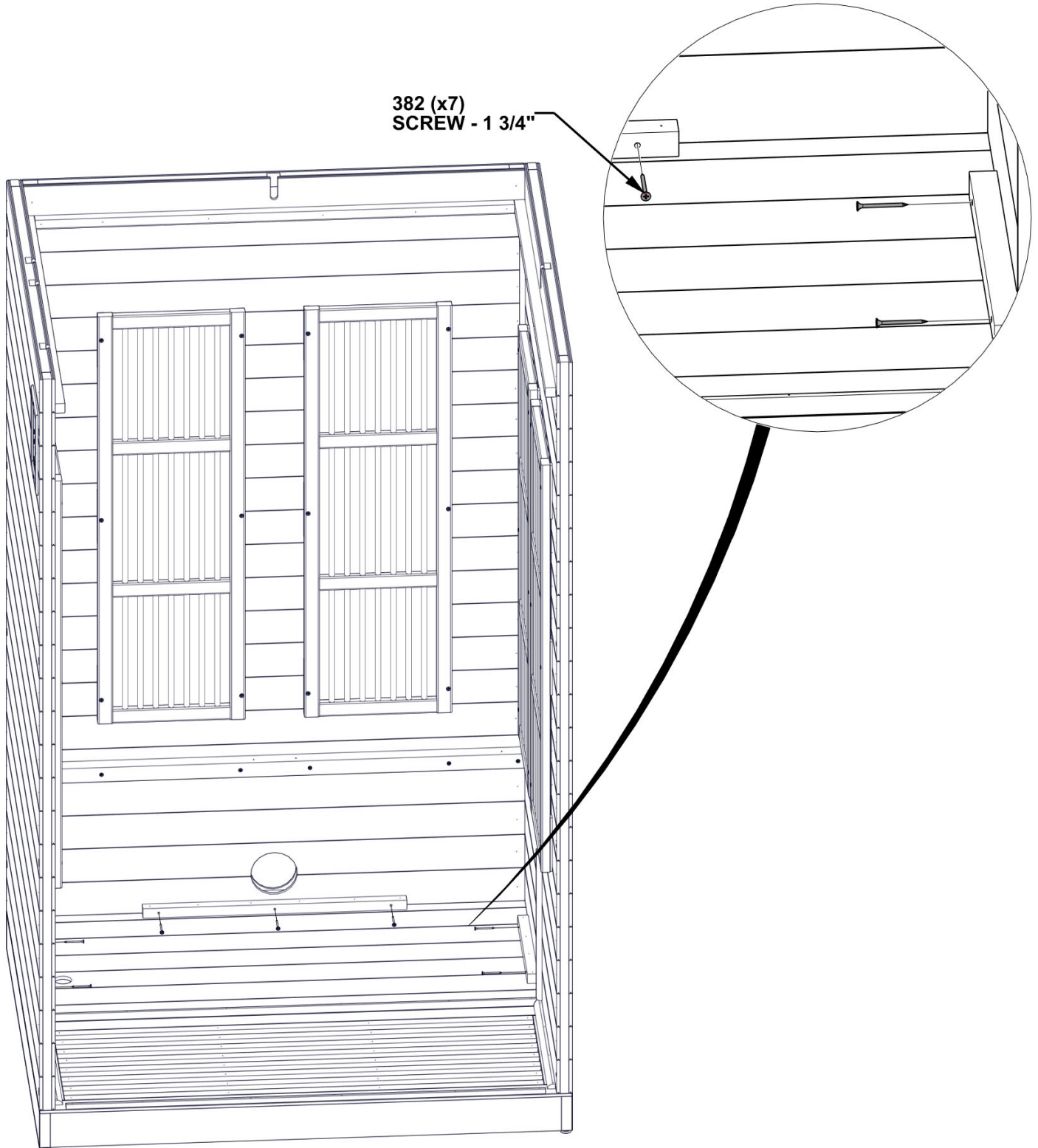
- ALIGN THROUGH HOLES IN SIDE WALL PANEL WITH THREADED INSERTS IN BACK WALL PANEL.
- INSERT HARDWARE AS SHOWN.
- **HAND TIGHTEN ONLY.**



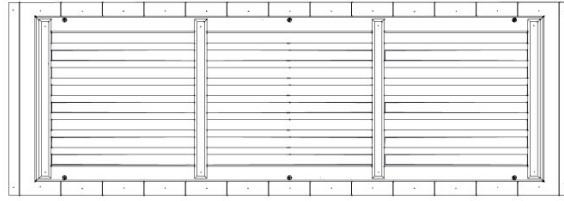
# STEP 7 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
7	H100382	SCREW PFH 8x1 3/4 BLK

- ENSURE WALL PANELS ARE PRESSED FIRMLY AGAINST TRIM AND CLEATS ON THE INSIDE.
- ENSURE OUTSIDE OF EACH WALL PANEL IS FLUSH WITH OUTSIDE OF FLOOR PANEL.
- ATTACH WITH SCREWS AS SHOWN.

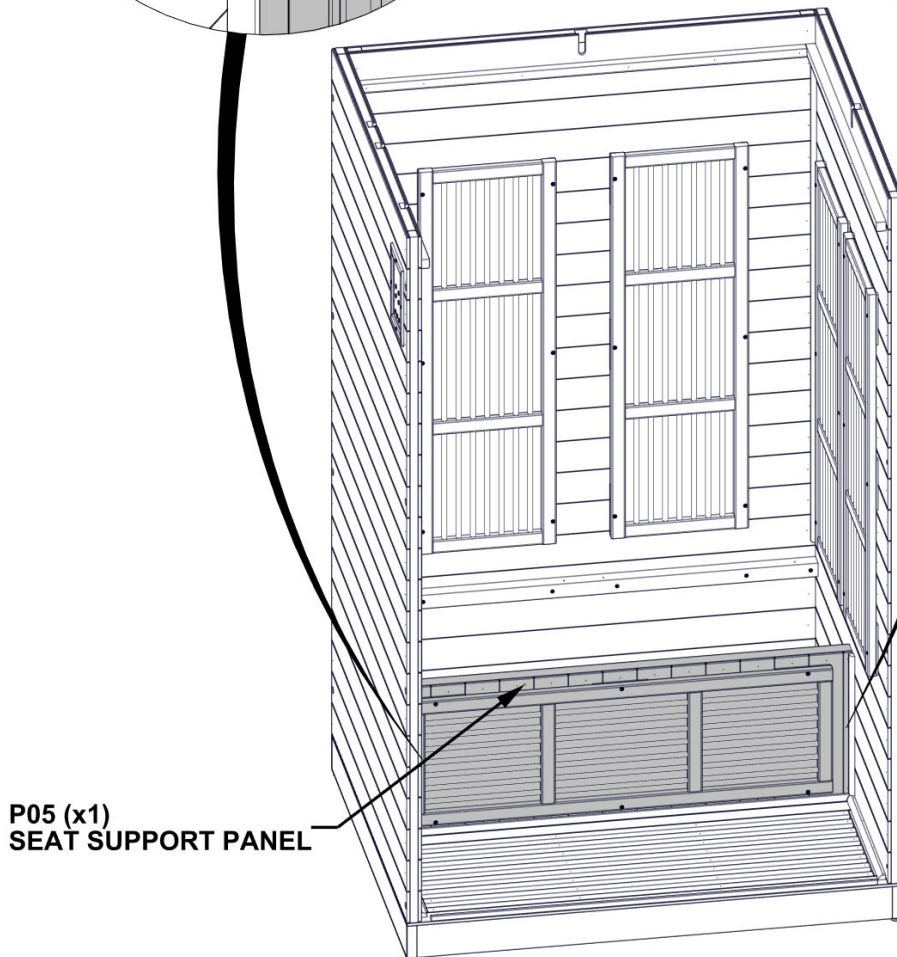
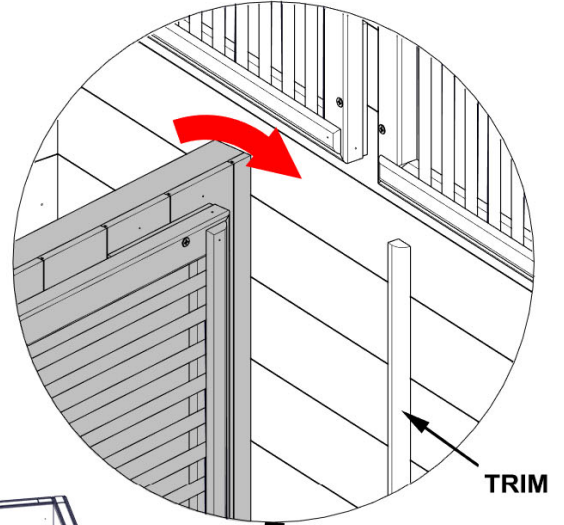
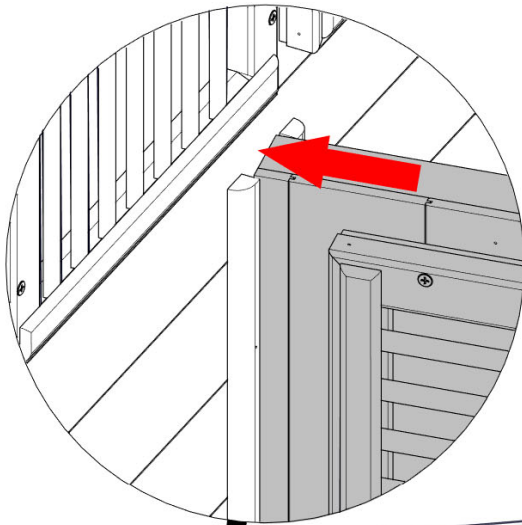


