



Installation Guide

Barrel N°54

The Wait Is Over.

Everything you need to build your very own Thermory Barrel Sauna is right there in front of you. If it looks like a lot, it is. If it seems too complicated to assemble, it isn't.

These instructions are specifically written to guide you through each step with ease. And if you need additional encouragement, you can scan the code on the back of this guide to see how it's done.

The Thermory Barrel Sauna No54 is designed for up to two people and is outfitted with a window. That's plenty of room for you and the friends helping you put this together. But if you want to enjoy the first steam all by yourself, we understand.



REAL WOOD
PRODUCTS



SUSTAINABLE



THERMALLY
MODIFIED
WOOD



DURABILITY



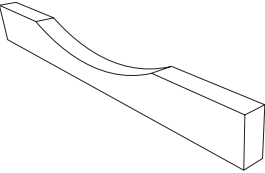
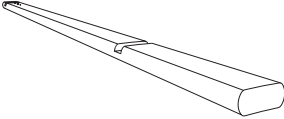
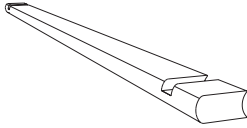
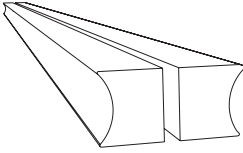
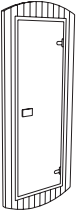
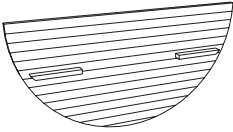
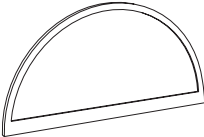
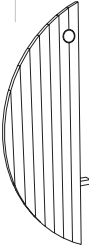
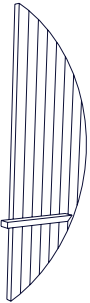
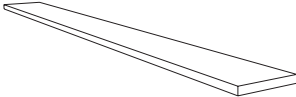
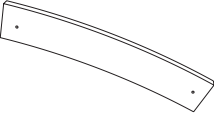
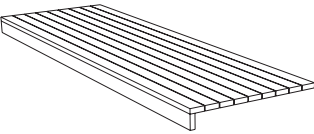
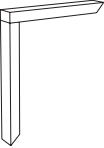
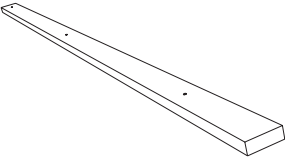
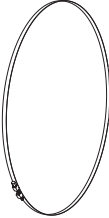
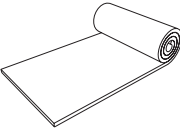
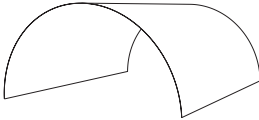
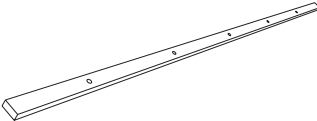
DIMENSIONAL
STABILITY



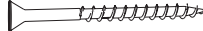
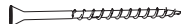
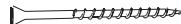
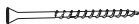
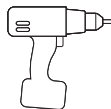
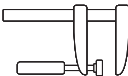
ECO-FRIENDLY
/ CHEMICAL-
FREE PROCESS



PARTS 1

CRADLES x2 	A	CENTER STAVE x1 	B	BODY STAVES x70 (+2 reserve) 	C	FINAL H-TYPE TOP STAVE x2 	H
FRONT PANEL x1 	F2	REAR PANEL x1 	V	REAR PANEL WITH WINDOW x1 	V1	LEFT PANEL SECTION x1 	F
RIGHT PANEL SECTION x1 	F1	ASPEN ROOF BOARD x1 	O	FLOORING DUCKBOARD x2 	L	DECORATIVE ROOF NISHING BOARDS x10 	W
INTERIOR BENCHES x2 	J	BENCH SUPPORTING LEGS x2 	J1	BACKREST STAVES x6 	J2	METAL BANDS x2 	I
ADHESIVE ROOF TAPE x1 	R	WATERPROOF ROOF COVER x1 	Z	WOODEN SLAT FOR ROOF COVER x2 	Z1		

