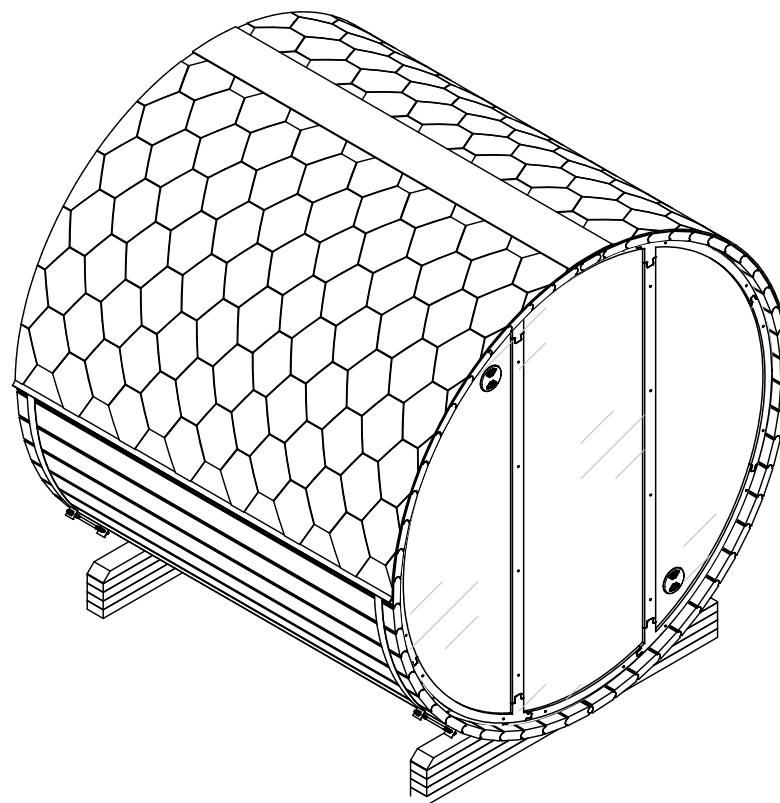
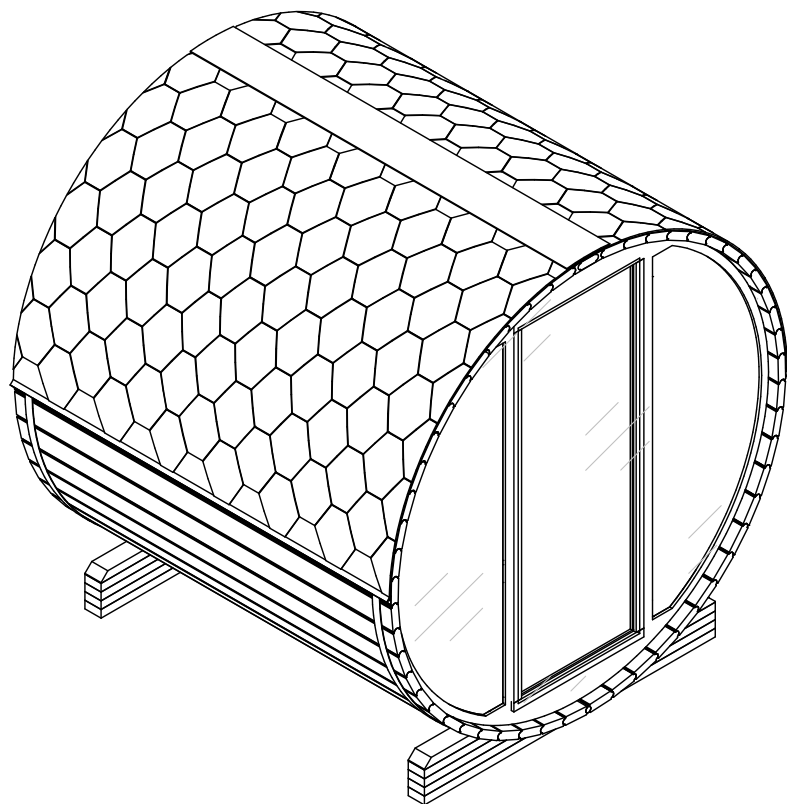


SAUNA 220 D4

FULL GLASS FRONT - FULL GLASS BACK

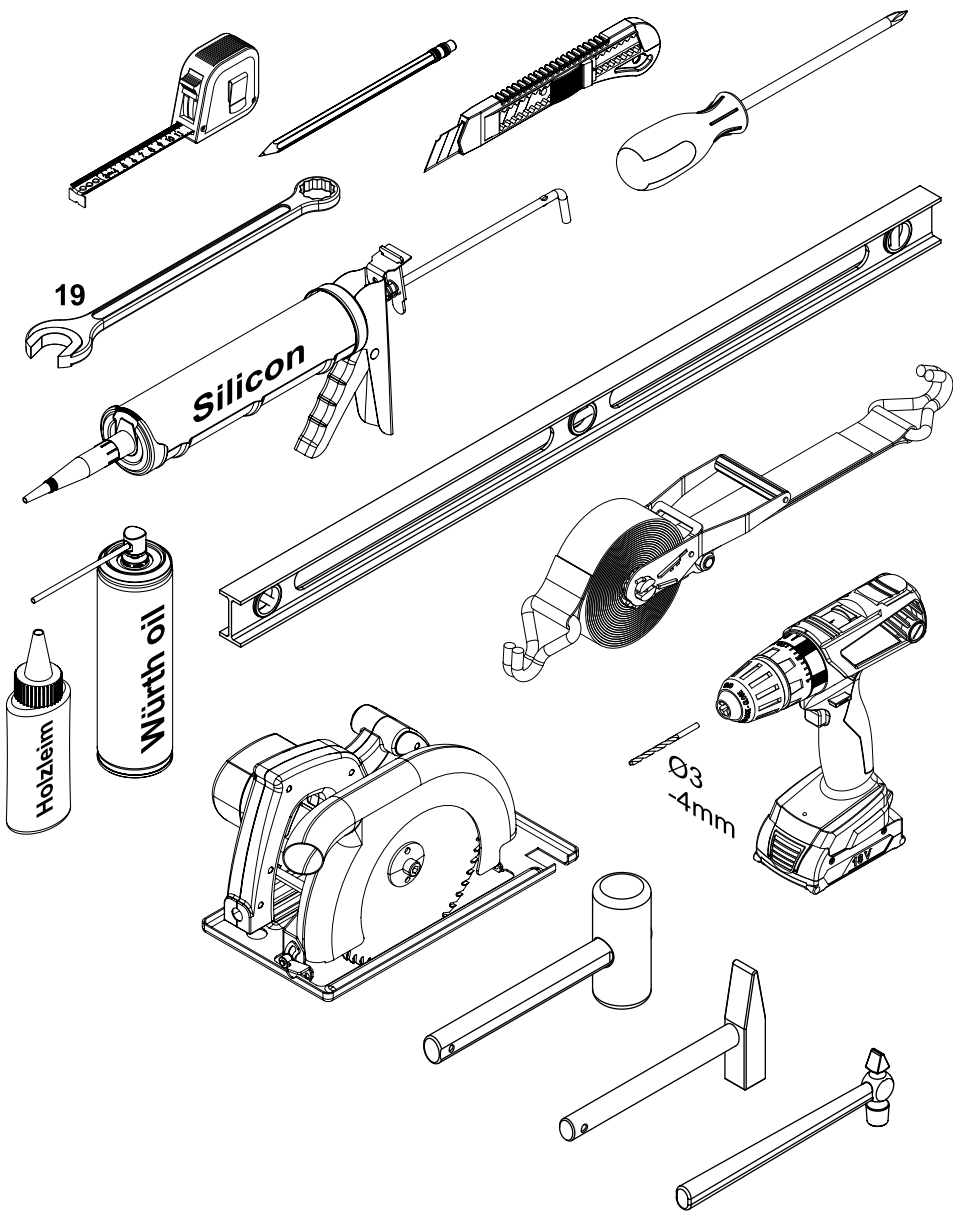


****Before you start assembling the sauna, please make sure all the pieces is there****

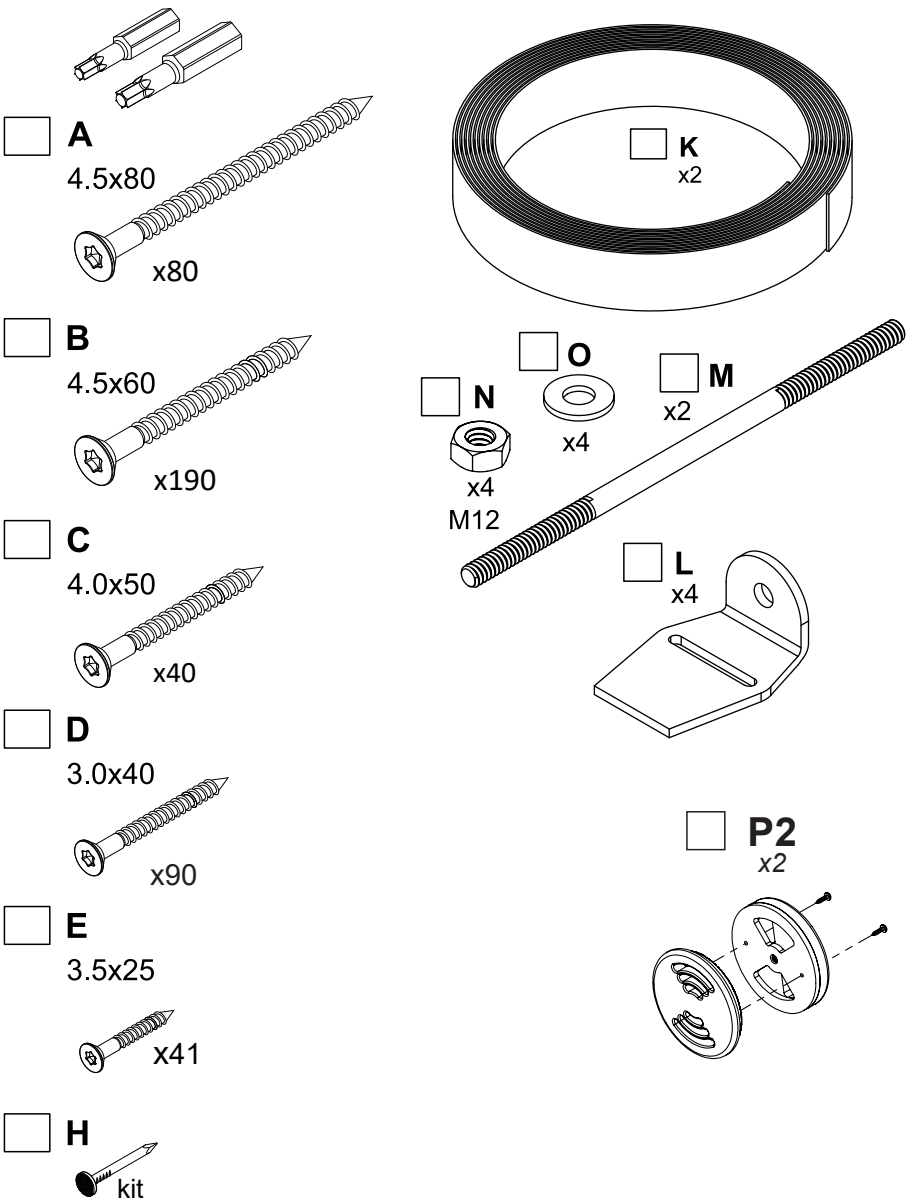
- A sauna barrel can never be 100% tight due to the construction.
- All measurements in mm (millimeter).
- Read the entire manual

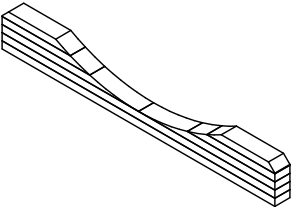
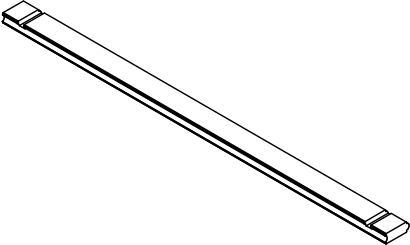
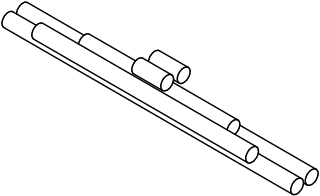
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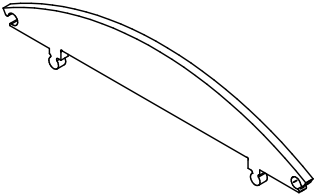
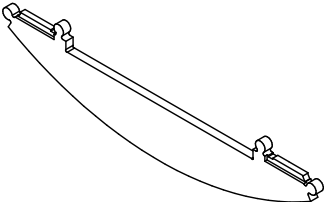
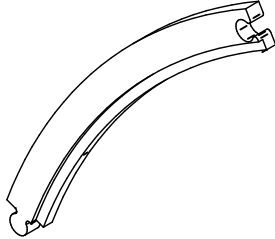
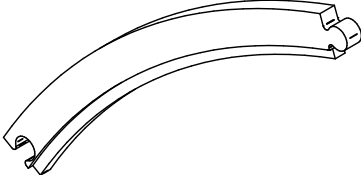
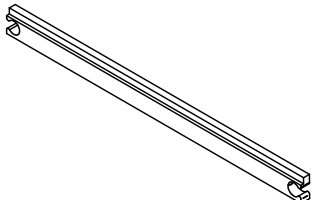
Tools that make your construction easier. Not included in the delivery.

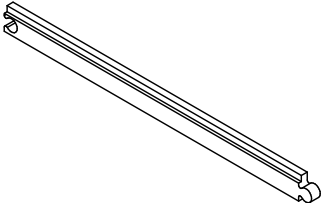
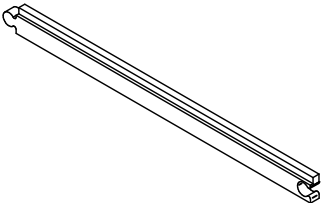
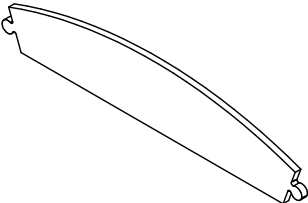
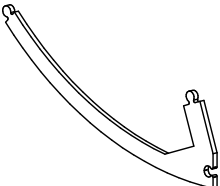
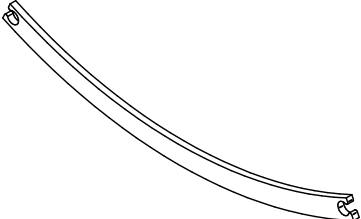


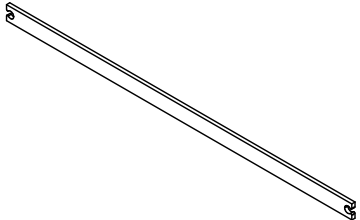
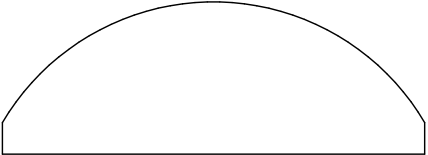
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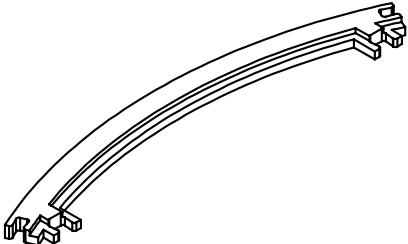
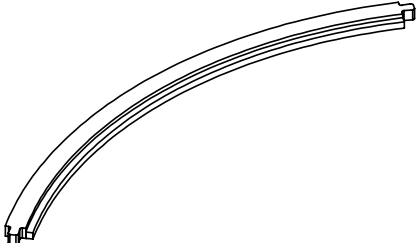


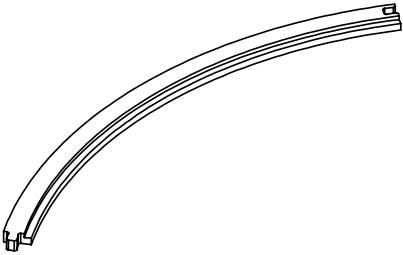
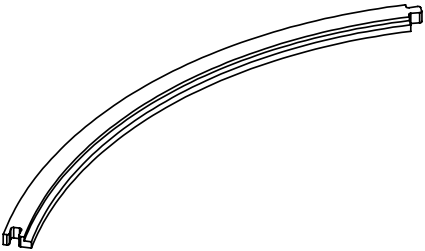
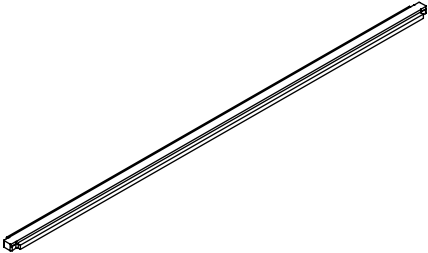
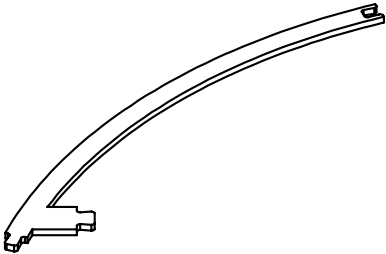
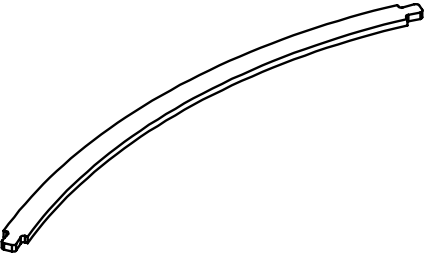
BASE AND FRAME			
No.	L x W x H	Qt	
1	1700x220x94	2	
2	2200x42x103	69 (+1)	
21	D24	kit	

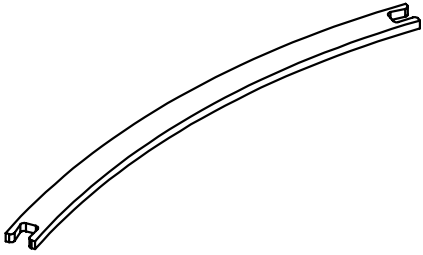
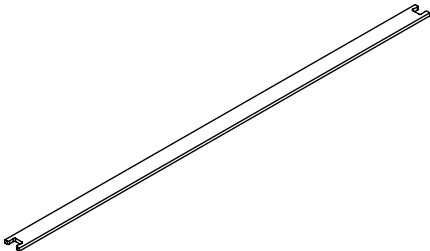
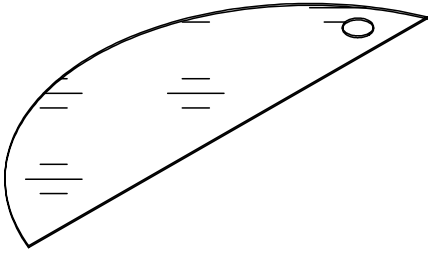
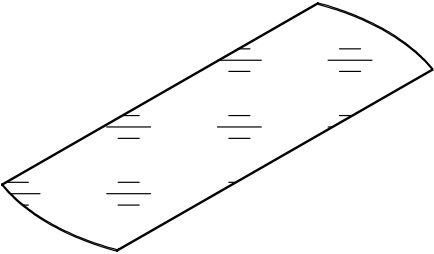
GLASS FRONT WALL BASE			
No.	L x W x H	Qt	
6	PLYWOOD 27mm	1	
7	PLYWOOD 27mm	1	
8	PLYWOOD 27mm	3	
9	PLYWOOD 27mm	3	
10	PLYWOOD 27mm	2	

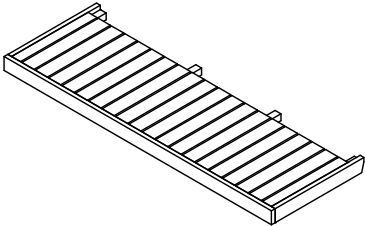
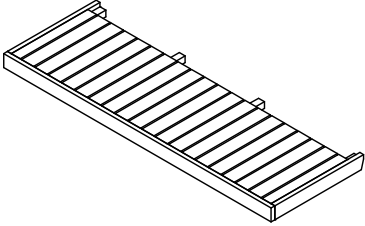
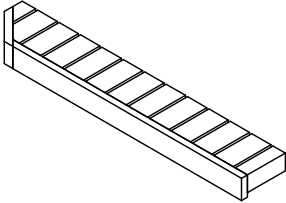
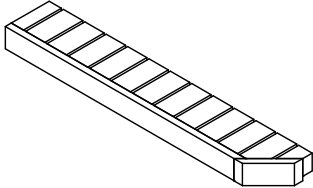
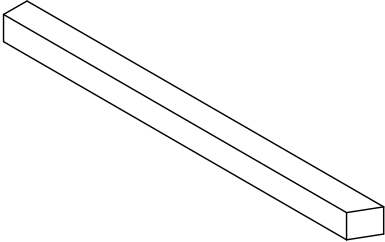
GLASS FRONT WALL BASE			
No.	L x W x H	Qt	
11	PLYWOOD 27mm	1	
11.1	PLYWOOD 27mm	1	
12	PLYWOOD 12mm	2	
13	PLYWOOD 12mm	4	
14	PLYWOOD 12mm	2	

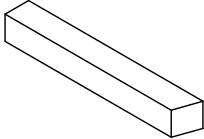
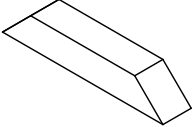
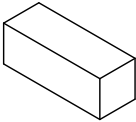
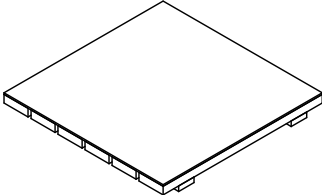
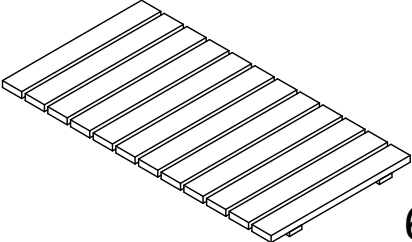
FRONT WALL GLASS FRAME			
No.	L x W x H	Qt	
15	PLYWOOD 12mm	2	
G1	GLASS 1861x671x8	2	

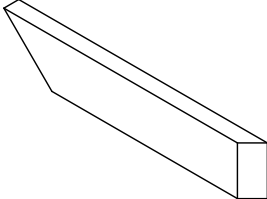
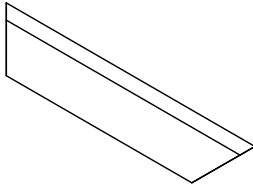
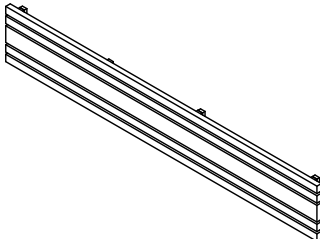
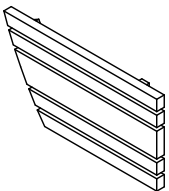
GLASS REAR WALL			
No.	L x W x H	Qt	
7a	PLYWOOD 27MM	2	
7b	PLYWOOD 27MM	2	

