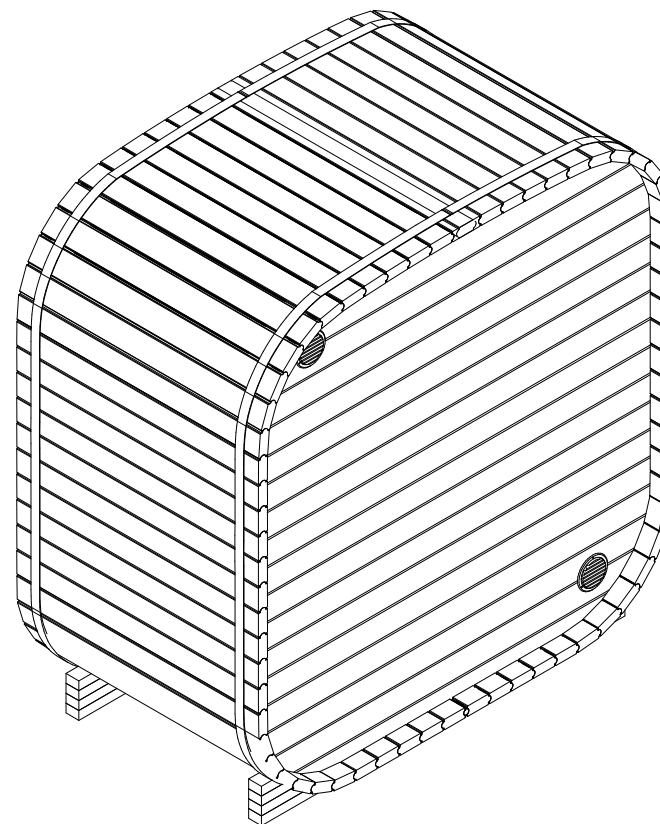
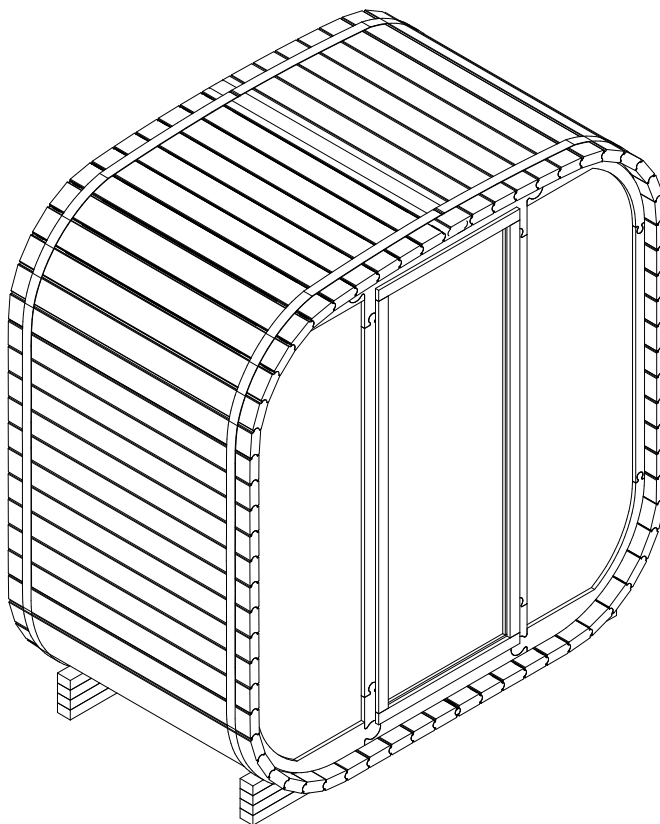


ILLI SAUNA 130

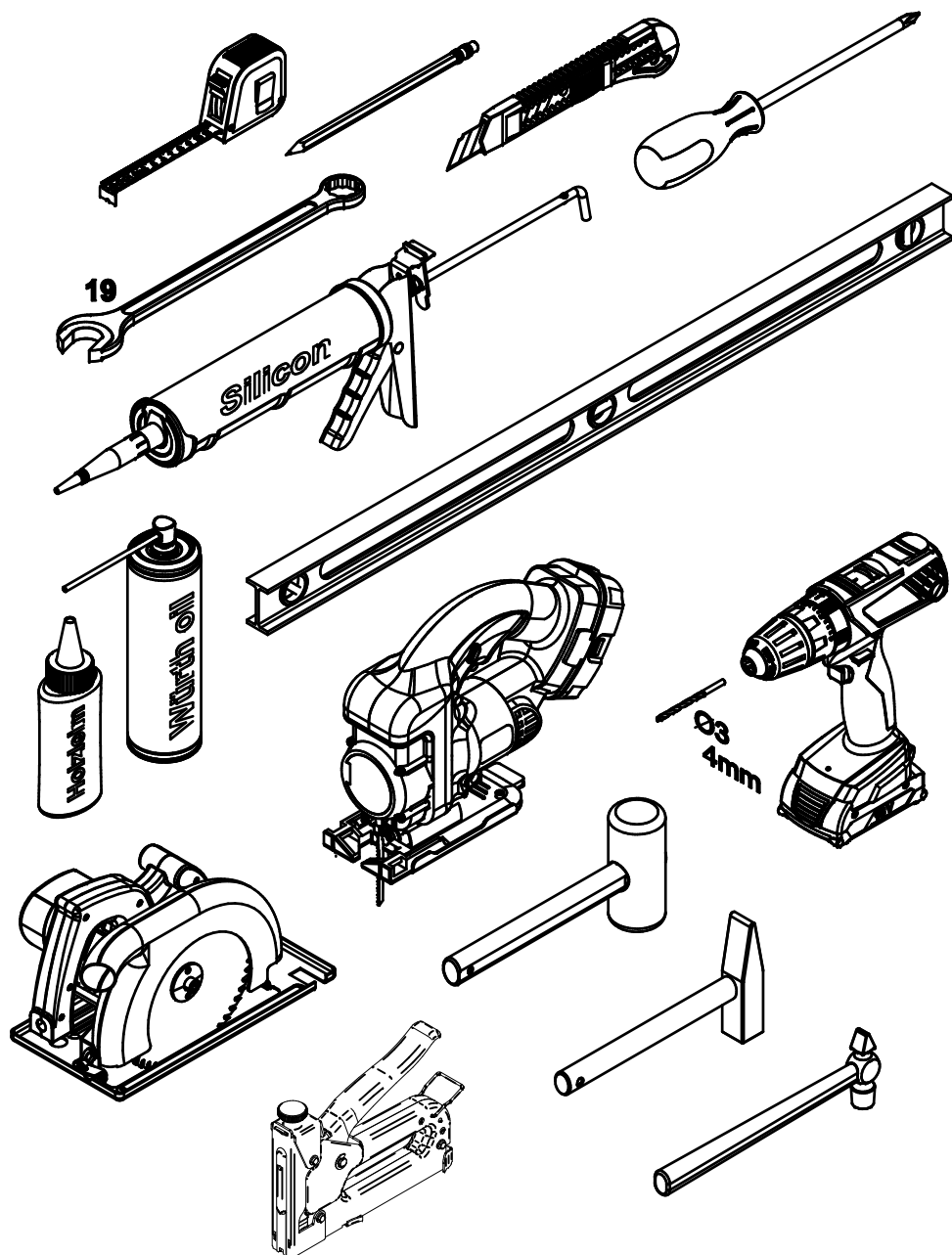


****Before you start assembling the sauna, please make sure all the pieces are there****

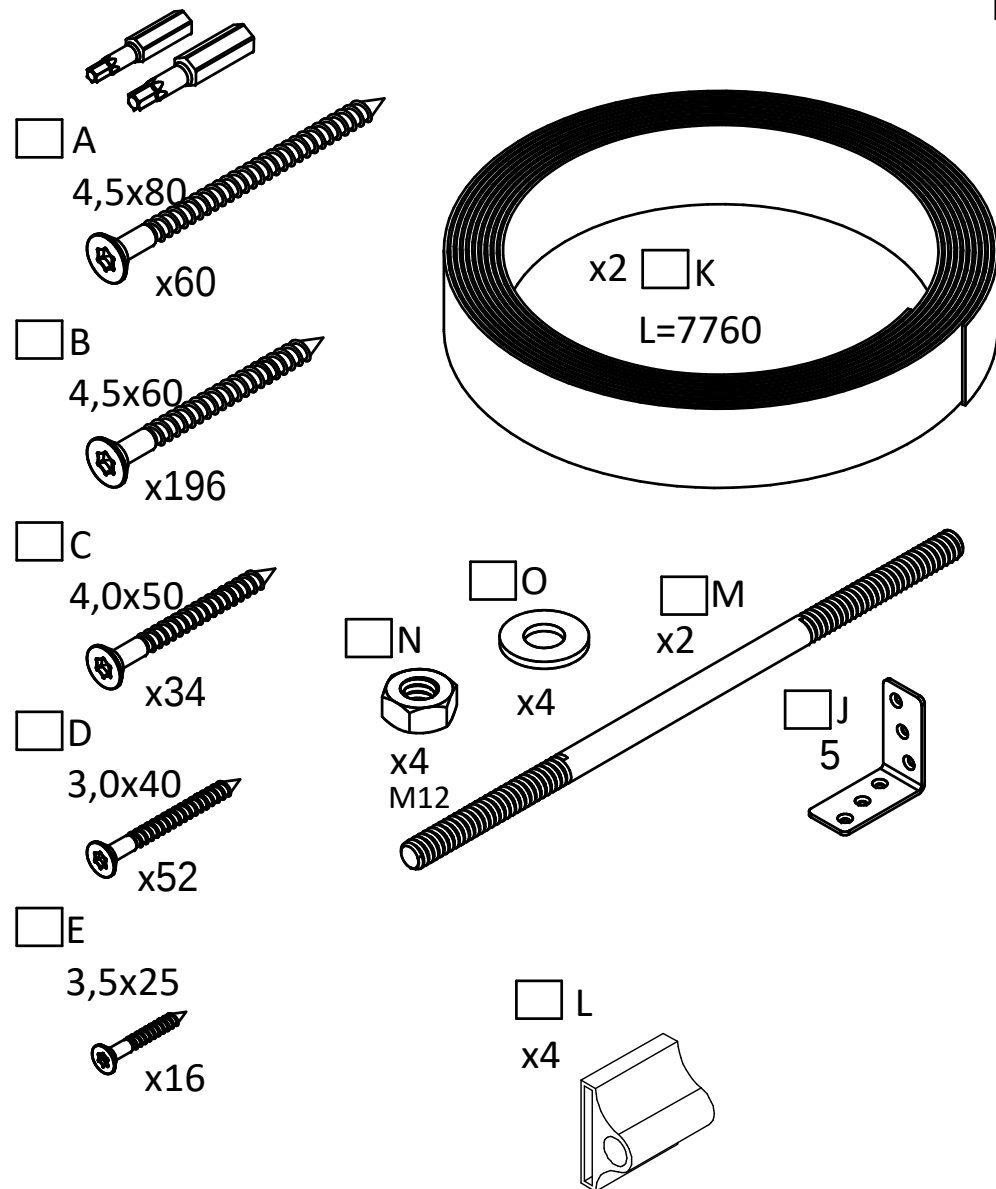
- A sauna barrel can never be 100% tight due to the construction.
- All measurements in mm (millimeter).
- Read the entire manual

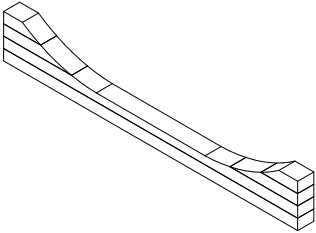
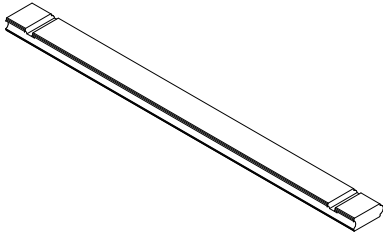
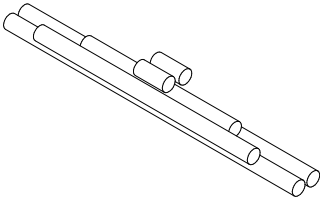
Serial no. : 130ILH2-_____

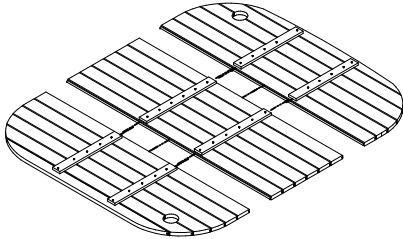
Tools that make your construction easier.
Not included in the delivery.

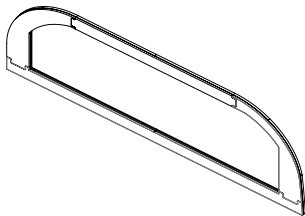
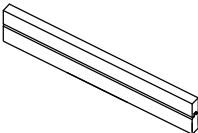
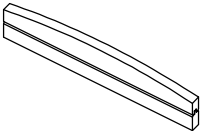


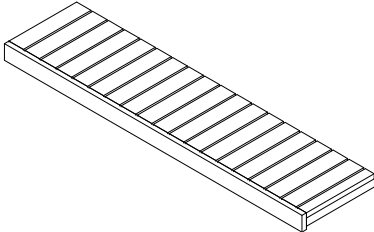
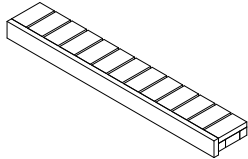
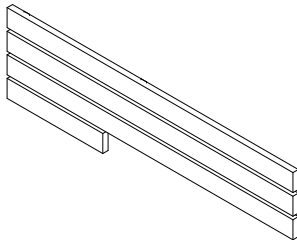
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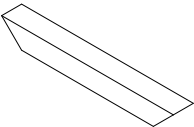
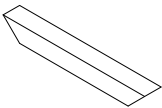
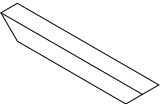
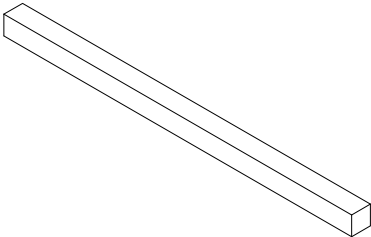
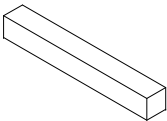


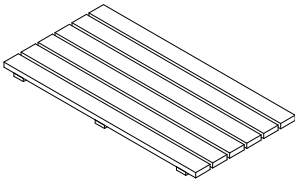
BASE AND FRAME			
No.	L x W x H	Qt	
1	1700x160x60	2	
3	1300x42x103	72 (+1)	
21	D24	kit	

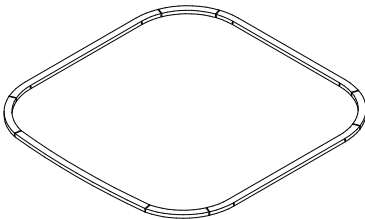
REAR WALL			
No.	L x W x H	Qt	
511	2134x1900x28	kit	

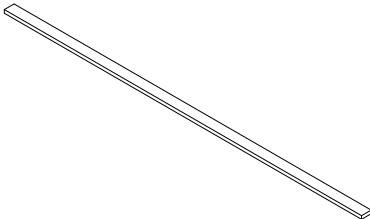
GLASS FRONT WALL			
No.	L x W x H	Qt	
621	PLYWOOD GLASS FRAME	2	
622	610x90x28	1	
623	610x108x28	1	

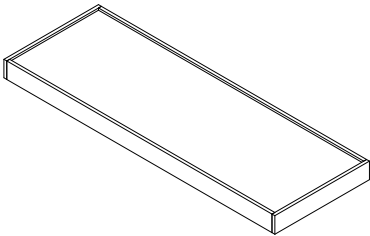
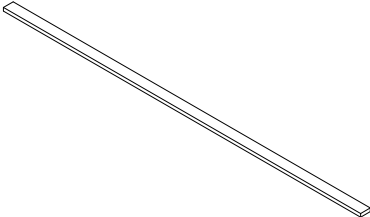
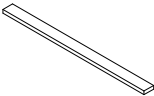
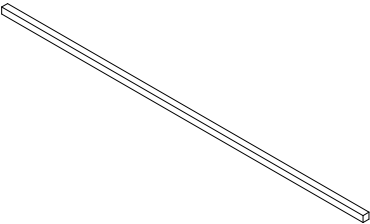
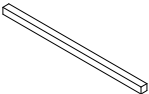
BENCHES AND SKIRTS			
No.	L x W x H	Qt	
81	<u>1855x450x90</u>	1	
83	<u>1290x205x90</u>	1	
85	<u>1850x408</u>	1	
99	<u>60x28x28</u>	8	
			4.

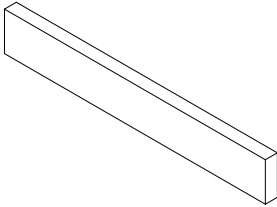
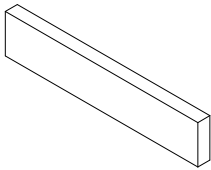
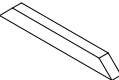
BENCH SUPPORTS			
No.	L x W x H	Qt	
91	<u>300x44x44</u>	2	
92	<u>133x44x44</u>	1	
93	<u>250x44x44</u>	2	
96	<u>813x44x44</u>	2	
97	<u>334x44x44</u>	2	

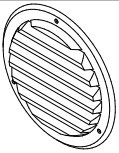
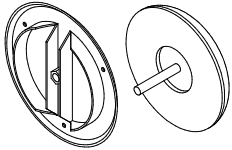
BENCH SUPPORTS AND FLOOR GRID			
No.	L x W x H	Qt	
98	<u>120x44x44</u>	2	
71	<u>1195x595</u>	1	
			5.

