

# **BARREL SAUNA**

## **Assembly Manual**





**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 Panel 1	9	1
Rear Panel 2	10	1
Rear Panel 3	11	1
Cradle Base	12	2
Cradle Base Supports	13	2
Base Support Screw Set	-	1

Part Name	Label*	Qty
Inside Floor Panel	14	1
Glass Door	15	1
Glass Door Hinges (with Allen Key)	16	2 Set
Door Handle, Magnet & Lock	17	1 Set
Inside Bench	18	2
Inside Bench Support	19	2
Triangular Roof Beam	20	2
Heater Fence	21	1 Set
Steel Band	22	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 9) are physically stickered with their descriptive part name.

### Accessory Parts

Part Name	Qty
Heater	1
Water Bucket	1
Ladle	1
Sand Timer	1
Hygrometer	1
Bitumen Set	1
Rubber Mallet	1
Light	1
Sauna Vents	7 (6x65mm & 1x60mm)

### Screws (Including Spares)

Size	Qty	Description
4*40 mm	250	Panel Set securing Piece, Inside Bench, Floor Panels, Front and Back Capping, Heater Fence, Bench supports
3*14mm	8	Door Lock and Metal Connector
5*70mm	10	Front and Back Panels
6*35mm	4	Heater Fence
6*75mm	2	Door Handle
4*30mm	6	Door Hinges
3*16mm	230	Bitumen Roofing, Magnetic Lock
5*50 mm	40	Fixing Bottom Staves to Support
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	4	Cradle Base
Steel Bands Bolt Set	6	Each set consist of 1x Bolt, 2x M10 Nut, 2x Shims
8*40 mm Dowel	36	Securing Edge Capping and bench supports

## PARTS LABELED



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

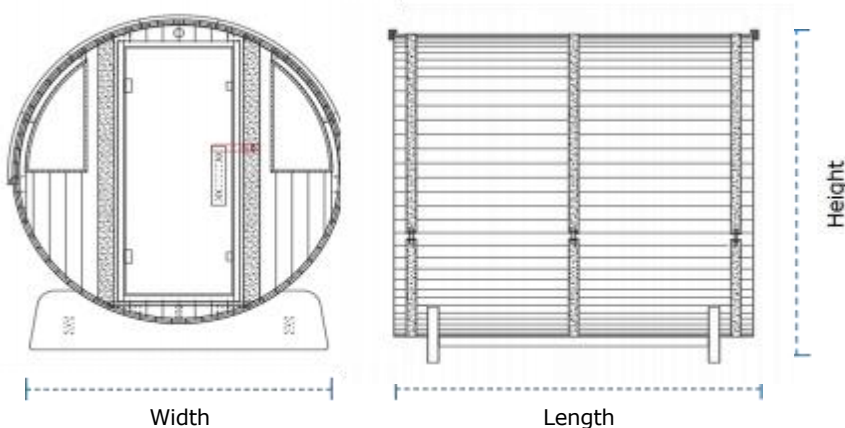
## FOUNDATION

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)	
Barrel	185	149	201	



## 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	205	169	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 half wall 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 9 x 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 18x 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** Install 15x more staves on either side of the barrel but DO NOT fasten with screws yet. You may need wiggle room to place the last stave - it is designed to be tight. Use a rubber mallet to gently tighten up the staves as you progress.



**14** 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.



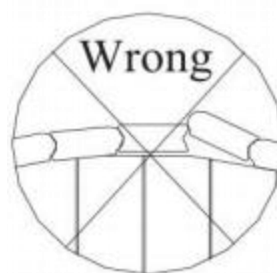
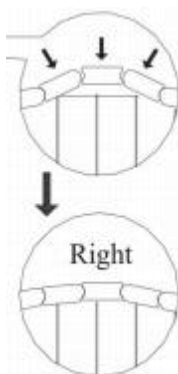
**15** If the front and rear dimensions are different, you will need to take the measurement between the two staves, for example our front dimension was 85mm and our rear was 95mm, so we used the D-Stave and a top centre stave to create a 90mm wide stave to fill the gap.



**16** Top piece provided with 5 sizes. Choose the one or two pieces that fits. Secure the two staves together using the 4 \*40mm screws.



**17** 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.





**18** Locate your steel bands and remove the blue protective tape.

Steel strip assembly---**Caution! Sharp Edge! Protective gloves needed.**

**Each of the steel strip assemblies** are made of the following components:

- (1) Bolt (1pcs)
- (2) Nuts (2pcs)
- (3) Shims (2 pcs)

Place stainless steel bands with pre-assembled brackets around sauna/spaced evenly apart. The two end stainless steel bands should cover the nails you used to hold the staves in place during assembly. Insert threaded rod through the bracket. Tighten nuts evenly so that the bands are of equal tension. Before tightening nuts/check to make sure bands are still even. Tighten nuts and install black vinyl thread protectors. You may place the brackets at the same level or vary them at different heights depending on our styling preference.



