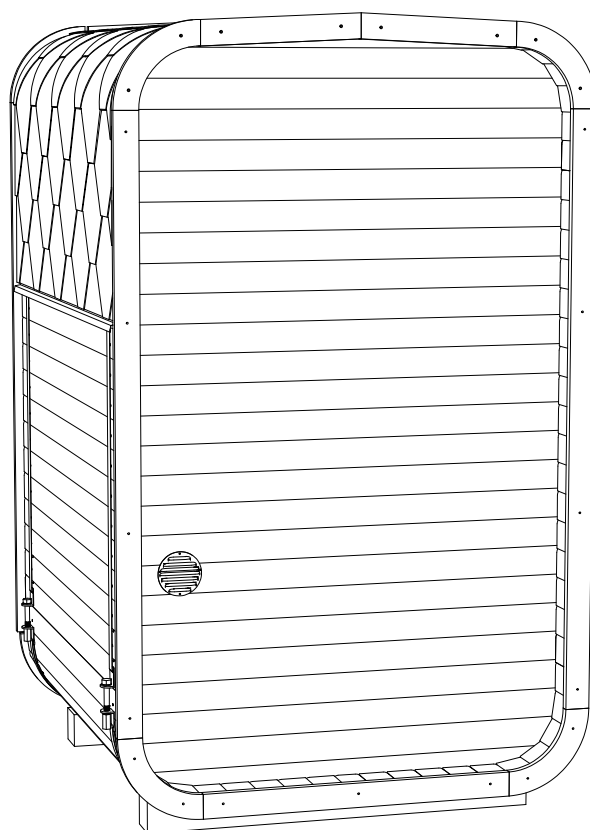
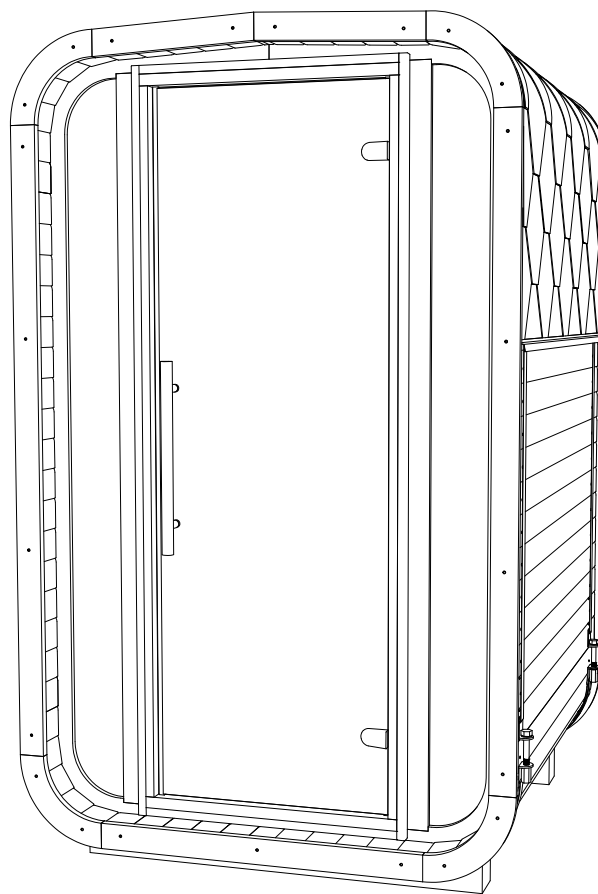

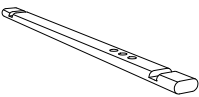
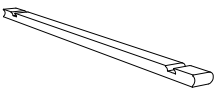

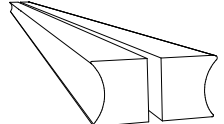
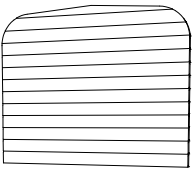
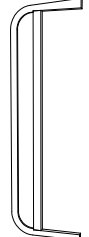
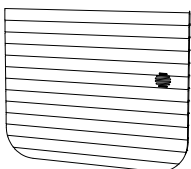
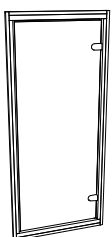
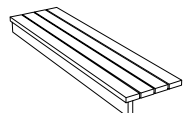
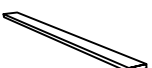
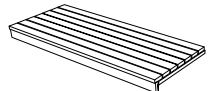

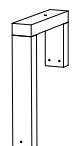
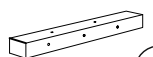
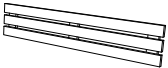
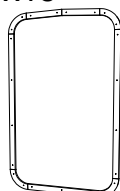

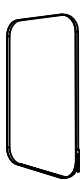


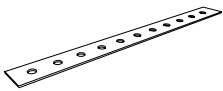
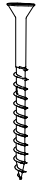

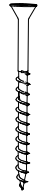







# Lux Sauna Manual

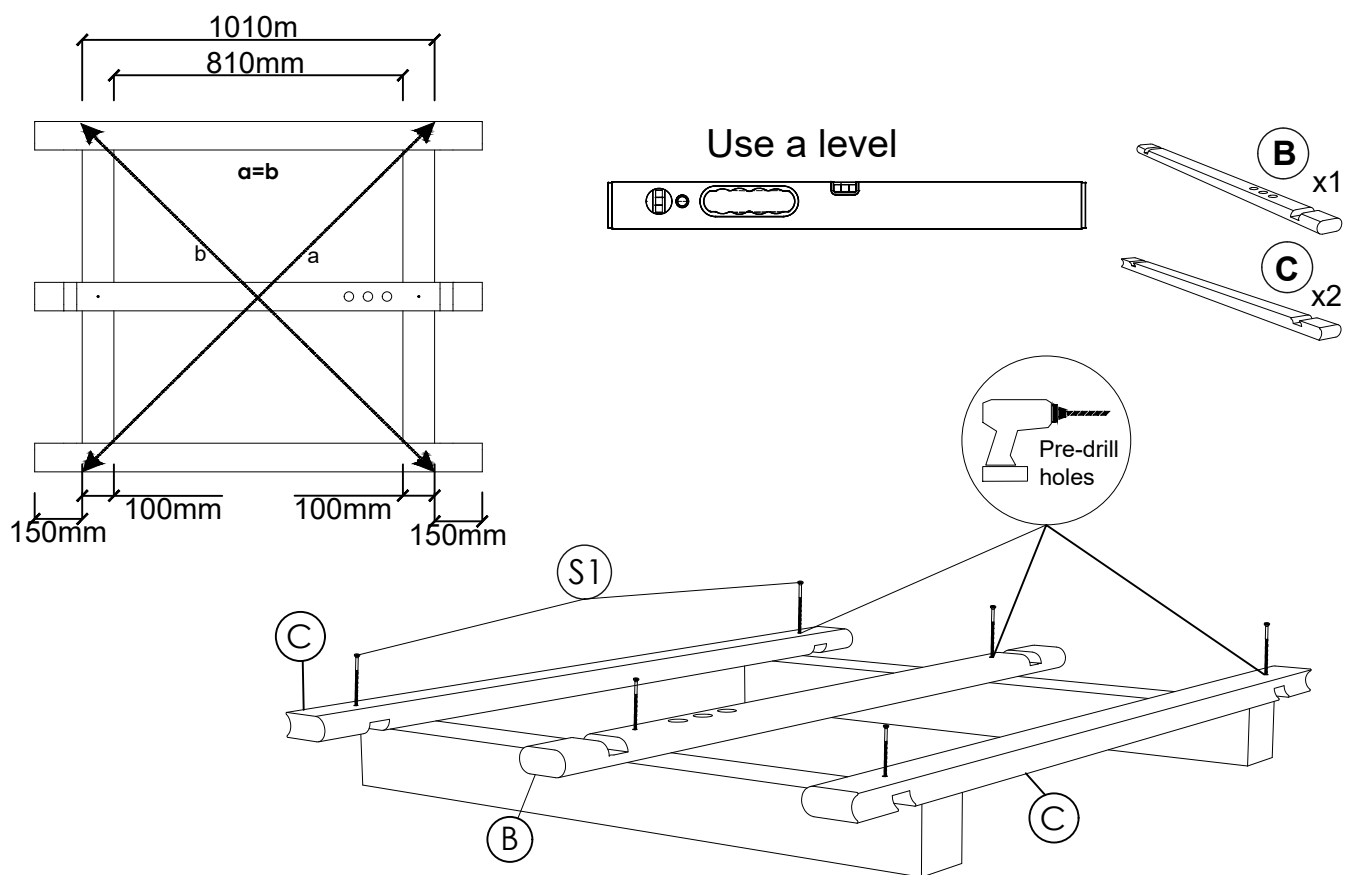


**Note: Please read this manual carefully before starting construction**

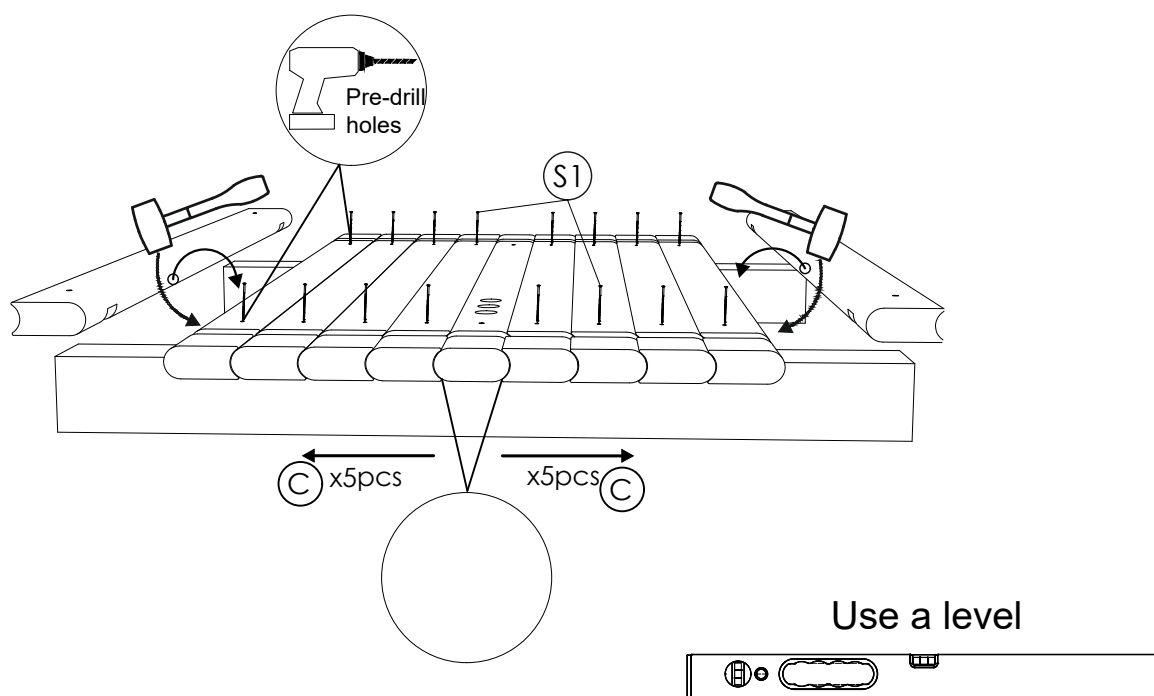
# **PARTS LIST - List may differ dependent on sauna size**

<p><b>A</b> x2</p>  <p>cradle</p>	<p><b>B</b> x1</p>  <p>center stave</p>	<p><b>C</b> x78</p>  <p>body stave</p>	<p><b>H1</b> x2 10mm</p>  <p>different thickness filling peaces</p>	<p><b>H</b> x2</p>  <p>final H tipe stave at the top</p>
<p><b>V3</b> x1</p>  <p>upper rear panel</p>	<p><b>F</b> x2</p>  <p>front panel</p>	<p><b>V</b> x1</p>  <p>bottom rear panel</p>	<p><b>F2</b> x1</p>  <p>door and door moldings</p>	<p><b>J5</b> x1</p>  <p>sauna bench step</p>
<p><b>O</b> x1</p>  <p>roof board</p>	<p><b>J</b> x1</p>  <p>sauna bench</p>	<p><b>L</b> x2</p>  <p>sauna floor</p>	<p><b>J1</b> x1</p>  <p>supporting leg</p>	<p><b>J3</b> x2</p>  <p>support board for sauna bench</p>
<p><b>J2</b> x1</p>  <p>backrest</p>	<p><b>W</b> x18</p>  <p>decorative roof finishing boards</p>	<p><b>Y1</b> x1</p>  <p>ventilation grill</p>	<p><b>I</b> x2</p>  <p>metal band</p>	
<p><b>J9</b> x1</p>  <p>support board for sauna bench</p>	<p>x2</p>  <p>wood pin</p>	<p><b>D</b> x1</p>  <p>Edge bracket</p>	<p><b>S1</b> x23</p>  <p>screw 5.0x100 SS</p>	<p><b>S10</b> x135</p>  <p>screw 4.0x60</p>
		<p><b>S4</b> x4</p>  <p>screw 5.0x120</p>		
<p><b>S6</b> x35</p>  <p>screw 5.0x70 SS</p>	<p><b>S7</b> x47</p>  <p>screw 4.2x55 brown</p>	<p><b>S12</b> x6</p>  <p>screw 4.0x30</p>	<p><b>S5</b> x25</p>  <p>screw 4.0x50 SS</p>	<p><b>S14</b> x8</p>  <p>screw 5.0x80</p>

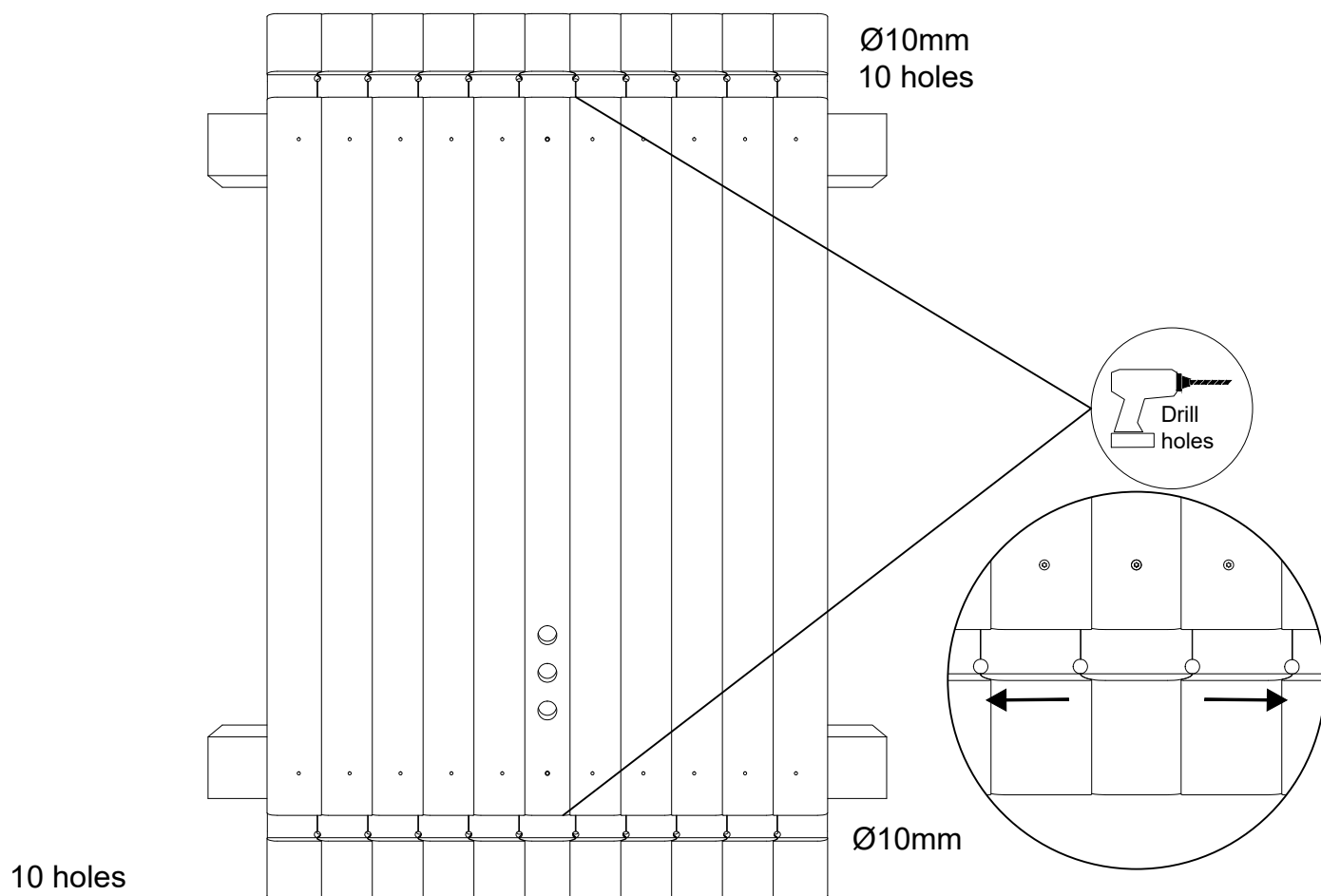
**STEP 1:** Place cradles on prepared surface. The base for the sauna cradles must be level and sturdy. Measure diagonally from corner to corner, ensuring measurements 'a' and 'b' are equal. The distance between cradles are in picture. Fix staves on both sides of the cradles to prevent any change in measurements. Check the levels again. Pre-drill holes before fixing the staves with screws. Fix the center stave (B) in the middle of the cradles. Leave the stave 150mm over the cradle on both sides.



