



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, 2595 WP, Netherlands Phone: 08005678990

# PAXTON 4-6P BARREL SAUNA WITH PORCH

**MODEL # : 2504448, 2504448-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](http://www.P65Warnings.ca.gov)



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

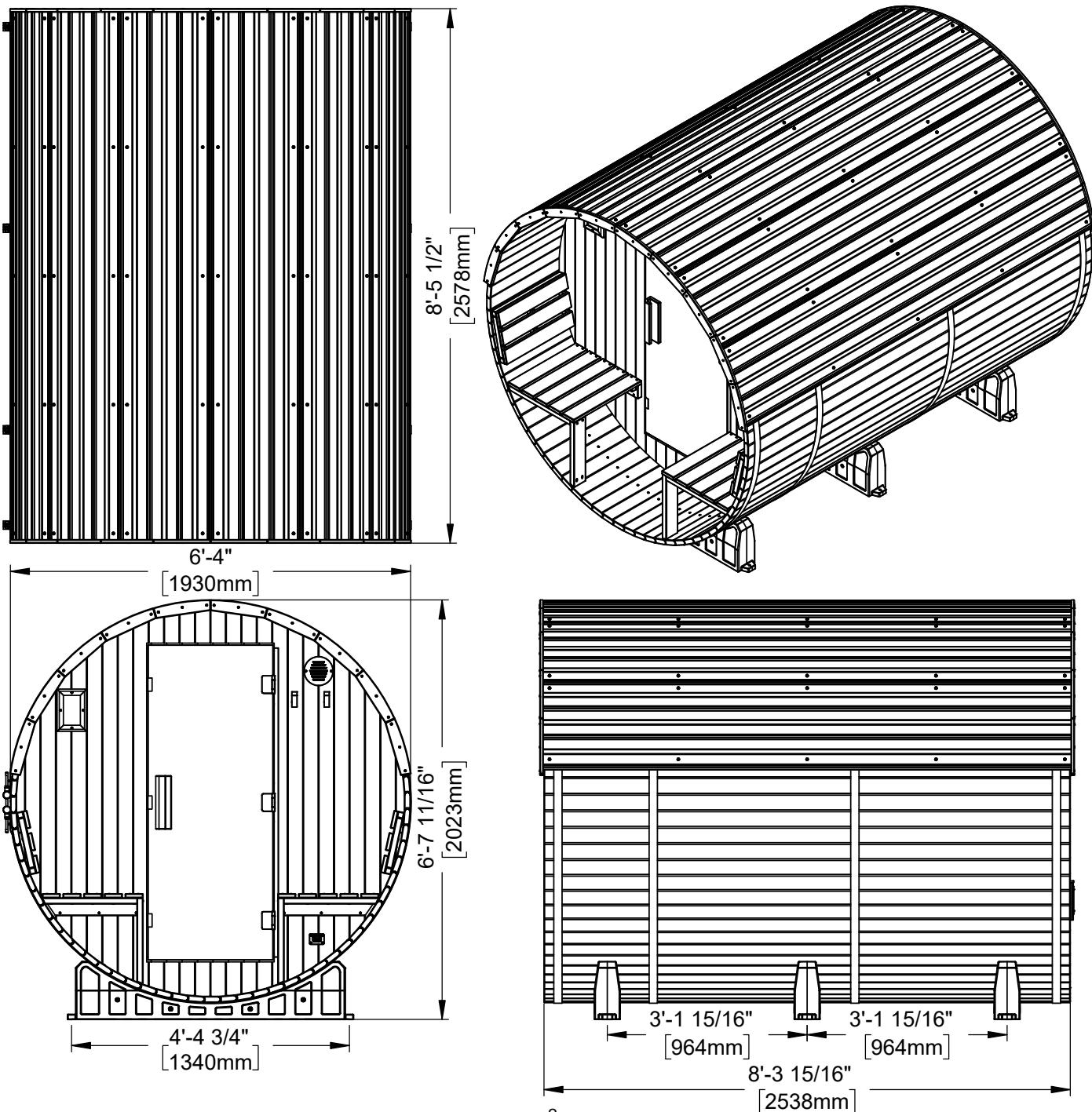
## CHOOSE A GOOD LOCATION FOR YOUR SAUNA!

It is critically important that the sauna foundation is sturdy and level.

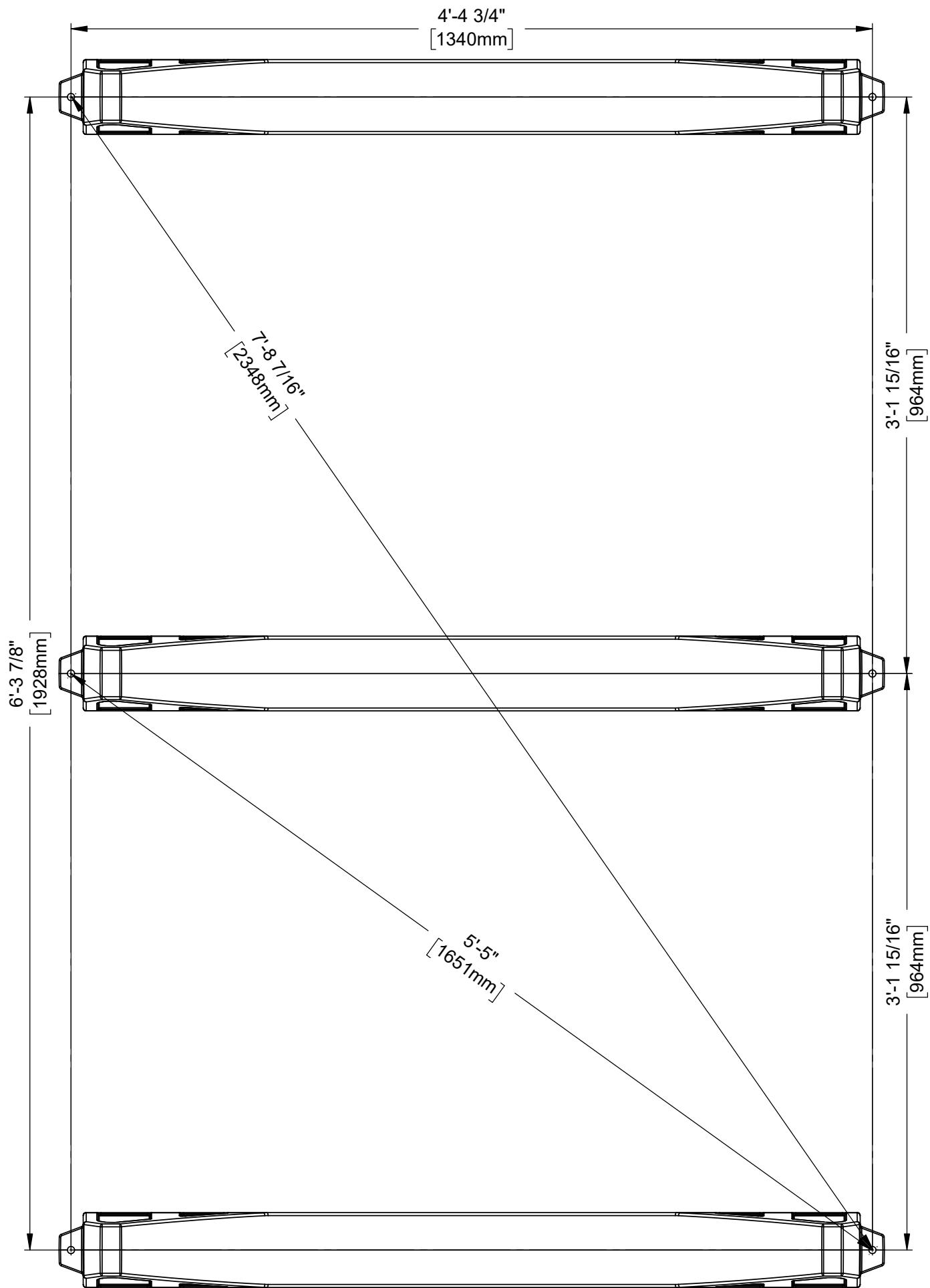
An unstable foundation can cause the sauna to tilt, shift, or fall, leading to injury.

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. (1400+ 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.
- Missing from the last review, please add:
- 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.

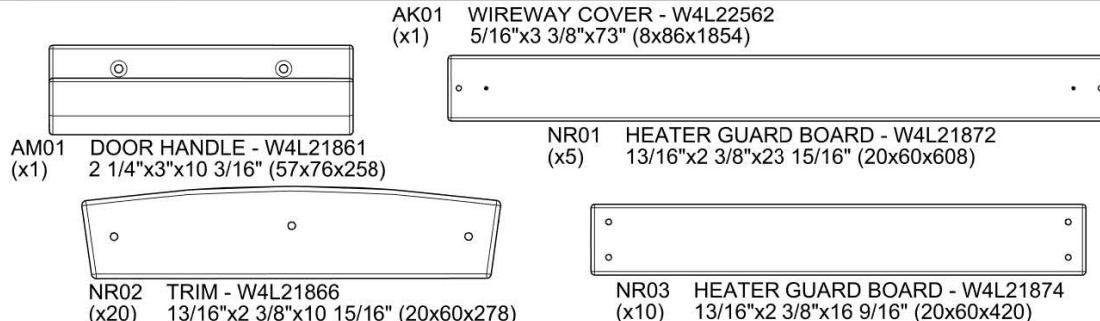


# OWNER'S MANUAL - ANCHORING LAYOUT

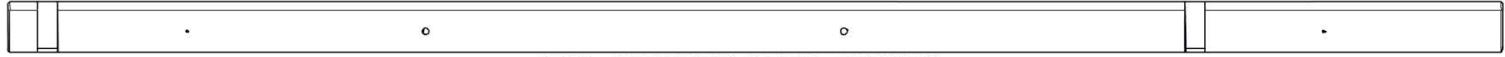


# OWNER'S MANUAL - PARTS IDENTIFICATION

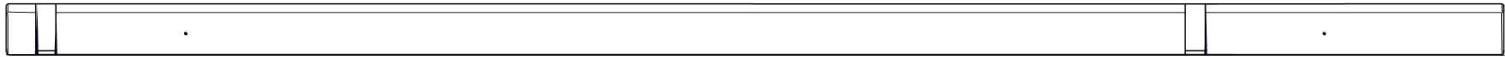
## WOOD COMPONENTS (NOT TO SCALE)



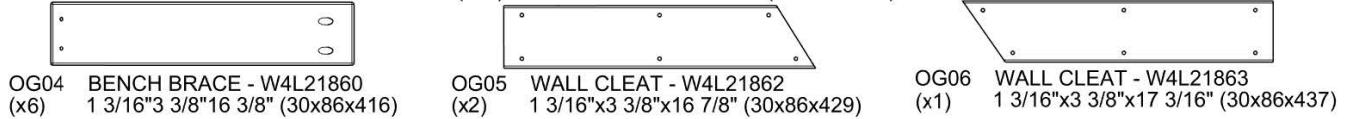
**OG01** PERIMETER BOARD - W4L21988  
 (x61) 1 3/16" x 3 3/8" x 99 15/16" (30x86x2538)



**OG02** PERIMETER BOARD - W4L21989  
 (x1) 1 3/16" x 3 3/8" x 99 15/16" (30x86x2538)



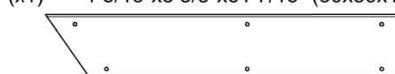
**OG03** PERIMETER BOARD - W4L21990  
 (x14) 1 3/16" x 3 3/8" x 99 15/16" (30x86x2538)



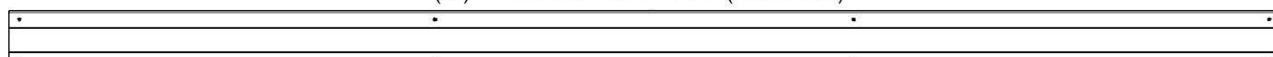
**OG07** WALL CLEAT - W4L21867  
 (x1) 1 3/16" x 3 3/8" x 63 15/16" (30x86x1624)



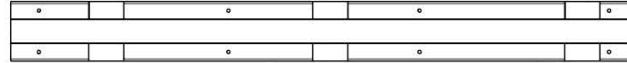
**OG08** WALL CLEAT - W4L21868  
 (x1) 1 3/16" x 3 3/8" x 61 7/16" (30x86x1560)



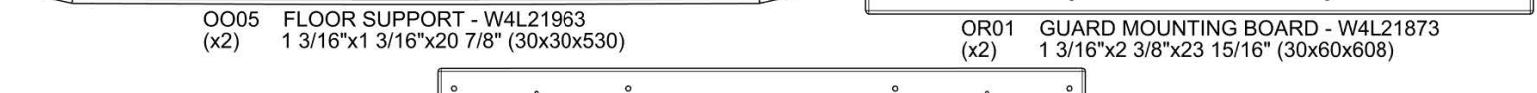
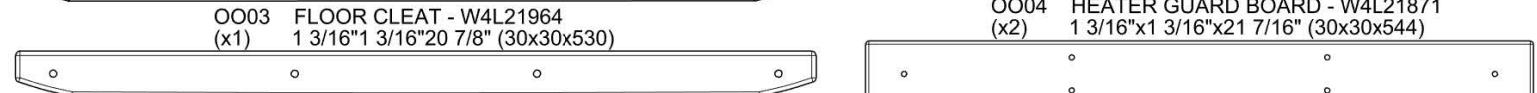
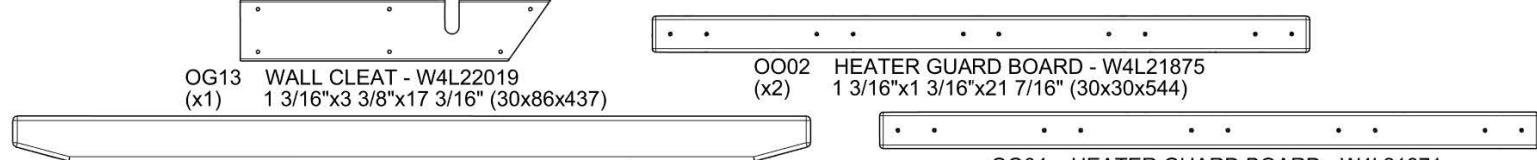
**OG09** WALL CLEAT - W4L21909  
 (x2) 1 3/16" x 3 3/8" x 18 7/8" (30x86x480)



**OG10** WIREWAY BOARD - W4L22561  
 (x1) 1 3/16" x 3 3/8" x 73" (30x86x1854)



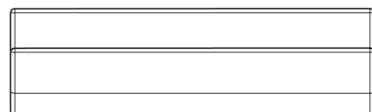
**OG12** WIREWAY BOARD - W4L21999  
 (x1) 1 3/16" x 3 3/8" x 35 3/16" (30x86x894)



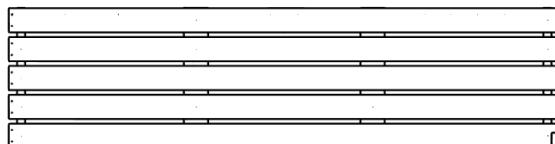
**OV01** HEATER GUARD SPACER - W4L21887  
 (x2) 1 3/16" x 4 7/16" x 23 15/16" (30x112x608)

# OWNER'S MANUAL - PARTS IDENTIFICATION

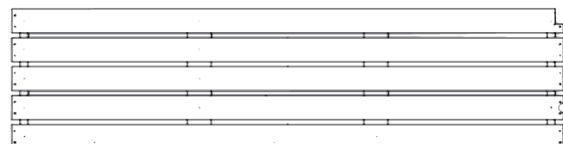
## ACCESSORY COMPONENTS (NOT TO SCALE)



AM02 DOOR HANDLE - W2A04795  
(x1) 2 1/4" x 3" x 10 3/16" (57x76x258)



BA01 RIGHT BENCH ASSEMBLY - W2A04826  
(x1) 1 15/16" x 19 1/8" x 75 1/4" (50x486x1912)



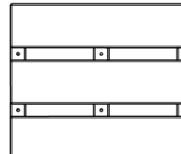
BA02 LEFT BENCH ASSEMBLY - W2A04827  
(x1) 19 1/8" x 75 1/4" (50x486x1912)



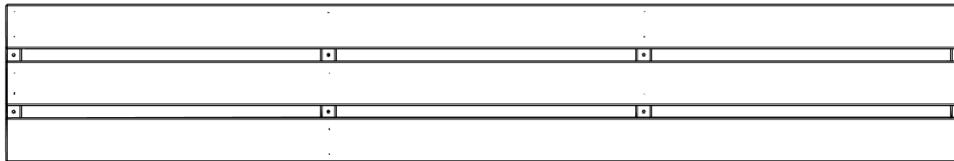
BA03 OUTSIDE BENCH ASSEMBLY - W2A04806  
(x1) 1 15/16" x 19 1/8" x 19 3/4" (50x486x502)



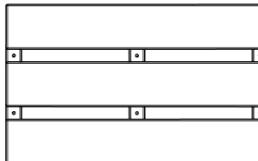
BA04 OUTSIDE BENCH ASSEMBLY - W2A04808  
(x1) 1 15/16" x 19 3/16" x 19 3/4" (50x487x502)



BR01 WALL BACK REST - W2A04790  
(x2) 1 15/16" x 12 1/16" x 14" (50x306x356)



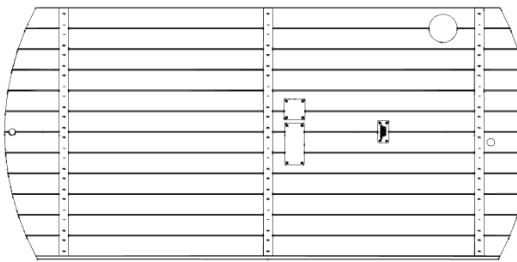
BR02 BENCH BACK REST - W2A04828  
(x2) 1 15/16" x 12 1/16" x 73 3/8" (50x306x1864)



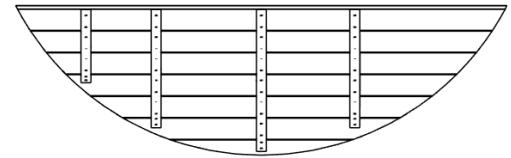
BR03 BENCH BACK REST - W2A04807  
(x2) 1 15/16" x 12 1/16" x 19 3/4" (50x306x502)



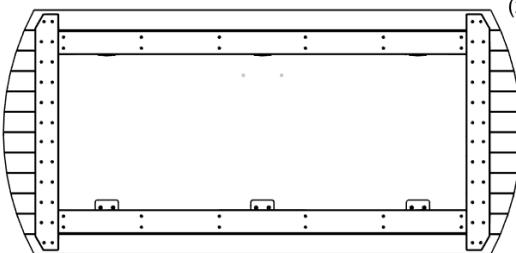
WP01 WALL PANEL ASSEMBLY - W2A04784  
(x1) 1 3/8" x 19 11/16" x 65 3/4" (35x500x1669)



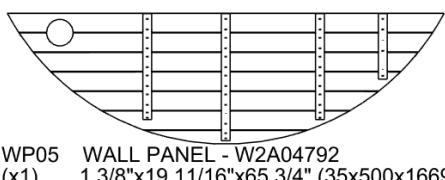
WP02 WALL PANEL ASSEMBLY - W2A04785  
(x1) 1 3/8" x 35 5/8" x 74 9/16" (35x906x1894)



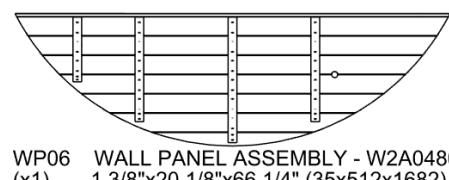
WP03 WALL PANEL ASSEMBLY - W2A04786  
(x1) 1 3/8" x 20 1/8" x 66 1/4" (35x512x1682)



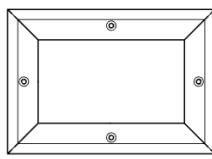
WP04 WALL PANEL ASSEMBLY - W2A04794  
(x1) 2 3/8" x 35 5/8" x 74 9/16" (60x906x1894)



WP05 WALL PANEL - W2A04792  
(x1) 1 3/8" x 19 11/16" x 65 3/4" (35x500x1669)



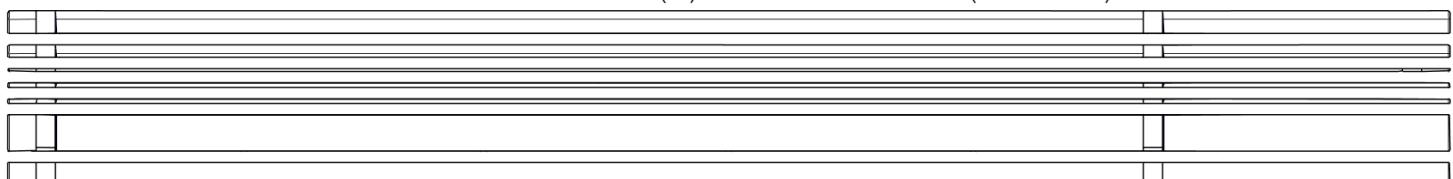
WP06 WALL PANEL ASSEMBLY - W2A04809  
(x1) 1 3/8" x 20 1/8" x 66 1/4" (35x512x1682)



TF01 TRIM FRAME - W2A04797  
(x1) 7/8" x 5 9/16" x 8 1/16" (22x142x204)



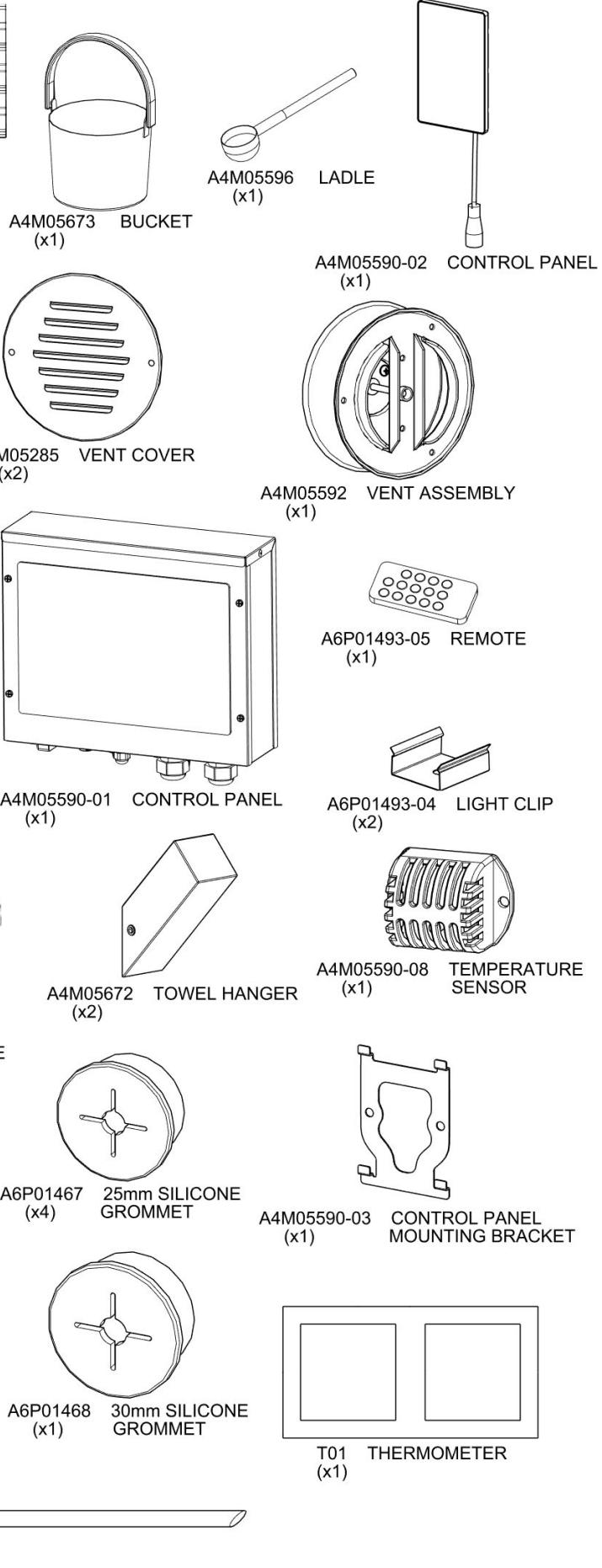
FP01 FLOOR PANEL ASSEMBLY - W2A04829  
(x1) 1 15/16" x 20 7/8" x 73 7/8" (50x530x1876)



BOARD SPACER KIT - W2A04961  
(x1)

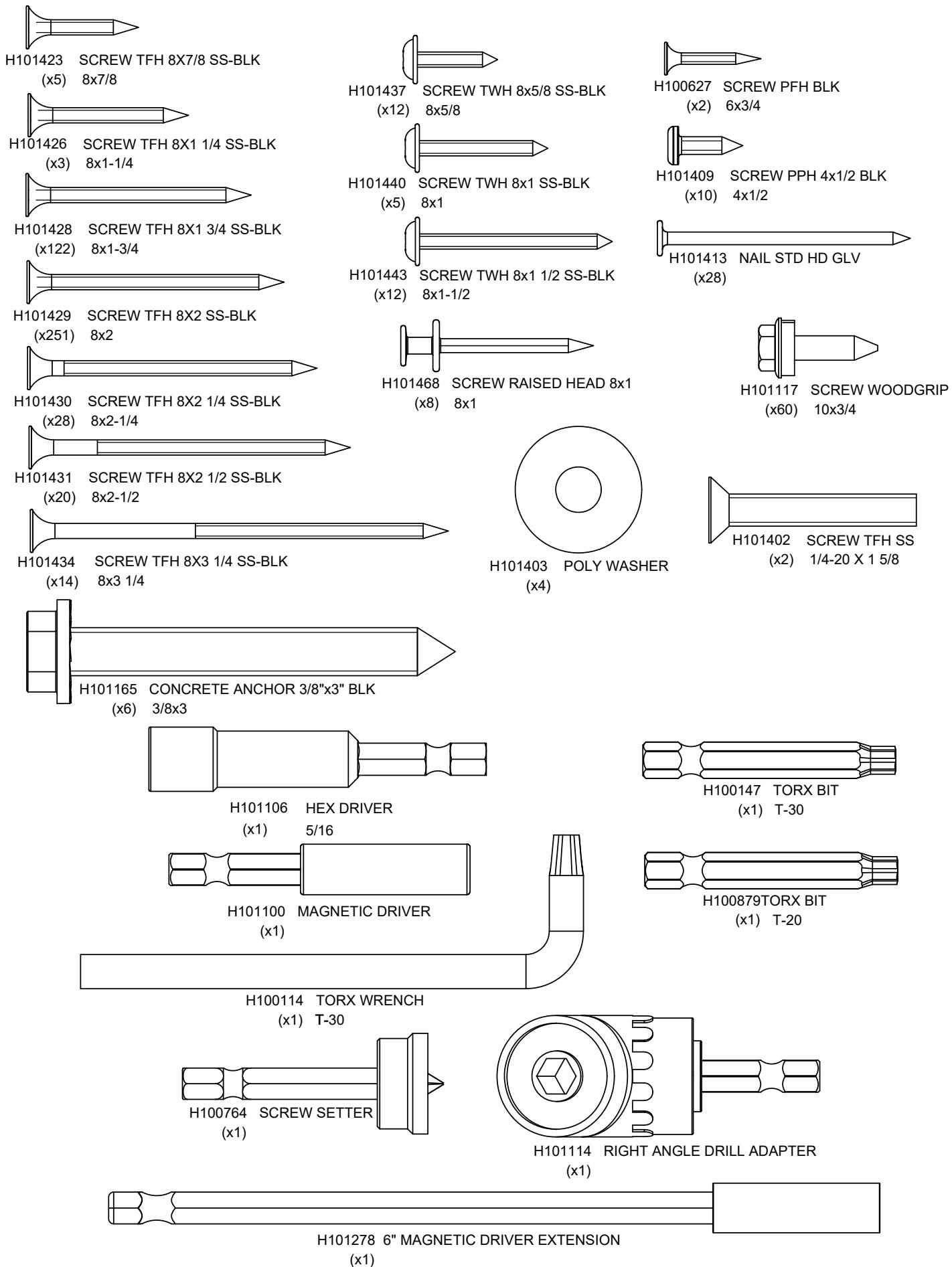
# OWNER'S MANUAL - PARTS IDENTIFICATION

## ACCESSORY COMPONENTS (NOT TO SCALE)



# OWNER'S MANUAL - PARTS IDENTIFICATION

## HARDWARE COMPONENTS



# 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.

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## **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.

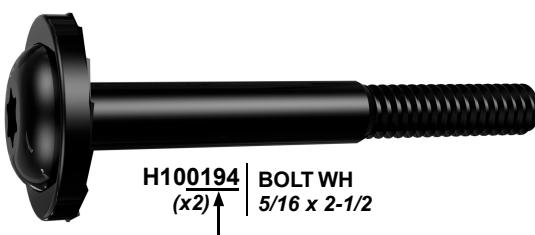
**NOTE: CARTONS ARE NOT ORGANIZED BY BOARD NUMBER.**



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## **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



Open End  
Wrench 11/16"



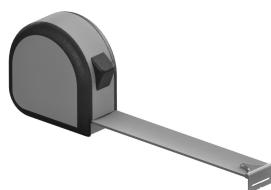
1/8", 3/16", 3/8" &  
7/16" Drill Bits



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



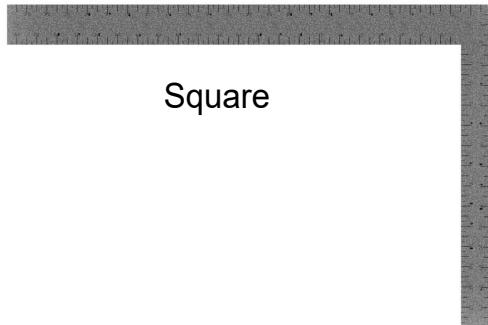
Phillips Screw Driver



Tape Measure



Claw Hammer



Square



Level 24"



Rubber Mallet  
- Optional



Rope 25ft [7.62m] long - Optional

## PRE-ASSEMBLY STEP 3 - CHOOSE YOUR ASSEMBLY METHOD

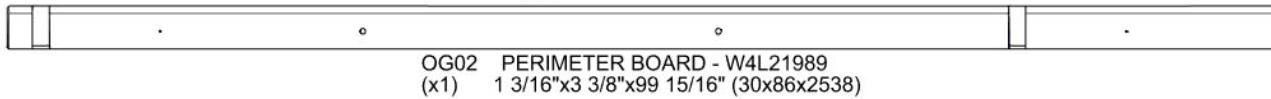
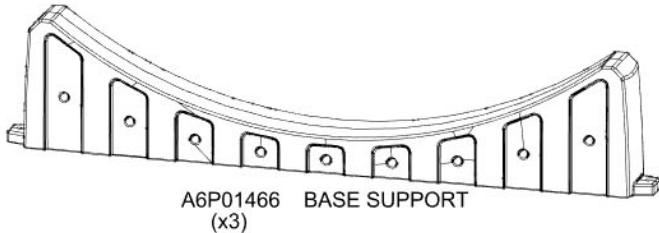
There are several types of assembly instructions available to you.