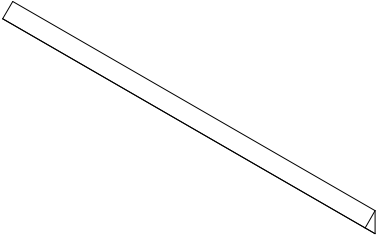
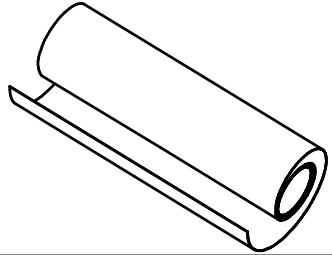
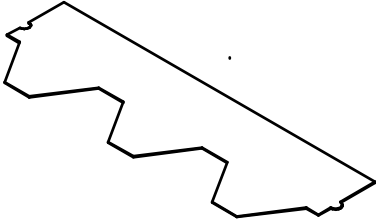
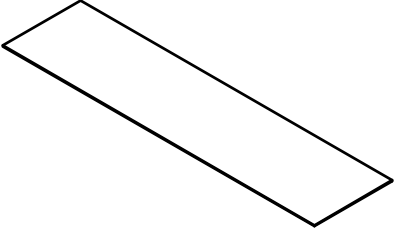
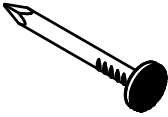
COVER ARCHES			
No.	L x W x H	Qt	
151	COVER ARCHES	KIT	

EXTRA PARTS FOR WALL ASSEMBLING (profile may vary)			
No.	LENGTH	Qt	
E1	1850mm	3	

DOOR AND TRIMS			
No.	L x W x H	Qt	
101	1920x590x92	1	
102	1900x45x15	2	
103	660x45x15	2	
104	1920x28x28	2	
105	646x28x28	2	

HEATER GUARD			
No.	L x W x H	Qt	
88	605x90x28	3	
89	450x90x28	1	
90	300X40X28	1	

VENTILATION			
No.	L x W x H	Qt	
901	AIR VENT	3	
902	AIR VENT	1	

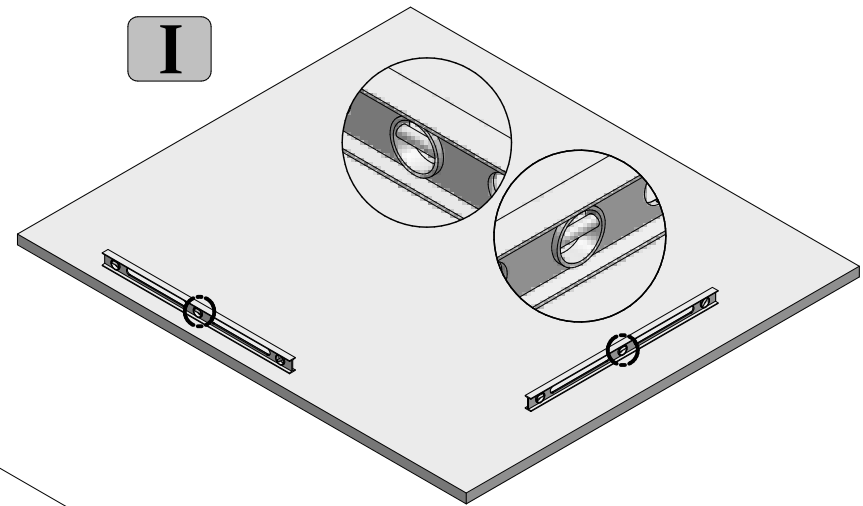
ROOFING			
No.	L x W x H	Qt	
4	1300x44x44	2	
141	4000x1500	1	
142	1000x320	51	
143	1000x250	2	
H	NAILS	KIT	 7.

FOUNDATION PLAN

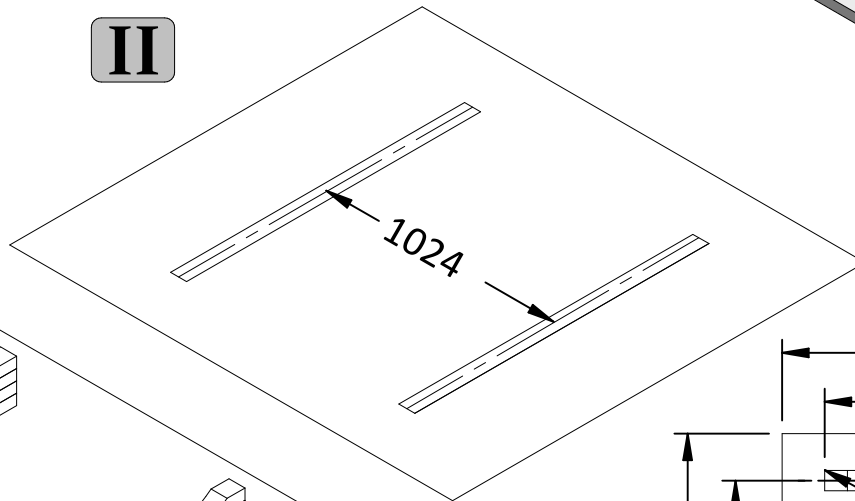
I - Make sure the foundation is leveled

II - Mark down the cradles position

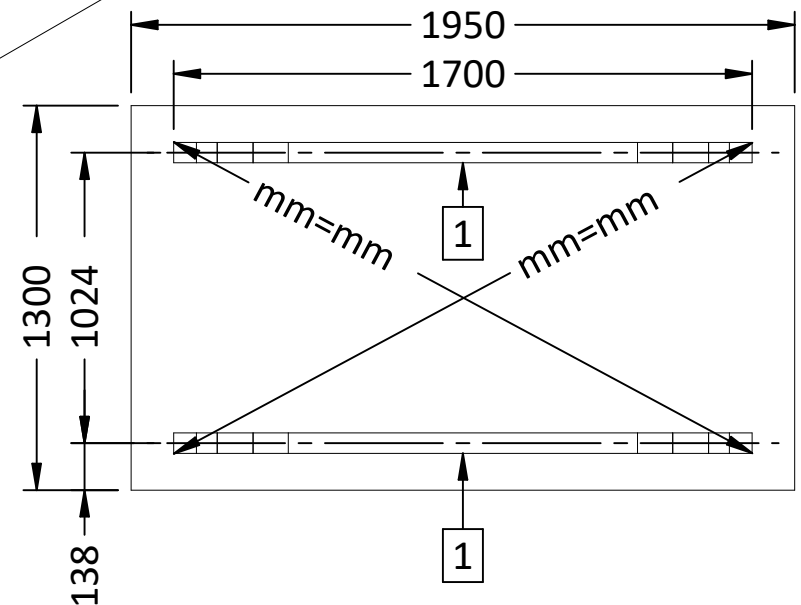
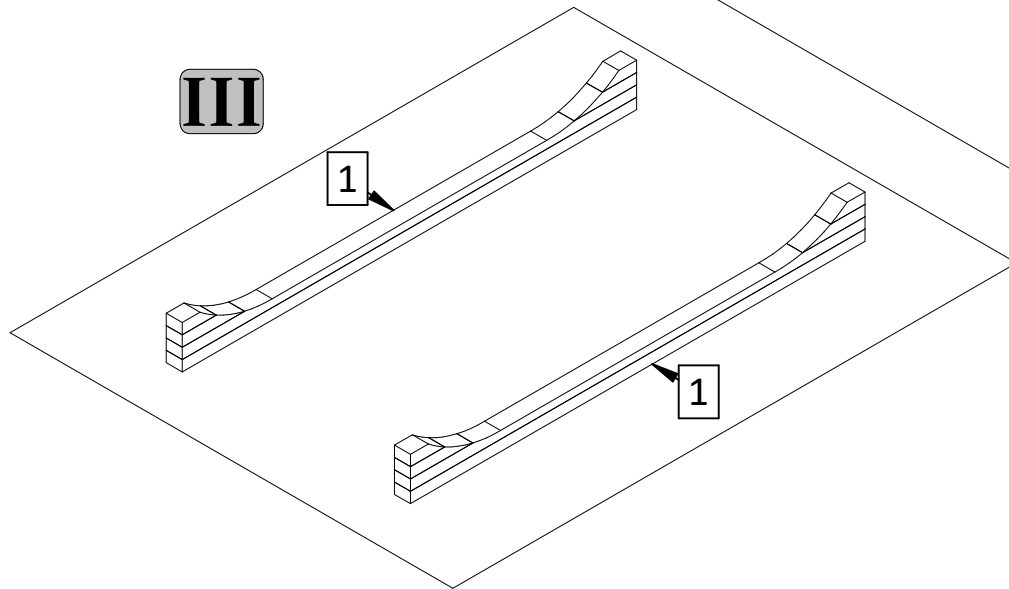
III - Position the cradles



II



III

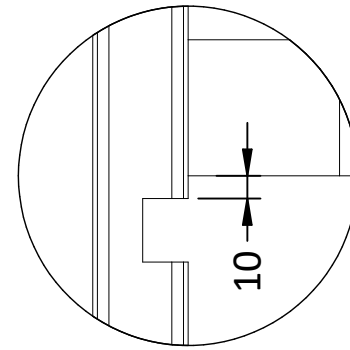
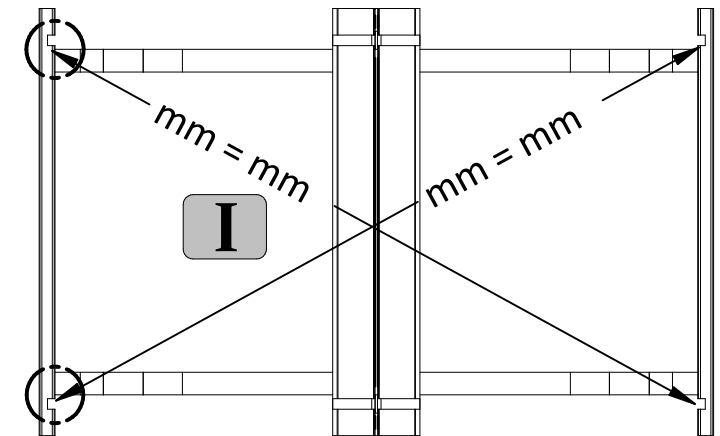
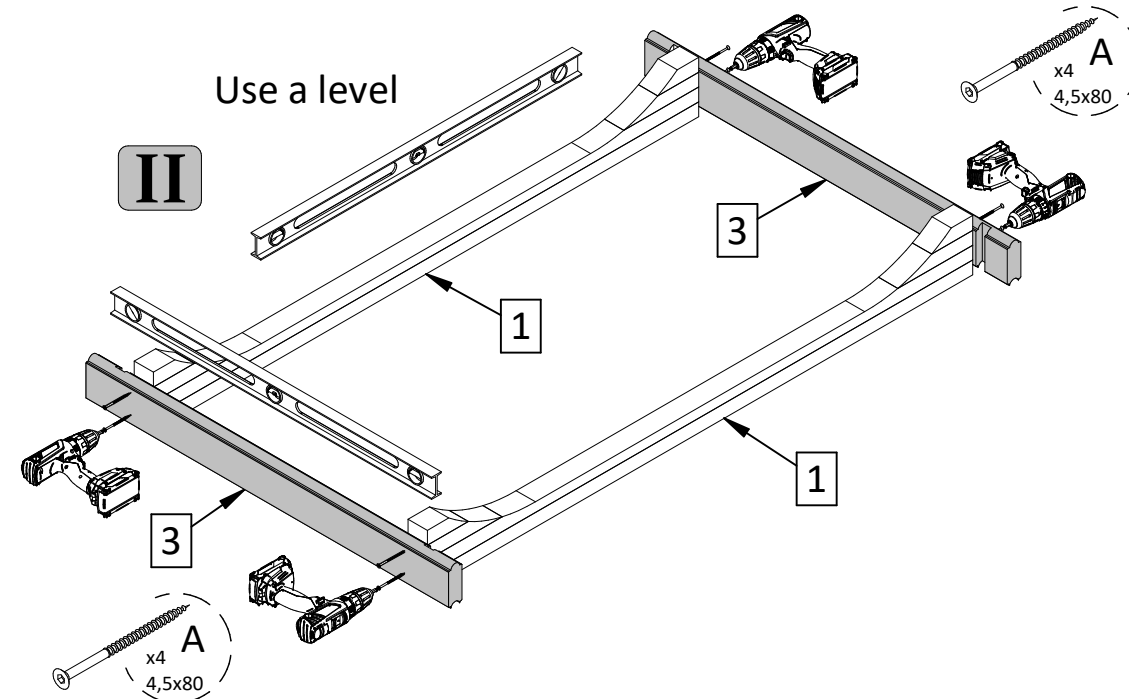
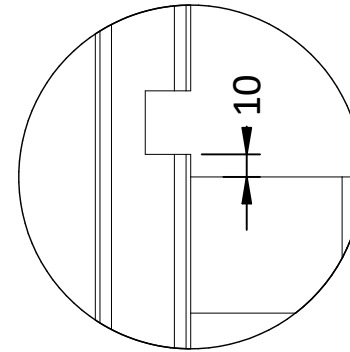


CRADLES SETUP

I - Place two cradles parallel to each other and next to them 2 staves to form a square. Cradles have to stay 10mm inwards from the stave groove (check drawing I in the circle). Measure the diagonals from opposite corners - they have to be equal in length.

II - Check if the cradles and staves are in one level.

III -Connect the staves and the cradles temporarily with screws. Later on you have to remove the staves.

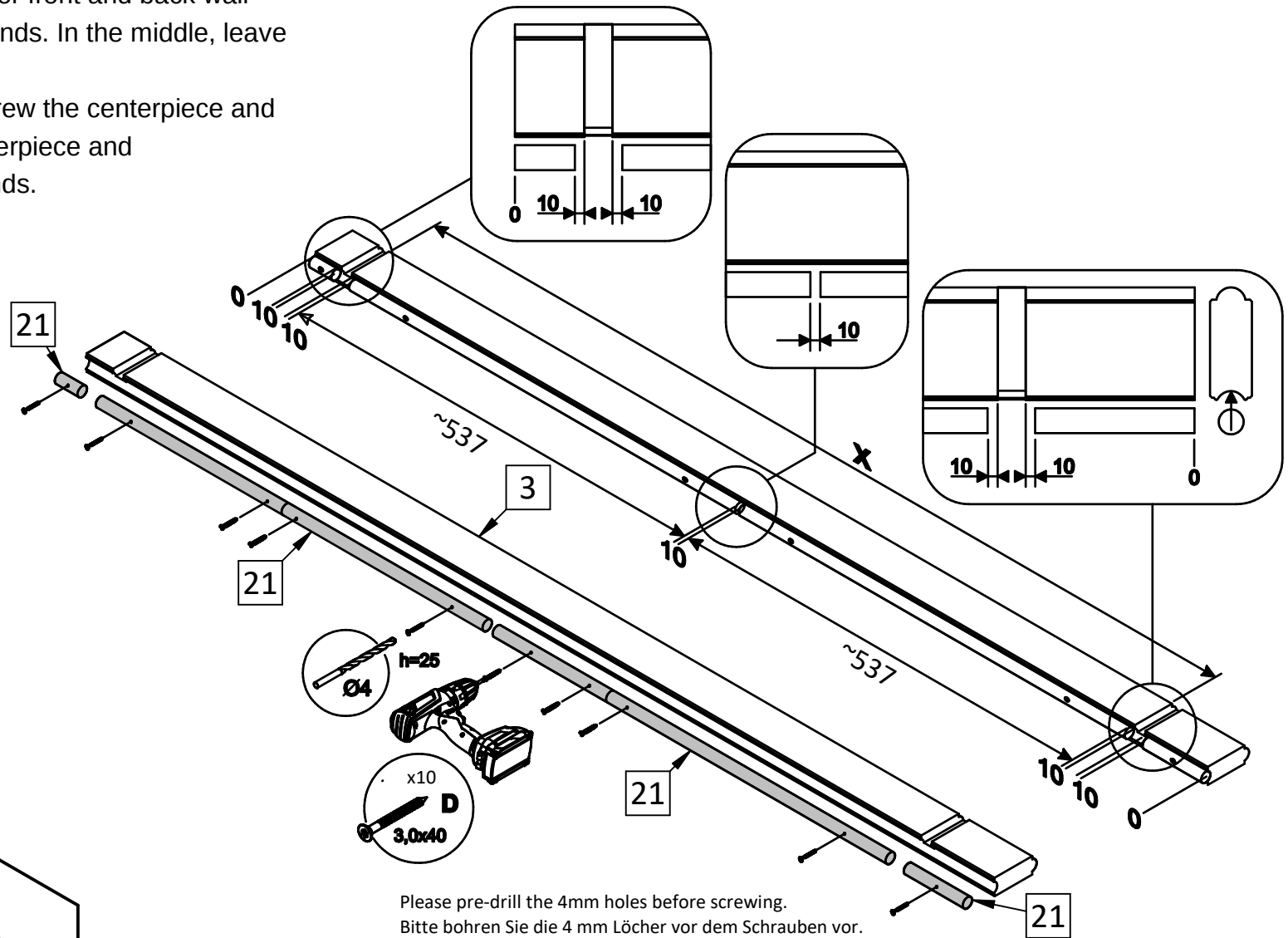
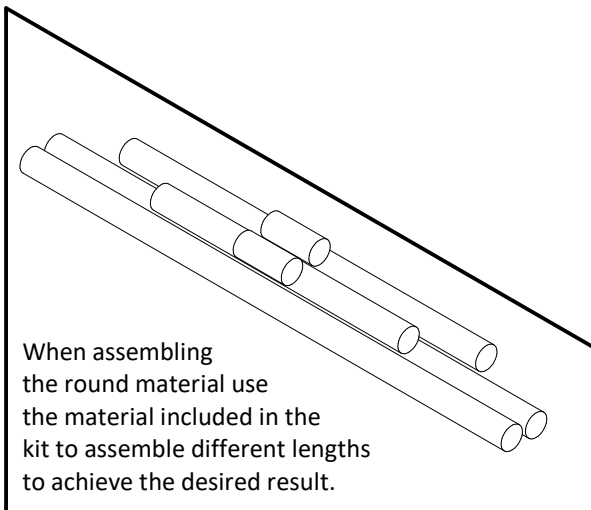


POSITIONING THE CENTERPIECE

I - Use the round shape sticks to make the bottom centerpiece (marked as 21).

