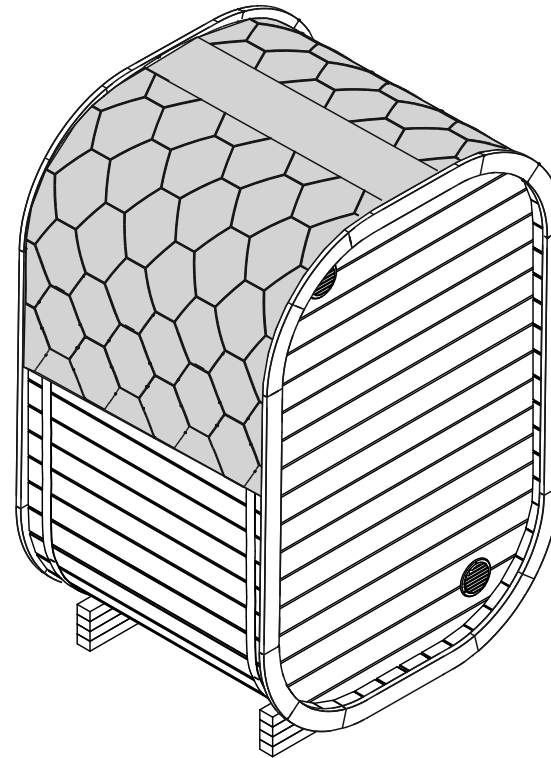
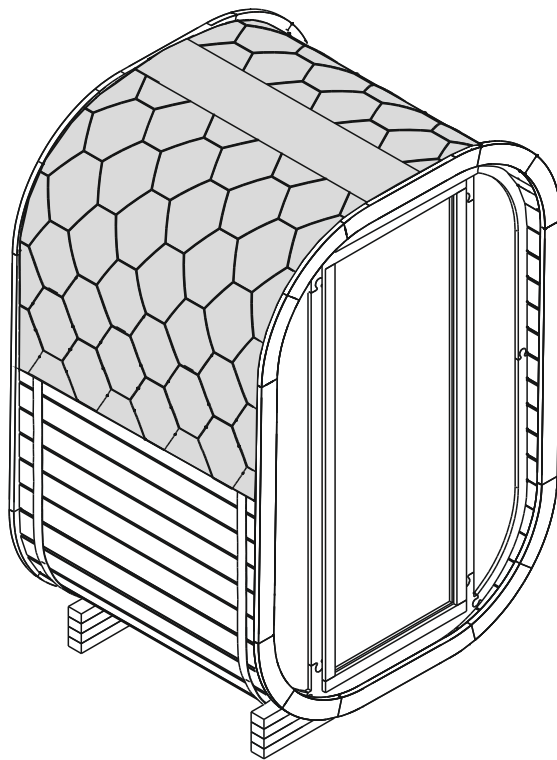




****Before you start assembling the sauna, please make sure all the pieces is there****

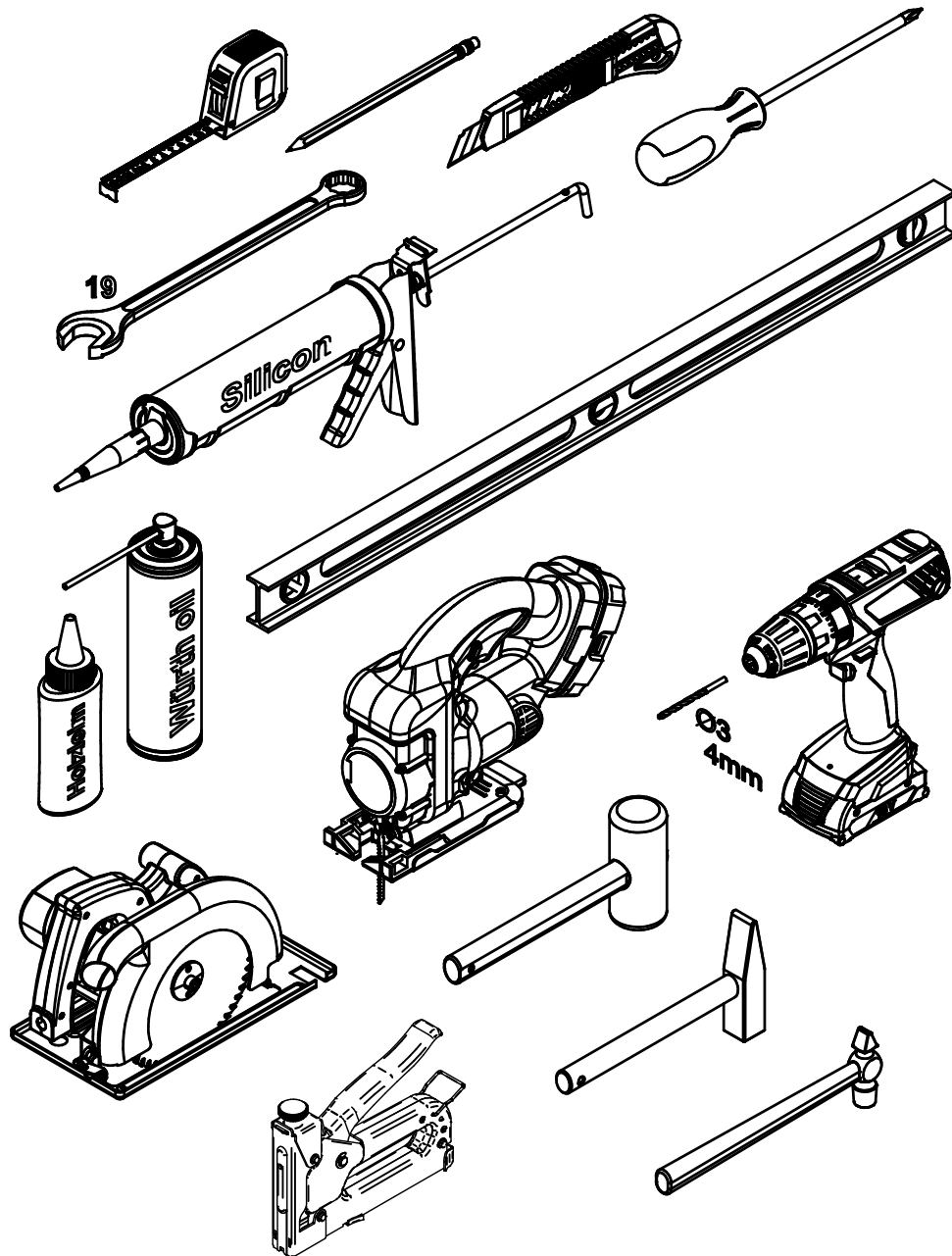
- A sauna barrel can never be 100% tight due to the construction.
- All measurements in mm (millimeter).
- Read the entire manual

Serial No. : 130ELH2-_____

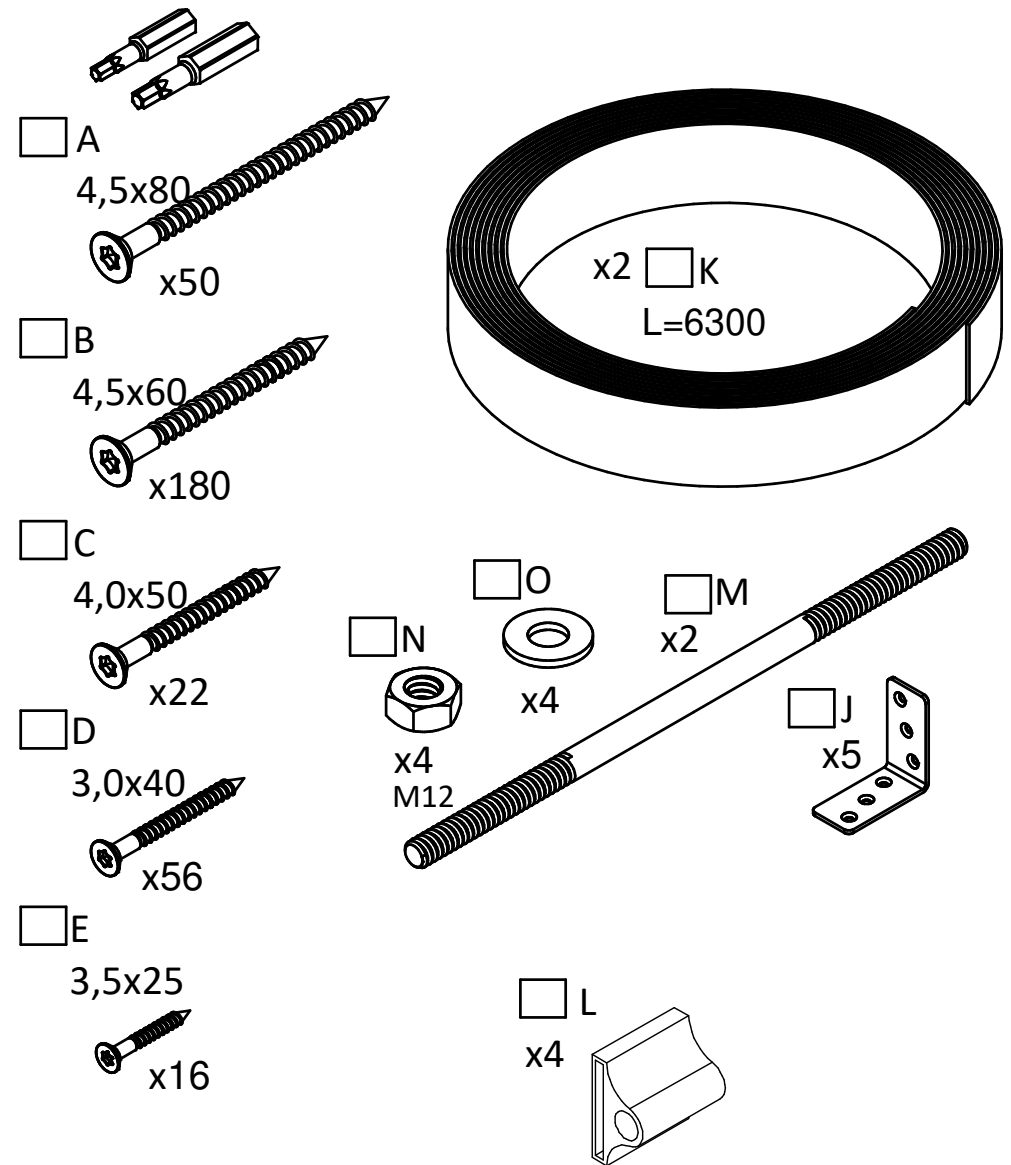
rev: 01
EL130H2-2-00

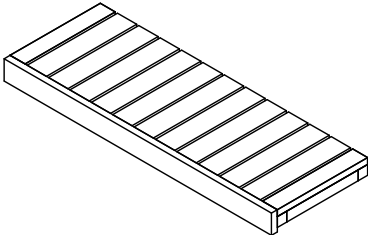
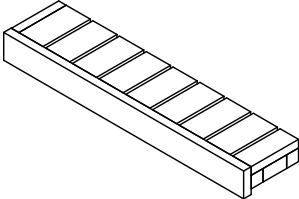
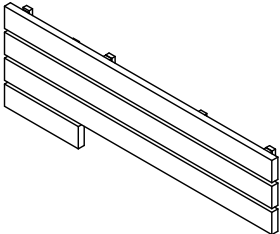
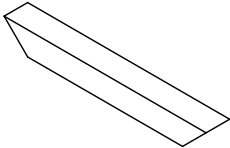
Tools that make your construction easier.

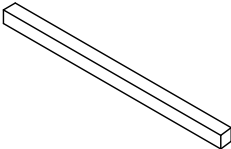
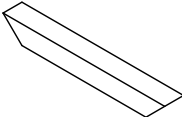
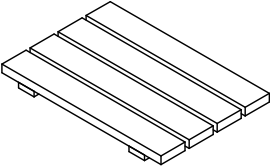
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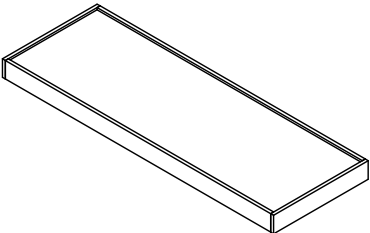
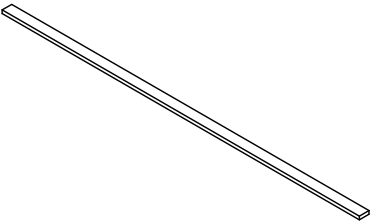
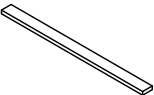
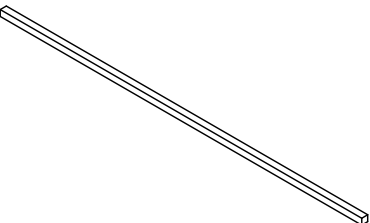
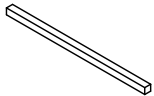


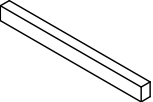
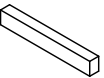
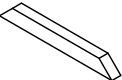
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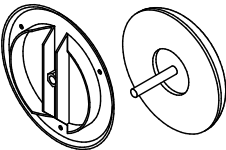
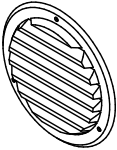


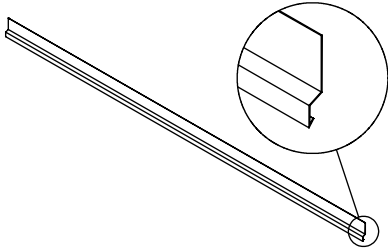
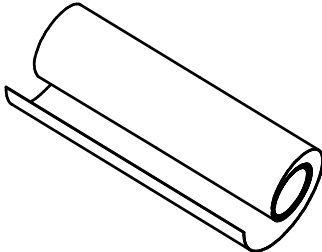
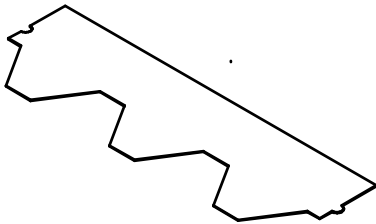
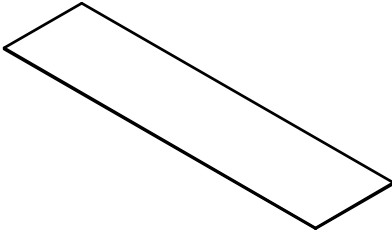
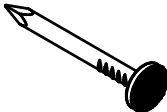
BENCHES, SKIRTS AND SUPPORTS			
No.	L x W x H	Qt	
81	1250x450x90	1	
82	898x205x90	1	
83	1250x408x28	1	
84	60x28x28	6	
91	378x44x44	2	

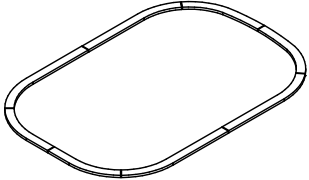
BENCH SUPPORTS AND FLOOR GRIDS			
No.	L x W x H	Qt	
92	813x44x44	2	
93	290x44x44	2	
94	250x44x44	2	
95	133x44x44	1	
71	595x620	1	

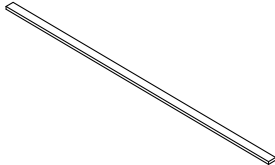
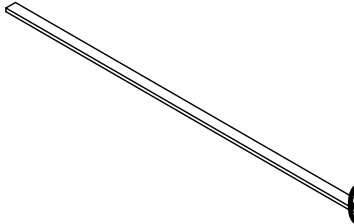
DOOR AND TRIMS			
No.	L x W x H	Qt	
101	1920x590x92	1	
102	1900x45x15	2	
103	660x45x15	2	
104	1920x28x28	2	
105	646x28x28	2	

HEATER GUARD			
No.	L x W x H	Qt	
121	610X40X28	1	
122	278X40X28	1	
123	350X40X28	1	

VENTILATION			
No.	L x W x H	Qt	
901	VENT	1	
902	VENT	3	 5.

ROOFING			
No.	L x W x H	Qt	
4	1300	2	
141	3300x1500	1	
142	1000x320	41	
143	1000x250	2	
H	NAILS	KIT	

FRONT AND BACK COVER ARCHES			
No.	L x W x H	Qt	
151	COVER ARCHES	KIT	

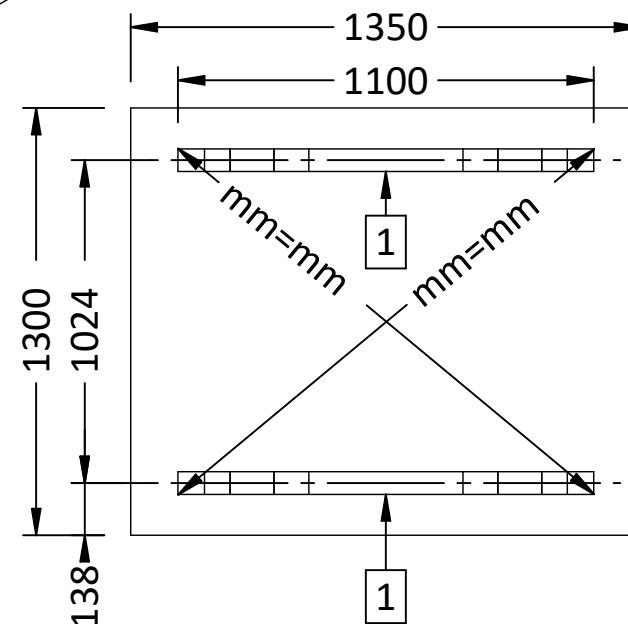
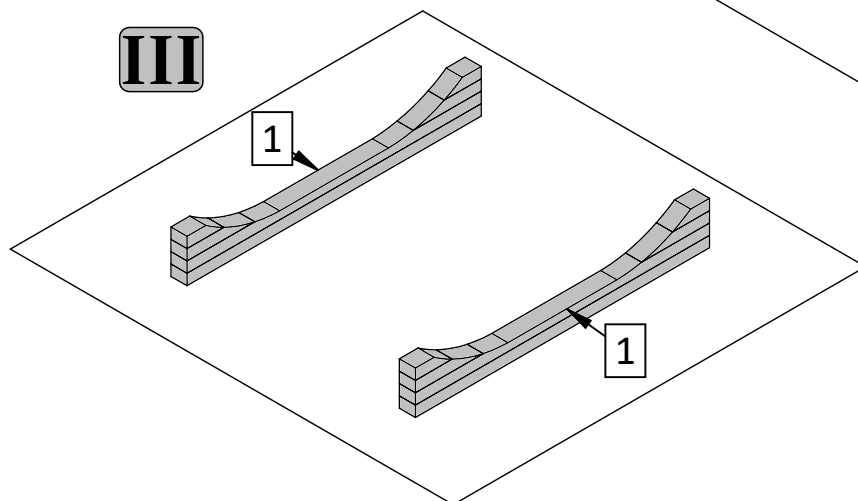
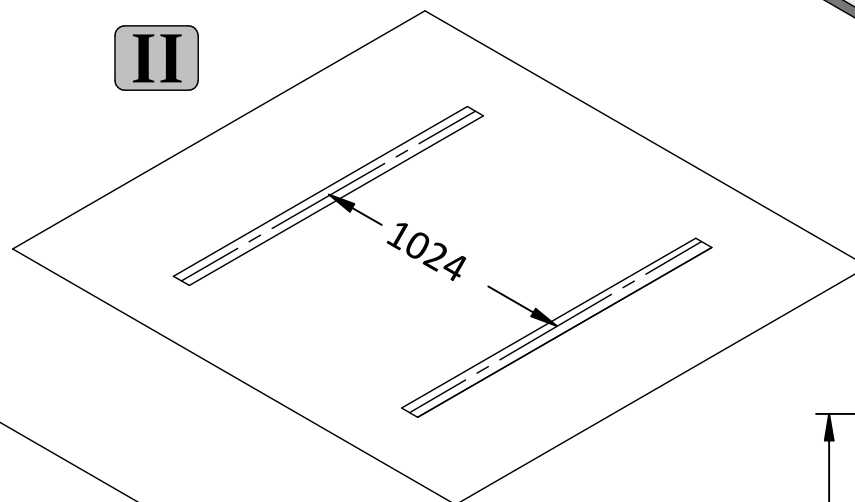
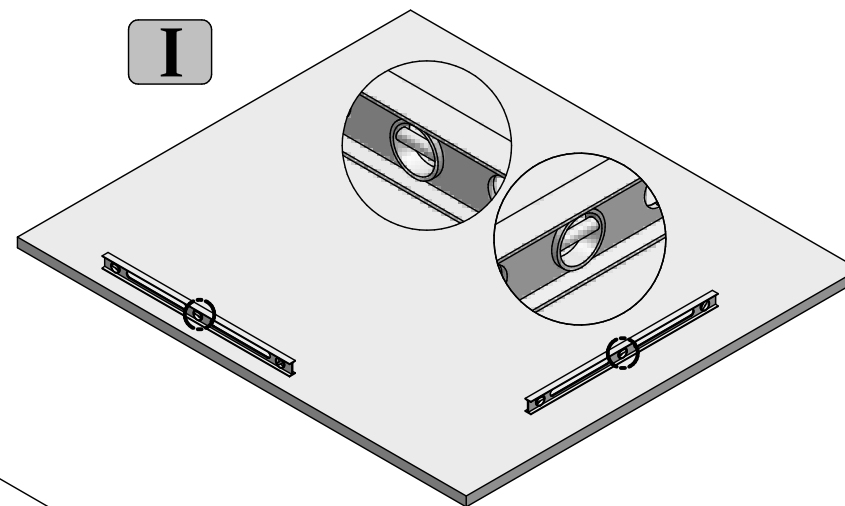
EXTRA PARTS FOR WALL ASSEMBLING (profile may vary)			
No.	LENGTH	Qt	
E1	1250mm board	1	
E2	1700mm board	2	