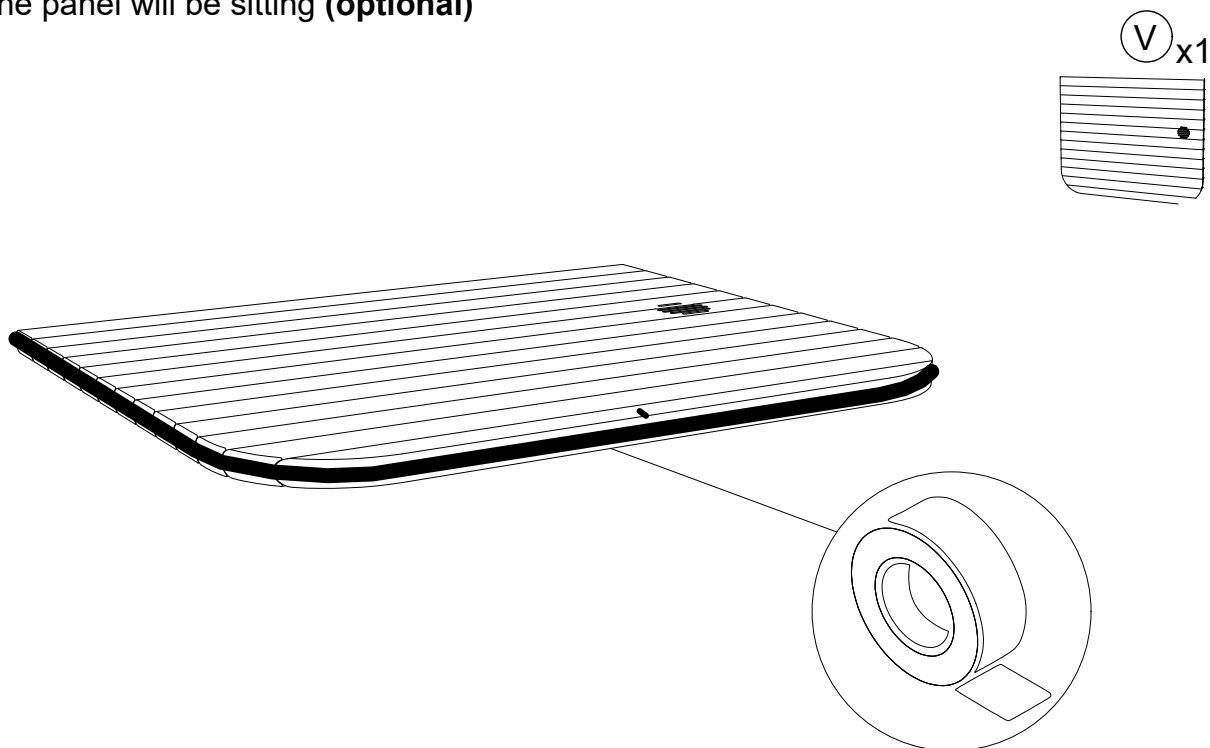
**STEP 2:** Attach five staves (C) on each side of the center stave. Check the level while installing the staves and use a rubber hammer for a tighter fit. Pre-drill holes for the screws. After fixing eight staves, remove the side staves and reattach them.



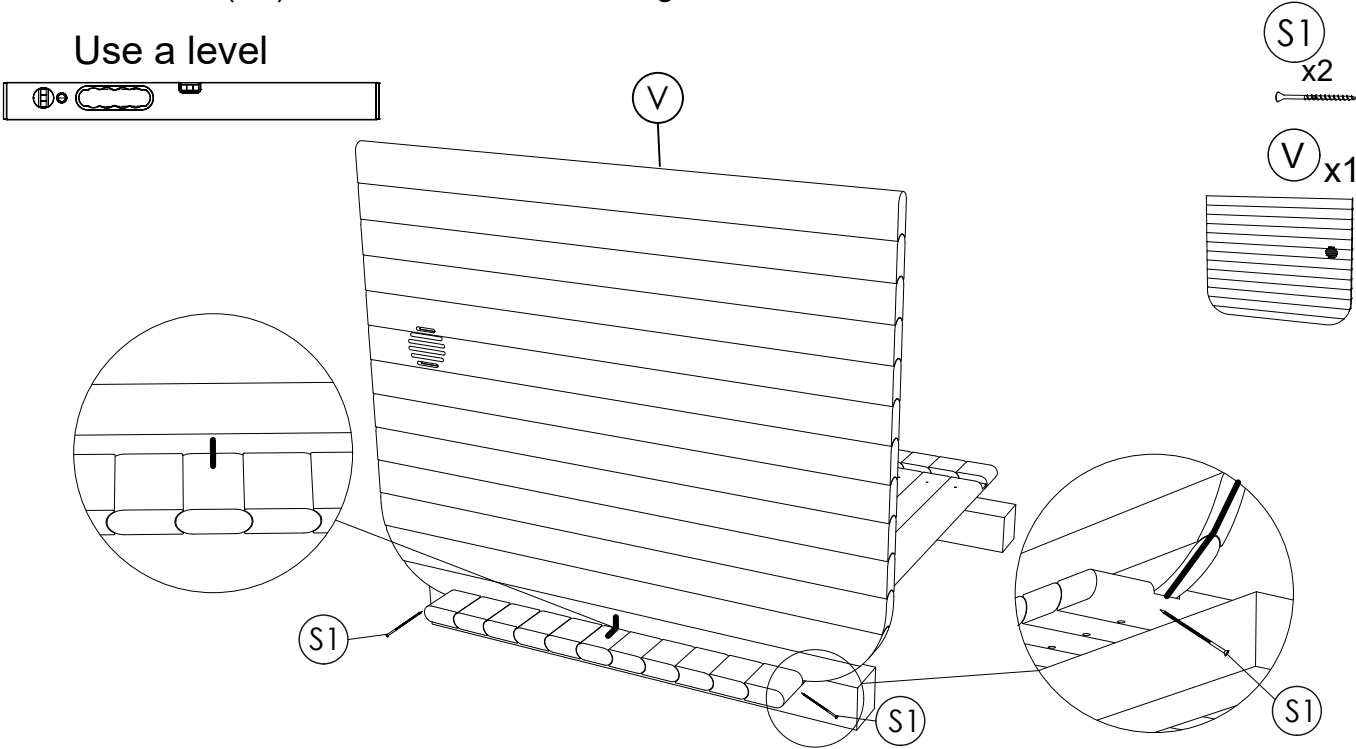
**STEP3:** Drill ten 10mm holes in front and back wall grooves to the out-side in board connections as shown in the picture. This will help drain excess water faster - **Optional**.



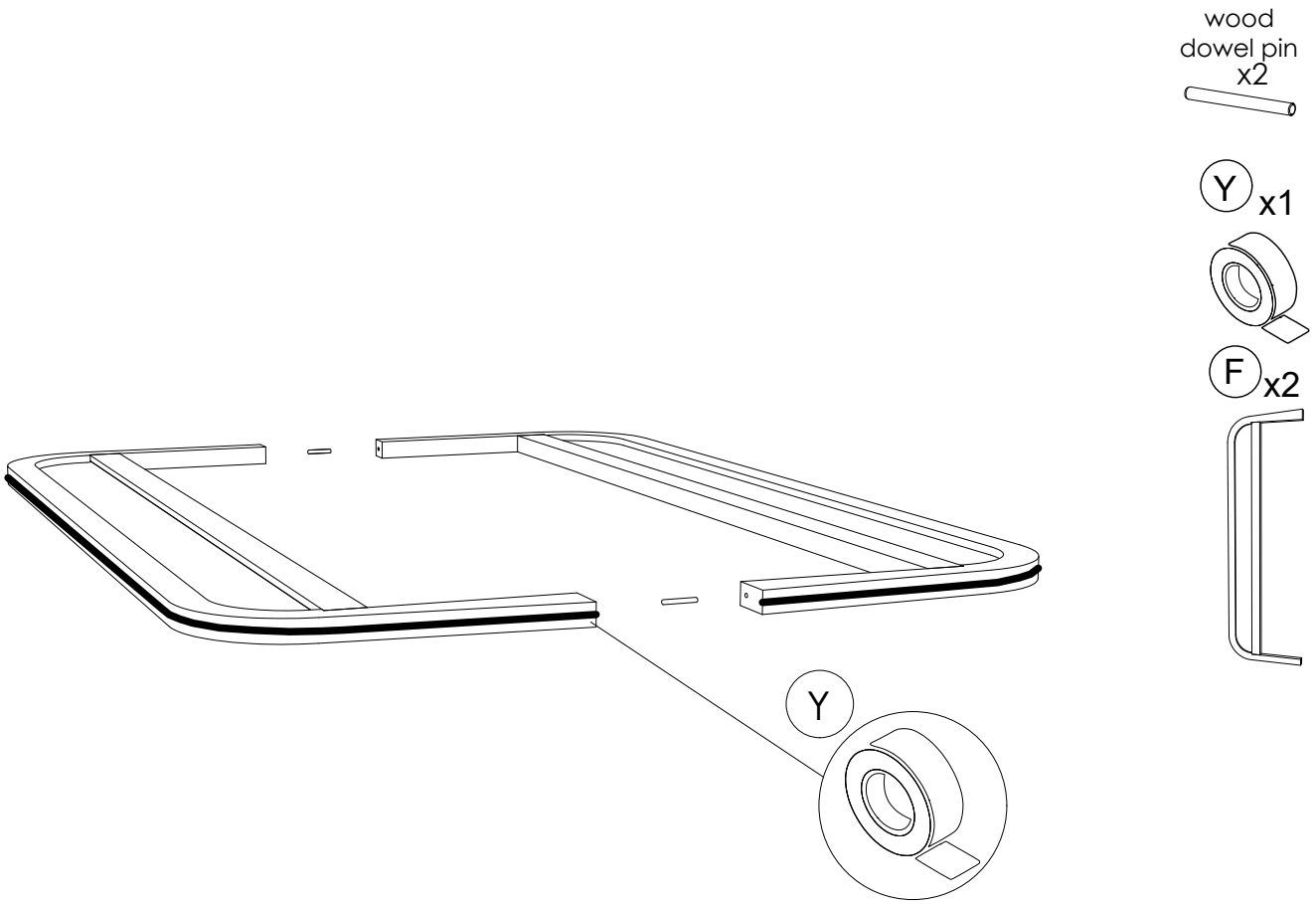
**STEP 4:** You may attach adhesive tape along the rear panel's edge. At the bottom of the rear panel (V), draw a line where the centre of the panel is. Do the same on the centre stave of the floor, where the panel will be sitting (**optional**)



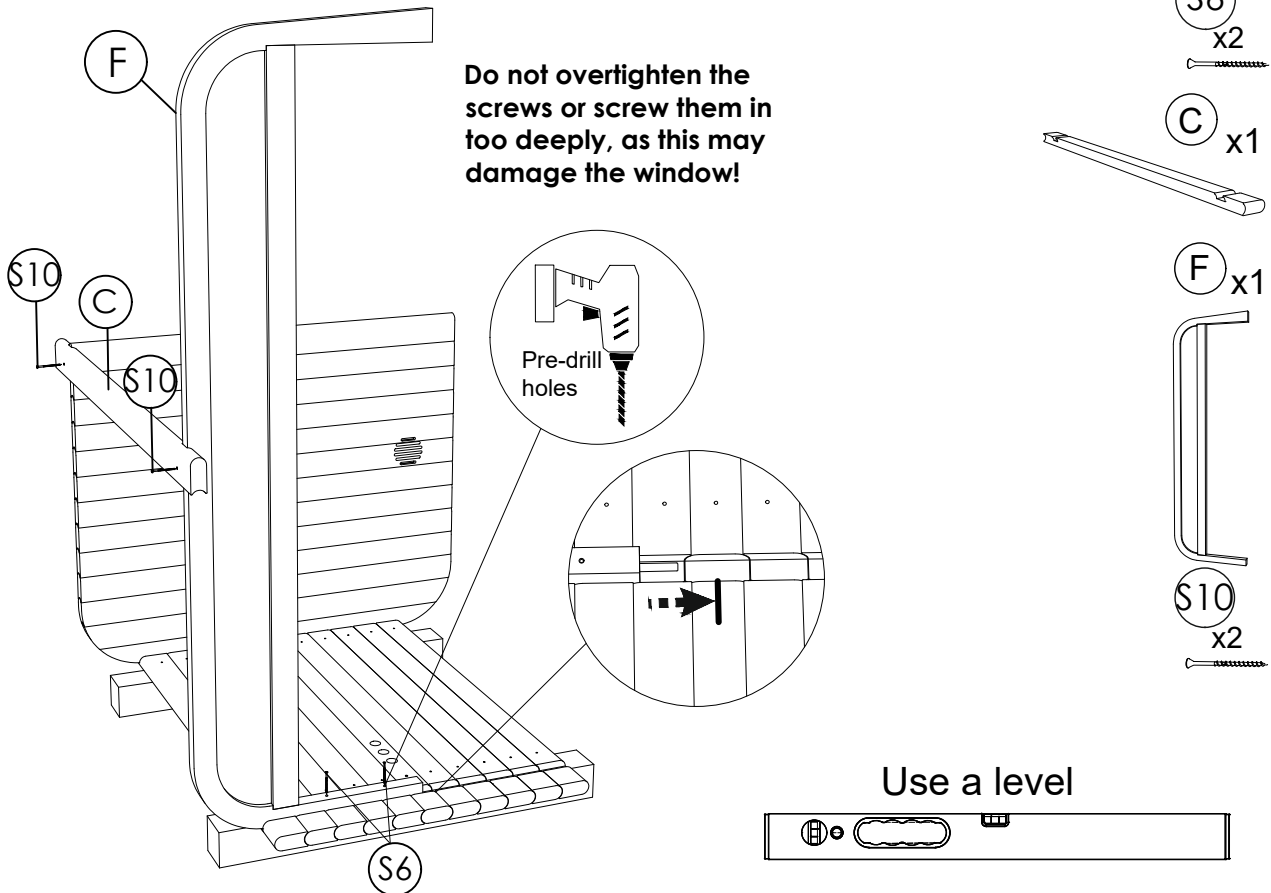
**STEP 5:**Place rear bottom panel (V) in the board groove. Check that the panel is level. Secure panel with screws (S1) at the both corners through the stave.



