

# BARREL SAUNA Assembly Manual



## 1. BEFORE YOU START



**IMPORTANT! READ THIS SECTION ENTIRELY  
BEFORE PROCEEDING WITH INSTALLATION.**

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### LOCATION

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Think carefully about where you want to locate the sauna. After you have completed the installation the sauna won't be able to be moved due to its size and weight. The sauna will need to be in a location that can have power access installed. Confirm the electrical supply with your electrician before building the sauna.

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### ELECTRICS - HEATER

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The provided sauna heater must be installed by a registered electrician. No wiring, switches, RCD or electrical accessories are included.

#### **Setup**

Install the heater as per the manufacturer instructions included, along with any electrical protective devices. The heater is to be mounted near ground level on the 'back wall' and surrounded by the provided wooden heater fence.

Cable for the heater can be fed through the back or the base staves. A hole for the conduit will need to be drilled on installation.

## 2. IMPORTANT SAFETY & GENERAL INFORMATION



**PLEASE READ ENTIRE MANUAL THROUGH BEFORE PROCEEDING WITH INSTALLATION.**

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### SAFETY & OPERATION

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**Read all health and safety instructions. If unsure about your health concerns, consult with your physician prior to use. If you feel light-headed or heat exhaustion during session, exit the sauna immediately.**

1. Read and follow all instructions carefully.
2. When installing and using the electrical equipment, basic safety precautions should always be followed.
3. To reduce the risk of injury, do not allow children to use the sauna unless they are closely supervised at all times.
4. Do not use the sauna immediately following strenuous exercise. Wait at least 30 minutes to allow the body to cool down completely.
5. Excessive temperature has a high potential for causing fetal damage during the early months of pregnancy. Pregnant or possibly pregnant women should contact their physician prior to using the sauna.
6. Hypothermia Danger: Prolonged exposure to hot air will induce hypothermia. Hypothermia occurs when the internal temperature of the body reaches a level several degrees above the normal body temperature of 37°C. While hypothermia has many health benefits, it is important not to allow your body's core temperature to rise above 39.4°C. Symptoms of excessive hypothermia include dizziness, lethargy, drowsiness, and fainting.
7. The use of alcohol, drugs, or medications prior to or during the sauna session may lead to unconsciousness.
8. Persons suffering from obesity or with a medical history of heart disease, low or high blood pressure, circulatory system problems, or diabetes should consult a physician prior to using the sauna.
9. Persons using medications should consult a physician before using the sauna since some medications may induce drowsiness while others may affect heart rate, blood pressure, and circulation.
10. Never sleep inside the sauna while the unit is in full operation.
11. **DO NOT** use any type of cleaning agents on the interior of the sauna.
12. **DO NOT** stack or store any object on top of or inside the sauna.
13. If power supply cord becomes damaged it must immediately be replaced by a service technician. Please contact your local dealer for assistance.
14. **DO NOT** use the unit during an electrical storm, as there is a remote risk of shock.
15. Altering or tampering of any electrical connections on the power supply will void the manufacturer's warranty.
16. Dry your hands before handling electrical controls. Never unplug the power cord or adjust the controls with wet hands or when you have wet bare feet. A danger of electrical shock exists.
17. **DO NOT** attempt any repair without consulting the manufacturer first. Unauthorized repair attempts will void the manufacturer's warranty.
18. All natural wood articles have variations in the color, grain, and irregularities such as knots, and fine cracks. These characteristics are a part of the natural beauty of the wood, and in no way should be considered defective.



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## WOOD& EXPECTATIONS

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This Barrel Sauna is designed for outdoor use.

The lumber is naturally resistant to the elements. Rain and sun will not damage the wood, although natural weathering and coloring of the wood will occur over time.

The cedar is rustic cedar, so expect there to be slight imperfections and knots, this gives the barrel sauna its beautiful rustic look and feel. Because of the knots and being softwood, the staves will tend to bend out of line on their own. This is completely normal and will be self corrected as the Sauna is built.

Properly assembled, you should not experience water dripping into the sauna. However, you will experience water seepage, especially on the top and sides of the sauna. This is because of the porous characteristics of the wood and due to the ball-and-socket profile design of the staves.

