

SALUS  SAUNAS



Horizon Sauna with Window

OWNER'S MANUAL

WARNING! Do not place anything combustible close to heater, above the heater, and on both sides of the heater. This includes but not limited to towels, lights, robe hookes, accessories, etc. Nothing should be on the same wall as your heater that is combustible.

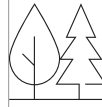
The Wait Is Over.

Everything you need to build your very own Thermory Barrel Sauna is right there in front of you. If it looks like a lot, it is. If it seems too complicated to assemble, it isn't.

These instructions are specifically written to guide you through each step with ease. And if you need additional encouragement, you can scan the code on the back of this guide to see how it's done.

The roomy Horizon barrel sauna is designed for up to six people and is outfitted with a window. That's plenty of room for you and the friends helping you put this together. But if you want to enjoy the first steam all by yourself, we understand.

We truly appreciate the opportunity to share our love of sauna culture with you. And if there's anything we can do to make your sauna experience better, please don't hesitate to let us know. If not, just relax and enjoy.



REAL WOOD PRODUCTS



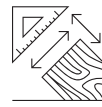
SUSTAINABLE



THERMALLY MODIFIED WOOD



DURABILITY



DIMENSIONAL STABILITY



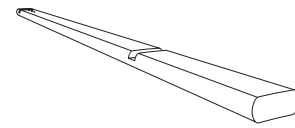
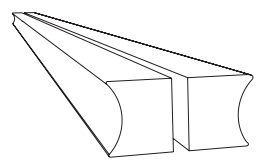
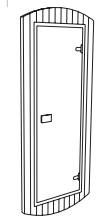
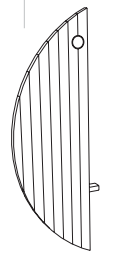
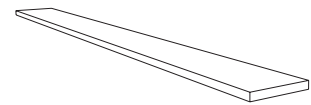

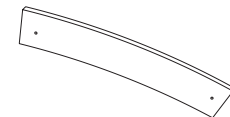
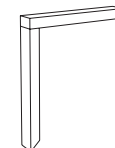
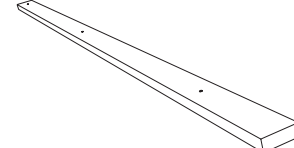
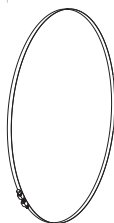
ECO-FRIENDLY / CHEMICAL-FREE PROCESS



BARRELS

Installation guide Horizon with Window

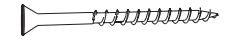
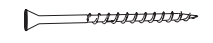
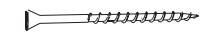
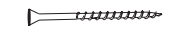
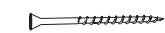
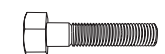
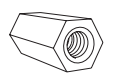

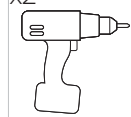
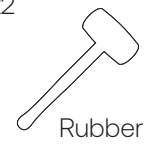







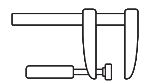
PARTS 1

| | | | |
|---|---|---|---|
| <p>CRADLES x3 A</p>  | <p>CENTER STAVE x1 B</p>  | <p>BODY STAVES x80 (+1 reserve) C</p>  | <p>FINAL H-TYPE TOP STAVE x2 H</p>  |
| <p>FRONT PANEL x1 D</p>  | <p>REAR PANEL x1 E</p>  | <p>REAR PANEL WITH WINDOW E1</p>  | <p>LEFT PANEL SECTION x1 F</p>  |
| <p>RIGHT PANEL SECTION F1</p>  | <p>ASPEN ROOF BOARD x1 O</p>  | <p>FLOORING DUCKBOARD x2 L</p>  | <p>DECORATIVE ROOF NISHING BOARDS x10 W</p>  |
| <p>INTERIOR BENCHES x2 J</p>  | <p>BENCH SUPPORTING LEGS x2 J1</p>  | <p>BACKREST STAVES x6 J2</p>  | <p>WIRE RACEWAYS x3 V</p>  <p>*if needed for heater installation.</p> |
| <p>METAL BANDS x2 I</p>  | <p>ADHESIVE ROOF TAPE x1 R</p>  | <p>WATERPROOF ROOF COVER x1 Z</p>  | <p>WOODEN SLAT FOR ROOF COVER x2 Z1</p>  |

