

Barrel assembly



1 Must start with level dry area!



2 Put cradles on ground



3 Find Center point of cradle. VERY IMPORTANT that first stave is same in each cradle.



4 Put bottom, stave with 2 round sides and Center it on cradle, 6" from end and secure with 3" screw. Drain hole is still open



5 Do same at both ends. Stave must be centered.



6 Secure 3 left staves and 3 right staves in cradle with 3" screws. Make sure they are tight against each other

Barrel assembly



Center door and insert into dado



Door should be straight



Screw right front wall and left front wall into place to finish front wall



Front wall finished. Make sure it does not fall at this point



Assemble back wall like you did on front wall with the 4" screws to connect



Center wall to Center of stave

Barrel assembly



Use 1 stave for safety so walls don't fall



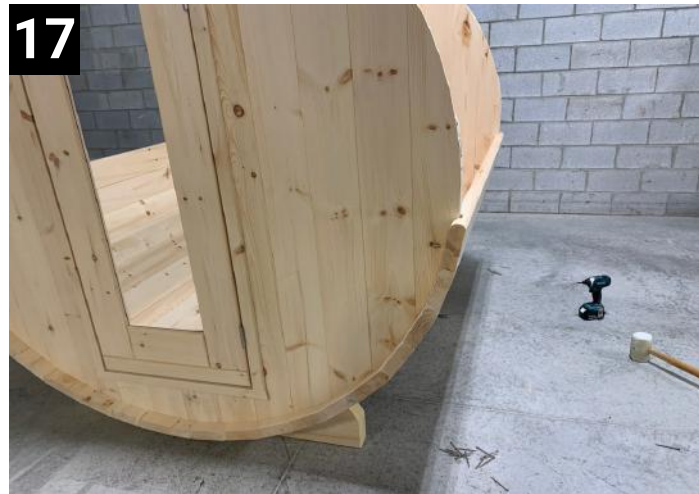
Start putting stave on each side with 3" screws. Do not bury the screw heads



Just put screw in as deep as shown. Bands will pull in rest tight later in process



Make sure each stave is tight against the previous stave



Do 10 staves on left side and 10 staves on right side and stop. Put floor in now and benches at this point



Put assembled floor in

Barrel assembly



19 Fasten floor down with 2" screws on 4 corners VERY IMPORTANT to do benches next as they come over wall.



20 Using measuring sticks provided screw on 2x4 bench support. Do both sides same



21 2x4 bench support



22 Secure bench to wall with two 2" screws. One near front and one near back of bench



23 Finished look of benches installed



24 Continue to put rest of staves on and secure each one with a 3" screw. Remember to keep staves tight together

Barrel assembly



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Do not secure top 6 staves to allow movement for inserting top stave



26

Set top in like this by lifting other two staves up a bit. Then massage them all down with rubber mallet softly



27

Some little gaps will show. Do not screw these down. Ready for bands now



28

Place bolts of bands about 16-20" of ground to allow room for roof boards.



29

Place bands over top of the screw nails to cover holes, when a porch is added still put bands over screws at front wall



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Band placement on back

Barrel assembly



31 While tightening bands hit staves lightly to get even tightness



32 Use 9/16" socket wrench and 9/16" combination wrench to tighten.



33 Do not over tighten to point of bending bolts.



34 21" from top of door to top of handle but also can be your preference.



35 Inside handle goes across door at around 26" height from top of door. Can use this as towel bar inside.



36 Center top bargeboard and screw on with 2" screws.

Barrel assembly



37

Place bottom of bargeboards 1/4" below staves.



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Bargeboards Tight together until bottom



39

Bargeboards bottom will have gaps



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Put plastic membrane over wood staves and over each end. then neoprene strips then roof boards.



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neoprene strips equal height off ground on both sides over the black plastic not onto wood. Then roof boards.



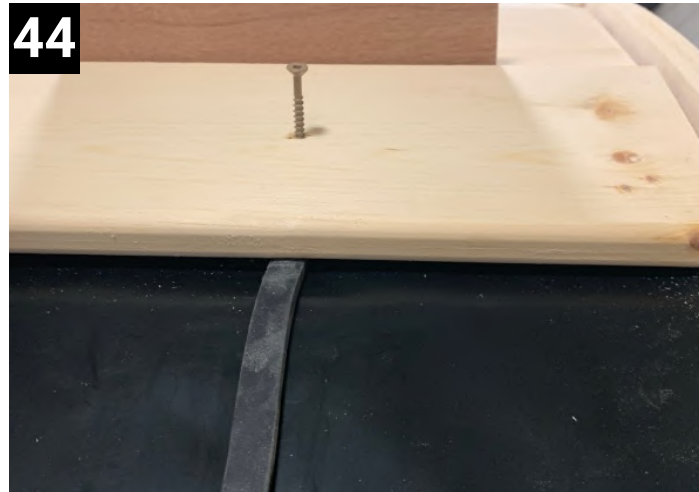
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fasten near bottom to hold if needed.

Barrel assembly



Center top 2 roof boards on Sauna



Use spacer boards for gap between roof boards, very important that screw goes through neoprene strip to seal



Keep end of boards equal space to look nice



Put one screw in at each end so screw goes through neoprene strip and into roof stave. Keeps water seal



Use 1/4" spacers to put rest of roof boards on



Roof boards come down and cover roof membrane on both side for a nice look

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49 Screw towel hook on and maple leaf on with 1 3/4" screws.



50 Set back rest in and screw in with 3" screws