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)

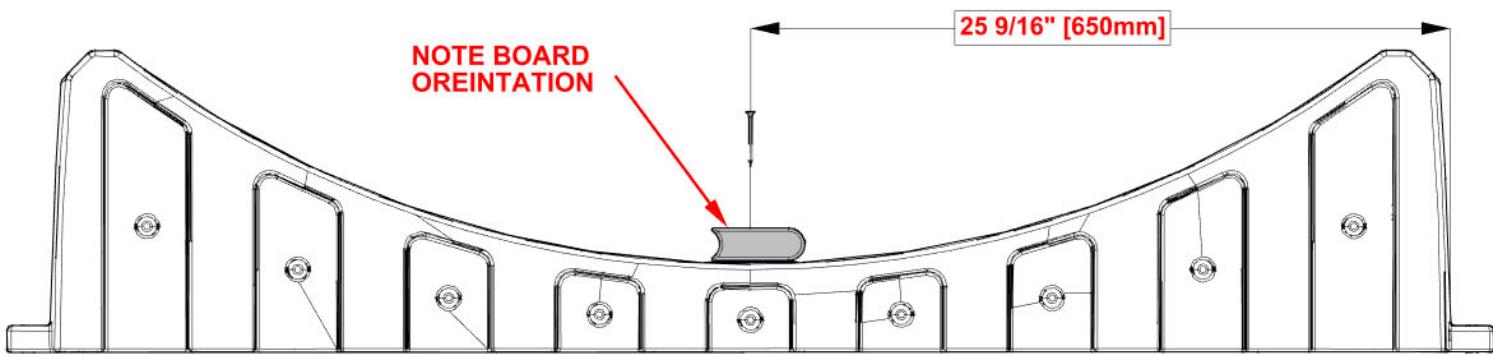


# STEP 1 - BASE ASSEMBLY

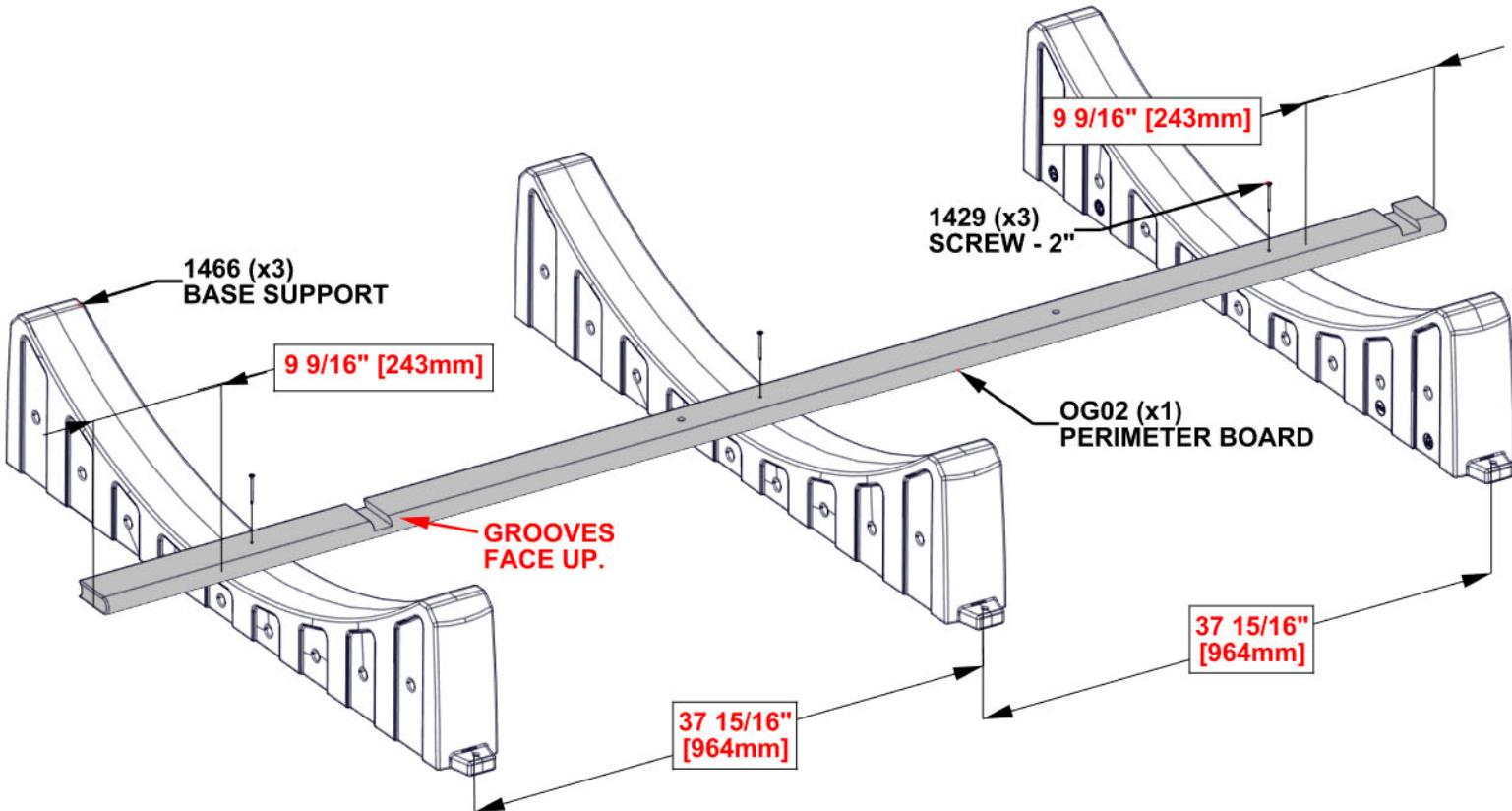
QTY	PART NUMBER	DESCRIPTION
3	H101429	SCREW TFH 8X2 SS-BLK



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



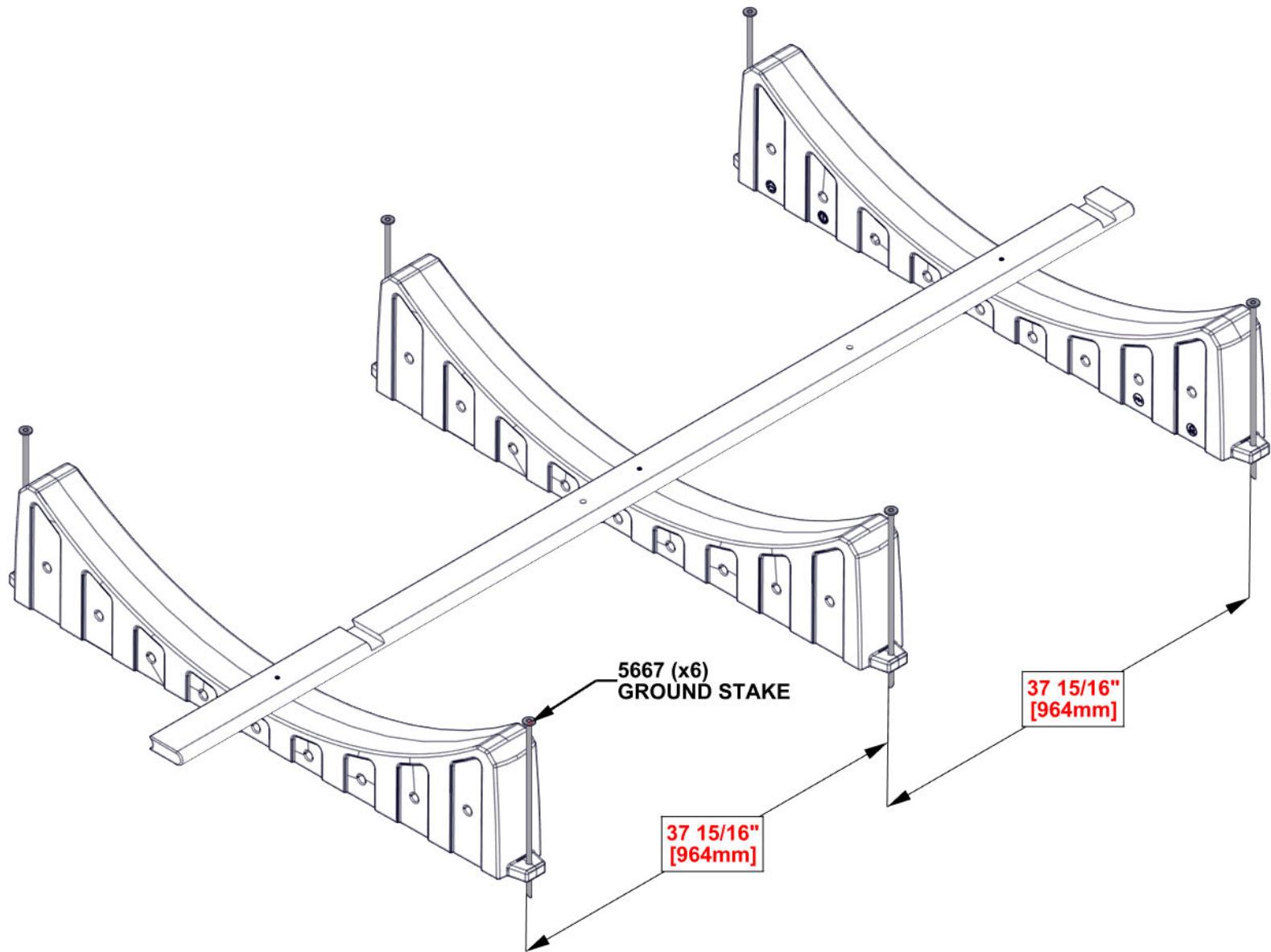
FRONT VIEW



## STEP 2 - ANCHORING TO GROUND



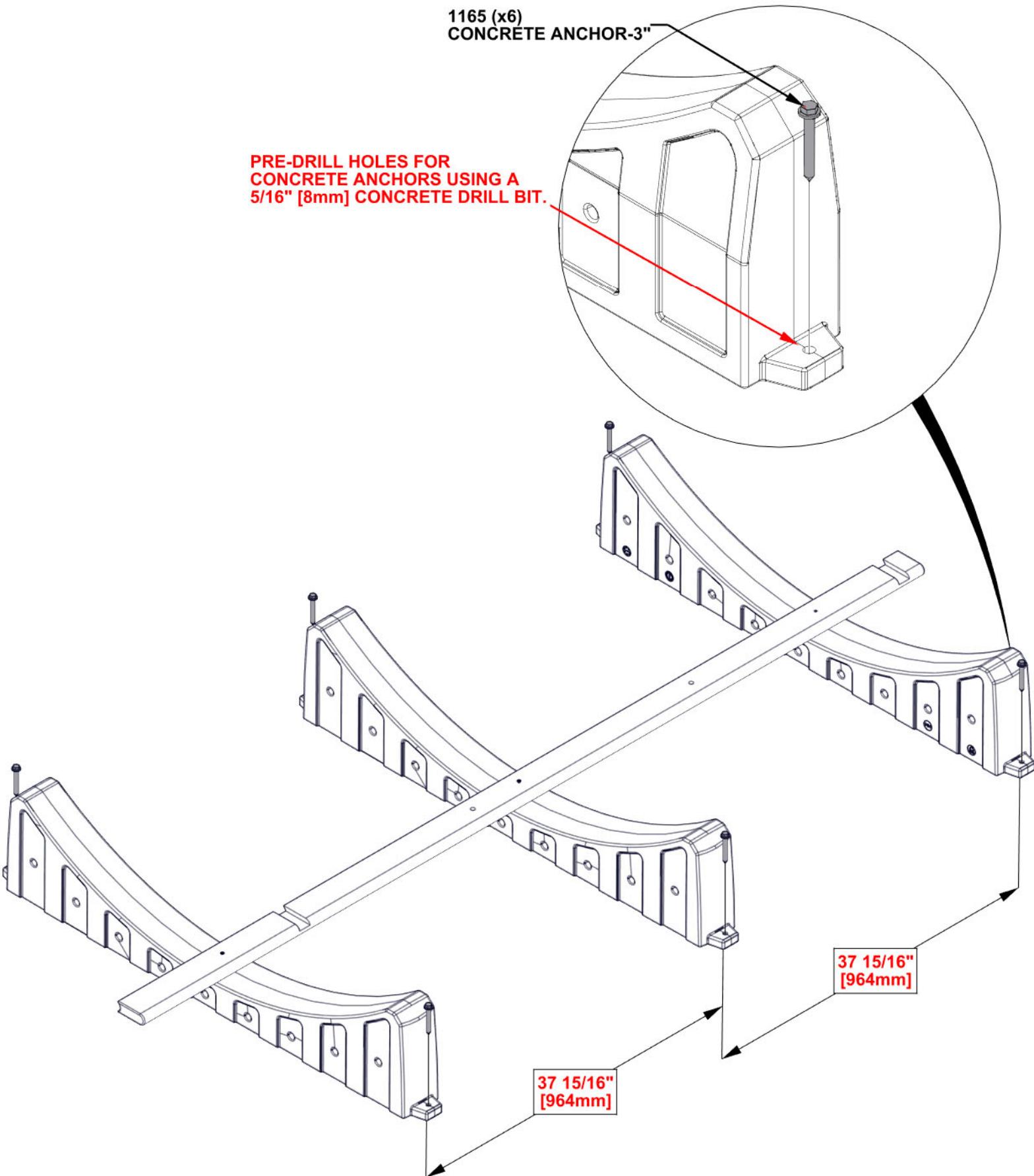
- IF SAUNA IS TO SIT ON A CONCRETE SURFACE, SEE STEP 3.



## STEP 3 - ANCHORING TO CONCRETE

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

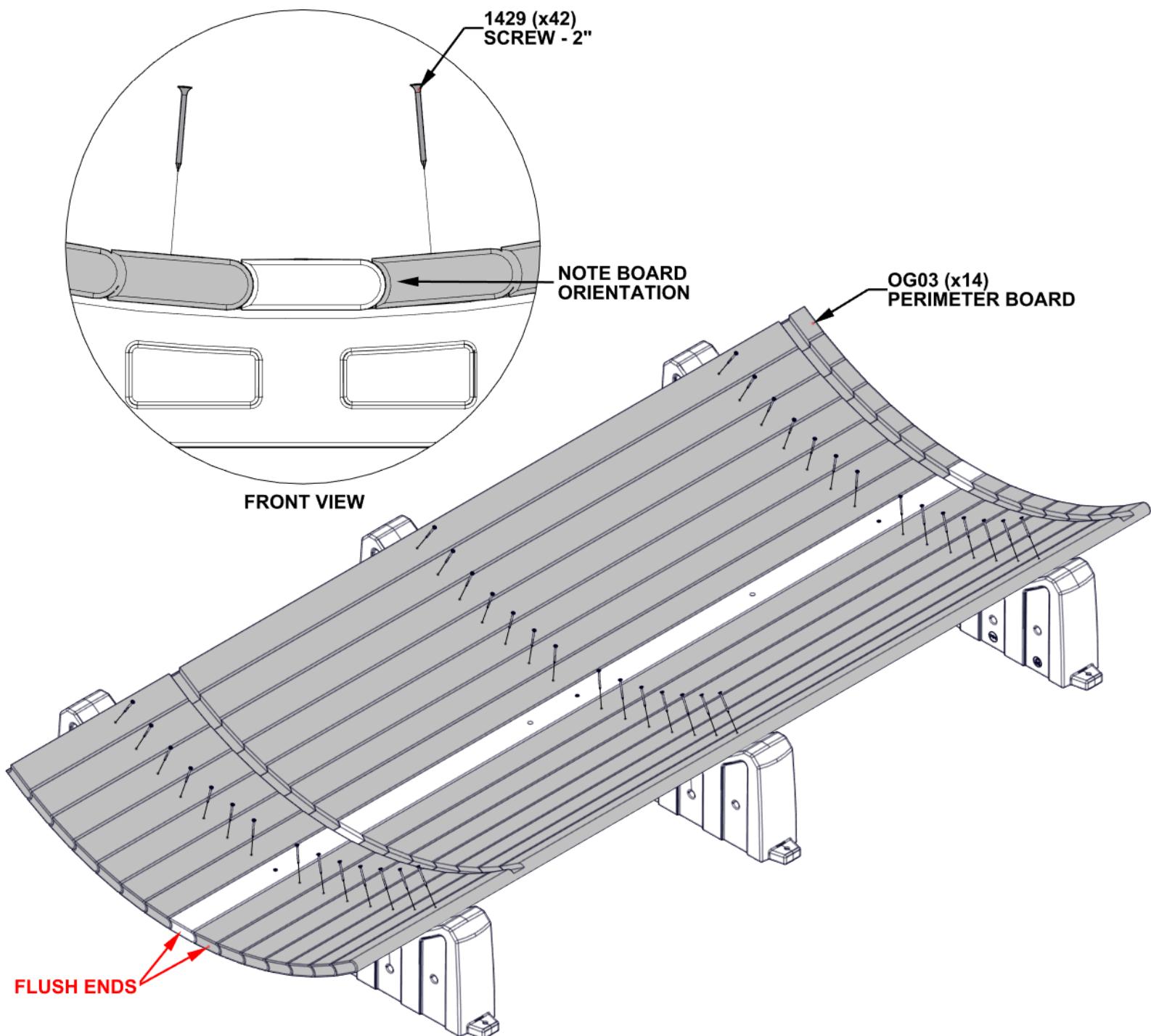
QTY	PART NUMBER	DESCRIPTION
6	H101165	CONCRETE ANCHOR 3/8x3" BLK



## STEP 4 - BASE ASSEMBLY

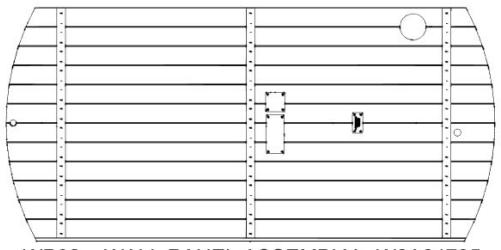
QTY	PART NUMBER	DESCRIPTION
42	H101429	SCREW TFH 8X2 SS-BLK

OG03 PERIMETER BOARD - W4L21990  
(x14) 1 3/16"x3 3/8"x99 15/16" (30x86x2538)

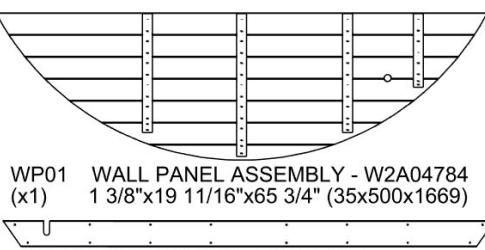


# STEP 5 - BACK WALL ASSEMBLY

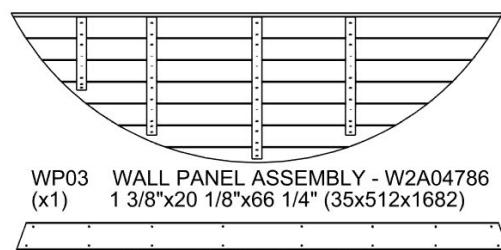
QTY	PART NUMBER	DESCRIPTION
32	H101429	SCREW TFH 8X2 SS-BLK



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



WP01 WALL PANEL ASSEMBLY - W2A04784  
(x1) 1 3/8"x19 11/16"x65 3/4" (35x500x1669)

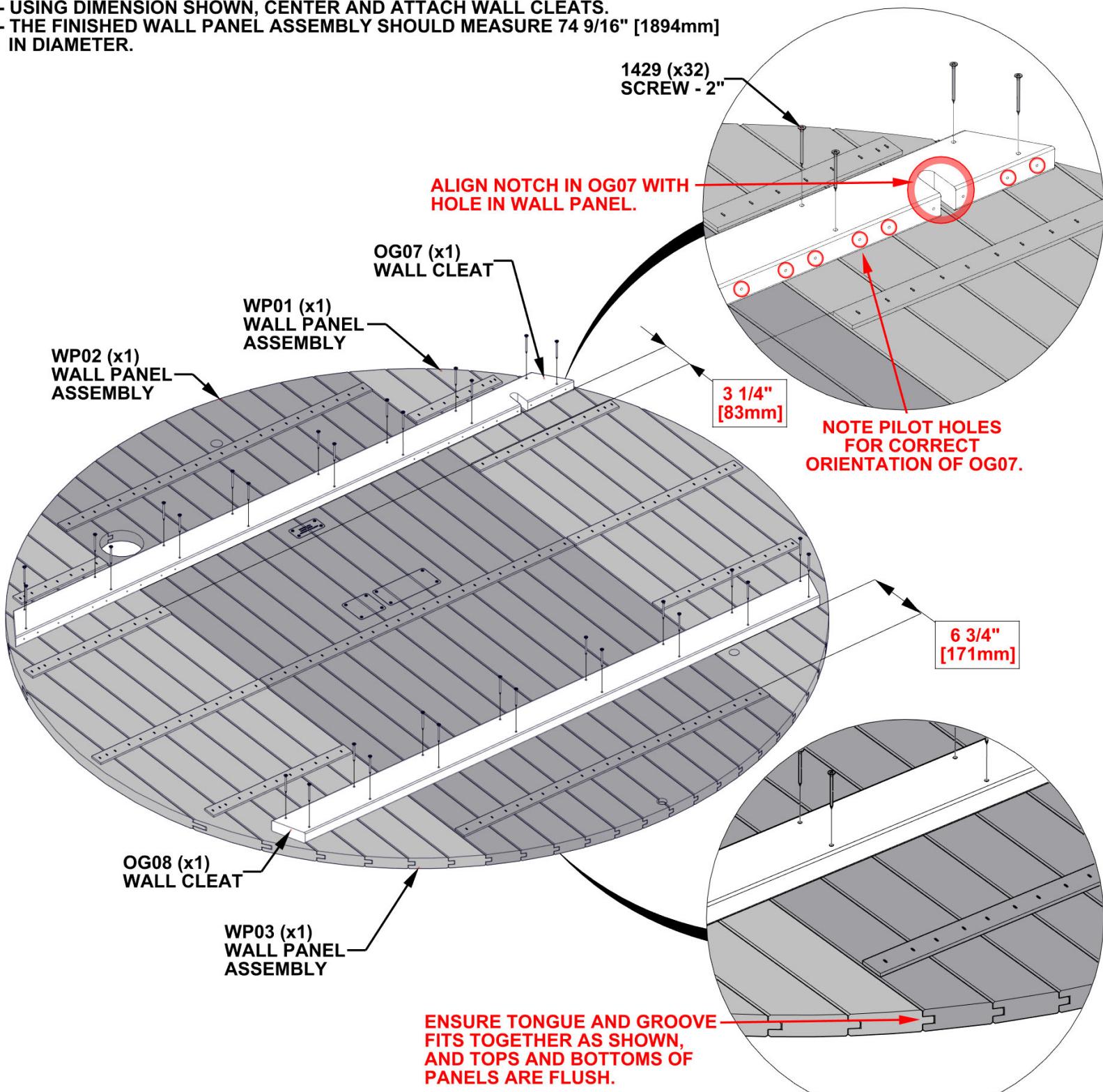


WP03 WALL PANEL ASSEMBLY - W2A04786  
(x1) 1 3/8"x20 1/8"x66 1/4" (35x512x1682)

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.

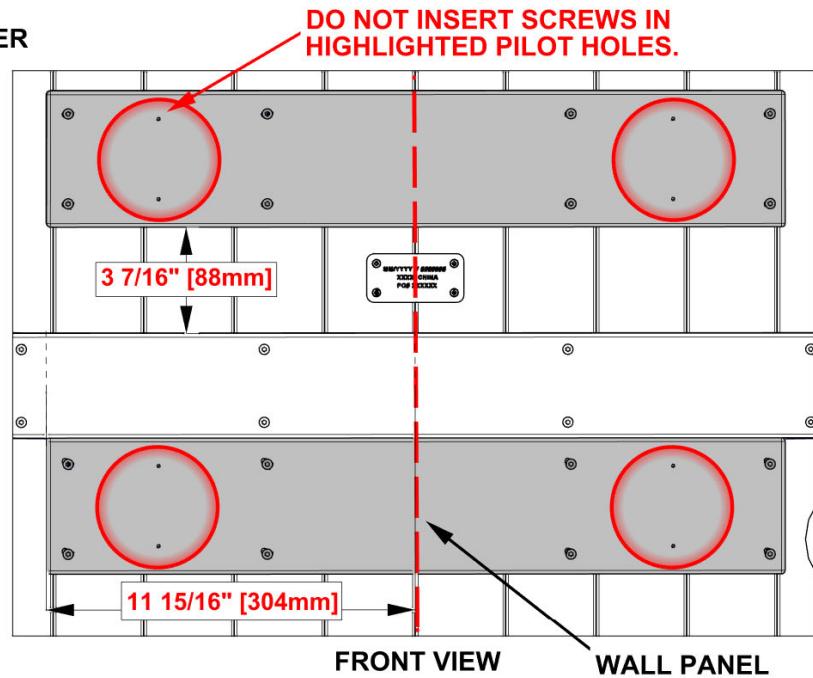
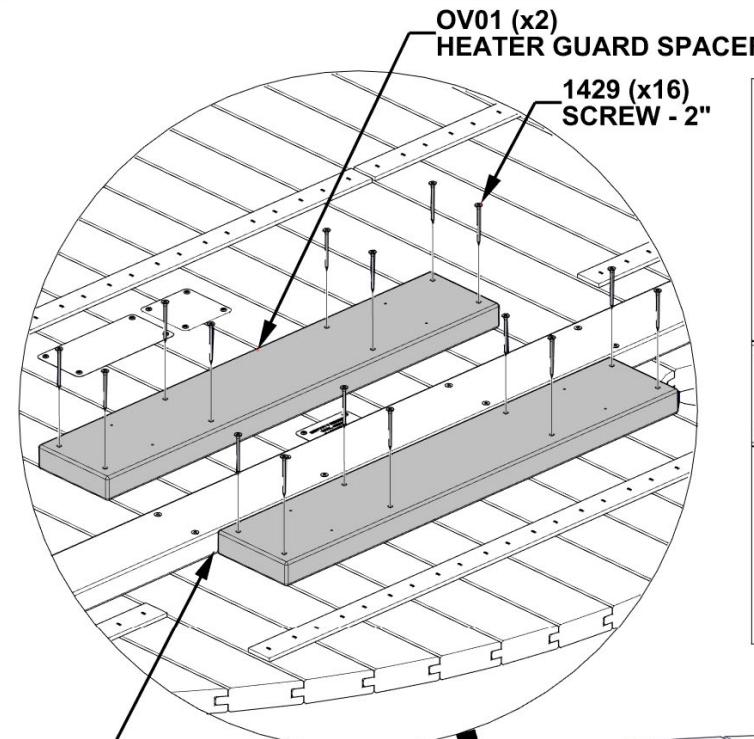


# STEP 6 - BACK WALL ASSEMBLY

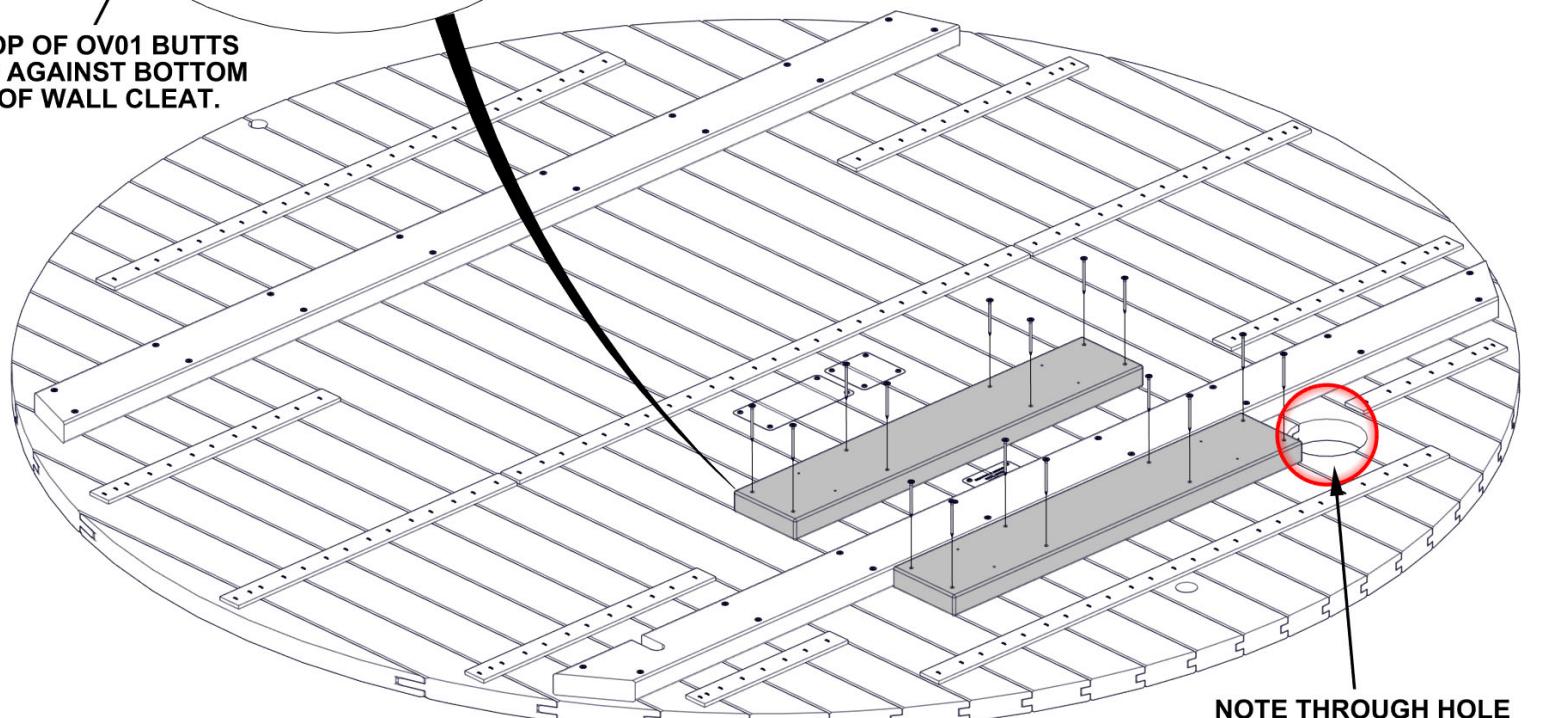
QTY	PART NUMBER	DESCRIPTION
16	H101429	SCREW TFH 8X2 SS-BLK



OV01 HEATER GUARD SPACER - W4L21887  
(x2) 1 3/16" x 4 7/16" x 23 15/16" (30x112x608)



TOP OF OV01 BUTTS UP AGAINST BOTTOM OF WALL CLEAT.



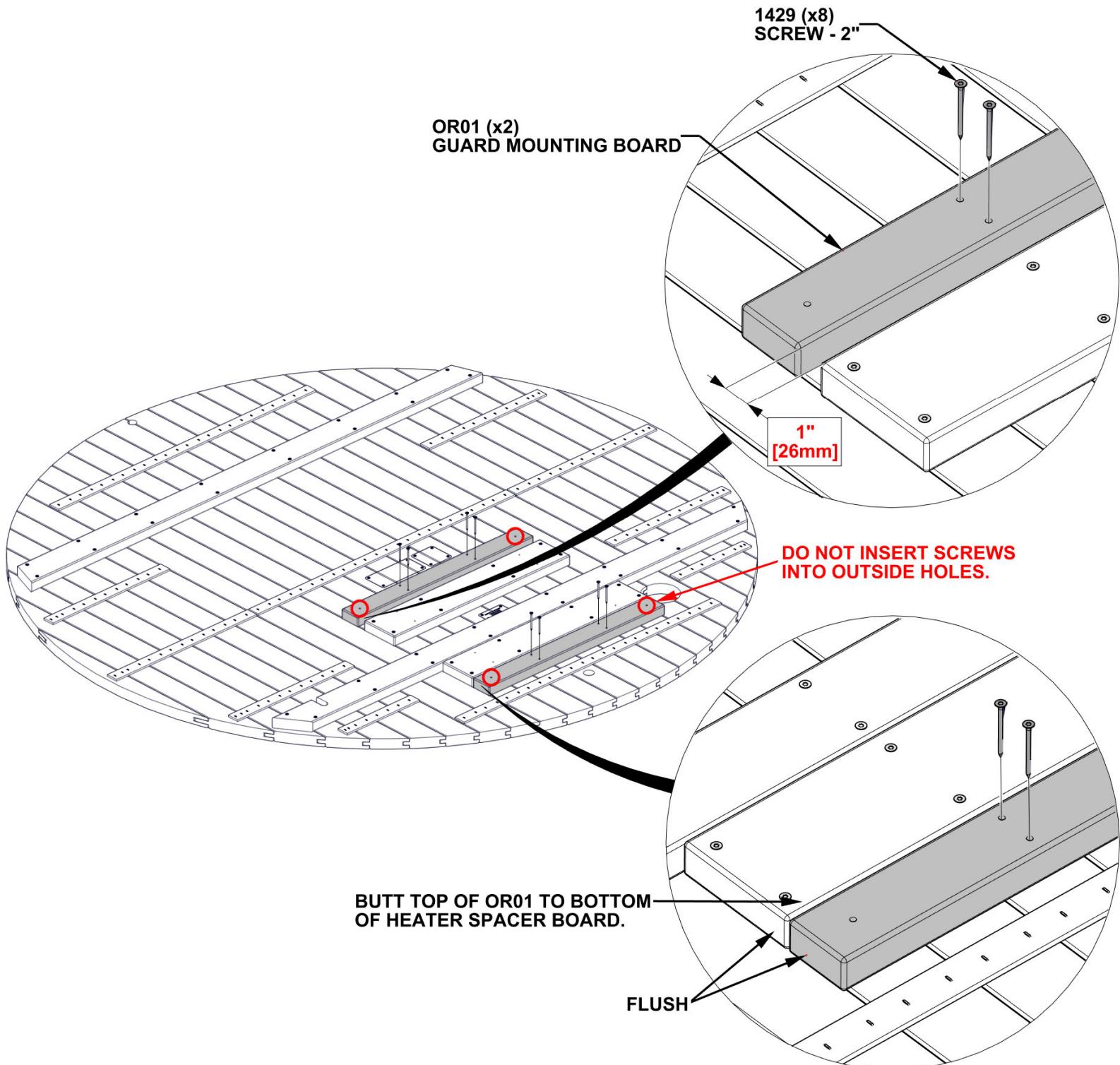
## STEP 7 - BACK WALL ASSEMBLY

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



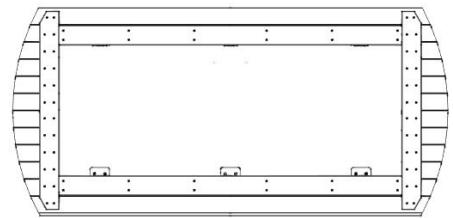
OR01 GUARD MOUNTING BOARD - W4L21873  
(x2) 1 3/16" x 2 3/8" x 23 15/16" (30x60x608)

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

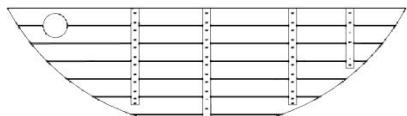


# STEP 8 - FRONT WALL ASSEMBLY

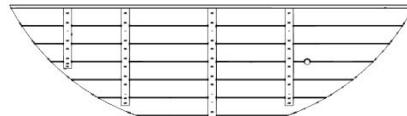
QTY	PART NUMBER	DESCRIPTION
24	H101429	SCREW TFH 8X2 SS-BLK



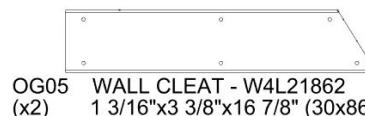
WP04 WALL PANEL ASSEMBLY - W2A04794  
(x1) 2 3/8"X35 5/8"X74 9/16" (60x906x1894)



WP05 WALL PANEL - W2A04792  
(x1) 1 3/8"X19 11/16"x65 3/4" (35x500x1669)



WP06 WALL PANEL ASSEMBLY - W2A04809  
(x1) 1 3/8"X20 1/8"x66 1/4" (35x512x1682)



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)



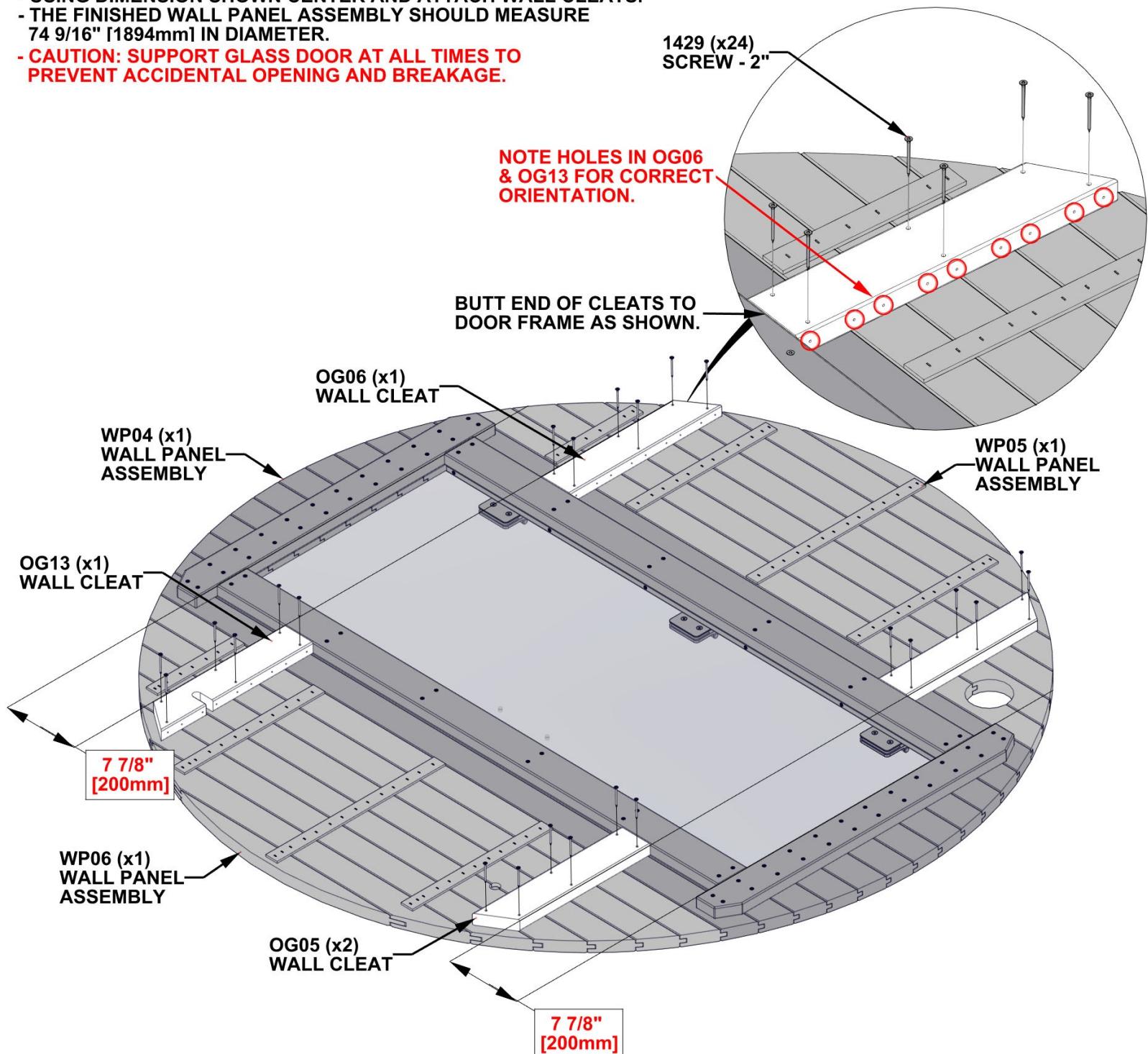
OG13 (x1) WALL CLEAT - W4L22019  
1 3/16"x3 3/8"x17 3/16" (30x86x437)

- USING DIMENSION SHOWN CENTER AND ATTACH WALL CLEATS.