FOUNDATION PLAN

I - Make sure the foundation is leveled.

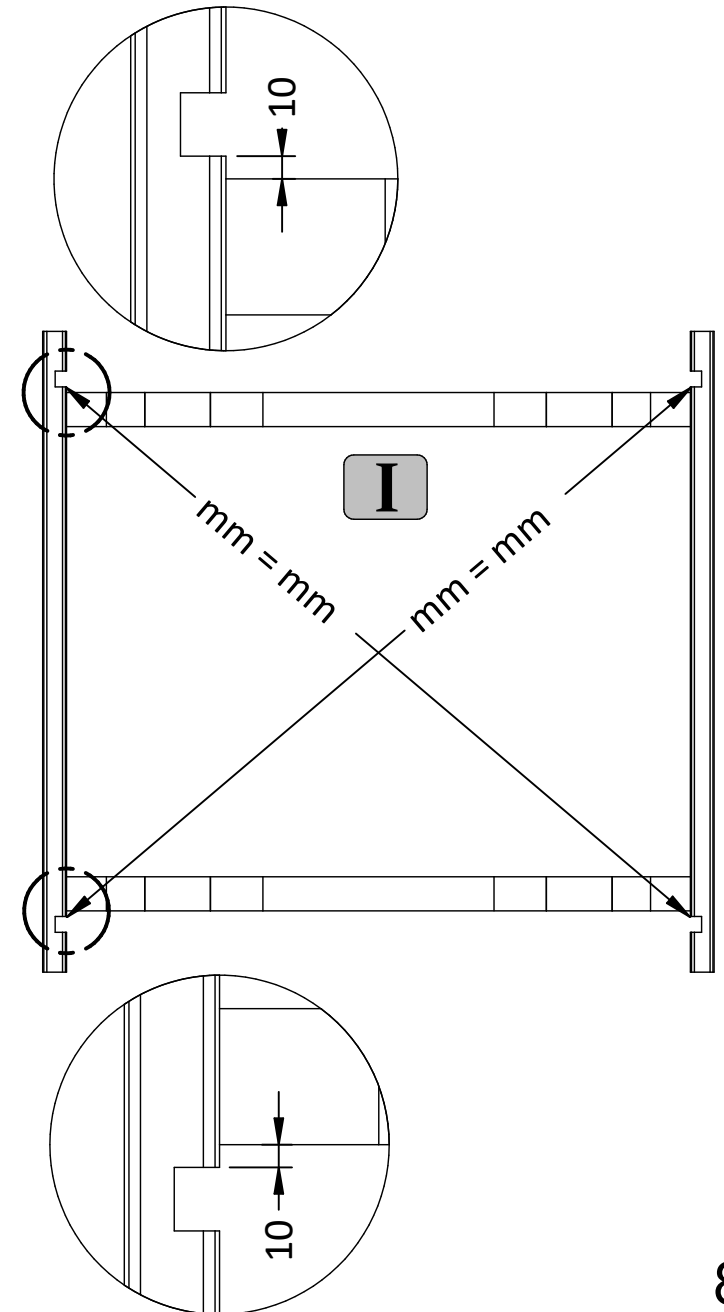
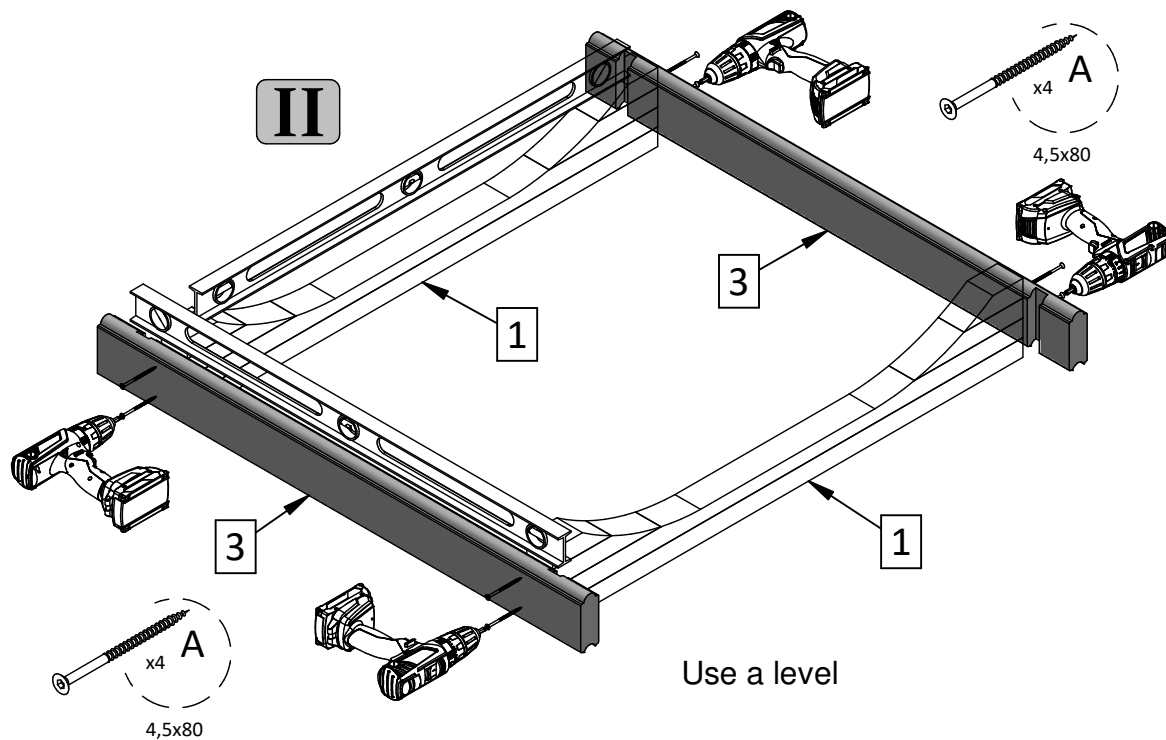
II - Mark down the cradles position.

III - Position the cradles.



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).
- 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.

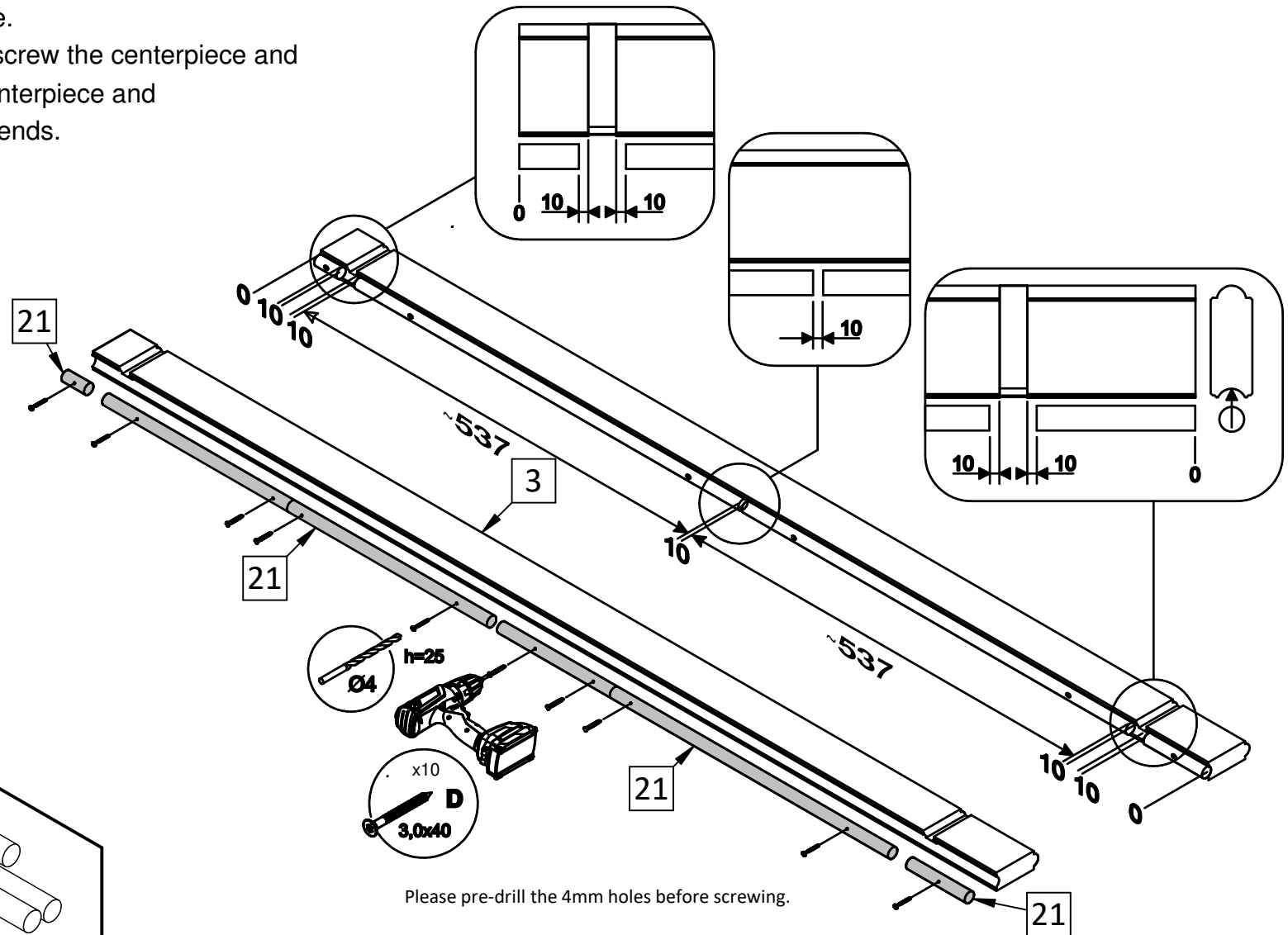


POSITIONING THE CENTERPIECE

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

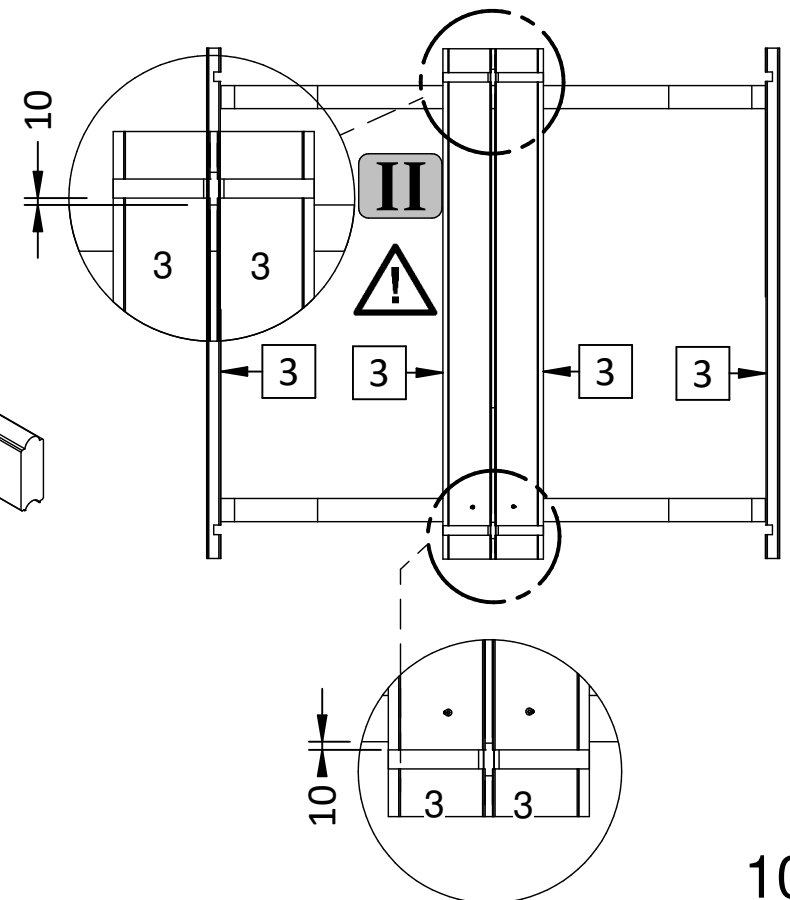
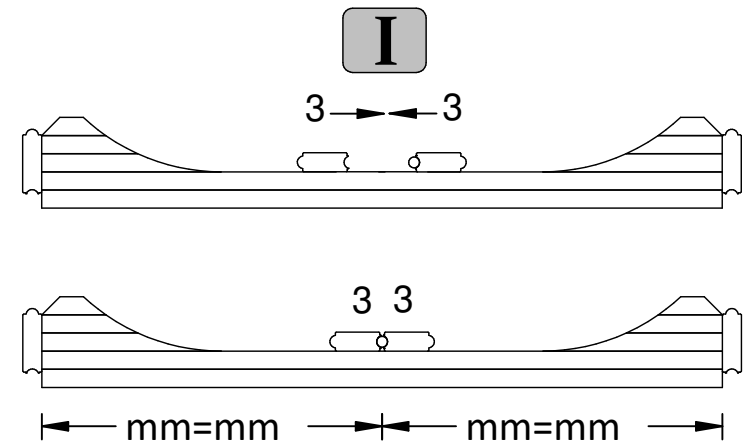
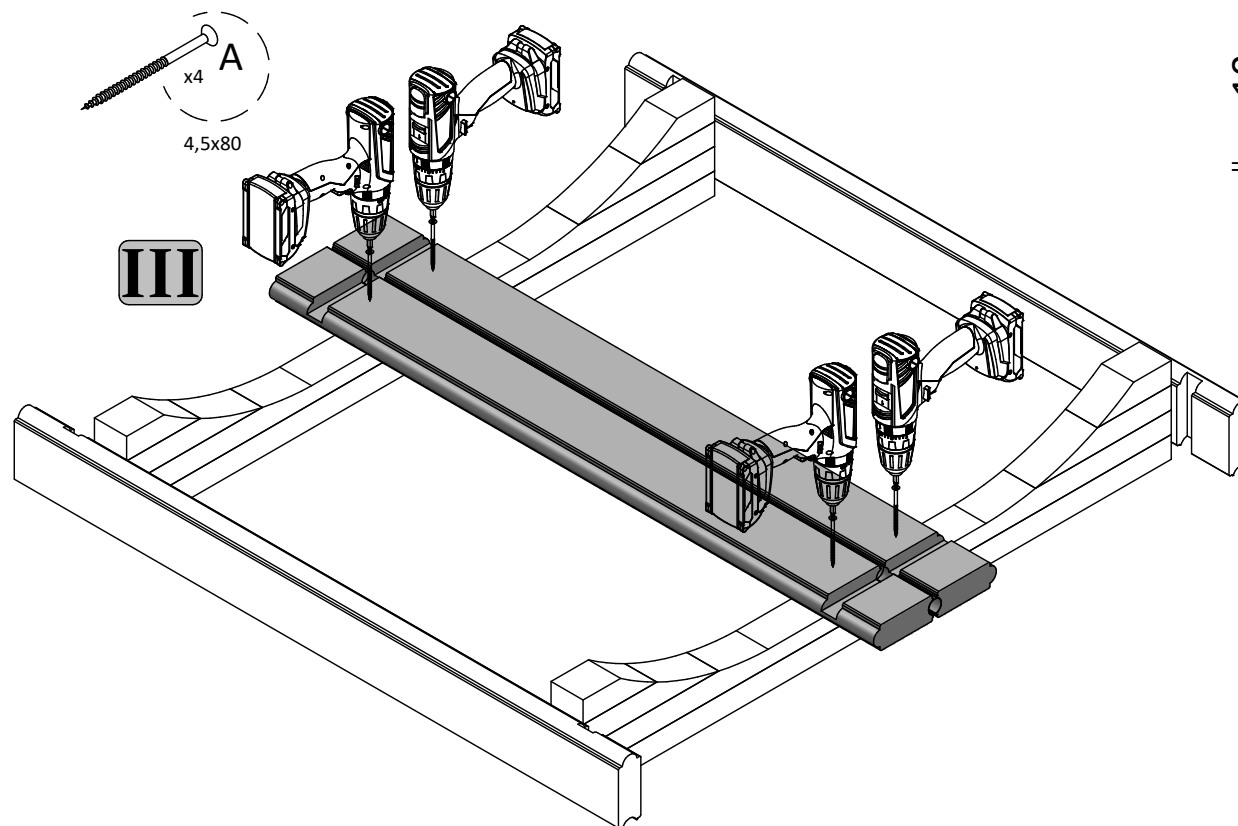
II - Within centerpiece leave gaps for front and back wall groove. Add extra 10mm on both ends. In the middle, leave a 10mm gap for a water drainage.

