



# ASSEMBLY INSTRUCTIONS

for

## LUNA SAUNA

Read these assembly instructions and the accompanying video to enhance your building experience.



[www.leisurecraft.com](http://www.leisurecraft.com)

Other fine products by Leisure Craft



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# CONGRATULATIONS

on the purchase of your

## Luna Sauna

**Just a few things to follow.....**

**Please be sure to read this entire manual  
Before proceeding with the assembly.**

All electrical connections must be performed  
By a qualified electrician.



For further information about your heater and  
Installation instructions, please refer to the  
provided heater manual.



Always ensure that you have the correct screw  
length so that the screw does not go all the way  
through the material and come out the other side.



# Tools Checklist

Ensure you have the following tools to finish the job right!



Cordless Driver

☐


Level

☐


2" Hole Saw with bit for cordless driver or drill. 1 1/2" size minimum

☐


Utility Knife

☐


#3 Robertson Bit (Short & 4" or longer)

☐


Mallet

☐


Wrench Socket 1/4" (6mm)

☐

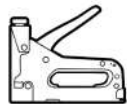

Pencil

☐


Hacksaw

☐


Hammer for optional thermostat

☐


or



Staple Gun or Nail/Staple Gun

☐


Tape Measure

☐


or



1/4" Wrench or Adjustable

☐


Square

☐

# Sauna Base Preparation

Ensure the base for your sauna is level with a slight slope to the back for drainage. A solid base for your sauna is recommended and can be made from the following.



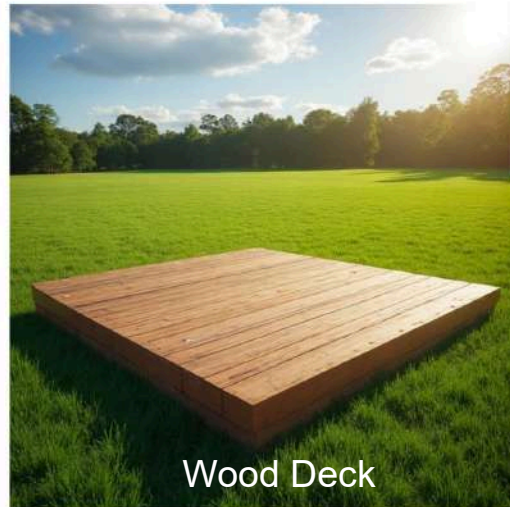
Crushed Stone



Patio Stone/Paver Blocks



Concrete Pad



Wood Deck

It is recommended to build a base larger than required to provide a sitting area for cooling off during your sauna session.

# Assembly Instructions



If you are assembling a Luna Sauna without a porch start here. If the Luna Sauna you are assembling contains a porch start at **Step 1P**.

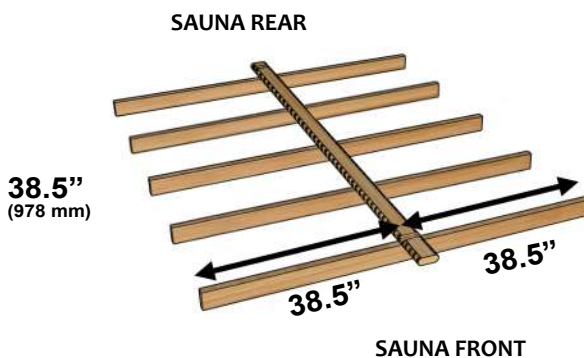
**1**

| Model       | Distance from front to back of Floor Joists |
|-------------|---------------------------------------------|
| 860LU/862LU | 66"                                         |
| 870LU/872LU | 79"                                         |
| 880LU/882LU | 90"                                         |

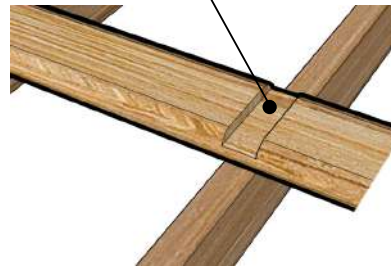


Use the above chart to spread out the cradle boards to the approximate distance given for your sauna model. Ensure the boards have a solid and flat base to rest on.

**2**



Stave groove



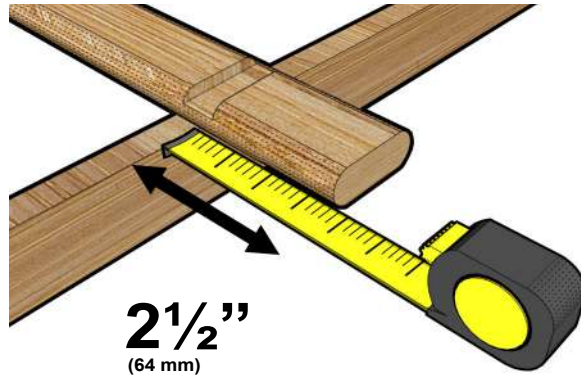
Stave Profile

Center the bottom stave on the floor joists. Ensure the groove on the stave is facing upwards and is square on the bottom floor joist.



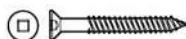
## Bottom Frame Assembly (No Porch)

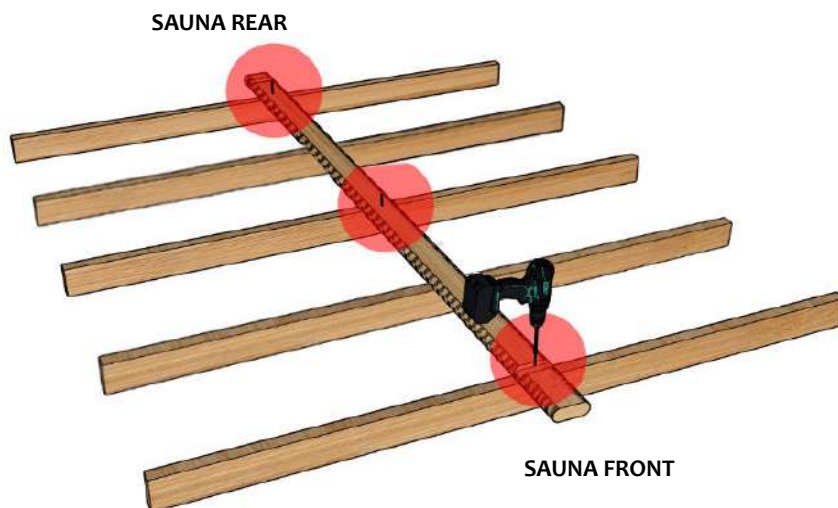
3



Ensure the stave is placed 2 1/2" (64 mm) from the front of the sauna build (no porch build).  
Repeat this for the back end of the sauna build.

4

 **3X**  
2.5" (64mm) Robertson



Fasten the center stave to the cradle boards with one screw for each intersection.  
Make adjustments as needed to ensure each intersection is square.

Continue to **STEP 6**



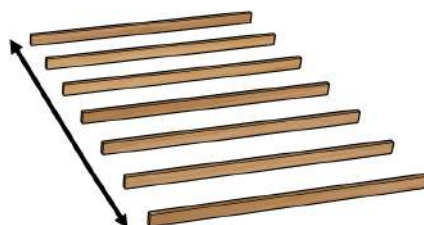
# Bottom Frame Assembly (Porch)



If the Luna you are assembling is a Luna Sauna that contains a **porch** start at here.

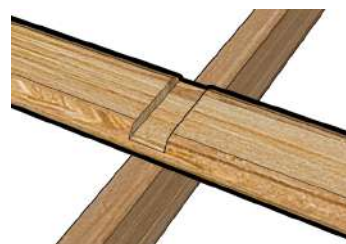
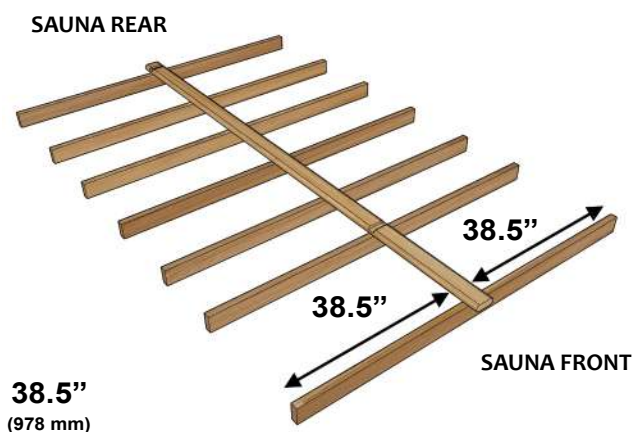
**1P**

| Model         | Distance from front to back of Floor Joists |
|---------------|---------------------------------------------|
| 860LUP/862LUP | 90"                                         |
| 870LUP/872LUP | 103"                                        |
| 880LUP/882LUP | 114"                                        |



Use the above chart to spread out the cradle boards to the approximate distance given for your sauna model. Ensure the boards have a solid and flat base to rest on.

**2P**



Stave Profile

Center the bottom stave on the floor joists. Ensure the groove on the stave is facing upwards and is square on the bottom floor joist.

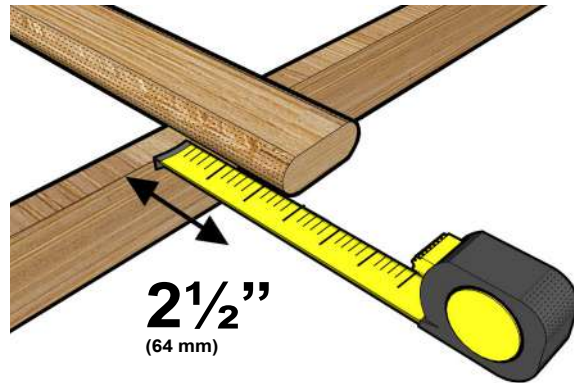


Scan the code for a video of the assembly process:



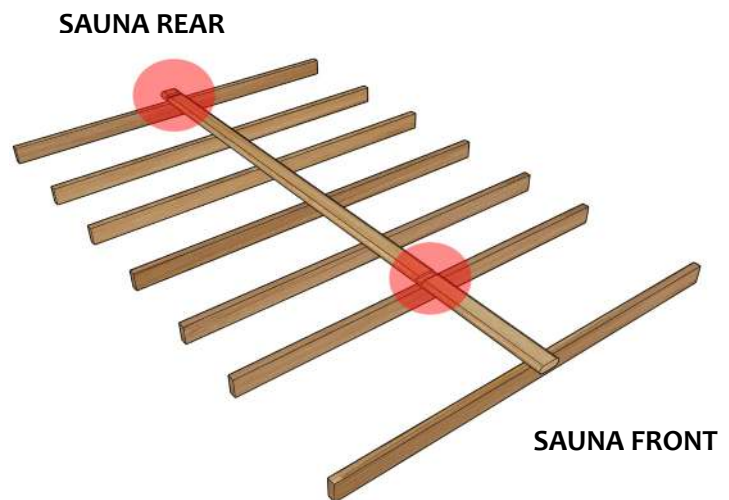
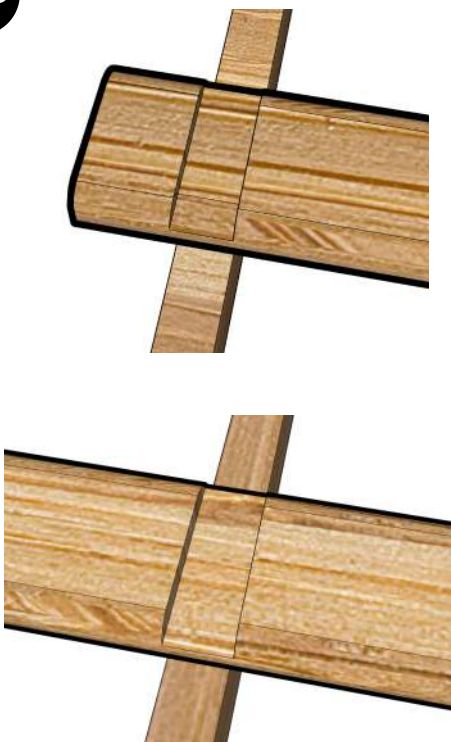
## Bottom Frame Assembly (Porch)

3P



Ensure the stave is placed 2 1/2"(64mm) from the front of the sauna build (porch build).

4P



Starting from the front of the sauna frame ensure the second and last cradle boards lie directly under the grooves in the center stave (see image above).



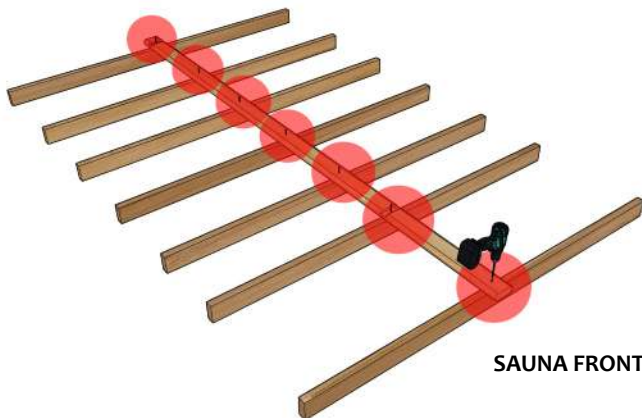
## Bottom Frame (Porch)

**5P**

 **7X**  
2.5" (64mm) Robertson



SAUNA REAR



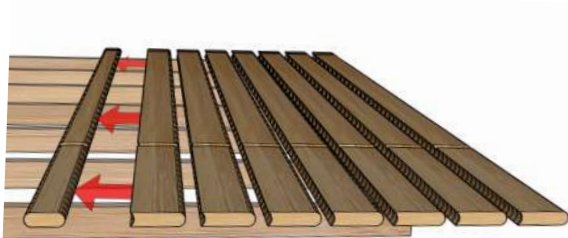
SAUNA FRONT



Fasten the center stave to the cradle boards with one screw for each intersection.  
Make adjustments as needed to ensure each intersection is square.

Continue to **STEP 6**

**6**



Lay 7 staves on one side of the center stave. Ensure they are aligned with one another.



Scan the code for a video of the assembly process:



## Bottom Frame Assembly

7



Repeat for the opposite side.

8

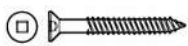


When finished line up the floorboards so they are flush and even with one other.



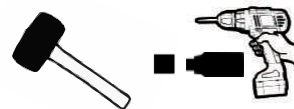
## Bottom Frame Assembly

9

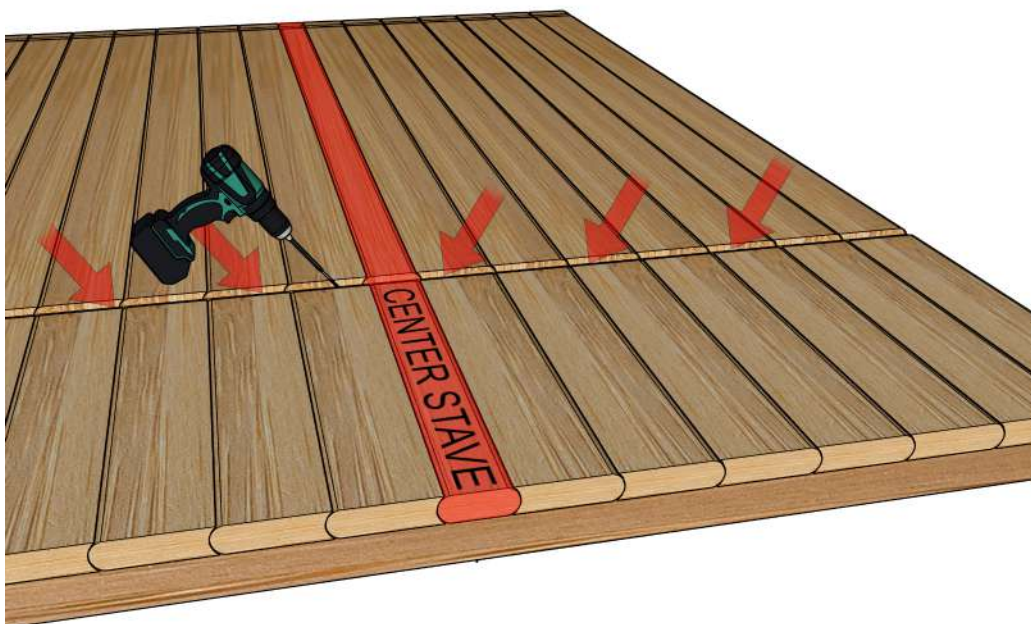


2 1/2" Robertson

14X



**TIP:** Use a rubber mallet to tighten the fit between the floor boards.

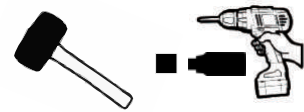


Starting with the stave closest to the center stave tap it tightly towards the centre. Next fasten a screw angled towards the center stave. Repeat this for all staves starting from the center to the outside of the platform. Do this for both sides of the center stave.



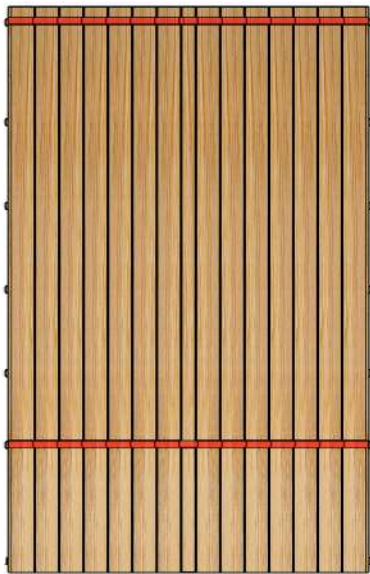
## Bottom Frame Assembly

**10**  **14X**  
2 1/2" Robertson



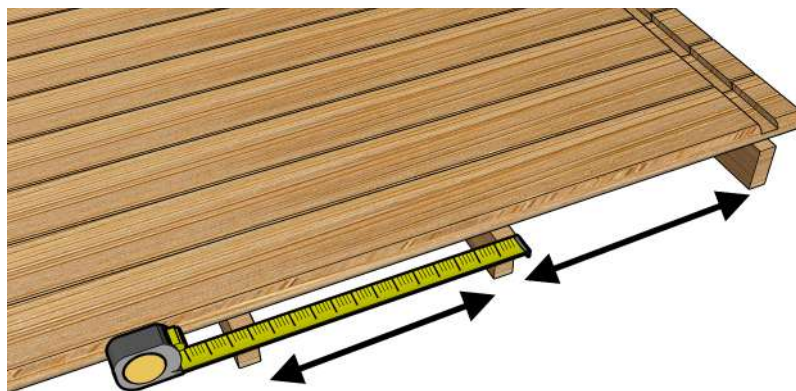
Groove B

Groove A



On the inside of **Groove A** and **B** add a screw for every stave.

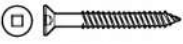
**11**

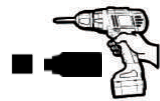


Use a tape measure to evenly space out the remaining cradle boards.