Water seepage WILL NOT hurt the sauna and in most cases will dry quickly in the hot, dry environment when the sauna is in use. If you wish to keep your sauna completely dry at all times, then you should place it under a covering or structure with a roof.

Light sanding will help to alleviate water stains.

## PARTS LIST

### Installation Parts

| Part Name                 | Label* | Qty               |
|---------------------------|--------|-------------------|
| Regular Staves            | 1      | 64                |
| Starting Bottom Stave     | 2      | 1                 |
| Final Top Stave           | 3      | 5 (Several Sizes) |
| Front Edge Capping        | 4      | 7                 |
| Rear Edge Capping         | 5      | 7                 |
| Front Panel Part 1 (Door) | 6      | 1                 |
| Front Panel Part 2        | 7      | 1                 |
| Front Panel Part 3        | 8      | 1                 |
| Rear Lower Panel          | 9      | 1                 |
| Rear Glass Panel          | 10     | 1                 |
| Internal Glass Surrounds  | 11     | 6                 |
| External Glass Surrounds  | 12     | 7 + 1 Long Edge   |
| Cradle Base               | 13     | 2                 |
| Cradle Base Supports      | 14     | 2                 |
| Base Support Screw Set    | -      | 1                 |

| Part Name                          | Label* | Qty    |
|------------------------------------|--------|--------|
| Inside Floor Panel                 | 15     | 2      |
| Glass Door                         | 16     | 1      |
| Glass Door Hinges (with Allen Key) | 17     | 2 Set  |
| Door Handle, Magnet & Lock         | 18     | 1 Set  |
| Inside Bench                       | 19     | 2      |
| Inside Bench Support               | 20     | 2      |
| Inside Bench Backrest              | 21     | 2      |
| Triangular Roof Beam               | 22     | 2      |
| Heater Fence                       | 23     | 1 Set  |
| Steel Band (3 x Long & 3 x Short)  | 24     | 3 Sets |
| Screws/ Hardware Kit               | -      | 1 Set  |

\*NOTE: The 'Label' column in the above table corresponds to the following page diagram which identifies the pieces for your reference. The physical items are not numbered. Some pieces however (such as the 'starting bottom stave') are physically stickered with their descriptive part name.

### Accessory Parts

| Part Name             | Qty                 |
|-----------------------|---------------------|
| Harvia 6kW Heater     | 1                   |
| Towel Rack            | 1 Set               |
| Magazine Holder       | 1 Set               |
| Cup Holder            | 1 Set               |
| Water Bucket          | 1                   |
| Ladle                 | 1                   |
| Sand Timer            | 1                   |
| Sauna Vents           | 8 (6x65mm & 2x60mm) |
| Hygrometer            | 1                   |
| Bitumen Set           | 1                   |
| Rubber Mallet         | 1                   |
| Window Suction Holder | 2                   |

### Screws (Including Spares)

| Size                   | Qty | Description   |
|------------------------|-----|---|
| 4*40 mm                | 283 | Panel Set securing Piece, Cup Holder, Magazine Rack, Inside Bench, Floor Panels, Front and Back Capping, Towel Rack, Heater Fence |
| 3*30mm                 | 6   | Outside Hook  |
| 3*14mm / 16mm          | 20  | Door Lock and Metal Connector   |
| 5*70 mm                | 8   | Front and Back Panels   |
| 6*35mm                 | 4   | Heater Fence  |
| 6*75 mm                | 2   | Door Handle   |
| 4*30mm                 | 8   | Door Hinges   |
| 3*14mm                 | 258 | Bitumen Roofing, Magnetic Lock  |
| 5*50 mm                | 40  | Fixing Bottom Staves to Support   |
| Metal Connector        | 5   | Binding Glass Surrounds   |
| M8 Moon Nut            | 4   | Cradle Base Supports  |
| M8 Shim                | 4   | Cradle Base Supports  |
| M8 Hex Nut             | 4   | Cradle Base Supports  |
| 100mm Double Side Bolt | 4   | Cradle Base Supports  |
| Plastic Cap            | 5   | Cradle Base   |
| Steel Bands Bolt Set   | 6   | Each set consist of 1x Bolt, 2x M12 Nut with Cap, 2x M12 Nut, 2x Shims, 2x Spacers  |
| 8*40 mm Dowel          | 38  | Securing Edge Capping   |

