



pure cübe

ASSEMBLY INSTRUCTIONS

for the

ORION SAUNA

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



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CONGRATULATIONS

on the purchase of your

ORION 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.

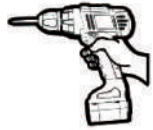


Always ensure that you have the correct screw
length so that the screw does not go all the way
through the material and come out the other side.



Tools Checklist

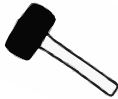
Ensure you have the following tools to finish the job right!



Cordless Driver

☐


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

☐


Mallet

☐


Hole Saw

☐

2" (51 mm) Hole Saw with bit for cordless driver or drill. 1 1/2" - 2" (38-51 mm) size



Tape Measure

☐


Drill Bit Set

☐

Drill Bit Set with 1/2" (13mm) & 1/8" (3 mm) Bit



Snips

☐


or



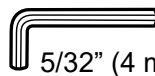
Staple Gun or
Nail/Staple Gun

☐


#2 Robertson

☐


Phillips

☐


5/32" (4 mm)

or



5/32" (4 mm)

☐


Hammer

☐


Utility Knife

☐


Marker or Pencil

☐


Square

☐


Level

☐


1/4" Wrench

☐


Circular Saw, Table Saw
or Mitre Saw

☐


Adjustable

☐


Drywall Saw

☐


Scan the code for a video of the assembly process:



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.