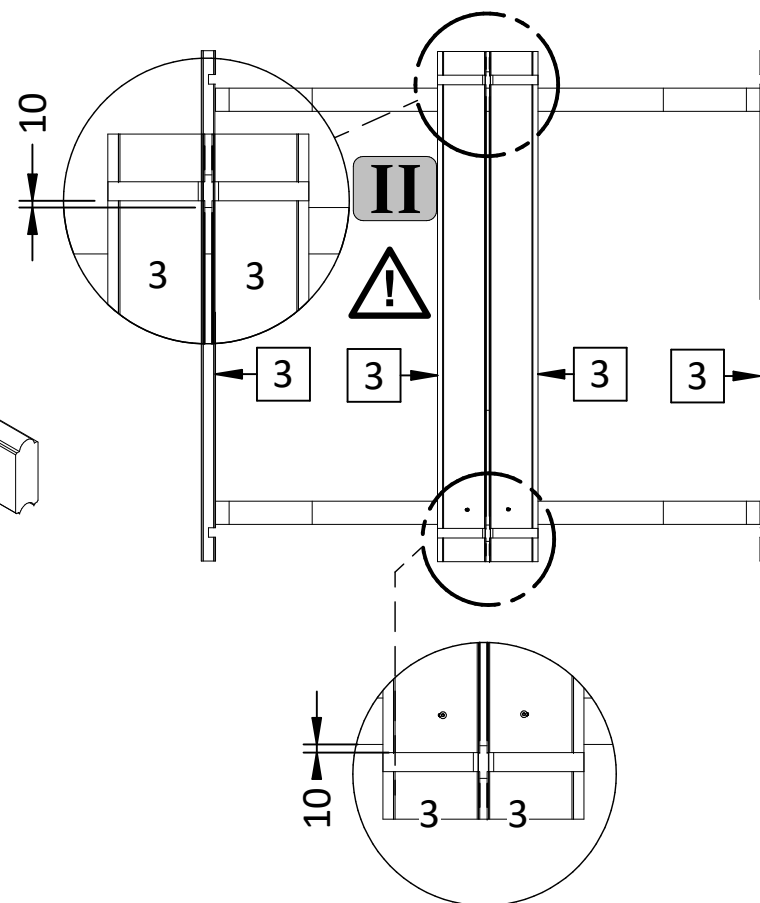
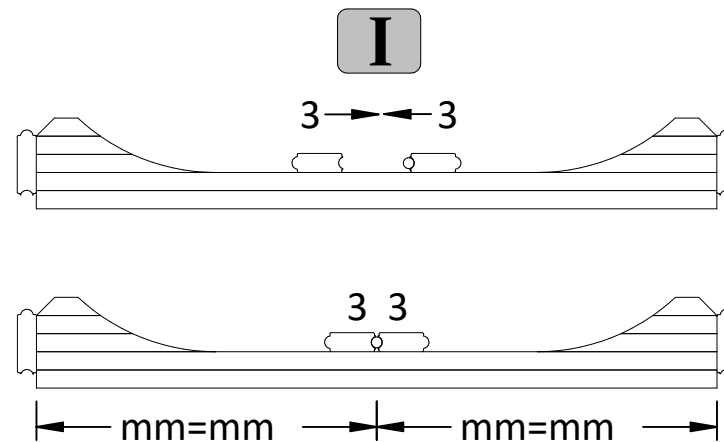
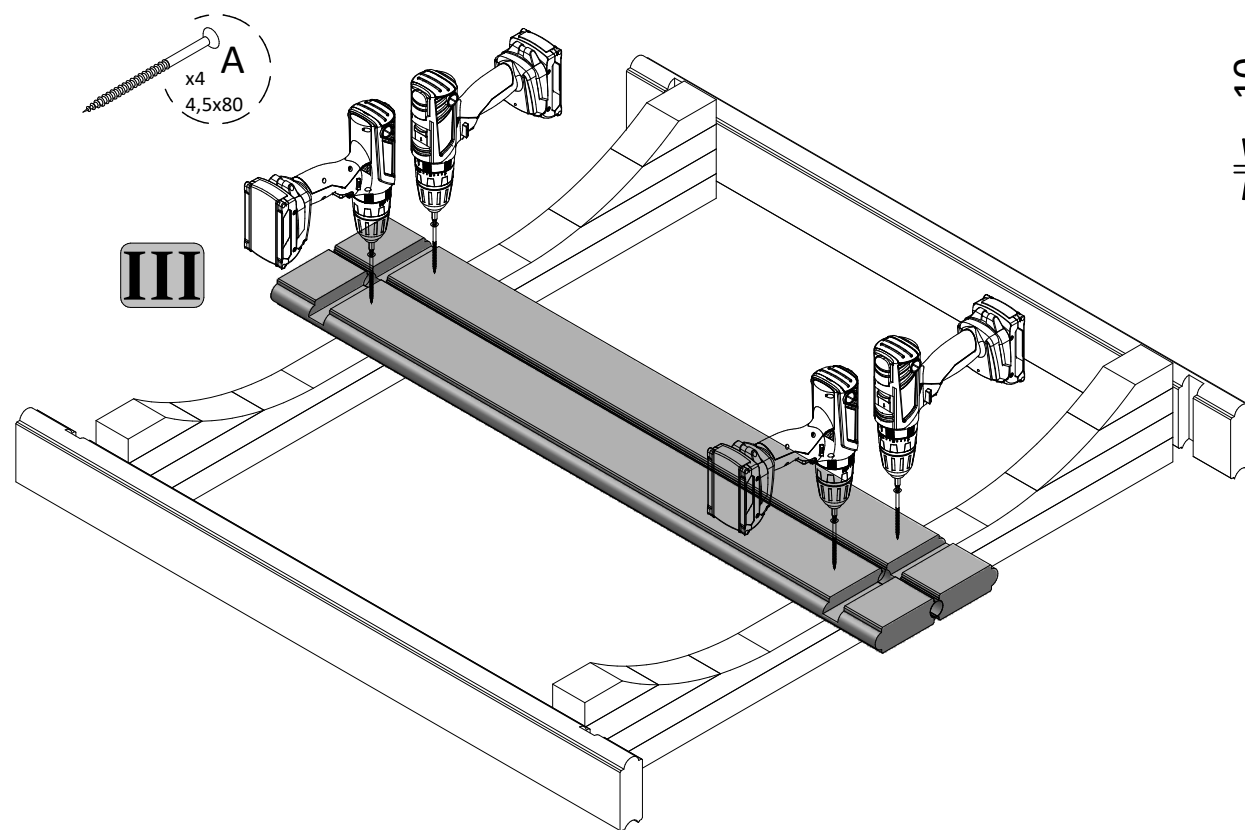
II - Within centerpiece leave gaps for front and back wall groove. Add extra 10mm on both ends. In the middle, leave a 10mm gap for a water drainage.

III - Predrill the screw holes and screw the centerpiece and one stave to each other. Both centerpiece and the stave has to be flush in both ends.



SECURE BOTTOM STAVES AND CENTERPIECE.

Make sure that the centerpiece is in the middle. Start placing more staves and fixing them to the cradle with screws.

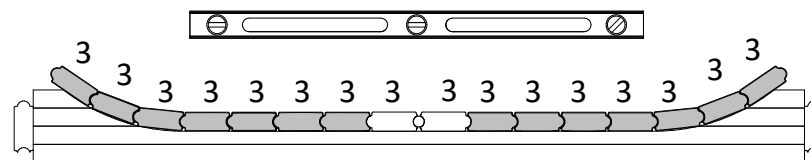
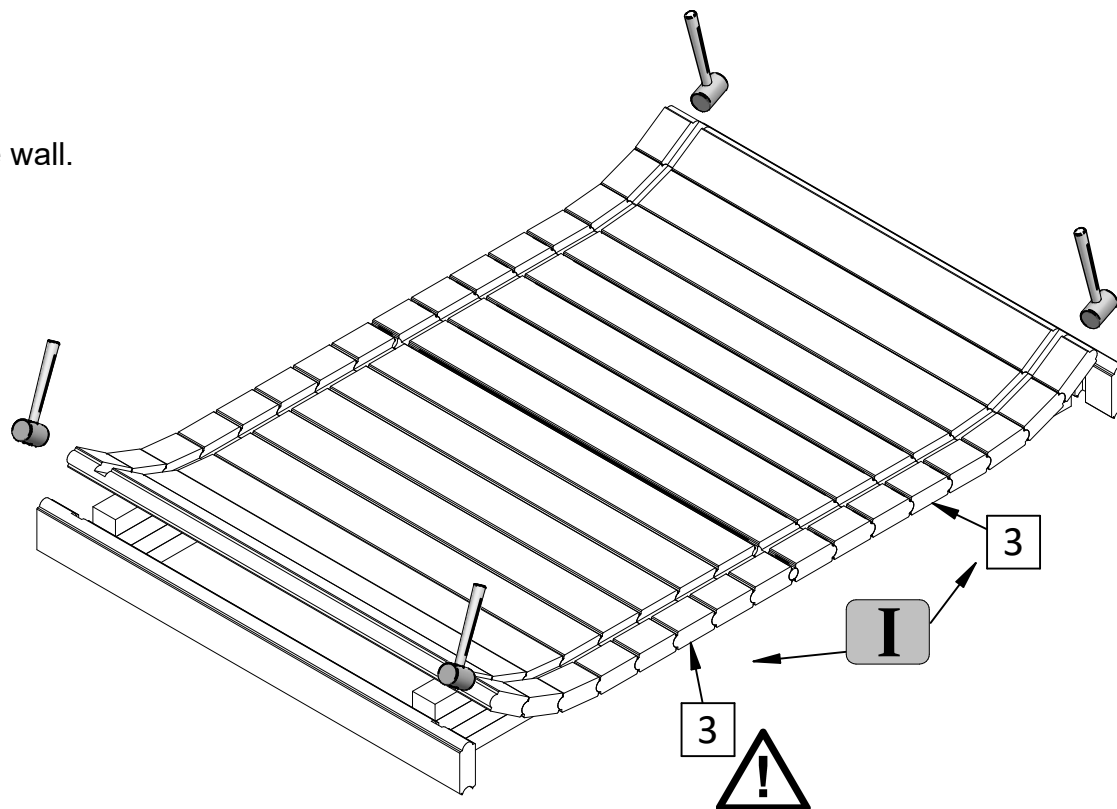
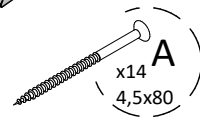
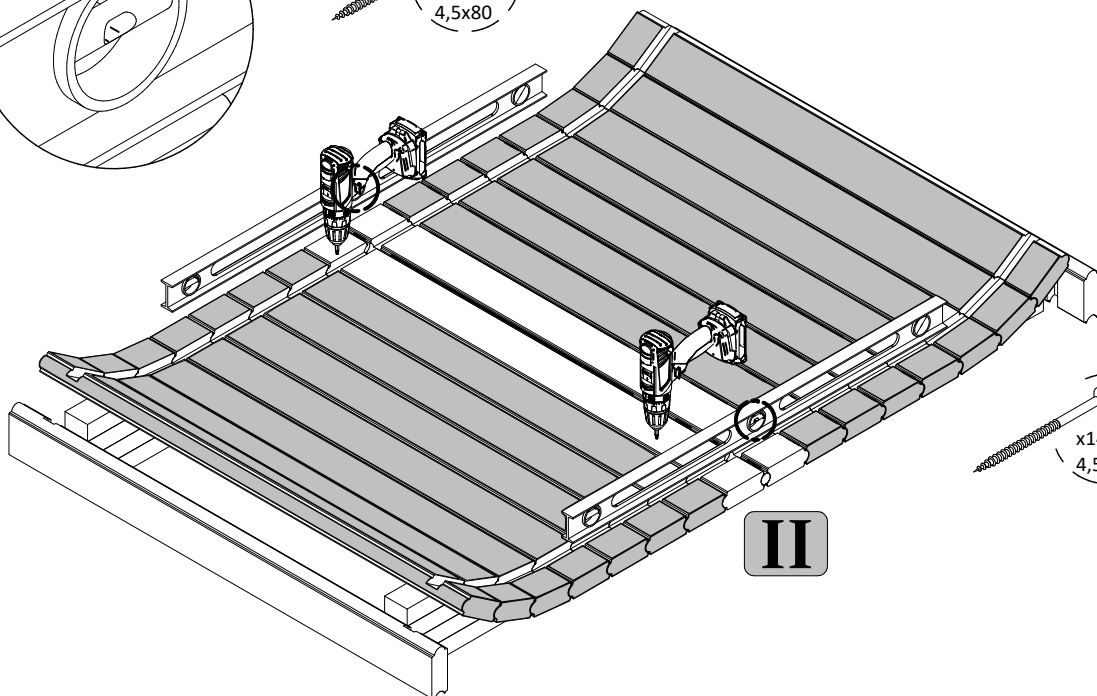
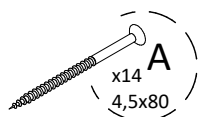
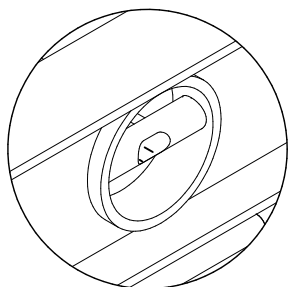


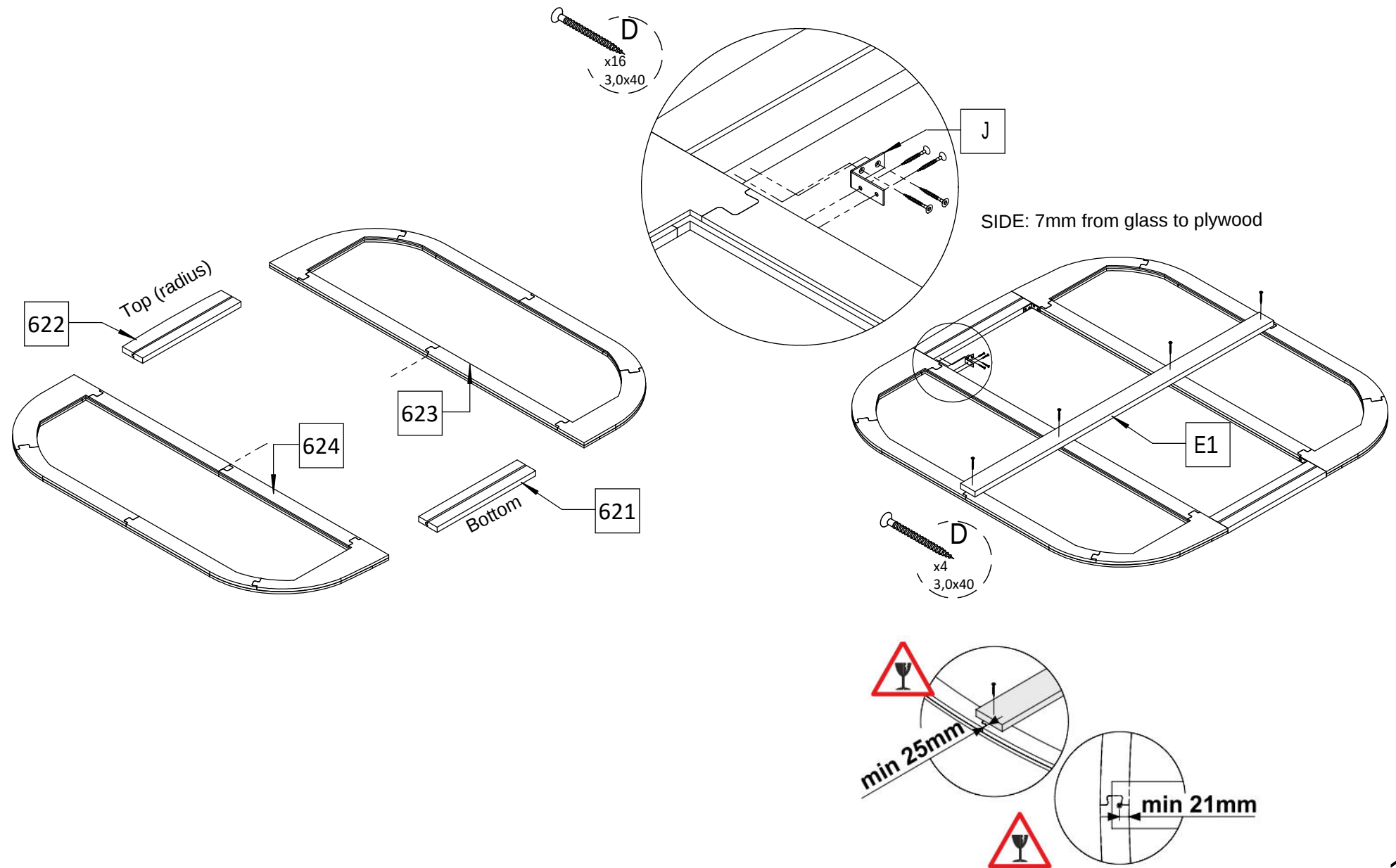
ADD MORE STAVES TO THE BOTTOM.

I - Tap the staves gently in with rubber mallet.

II - Make sure they are evenly levelled with the opposite side of the wall.

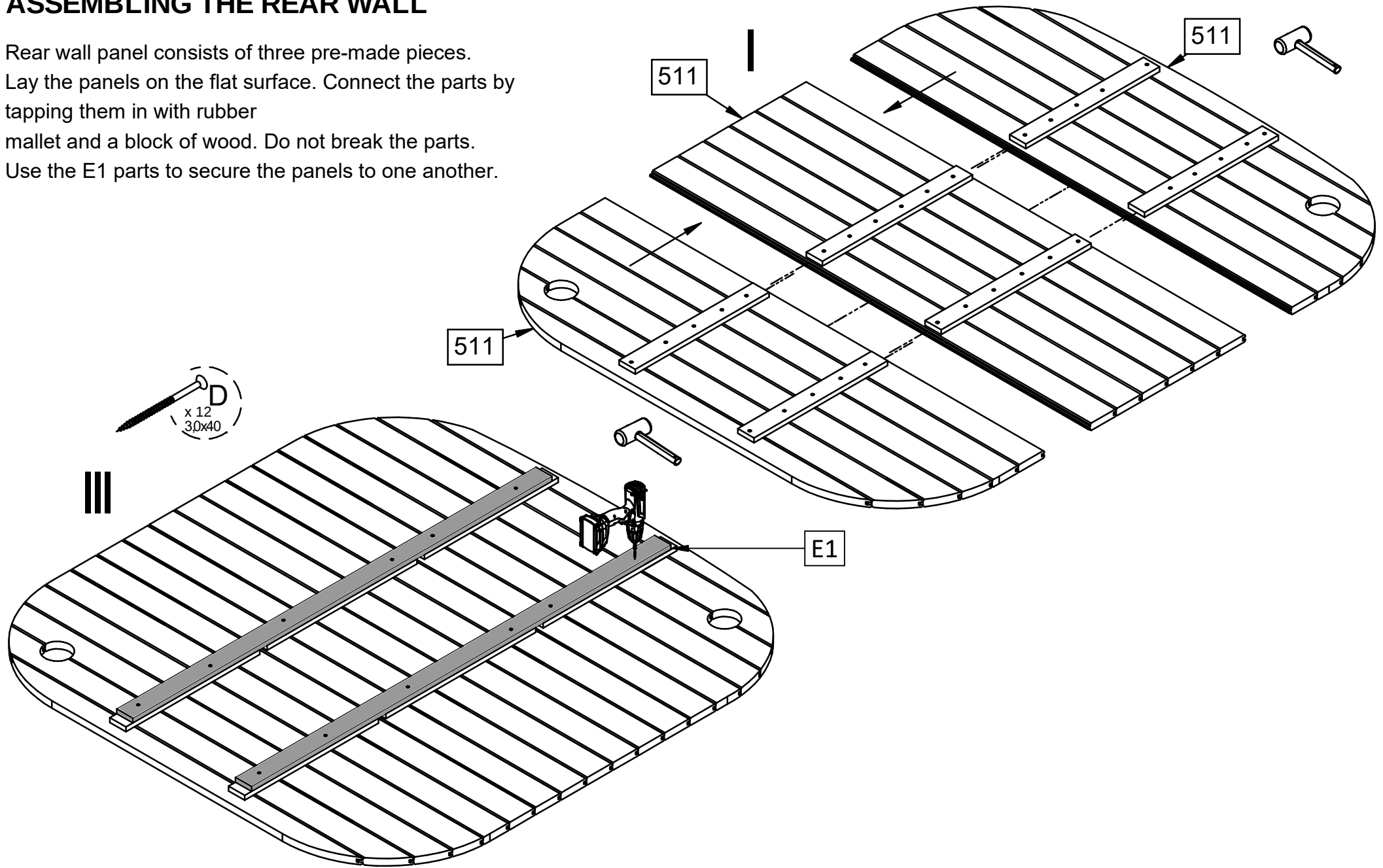
Use a level





ASSEMBLING THE REAR WALL

Rear wall panel consists of three pre-made pieces.
Lay the panels on the flat surface. Connect the parts by
tapping them in with rubber
mallet and a block of wood. Do not break the parts.
Use the E1 parts to secure the panels to one another.