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## PARTS LABELED

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*NOTE: Appearance of sauna and particular parts may vary from the diagram shown above.*

### 3. PRE-ASSEMBLY CHECKS

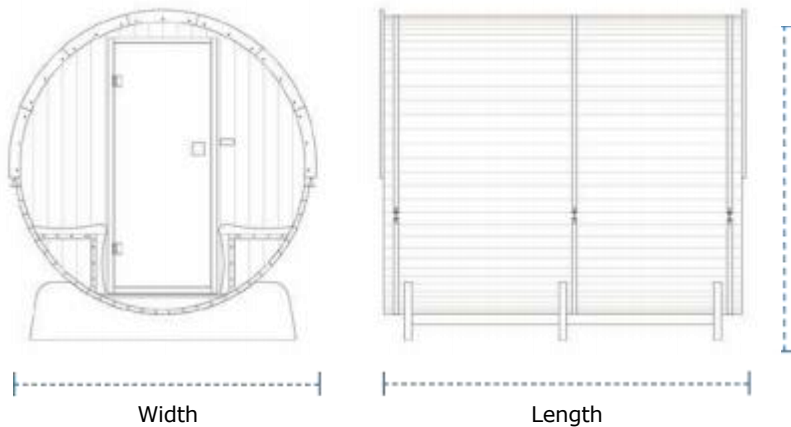
#### FOUNDATION

An outdoor sauna can weigh up to 600kg once assembled, therefore requires a sturdy foundation. This needs to be a flat, level surface that supports the entire weight of the sauna and users. We recommend using either a concrete slab or a pile foundation. The base of the sauna must not rest upon anything that will degrade the quality of the timber (soil, grass etc.)

Your foundation should have some form of drainage or contour, allowing storm water to drain away from the base of the sauna. If you find after creating the foundation that your sauna base does not sit level, use packing shims or similar to correct to level positioning.

Once your outdoor sauna has been assembled, it becomes near impossible to move great distances. Therefore assembling the sauna in its desired location, or very close to, is strongly advised. Moving your assembled sauna can potentially cause damage or alter its performance, which may void the warranty. Refer to the below table for the assembled measurements of your outdoor sauna. Use these as a reference when planning your foundation.

| Item   | Width (cm) | Length (cm) | Height (cm) | Weight (kg) |
|--------|------------|-------------|-------------|-------------|
| Barrel | 190        | 169         | 204         | 420         |



#### Foundation Requirements

Below is a table which covers the minimum dimensions required for an outdoor sauna foundation.

| Item   | Width (cm) | Length (cm) | Thickness (cm)  |
|--------|------------|-------------|-----------------|
| Barrel | 210        | 189         | 10 (Reinforced) |



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## TOOLS

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Tools required include screw drivers set, power drill set, measuring tape, level, mallet, socket set, oiling brush and roller.



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## RESOURCES

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WATERPROOF  
SILICONE  
FOR BITUMEN  
ROOF

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## OPTIONAL

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STAPLER ASSISTS  
WITH ATTACHING  
BITUMEN ROOFING

## 4. INSTALLATION INSTRUCTIONS

- 1** Stand the two cradle bases, equal distance apart matching the length of the two cradle support lengths. Take some time to note the dowels at the ends of the support lengths, and the grooves in the cradles.



- 2** Screw the 100mm double sided bolt into the pre-drilled hole



- 3** Slot the two cradle support lengths onto the two bolt ends of the cradle base



- 4** Secure the cradle support lengths by placing the half moon steel washer, standard washer and nut on to each thread appearing on the end of the cradle base. Tighten the nut using a socket set



- 5** Make sure each support is tightly fixed to the cradle base. Use a tool with a 90 degree edge to make sure each support sits square to the cradle.



- 6** Start by locating the 'bottom stave'. This stave will have one vent hole pre-drilled. Fit the bottom stave into the centre of the cradle bases using the provided dowels (the rear vent should sit close to the back cradle base)



- 7** Begin to lay 2 x staves on either side of the mounted centre stave. Gently tap the 2nd stave inwards and hold the pressure while securing with a '5\*50mm' screw. Repeat the same at the rear. Only securing every 2nd stave is required. Continue to do this on either side until you have successfully installed 7 x staves on each side of the centre stave.