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.

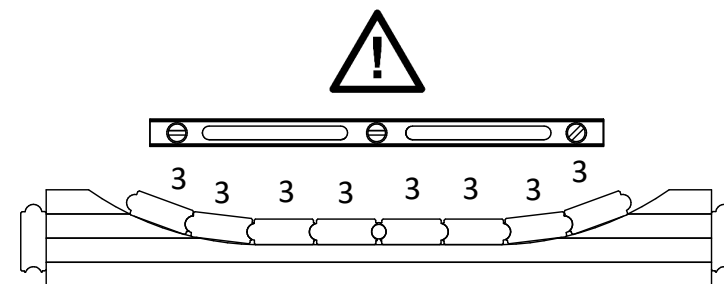
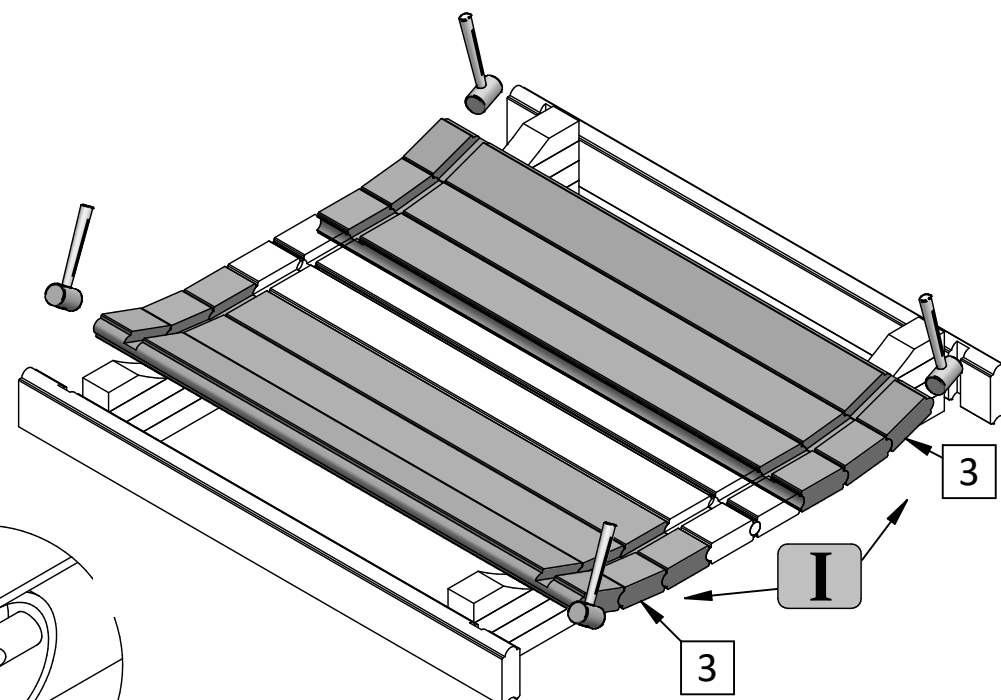
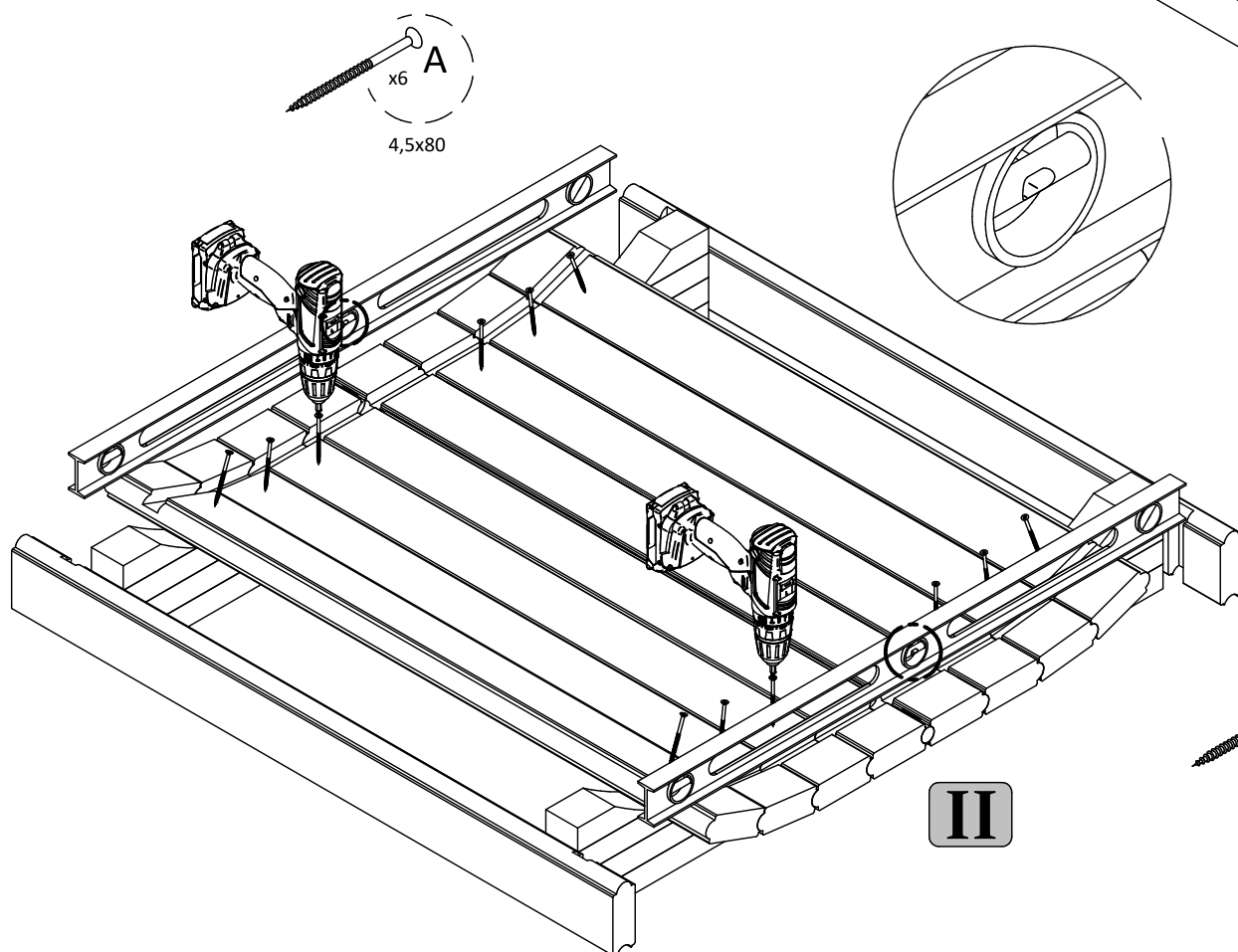


ADD MORE STAVES TO THE BOTTOM.

I - Tap the staves gently in with rubber mallet.

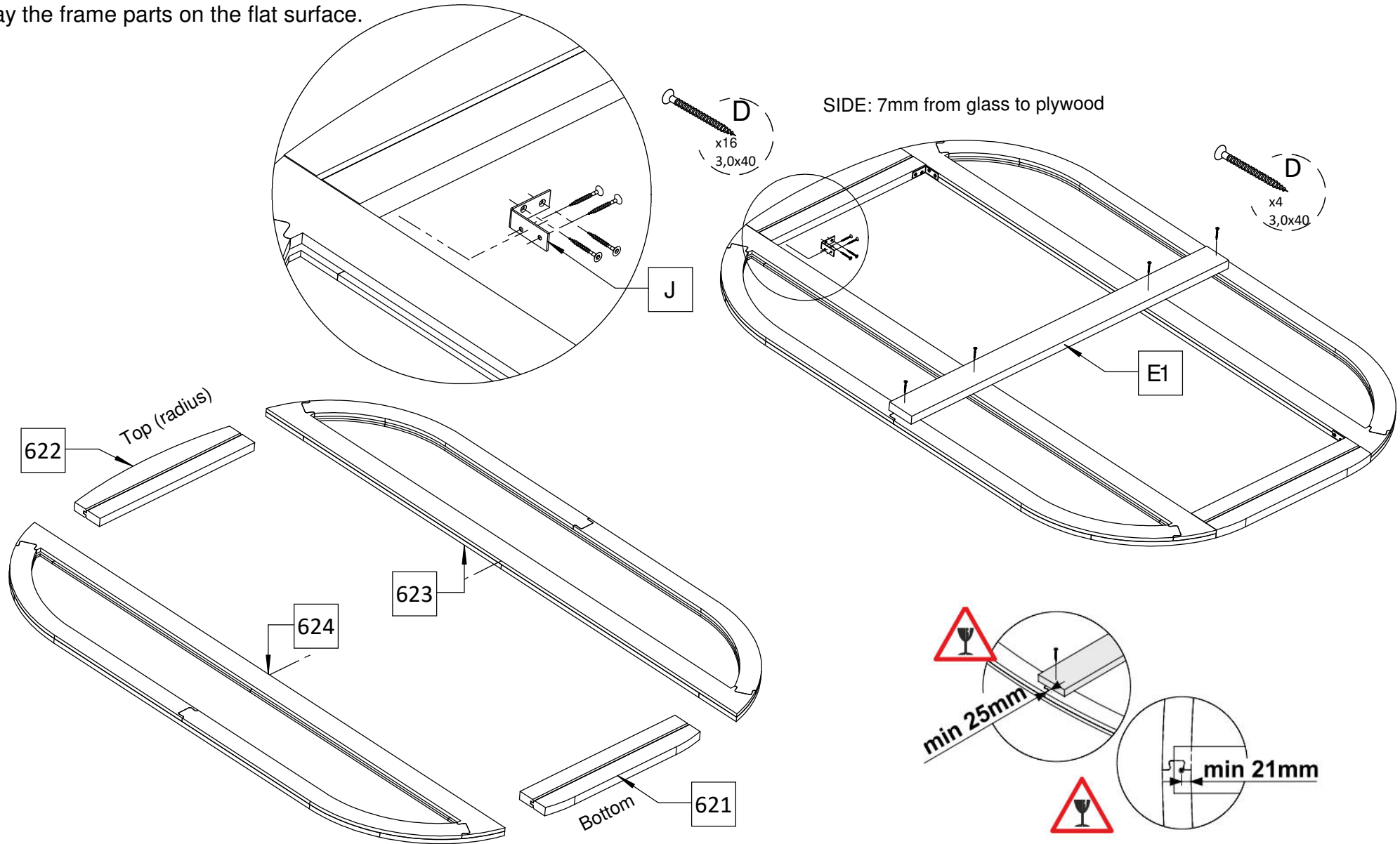
II - Make sure they are evenly levelled with the opposite side of the wall.

Use a level



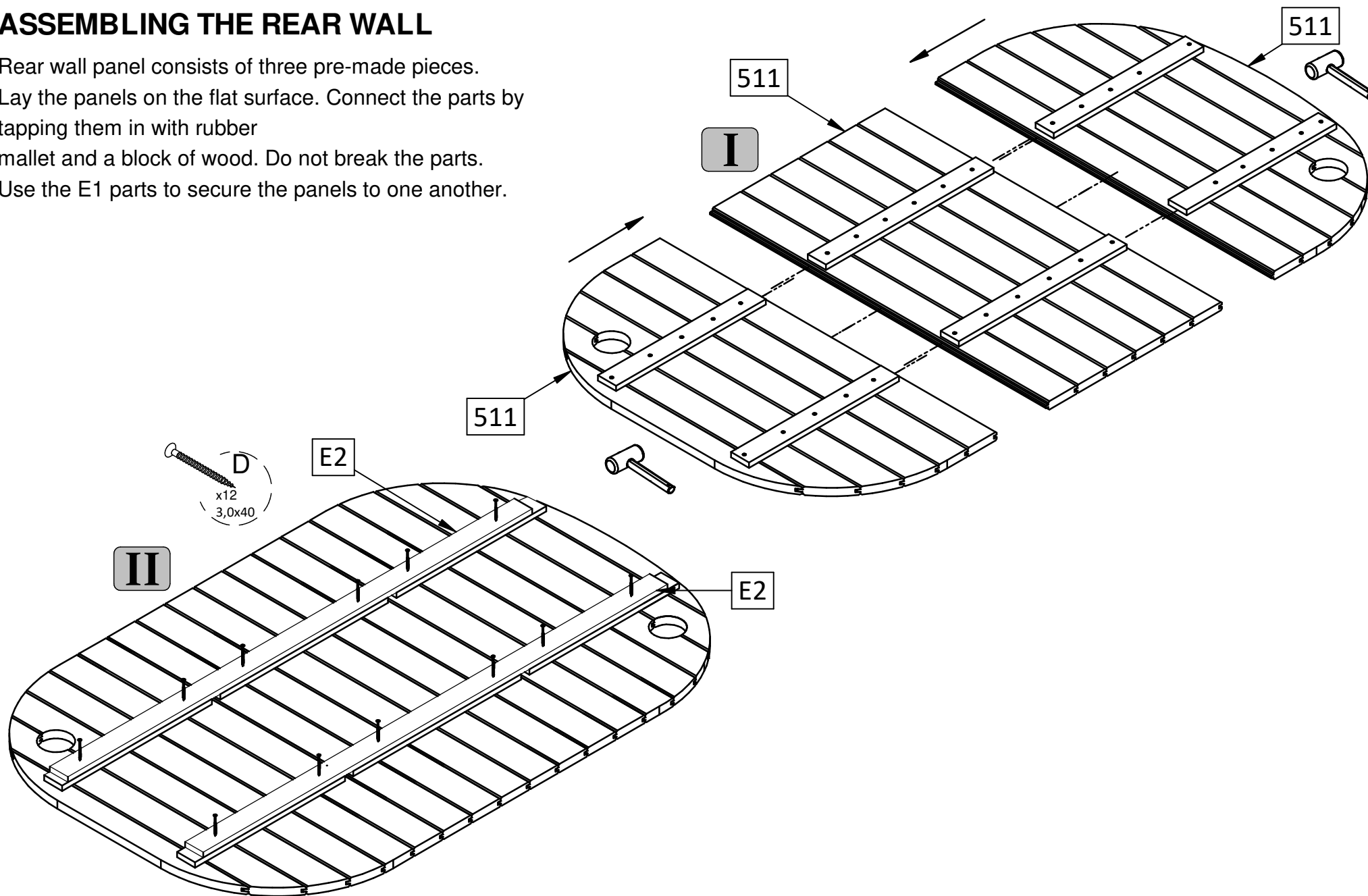
ASSEMBLING THE FULL GLASS FRONT WALL

Lay the frame parts on the flat surface.



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

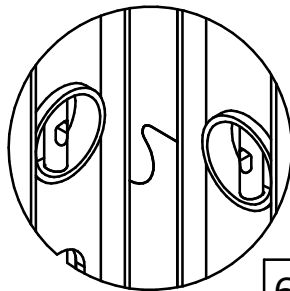
I - Tap the front wall base and back wall gently into the groove with rubber mallet.

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.

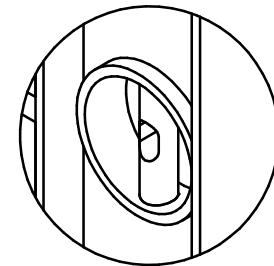
II



Use a level

621-623

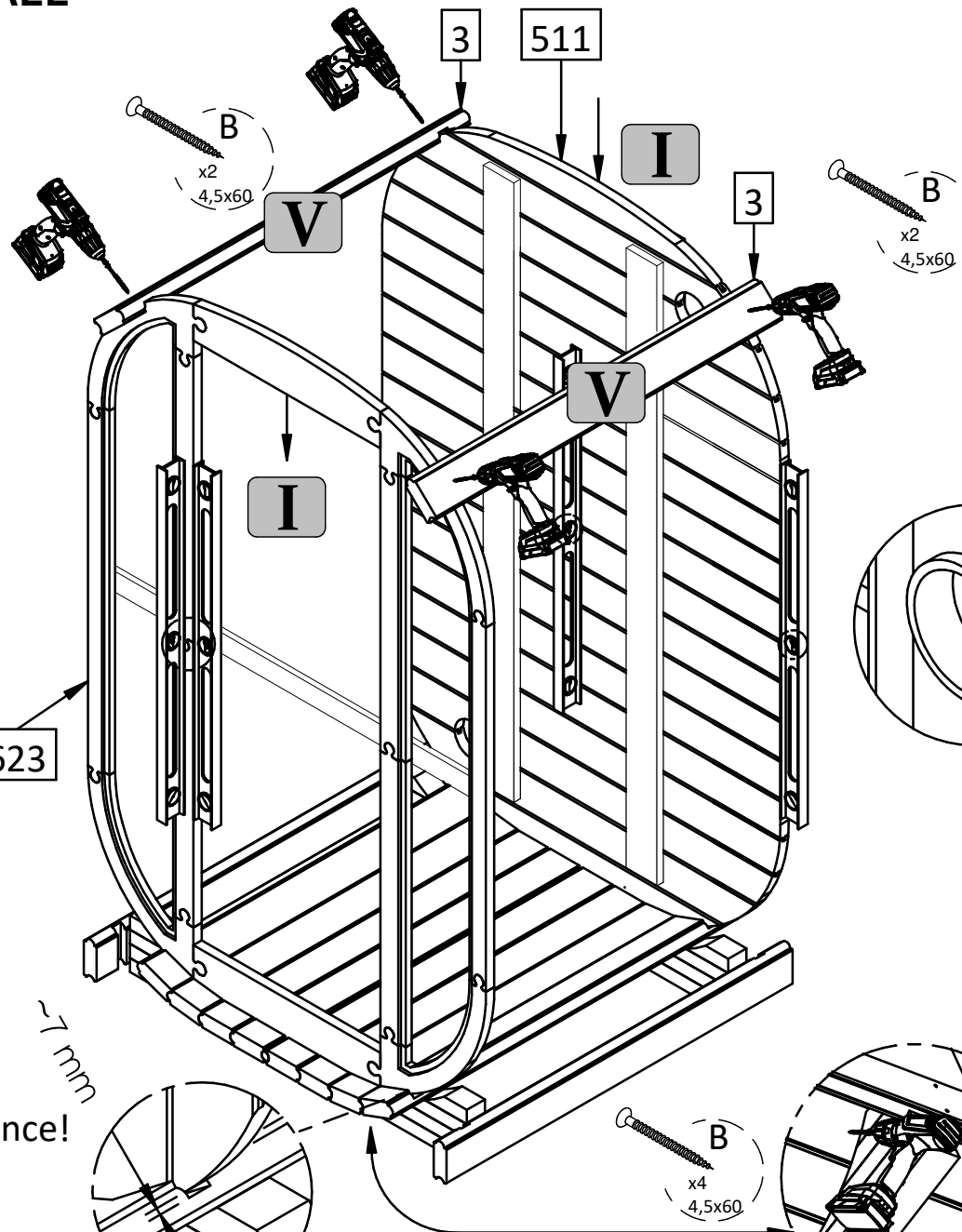
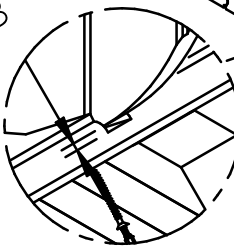
III



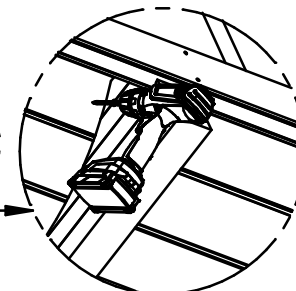
Important! Keep your distance!
Don't leave a gap if
the sauna is made of
thermowood.