BARRELS

Installation guide Horizon with Window

PARTS 2

| | | | | | | |
|---|---|---|--|---|--|---|
| <p>SCREW 5.0X120 x8 M</p>  | <p>SCREW 4.2X70 x120 N</p>  | <p>STAINLESS STEEL SCREW 4.2X70 x24 N1</p>  | <p>SCREW 4.0X50 x70 P</p>  | | | |
| <p>STAINLESS STEEL SCREW 4.0X50 x24 P1</p>  | <p>Ø BOLT 16X140 x2</p>  | <p>HEX NUT M16 (SW24) x2</p>  | <p>FLAT WASHER x4 U</p>  | | | |
| <p>TOOLS REQUIRED: x2</p>  | <p>x2</p>  <p>Rubber</p> | <p>x3</p>  | <p>x2</p>  | <p>x2</p>  <p>24mm</p> | <p>x2</p>  <p>10'</p> | <p>x3</p>  |
| <p>3 People Recommended</p>  | | <p>6'</p>  | <p>x2</p>  | | | |

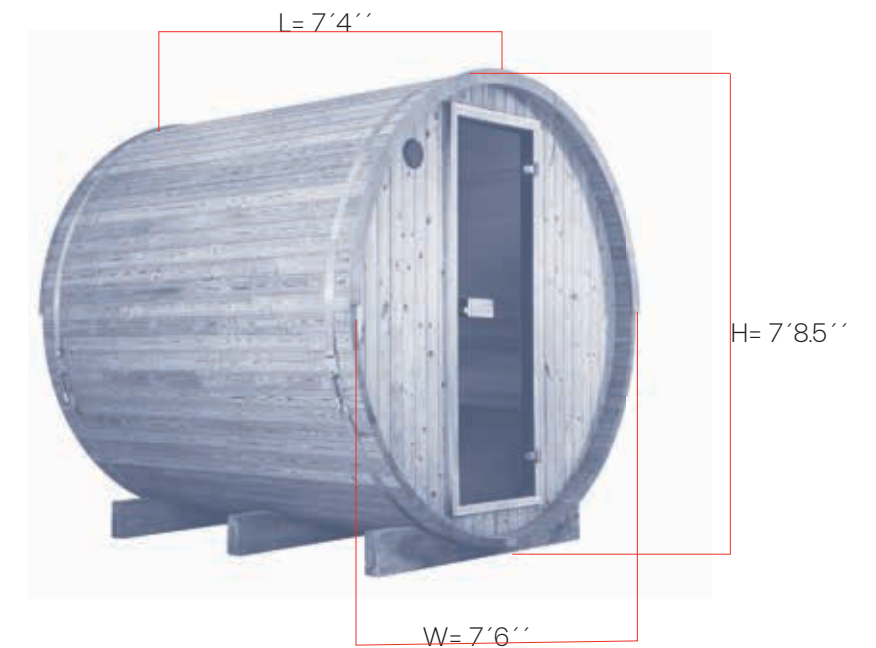
STEP ZERO

Before you begin, be sure the sauna will fit in your chosen location.

Approximately L x W x H of 8' x 8' x 8' is ideal. Overall dimensions are shown here.

Be sure the site is level and free of standing water after rainfall.

Concrete, pavers or crushed stone is preferred.



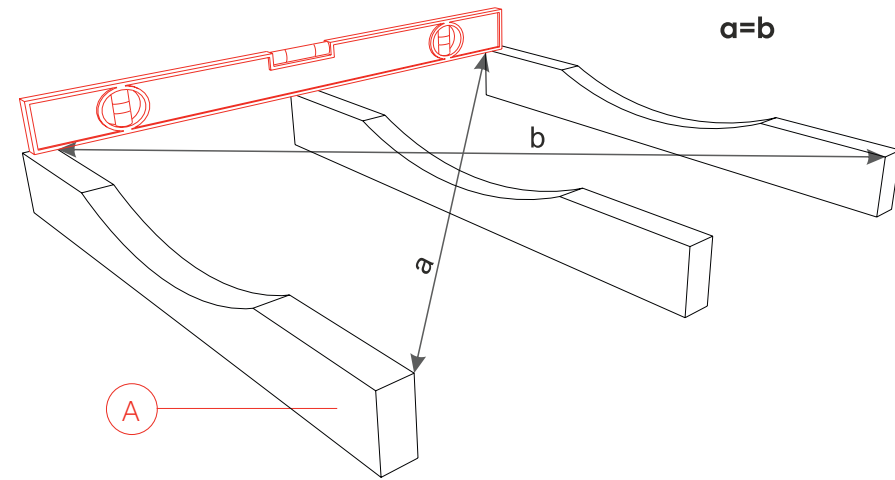
BARRELS

STEP ONE

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.