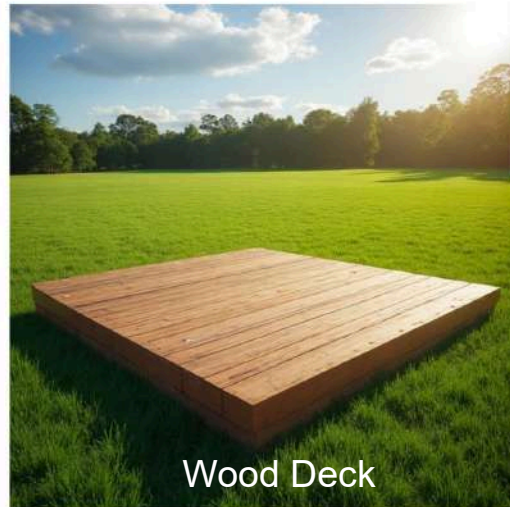
Crushed Stone



Patio Stone/Paver Blocks



Concrete Pad



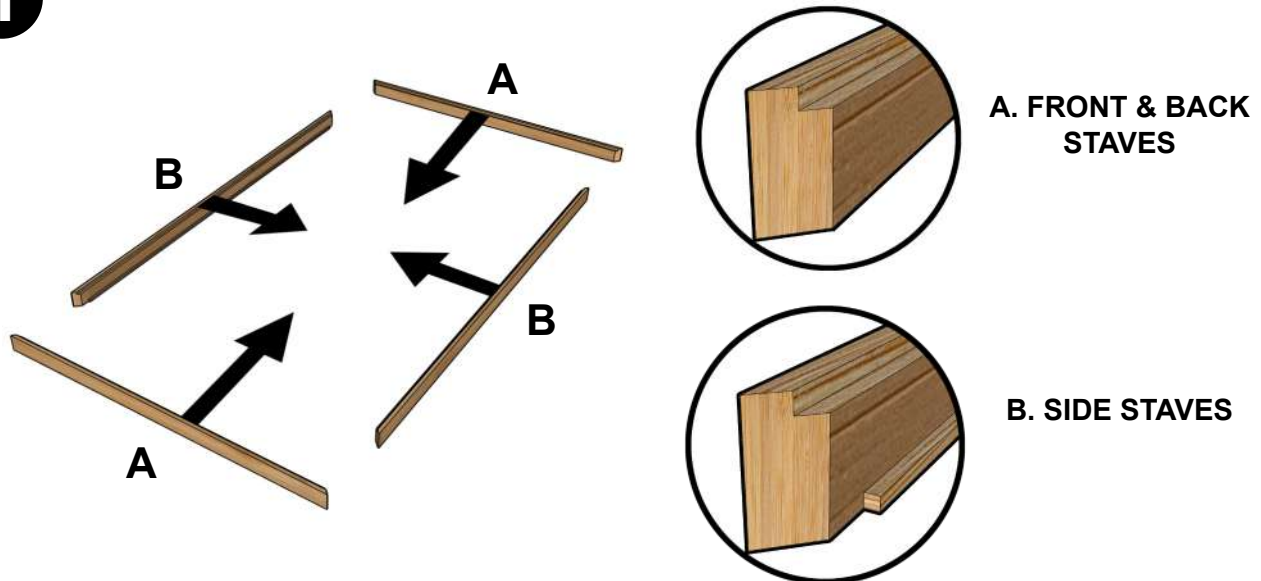
Wood Deck

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



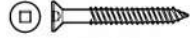
Assembly Instructions

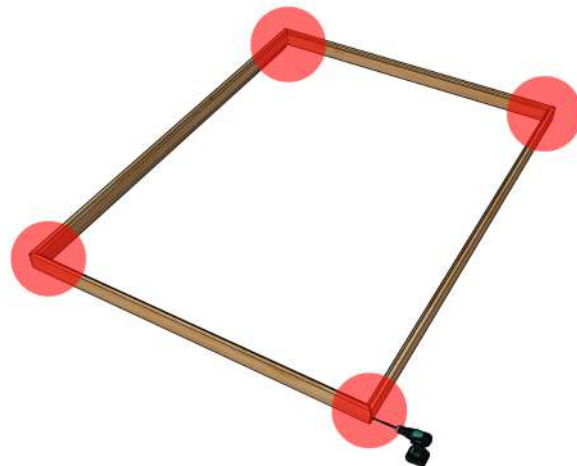
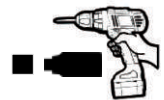
1



On a large flat area or platform place the floor pieces down for assembly.

2

 **8X**
2.5" (64mm) Robertson

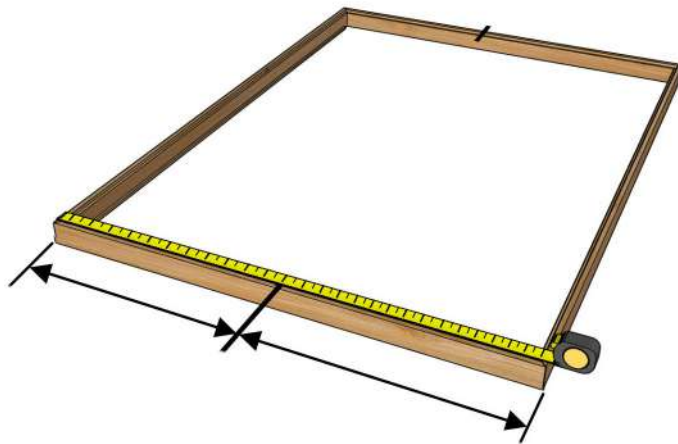


Connect the frame with screws in the pre-drilled holes.



Bottom Frame Assembly

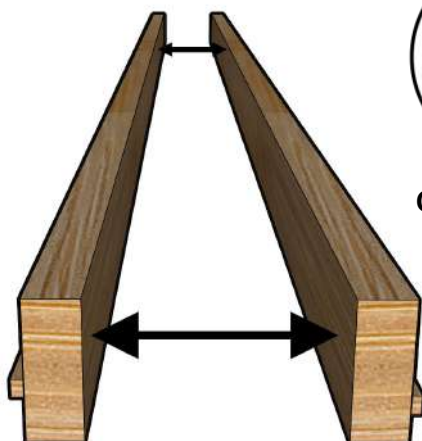
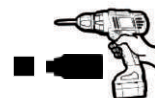
3



Mark the middle point of the front and back joists.

4

 **4X**
2.5" (64mm) Robertson



CENTER JOIST

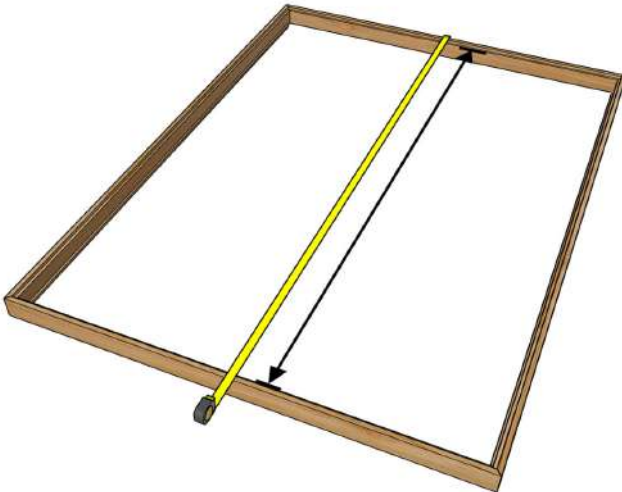


Find the center floor joists with the insulation supports. Place the joists so the flat wide face of each joist is facing one another.