## Back Wall Assembly

**12**  **10X**  
2 1/2" Robertson



Fasten the remaining cradle boards with screws.

**13**

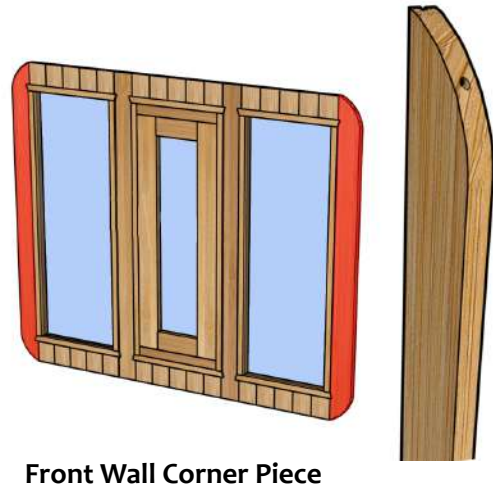
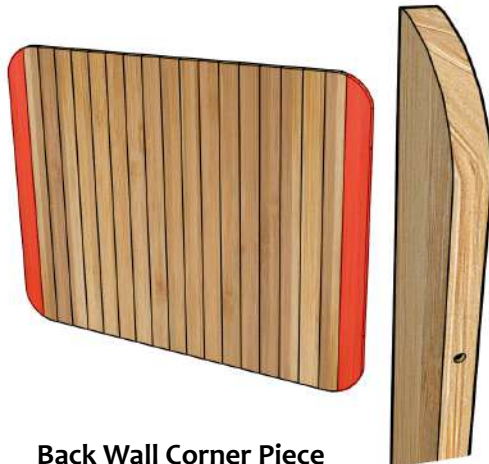


Layout the back wall staves. There should be 4 curved staves for the ends of the wall. There will be 15 straight staves used for the middle of the wall.



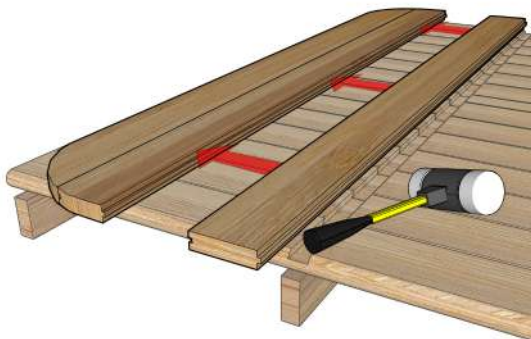
## Back Wall Assembly

14



There are two types of corner pieces for your sauna.  
Ensure you have the correct corner pieces for the back wall assembly.  
Use the image above to identify the back wall corner pieces.

15



Gently hammer the staves working from side to side to connect them together.



## Back Wall Assembly

16



Continue adding staves until the wall is approximately half built.

17



4X

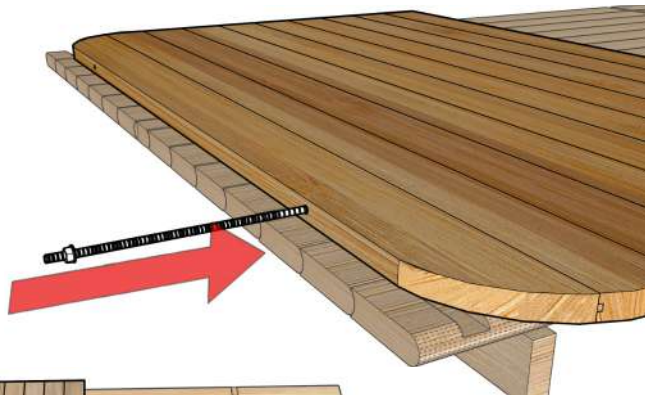
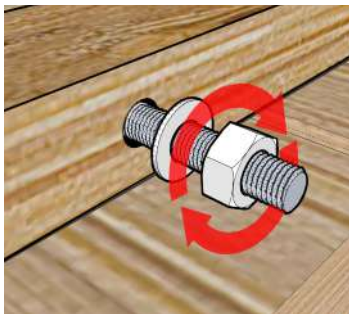


1/4" Wrench

or



Adjustable

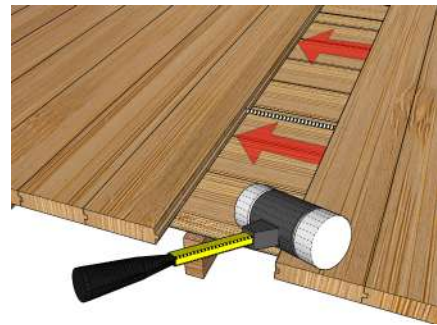
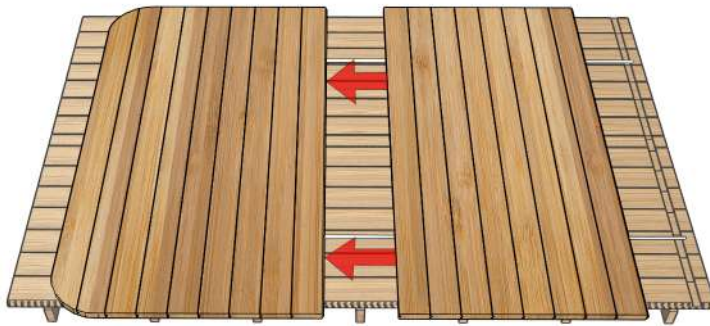


Add a washer & nut to the ends of two threaded rods.  
Slide the threaded rods through the holes of both stave ends.



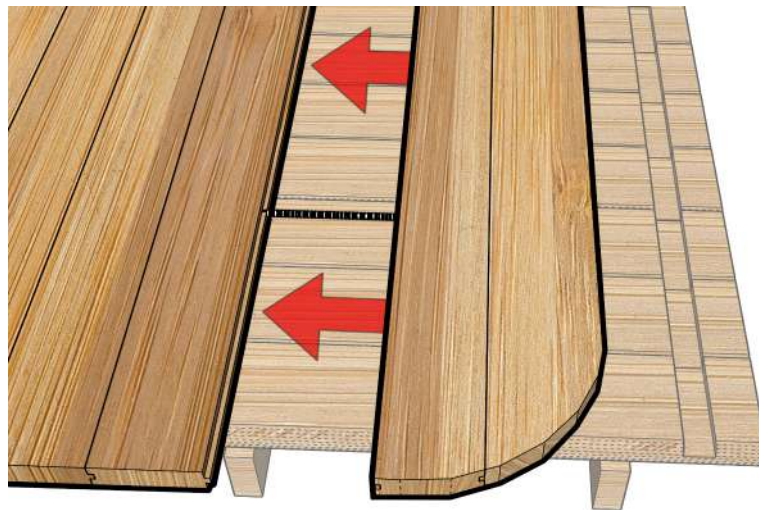
## Back Wall Assembly

18



Continue sliding straight staves onto the threaded rods. Connecting the staves together gently hammer each stave together to ensure a tight fit.

19

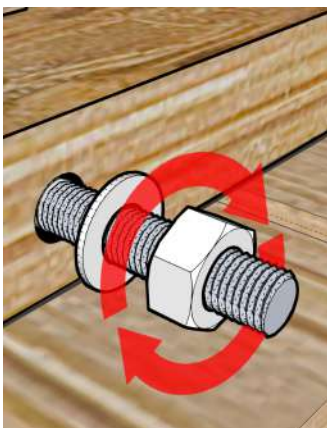
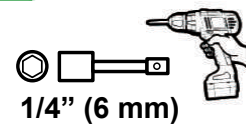


After the straight staves have been added, slide the corner pieces onto the threaded rods. Hammer the corner staves for a tight fit.



## Back Wall Assembly

20



Add a washer and nut onto the end of the threaded rod. Do this for both threaded rods.  
Tighten both threaded rods.

21



Cut off any threaded rod that is protruding from the four holes with a hacksaw.

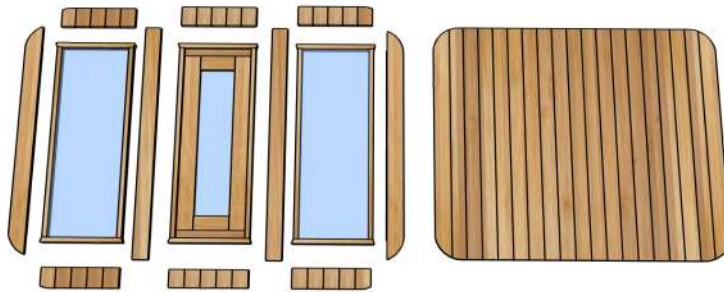


Scan the code for a video of the assembly process:



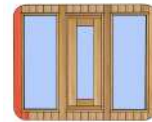
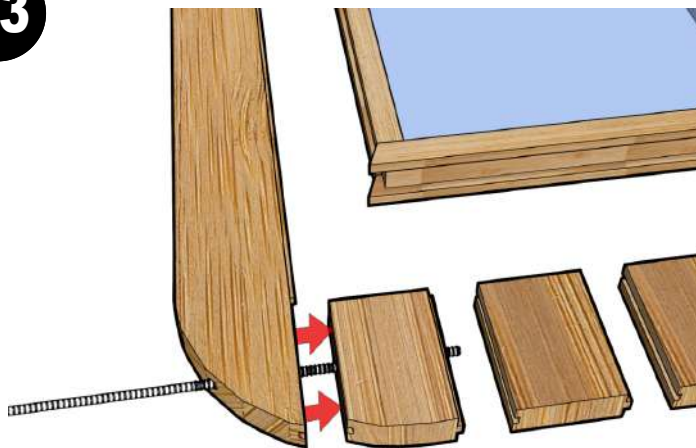
## Front Wall Assembly

22



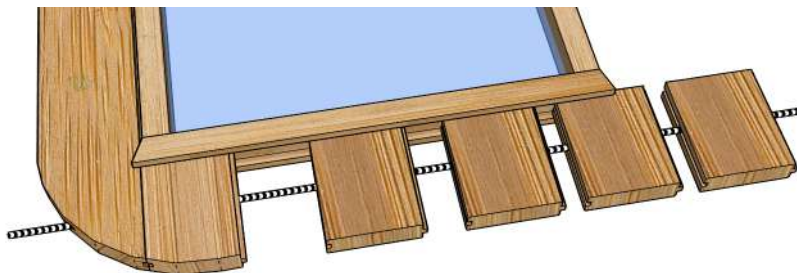
Using the assembled back wall as a guide, lay out the front wall including windows and door.

23



Slide the threaded rod through the bottom hole into the small curved corner stave.

24

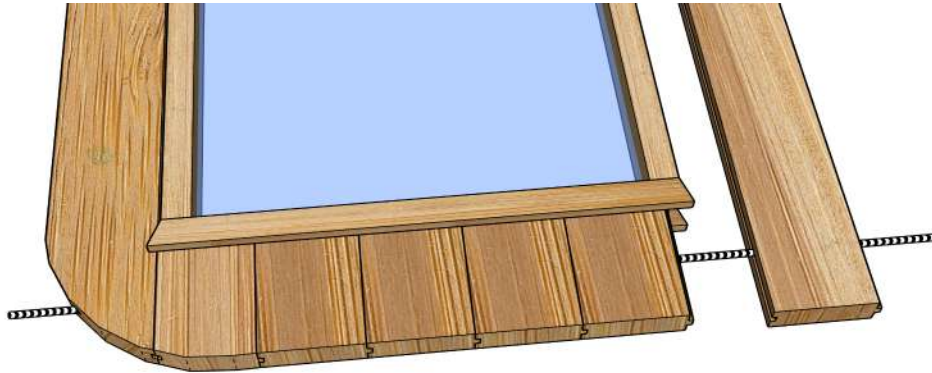
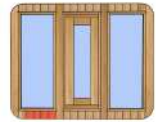
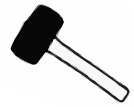


Continue sliding more staves along the threaded rod. Tap each stave to ensure a tight fit between the other staves and the window.



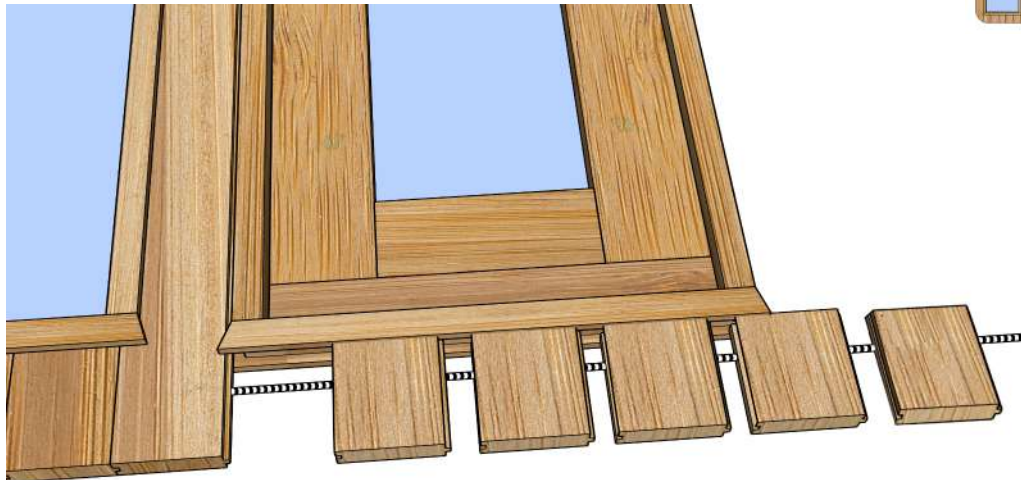
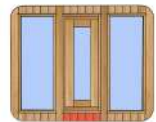
## Front Wall Assembly

25



As you continually add staves to the front wall ensure a tight fit between the other staves and the window by tapping staves together.

26

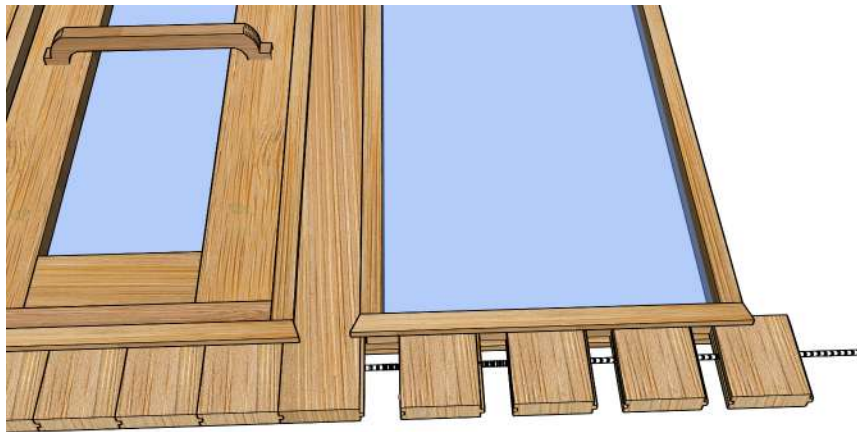


## Front Wall Assembly

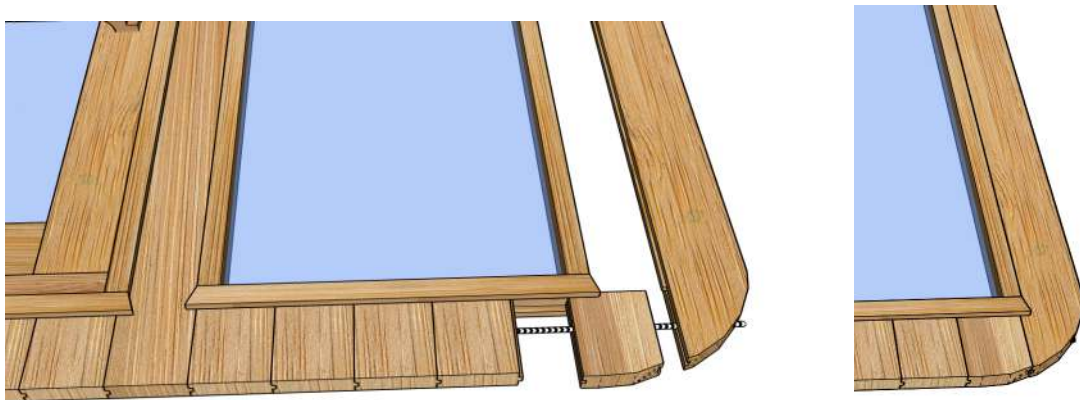
27



28

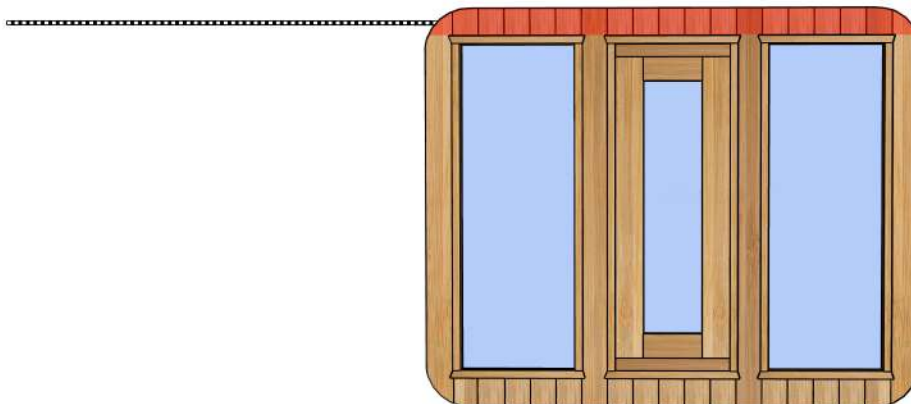


29



## Front Wall Assembly

30



Follow through **STEPS 23-30** to assemble the staves covering the top of the wall.

31



4X

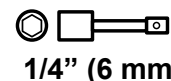


1/4" Wrench

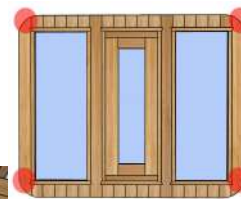
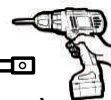
or



Adjustable



1/4" (6 mm)

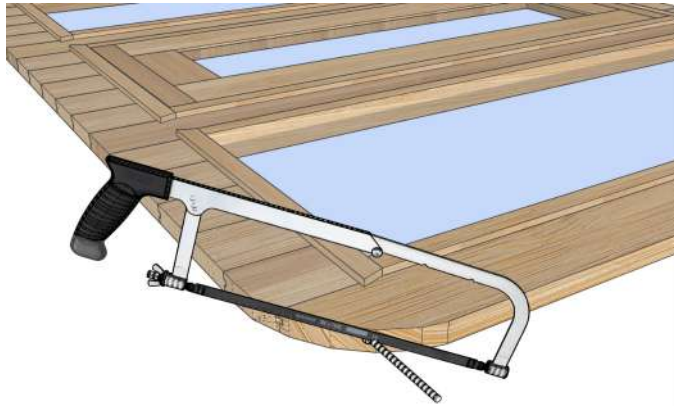


Add a washer and nut on the end of the threaded rod. Do this for both threaded rods at both ends. Tighten all threaded rods.



