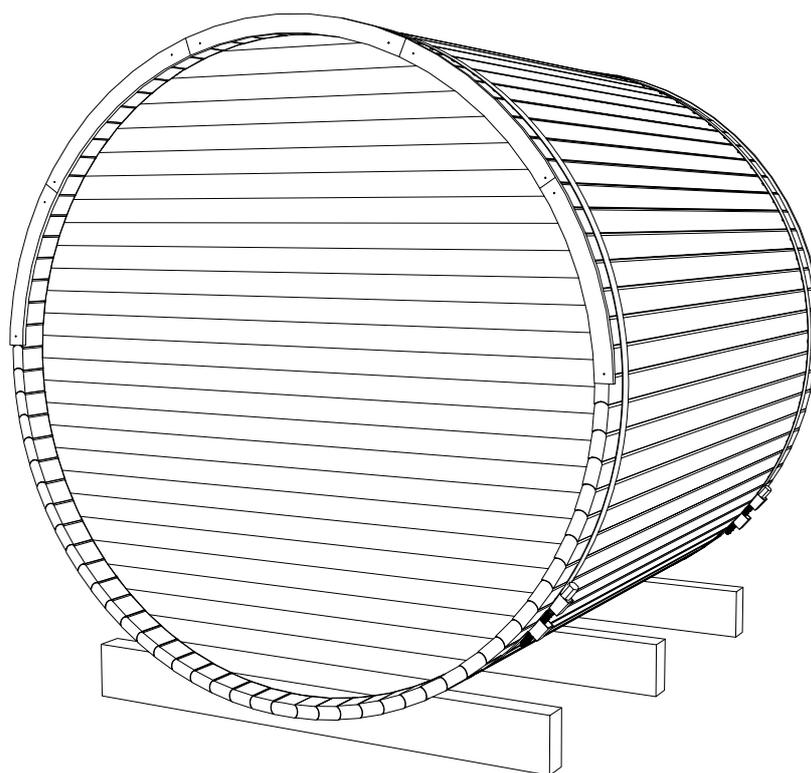
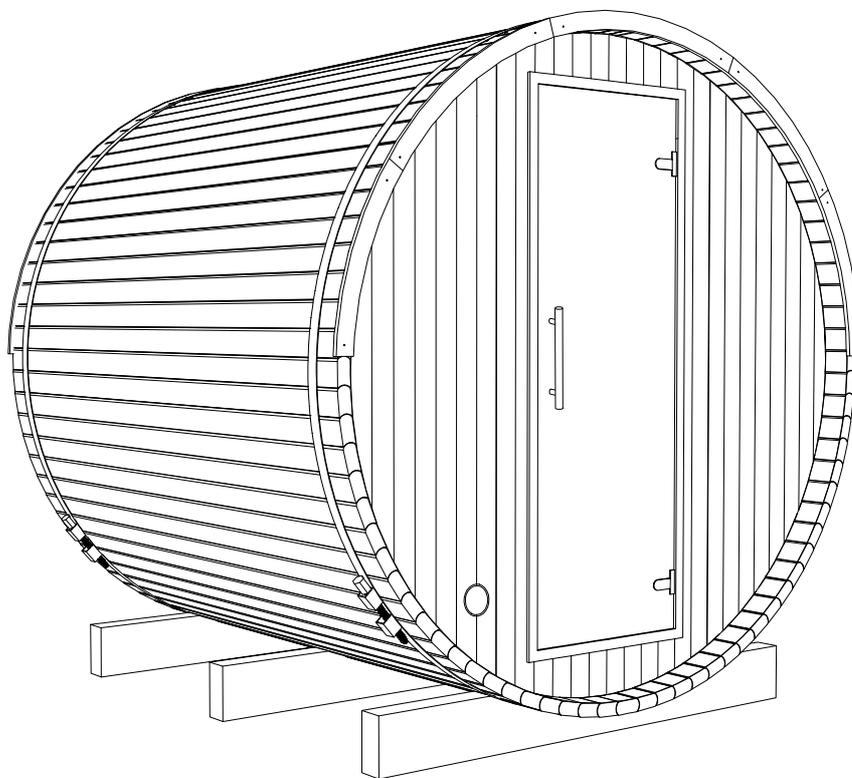


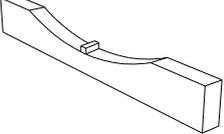
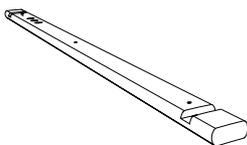
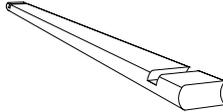
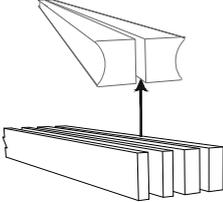
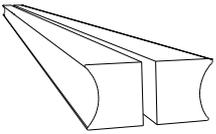
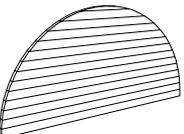
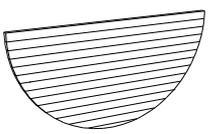
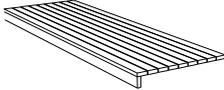
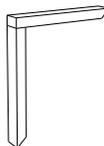
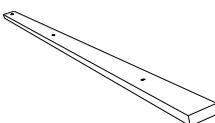
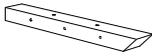
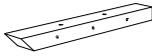
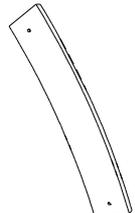
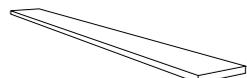
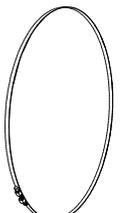
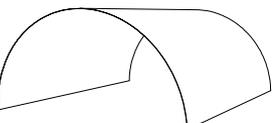
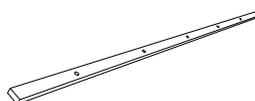
# BARREL SAUNA

## ASSEMBLY INSTRUCTION



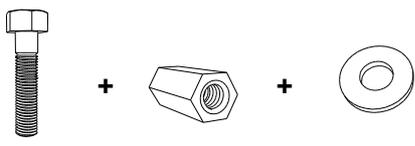
MODEL: R-190-180 (No 53)