- 8** Double check you have not missed any sides of the base supports or side struts. While the base is upside down, install the 4x black hole covers over the base support mounting bolts. Use the rubber hammer to tap them in.



## 4. INSTALLATION INSTRUCTIONS

- 9** locate the 3 segments of the front wall and lay these onto a clean workbench. Using the tongue and grooves, slot each side piece into the centre segment, making sure all the edges are flush and the bench supports are located at the bottom. Use the 4 x 5\*70mm screws and screw them into each order of the front panel.



- 10** Gently lift the front wall into place. While one person holds it in place, level the front wall with the base structure (use the door frame to help and NOT the bench supports). Secure the levelled front wall in place using a 4\*40mm screw on both sides. Continue to support this wall as wind can blow it over.



- 11** Locate the back halfwall and position it into place. Make sure the 2x pre-drilled vent holes are central with the centre bottom stave and level it before securing with the 4\*40mm screws.



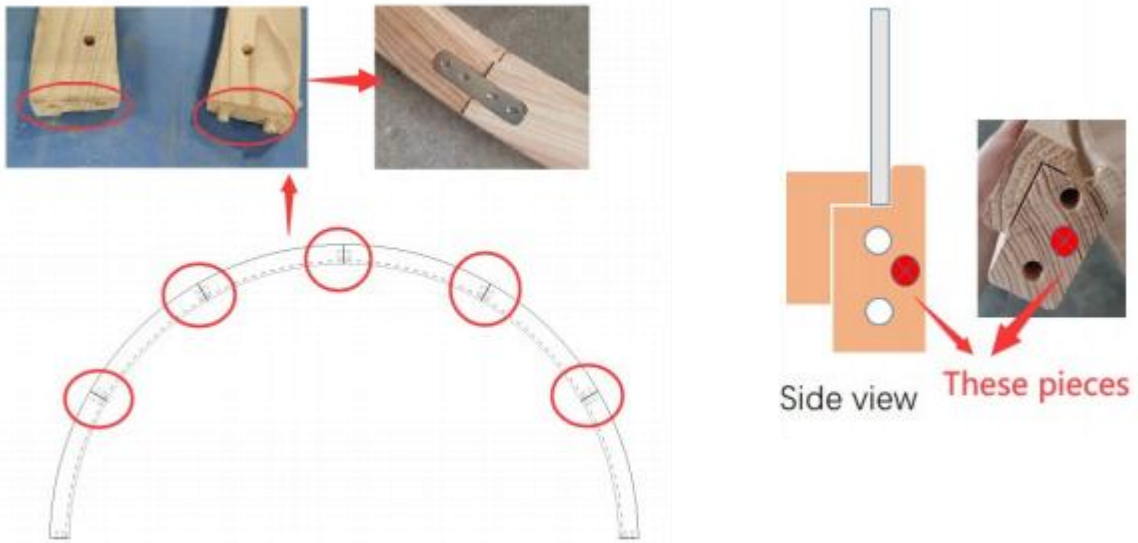
- 12** Install 10x more staves onto either side of the barrel. Use a rubber mallet to gently tighten up the staves as you go. Use '4\*40mm screws' to fix the 20x new staves one-by-one to the front & back panels. Please note: Now the staves are screwed into the front and back wall, the screw position for adding these staves should no longer be in the centre of the stave. The correct positioning for the screw should be on the top edge as per the below image. This allows for some movement when adding additional staves, particularly the top stave.