~7 mm



IV



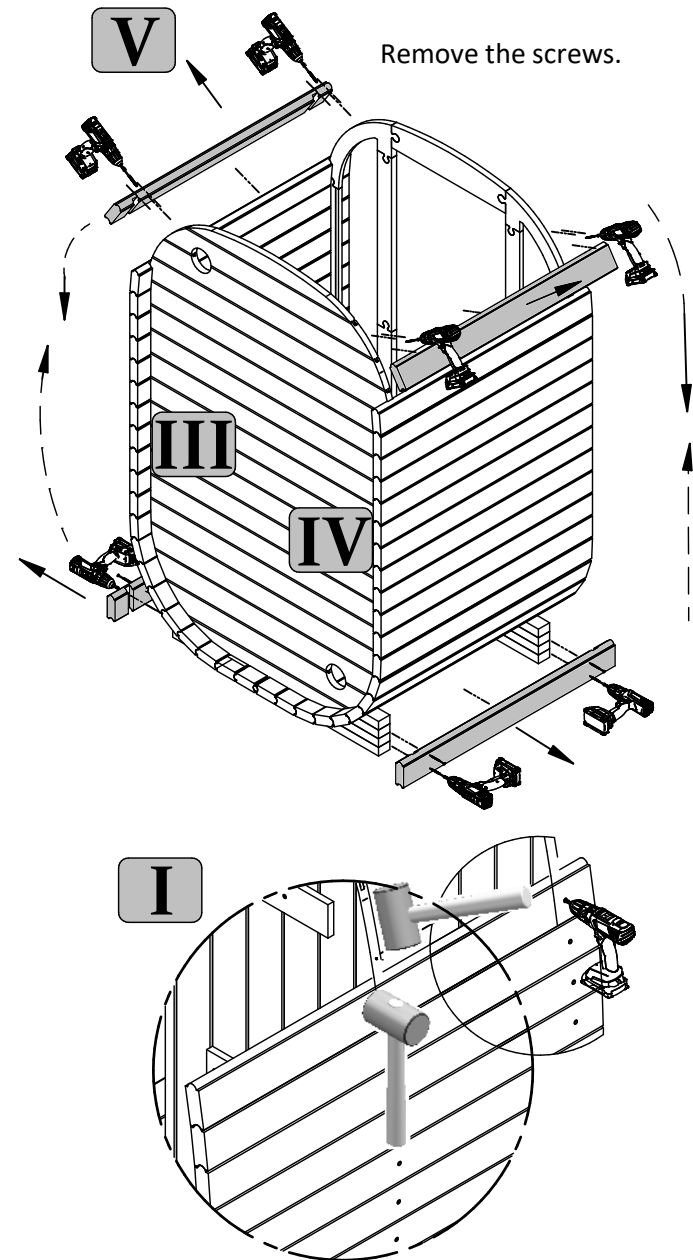
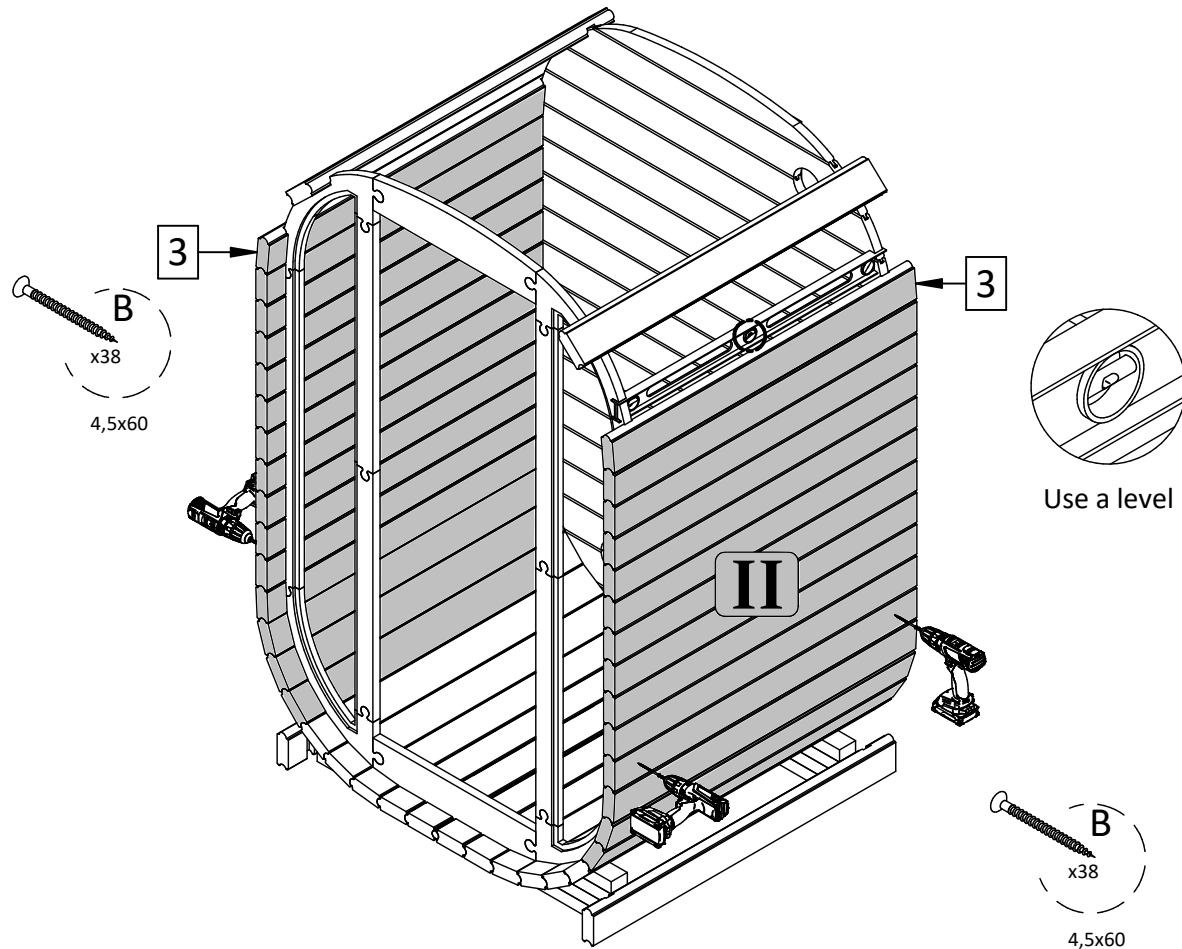
BUILDING UP THE WALLS

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.

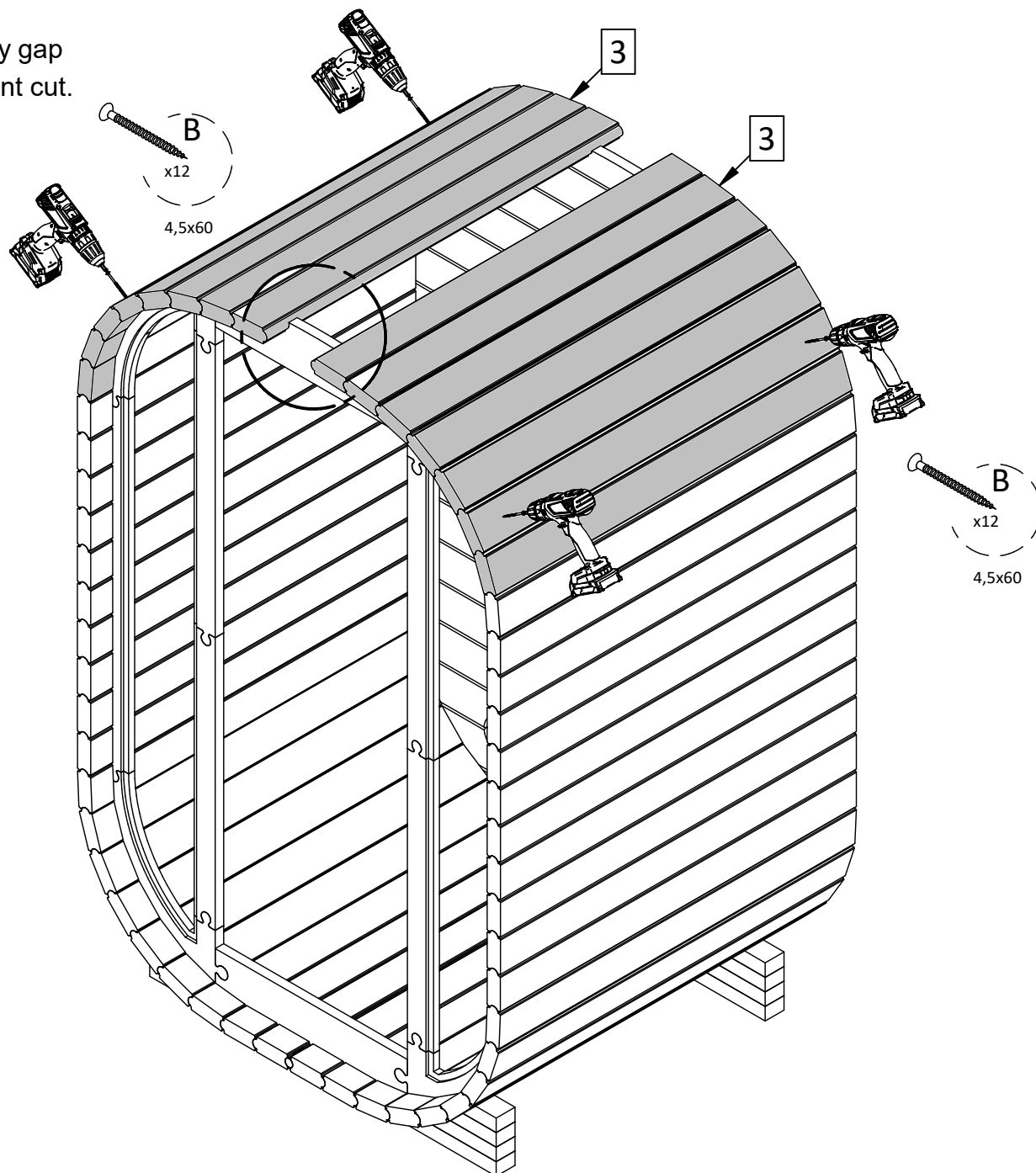
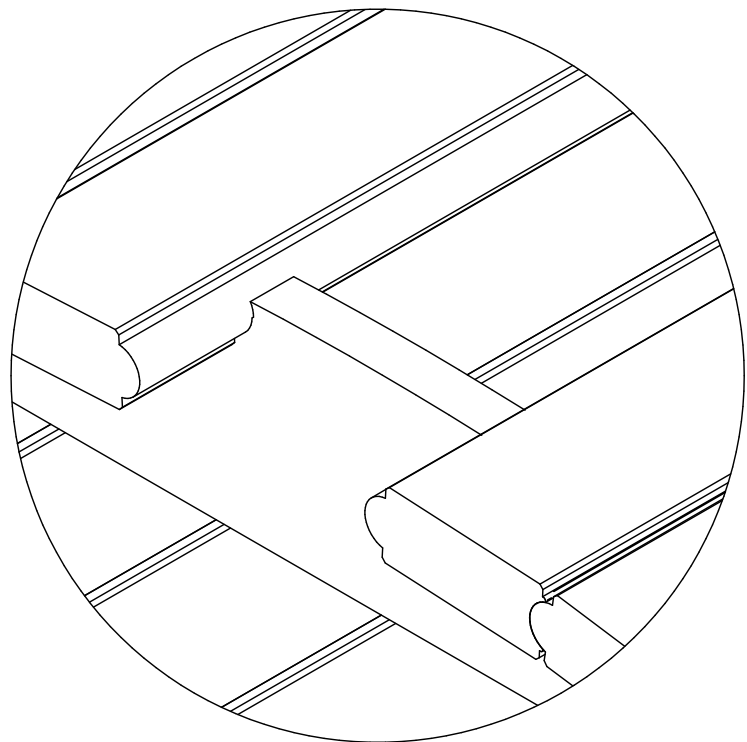
III - IV As you build the side wall higher, the structure becomes solid.

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.



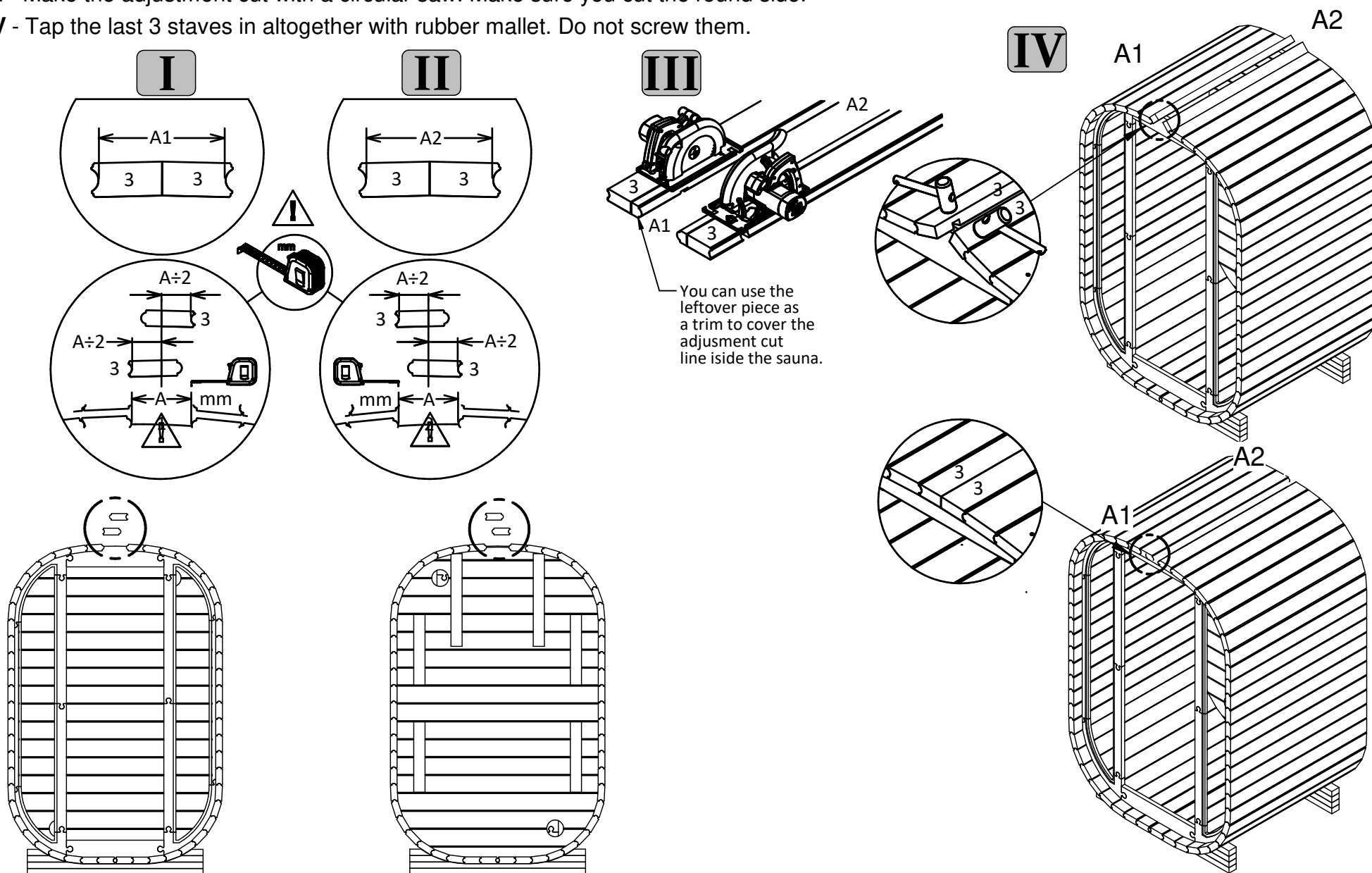
CONNECTING THE ROOFTOP

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.

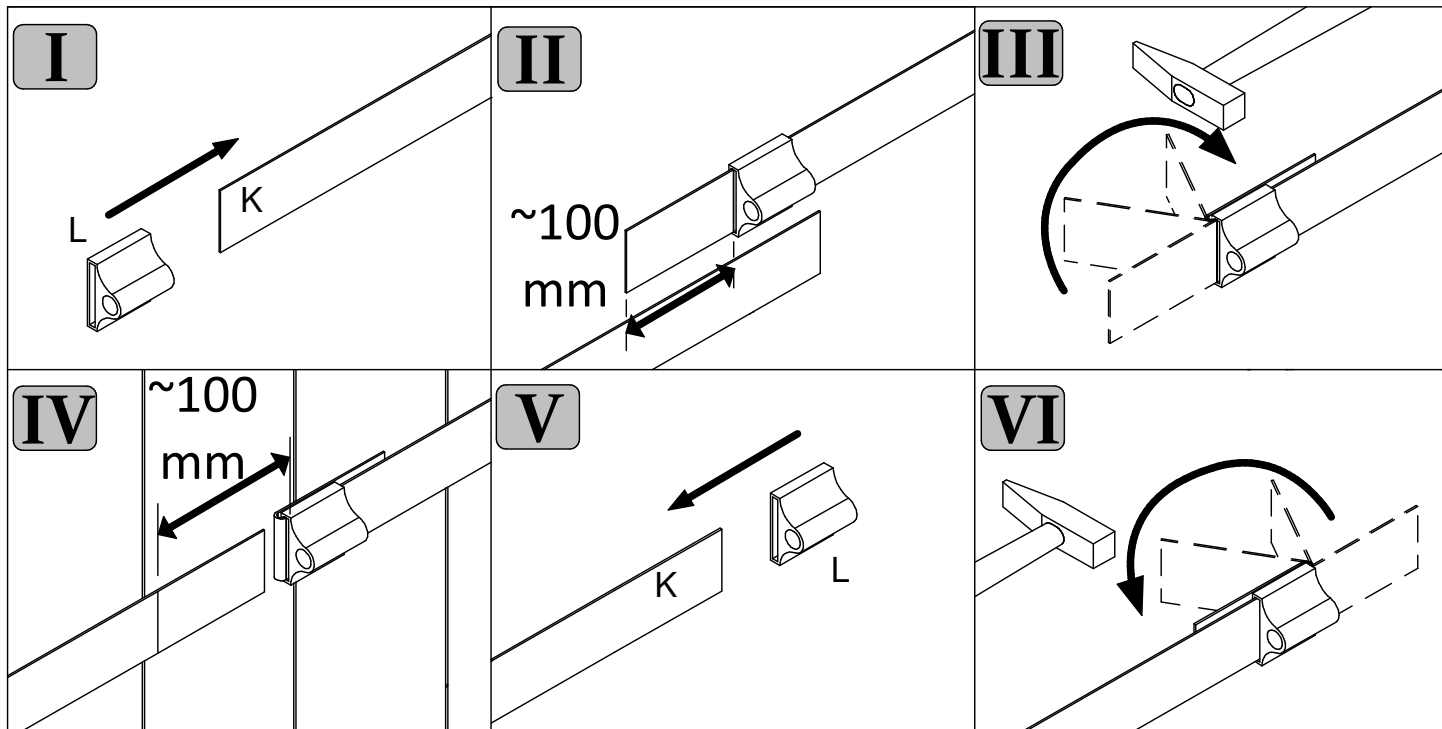
III - Make the adjustment cut with a circular saw. Make sure you cut the round side.

