



Manufactured by:
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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



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



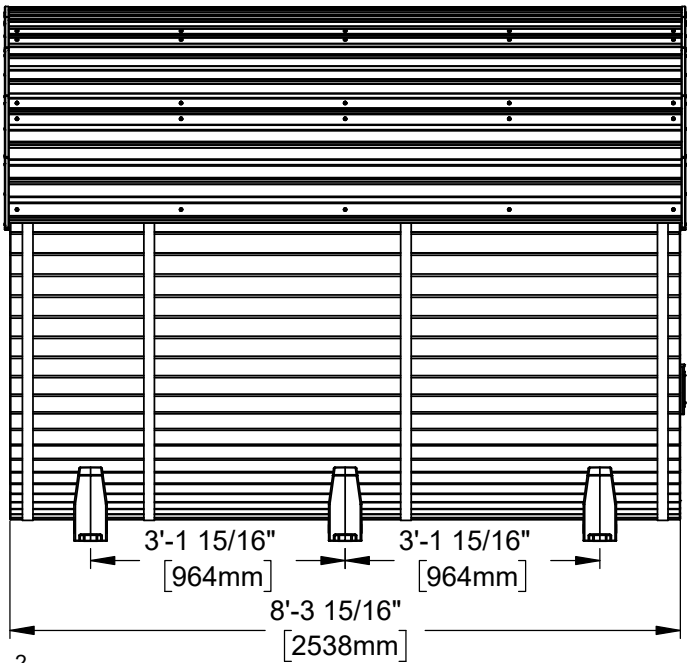
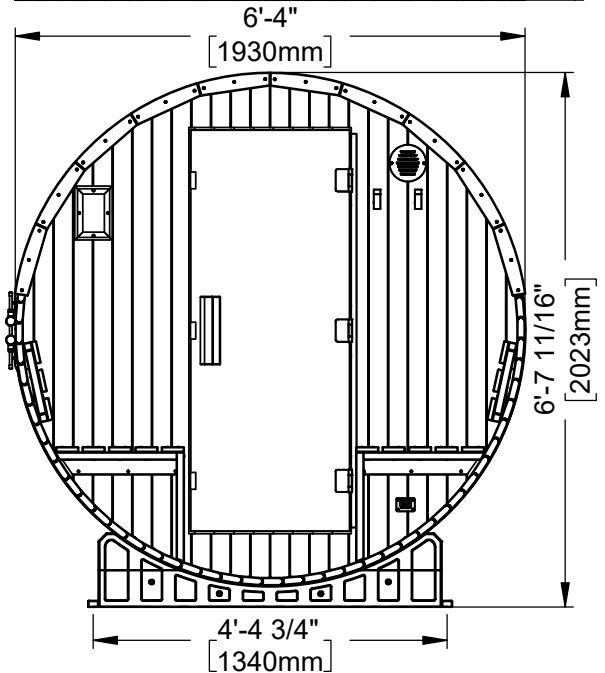
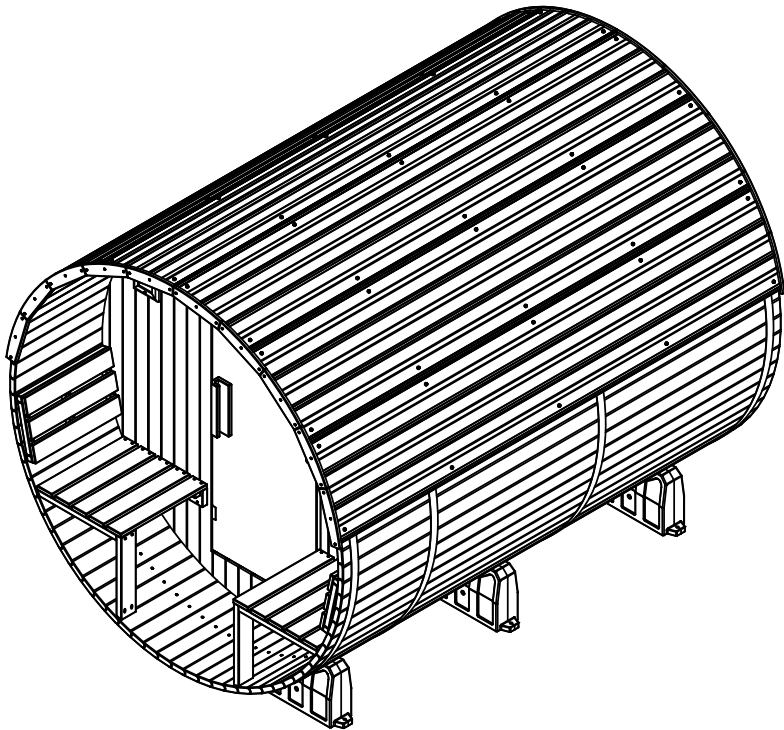
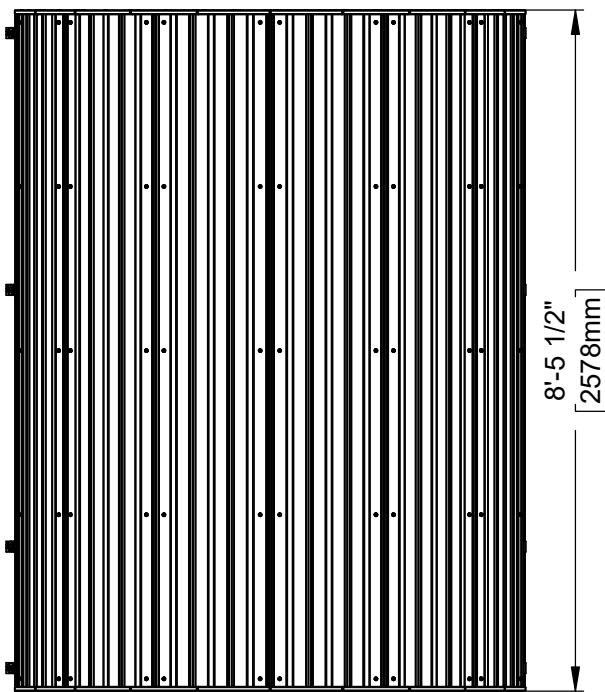
EASY STEP-BY-STEP
3D INTERACTIVE INSTRUCTIONS
DOWNLOAD THE FREE APP



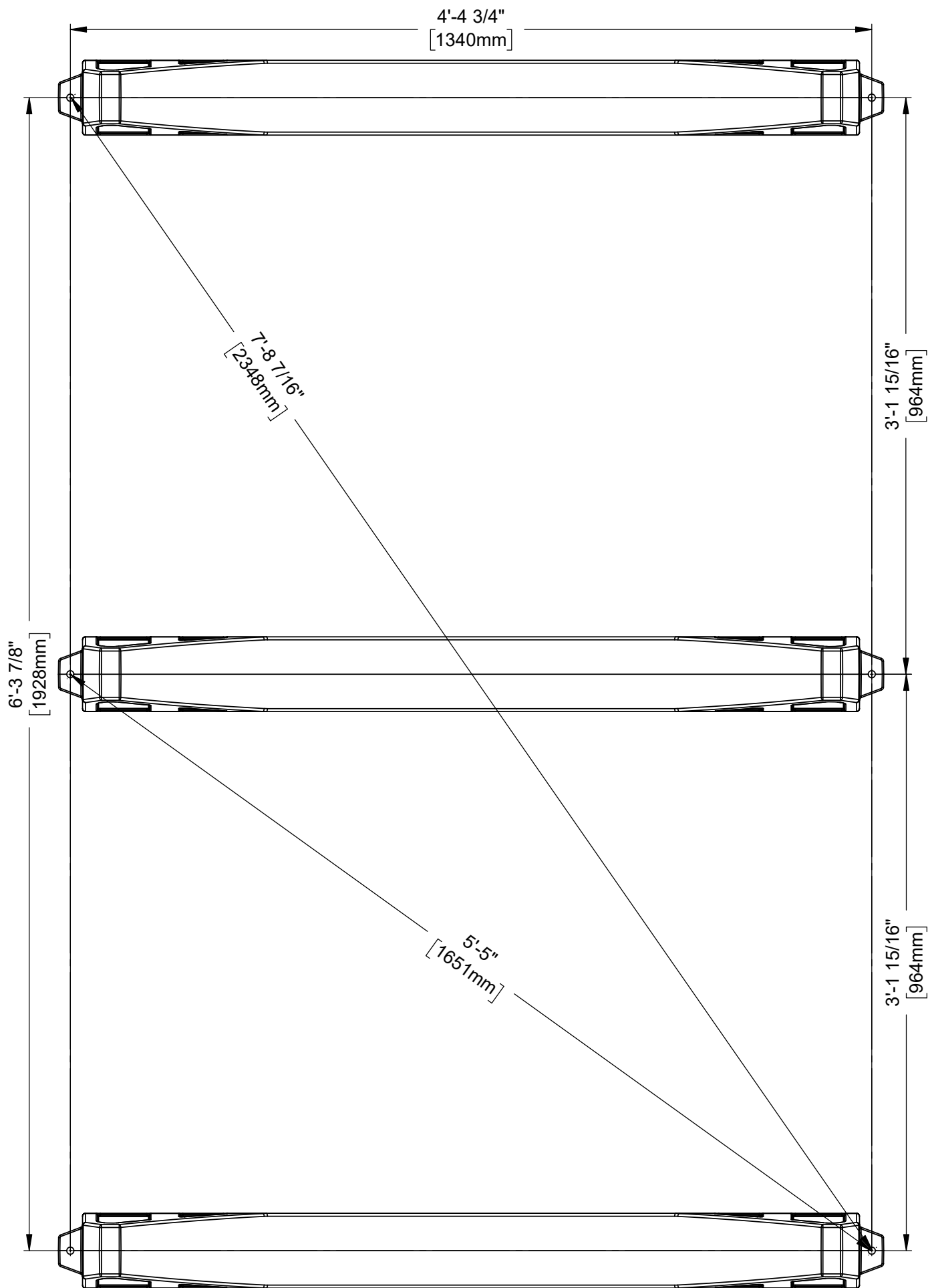
OWNER'S MANUAL - BASIC SETUP DIMENSIONS & ASSEMBLY NOTES

CHOOSE A GOOD LOCATION FOR YOUR SAUNA!

- It is critically important 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 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.

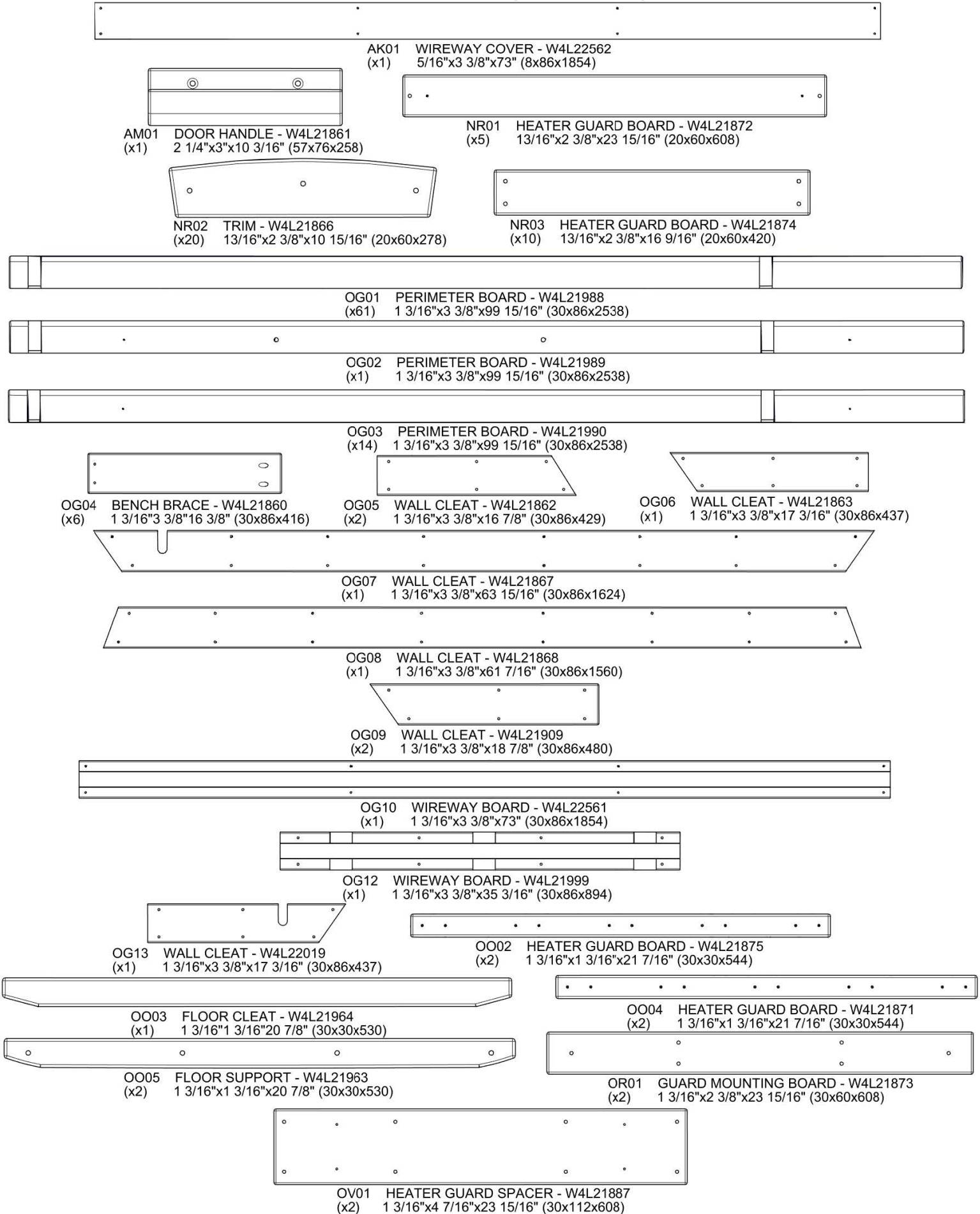


OWNER'S MANUAL - ANCHORING LAYOUT



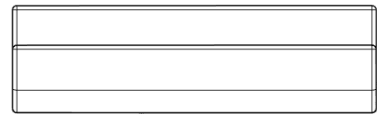
OWNER'S MANUAL - PARTS IDENTIFICATION

WOOD COMPONENTS (NOT TO SCALE)

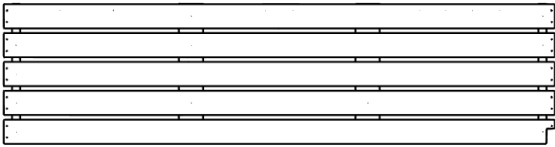


OWNER'S MANUAL - PARTS IDENTIFICATION

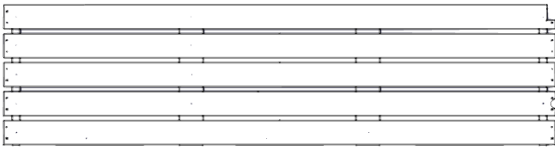
ACCESSORY COMPONENTS (NOT TO SCALE)



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



BA01 RIGHT BENCH ASSEMBLY - W2A04826
(x1) 1 15/16"x19 1/8"x75 1/4" (50x486x1912)



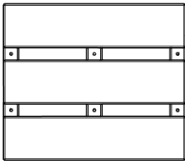
BA02 LEFT BENCH ASSEMBLY - W2A04827
(x1) 19 1/8"x75 1/4" (50x486x1912)



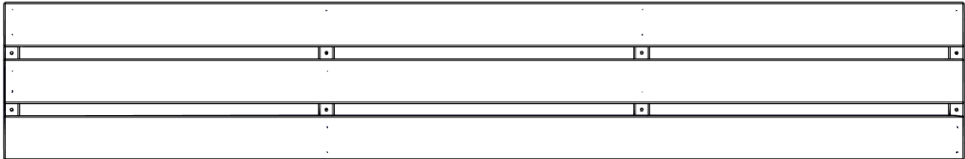
BA03 OUTSIDE BENCH ASSEMBLY - W2A04806
(x1) 1 15/16"x19 1/8"x19 3/4" (50x486x502)



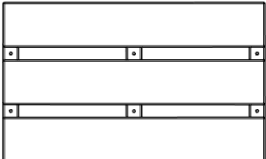
BA04 OUTSIDE BENCH ASSEMBLY - W2A04808
(x1) 1 15/16"x19 3/16"x19 3/4" (50x487x502)



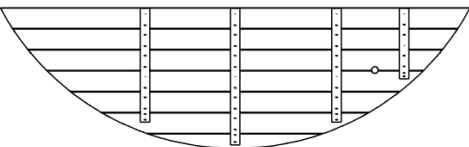
BR01 WALL BACK REST - W2A04790
(x2) 1 15/16"x12 1/16"x14" (50x306x356)



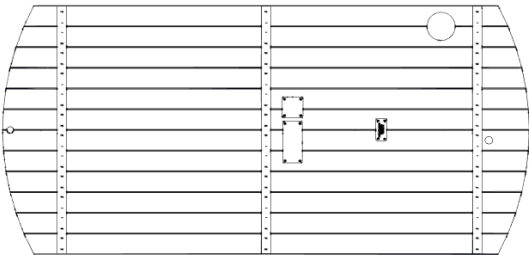
BR02 BENCH BACK REST - W2A04828
(x2) 1 15/16"x12 1/16"x73 3/8" (50x306x1864)



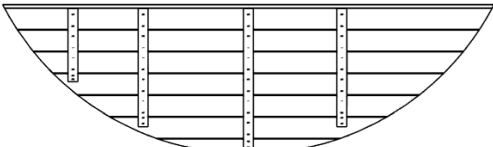
BR03 BENCH BACK REST - W2A04807
(x2) 1 15/16"x12 1/16"x19 3/4" (50x306x502)



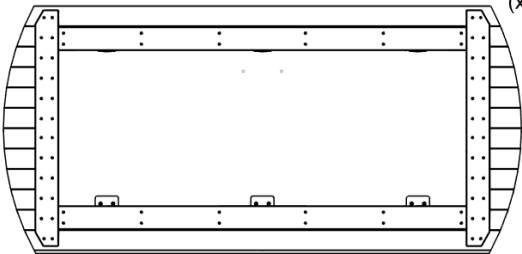
WP01 WALL PANEL ASSEMBLY - W2A04784
(x1) 1 3/8"x19 11/16"x65 3/4" (35x500x1669)



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



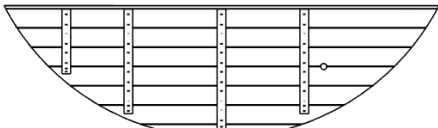
WP03 WALL PANEL ASSEMBLY - W2A04786
(x1) 1 3/8"x20 1/8"x66 1/4" (35x512x1682)



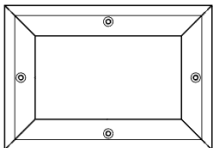
WP04 WALL PANEL ASSEMBLY - W2A04794
(x1) 2 3/8"x35 5/8"x74 9/16" (60x906x1894)



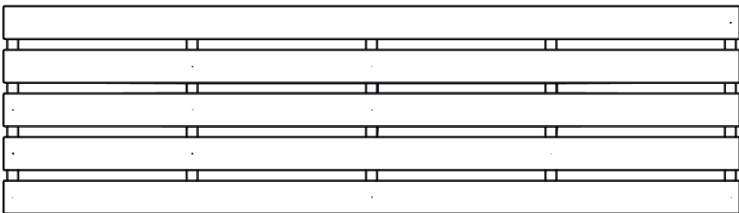
WP05 WALL PANEL - W2A04792
(x1) 1 3/8"x19 11/16"x65 3/4" (35x500x1669)



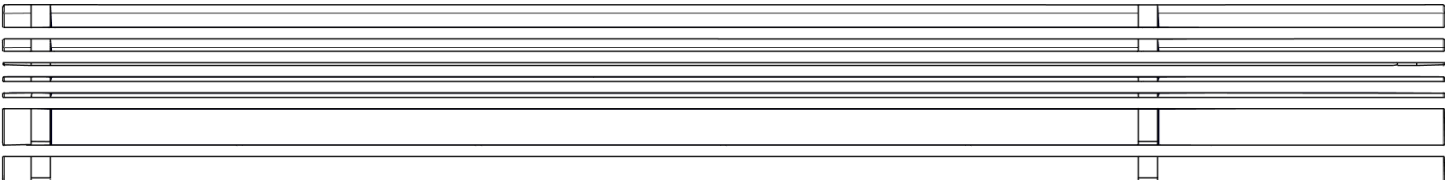
WP06 WALL PANEL ASSEMBLY - W2A04809
(x1) 1 3/8"x20 1/8"x66 1/4" (35x512x1682)



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



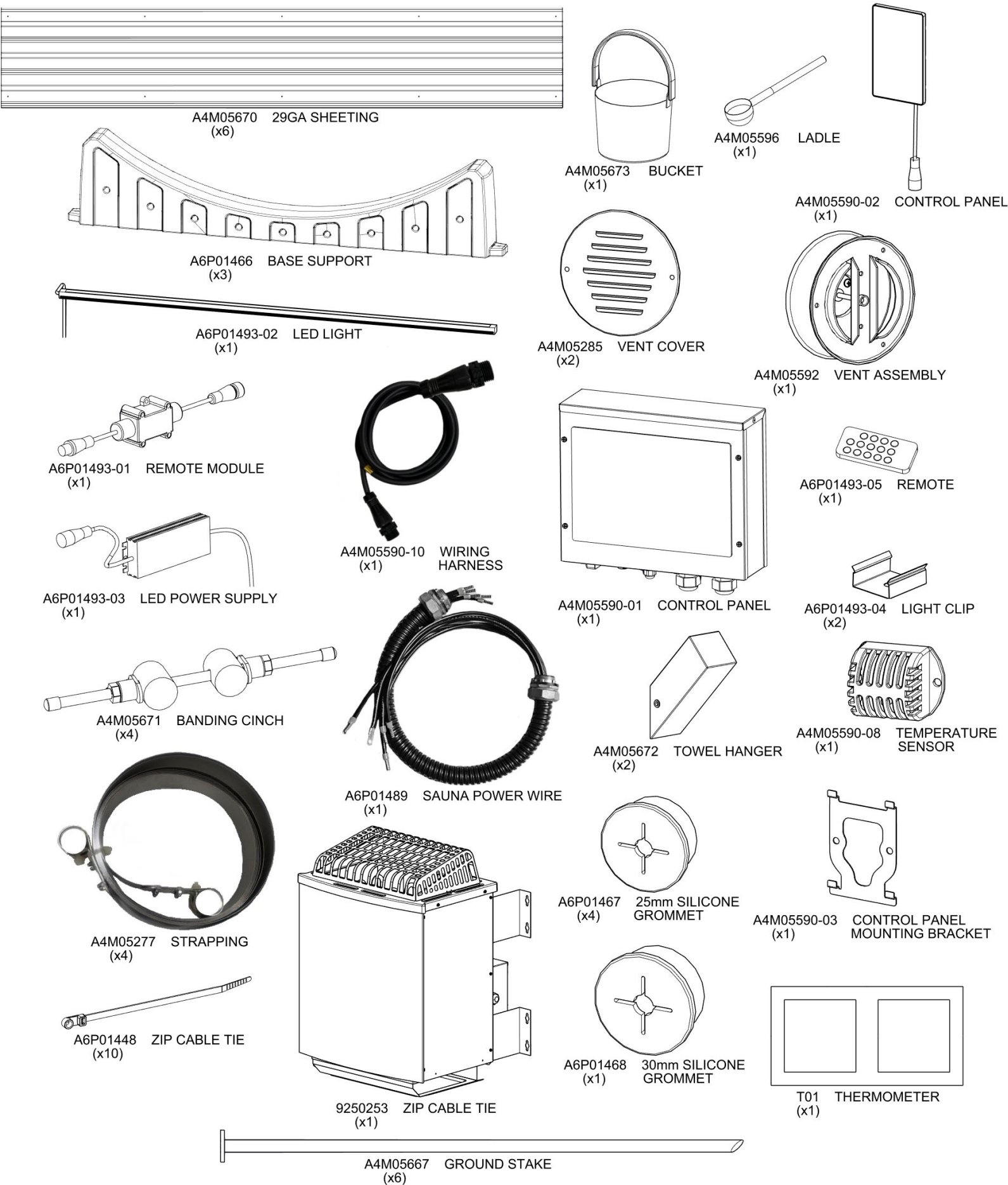
FP01 FLOOR PANEL ASSEMBLY - W2A04829
(x1) 1 15/16"x20 7/8"x73 7/8" (50x530x1876)



BOARD SPACER KIT - W2A04961
(x1)

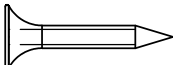
OWNER'S MANUAL - PARTS IDENTIFICATION

ACCESSORY COMPONENTS (NOT TO SCALE)

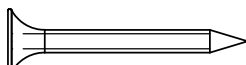


OWNER'S MANUAL - PARTS IDENTIFICATION

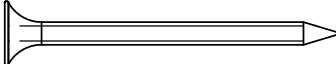
HARDWARE COMPONENTS



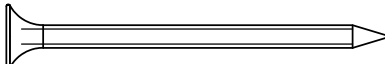
H101423 SCREW TFH 8X7/8 SS-BLK
(x5) 8x7/8



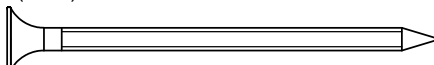
H101426 SCREW TFH 8X1 1/4 SS-BLK
(x3) 8x1-1/4



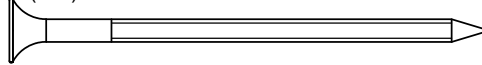
H101428 SCREW TFH 8X1 3/4 SS-BLK
(x122) 8x1-3/4



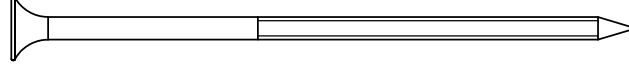
H101429 SCREW TFH 8X2 SS-BLK
(x251) 8x2



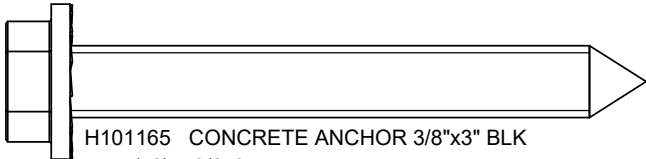
H101430 SCREW TFH 8X2 1/4 SS-BLK
(x28) 8x2-1/4




H101431 SCREW TFH 8X2 1/2 SS-BLK
(x20) 8x2-1/2



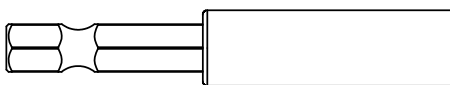
H101434 SCREW TFH 8X3 1/4 SS-BLK
(x14) 8x3 1/4




H101165 CONCRETE ANCHOR 3/8"x3" BLK
(x6) 3/8x3"



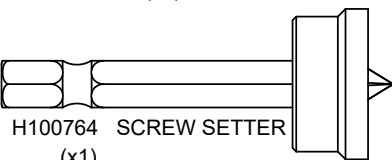
H101106 HEX DRIVER
(x1) 5/16



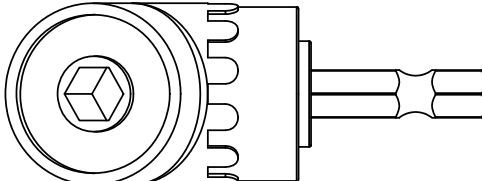
H101100 MAGNETIC DRIVER
(x1)



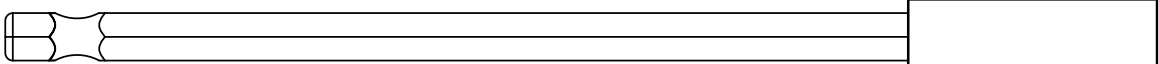
H100114 TORX WRENCH
(x1) T-30




H100764 SCREW SETTER
(x1)



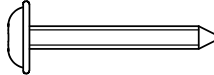
H101114 RIGHT ANGLE DRILL ADAPTER
(x1)



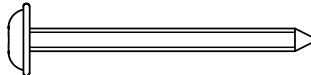
H101278 6" MAGNETIC DRIVER EXTENSION
(x1)



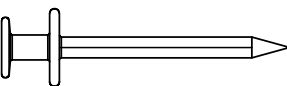
H101437 SCREW TWH 8x5/8 SS-BLK
(x12) 8x5/8



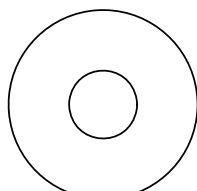
H101440 SCREW TWH 8x1 SS-BLK
(x5) 8x1



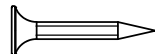
H101443 SCREW TWH 8x1 1/2 SS-BLK
(x12) 8x1-1/2



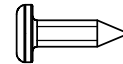
H101468 SCREW RAISED HEAD 8x1
(x8) 8x1



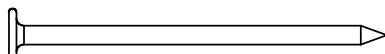
H101403 POLY WASHER
(x4)



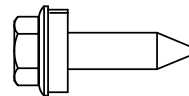
H100627 SCREW PFH BLK
(x2) 6x3/4



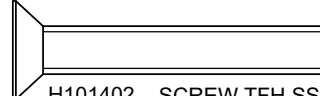
H101409 SCREW PPH 4x1/2 BLK
(x10) 4x1/2



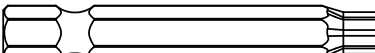
H101413 NAIL STD HD GLV
(x28)



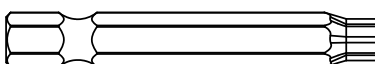
H101117 SCREW WOODGRIP
(x60) 10x3/4



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



H100147 TORX BIT
(x1) T-30



H100879 TORX BIT
(x1) T-20

PRE-ASSEMBLY STEP 1 - SORTING PARTS

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

WOOD PARTS:

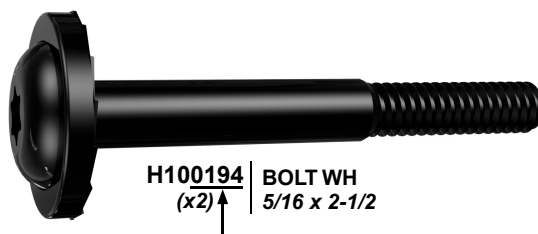
- Organize wood parts by the three-digit, alpha-numeric number stamped on each board (ex. P01).
- If there are multiple boards with the same stamped number, stack those pieces together.
- Stamps can be found on the flat surface of the boards or on the end of the boards.
- Allow yourself plenty of room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

NOTE: CARTONS ARE NOT ORGANIZED BY BOARD NUMBER.



HARDWARE PARTS:

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



PRE-ASSEMBLY STEP 2 - TOOLS REQUIRED



Cordless Drill
or Electric Drill



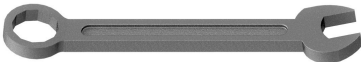
Drill
Attachments:
Phillips Head



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



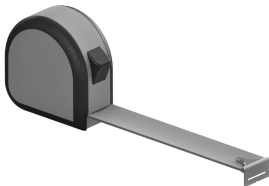
Phillips Screw Driver



Open End
Wrench 11/16"



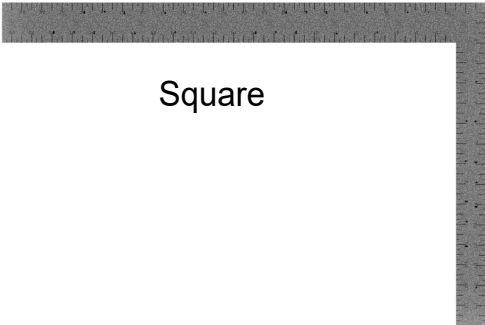
3/8" Drive Ratchet, 1/2" &
7/16" STD Sockets, 1/2" &
7/16" Deep Sockets



Tape Measure



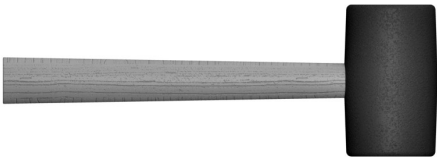
Claw Hammer



Square



Level 24"



Rubber Mallet
- Optional



Rope 25ft [7.62m] long - Optional

PRE-ASSEMBLY STEP 3 - CHOOSE YOUR ASSEMBLY METHOD

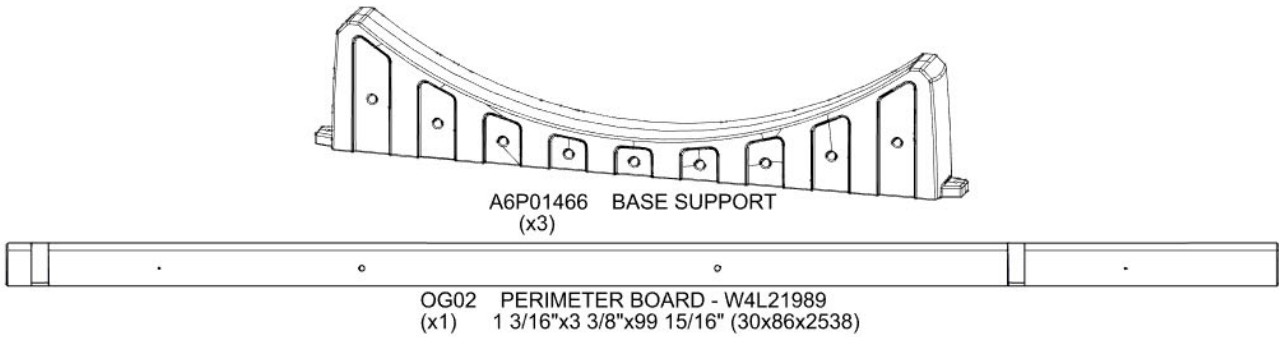
There are several types of assembly instructions available to you.