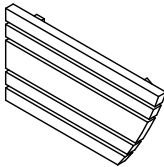
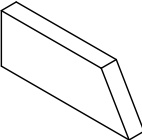
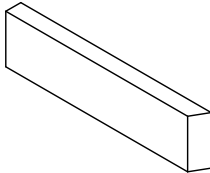
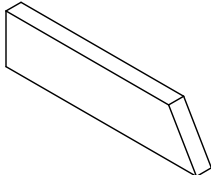
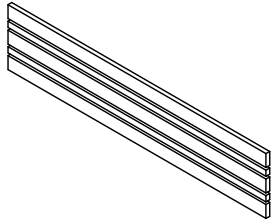
GLASS REAR WALL			
No.	L x W x H	Qt	
7c	PLYWOOD 27MM	1	
7d	PLYWOOD 27MM	1	
7e	PLYWOOD 27MM	2	
7f	PLYWOOD 12MM	4	
7g	PLYWOOD 12MM	2	

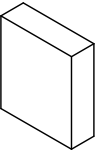
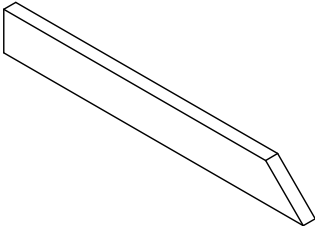
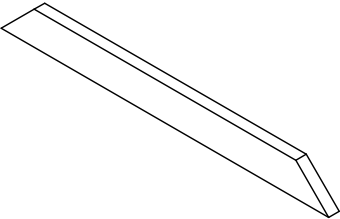
GLASS REAR WALL			
No.	L x W x H	Qt	
7h	PLYWOOD 12MM	2	
7i	PLYWOOD 12MM	2	
G2	2000x671x8	2	
G3	2162x740x8	1	

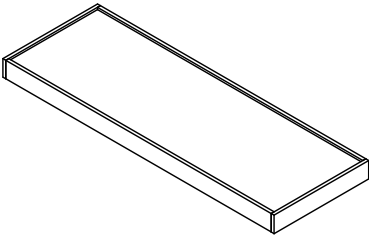
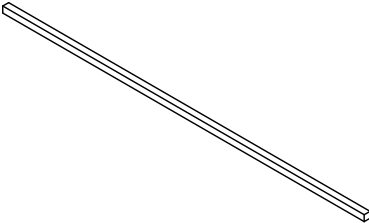
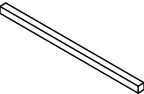
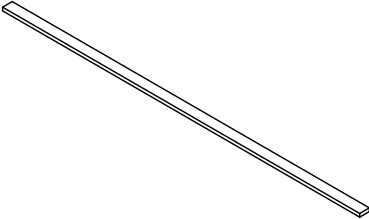
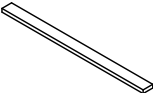
BENCHES AND SUPPORT LEGS			
No.	L x W x H	Qt	
24L	2000x692x90	1	
24R	2000x692x90	1	
26L	1258x205	1	
26R	1258x205	1	
25	667x44x44	6	

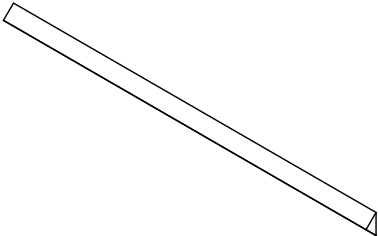
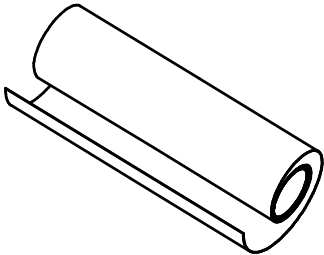
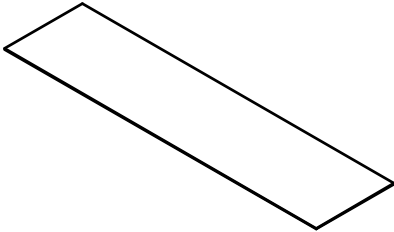
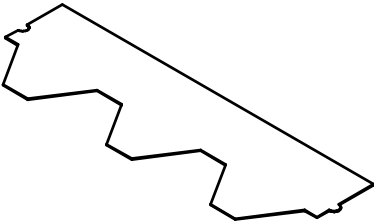
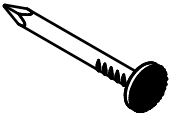
SUPPORT LEGS AND FLOOR GRIDS			
No.	L x W x H	Qt	
26.1	326x44x44	2	
26.2	250x44x44	2	
23	120x44x44	8	
32	595x700	1	
32A	1362x650	1	

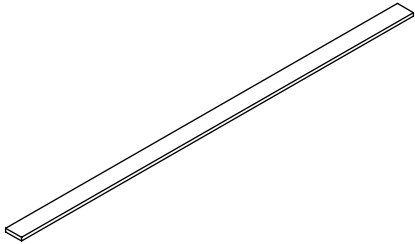
SKIRTS AND COVER BOARDS			
No.	L x W x H	Qt	
25.1	60x28x28	12	
27L	465x90x28	1	
27R	465x90x28	1	
29	1940x298	2	
29L	572x298	2	

COVER BOARDS AND BACK REST			
No.	L x W x H	Qt	
29R	572x298	2	
30	239x90x28	2	
30.1	356x90x28	2	
30.2	356x90x28	2	
36	1930x420	2	

HEATER GUARD			
No.	L x W x H	Qt	
33	100x90x28	4	
34	700x90x28	2	
35	875x90x28	1	

DOOR AND TRIMS			
No.	L x W x H	Qt	
37	1890x690	1	
38	1890x28x28	2	
39	746x28x28	2	
40	1870x45x15	2	
41	760x45x15	2	
8.			

ROOFING			
No.	L x W x H	Qt	
44	2200x44x44	2	
45A	7100x1500	1	
45	1000x250	3	
46	1000x320	76	
H	NAILS	KIT	

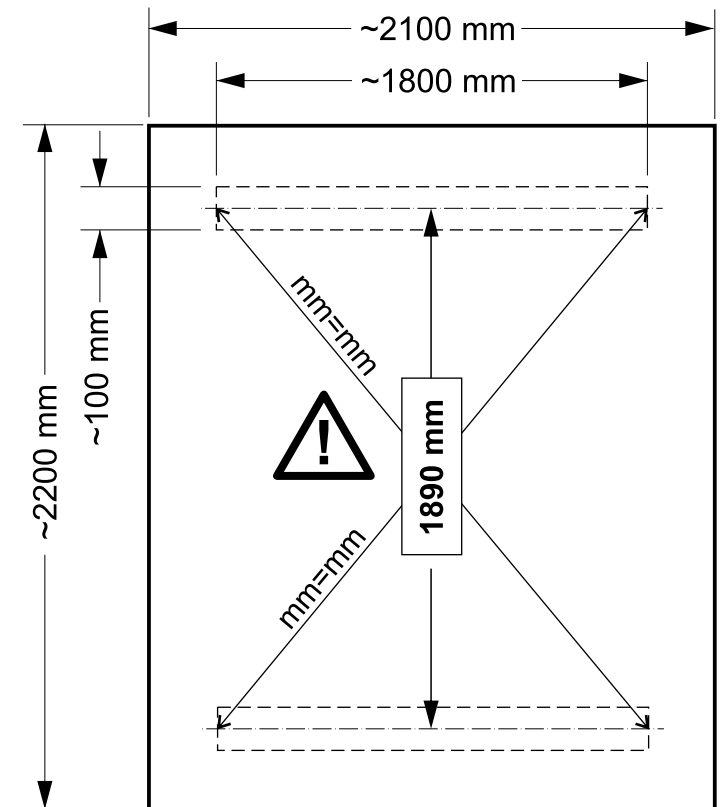
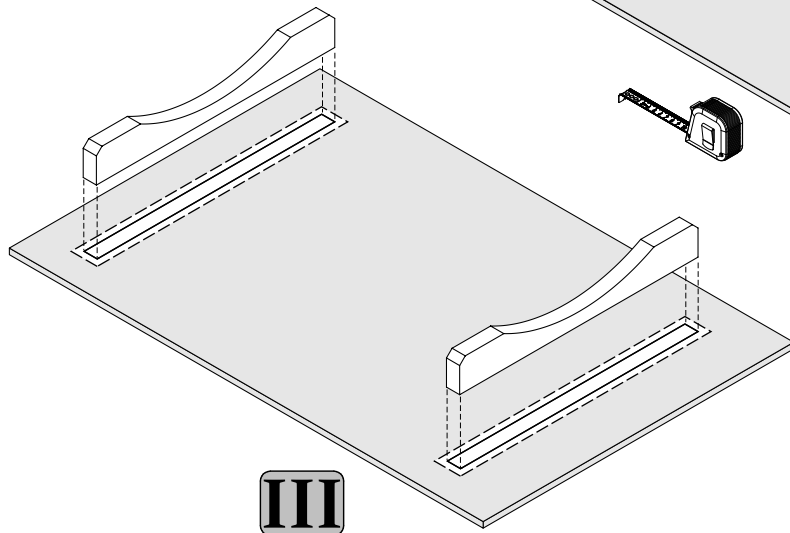
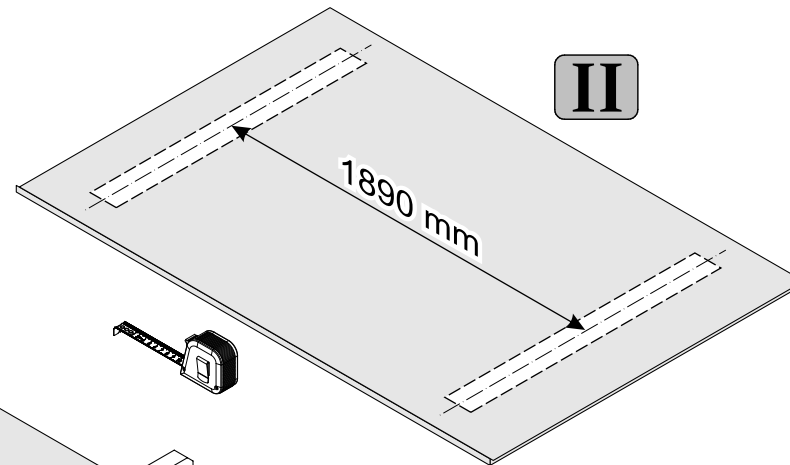
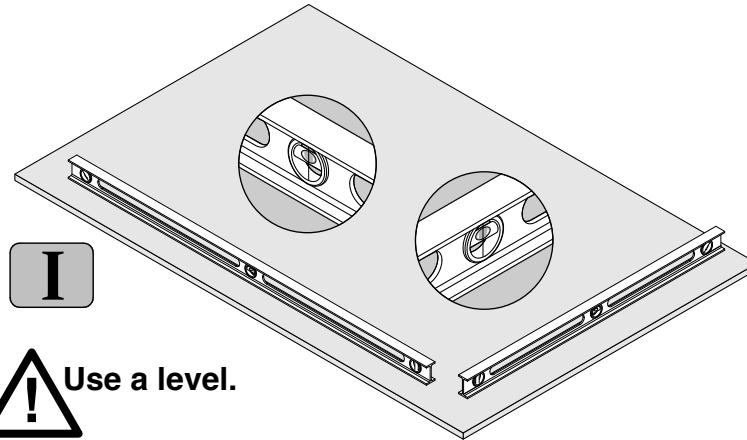
EXTRA PARTS FOR WALL ASSEMBLING (profile may vary)			
No.	LENGTH	Qt	
E2	2210mm	2	

FOUNDATION PLAN

I - Make sure the foundation is leveled

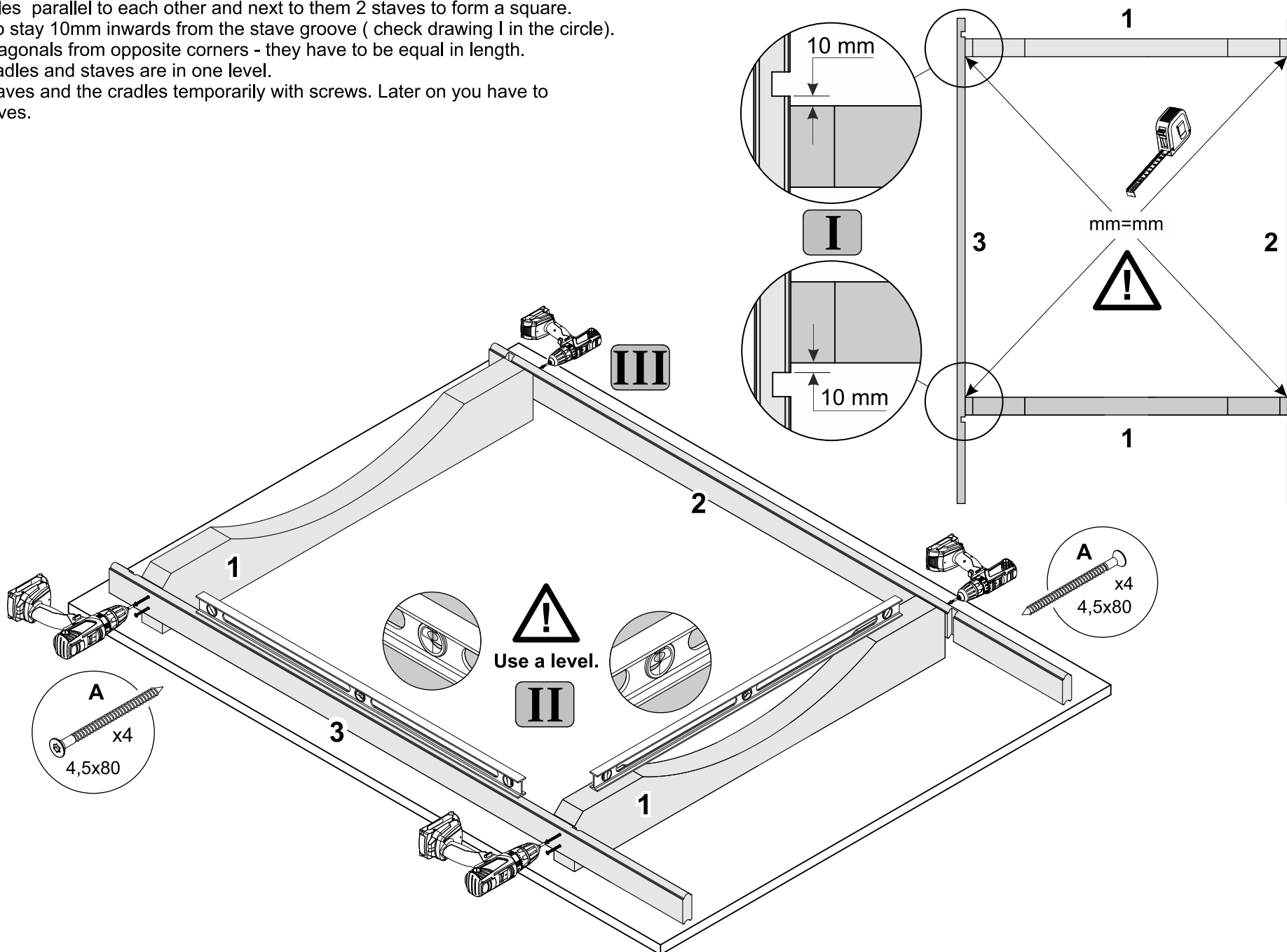
II - Mark down the cradles position

III - Position the cradles



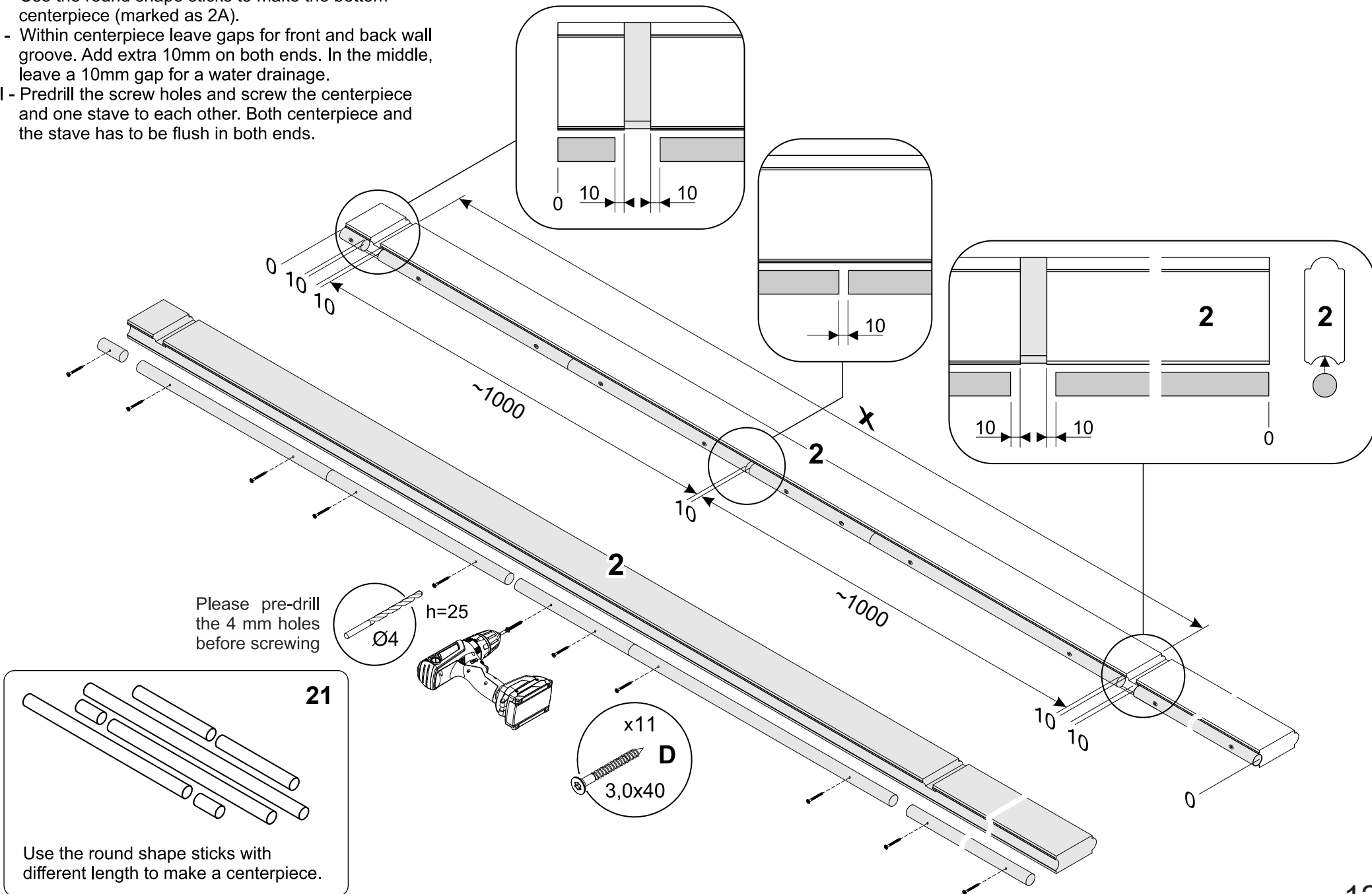
CRADLES SETUP

- 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).
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.



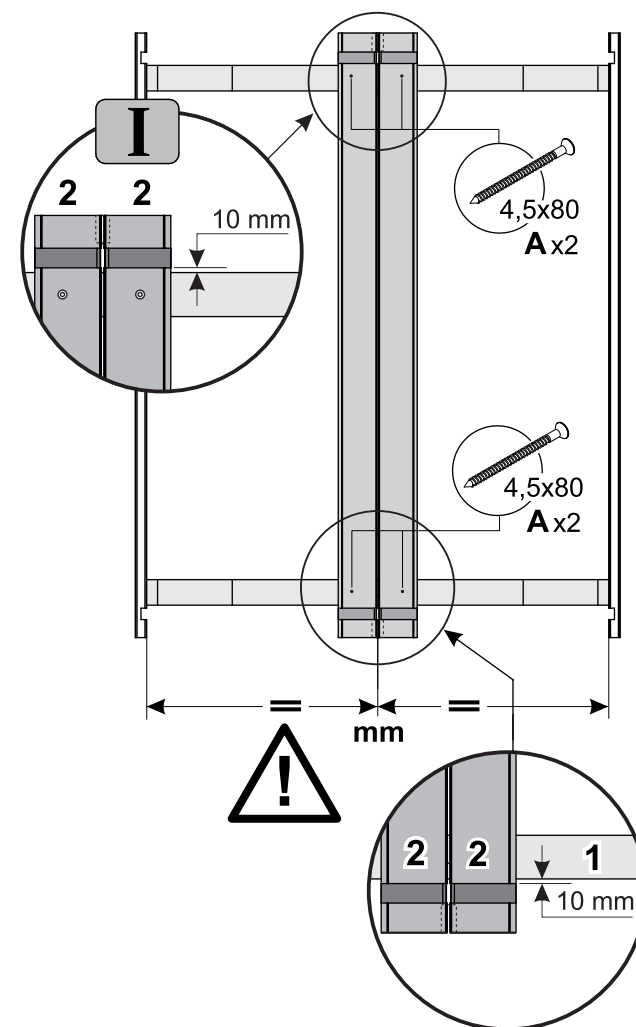
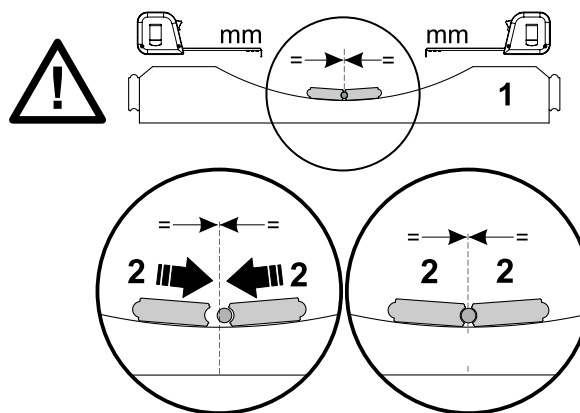
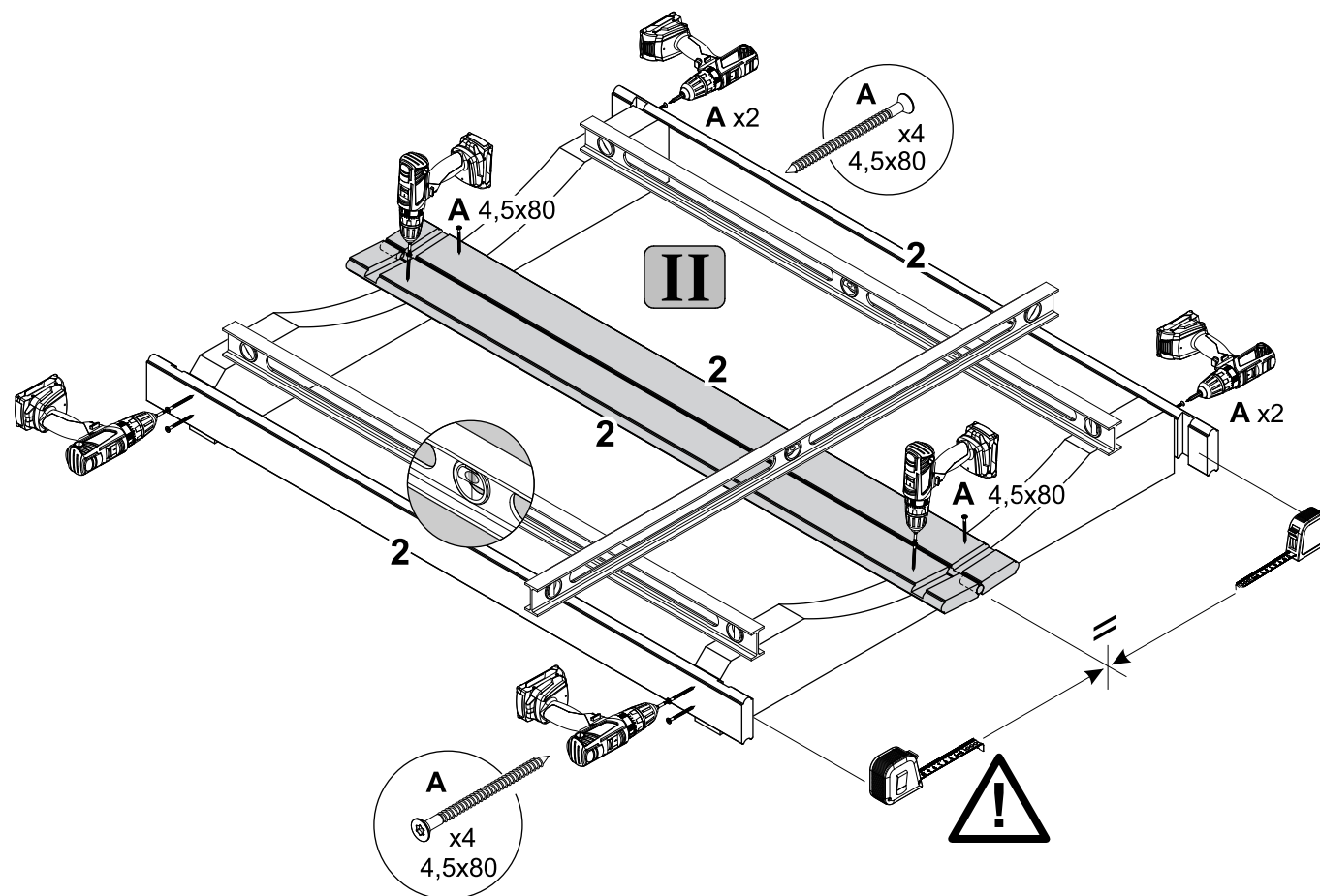
POSITIONING THE CENTERPIECE

- I - Use the round shape sticks to make the bottom centerpiece (marked as 2A).
- 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.