Bottom Frame Assembly

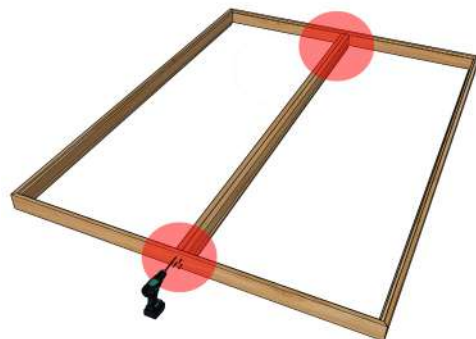
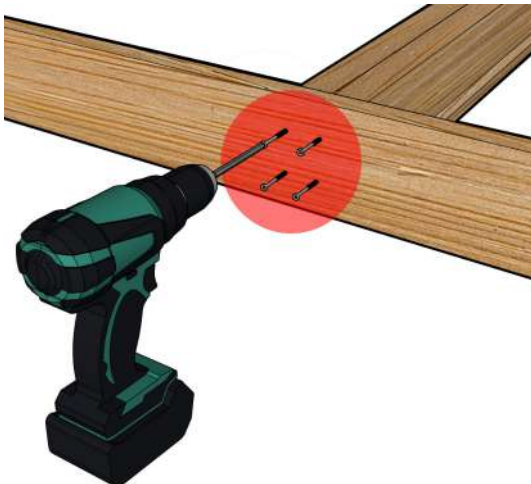
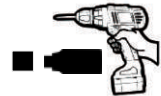
5



Measure the distance between the front and back floor joist and trim the center floor joists if necessary.

6

 **8X**
2.5" (64mm) Robertson

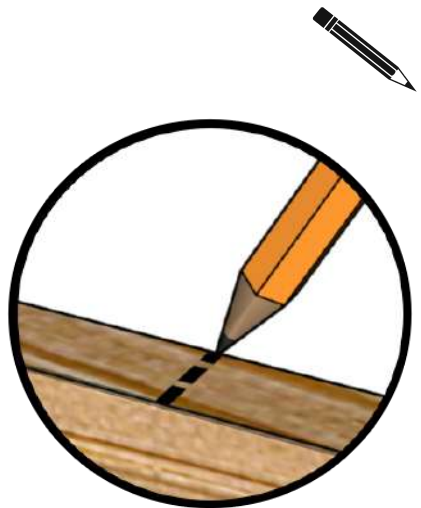
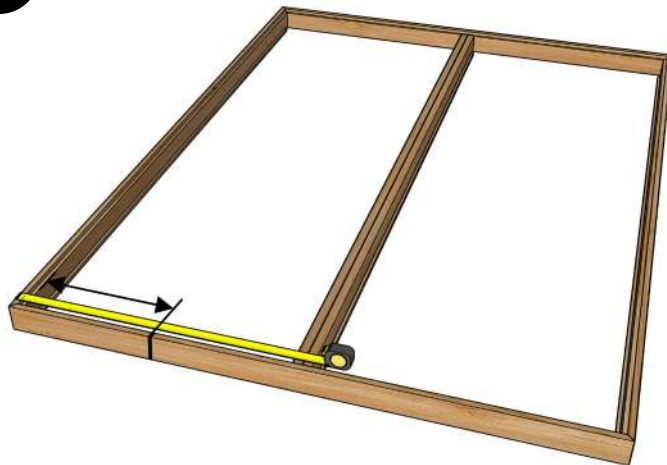


Fasten the center joist to the bottom frame. Ensure the joists are square.