# PART LIST

<p><b>A</b> x3</p> 	<p><b>B</b> x1</p> 	<p><b>A</b> x76</p> 	<p><b>H1</b> x4</p> 	<p><b>H</b> x2</p> 
<p>cradle</p>	<p>center stave</p>	<p>left side body stave</p>	<p>different thickness Filling peaces</p>	<p>final H tipe stave at the top</p>
<p><b>V3</b> x1</p> 	<p><b>F</b> x1</p> 	<p><b>F1</b> x1</p> 	<p><b>F2</b> x1</p> 	<p><b>V</b> x1</p> 
<p>upper rear panel</p>	<p>left panel section</p>	<p>right panel section</p>	<p>door panel</p>	<p>bottom rear panel</p>
<p><b>J</b> x2</p> 	<p><b>J1</b> x2</p> 	<p><b>J2</b> x6</p> 	<p><b>J4</b> x2</p> 	<p><b>J3</b> x2</p> 
<p>sauna bench</p>	<p>supporting leg</p>	<p>backrest stave</p>	<p>wall mount</p>	<p>wall mount</p>
<p><b>L</b> x2</p> 	<p><b>L1</b> x6</p> 	<p><b>W</b> x10</p> 	<p><b>O</b> x1</p> 	<p><b>I</b> x2</p> 
<p>Flooring duckboard</p>	<p>Fixing block for Flooring duckboard</p>	<p>decorative roof Finishing board</p>	<p>aspen roof board</p>	<p>metal band</p>
<p><b>Z</b> x1</p> 	<p><b>Z1</b> x2</p> 	<p><b>S1</b> x50</p> 	<p><b>S6</b> x30</p> 	<p><b>S7</b> x25</p> 
<p>Waterproof roof cover</p>	<p>Slat for roof cover</p>	<p>screw 5.0x100 SS</p>	<p>screw 5.0x70 SS</p>	<p>screw 4.2x55 brown</p>

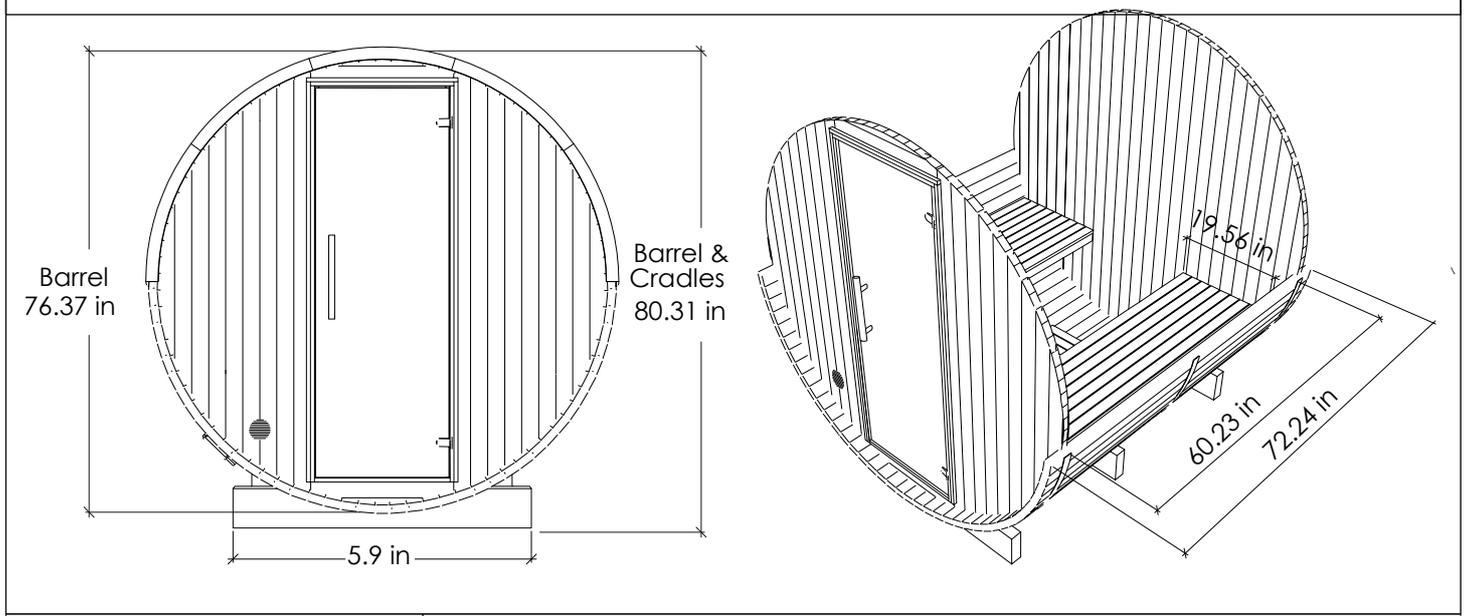
**PART LIST**

<p><b>S2</b> x190</p> 	<p><b>S5</b> x40</p> 	<p><b>S4</b> x8</p> 		
<p>screw 4.0x70</p>	<p>screw 4.0x50 SS</p>	<p>screw 5.0x120</p>		

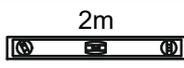
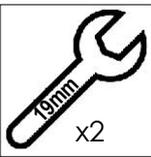
<p><b>S9</b> x2 + x2 + x4</p> 				
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<p>bolt ø12x140</p>	<p>hex nut M12 (SW19)</p>	<p>Flat washer</p>
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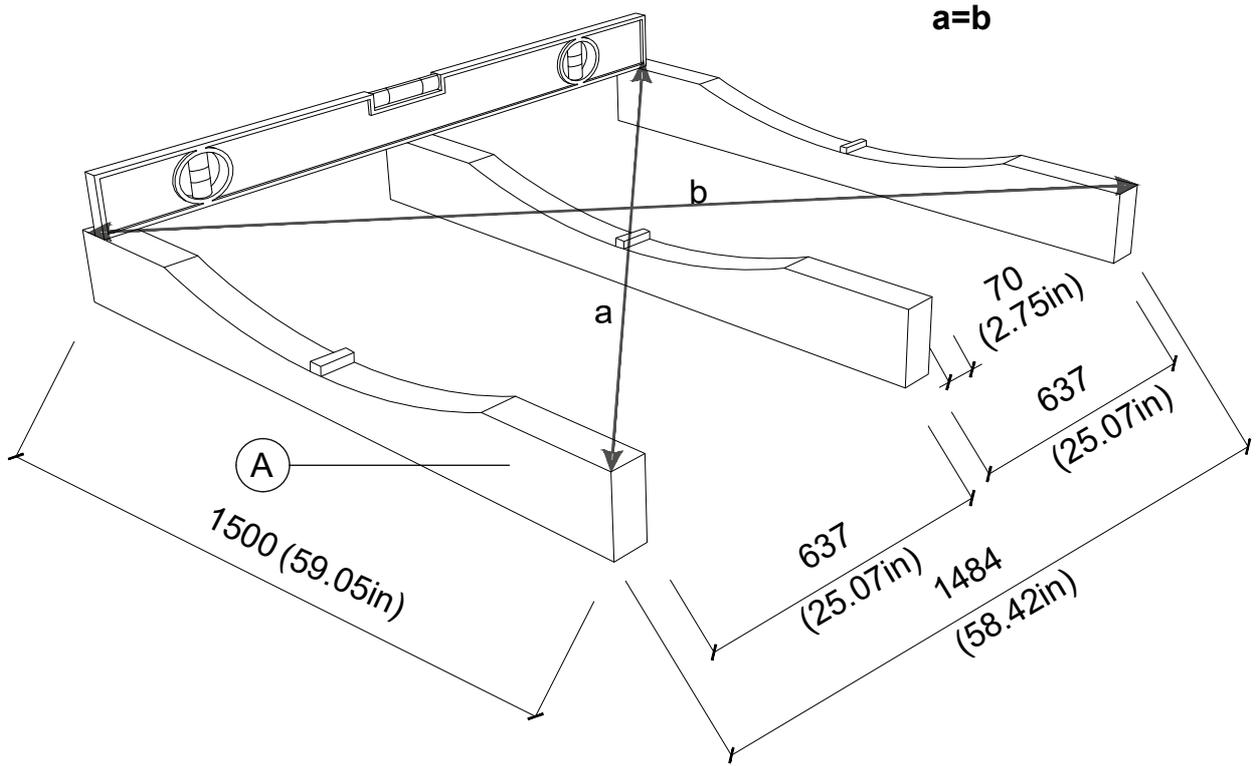
**BARREL DIMENSIONS**