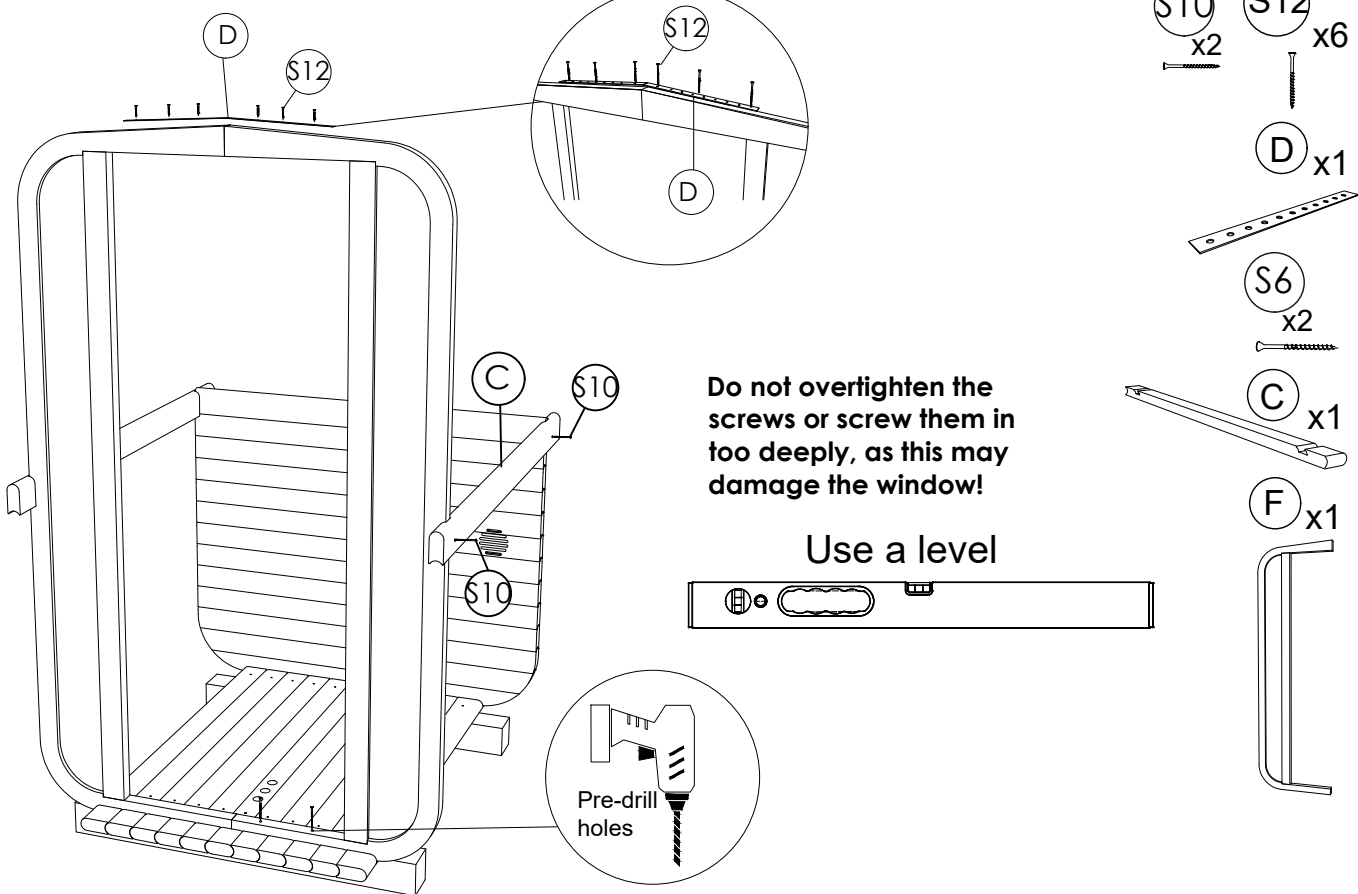
**STEP 6:** If desired, attach adhesive tape along the outer edge of both front panels (F). Then insert a wood pin into both holes on the top and bottom edges of each front panel.



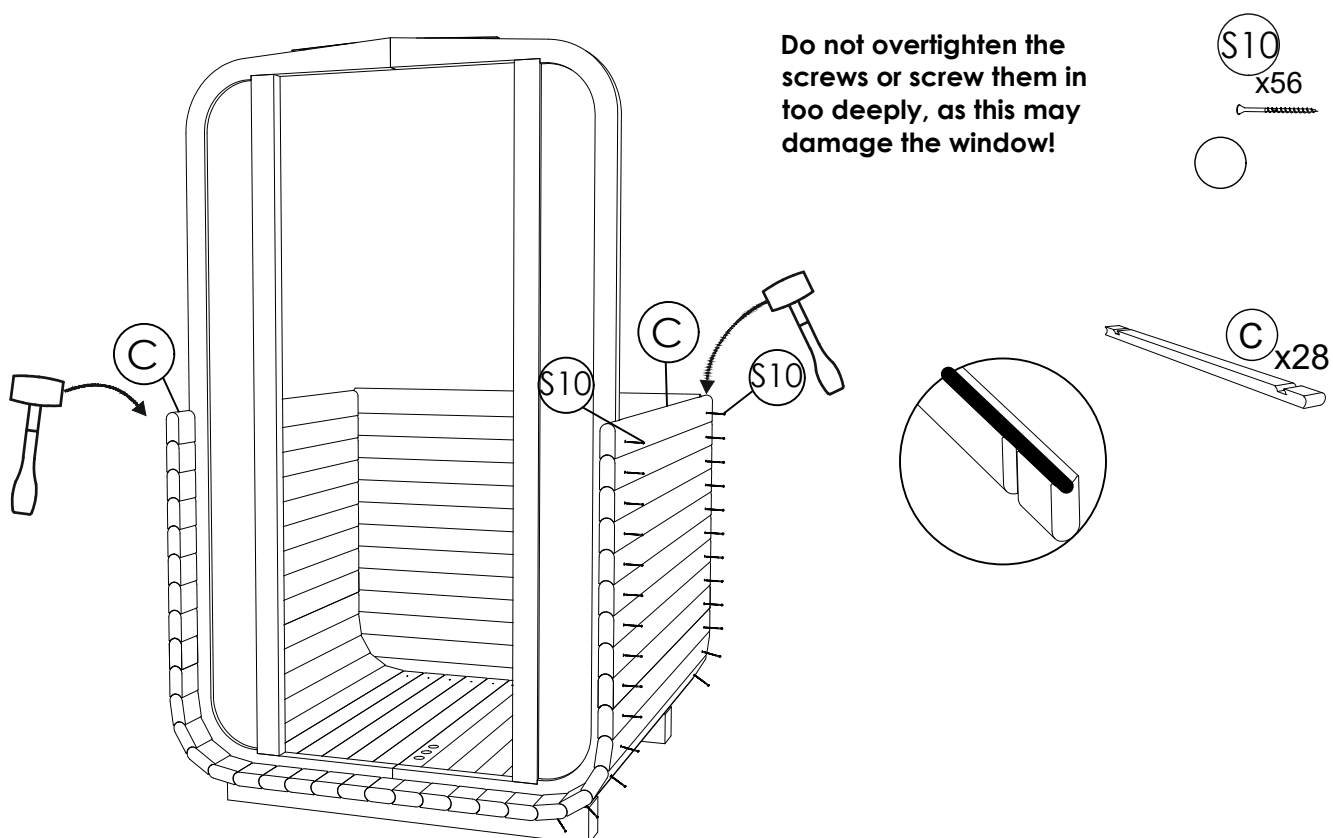
**STEP 7:** Draw a line on the center stave where the middle is. Take one of the panels (F) and put it directly next to the middle line. Fix it at the panel threshold with screws (S6). Pre-drill holes in the panel threshold, evenly spaced and not too close to the sides. Connect both panels with (C) stave, front and back, and fix using screws (S10). Make sure it's leveled.



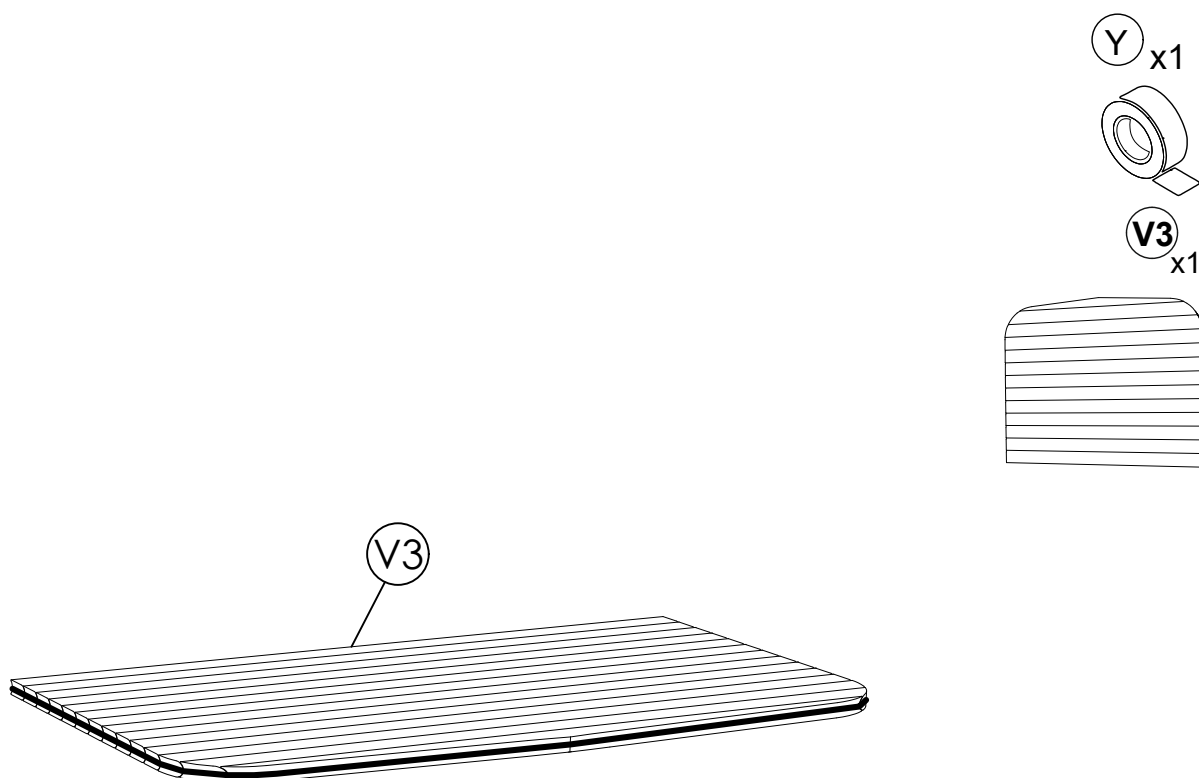
**STEP 8:** Place the second front panel (F). Slide it together that the top and bottom connects. Fix it at the panel threshold with screws (S6) pre-drill holes. Make sure it's level. Use metal bracket on top of the front panels to fix them together.



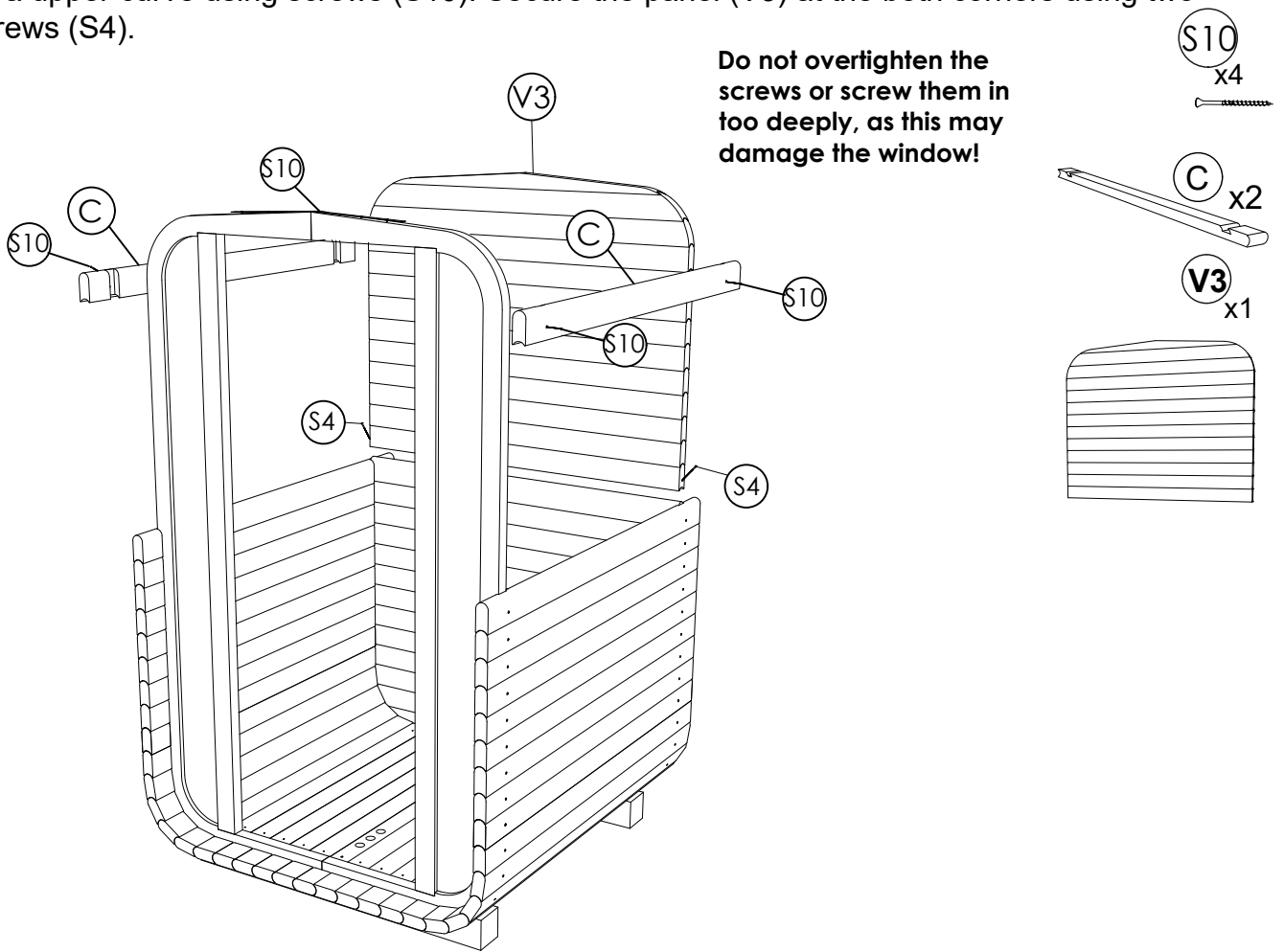
**STEP 9:** Fix 14 staves (C) on both sides with screws (S10). Use rubber hammer for tighter placement. Keep fixing staves till reach top of the rear panel (V).