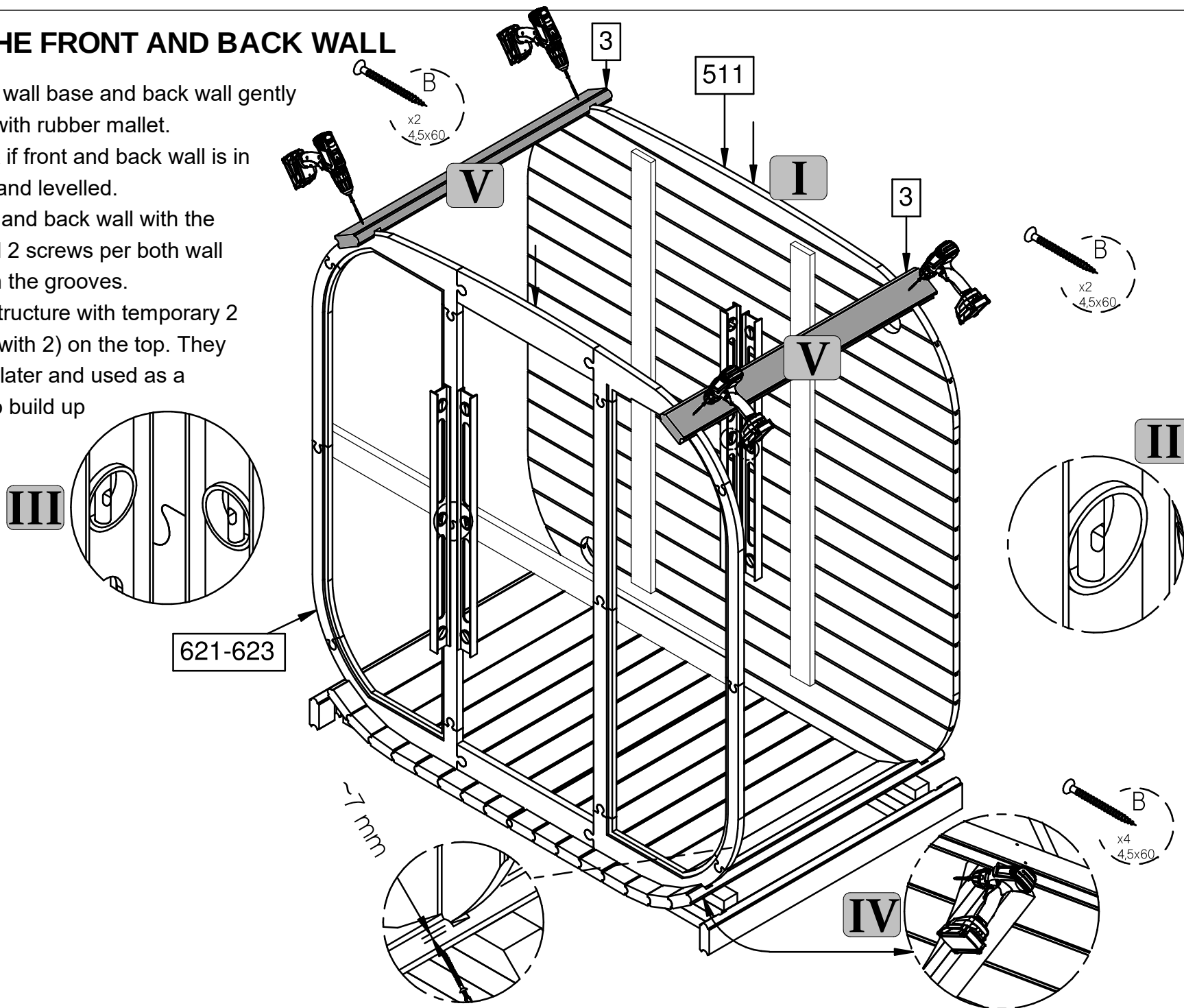
INSTALL THE FRONT AND BACK WALL

I - Tap the front wall base and back wall gently into the groove with rubber mallet.

II and III - Check if front and back wall is in upright position and levelled.

IV - Fix the front and back wall with the bottom part. Drill 2 screws per both wall from underneath the grooves.

V - Secure the structure with temporary 2 staves (marked with 2) on the top. They will be removed later and used as a regular staves to build up the sauna body.



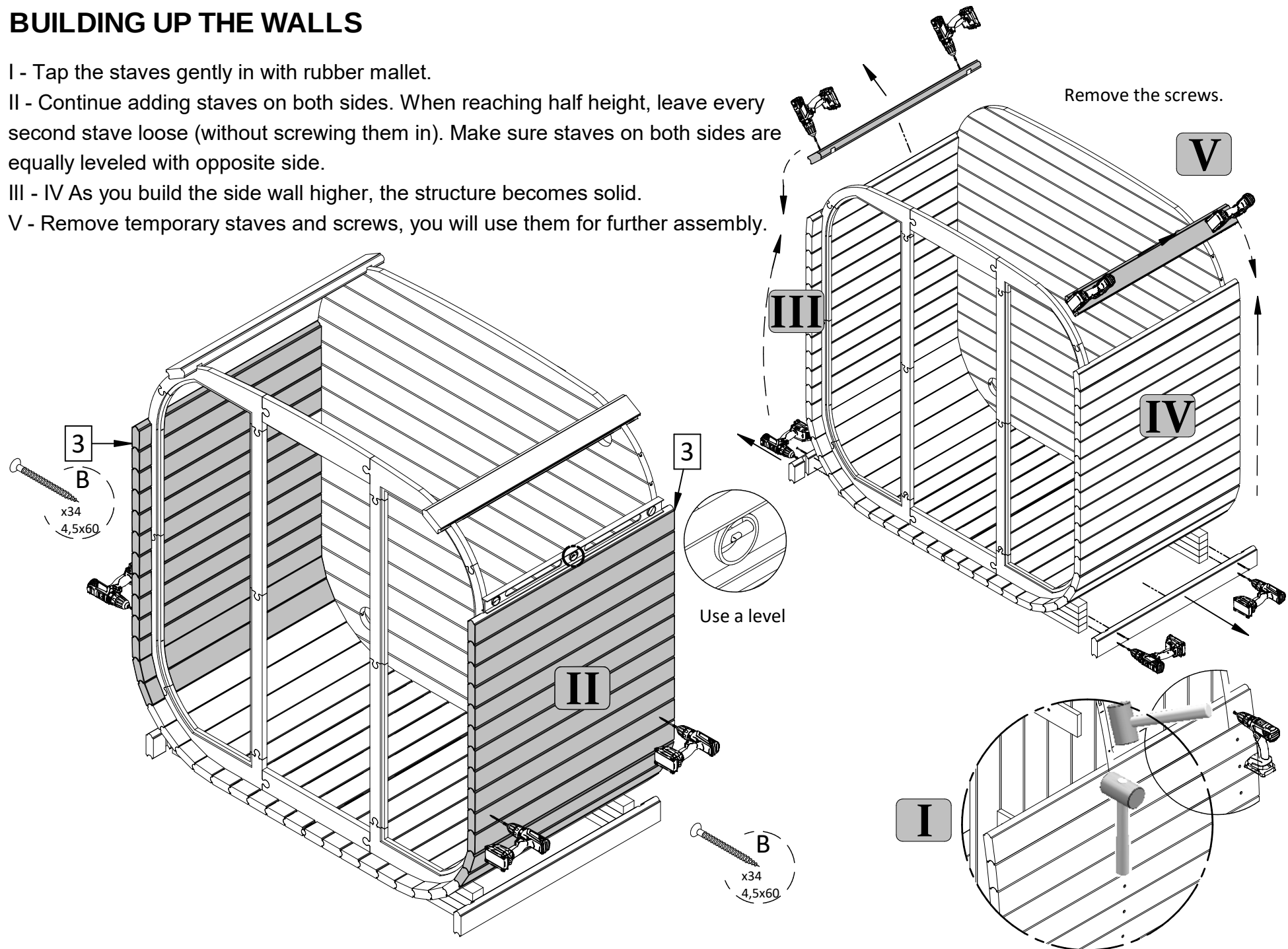
BUILDING UP THE WALLS

I - Tap the staves gently in with rubber mallet.

II - Continue adding staves on both sides. When reaching half height, leave every second stave loose (without screwing them in). Make sure staves on both sides are equally leveled with opposite side.

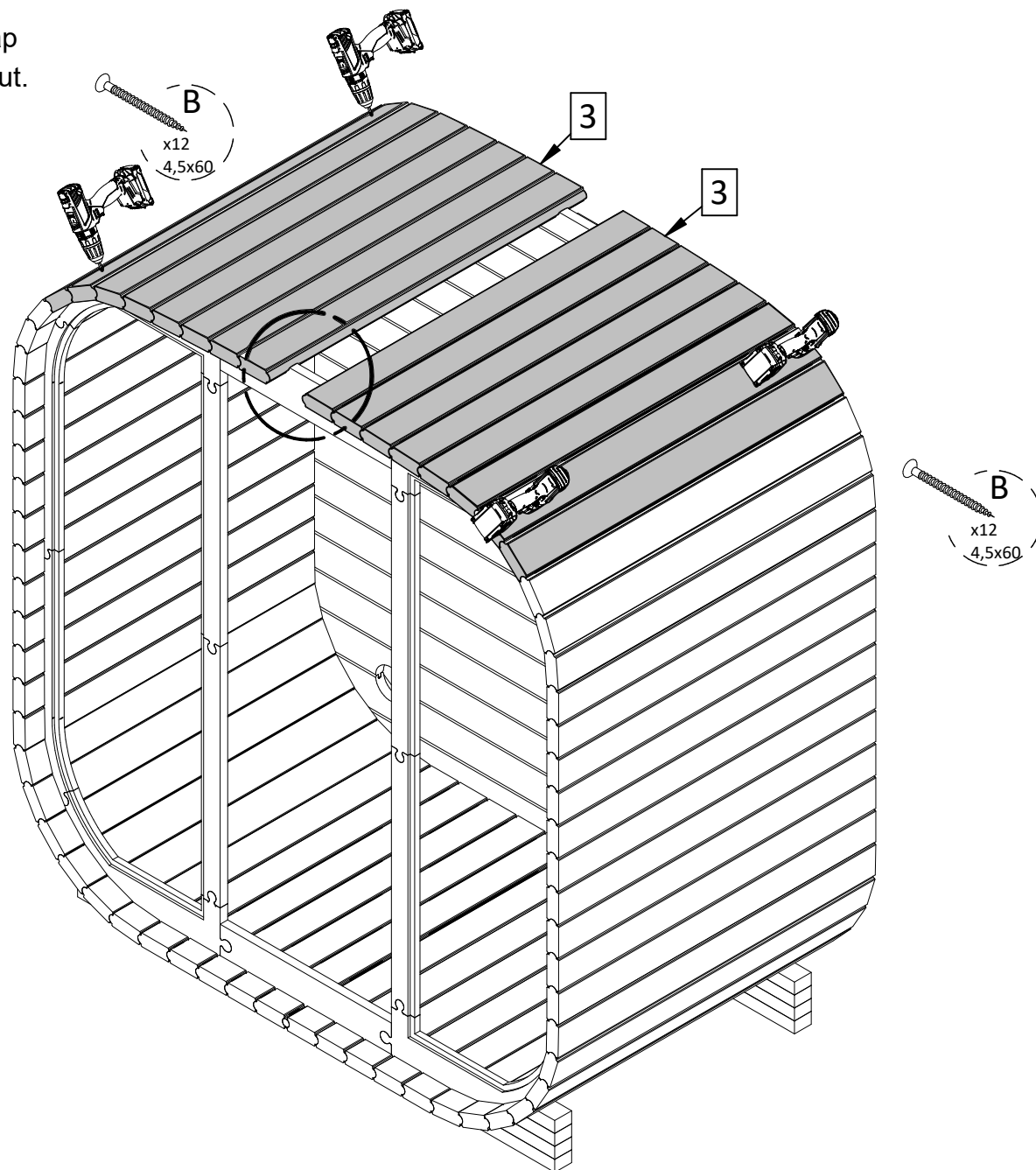
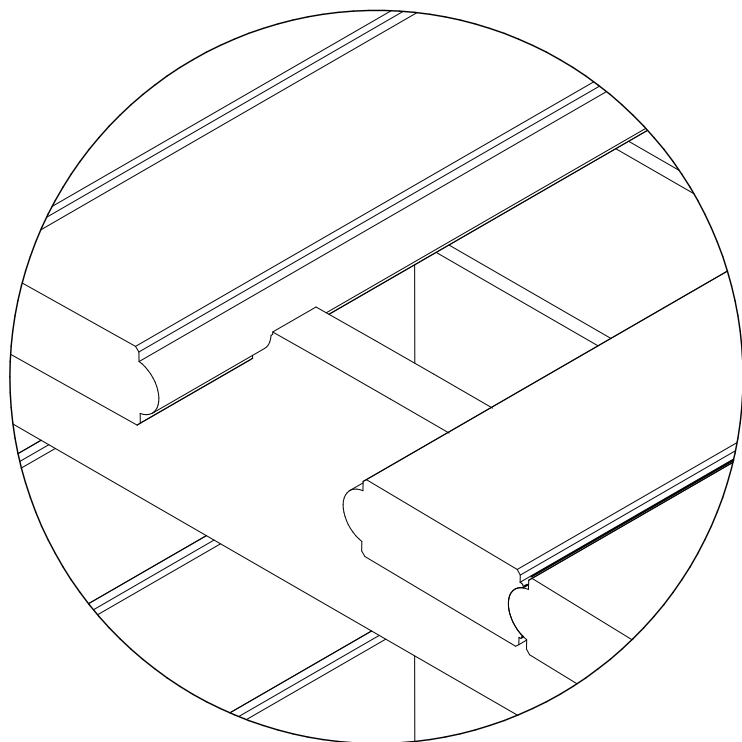
III - IV As you build the side wall higher, the structure becomes solid.

V - Remove temporary staves and screws, you will use them for further assembly.



PREPARING TOP 3 STAVES FOR ADJUSTMENT CUT

Leave the last 3 staves on top loose as well as an empty gap in the middle. This will allow you to make your adjustment cut.



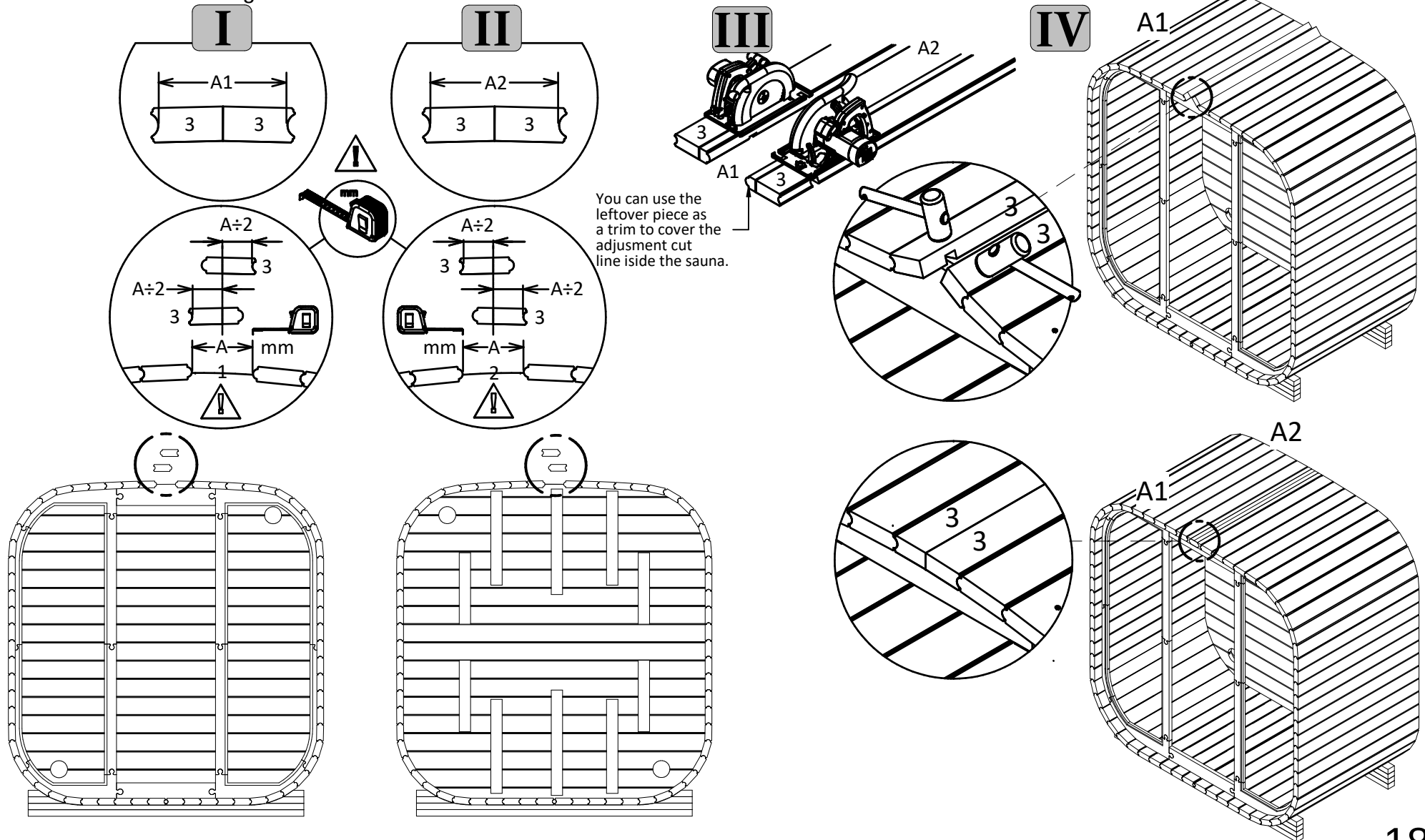
CONNECTING THE ROOFTOP

I-II - Measure the gap between the two last staves in the front and in the back as measurements can be different.

To make the last stave fit neatly, you will have to make an adjustment cut.

III - Make the adjustment cut with a circular saw. Make sure you cut the round side.

IV - Tap the last 3 staves in altogether with rubber mallet. Do not screw them.



FORM THE STEEL STRAP ENDS

I - Slide the bracket onto the steel strap.

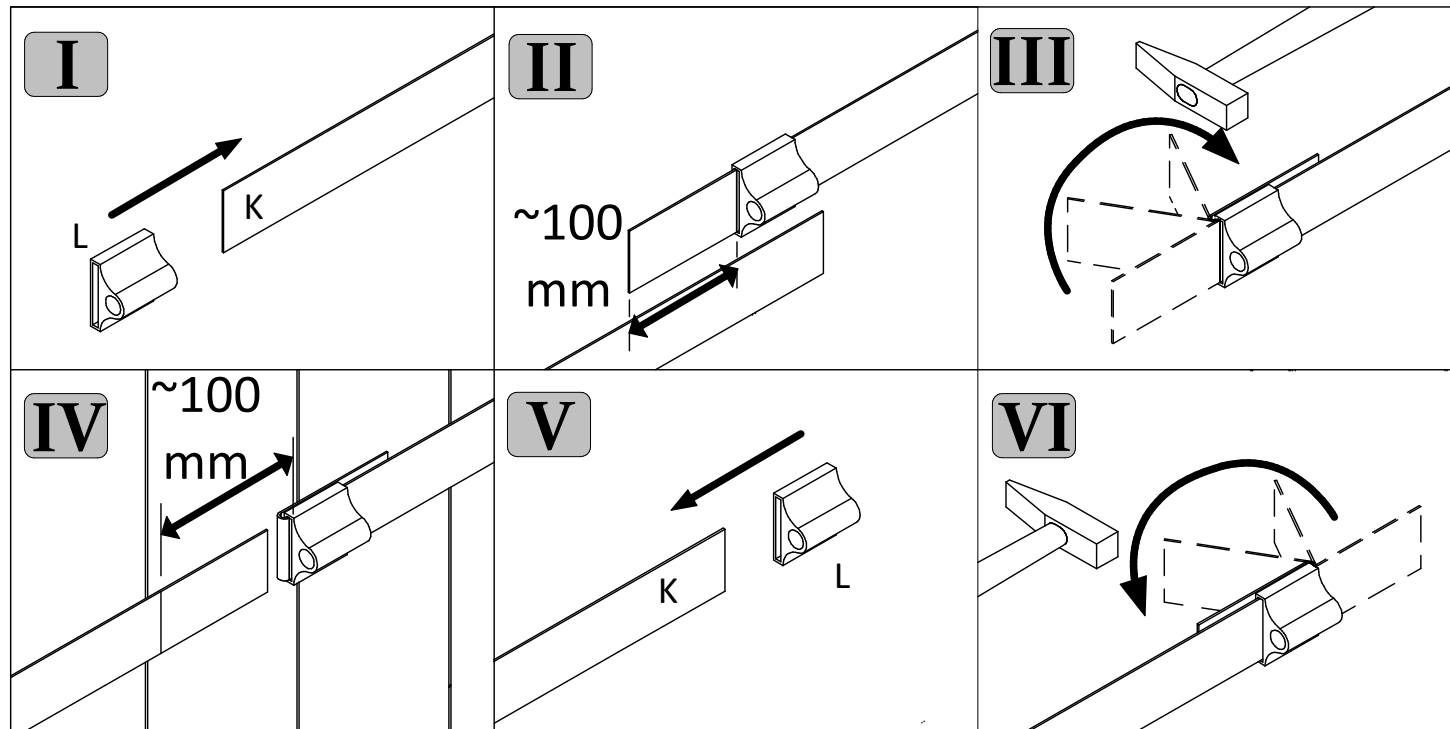
II - Mark the steel strap bend line with a marker.