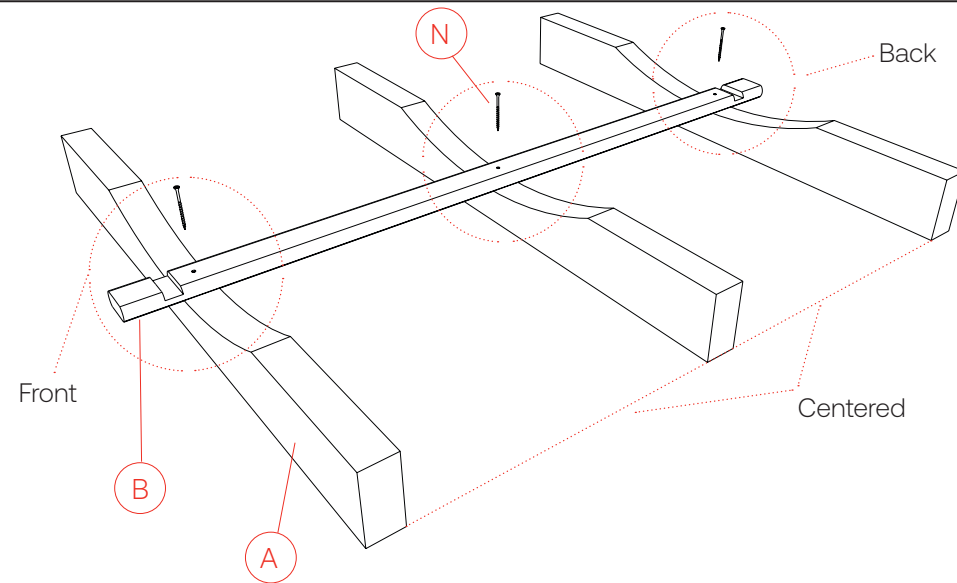


STEP TWO

Place the support cradles (A) on level site. The middle support cradle will have no dowel. 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 screw 4.2x70 (N).

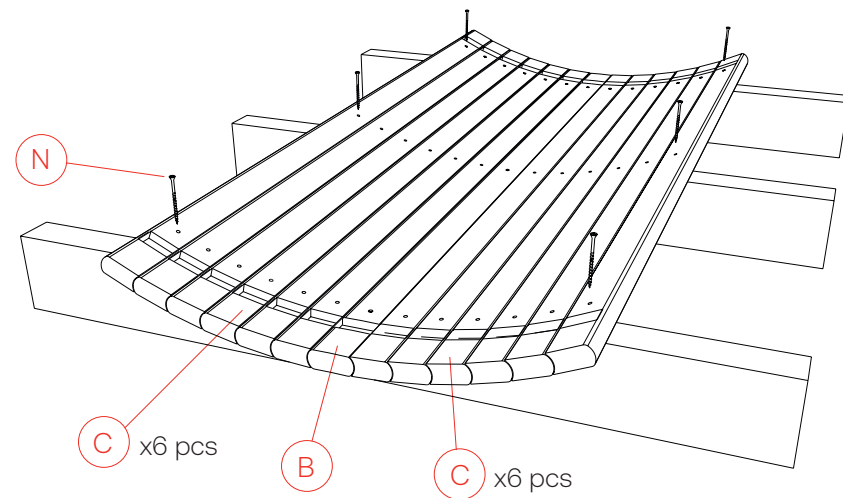


STEP THREE

Place 6 sauna body staves (C) to each side of the center stave (B) and fix with screws 4.2 x 70 (N).

Body staves (C) are left and right sided.

Be sure to align the panel groove on every next body stave.