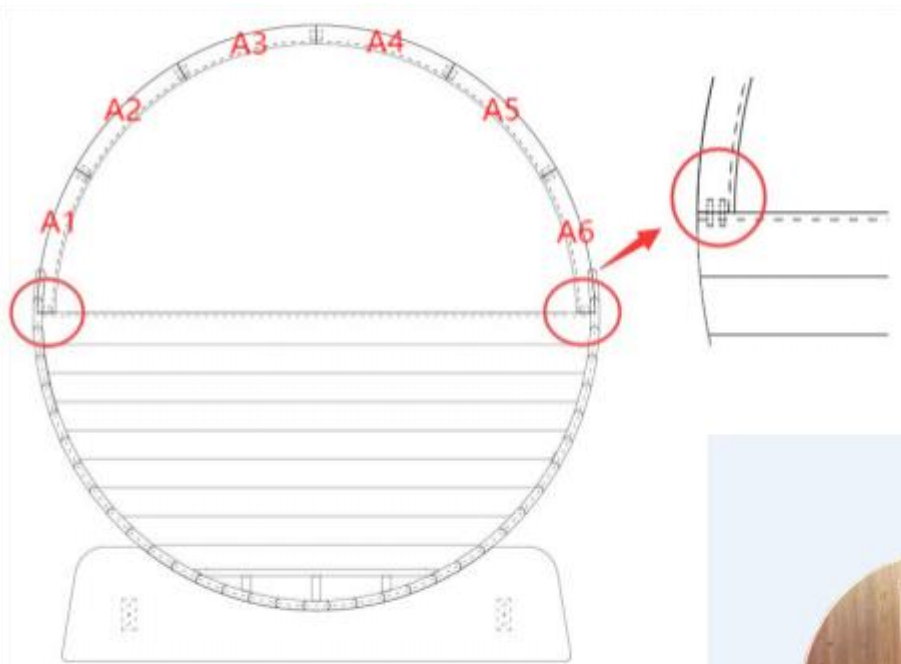
**TIP:** Continue to check that each side is even as you build the walls up. The last stave should be secured at the top.

## 4. INSTALLATION INSTRUCTIONS

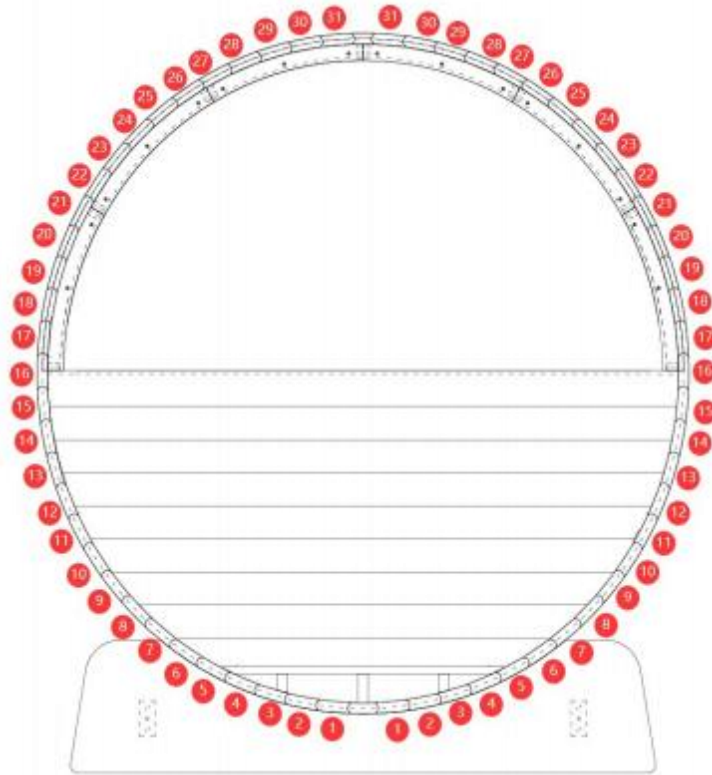
- 13** Connect the glass window wooden frames by wood plugs & metal pieces (Sharped head screws 3\*14mm).



- 14** Install the glass window wooden frame above the half wooden back panel, **then connect them securely by two screws 4\*40mm.**  
**IMPORTANT:** Should need a person to hold on the glass window wooden frame



- 15** Install the balance 14pcs staves (Following No.18-No.31) on each side forwards the top BUT DO NOT WITH SCREWS!!!!



- 16** At this point our final gap between the staves can vary, this is why we provide several sized final staves to account for this. You will need to tap the loose top staves outwards and measure the gap to gain a better idea on what top centre staves you require. Repeat this on the back and take note of the measurements.



- 17** If the front and rear dimensions are different, you will need to take the measurement between the two staves, for example our front dimension was 85mm and our rear was 95mm, so we used the D-Staff and a top centre stave to create a 90mm wide stave to fill the gap.