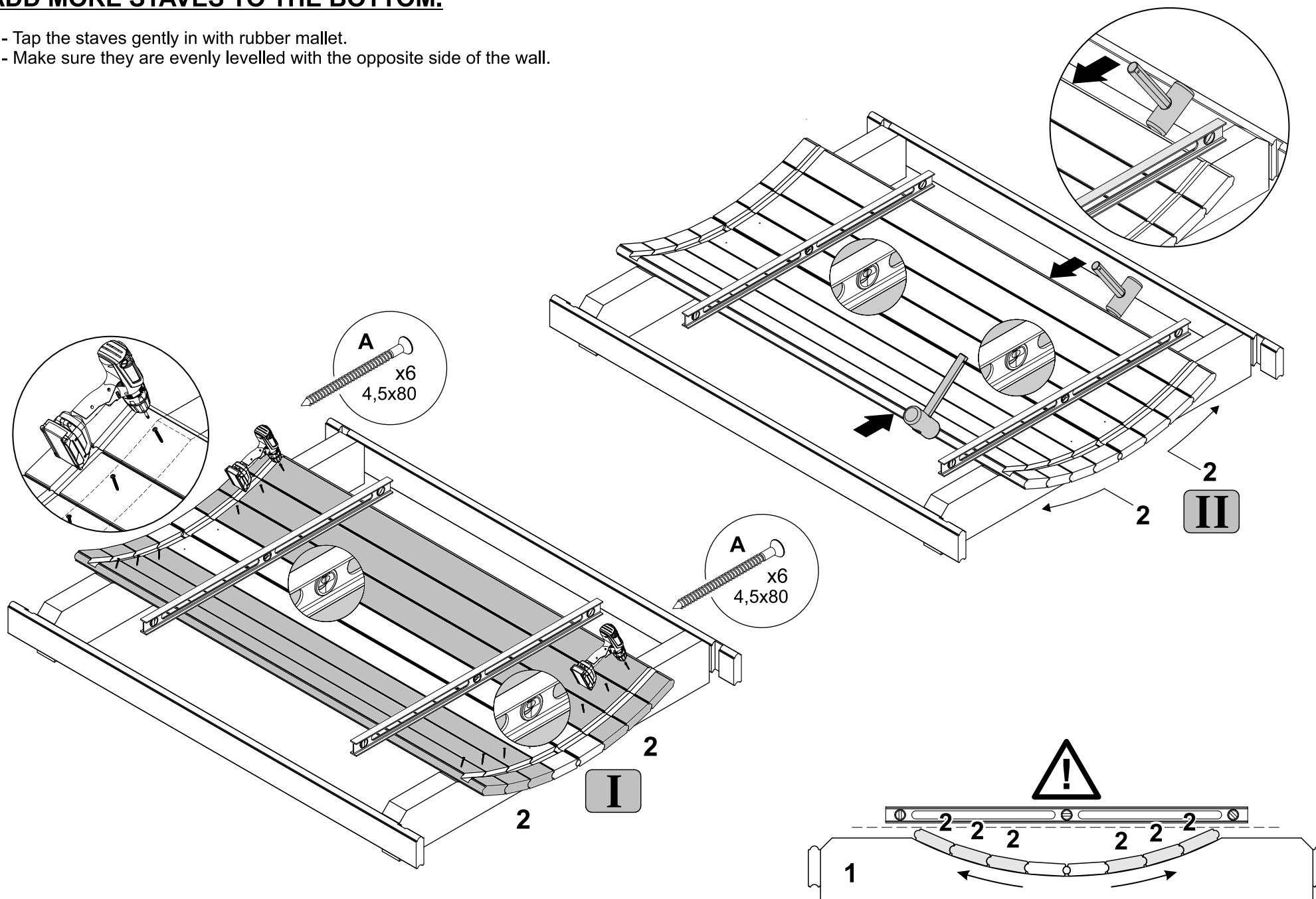
SECURE BOTTOM STAVES AND CENTERPIECE.

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.



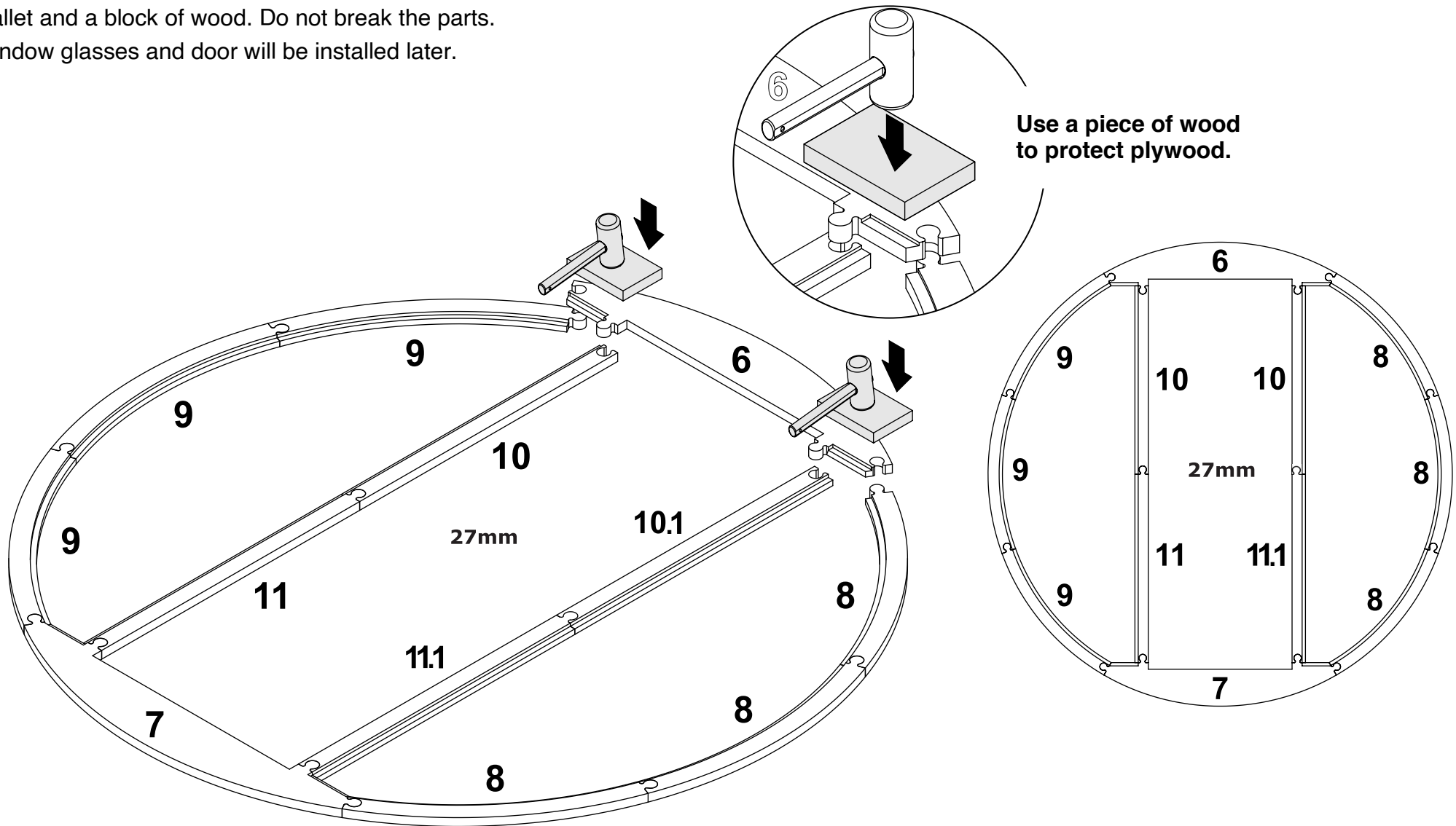
ASSEMBLING THE FULL GLASS FRONT WALL

The Full glass front wall consists of the glass front wall base (27mm) and the glass front wall top frame (12mm)

Lay the frame parts on the flat surface.

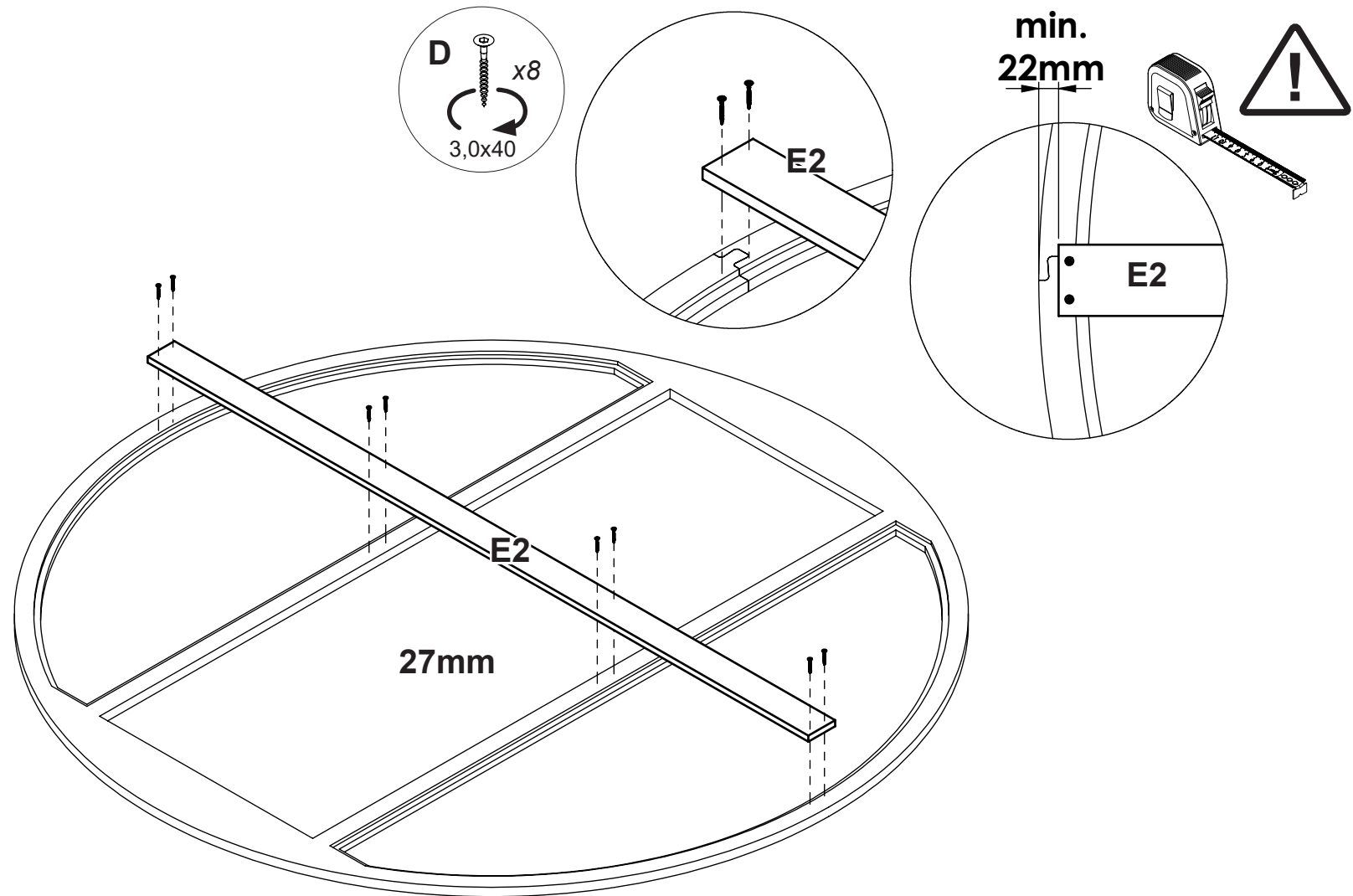
Connect the parts by tapping them in with rubber mallet and a block of wood. Do not break the parts.

Window glasses and door will be installed later.



INSTALLING WALL BRACKETS

Install wall brackets for holding frame together

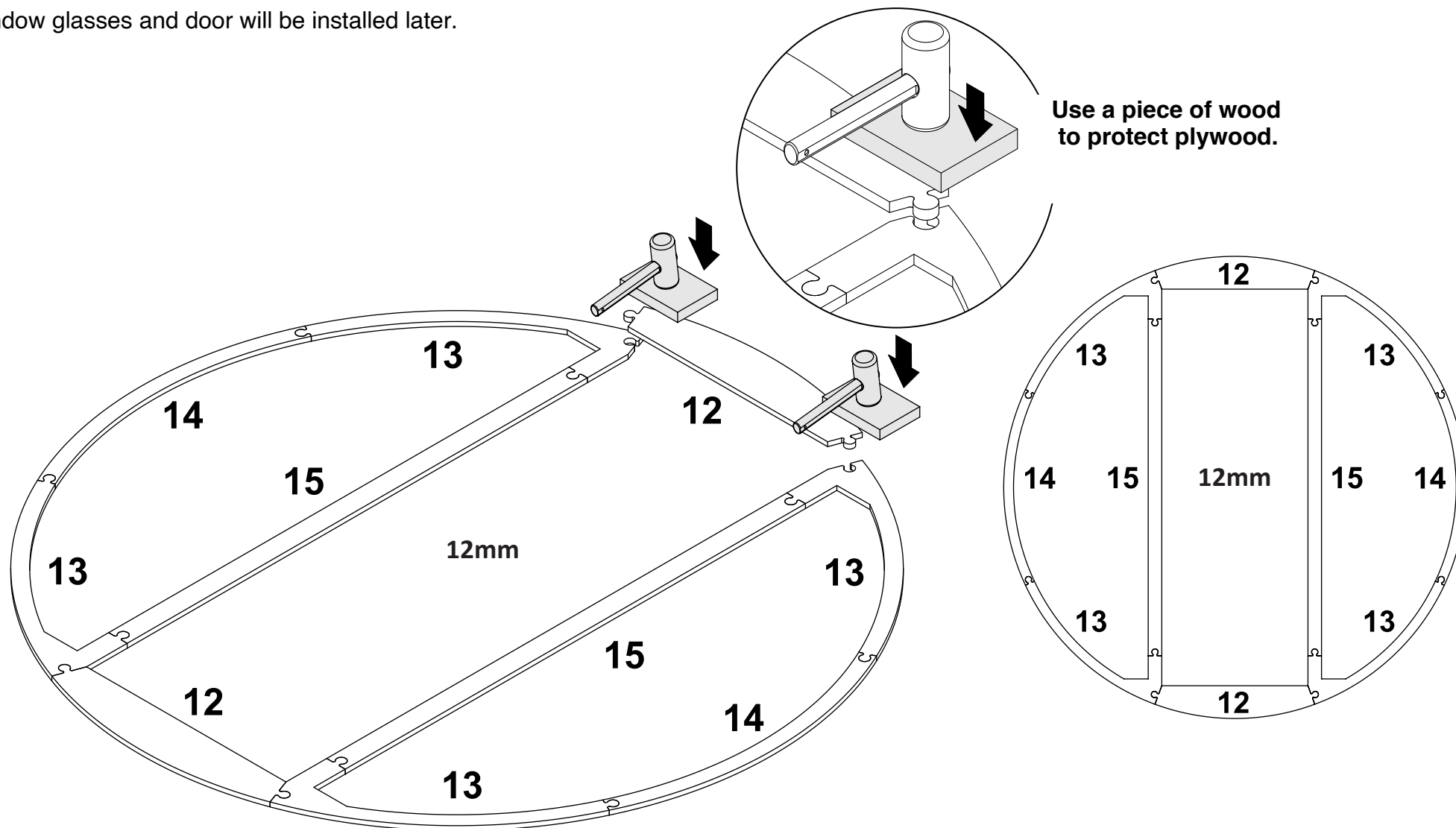


ASSEMBLING THE FULL GLASS FRONT WALL

Lay the frame parts on the flat surface.

Connect the parts by tapping them in with rubber mallet and a block of wood. Do not break the parts.

Window glasses and door will be installed later.



ASSEMBLING THE FULL GLASS BACK WALL

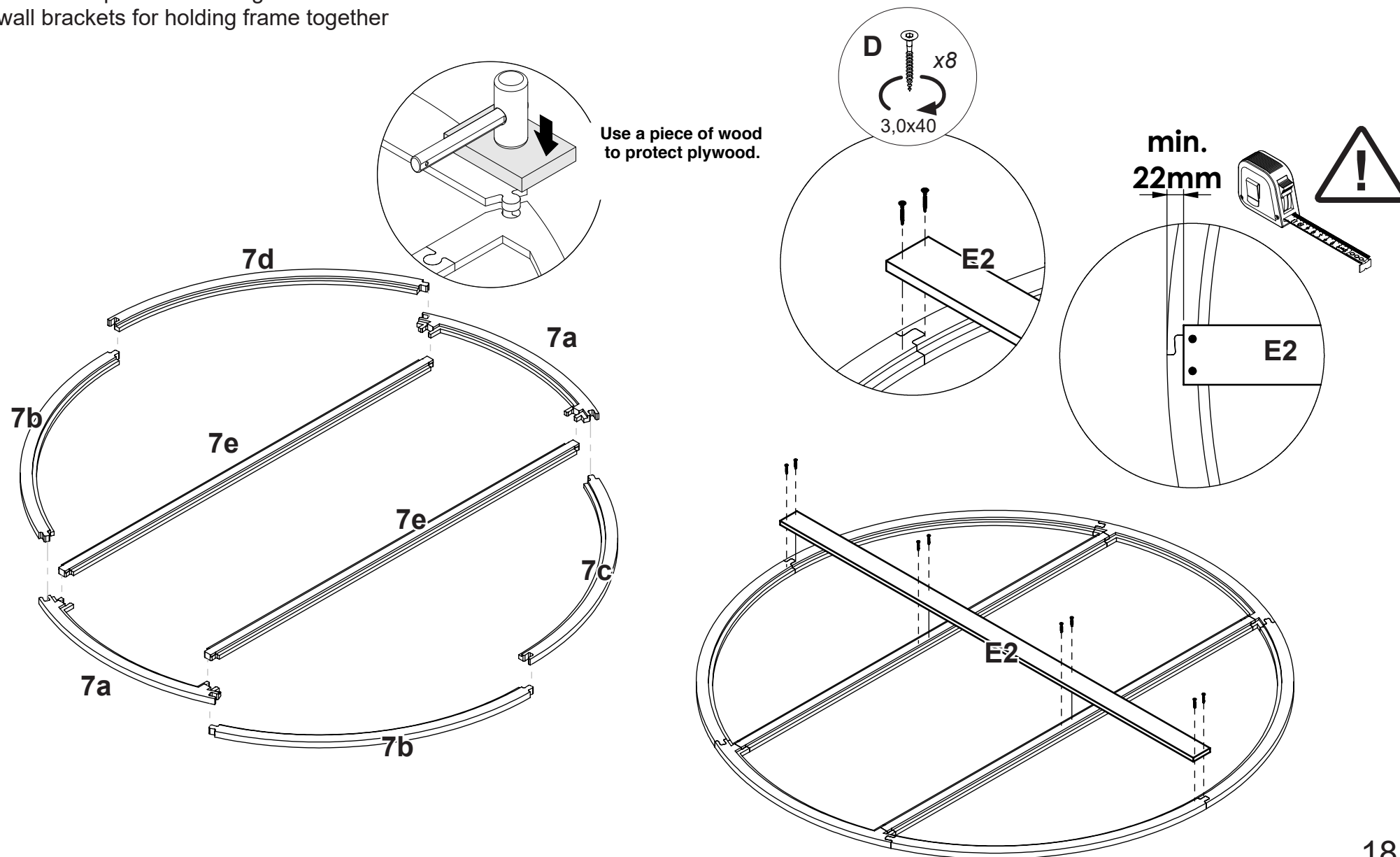
The full glass back wall consists of the glass wall base (27mm) and the glass wall top frame (12mm)

Lay the frame parts on the flat surface

Connect the parts by tapping them with rubber mallet and block of wood.