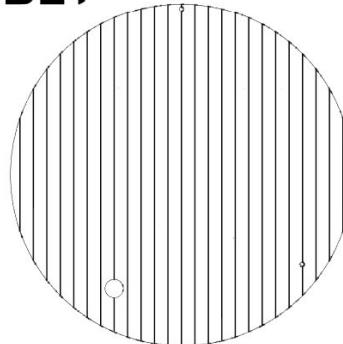
- THE FINISHED WALL PANEL ASSEMBLY SHOULD MEASURE

74 9/16" [1894mm] IN DIAMETER.

- CAUTION: SUPPORT GLASS DOOR AT ALL TIMES TO PREVENT ACCIDENTAL OPENING AND BREAKAGE.

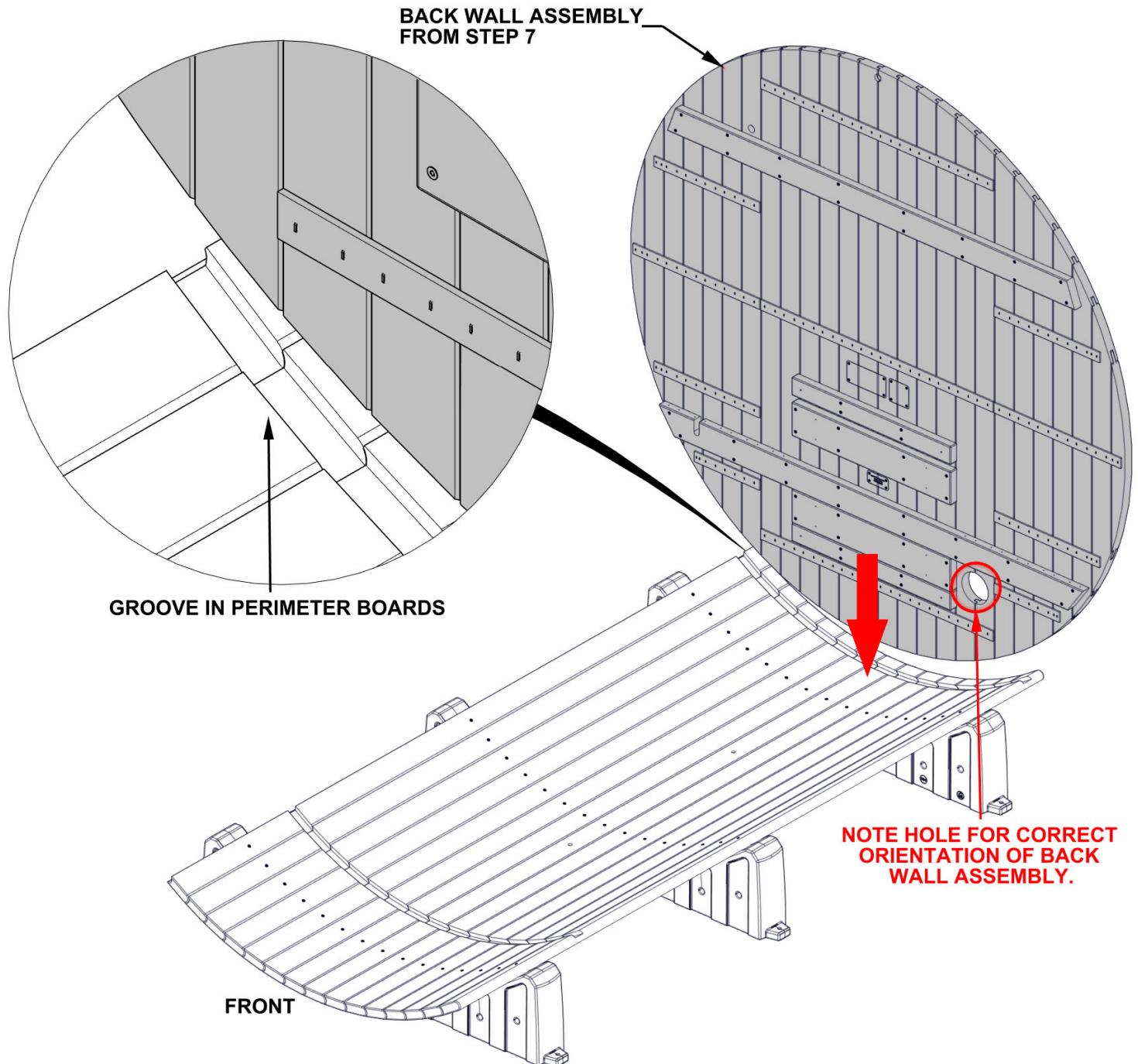


## STEP 9 - SAUNA ASSEMBLY

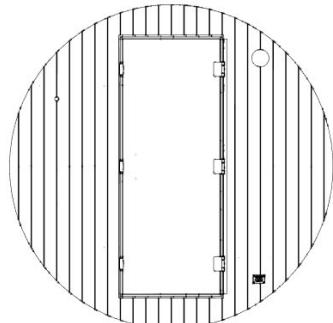


BACK WALL ASSEMBLY - FROM STEP 7

- 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 TOP AND BOTTOM NOT THE SIDES.



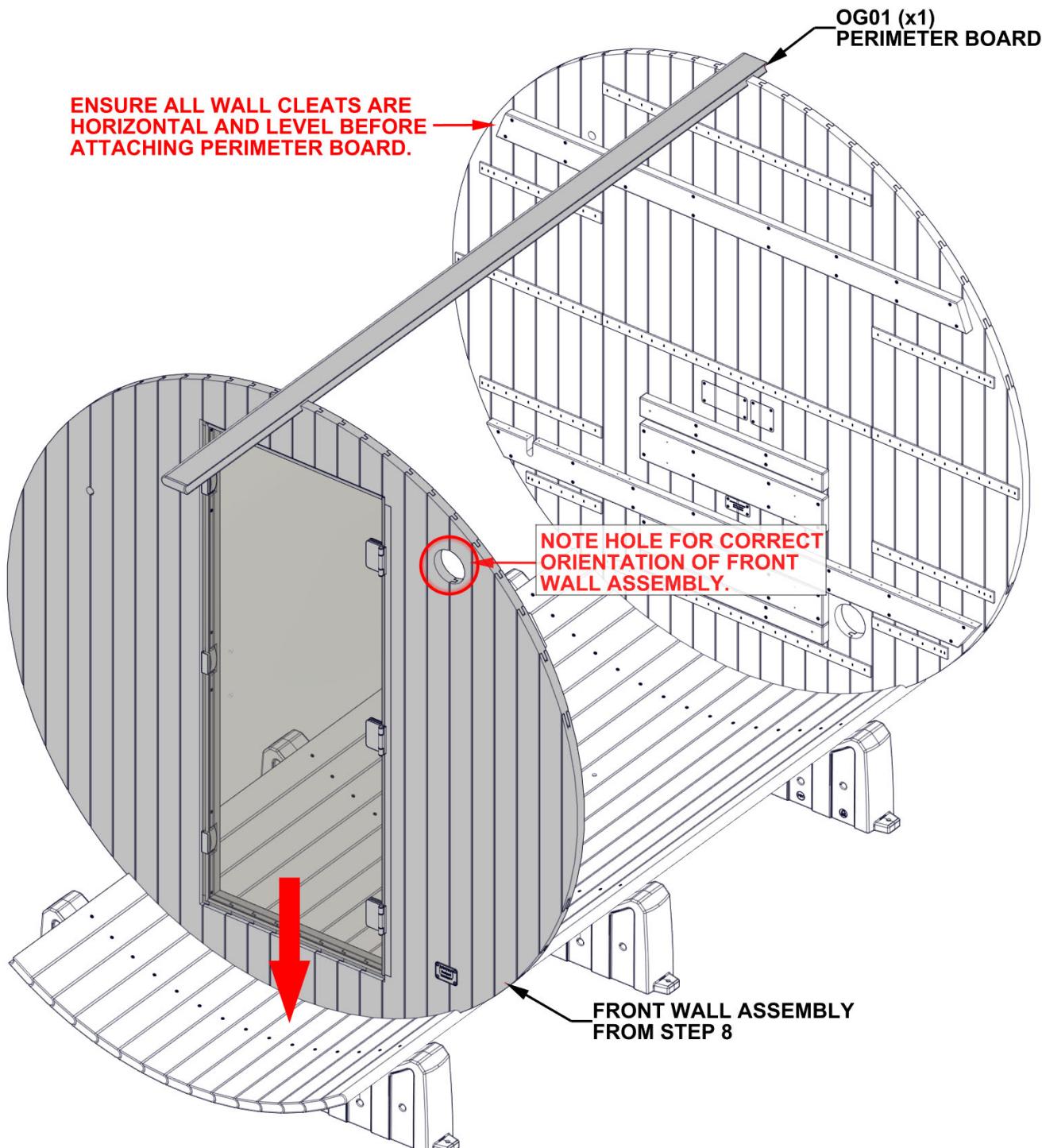
## STEP 10 - SAUNA ASSEMBLY



FRONT WALL ASSEMBLY - FROM STEP 8

OG01 PERIMETER BOARD - W4L21988  
(x1) 1 3/16" x 3 3/8" x 99 15/16" (30x86x2538)

- 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.



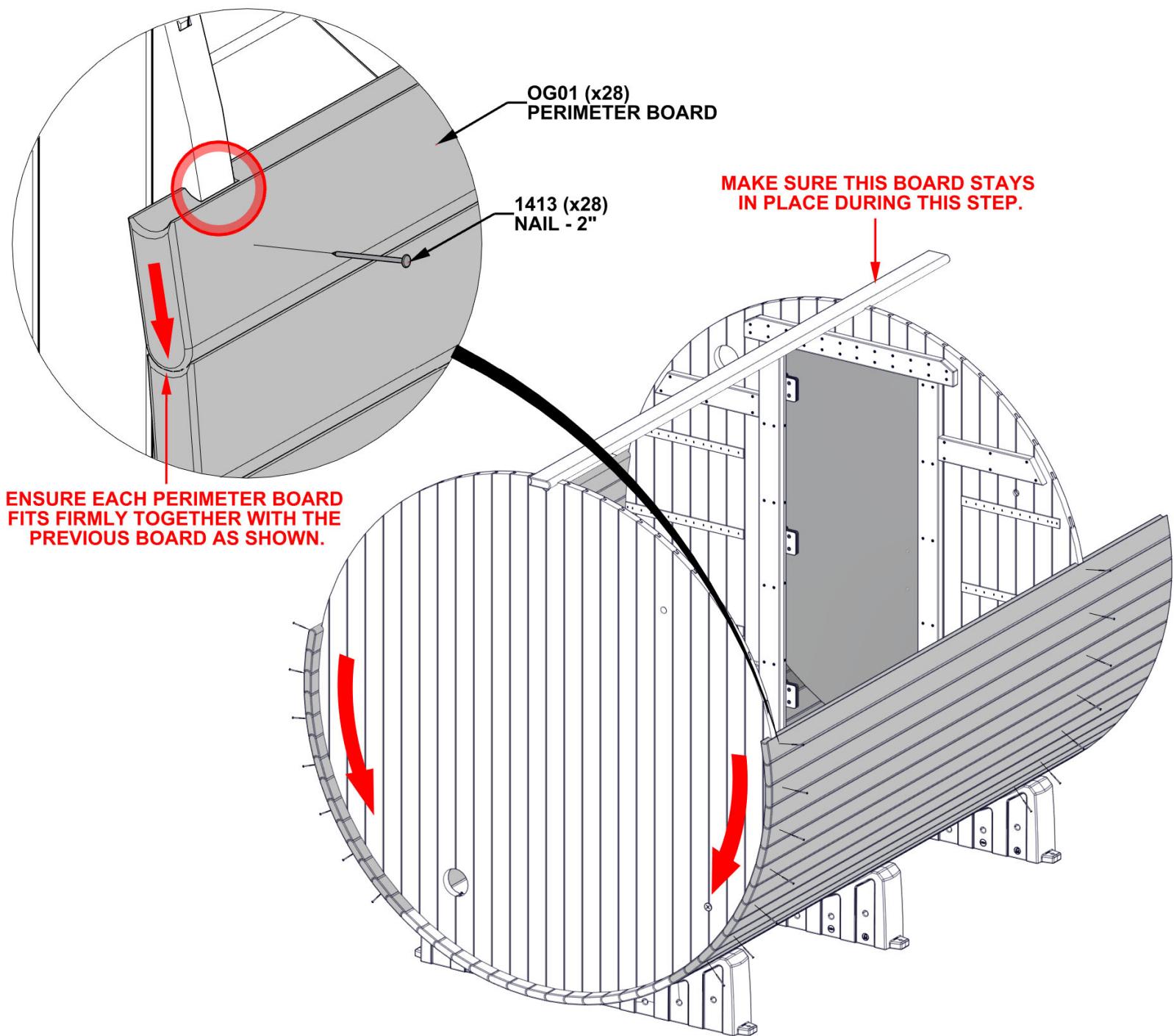
# STEP 11 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
28	H101413	NAIL STD 2.5x50 GLV



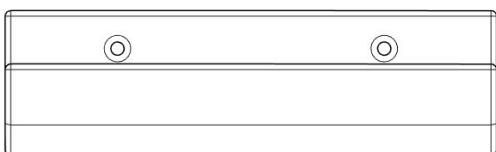
OG01 PERIMETER BOARD - W4L21988  
(x28) 1 3/16" x 3 3/8" x 99 15/16" (30x86x2538)

- 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.

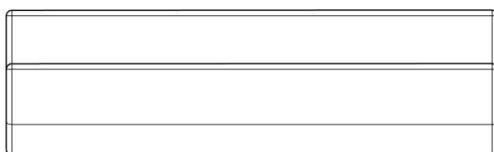


## STEP 12 - HANDLE ASSEMBLY

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

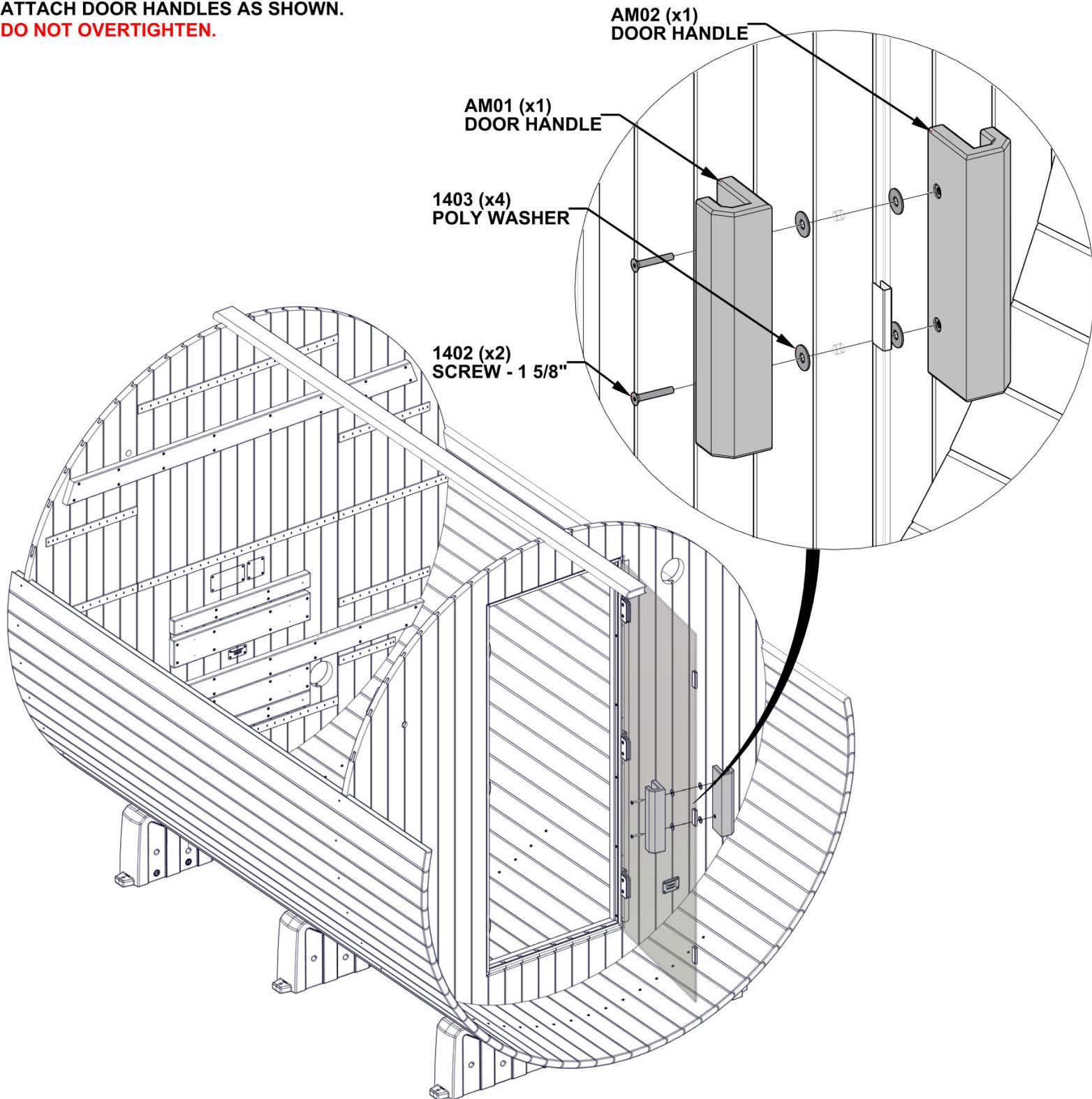


AM01 DOOR HANDLE - W4L21861  
(x1) 2 1/4" x 3" x 10 3/16" (57x76x258)



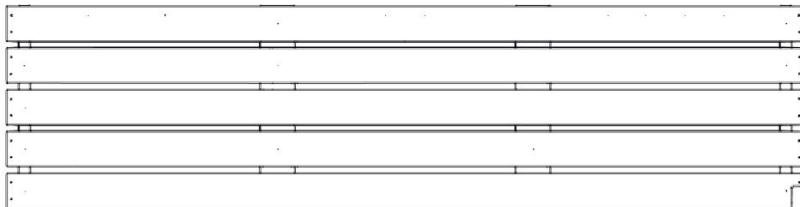
AM02 DOOR HANDLE - W2A04795  
(x1) 2 1/4" x 3" x 10 3/16" (57x76x258)

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



# STEP 13 - BENCH ASSEMBLY

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

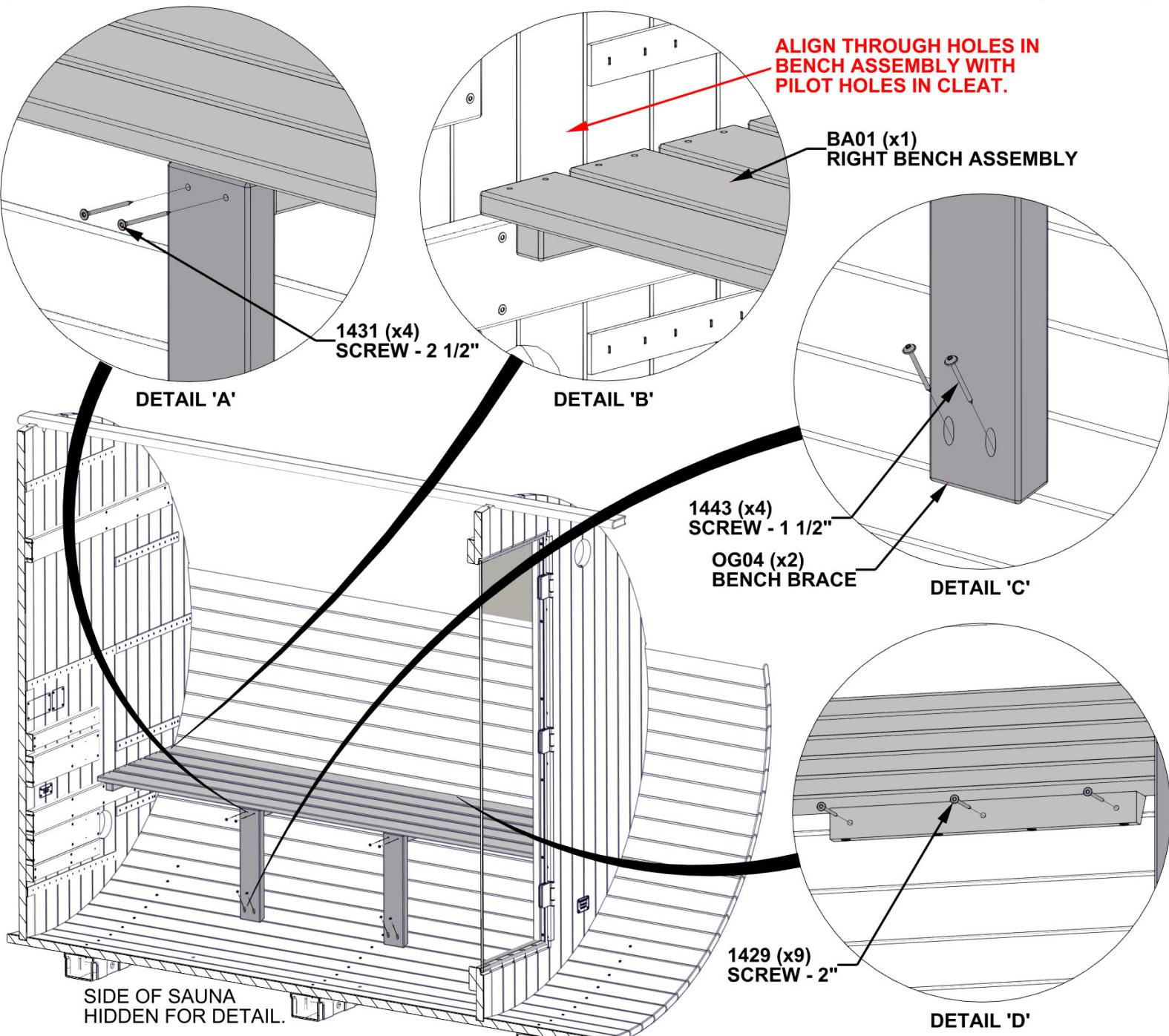


BA01 RIGHT BENCH ASSEMBLY - W2A04826  
(x1) 1 15/16" x 19 1/8" x 75 1/4" (50x486x1912)



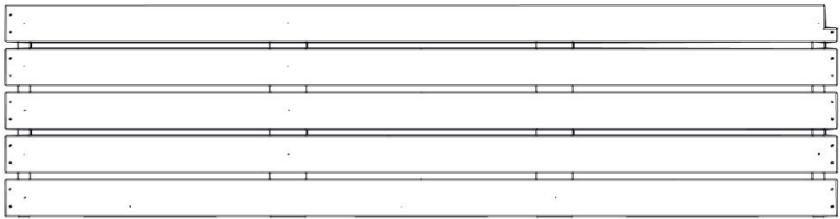
OG04 BENCH BRACE - W4L21860  
(x2) 1 3/16" x 3 3/8" x 16 3/8" (30x86x416)

- 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 14 - BENCH ASSEMBLY

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

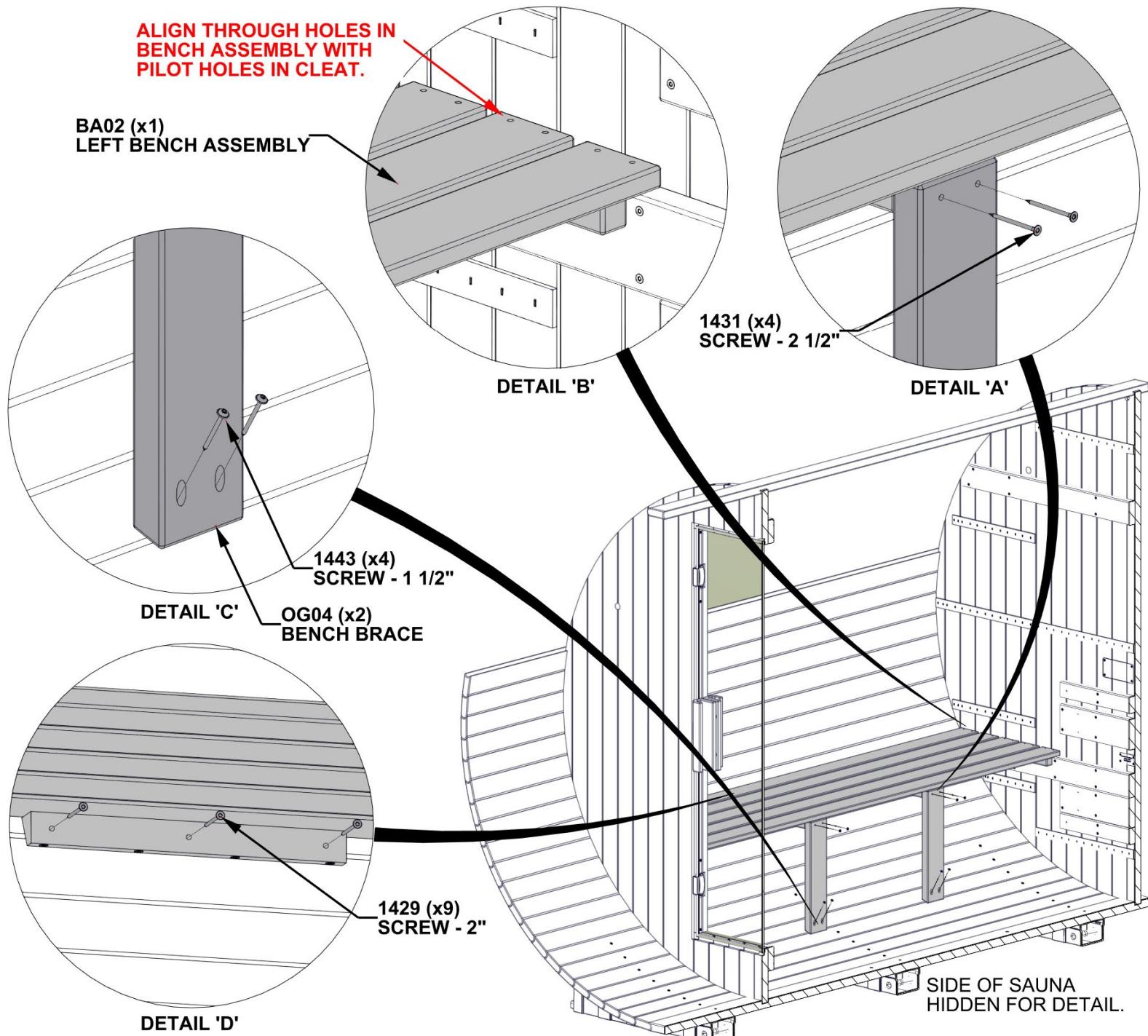


BA02 LEFT BENCH ASSEMBLY - W2A04827  
(x1) 19 1/8"75 1/4" (50x486x1912)



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

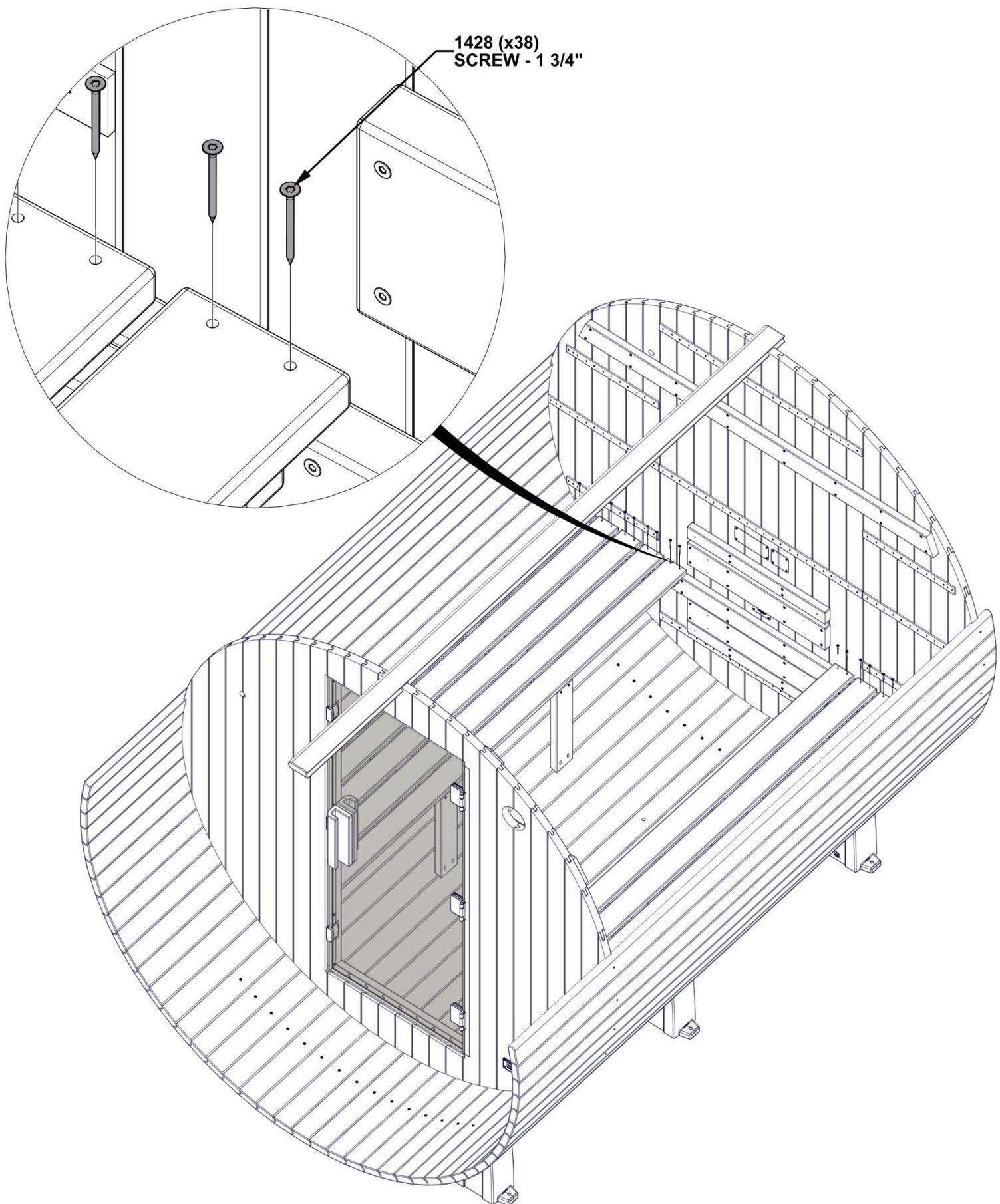
- 1) INSTALL BENCH BRACE OG04 TO BENCH ASSEMBLY. (DETAIL 'A')
- 2) PUSH THE BENCH WITH BENCH BRACE BOARD AGAINST THE WALL UNTIL IT MAKES CONTACT WITH THE SIDEWALL.
- 3) CHECK THE ALIGNMENT OF THE HOLES ON EACH END OF THE BENCH WITH THE PILOT HOLES ON THE CLEATS MOUNTED TO THE WALL. (DETAIL 'B')
- 4) 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 15 - BENCH ASSEMBLY

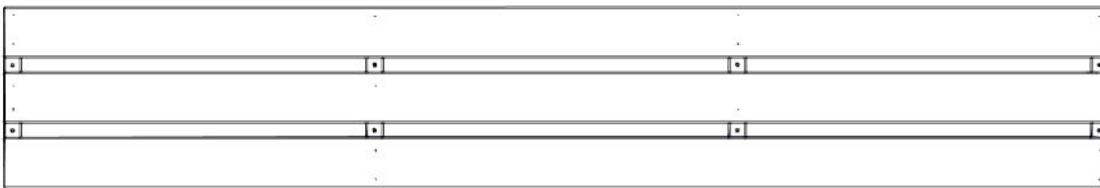
QTY	PART NUMBER	DESCRIPTION
38	H101428	SCREW TFH 8X1 3/4 SS-BLK

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



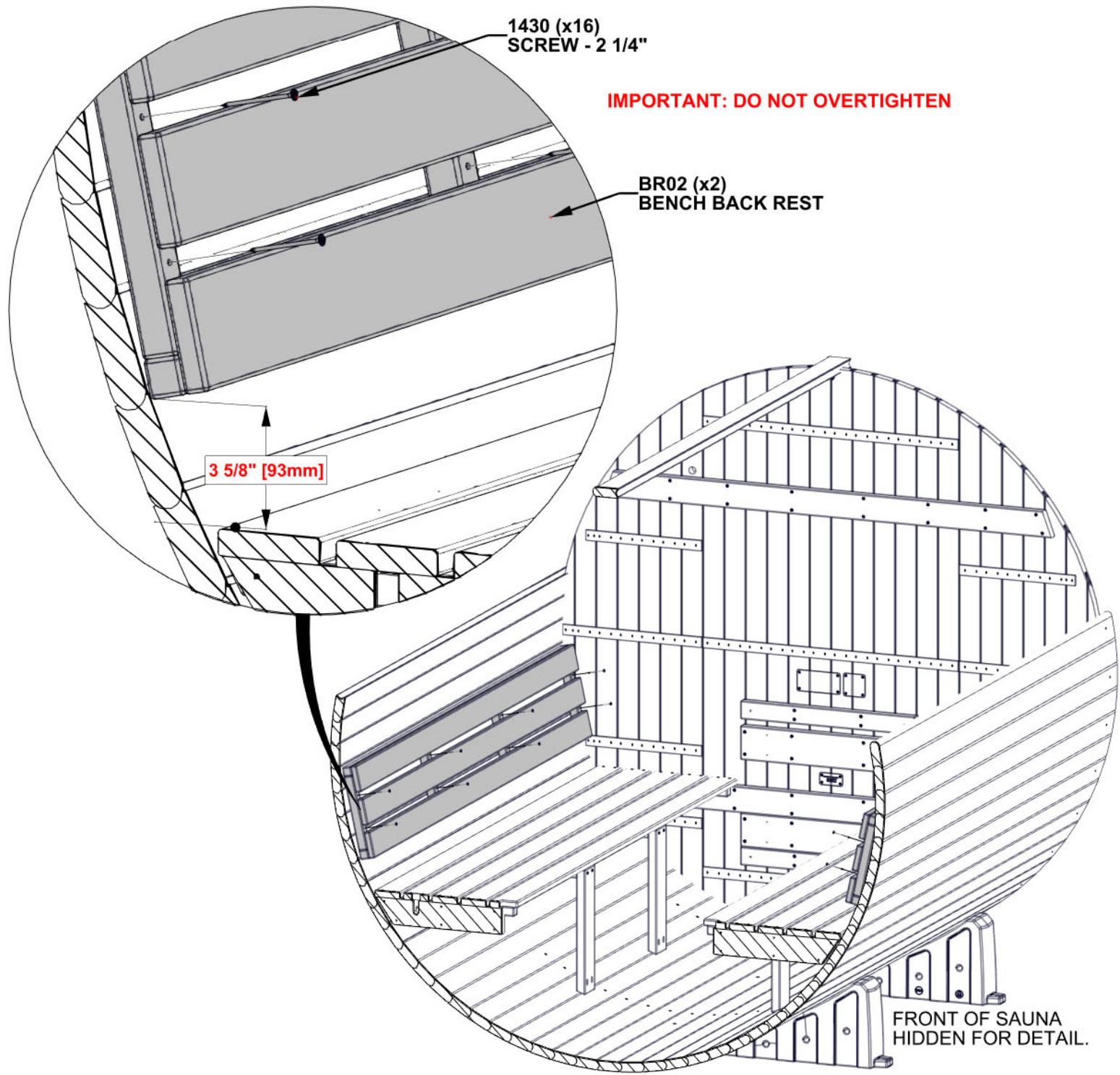
# STEP 16 - BENCH ASSEMBLY

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



BR02 BENCH BACK REST - W2A04828  
(x2) 1 15/16"x12 1/16"x73 3/8" (50x306x1864)