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



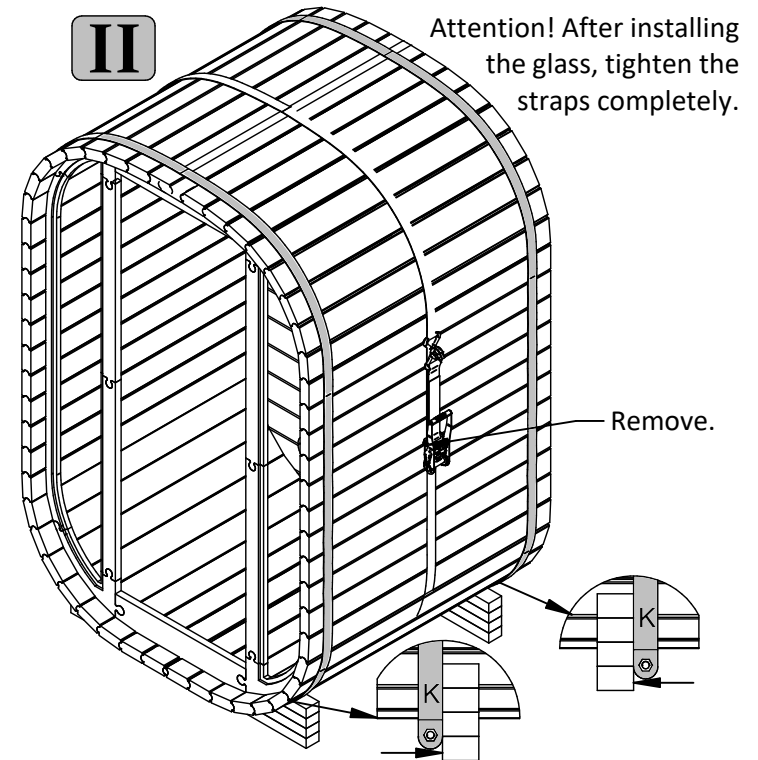
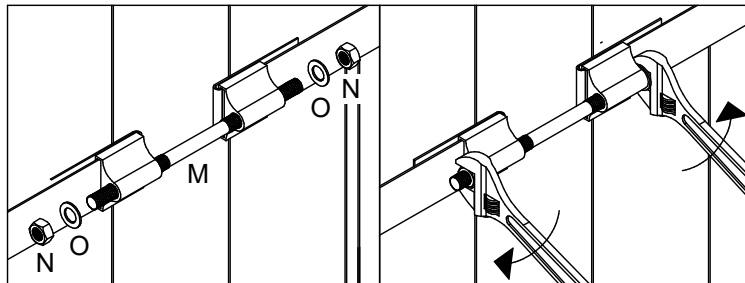
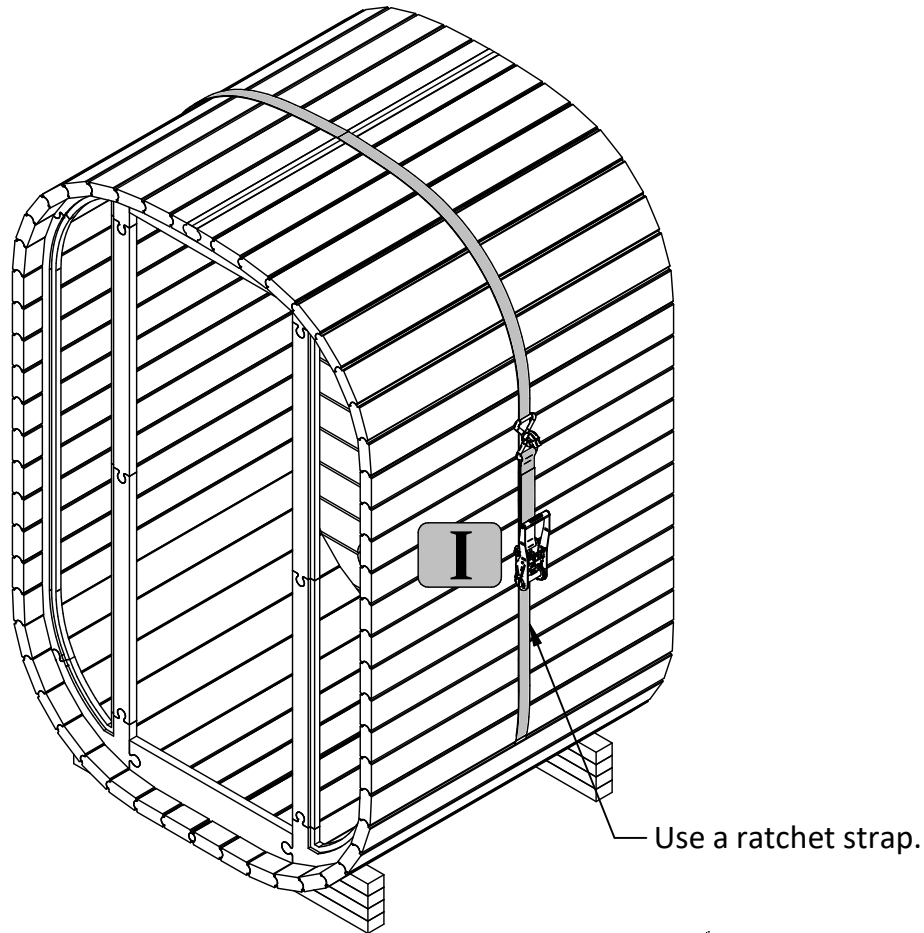
FORM THE STEEL STRAP ENDS

- 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.

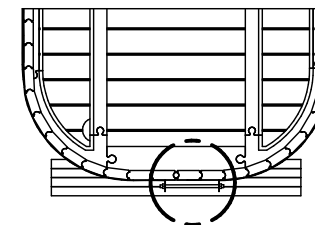
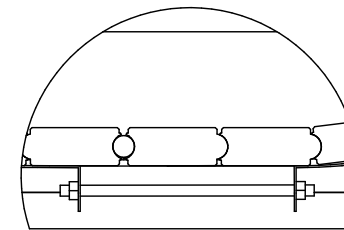


INSTALL THE STEEL STRAPS

- 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.

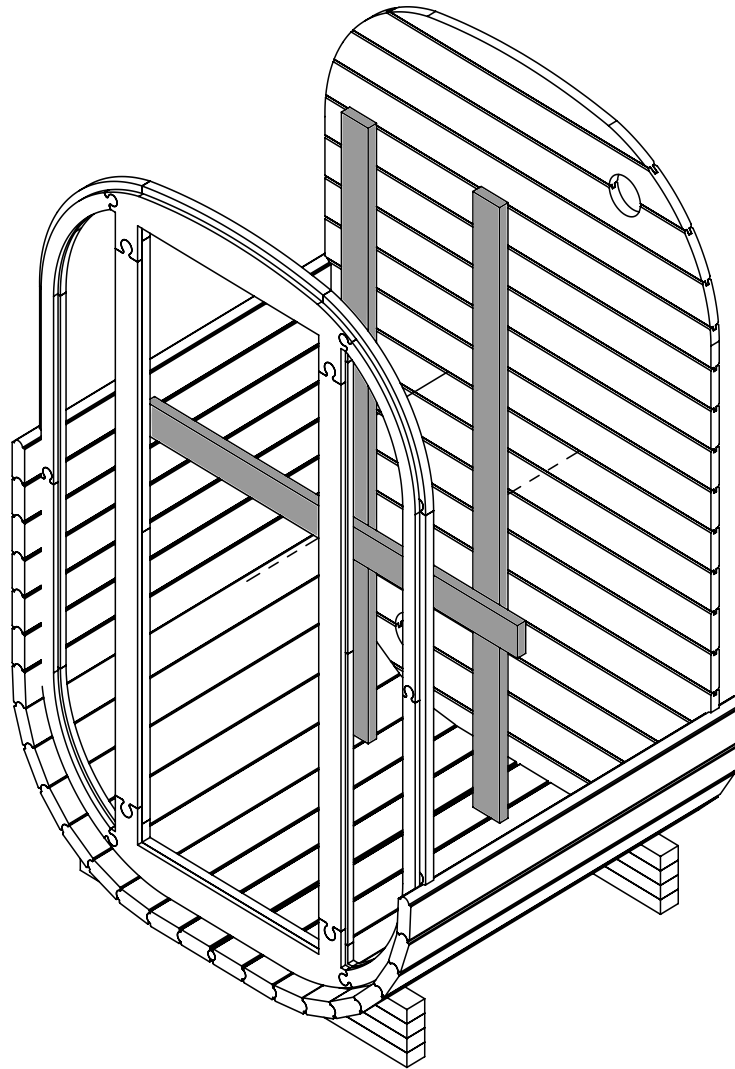


III



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.

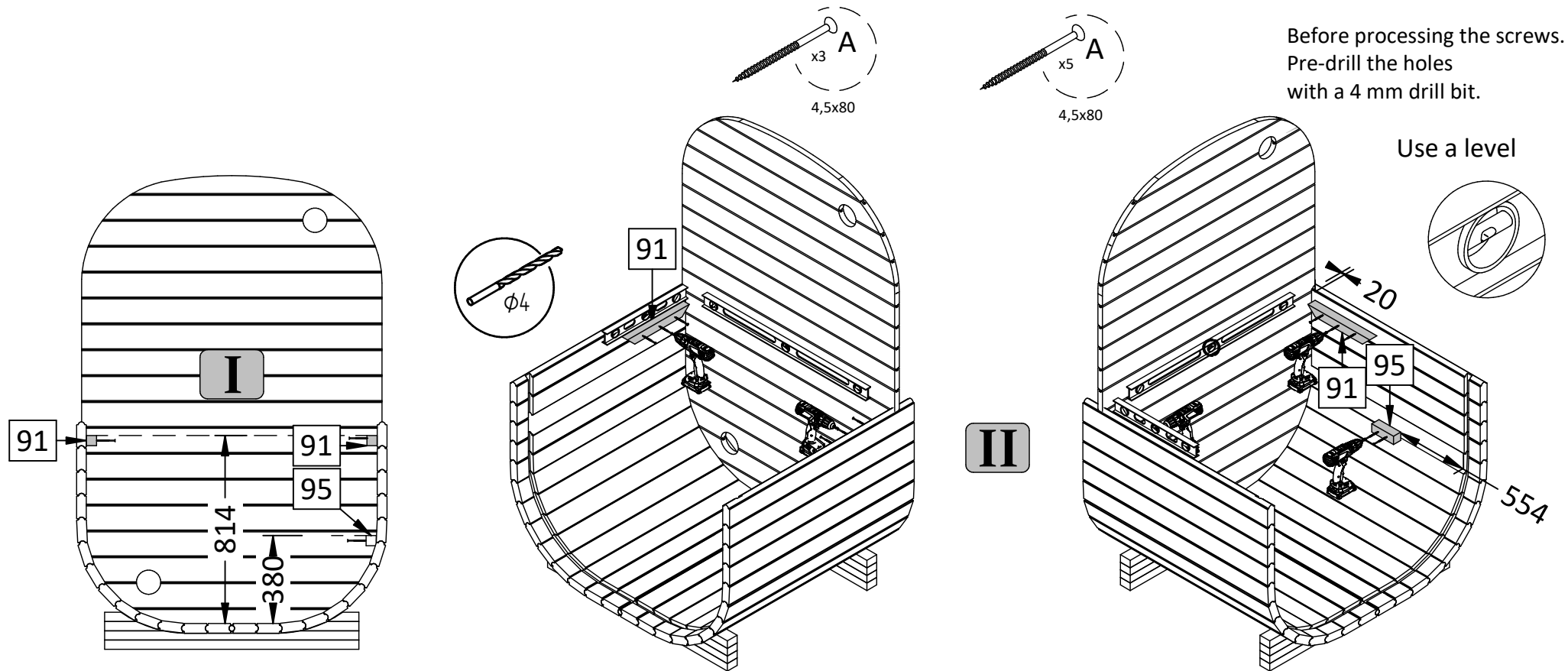
Remove all boards from the inside.



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.



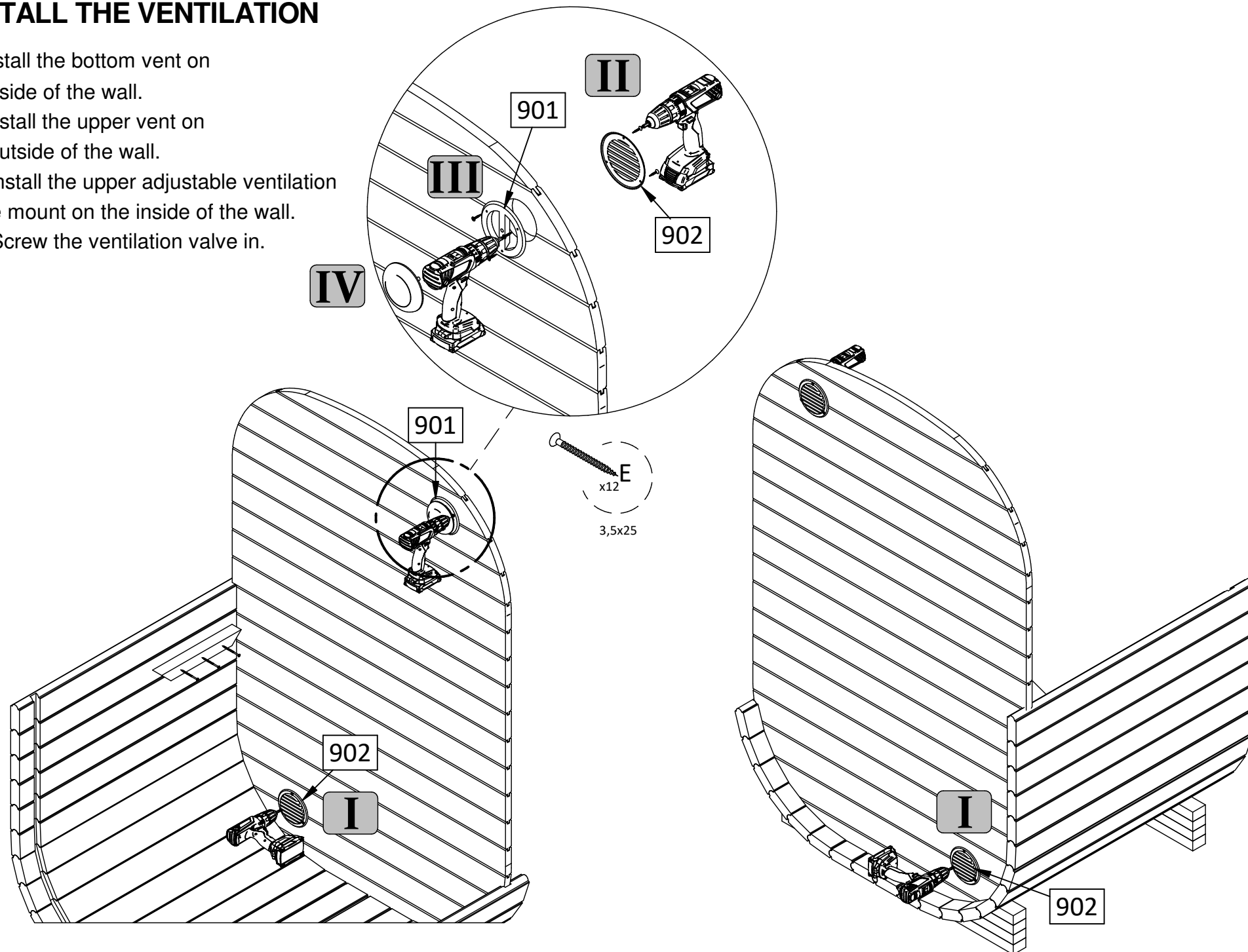
INSTALL THE VENTILATION

I - Install the bottom vent on both side of the wall.

II - Install the upper vent on the outside of the wall.

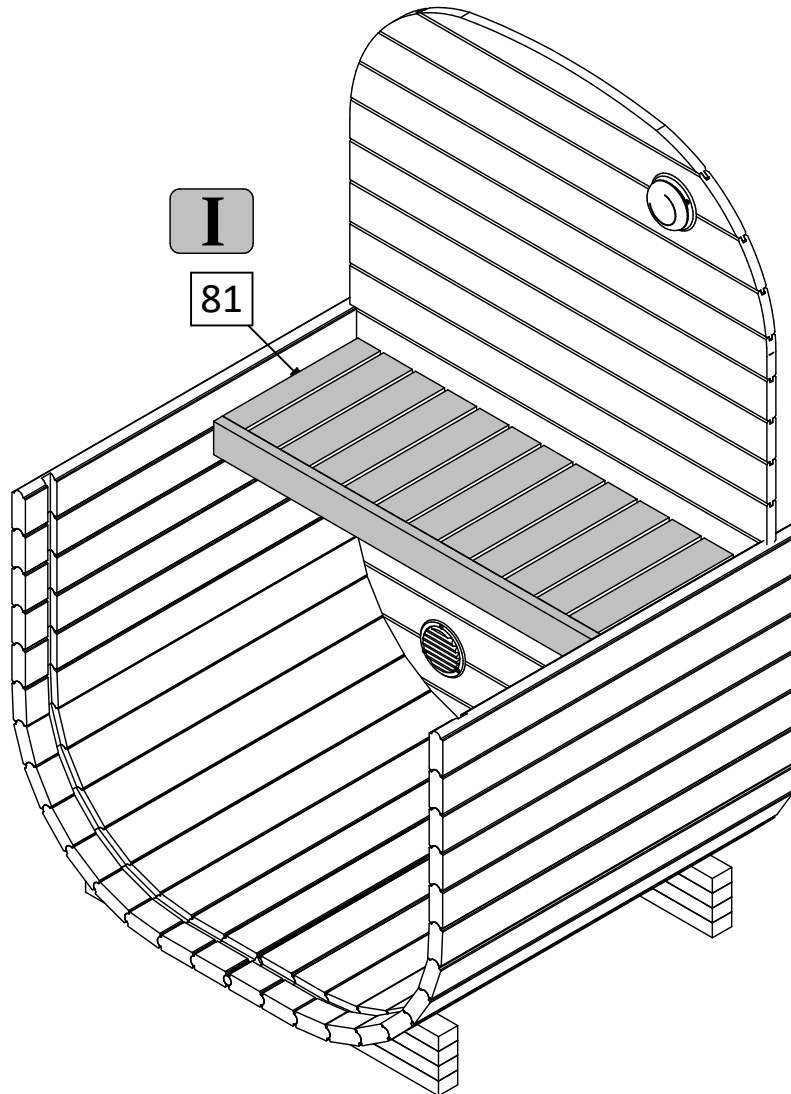
III - Install the upper adjustable ventilation valve mount on the inside of the wall.