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

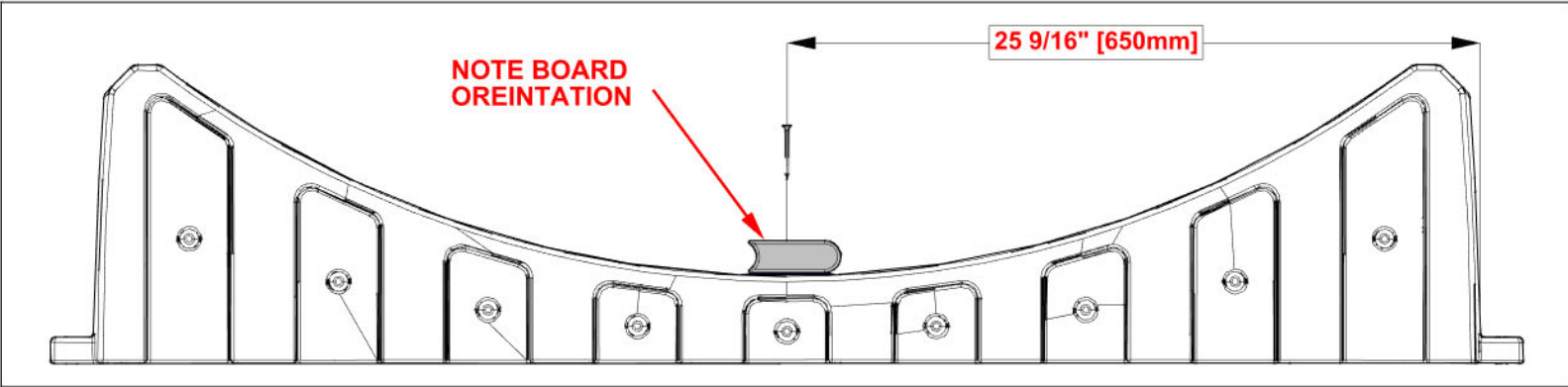


STEP 1 - BASE ASSEMBLY

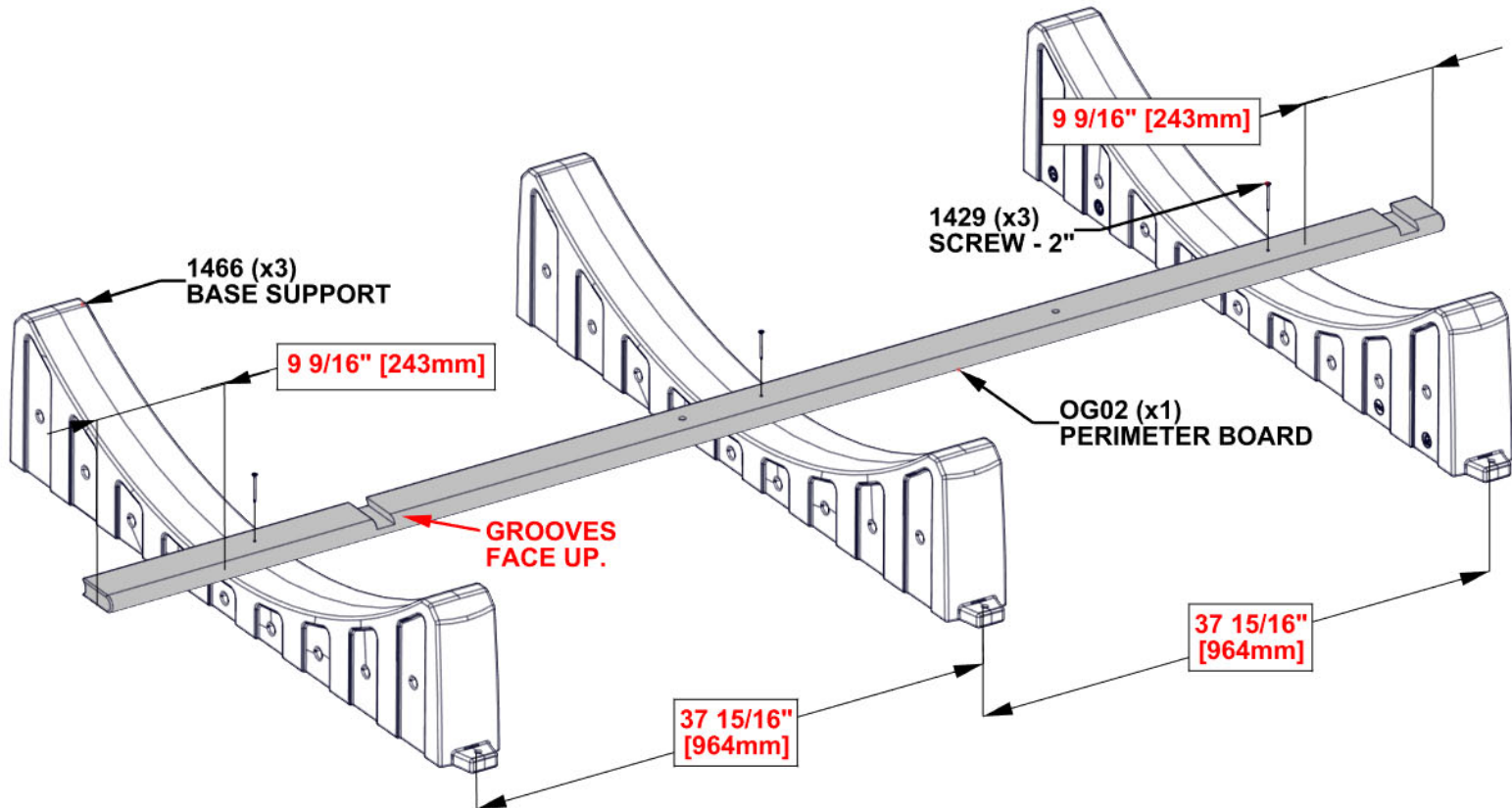
QTY	PART NUMBER	DESCRIPTION
3	H101429	SCREW TFH 8X2 SS-BLK



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



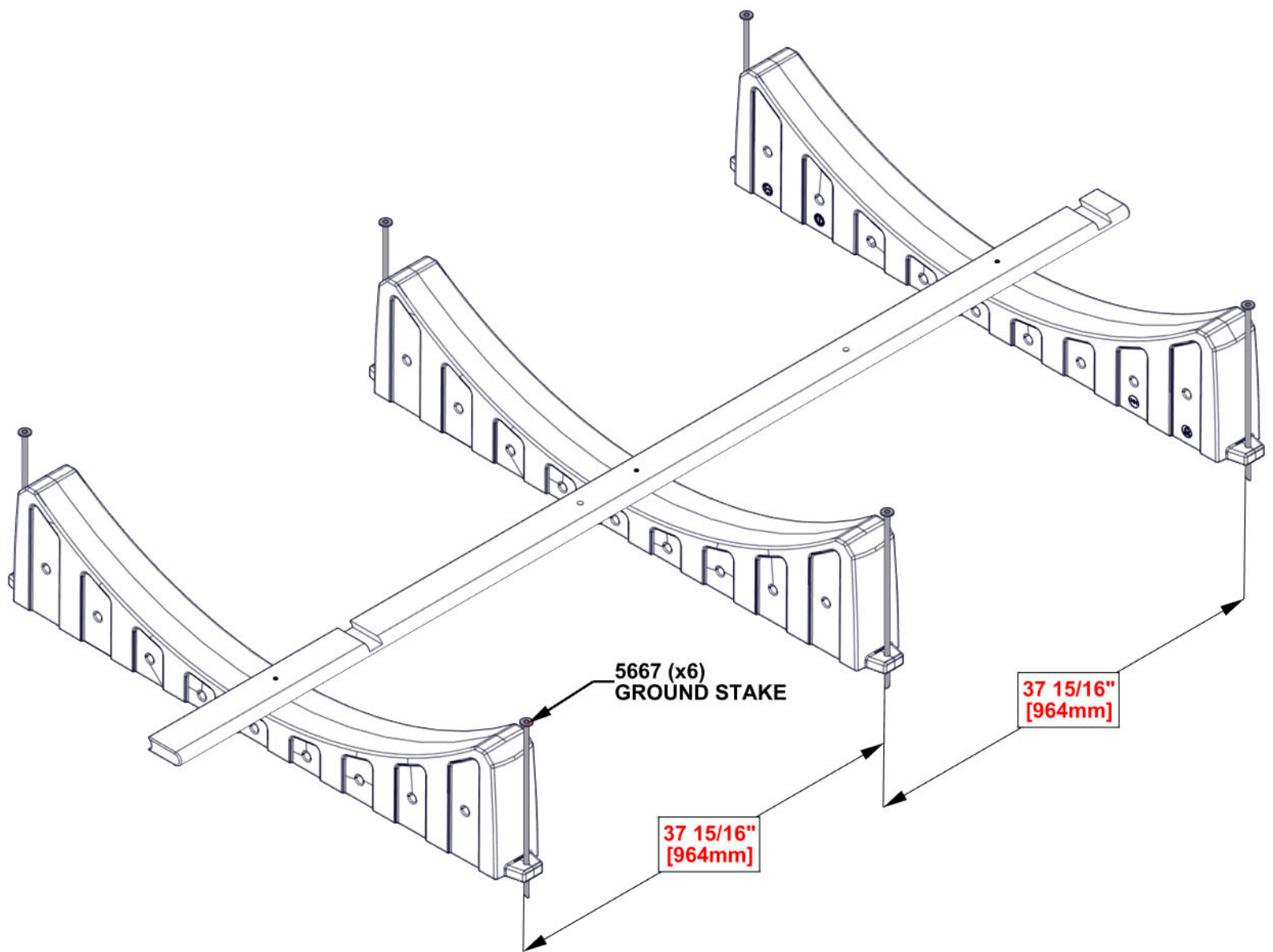
FRONT VIEW



STEP 2 - ANCHORING TO GROUND



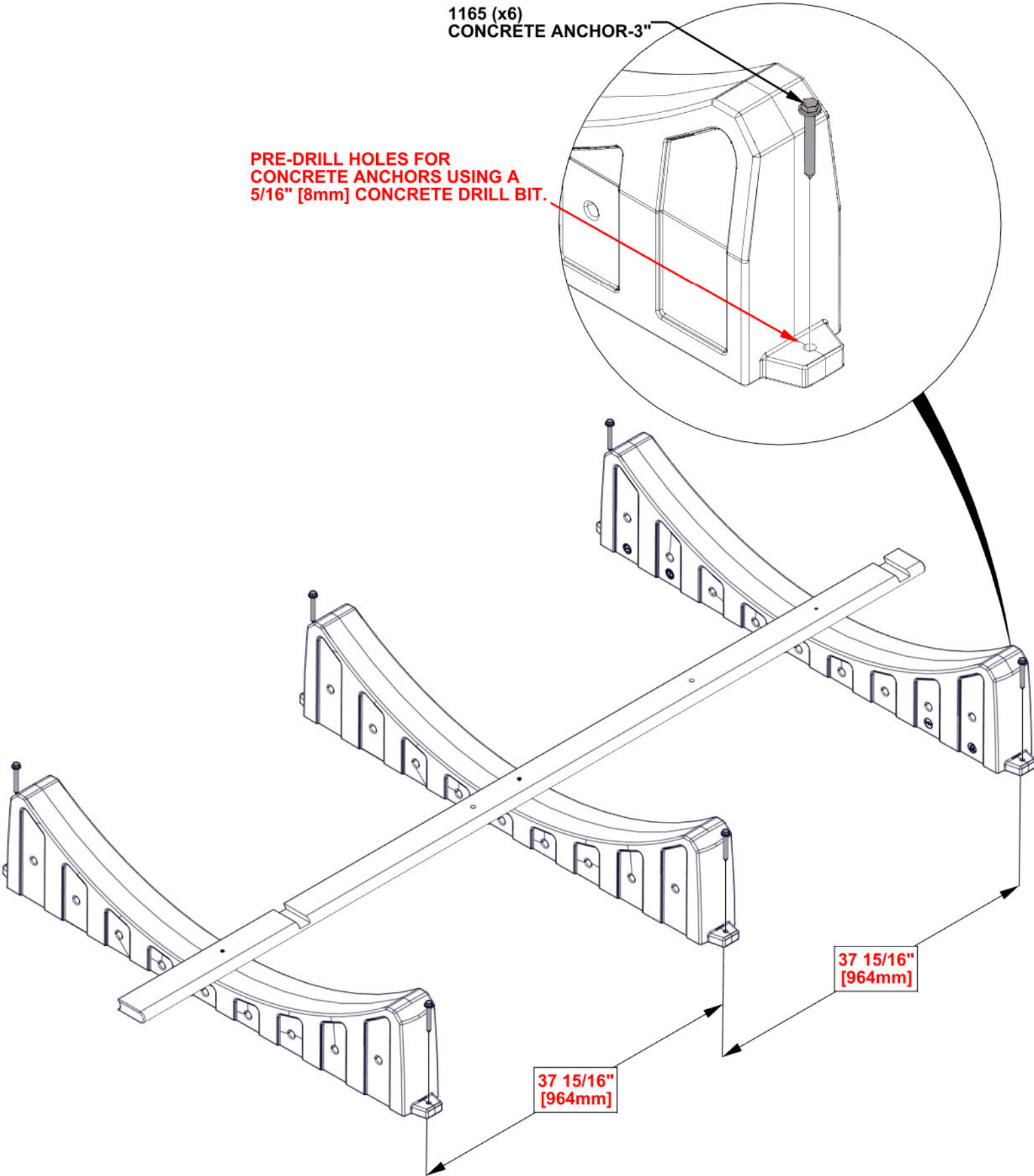
- IF SAUNA IS TO SIT ON A CONCRETE SURFACE, SEE STEP 3.



STEP 3 - ANCHORING TO CONCRETE

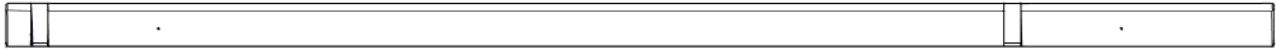
QTY	PART NUMBER	DESCRIPTION
6	H101165	CONCRETE ANCHOR 3/8x3" BLK

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

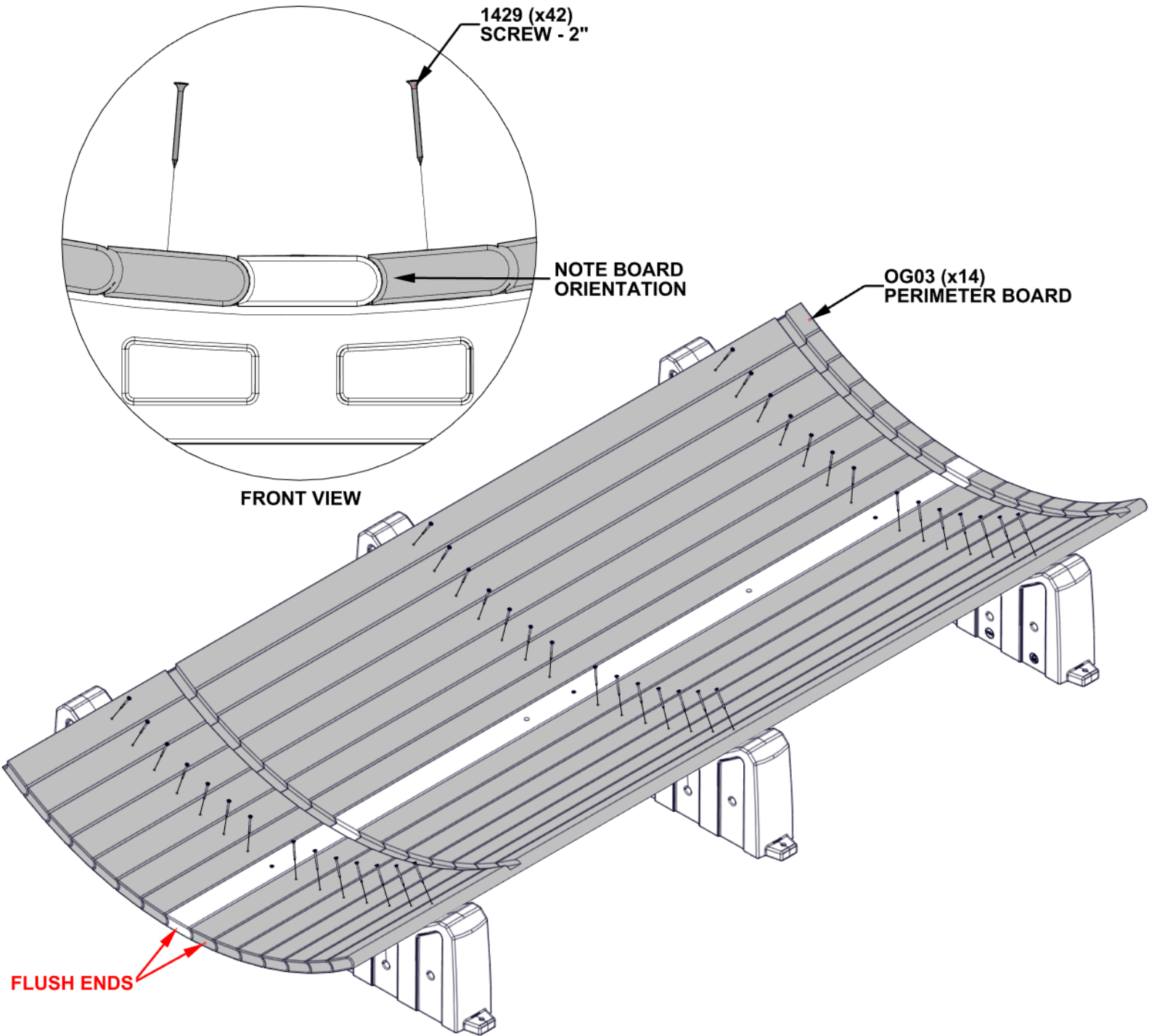


STEP 4 - BASE ASSEMBLY

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

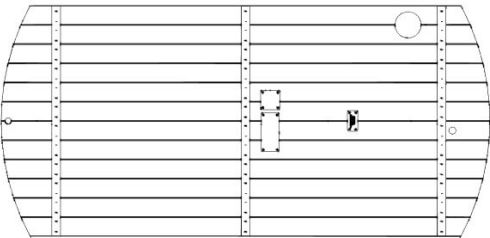


OG03 PERIMETER BOARD - W4L21990
(x14) 1 3/16"x3 3/8"x99 15/16" (30x86x2538)

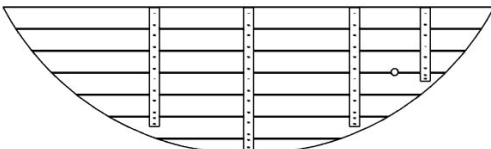


STEP 5 - BACK WALL ASSEMBLY

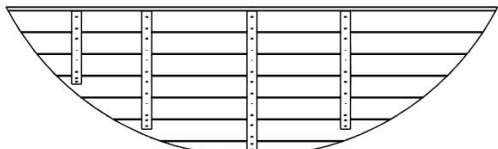
QTY	PART NUMBER	DESCRIPTION
32	H101429	SCREW TFH 8X2 SS-BLK



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)

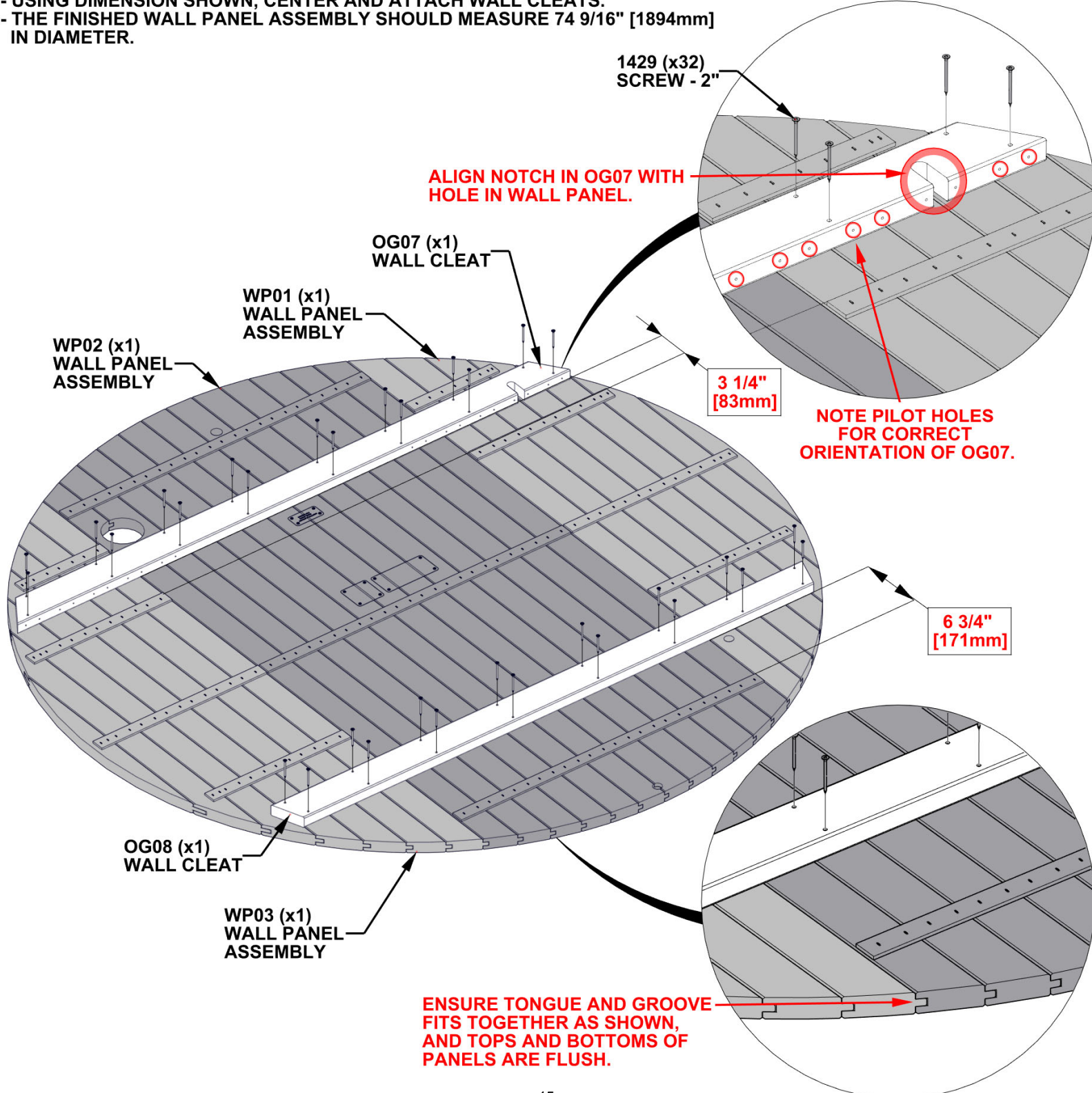


OG07 WALL CLEAT - W4L21867 (x1) 1 3/16"x3 3/8"x63 15/16" (30x86x1624)



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.

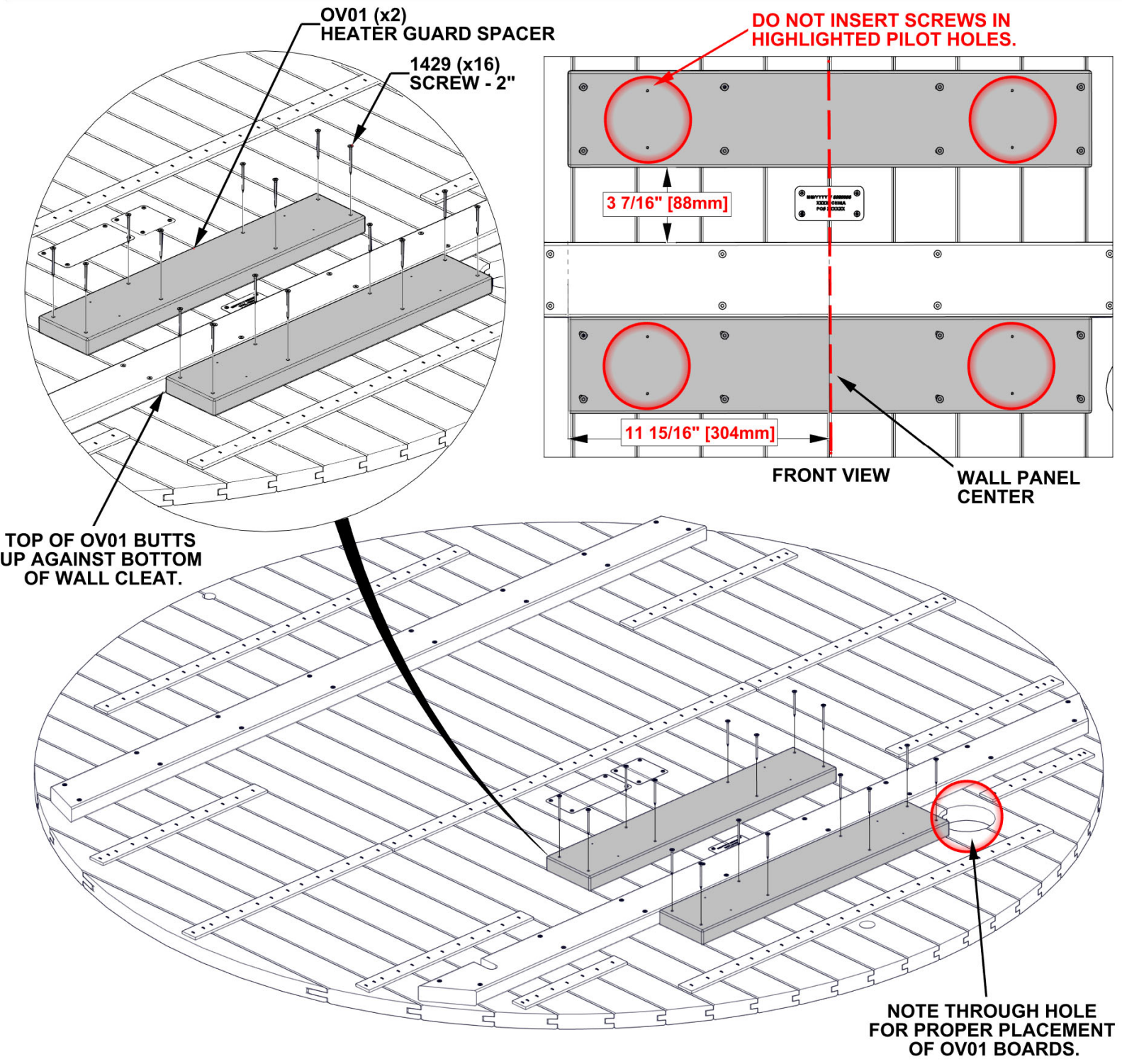


STEP 6 - BACK WALL ASSEMBLY

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



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



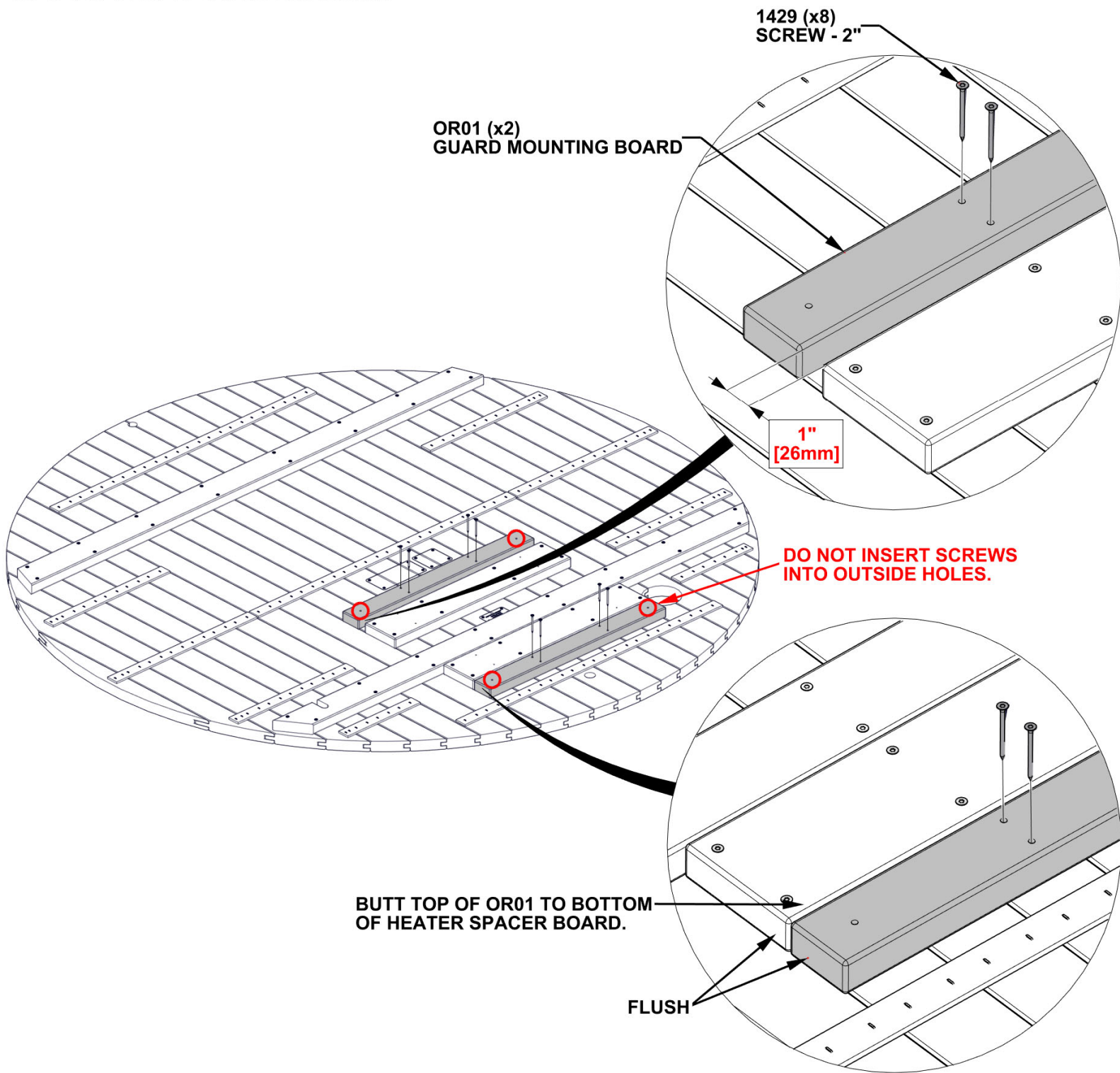
STEP 7 - BACK WALL ASSEMBLY

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



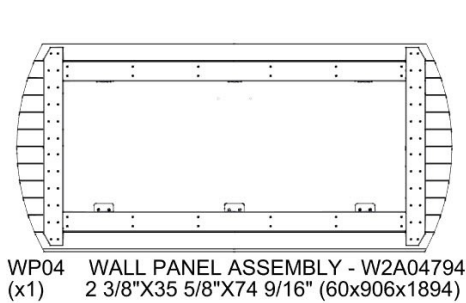
OR01 GUARD MOUNTING BOARD - W4L21873
(x2) 1 3/16"x2 3/8"x23 15/16" (30x60x608)

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

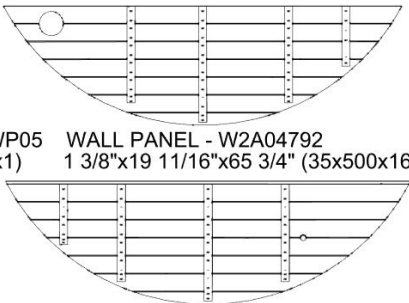


STEP 8 - FRONT WALL ASSEMBLY

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



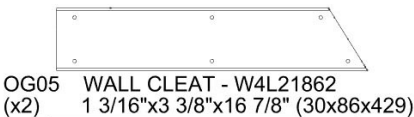
WP04 WALL PANEL ASSEMBLY - W2A04794 (x1)
2 3/8"X35 5/8"X74 9/16" (60x906x1894)



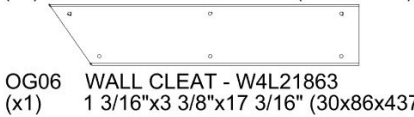
WP05 WALL PANEL - W2A04792 (x1)
1 3/8"x19 11/16"x65 3/4" (35x500x1669)



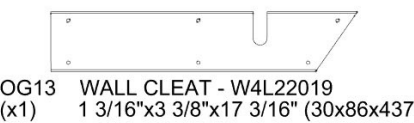
WP06 WALL PANEL ASSEMBLY - W2A04809 (x1)
1 3/8"x20 1/8"x66 1/4" (35x512x1682)



OG05 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)



OG13 WALL CLEAT - W4L22019 (x1)
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.

1429 (x24)
SCREW - 2"

NOTE HOLES IN OG06 & OG13 FOR CORRECT ORIENTATION.

BUTT END OF CLEATS TO DOOR FRAME AS SHOWN.