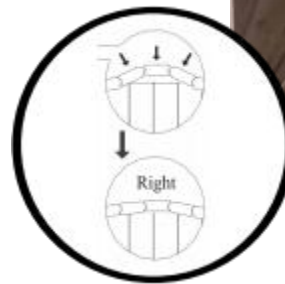


**18** Secure the two staves together using the 3\*30mm screws



**19** These staves should only need a light tap to lock into position.

Making it too tight might result in the front and rear wall segments to separate. Minor gaps between staves are OK as we will install metal bands later which will put it all tight.



**20** Install the glass window:

1) Grab the 2 window suction holders and secure these to the glass window, test to make sure they're attached correctly. With two people, carefully position the glass into the bottom groove in the rear wall. Make sure you have someone holding the rear glass window keeping it into position, and then secure the straight long wood to the bottom with 4\*40mm screws.



**21** Locate the 7 external glass surrounds. Position the first one at the top in the center of the glass. Secure this in place using the 4\*40mm screws. Then continue to install 3 more evenly on either side.



## 4. INSTALLATION INSTRUCTIONS

- 22** Locate your steel bands and remove the blue protective tape. Once you have removed the blue tape, separate the 3 long bands and the 3 short bands. Feed a short band under the base.



- 24** Once all 3 bands are in place and bolted together, adjust the heights of the six bolts so they are level on both sides. Tighten them evenly using a 19mm tube socket and 19mm ring spanner. While the bands are being tightened, gently tap the top loose staves with the rubber hammer to help them lock into place.



- 23** Then lay a long band over the top in line with the short band. Using the bolts provided, join the two ends of each band together but do not tighten yet. Repeat this on the rear and in the middle. The bands should remain on the outside of the rear base support.



- 25** Count to the 16th stave up from the bottom stave (bottom centre stave not counted) on each side of the sauna and pencil a mark for the drip edge to be secured. Fasten each beam with 5x '4\*40mm' screws across the length of the sauna on each side. The drip edge should sit level with the top edge of the 16th stave.



## 4. INSTALLATION INSTRUCTIONS

- 26** Install the vent guards in the back wall, internal floor and front wall. Gently tap these in using a flat surface to prevent denting.