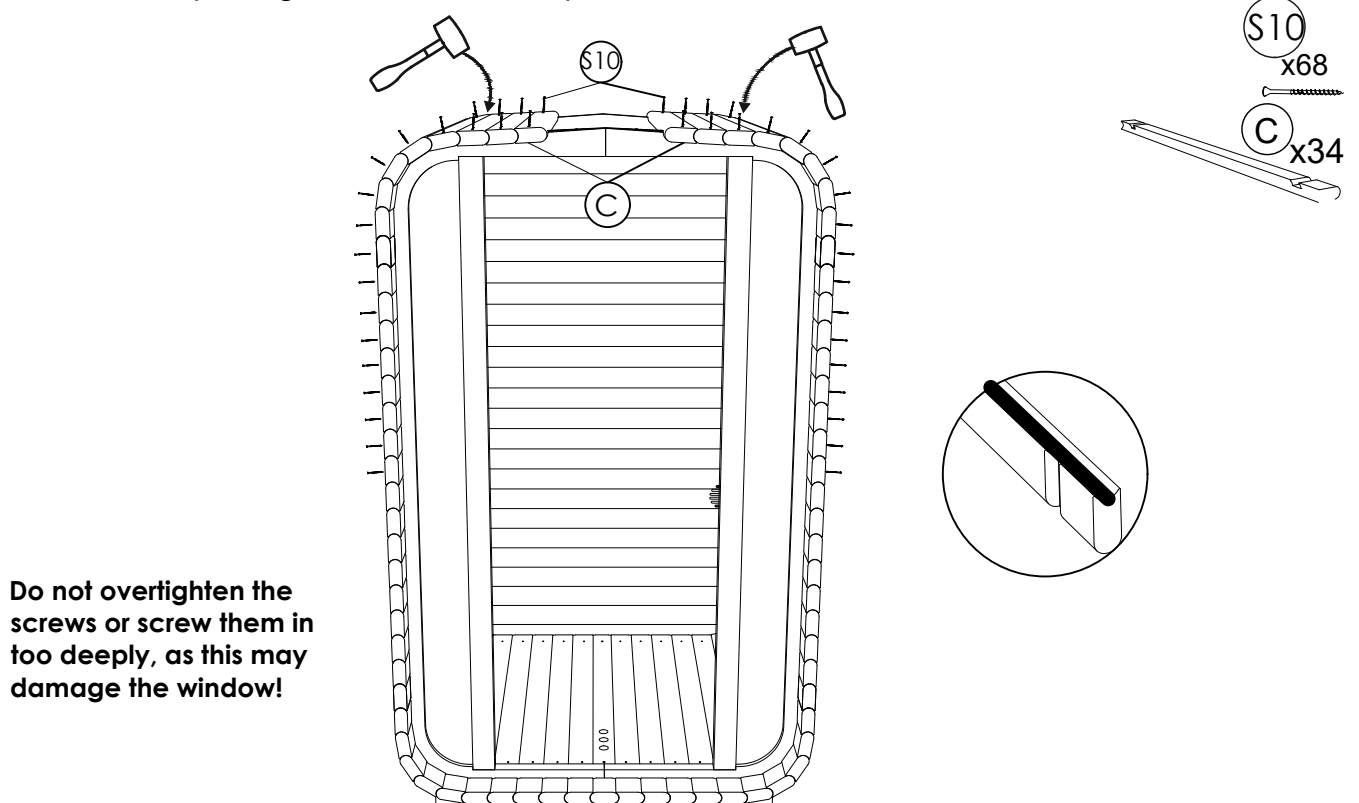
**STEP 10:** Attach adhesive tape along the rear panel (V3) edge.



**STEP 11:** Install the panel (V3) with caution. Use spray foam between panels for better insulation. Place it on top of the lower back panel (V). Check level and that side edges are aligned with bottom panel. One keeps holding the panel, and the other is fixing the side stave on an upper curve using screws (S10). Secure the panel (V3) at the both corners using two screws (S4).

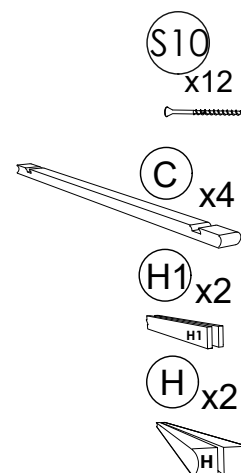
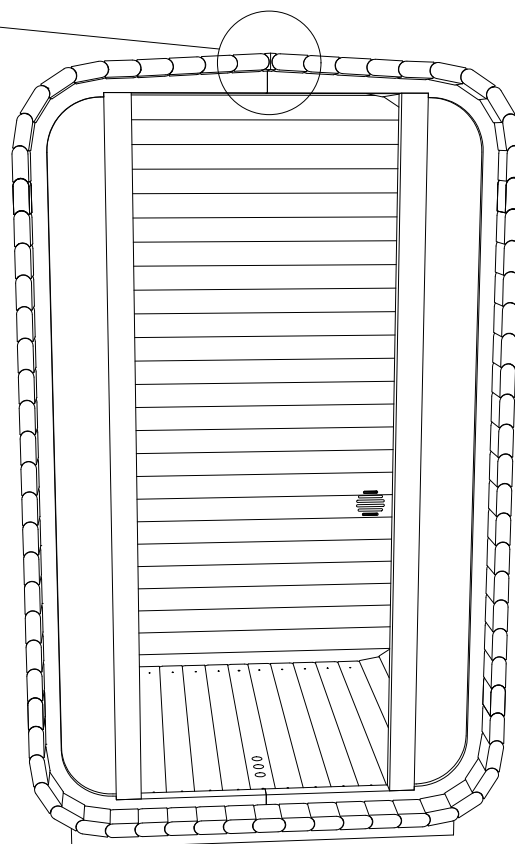
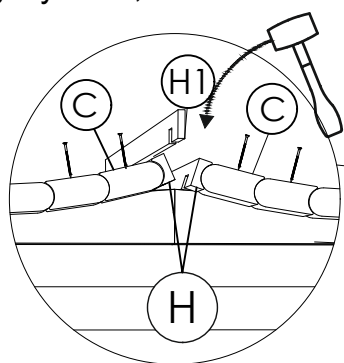


**STEP 12:** Fix 17 staves (C) on both sides with screws (S10). Use rubber hammer for tighter placement. Keep fixing staves till reach top of the roof.

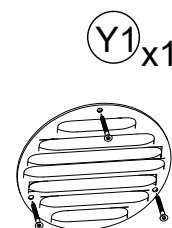
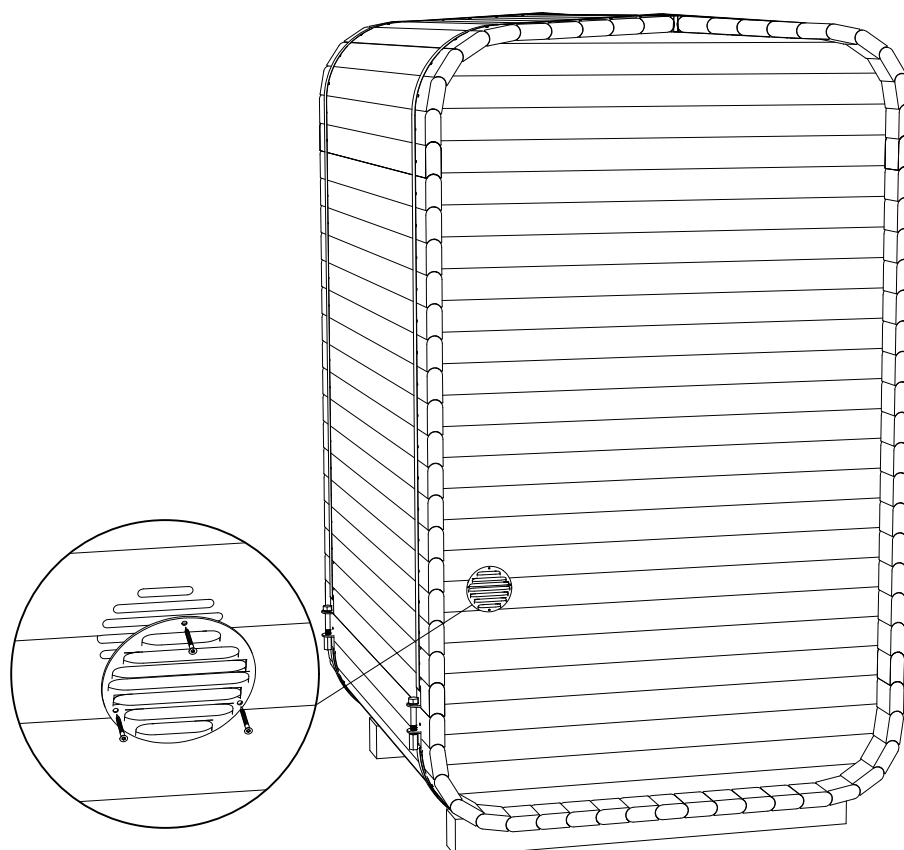




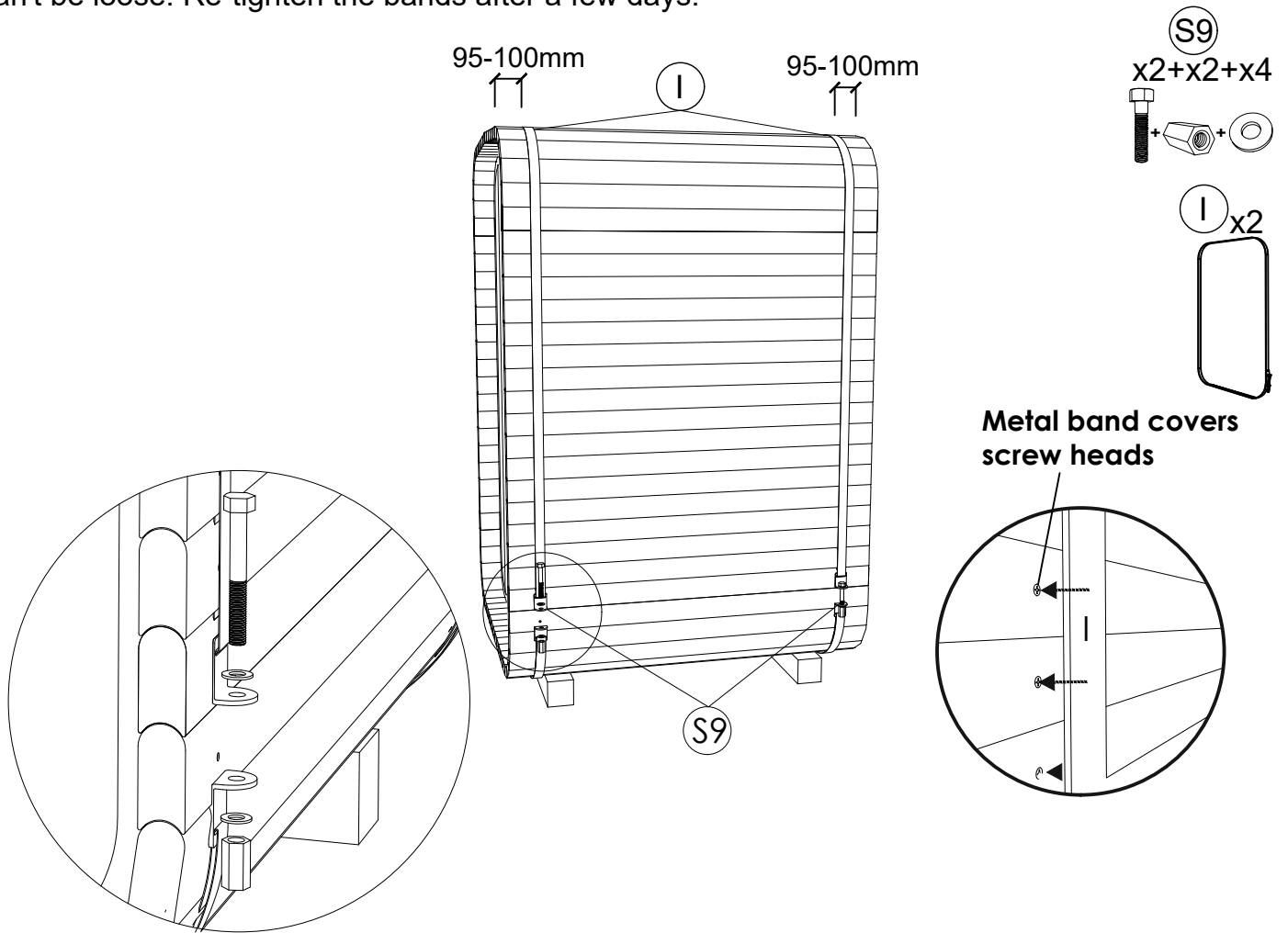
**STEP 13:** Finish roof with (C) staves and final staves (H). If needed, use thinner staves (H1) to fill the gap between (H) staves and apply spray foam between staves. Make sure that centre of the roof is tightly filled, then fix with screws (S10).



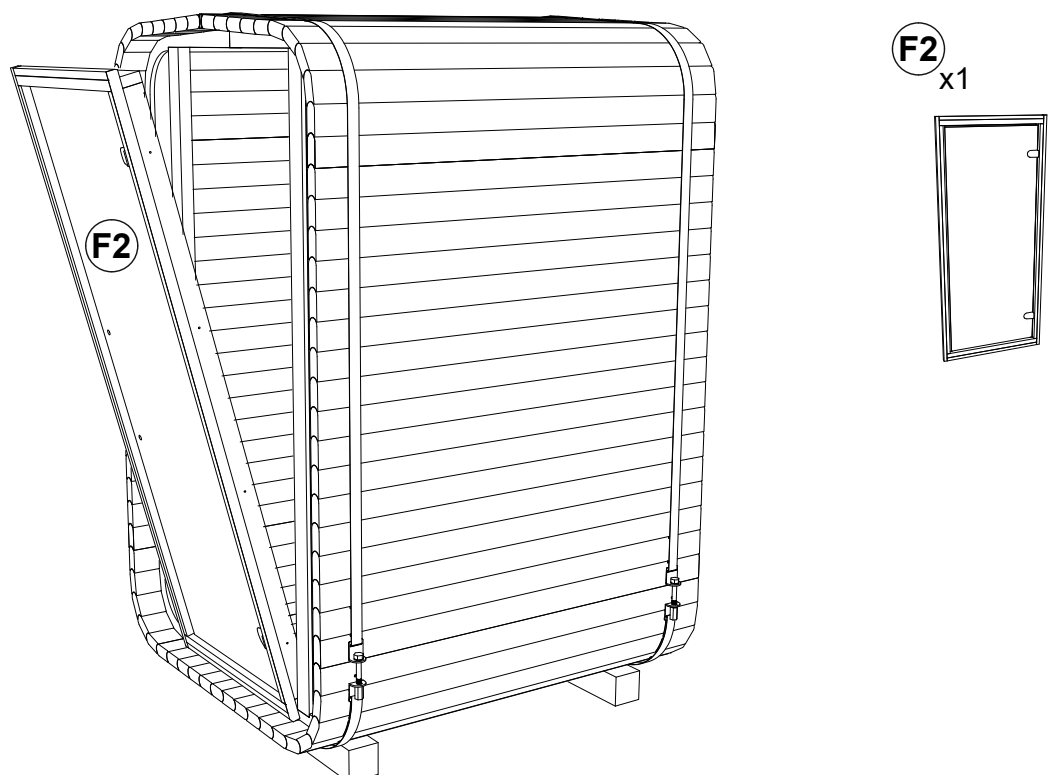
**STEP 14** Install ventilation grill from outside over the ventilation cuts.