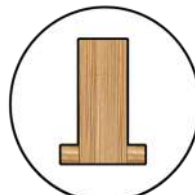
Bottom Frame Assembly

7

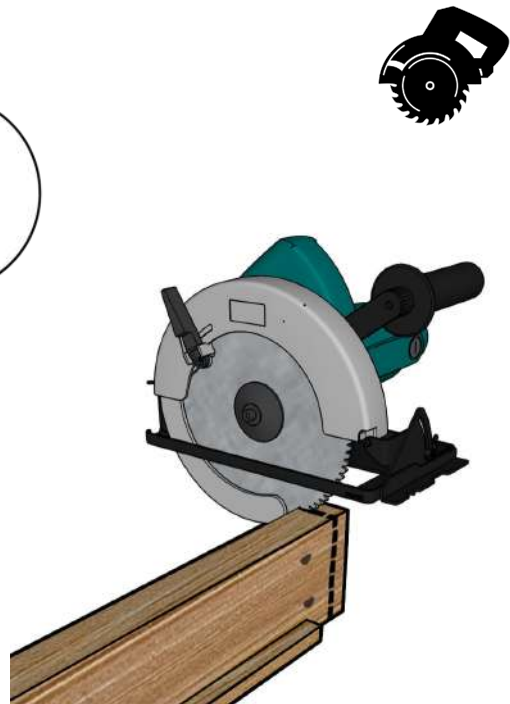


Mark the center point between the frame center and side joists.

8



JOIST



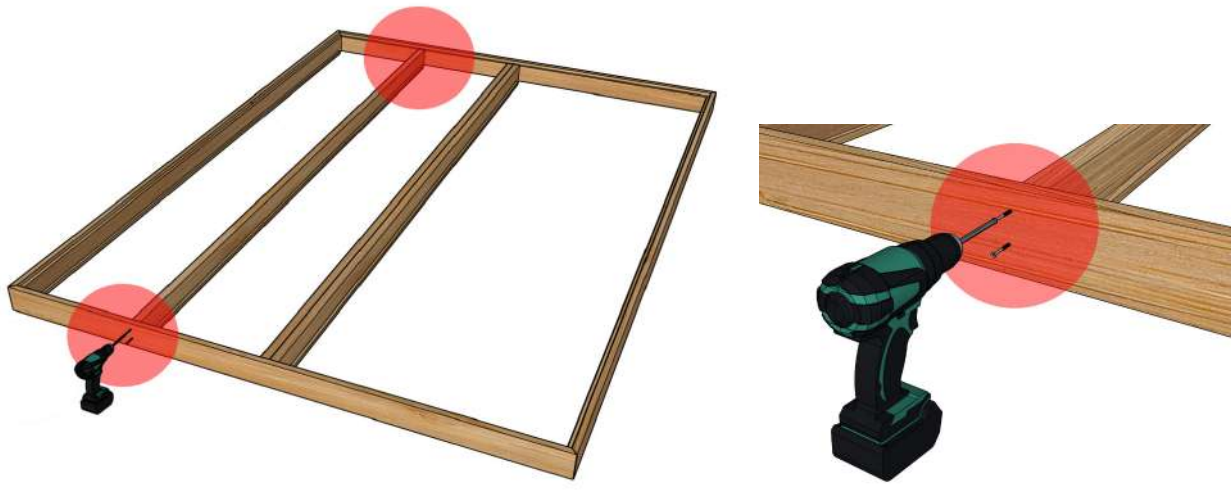
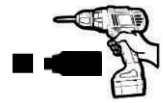
Measure the distance between the front and back floor joist and trim the floor joist if necessary.



Bottom Frame Assembly

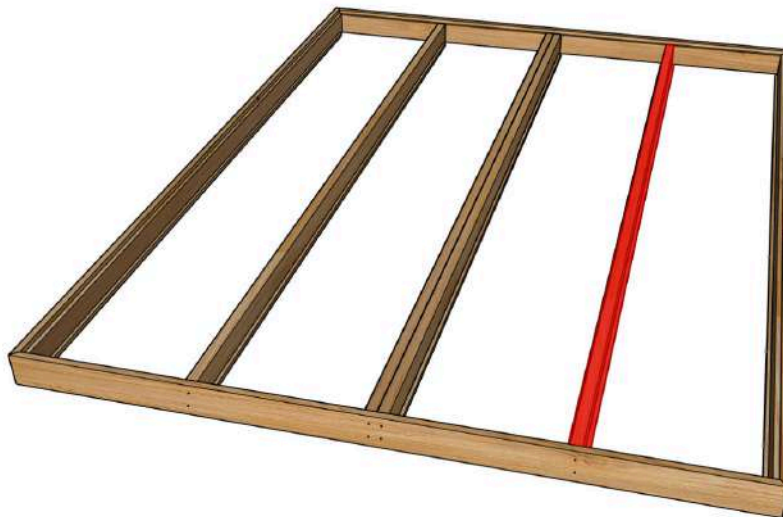
9

 **8X**
2.5" (64mm) Robertson



Fasten the joist to the bottom frame. Ensure the joists are square.