PARTS 2

SCREW 5.0X120	x10	M	SCREW 4.2X70	x130	N	STAINLESS STEEL SCREW 4.2X70	x18	N1	SCREW 4.0X50	x65	P
											
STAINLESS STEEL SCREW 4.0X50	x25	P1	Ø BOLT 16X140	x2		HEX NUT M16 (SW24)	x2		FLAT WASHER	x4	U
						+					
						+					
TOOLS REQUIRED:	x2		x2		Rubber	x3			x2		
						x2		24mm	x2		
									x3		
						3 People Recommended			6'		
											
									x2		

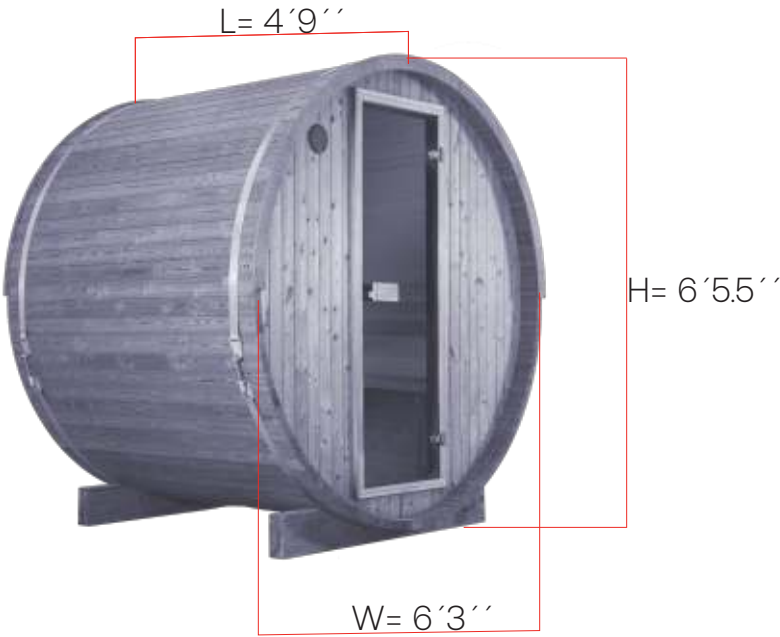
STEP ZERO

Before you begin, be sure the sauna will fit in your chosen location.

Approximately L x W x H of 6' x 7' x 7' is ideal. Overall dimensions are shown here.

Be sure the site is level and free of standing water after rainfall.

Concrete, pavers or crushed stone is preferred.

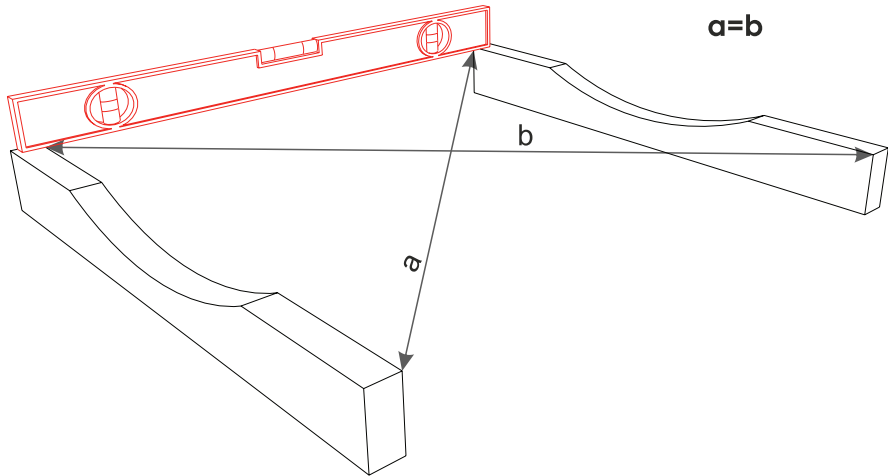


STEP ONE

Measure support cradles (A) diagonally from corner to corner.

Measurements “a” and “b” should be equal to ensure the cradles are square.

Be sure cradles remain level.