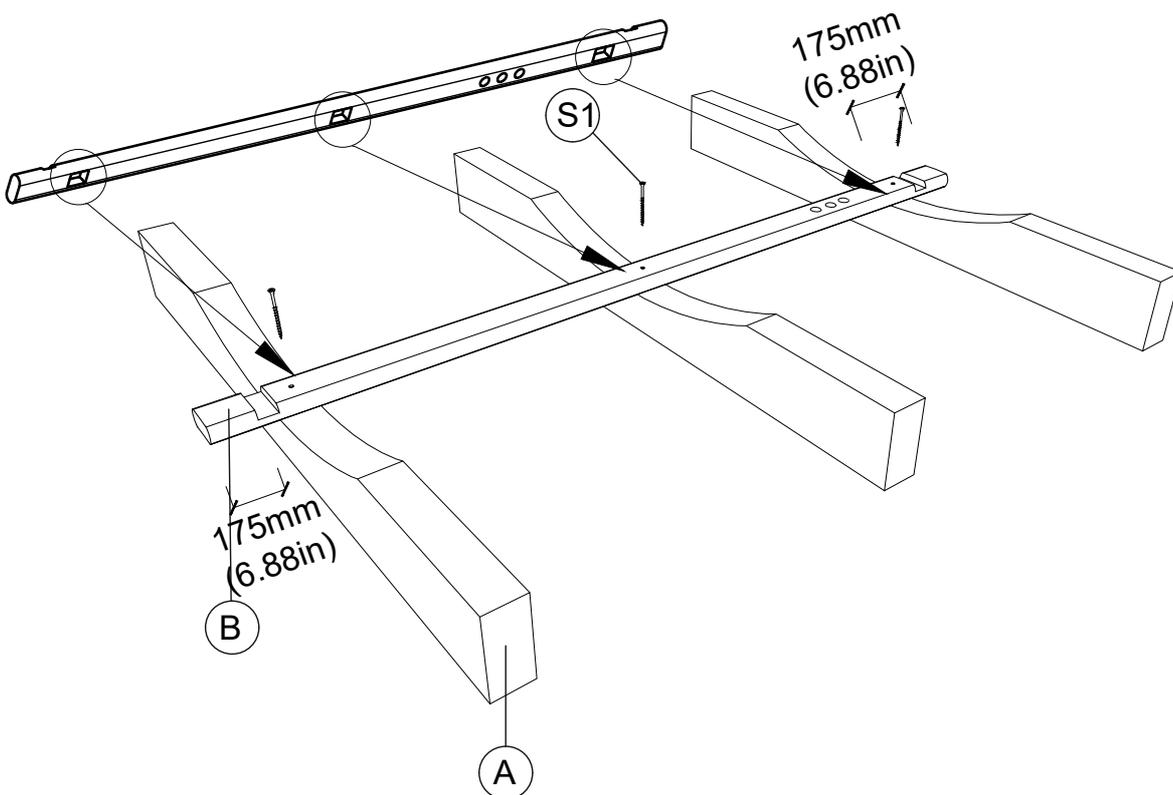
RECOMMENDATION	TOOLS REQUIRED
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 <p>2 person recommended</p>	       
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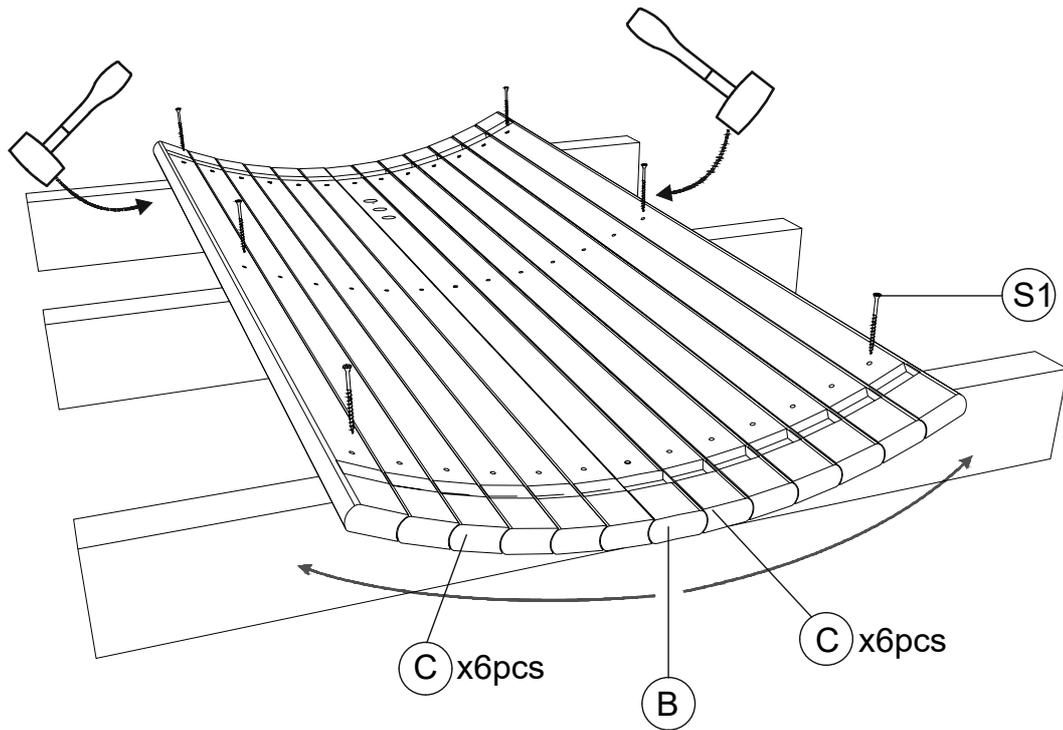
STEP 1: Measure support cradles (A) diagonally from corner to corner. Measurements "a" and "b" should be equal to ensure the cradles are square. Be sure cradles remain level.