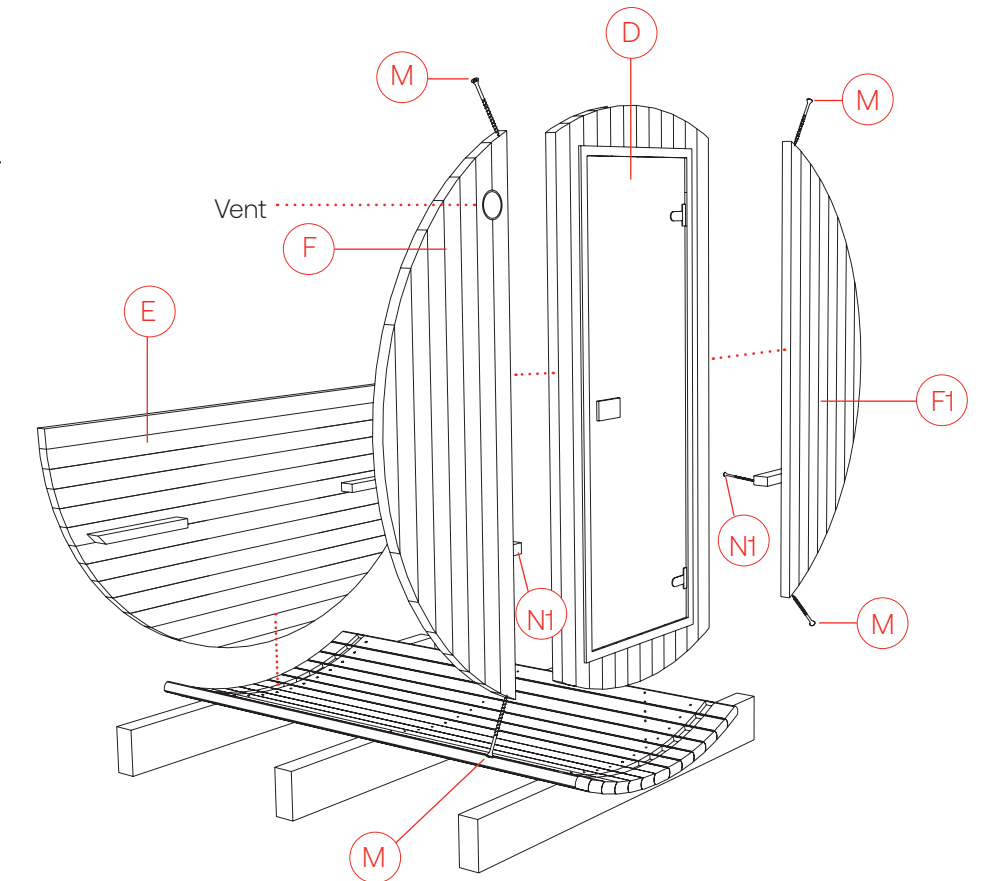
BARRELS

STEP FOUR

Place door panel (D) in front slot. Be sure panel is centered, leveled, completely seated. Attach side panels (F, F1) using 4 5.0 x 120 (M) screws and 2 4.2 x 70 (N1) stainless steel screws.