10



Follow **STEPS 7-9** for the joist on the opposite side of the center joist.

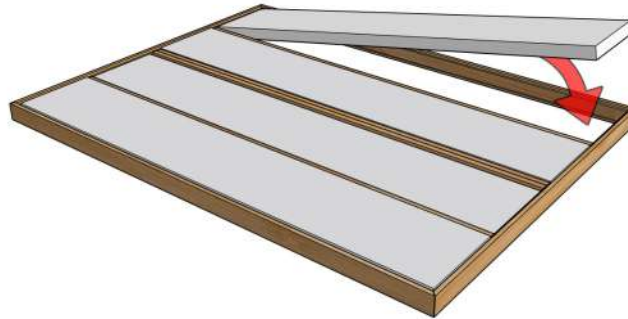


Scan the code for a video of the assembly process:



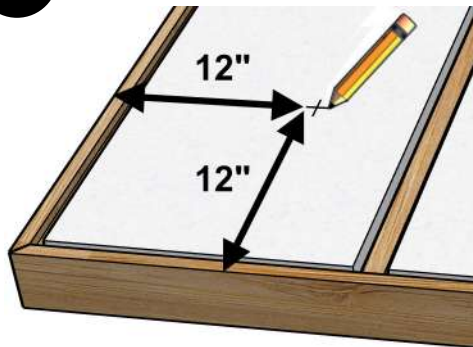
Bottom Frame Assembly

11



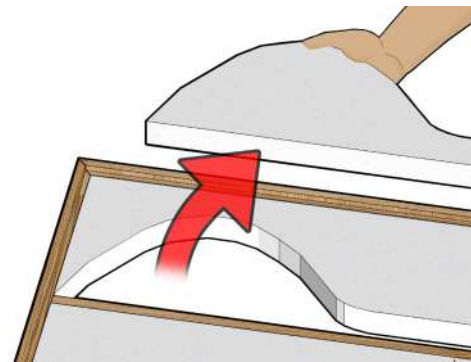
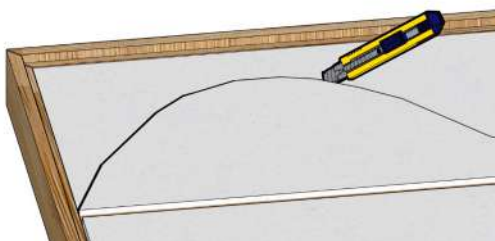
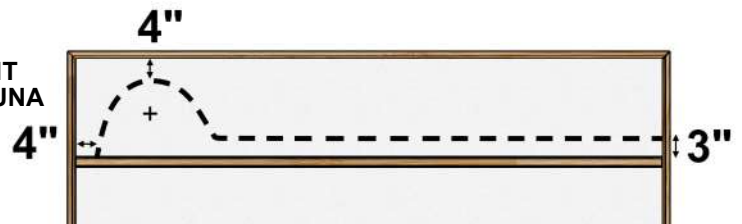
Place the insulation panels between the joists.
Ensure each insulation panel is square and sits flat inside each panel slot between the joists.
Some trimming may be needed so each panel fits into the panel slots.

12



FRONT OF SAUNA

FRONT
OF SAUNA



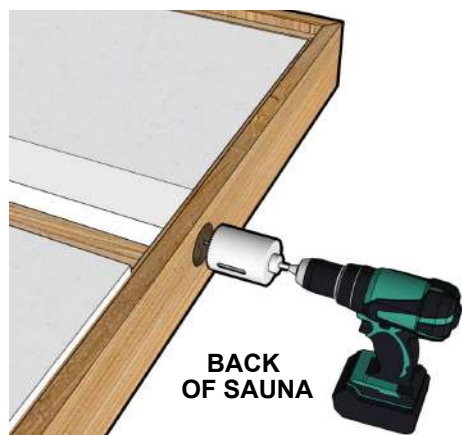
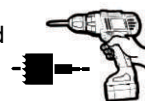
Locate the foam where the heater wire will be routed through. On this panel mark **12" (305 mm)** from the front and side joists. On the foam panel where the heater wire will be routed cut an area as shown in the image above.



Bottom Frame Assembly

13

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



Mark the spot where the wire will come through the back floor joist and cut out with a **2"(51 mm)** hole.