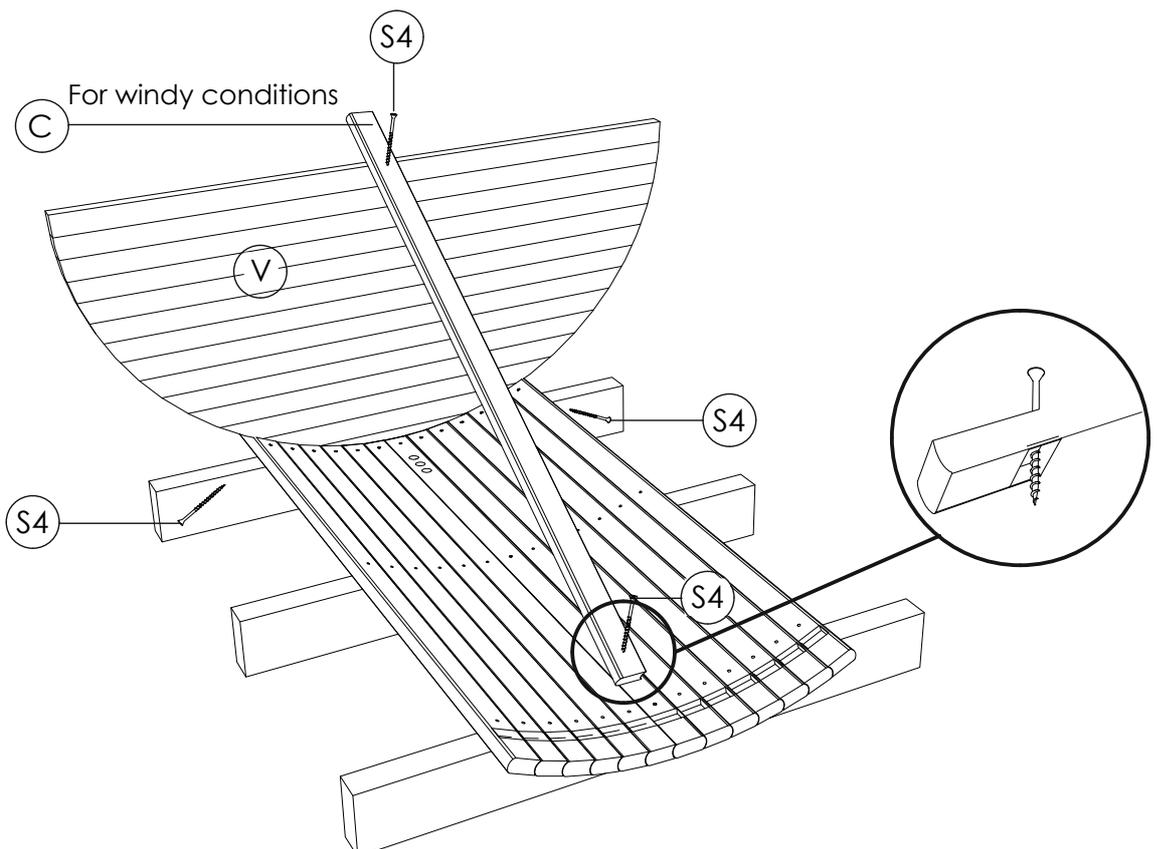
STEP 2: Place the support cradles (A) on level site. Carefully level for better stability. Place the center stave (B) on wooden dowels embedded in outer support cradles (A). Fix the center stave (B) with 5.0x100 SS(S1).



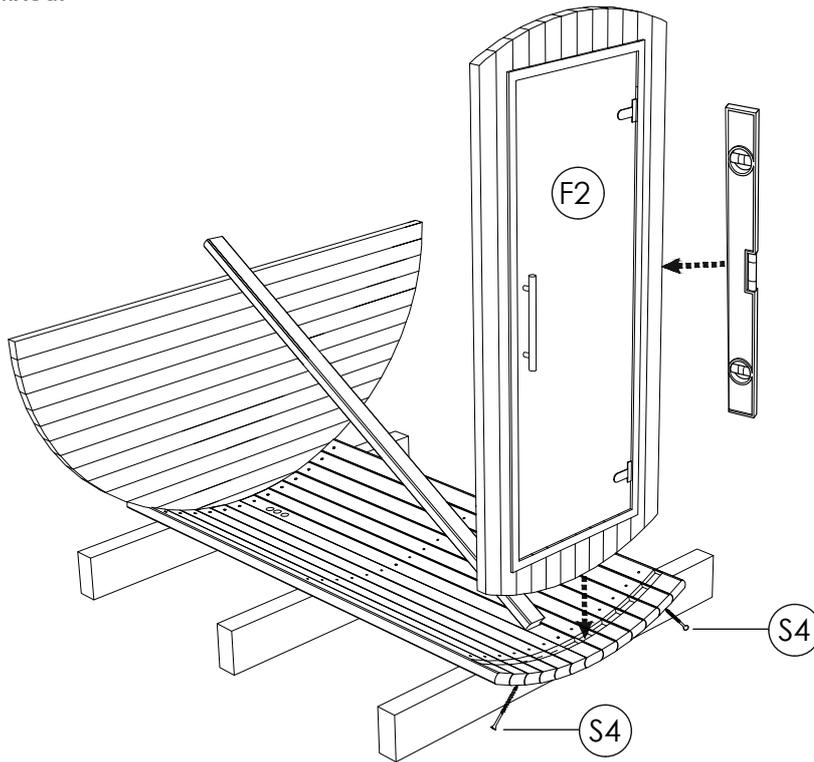
STEP 3: Place 6 sauna body staves (C) to each side of the center stave (B) and fix with screws 5.0x100 SS (S1). Be sure to align the panel groove on every next body stave, to do that use rubber hammer.