Do not break the parts. Window glasses will be installed later

Install wall brackets for holding frame together

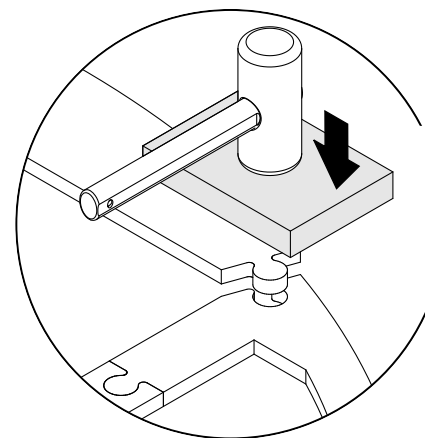
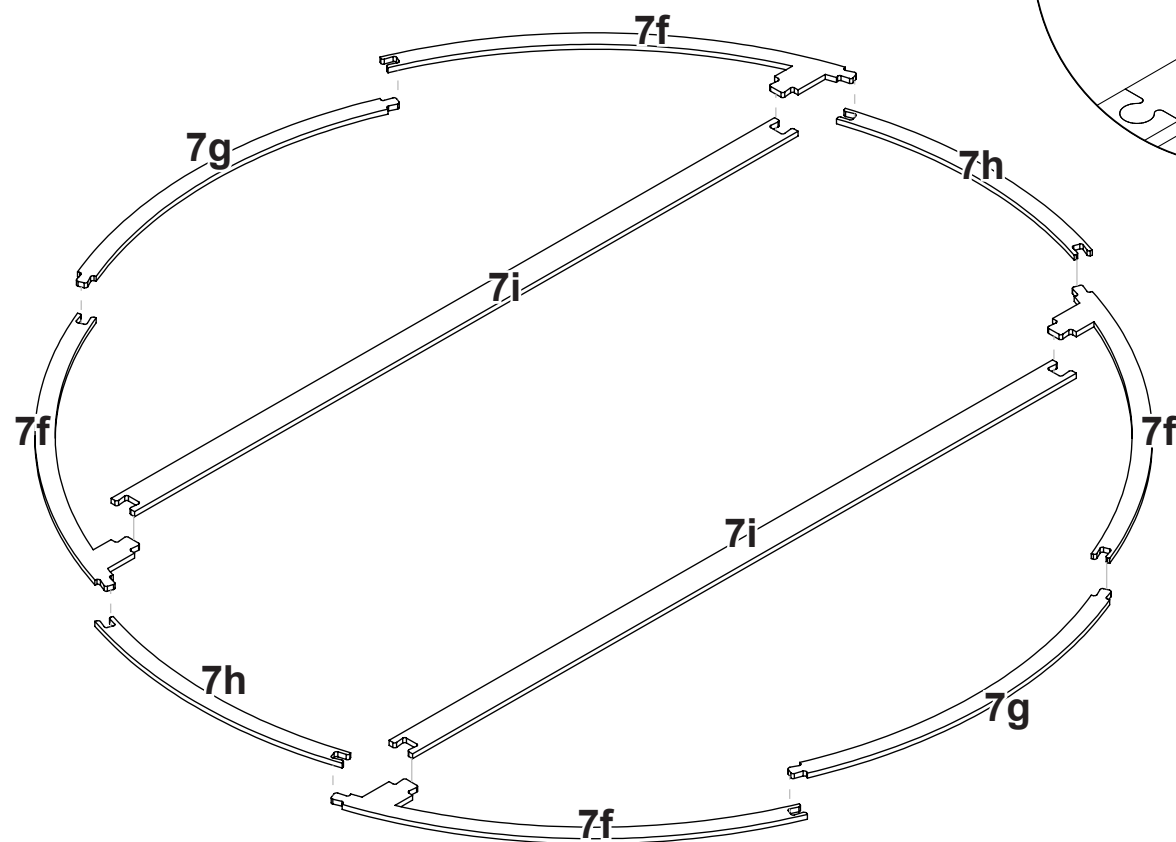


ASSEMBLING THE COVER FRAME FOR BACK WALL

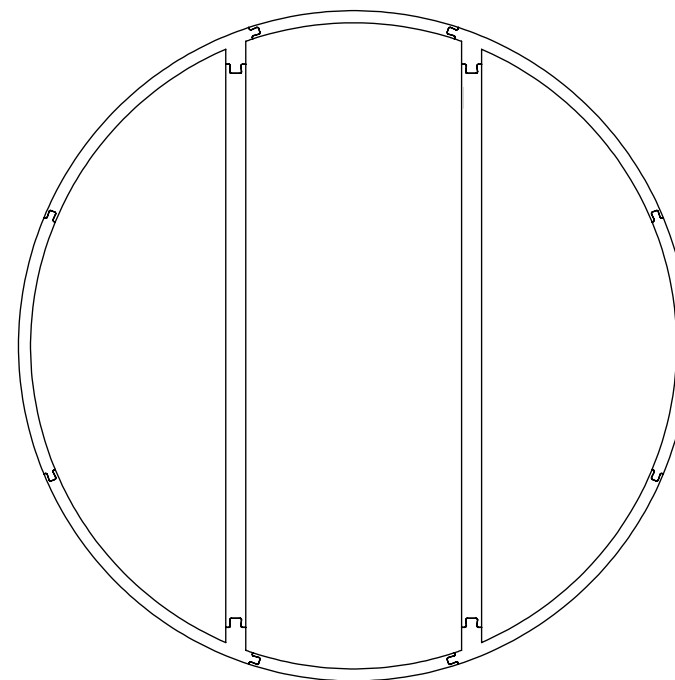
Lay the frame parts on the flat surface

Connect the parts by tapping them with rubber mallet and block of wood.

Do not break the parts. Window glasses will be installed later



**Use a piece of wood
to protect plywood.**



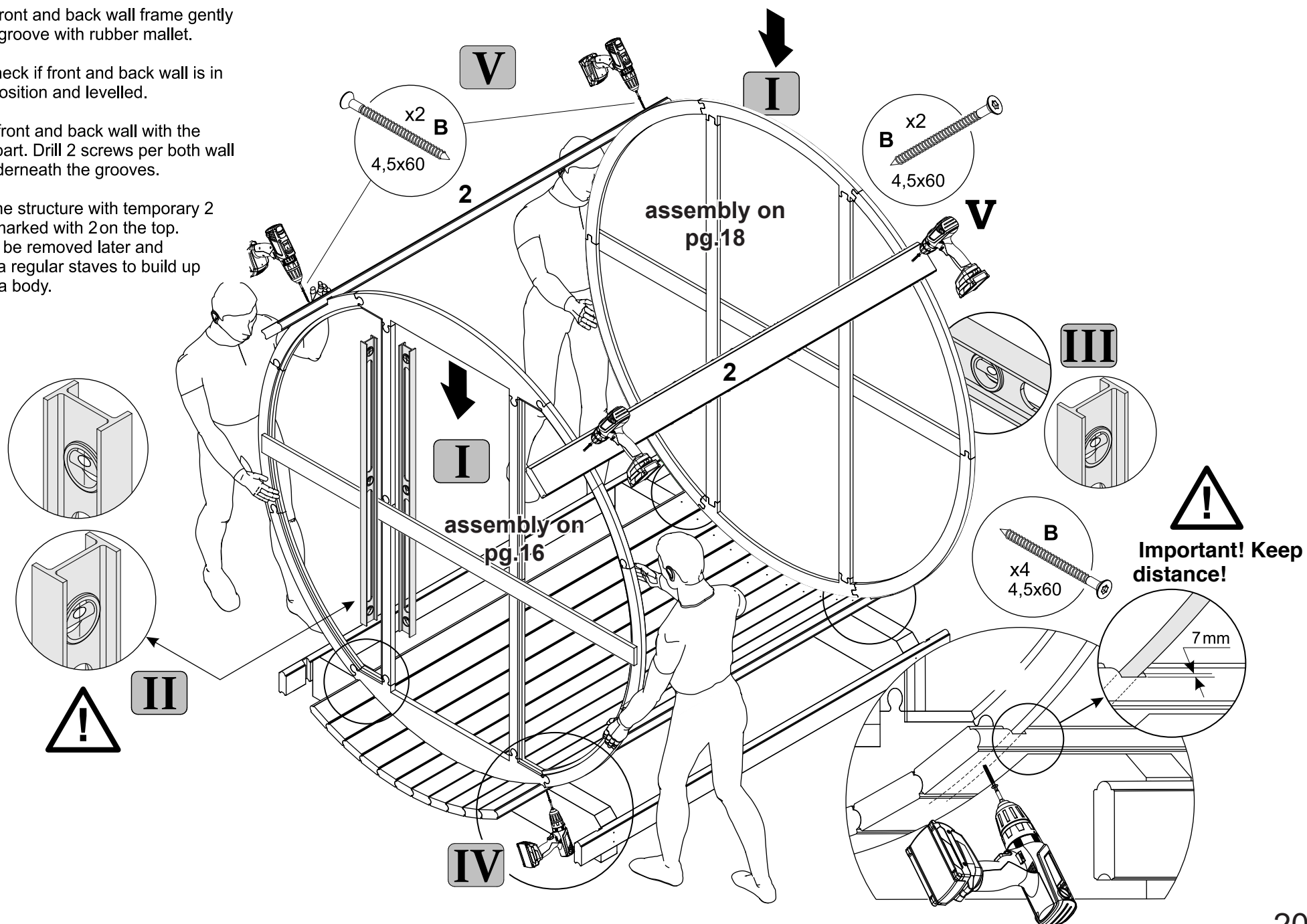
INSTALL THE FRONT AND BACK WALL

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

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

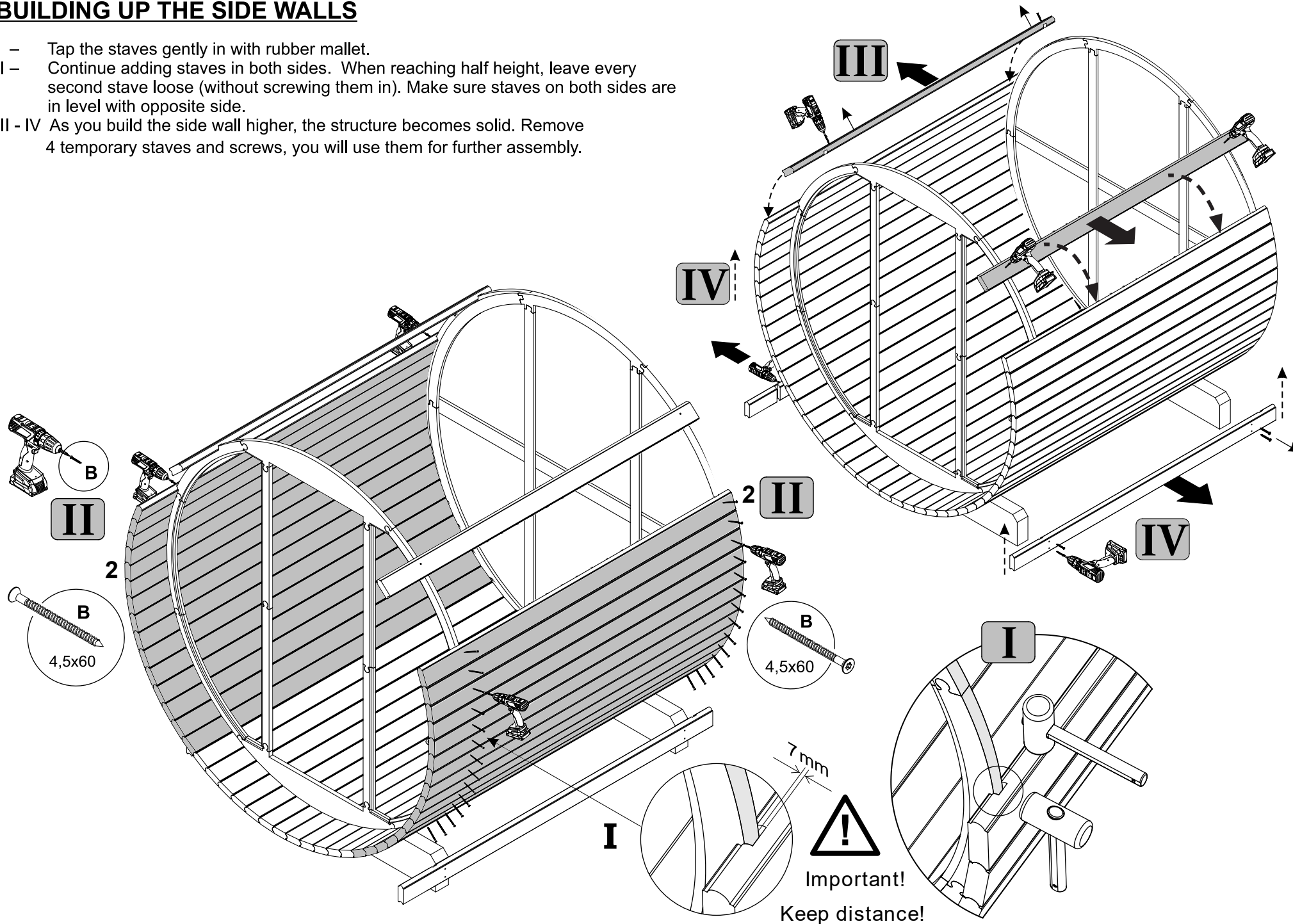
IV - Fix the front and back wall with the bottom part. Drill 2 screws per both wall from underneath the grooves.

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.



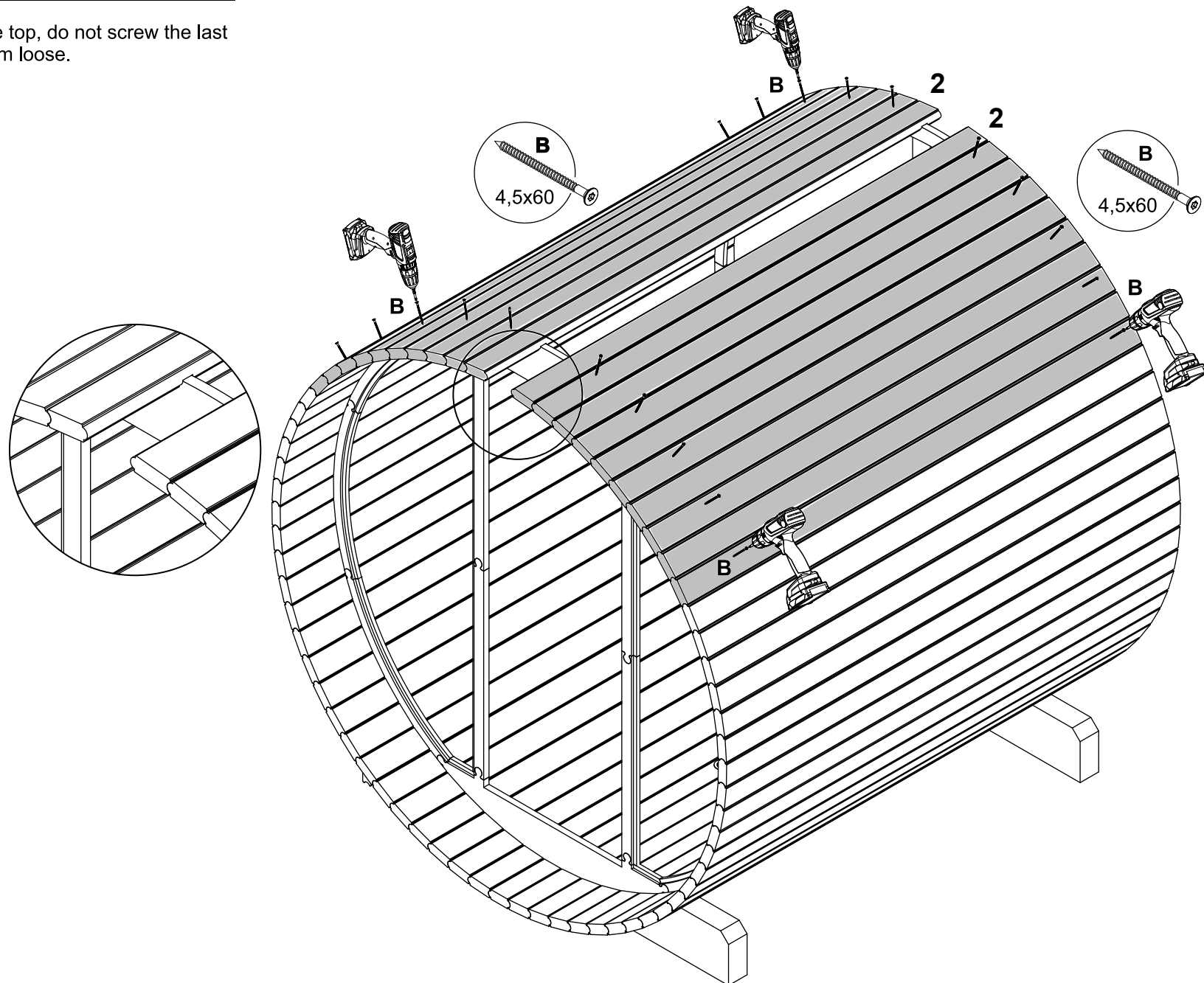
BUILDING UP THE SIDE WALLS

- I – Tap the staves gently in with rubber mallet.
- II – Continue adding staves in both sides. When reaching half height, leave every second stave loose (without screwing them in). Make sure staves on both sides are in level with opposite side.
- III - IV As you build the side wall higher, the structure becomes solid. Remove 4 temporary staves and screws, you will use them for further assembly.



REACHING TO THE TOP STAVES

When you reach to the top, do not screw the last 3 staves in. Leave them loose.



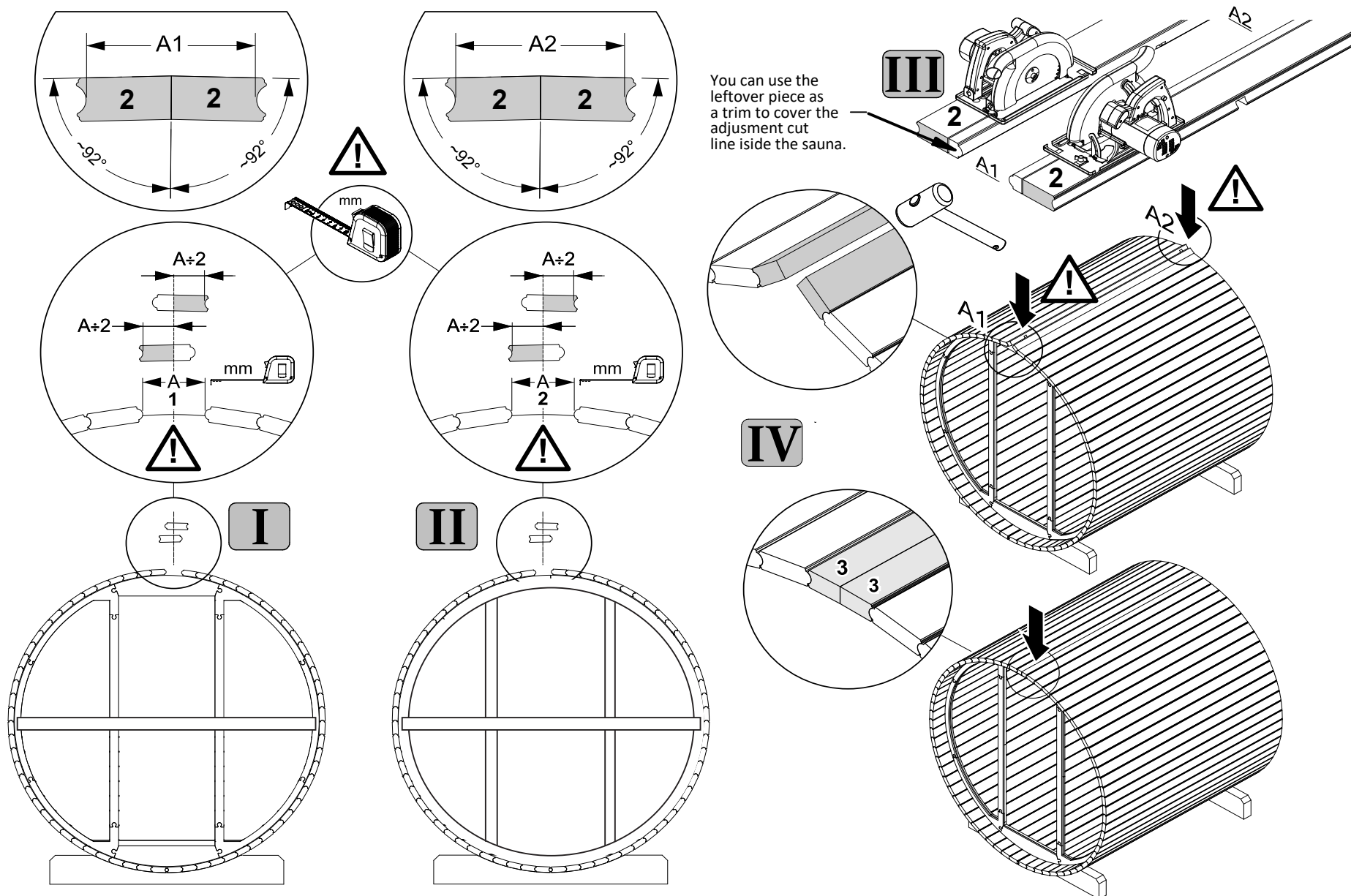
CONNECTING THE ROOFTOP

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

To make the last missing stave in right width, you have to make an adjustment cut.

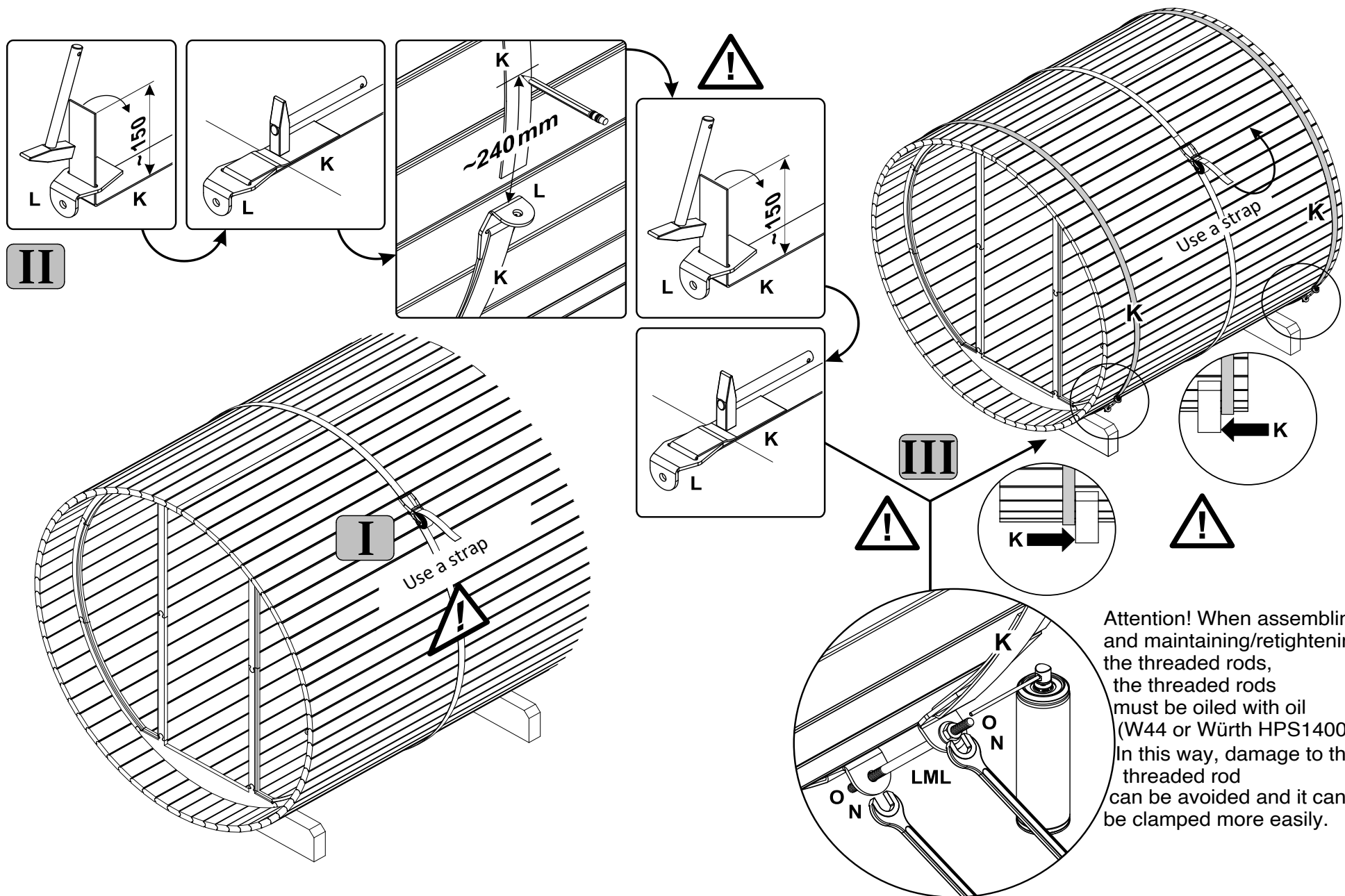
III - Make the adjustment cut with circular saw. Make sure you cut the right side

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



INSTALL THE STEEL BANDS

- I – Tie a loose rope or strap around to tighten the sauna.
- II – Mount steel bands and brackets. Bend the steel band backwards (length 150 mm)
- III – Install the steel bands so that they cover the screws. Tighten the nuts evenly.