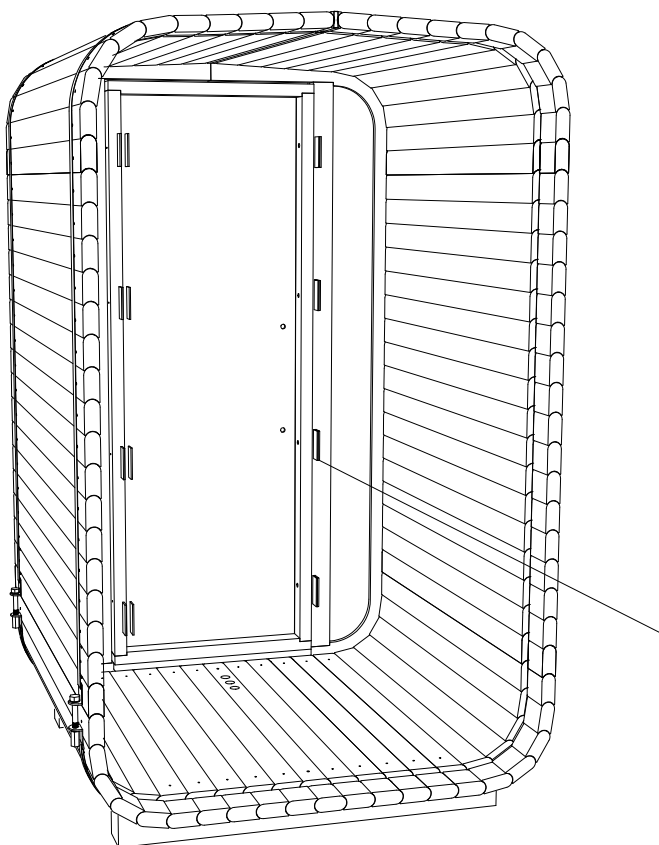
**STEP 15:** Install metal bands over the screw heads. **Screws (S9) must be placed as shown in picture**, then tighten the screws. Check the bands align evenly all around the sauna 95-100mm from the back and front. Keep tightening bands till you feel strong resistance, bands can't be loose. Re-tighten the bands after a few days.



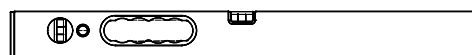
**STEP 16:** Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.



**STEP 17:** Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. Spacer must fit tightly.



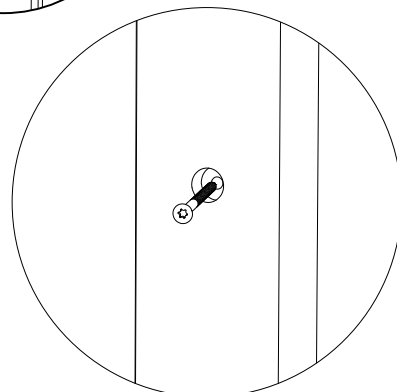
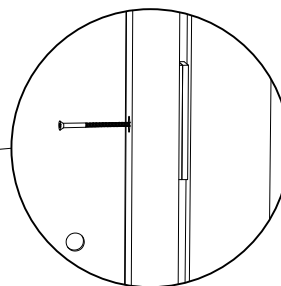
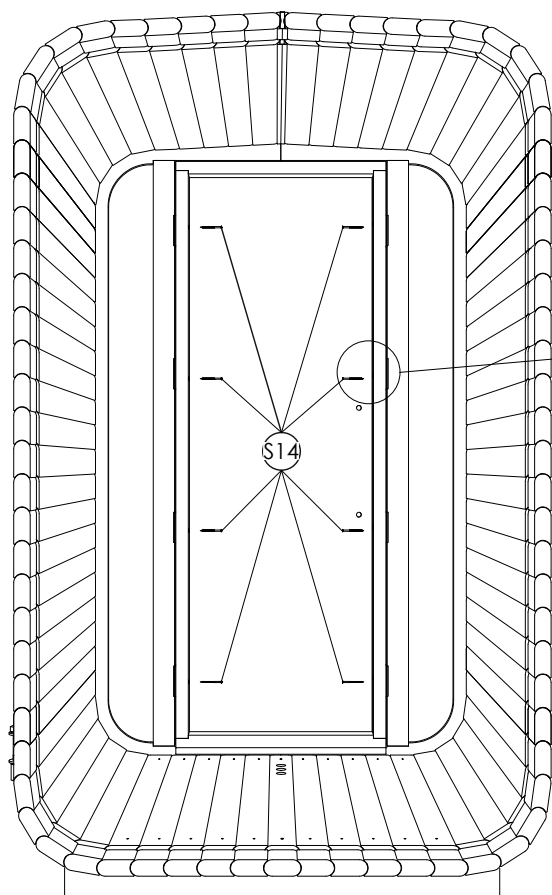
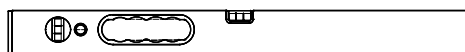
Use a level



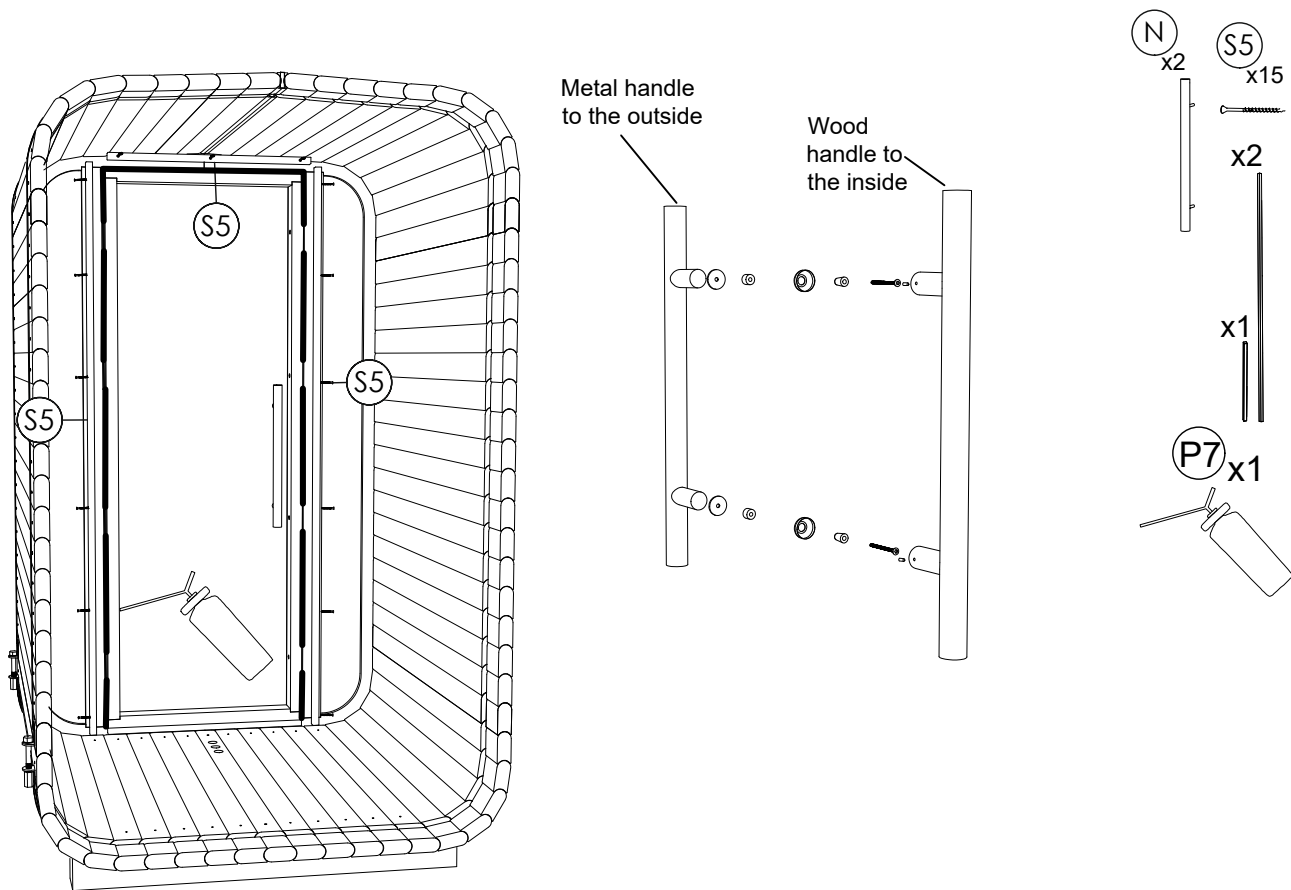
**STEP 18:** Fix one side of the door box with screws (S14) slightly to the outside through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly, they can't slip down before door is fixed with screws. Use screws (S14) to fix doors. Check door box, both sides should be straight, they must not be bent inwards or outwards.

S14  
x8

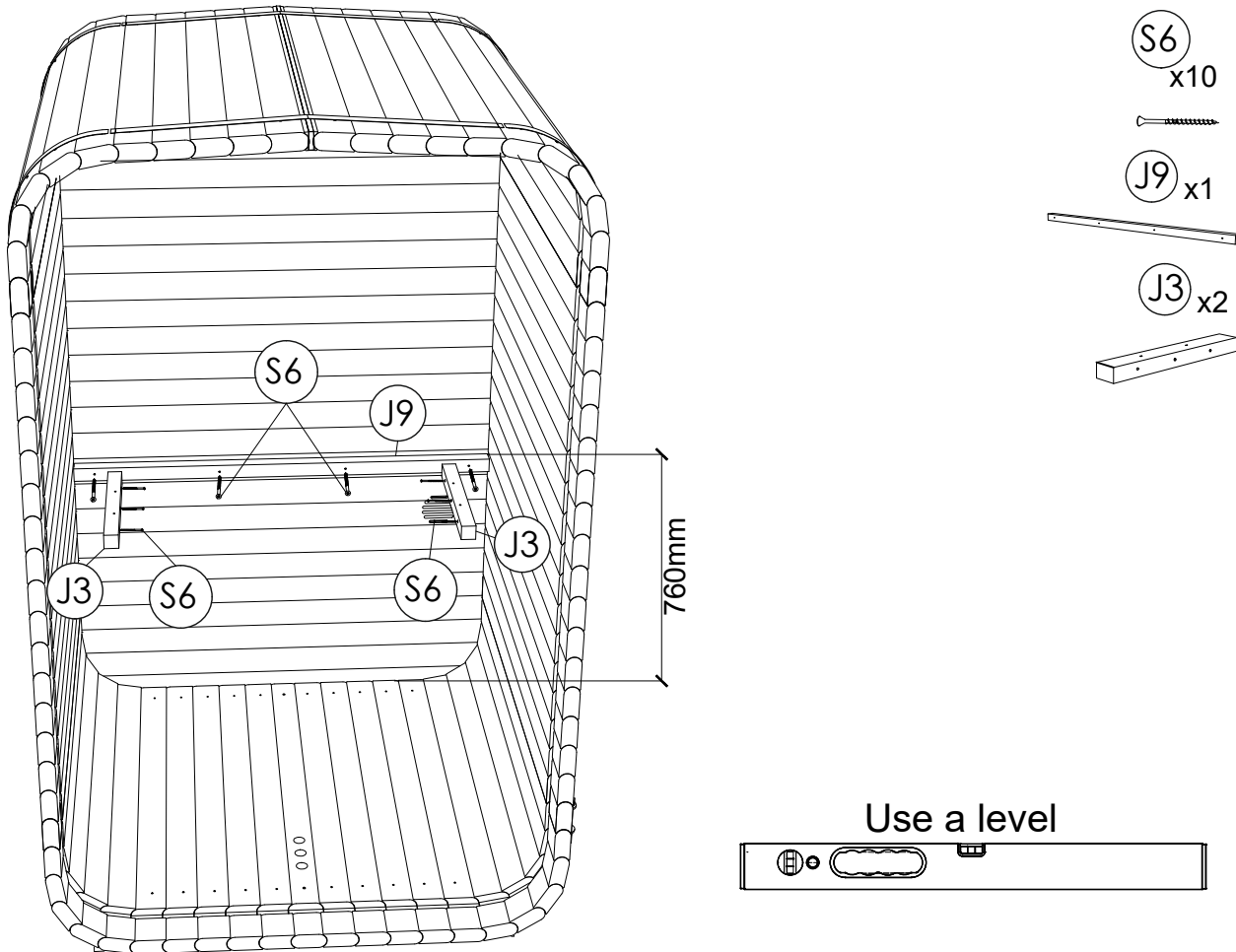
Use a level



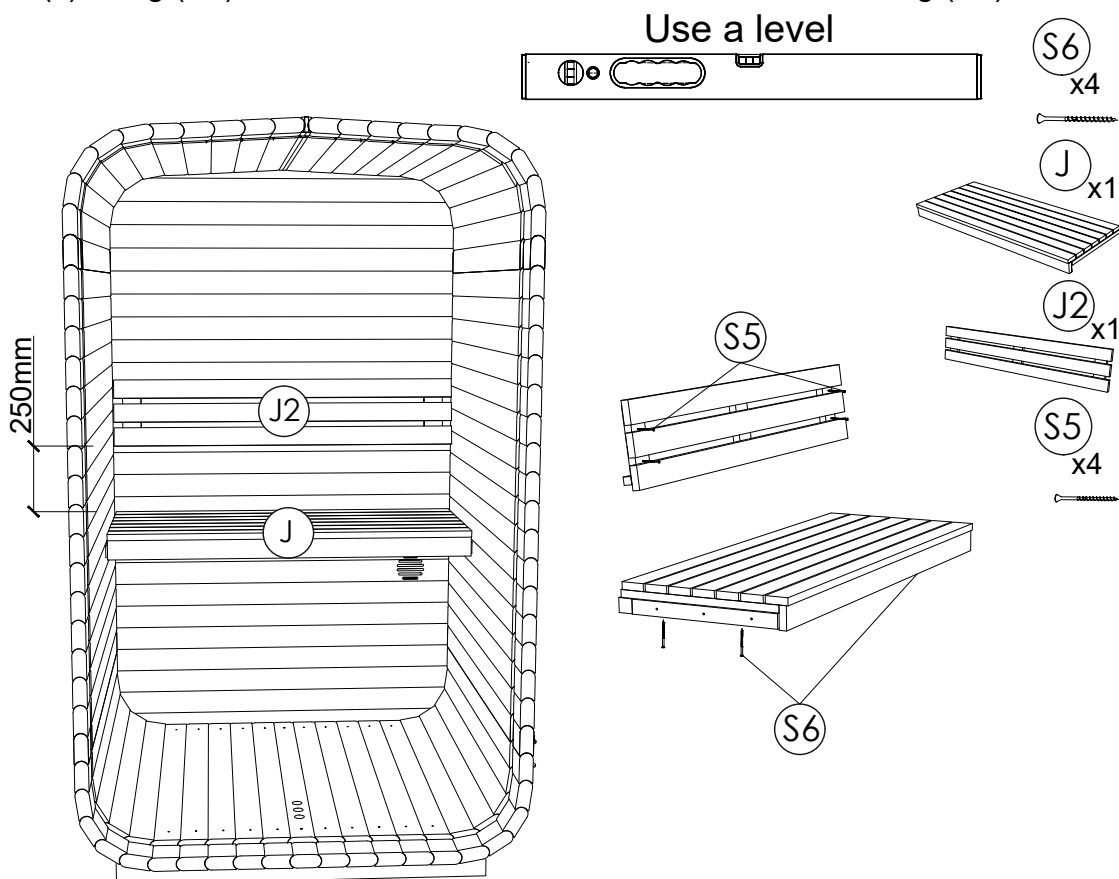
**STEP 19:** Fix door moldings to both sides and on top of the door with (S5) screws.