## Front Wall Assembly

32



Cut off any threaded rod that is protruding from each of the four holes with a hacksaw.

33



Use a broom or a brush to remove any debris from inside the dado grooves.  
This will ensure a better fit for connecting walls.



## Front Wall Assembly

34



Recommended  
two person job

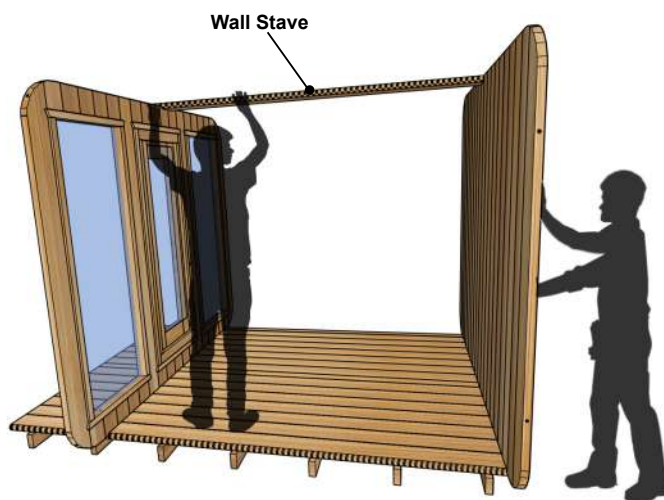


Using a helper, stand up the front wall and place in groove at the front of the sauna.  
Ensure it is centered on either side of the floor platform.

35



Recommended  
two person job

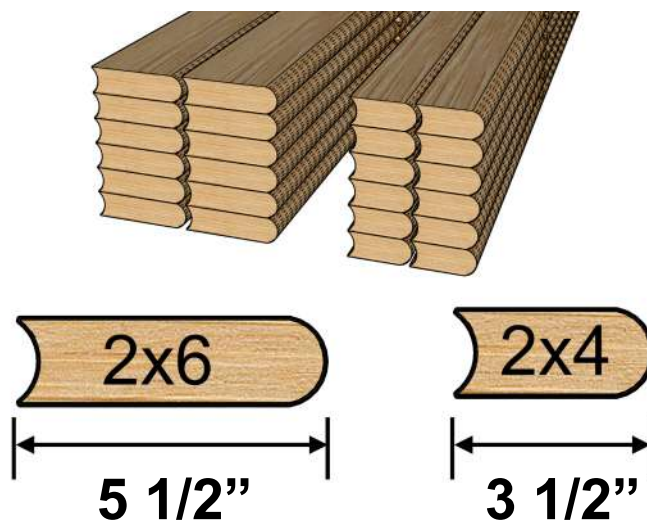


Repeat the process for the rear wall. Once both are centred in the grooves, use any wall stave to temporarily brace the walls to prevent them from falling. This will provide support while you build the side walls.



## Side Wall Assembly

36



Gather the remaining wall staves.  
The **2x6** wider staves are for flat areas of the wall and the **2x4** thinner staves are for the wall corners.

37



Install six of the thinner **2x4** corner staves along the corner bottom.  
Use a mallet to position and tighten each stave to the wall.



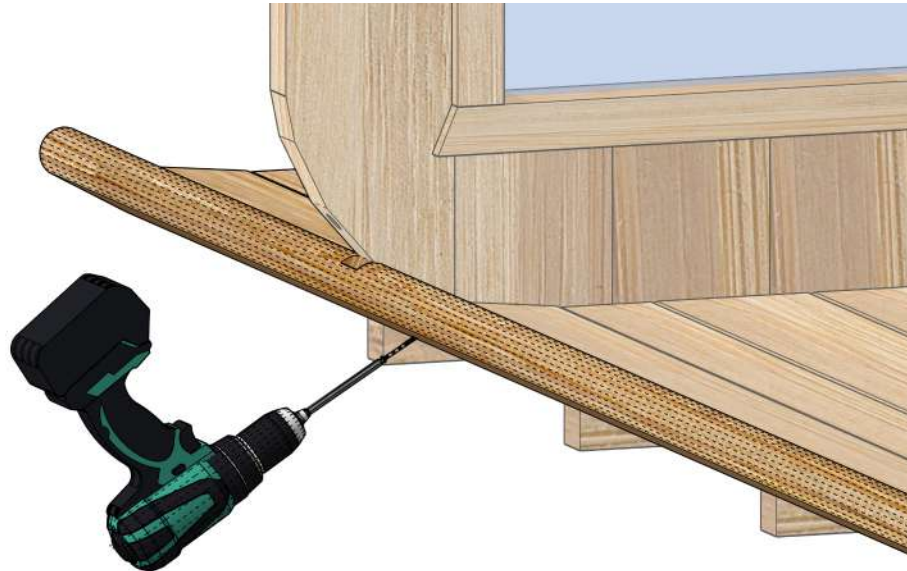
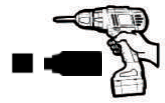
## Side Wall Assembly

38



**12X**

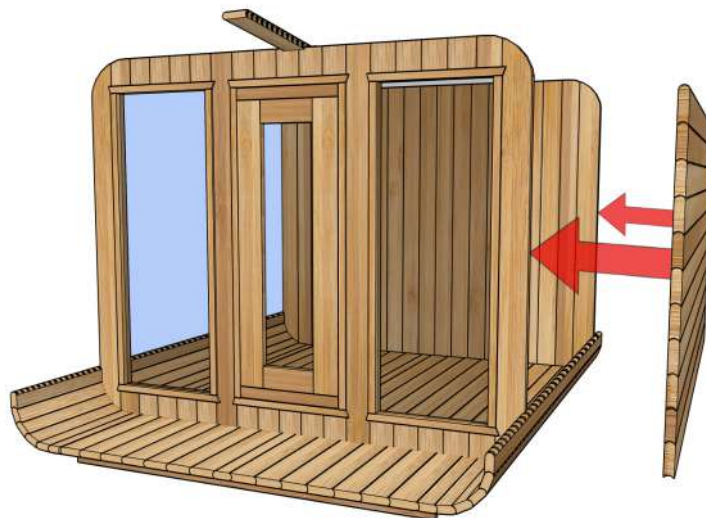
3.5" (89 mm) Robertson



Fasten the six corner staves with a screw connecting to the edge of both sauna walls.

**TIP:** A 90 degree screw gun or attachment may be useful.

39



Once the top corners are installed, start installing eleven of the **2x6** wider staves along the sides of the sauna.



Scan the code for a video of the assembly process:



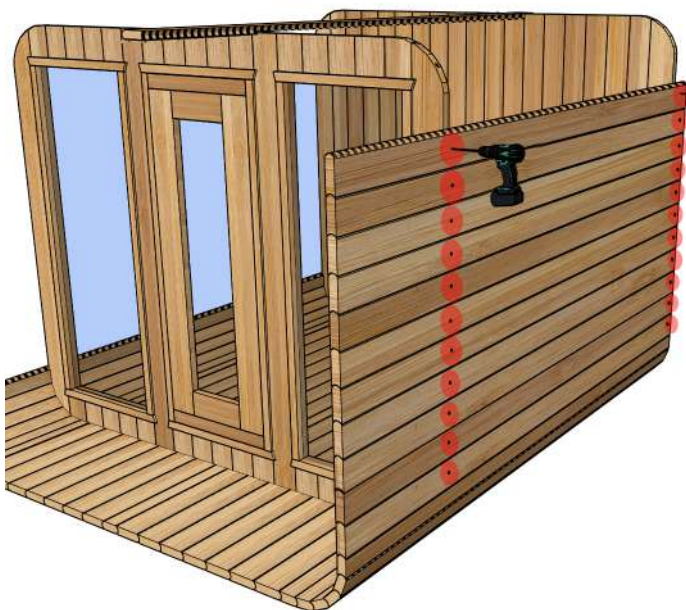
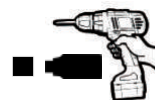
## Side Wall Assembly

40



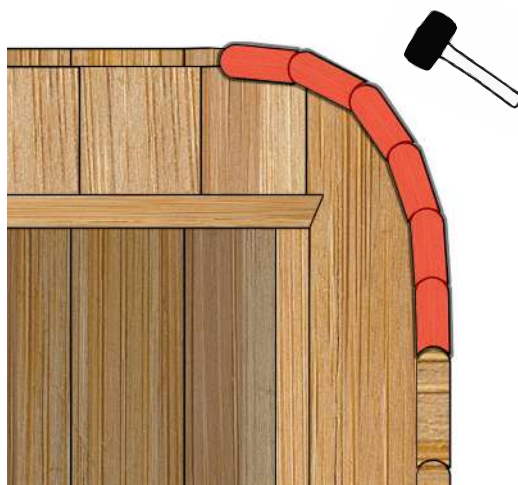
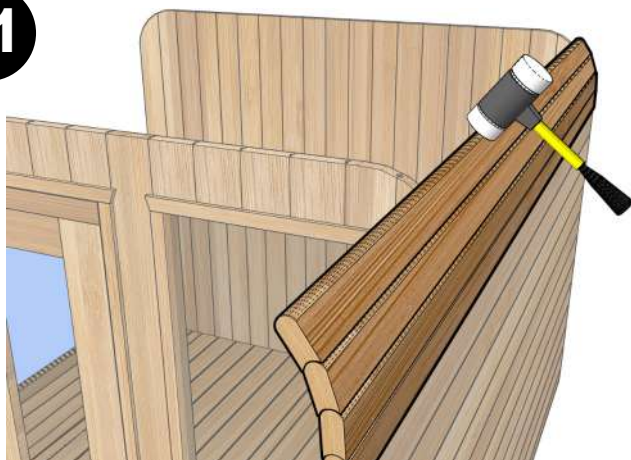
**22X**

2.5" (64mm) Robertson



Fasten the wide staves with a single screw connecting to the edge of both sauna walls.

41

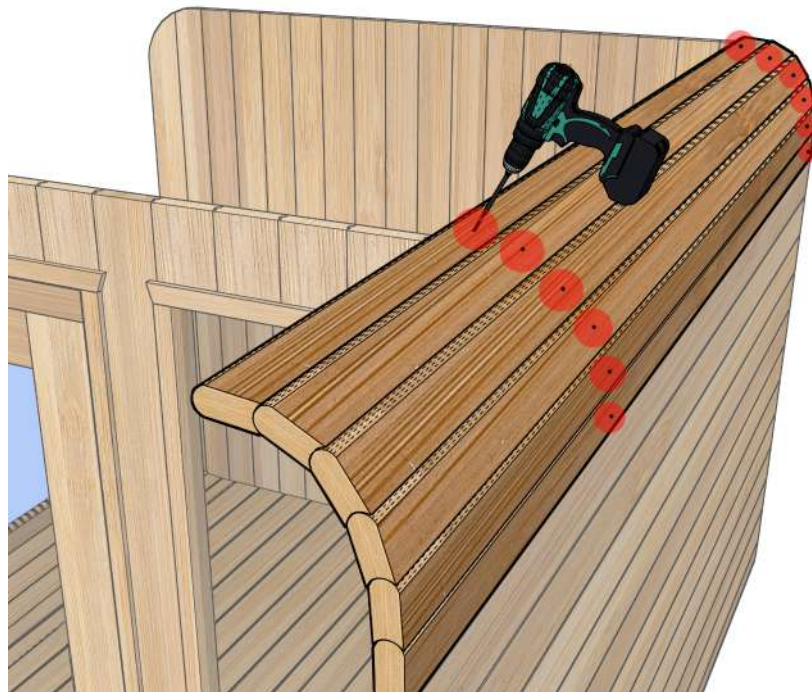
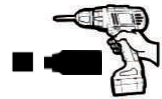


Install six of the **2x4** thinner corner staves along the corner top.  
Use a mallet to position and tighten each stave to the wall.



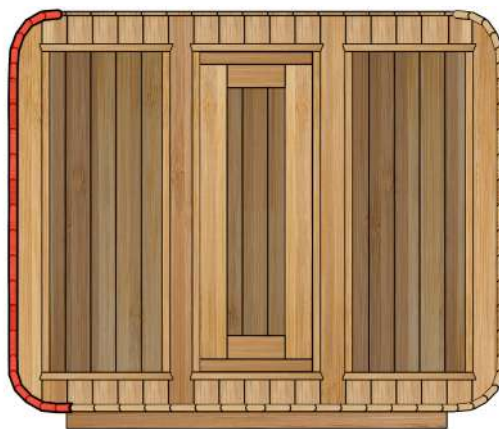
## Roof Assembly

**42**  **12X**  
3.5" (89 mm) Robertson



Fasten the six corner staves with a screw to the edge of both sauna walls.

**43**



Repeat **STEPS 37-42** to install staves for the other side of the sauna.



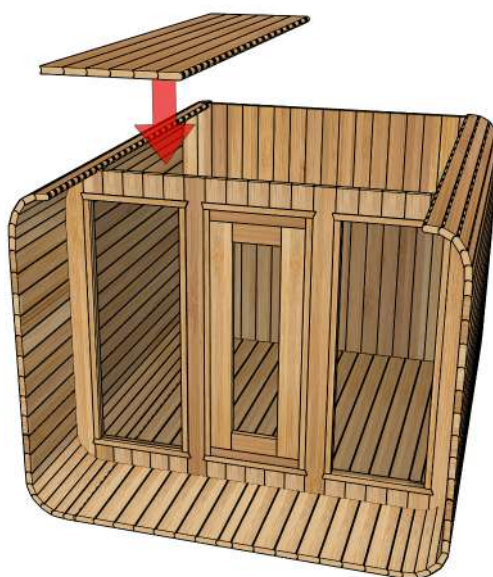
## Roof Assembly

44



Remove the temporary stave added in **STEP 35**. This stave will be used for the next step.

45



Install staves (**2x6**) on one side of the sauna working towards the middle of the roof.

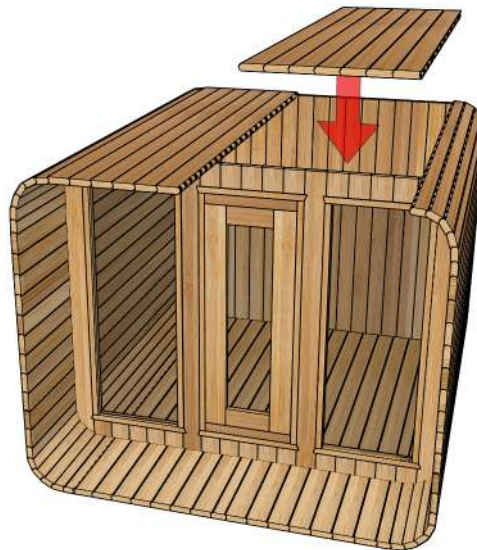
When you reach close the middle of the roof stop.

Use a mallet as necessary to create a tight fit between staves but do not fasten any roof staves yet.



## Roof Assembly

46

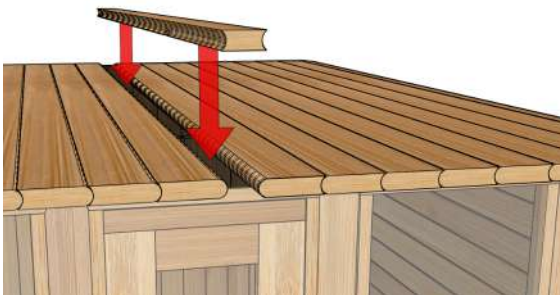


Continue installing staves (**2x6**) to the opposite side of the roof. When you reach close to the middle with a gap for one stave remaining, you may stop. Use a mallet as necessary to create a tight fit between staves but do not fasten any roof staves yet.

47



Center Stave Shape



For the remaining gap add the special center stave (see image above). Flatten the roof by finessing the center stave with a mallet.



## Roof Assembly

48

Gap Between Staves



Staves Too Tight To Flatten



Staves Are Snug And Flat



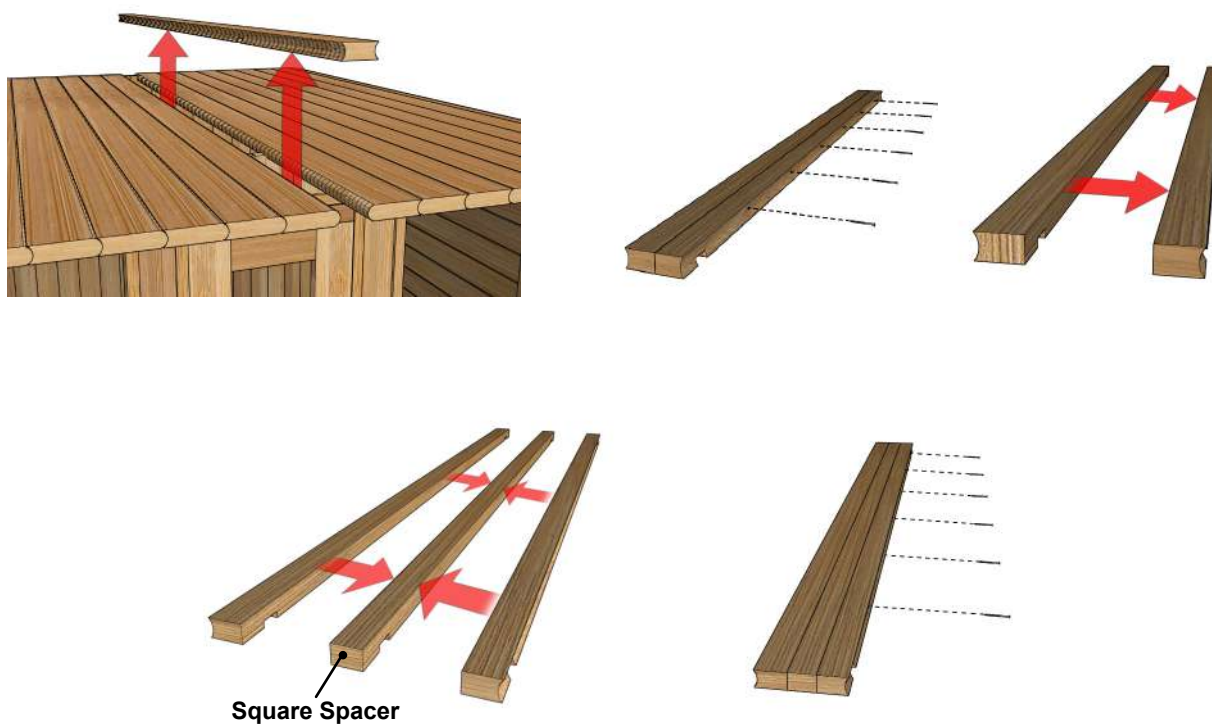
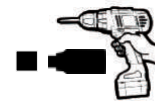
- If you experienced no problems with fitting the staves into the roofline then continue to **Step 52**.
- If the staves are too loose or there is a gap between the staves, you may need to add one of the spacer boards to the top stave. Continue to **Step 49A**.
- If your sauna staves are too tight to allow the staves to settle into a flat roofline you may need to make the top stave narrower. Continue to **Step 50B**.