14



Please check with your local electrician/technician for any wiring setup or routing to be done for your sauna build.



Feed and place the heater wire for installation later.

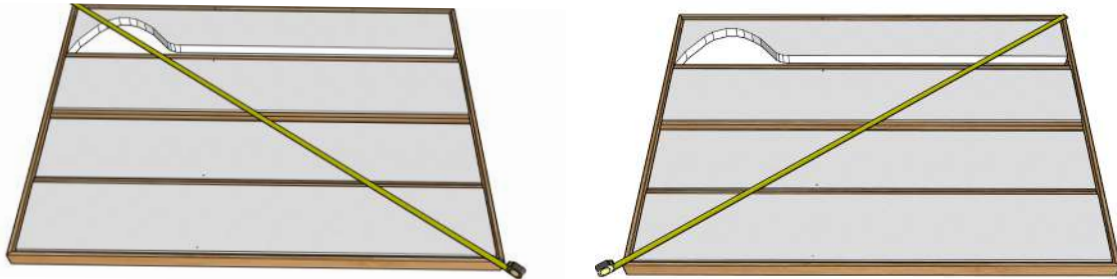


Scan the code for a video of the assembly process:



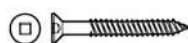
Bottom Frame Assembly

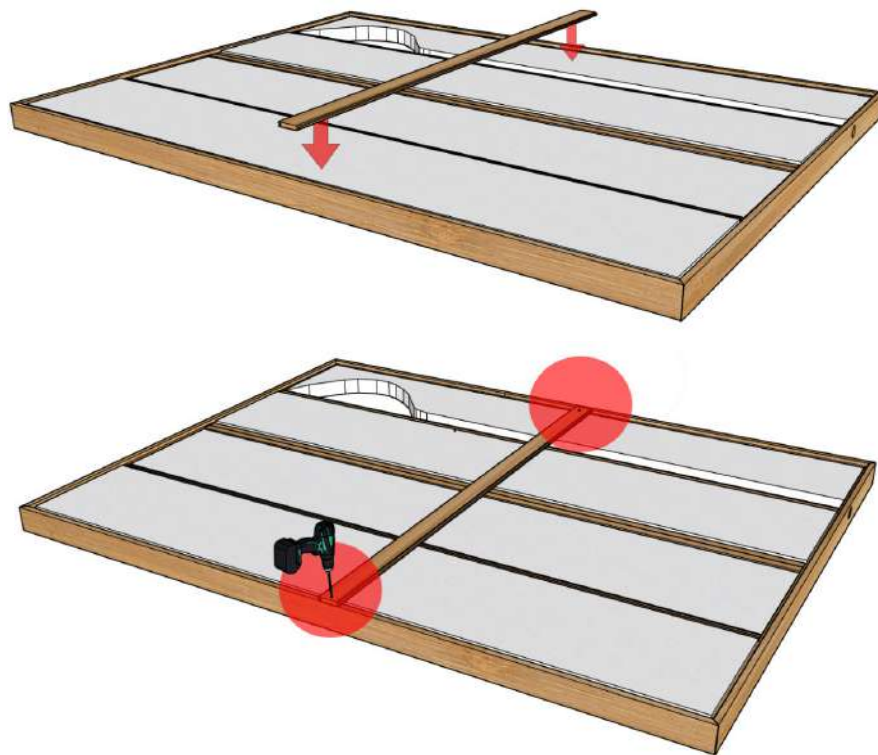
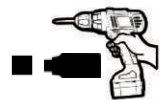
15



Check the frame is square. Make adjustments if necessary.