OG06 (x1)
WALL CLEAT

WP04 (x1)
WALL PANEL ASSEMBLY

WP05 (x1)
WALL PANEL ASSEMBLY

OG13 (x1)
WALL CLEAT

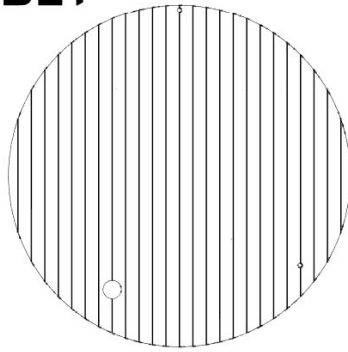
7 7/8"
[200mm]

WP06 (x1)
WALL PANEL ASSEMBLY

OG05 (x2)
WALL CLEAT

7 7/8"
[200mm]

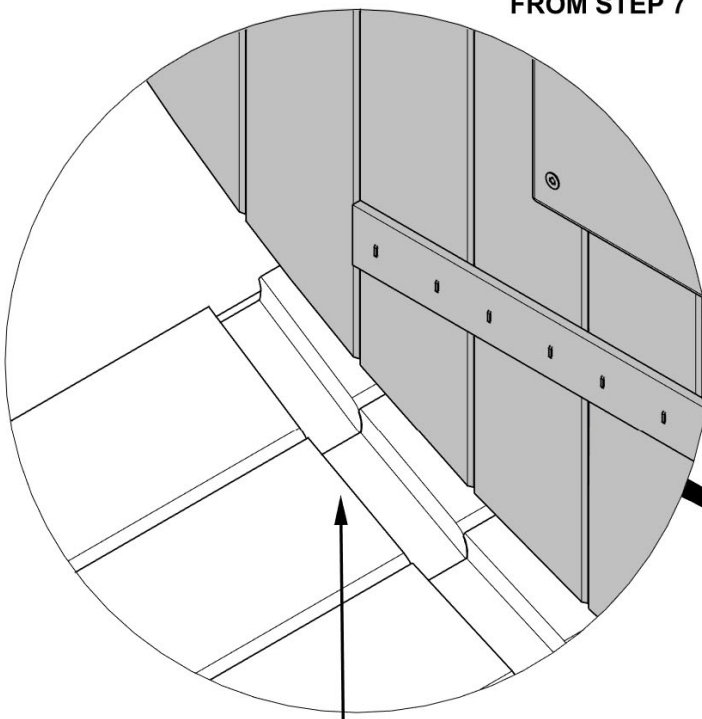
STEP 9 - SAUNA ASSEMBLY



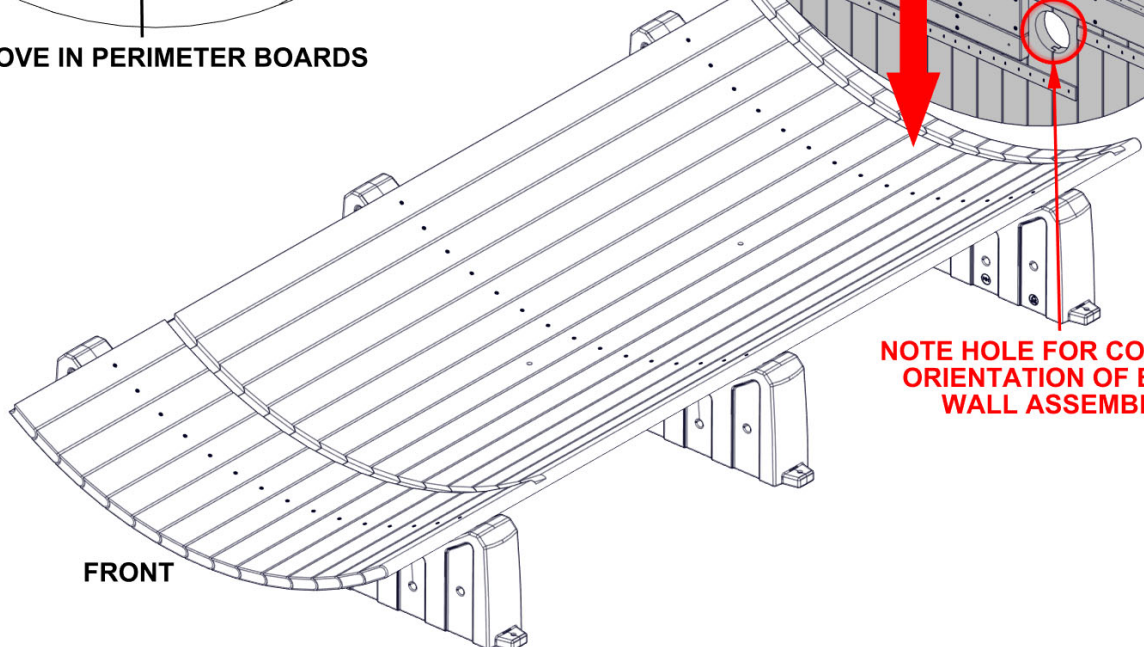
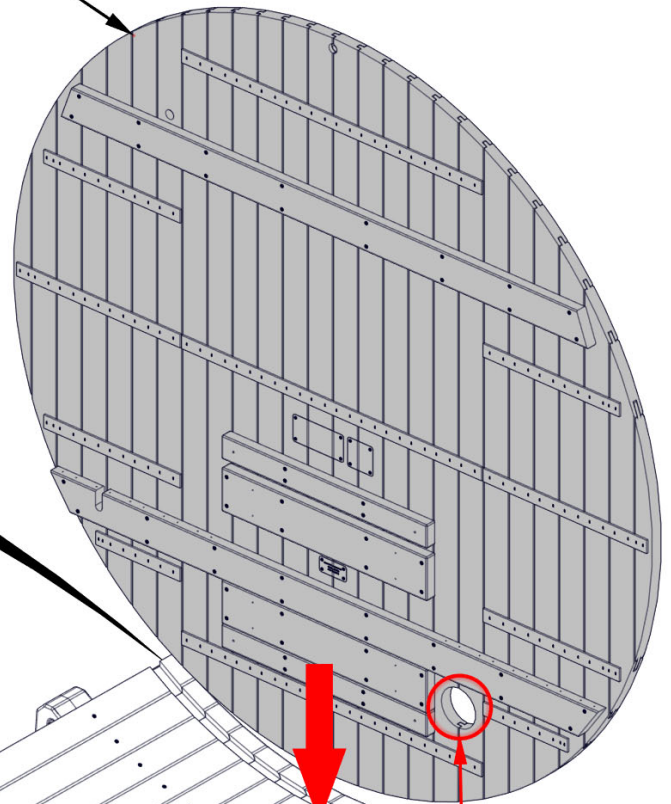
BACK WALL ASSEMBLY - FROM STEP 7

- 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.

BACK WALL ASSEMBLY
FROM STEP 7



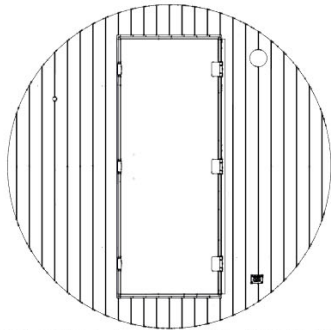
GROOVE IN PERIMETER BOARDS



NOTE HOLE FOR CORRECT
ORIENTATION OF BACK
WALL ASSEMBLY.

FRONT

STEP 10 - SAUNA ASSEMBLY

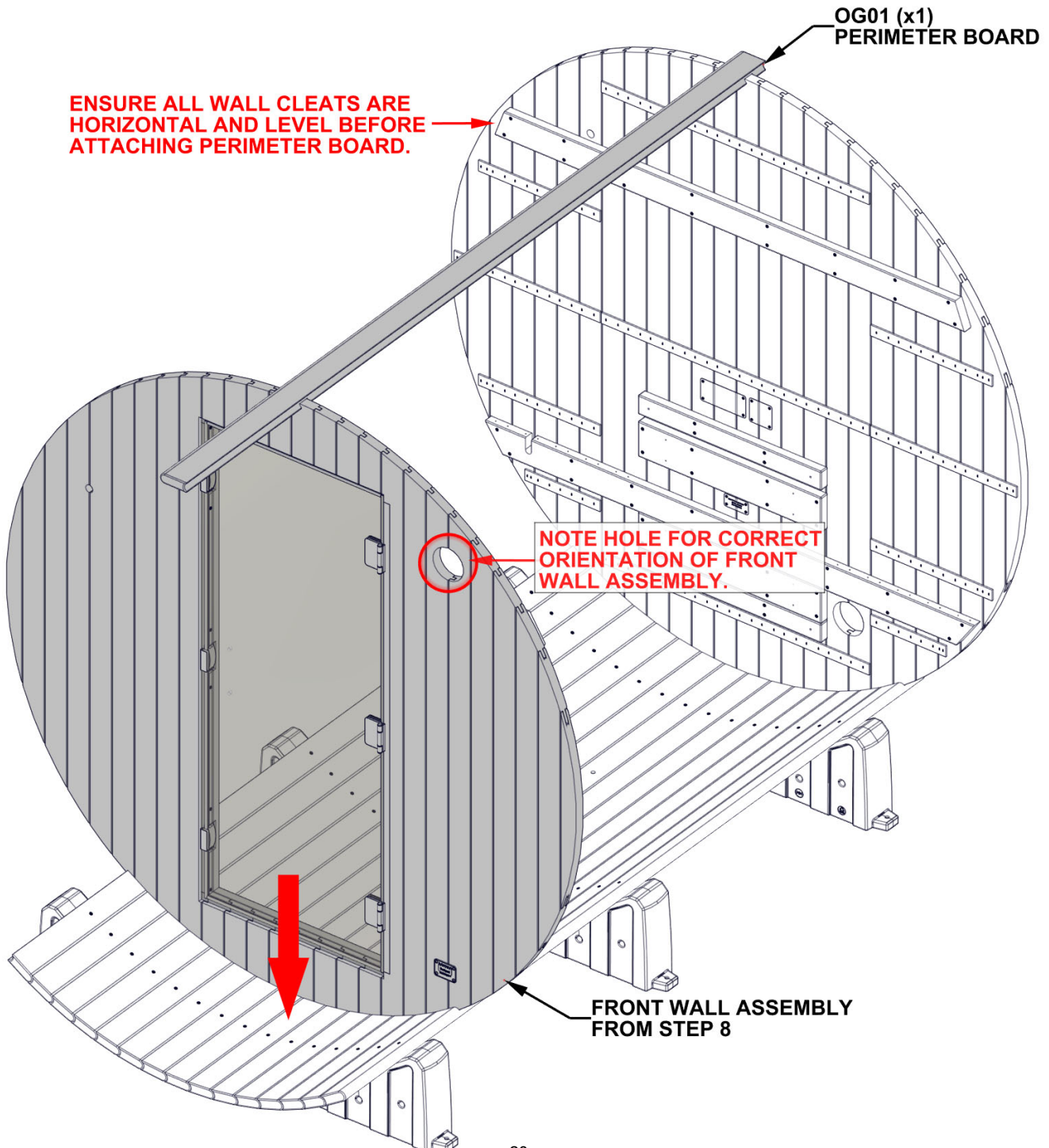


FRONT WALL ASSEMBLY - FROM STEP 8



OG01 PERIMETER BOARD - W4L21988
(x1) 1 3/16"x3 3/8"x99 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.



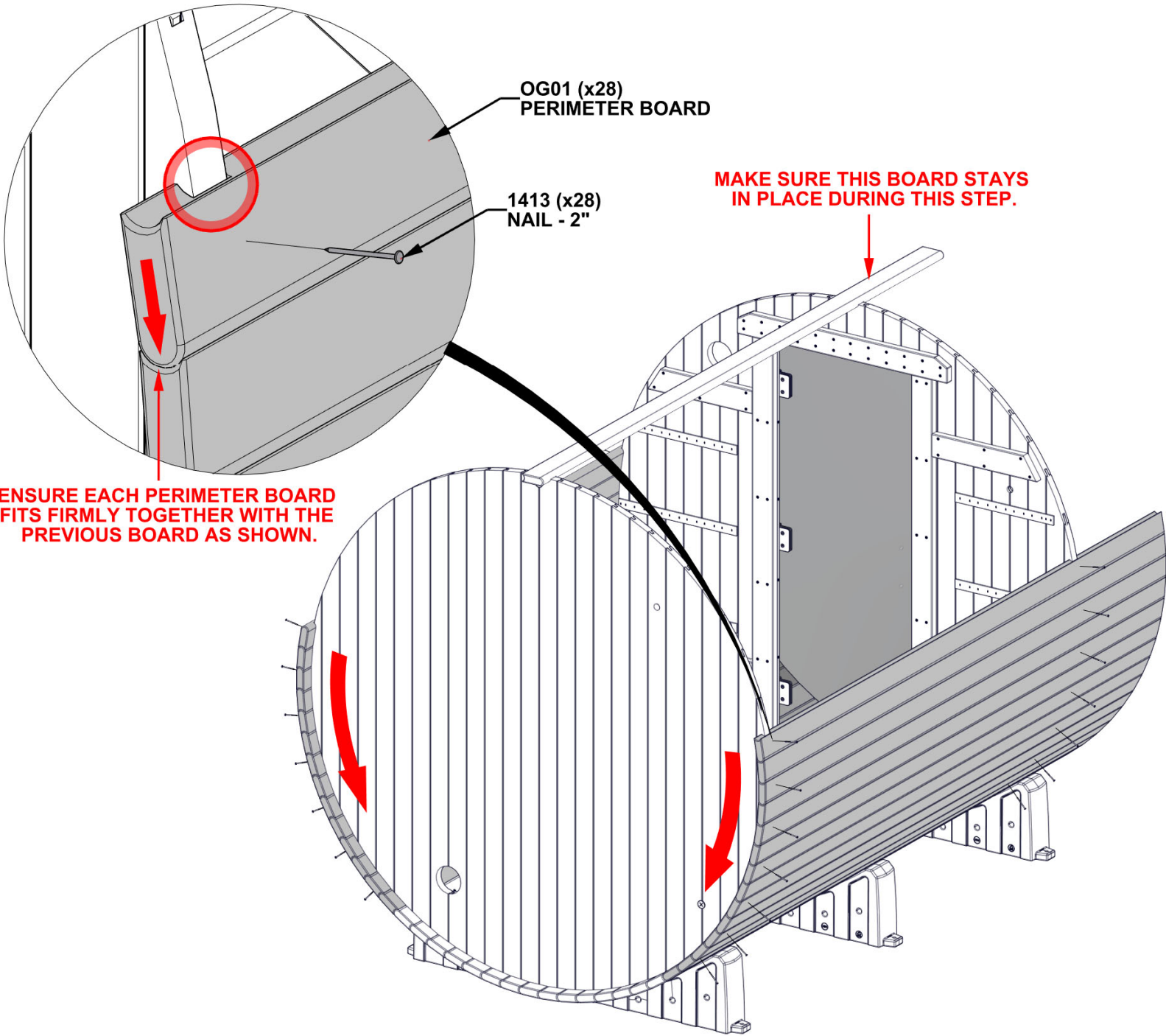
STEP 11 - SAUNA ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
28	H101413	NAIL STD 2.5x50 GLV



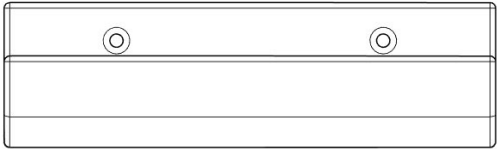
OG01 PERIMETER BOARD - W4L21988
(x28) 1 3/16"x3 3/8"x99 15/16" (30x86x2538)

- 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.

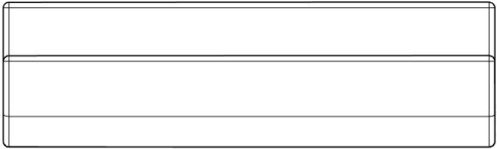


STEP 12 - HANDLE ASSEMBLY

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

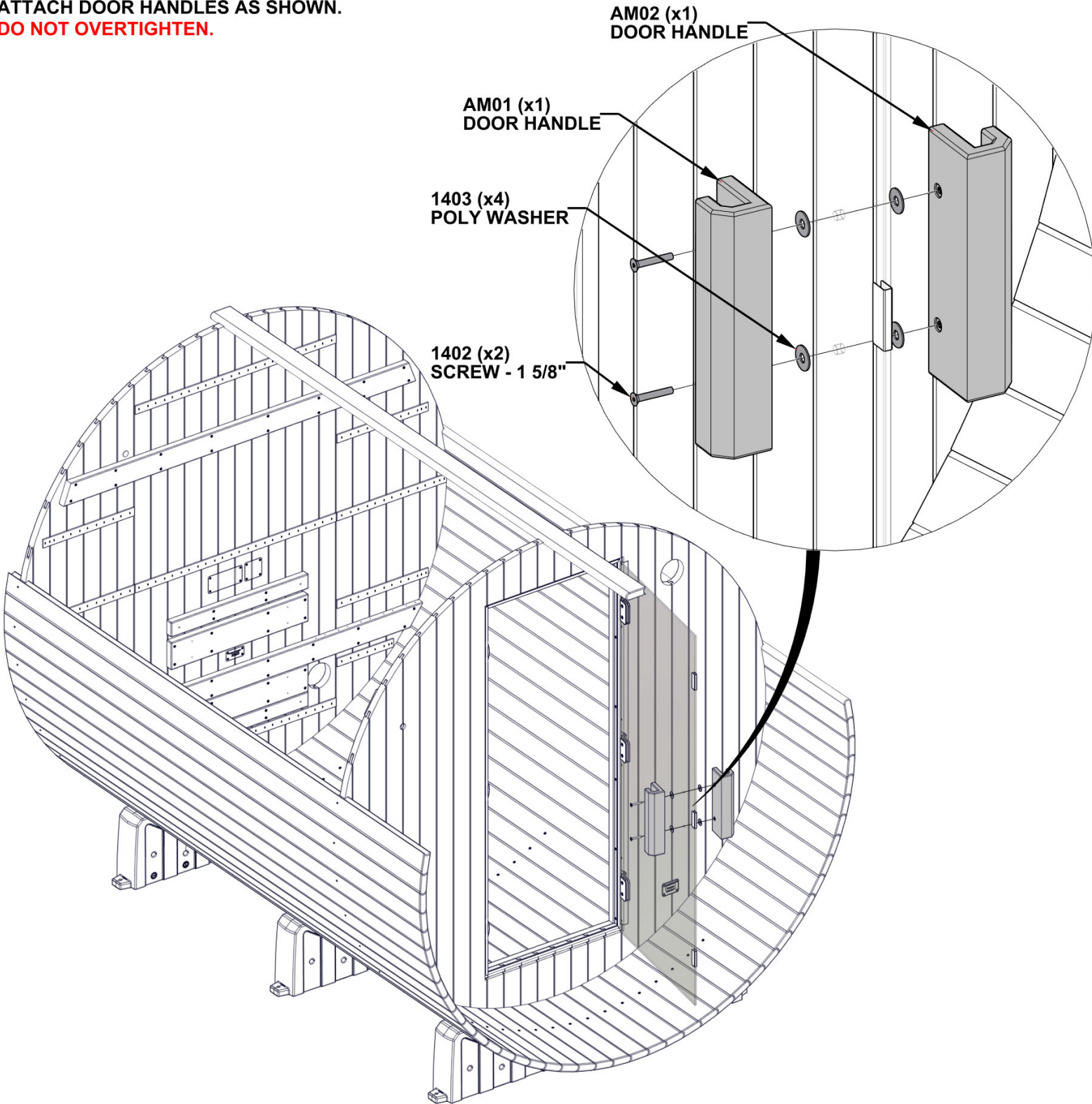


AM01 DOOR HANDLE - W4L21861
(x1) 2 1/4"x3"x10 3/16" (57x76x258)



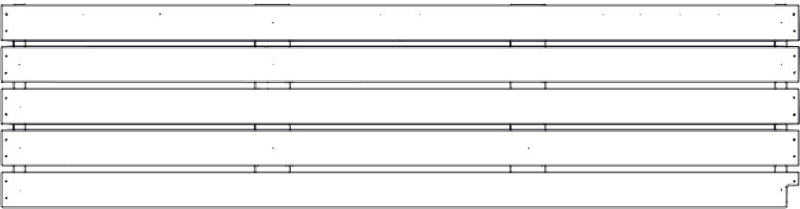
AM02 DOOR HANDLE - W2A04795
(x1) 2 1/4"x3"x10 3/16" (57x76x258)

- 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

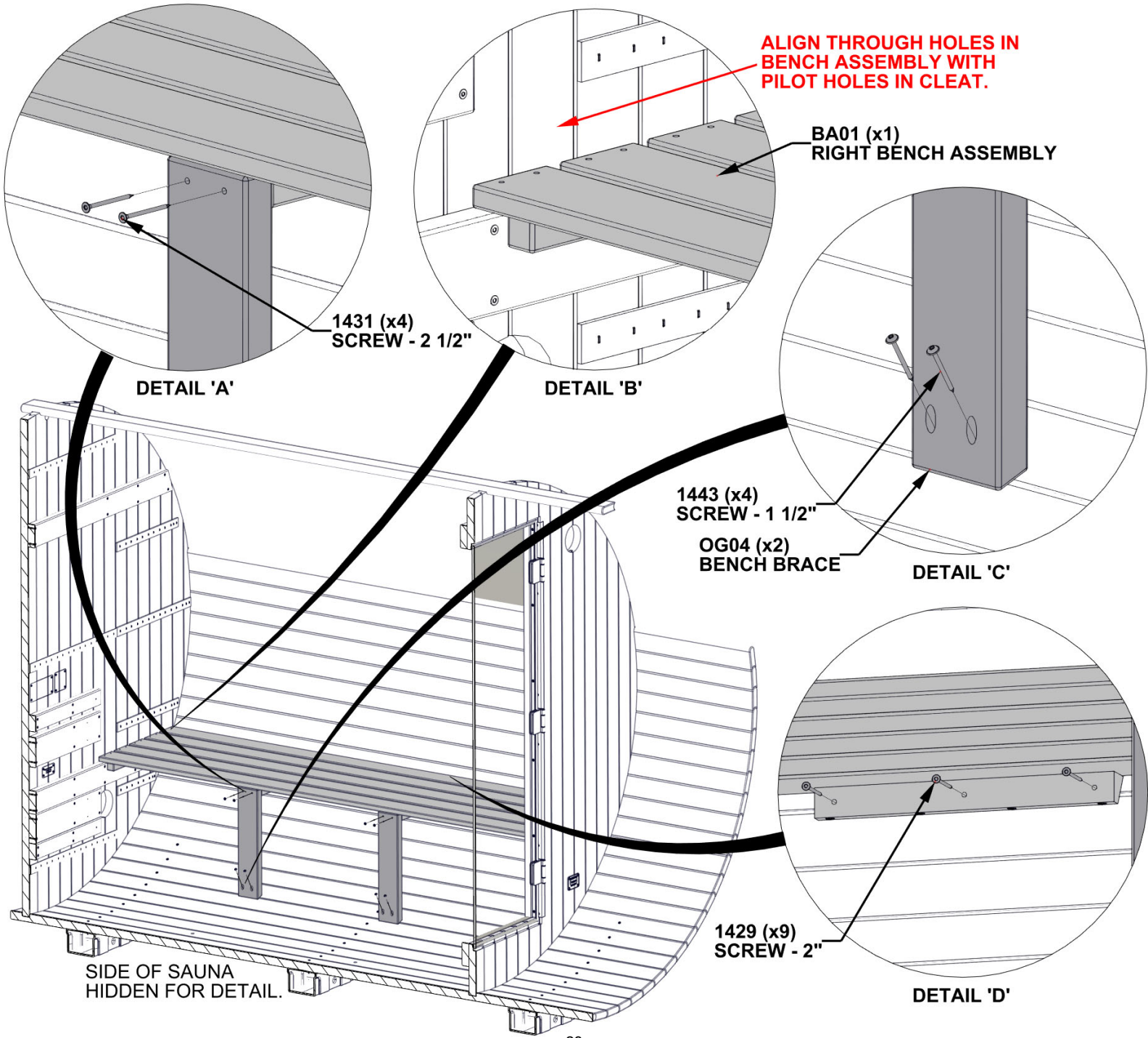


BA01 RIGHT BENCH ASSEMBLY - W2A04826
(x1) 1 15/16"x19 1/8"x75 1/4" (50x486x1912)



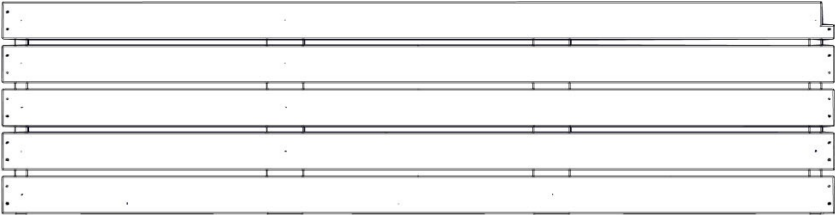
OG04 BENCH BRACE - W4L21860
(x2) 1 3/16"x3 3/8"x16 3/8" (30x86x416)

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



STEP 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)

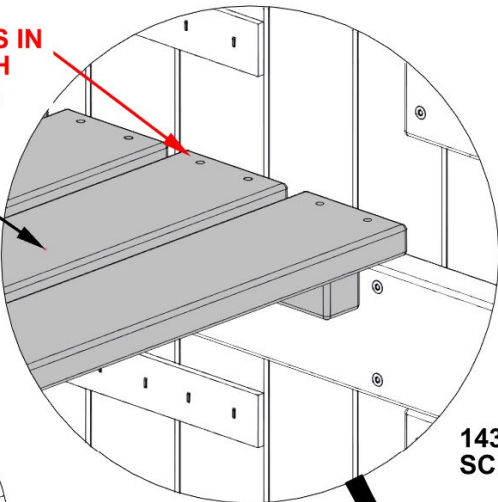


OG04 BENCH BRACE - W4L21860
(x2) 1 3/16"3 3/8"16 3/8" (30x86x416)

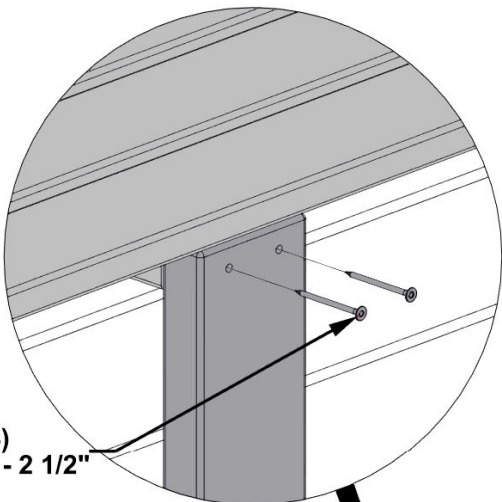
- 1) INSTALL BENCH BRACE OG04 TO BENCH ASSEMBLY. (DETAIL 'A')
- 2) PUSH THE BENCH WITH BENCH BRACE BOARD AGAINST THE WALL UNTIL IT MAKES CONTACT WITH THE SIDEWALL.
- 3) CHECK THE ALIGNMENT OF THE HOLES ON EACH END OF THE BENCH WITH THE PILOT HOLES ON THE CLEATS MOUNTED TO THE WALL. (DETAIL 'B')
- 4)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

ALIGN THROUGH HOLES IN
BENCH ASSEMBLY WITH
PILOT HOLES IN CLEAT.

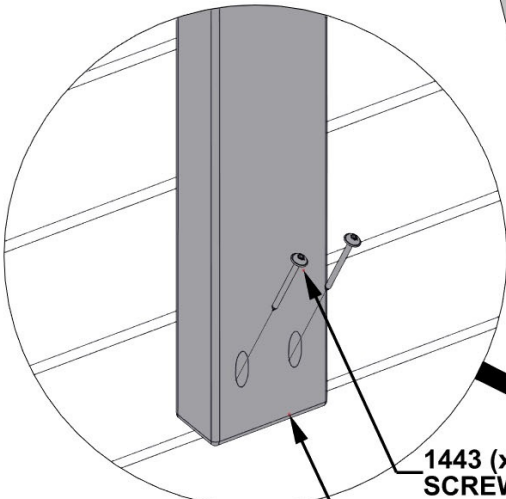
BA02 (x1)
LEFT BENCH ASSEMBLY



DETAIL 'B'

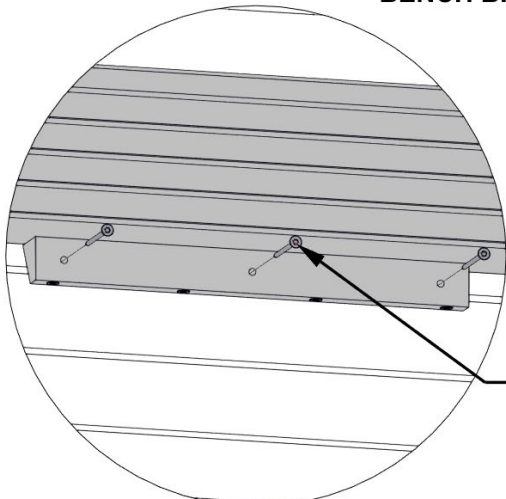


DETAIL 'A'



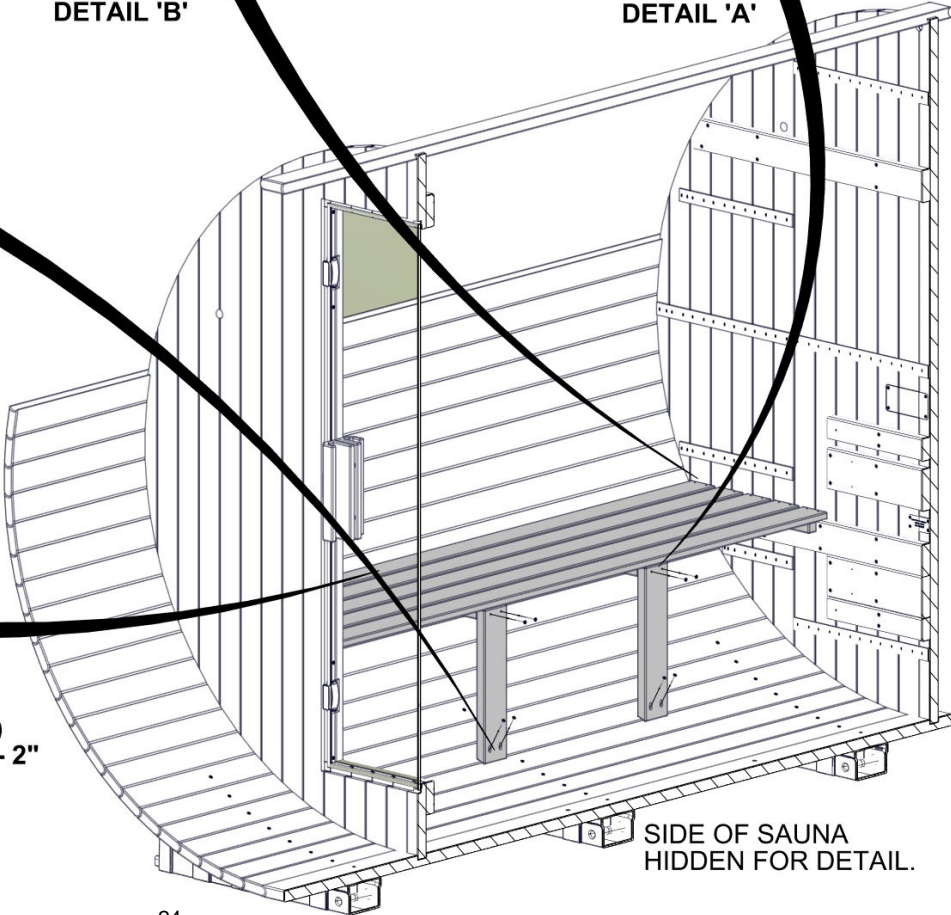
DETAIL 'C'

1443 (x4)
SCREW - 1 1/2"
OG04 (x2)
BENCH BRACE



DETAIL 'D'

1429 (x9)
SCREW - 2"

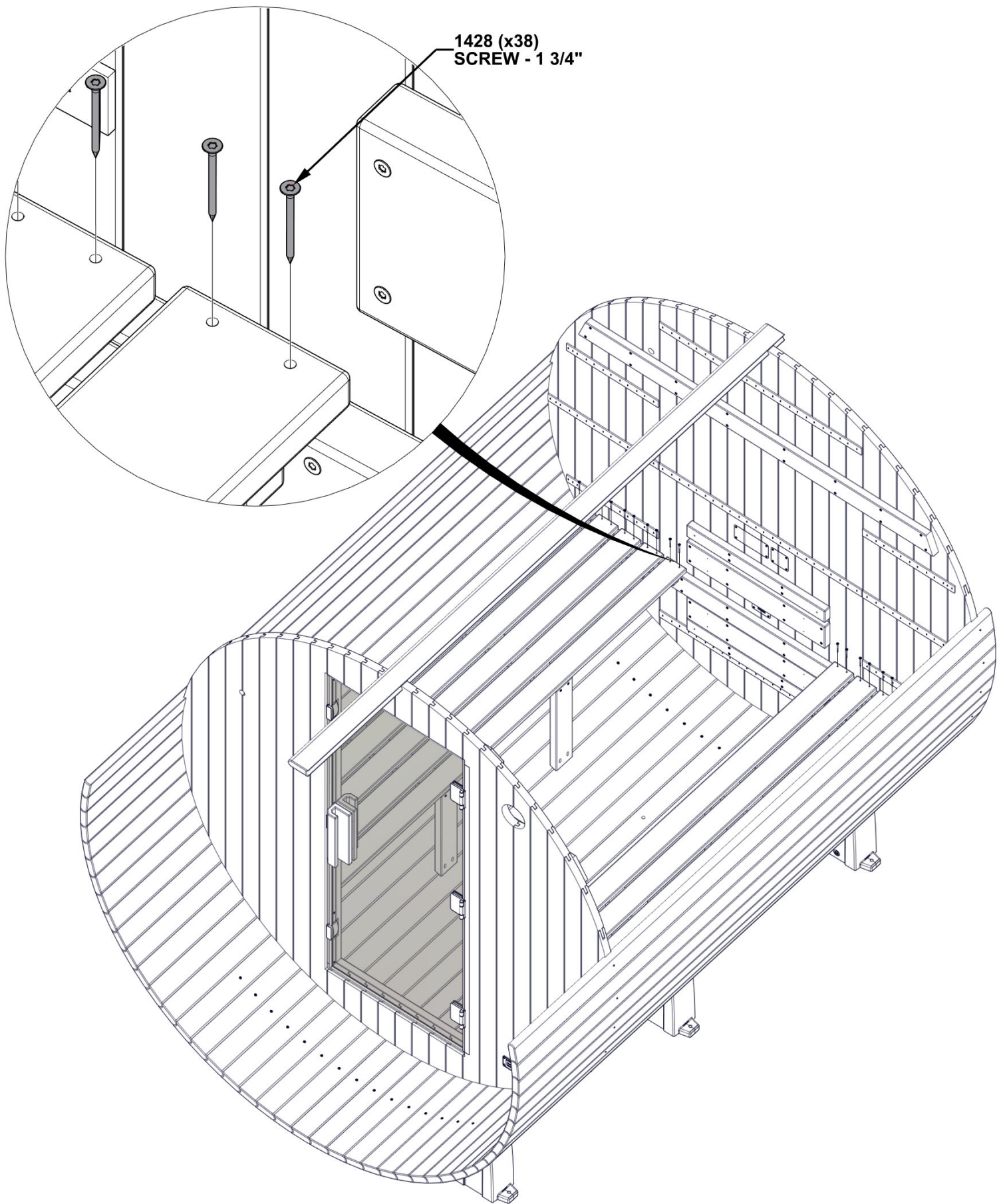


SIDE OF SAUNA
HIDDEN FOR DETAIL.