## Staves Too Loose

49A

If the staves are too loose or there is a gap between the staves, you may need to add one of the spacer boards to the top stave.



Begin by removing the center stave from the top of the sauna. The center stave is actually two pieces held together by screws. Begin by removing the screws holding the top stave together. Separate the stave into two pieces.

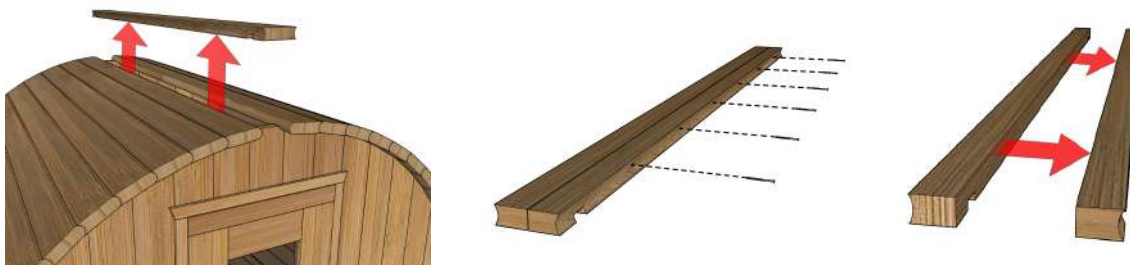
In your sauna package there is a square spacer the same length as the top spacer. Take this stave and position it between the two top stave pieces. Refasten all three pieces with the screws that held the top stave together. See image above for details. Continue to **STEP 51**.



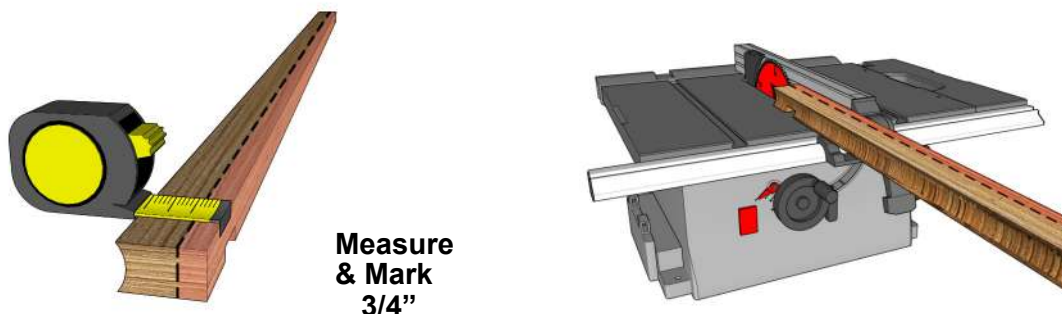
## Staves Too Tight

**50B**

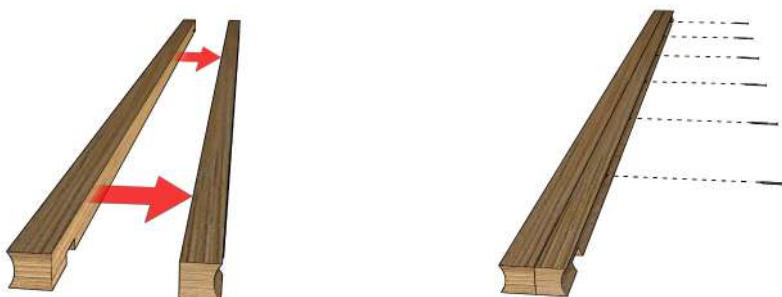
In rare instances, your sauna staves might be too tight to allow the staves to settle into the correct position and be aligned with one another. This doesn't happen often, and the sauna staves and bands are always better being as tight as possible.



Begin by removing the top stave from the top of the sauna. The top stave is actually two pieces held together by screws. Begin by removing the screws holding the top stave together. Separate the stave into two pieces.



Measure and mark **3/4 inches (19 mm)** on both stave pieces from the flat side of the stave. Using a circular or table saw safely cut off 3/4 inches off each stave piece to make them thinner. Reassemble both pieces with the cut edge of each piece facing the other.

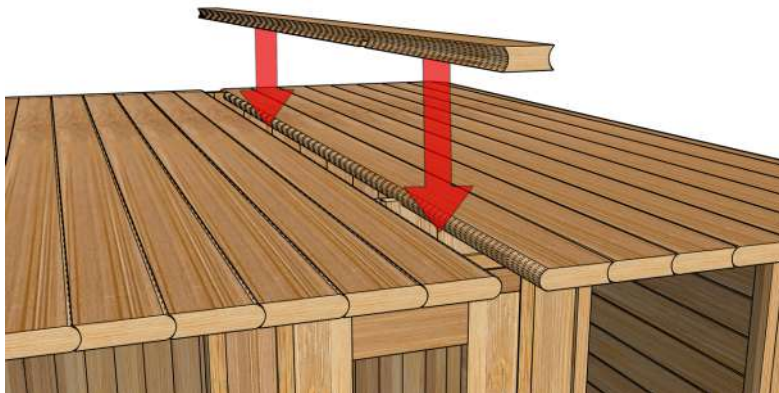


Refasten both stave pieces with the screws that held the top stave together. See image above for details. Continue to **STEP 51**.



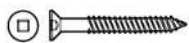
## Roof Assembly Continued

51



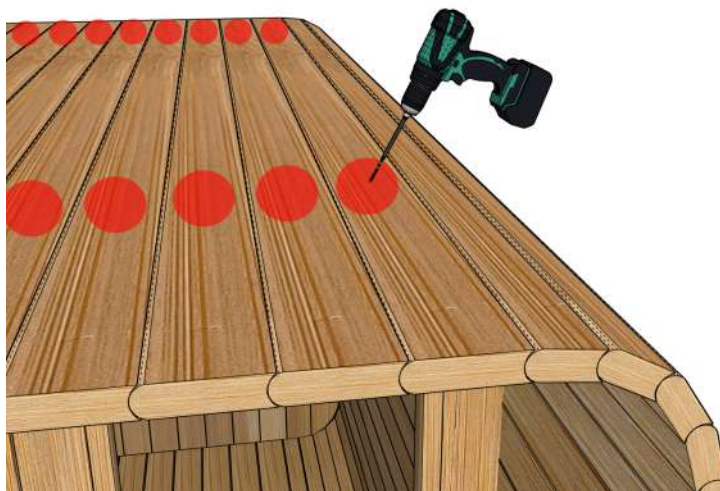
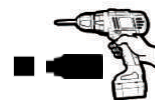
Refit the new center stave in the same position on the roof line.

52



**32X**

2.5" (64mm) Robertson



Secure all roof staves with screws into the front and back walls.

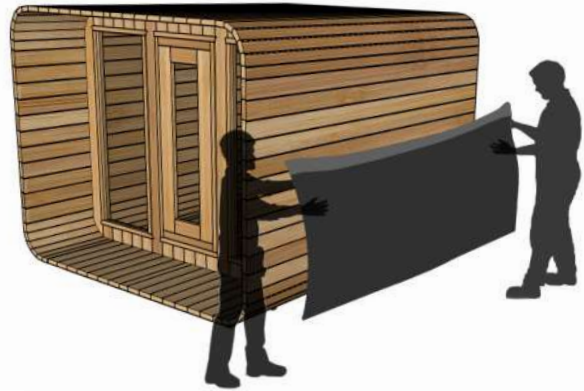


## Roof Membrane Installation

53



Recommended  
two person job



Take an ice and water shield and remove the plastic backing off the back of the shield. This will allow the adhesive to stick to the wood underneath.

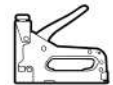
Apply the ice and water shield over the side of the sauna aligning the shield with the bottom of the first full size stave at the bottom.

54



1 1/4"

Staples



Staple the top of the ice and water shield. Wrap the shield around the sauna staves along the sides and staple around the edges.



Scan the code for a video of the assembly process:



## Roof Membrane Installation

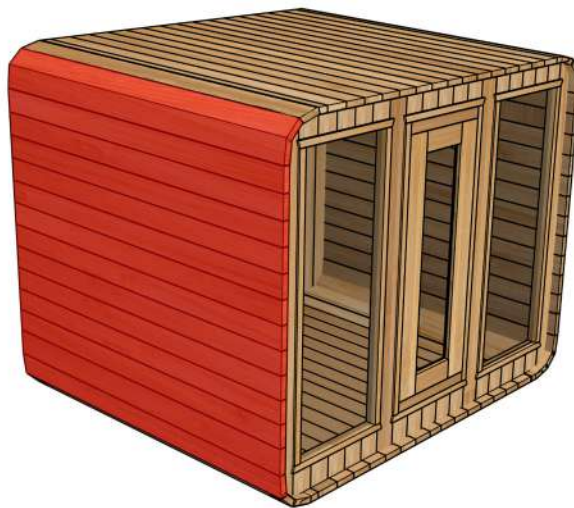
55



Apply a second sheet of ice and water shield. Ensure that it is placed on top and overlaps the bottom sheet by **4 inches (102 mm)**. (see image above).

Follow the steps from **STEP 54** to staple the ice and water shield.

56



Repeat **STEP 53-55** for the opposite side of the sauna.



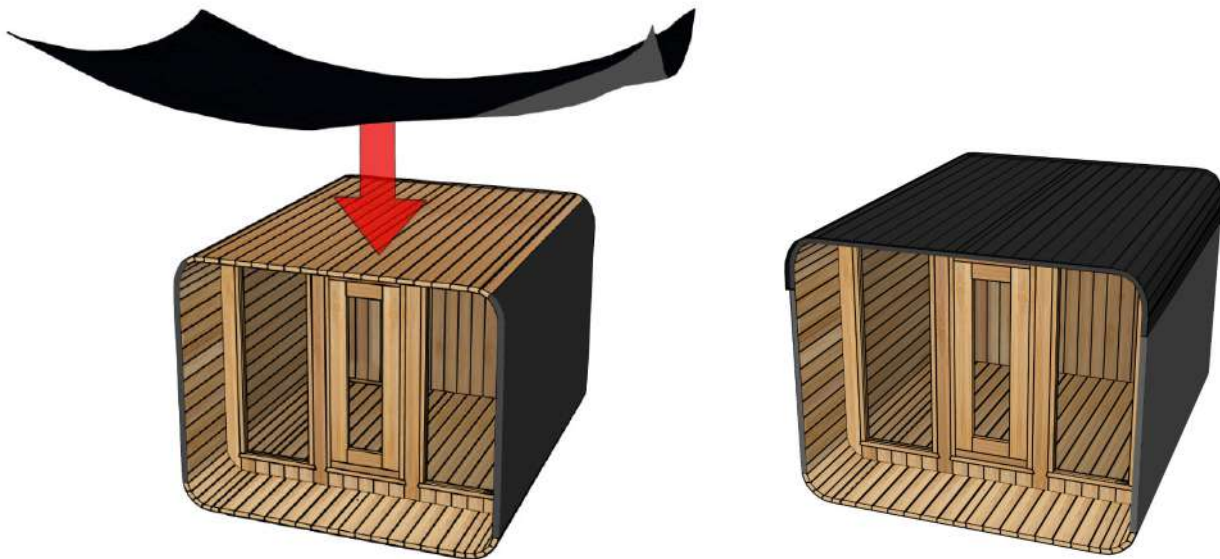
## Roof Membrane Installation

57



Use a utility knife to cut the excess sheeting off both the front and back of the sauna frame.

58



Place the roof membrane and drape it over the sauna. Ensure the membrane is centered side to side and front to back.



## Roof Membrane Installation

59

 **1 1/4"**  
(32 mm)  
Staples



Fold the ends of the sheeting over and staple the ends of the side wall board to the sheeting. Do this for both the front and back of the sauna.  
Do not staple the bottom horizontal edges of the membrane.

60



Using a utility knife to cut the excess sheeting off both the front and back of the sauna frame.

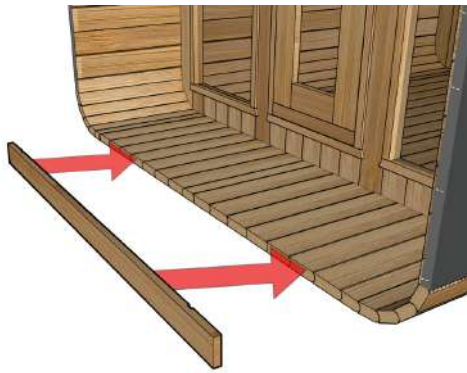


Scan the code for a video of the assembly process:



## Trim Installation

61



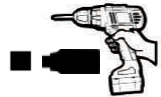
The bottom trim piece has grooves cut on either end to assist in the drainage of excess water. This side with the grooves will be placed towards the inside of the sauna.



To install the sauna trim, start with the longest piece on the front bottom. Center this piece so the same distance is left on either side.

62

  **4X**  
2" (51mm) Robertson



Secure the bottom trim board with screws.



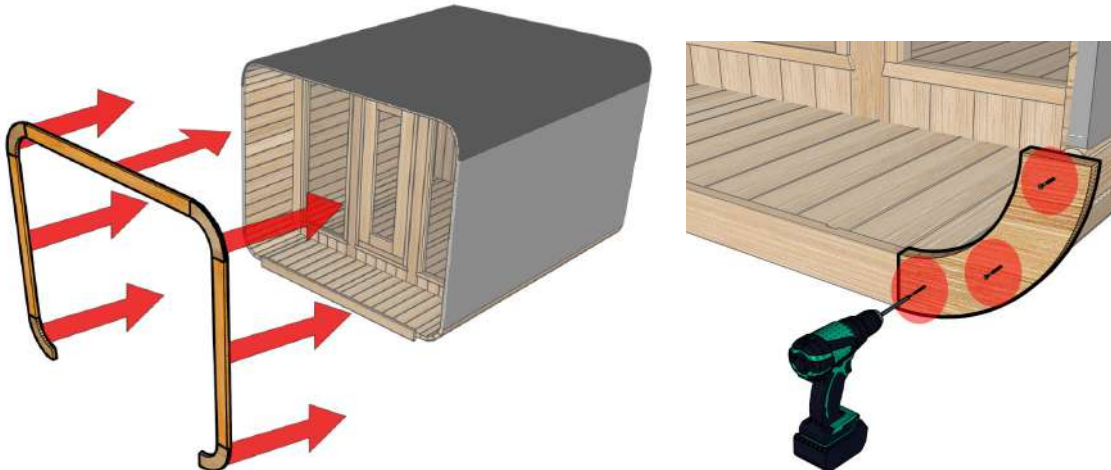
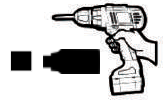
Scan the code for a video of the assembly process:



## Trim Installation

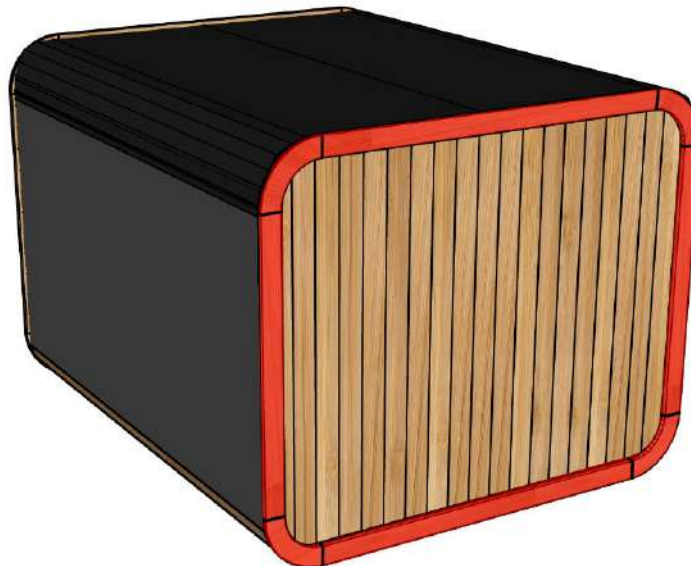
63

 **24X**  
2" (51mm) Robertson



Continue placing and fasten the other trim pieces for the front of the sauna.  
Use three screws for the corner trim and 4 screws in the side and top pieces spaced evenly.

64



Repeat **STEP 62-63** for the trim on the rear of the sauna.

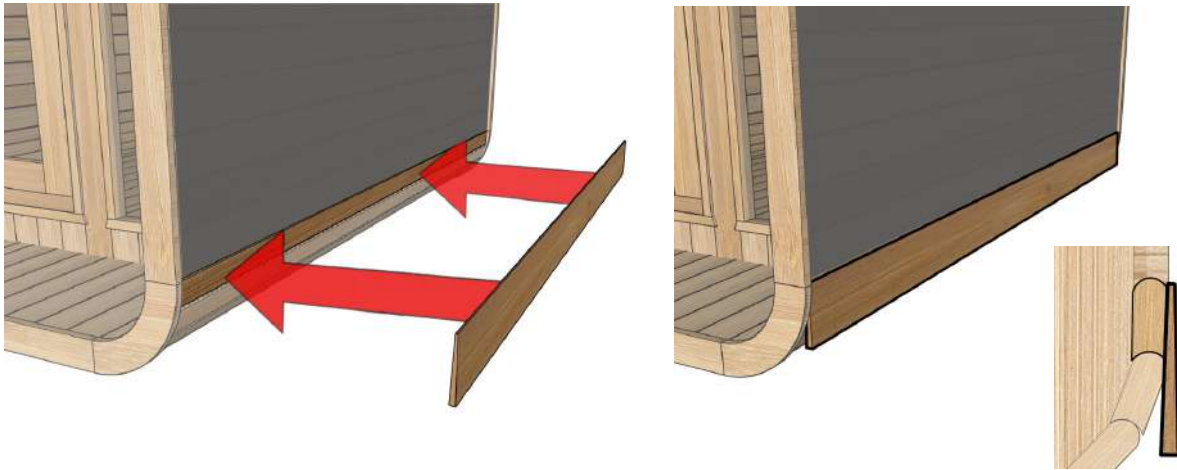


Scan the code for a video of the assembly process:



## Shingle Installation

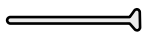
65



Begin placing the siding boards. Start at the bottom with the top of the siding flush with the bottom wall stave.