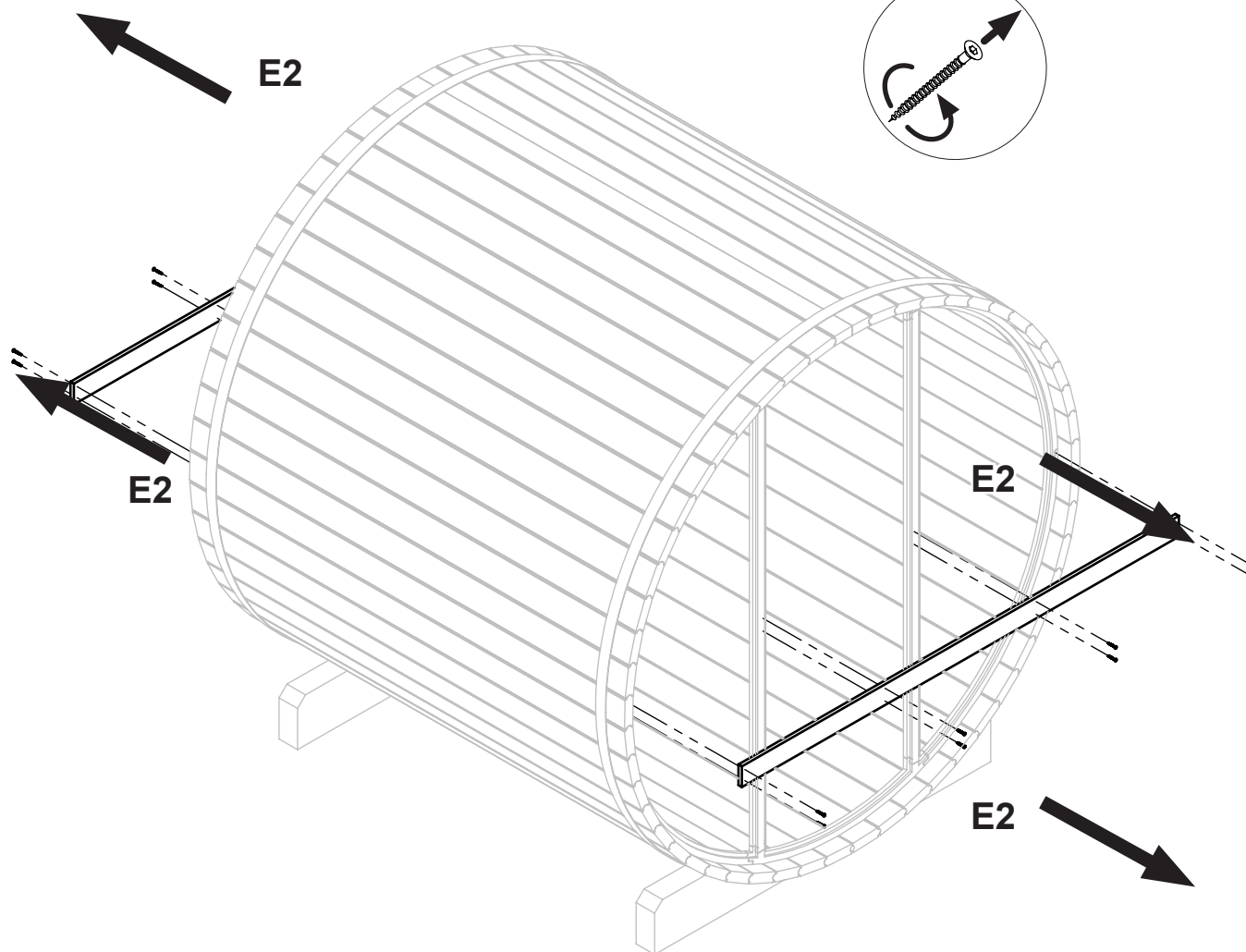
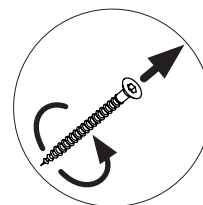


REMOVE WALL BRACKETS

I - Unscrew and remove wall brackets

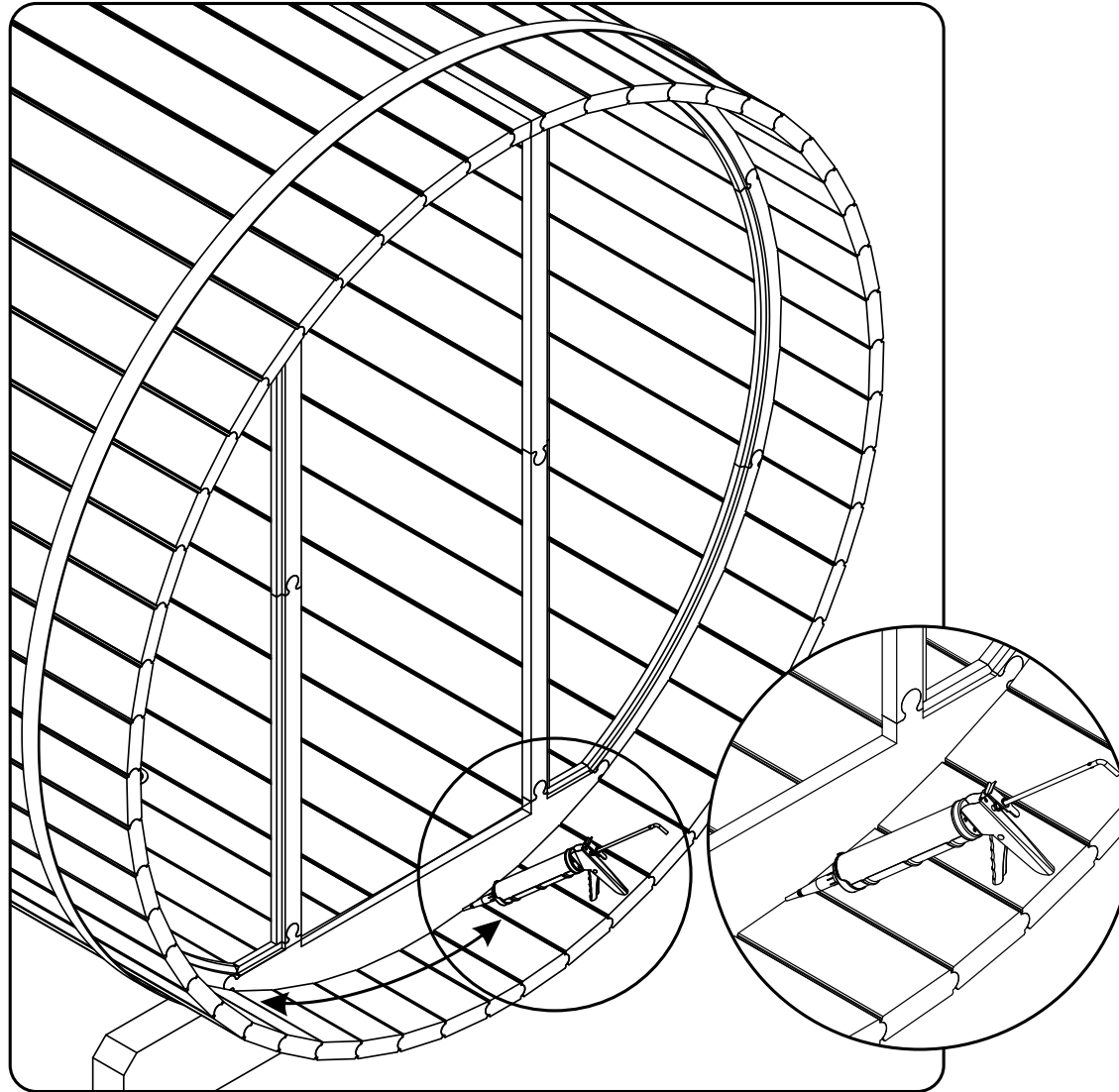


Please remove the boards shown!



SEAL THE WALLS

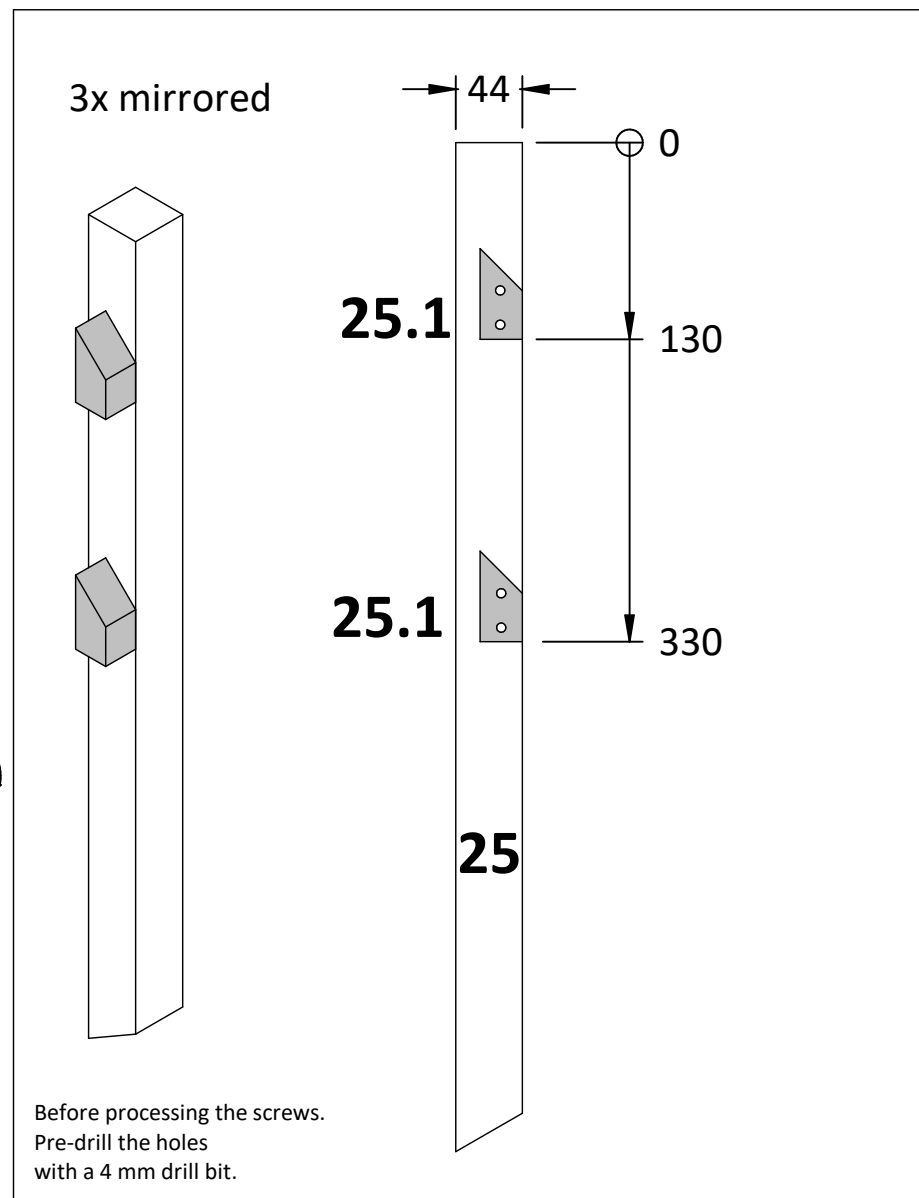
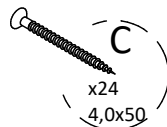
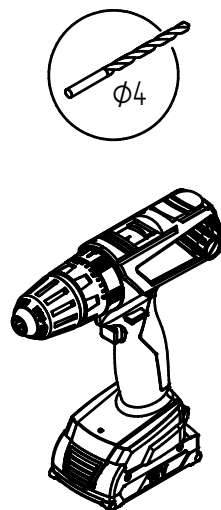
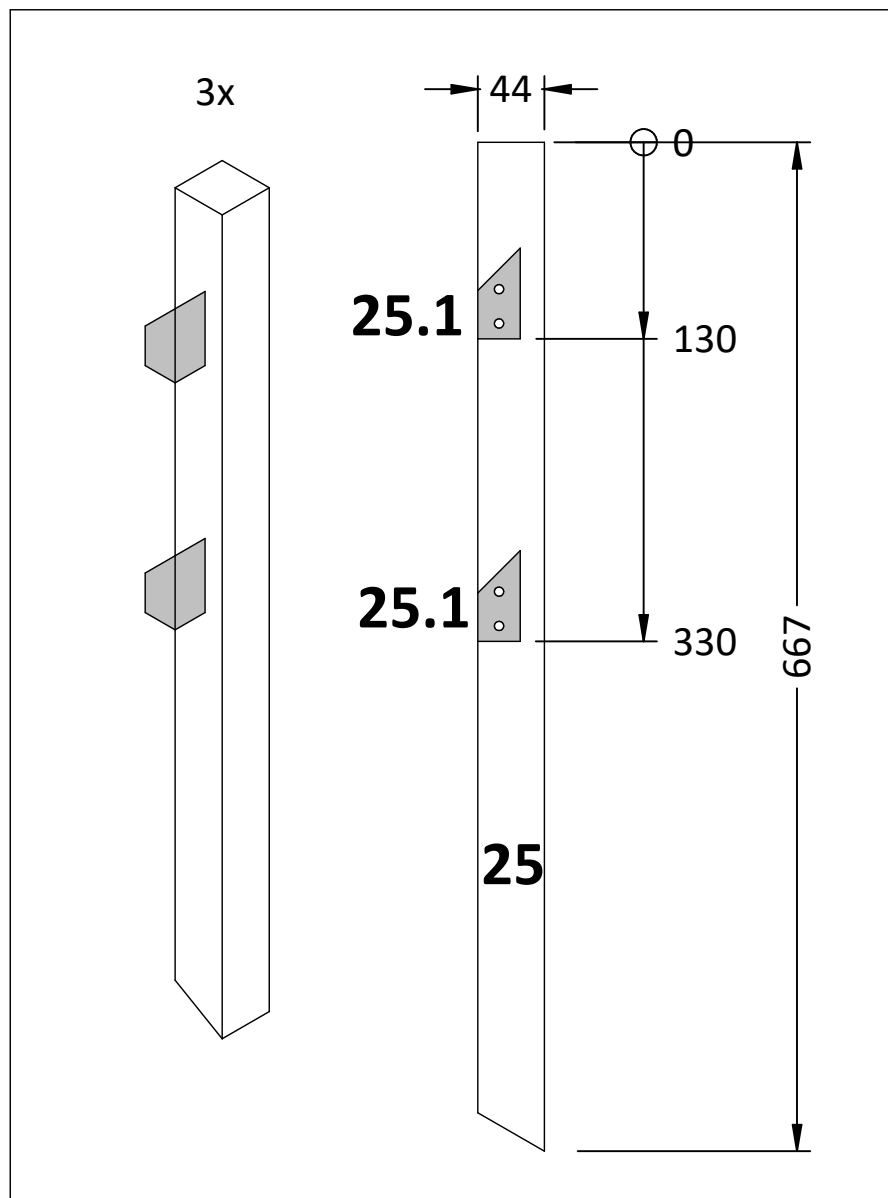
Seal the front and rear wall seams half way up the wall. Leave the bottom center part clean.



PREPARE THE BENCH SUPPORT LEGS

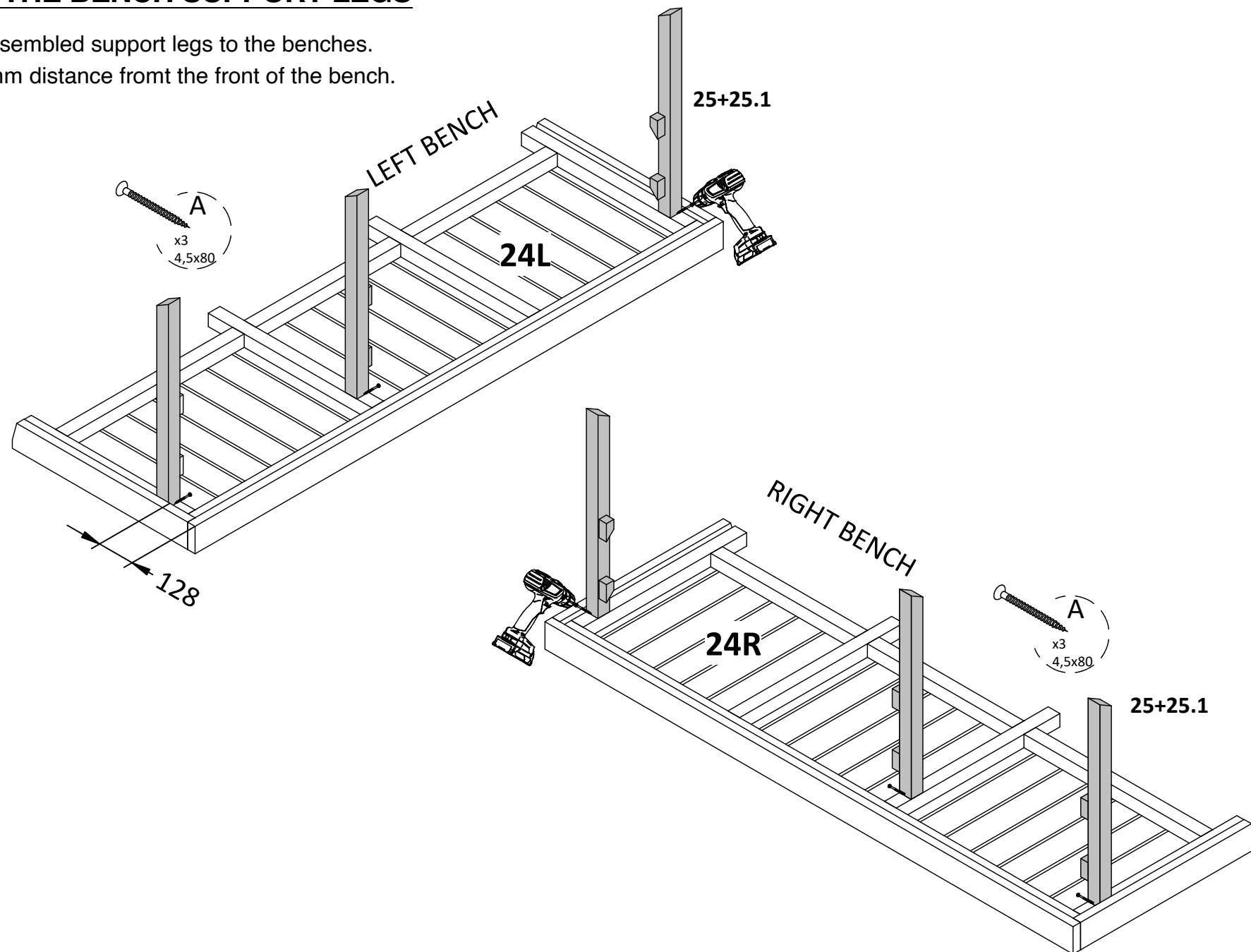
I - Screw the skirt holders (25.1) to the bench support legs (25).

PS! The legs are pre-cut at an angle to match the curved floor. Install with the higher part of the angled cut facing the middle of the sauna.



INSTALL THE BENCH SUPPORT LEGS

Screw the assembled support legs to the benches.
Keep a 128mm distance from the front of the bench.

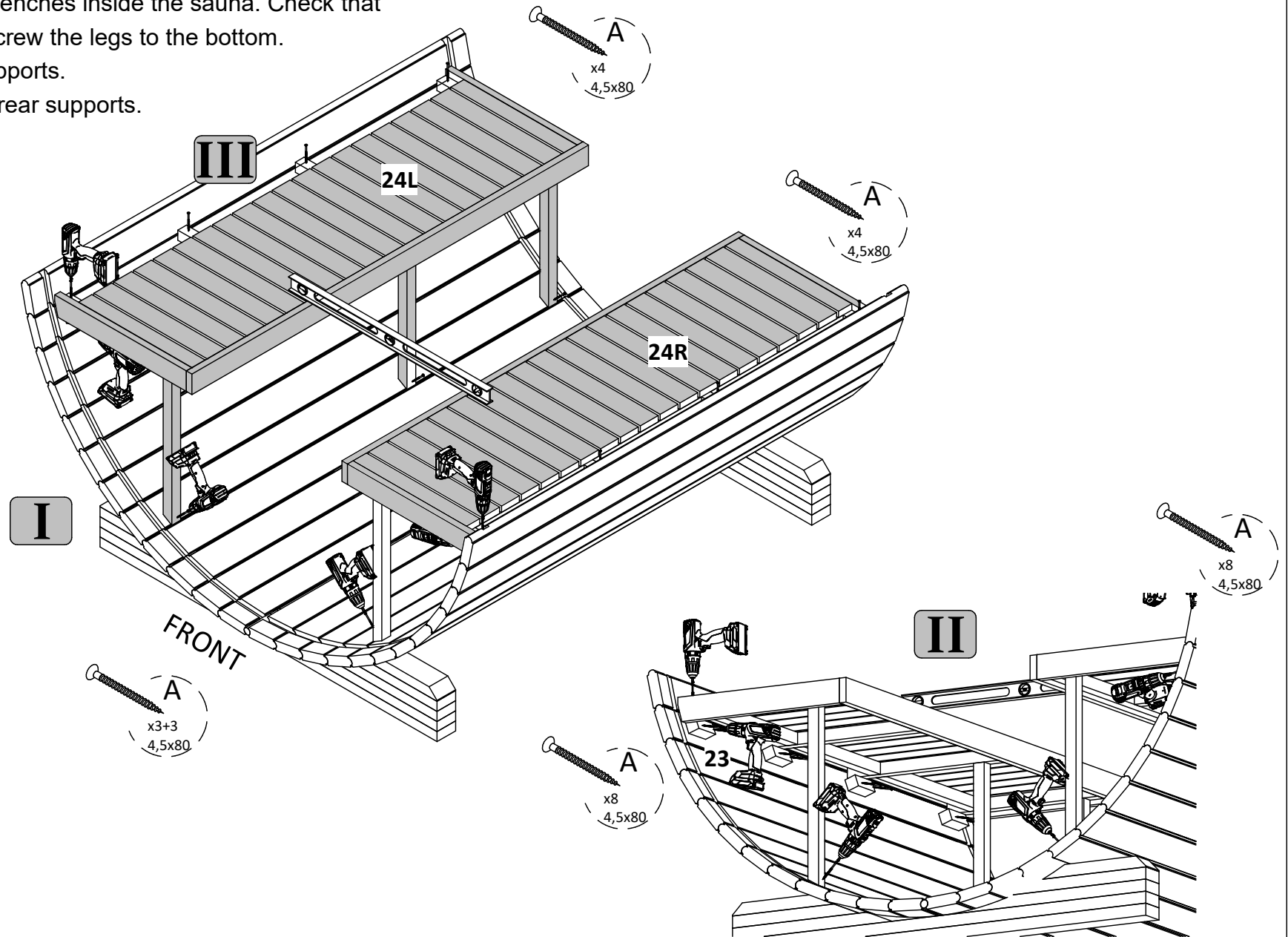


INSTALL THE BENCH SUPPORTS

I - Position the assembled benches inside the sauna. Check that the benches are levelled. Screw the legs to the bottom.