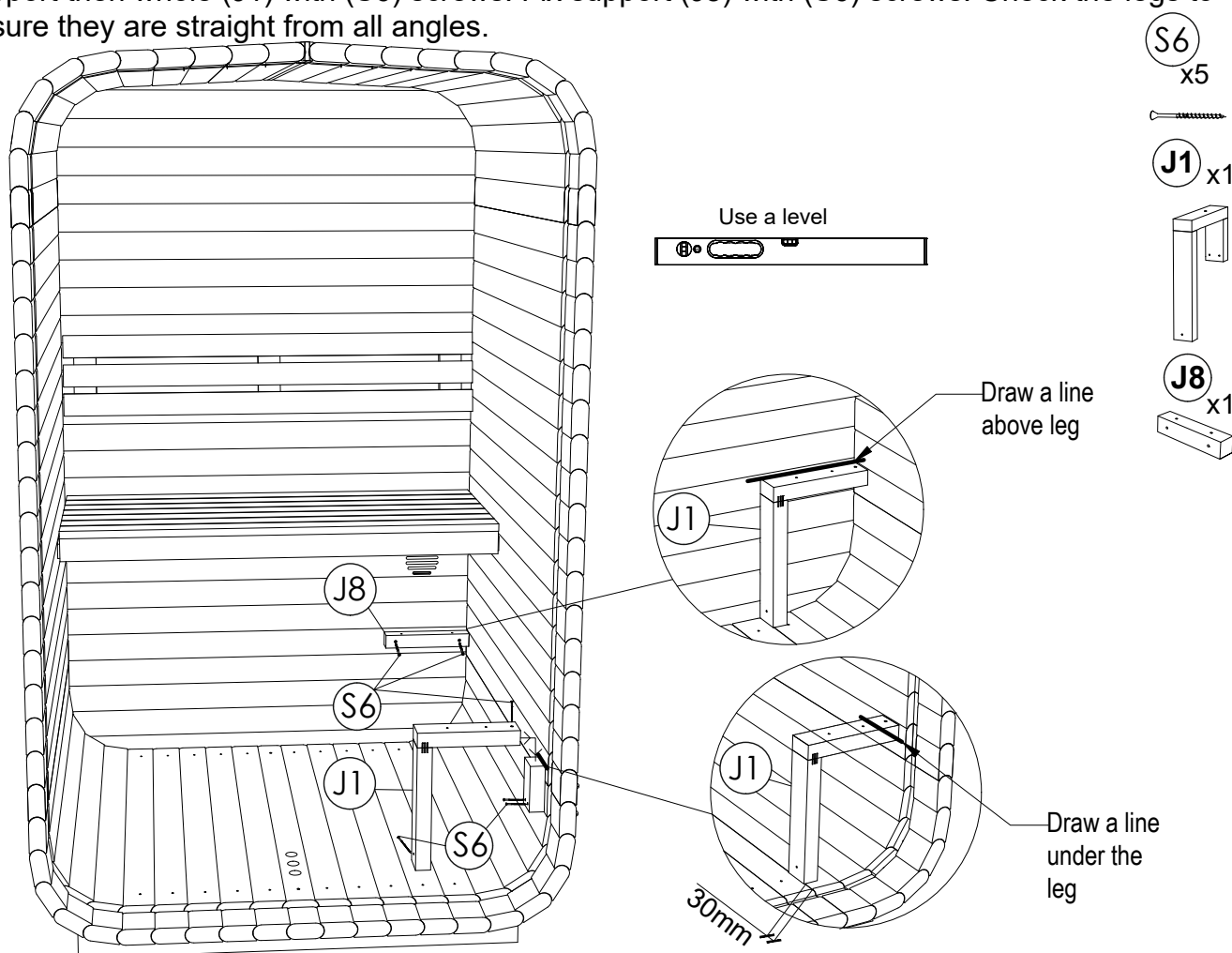
**STEP 20:** Install bench supports (J9;J3) with (S6) screws. Take measurements as in the picture. Check the the supports to ensure they are straight from all angles.



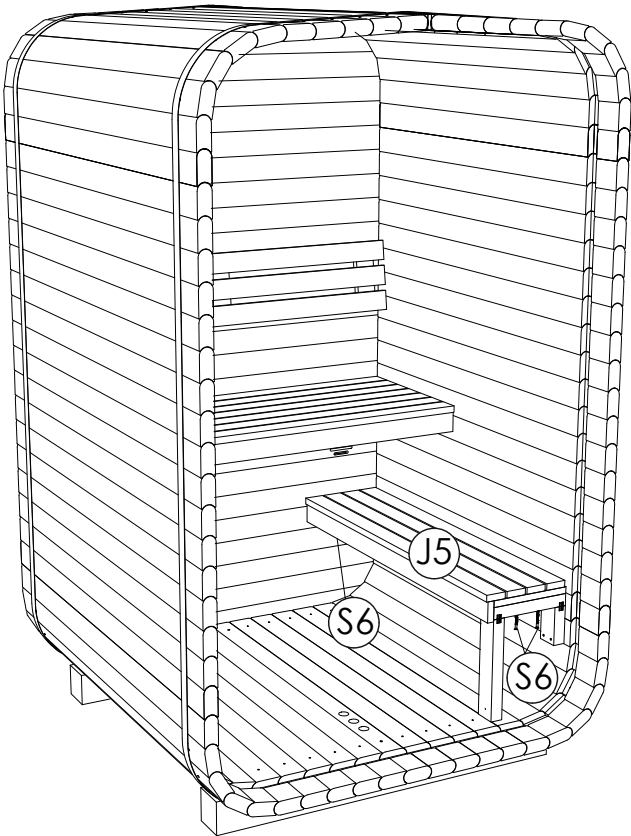
**STEP 21:** Fix bench (J) using (S6) screws. Fix backrest 250mm above bench using (S5) screws.



**STEP 22:** Put support leg(J1) on the back wall and draw a line for bench step support (J8) height. Put support leg(J1) 30mm from front wall and draw a line under leg upper part. Fix leg support then whole (J1) with (S6) screws. Fix support (J8) with (S6) screws. Check the legs to ensure they are straight from all angles.



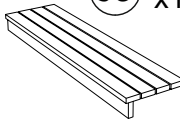
**STEP 23:** Fix step bench (J5) on top of the legs (J6) using (S6). Bench cross boards have to match the tops of the bench legs. Fix Bench step (J7) using (S6) screws.



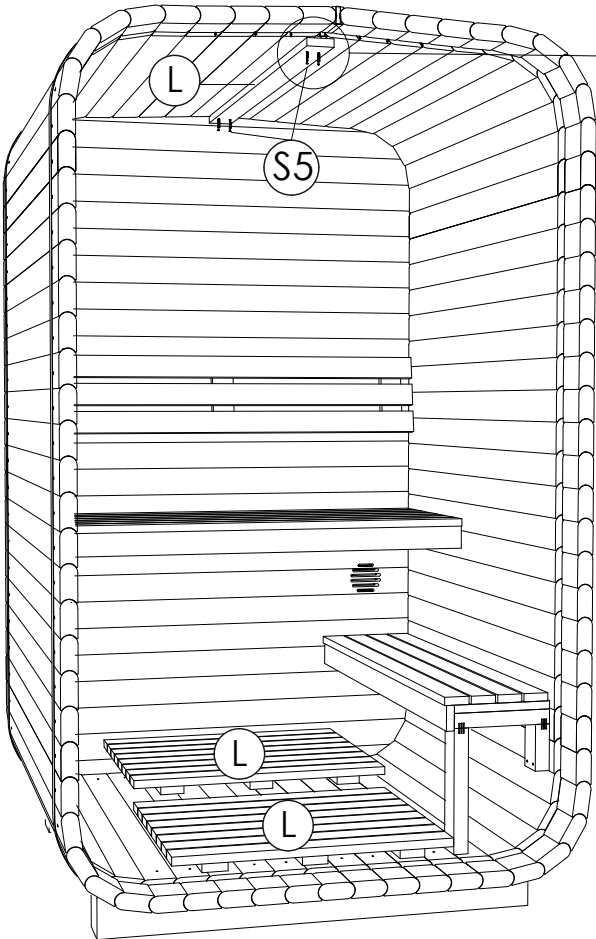
(S6)  
x4



(J5) x1



**STEP 24:** Install the ceiling board (O) in the middle of the ceiling, pre-drill holes for screws (S5). Lay in sauna floor (L).