66

Finish Nails

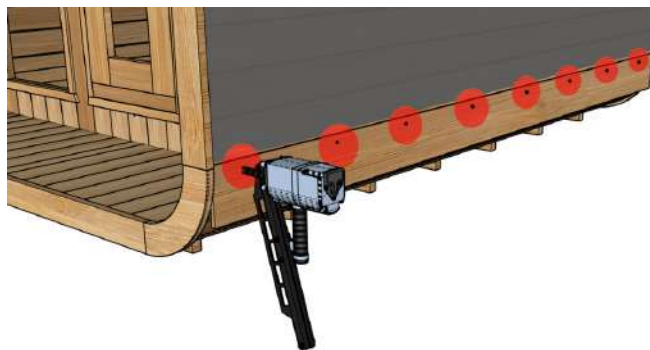


or

1 1/4"  
(32 mm)



or



Secure with finish nails or staples across the top.

**PLEASE NOTE:** Do not go longer than 1 1/4" for staples or nails.



## Shingle Installation

67

Finish Nails

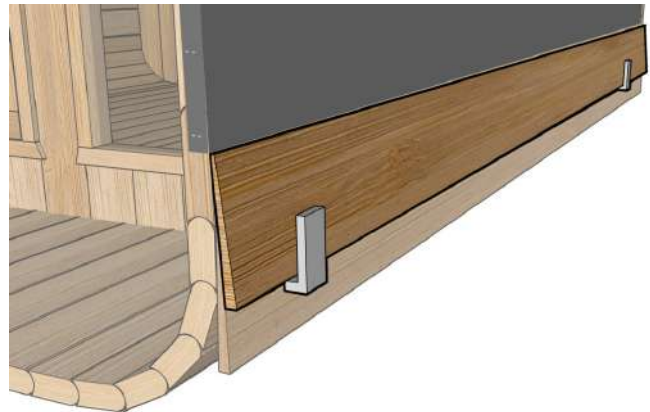
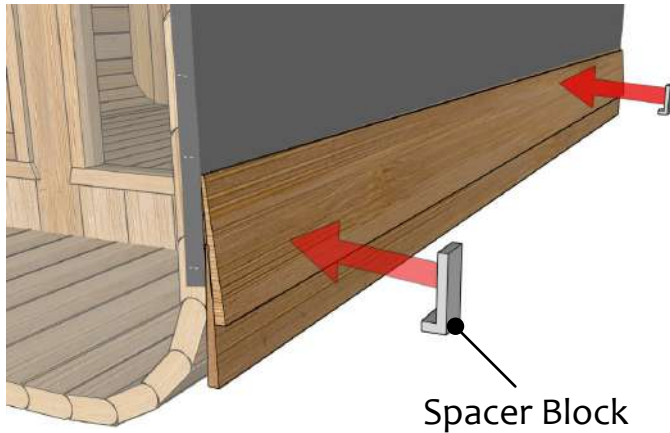
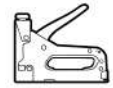


or

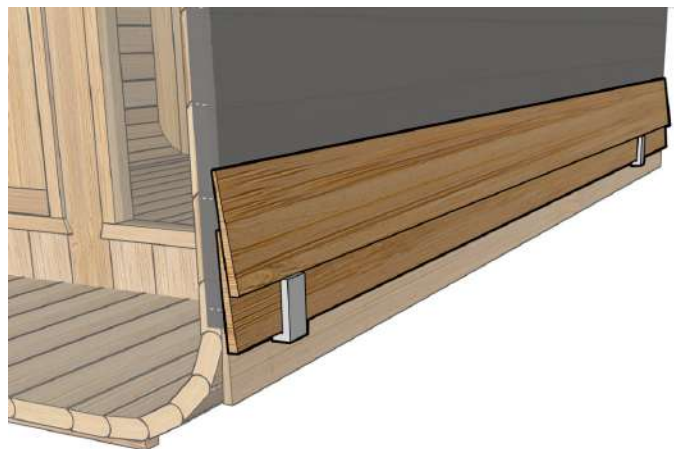
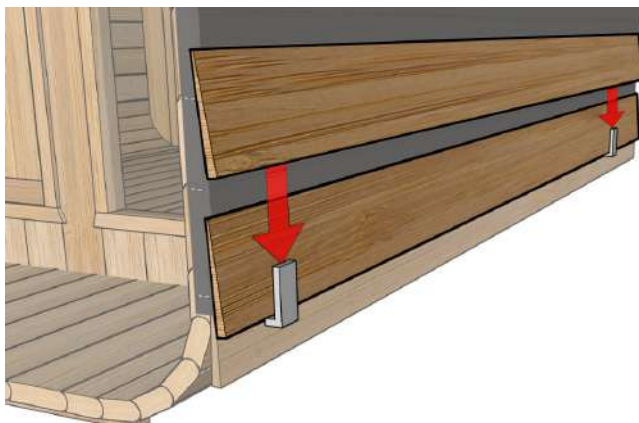
1 1/4"  
(32 mm)



or



Use the provided spacer blocks to gauge the correct distance for spacing between each board.  
Position the spacer block underneath the last installed shingle.  
Do this for both sides of the board.



Slide the next shingle on top of the spacer block for ends. This will determine where the shingle will be fastened.

**PLEASE NOTE:** The trim has been taken off the above images to better illustrate shingle installation.



## Shingle Installation

68

Finish Nails

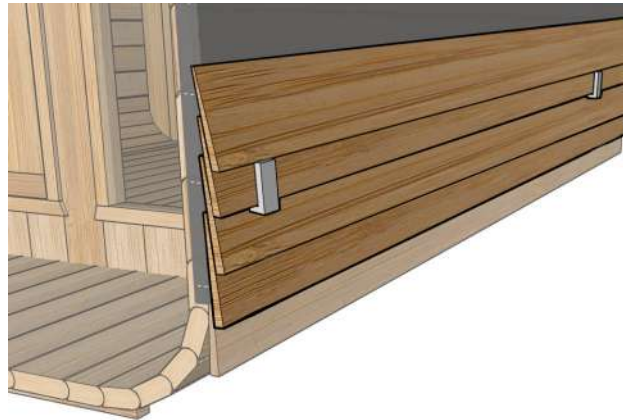
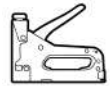


or

1 1/4"



or



Continue using the space block adding/fastening shingles.  
Secure with finish nails or staples across the top.

69



When you reach bottom of the roof membrane secure a shingle underneath the liner  
and use the spacers to position the shingle.  
This will help protect from water getting between the siding and wall staves.



Scan the code for a video of the assembly process:



## Shingle Installation

70

Finish Nails

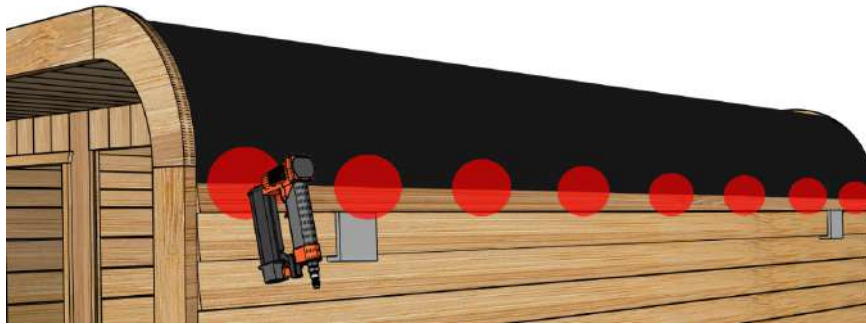
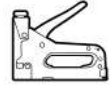


or

1 1/4"  
(32 mm)

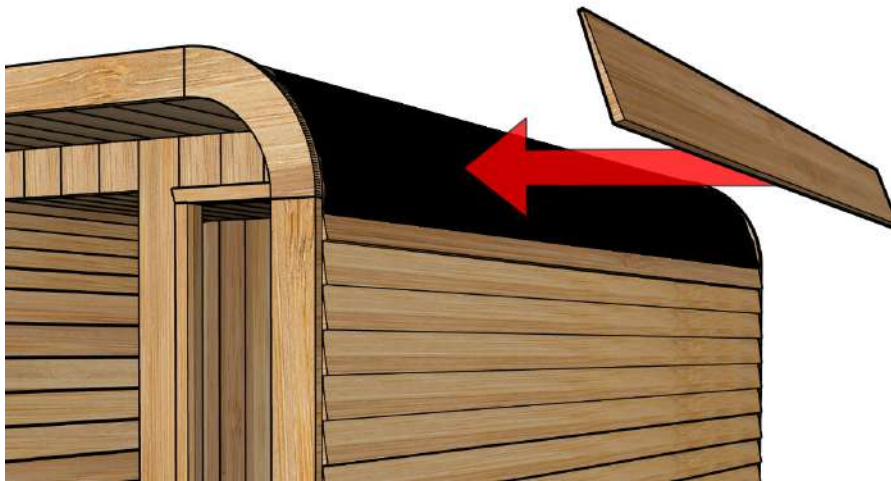


or



Fasten the shingle.

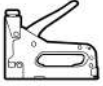
71

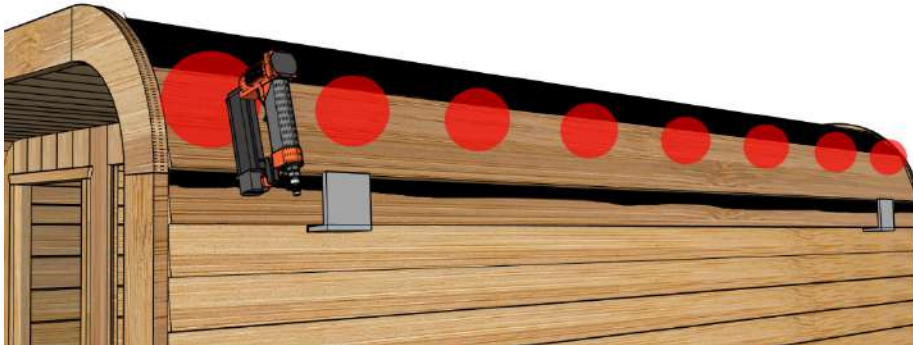


Place the next shingle over the membrane .



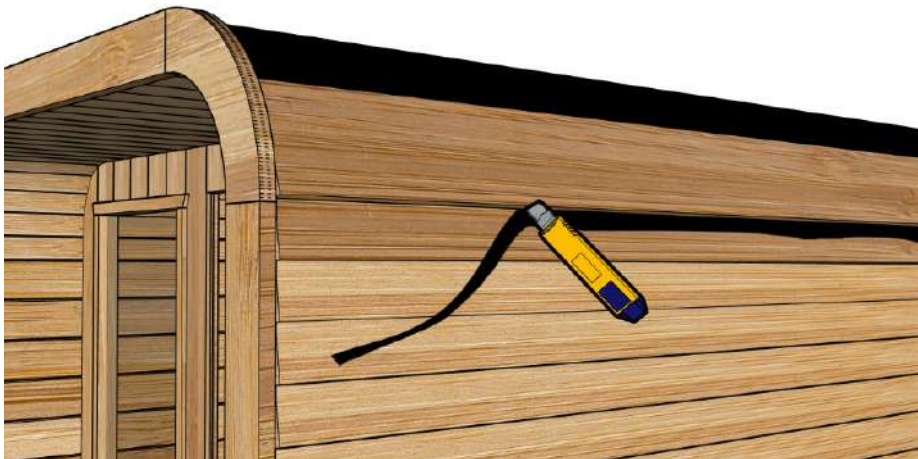
## Shingle Installation

**72** Finish Nails  or 1 1/4"  (32 mm)  or 



Fasten the shingle.

**73** 



Cut off any excess material from the membrane along the shingle.



## Shingle Installation

74



Continue installing the shingles until you reach the top of the sauna following **STEPS 65-68**.



## Door Handle Installation

75



Place the outer door handle at desired height.

76

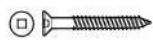


Ensure it is centred and secure with screws.



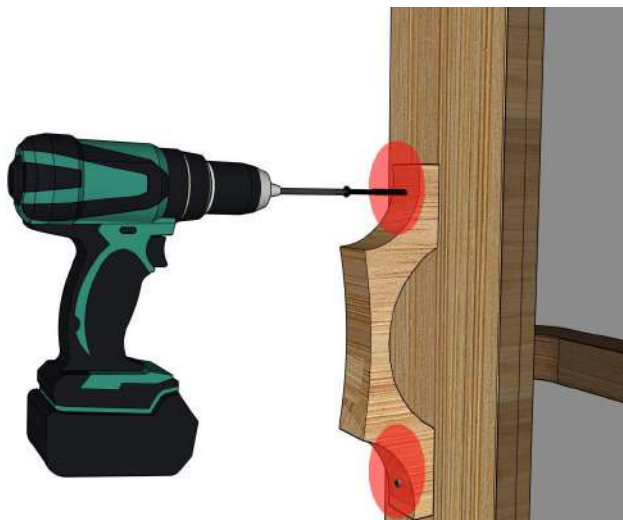
## Door Handle Installation

77



**2X**

2 1/2" (64 mm) Robertson



Fasten with 2 screws in the pre-drilled holes .

78



Place the inner door handle at desired height.



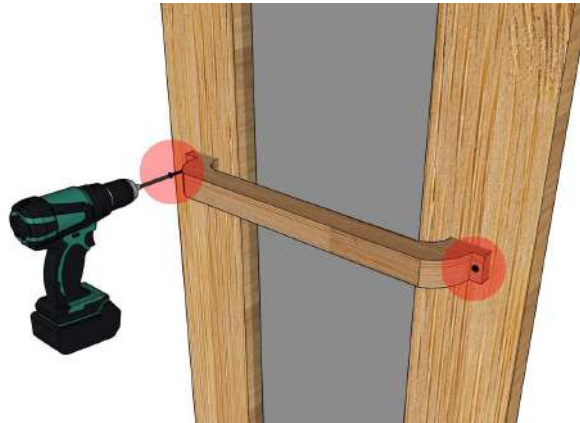
Scan the code for a video of the assembly process:



## Bench Installation

79

 **2X**  
2 1/2" (64 mm) Robertson



Fasten with 2 screws. Ensure handle is installed level and secure.

**PLEASE NOTE:** The following instructions demonstrate the installation of a typical bench setup. Your setup may differ slightly depending on the options you may have for your bench placement and may require a different setup.

80



Space the bench brackets out at the back of the sauna (Approximately 2 feet apart).

Do not fasten yet.

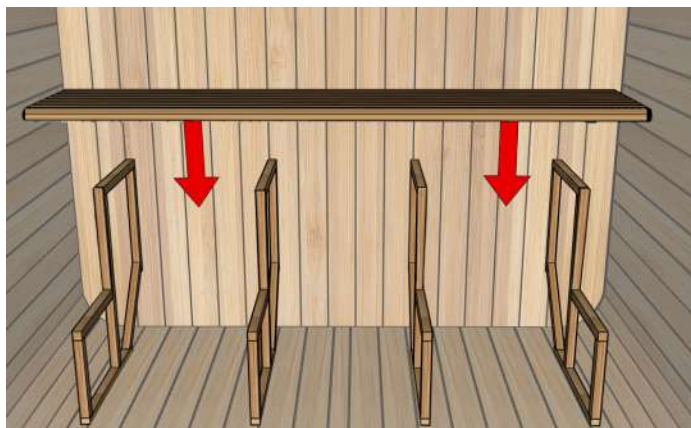


Scan the code for a video of the assembly process:



## Bench Installation

81



Place the bench top on the bench supports.

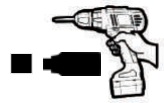
Line the bench brackets up with the seat support bracket on the bottom of bench.



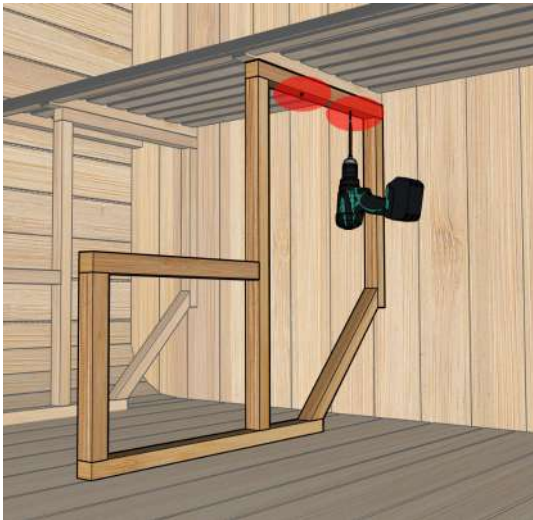
## Bench Installation

82

 **12X**  
2 1/2" (64 mm) Robertson



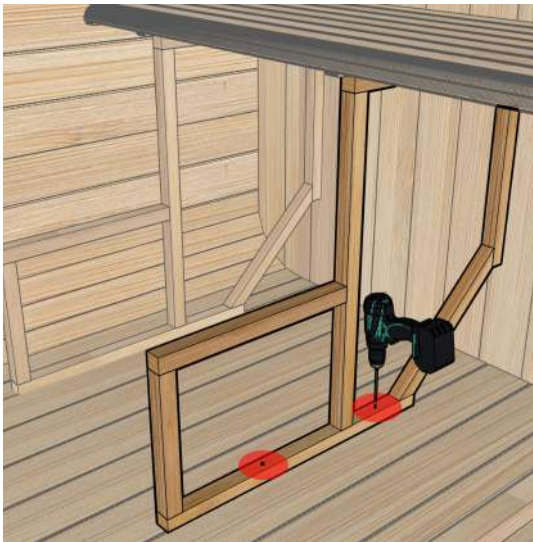
**A**



**B**



**C**

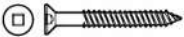


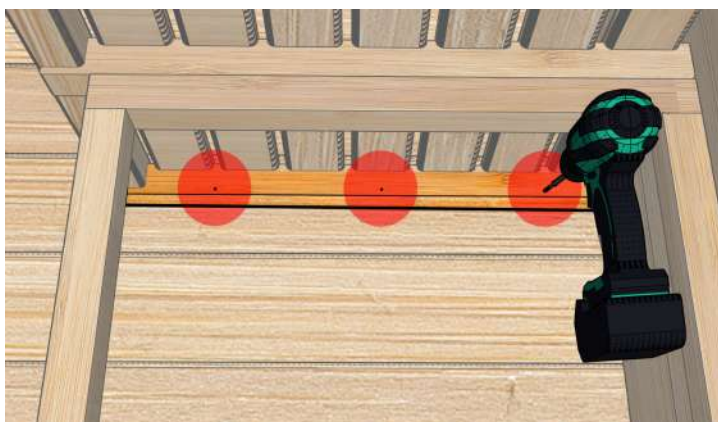
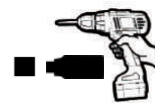
Fasten each of the four supports to the bench, rear wall and floor.