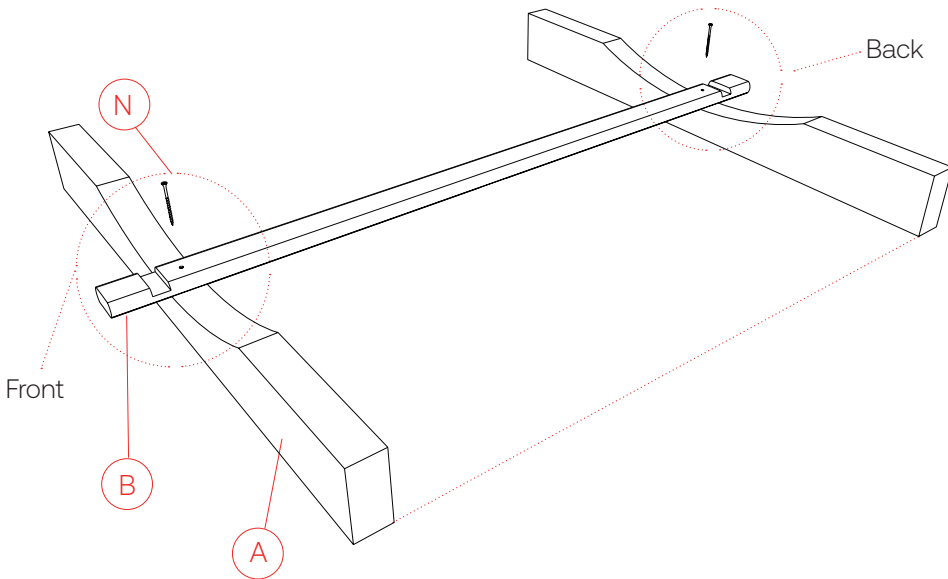


STEP TWO

Place the support cradles (A) on level site. Carefully level for better stability.

Place the center stave (B) on wooden dowels embedded in outer support cradles (A).

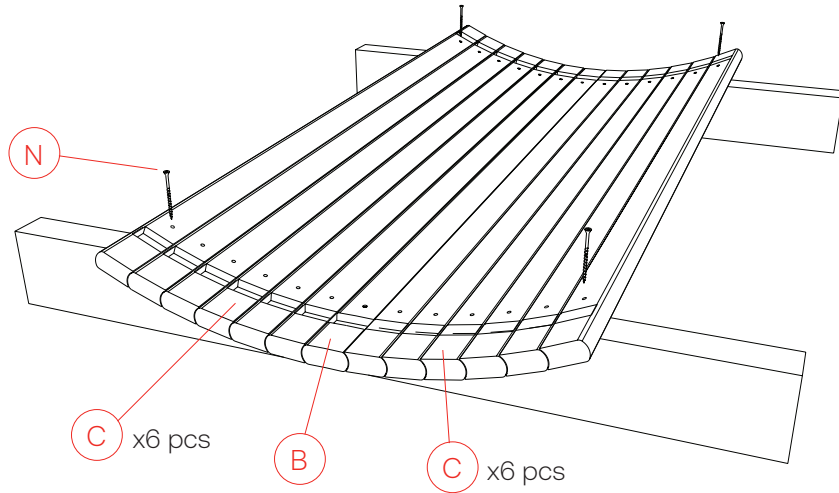
Fix center stave (B) to cradles with screws 4.2 x 70 (N).



STEP THREE

Place 6 sauna body staves (C) to each side of the center stave (B) and fix with screws 4.2 x 70 (N).

Be sure to align the panel groove on every next body stave.