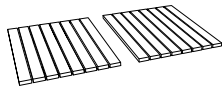
(S5)  
x4



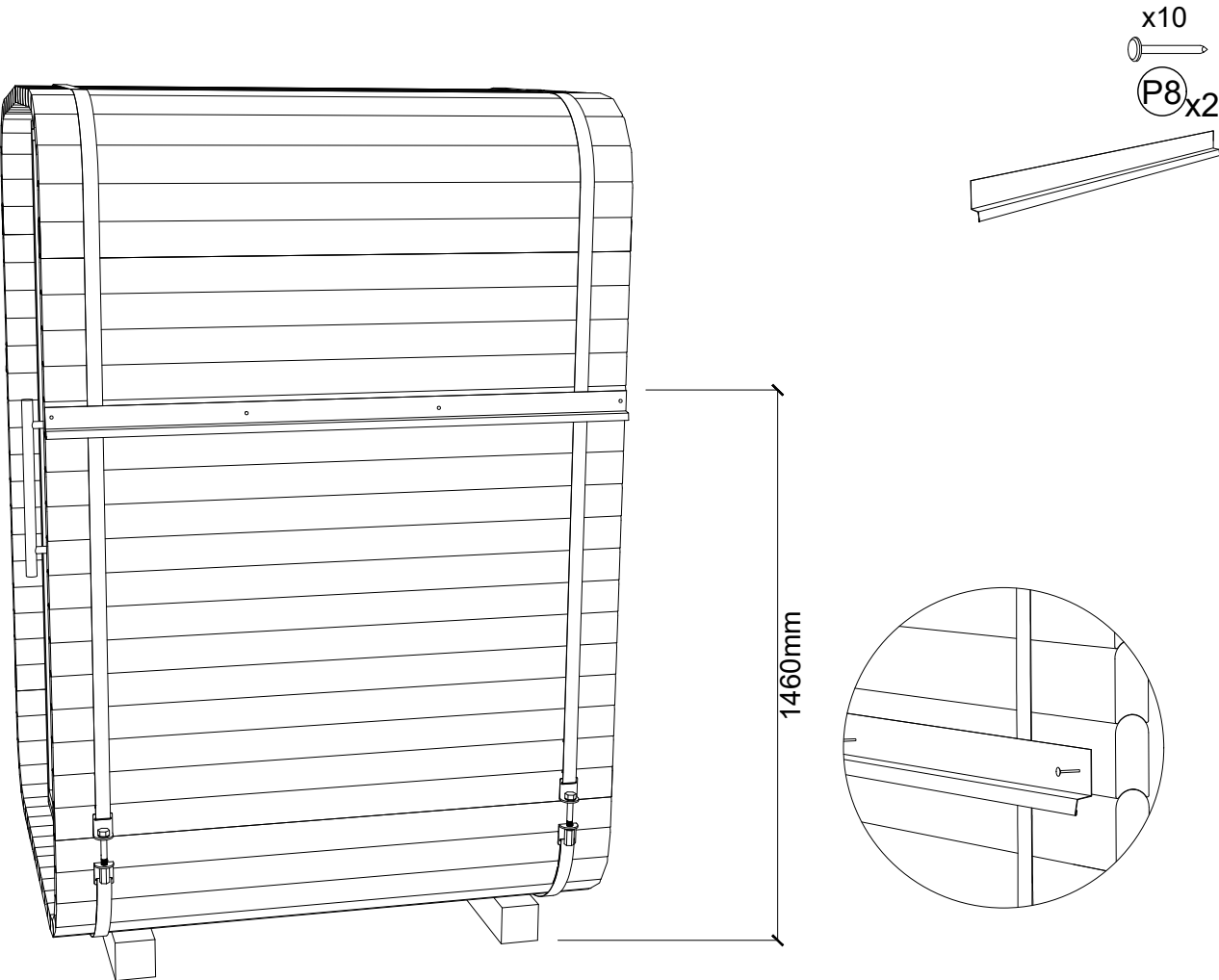
(O) x1



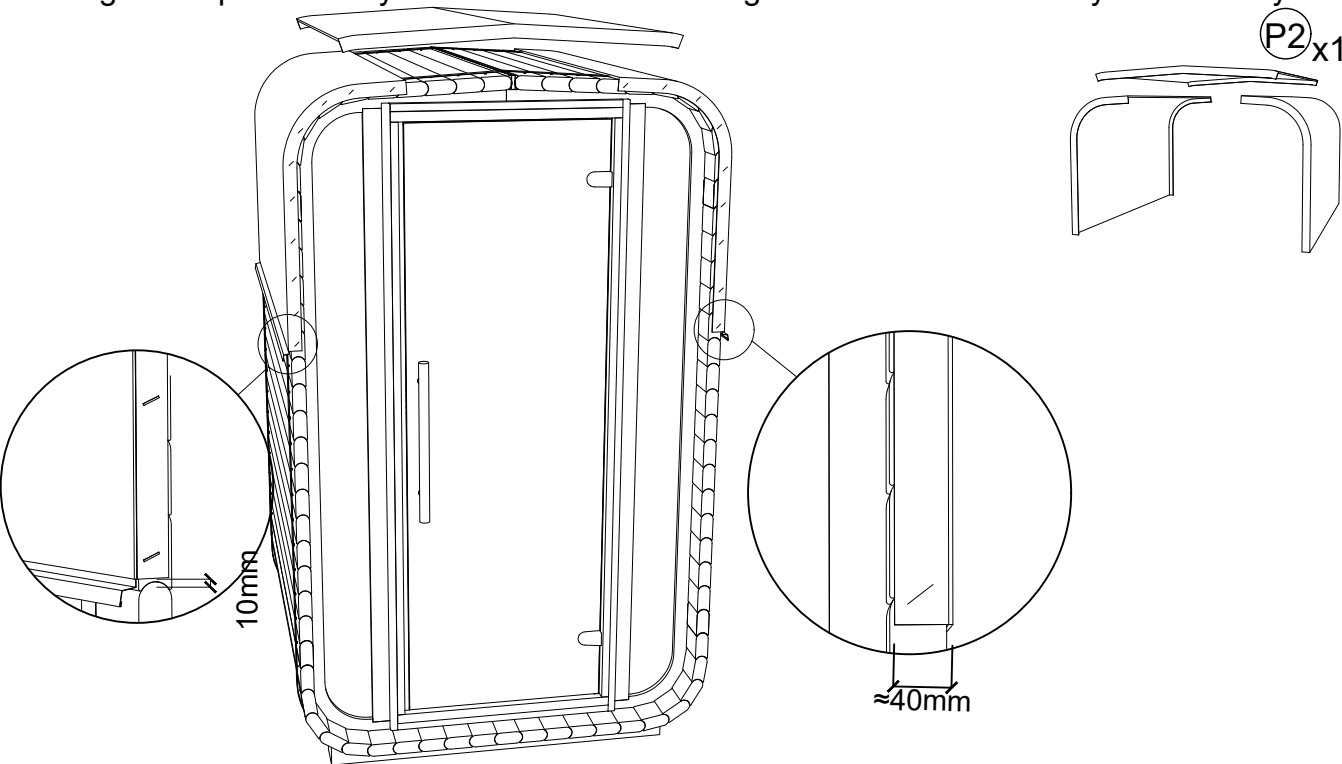
(L) x2



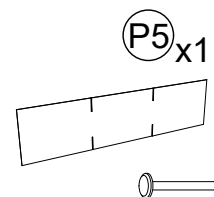
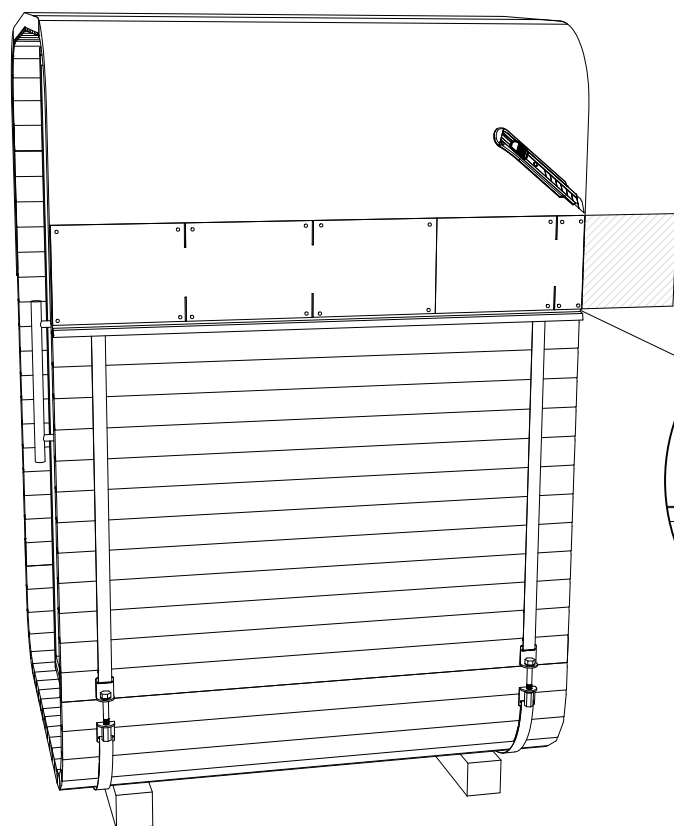
**STEP 25:** Place the rain droplet upper edge 1460mm from ground. Make sure it's leveled. Fix it on both sides with shingle nails.



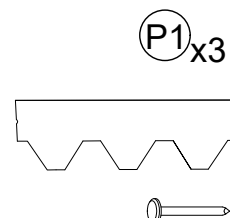
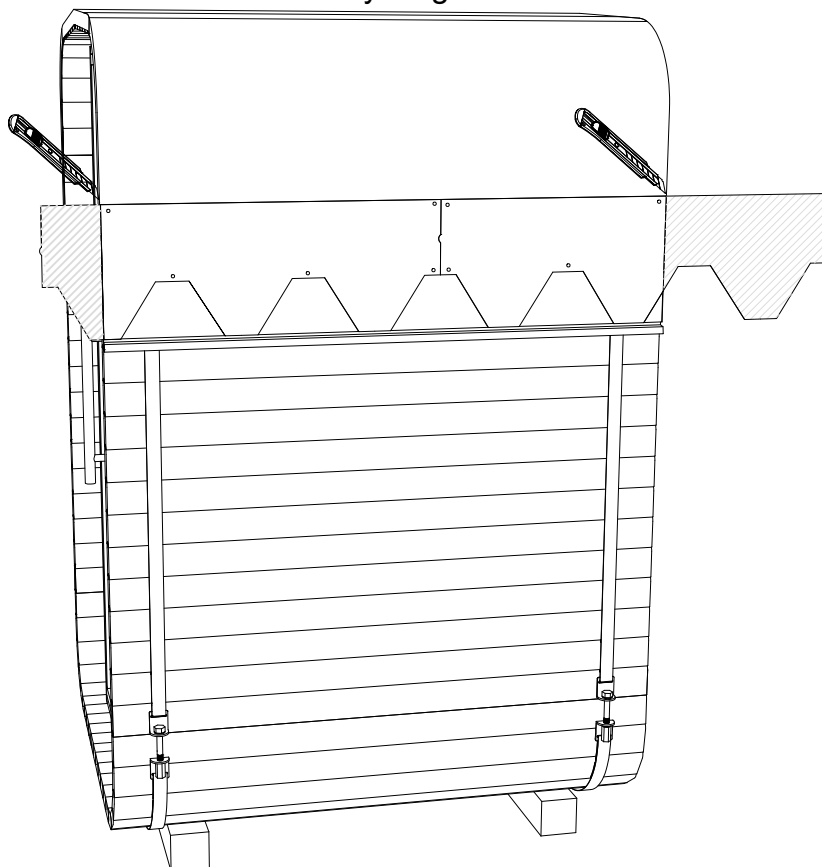
**STEP 26:** Lay out underlay on both sides first. Then lay middle part on top of the roof, that it is evenly placed and covers both underlay sheets. Leave about 40mm over the front and back edges. Staple underlay at the front and back edges. Cut excess underlay if necessary.



**STEP 27:** Remove protective film from the bottom of the sheet. Place starting shingles next to each other. Then fix with nails as in picture. Cut excess part of the starting shingle before nailing it. Do the same on the other side.

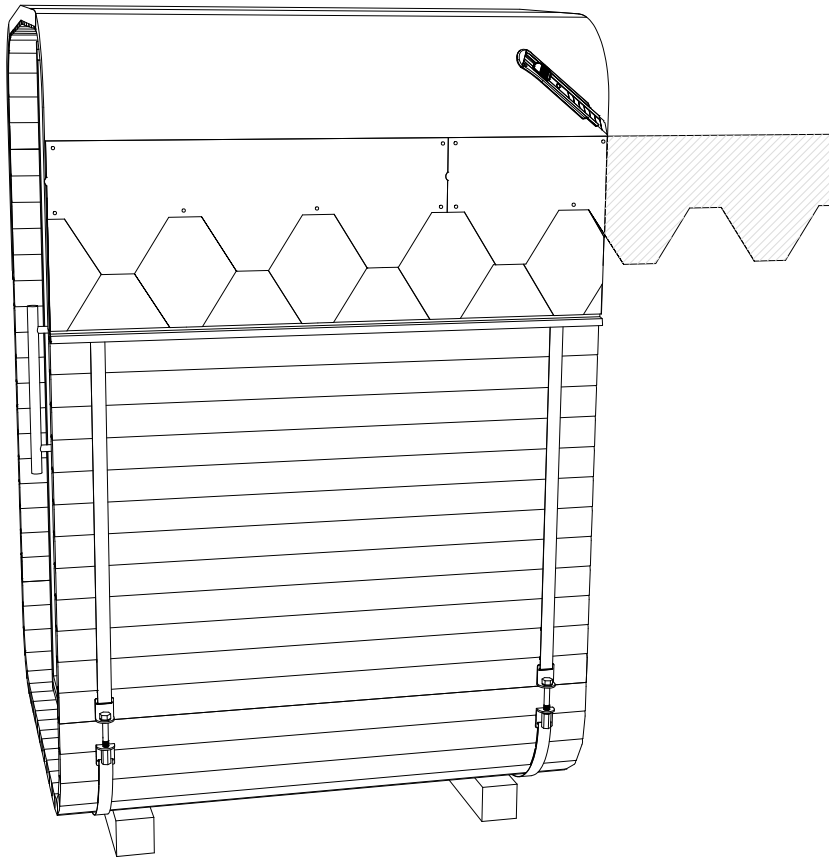


**STEP 28:** For 1st shingle cut off the half of hexagonal part. Remove protective film from the bottom of the sheet. Start placing shingles over starting shingles. Fix 2nd shingle needs to be cut. Measure the necessary length and fix it with nails.

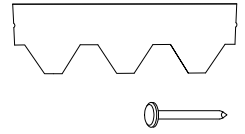




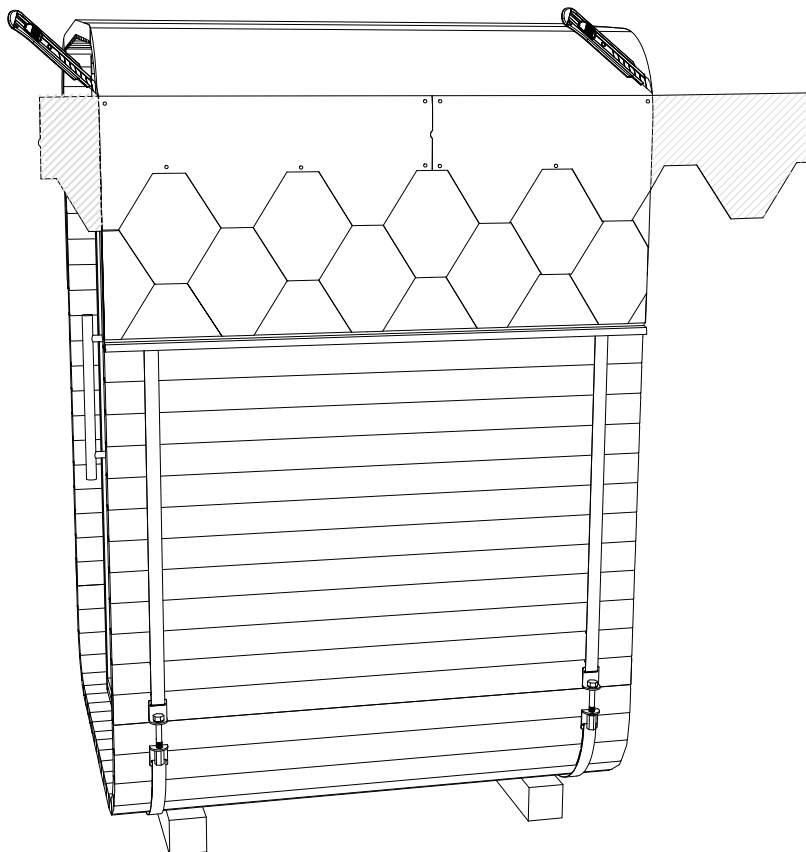
**STEP 29:** Remove the protective film from the bottom of the sheet. The second row starts with the whole shingle, fix it with shingle nails. Last shingle needs to be cut by measured length.



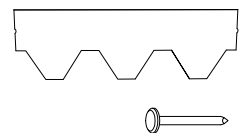
(P1)<sub>x3</sub>



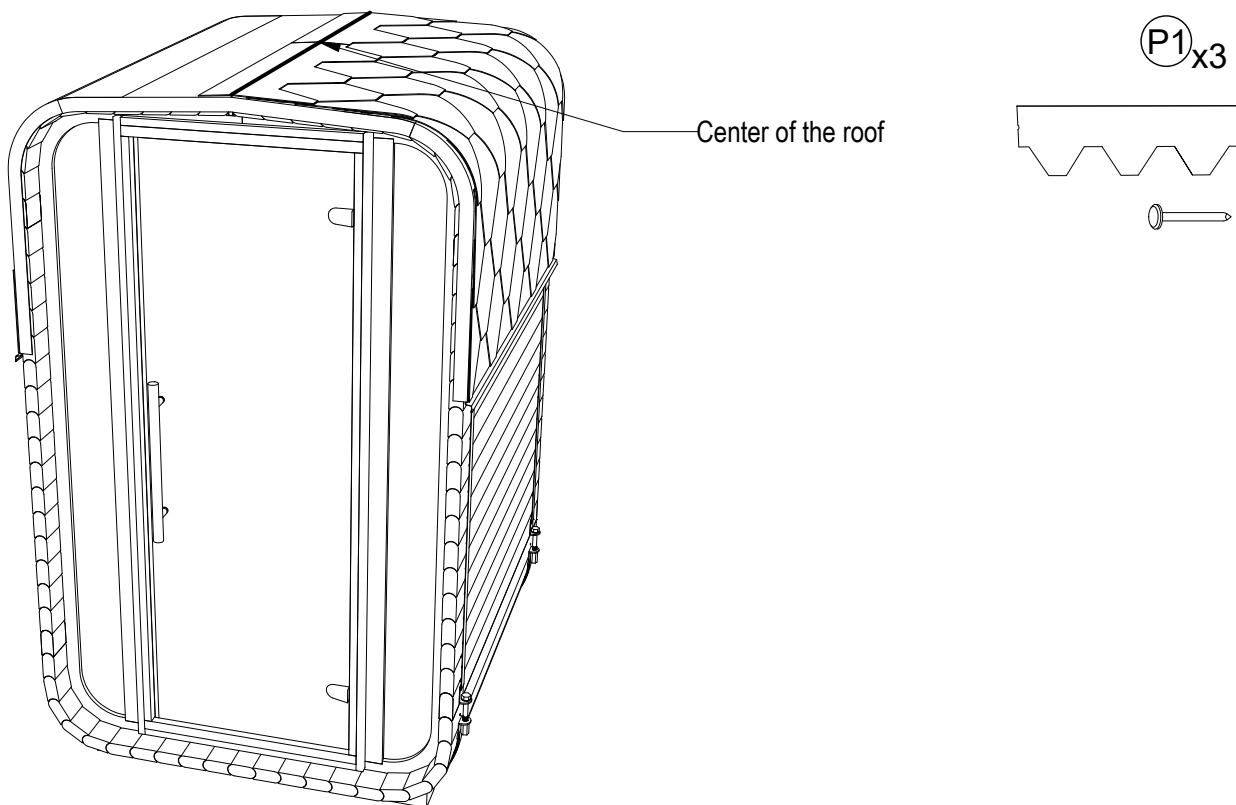
**STEP 30:** Third row goes exactly like first row. Cut half of hexagonal part from shingle and fix it with shingle nails. Remove protective film from the bottom of the sheet.