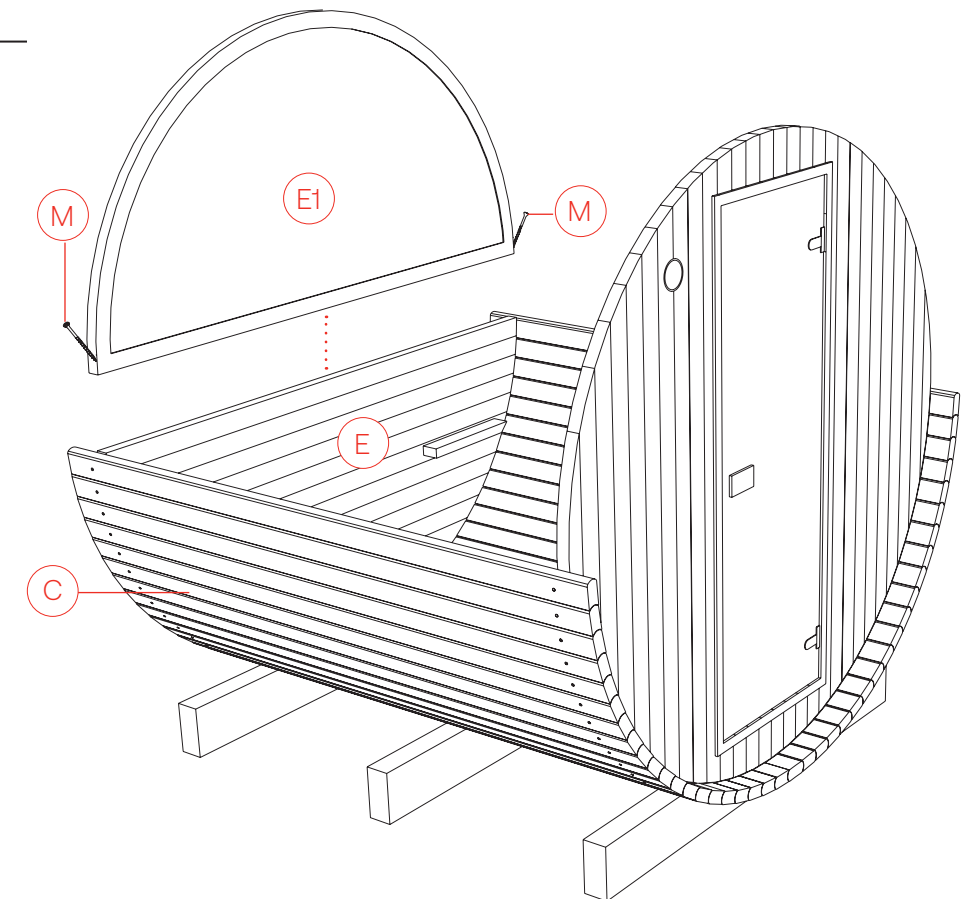
Place rear panel (E) with bench supports facing interior.

Confirm width of rear panel (E) matches combined width of left panel section (M), front panel (D) and right panel section (M). These panels must be completely seated into the floor panel.



STEP FIVE

Place body staves (C) until the halfway point. Place rear panel (E) with window (E1) on rear panel (E), fix by 2 screws 5.0 x 120 (M).