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



## STEP 17 - FLOOR CLEAT INSTALLATION

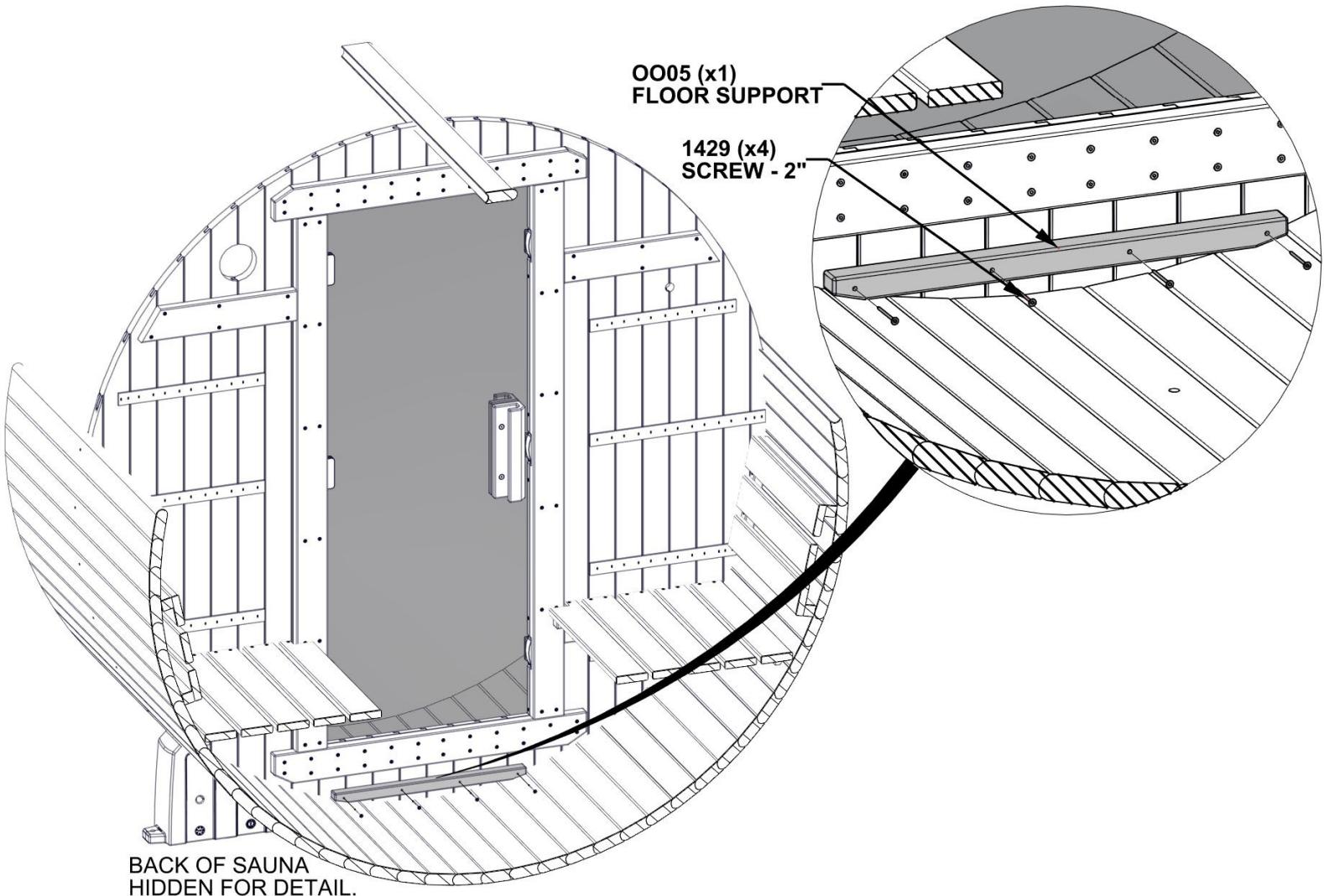
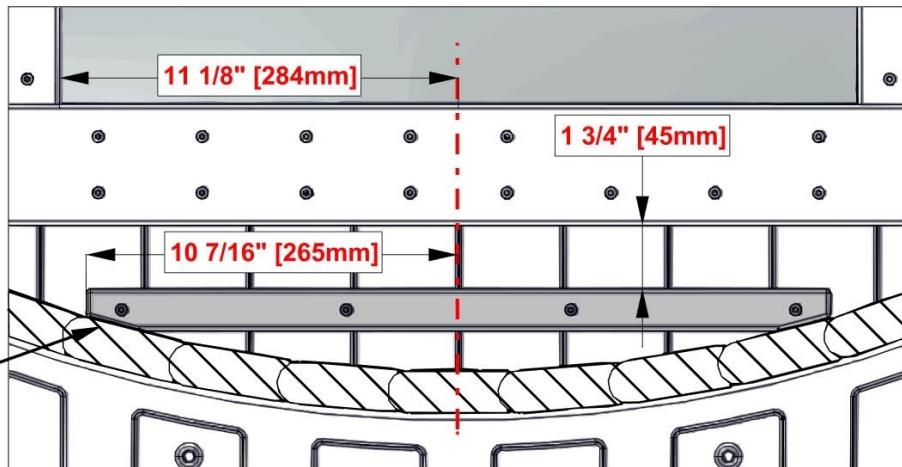
QTY	PART NUMBER	DESCRIPTION
4	H101429	SCREW TFH 8X2 SS-BLK



OO05 FLOOR SUPPORT - W4L21963  
(x1) 1 3/16" x 1 3/16" x 20 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.**

SUPPORT BOARD WILL REST ON FLOOR.



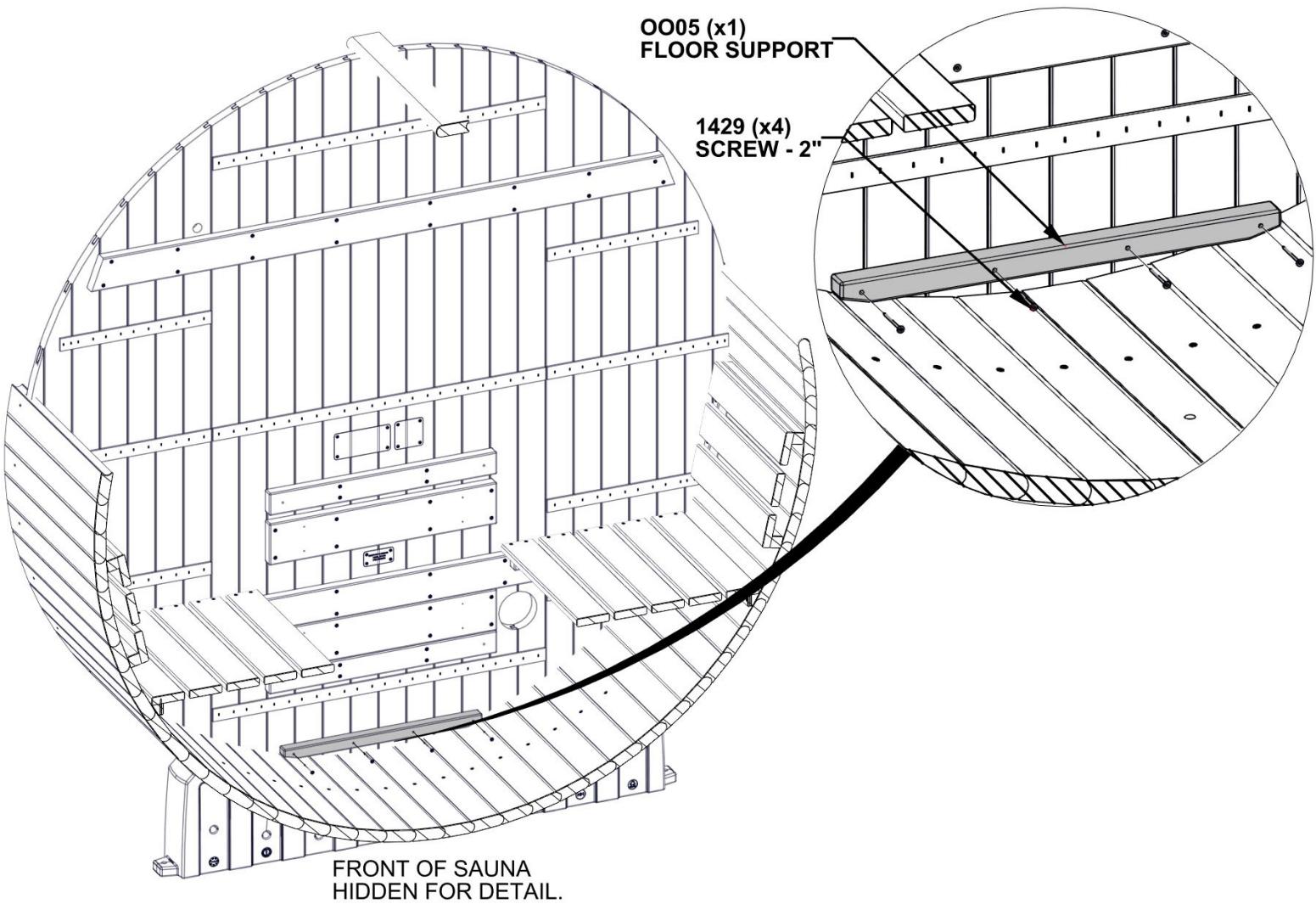
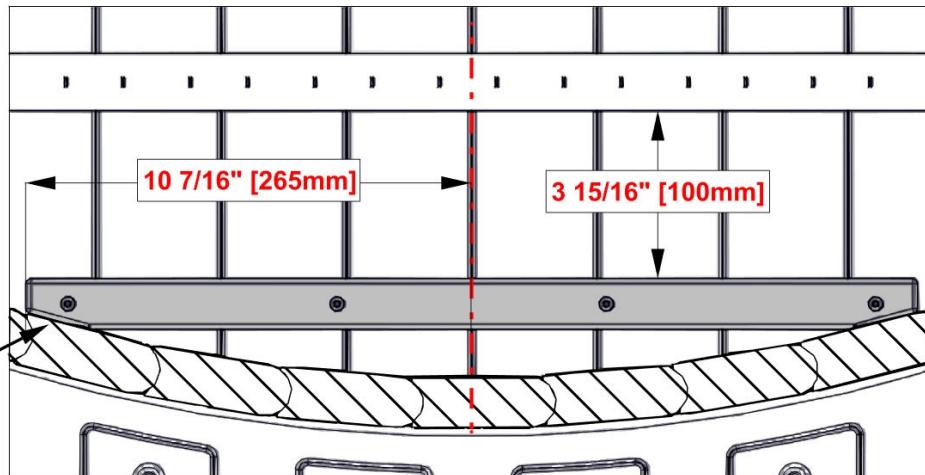
## STEP 18 - FLOOR CLEAT INSTALLATION

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 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.**



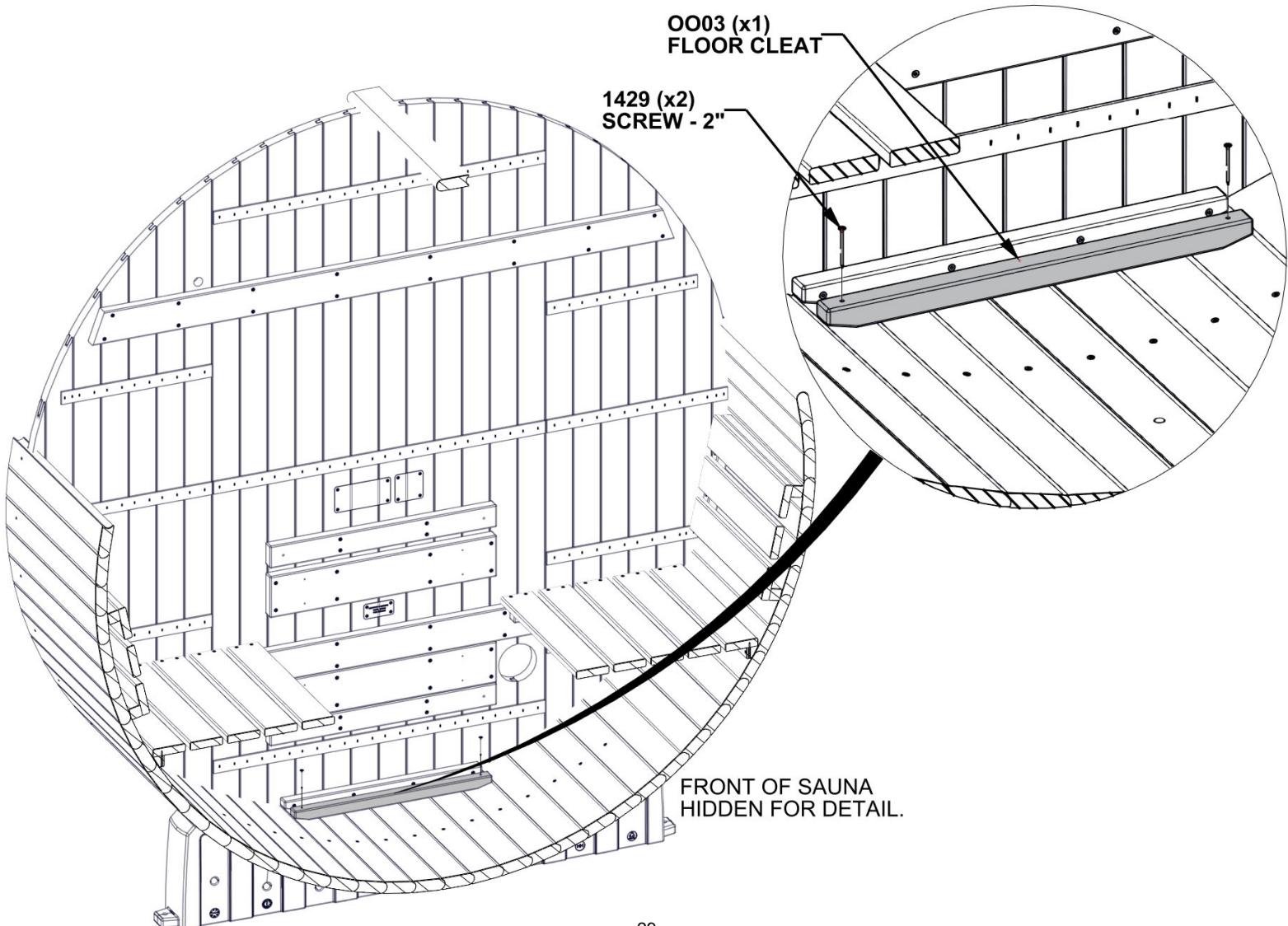
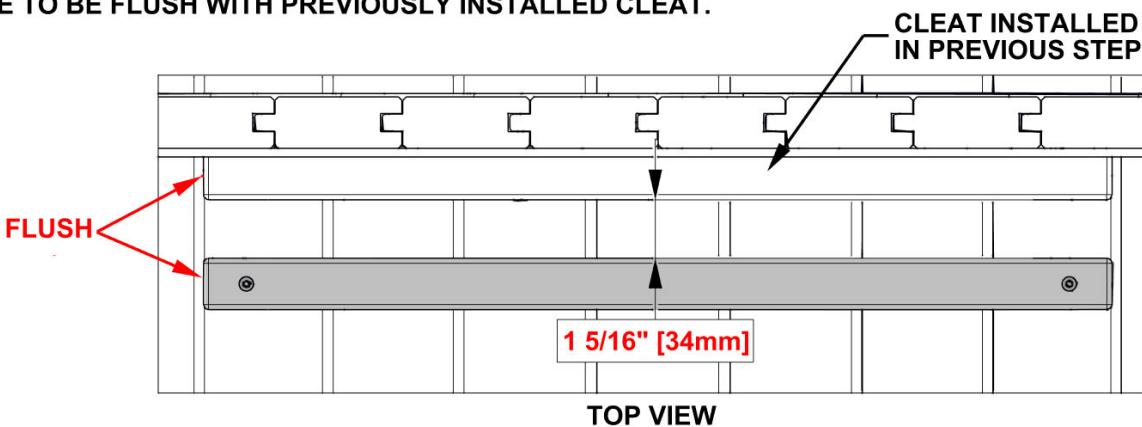
## STEP 19 - FLOOR CLEAT INSTALLATION

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

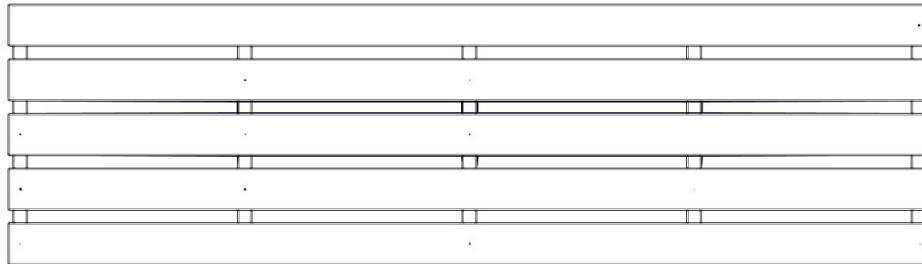


OO03 FLOOR CLEAT - W4L21964  
(x1) 1 3/16" x 1 3/16" x 20 7/8" (30x30x530)

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

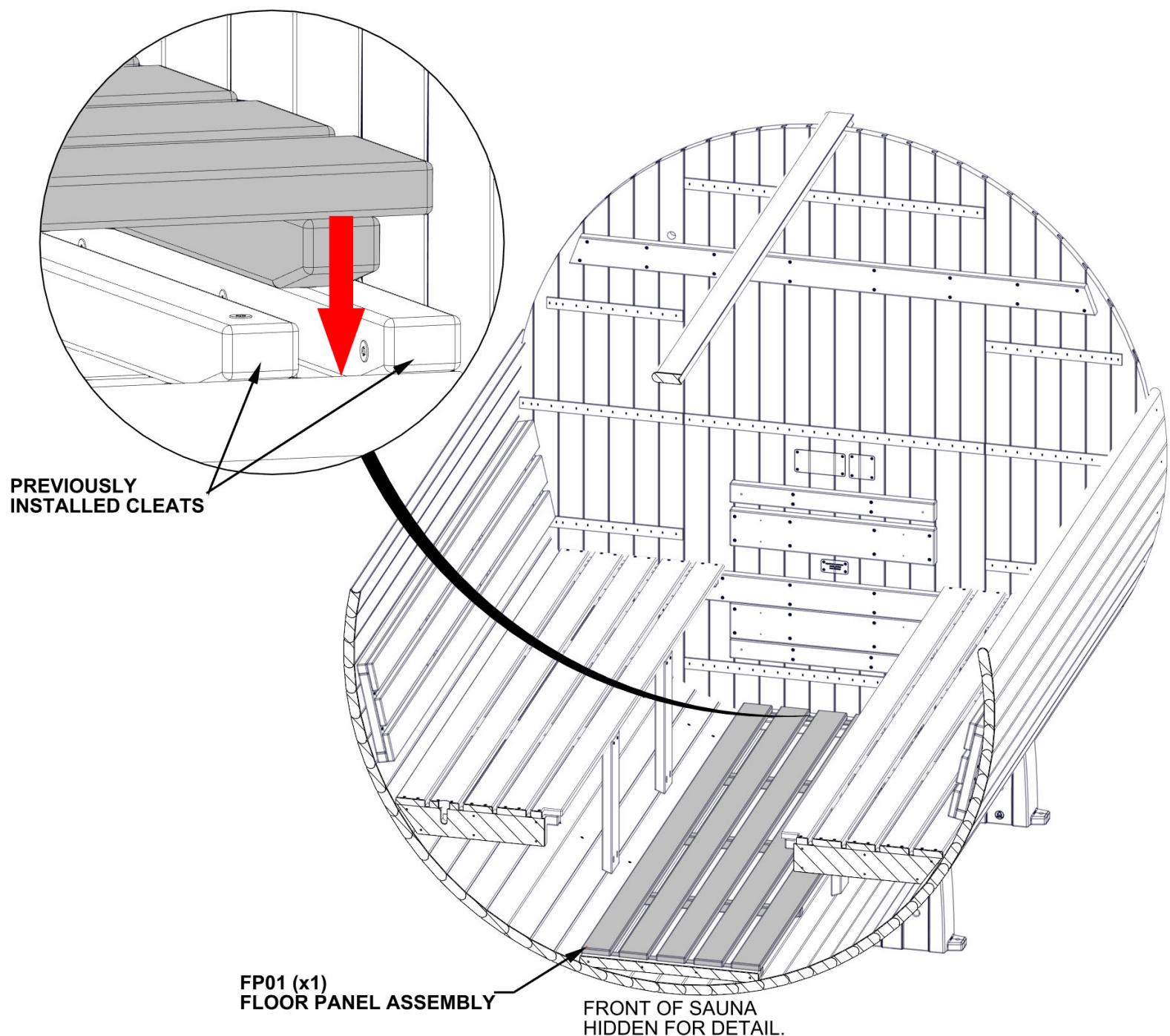


## STEP 20 - FLOOR INSTALLATION



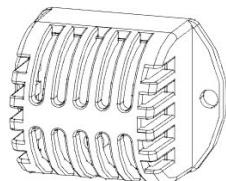
FP01 FLOOR PANEL ASSEMBLY - W2A04829  
(x1) 1 15/16" x 20 7/8" x 73 7/8" (50x530x1876)

- 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 21 - TEMPERATURE SENSOR INSTALLATION

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

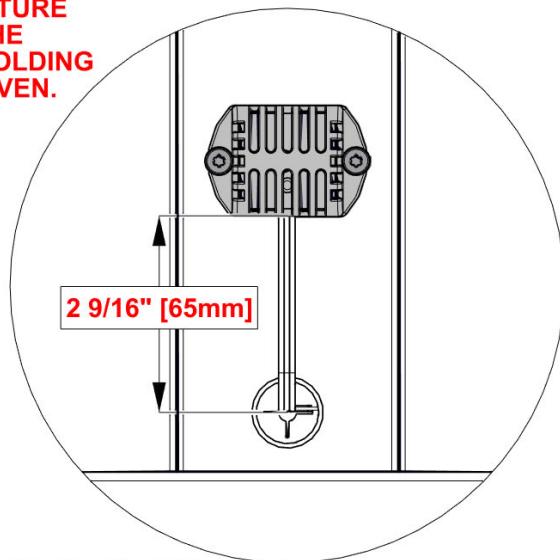


A4M05590-08 TEMPERATURE SENSOR (x1)



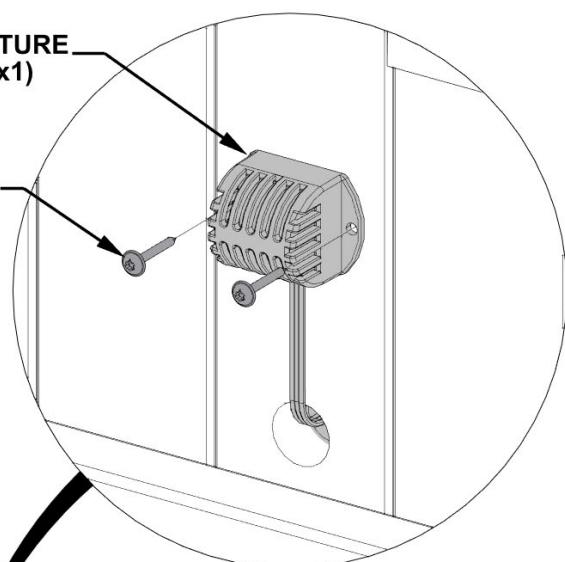
A6P01467 SILICON GROMMET 25mm (x1)

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

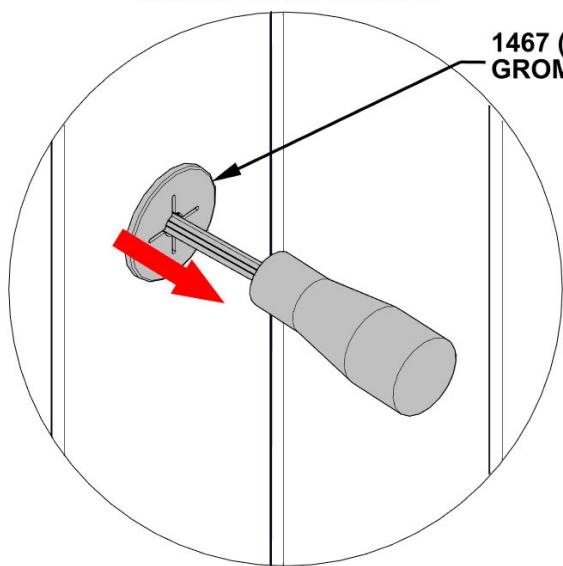


TEMPERATURE SENSOR (x1)

1440 (x2)  
SCREW - 1"

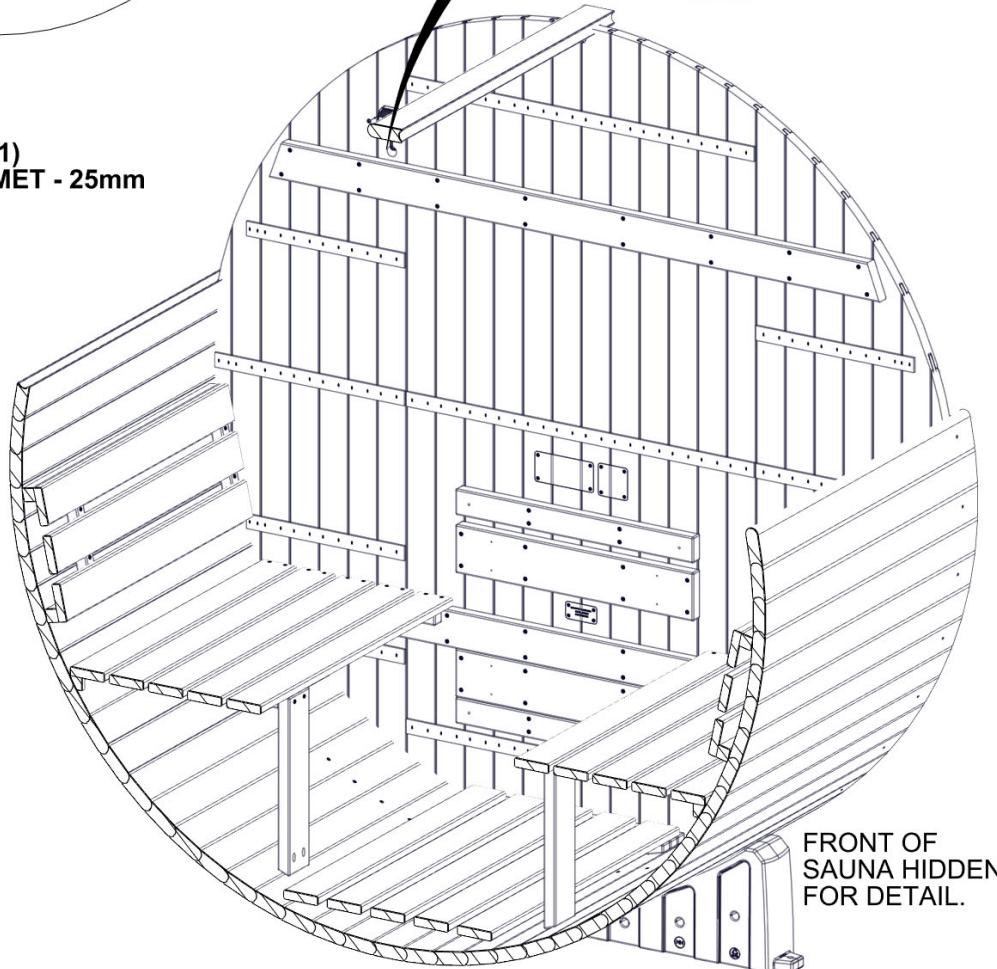


RUN CABLE THROUGH HOLE IN WALL PANEL AND THROUGH GROMMET AS SHOWN.



1467 (x1)  
GROMMET - 25mm

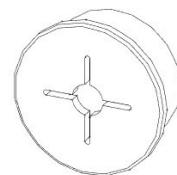
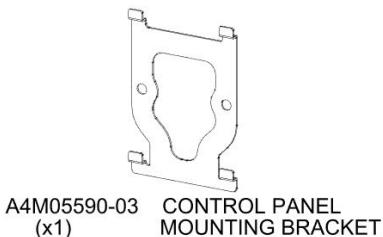
BACK VIEW



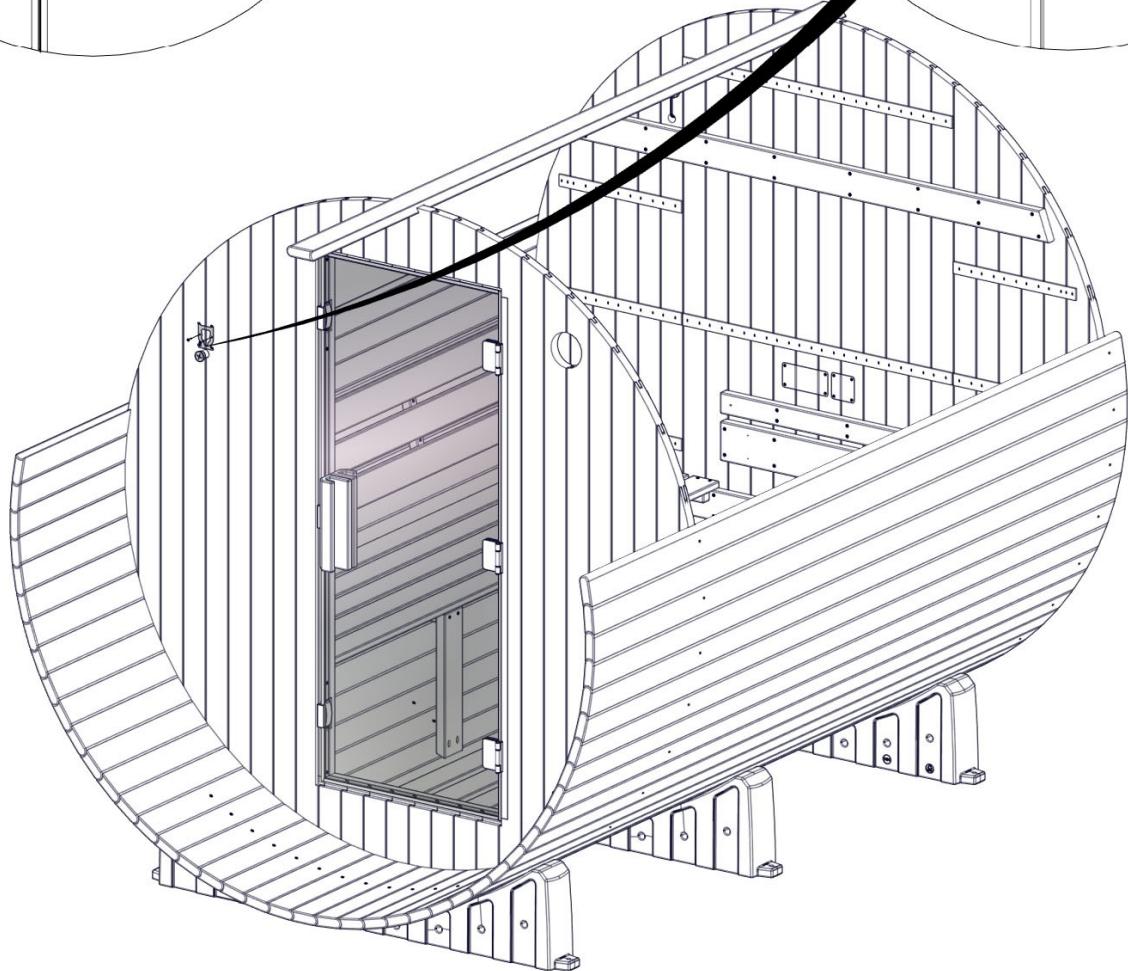
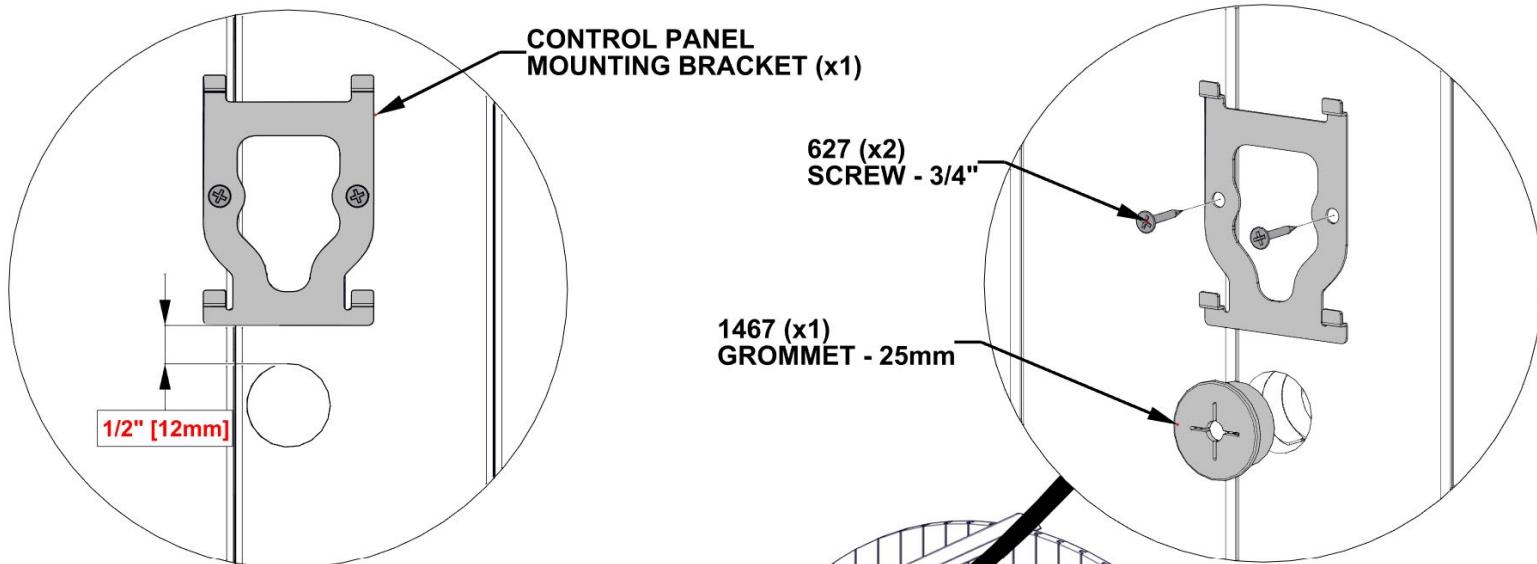
FRONT OF SAUNA HIDDEN FOR DETAIL.