STEP 15 - BENCH ASSEMBLY

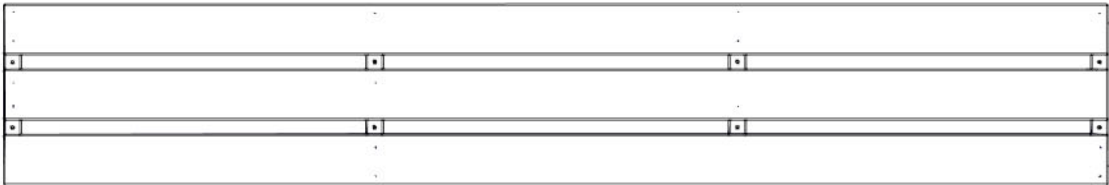
QTY	PART NUMBER	DESCRIPTION
38	H101428	SCREW TFH 8X1 3/4 SS-BLK

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



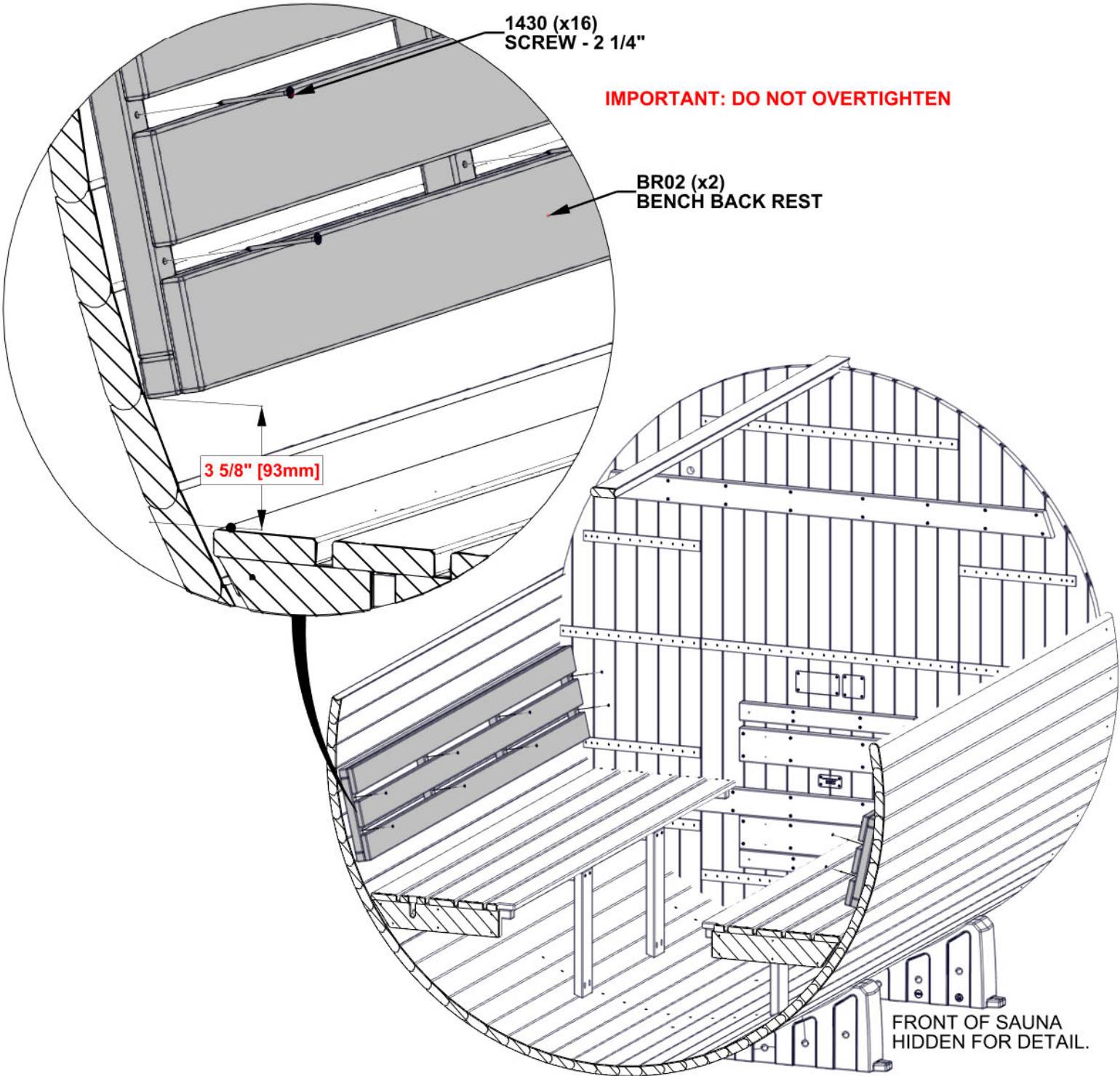
STEP 16 - BENCH ASSEMBLY

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

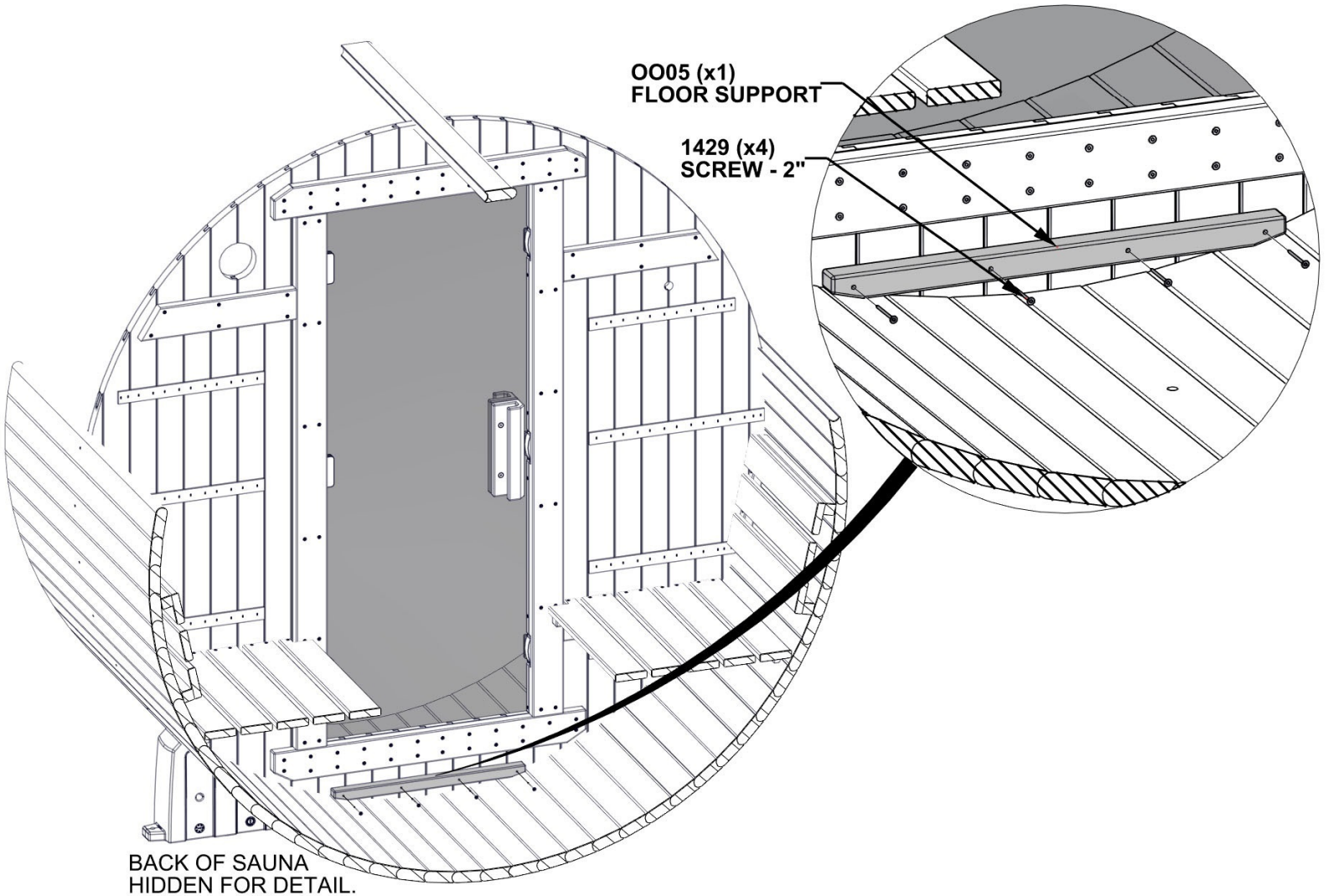
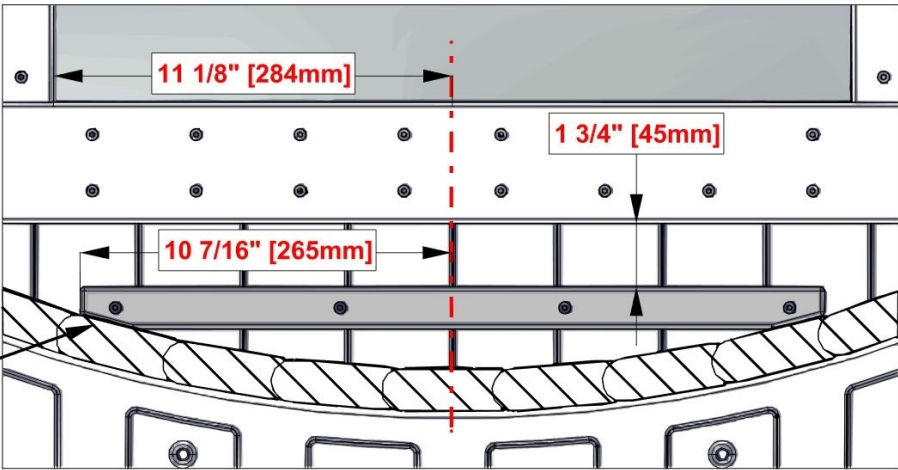
QTY	PART NUMBER	DESCRIPTION
4	H101429	SCREW TFH 8X2 SS-BLK



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

SUPPORT BOARD WILL REST ON FLOOR.



STEP 18 - FLOOR CLEAT INSTALLATION

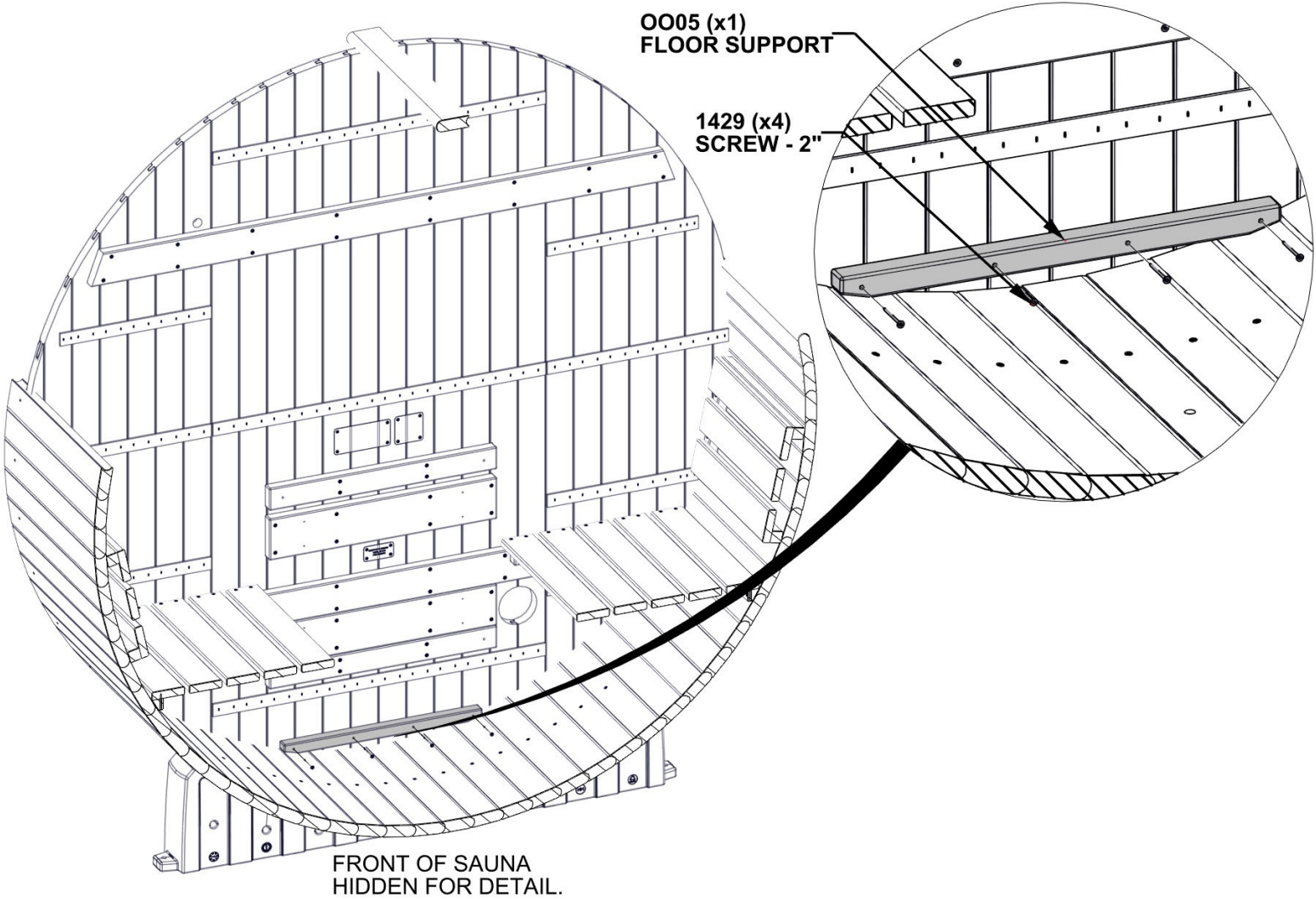
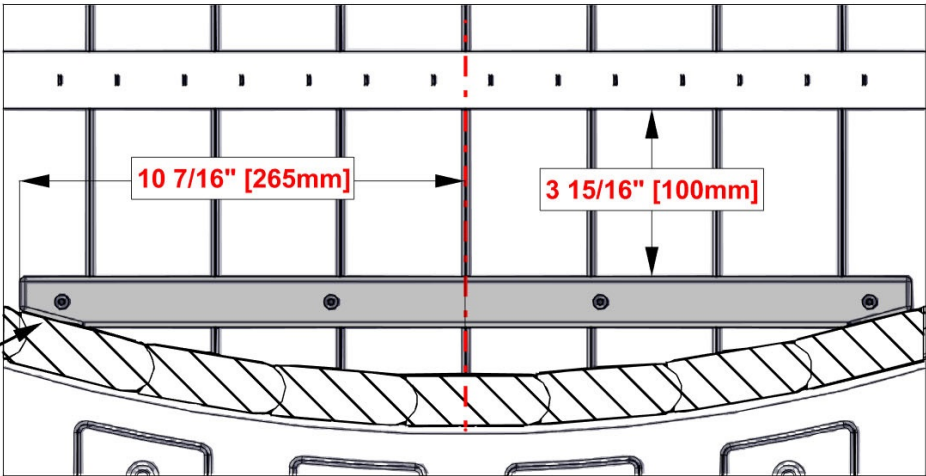
QTY	PART NUMBER	DESCRIPTION
4	H101429	SCREW TFH 8X2 SS-BLK



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.**

SUPPORT BOARD WILL REST ON FLOOR.



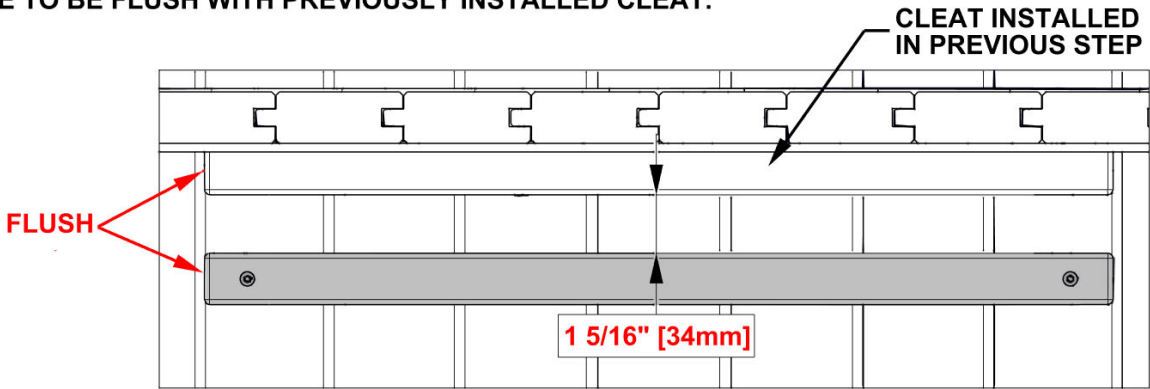
STEP 19 - FLOOR CLEAT INSTALLATION

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

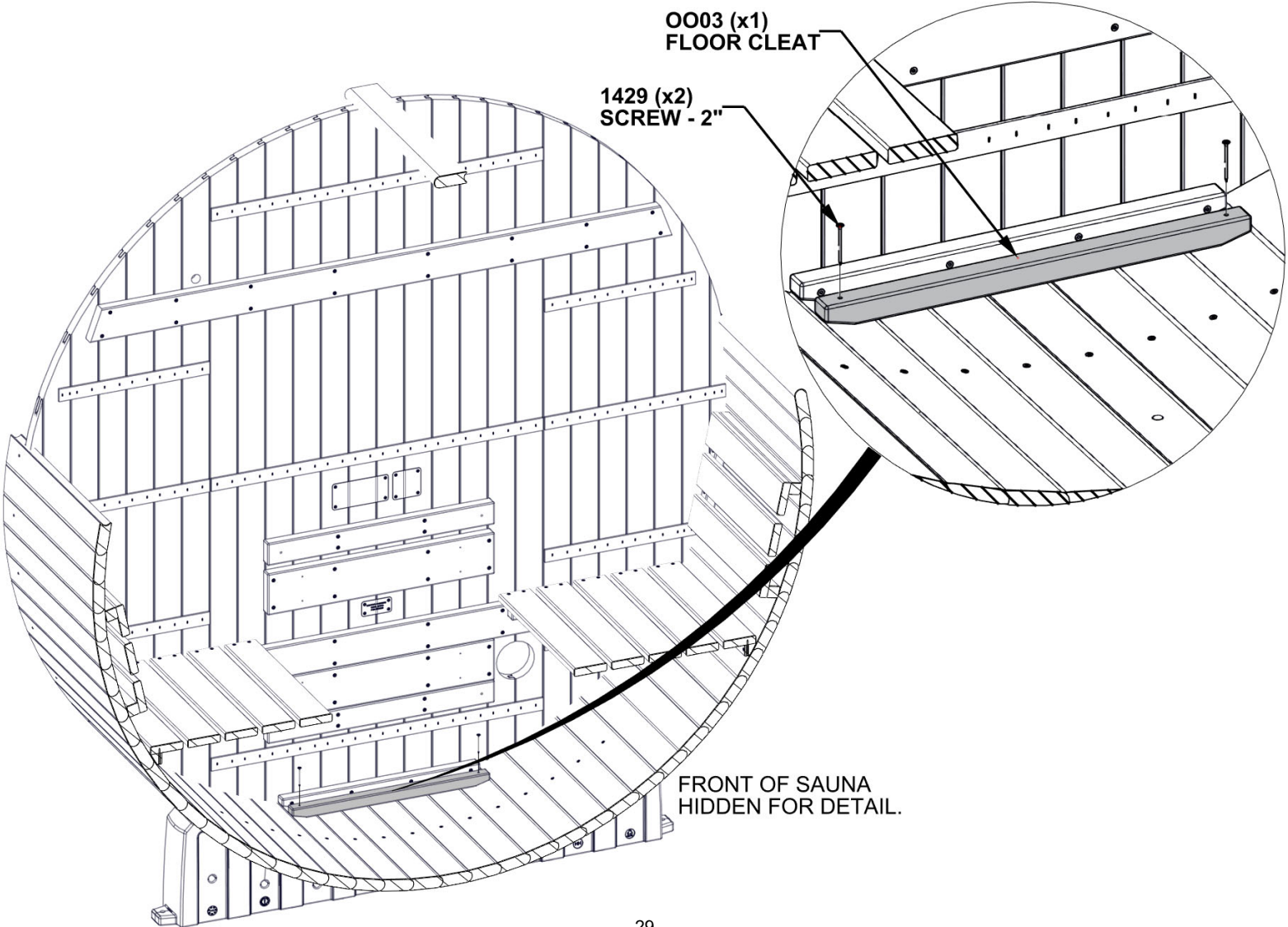


OO03 FLOOR CLEAT - W4L21964
(x1) 1 3/16"1 3/16"20 7/8" (30x30x530)

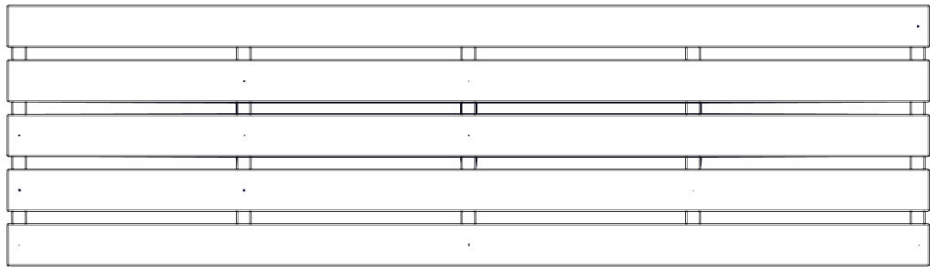
- LOCATE OO03 BOARD USING DIMENSION SHOWN.
- ENDS ARE TO BE FLUSH WITH PREVIOUSLY INSTALLED CLEAT.



TOP VIEW

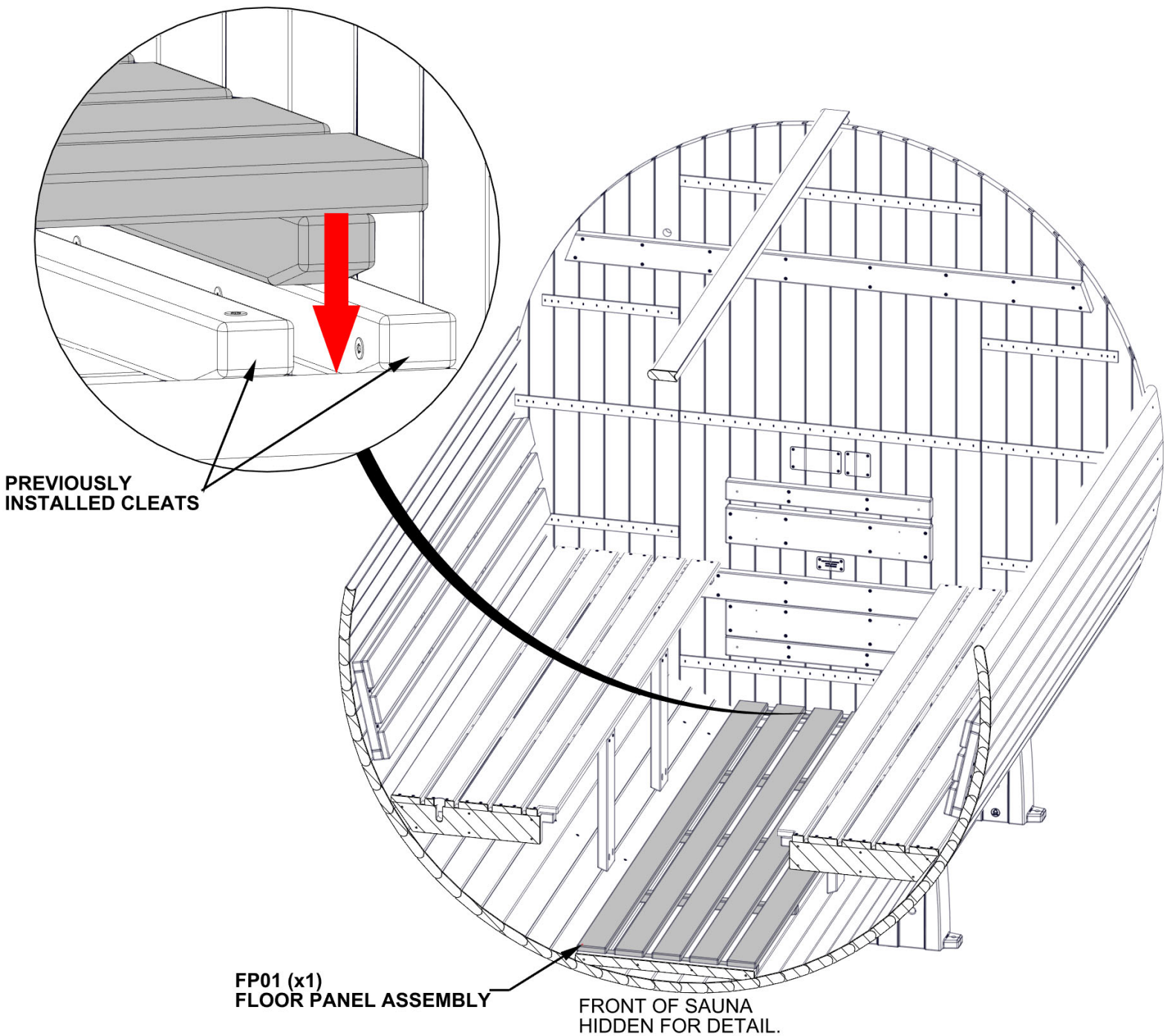


STEP 20 - FLOOR INSTALLATION



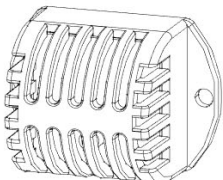
FP01 FLOOR PANEL ASSEMBLY - W2A04829
(x1) 1 15/16"x20 7/8"x73 7/8" (50x530x1876)

- 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.

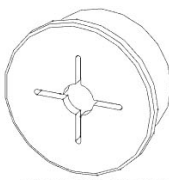


STEP 21 - TEMPERATURE SENSOR INSTALLATION

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

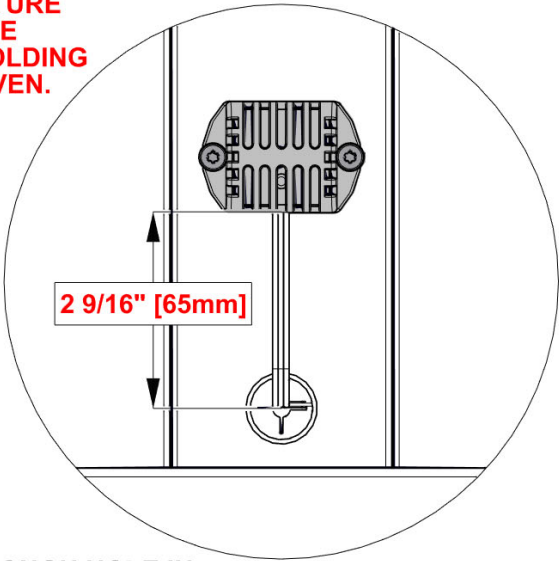


A4M05590-08 TEMPERATURE SENSOR (x1)



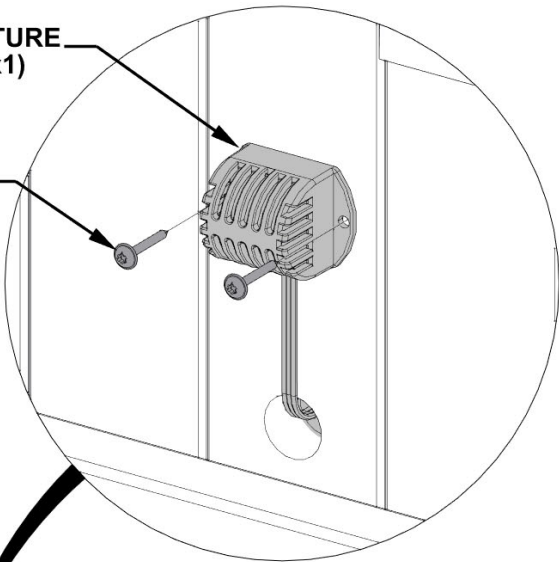
A6P01467 SILICON GROMMET 25mm (x1)

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

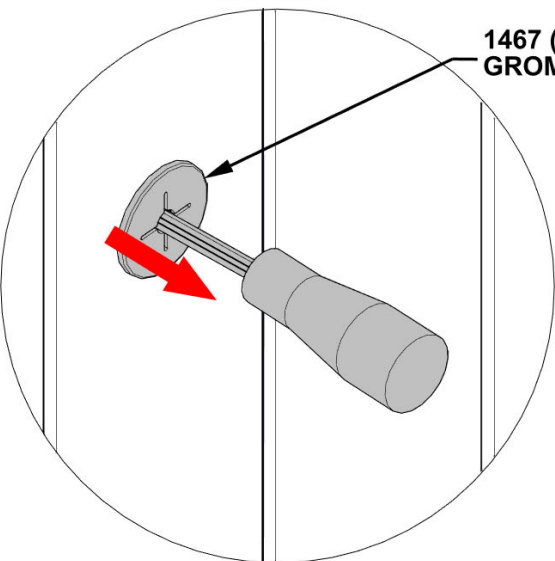


TEMPERATURE SENSOR (x1)

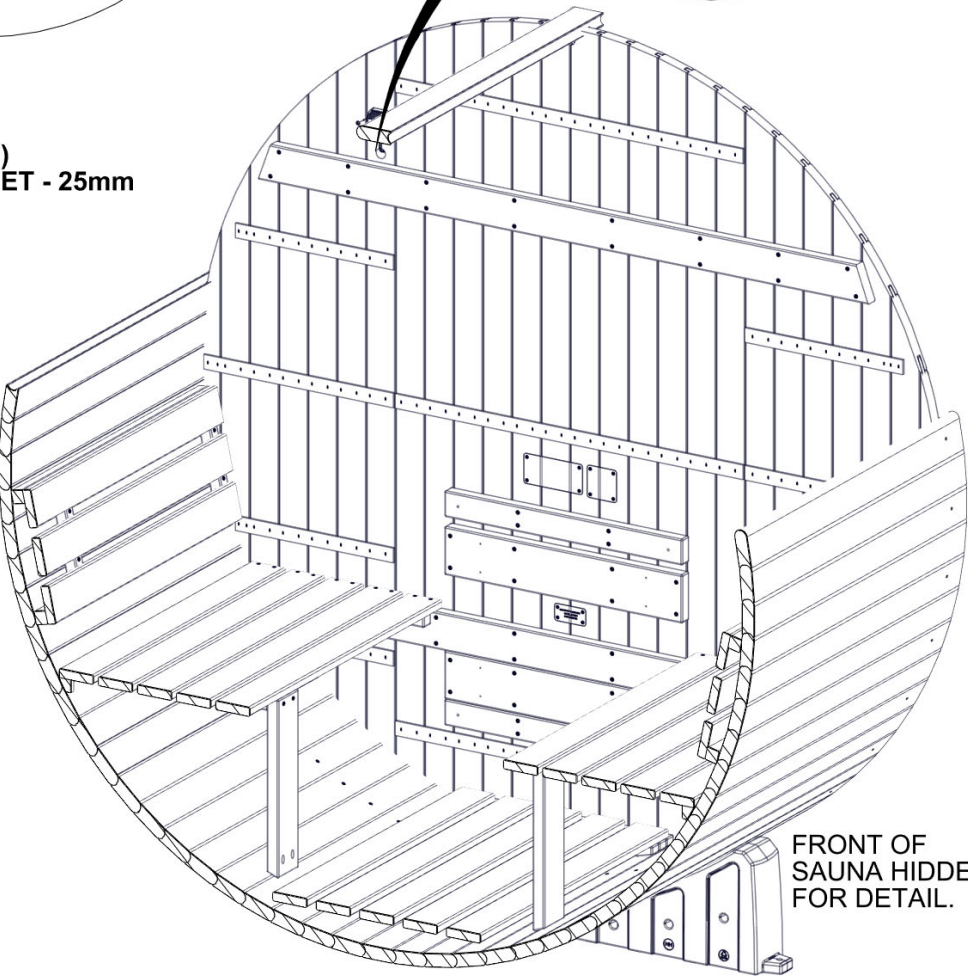
1440 (x2) SCREW - 1"



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



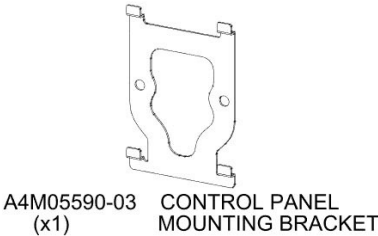
BACK VIEW



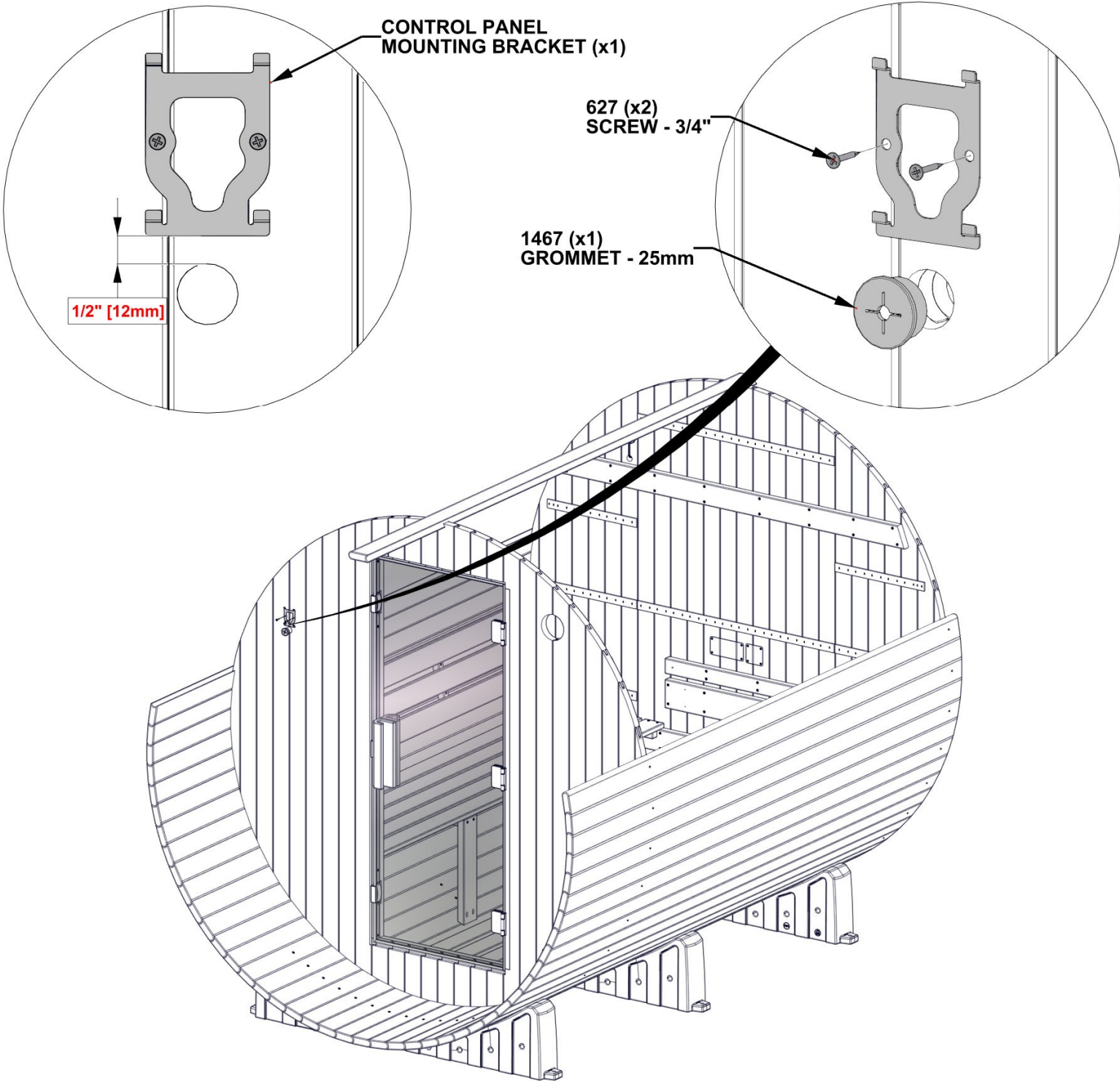
FRONT OF SAUNA HIDDEN FOR DETAIL.