IV - Screw the ventilation valve in.



INSTALL THE BENCH

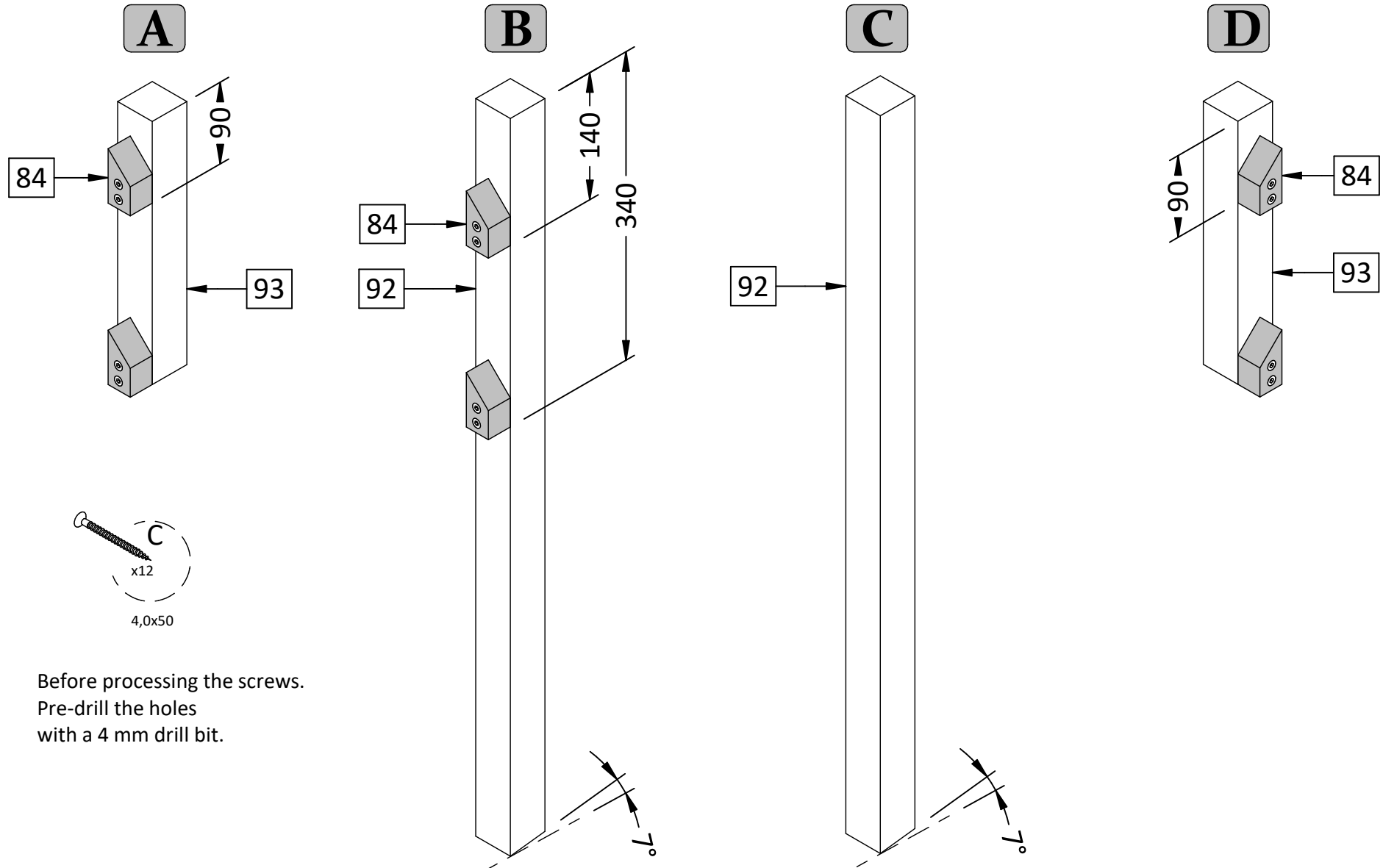
I - Place the bench on the supports. The bench has to be tight against the back wall.



PREPARE THE BENCH SUPPORT LEGS

I - Screw the skirt holders (84) to the bench support legs (93; 92; 93 mirrored).

PS! The legs are pre-cut at a 7-degree angle to match the curved floor. Install with the higher part of the angled cut facing outward.

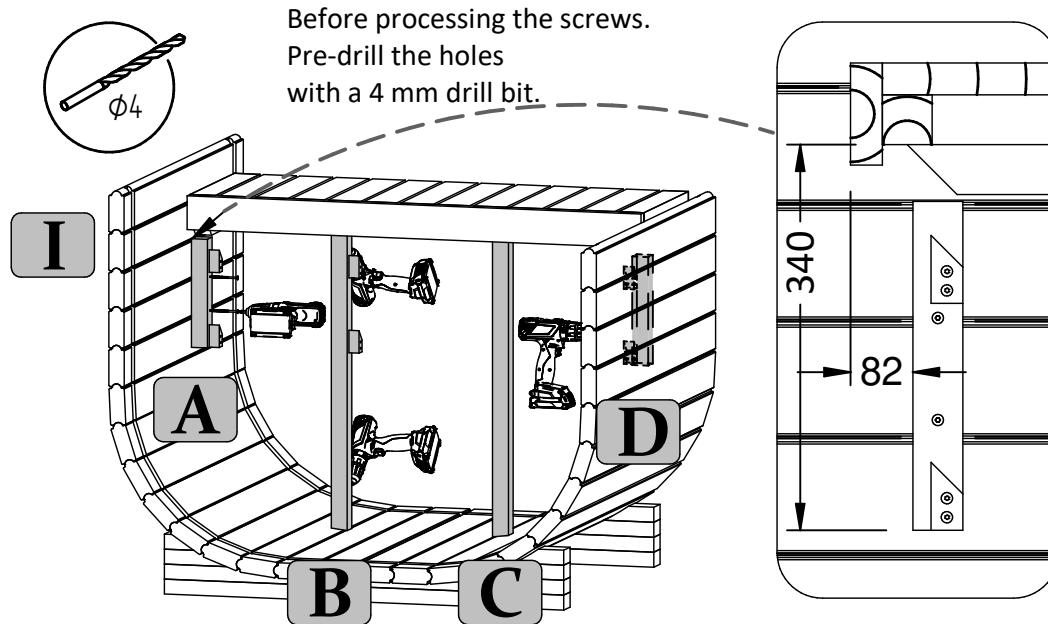


INSTALL THE BENCH SUPPORT LEGS

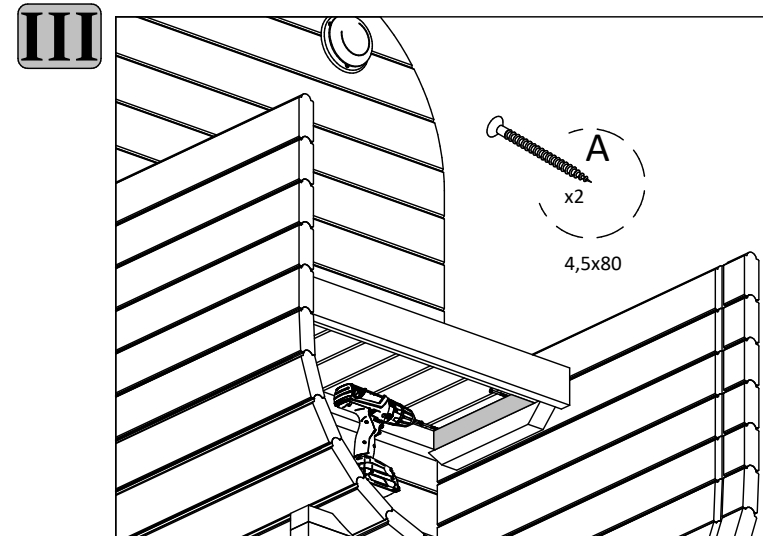
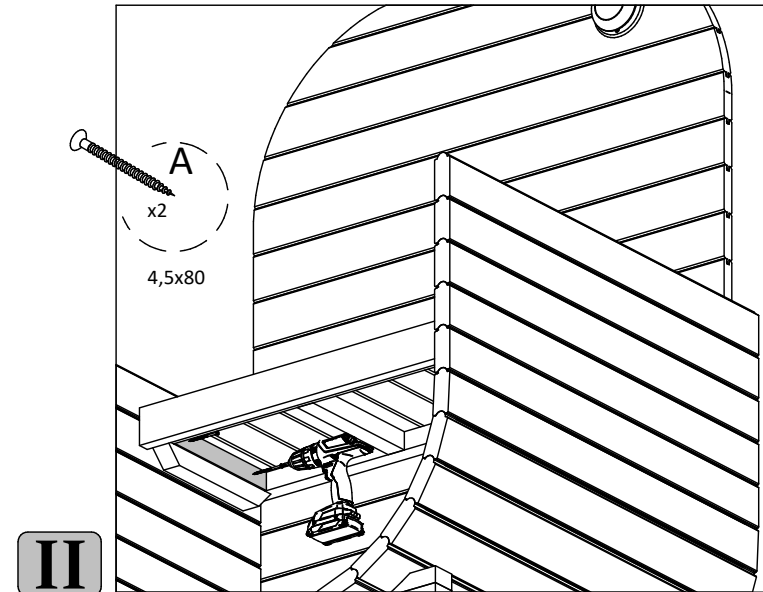
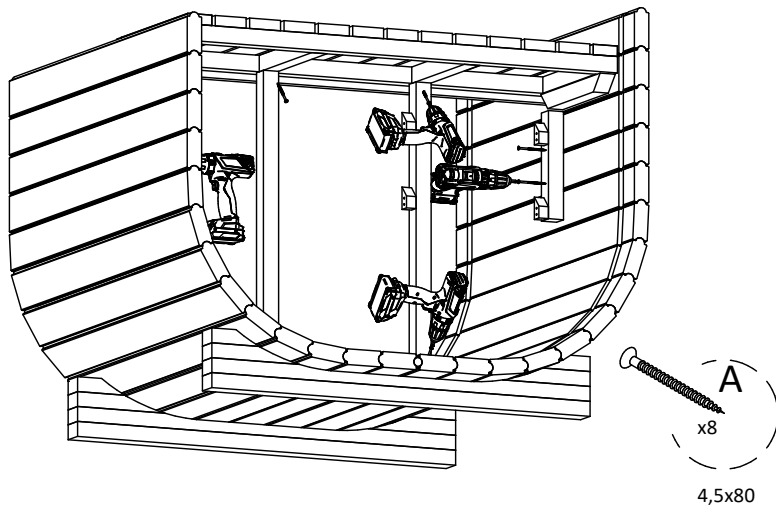
I - Screw the support legs under the bench (92) and to the sidewalls (93). Keep a 55mm distance from the front of the bench.

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

III - Screw the bench to the sidewalls.



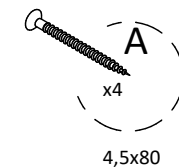
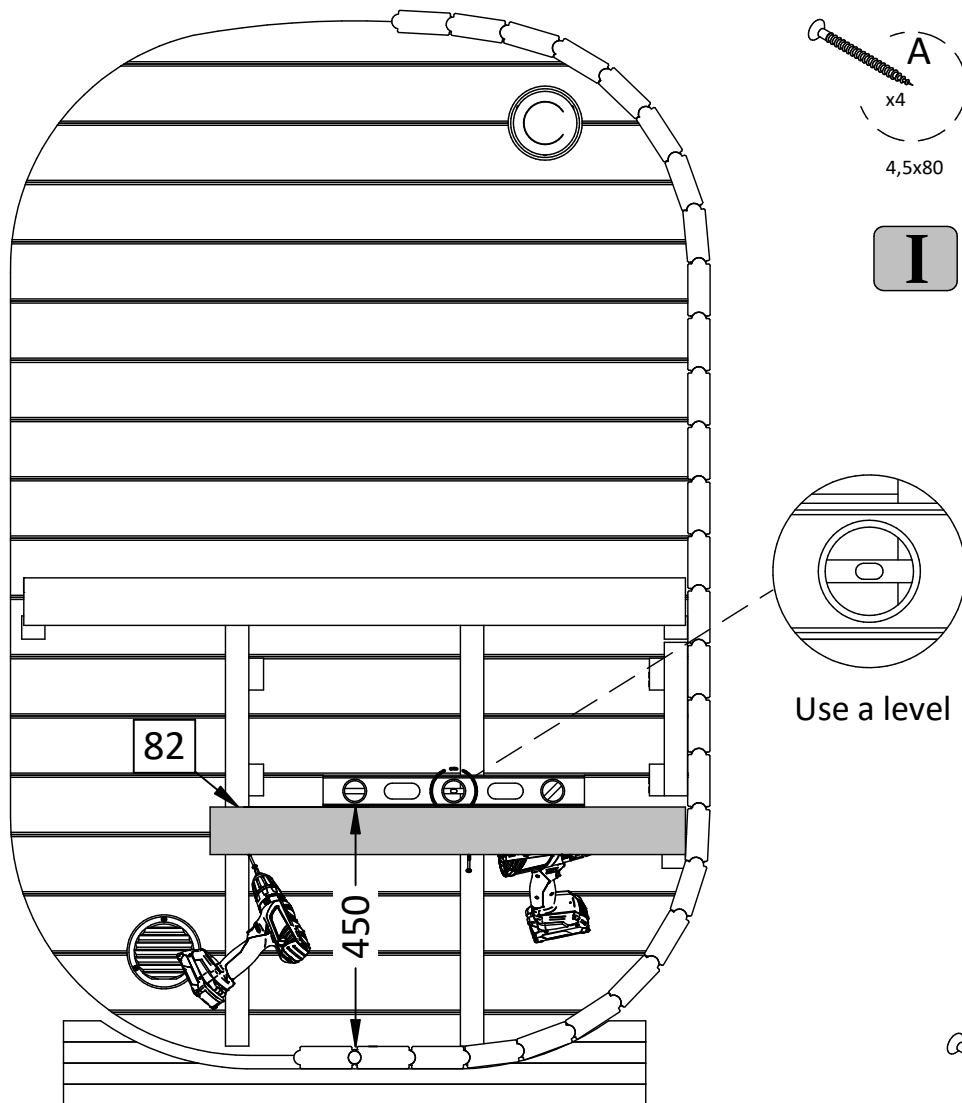
Use a level



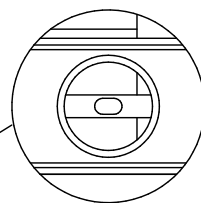
INSTALL THE LOWER BENCH

I - Connect the lower bench with upper bench supports to the height of 450mm. Make sure bench is leveled. Screw the bench to the sidewall.

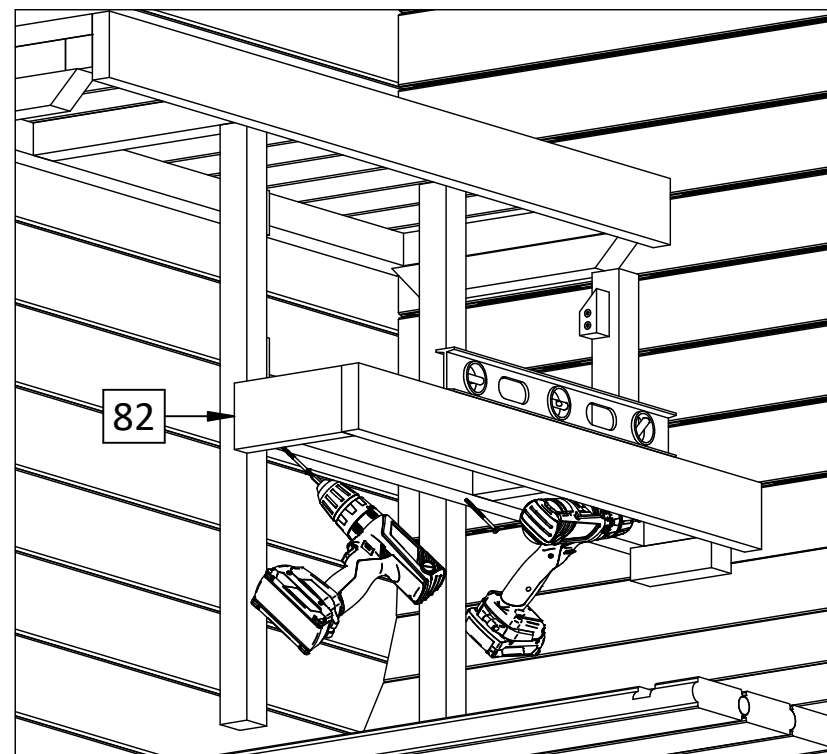
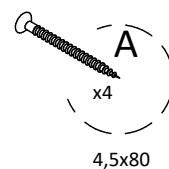
II - Fix the lower bench to the upper bench with diagonal supports (94).