III - Bend the steel strap backward.

IV - Measure the other side of the steel strap on the sauna and mark it (next page).

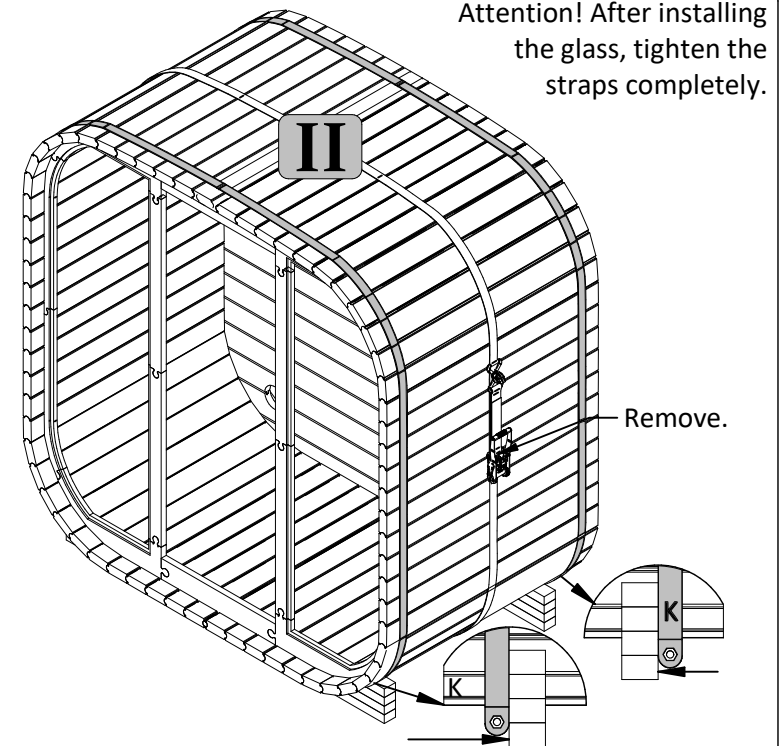
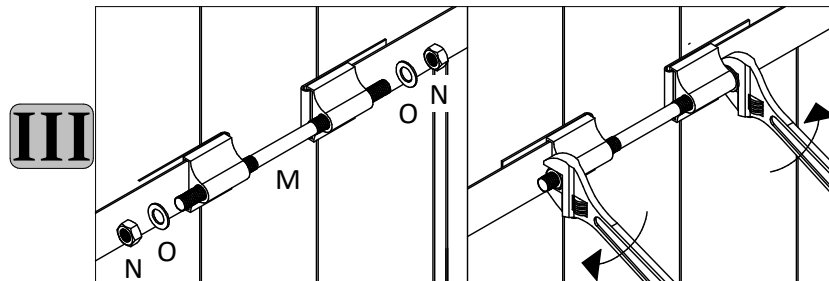
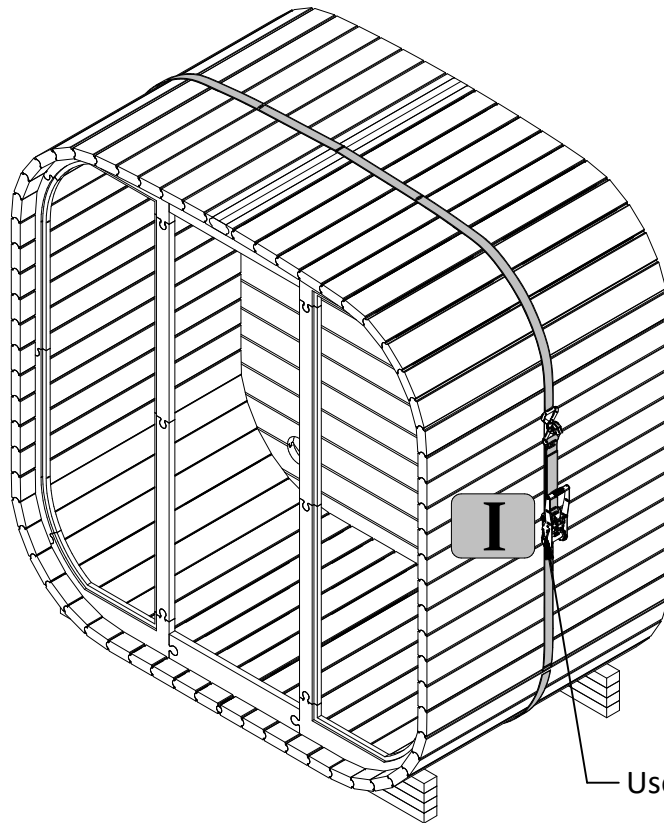
V - Slide the bracket onto the steel strap.

VI - Bend the leftover part of the steel strap backward.

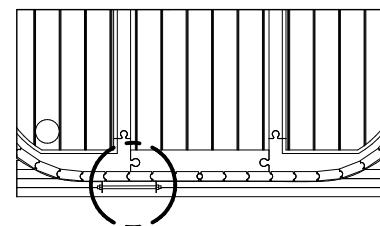


INSTALL THE STEEL STRAPS

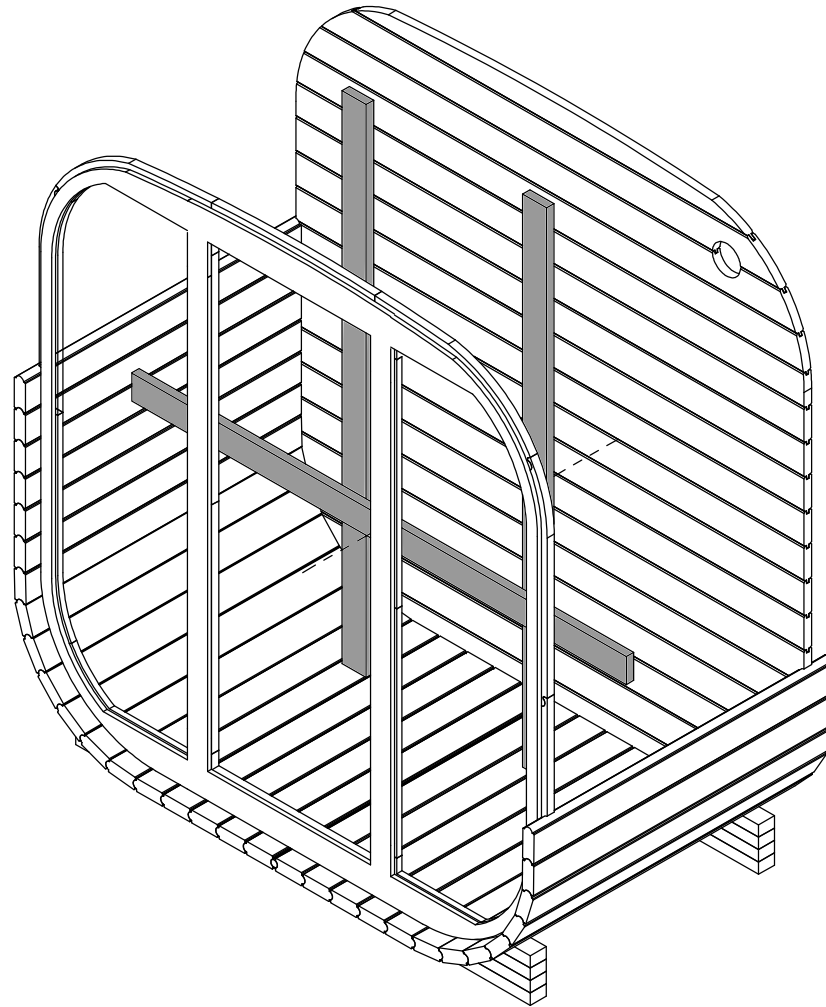
- I - Tie a loose rope or strap around to tighten the sauna.
- II - Mount steel straps and brackets.
- III - Install the steel straps so that they cover the screws. Tighten the nuts evenly.



Attention! When assembling and maintaining/retightening the threaded rods, the threaded rods must be oiled with oil (W44 or Würth HPS1400). In this way, damage to the threaded rod can be avoided and it can be clamped more easily.



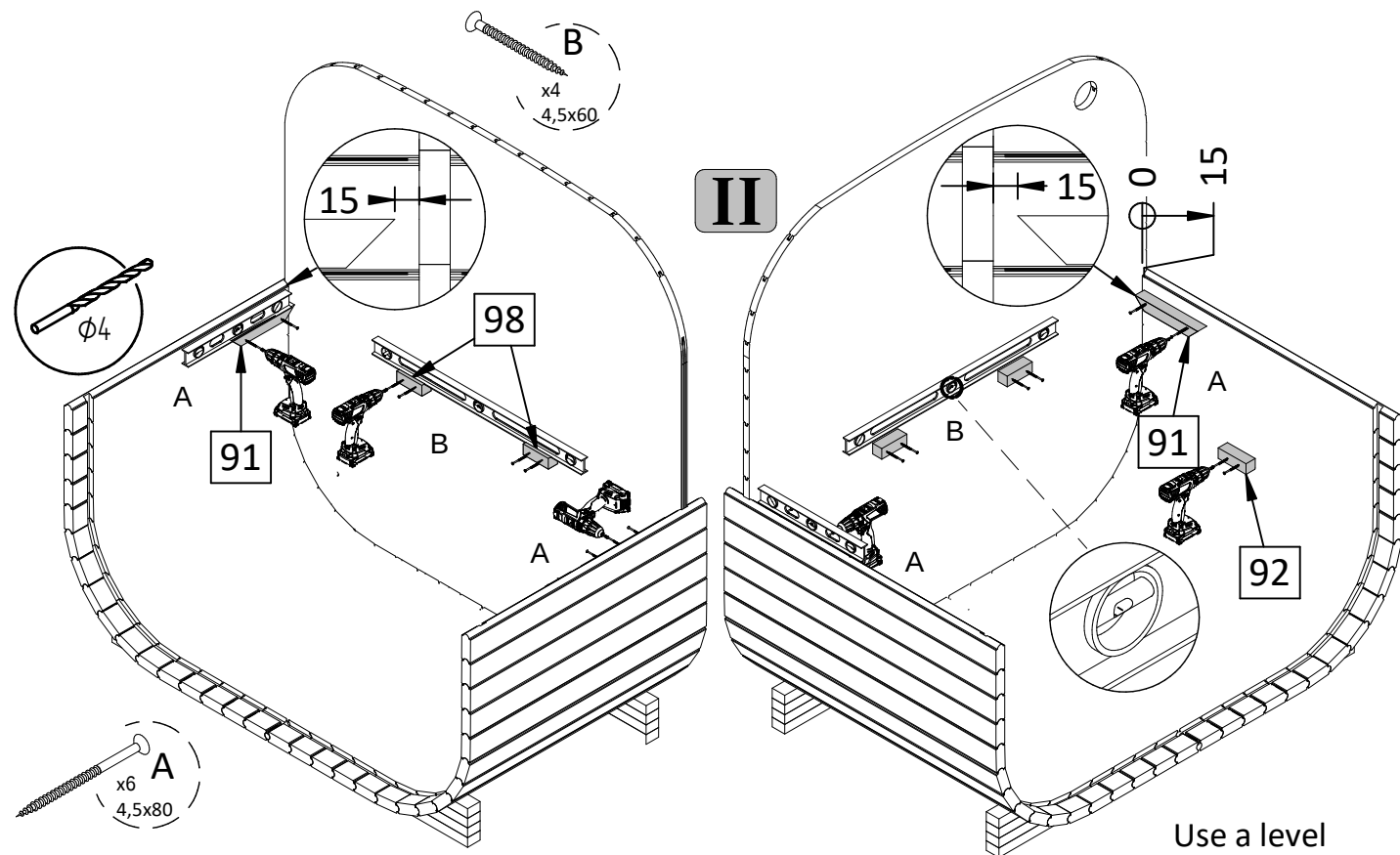
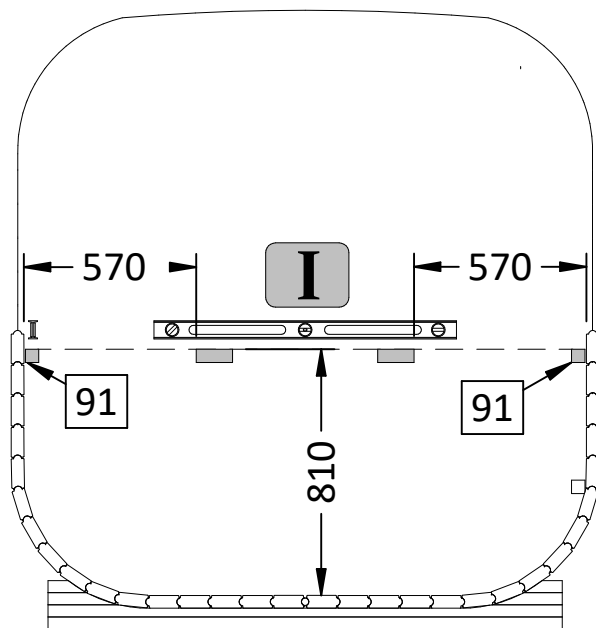
Remove all boards from the inside.



INSTALL THE BENCH SUPPORTS

I - Mark the height 814mm from the bottom of the floor to both side walls. Use a carpenter level.

II - Screw the bench supports to the side walls.



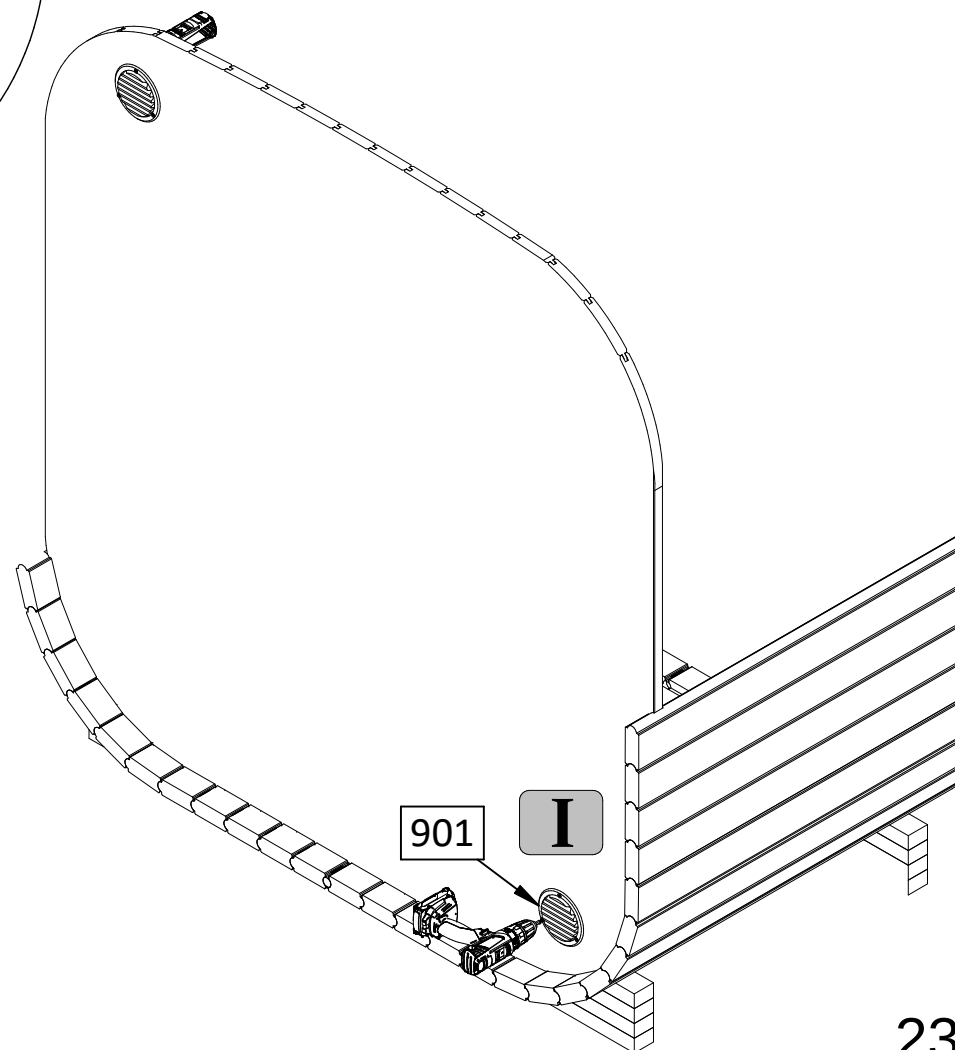
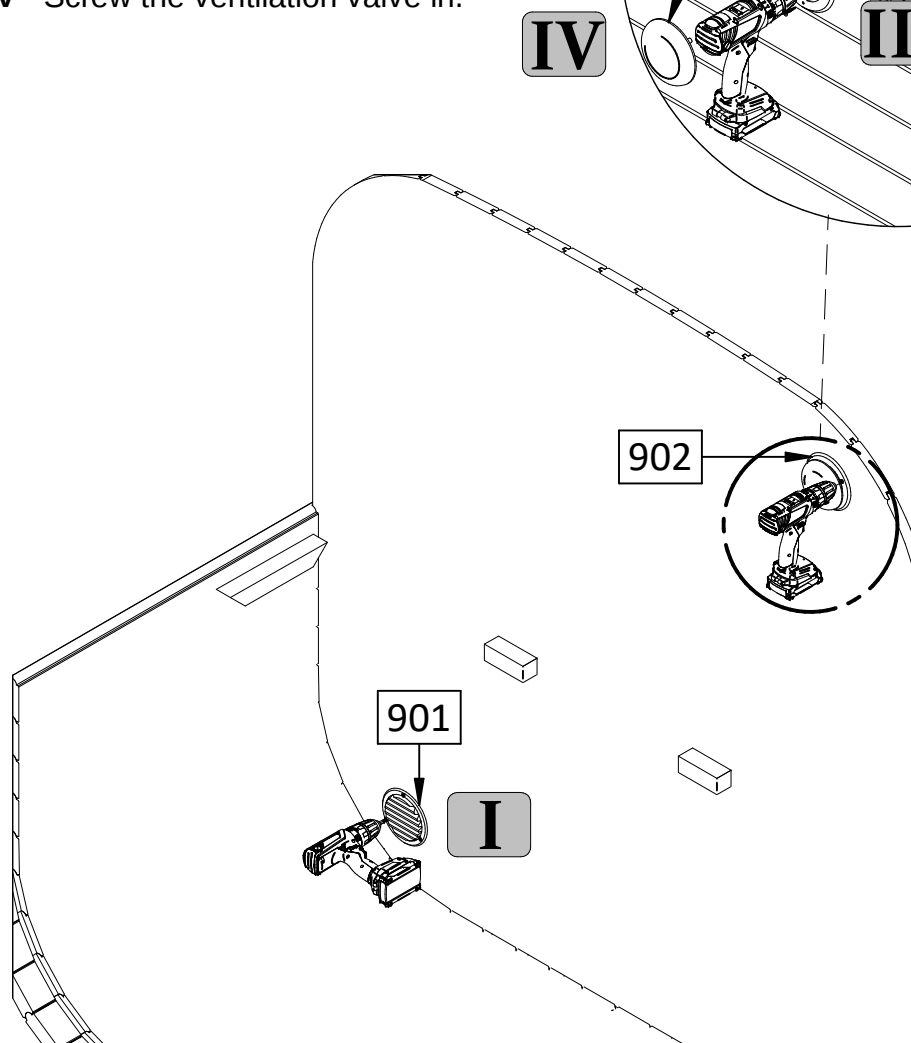
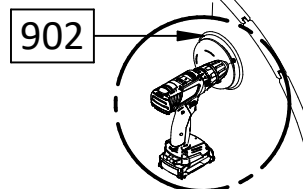
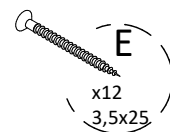
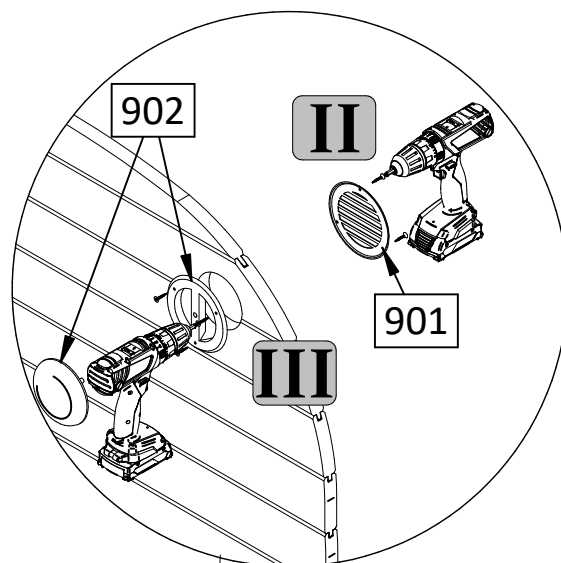
INSTALL THE VENTILATION