II - Install the rear bench supports.

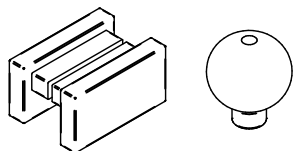
III - Screw the bench to the rear supports.



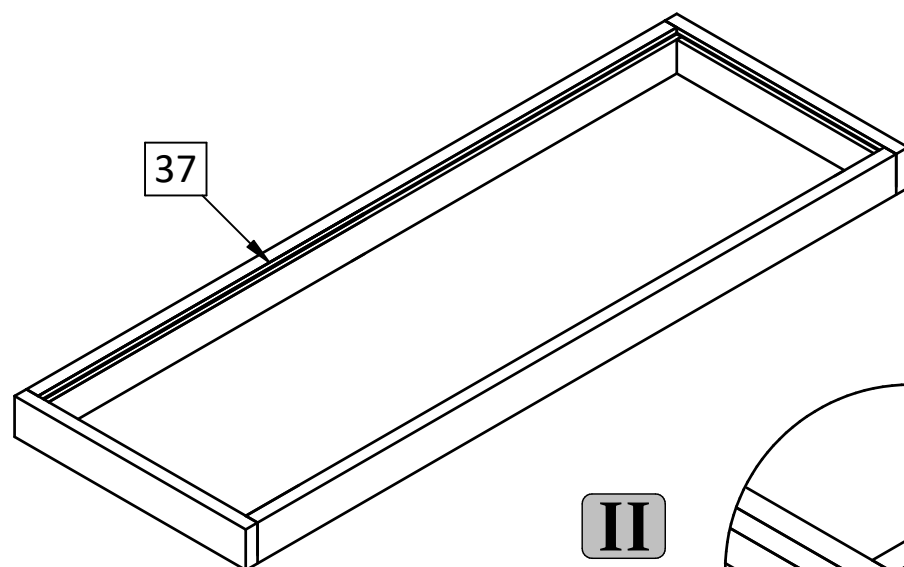
PREPARING THE DOOR FOR INSTALLATION

- I - Mount the external door frame (parts 38 and 39), 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.

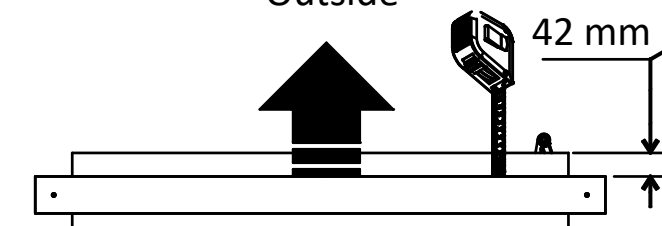
The exterior door handle must be varnished!



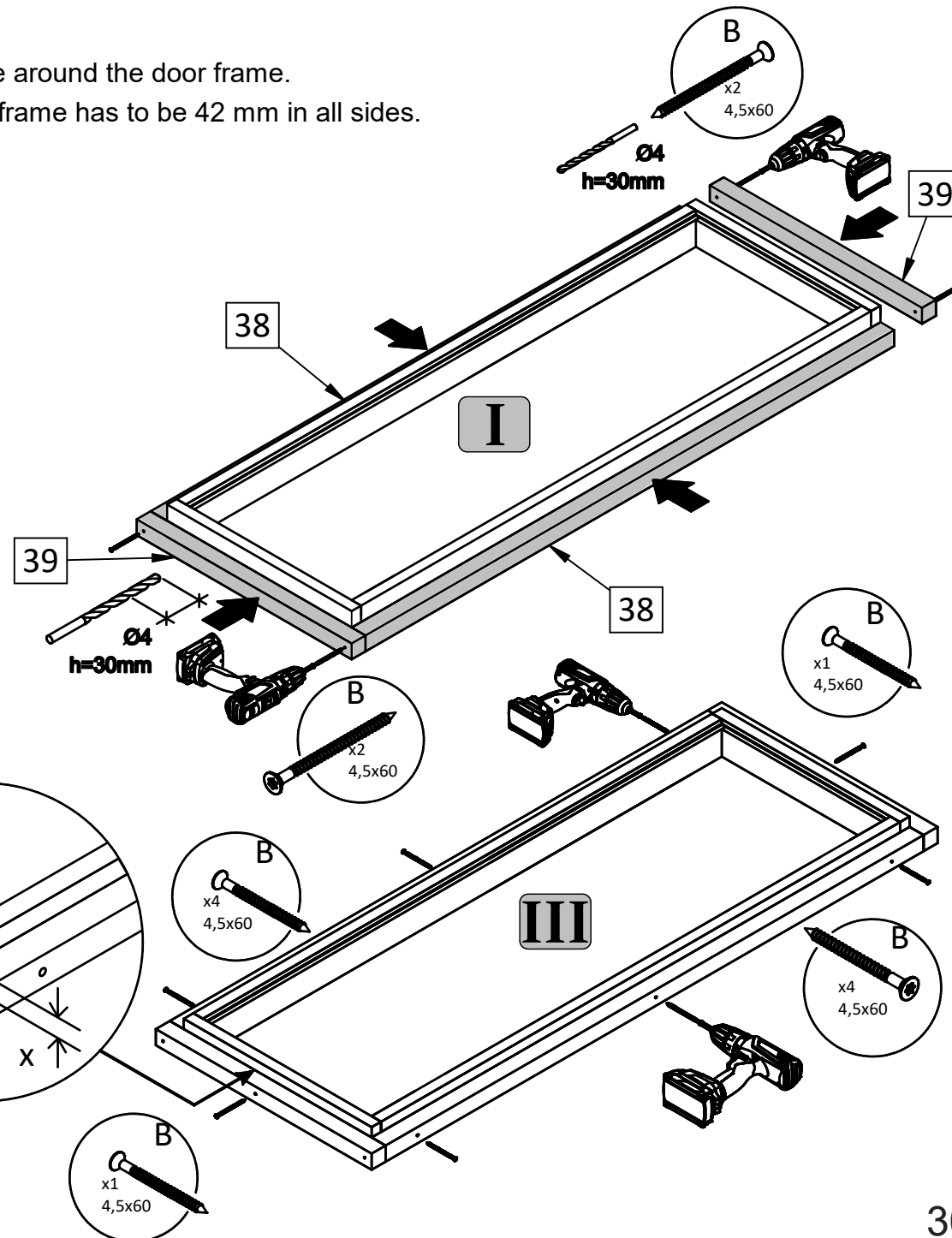
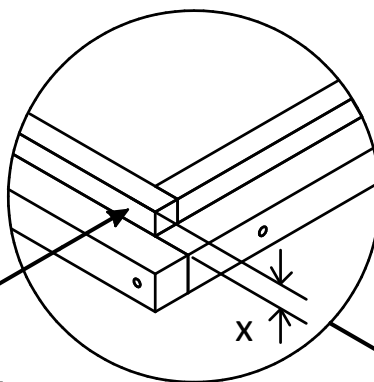
Read the manual supplied with the door!



Outside

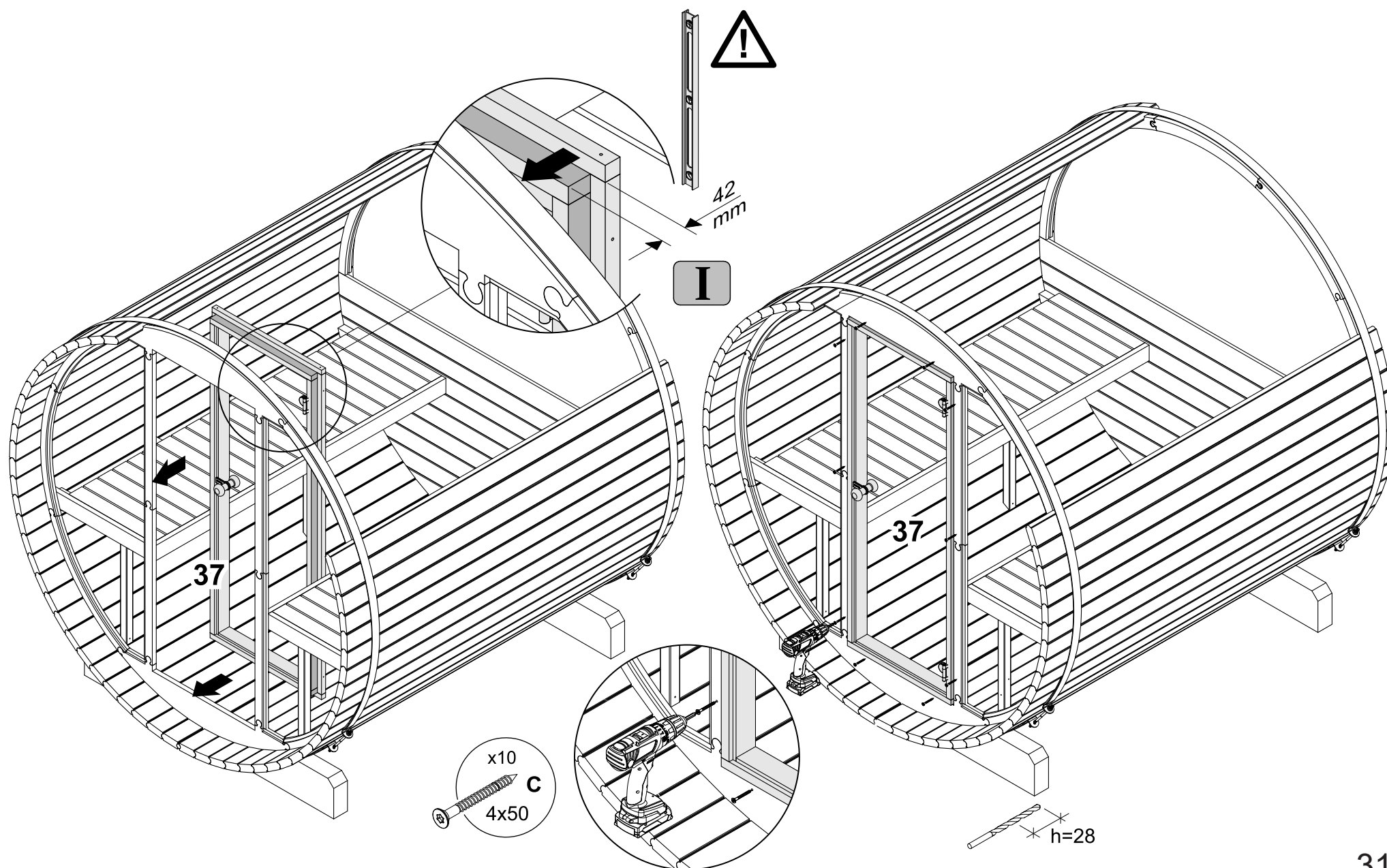


II



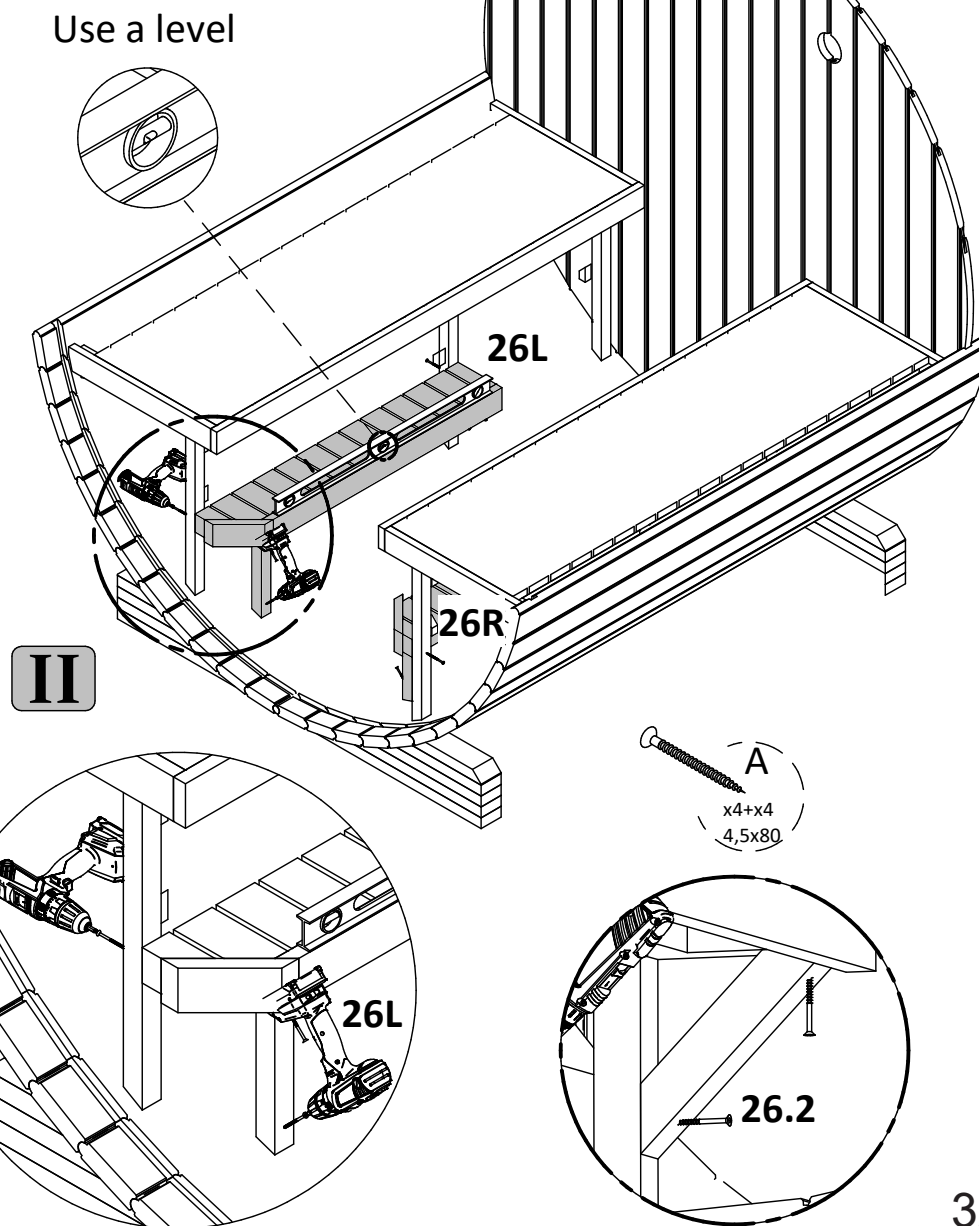
INSTALL THE DOOR AND GLASS FRONT

I - Install the door frame so that it stands 15mm outwards from the frame. It will be flush later, when the external window frame (15mm thick) is installed. Center the door in the frame.



- I - Attach the support legs and diagonals to the lower benches.
- II - Place the benches inside the sauna and screw them in place.

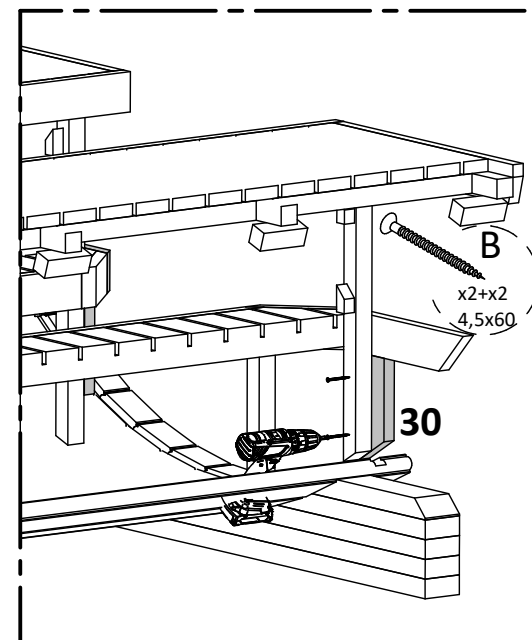
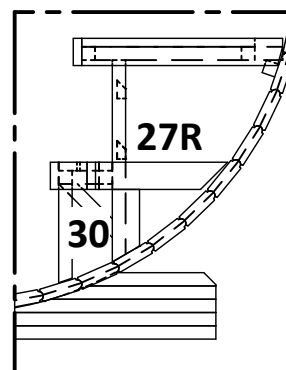
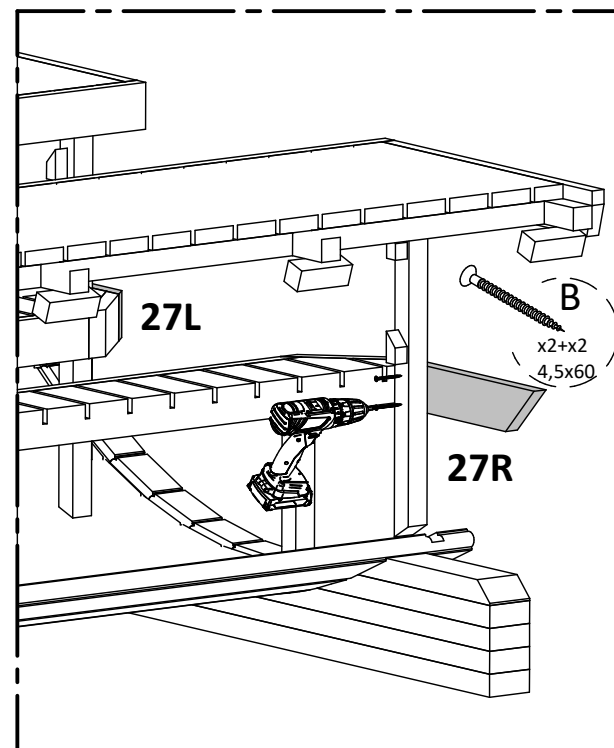
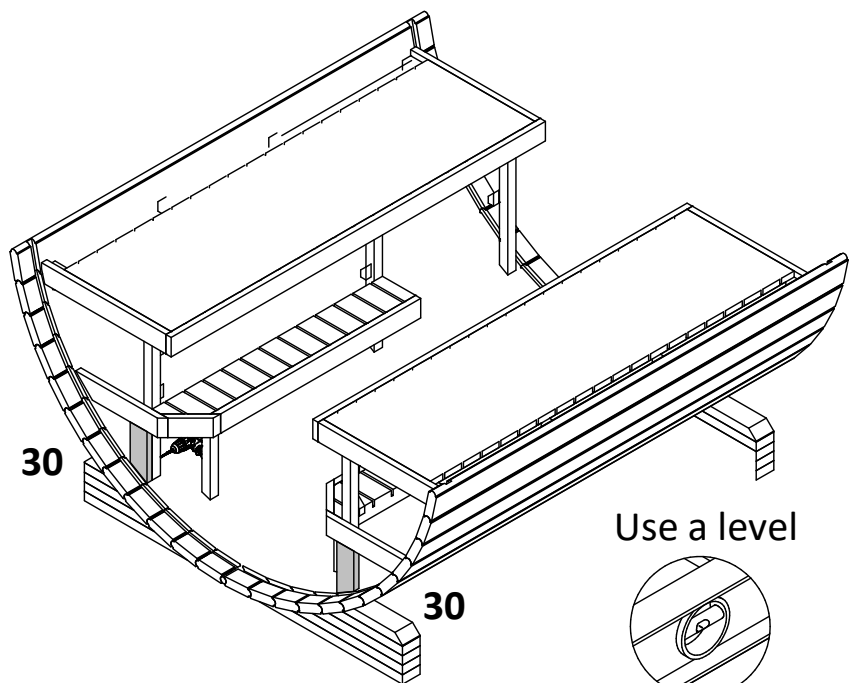
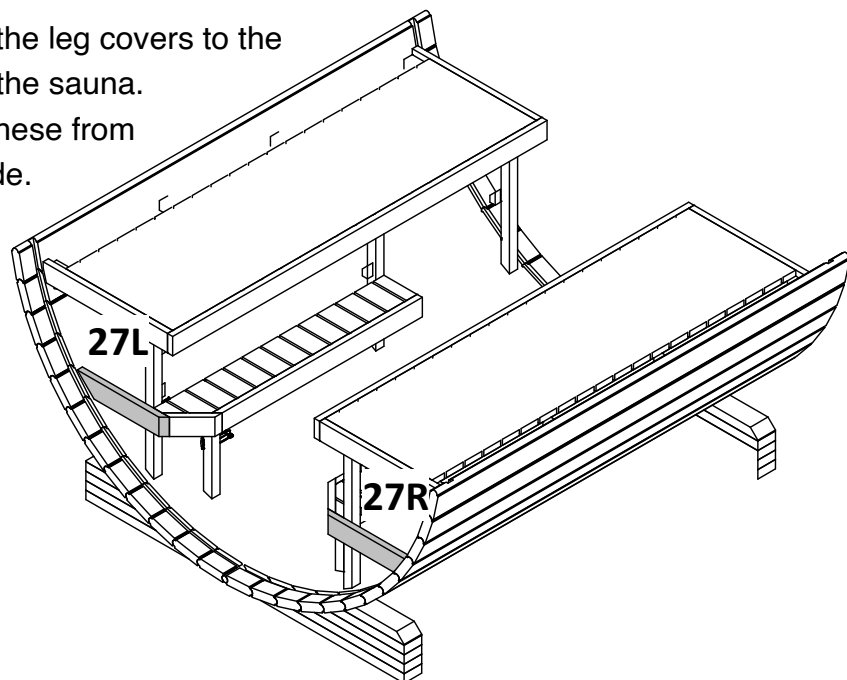
II - Place the benches inside the sauna and screw them in place.