# STEP 8 - SAUNA ASSEMBLY



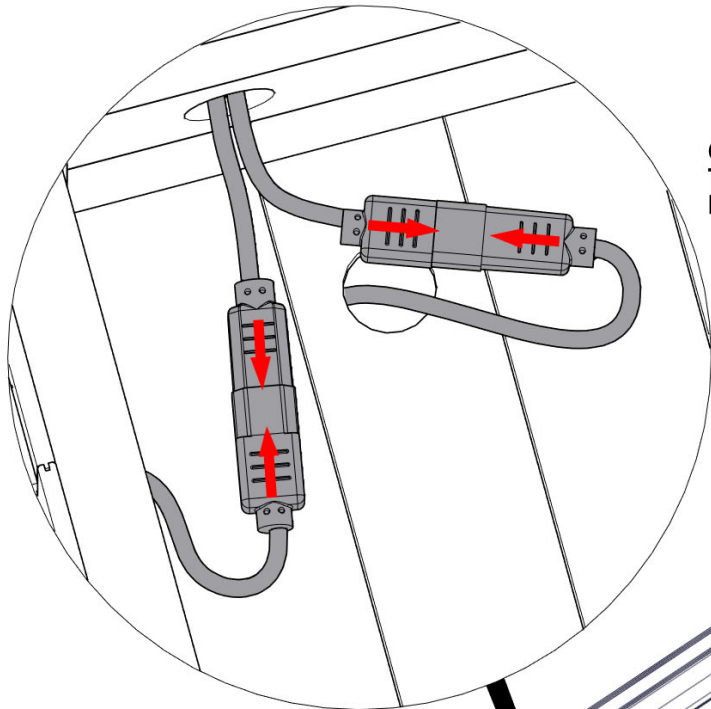
P05 SEAT SUPPORT PANEL - W2A04759  
(x1) 2 15/16"x15 3/8"x44 3/4" (74x390x1136)

- TO INSTALL P05, INSERT AT AN ANGLE AS SHOWN.
- ENSURE LEFT SIDE FITS BETWEEN THE TWO PIECES OF TRIM.
- ROTATE ASSEMBLY UNTIL THE PANEL RESTS AGAINST THE SINGLE PIECE OF TRIM ON RIGHT SIDE.



P05 (x1)  
SEAT SUPPORT PANEL

# STEP 9 - SAUNA ASSEMBLY

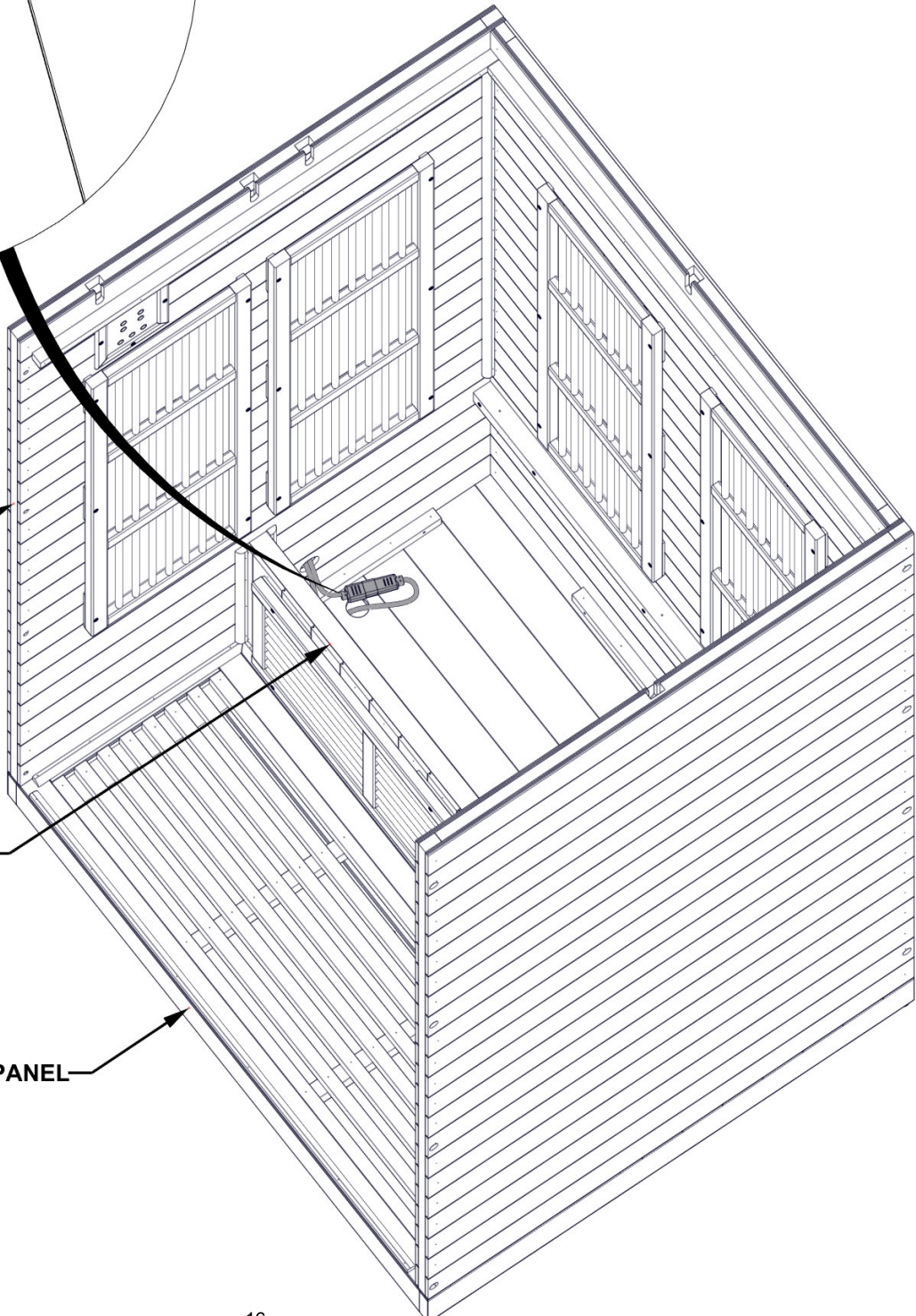


CONNECT POWER CORDS FROM SIDE WALL TO POWER CORDS IN SEAT SUPPORT PANEL AND FLOOR PANEL AS SHOWN.