I - Install the bottom ventilation grilles on both side of the wall.

II - Install the upper ventilation grille on the outside of the wall.

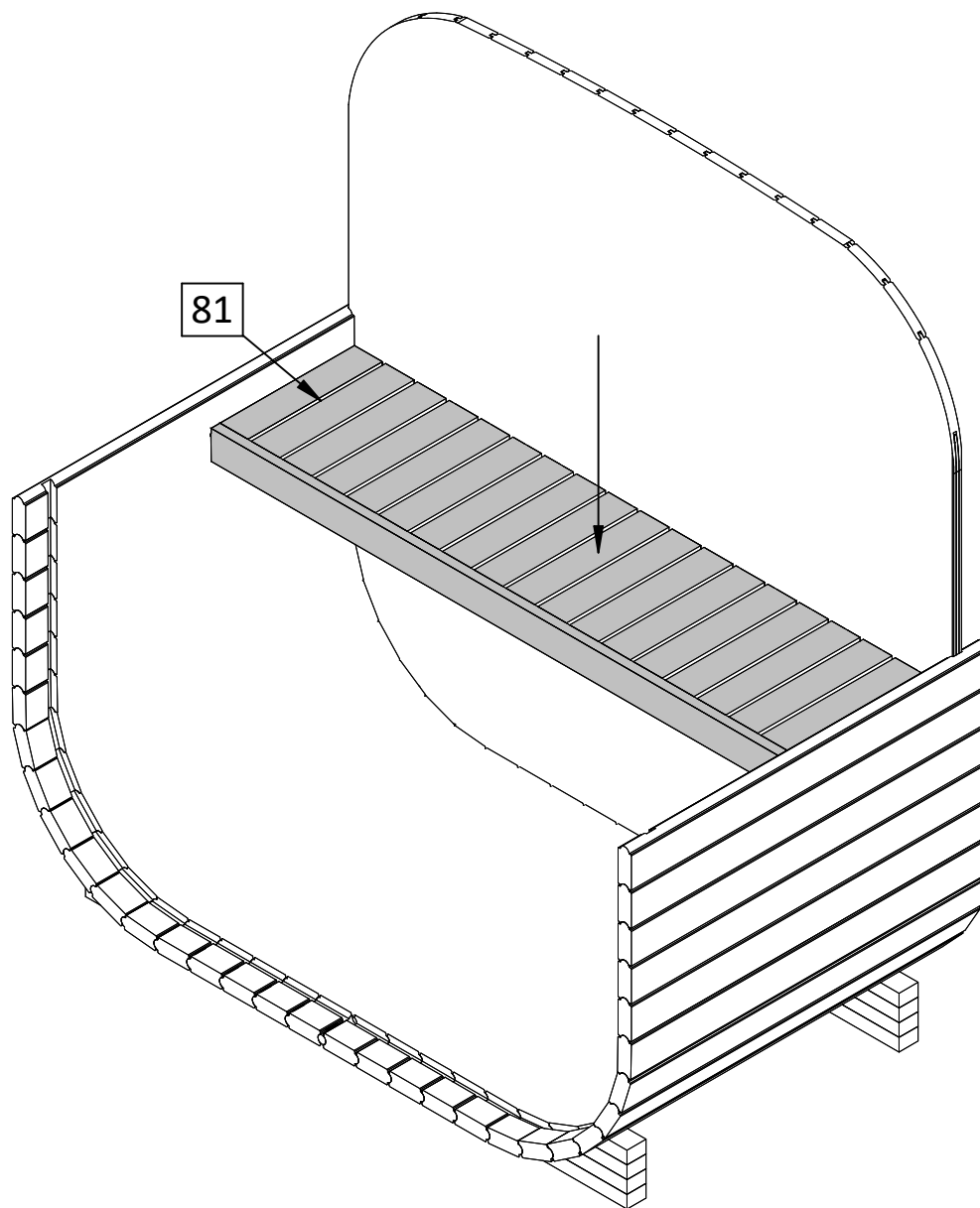
III - Install the upper adjustable ventilation valve mount on the inside of the wall.

IV - Screw the ventilation valve in.



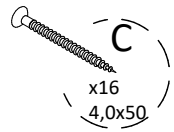
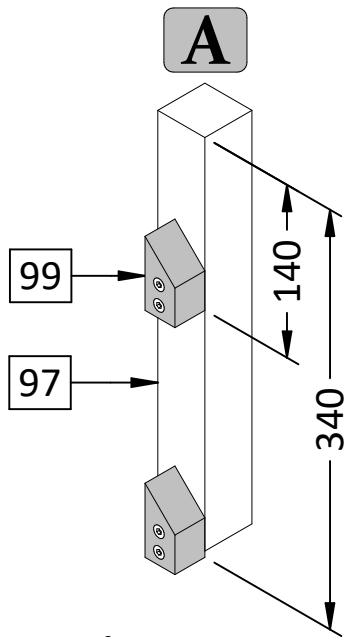
INSTALL THE BENCH

I - Place the bench on the supports. The bench has to be tight against the back wall.

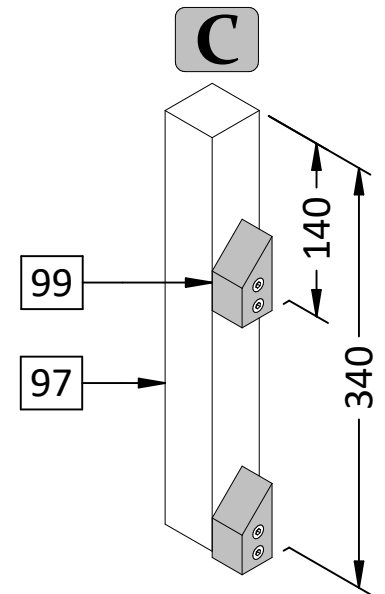
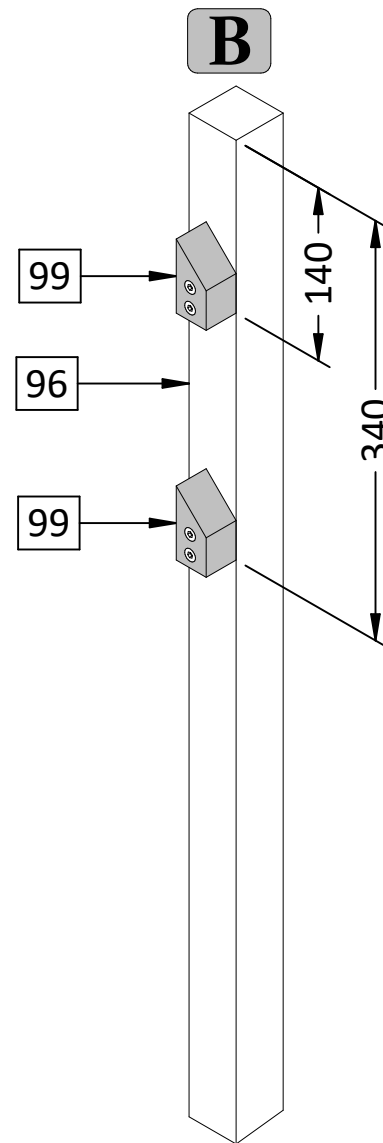
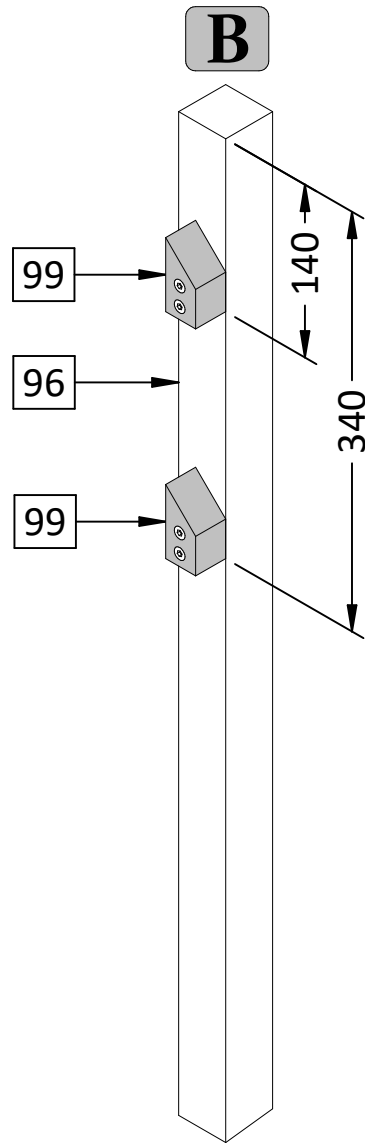


PREPARE THE BENCH SUPPORT LEGS

Screw the skirt holders (99) to the bench support legs (97, 2 pcs 96 and 97 mirrored).



Before processing the screws.
Pre-drill the holes
with a 4 mm drill bit.

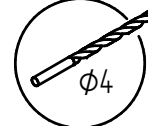
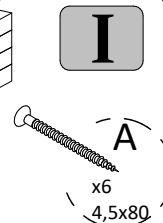
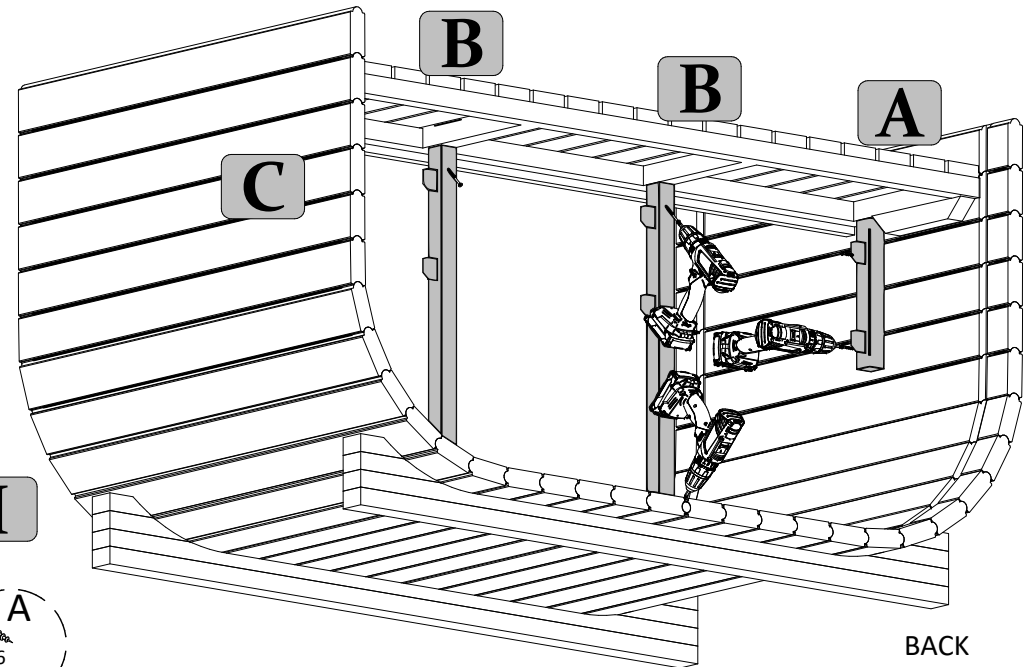
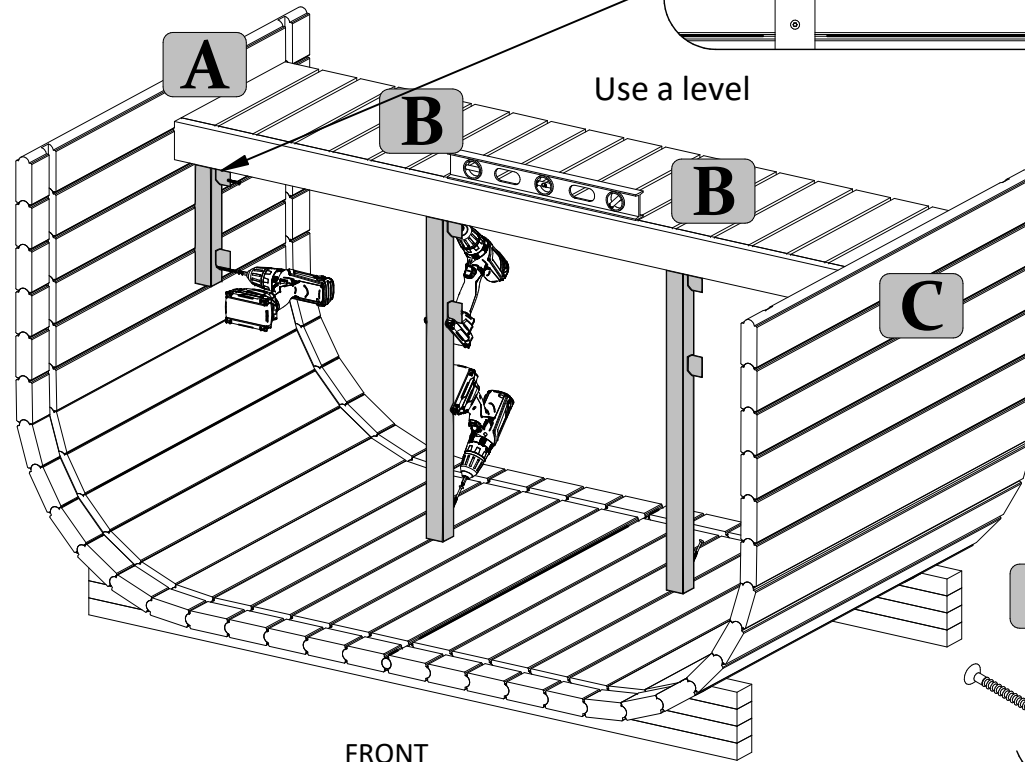
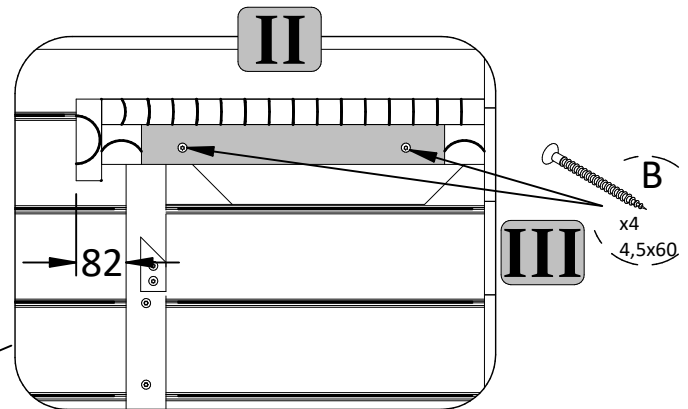


INSTALL THE BENCH SUPPORT LEGS

I - Screw the support legs under the bench (97) and to the sidewalls (96). Keep a 82mm distance from the front of the bench.

II - If needed make height adjustments to the bench supports on the walls.

III - Screw the bench to the sidewalls.

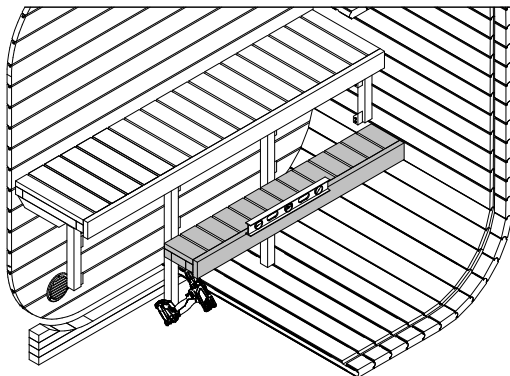


Before processing the screws.
Pre-drill the holes
with a 4 mm drill bit.