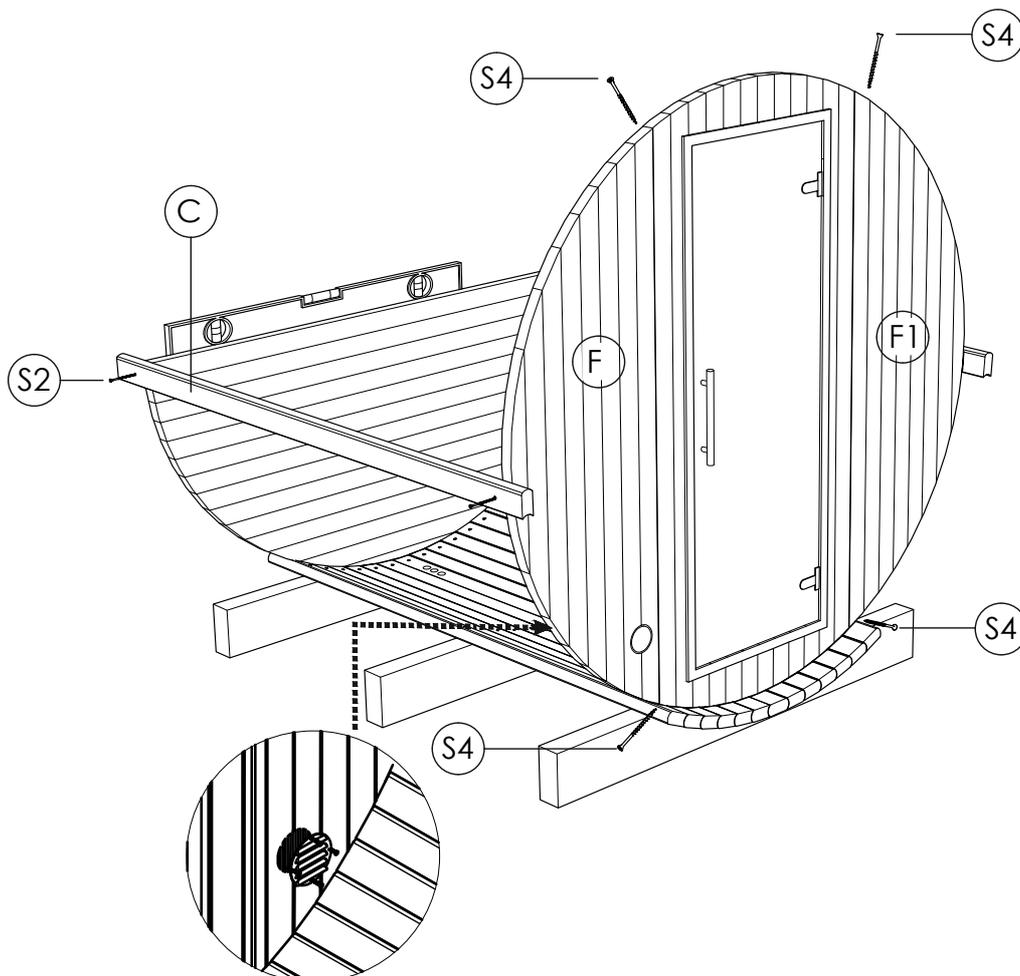
STEP 4: Place rear panel (V) in stave groove, be sure panel is centered, leveled, completely seated. Fix panel using 5.0 x 120 (S4) screws through last floor stave on both sides.



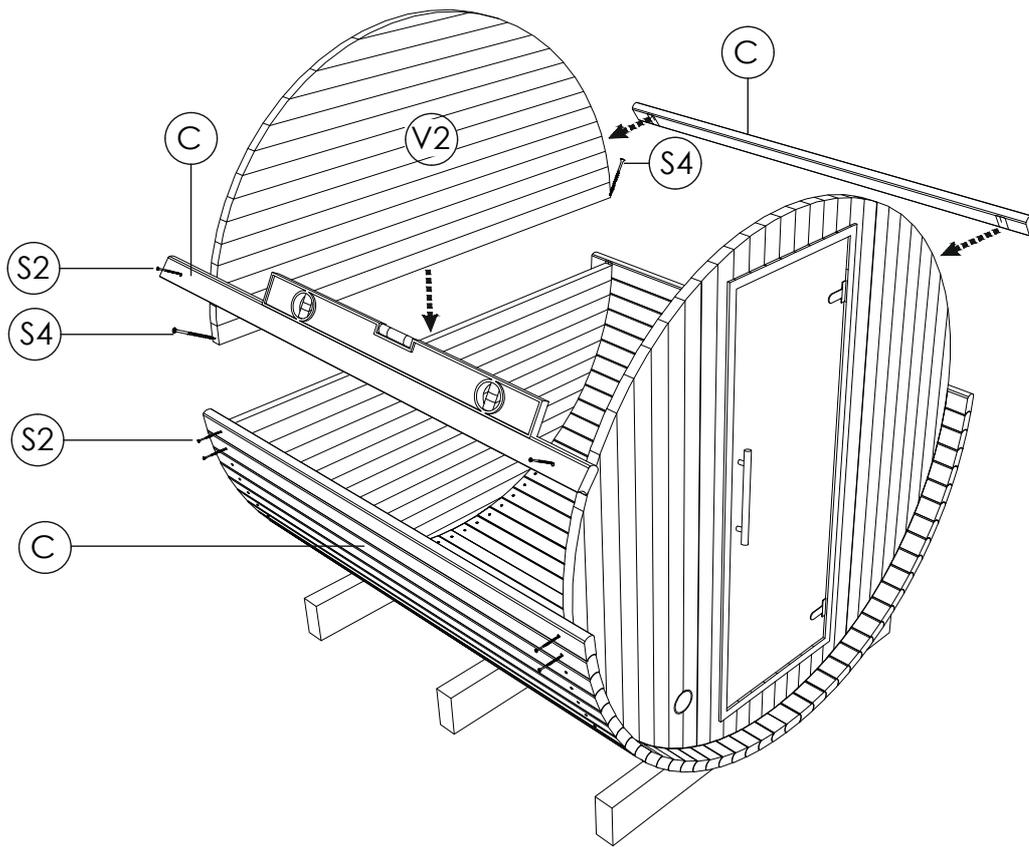
**STEP 5:** To install the door panel (F2), place it in the groove in front of the stave. Make sure that the panel is centered, level, and completely seated. Then, use two screws (S4) that are 5.0 x 120 in size to fix it on each side of the last stave from underneath. For safety purposes, it is recommended that one person hold the door panel while it is being fixed.