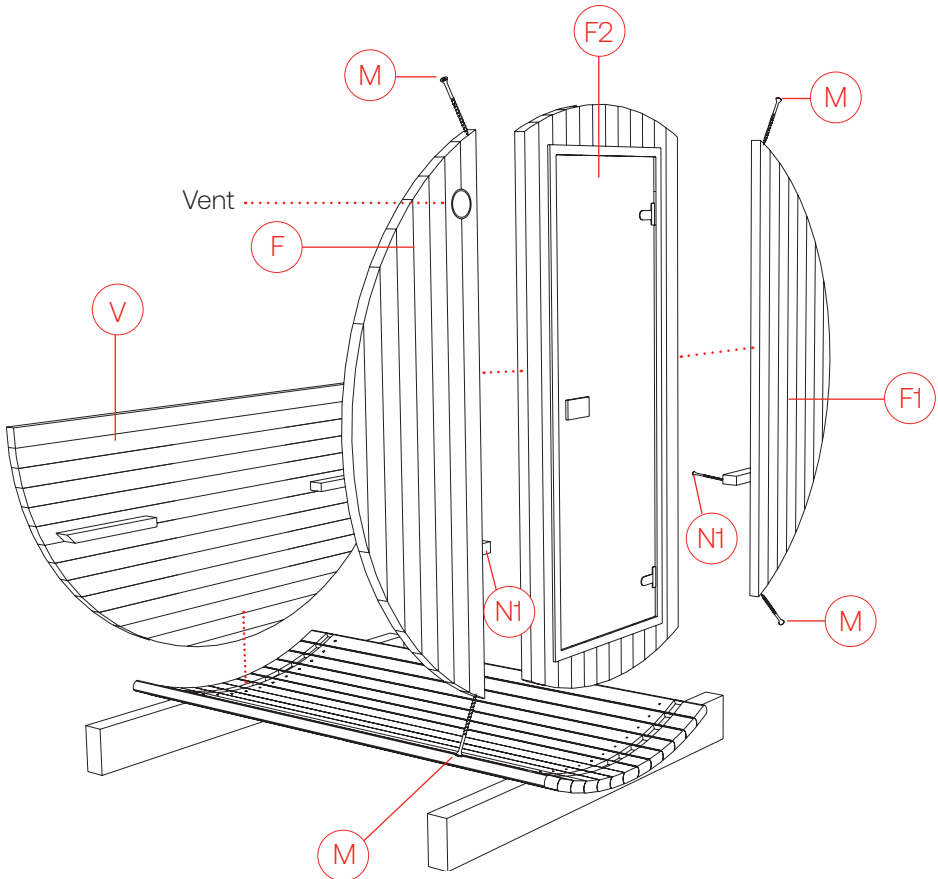


STEP FOUR

Place door panel (F2) in front slot. Be sure panel is centered, leveled, completely seated. Attach side panels (F, F1) using 4 5.0 x 120 (M) screws and 2 4.2 x 70 (N1) stainless steel screws.

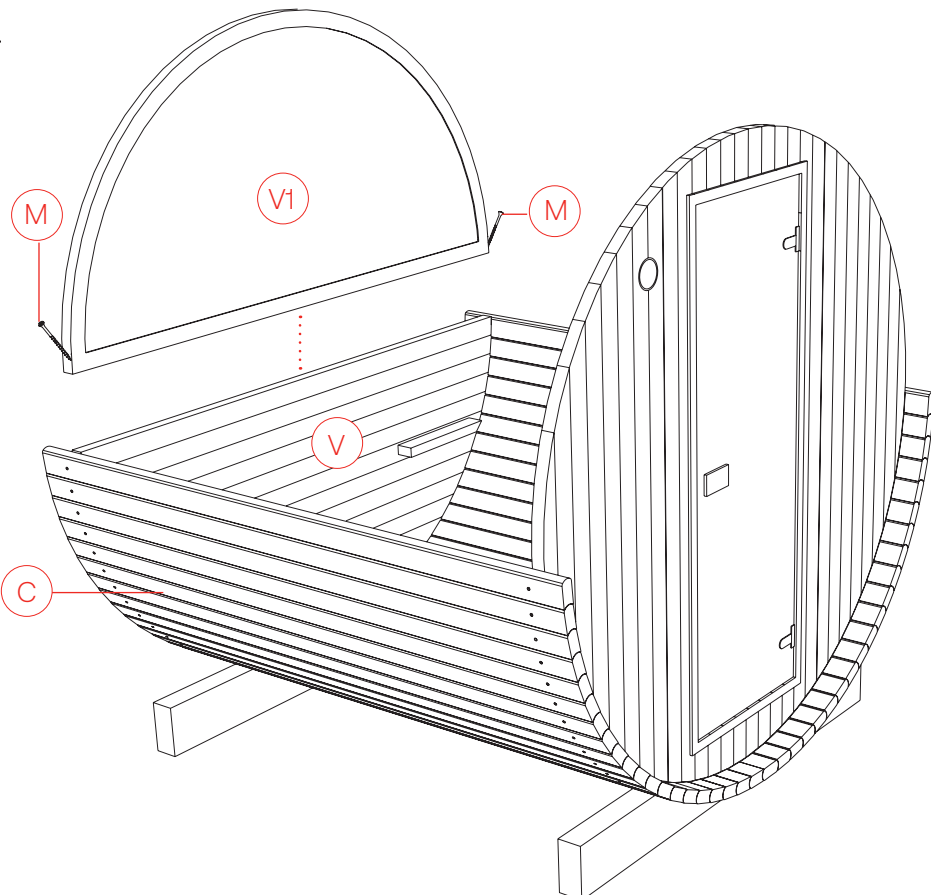
Place rear panel (V) with bench supports facing interior.