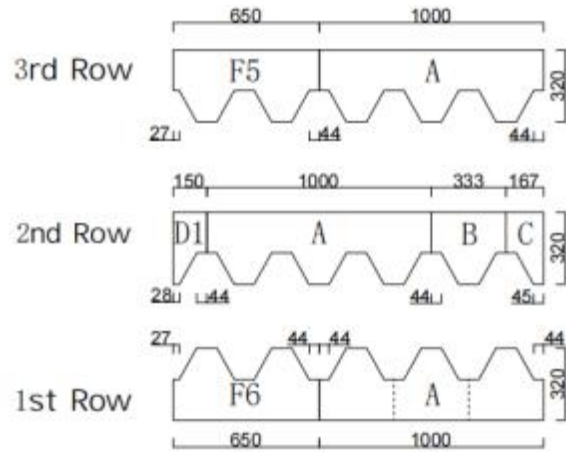


**TIP:** You may need to bend out the small nodes of each vent using a flathead screwdriver or chisel.

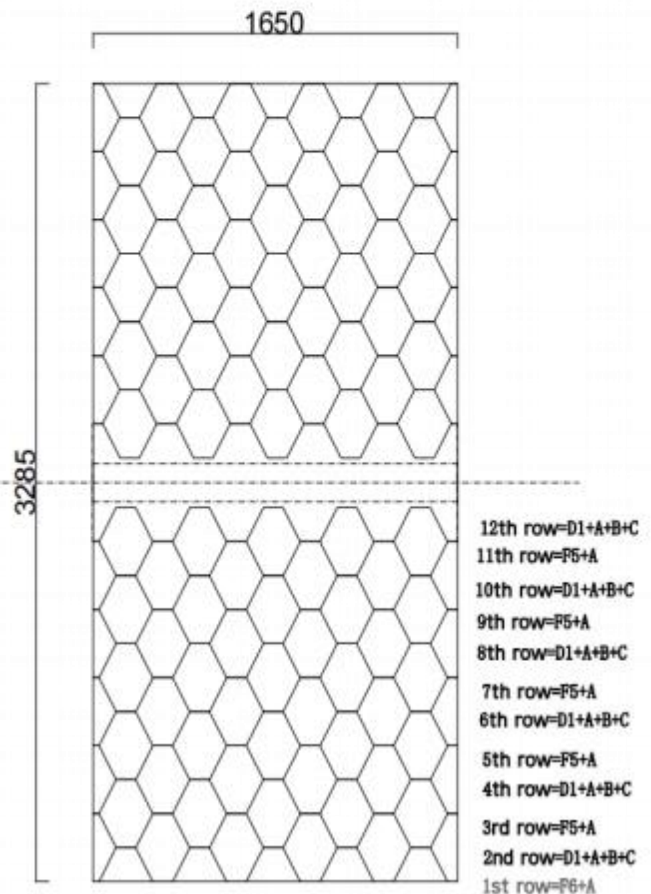
- 28** Position segment F6 along the drip edge, making sure the flat part of the segment is flush with the bottom of the drip edge. Secure these using a staple gun. **BE SURE TO STAPLE & SCREW AT THE TOP OF THE RIDGE SO IT WILL BE COVERED BY THE NEXT LAYER.** Use 3 -4 of the provided 3x14mm screws to secure each segment in place.



- 27** Locate the packs of bitumen rooftiles and arrange them into their shapes.



|    |        |
|----|--------|
| A  | 26 pcs |
| B  | 13 pcs |
| C  | 13 pcs |
| D1 | 13 pcs |
| F5 | 11 pcs |
| F6 | 2 pcs  |



**29** Once the first layer is secure, position a D1 segment next and secure in place. Make sure to always start at the front edge and to make sure the segments are flush. Then continue to install the A and E segments using staples to hold the segment in place and then the 3x 14mm screws to securely mount it. Remember to staple and screw at the top.



**30** Continue to follow these steps and lay each layer on top of the previous. Follow the layer guide for each side of the sauna.



**32** Locate the decorative boards and begin to install these, start from the top centre and work your way down. The last 2 boards on either side may extrude over the drip edge. If this is the case, hold the decorative board in place, mark it and trim the drip edge & bitumen tile as required. Repeat this at the back.

**31** Before installing the last centre top layer of bitumen apply a generous layer of sealant to the underside of the tile and carefully position it into place. DO NOT STAPLE OR SCREW THIS TILE. Firmly press down on the areas where sealant was applied, creating a waterproof seal.



## 4. INSTALLATION INSTRUCTIONS

- 33** Locate the 2 piece internal floor panels and position these in place. Ensure these are level and pushed as far forward towards the front wall as possible, this is to leave breathing room under the heater. Secure these in place using the 4\*40mm screws.



- 35** Secure it in place using 2x 4\*40mm screws into the predrilled holes on the side supports. Repeat this on the other side.



- 34** Position the bench support in place, the vertical supports which extrude higher should be at the bottom. Make sure there is a 10mm gap between the pre-installed side bench support and the front bench support.



- 36** Lay the bench seat on top and position it into place. Secure the ends into the pre-mounted side supports on both sides using 4\*40mm screws.



**37** Locate the backrest and position it into place. Centralize it and secure it on each end using the 4\*40mm screws



**38** Now locate the heater fence and bolt these together using the 6\*35mm. Make sure the larger gap in the guard is mounted at the bottom, this is to allow access to the heat control dials.



**39** Position the assembled guard in the centre of the 2 bench seats on the rear wall. Measure 90mm off the floor and make a mark. This will be used for the height of the guard. (We used a piece of 90mm thick timber to give us our height.) Make sure the guard is flush and central between the bench seats, and secure using the 4\*40mm screws in the pre-drilled holes.