STEP 22 - CONTROL PANEL ASSEMBLY

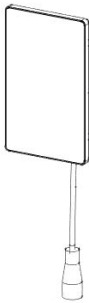
QTY	PART NUMBER	DESCRIPTION
2	H100627	SCREW PFH 6x3/4 BLK



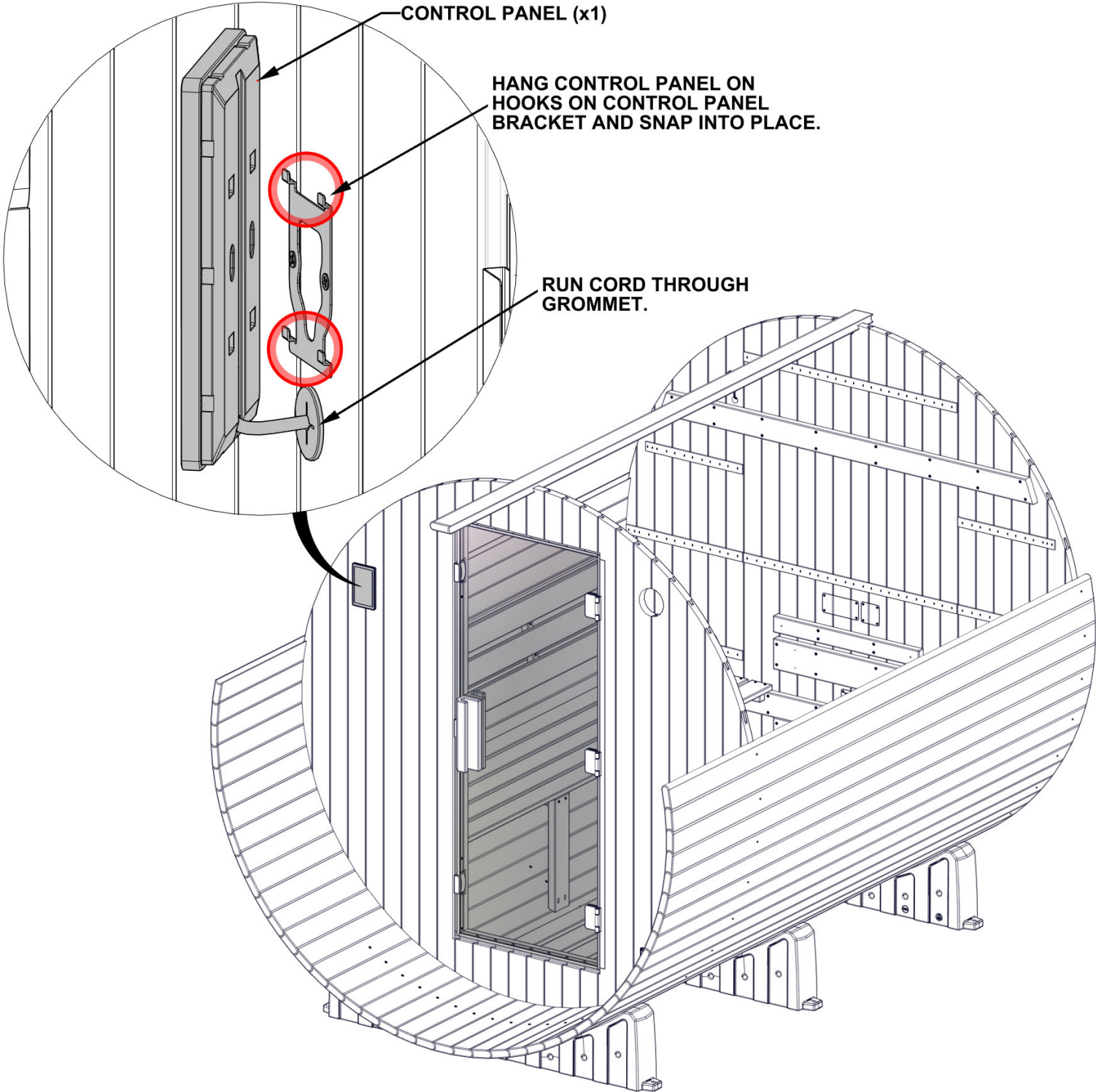
- CENTER MOUNTING BRACKET SLIGHTLY OVER CUTOUT IN WALL PANEL AND ATTACH AS SHOWN.
- INSERT GROMMET.



STEP 23 - CONTROL PANEL ASSEMBLY



A4M05590-02 CONTROL PANEL
(x1)

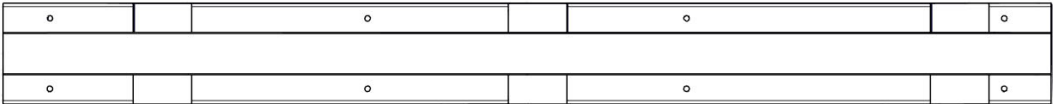


STEP 24 - WIREWAY ASSEMBLY

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

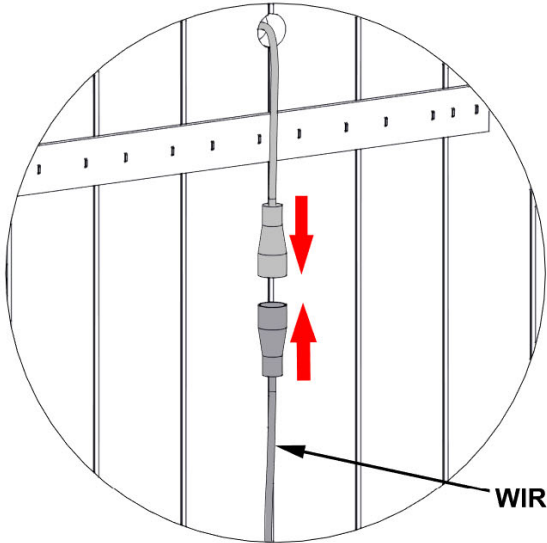


A4M05590-10 WIRING HARNESS
(x1)

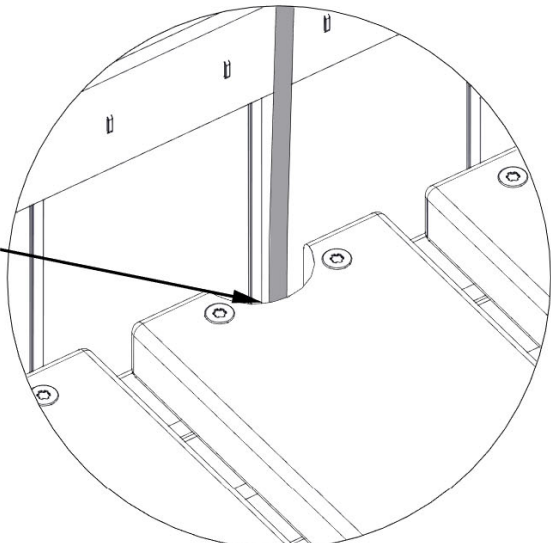


OG12 WIREWAY BOARD - W4L21999
(x1) 1 3/16"x3 3/8"x35 3/16" (30x86x894)

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



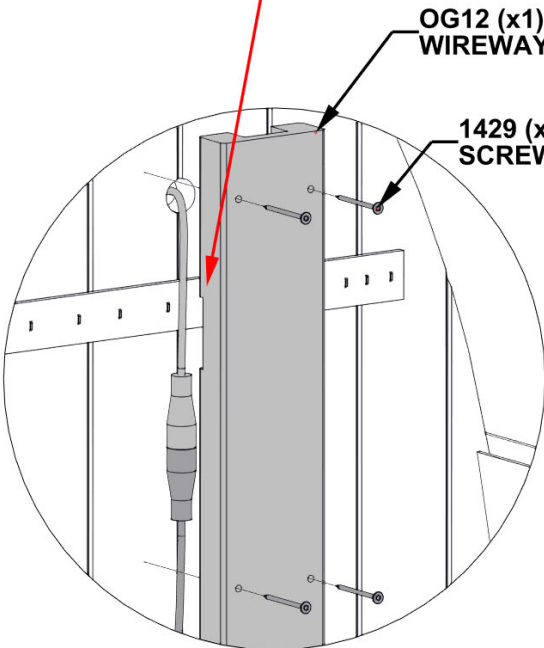
DETAIL 'A'



CUTOUT IN BENCH
ASSEMBLY

DETAIL 'B'

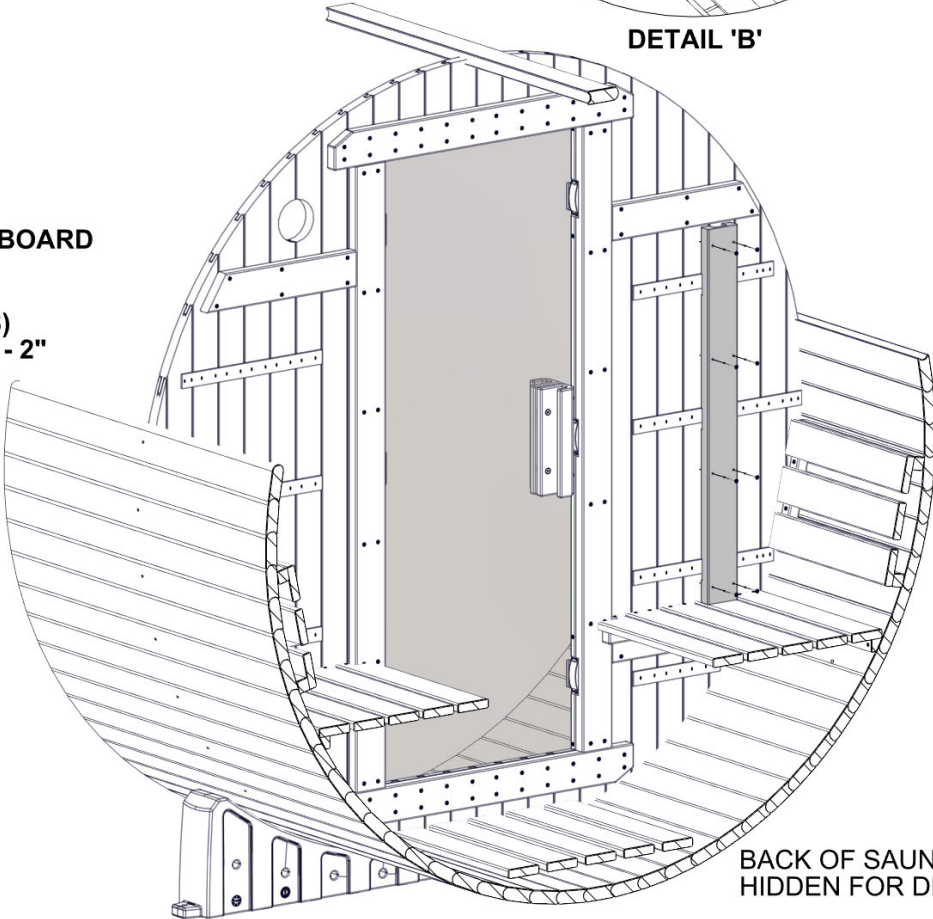
WIREWAY BOARD WILL ONLY FIT ONE
WAY. ALIGN NOTCHES IN WIREWAY
BOARD WITH CLEATS IN SIDEWALL.



DETAIL 'C'

OG12 (x1)
WIREWAY BOARD

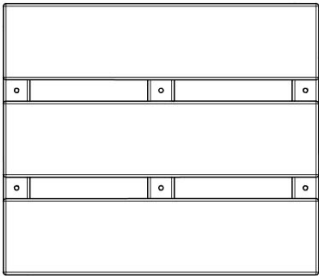
1429 (x8)
SCREW - 2"



BACK OF SAUNA
HIDDEN FOR DETAIL.

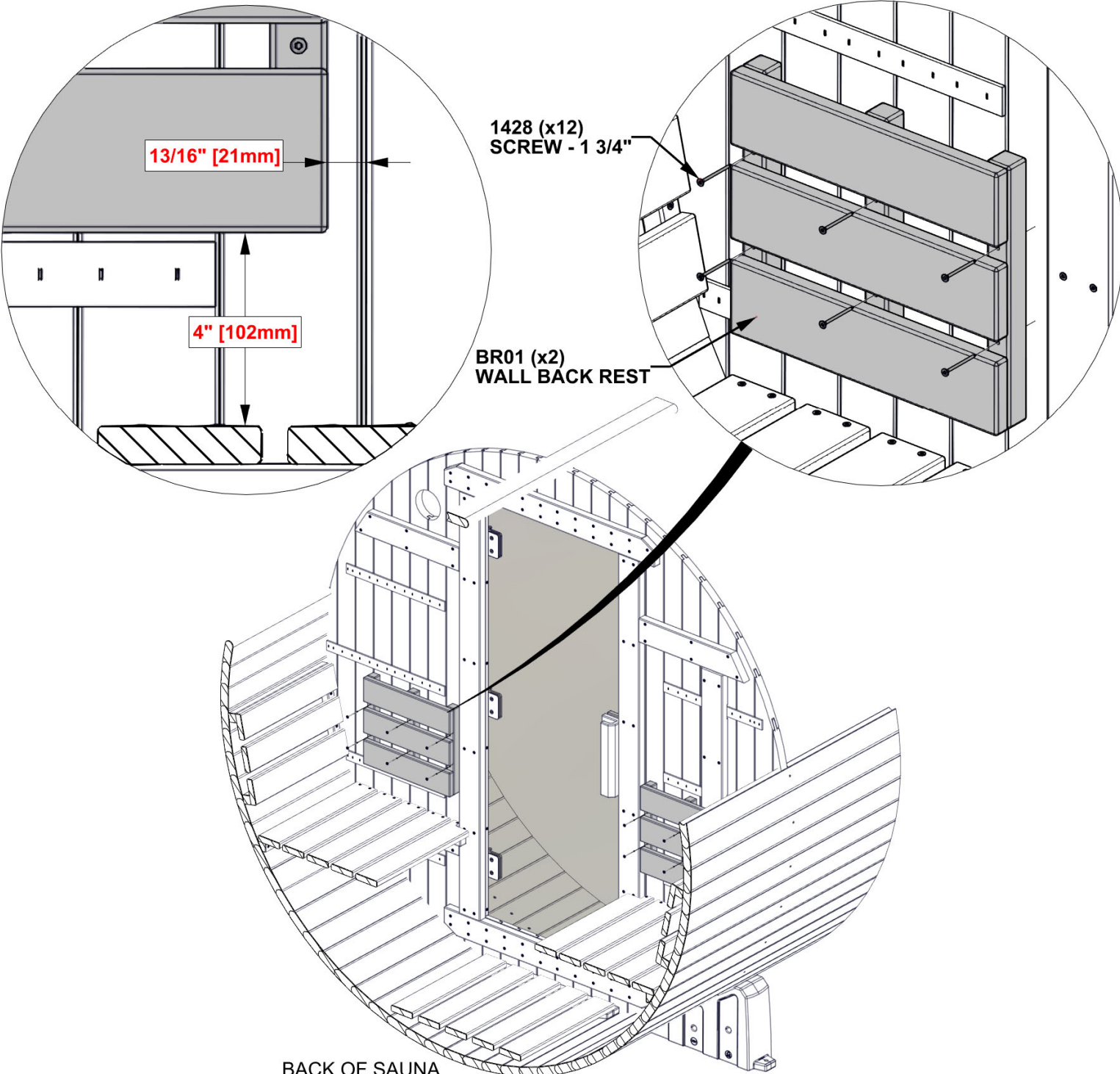
STEP 25 - BACK REST ASSEMBLY

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.



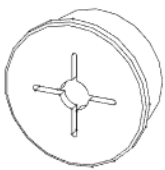
BACK OF SAUNA
HIDDEN FOR DETAIL.

STEP 26 - WIREWAY ASSEMBLY

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

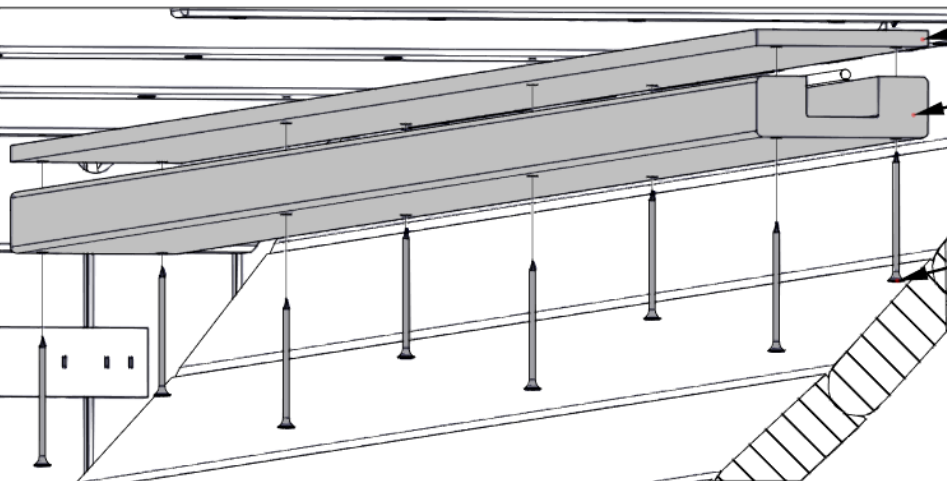
AK01 WIREWAY COVER - W4L22562
(x1) 5/16"x3 3/8"x73" (8x86x1854)

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



A6P01467 SILICONE GROMMET 25mm
(x1)

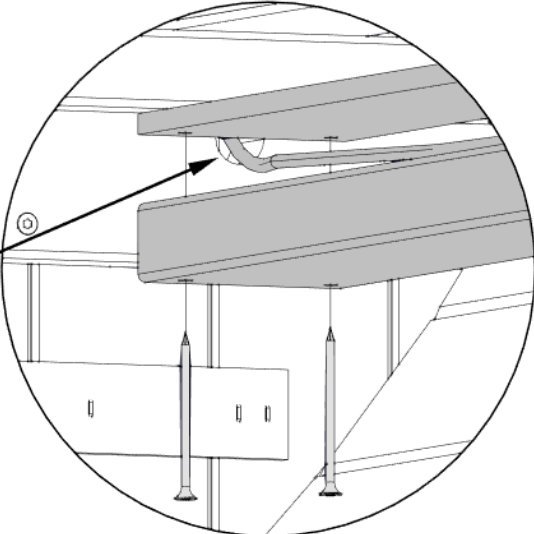
- RUN CABLE BETWEEN AK01 AND OG10.
- ENSURE CABLE RUNS IN CHanneLED PORTION OF OG10.
- NOTE, THE WIRING HARNESS EXCESS CAN BE BUNDLED WITH PROVIDED ZIP CABLE TIES.
- USE RIGHT ANGLE DRILL ADAPTER TO INSERT BACK SCREWS.
- **BE CAUTIOUS WHEN INSERTING SCREWS TO PREVENT PINCHING OR PENETRATING CORDS.**



AK01 (x1)
WIREWAY COVER
OG10 (x1)
WIREWAY BOARD

1431 (x8)
SCREW - 2 1/2"

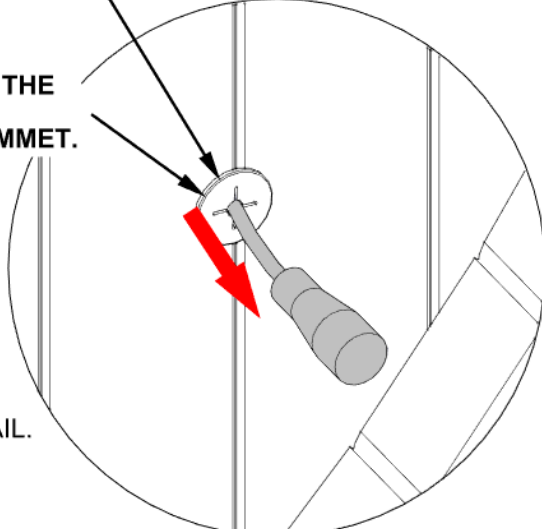
RUN CABLE BETWEEN
AK01 AND OG10 BOARDS.



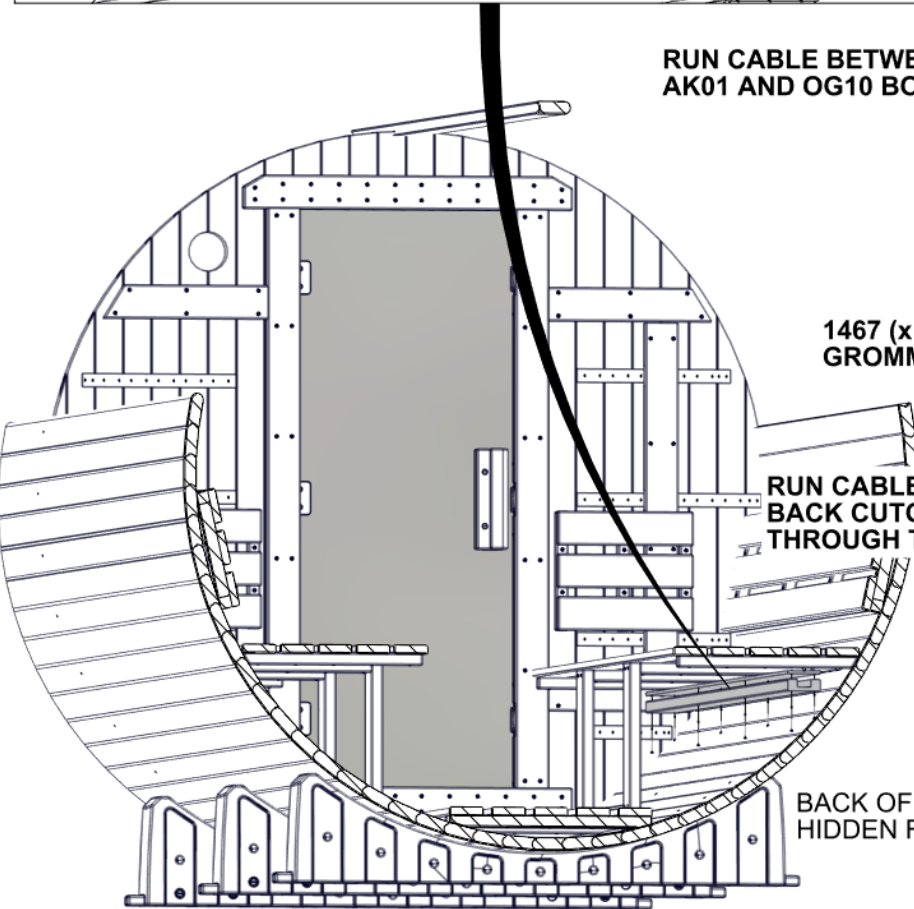
FRONT

1467 (x1)
GROMMET - 25mm

RUN CABLE OUT OF THE
BACK CUTOUT AND
THROUGH THE GROMMET.



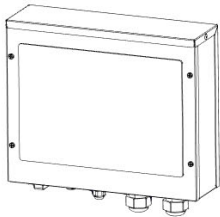
BACK



BACK OF SAUNA
HIDDEN FOR DETAIL.

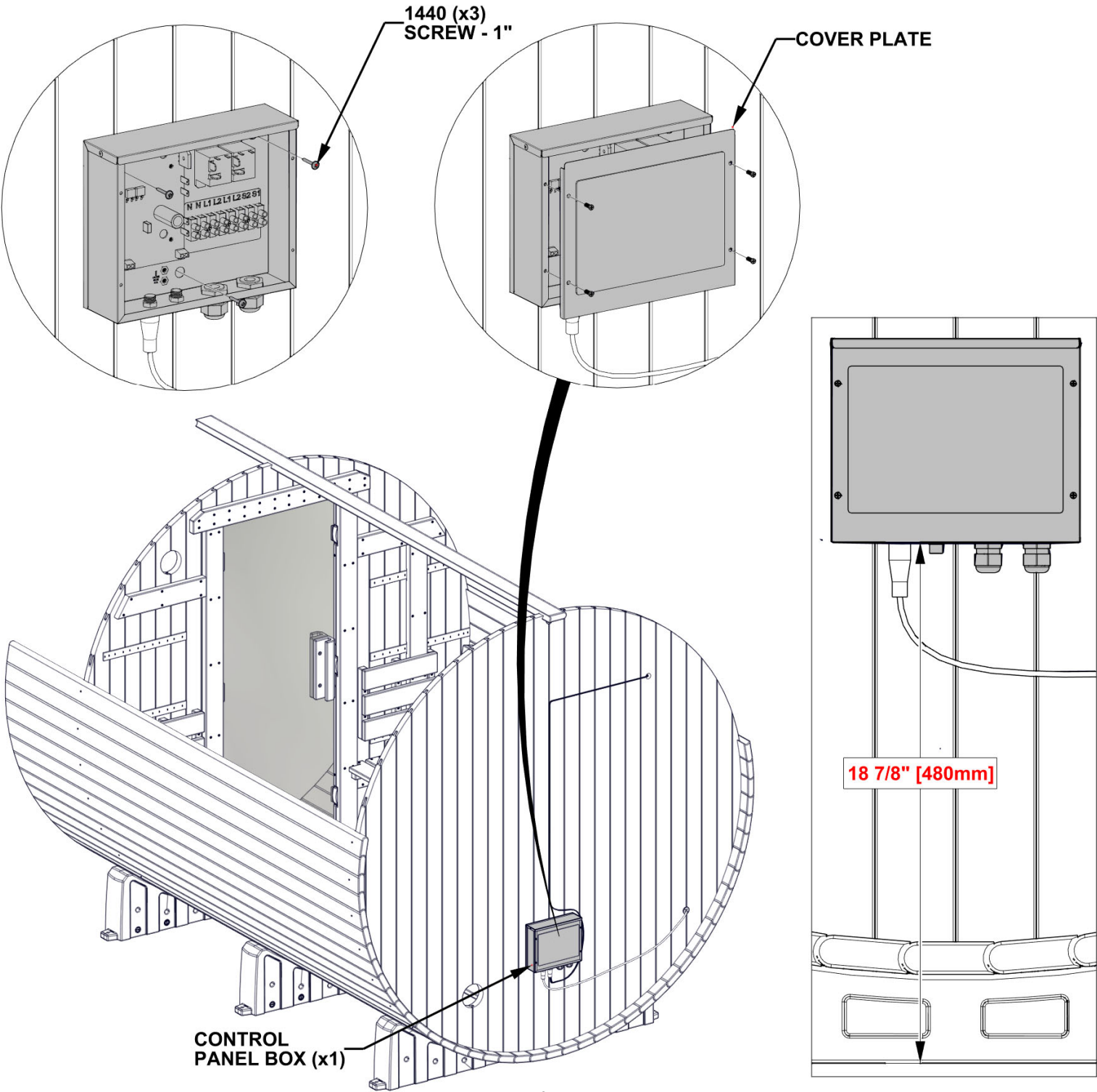
STEP 27 - CONTROL PANEL INSTALLATION

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



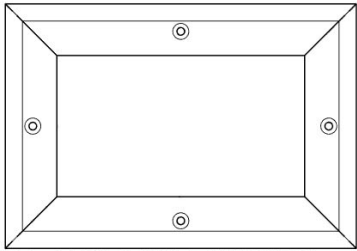
A4M05590-01 CONTROL PANEL BOX
(x1)

- 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



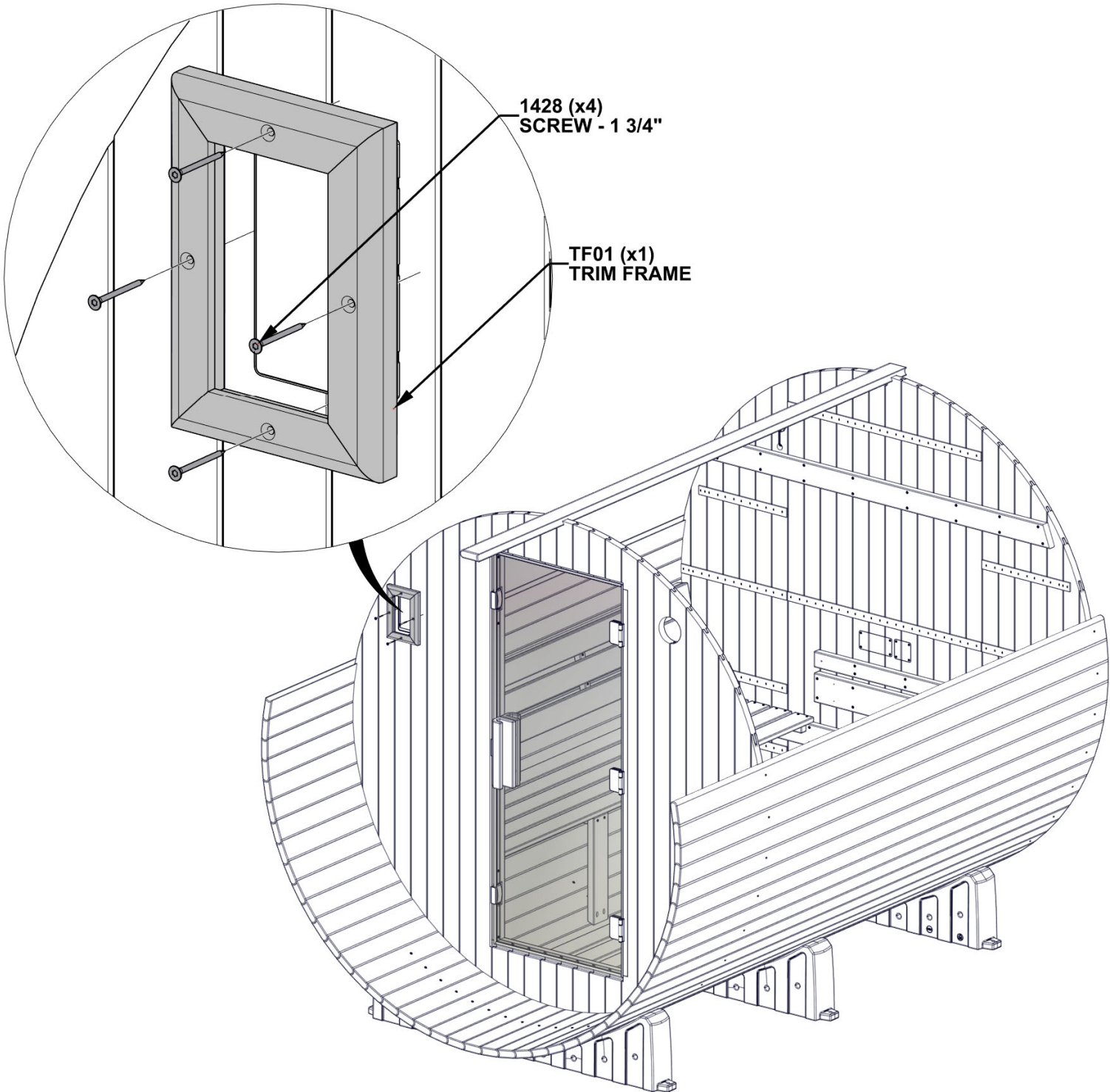
STEP 28 - CONTROL PANEL ASSEMBLY

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



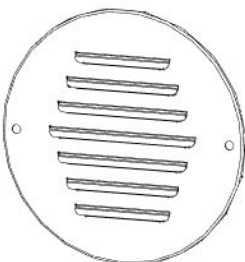
TF01 TRIM FRAME - W2A04797
(x1) 7/8"x5 9/16"x8 1/16" (22x142x204)