SIDE WALL PANEL

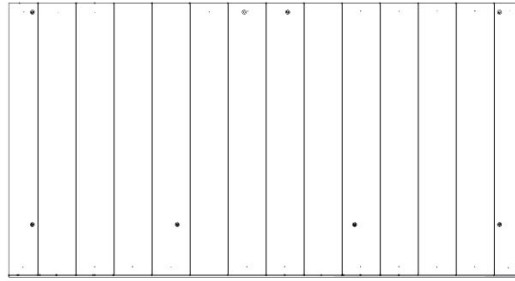
SEAT SUPPORT PANEL

FLOOR PANEL



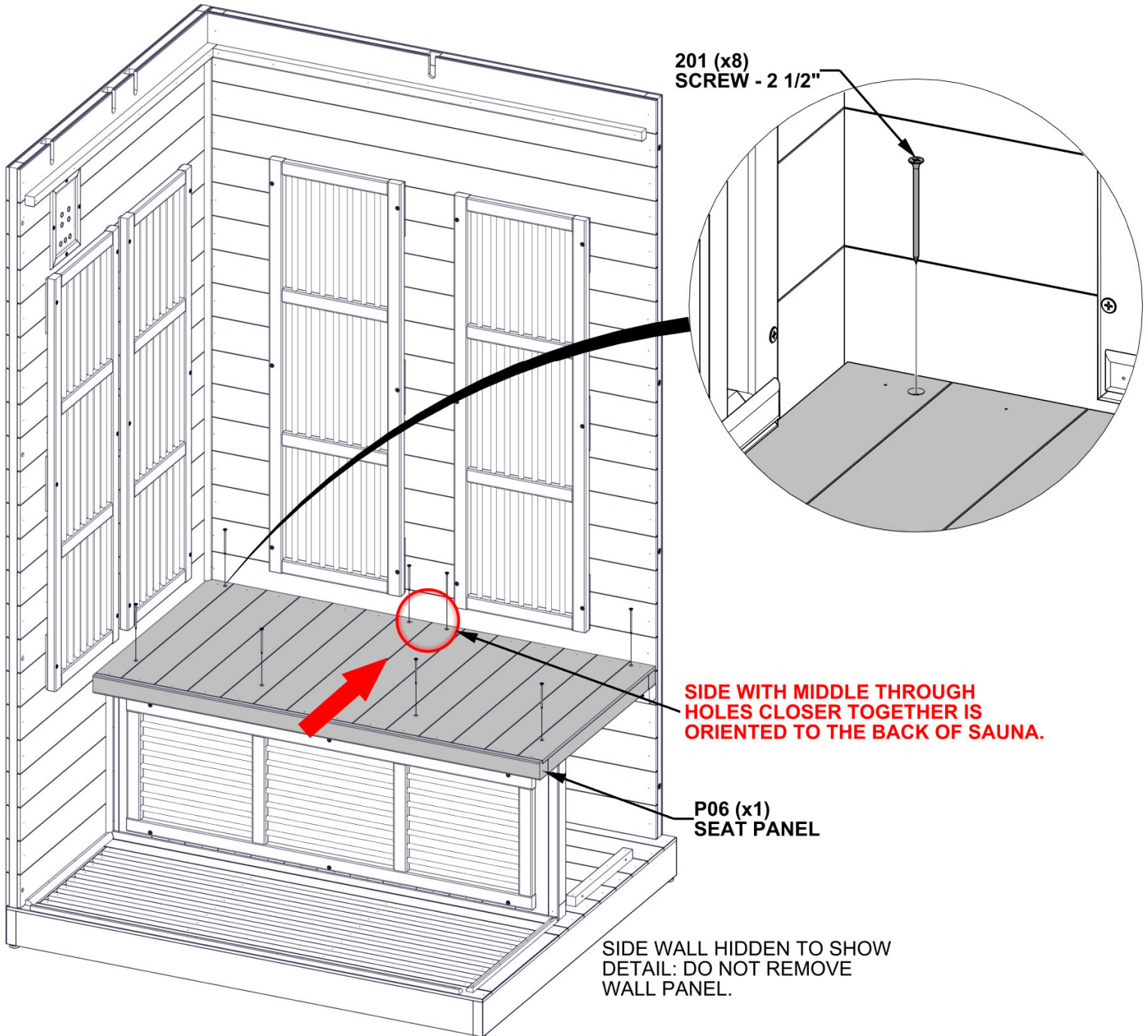
# STEP 10 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
8	H100201	SCREW PFH 8x2 1/2 BLK



P06 SEAT PANEL - W2A04758  
(x1) 1 3/4"x23 13/16"x44 3/4" (44x605x1136)

- SLIDE P06 INTO PLACE AS SHOWN.
- ENSURE BACK SIDE OF P06 IS AGAINST BACK WALL BEFORE ATTACHING.
- ENSURE P05 IS STILL IN THE CORRECT POSITION AND WAS NOT MOVED WHEN SLIDING IN SEAT PANEL.
- ATTACH WITH SCREWS AS SHOWN.