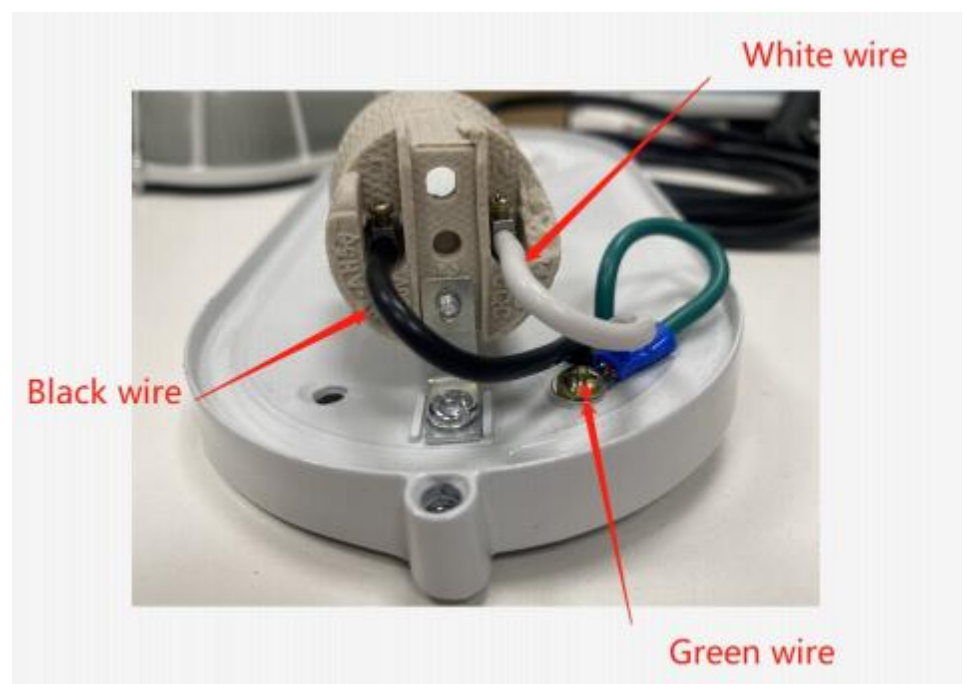


**40** Install the door handle using the 6\*75mm screw. Be sure to put the oiled handle on the outside.



**41** Connect the light with the power cord.

- 1) Unscrew the light cover
- 2) Three wires are gotten through the hole
- 3) Connect the wires to the access of the light like below instruction by screws



## WARRANTY

One-year limited warranty on electrical, heater and cabinetry parts only.

Limited warranty on Sauna replacement parts. We warrant its products to be free of defects in material and workmanship. Parts, which become defective within the warranty period, will be repaired except for damage due to negligence, abuse, misuse, misapplication, unauthorized modifications, improper installation, or normal wear and tear. We will not cover any labor costs attributable to disassembly and reassembly of the unit. We will not be responsible for labor costs of the routine maintenance, adjustments or alterations to the calibration of the electrical devices.

Any parts claimed to be defective must be shipped freight prepaid, to us and the repaired or replaced product will be returned to the sender freight collect. When sent to us, the product must be accompanied by the sales receipt or other proof of purchase date, as well as the sender's name, mailing address, daytime telephone number and any other information relating to the sender's claim.

This warranty is extended only to the original purchaser and terminated upon transfer of ownership. This warranty shall not apply to any product or component used in any industrial, rental, club or commercial purpose. This warranty shall not apply to any claims arising from the misuse, neglect, accident, abuse, improper installation, including but not limited to exposure to fire or to excessive heat, and other hazards of nature. Under no circumstances will the manufacturer be liable for any special or consequential damages arising from the use of the product, components, and the parts attached, or installed with it. Nor for injury to any person, any claims for damages arising from the use, installation or servicing of the product. The purchaser is responsible for providing adequate access to the equipment so that any necessary service may be performed. The purchaser must establish, by dated sales slip, invoice or deliver receipt, the date of purchase. All costs for removing and reinstalling the sauna including the freight charges to and from customer shall be at the customer's expense.

REGARDLESS OF THE WARRANTY CARD BEING RETURNED WITHIN THE SPECIFIED TIME PERIOD. THERE SHALL BE NO WARRANTIES OR OBLIGATIONS: EXPRESS OR IMPLIED HEREUNDER. SPECIFICALLY EXCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, OTHER THAN SPECIFICALLY DESCRIBED HEREIN. NO LIABILITY SHALL ACCURE TO OUR EXCEPT AS SETFORTH HEREIN.