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

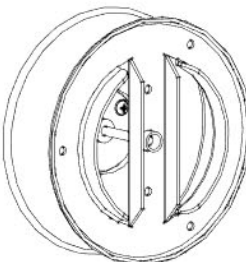


STEP 29 - VENT ASSEMBLY

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

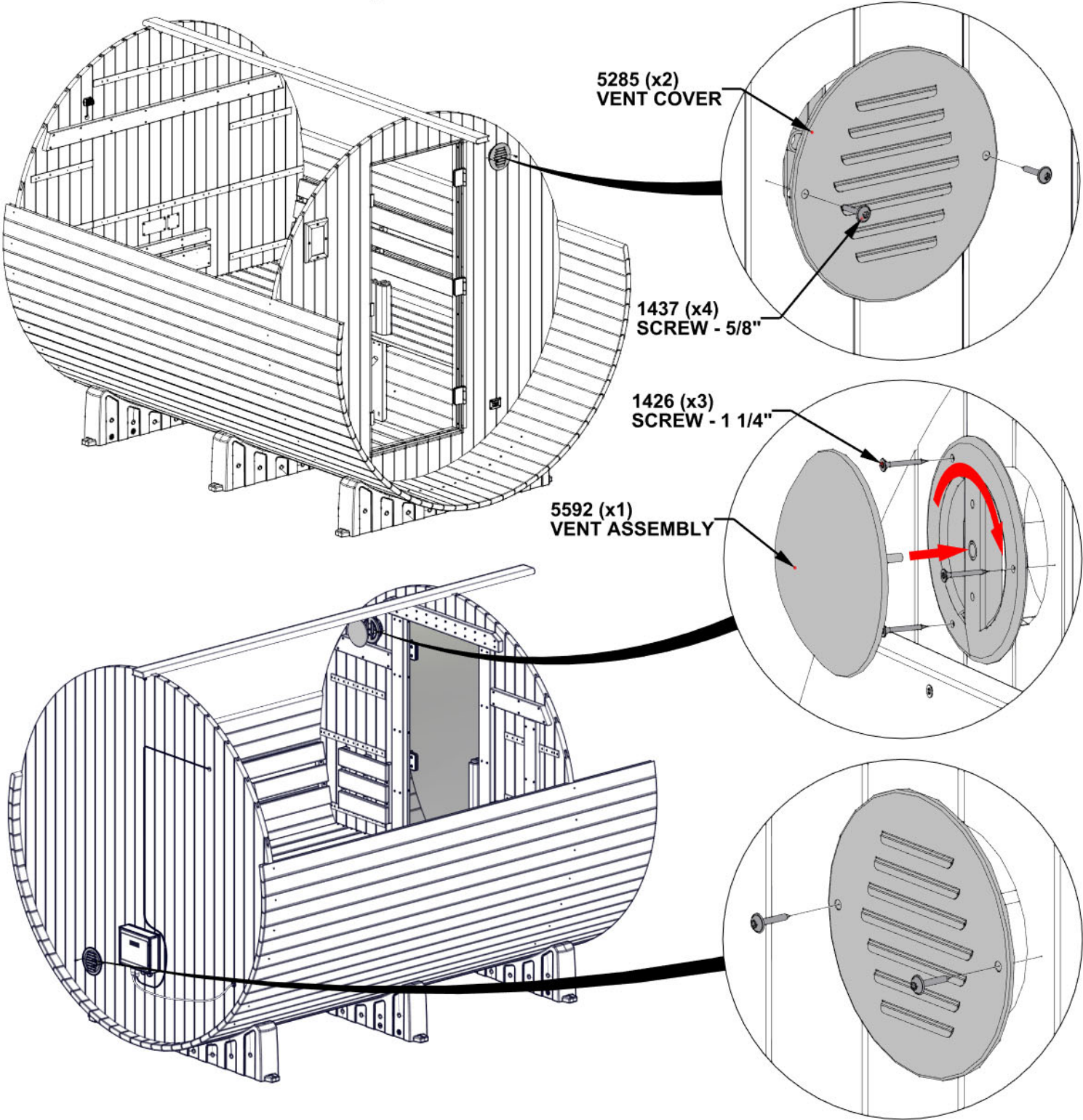


A4M05285 VENT
(x2)

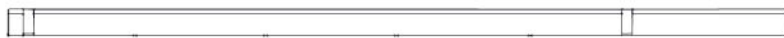


A4M05592 VENT COVER
(x1)

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



STEP 30 - BARREL ASSEMBLY

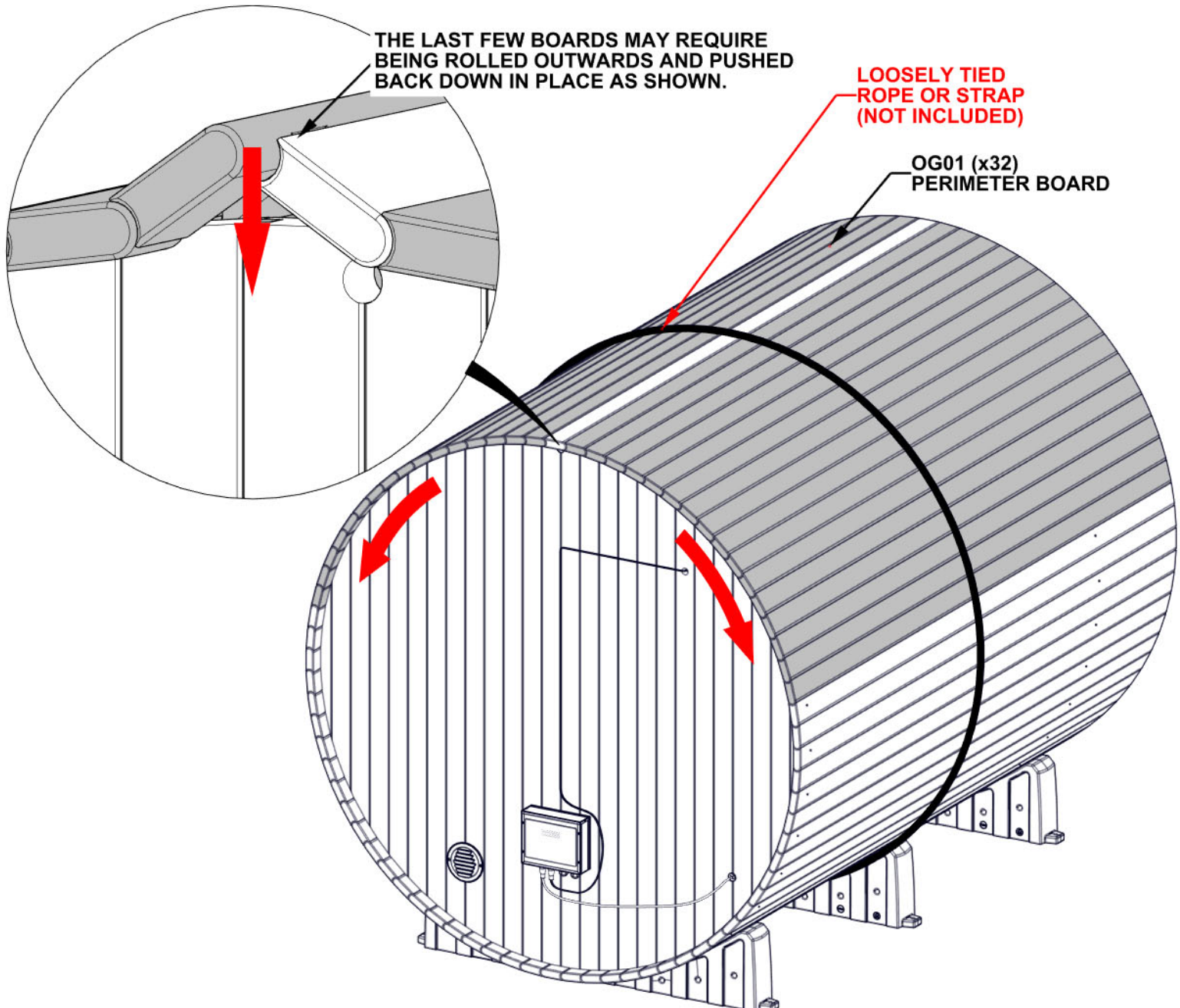


OG01 PERIMETER BOARD - W4L21988
(x32) 1 3/16"x3 3/8"x99 15/16" (30x86x2538)

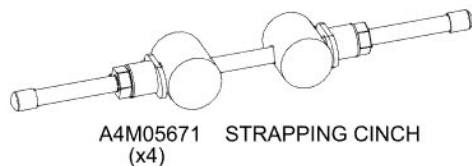


BOARD SPACER KIT - W2A04961
(x1)

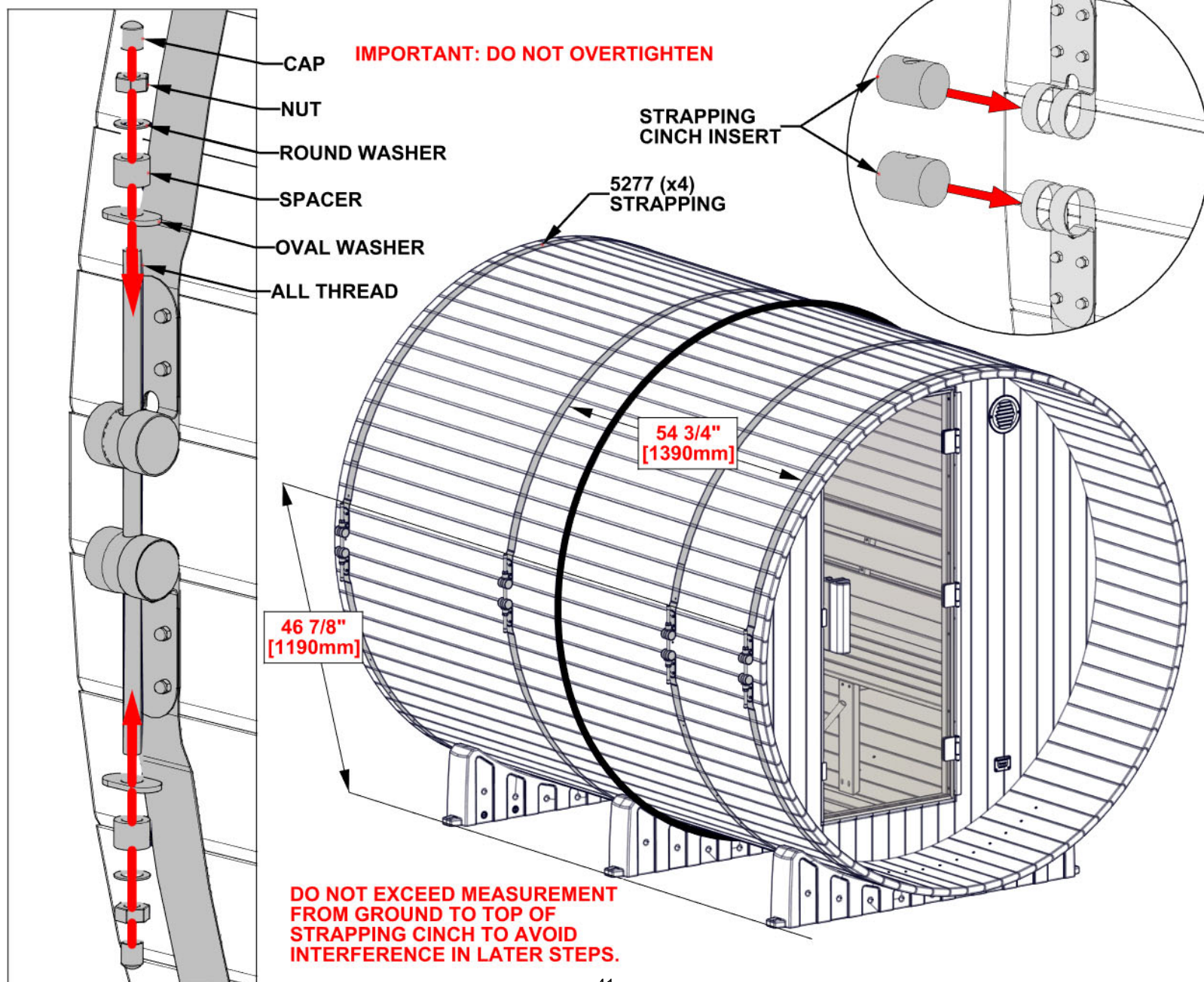
- A ROPE OR STRAP IS SUGGESTED TO BE LOOSELY TIED/ATTACHED AROUND THE BARREL TO HELP HOLD BOARDS IN PLACE.
- ALIGN GROOVE IN PERIMETER BOARDS WITH BOTH FRONT WALL AND BACK WALL ASSEMBLIES.
- WORKING UPWARDS, STACK PERIMETER BOARDS TO BOTH SIDES UNTIL THEY MEET AT THE TOP
- REMOVE TOP BOARD THAT WAS INSTALLED 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

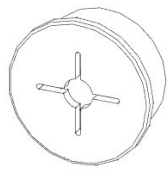
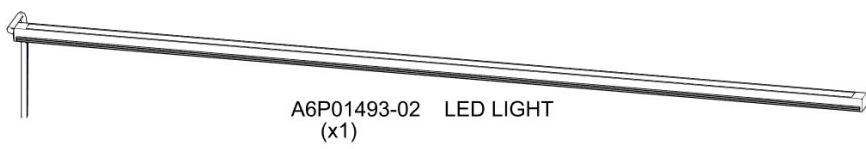
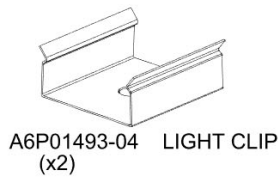


- WRAP STRAPPING AROUND SAUNA AS SHOWN.
- POSITION TWO STRAPS TO COVER THE NAILS INSTALLED IN STEP 11.
- THE THIRD STRAP WILL BE LOCATED 2" [50mm] FROM THE FRONT EDGE OF THE SAUNA, AND THE FOURTH WILL BE LOCATED 54 3/4" [1390mm] FROM THAT STRAP AS SHOWN. OTHERWISE STRAPPING MAY INTERFERE WITH ROOF SHEET 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.

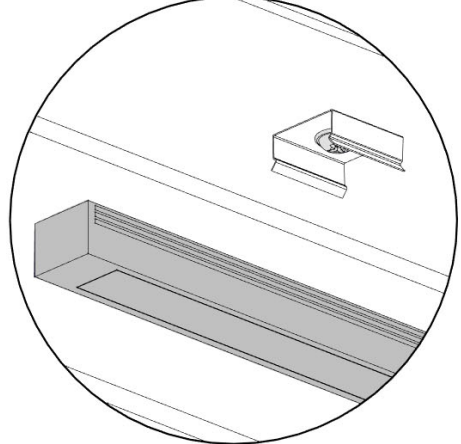
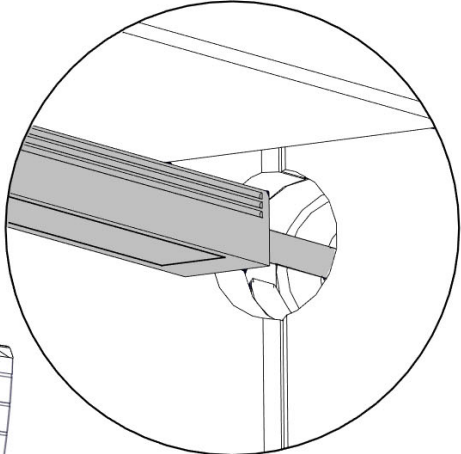
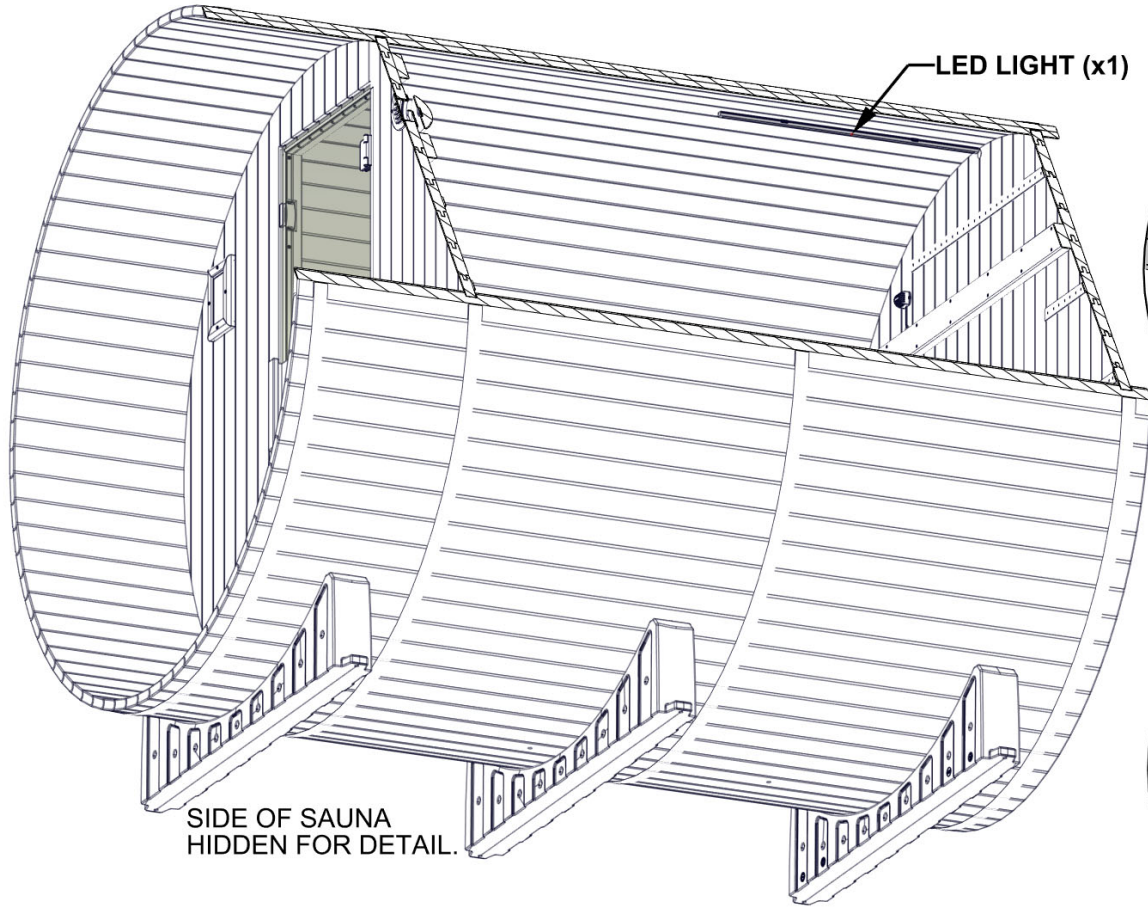
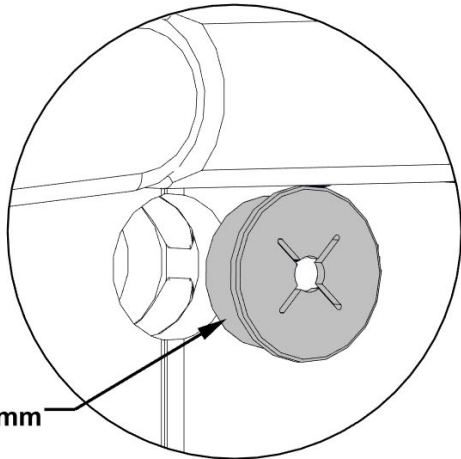
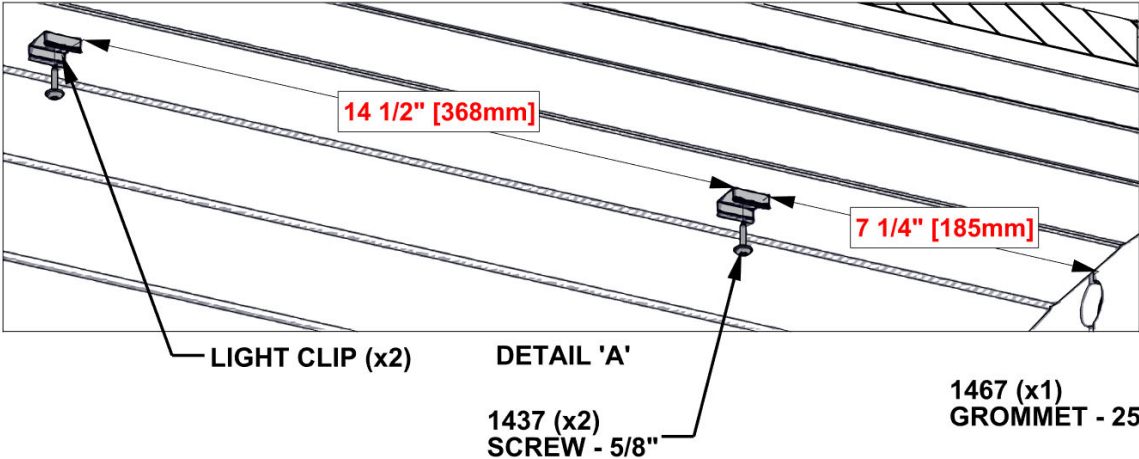


STEP 32 - LIGHT ASSEMBLY

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

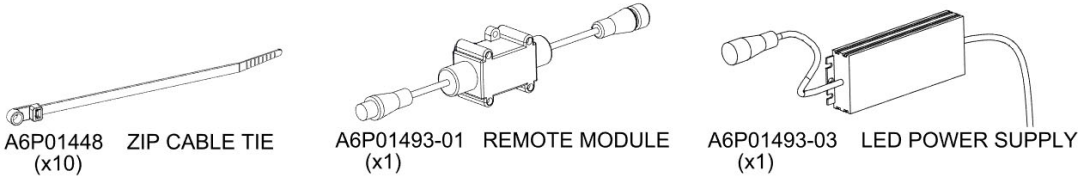


- INSTALL GROMMET IN THE TOP OF THE BACK WALL PANEL ASSEMBLY AS SHOWN.
- INSTALL CLIPS ON THE TOP CENTER BOARD AS SHOWN USING APPROXIMATE DIMENSIONS. (DETAIL 'A')
- THREAD CORD THROUGH CUTOUT AND GROMMET. (DETAIL 'B')
- SNAP LED LIGHT INTO LIGHT CLIPS. (DETAIL 'C')

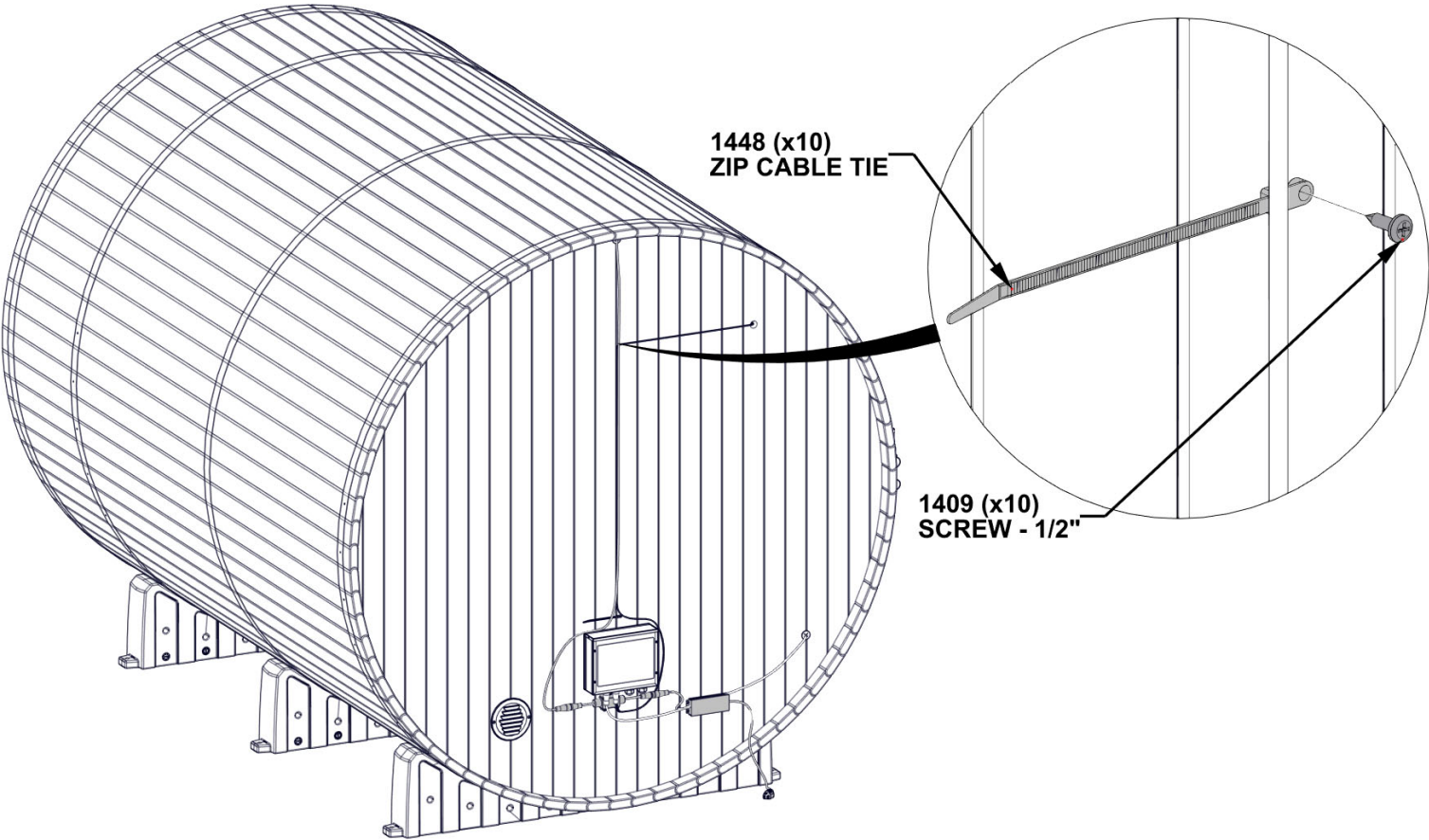
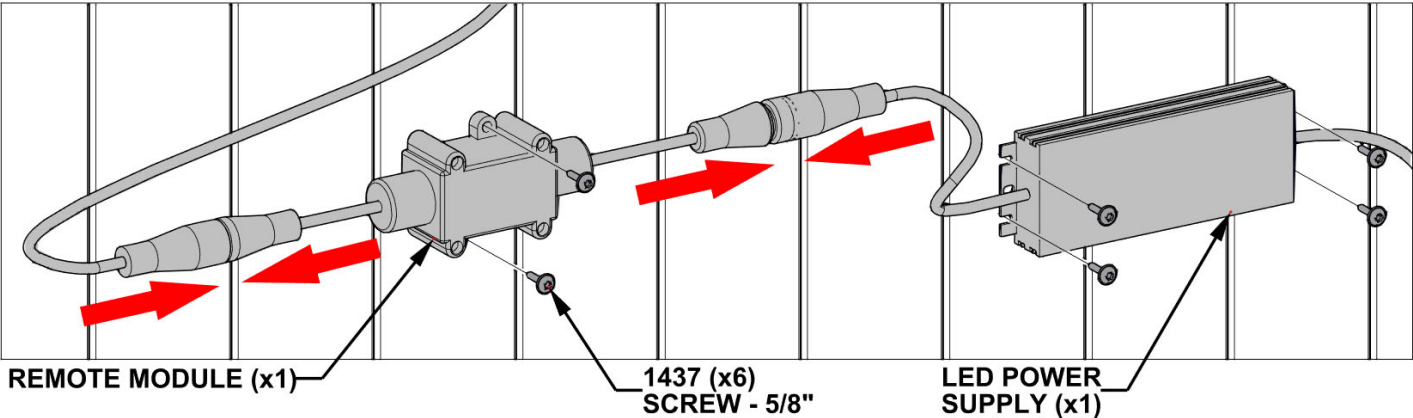


STEP 33 - ELECTRICAL

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

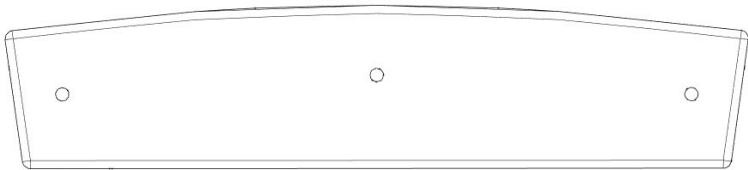


- LOCATE REMOTE MODULES AND POWER SUPPLIES IN APPROXIMATE LOCATIONS.
- ENSURE REMOTE MODULES AND POWER SUPPLIES ARE ORIENTED HORIZONTALLY WHEN ATTACHING.
- USE ZIP TIES WHERE NEEDED TO ATTACH AND ORGANIZE CORDS.