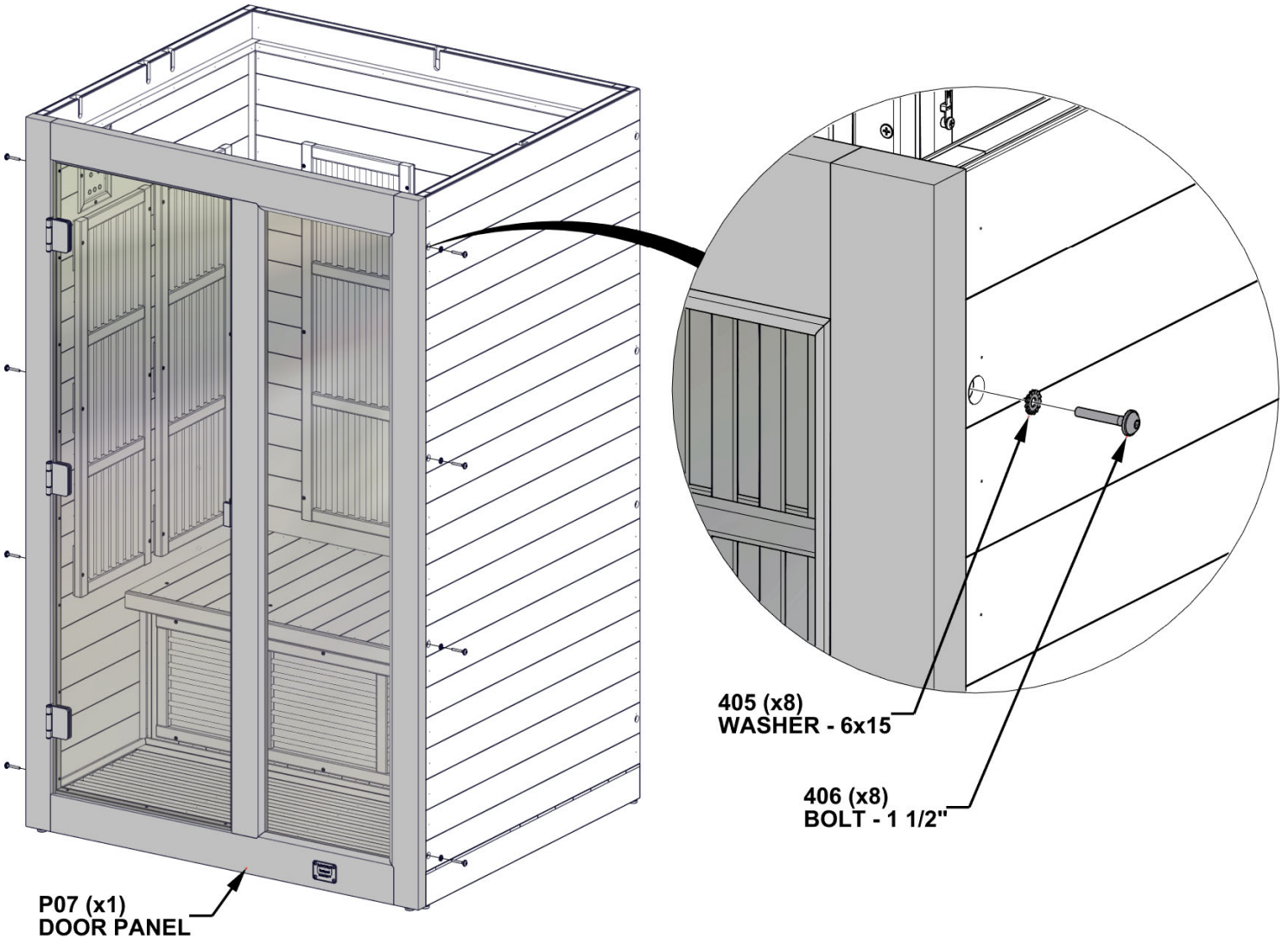
# STEP 11 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
8	H100405	WASHER LOCK EXT 6x15
8	H100406	BOLT WH 1/4x1 1/2 BLK



P07 DOOR PANEL - W2A04762  
(x1) 1 7/16"x47 11/16"x76 9/16" (36x1212x1944)

- ORIENT P07 AS SHOWN.
- ENSURE SIDES OF P07 ARE FLUSH WITH SIDE PANELS.
- ALIGN THROUGH HOLES IN SIDE WALL PANEL WITH THREADED INSERTS IN BACK WALL PANEL.
- INSERT HARDWARE AS SHOWN.
- **FULLY TIGHTEN ALL CORNER BOLTS AFTER FRONT BOLTS ARE ATTACHED.**



P07 (x1)  
DOOR PANEL

# STEP 12 - SAUNA ASSEMBLY

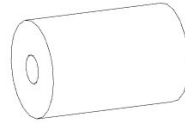
QTY	PART NUMBER	DESCRIPTION
2	H100405	WASHER LOCK EXT 6x15
4	H101403	POLY WASHER
2	H101450	BOLT WH 1/4x5 BLK



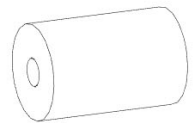
OO01 HANDLE BAR - W4L21815  
(x1) 1 3/16"x1 3/16"x11 15/16" (30x30x304)



H01 HANDLE ASSEMBLY - W2A04763  
(x1) 1 3/16"x1 3/16"x11 15/16" (30x30x304)

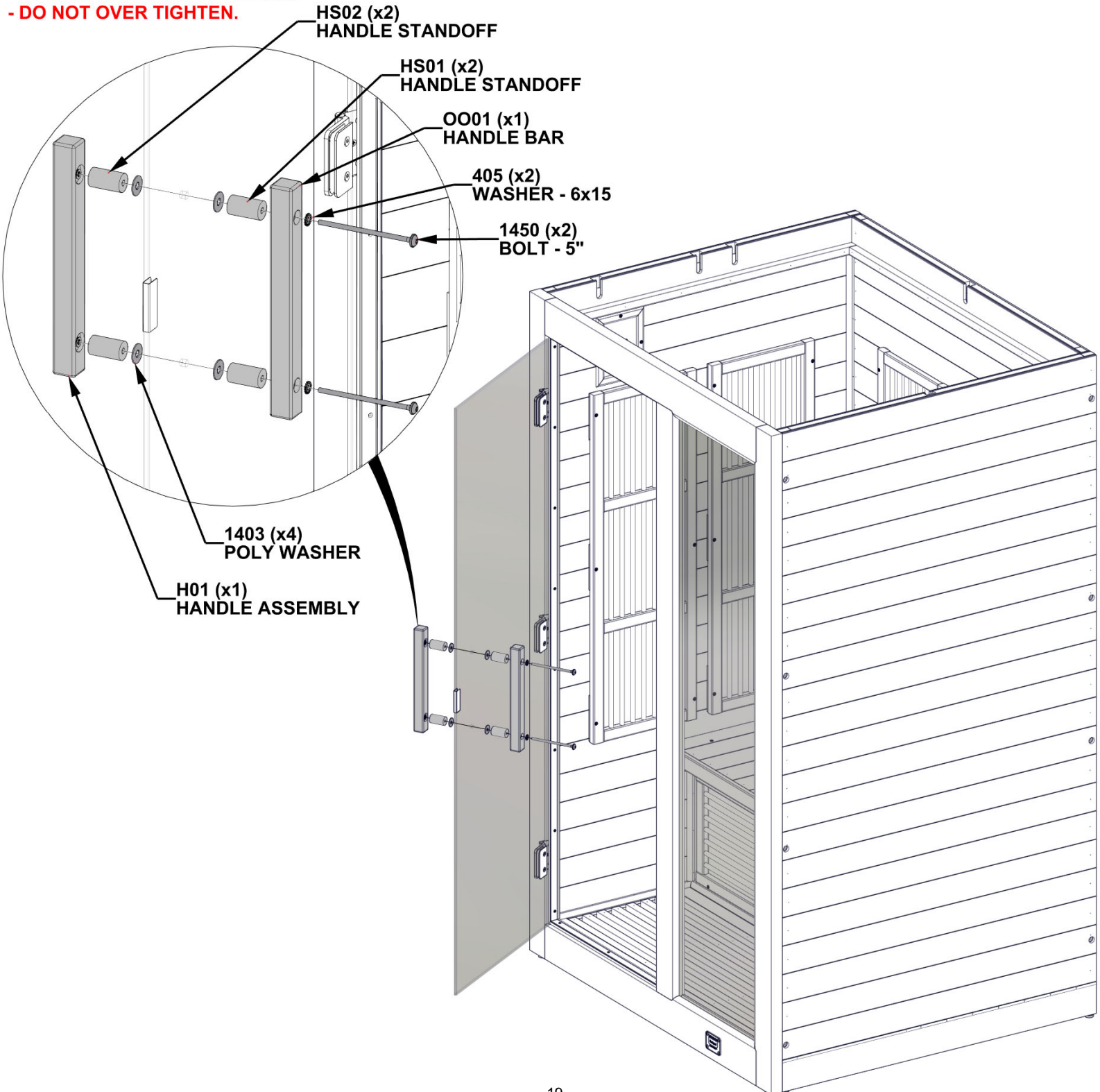


HS01 HANDLE STANDOFF - W4L21813  
(x1) 15/16"x1 5/8" (24x42)