## STEP 22 - CONTROL PANEL ASSEMBLY

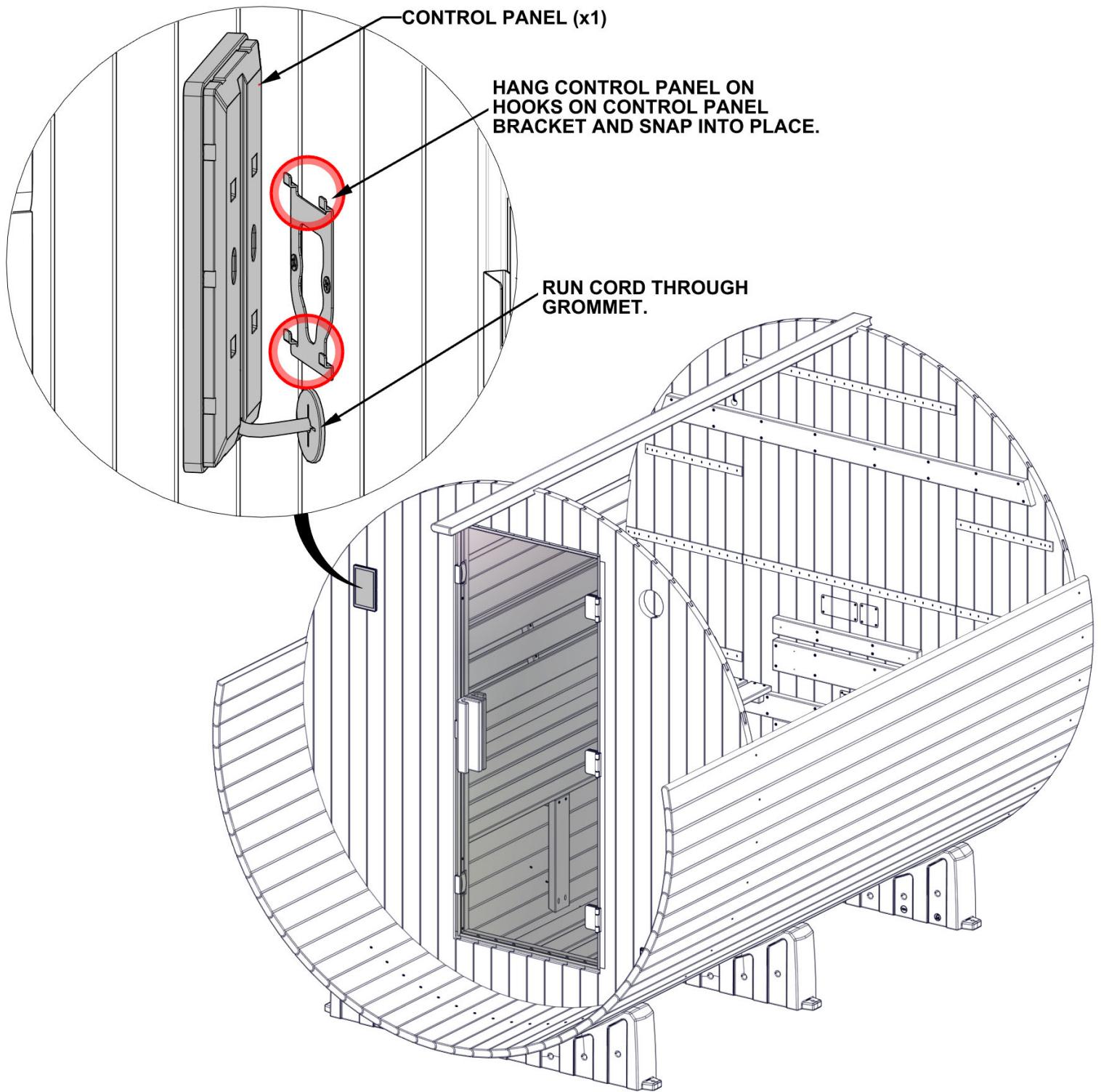
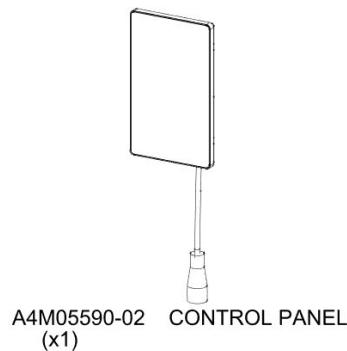
QTY	PART NUMBER	DESCRIPTION
2	H100627	SCREW PFH 6x3/4 BLK



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



## STEP 23 - CONTROL PANEL ASSEMBLY

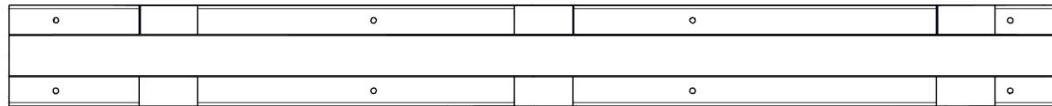


## STEP 24 - WIREWAY ASSEMBLY

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

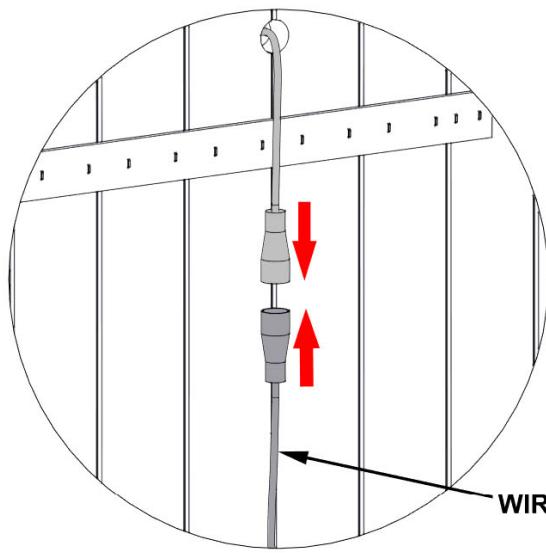


A4M05590-10 WIRING HARNESS (x1)

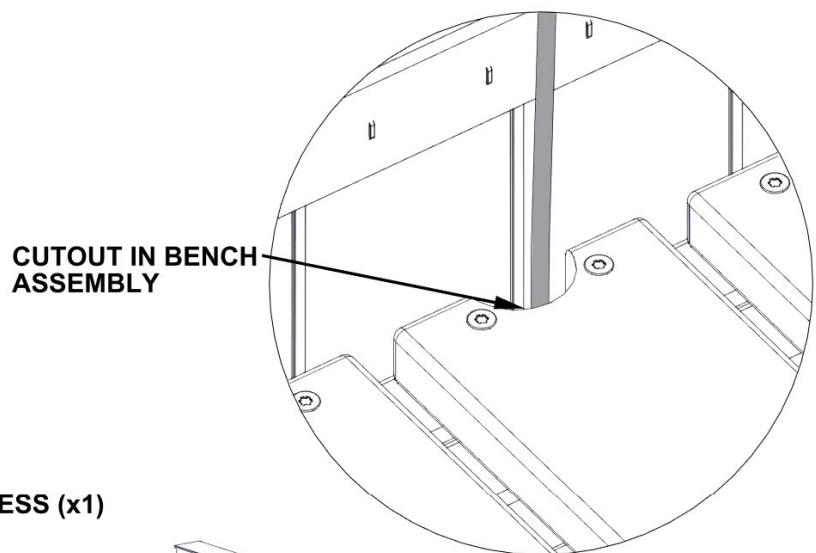


OG12 WIREWAY BOARD - W4L21999 (x1) 1 3/16" x 3 3/8" x 35 3/16" (30x86x894)

- 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.

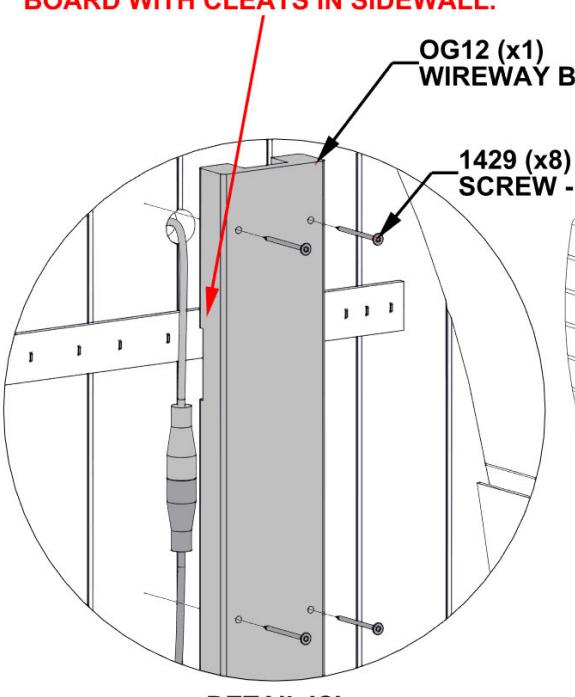


DETAIL 'A'

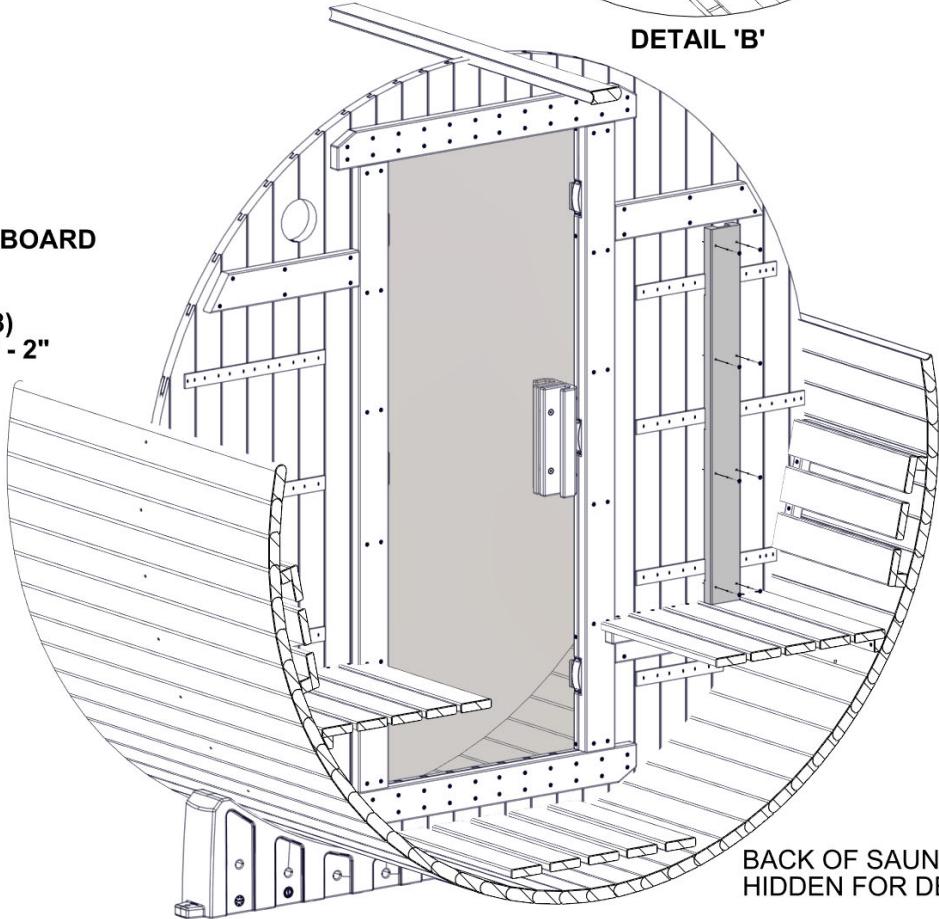


DETAIL 'B'

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



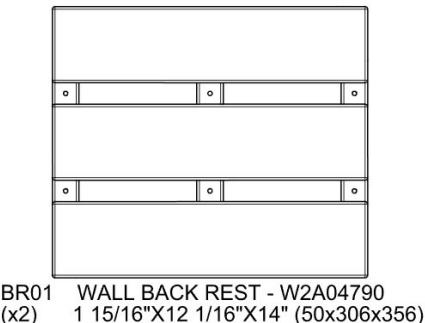
DETAIL 'C'



BACK OF SAUNA HIDDEN FOR DETAIL.

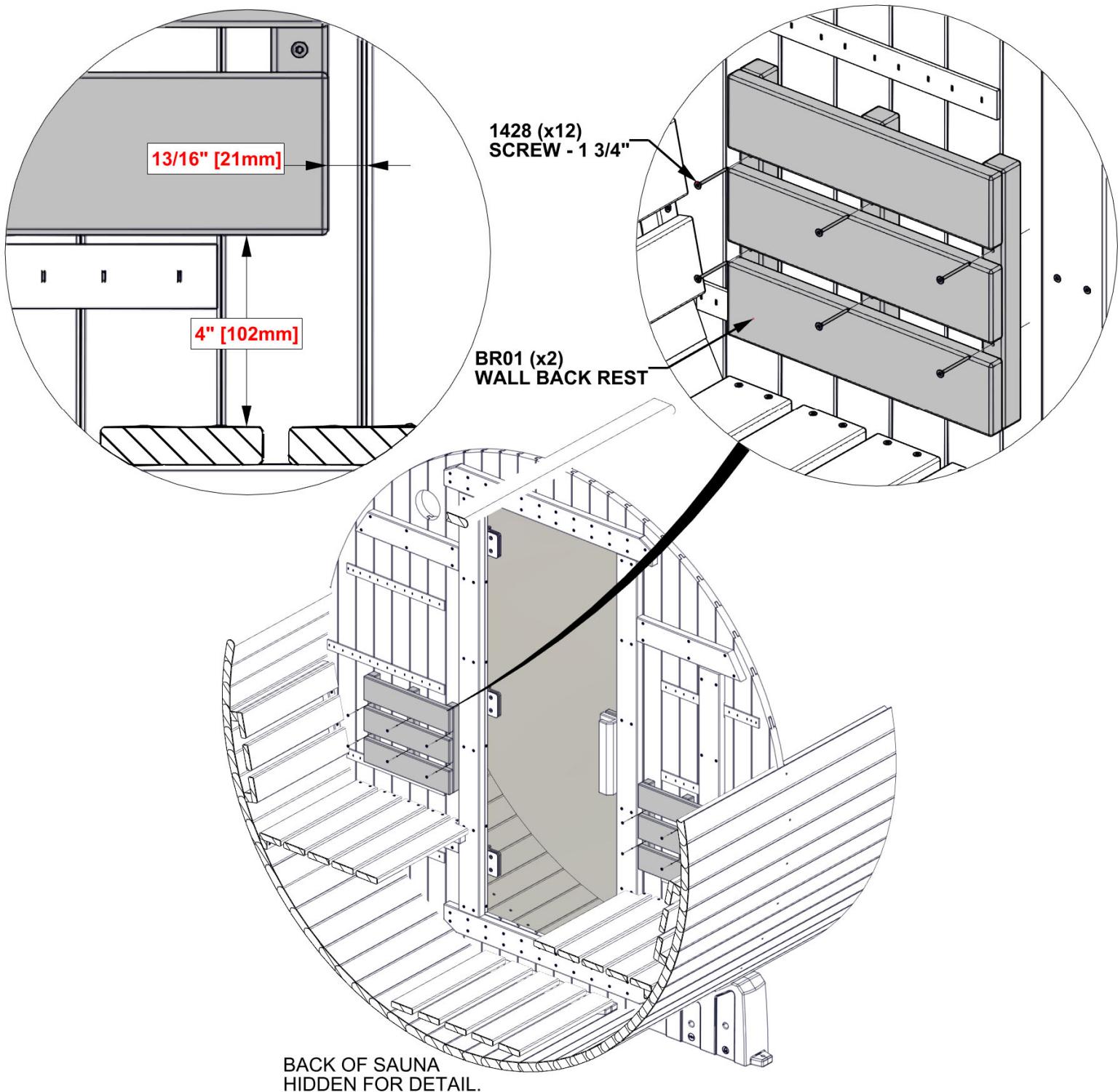
## STEP 25 - BACK REST ASSEMBLY

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.

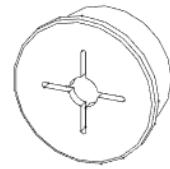


## STEP 26 - WIREWAY ASSEMBLY

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

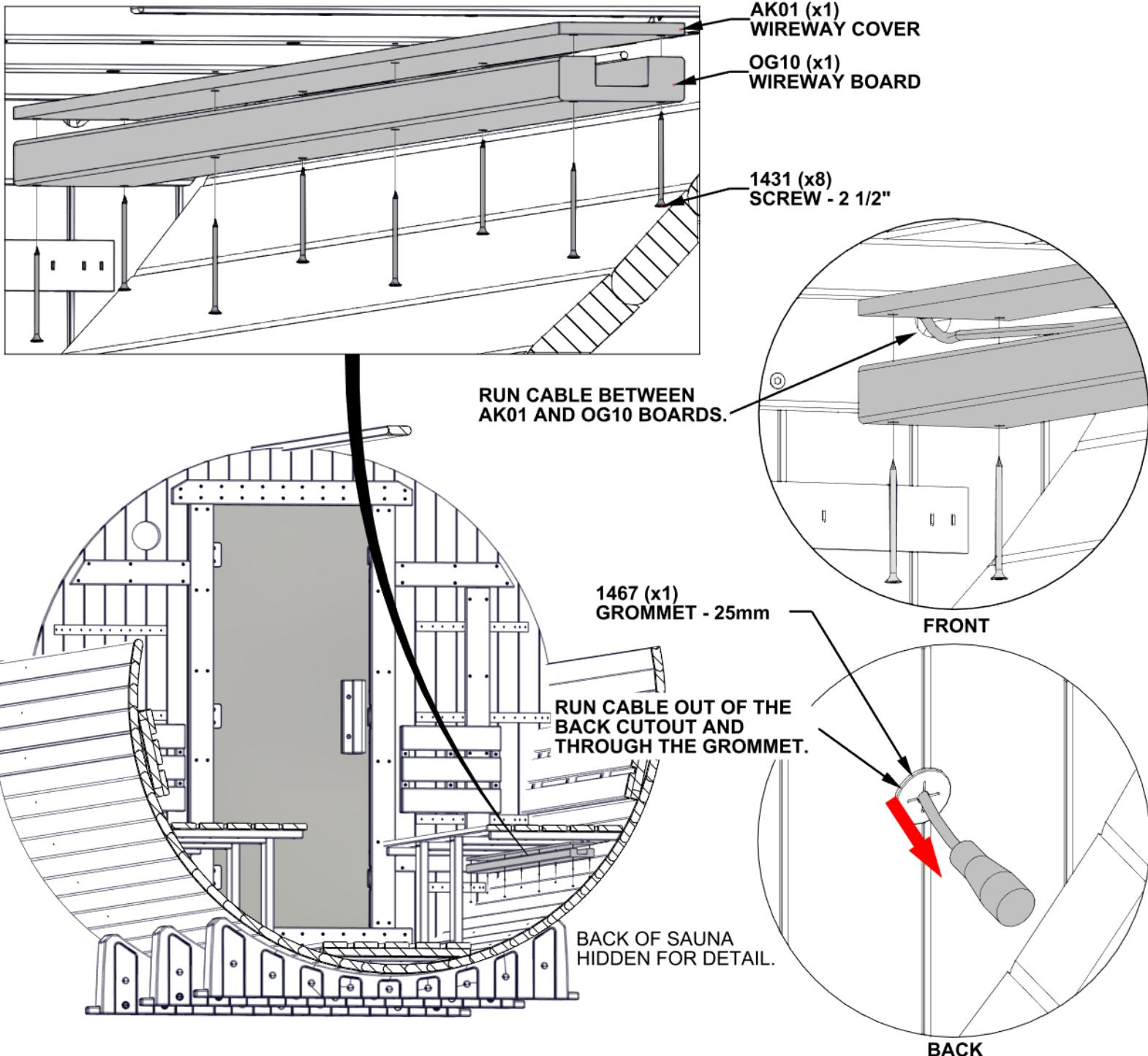
AK01 WIREWAY COVER - W4L22562  
(x1) 5/16"x3 3/8"x73" (8x86x1854)

OG10 WIREWAY BOARD - W4L22561  
(x1) 1 3/16"x3 3/8"x73" (30x86x1854)



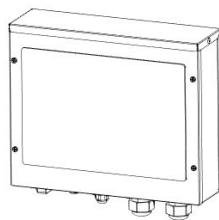
A6P01467 (x1) SILICONE GROMMET 25mm

- RUN CABLE BETWEEN AK01 AND OG10.
- ENSURE CABLE RUNS IN CHANNELLED 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.
- BE CAUTIOUS WHEN INSERTING SCREWS TO PREVENT PINCHING OR PENETRATING CORDS.



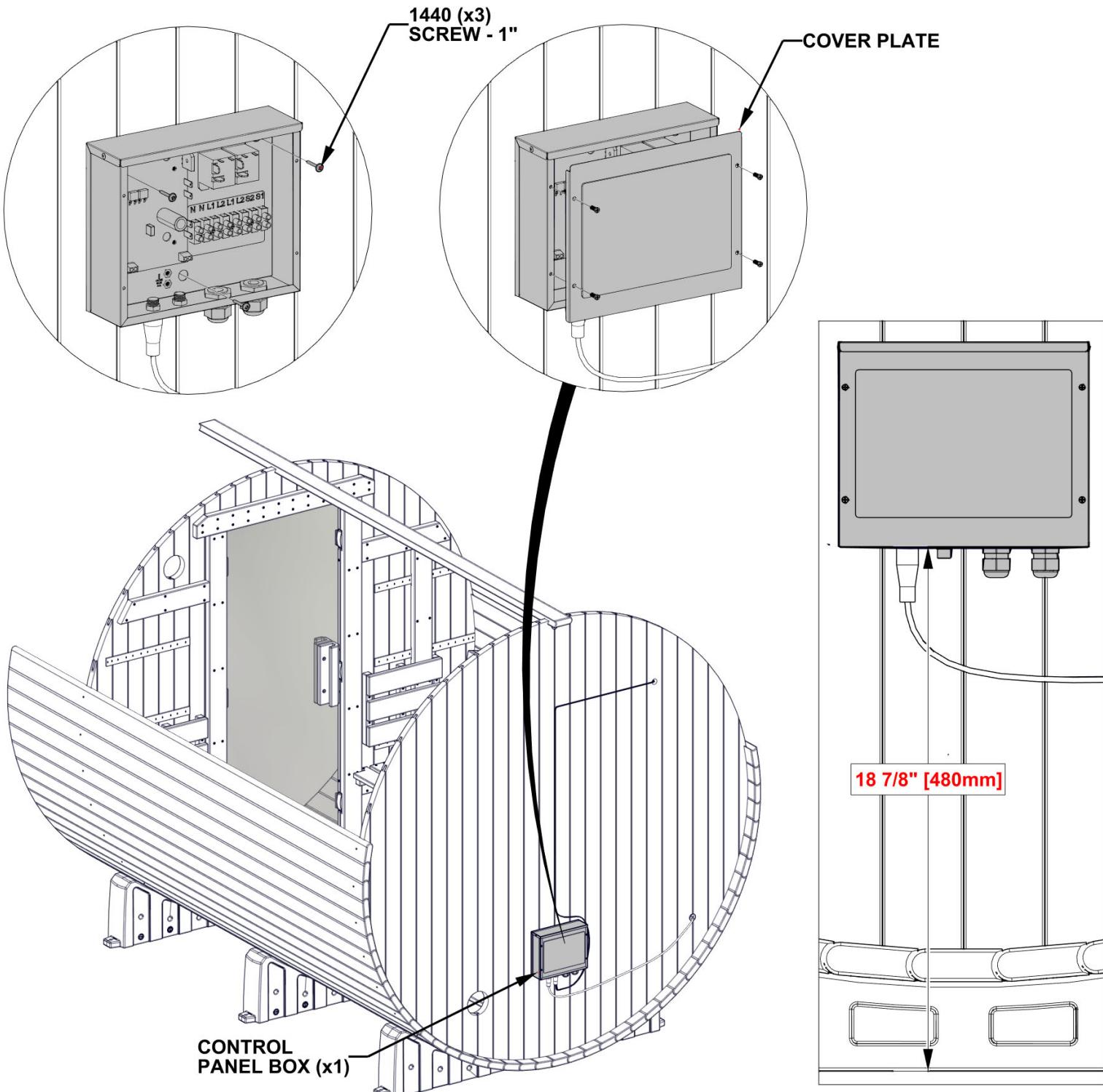
## STEP 27 - CONTROL PANEL INSTALLATION

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



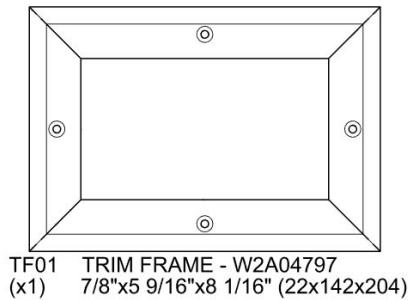
A4M05590-01 CONTROL PANEL BOX  
(x1)

- 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



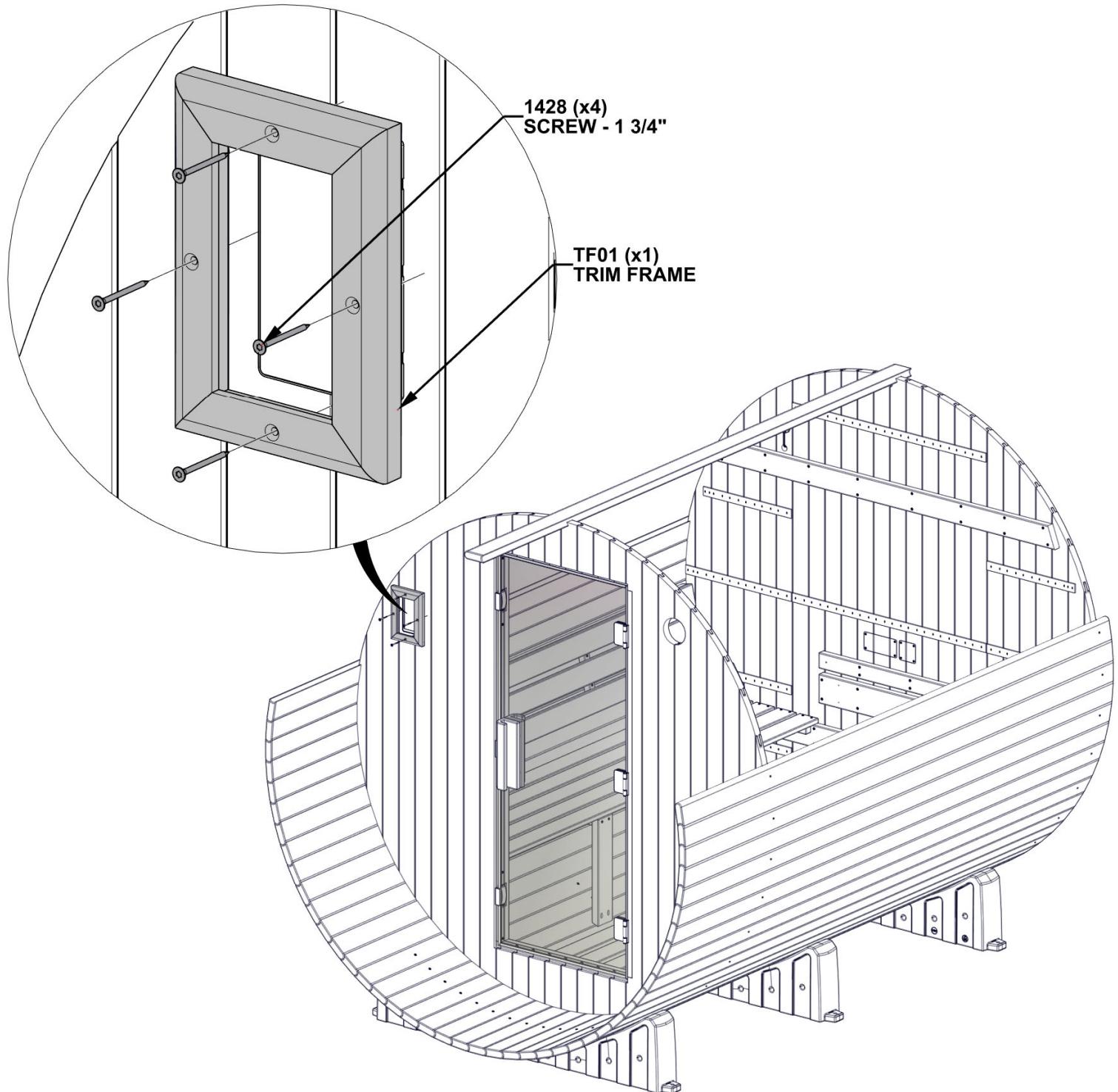
## STEP 28 - CONTROL PANEL ASSEMBLY

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



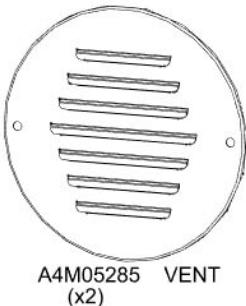
TF01 TRIM FRAME - W2A04797  
(x1) 7/8" x 5 9/16" x 8 1/16" (22x142x204)

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



## STEP 29 - VENT ASSEMBLY

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

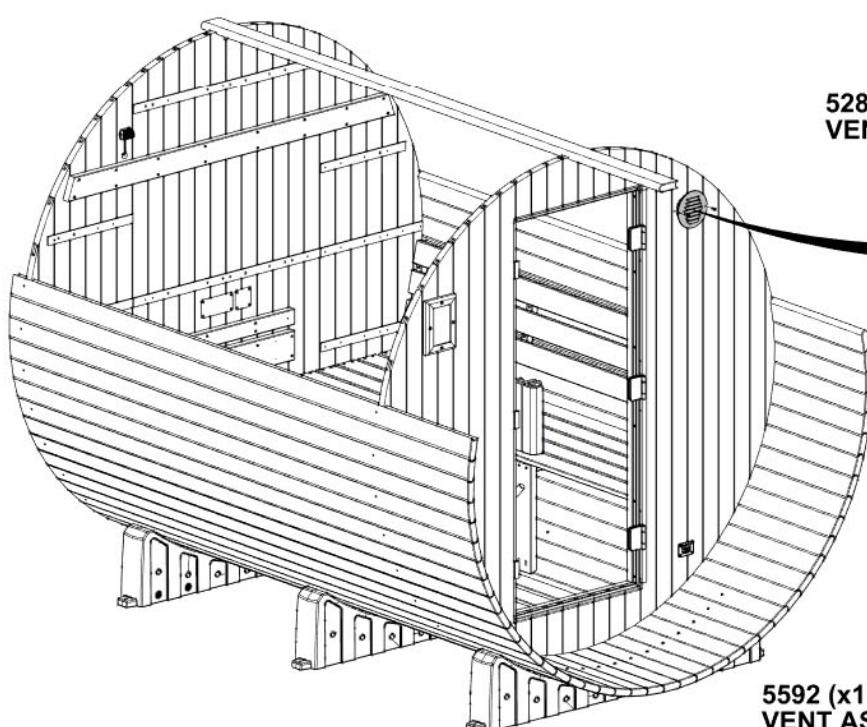


A4M05285 VENT  
(x2)



A4M05592 VENT COVER  
(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.