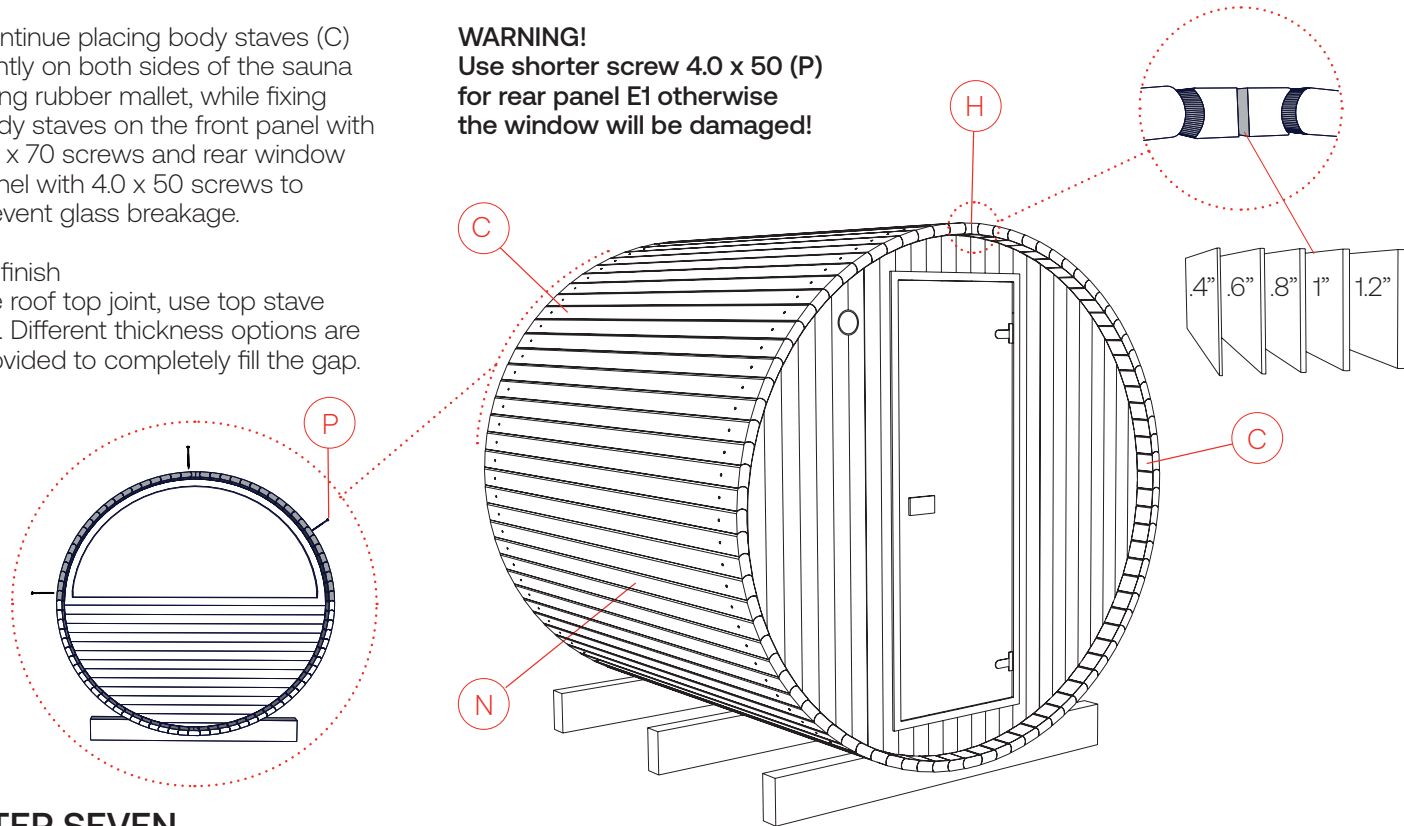
BARRELS

STEP SIX

Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, while fixing body staves on the front panel with 4.2 x 70 screws and rear window panel with 4.0 x 50 screws to prevent glass breakage.

To finish the roof top joint, use top stave (H). Different thickness options are provided to completely fill the gap.

WARNING!
Use shorter screw 4.0 x 50 (P) for rear panel E1 otherwise the window will be damaged!



STEP SEVEN

Measure steel bands (I) to ensure correct length of 276,\" +/- 1/2\" is acceptable.

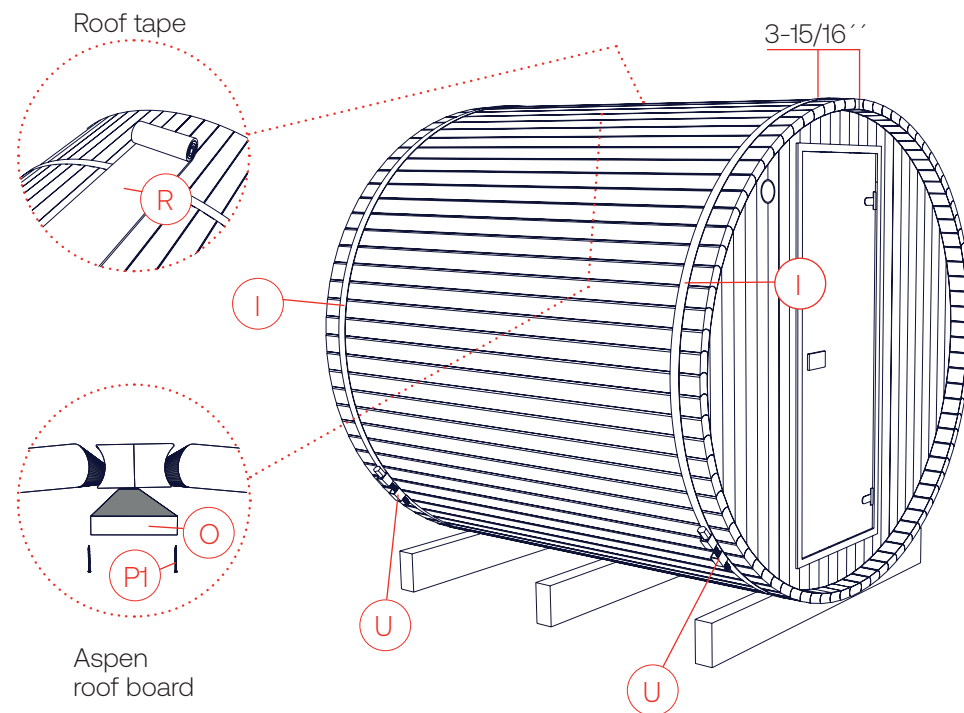
Install steel bands (I) by wrapping bands around barrel prior to connecting with bolts and nuts (U).