Confirm width of rear panel (V) matches combined width of left panel section (F), front panel (F2) and right panel section (F1). These panels must be completely seated into the floor panel.



STEP FIVE

Place body staves (C) until the halfway point. Place rear panel with window (V1) on rear panel (V), fix by 2 screws 5.0 x 120 (M).

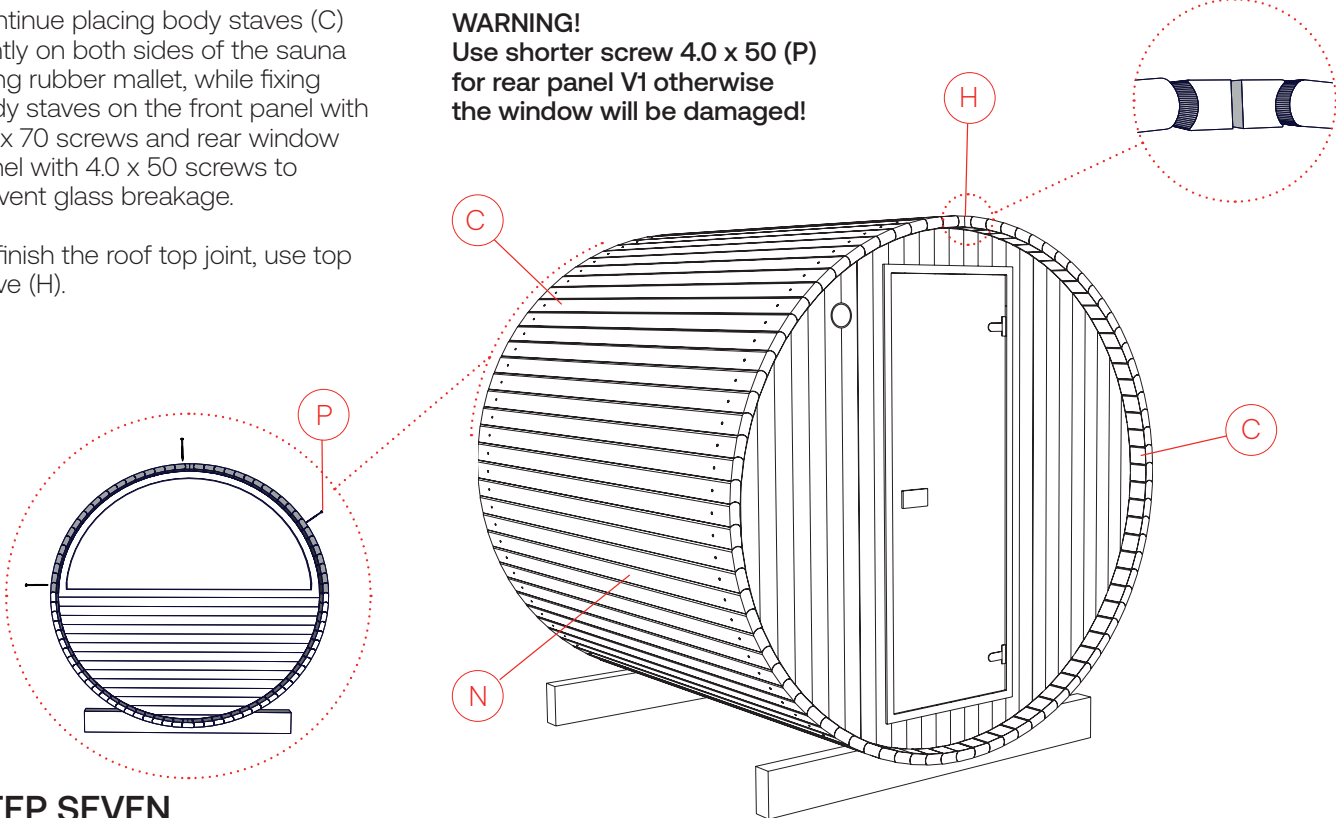


STEP SIX

Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, while fixing body staves on the front panel with 4.2 x 70 screws and rear window panel with 4.0 x 50 screws to prevent glass breakage.