INSTALL THE FRONT LEG COVERS

Attach the leg covers to the front of the sauna.

Screw these from the inside.

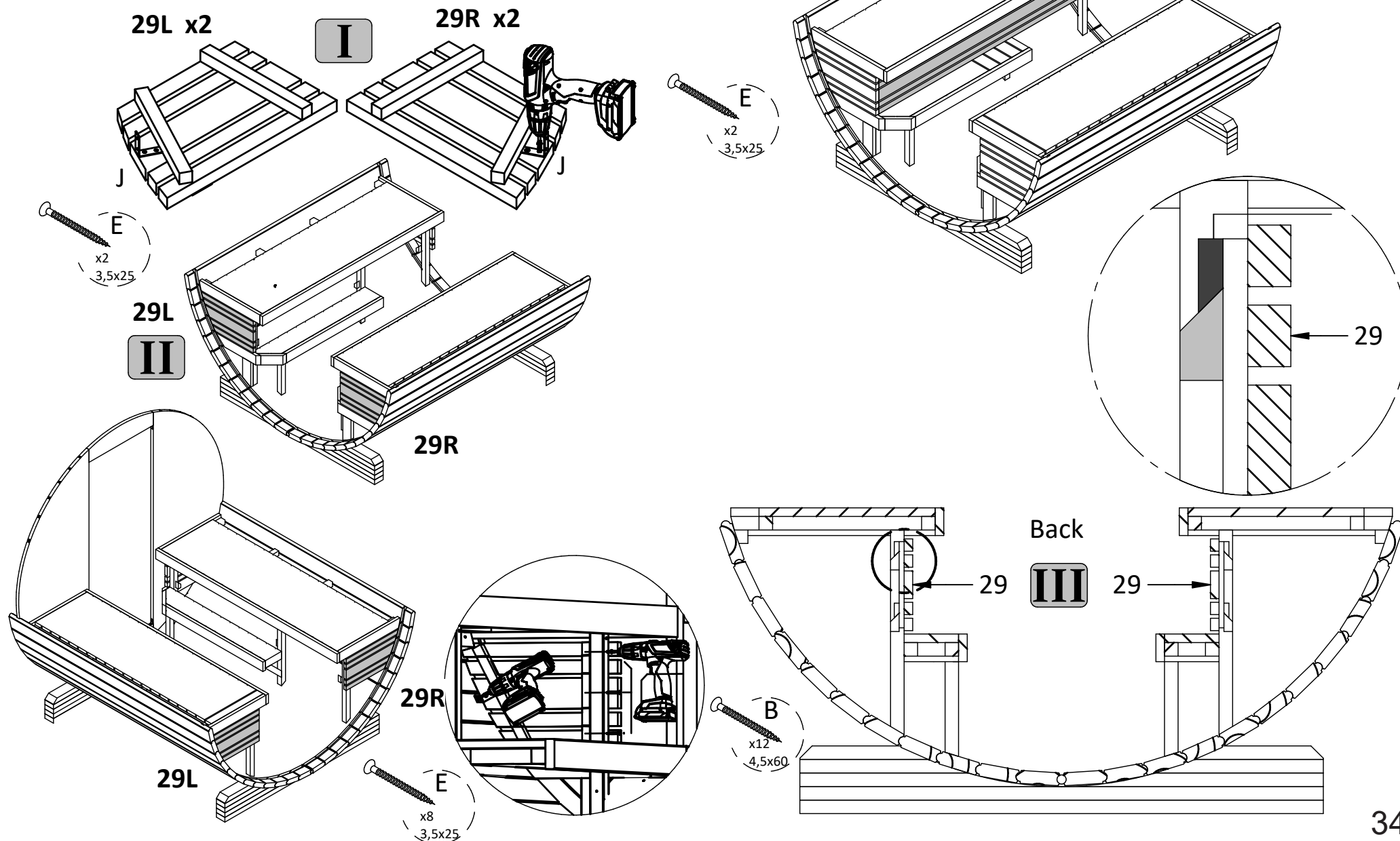


INSTALL THE SKIRTS

I - Attach the L-brackets to the sideskirts.

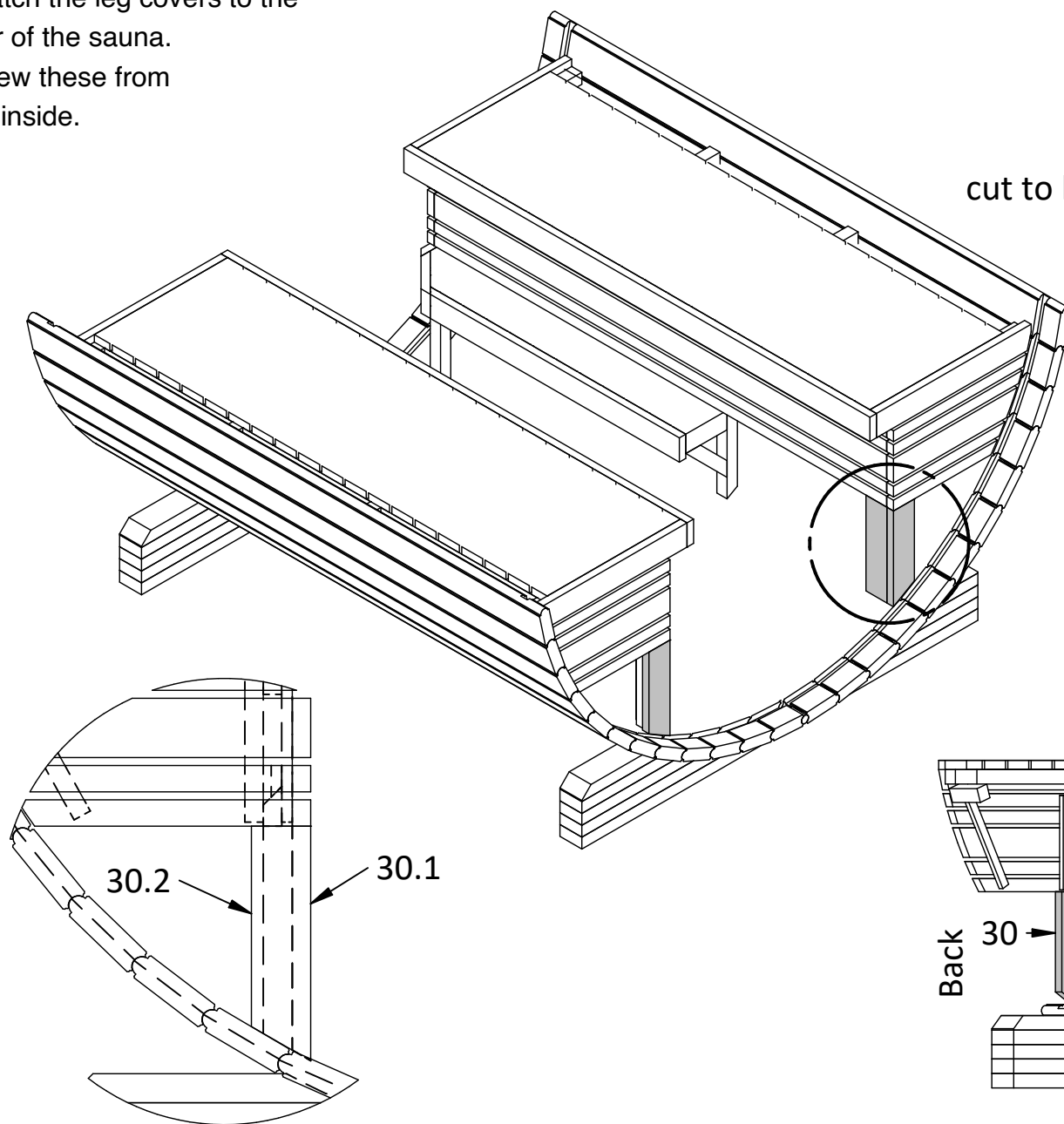
II - Place the skirts in place and screw these from the inside.

III - Hang the long skirts in place.

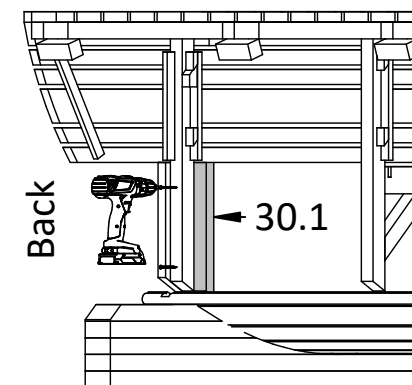
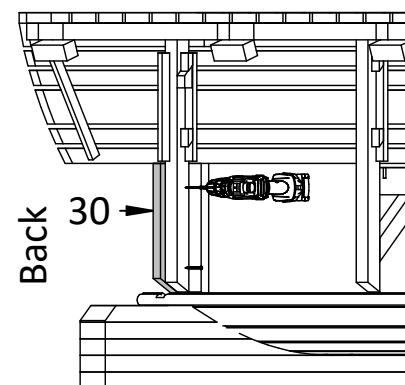
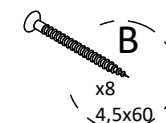
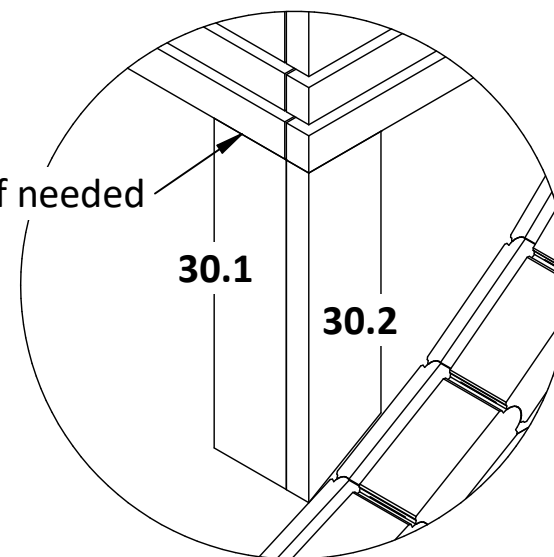


INSTALL THE REAR LEG COVERS

Attach the leg covers to the rear of the sauna.
Screw these from the inside.

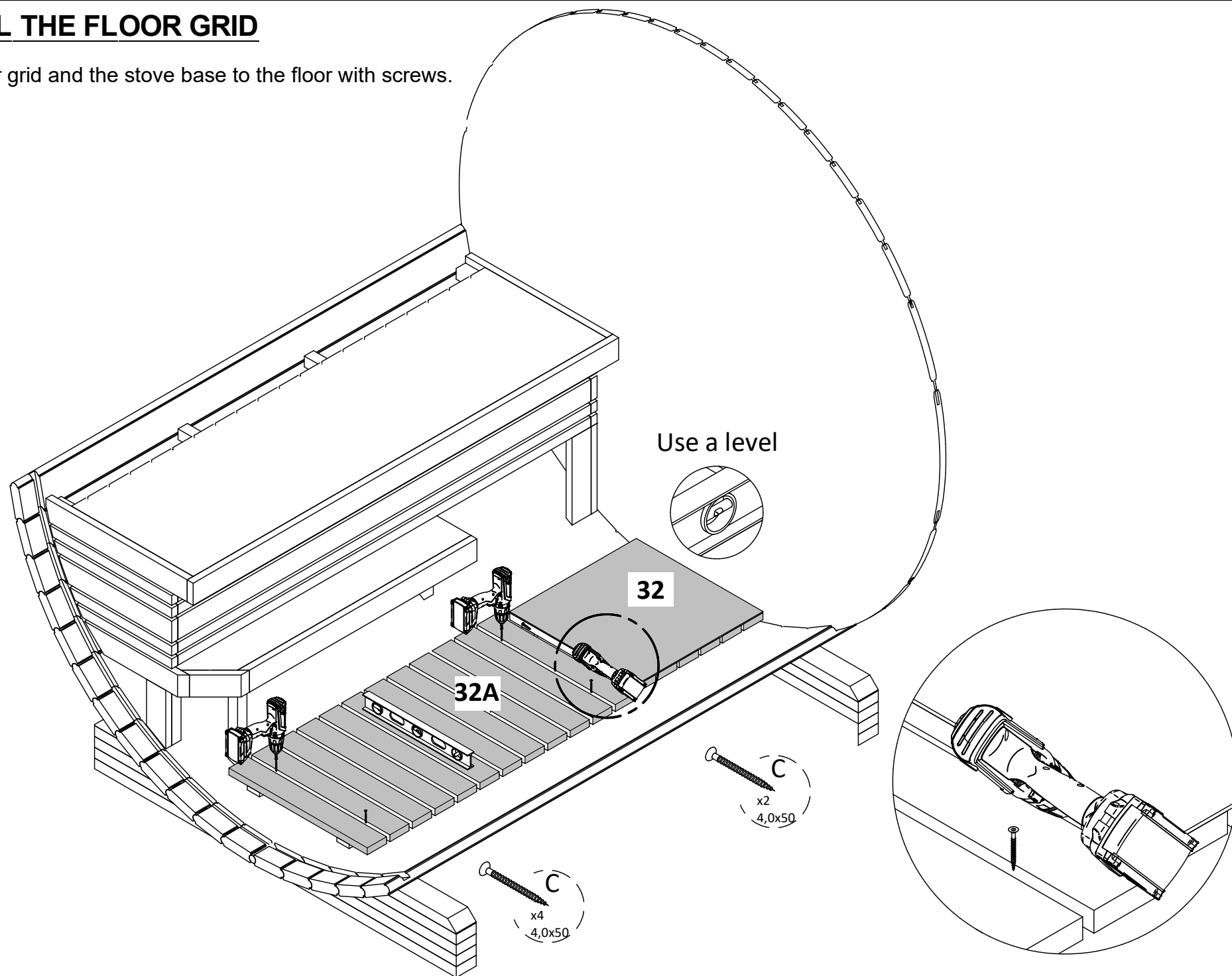


cut to length if needed



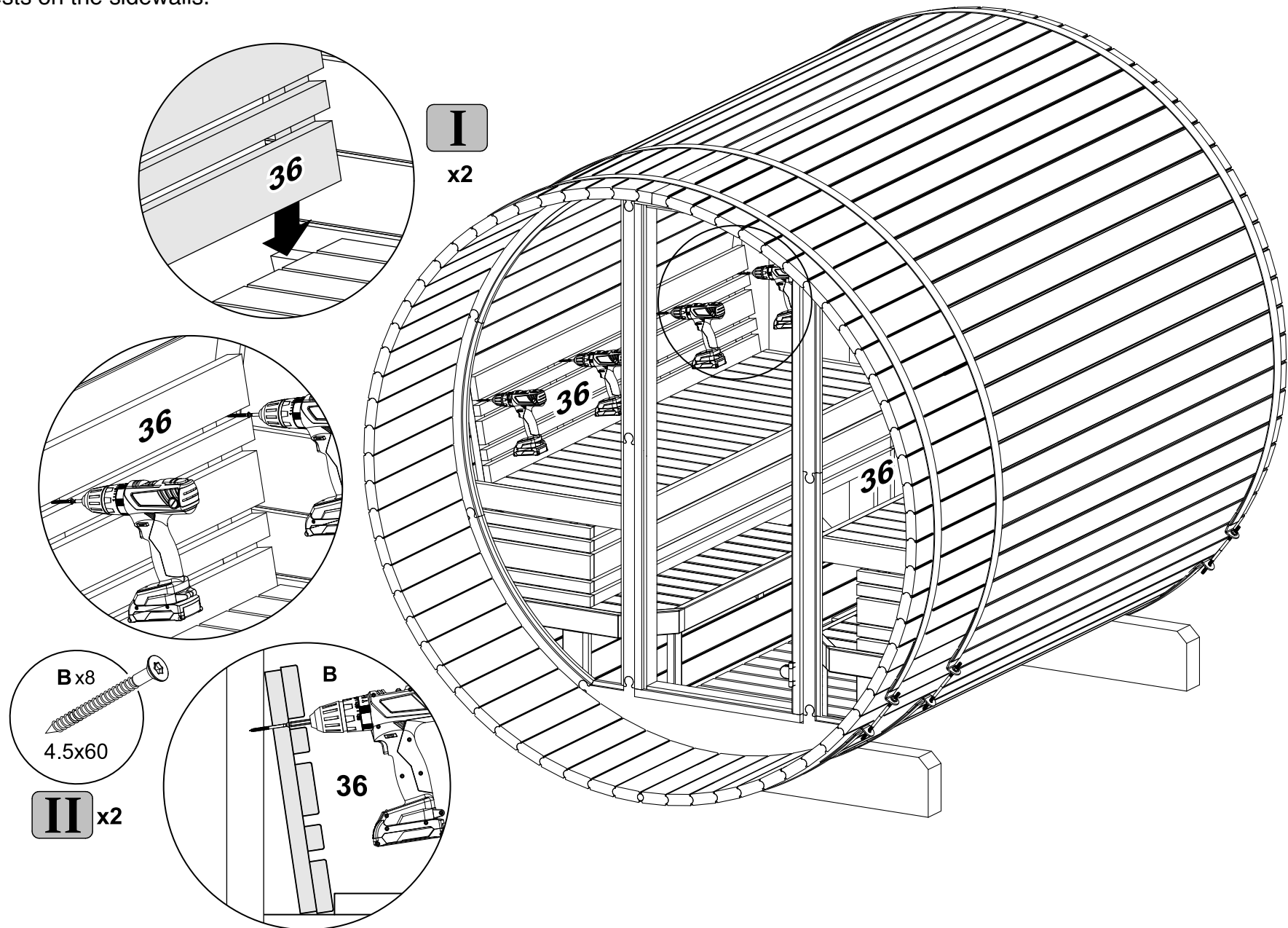
INSTALL THE FLOOR GRID

Fix the floor grid and the stove base to the floor with screws.



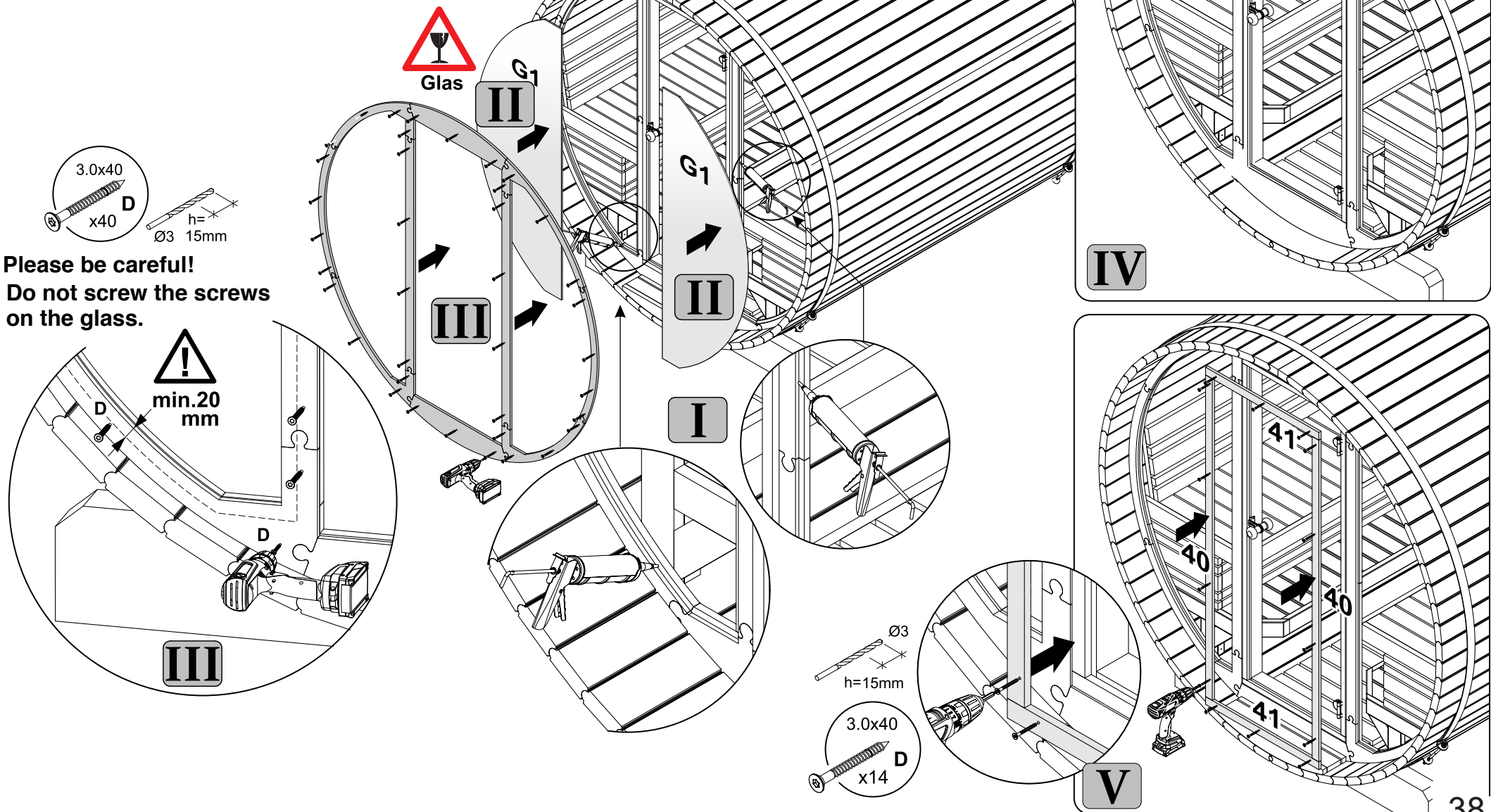
INSTALL THE BACKRESTS

Install the back rests on the sidewalls.