16

 **2X**
1.5" (38 mm) Robertson

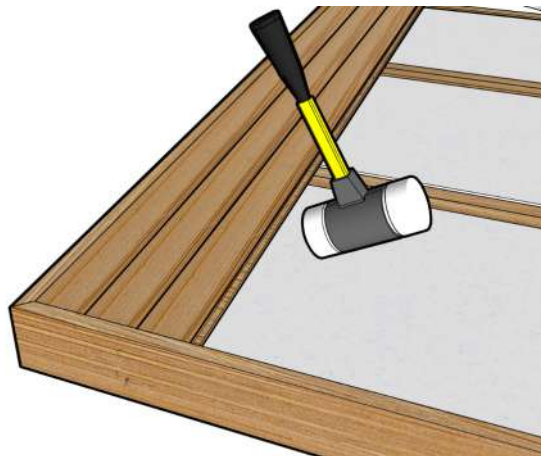
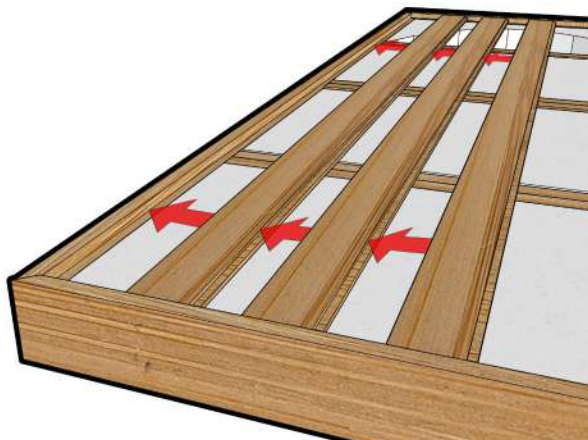


Place and fasten a floor board to keep your frame from moving.



Bottom Frame Assembly

17



Begin placing the floor boards, ensure the smoother side is on top and the tongues are tight into the grooves.

18

Finish Nails

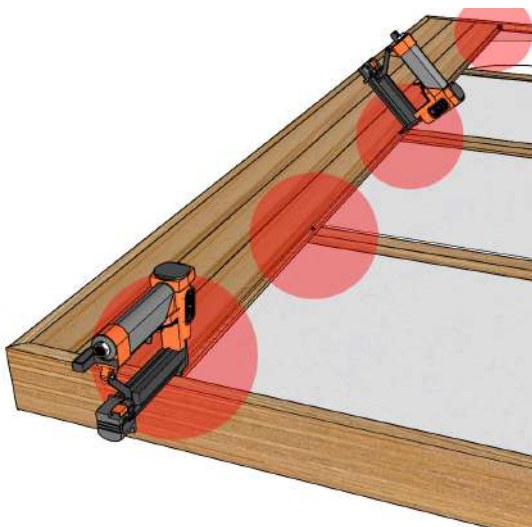


or

1 1/4"



or



Secure with staples or finish nails. Be sure to secure through the tongues and not the face of the center of the floor boards, for a cleaner look.



Scan the code for a video of the assembly process:



Bottom Frame Assembly

19

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



On the fourth board, mark **12" (51 mm)** from the side joist in the center of the board.
Cut out with a 2 inch (305 mm) hole saw.

20

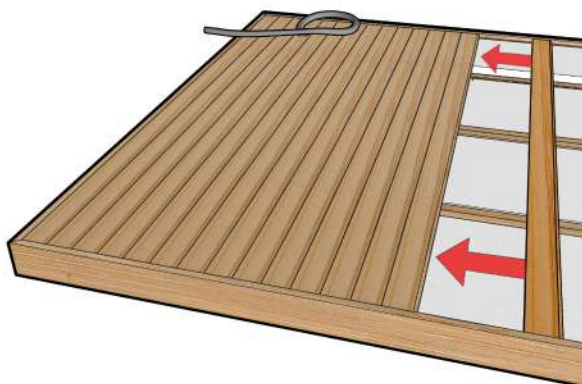
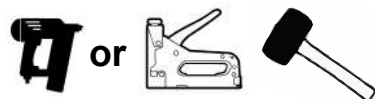


Feed the heater wire through the insulation channel & floor board hole.