Place steel bands evenly around barrel, covering screw heads.

Measure from steel band to barrel edge to ensure the steel band is even.

Cover roof with roof tape. Rub and smooth with pressure to ensure adhesion.

Install interior aspen roof trim (O) with 4.0 x 50 (P1) stainless steel screws.



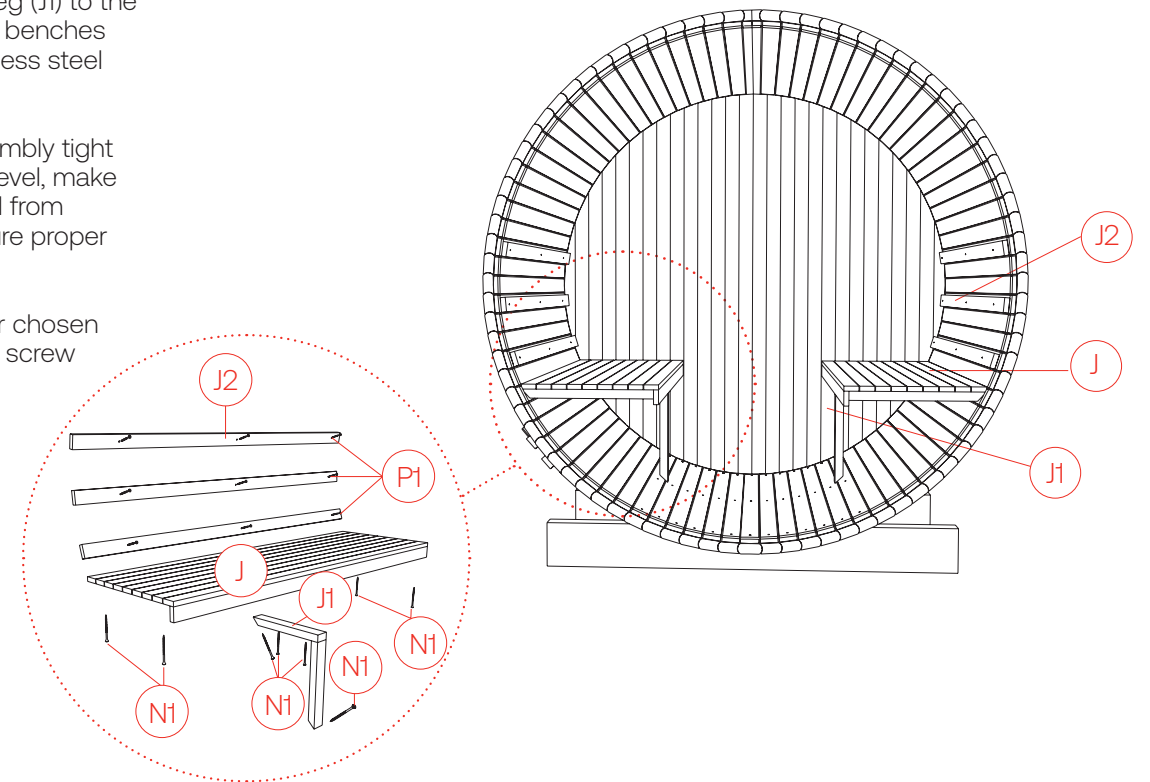
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STEP EIGHT

Attach interior supporting leg (J1) to the bench (J), install two sauna benches on wall mounts using stainless steel screws 4.2 x 70 (N1).