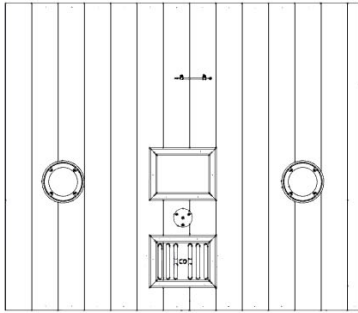
HS02 HANDLE STANDOFF - W4L21814  
(x1) 15/16"x1 5/8" (24x42)

**- ATTACH HANDLES AS SHOWN.**  
**- DO NOT OVER TIGHTEN.**



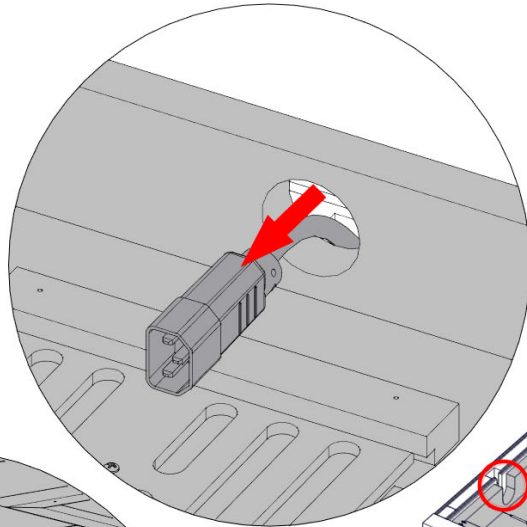
# STEP 13 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
8	H100382	SCREW PFH 8x1 3/4 BLK

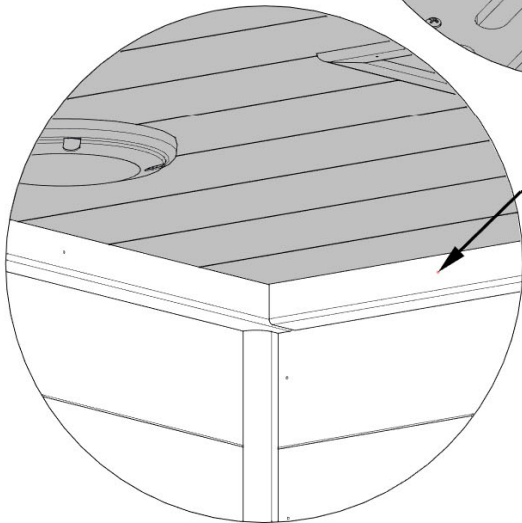


P08 ROOF PANEL - W2A04757  
(x1) 3 11/16"x18 9/16"x44 3/4" (93x472x1136)

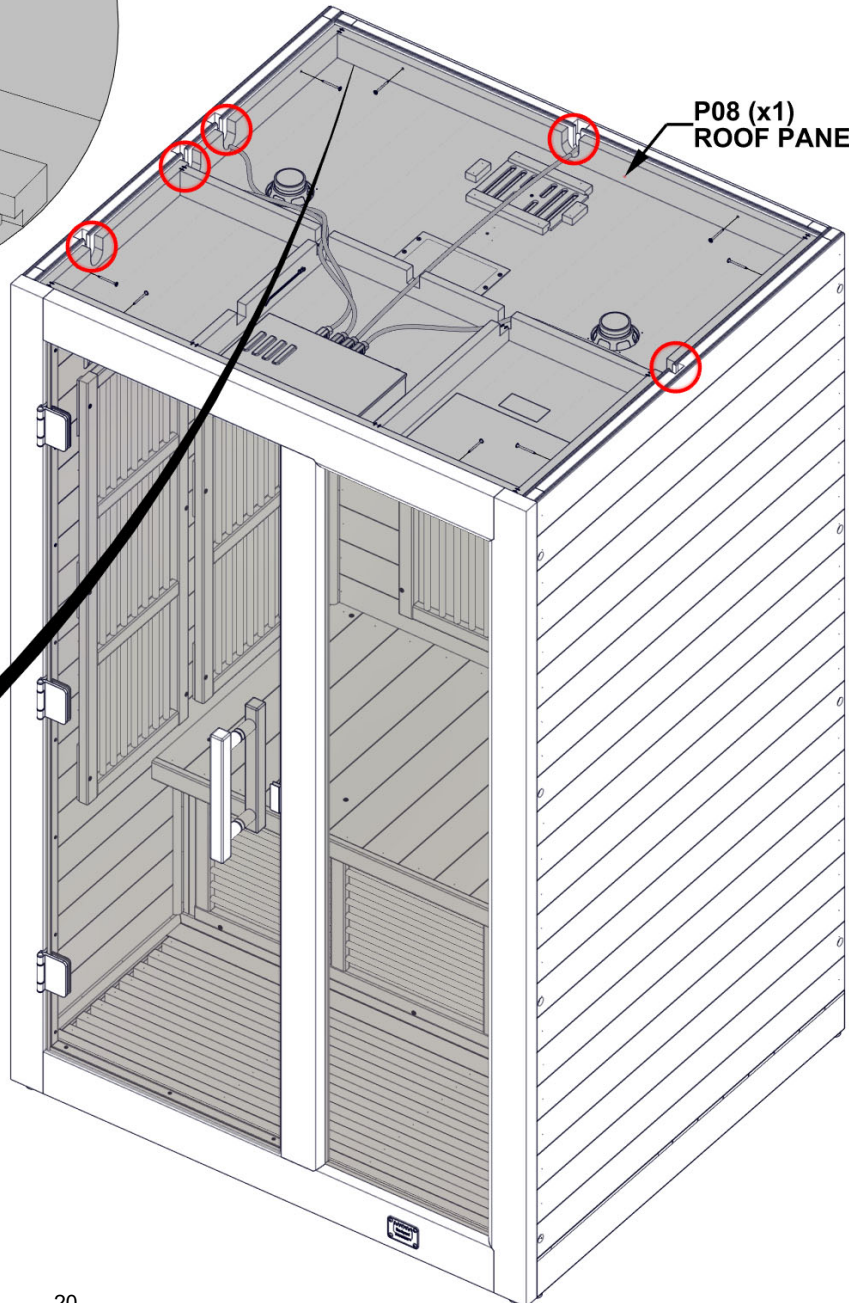
- LOWER ROOF PANEL INTO PLACE ORIENTED AS SHOWN UNTIL IT RESTS ON TRIM INSIDE SAUNA.
- INSERT SCREWS TO ATTACH ROOF PANEL AS SHOWN.