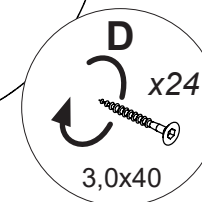
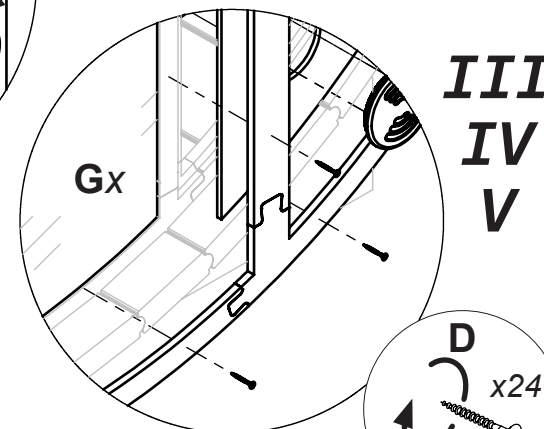
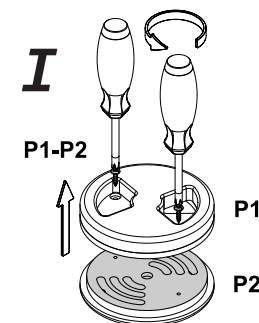
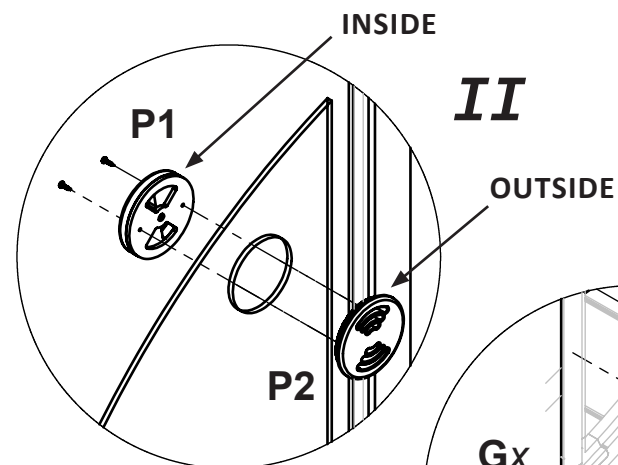
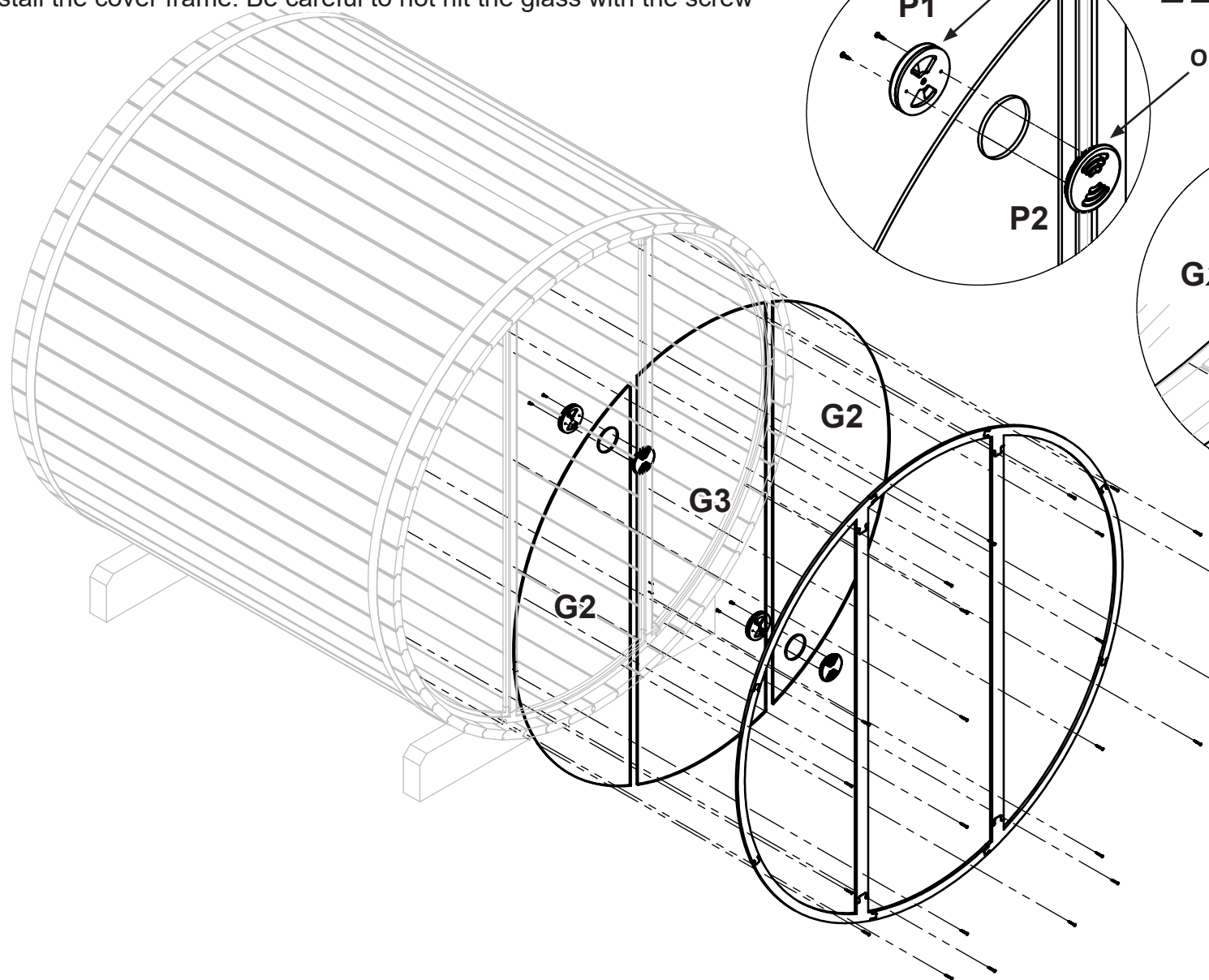
INSTALL THE FRONT WINDOWS

- I – Fill up the front window groove with water proof silicone.
- II – Place the windows tightly into the groove and squeeze gently in.
- III – Install the cover frame. Be careful to not hit the glass with the screw.
- IV-V - Install the door trim.



INSTALL BACK WINDOWS AND VENTILATION

- I** - Disassemble the ventilation valve
- II** - Install the ventilation onto glass and screw the two halves together
- III** - Fill up the window groove with water proof silicone
- IV** - Place the windows tightly into the groove and squeeze gently in
- V** - Install the cover frame. Be careful to not hit the glass with the screw



INSTALL THE ROOF UNDERLAYMENT

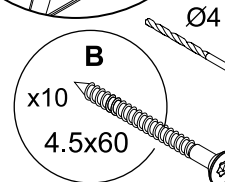
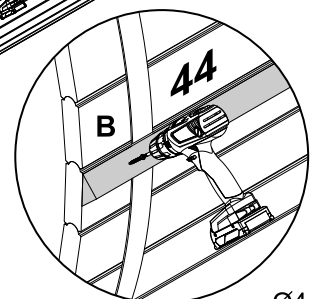
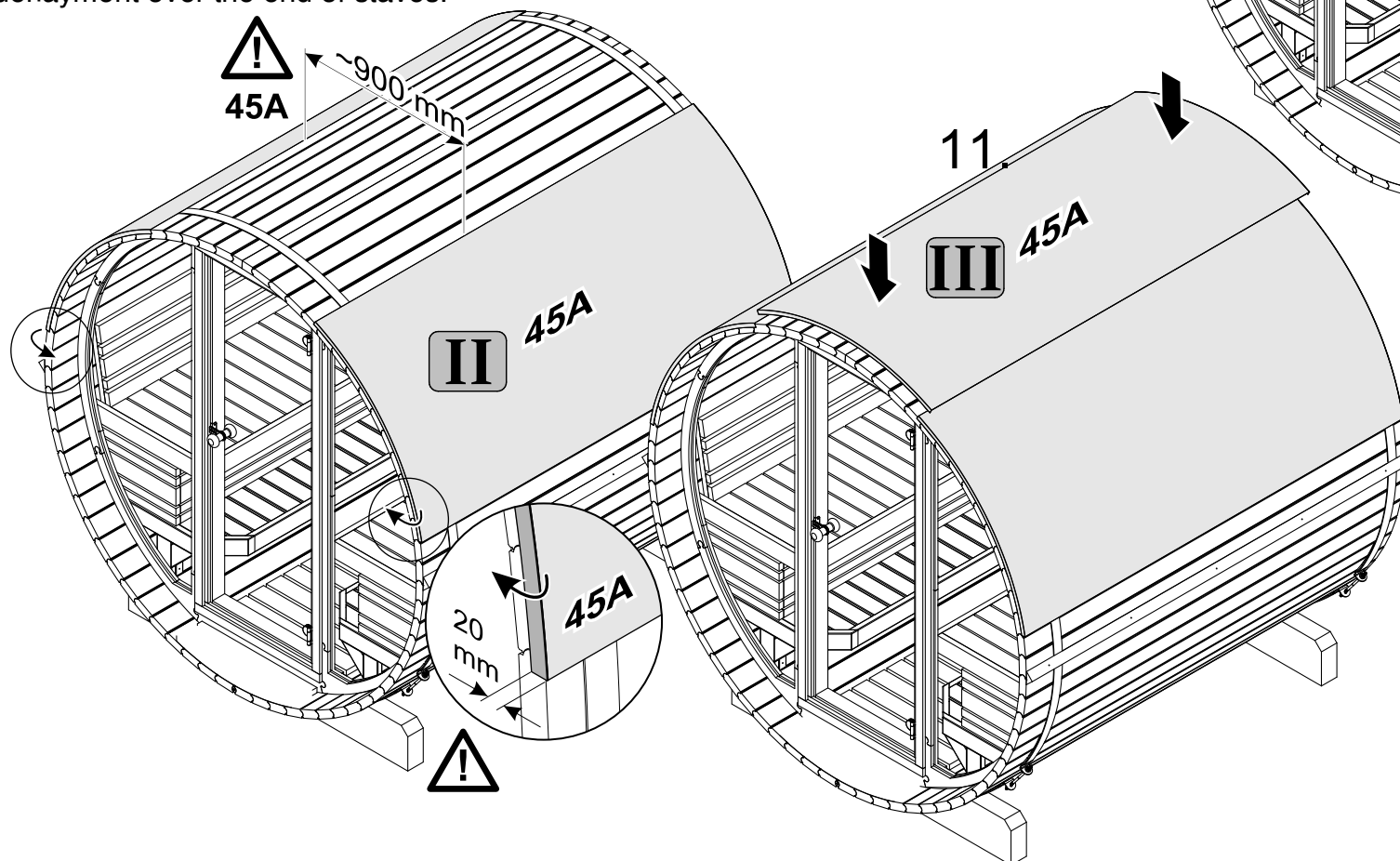
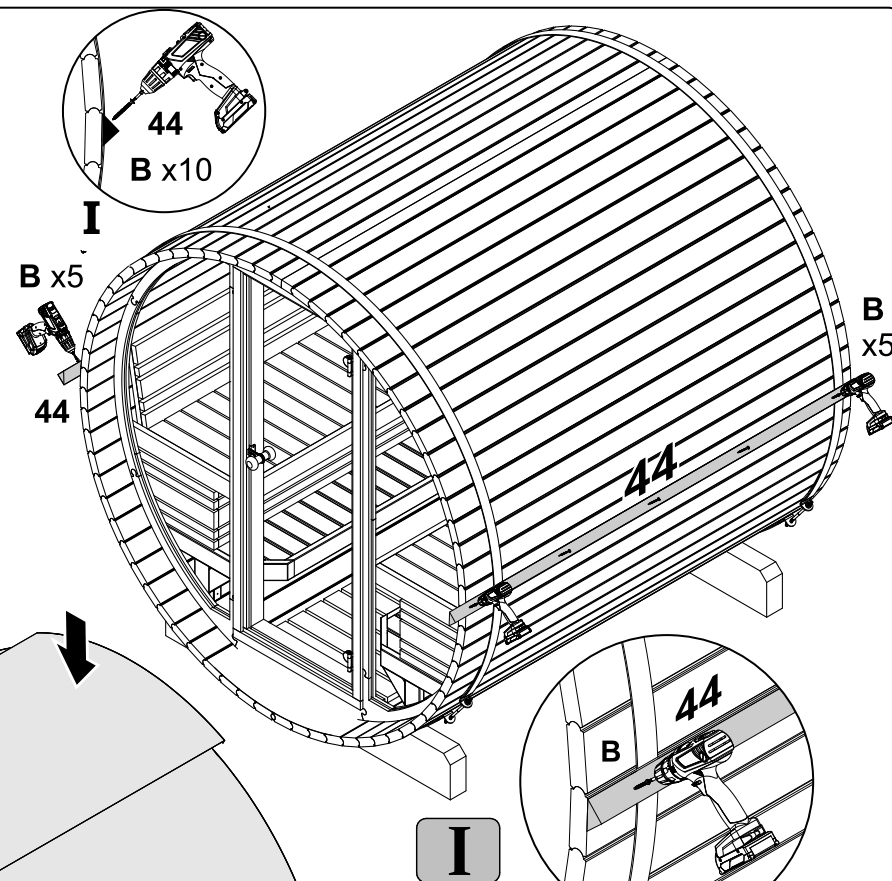
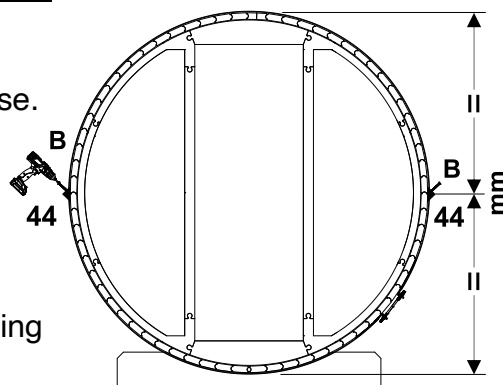
I - Install the roof drip edges on the sidewalls, measure them to the center of the sauna height wise.

II - Install the underlayment onto the roof starting from the drip edge and finish on the side.

Repeat this on the other side. Use a stapler to fix the underlayment. Cut to length if needed.

Install the last piece on the top of the roof overlapping the pieces on the sides.

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



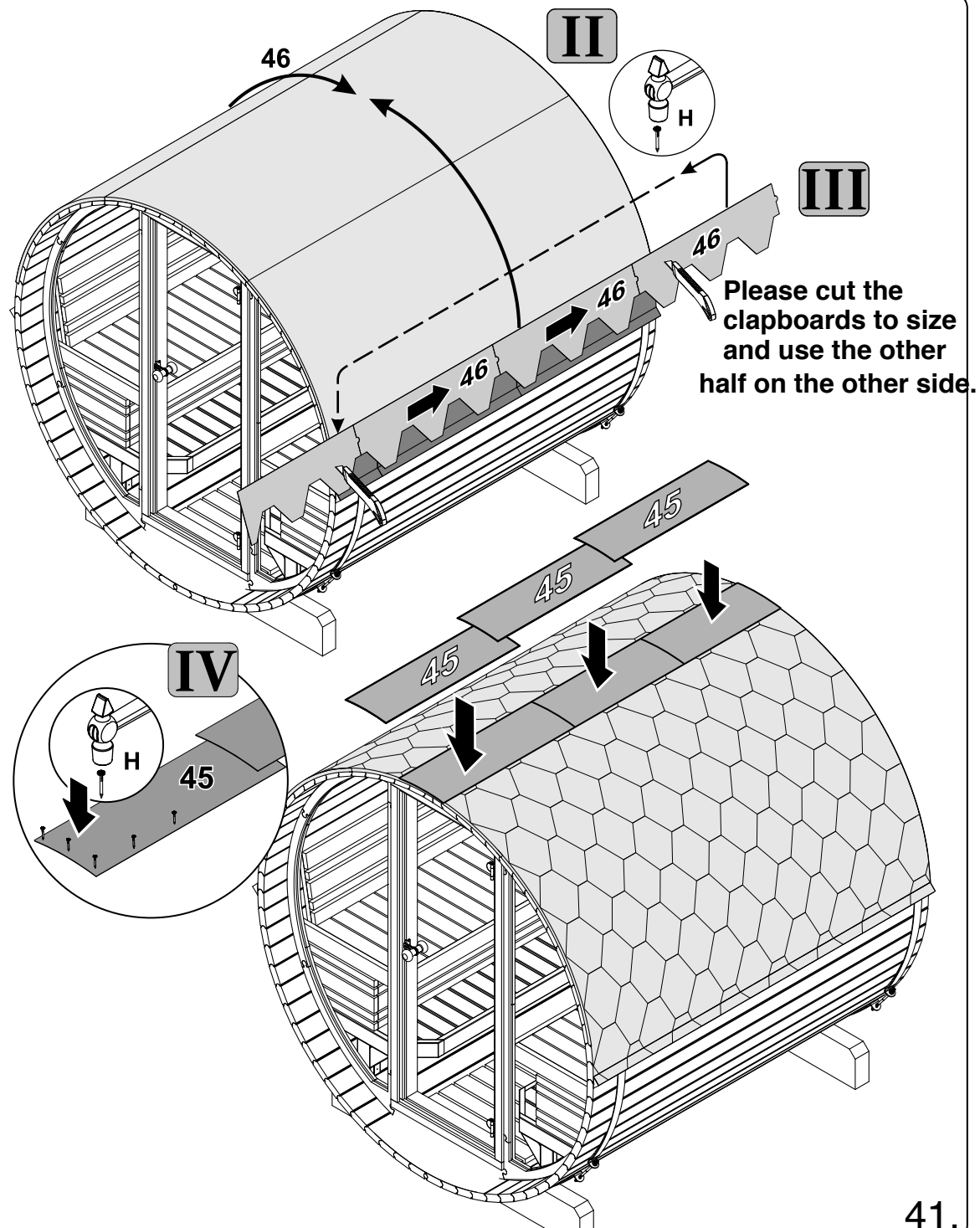
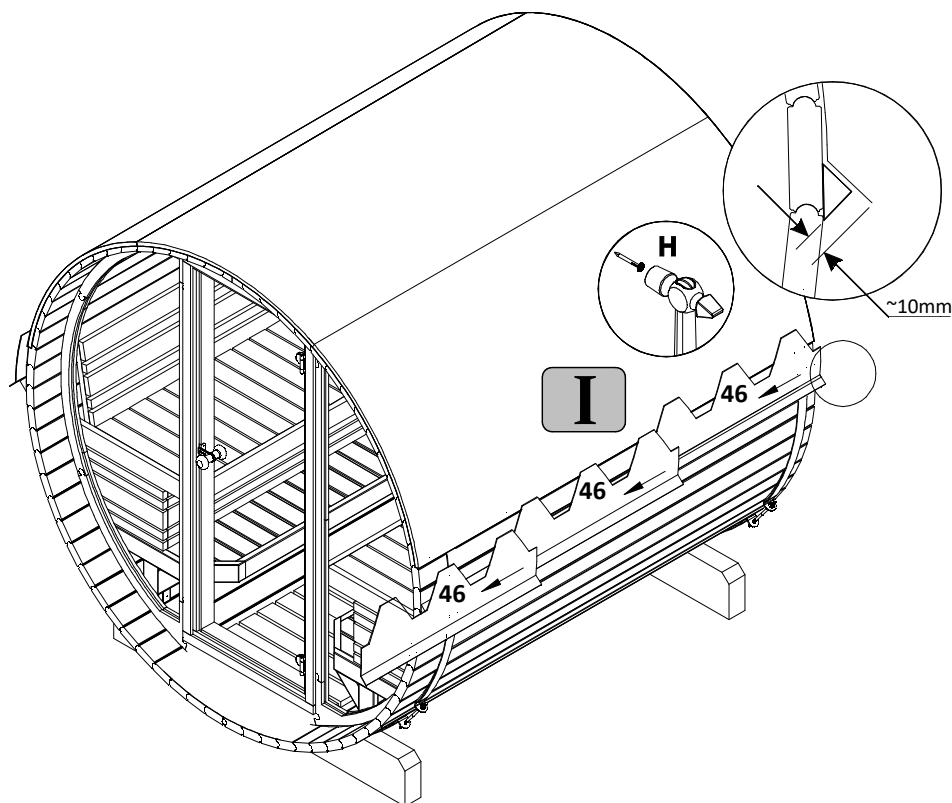
INSTALL THE ROOF SHINGLES

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.

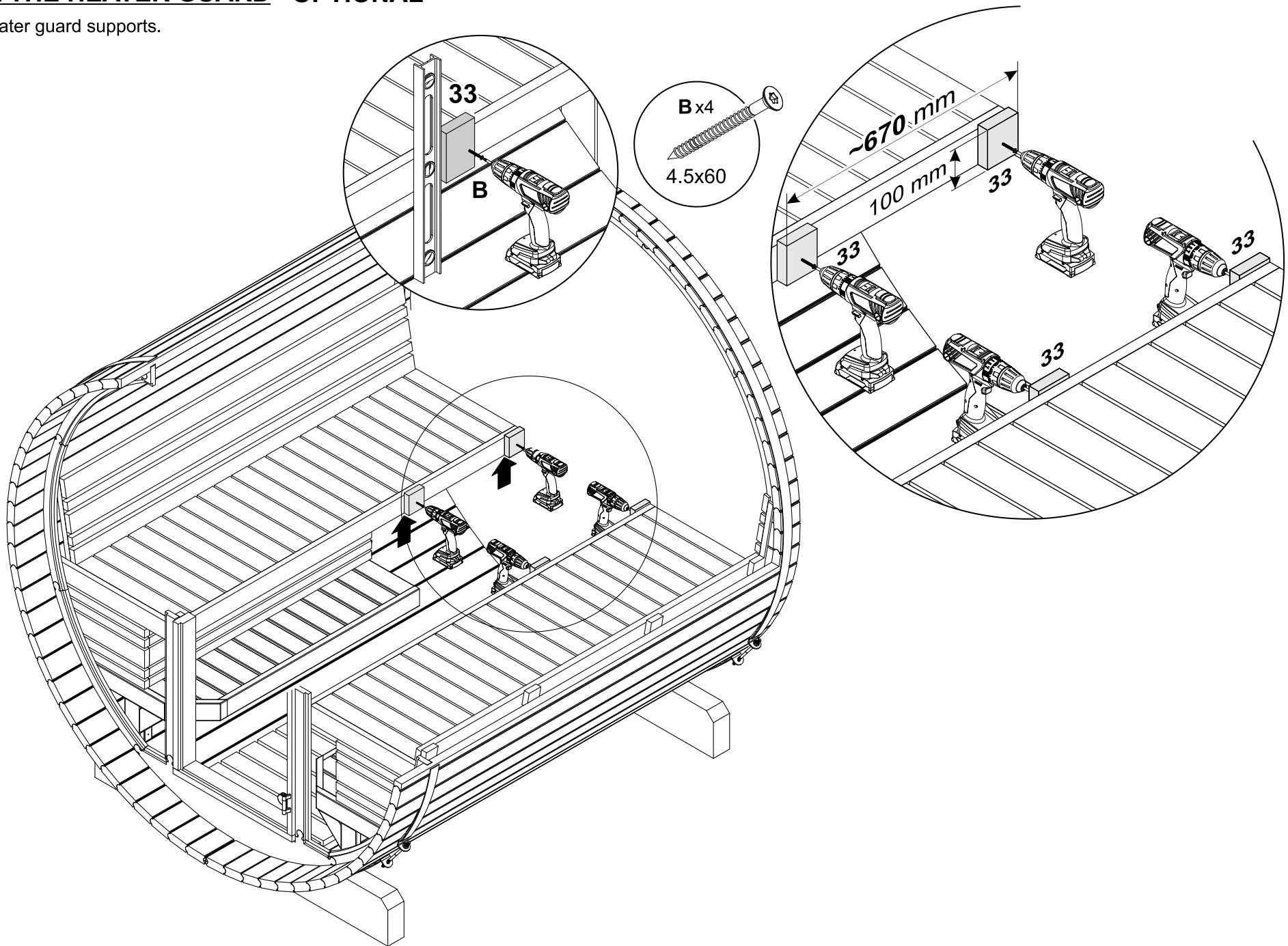
IV - Cover the roof ridge.



PS! Also check the shingles installation manual inside the package.

INSTALL THE HEATER GUARD - OPTIONAL

Install the heater guard supports.



INSTALL THE HEATER GUARD - OPTIONAL

- I - Screw the heater guard parts together.
- II - Install the supports and heater guard.

Please pre-drill the 4mm holes before screwing.