## Bench Installation

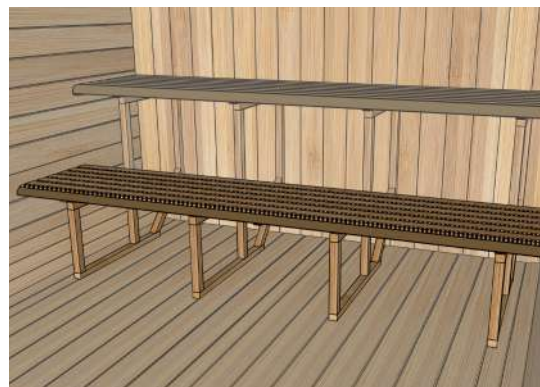
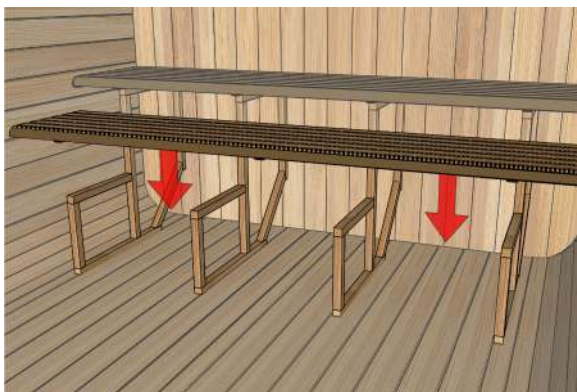
**83**

 **6X**  
2 1/2" (64 mm) Robertson



Fasten the end supports of the bench top to the side walls of the sauna.

**84**



Follow **STEP 81-83** for the lower bench fastening the bottom and sides of the bench top .

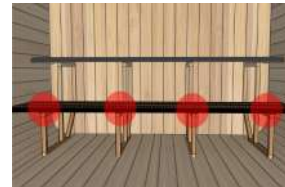


Scan the code for a video of the assembly process:



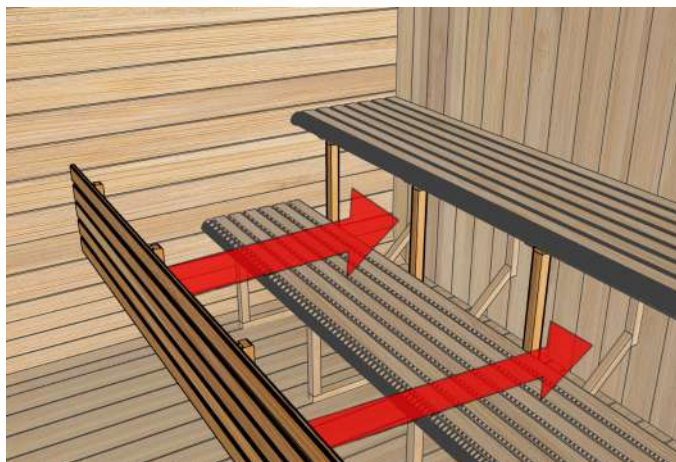
## Bench Installation

85



Fasten the end supports of the bench top to the side walls of the sauna.

86



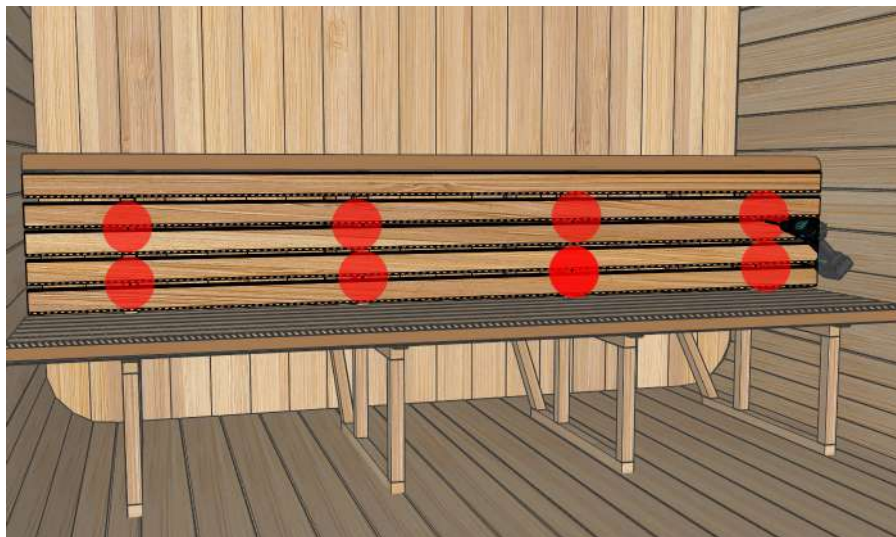
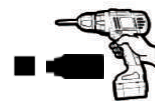
Position the front enclosure on the bench.



## Bench Installation

87

 **6X**  
2 1/2" (64 mm) Robertson



Fasten the front enclosure. Screw between the slats into the bench brackets.

88



Follow **STEPS 86-87** for installing the bottom enclosure.

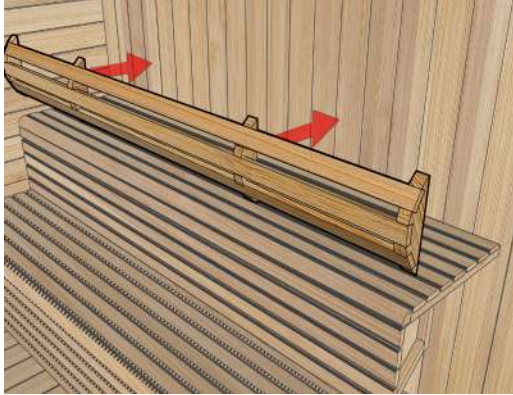


Scan the code for a video of the assembly process:



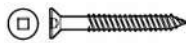
## Bench Installation

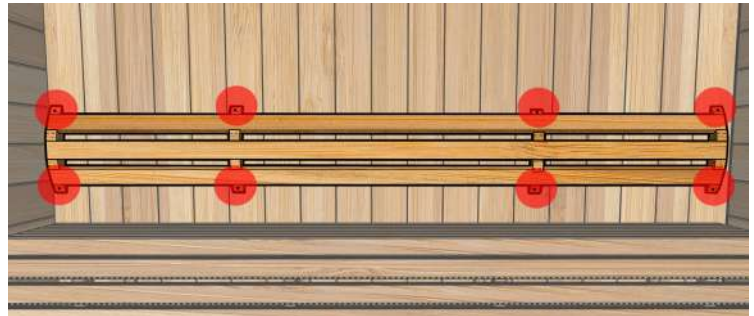
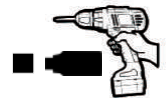
89



Position the back support at your desired height. Ensure it is level.

90

 **8X**  
2 1/2" (64 mm) Robertson



Fasten the back support. Add a screw to each of the pre-drilled holes areas shown.

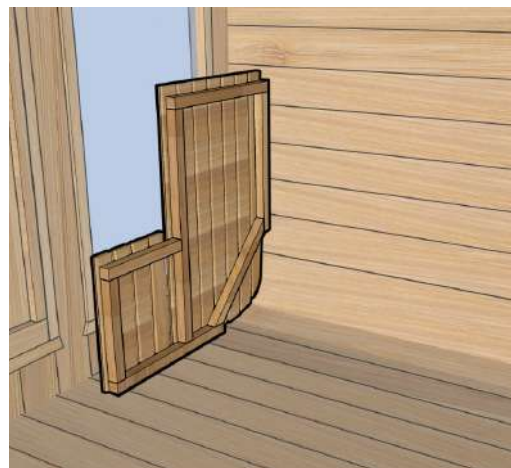
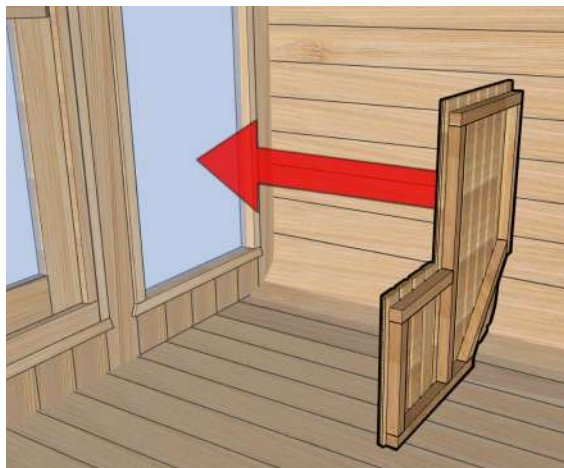


# L Bench Installation



Follow **STEPS 91-98** if you are installing an “L” bench assembly

**91**



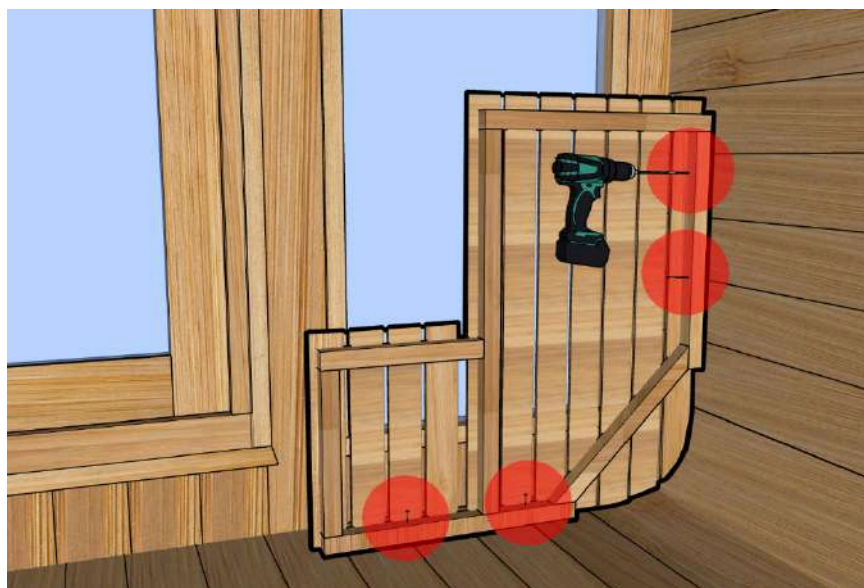
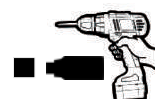
Position the enclosed side bench support against the front wall and side wall (see image above).

**92**



**4X**

2 1/2" (64 mm) Robertson



Fasten the enclosed side bench support with screws.

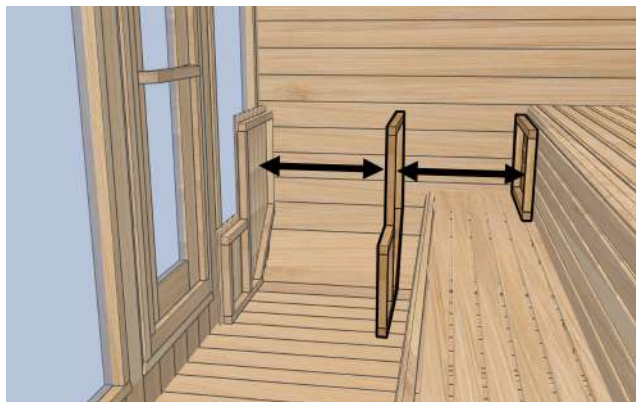


Scan the code for a video of the assembly process:



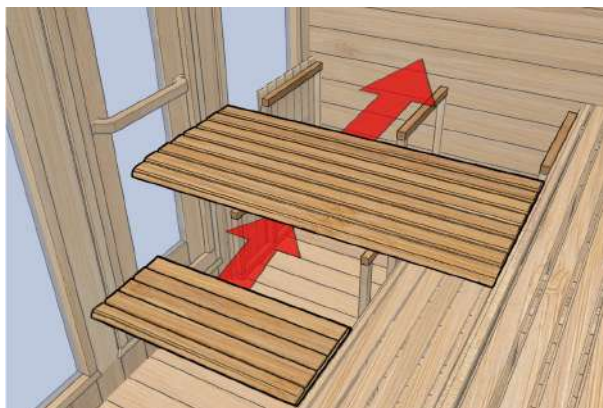
## L Bench Installation

93



Lay out the remaining support bracket and small end support like shown.

94



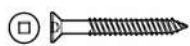
Place the the bench tops on to the bench supports.

Line the bench supports up with the seat support bracket on the bottom of bench.



## L Bench Installation

95



**8X**

2 1/2" (64 mm) Robertson



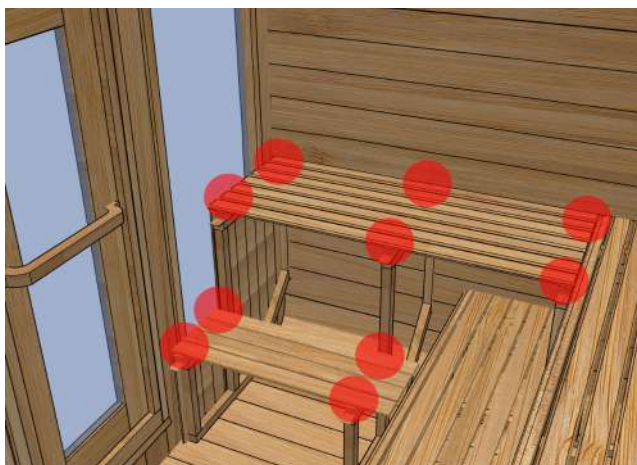
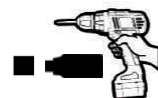
Once bench brackets are lined up with the supports, fasten the bench bracket and small end support to the back wall and floor with screws.

96



**10X**

2 1/2" (64 mm) Robertson



Fasten the bench bracket to the bottom of the bench top.

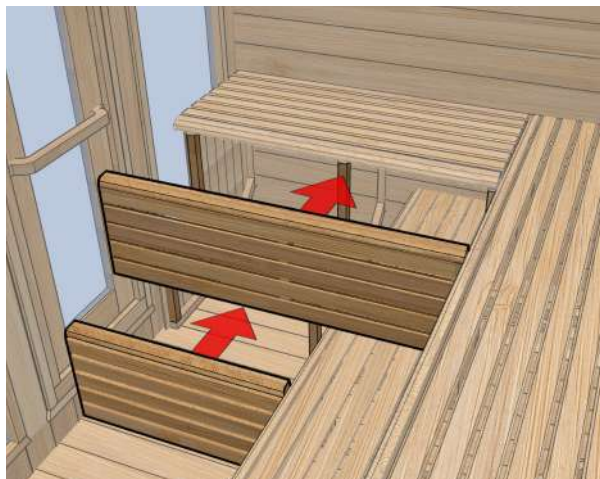


Scan the code for a video of the assembly process:



## L Bench Installation

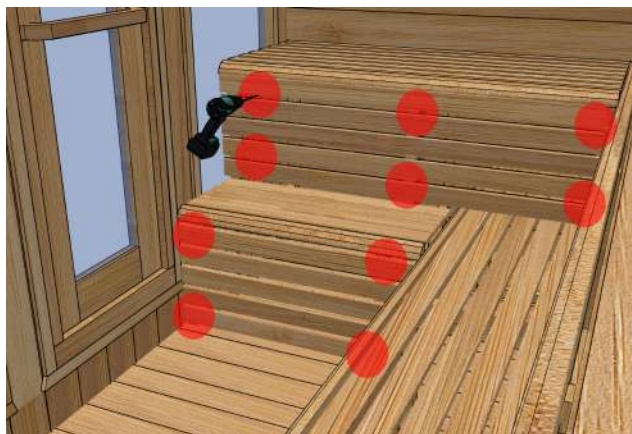
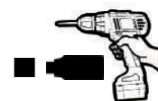
97



Position the front bench enclosures.

98

 **10X**  
2 1/2" (64 mm) Robertson



Secure the front bench enclosures. Fasten with a screw between the slats for a cleaner look.

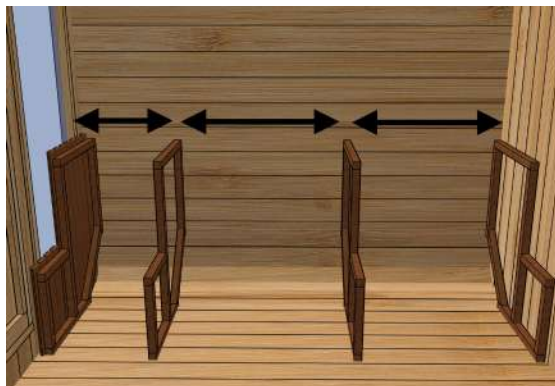


## Side Bench Installation



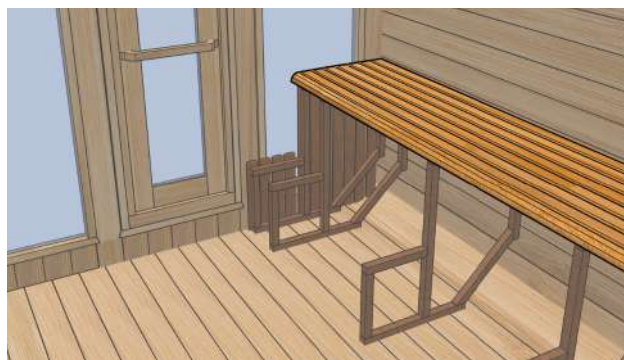
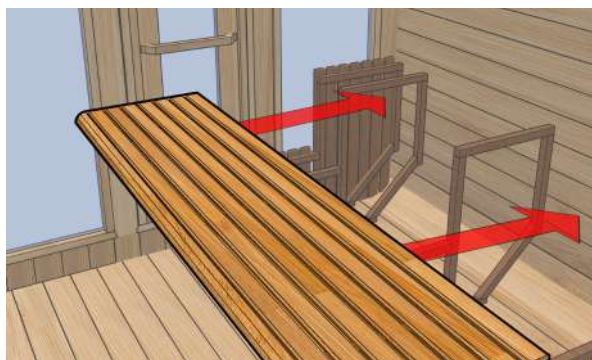
Follow **STEPS 99-108** if you are installing a side bench assembly

99



Place the enclosed side bench support against the front wall and space the other bench supports along the side wall.

100



Seat Support Bracket

Bench Bracket

Place the bench top on the bench supports. Align the bench bracket with the seat support bracket on the bottom of bench.