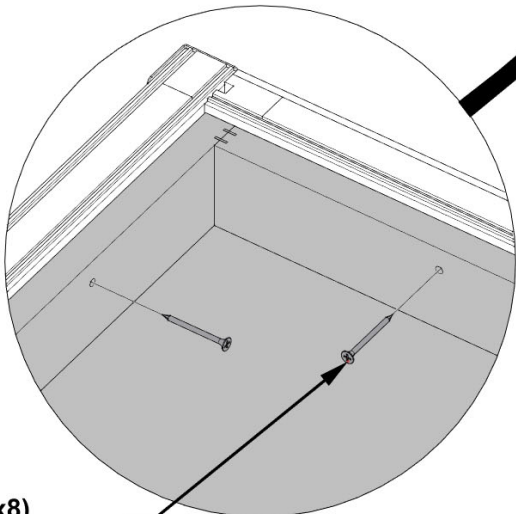
**RUN POWER CABLES FROM SIDE WALLS THROUGH HIGHLIGHTED HOLES IN ROOF PANEL AS IT IS LOWERED INTO PLACE. LOWER CAREFULLY TO ENSURE CABLES ARE NOT PINCHED BETWEEN WALL PANELS AND ROOF PANEL.**



INSIDE TRIM



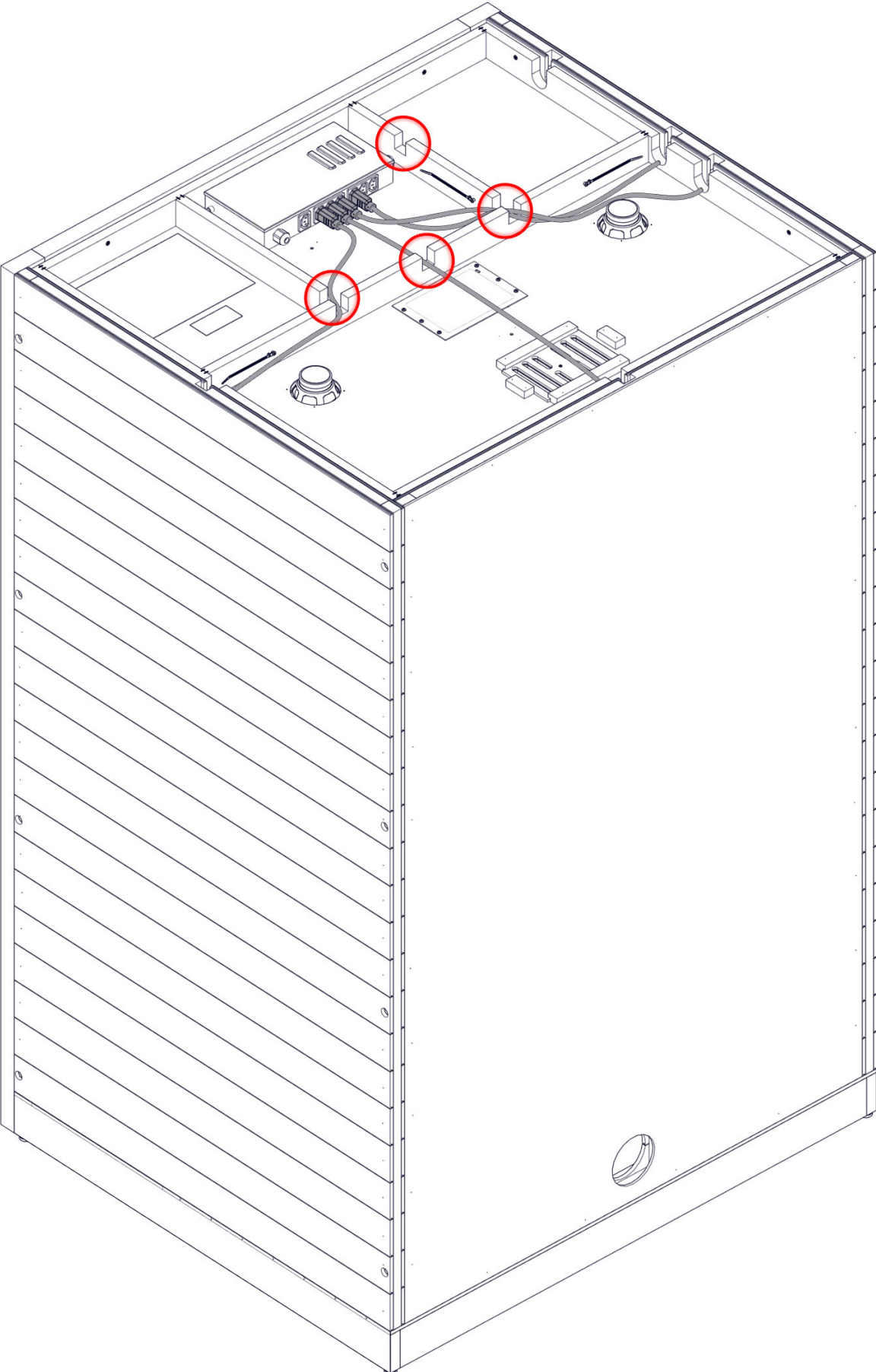
P08 (x1)  
ROOF PANEL



382 (x8)  
SCREW - 1 3/4"

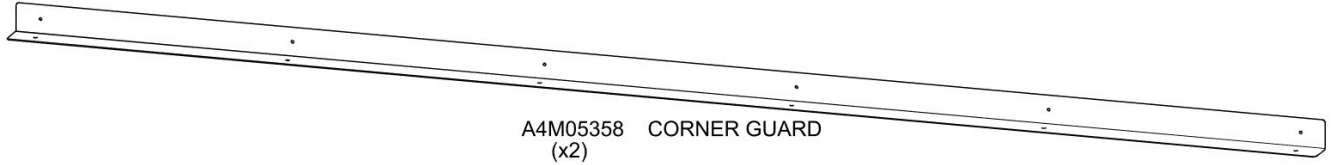
# STEP 14 - SAUNA ASSEMBLY

- CONNECT POWER CORDS FROM SIDE WALLS TO THE CONTROLLER AS SHOWN.
- ENSURE POWER CORDS ARE RUN THROUGH NOTCHES IN THE ROOF PANEL.