To finish the roof top joint, use top stave (H).

WARNING!
Use shorter screw 4.0 x 50 (P) for rear panel V1 otherwise the window will be damaged!



STEP SEVEN

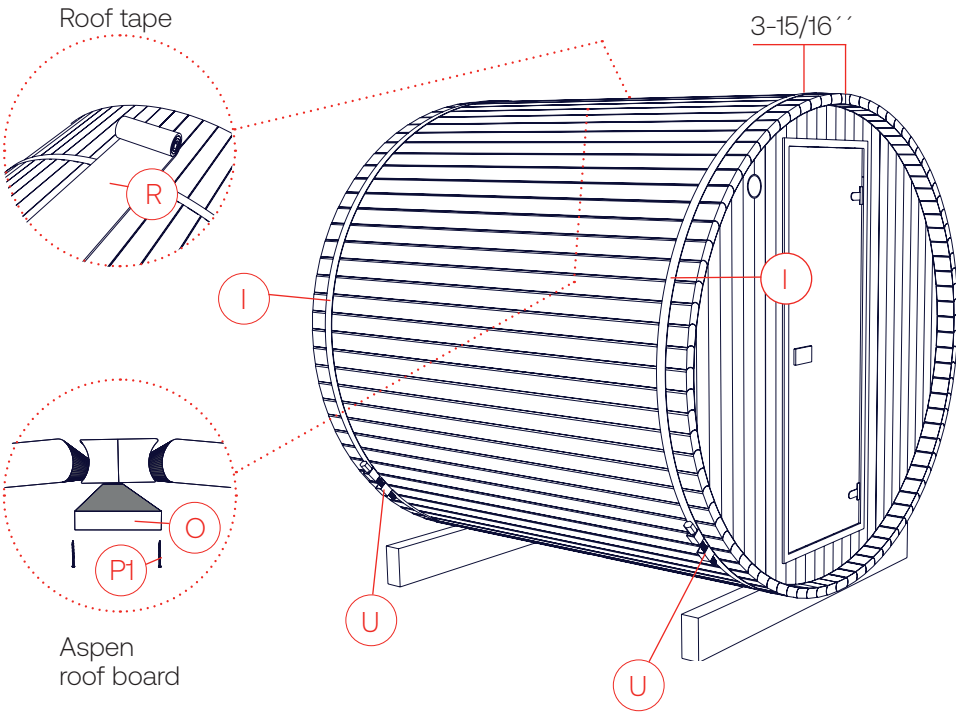
Install steel bands (I) by wrapping bands around barrel prior to connecting with bolts and nuts (U).

Place steel bands evenly around barrel, covering screw heads.

Measure from steel band to barrel edge to ensure the steel band is even.

Cover roof with roof tape. Rub and smooth with pressure to ensure adhesion.

Install interior aspen roof trim (O) with 4.0 x 50 (P1) stainless steel screws.