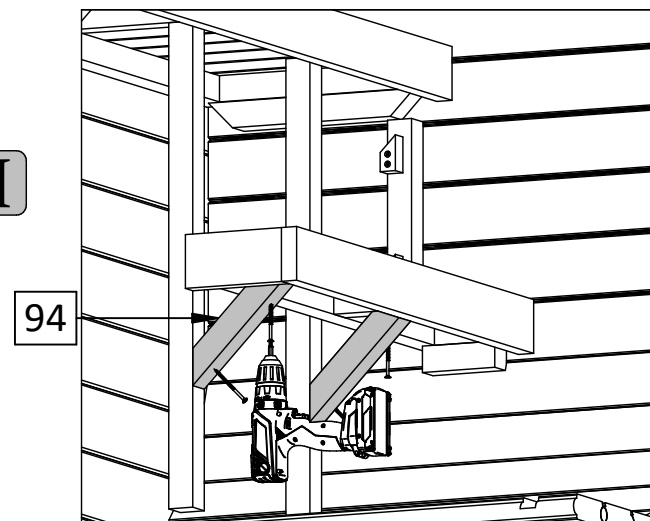
I



Use a level



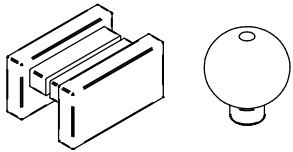
II



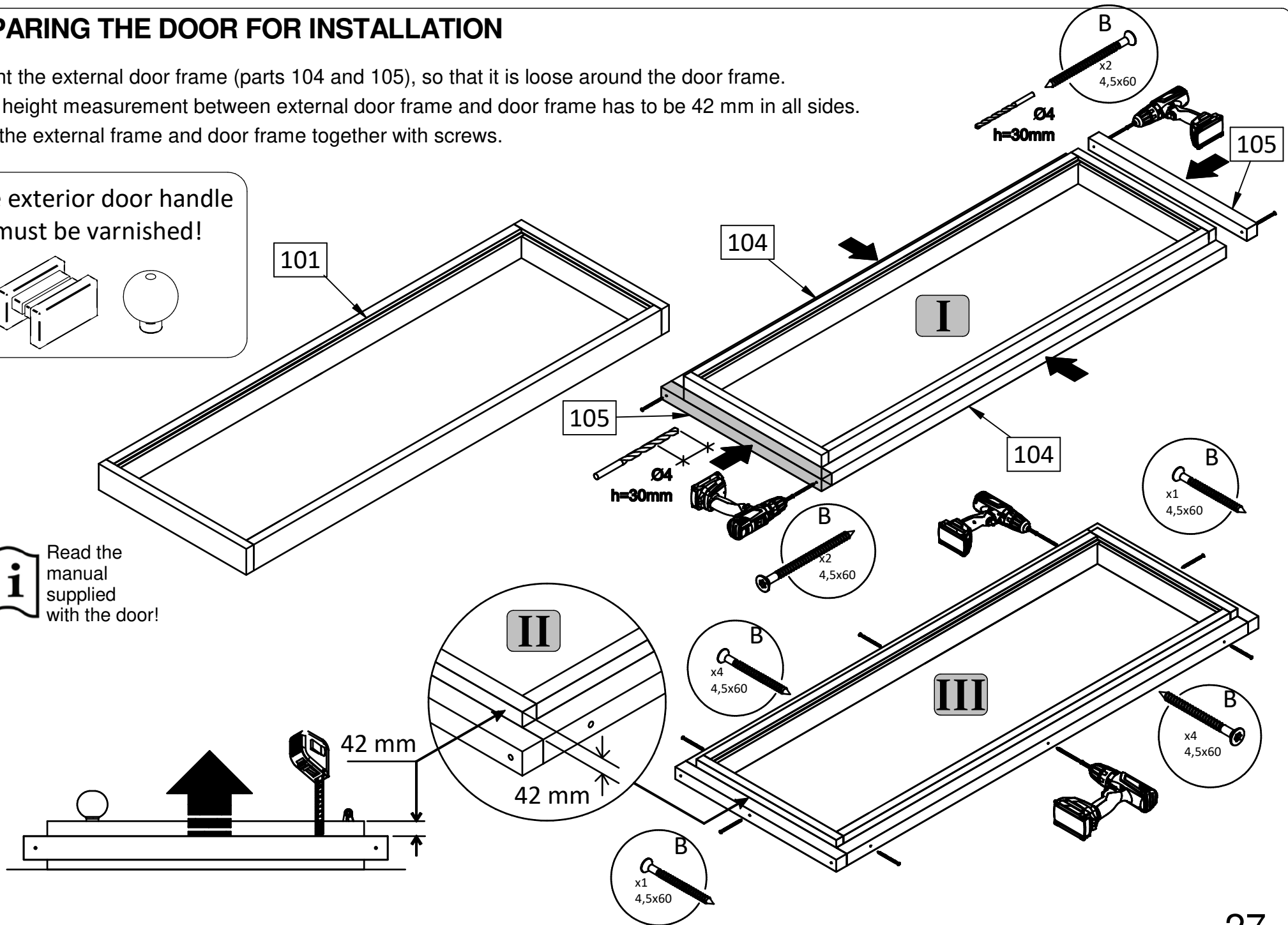
PREPARING THE DOOR FOR INSTALLATION

- 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.

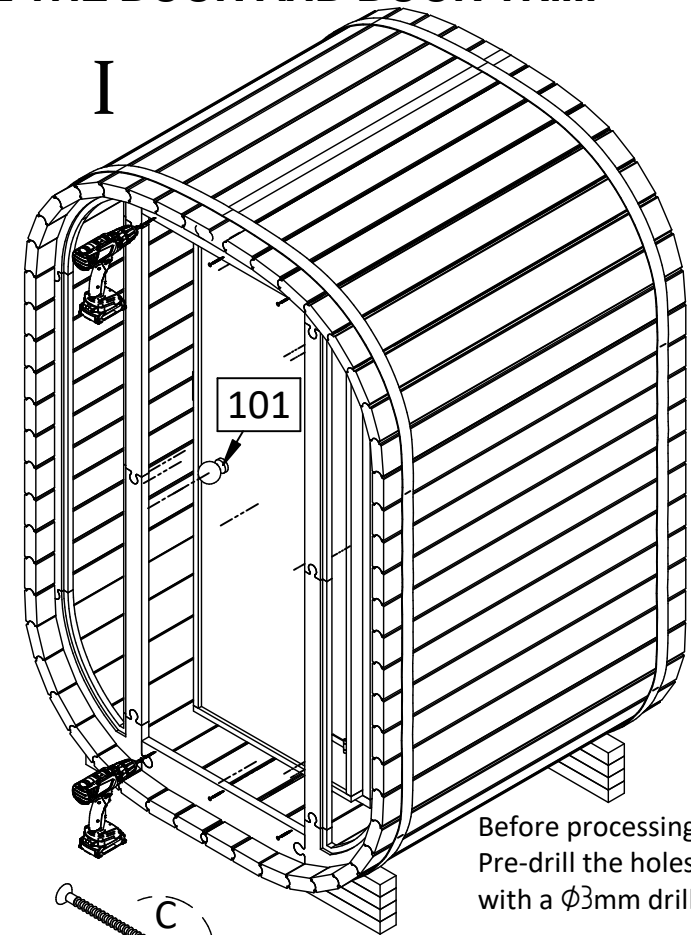
The exterior door handle must be varnished!



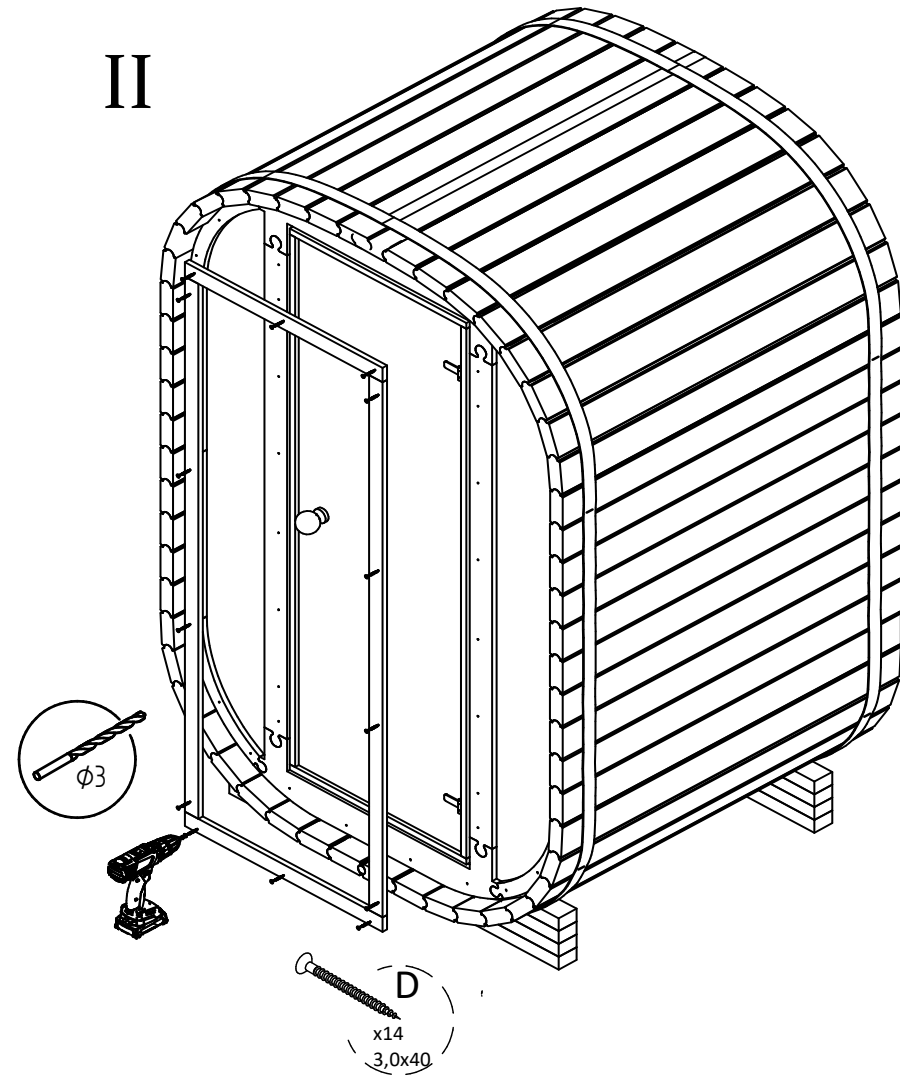
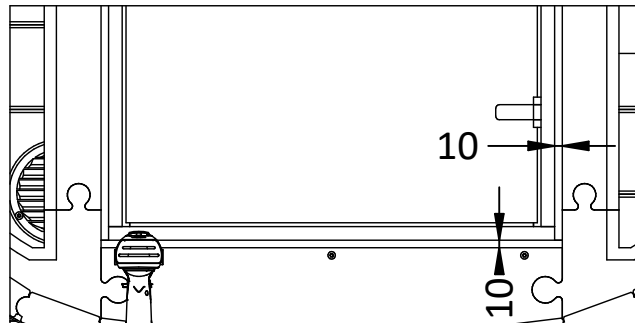
Read the manual supplied with the door!



INSTALL THE DOOR AND DOOR TRIM



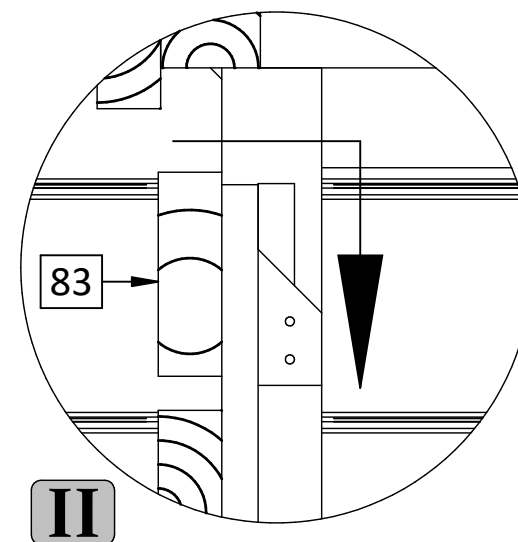
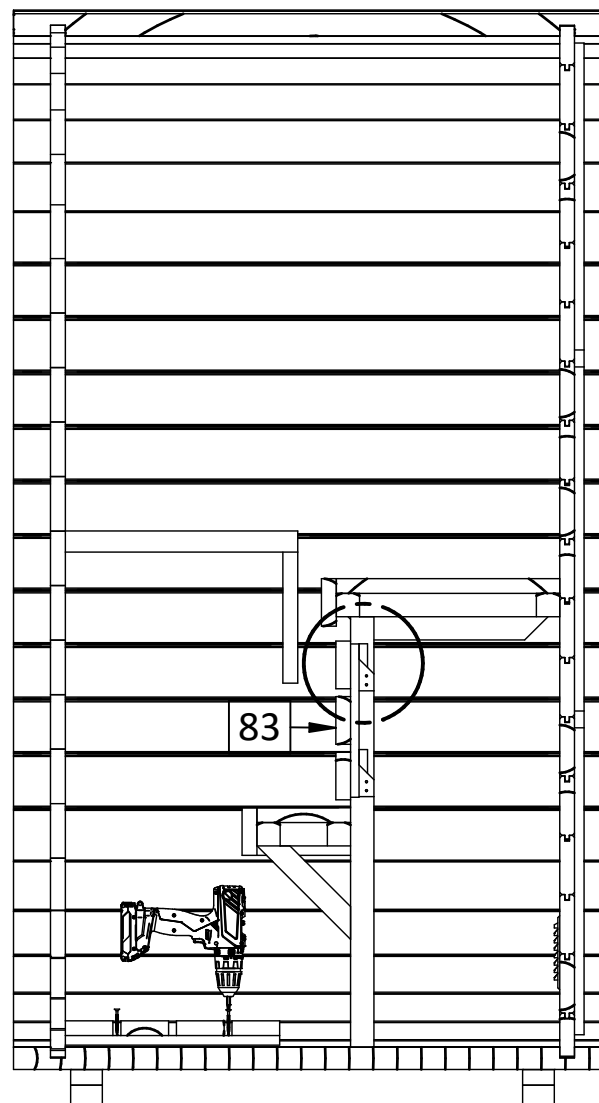
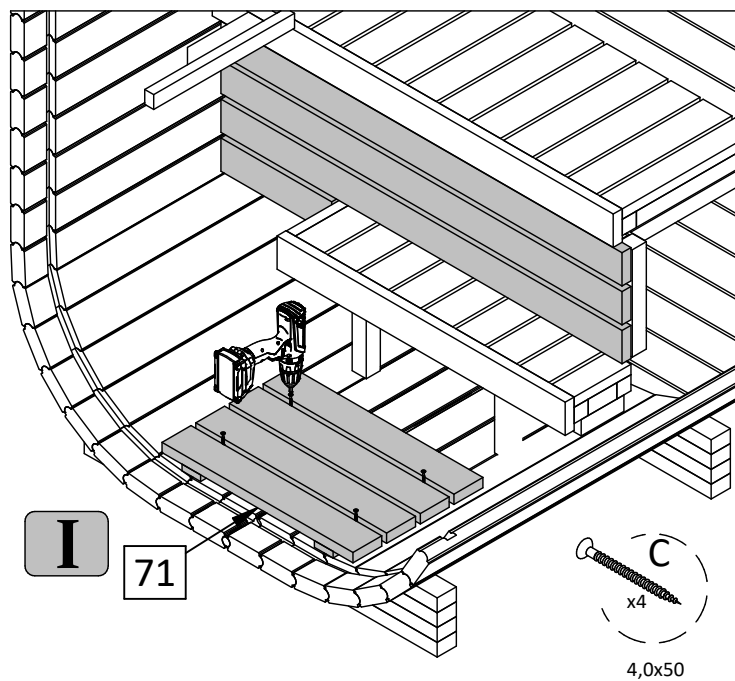
Before processing the screws.
Pre-drill the holes
with a $\phi 3$ mm drill bit.



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.

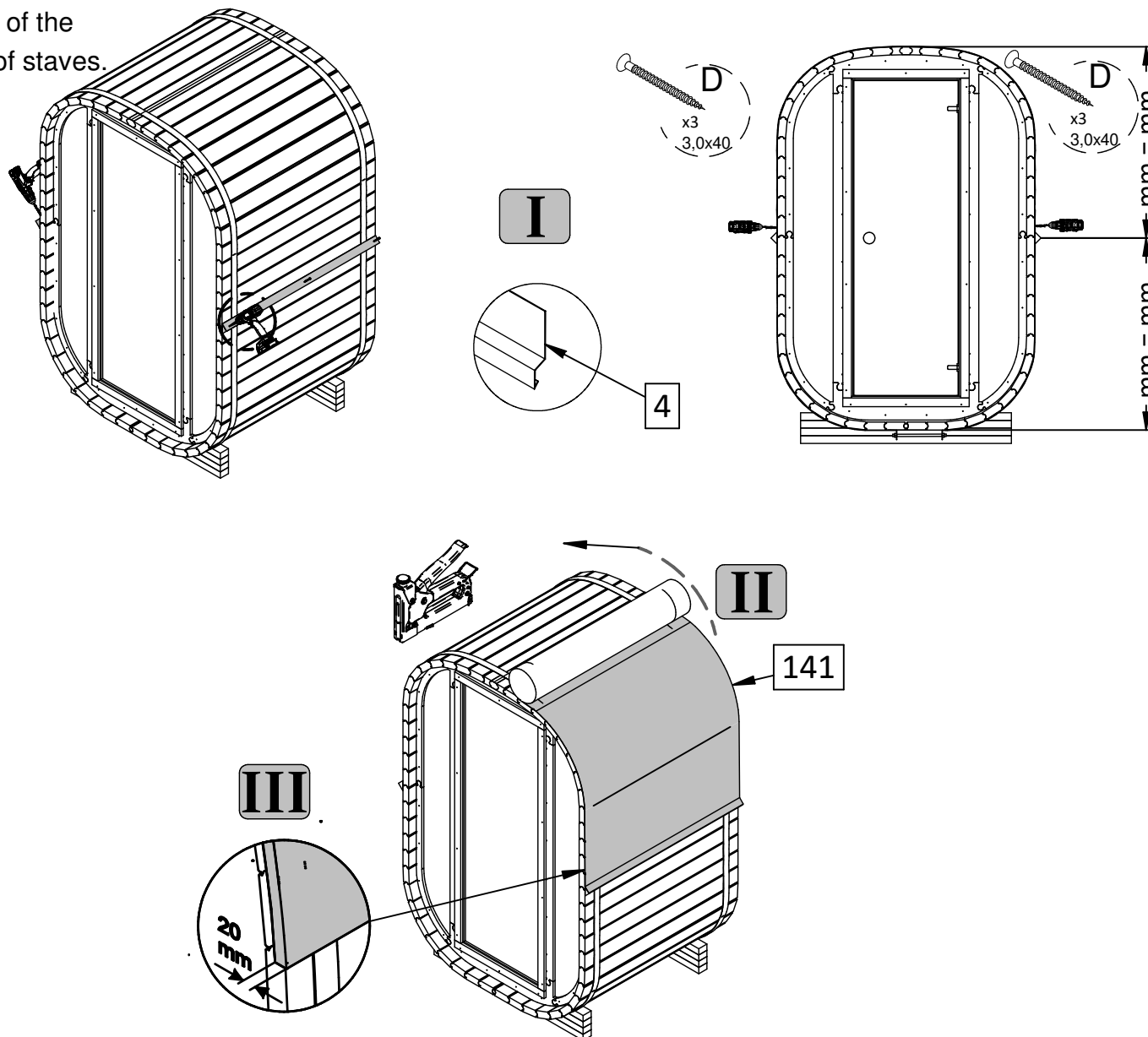


INSTALL THE ROOF UNDERLAYMENT

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.