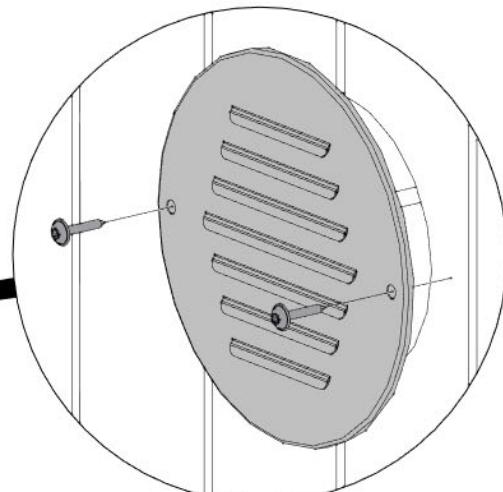
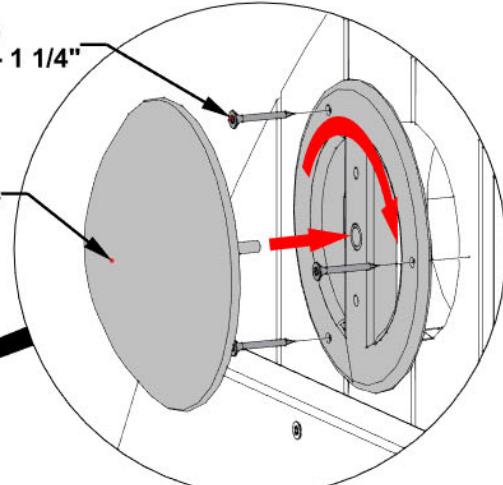
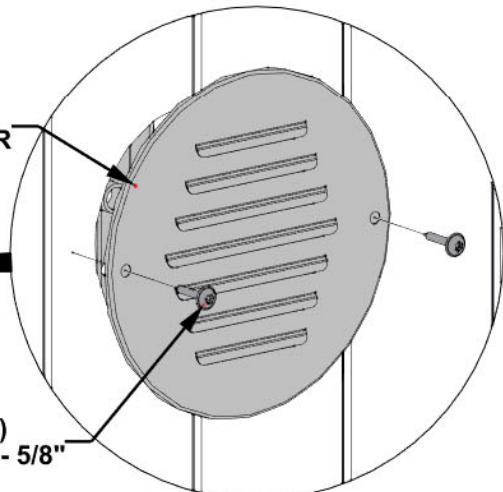
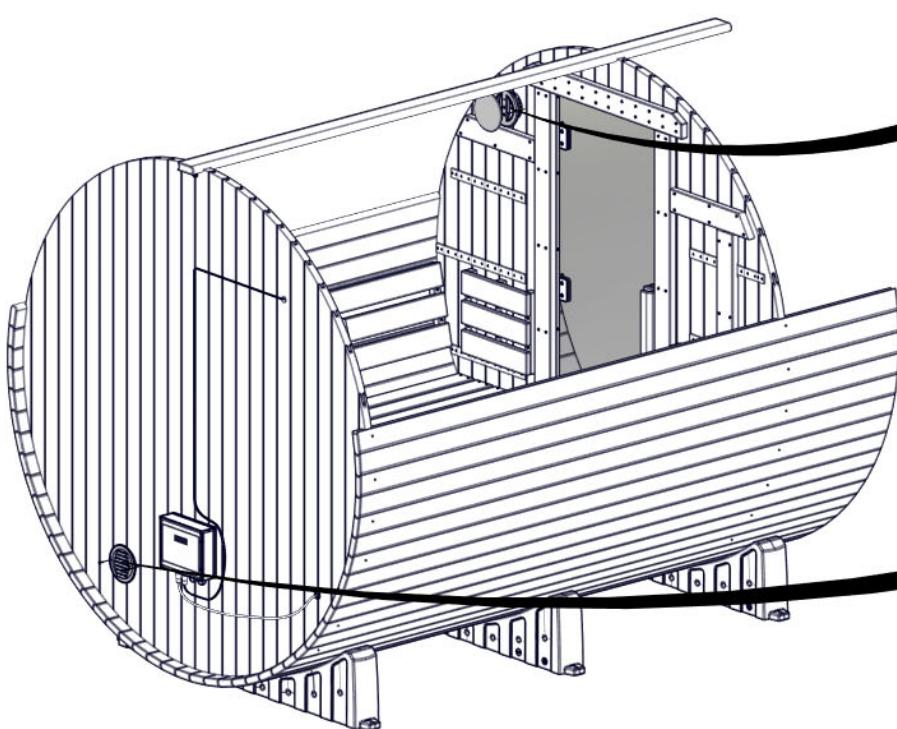


5285 (x2)  
VENT COVER

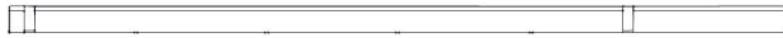
1437 (x4)  
SCREW - 5/8"

1426 (x3)  
SCREW - 1 1/4"

5592 (x1)  
VENT ASSEMBLY



## STEP 30 - BARREL ASSEMBLY

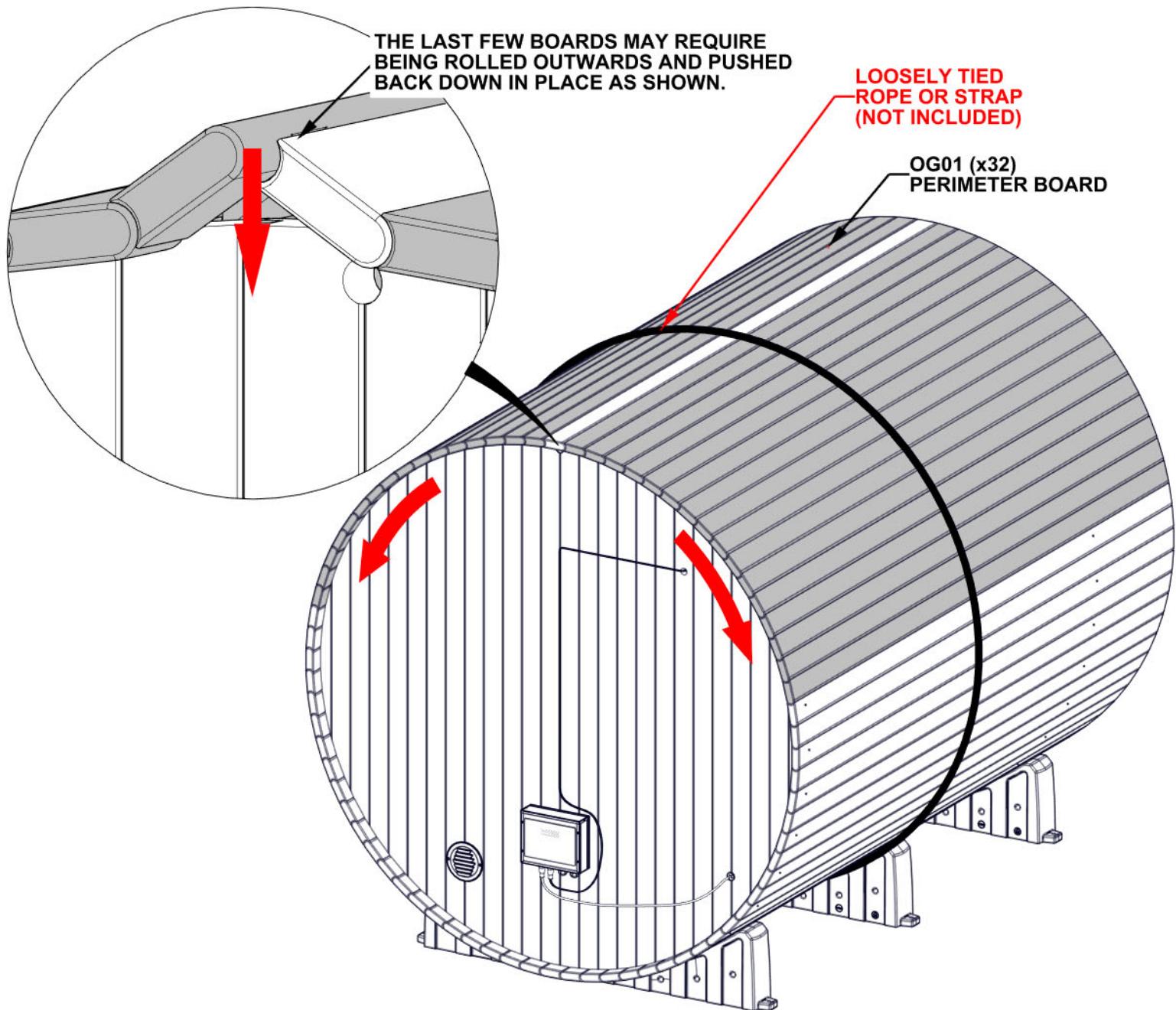


OG01 PERIMETER BOARD - W4L21988  
(x32) 1 3/16" x 3 3/8" x 99 15/16" (30x86x2538)

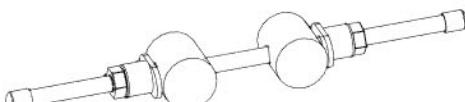


BOARD SPACER KIT - W2A04961  
(x1)

- 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 SOME SPACER BOARDS, FROM THE BOARD SPACER KIT, WILL BE NEEDED TO FILL ANY GAPS BETWEEN THE PERIMETER BOARDS FOR A SNUG FIT.



# STEP 31 - BARREL ASSEMBLY

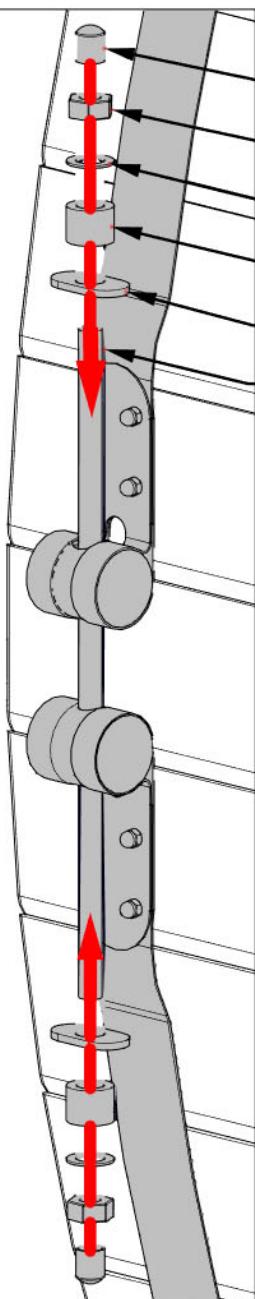


A4M05671 STRAPPING CINCH  
(x4)



A4M05277 STRAPPING  
(x4)

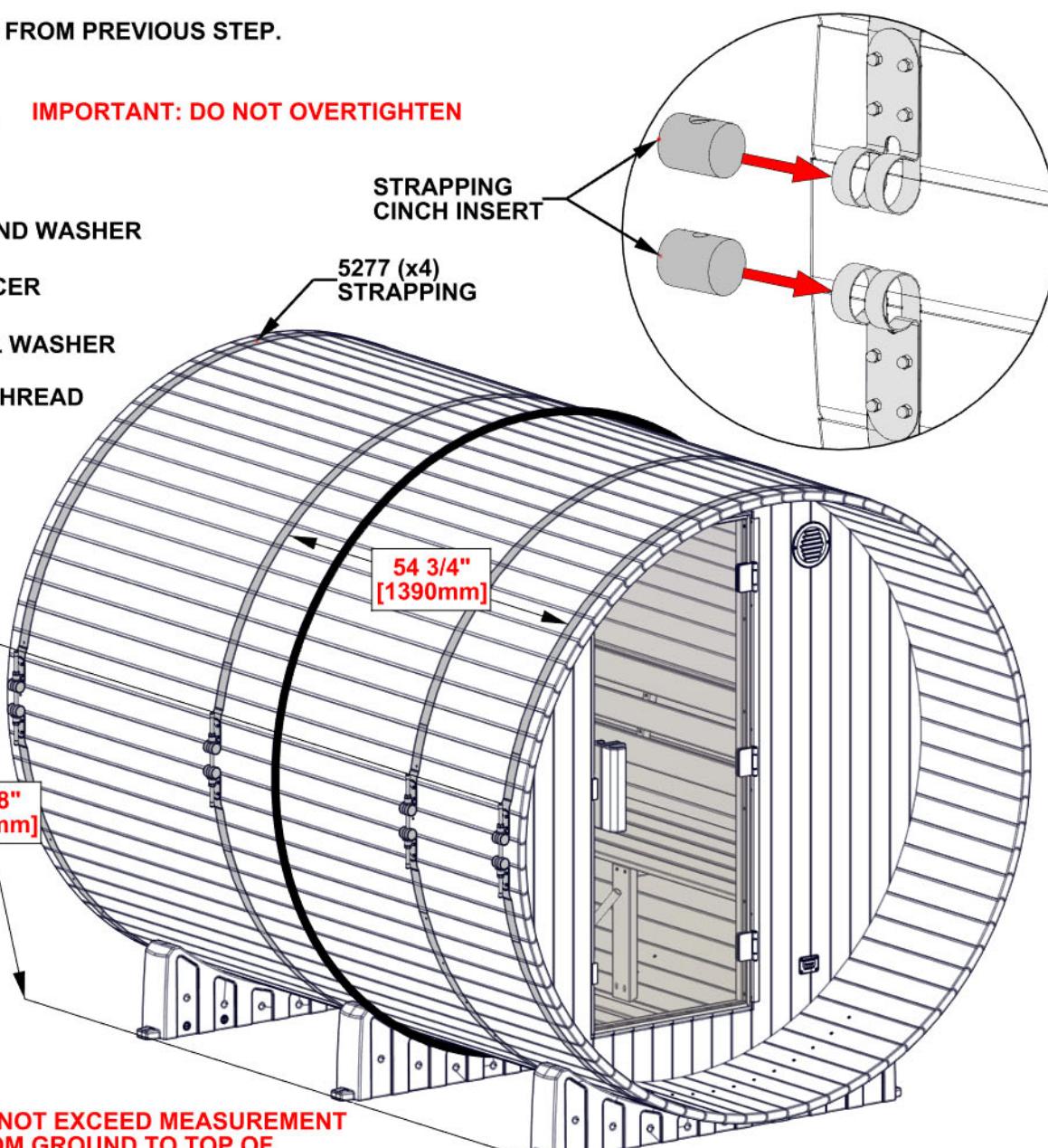
- WRAP STRAPPING AROUND SAUNA AS SHOWN.
- POSITION TWO STRAPS TO COVER THE NAILS INSTALLED IN STEP 11.
- THE THIRD STRAP WILL BE LOCATED 2" [50mm] FROM THE FRONT EDGE OF THE SAUNA, AND THE FOURTH WILL BE LOCATED 54 3/4" [1390mm] FROM THAT STRAP AS SHOWN. OTHERWISE STRAPPING MAY INTERFERE WITH ROOF SHEET SCREWS.
- INSERT STRAPPING CINCH INSERTS INTO THE EYES ON STRAPPING.
- INSERT THE ALL THREAD THROUGH THE INSERTS AND CONNECT HARDWARE AS SHOWN.
- BEFORE TIGHTENING, VERIFY STRAPPING IS PROPERLY POSITIONED AND STRAIGHT.
- THE STRAPPING CINCHES CAN BE EITHER ALIGNED OR STAGGERED BASED ON PERSONAL PREFERENCE.
- TIGHTEN ALL NUTS EVENLY.
- REMOVE ROPE/STRAP IF USED FROM PREVIOUS STEP.



IMPORTANT: DO NOT OVERTIGHTEN

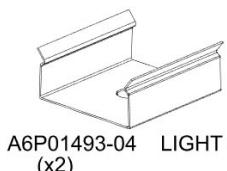
STRAPPING CINCH INSERT

5277 (x4)  
STRAPPING

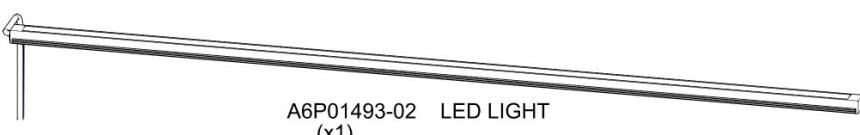


## STEP 32 - LIGHT ASSEMBLY

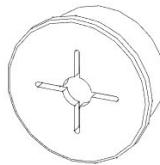
QTY	PART NUMBER	DESCRIPTION
2	H101437	SCREW TWH 8x5/8 SS-BLK



A6P01493-04 LIGHT CLIP (x2)

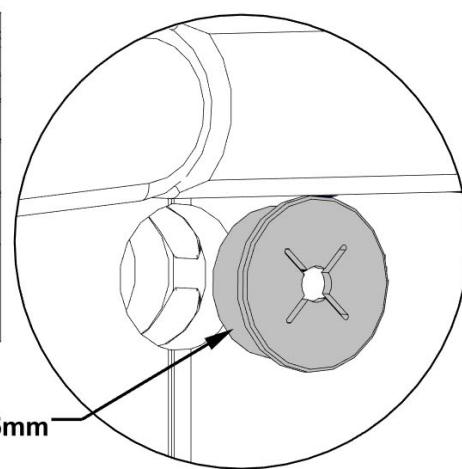
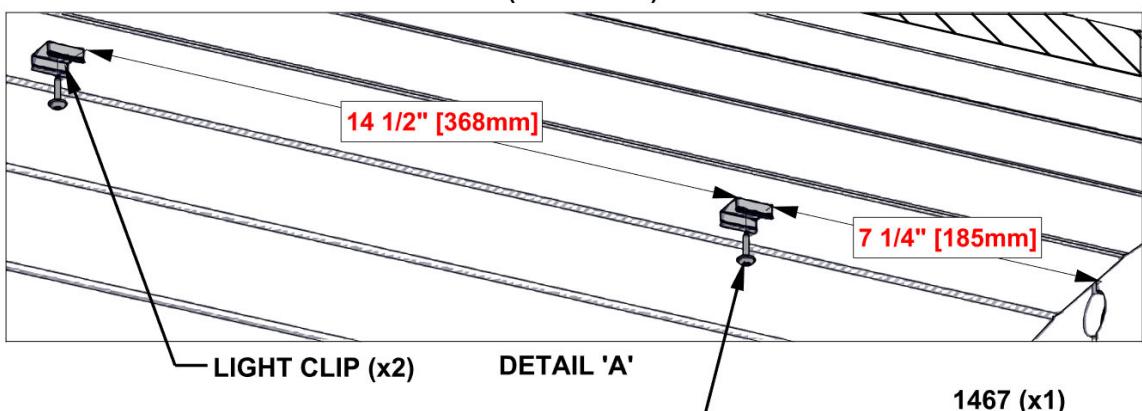


A6P01493-02 LED LIGHT (x1)

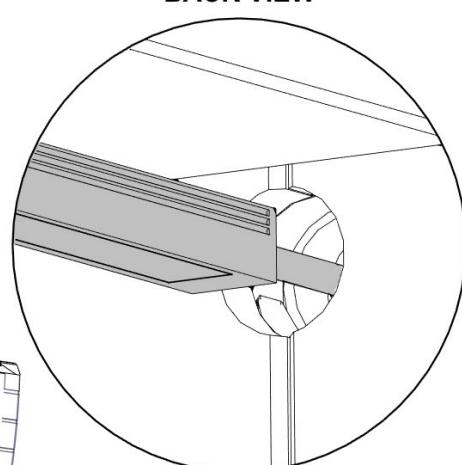
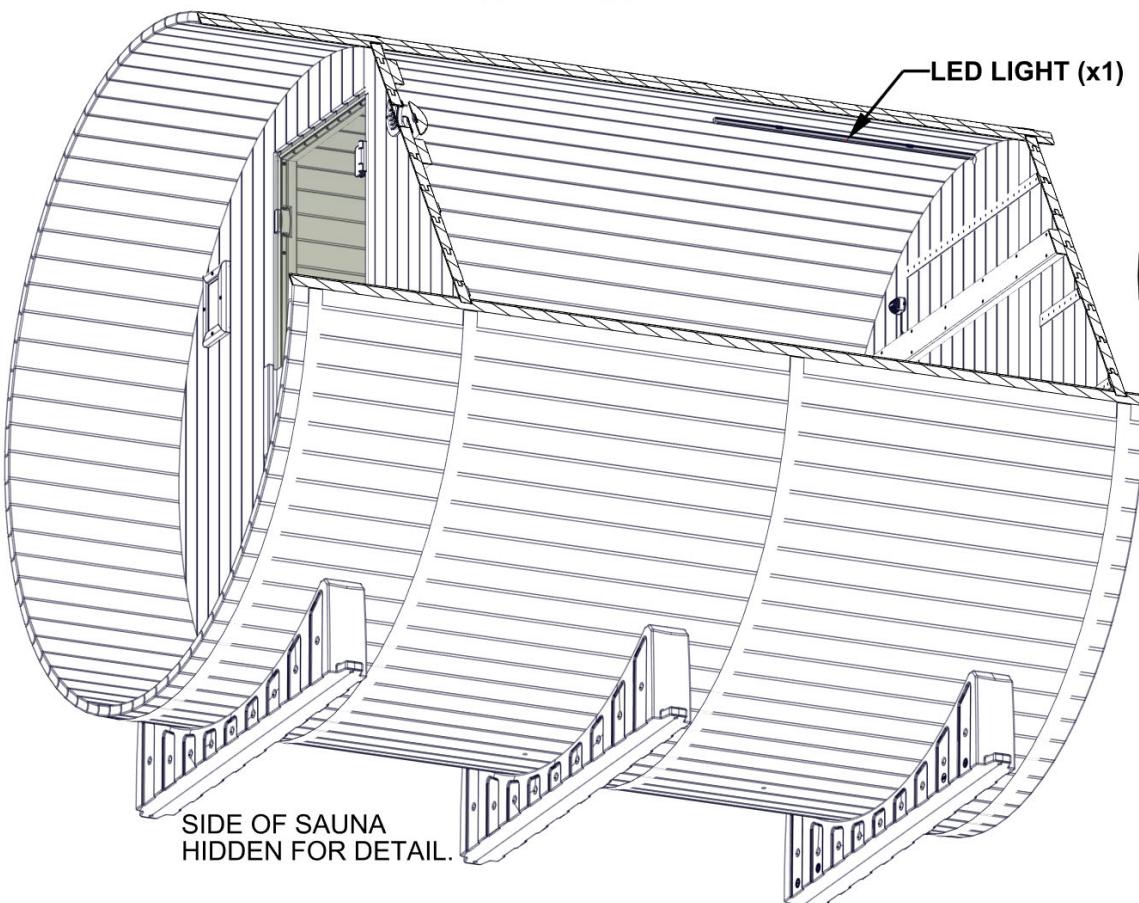


A6P01467 SILICONE GROMMET 25mm (x1)

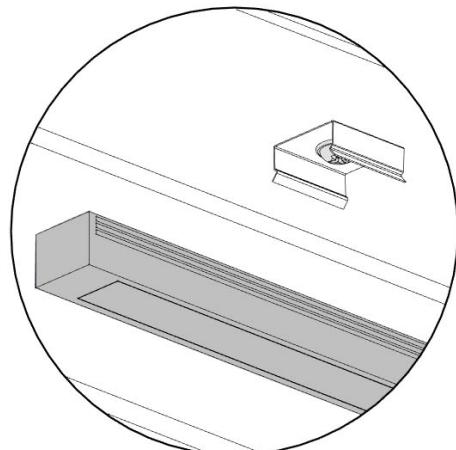
- INSTALL GROMMET IN THE TOP OF THE BACK WALL PANEL ASSEMBLY AS SHOWN.
- INSTALL CLIPS ON THE TOP CENTER BOARD AS SHOWN USING APPROXIMATE DIMENSIONS. (DETAIL 'A')
- THREAD CORD THROUGH CUTOUT AND GROMMET. (DETAIL 'B')
- SNAP LED LIGHT INTO LIGHT CLIPS. (DETAIL 'C')



BACK VIEW



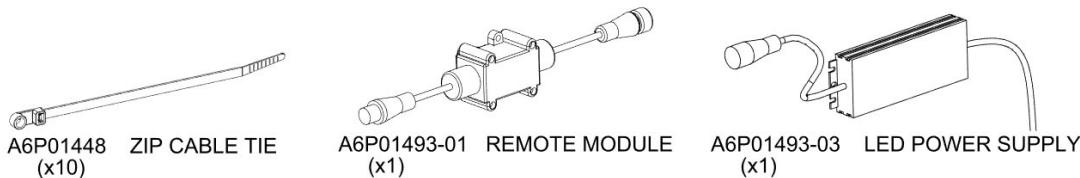
DETAIL 'B'



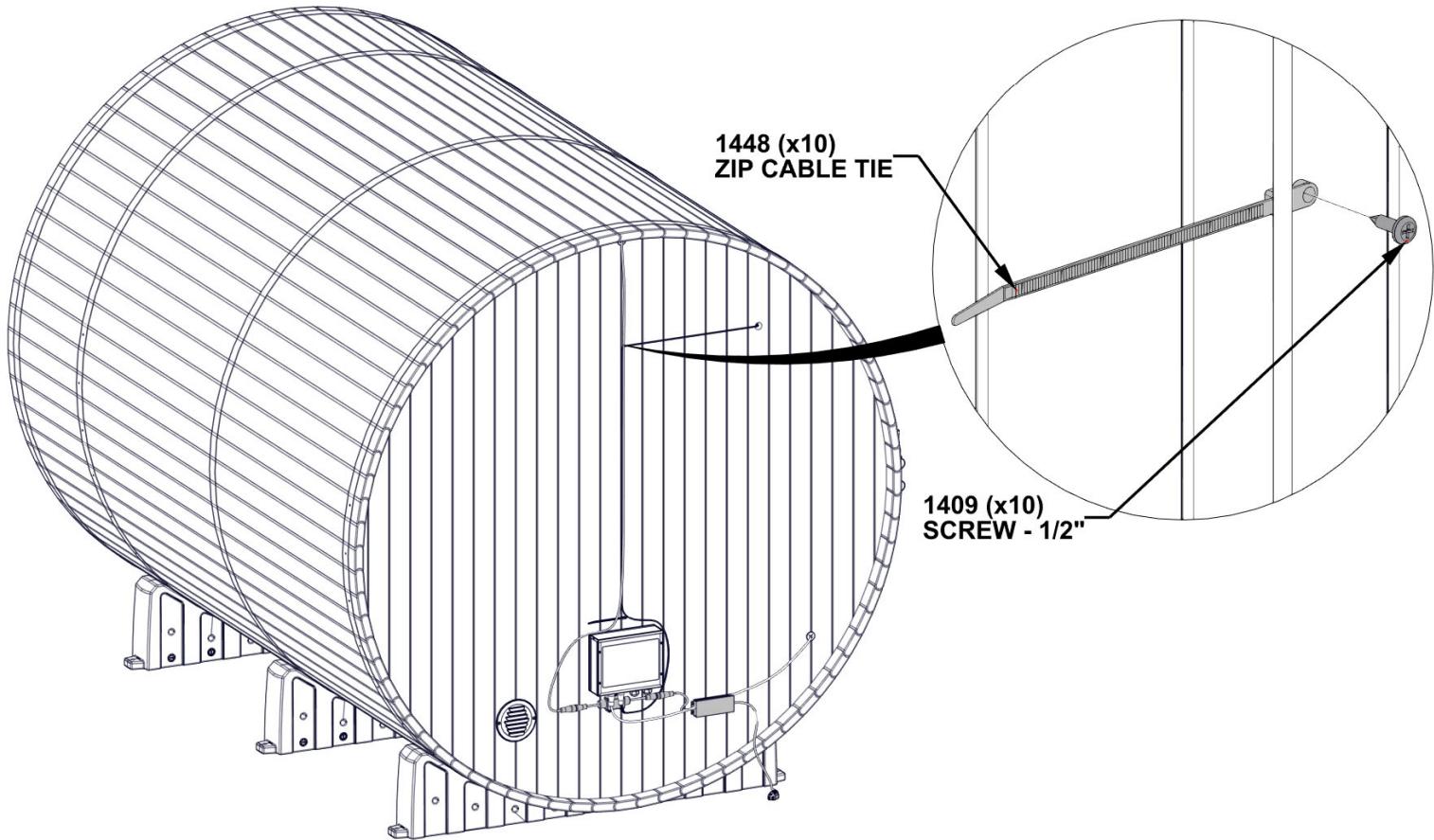
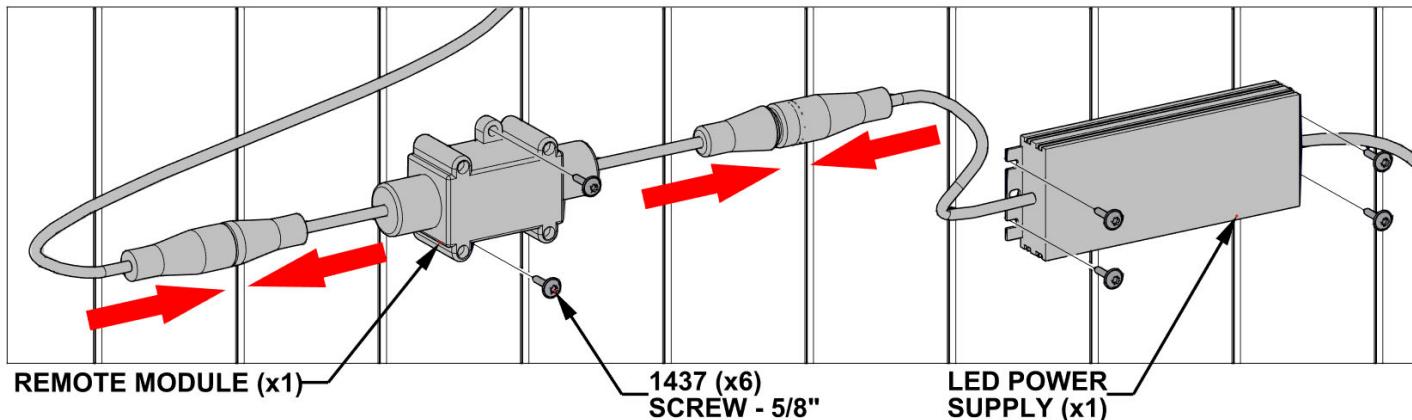
DETAIL 'C'

## STEP 33 - ELECTRICAL

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

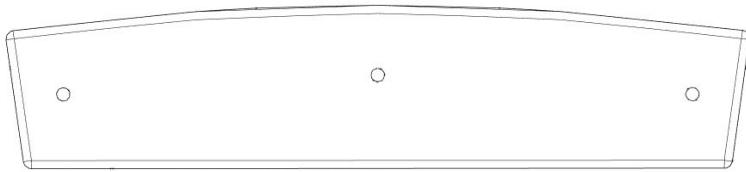


- LOCATE REMOTE MODULES AND POWER SUPPLIES IN APPROXIMATE LOCATIONS.
- ENSURE REMOTE MODULES AND POWER SUPPLIES ARE ORIENTED HORIZONTALLY WHEN ATTACHING.
- USE ZIP TIES WHERE NEEDED TO ATTACH AND ORGANIZE CORDS.

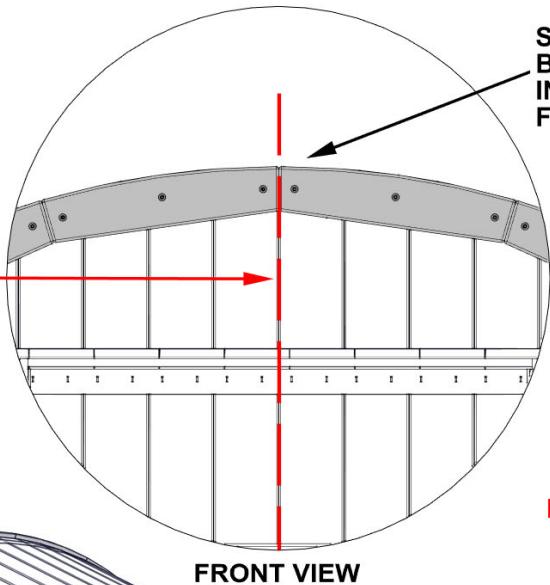


## STEP 34 - TRIM ASSEMBLY

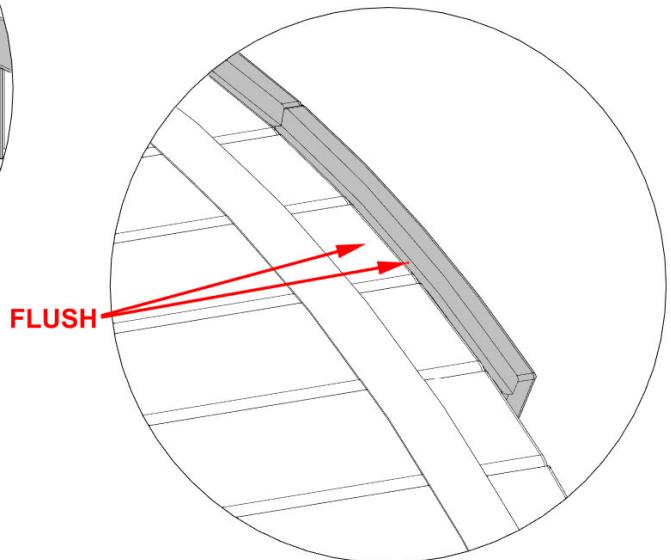
QTY	PART NUMBER	DESCRIPTION
60	H101429	SCREW TFH 8X2 SS-BLK



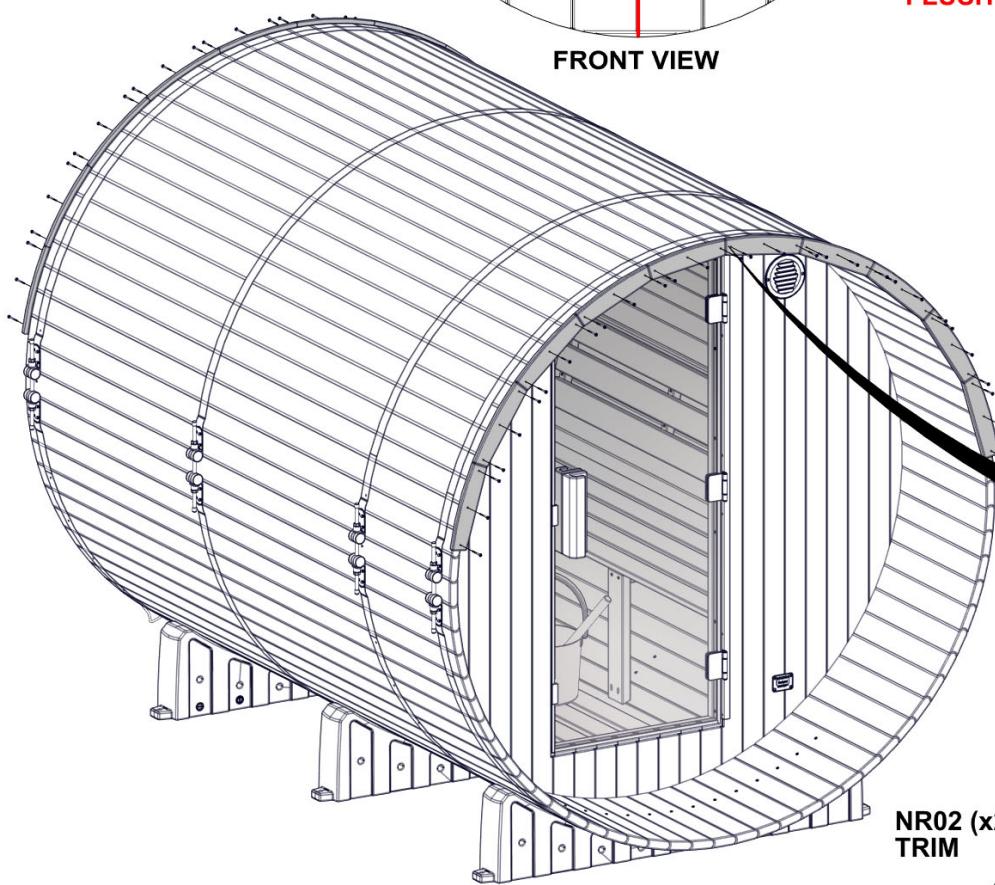
NR02 TRIM - W4L21866  
(x20) 13/16"x2 3/8"x10 15/16" (20x60x278)



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

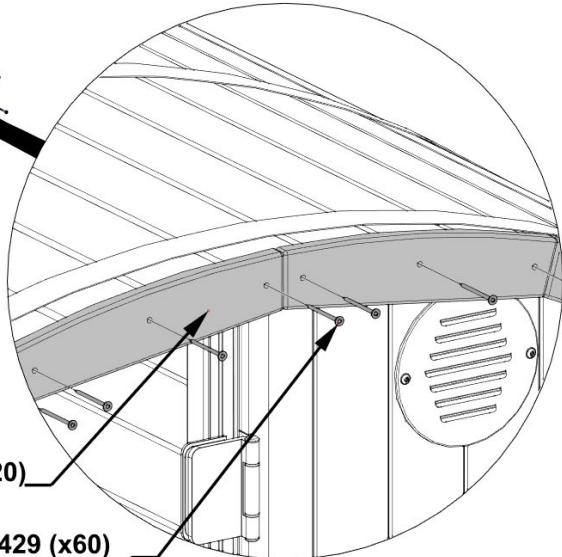


FLUSH



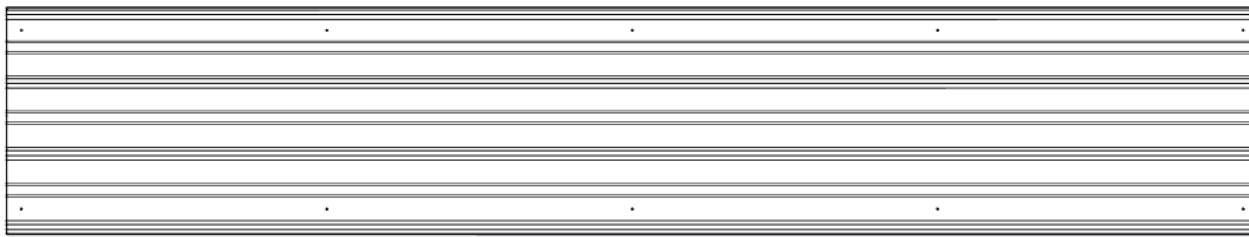
NR02 (x20)  
TRIM

1429 (x60)  
SCREW - 2"