**19** Once all 3 bands are in place and bolted together/adjust the heights of the bolts so they are level on both sides. While the bands are being tightened gently tap the top loose staves with the rubber hammer to help them lock into place.



**20** 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.

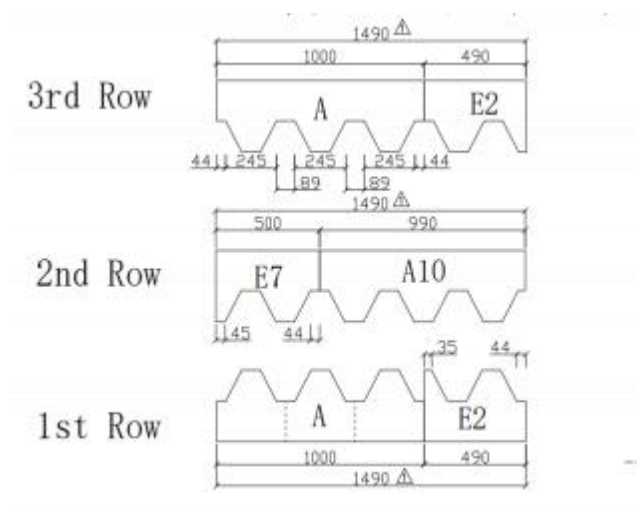


**21** Install the vent guards in the back wall/ internal floor and front wall. Gently tap these in using a flat surface to prevent denting.



## 4. INSTALLATION INSTRUCTIONS

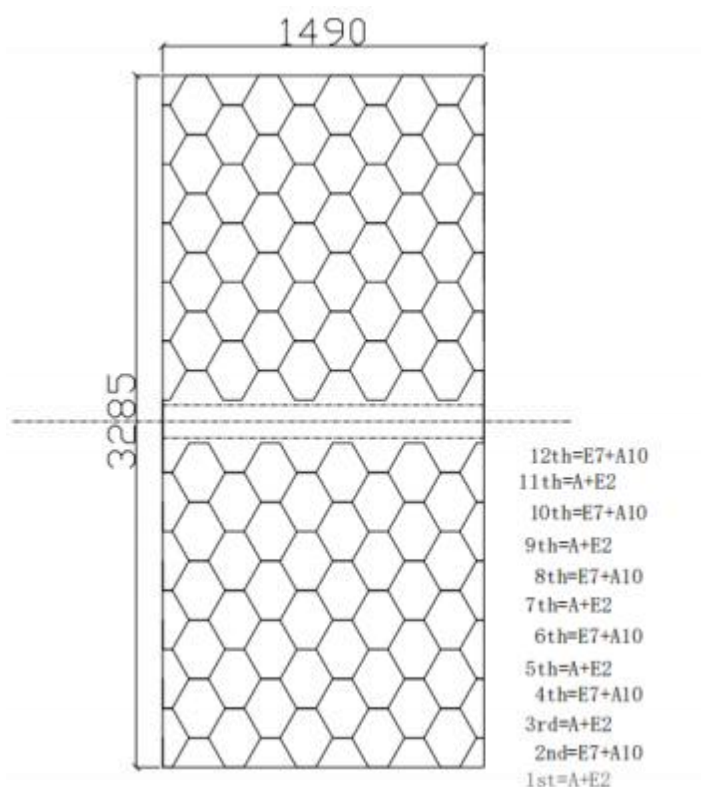
**22** Locate the packs of bitumen rooftiles and arrange them into their shapes.



A = 13pcs  
A10 = 13pcs  
E7 = 13pcs  
E2 = 13pcs

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

**23** Position segment A 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 3x16mm screws to secure each segment in place.





**24** 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 16mm screws to securely mount it. Remember to staple and screw at the top.



**26** 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.



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



**27** 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.





## 4. INSTALLATION INSTRUCTIONS

**28** Locate the 1 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.



**30** Install the bench leg supports on each side and secure with 2x 4\*40mm Screws.



**29** Install the benches inside in the barrel. Place the long benches onto the sides of the barrel using the supports at the front and back panels. In the center on the benches underneath/ install the 20cm \Inside bench support beam/ onto the side of the barrel wall using 2x 4\*40mm Screws/. Then screw the bench from the topside down into the support beams.



**31** 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.



**32** 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.



**34** Install the door handle using the 6\*75mm screw.



**36** Install the door lock using a 3\*16mm screw. Mount the magnetic catches at the top and bottom of the door frame using the provided 3x16mm screws.