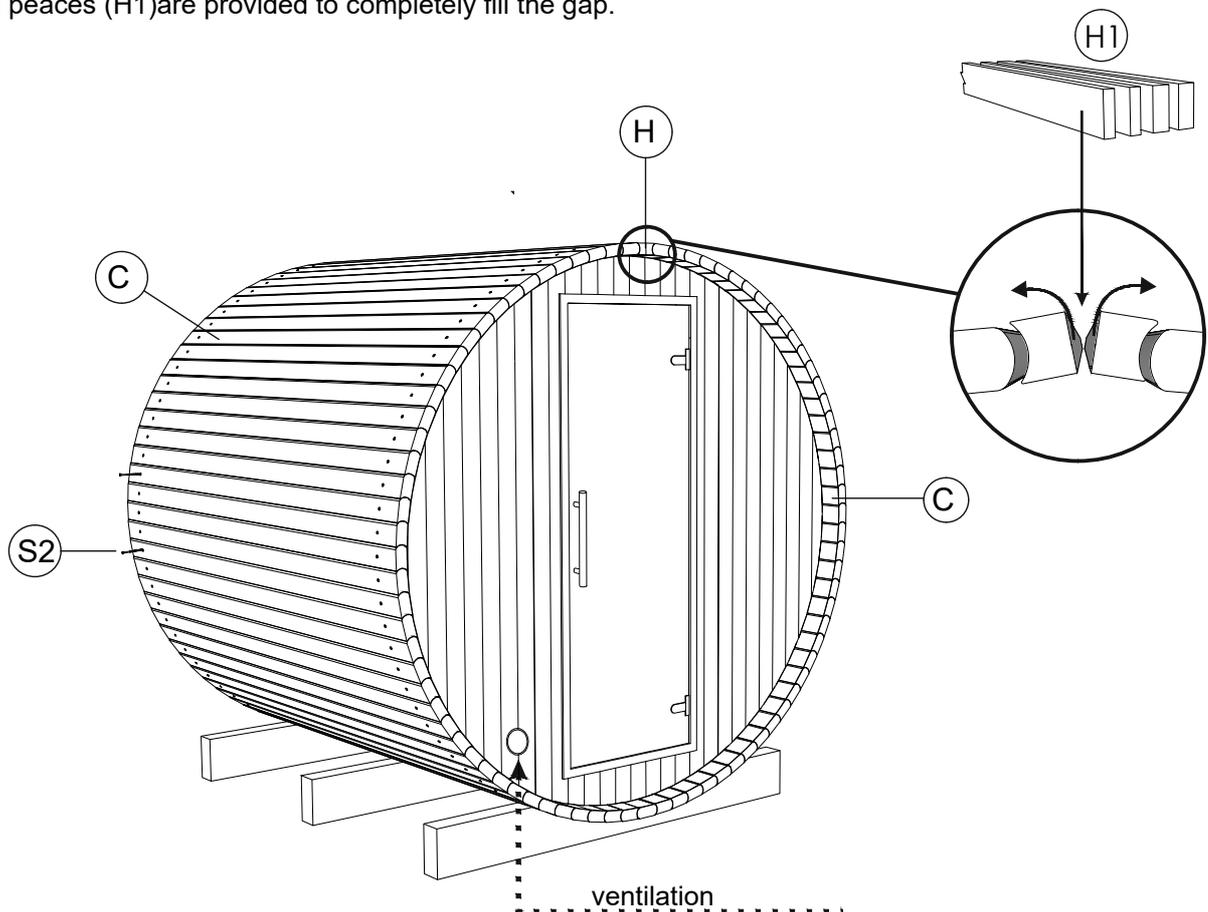
**STEP 6:** Attach side panel (F) using 4 5.0 x 120 (S4) screws. One person still holds door panel. Place body stave (C) on rear and front panel to connect both panels using 4.0 x 70 SS (S2) screws. Check panel level before fix them. These panels must be completely seated into the floor groove. Fix ventilation grill from inside on ventilation cuts.



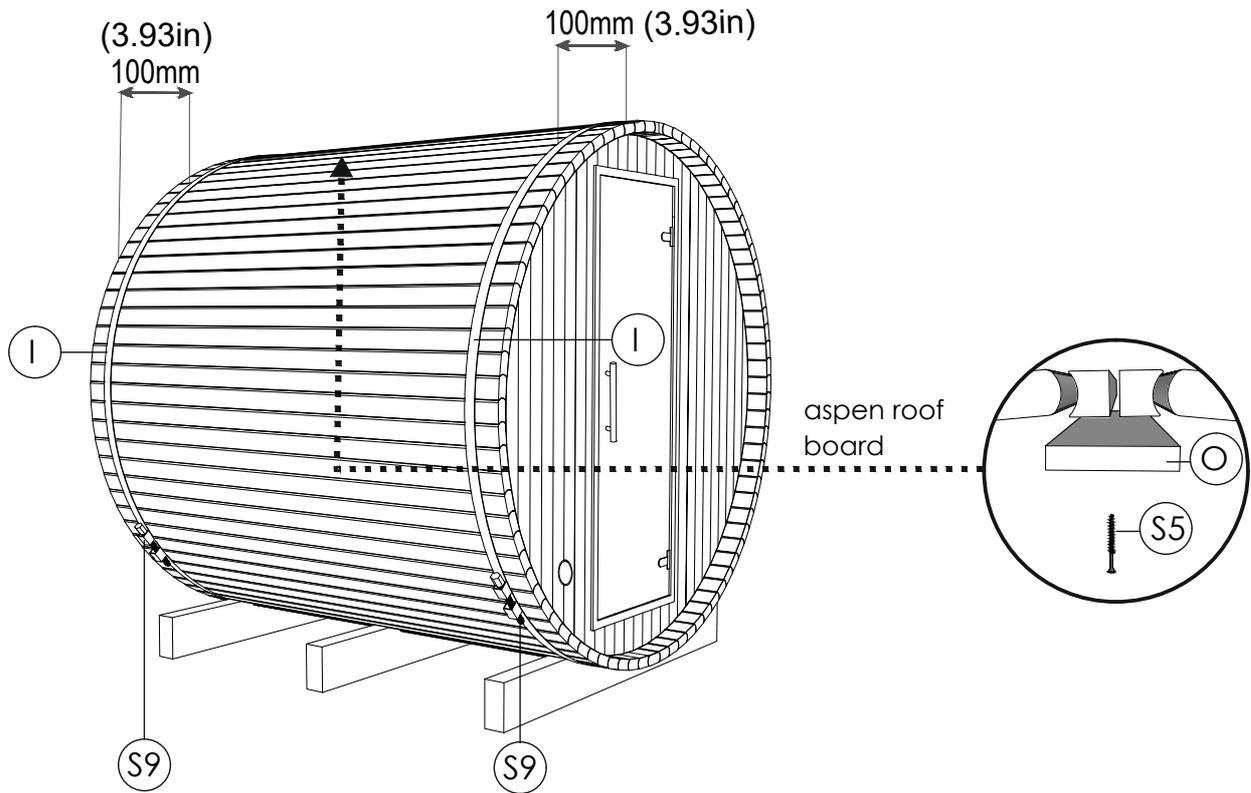
**STEP 7:** Firstly, position the body staves (C) until you reach the halfway point. Secondly, take the upper rear panel (V2) and place it on the bottom rear panel (V). Secure it by using 2 screws 5.0 x 120 (S4). Lastly, temporarily connect the panels (F2; V2) together by placing one or two body staves (C) on top of them.