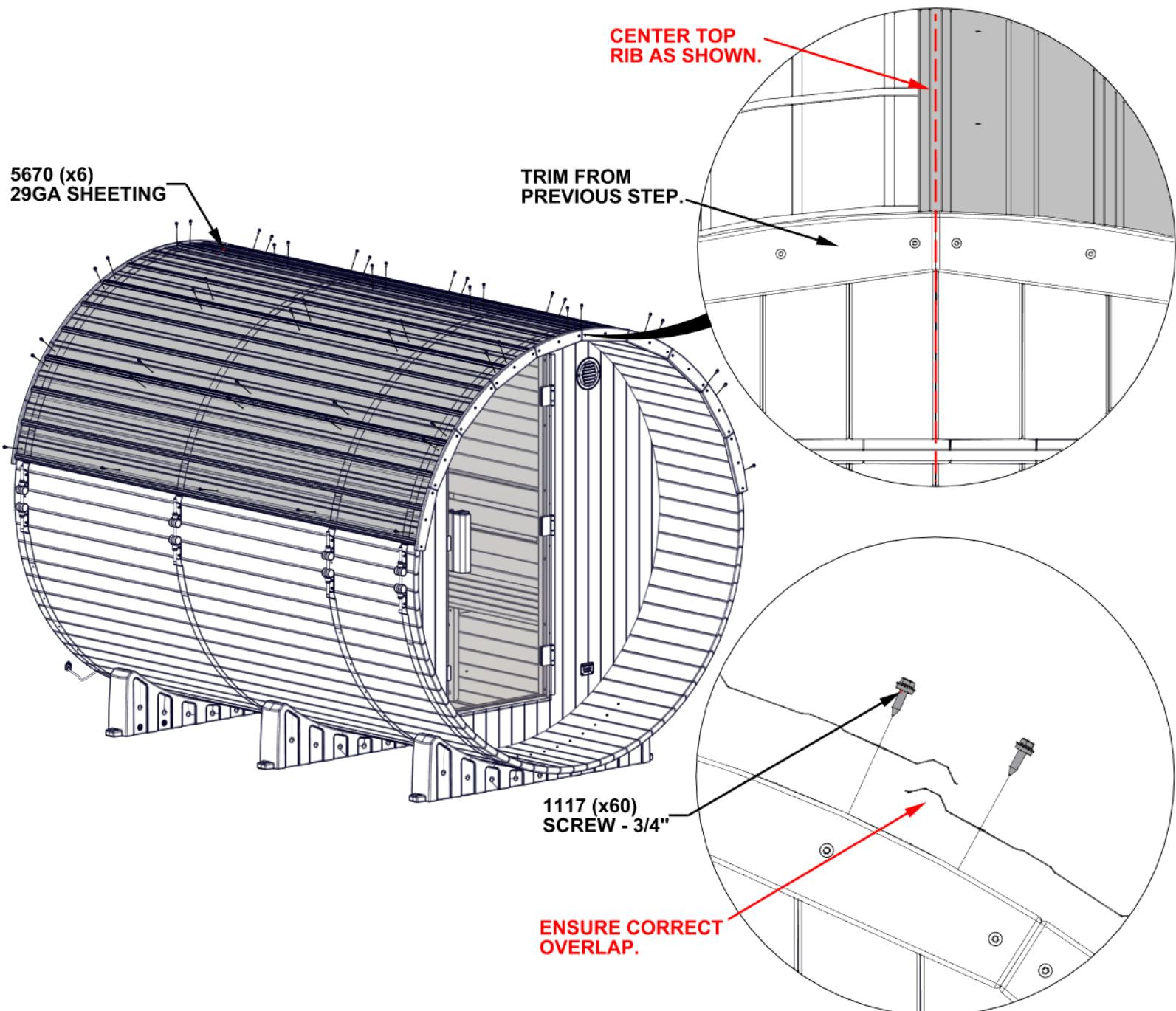
# STEP 35 - ROOF ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
60	H101117	SCREW WOODGRIP 10-16x3/4" BLK



A4M05670 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 36 - HEATER GUARD ASSEMBLY

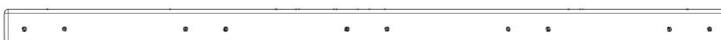
QTY	PART NUMBER	DESCRIPTION
20	H101428	SCREW TFH 8X1 3/4 SS-BLK



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

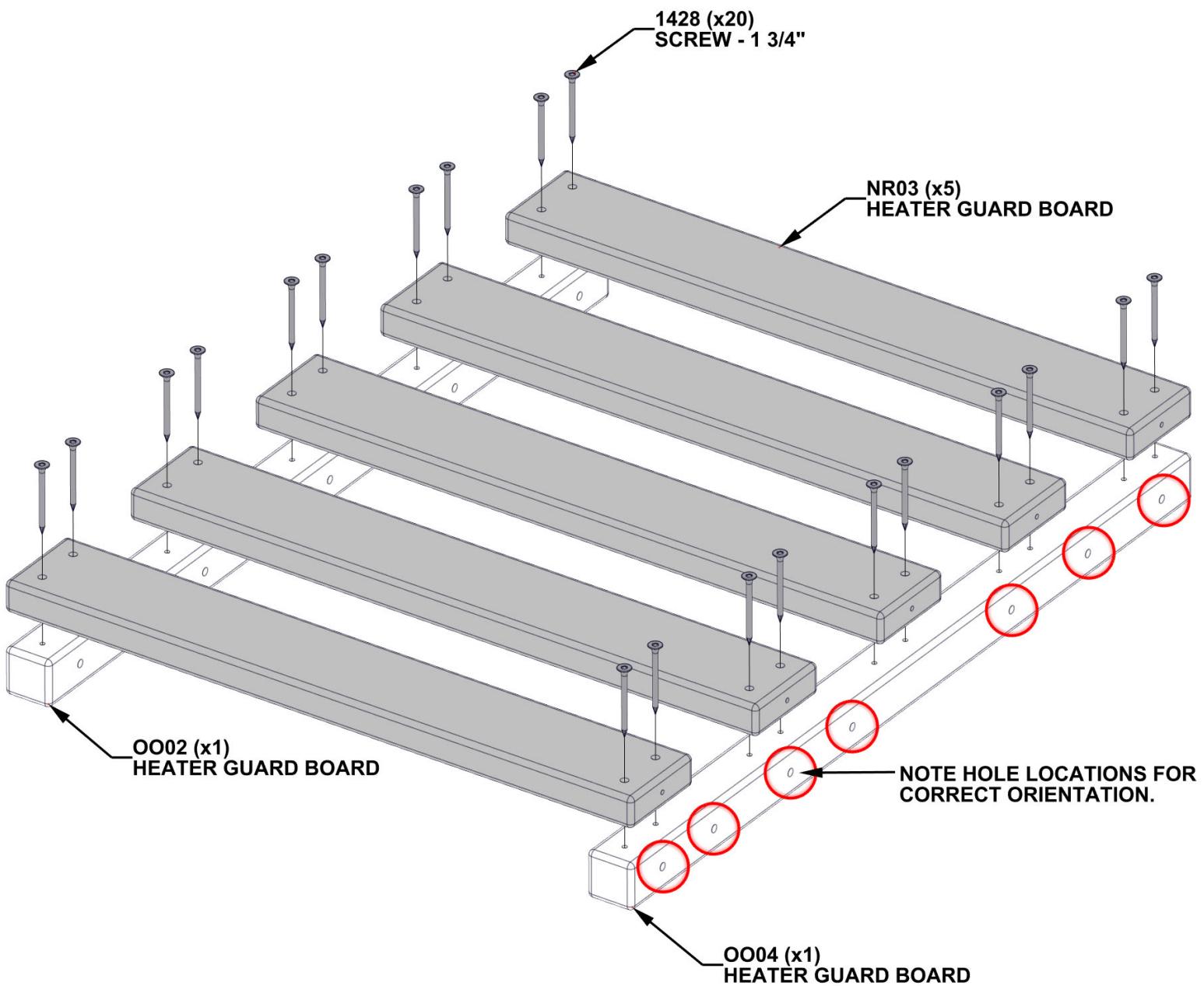


OO04 HEATER GUARD BOARD - W4L21871  
(x1) 1 3/16"x1 3/16"x21 7/16" (30x30x544)



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 37 - HEATER GUARD ASSEMBLY

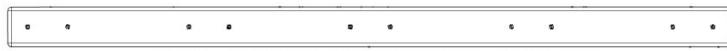
QTY	PART NUMBER	DESCRIPTION
20	H101428	SCREW TFH 8X1 3/4 SS-BLK



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

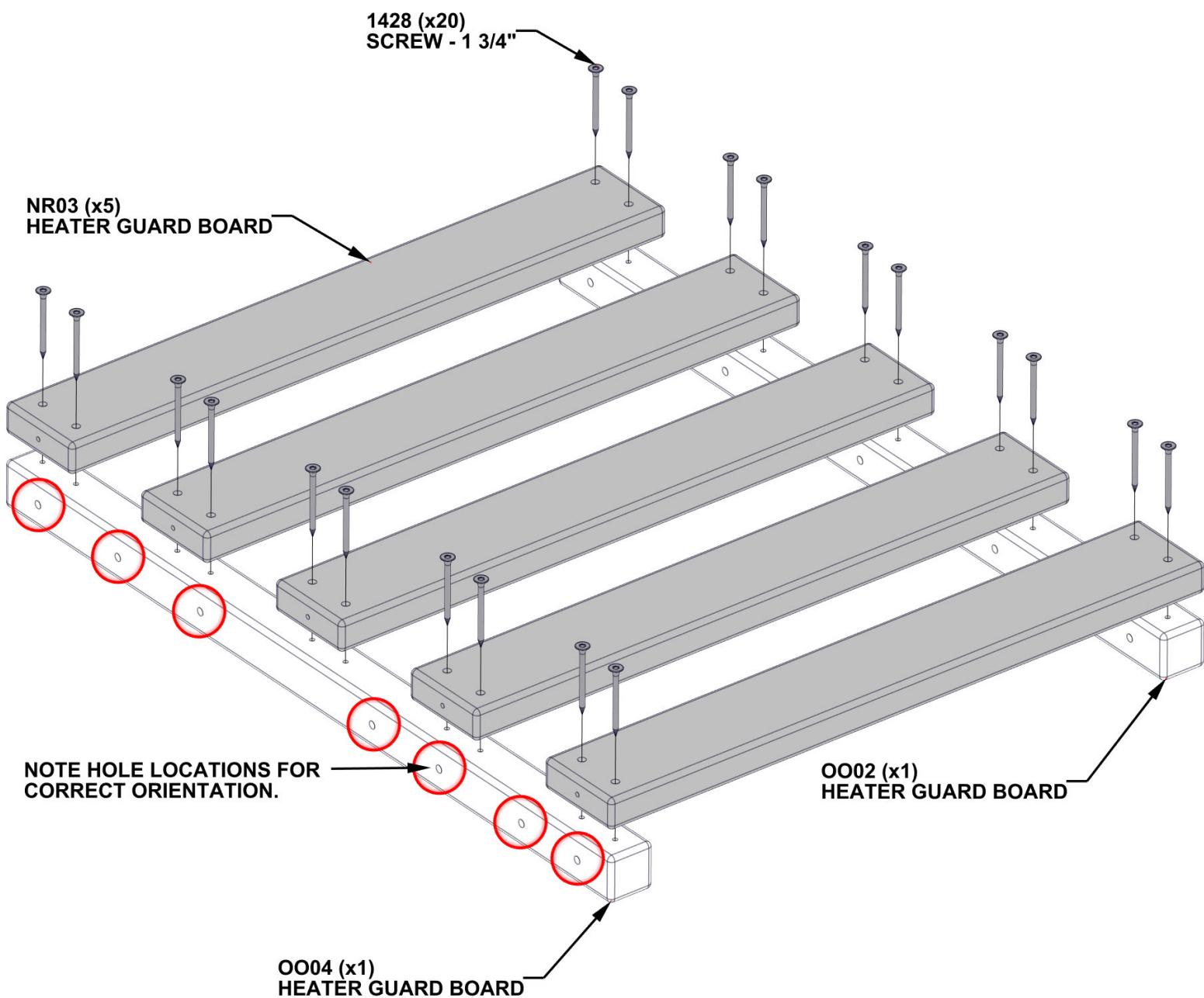


OO02 HEATER GUARD BOARD - W4L21875  
(x1) 1 3/16"x1 3/16"x21 7/16" (30x30x544)



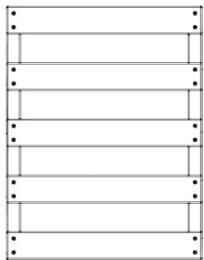
OO04 HEATER GUARD BOARD - W4L21871  
(x1) 1 3/16"x1 3/16"x21 7/16" (30x30x544)

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

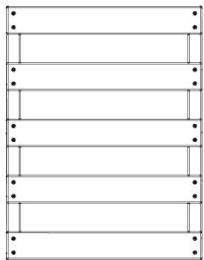


## STEP 38 - HEATER GUARD ASSEMBLY

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



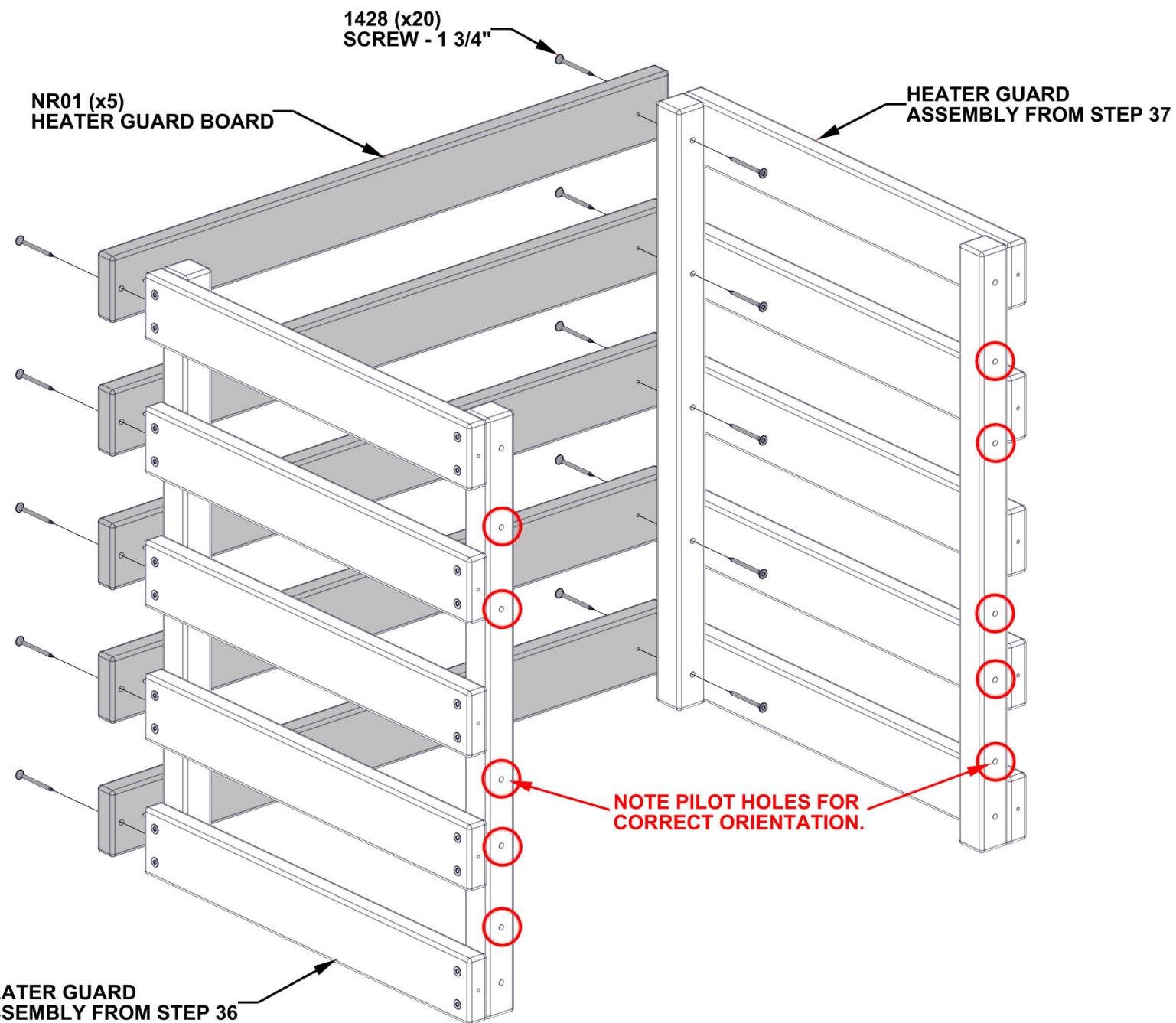
HEATER GUARD ASSEMBLY FROM STEP 36



HEATER GUARD ASSEMBLY FROM STEP 37



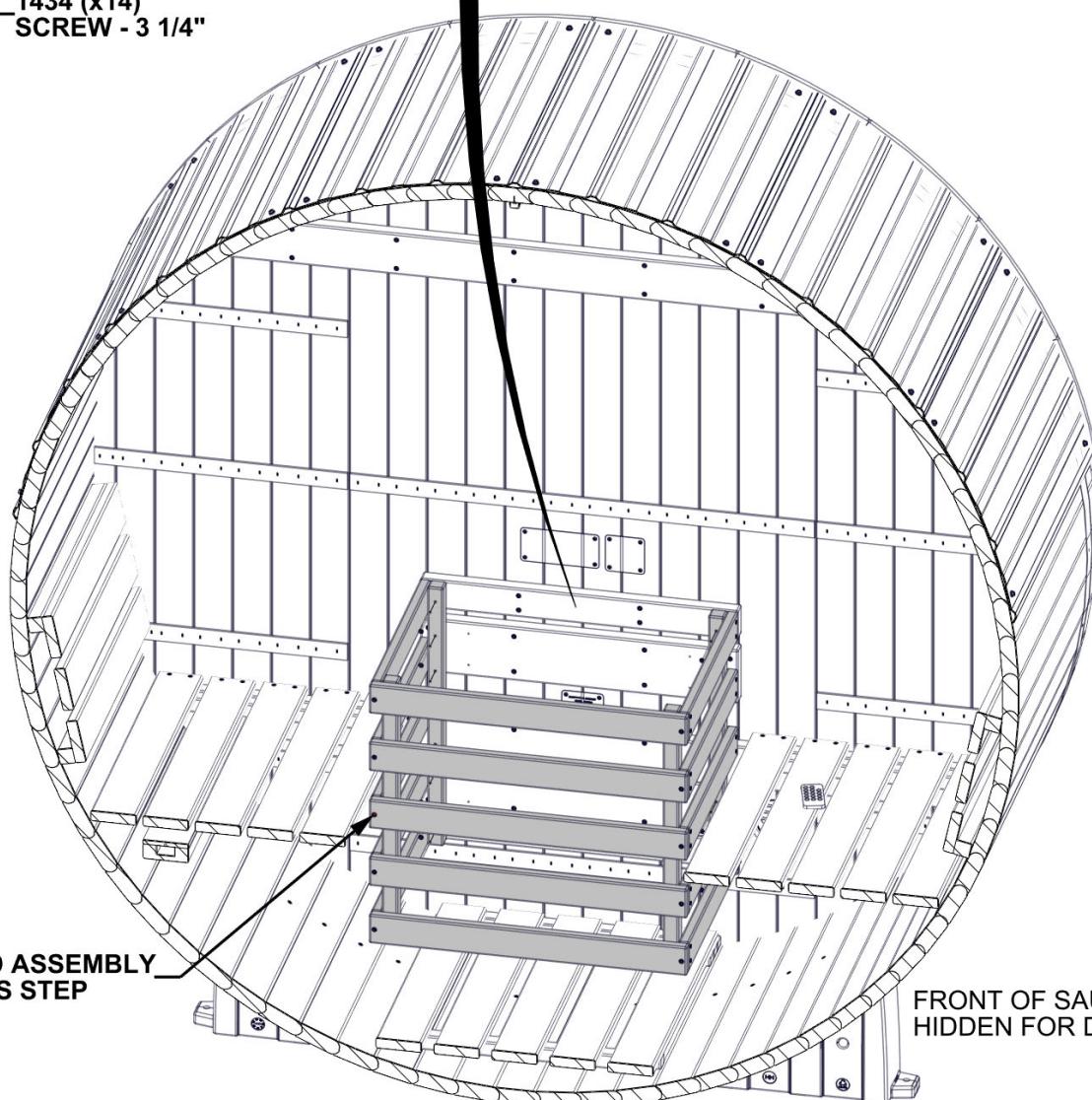
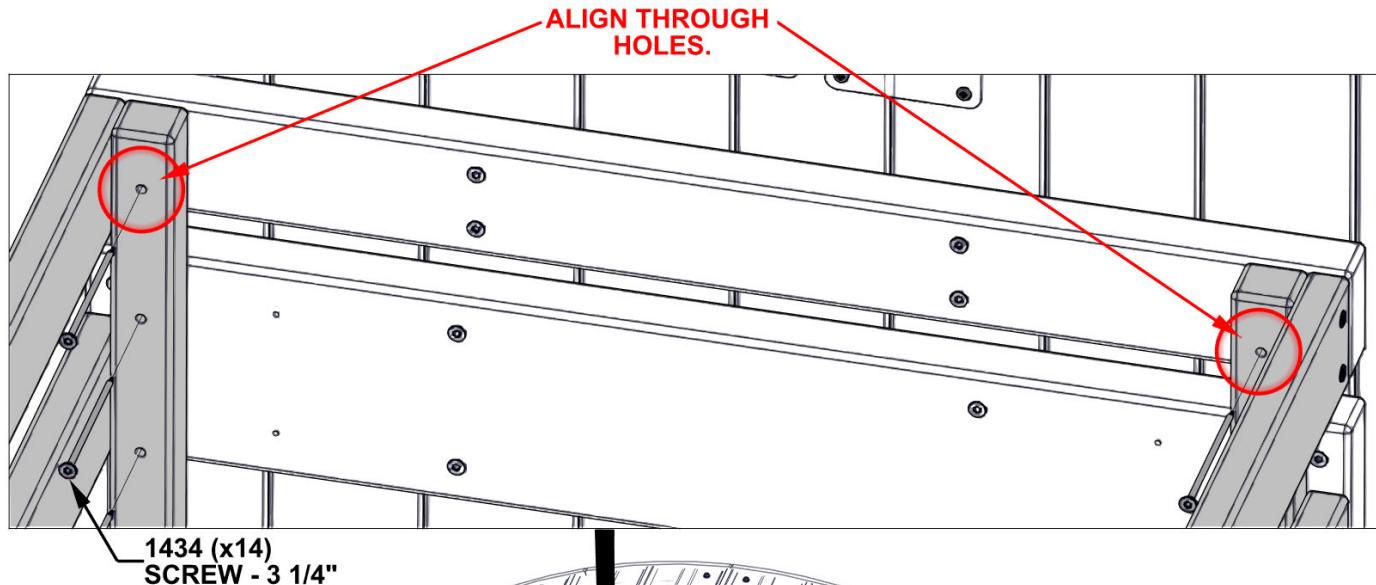
NR01 HEATER GUARD BOARD - W4L21872  
(x5) 13/16"x2 3/8"x23 15/16" (20x60x608)



## STEP 39 - HEATER GUARD ASSEMBLY

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

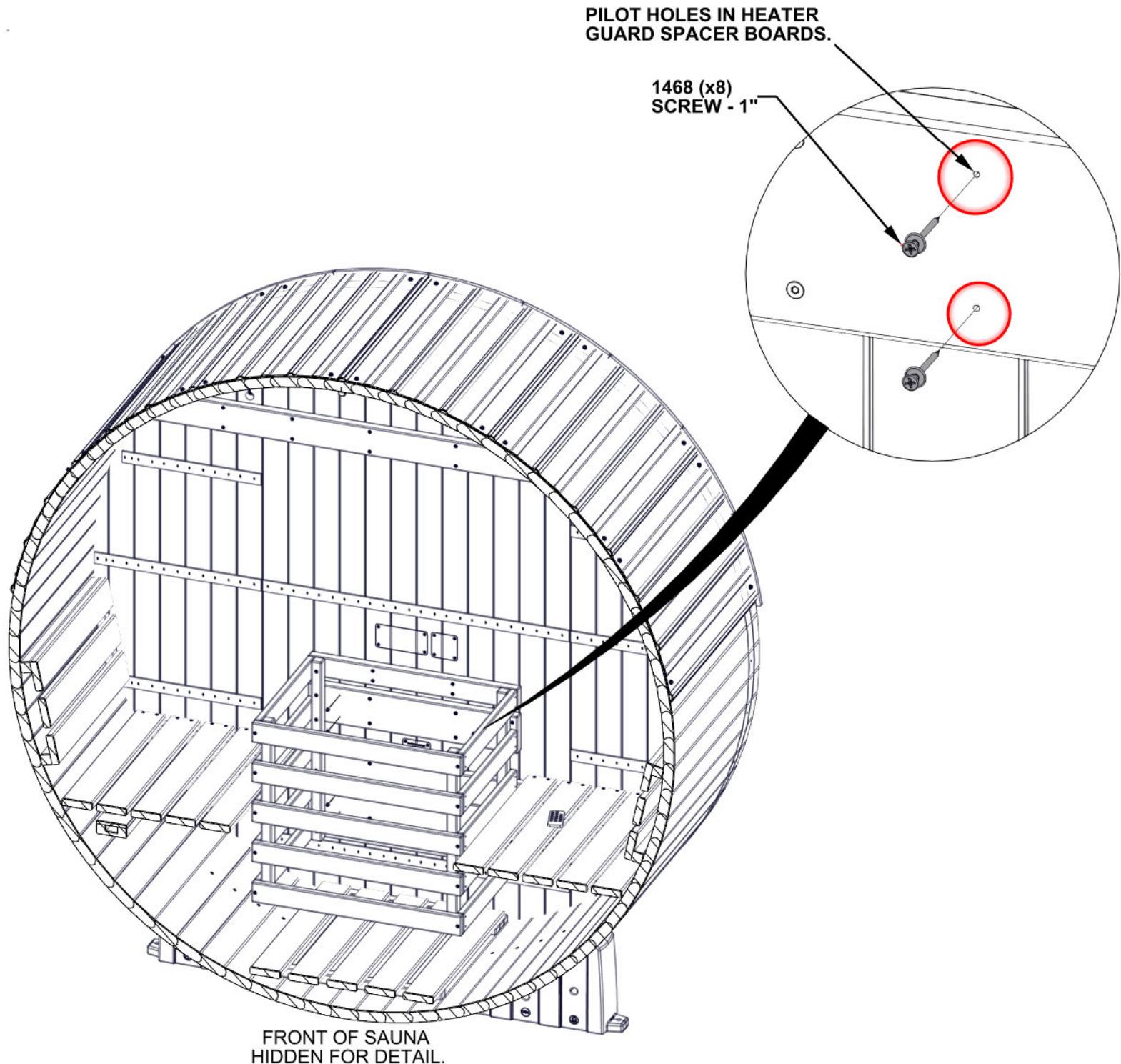
- POSITION HEATER GUARD ASSEMBLY AS SHOWN.
- ALIGN TOP AND BOTTOM THROUGH HOLES WITH THROUGH HOLES IN PREVIOUSLY INSTALLED GUARD MOUNTING BOARDS AND ATTACH.
- ENSURE SIDES OF THE HEATER GUARD ASSEMBLY ARE FLUSH WITH THE ENDS OF THE PREVIOUSLY INSTALLED HEATER SPACER BOARDS.



## STEP 40 - HEATER MOUNT INSTALLATION

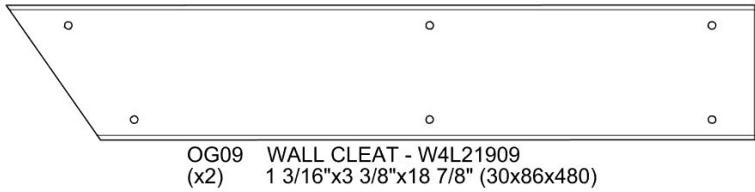
QTY	PART NUMBER	DESCRIPTION
8	H101468	SCREW RAISED HEAD 8x1"

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

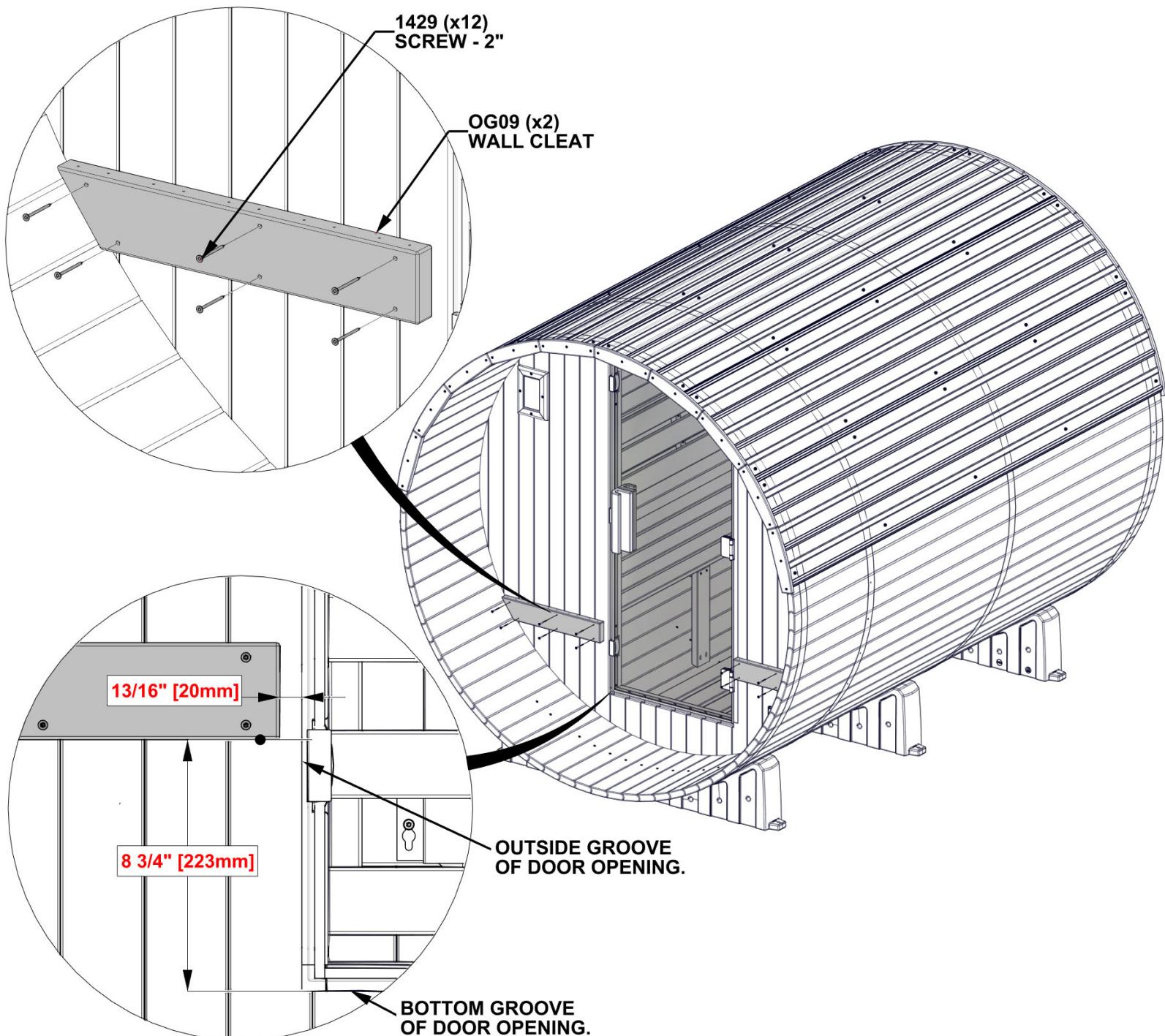


# STEP 41 - BENCH ASSEMBLY

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

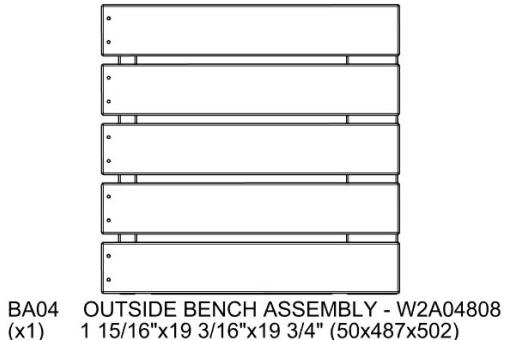


- USING DIMENSIONS SHOWN, ATTACH AS SHOWN.
- ENSURE MEASUREMENTS ARE TAKEN FROM THE OUTSIDE AND BOTTOM GROOVE OF THE DOOR OPENING.