**33** Secure the hinges to the glass door using the provided hinges and allen key. Position the door in place and secure the hinges to the recessed frame using the 4\*30mm screws.

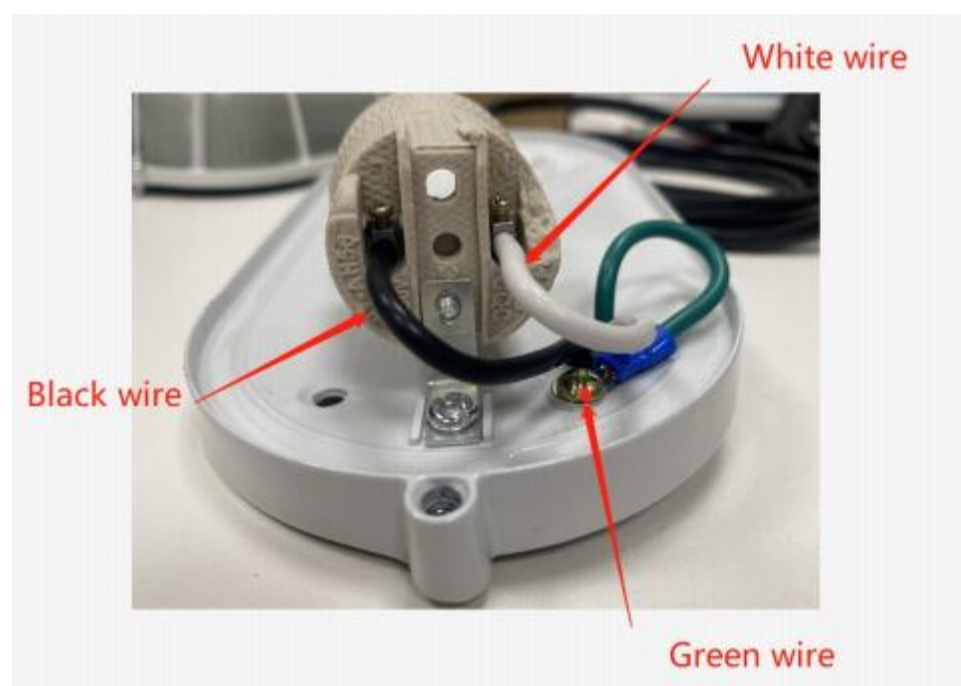


**35** The door lock is a simple slot, connect and screw system. Slot the handle piece through the pre-drilled hole and connect the locking bar. Secure the lock bar to the handle with 2x '3\*14mm' screws.



**37** 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.

THIS UNIT IS MEANT FOR INDOOR USE ONLY. WARRANTY IS VOIDED IF THIS INFRARED SAUNA IS PLACED IN AN OUTDOOR ENVIRONMENT.

Infrared Sauna replacement parts come with a limited warranty. We warrant its products to be free of defects in material and workmanship. Parts, that 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 suggest customers replace the carbon heater after one year for better sauna experience.

Labor costs associated with the disassembly and reassembly of the unit are not covered under this policy. We will not be responsible for labor costs of the routine maintenance, adjustments or alterations to the calibration of the electrical devices.

All parts claimed to be defective must be shipped to us with freight prepaid. The repaired or replaced product will be returned to the sender on a freight-collect basis. When returning the product to us, it must be accompanied by the sales receipt or other proof of purchase date, along with the sender's name, mailing address, daytime telephone number, and any additional information pertinent to the claim.

This warranty is granted solely to the original purchaser and shall be void upon transfer of ownership. This warranty shall not apply to any product or component used for industrial, rental, club, or commercial purpose. This warranty shall not apply to any claims arising from the misuse, neglect, accident, abuse, or improper installation, including, but not limited to, exposure to fire, excessive heat, and or other hazards of nature. Under no circumstances will shall the manufacturer be liable for any special or consequential damages arising from the use of the product, components, or any parts attached, or installed with it thereto. Nor shall the company be liable for injury to any person, or for any claims for damages arising from the use, installation, or servicing of the product. The purchaser is responsible for providing ensuring that adequate access to the equipment so that is provided to facilitate the performance of any necessary service. The purchaser must establish provide proof of the purchase date through a dated sales slip, invoice or deliver receipt, the date of purchase. All costs for removing and reinstalling associated with the removal and re-installation of 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.

### Warnings

The warranty for our saunas is strictly limited to one year and applies exclusively to residential use. Any commercial application, outdoor installation, improper usage, or continuous operation exceeding 3,000 hours will render the warranty void and may result in safety risks or compromised performance.