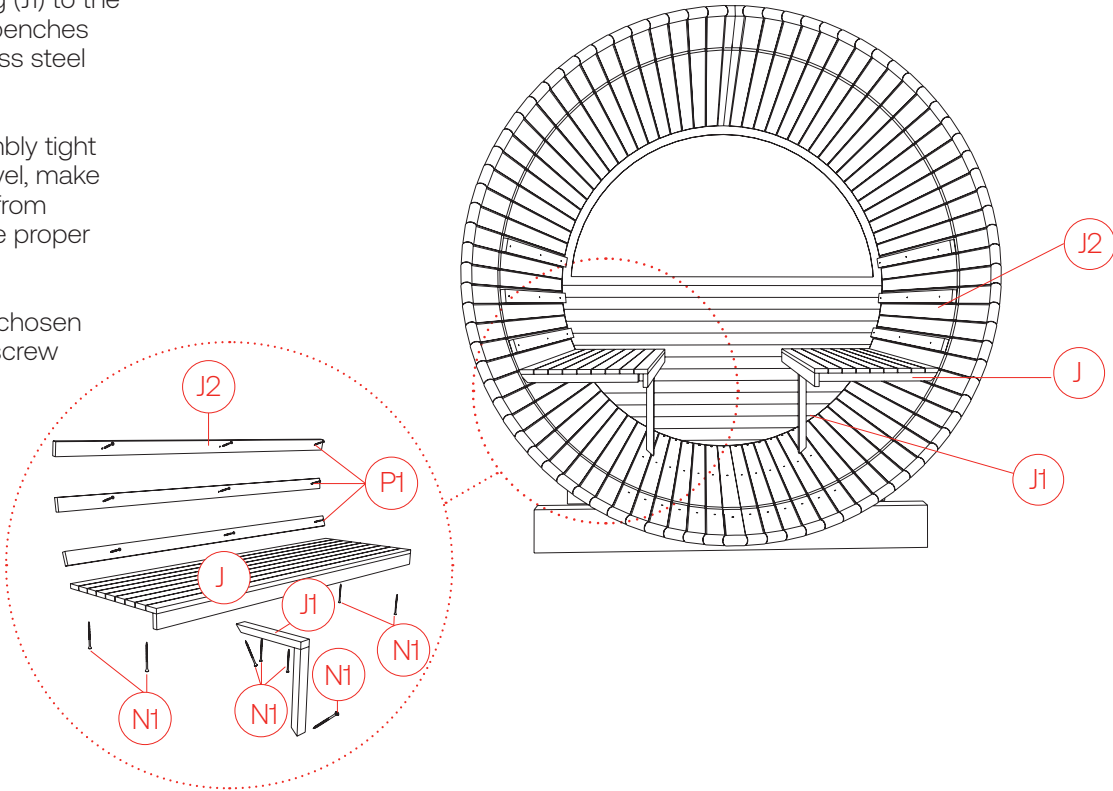


STEP EIGHT

Attach interior supporting leg (J1) to the bench (J), install two sauna benches on wall mounts using stainless steel screws 4.2 x 70 (N1).

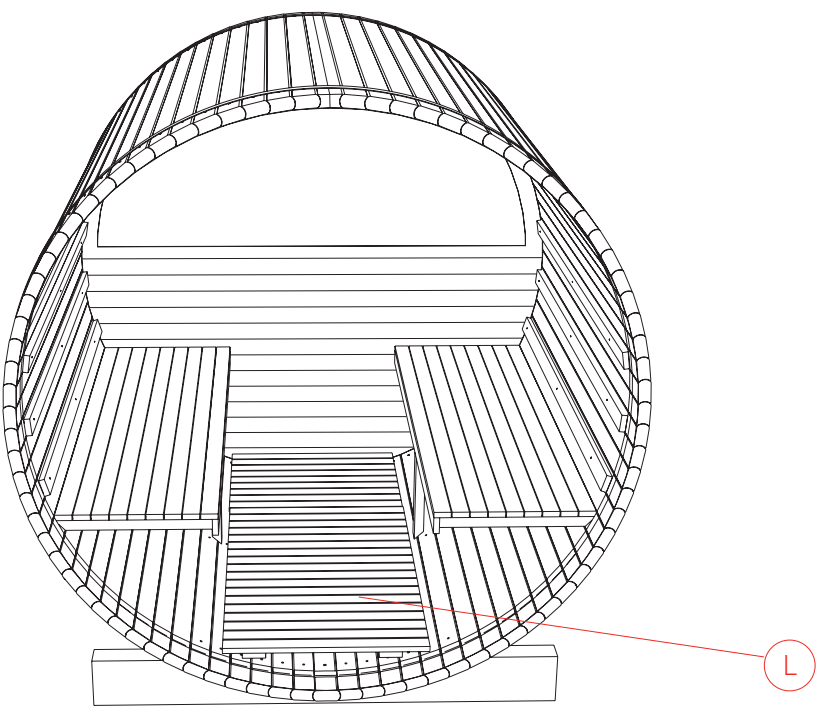
Hold the seat and leg assembly tight to the sauna wall. Using a level, make sure the bench seat is level from front to back. This will ensure proper placement.