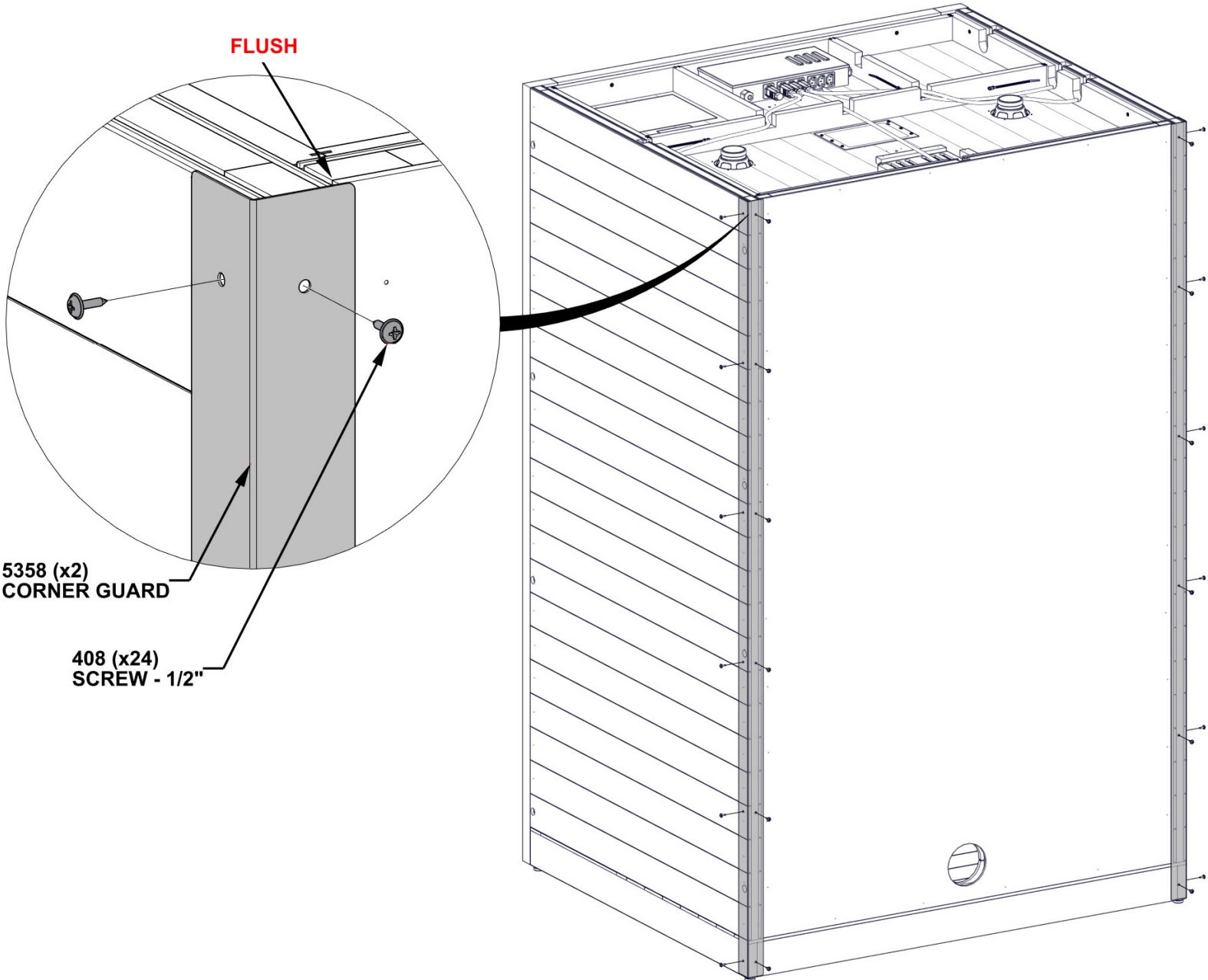


# STEP 15 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
24	H100408	SCREW PWH 8x1/2 BLK

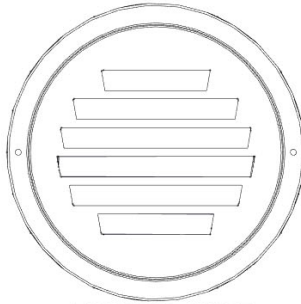


- HOLD CORNER GUARD FLUSH WITH TOP OF BACK AND SIDE WALL PANELS AND ATTACH.



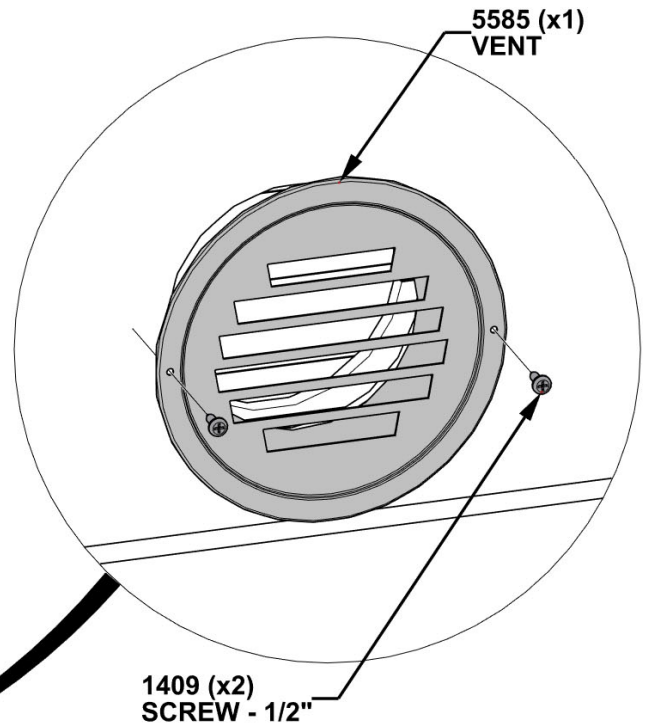
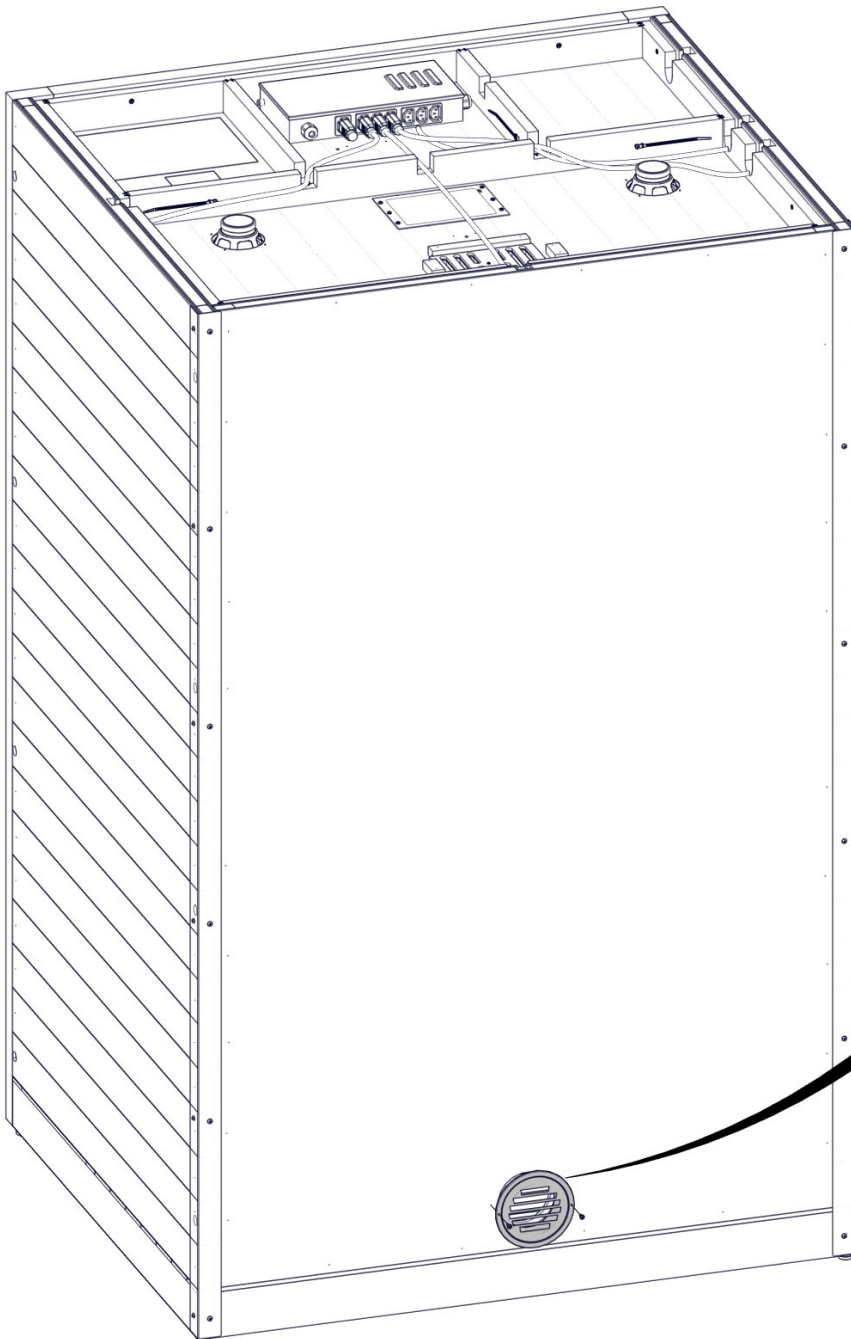
# STEP 16 - SAUNA ASSEMBLY

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

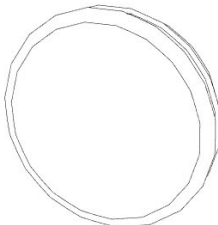


A4M05585 VENT  
(x1)

- INSERT VENT INTO HOLE IN BACK OF SAUNA.
- ATTACH WITH SCREWS AS SHOWN.