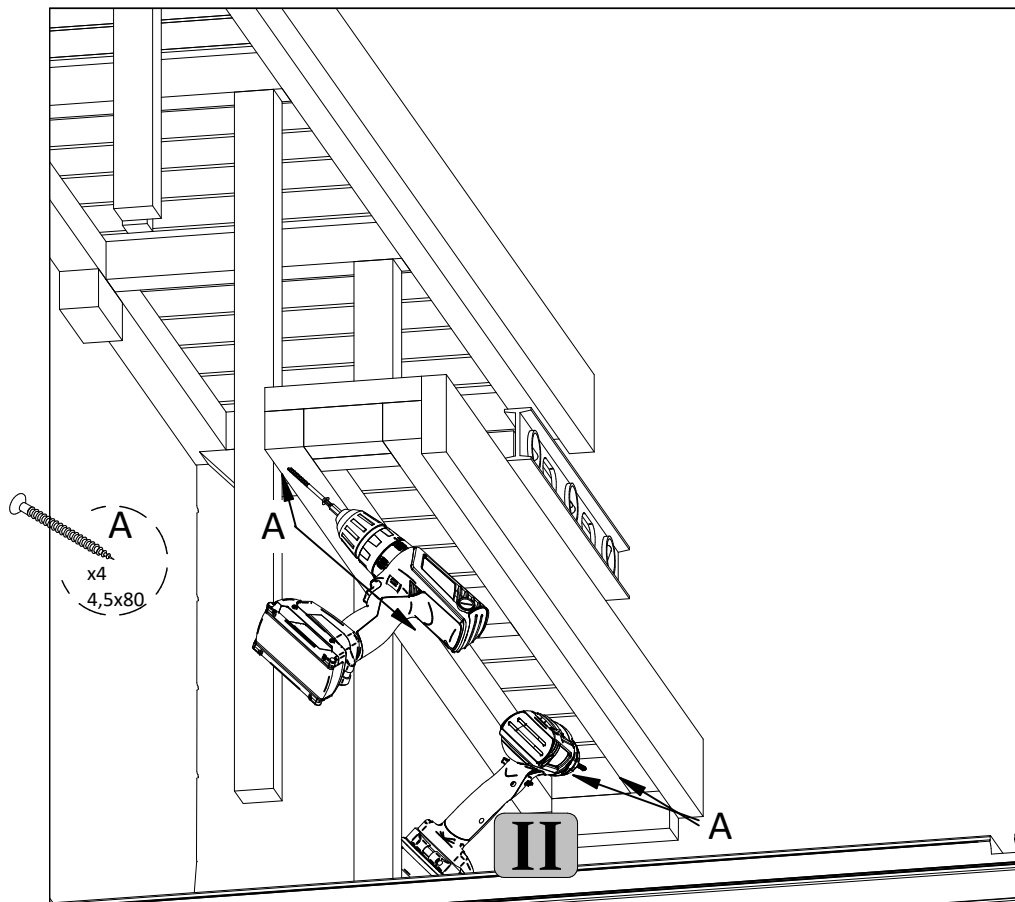
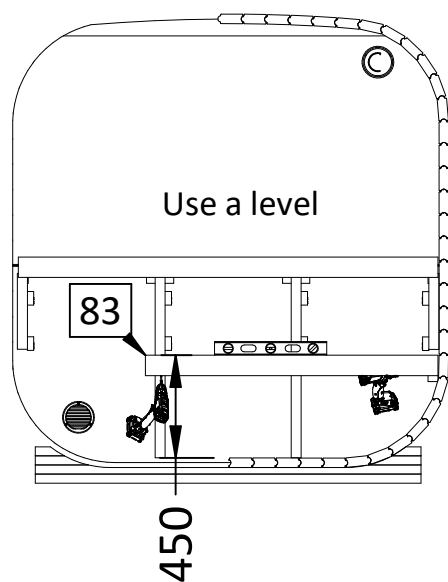
INSTALL THE LOWER BENCH

I - Connect the lower benches with upper bench supports to the height of 450mm.

II - Make sure bench is leveled. Screw the lower benches to the sidewall.

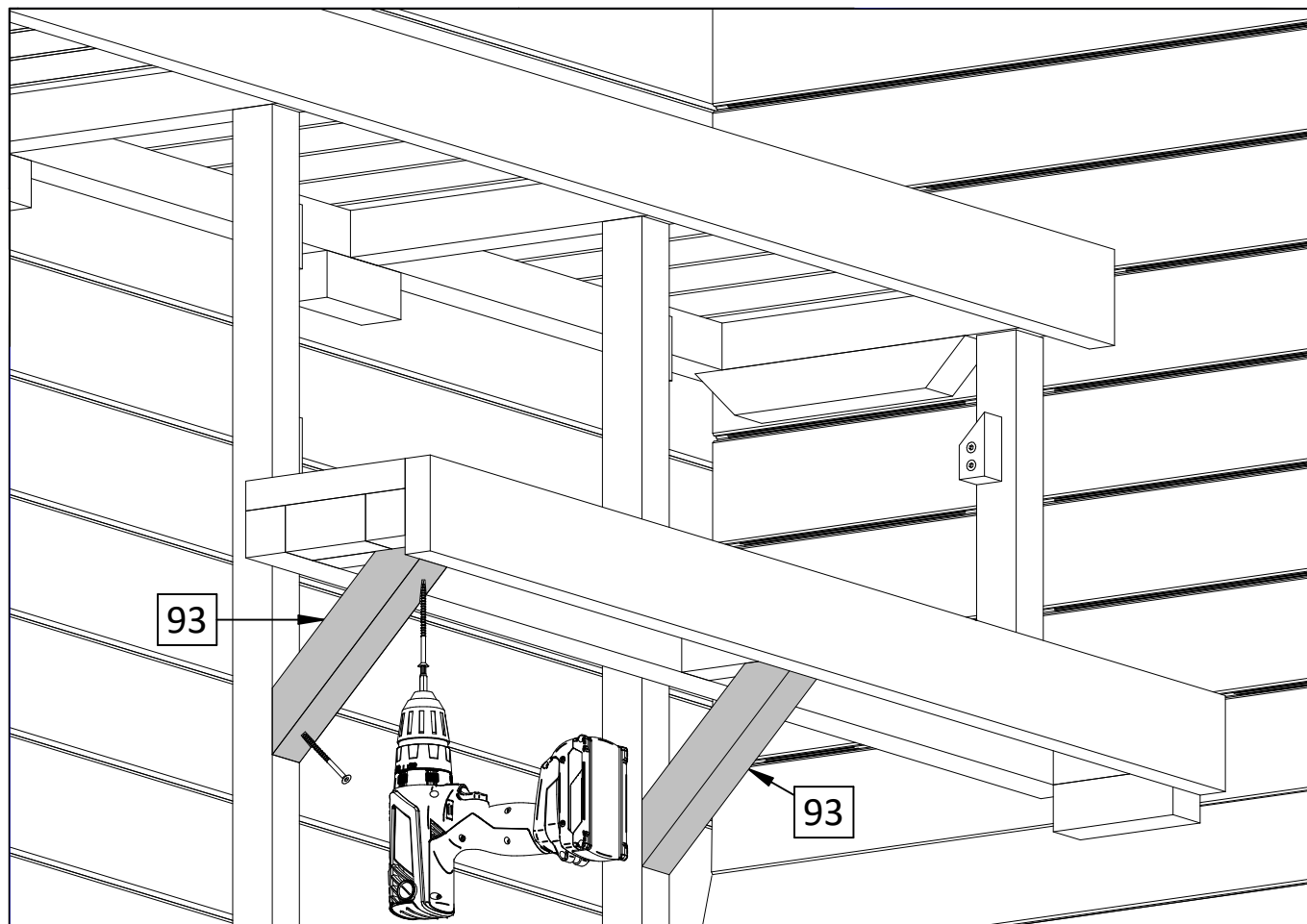
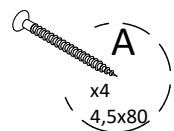


I



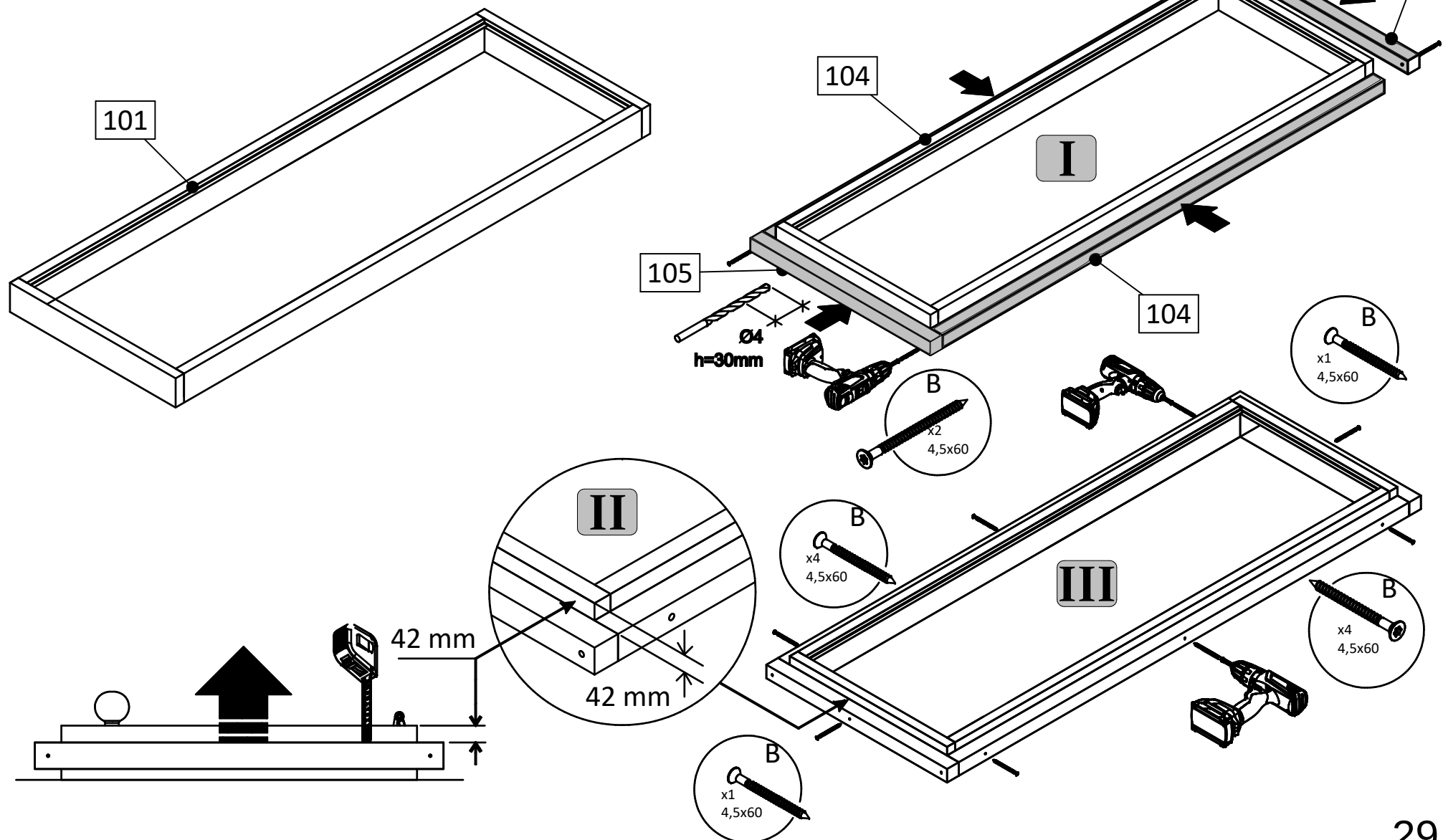
INSTALL THE LOWER BENCH SUPPORT DIAGONALS

I - Fix the lower bench to the upper bench with diagonal supports (93).



PREPARING THE DOOR FOR INSTALLATION

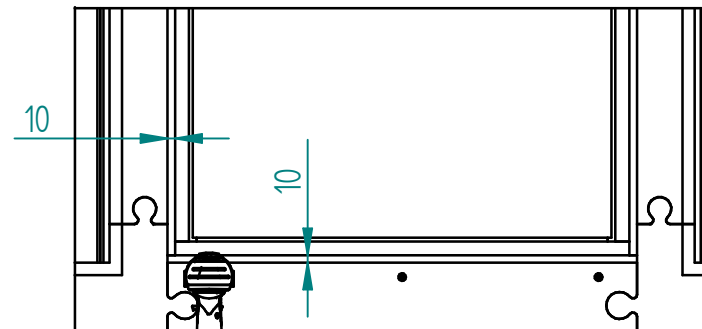
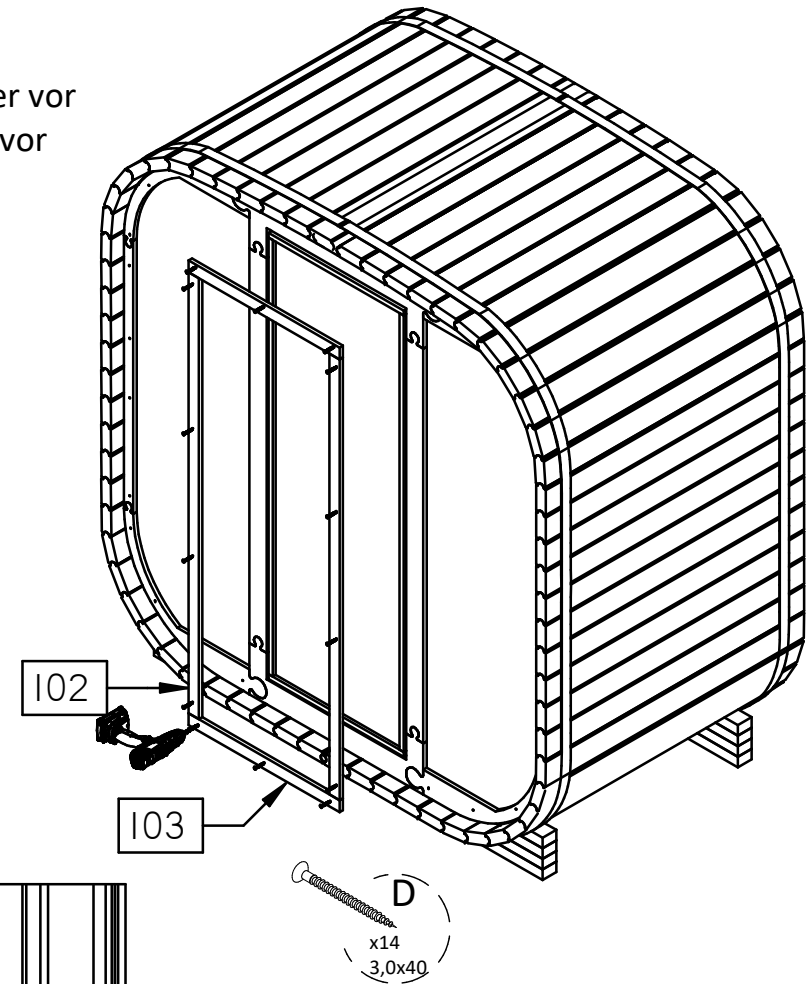
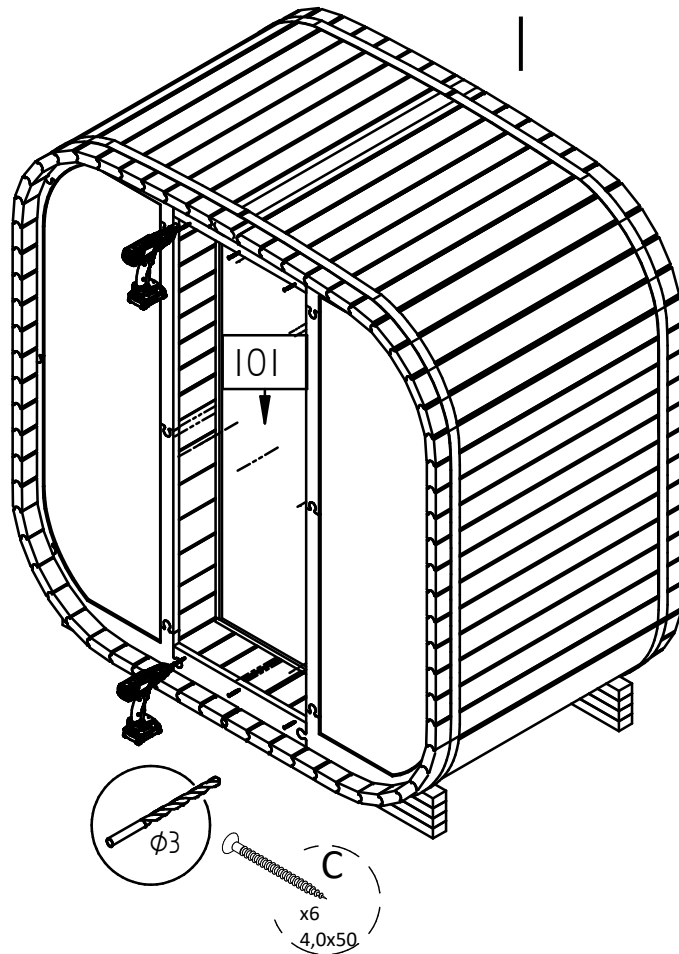
- I - Mount the external door frame (parts 104 and 105), so that it is loose around the door frame.
- II - The height measurement between external door frame and door frame has to be 42 mm in all sides.
- III - Fix the external frame and door frame together with screws.



Before processing the screws.

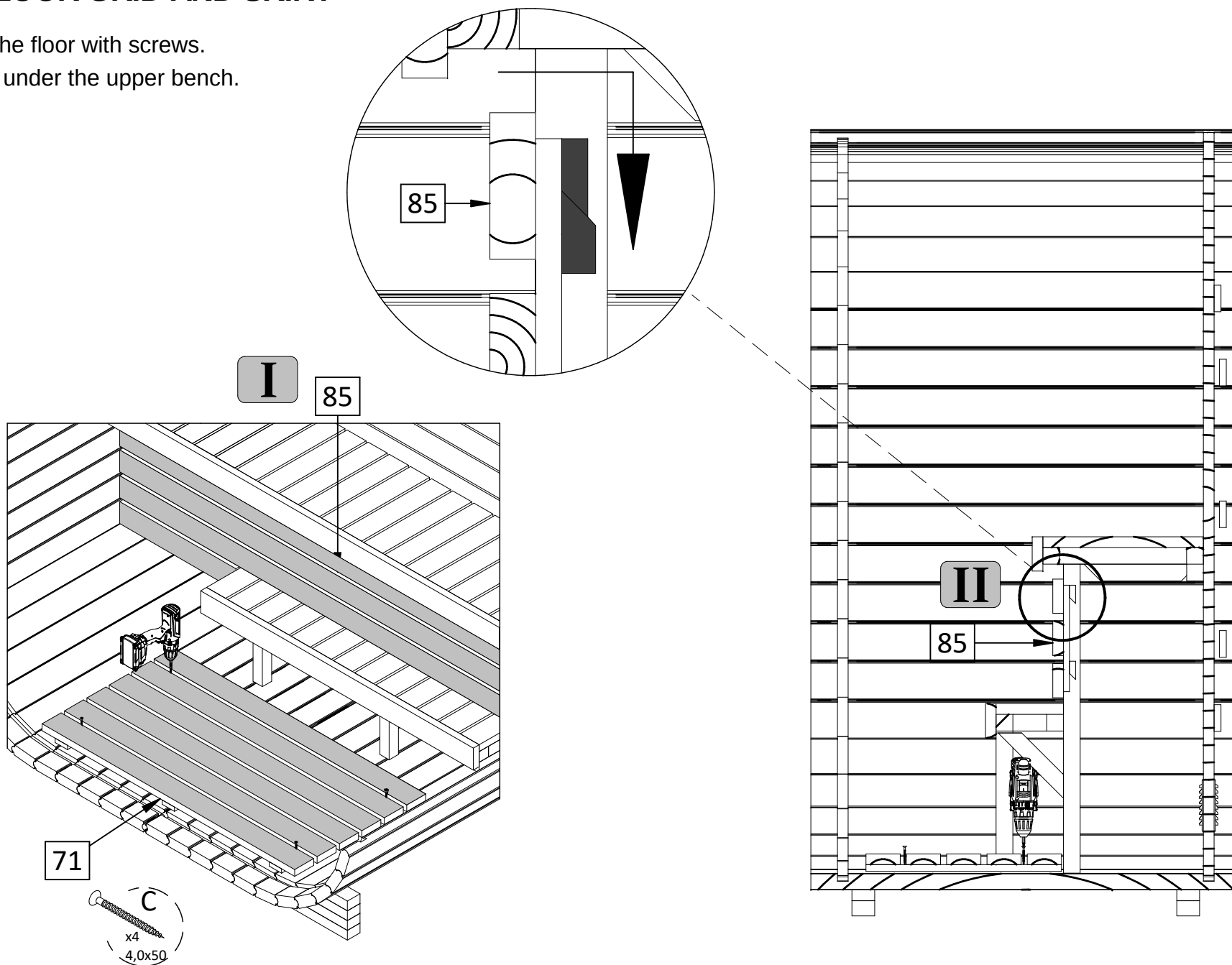
Pre-drill the holes
with a $\phi 3$ mm drill bit.