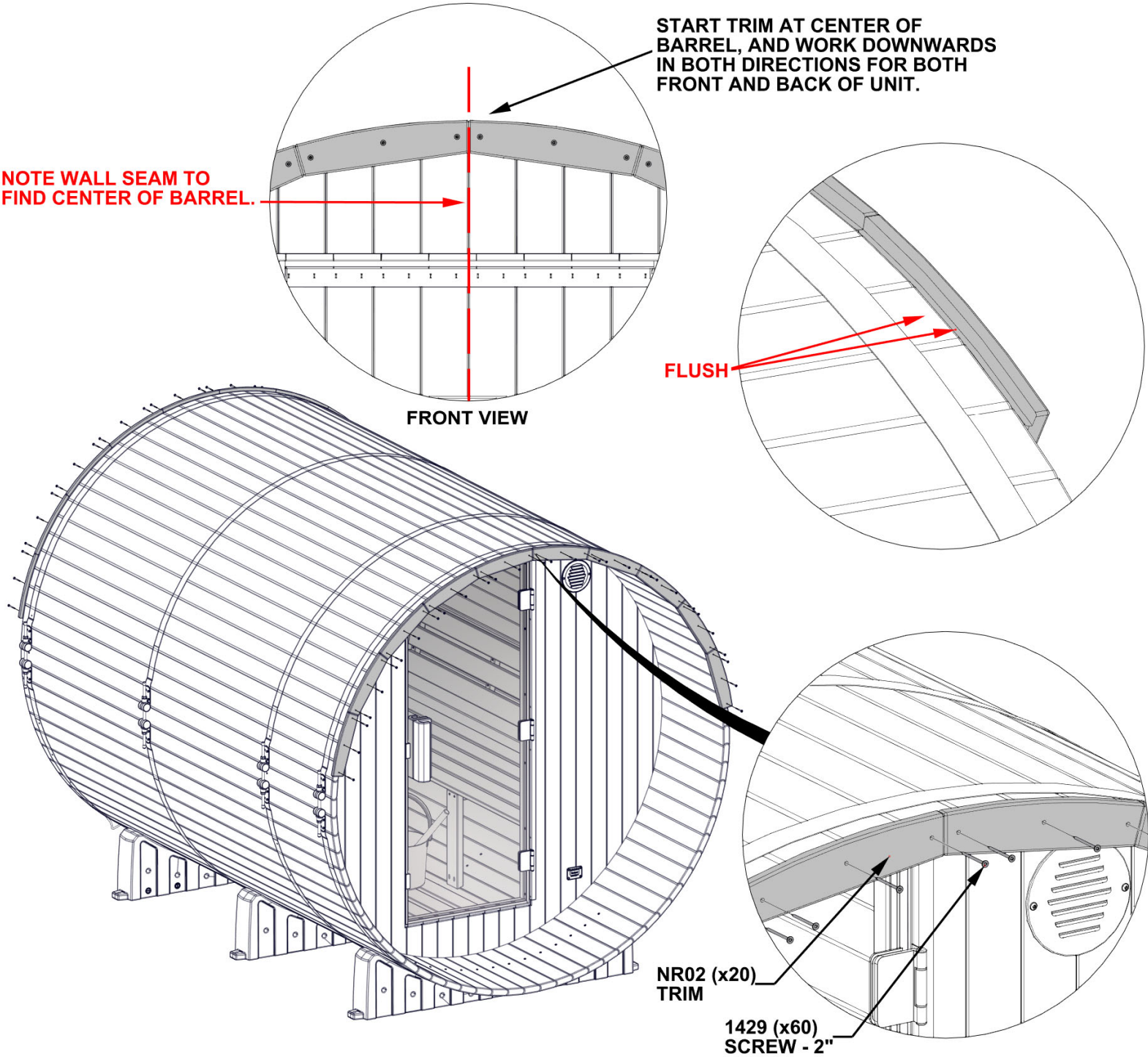


STEP 34 - TRIM ASSEMBLY

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

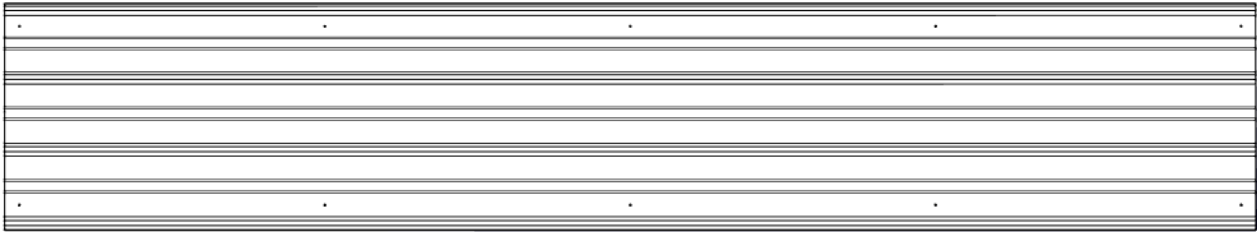


NR02 TRIM - W4L21866
(x20) 13/16"x2 3/8"x10 15/16" (20x60x278)



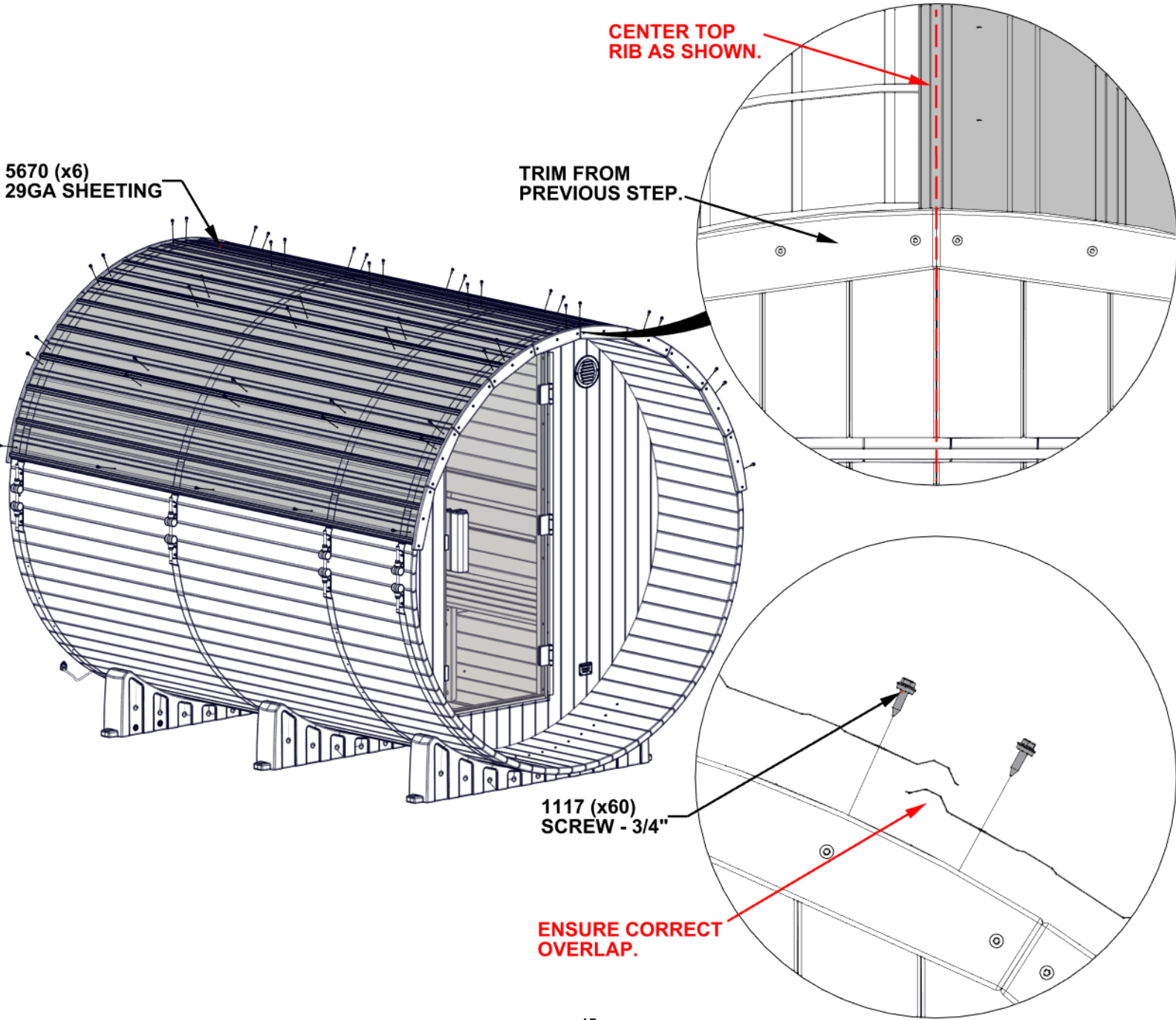
STEP 35 - ROOF ASSEMBLY

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)

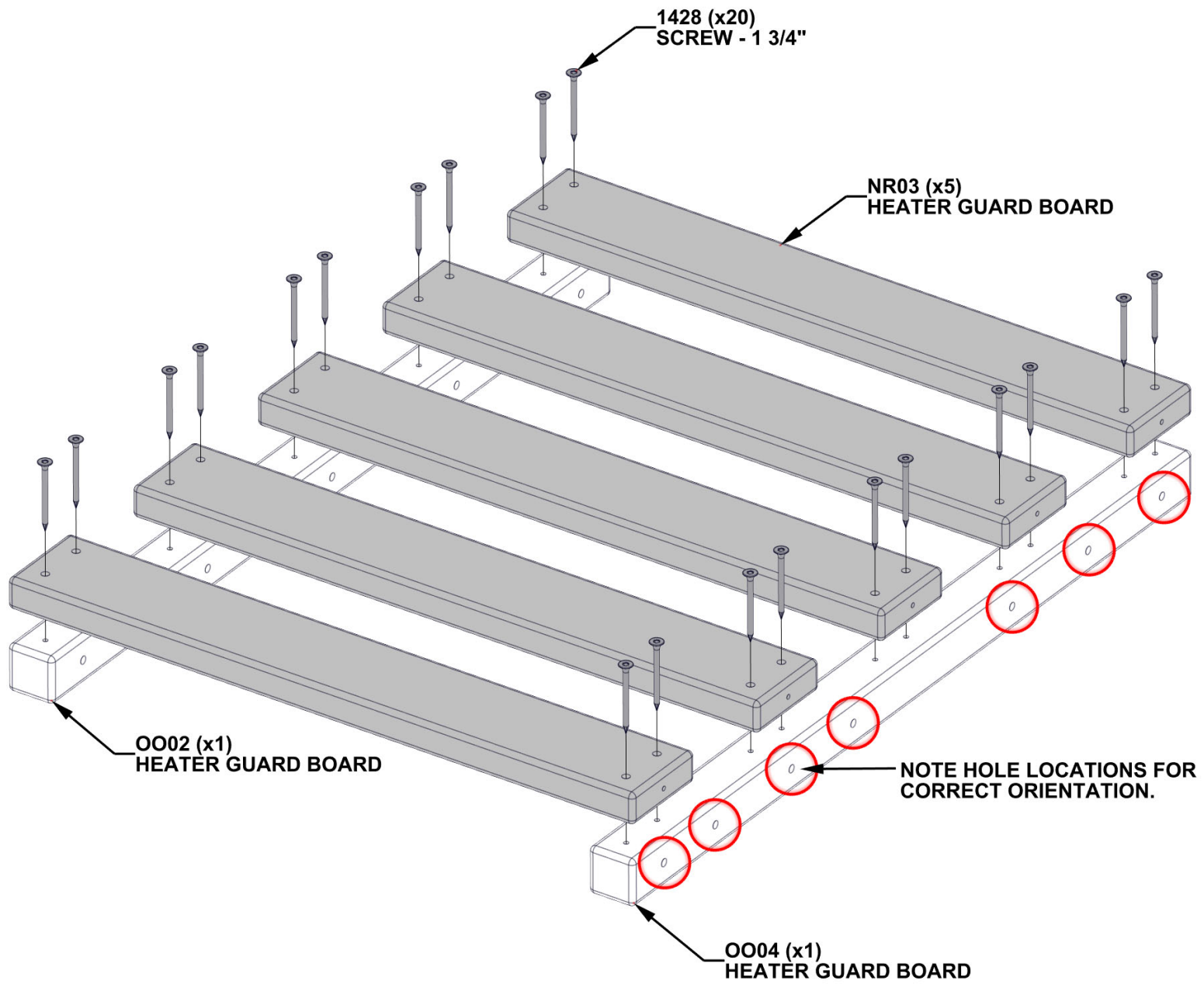


OO04 HEATER GUARD BOARD - W4L21871
(x1) 1 3/16"x1 3/16"x21 7/16" (30x30x544)



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)

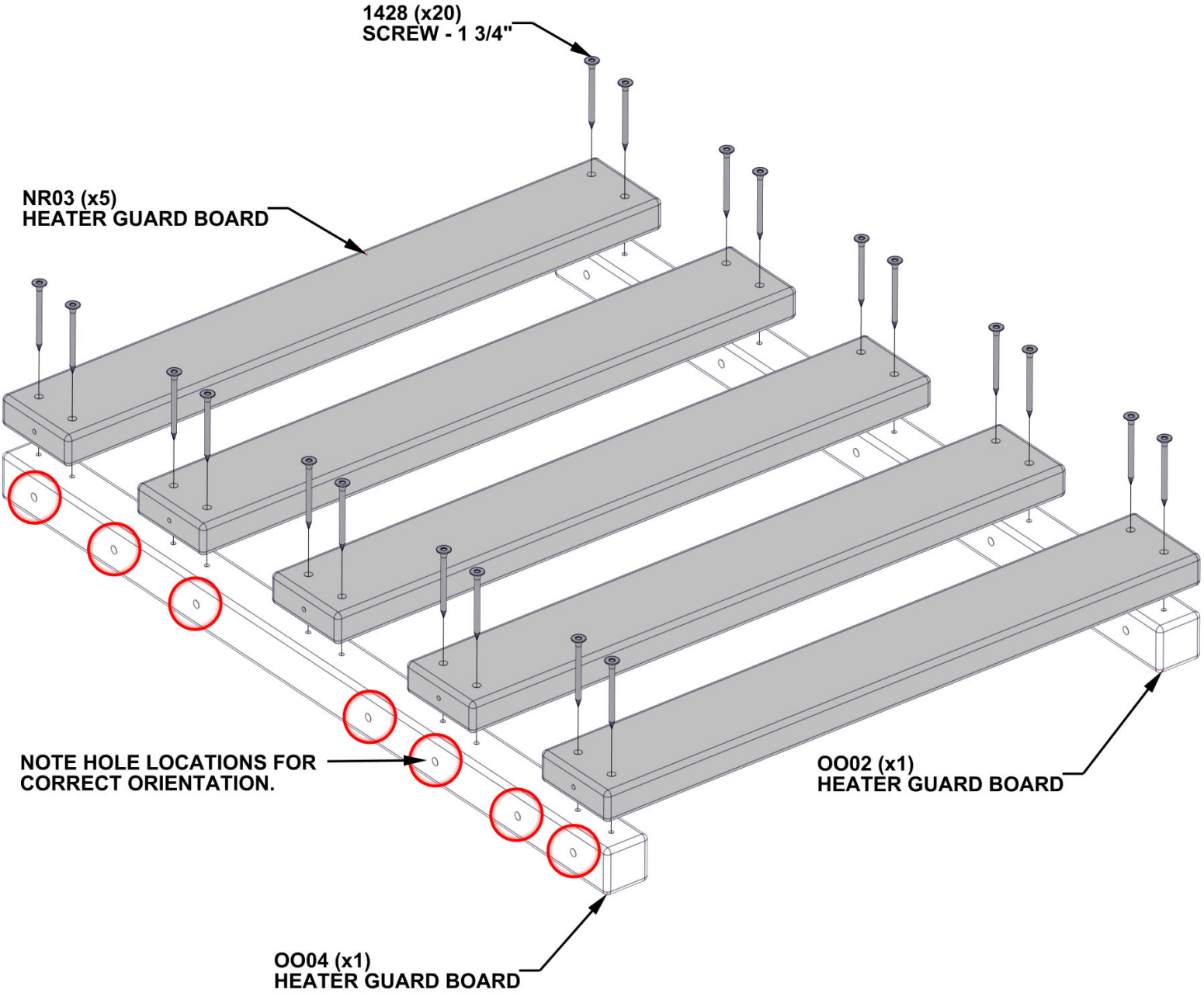


OO02 HEATER GUARD BOARD - W4L21875
(x1) 1 3/16"x1 3/16"x21 7/16" (30x30x544)



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.

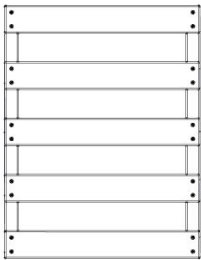


STEP 38 - HEATER GUARD ASSEMBLY

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



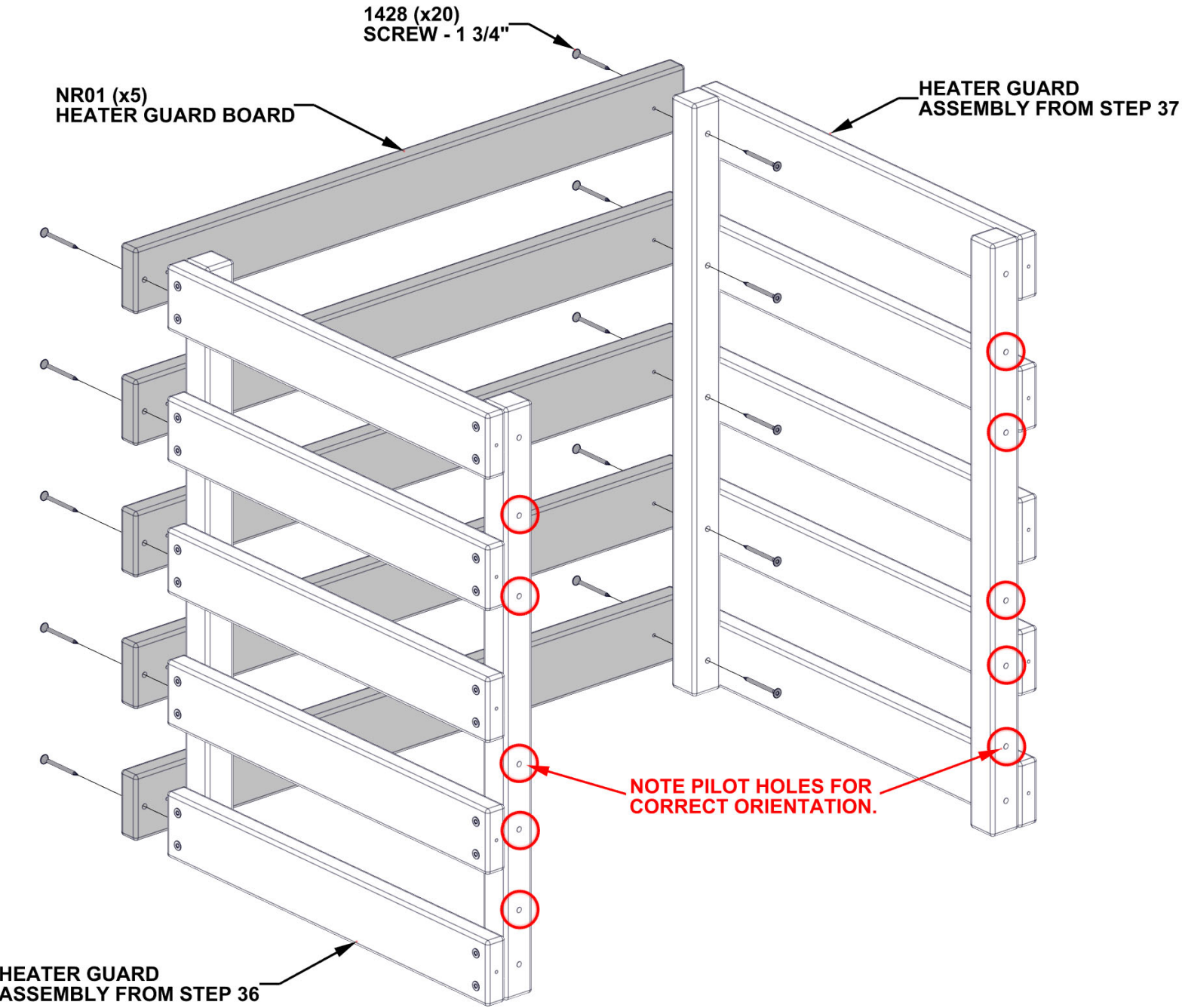
HEATER GUARD ASSEMBLY FROM STEP 36



HEATER GUARD ASSEMBLY FROM STEP 37



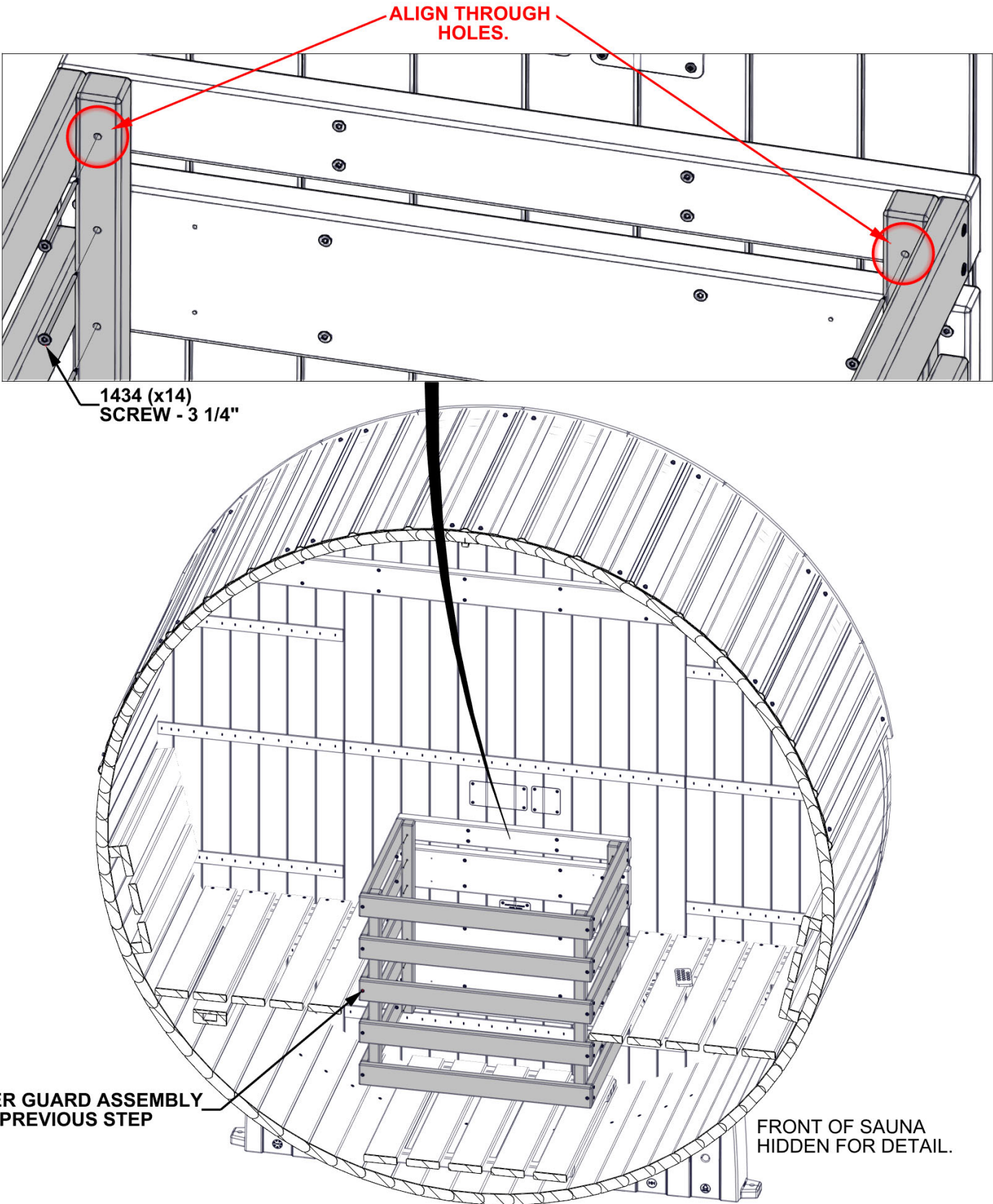
NR01 HEATER GUARD BOARD - W4L21872
(x5) 13/16"x2 3/8"x23 15/16" (20x60x608)



STEP 39 - HEATER GUARD ASSEMBLY

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

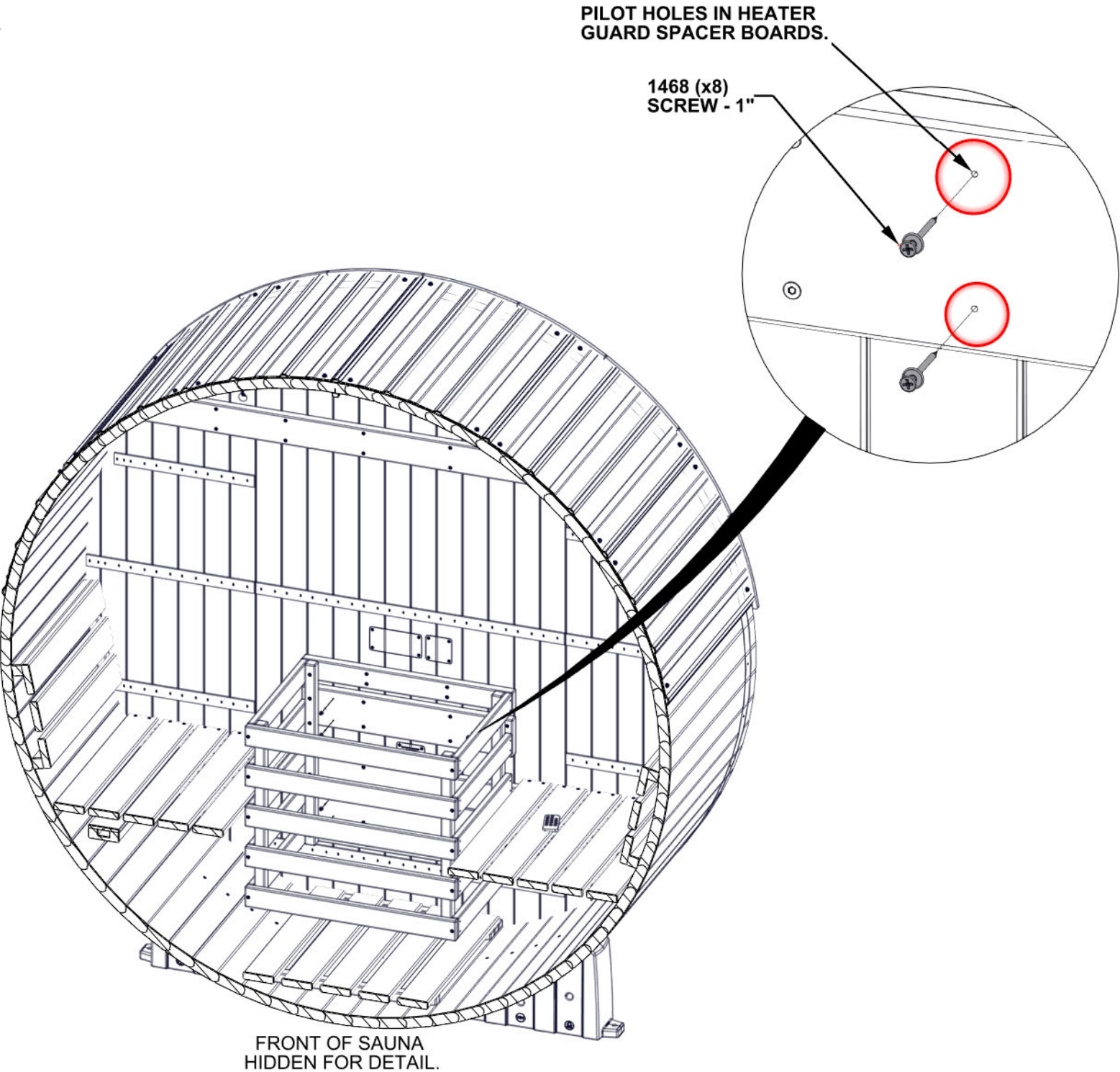
- POSITION HEATER GUARD ASSEMBLY AS SHOWN.
- ALIGN TOP AND BOTTOM THROUGH HOLES WITH THROUGH HOLES IN PREVIOUSLY INSTALLED GUARD MOUNTING BOARDS AND ATTACH.
- ENSURE SIDES OF THE HEATER GUARD ASSEMBLY ARE FLUSH WITH THE ENDS OF THE PREVIOUSLY INSTALLED HEATER SPACER BOARDS.



STEP 40 - HEATER MOUNT INSTALLATION

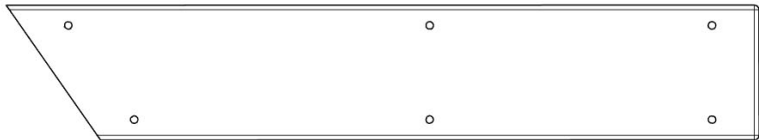
QTY	PART NUMBER	DESCRIPTION
8	H101468	SCREW RAISED HEAD 8x1"

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



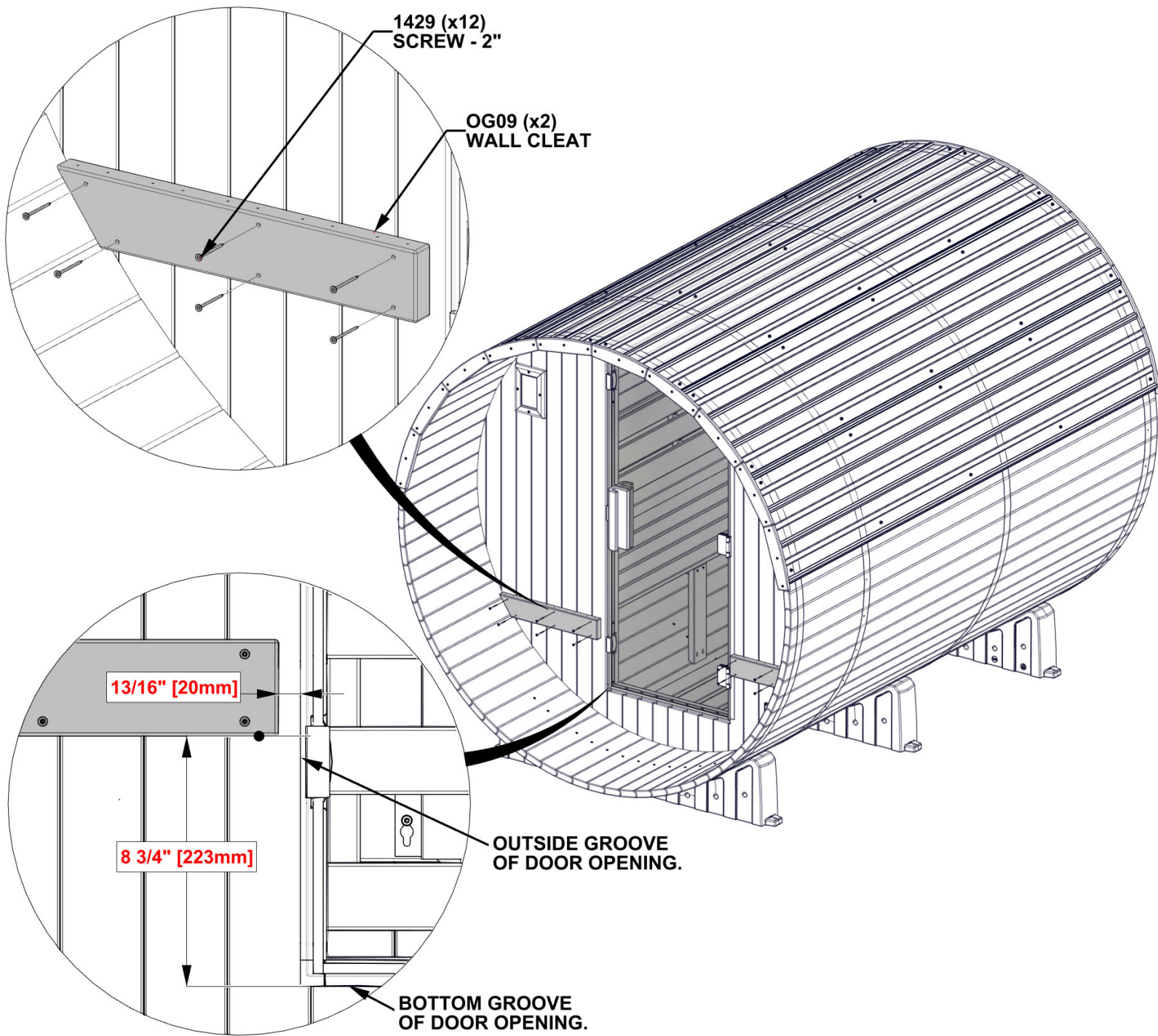
STEP 41 - BENCH ASSEMBLY

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



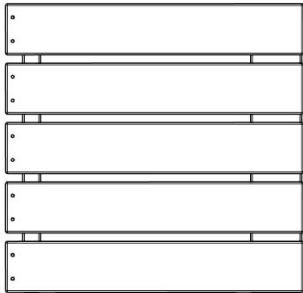
OG09 WALL CLEAT - W4L21909
(x2) 1 3/16"x3 3/8"x18 7/8" (30x86x480)

- 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

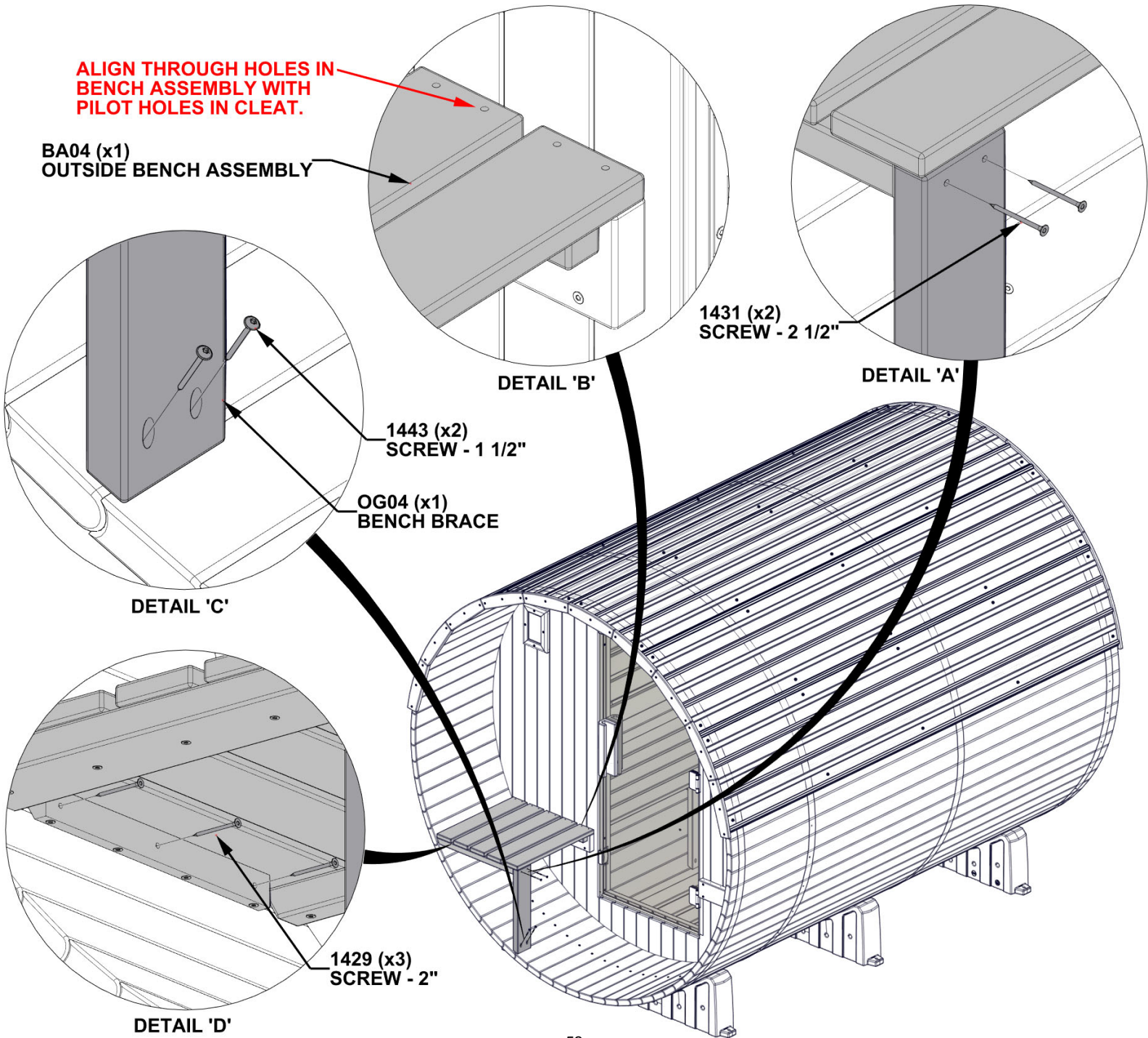


BA04 OUTSIDE BENCH ASSEMBLY - W2A04808
(x1) 1 15/16"x19 3/16"x19 3/4" (50x487x502)