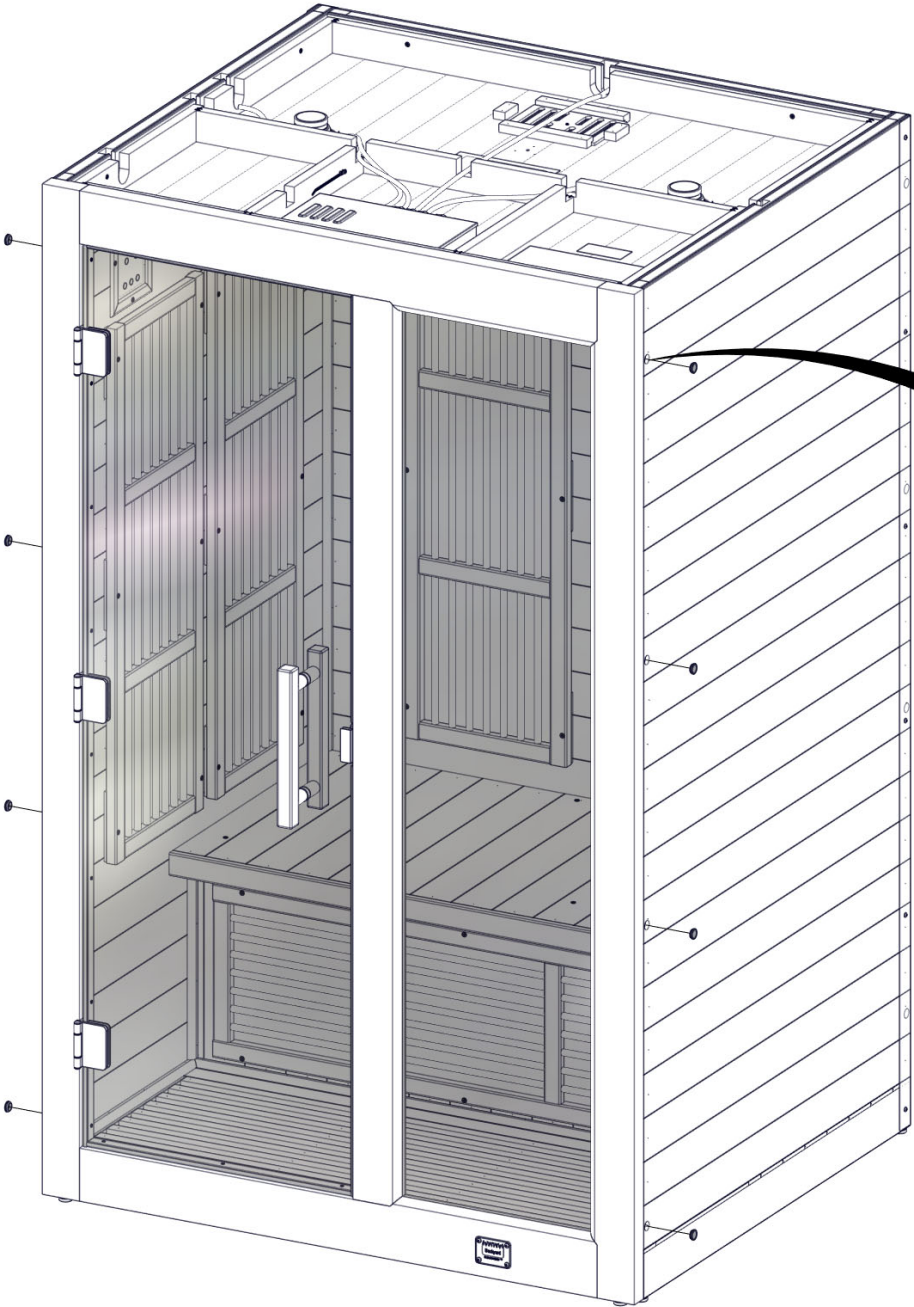


# STEP 17 - SAUNA ASSEMBLY

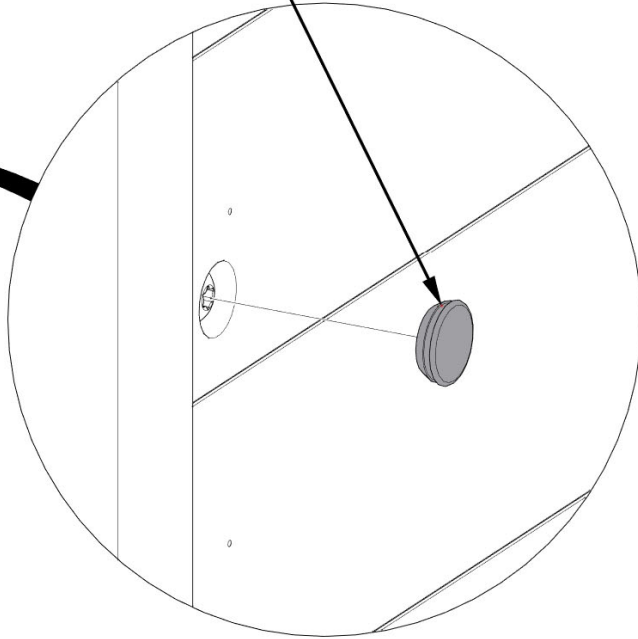


A6P01507 PLUG  
(x8)

- INSERT PLUGS INTO HOLES TO COVER BOLTS.

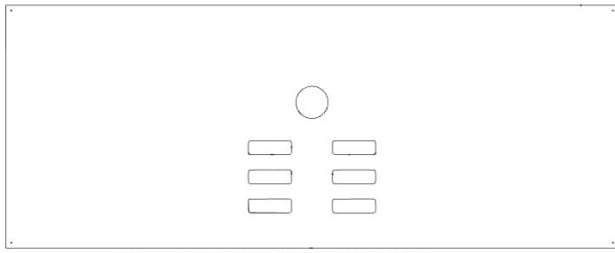


1507 (x8)  
PLUG

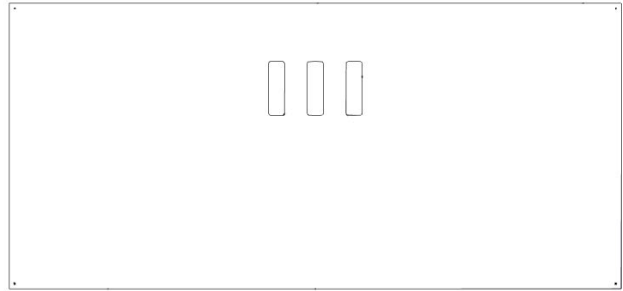


# STEP 18 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
8	H101409	SCREW 4x1/2 BLK



R01 ROOF COVER - W4L21811  
(x1) 3/16"x17 11/16"x44 3/4" (5x450x1136)



R02 ROOF COVER - W4L21812  
(x1) 3/16"x20 7/8"x44 3/4" (5x530x1136)

- INSERT ROOF COVERS ORIENTED AS SHOWN.
- RUN POWER CORD THROUGH HOLE IN R01 AS SHOWN.
- ATTACH WITH SCREWS USING PILOT HOLES IN ROOF COVERS.