Bitte bohren Sie
die $\phi 3$ mm Löcher vor
dem Schrauben vor



INSTALL THE FLOOR GRID AND SKIRT

- I - Fix the floor grid to the floor with screws.
- II - Hang the front skirt under the upper bench.



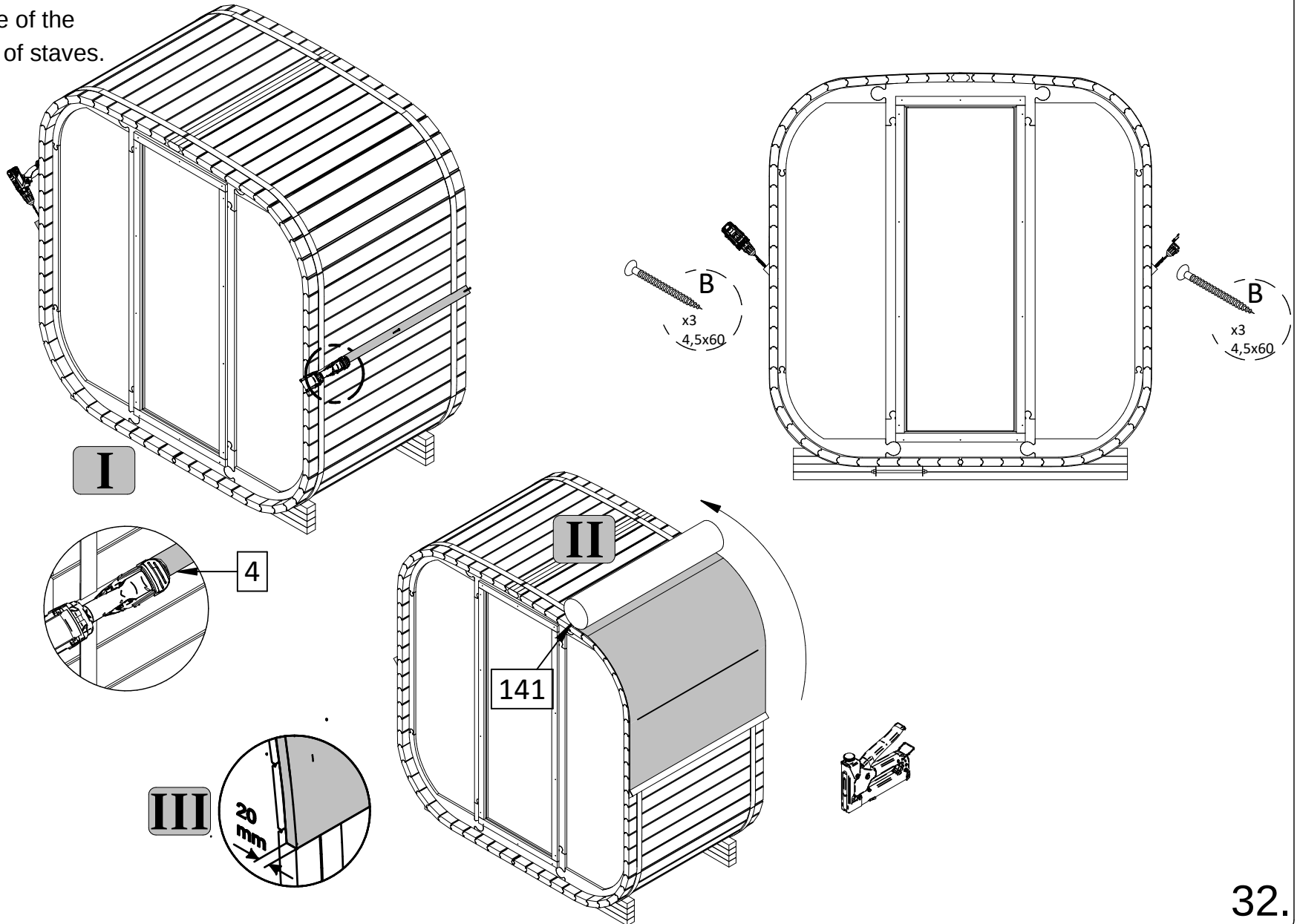
INSTALL THE ROOF UNDERLAYMENT

I - Install the roof drip edges on the sidewalls, measure them to the center of the sauna height wise.

II - Roll the underlayment onto the roof starting from the drip edge and finish on the other side. Use a stapler to fix the underlayment.

Cut to length if needed.

III - Be sure to turn the edge of the underlayment over the end of staves.



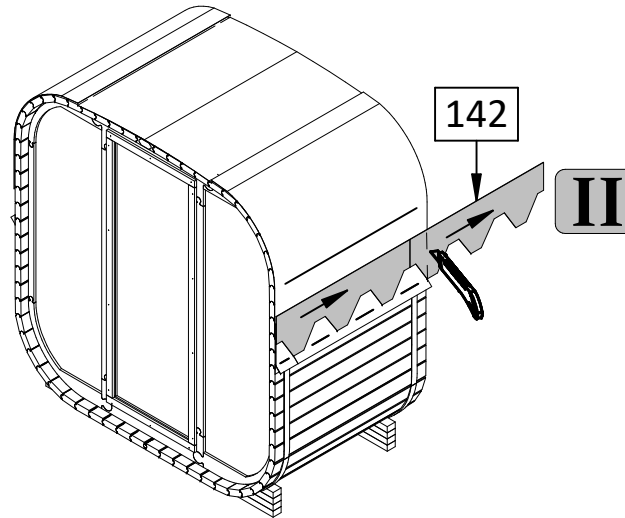
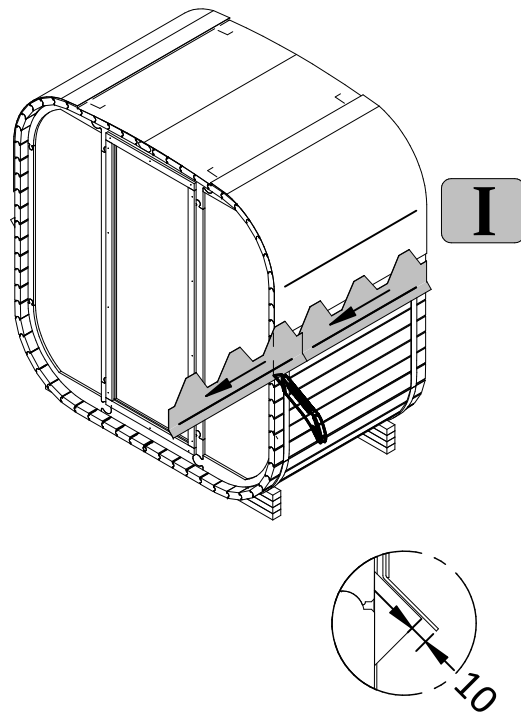
INSTALL THE ROOF SHINGLES

I - Install the the first shingles over the drip edge upside down.

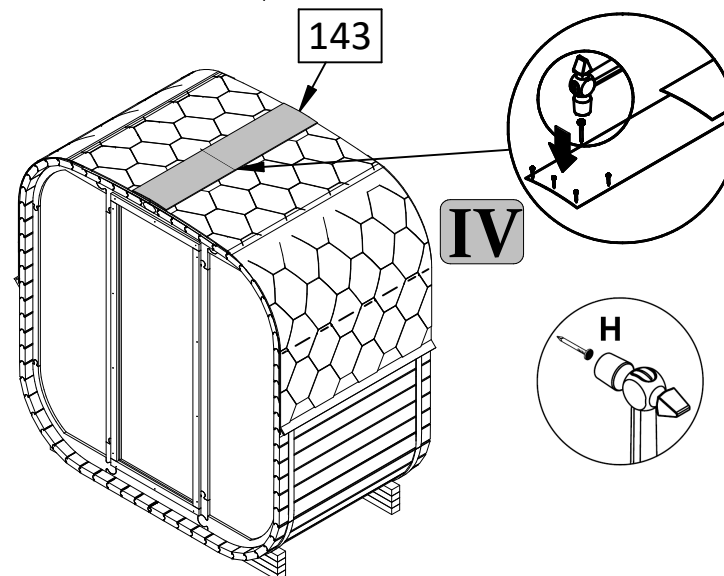
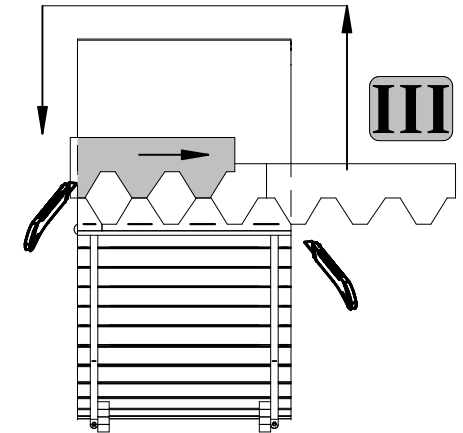
II - Follow the shingles manual and install the first row.

III - Cut the leftover piece and use it to start a new row.

IV - Cover the roof ridge.

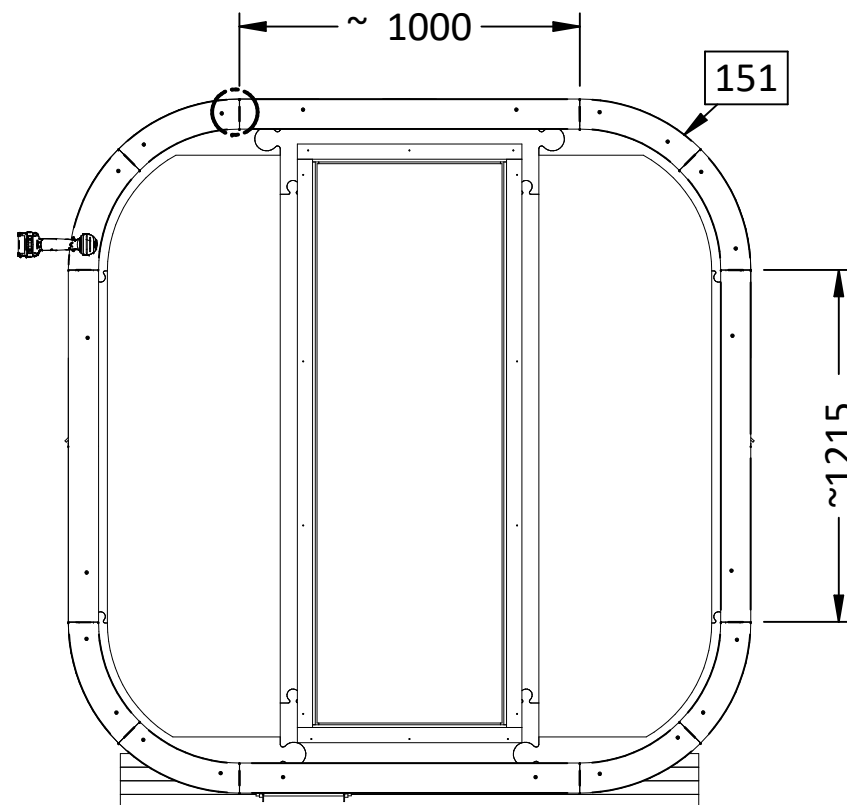
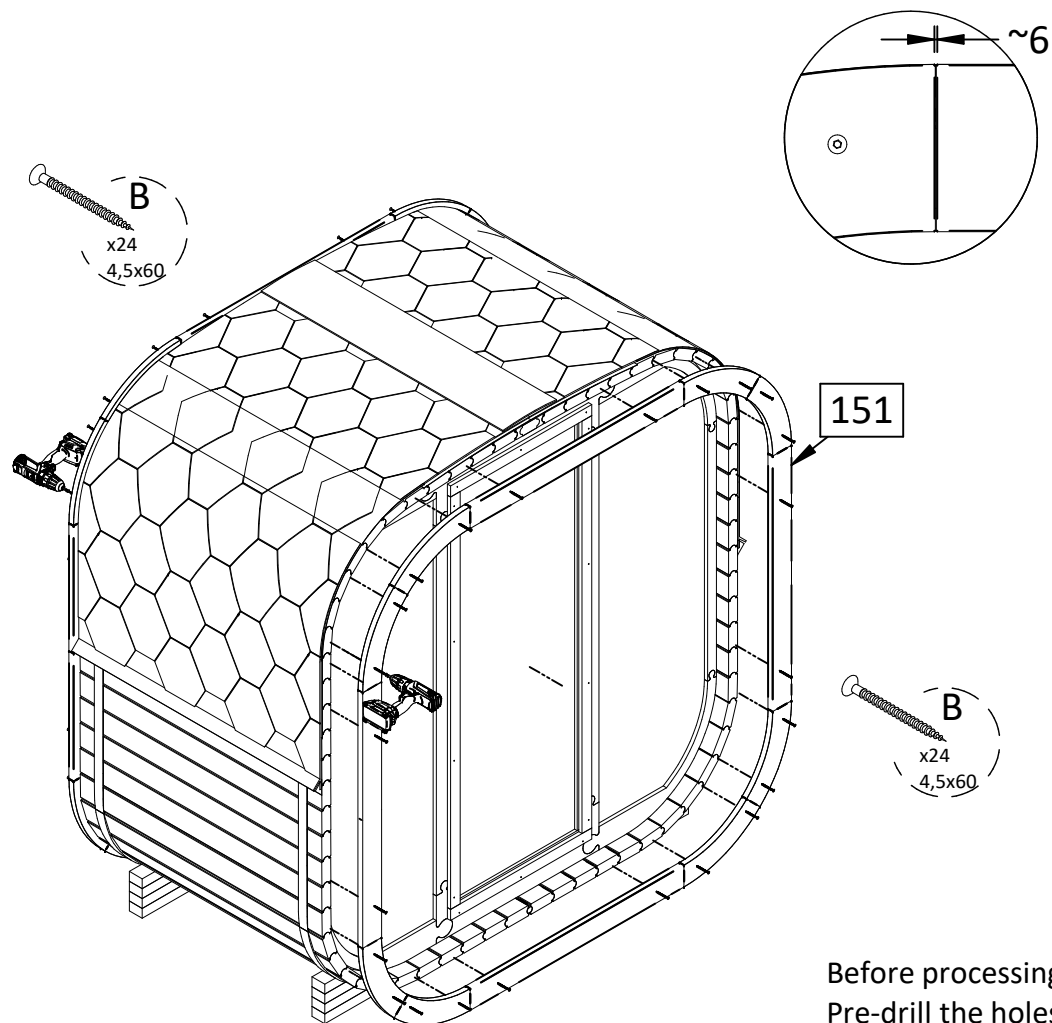


Please cut the shingles to size and use the other half on the other side.



INSTALL THE FRONT AND BACK COVER ARCHES

I - Install the the front and back cover arches, leave a gap of ~6mm between the ends.

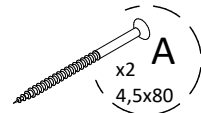
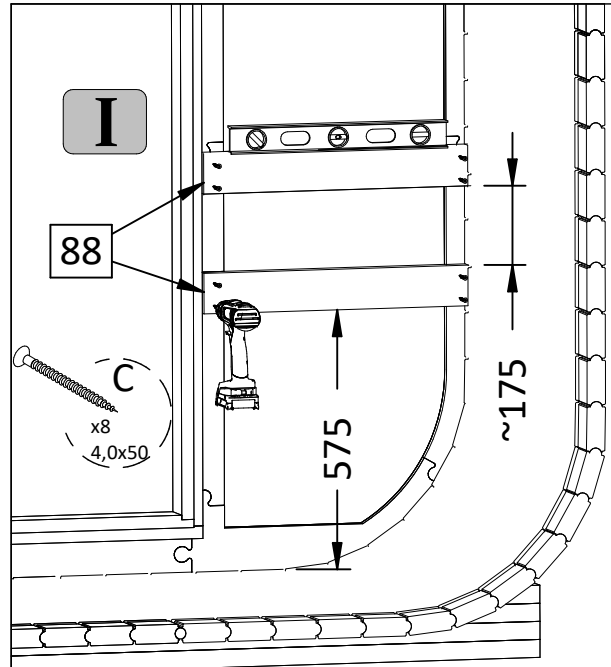
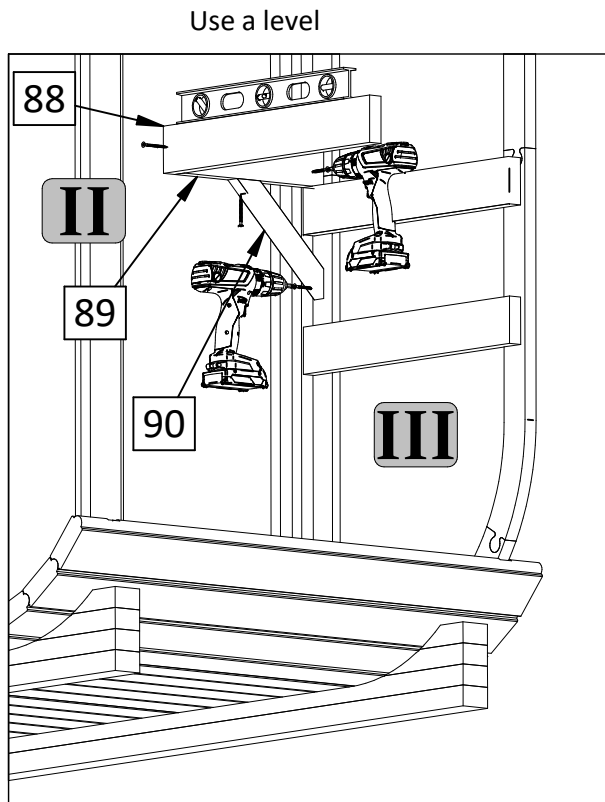


If necessary, cut the details to the appropriate size

Before processing the screws.
Pre-drill the holes
with a $\phi 4$ mm drill bit.

OPTIONAL - INSTALL THE HEATER GUARD

- I - Install the heater guard on the marked height.
- II - Screw the guard to the door support.
- III - Install the support diagonal under the guard.
- IV - Install the metal support under the guard.



Before processing the screws.
Pre-drill the holes
with a 4 mm drill bit.