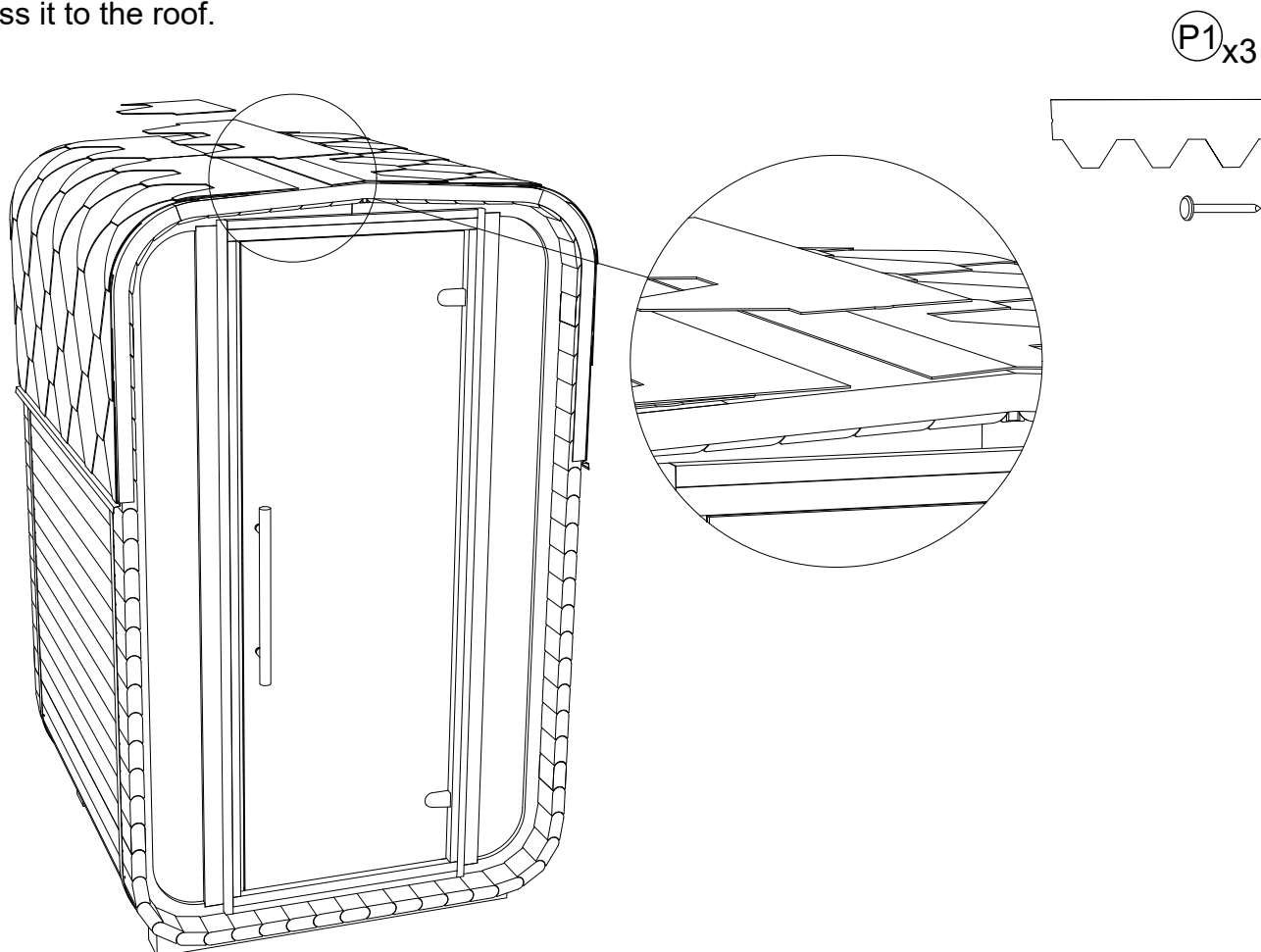
(P1)<sub>x3</sub>



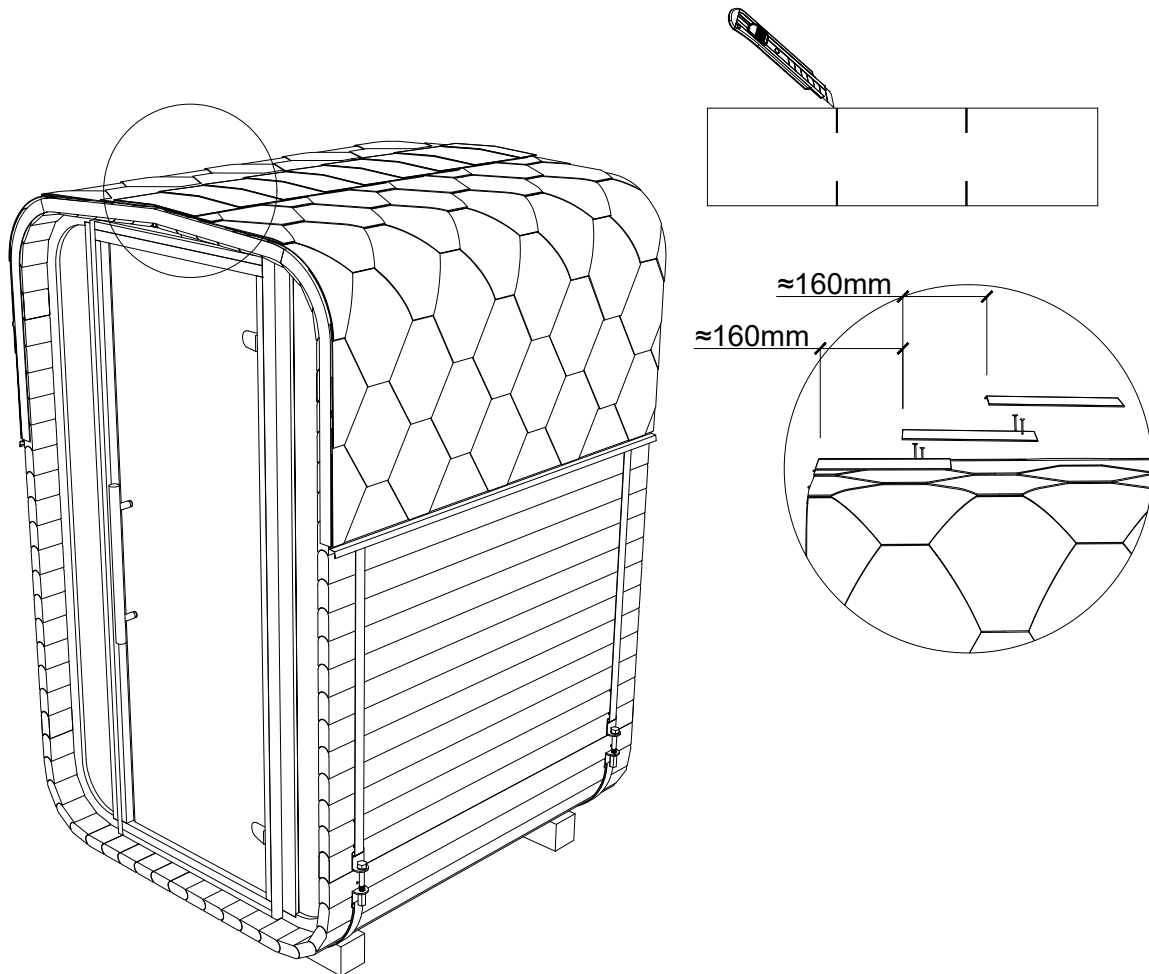
**STEP 31:** Keep placing shingles till last layer goes over the middle of the roof.



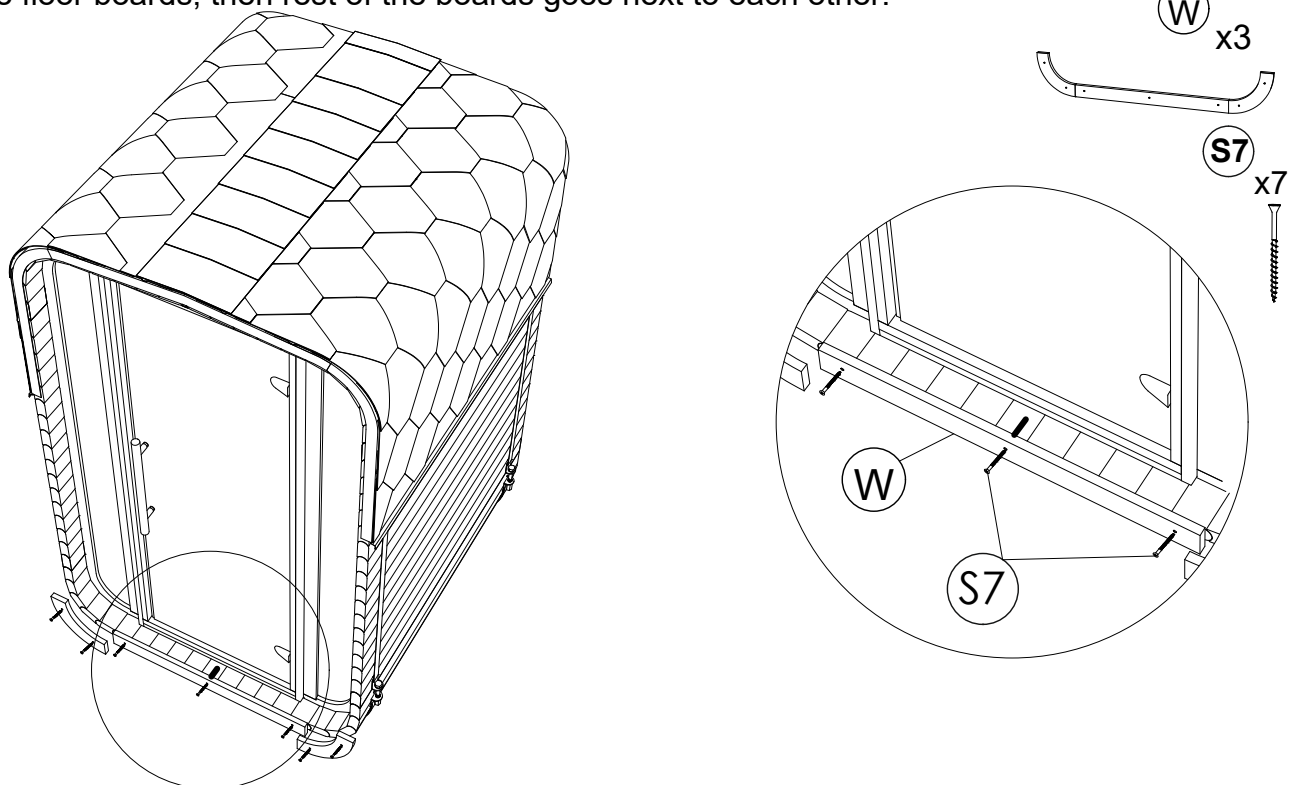
**STEP 32:** Repeat same steps for other side, till last layer goes over middle of the roof. Use heat source for better adhesion. Lift every rectangle, heat a bit with some heat source and press it to the roof.



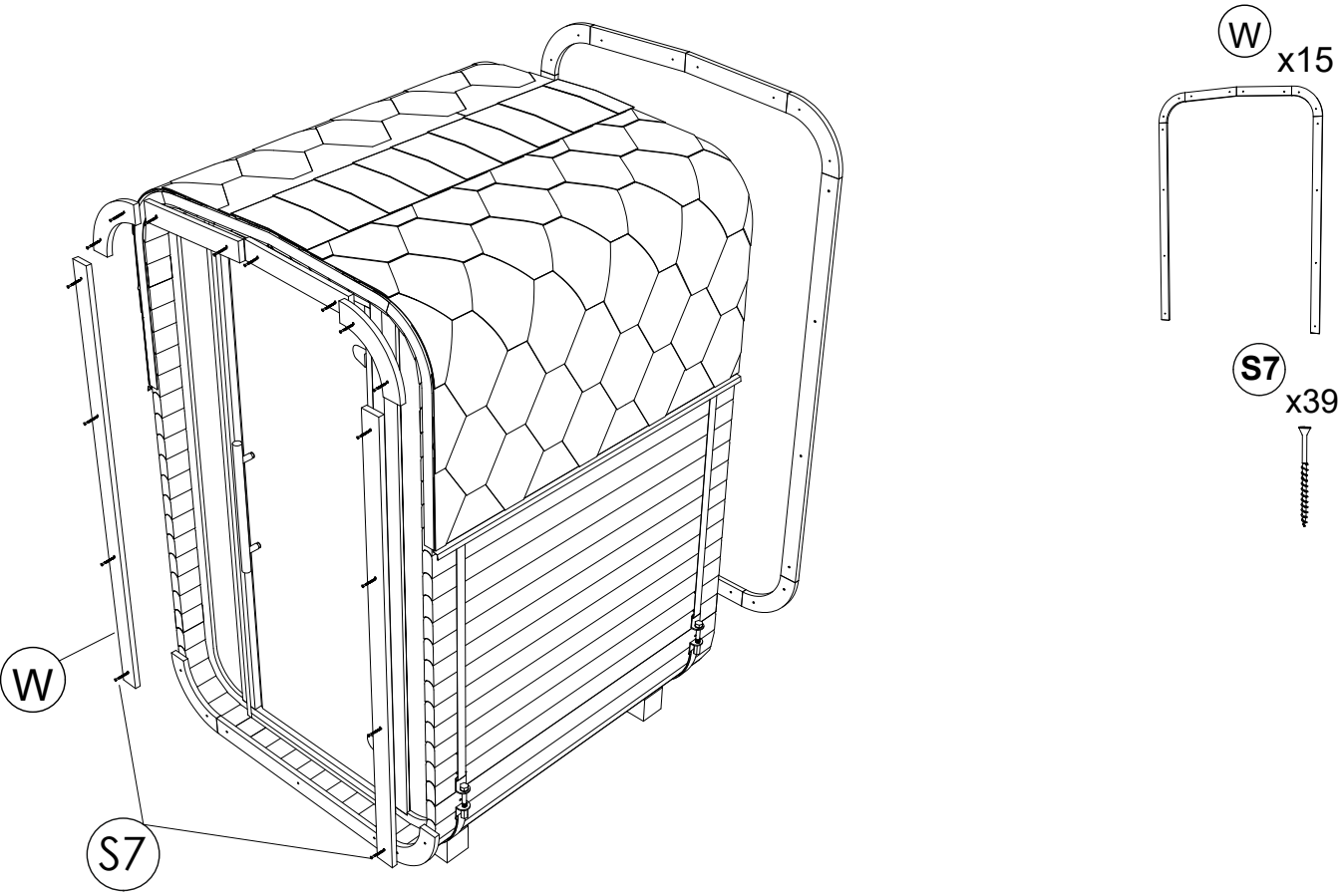
**STEP 33:** For top of the roof use starting shingles. Cut some shingles in squares, there are marked lines. Take off protective film. Nail each shingle with two nails. Next shingle goes about 160mm over previous. After it's done, use heat source for better adhesion.



**STEP 34:** Install front and back decorative roof finishing boards(W) using (S7) screws. Start by fixing one bottom board. Draw a center line put board exactly in the middle. Fix it about 5mm above floor boards, then rest of the boards goes next to each other.



**STEP 35:** Finish front decorative boards. Make sure they are in line. The same steps apply for back side.



**STEP 36:** Use silicon sealant behind decorative boards to fill gap between shingles and boards at the front and back side.