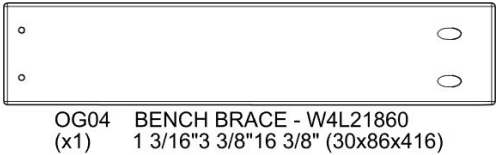
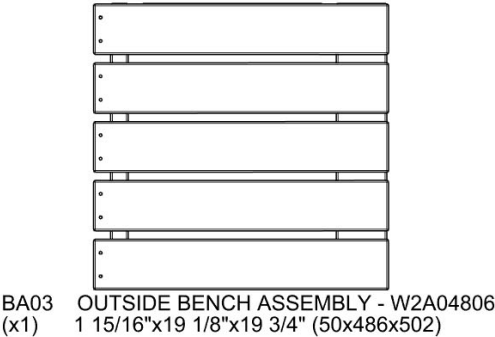
OG04 BENCH BRACE - W4L21860
(x1) 1 3/16"x3 3/8"x16 3/8" (30x86x416)

- 1) INSTALL BENCH BRACE OG04 TO BENCH ASSEMBLY. (DETAIL 'A')
- 2) PUSH THE BENCH WITH BENCH BRACE BOARD AGAINST THE WALL UNTIL IT MAKES CONTACT WITH THE SIDEWALL.
- 3) CHECK THE ALIGNMENT OF THE HOLES 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')

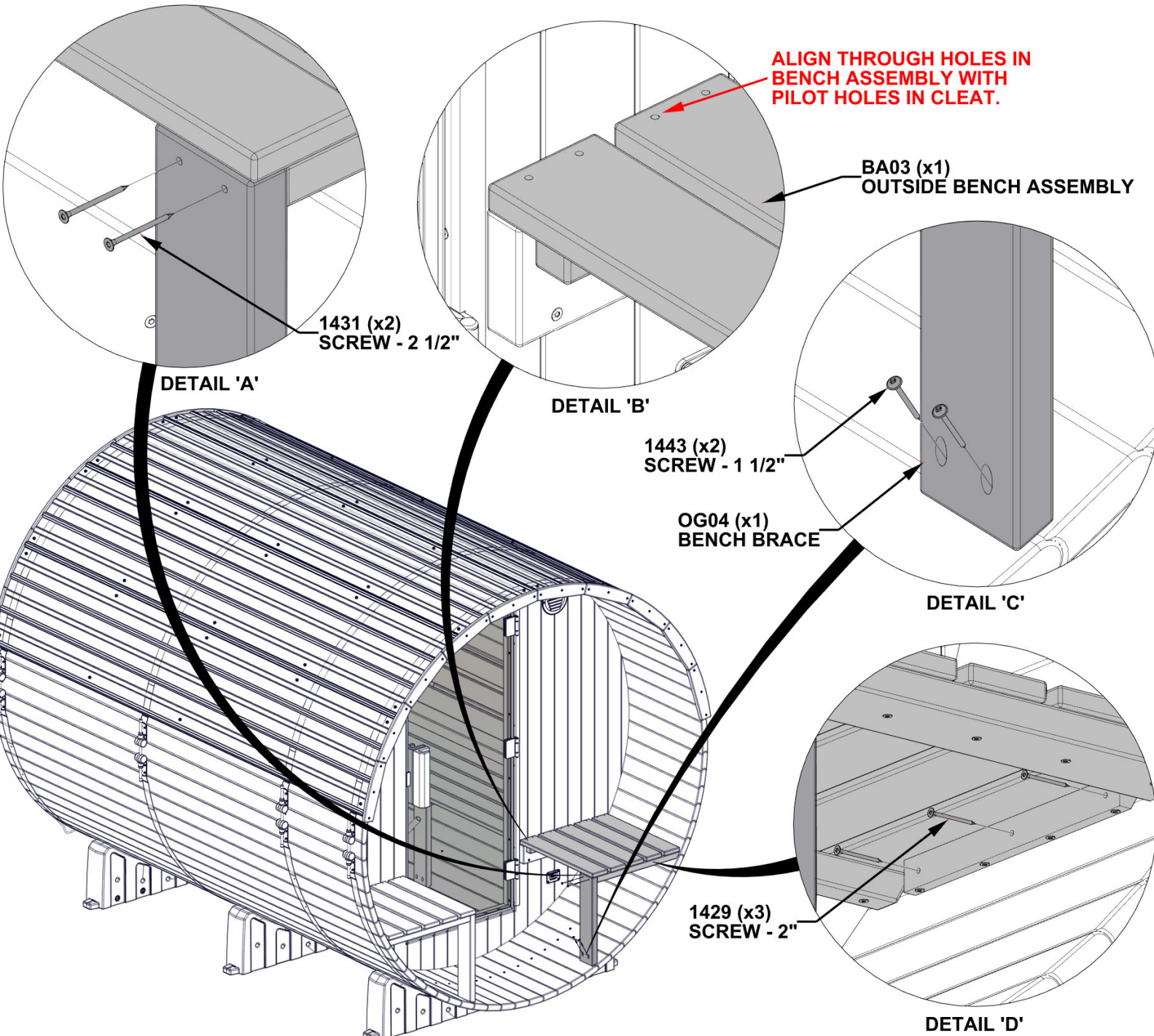


STEP 43 - BENCH ASSEMBLY

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



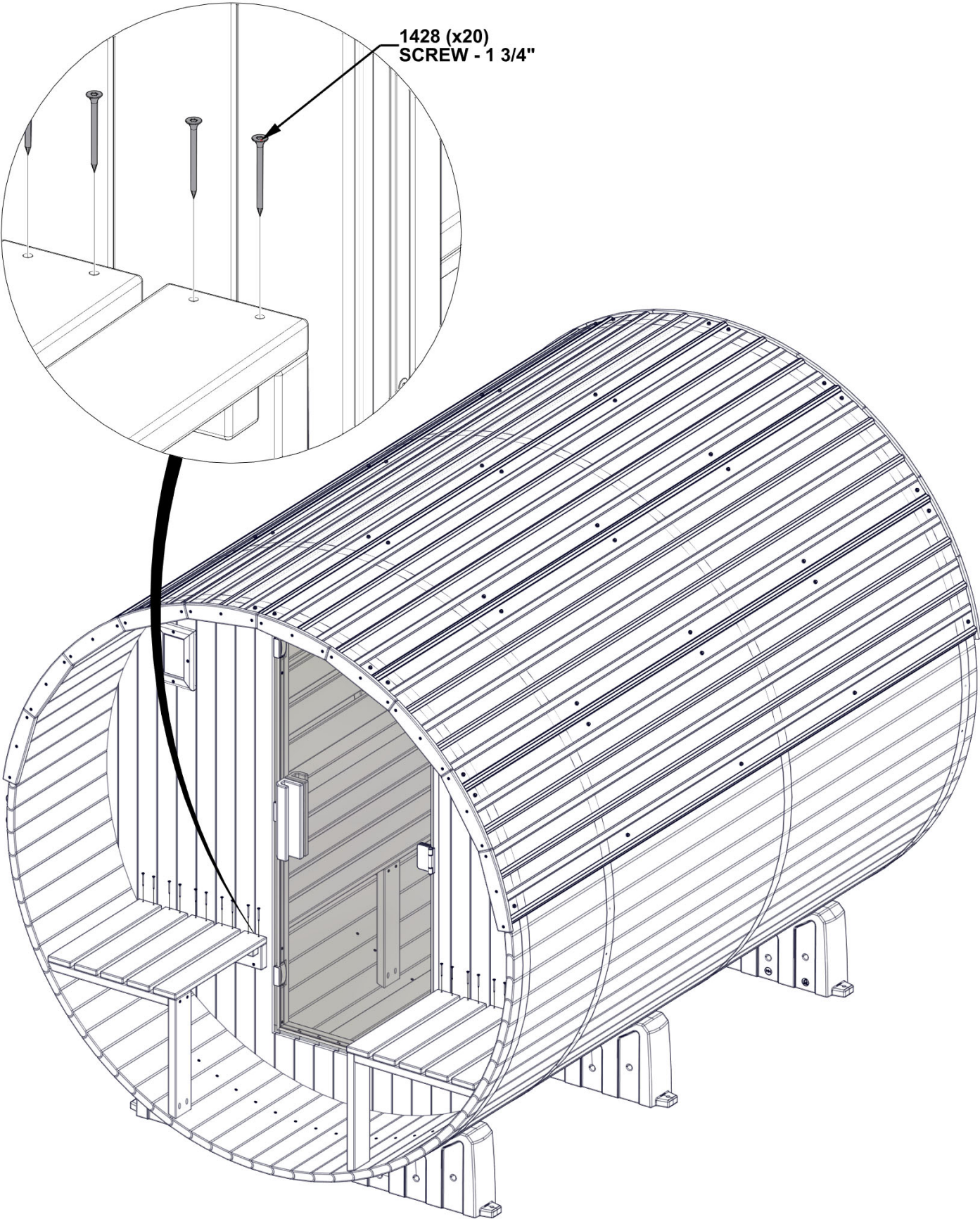
- 1) INSTALL BENCH BRACE OG04 TO BENCH ASSEMBLY. (DETAIL 'A')
- 2) PUSH THE BENCH WITH BENCH BRACE BOARD AGAINST THE WALL UNTIL IT MAKES CONTACT WITH THE SIDEWALL.
- 3) CHECK THE ALIGNMENT OF THE HOLES AT THE END OF THE BENCH WITH THE PILOT HOLES ON THE CLEAT MOUNTED TO THE WALL. (DETAIL 'B')
- 4) ENSURE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

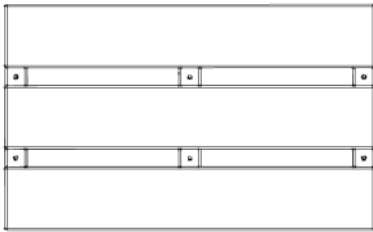
QTY	PART NUMBER	DESCRIPTION
20	H101428	SCREW TFH 8X1 3/4 SS-BLK

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



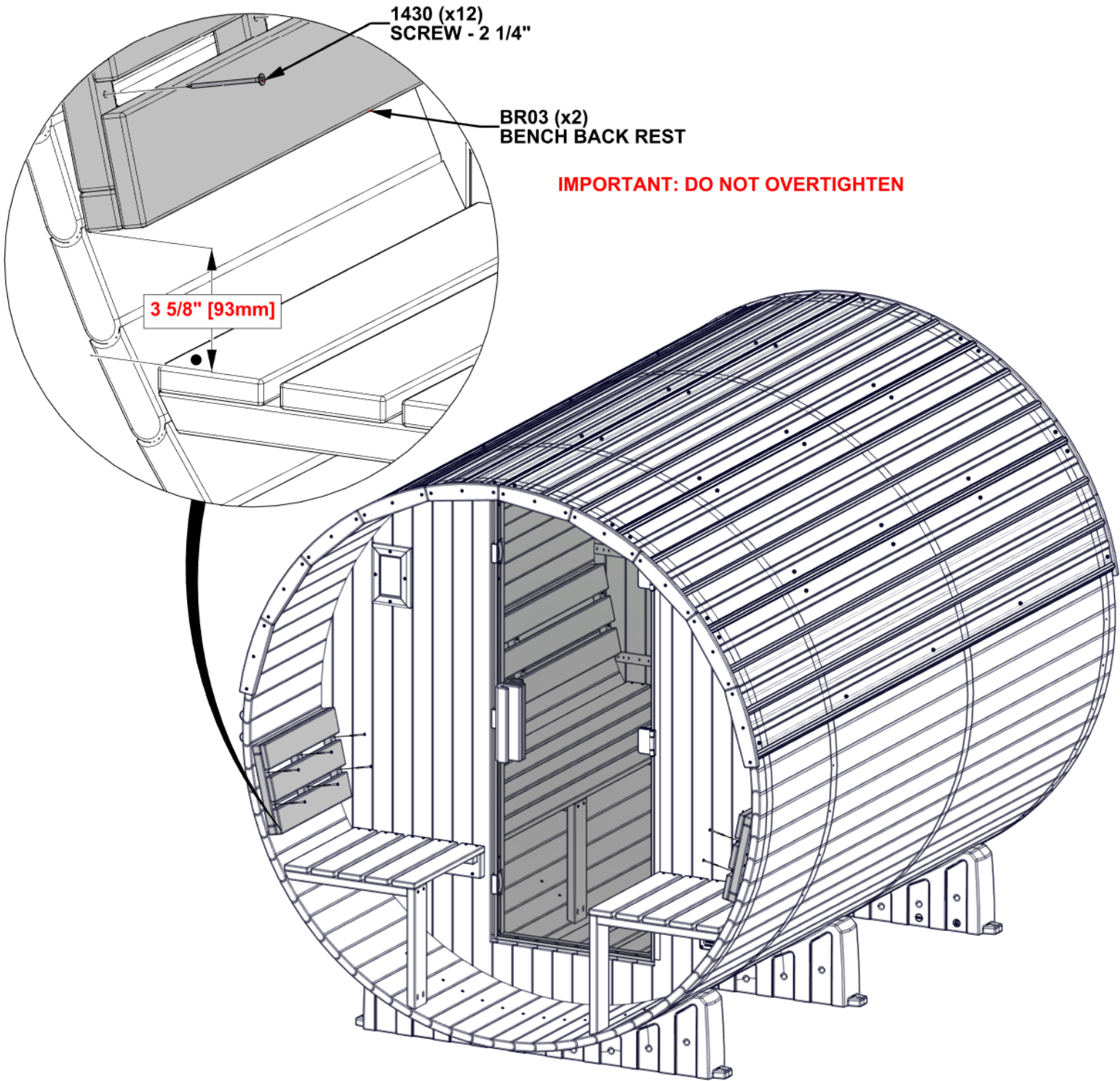
STEP 45 - BENCH ASSEMBLY

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



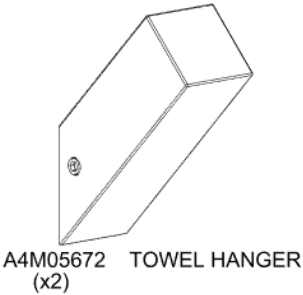
BR03 BENCH BACK REST - W2A04807
(x2) 1 15/16"x12 1/16"x19 3/4" (50x306x502)

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

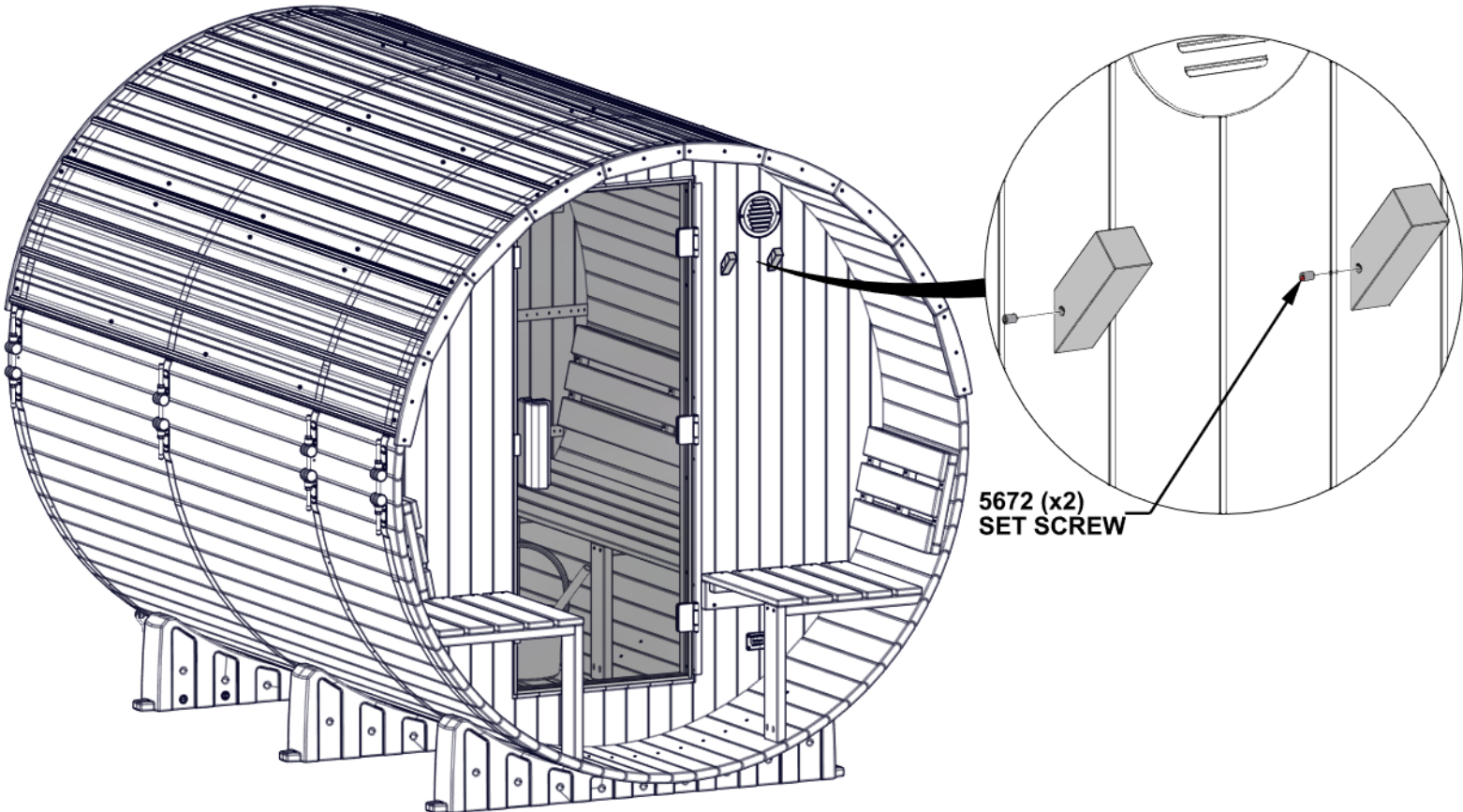
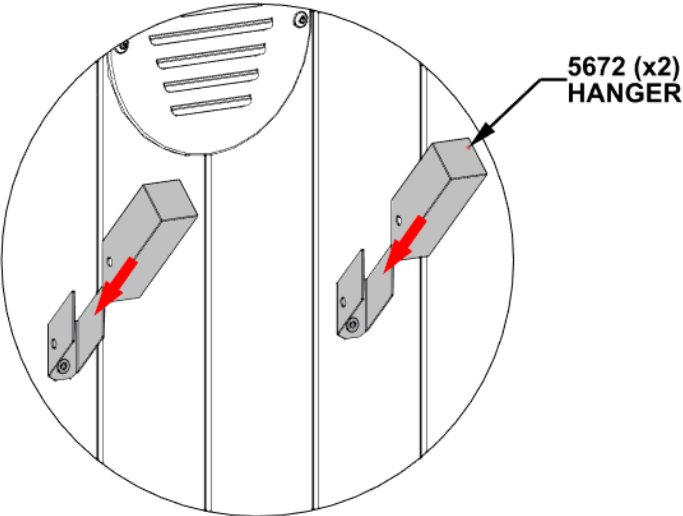
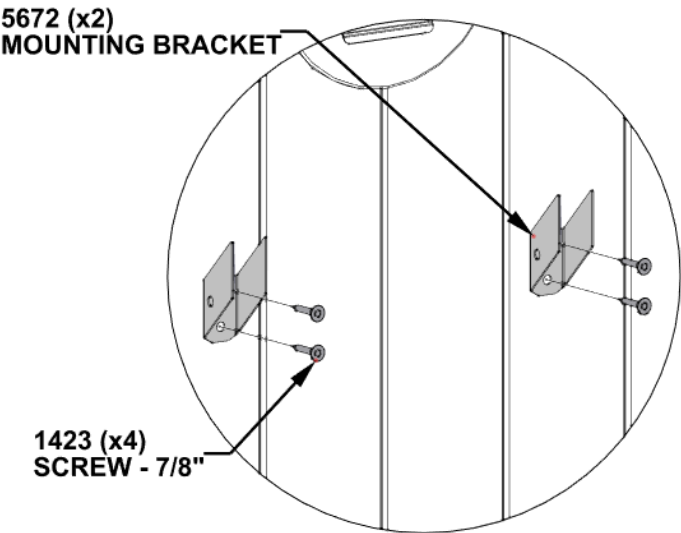


STEP 46 - TOWEL HANGER INSTALLATION

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

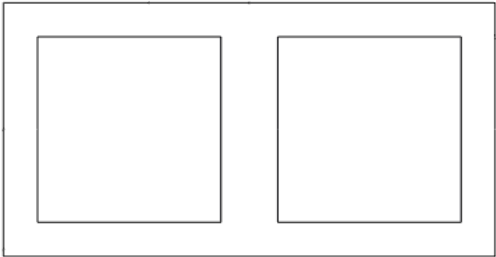


- INSTALL TOWEL HANGERS AT ANY DESIRED LOCATION ON THE RIGHT SIDE.
- HOWEVER, DO NOT INSTALL SCREWS AT THE SEAMS OF PANEL BOARDS.



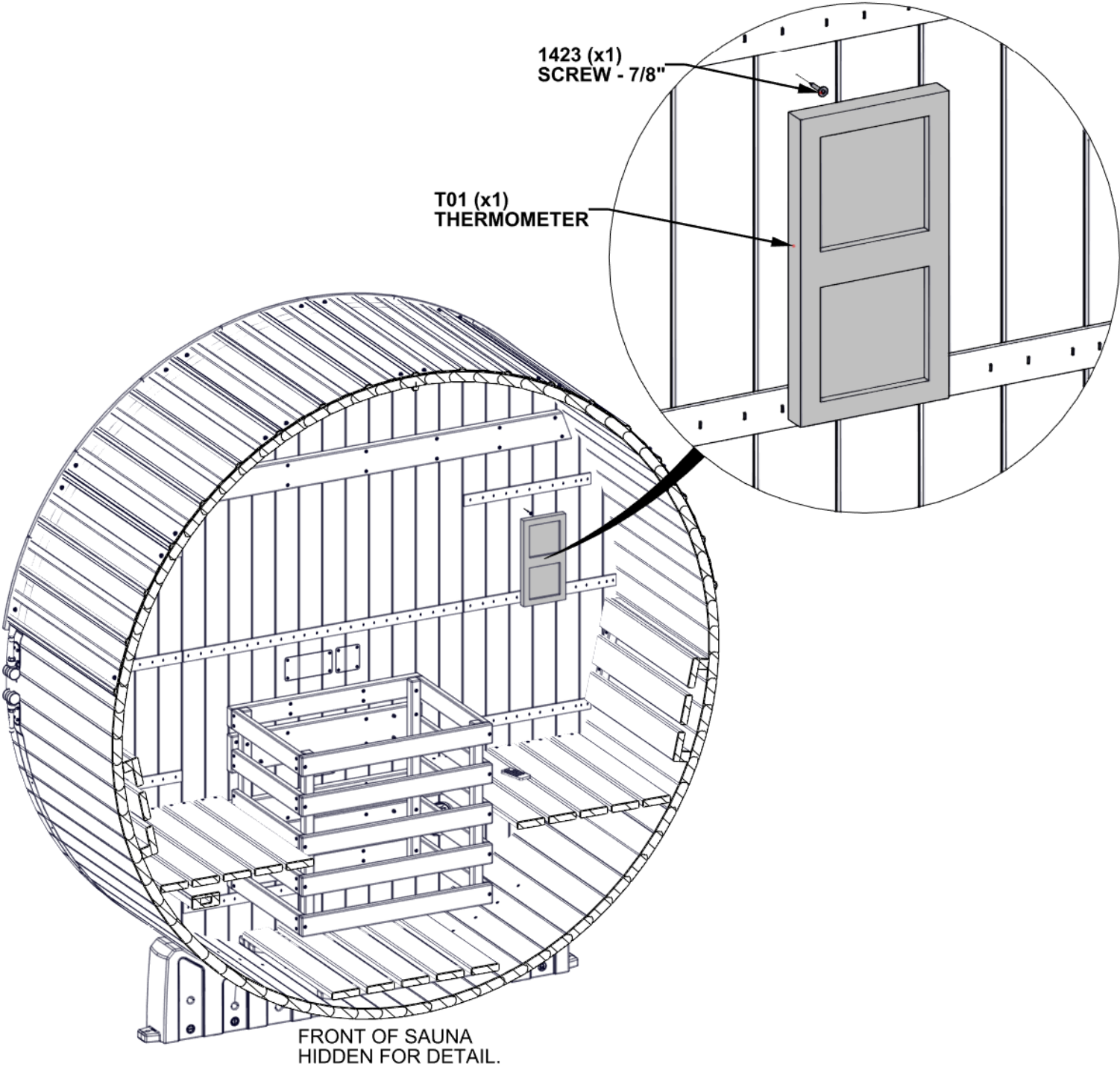
STEP 47 - THERMOMETER INSTALLATION

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

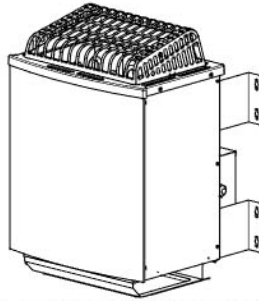


T01 THERMOMETER - W4L21965
(x1)

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

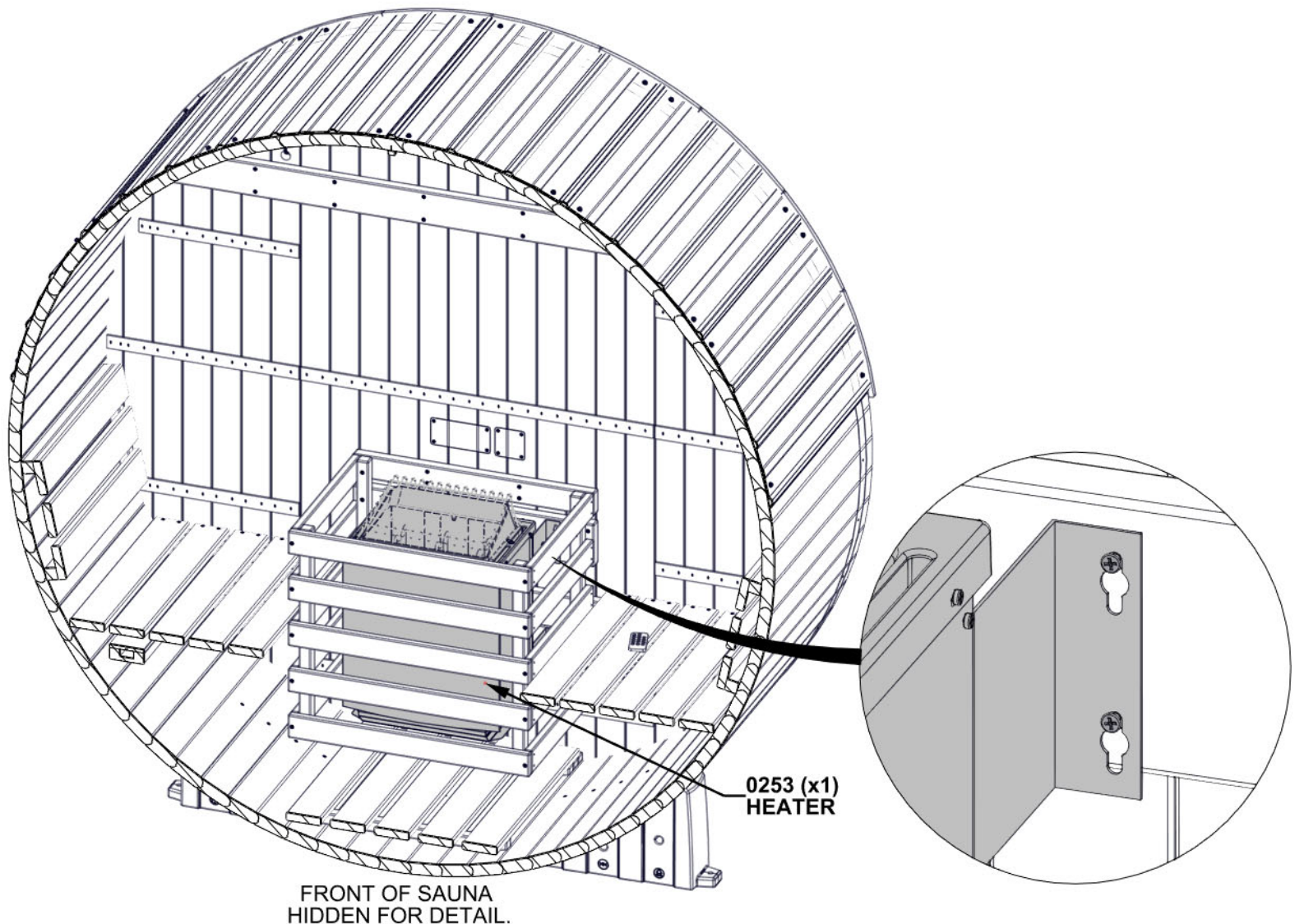


STEP 48A - HEATER INSTALLATION

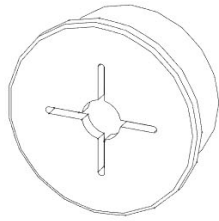


9250253 9KW ELECTRIC SAUNA HEATER
(x1)

- **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

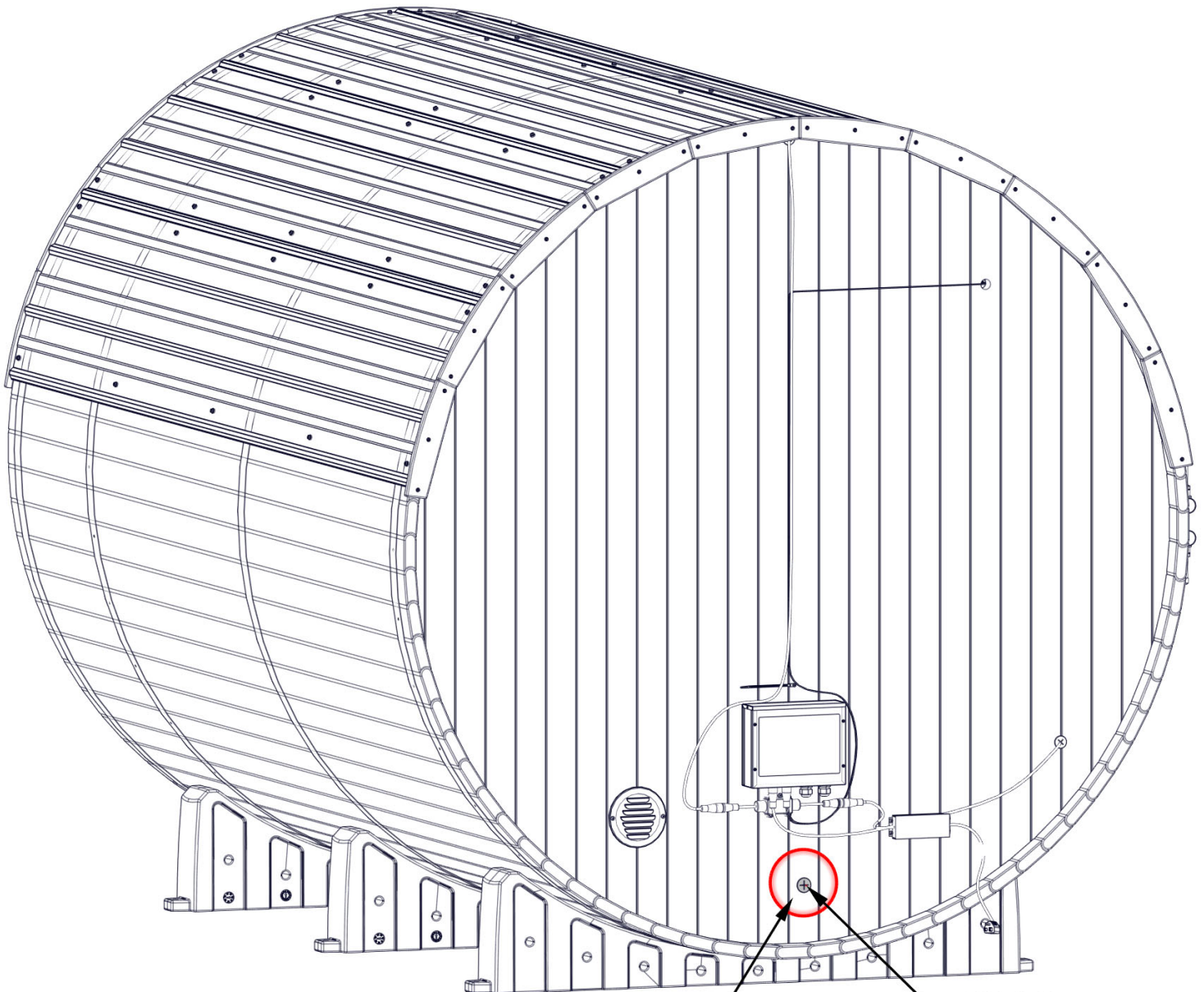


A6P01468 30mm SILICON GROMMET
(x1)



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.



RUN SAUNA POWER WIRE
THROUGH HOLE IN BACK WALL.

1468 (x1)
GROMMET - 30mm

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.