## STEP 42 - BENCH ASSEMBLY

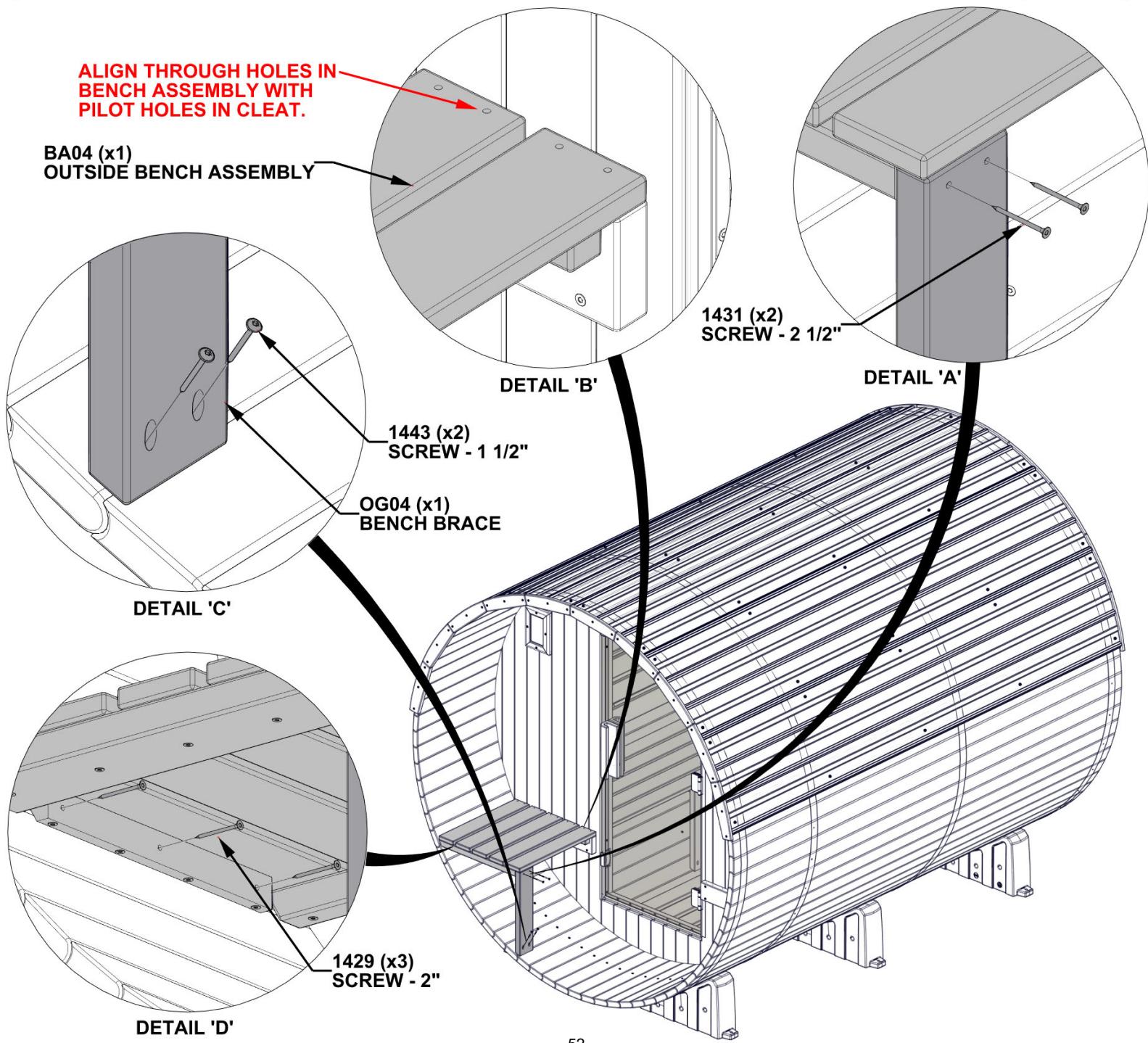
QTY	PART NUMBER	DESCRIPTION
3	H101429	SCREW TFH 8X2 SS-BLK
2	H101431	SCREW TFH 8X2 1/2 SS-BLK
2	H101443	SCREW TWH 8x1 1/2 SS-BLK



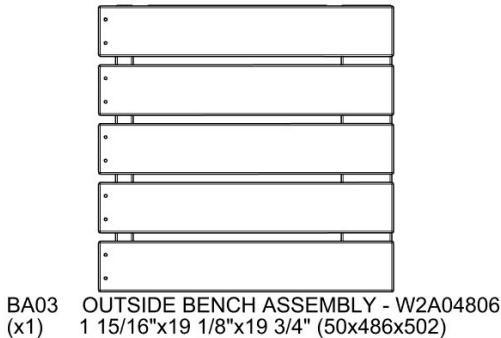
OG04 BENCH BRACE - W4L21860  
(x1) 1 3/16"3 3/8"16 3/8" (30x86x416)

BA04 OUTSIDE BENCH ASSEMBLY - W2A04808  
(x1) 1 15/16"x19 3/16"x19 3/4" (50x487x502)

- 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 AT THE END OF THE BENCH WITH THE PILOT HOLES ON THE CLEAT 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 43 - BENCH ASSEMBLY



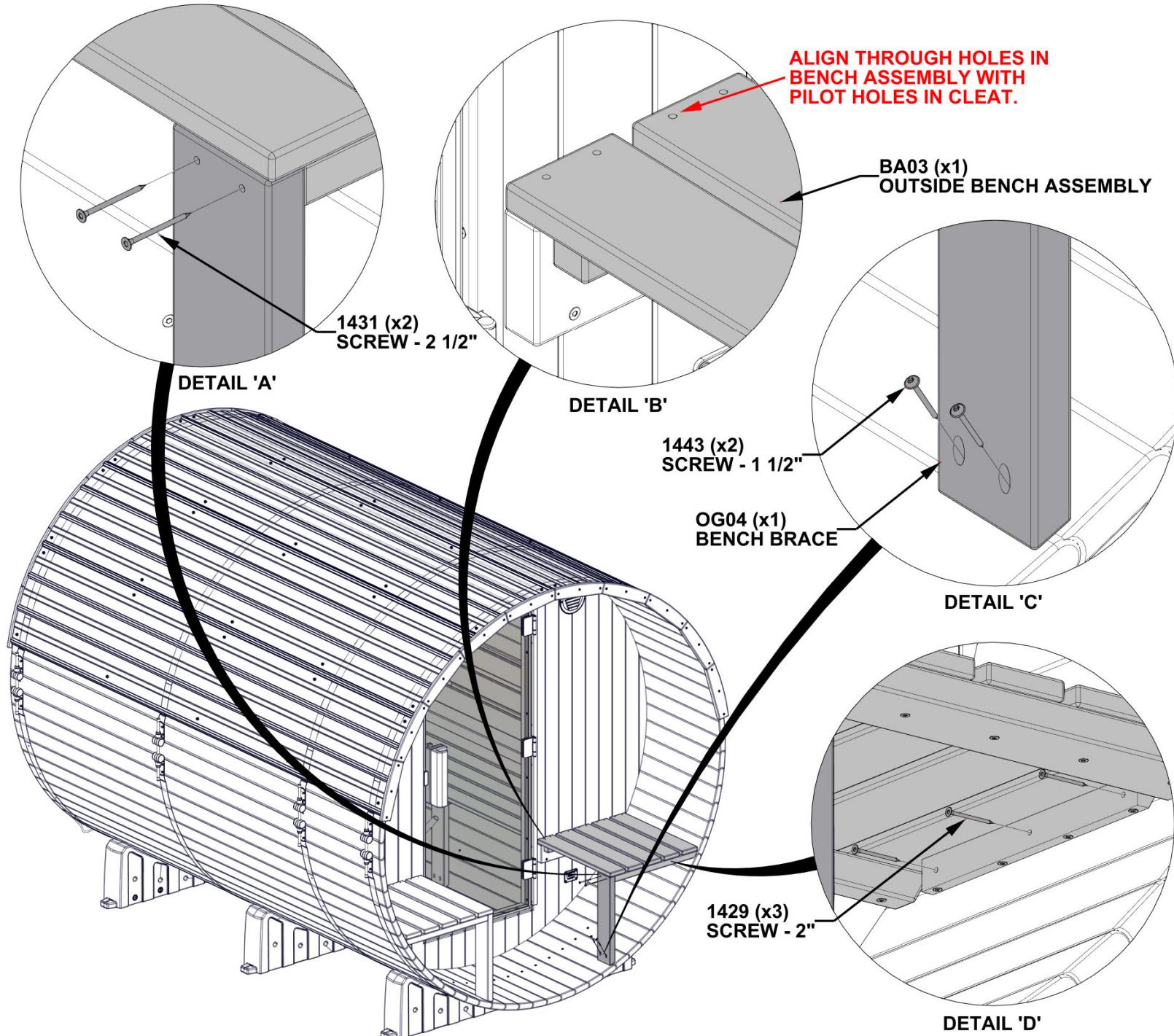
BA03 OUTSIDE BENCH ASSEMBLY - W2A04806  
(x1) 1 15/16"x19 1/8"x19 3/4" (50x486x502)

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



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

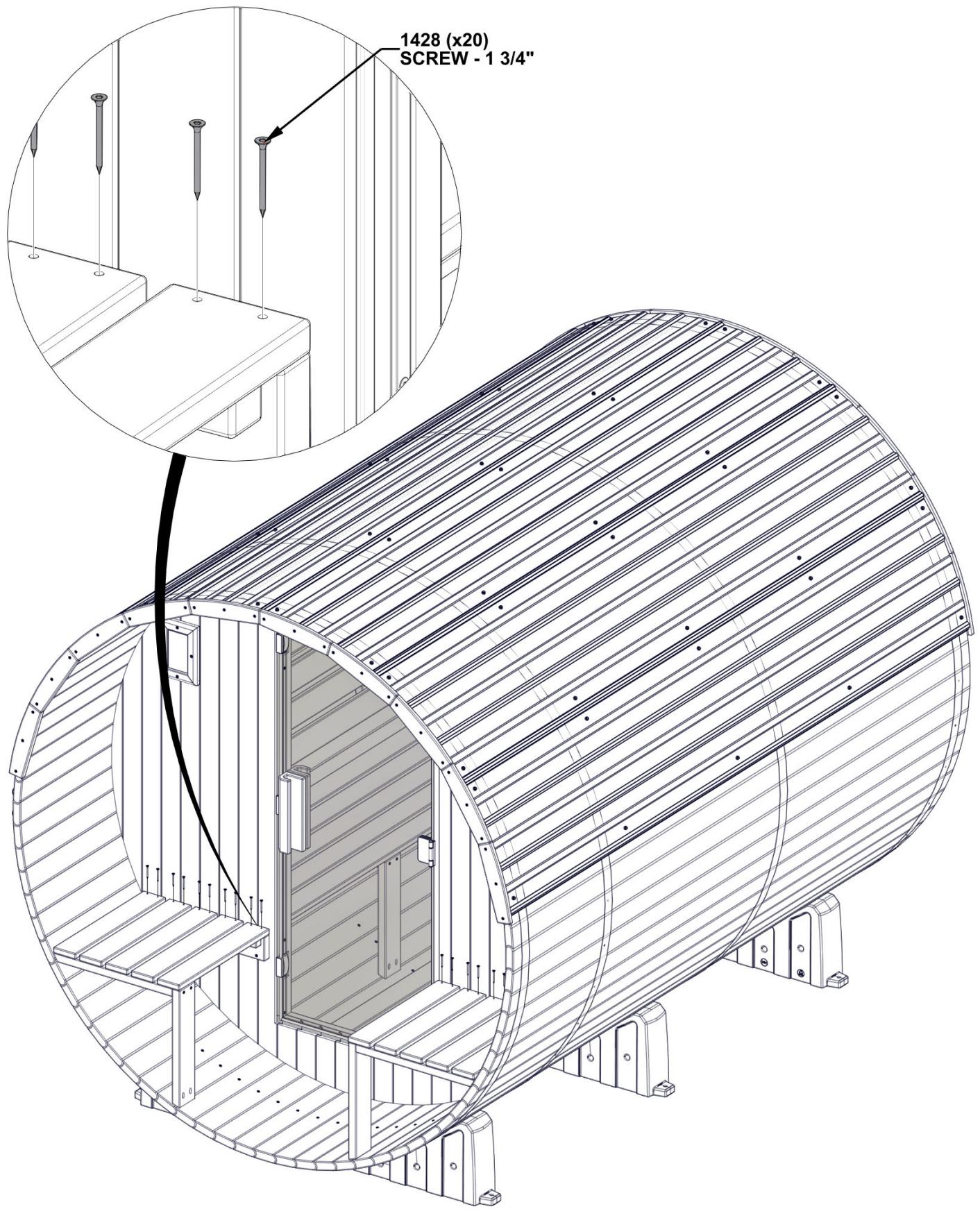
- 1) INSTALL BENCH BRACE OG04 TO BENCH ASSEMBLY. (DETAIL 'A')
- 2) PUSH THE BENCH WITH BENCH BRACE BOARD AGAINST THE WALL UNTIL IT MAKES CONTACT WITH THE SIDEWALL.
- 3) CHECK THE ALIGNMENT OF THE HOLES AT THE END OF THE BENCH WITH THE PILOT HOLES ON THE CLEAT MOUNTED TO THE WALL. (DETAIL 'B')
- 4) ENSURE 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 44 - BENCH ASSEMBLY

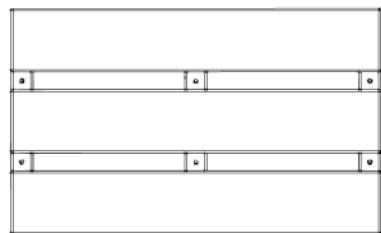
QTY	PART NUMBER	DESCRIPTION
20	H101428	SCREW TFH 8X1 3/4 SS-BLK

- ENSURE THROUGH HOLES ARE ALIGNED WITH PILOT HOLES AND ATTACH WITH SCREWS.



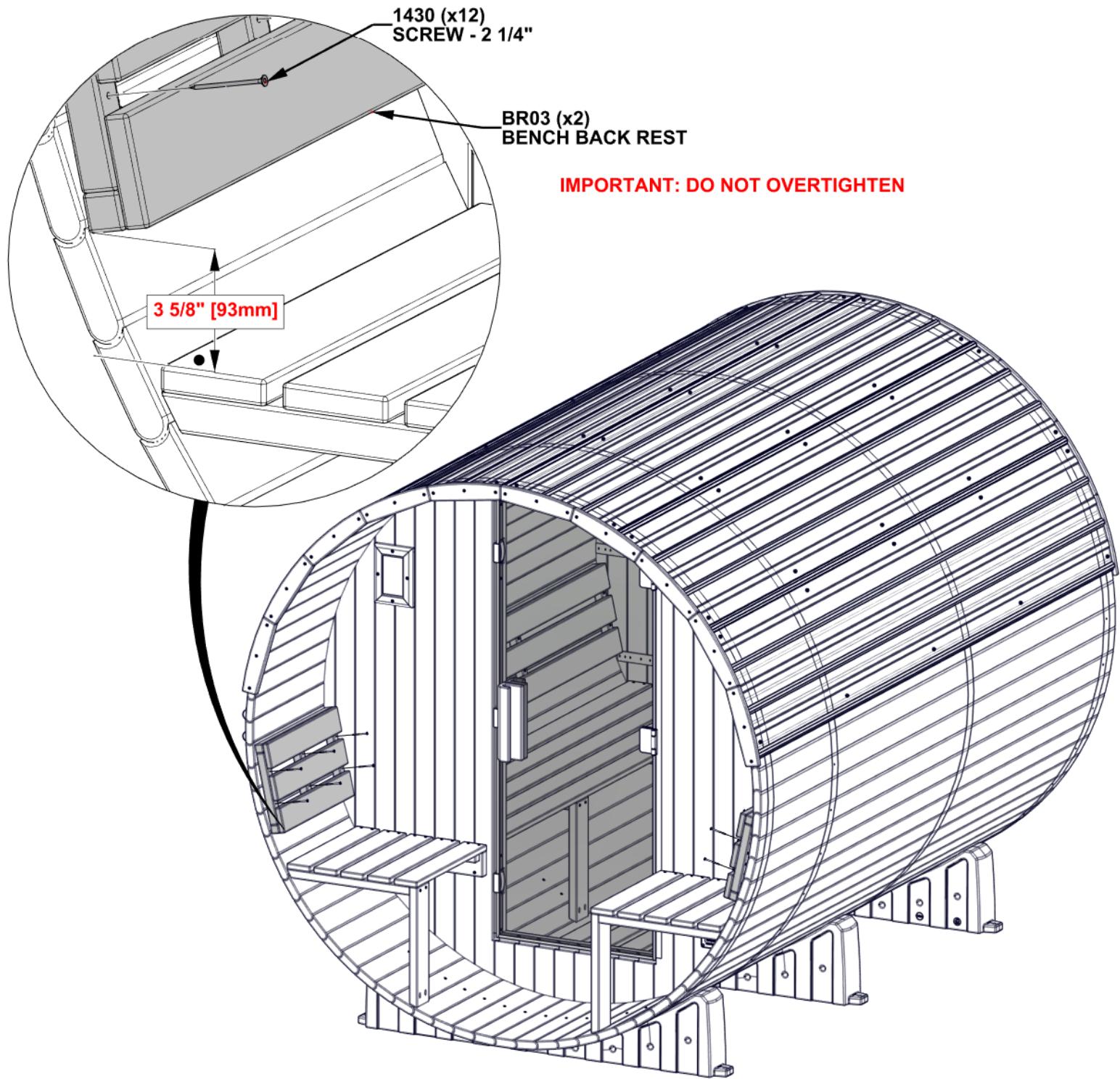
## STEP 45 - BENCH ASSEMBLY

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



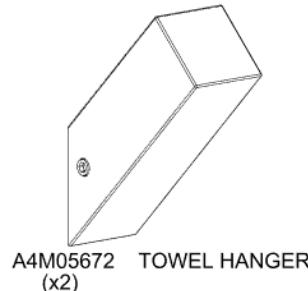
BR03 BENCH BACK REST - W2A04807  
(x2) 1 15/16"x12 1/16"x19 3/4" (50x306x502)

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

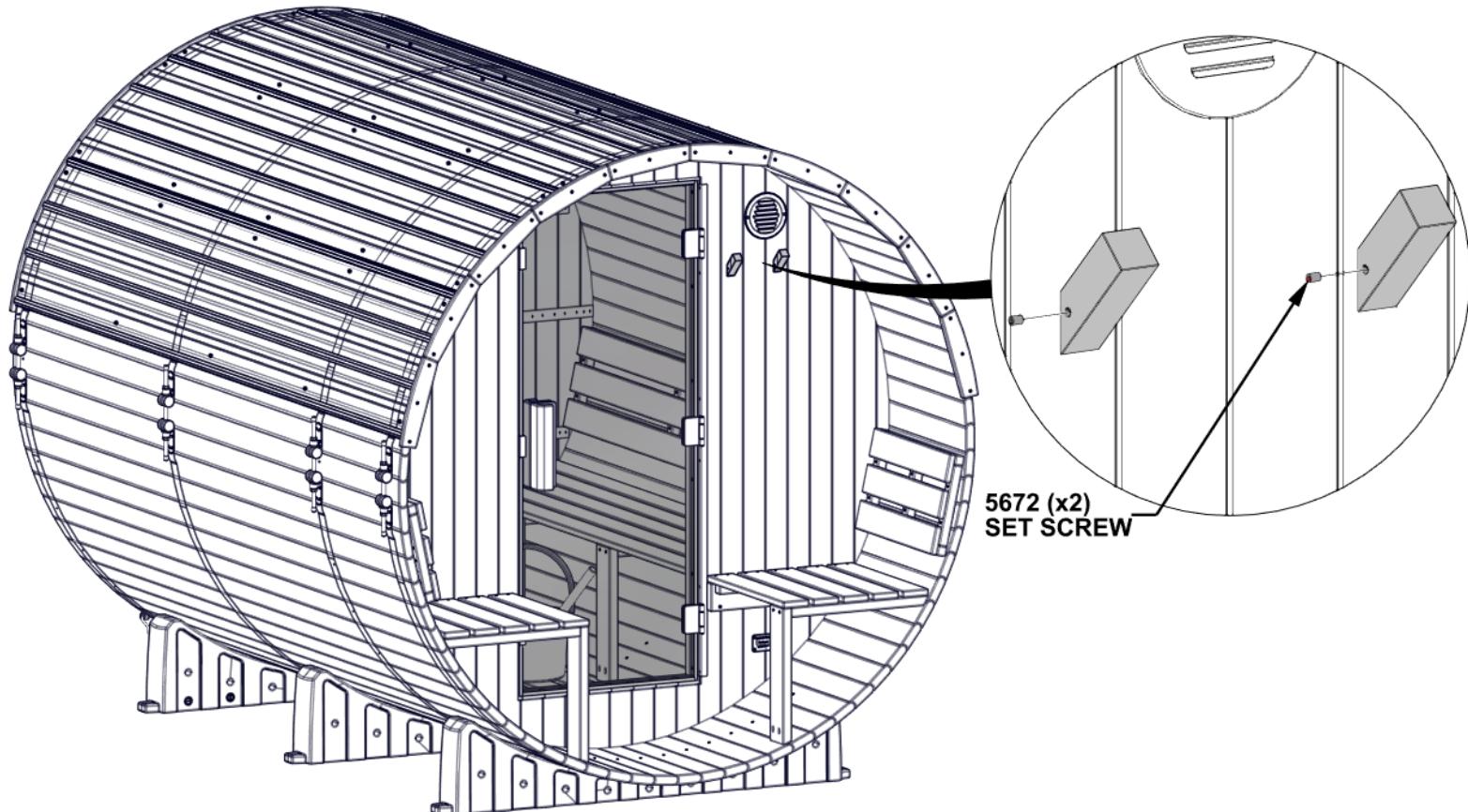
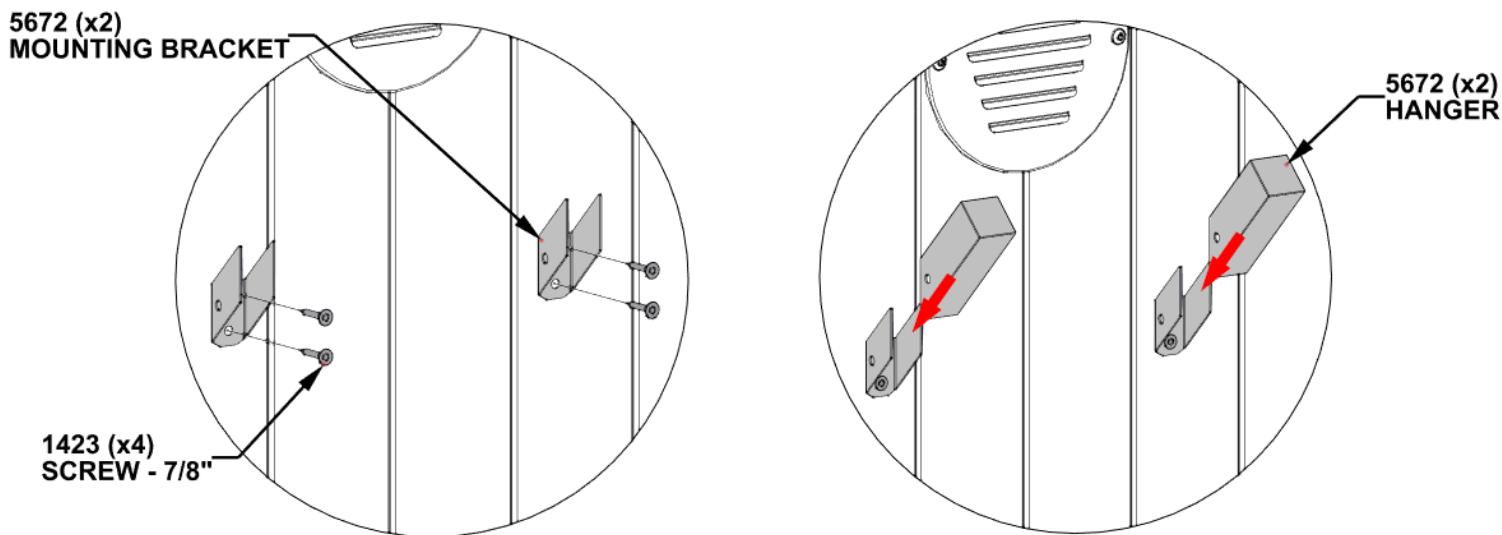


## STEP 46 - TOWEL HANGER INSTALLATION

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

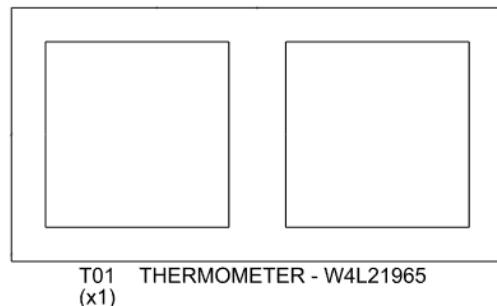


- INSTALL TOWEL HANGERS AT ANY DESIRED LOCATION ON THE RIGHT SIDE.
- HOWEVER, DO NOT INSTALL SCREWS AT THE SEAMS OF PANEL BOARDS.

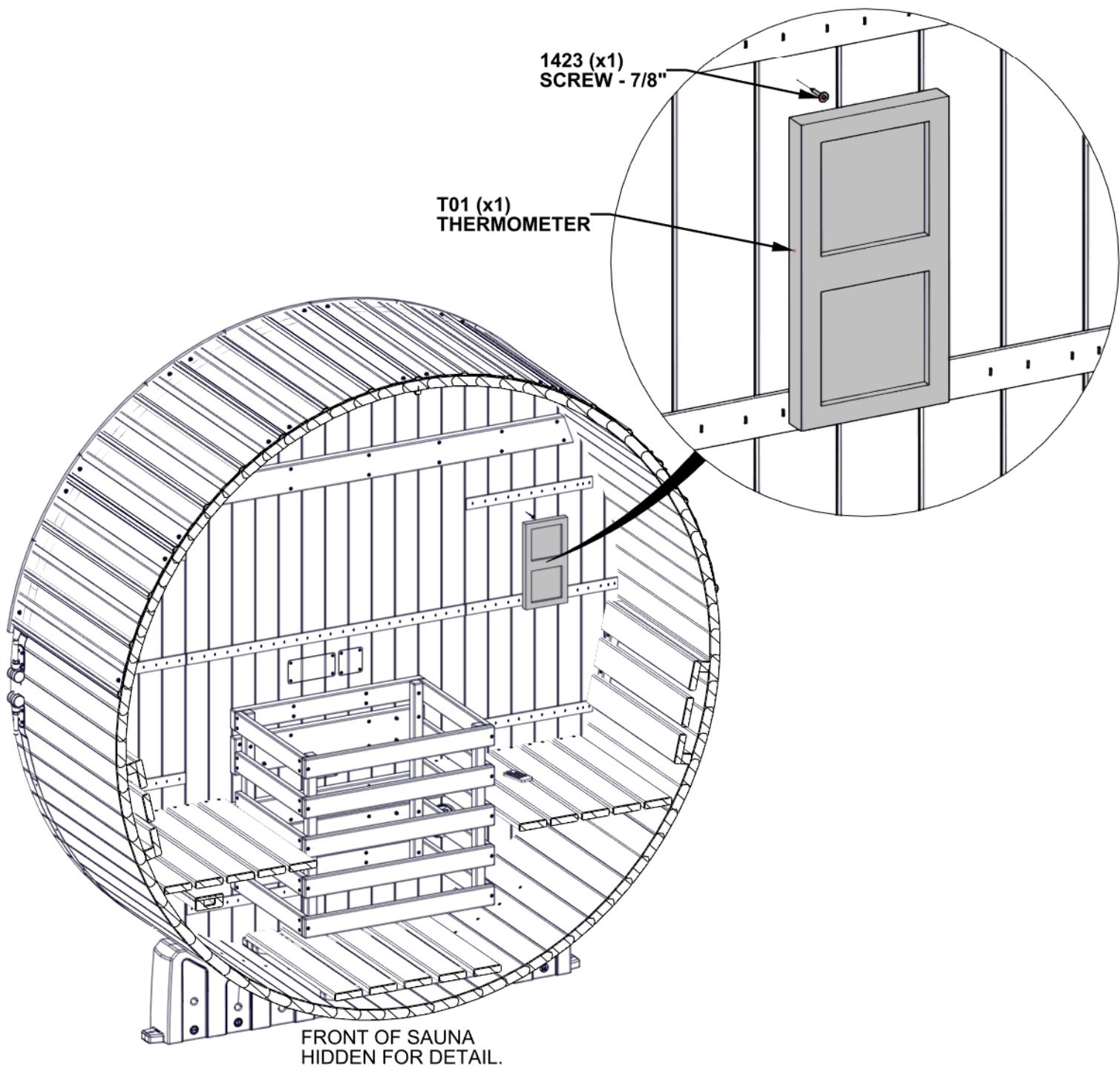


## STEP 47 - THERMOMETER INSTALLATION

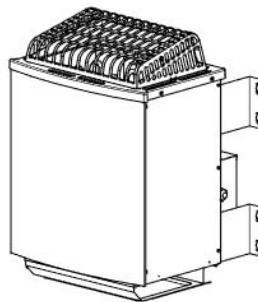
QTY	PART NUMBER	DESCRIPTION
1	H101423	SCREW TFH 8X7/8 SS-BLK



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

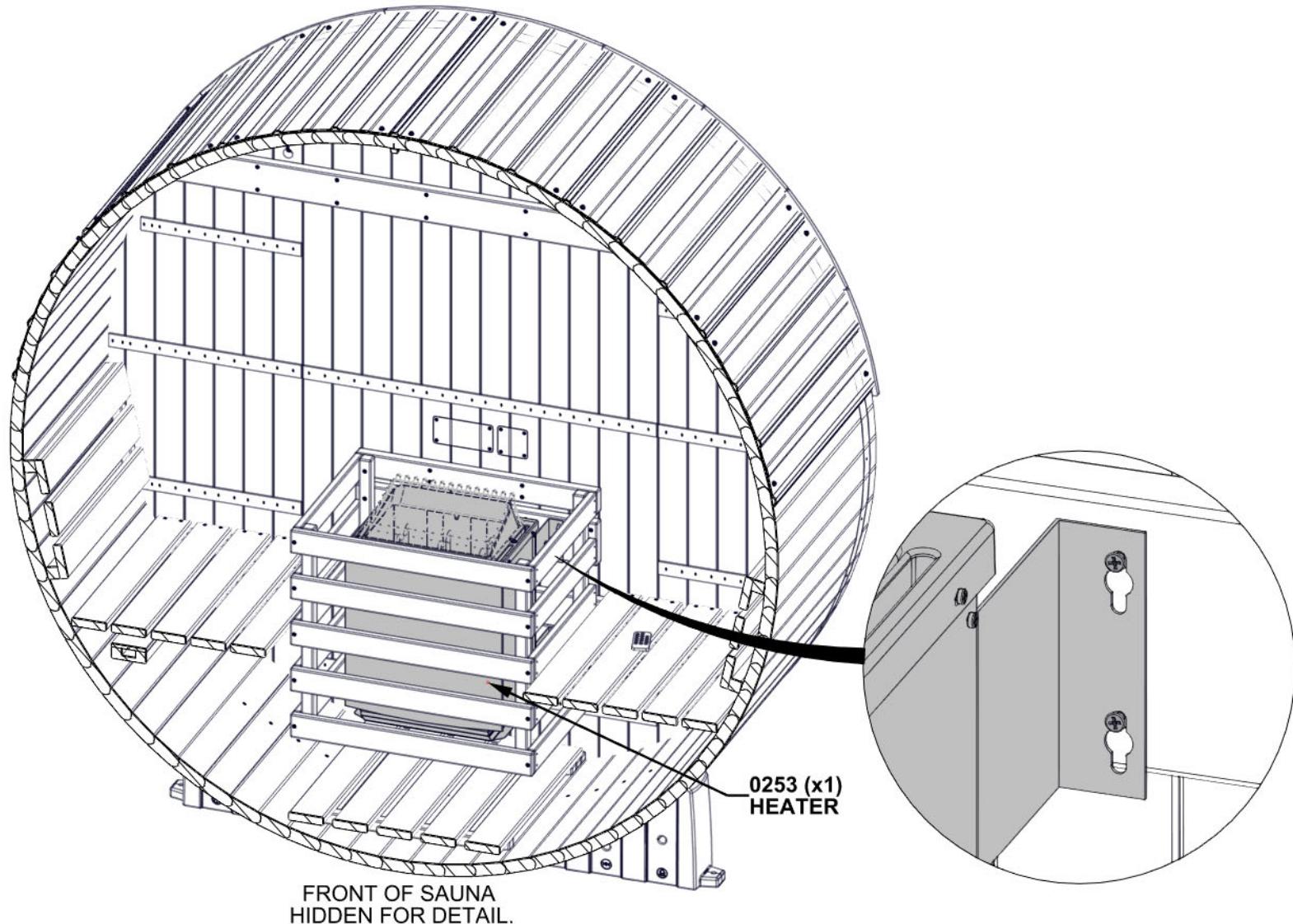


## STEP 48A - HEATER INSTALLATION

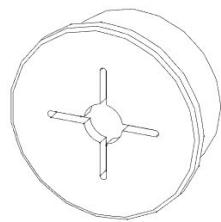


9250253 9KW ELECTRIC SAUNA HEATER  
(x1)

- 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.
- 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 48B - ELECTRICAL

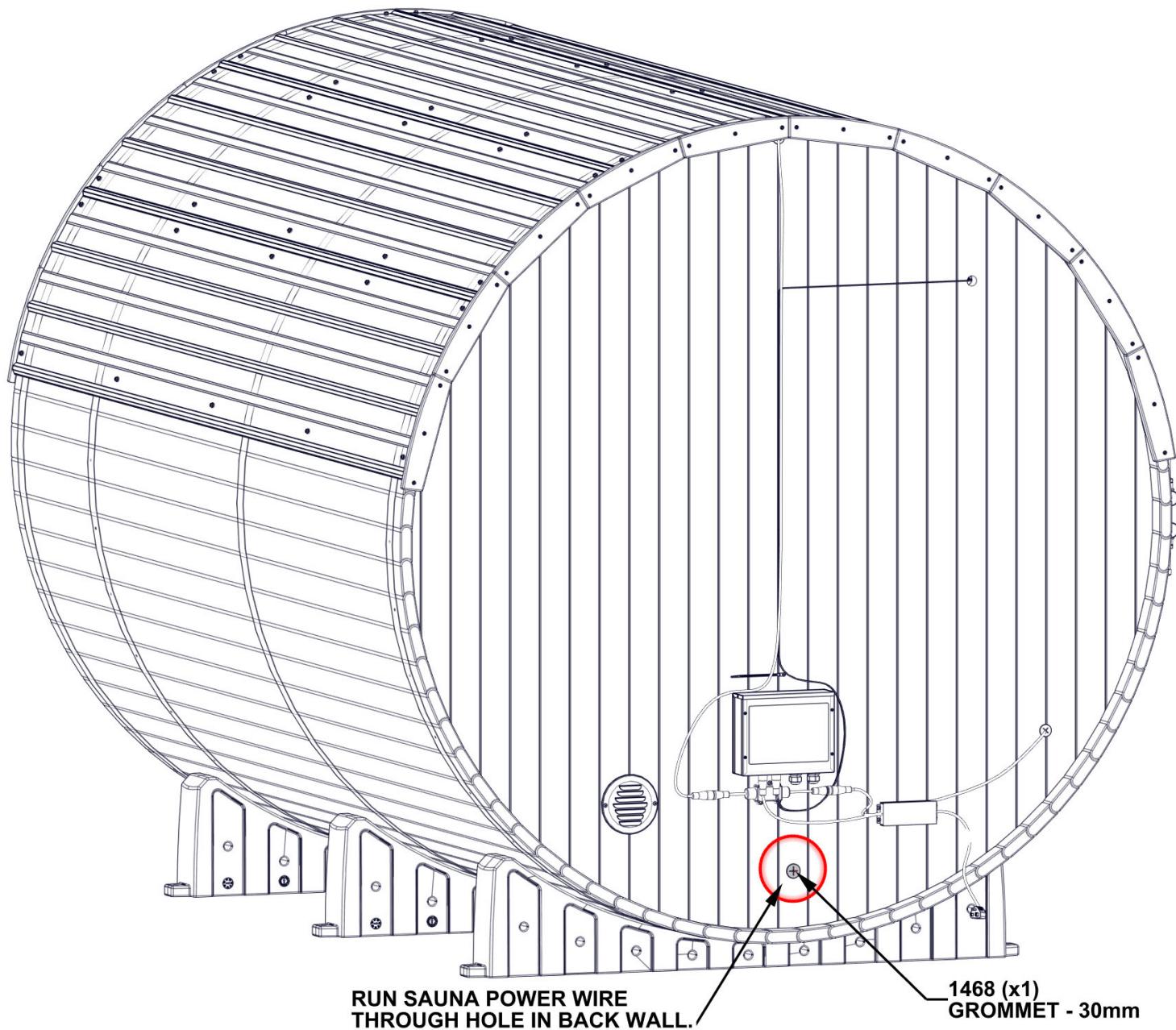


A6P01468 30mm SILICON GROMMET  
(x1)



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.



## STEP 49 - 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.