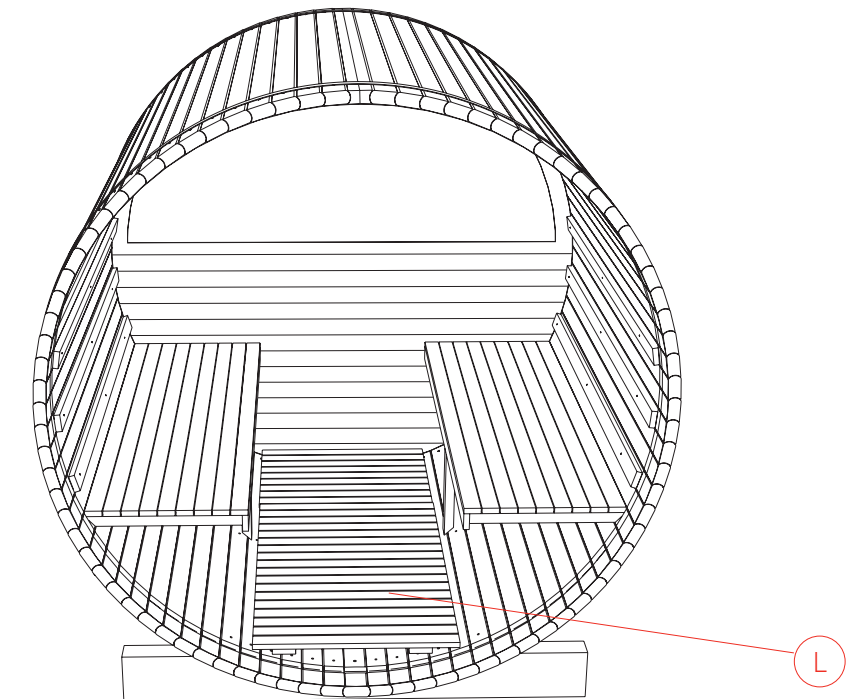
Hold the seat and leg assembly tight to the sauna wall. Using a level, make sure the bench seat is level from front to back. This will ensure proper placement.

Install backrests (J2) at your chosen height using stainless steel screw 4.0 x 50 (P1).



STEP NINE

Flooring duckboards (L) can be used for wiring runs, confirm specific wiring runs needed for chosen stove.

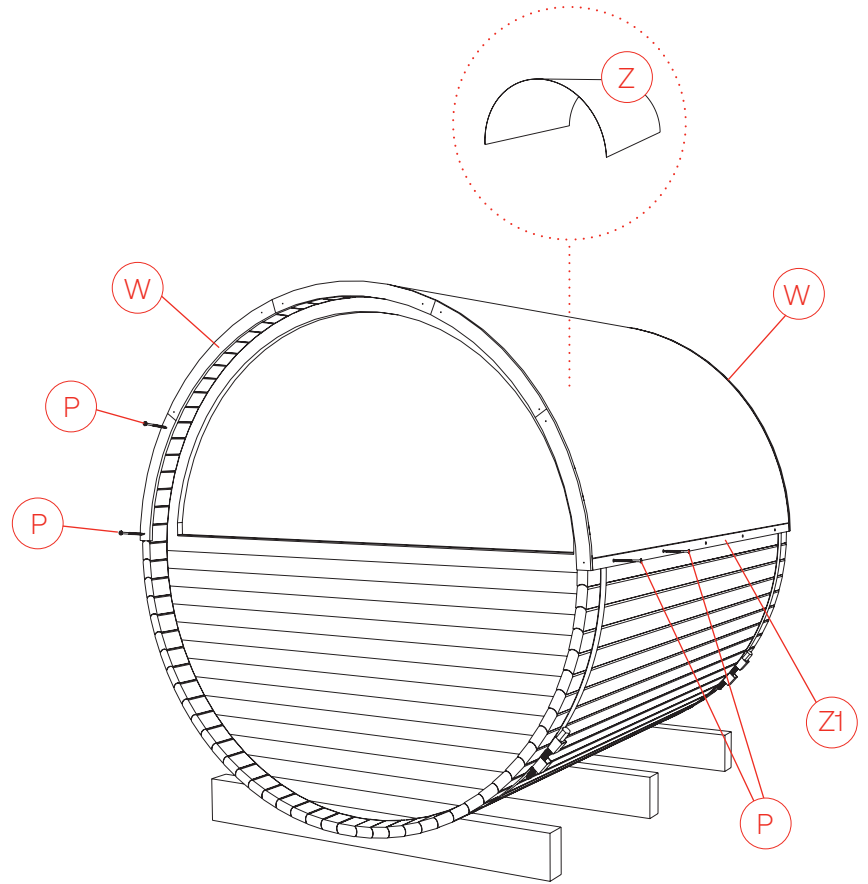


STEP TEN

Place waterproof roof cover (Z) and fix it with wooden slat (Z1) and screws 4.0 x 50 (P).

Install front and rear decorative roof finishing boards (W), fixing by screws 4.0 x 50 (P).

WATCH THE VIDEO



SEE HOW ASSEMBLY
WILL LOOK [HERE](#).



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