

Saunacore "Country Living" Barrel Sauna

1. Placing 3 bases on the ground in line, be sure the bases are parallel to each other. See Figure-1.
2. Put stave marked "S" on the center of the bases, with end have a groove on its inside face. See Figure-2.



Figure-1



Figure-2

3. Placing stave marked "A-1" in the center of the bases, close to stave "S" and match well. See Figure-3.
4. Then placing stave marked "A-2"~"A-3", "B-1"~"B-3" on the bases in turn and close to each other. Make sure that all the staves are square to bases and the groove is lined up on all pieces. See Figure-4.



Figure-3



Figure-4

5. Fix these 7 staves on bases with self-trapping screws from inside. See Figure-5.
6. Find panel "R-0" and raise it up, put one end into groove and make sure perfect vertical. See Figure-6.



Figure-5



Figure-6

7. Placing arc panel marked “R-1” to the left side of panel “R-0” by inner hasp and placing “R-2” to right.
See Figure-7.
8. Placing stave marked “A-4” close to stave “A-3” and placing stave marked “B-4” close to stave “B-3”.
See Figure-8.



Figure-7



Figure-8

9. Fix back panel to staves “A-4” and “B-4” by screwing self-trapping screws on strip. See Figure-9.
10. According to STEP 6&7, raising the front panel (“F-0” ~ “F-2”) in another end groove of bottom staves.
See Figure-10.



Figure-9



Figure-10

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11. According to STEP 9, Fix front panel to staves “A-4” and “B-4”.See Figure-11.
12. Next, placing 22 staves (“A-5” ~ “A-15” and “B-5” ~ “B-15”) around the back/front panel in order. Be very careful to keep the staves tight against each other. Then fix them to back/front panel by self-tapping screws. Pay attention to stave A-8 & B-8 have horizontal square to support bench. See Figure-12.



Figure-11



Figure-12

13. Next, placing 20 staves (“A-16”~ “A-25” and “B-16”~“B-25”) around the back/front panel in order. But don’t screw them right away. See Figure-13.
14. Refer to staves A-25 & B-25, you can assemble as picture show. See Figure-14.



Figure-13



Figure-14

15. Placing 2 iron bands 6cm to two ends of stave and 2 iron bands between three bases. Lay rubber under steel banding brackets, insert threaded rod through the brackets and install nuts tightly. See Figure-15.
16. Fix all the staves to back/front panels by self-tapping screws tightly. See Figure-16.



Figure-15



Figure-16

17. Fix bench support to back/front panels and in the middle of bench with screws, then lay down foot pedal in the bottom. See Figure-17.
18. Placing bench on the support in the barrel. See Figure-18.



Figure-17



Figure-18

19. Assemble the roof cap to the top staves by screwing self-tapping screws in corresponding position. See Figure-19.
20. After assembled handle to door frame, assembly finish. See Figure-20.

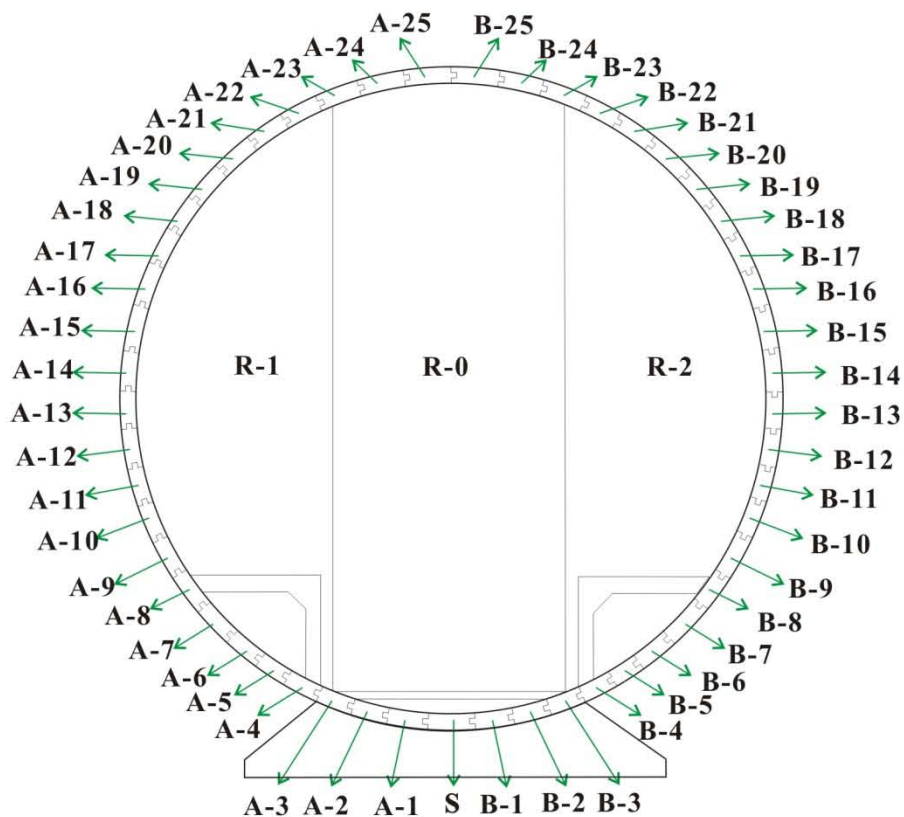


Figure-19

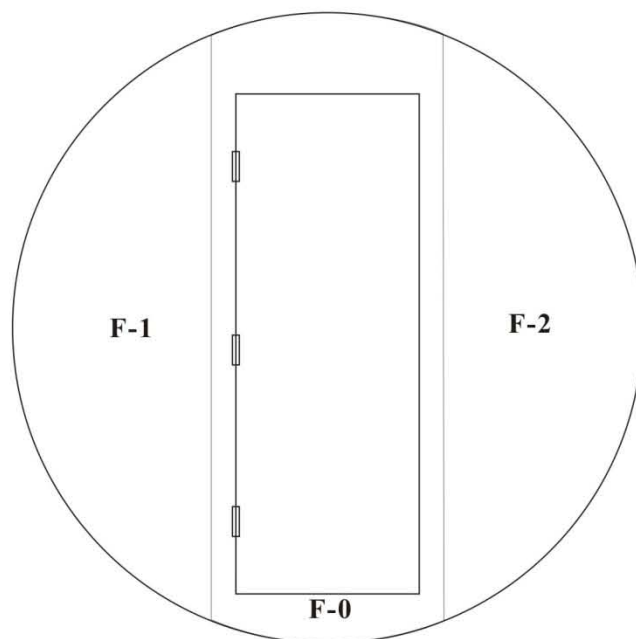


Figure-20

Marks In Barrel



Marks of Staves and Back Panel (Inside View)



Marks of Front Panel (Inside View)