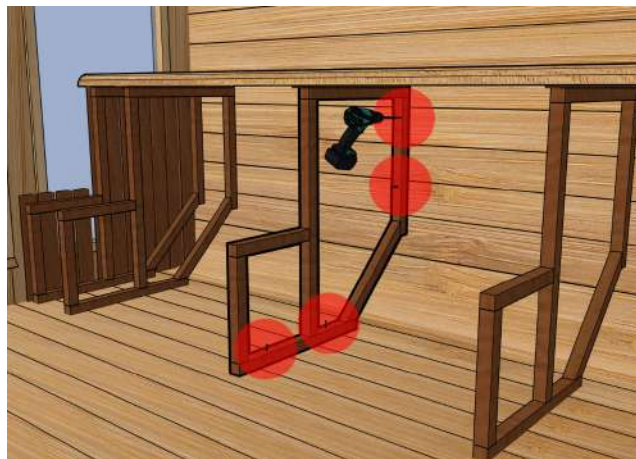
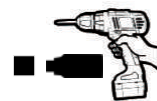
Scan the code for a video of the assembly process:



## Side Bench Installation

**101**

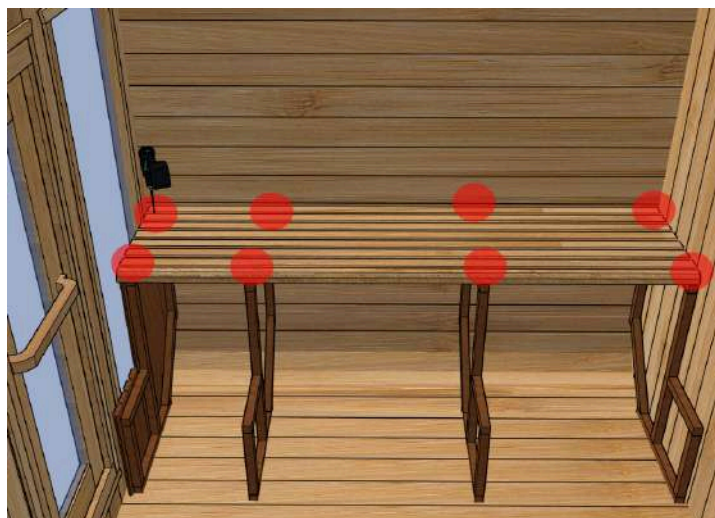
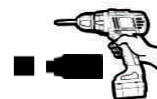
 **16X**  
2 1/2" (64 mm) Robertson



After the bench brackets are lined up with the seat supports fasten with screws.  
Do this for all four bench brackets including the enclosed bench bracket.

**102**

 **8X**  
2 1/2" (64 mm) Robertson

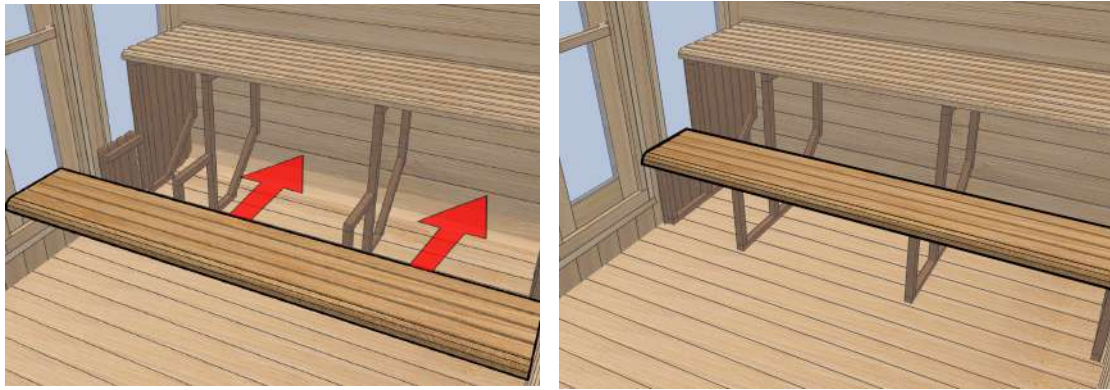


Fasten the bench bracket to the bottom of the bench top.



## Side Bench Installation

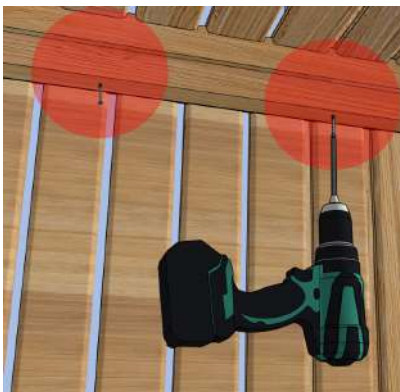
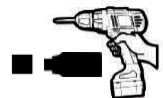
103



Place the bench top on the bench supports. Align the bench bracket with the seat support bracket on the bottom of bench.

104

 **8X**  
2 1/2" (64 mm) Robertson

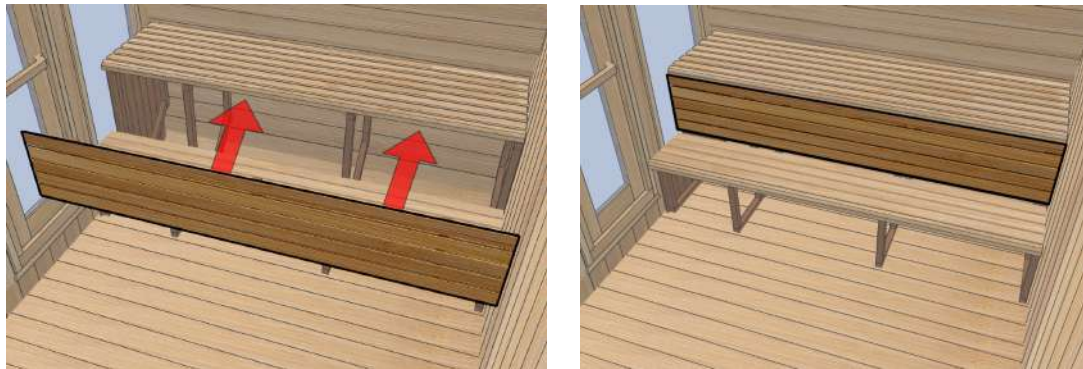


Fasten the bench bracket to the bottom of the bench top.



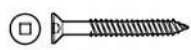
## Side Bench Installation

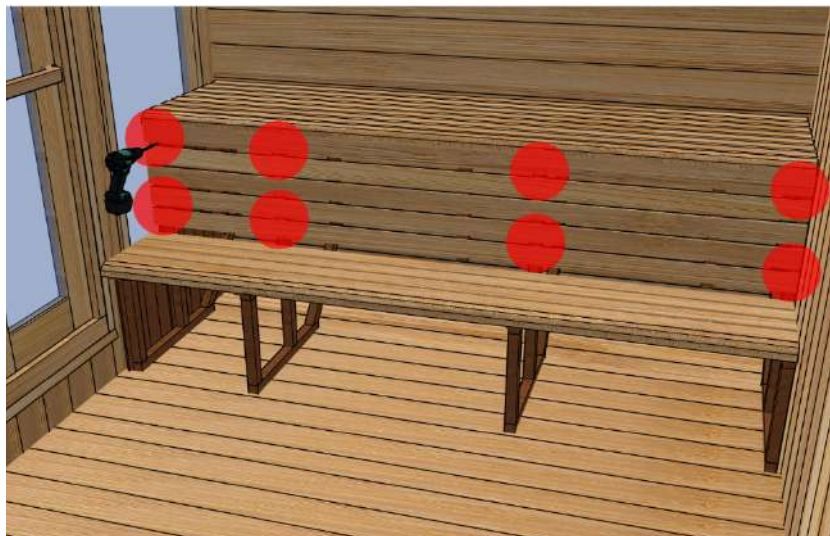
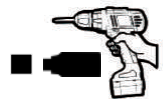
105



Position the front bench enclosures.

106

 **8X**  
2 1/2" (64 mm) Robertson



Secure the front bench enclosures. Fasten with a screw between the slats for a cleaner look.



## Side Bench Installation

107



Follow **STEPS 105-106** for the front bench enclosure for the bottom of the bench.

108

Follow **STEPS 89-90** for the back rest to be placed on the side wall.



Follow **STEPS 109-116** if you are installing an lounge bench assembly



**PLEASE NOTE:** If a lounge bench and two-tier bench are chosen for your sauna options, follow the instructions for sidewall bench assembly in the previous section.

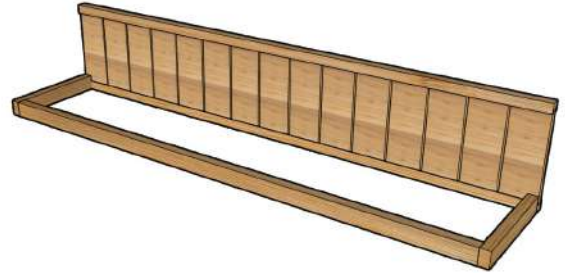
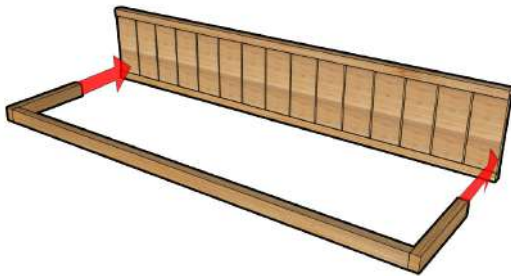


Scan the code for a video of the assembly process:



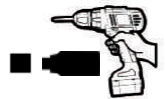
## Lounge Bench Installation

109



110

  **2X**  
2 1/2" (64 mm) Robertson



111



Position the frame against the wall.

Scan the code for a video of the assembly process:



## Lounge Bench Installation

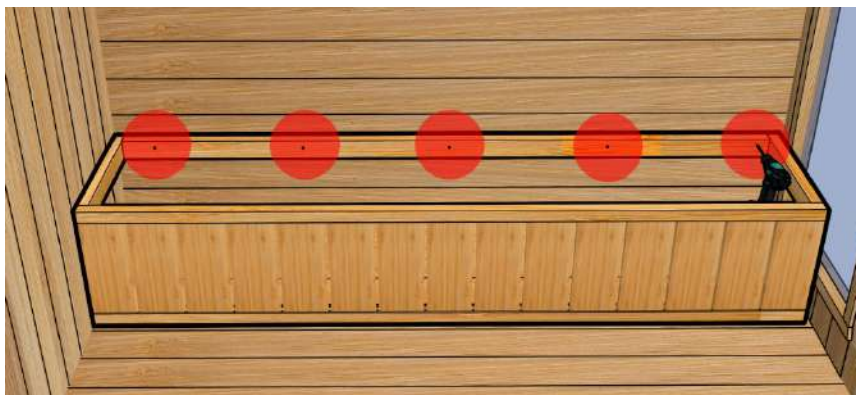
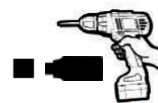
112



Ensure the frame is level before fastening.

113

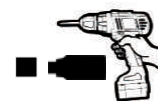
 **5X**  
2 1/2" (64 mm) Robertson



Fasten the frame to the sauna with screws.

114

 **5X**  
2 1/2" (64 mm) Robertson



Fasten the bottom frame to the sauna with screws.



## Lounge Bench Installation

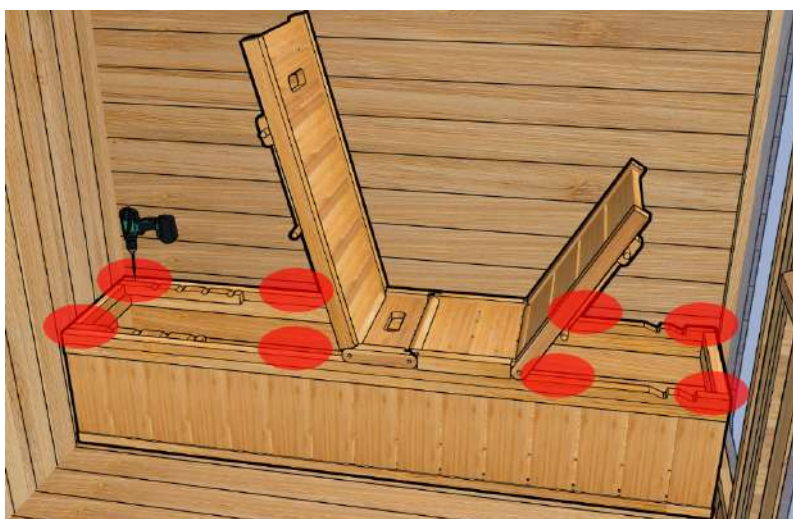
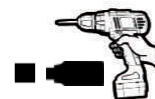
115



Place the assembled lounge bench onto the frame.

116

  **5X**  
2 1/2" (64 mm) Robertson



Lift up each end of the lounger and fasten the assembled lounge bench to the frame with screws.



# Exterior Bench Installation



The exterior bench instructions are for Luna models with porches only.

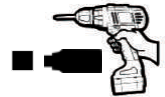
**117**



Identify the top and bottom sections for both porch benches.

**118**

 **2X**  
2 1/2" (64 mm) Robertson



Secure the two bench pieces together with a screw in each of the pre-drilled holes (See image above).  
Ensure the finished bench is flush when finished.



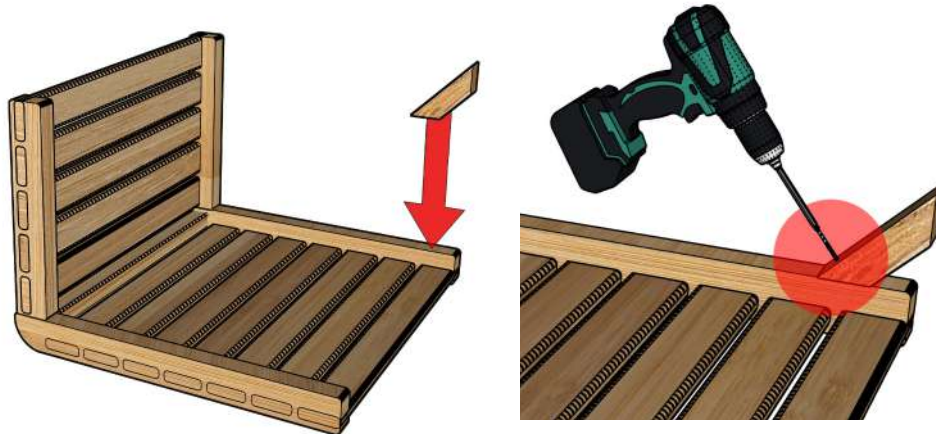
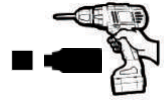
Scan the code for a video of the assembly process:



## Exterior Bench Installation

**119**

 **1X**  
2 1/2" (64 mm) Robertson



Place and fasten a gusset on the end of the seating area for the bench.



**TIP:** It may be helpful to use a square to ensure the gusset is placed flush with the end of the bench.

**120**

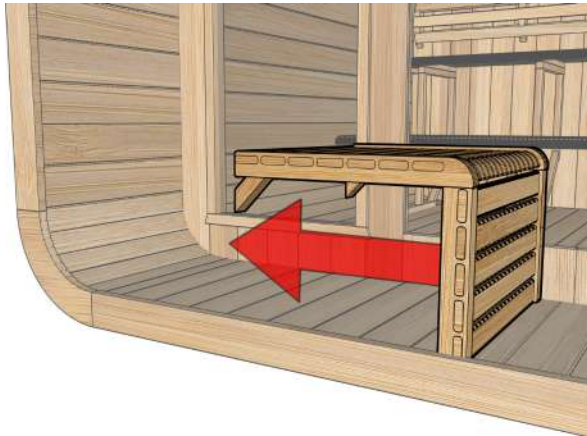


Repeat **STEP 119** for installing the second gusset on the opposite side of the bench.



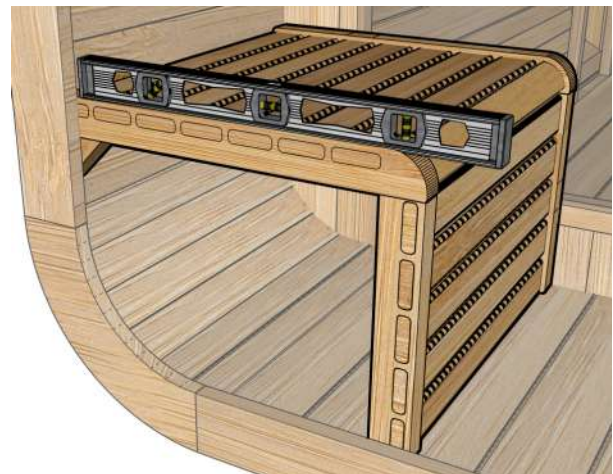
## Exterior Bench Installation

121



Fit the bench between the front window and the trim.

122



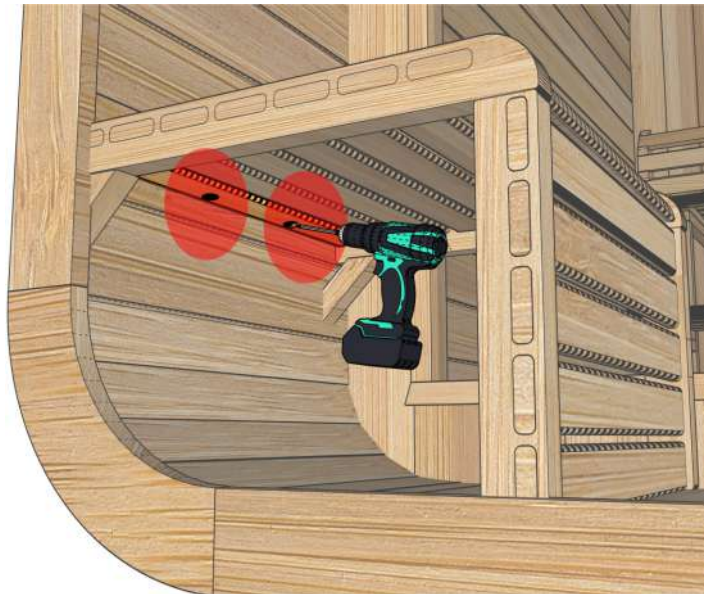
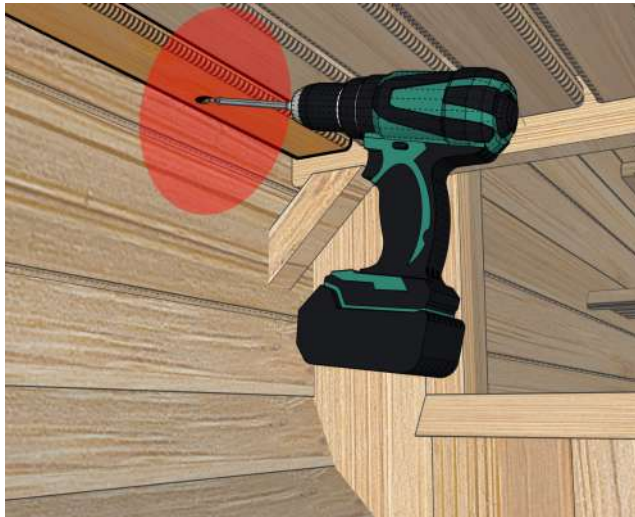
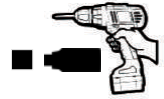
Ensure the bench is level before fastening the bench.



## Exterior Bench Installation

**123**

 **2X**  
2 1/2" (64 mm) Robertson



Fasten the bench to the wall with two screws in the pre-drilled holes underneath the bench.