Install backrests (J2) at your chosen height using stainless steel screw 4.0 x 50 (P1).



STEP NINE

Flooring duckboards (L) can be used for wiring runs, confirm specific wiring runs needed for chosen stove.

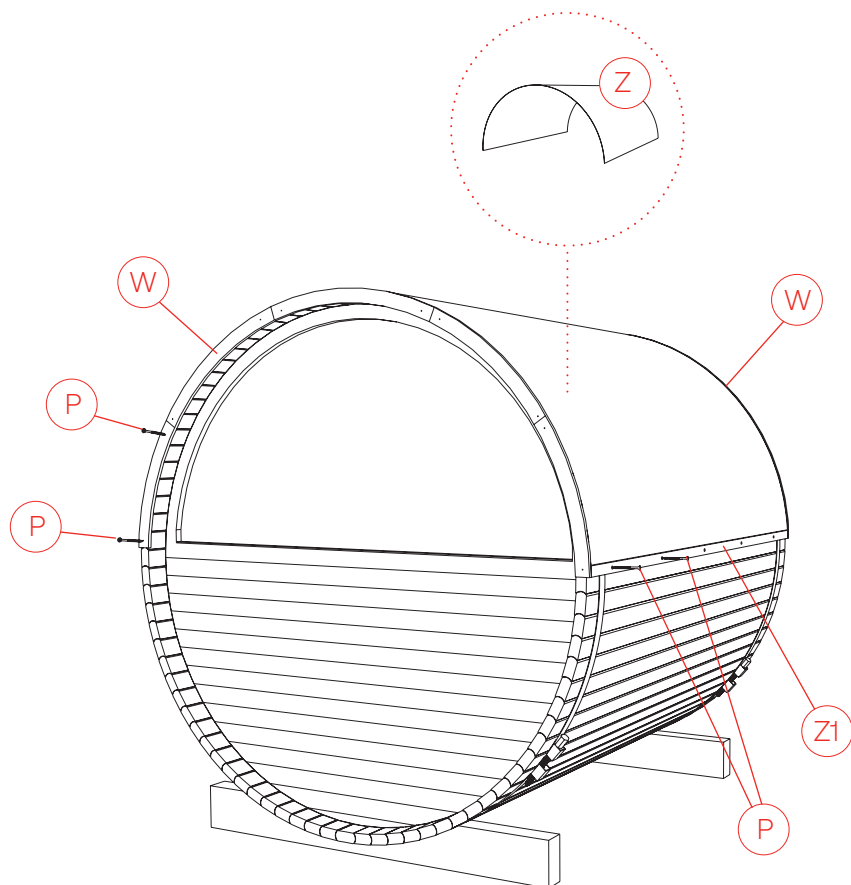


STEP TEN

Place waterproof roof cover (Z) and fix it with wooden slat (Z1) and screws 4.0 x 50 (P).

Install front and rear decorative roof finishing boards (W), fixing by screws 4.0 x 50 (P).

WATCH THE VIDEO



SEE HOW ASSEMBLY
WILL LOOK [HERE](#).



Thermory USA - Denver

537 W. Highlands Ranch Pkwy, Ste. 114
Highlands Ranch, CO 80129
720.759.7268
support@thermoryusa.com

Thermory USA - Buffalo

56 Harvester Ave, Ste. 1-201
Batavia, NY 14020
585.591.6590
support@thermoryusa.com