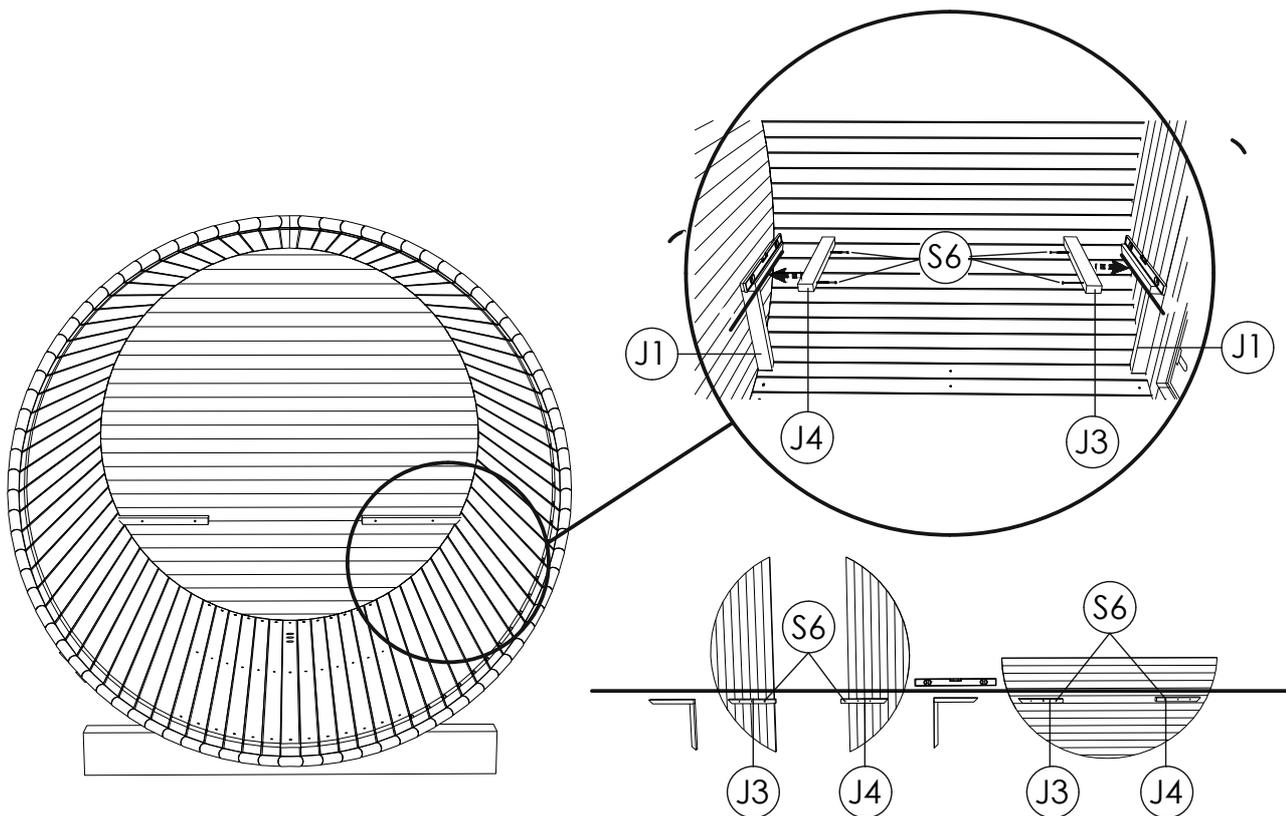
**STEP 8:** Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws 4.0x70(S2) . To finish the roof top joint, use roof finishing item (H). Different thickness filling peaces (H1)are provided to completely fill the gap.



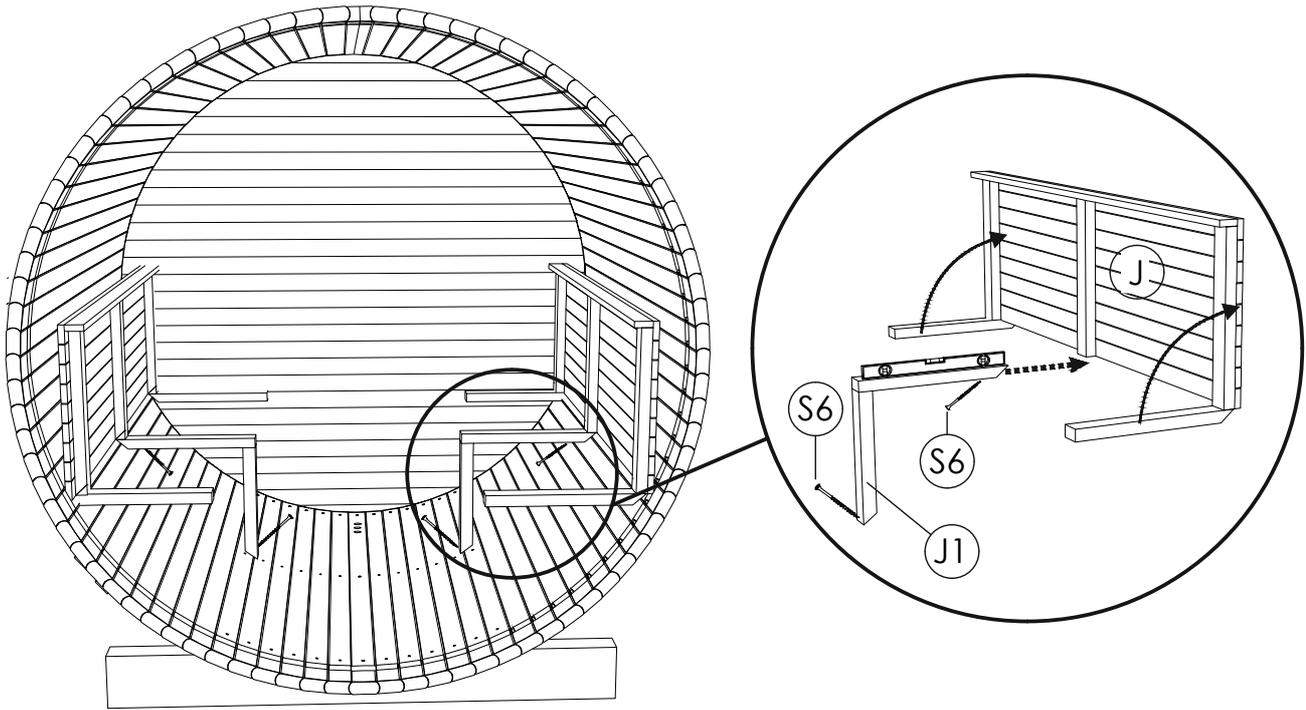
STEP 9: Install steel bands (I) by wrapping bands around the barrel, then connect with bolts and nuts (S9). Place steel bands evenly around the barrel approx 90-100mm from both sides, covering screw heads. The middle band should be evenly placed from both bands. Install interior aspen roof trim (O) in sauna with 4.0 x 50 SS (S5) screws.