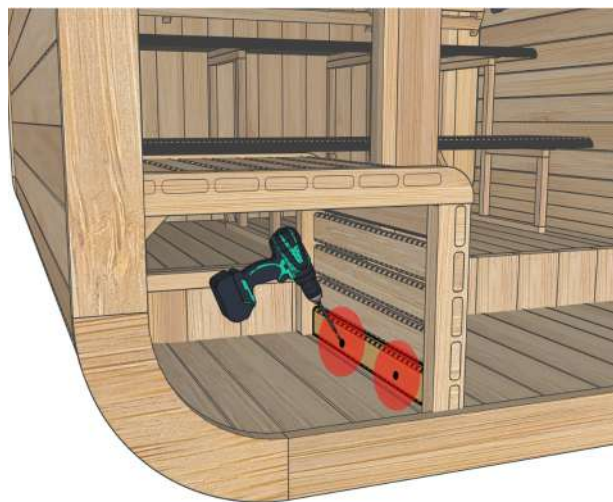
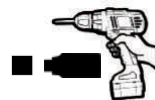
Scan the code for a video of the assembly process:



## Exterior Bench Installation

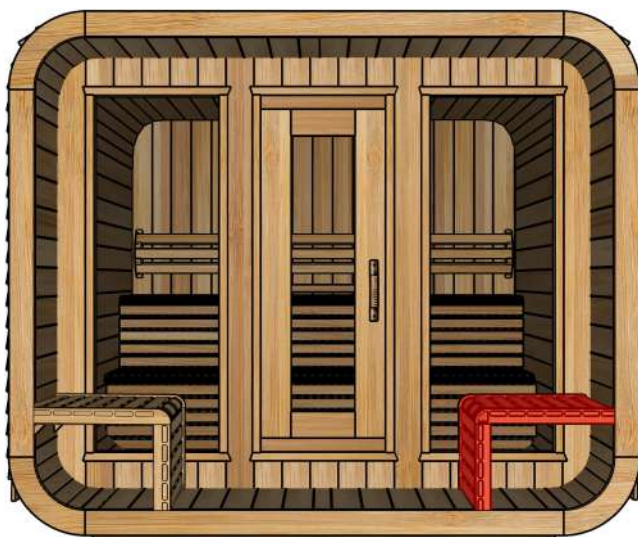
**124**

 **2X**  
2 1/2" (64 mm) Robertson



Fasten the bench to the floor with two screws in the pre-drilled holes underneath the bench.

**125**

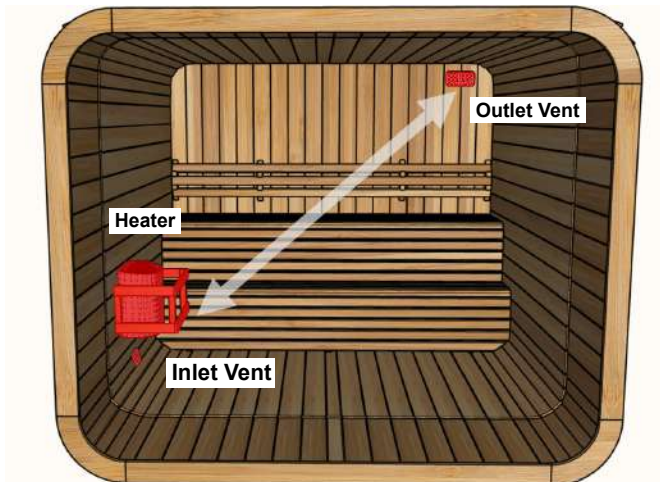


Repeat **STEPS 117-124** for the second bench.

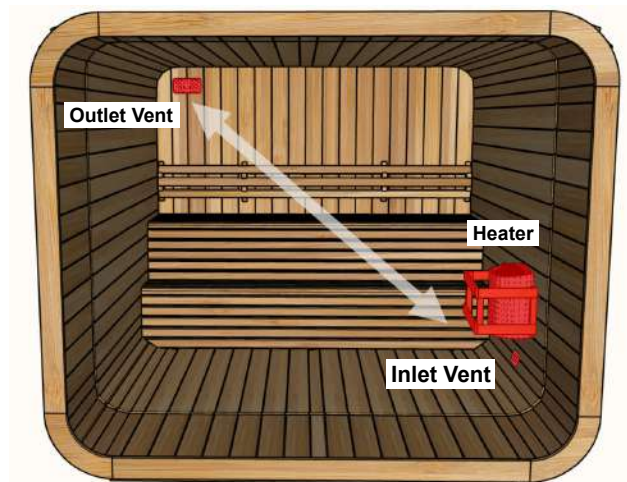


## Vent Installation

Installing vents for your sauna room will depend on your setup.  
See below for typical sauna setups.



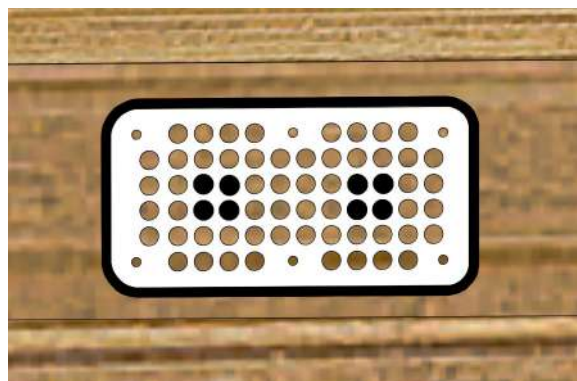
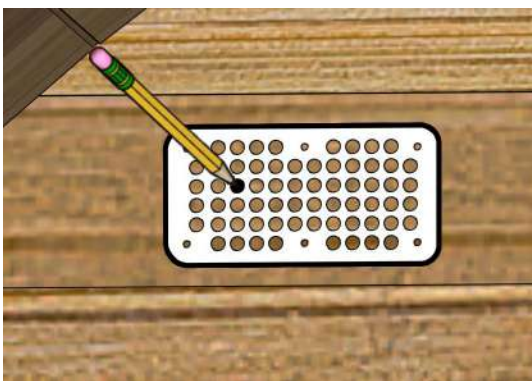
Setup A



Setup B

Place the inlet vent in the lower corner opposite to the outlet vent in the sauna.  
The inlet vent will be positioned underneath the heater.

126



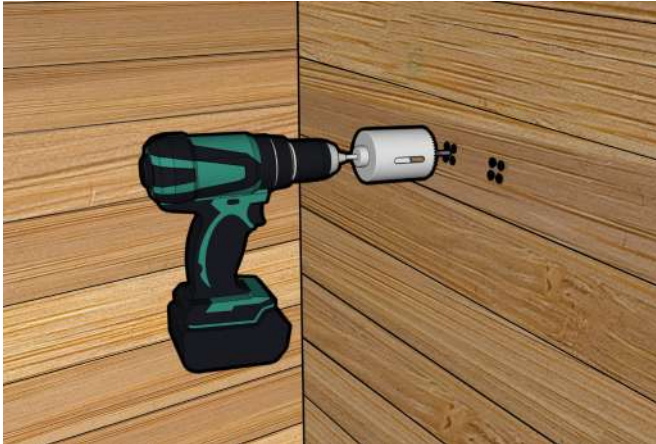
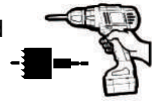
After locating an appropriate area for your vent use the vent cover as a template.  
Use the vent holes to mark off the dots as shown with a pencil.



## Vent Installation

127

2" (51 mm) Holesaw Recommended  
1 1/2" (38 mm) Minimum



Remove the vent cover and use a two inch hole saw to add two holes side by side for the vent. Create a hole between the four pencil marks etched on the wall from **Step 126**.

**PLEASE NOTE:** Only drill half way through the wall to avoid splintering the wood.

128



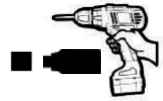
Continue drilling out the holes from the outer wall of the sauna.  
On the outer wall of the sauna position put the vent cover over the two holes.



## Vent Installation

129

 **6X**  
Provided screws

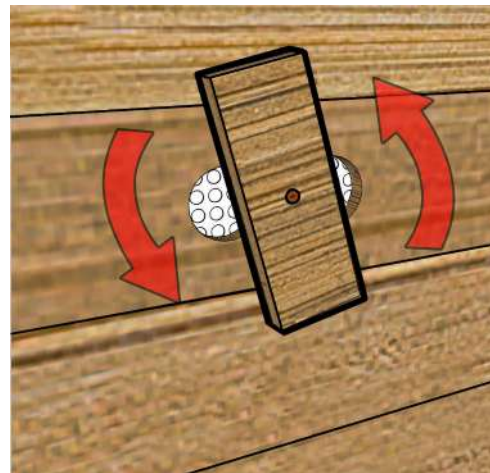
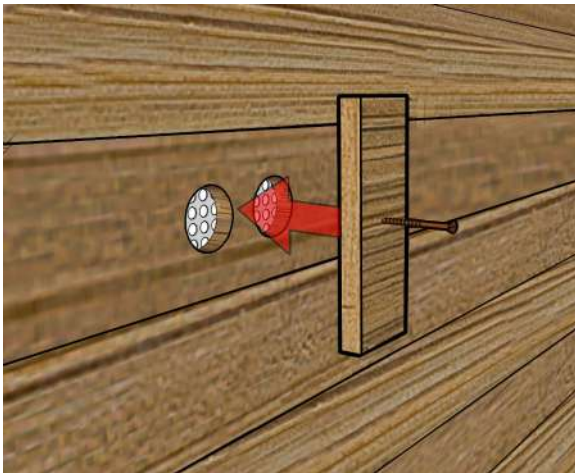
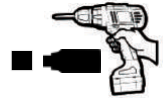


Fasten the vent cover on the outside wall with the six provided screws.

**PLEASE NOTE:** If you are installing the inlet vent place the cover to the inside wall of the sauna.

130

 **1X**  
1 1/2" (38 mm) Robertson



Add a screw to the provided wooden block in the pre-drilled hole.

Position and fasten the block between the two cut-out holes.

**PLEASE NOTE:** Only tighten the wooden block enough that it may swivel firmly.



## Vent Installation

131



Install the inlet vent in the lower corner opposite to the heater in the sauna.

Use **STEPS 126-129** as a guideline for installation.

**PLEASE NOTE:** The inlet vent cover will be installed on the inside of the sauna.

That concludes the basic instructions for the  
**Dundalk Luna Sauna with front porch.**

If you have any accessories left to install or will be in the near future please continue on to the next section.

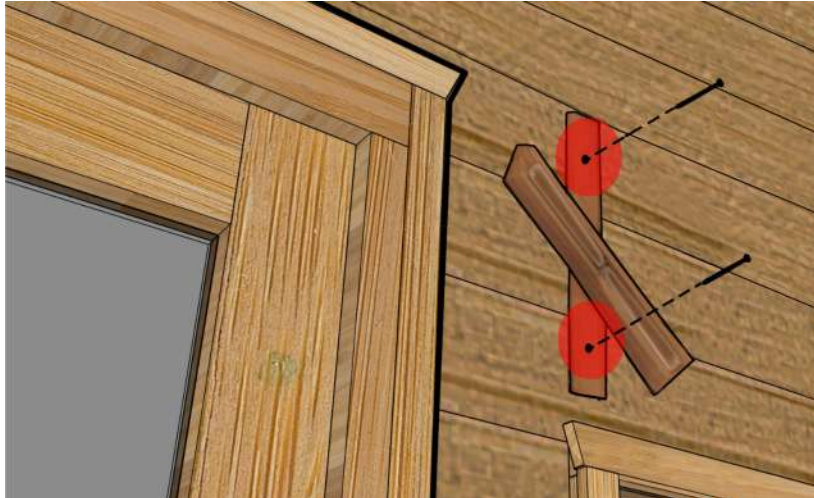
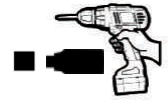
We hope you enjoy your sauna.



## Accessory Install Section

### Sand Timer (Optional)

 **2X**  
1 1/2" (38 mm) Robertson



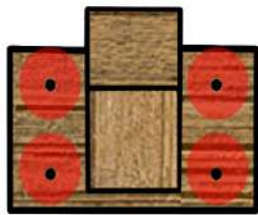
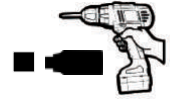
Place the sand timer in the desired location and secure with screws in the pre-drilled holes. Ensure it is in position and level so it may rotate without hitting the wall.



## Accessory Install Section

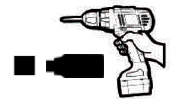
### Towel Hook (Optional)

**Single Towel Hook** **4X**    
1 1/2" (38 mm) Robertson



Place the towel hook in desired location and secure with screws in the pre-drilled holes.

**3 Towel Hook** **4X**    
1 1/2" (38 mm) Robertson



Place the towel hook in desired location and secure with screws in the pre-drilled holes.



## Accessory Install Section

### Thermometer (Optional)

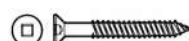
 **1X**  
Nail

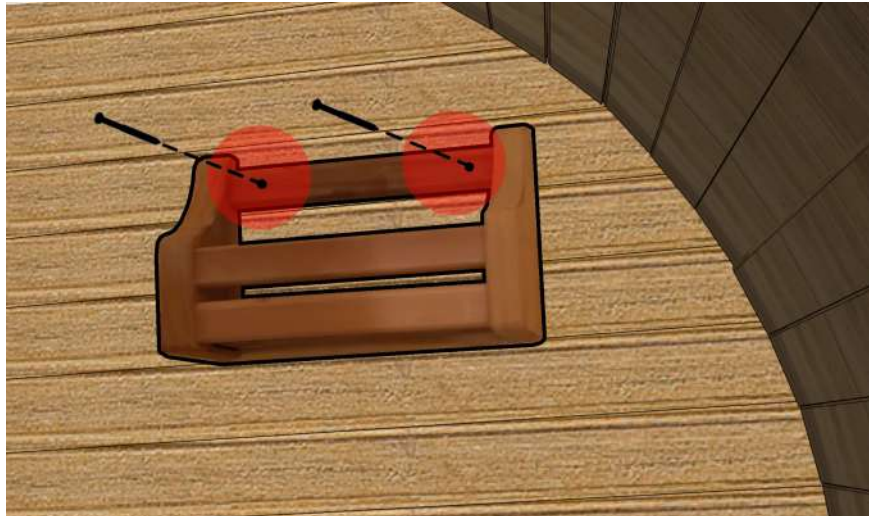
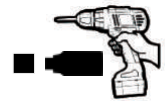


Place thermometer in desired location and secure with the provided nail.

**PLEASE NOTE:** The thermometer should be placed in a location away from the heater

### Shelf (Optional)

 **2X**  
2 1/2" Robertson



Place the towel hook in desired location and secure with screws in the pre-drilled holes.



## NOTES

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# INTRODUCING OUR SAUNA STAINS & FINISHES



## ALIS NATURAL OIL FOR EXTERIOR WOOD

Perfect for your sauna and garden furniture. This protective oil for outdoor wood offers great value.



Sesame



Light Teak



Elm Dark Brown



Black



## MELDOS NATURAL OIL FOR SAUNA INTERIORS

Meldos is a natural and versatile impregnating, perfect for protecting soft Woods and ideal use in saunas.

See your local paint retailer to purchase your preferred outdoor stains or water sealer or you can try LIVOS wood care products from Leisurecraft today!



Scan the code for a video of the assembly process:



# Maintaining Your Sauna After Installation

## INTERIOR

It is recommended to vacuum or sweep out the inside of your sauna frequently to remove dirt and debris. Under normal conditions, a slight wash of the floor and benches with warm soapy water several times a year will maintain its cleanliness. Leisurecraft offers a sauna room cleaner that can be used pure or diluted at a 4-1 ratio. Simply spray and wipe!

You can use a sheet of fine grit sandpaper or a low-pressure wash to remove more stubborn stains for a deeper cleaning of the interior of your sauna.

**NEVER USE ammonia or harsh cleaners as they can turn the wood gray.**



## EXTERIOR

Depending on the humidity and weather conditions in your area, the cedar will either shrink or expand based on the amount of moisture absorption. The desired effect is to have the cedar expand into the bands therefore making the sauna staves much tighter. Over time the lumber will weather naturally as a result of sun and rain, it will change into a weathered grey colour. The natural weathering will not harm the wood or impair the sauna's performance.

If you wish to retain the natural color of your Leisurecraft Sauna, Leisurecraft offers cedar sauna stain in 4 amazing colors, Espresso, Limestone Trail, Onyx Gem, and Pickled White in convenient 1 gallon pails.

## WATER SEEPAGE

Some minor water seeping into the sauna is expected and normal for an outdoor sauna. If your sauna is properly installed, you should not have water dripping in, but you should expect some water seepage, especially on the top and sides of the sauna. This is due to the porous characteristics of the wood and to the ball-and-socket profile design of the staves. Water seepage will not harm the sauna. The moisture will evaporate once you turn on the heater and the sauna heats up. If the water marks are bothersome, they can be easily removed with a light sanding with 80 or 100 grit sandpaper.



Scan the code for a video of the assembly process:





## 5 Year Residential Limited Warranty Policy

All products designed and manufactured by Dundalk LeisureCraft Inc. ("LeisureCraft") are covered by a limited warranty against defects in materials and workmanship under normal residential use for a period of five (5) years, beginning on the date the product is received by the original end-user consumer.

This warranty does not apply to defects resulting from normal wear and tear, improper installation, insufficient or improper maintenance, natural weather conditions or failure to follow the manufacturer's installation, usage, or care instructions.

In the event of a valid warranty claim, LeisureCraft will provide replacement parts at no charge. However, please note that the replacement of parts will not extend the original warranty period.

This warranty is limited solely to the replacement of parts and does not cover any associated service, labor, or installation costs, all of which are expressly excluded.

For products offered by LeisureCraft that are not manufactured by LeisureCraft, please refer to the warranty policy and terms provided by the manufacturer.

## LIMITED WARRANTY

Dundalk LeisureCraft Inc. ("LeisureCraft") is committed to providing high-quality sauna heaters and accessories to our customers. To offer peace of mind, we will match the manufacturer's warranty on all eligible products purchased from us. If the manufacturer offers a warranty on the product, we will honor that warranty, ensuring the same terms, coverage, and duration.

This warranty is limited to the replacement of parts only. It does not cover any service, labor, or installation costs, which are expressly excluded.

This warranty does not apply to defects caused by normal wear and tear, improper installation, inadequate or improper maintenance, or failure to adhere to the manufacturer's installation, use, or care instructions.

All electrical connections must be made by a licensed electrician. Failure to comply with this requirement will void the warranty.

For warranty claims or inquiries, please contact LeisureCraft customer support at:

Phone: 888-923-9813 Email: [support@leisurecraft.com](mailto:support@leisurecraft.com)

**Please ensure you fill out your warranty card!**





# leisurecraft

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