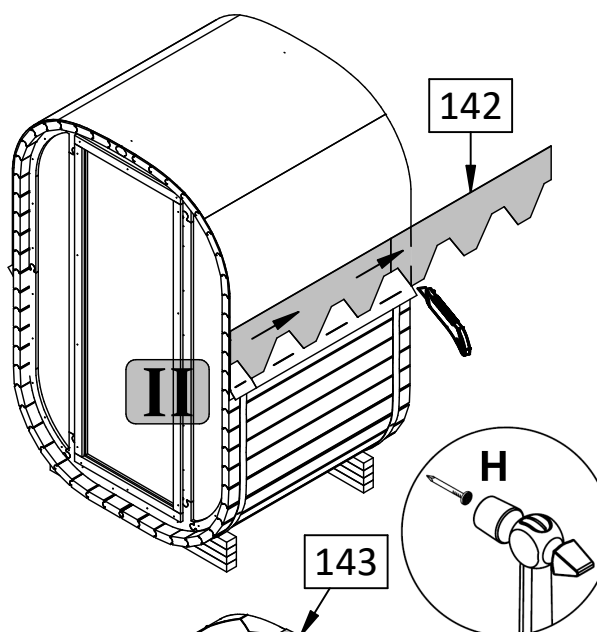
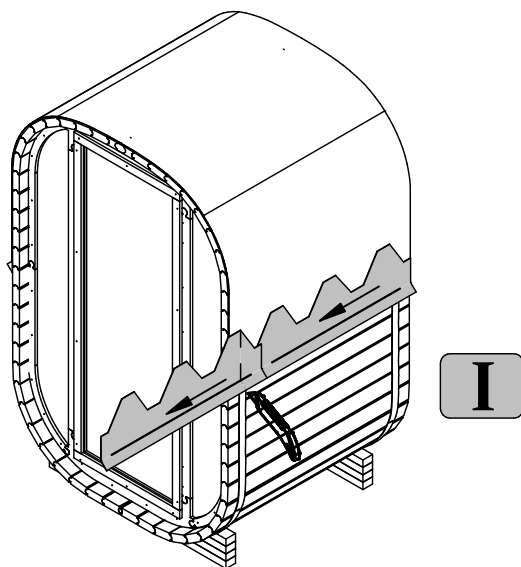
INSTALL THE ROOF SHINGLES

I - Install the the first shingles starting from the drip edge upside down.

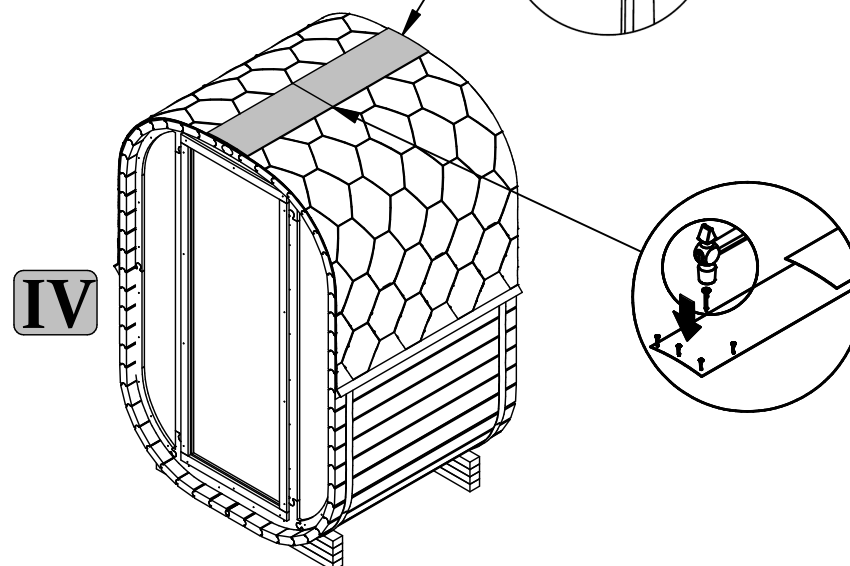
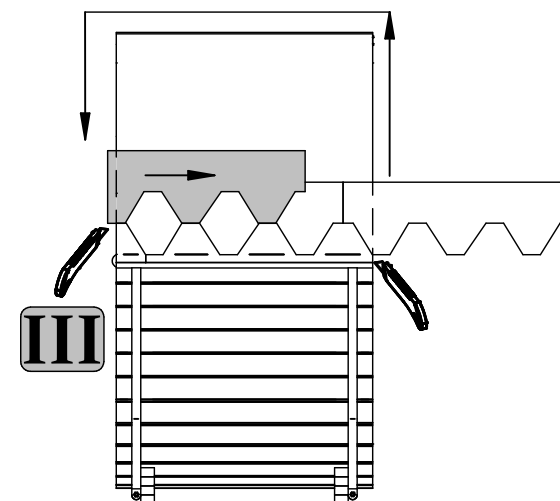
II - Follow the shingles manual and install the first row.

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

IV - Cover the roof ridge.

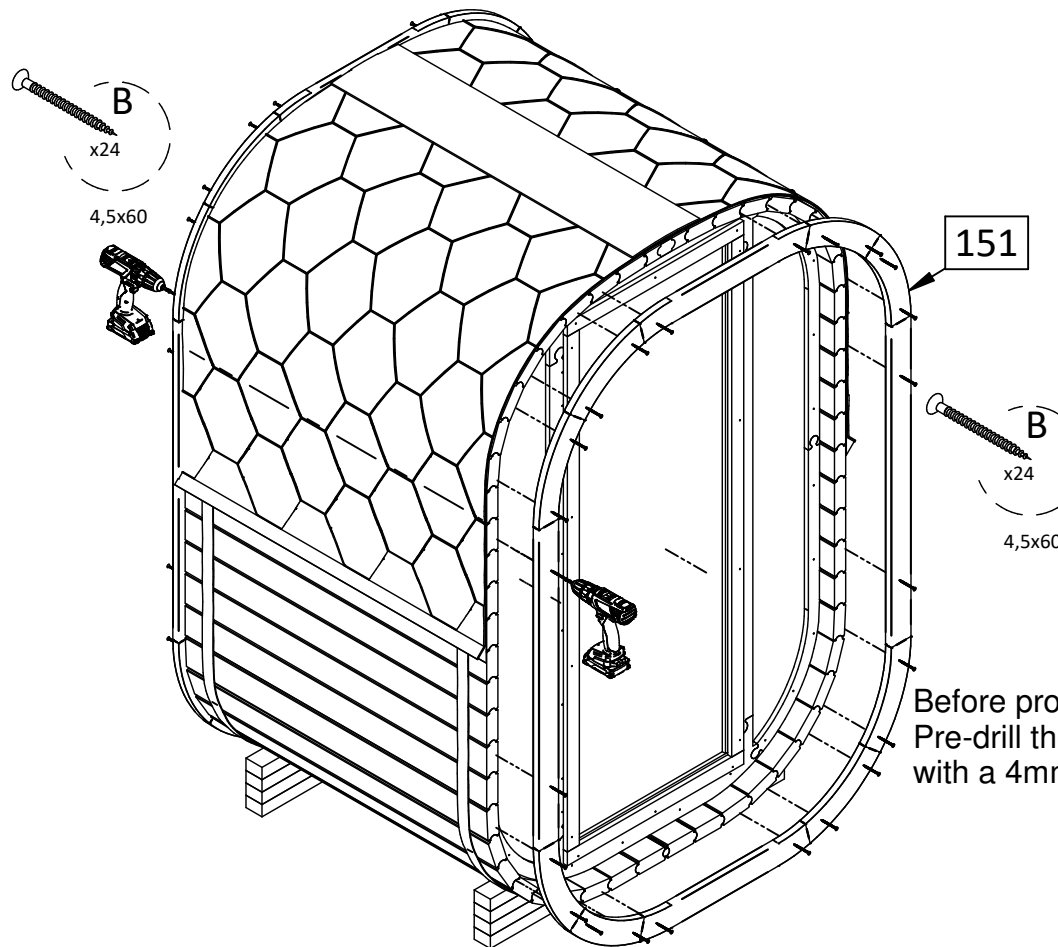


Please cut the shingles to size and use the other half on the other side.

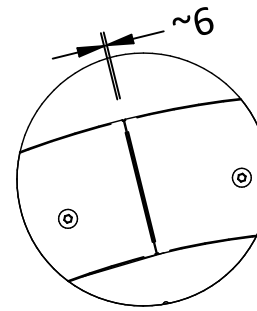


INSTALL THE FRONT AND BACK COVER ARCHES

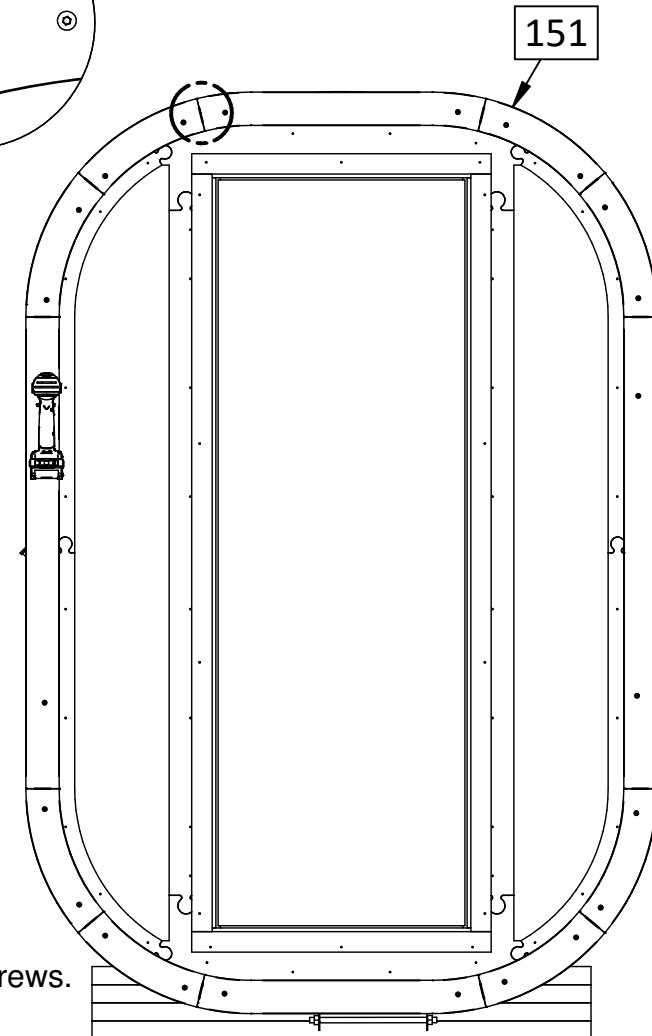
I - Install the the front and back cover arches, leave a gap of ~6mm between the ends.



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

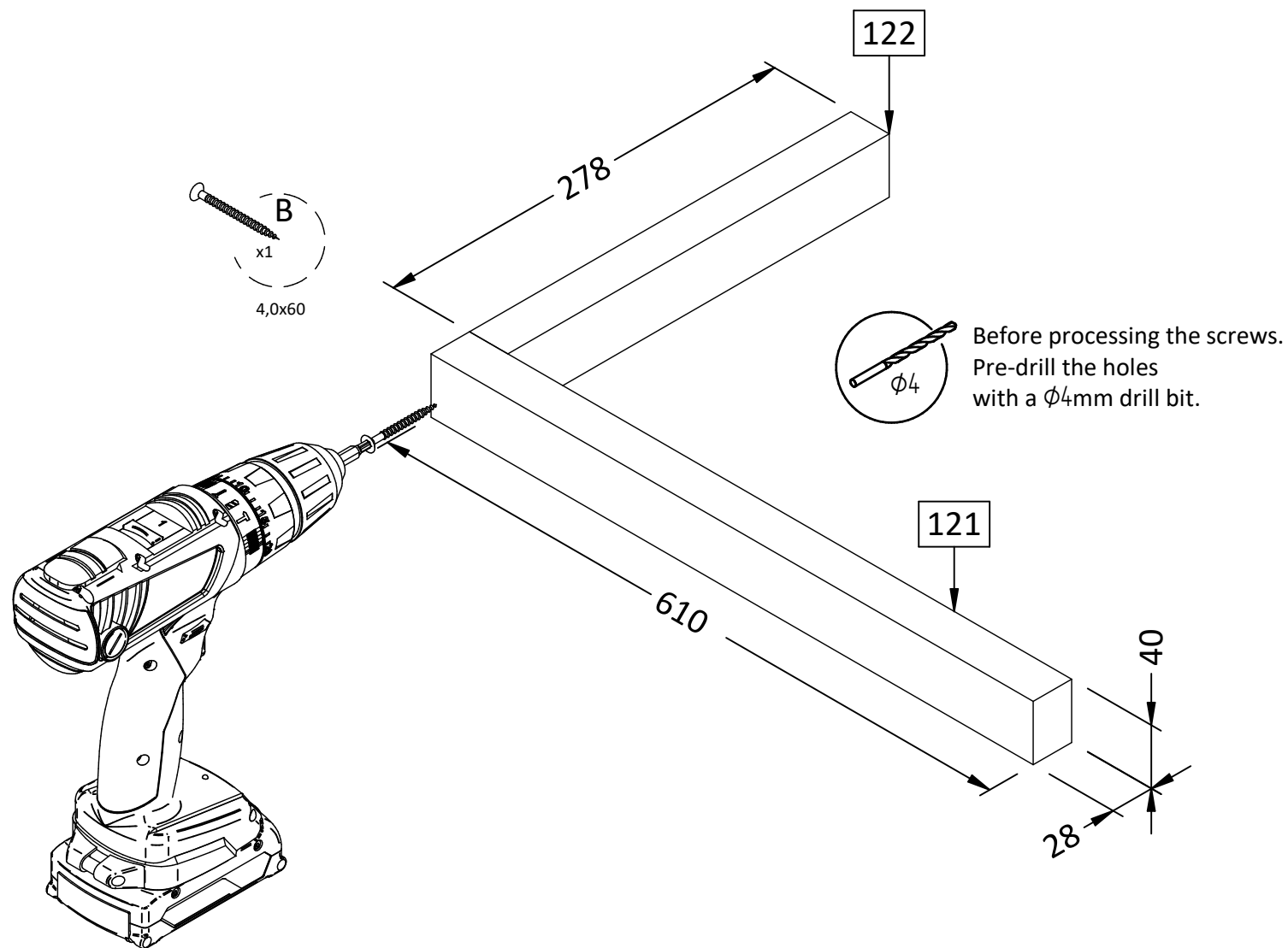


Attention! Leave a gap of 6 mm.



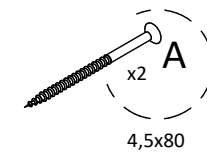
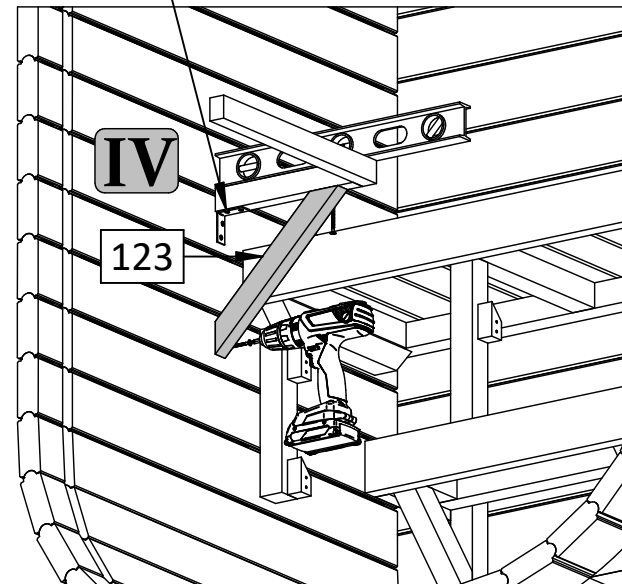
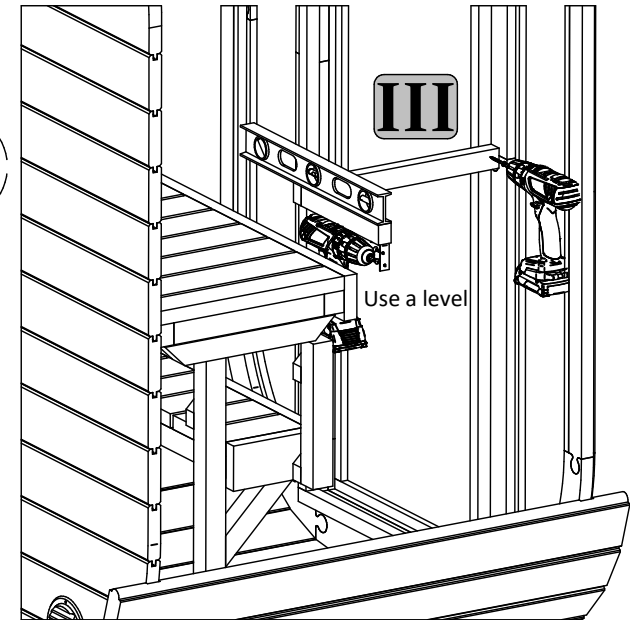
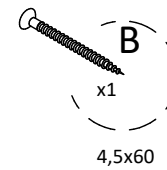
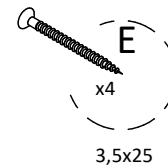
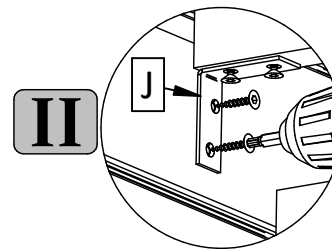
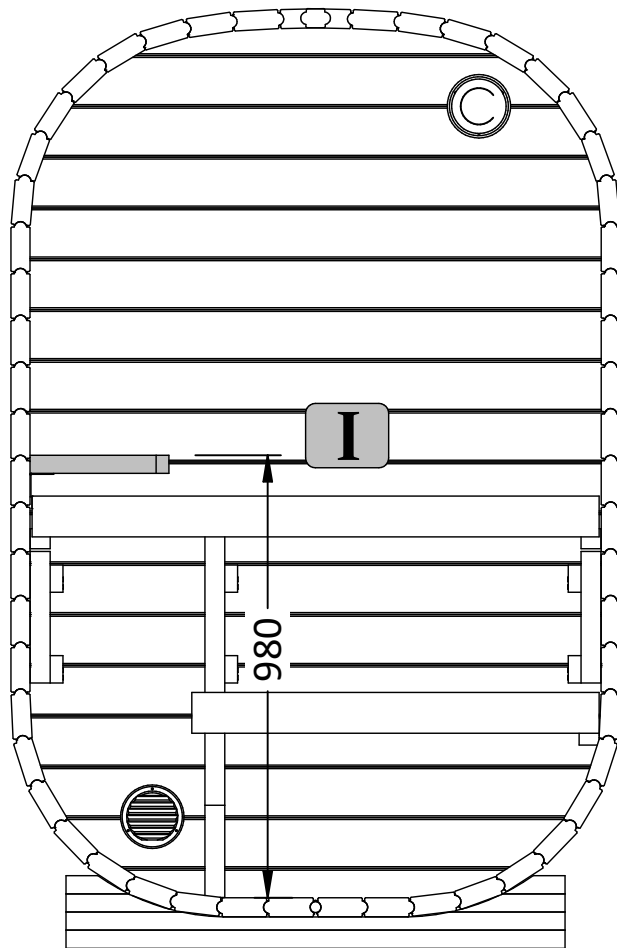
OPTIONAL - INSTALL THE HEATER GUARD

Screw the heater guard parts together.
Depending on your heater the guard may not be needed.



OPTIONAL - INSTALL THE HEATER GUARD

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



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