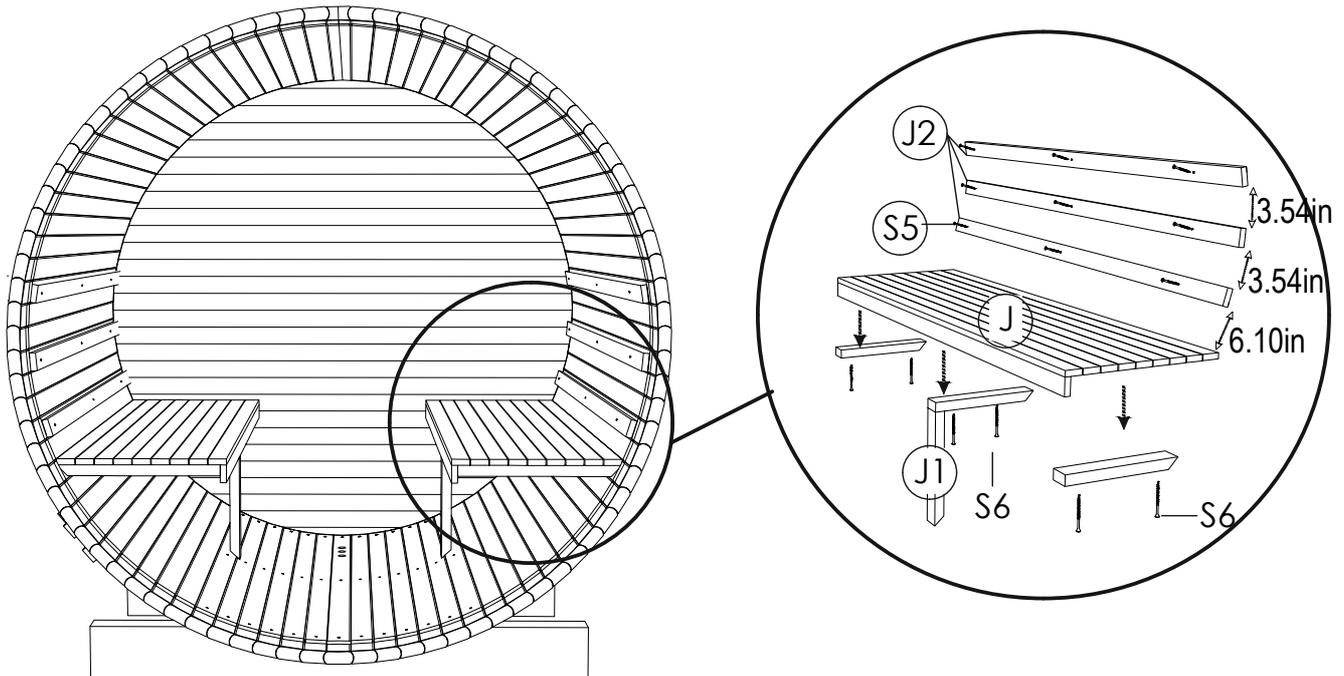
STEP 10: To install wall mounts (J3, J4) use interior supporting leg (J1). Put it on the sauna wall in level, mark a line where wall mounts will stand. Using screw 5.0x70 SS (S6) fix wall mounts (J3, J4) on the marked lines.



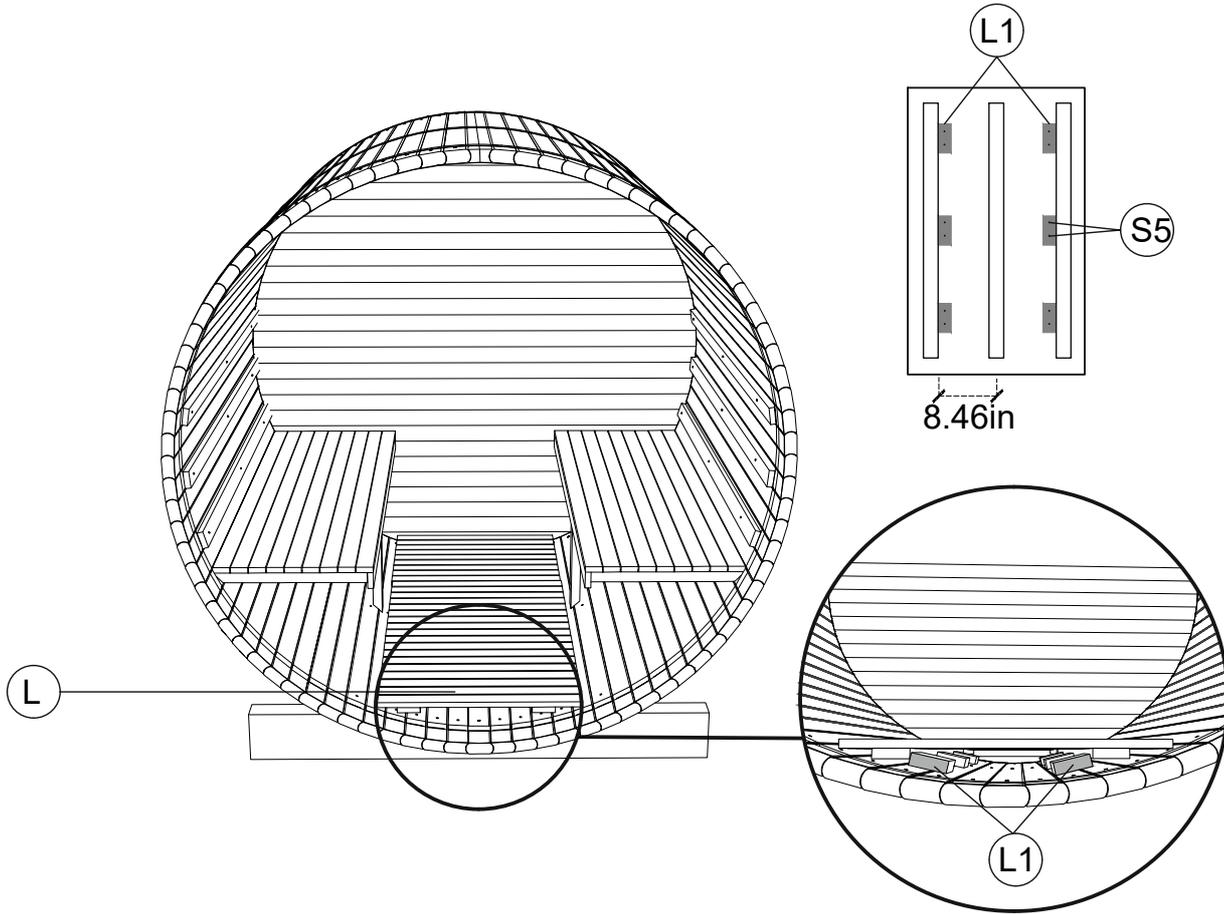
STEP 11: Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall mounts. Place J1 in the center and check the level. Using screw 5.0 x 70 SS (S6) fix bench leg to the wall and floor.



STEP 12: Install backrests (J2) at your chosen height using screw 4.0 x 50 SS (S5). Fix sauna bench (J) to wall mounts and support leg using 5 x 70 SS (S6) screws.



STEP 13: Install fixing blocks (L1) under floor duckboard. Place floor duckboards (L).



STEP 14: Place waterproof roof cover (Z) and fix it with wooden slat (Z1) and screws 4.0 x 50 (S7). Install front and rear decorative roof finishing boards (W), fixing by screws 4.2x55(S7).