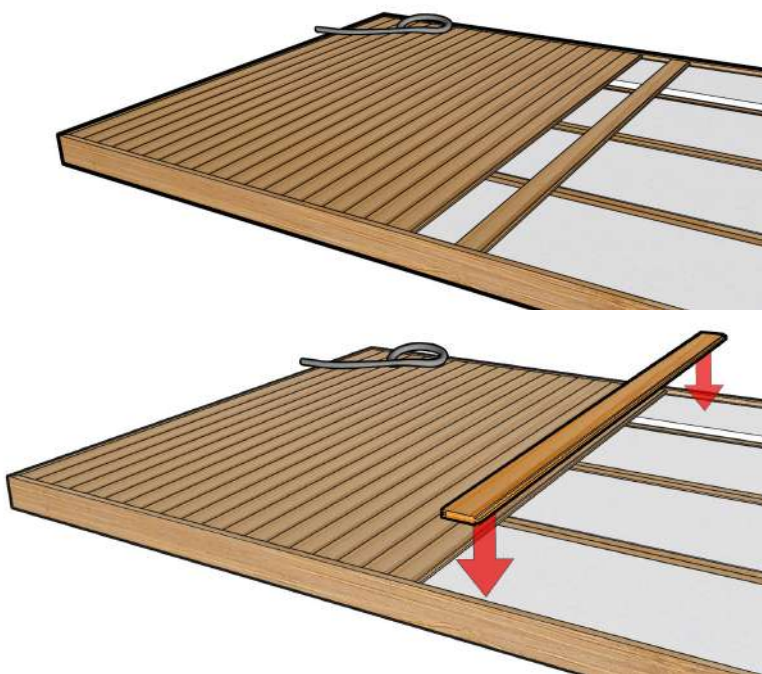
Bottom Frame Assembly

21 Finish Nails  or 1 1/4" (32 mm) 



Continue placing and fastening the floor boards. Ensure a tight fit between boards but using a mallet.

22



When you reach the temporary floor board remove it. Place and fasten the board.



Bottom Frame Assembly

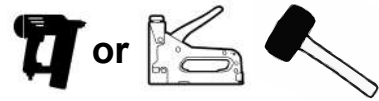
23

Finish Nails



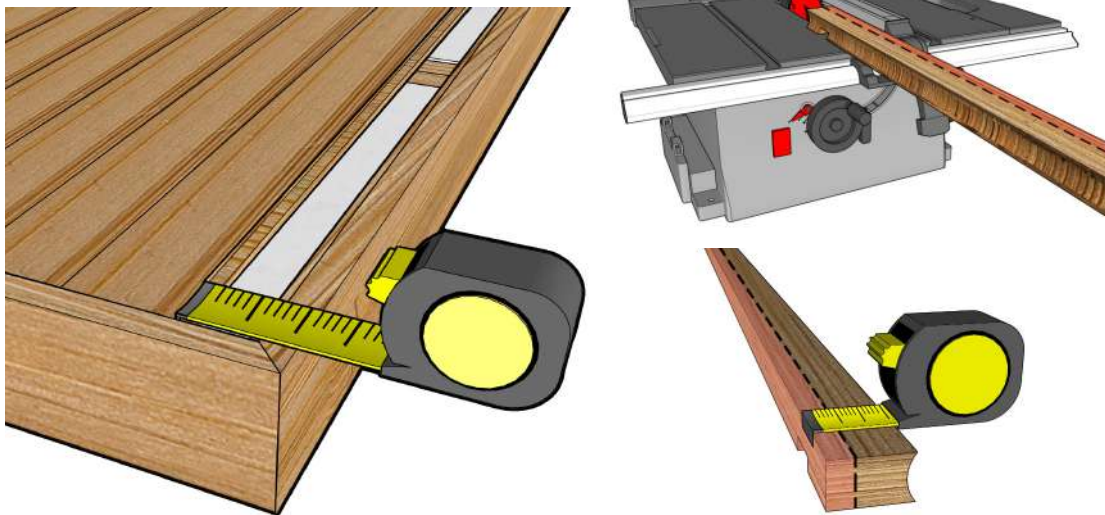
or

1 1/4"
(32 mm)



Continue placing and fastening the remaining floor boards. Ensure a tight fit between boards but using a mallet. Place but do not fasten the second last floor board.

24



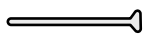
When you reach the end, measure the gap and cut the finisher board to fit.



Wall Assembly

25

Finish Nails



or

1 1/4"
(32 mm)



or



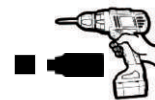
Place the final full size board and finisher. Fit both into place and fasten.

26



2X

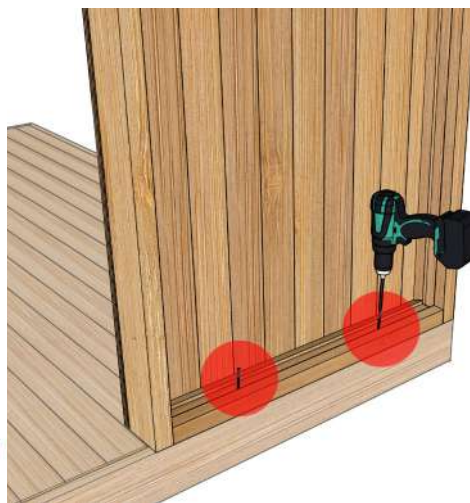
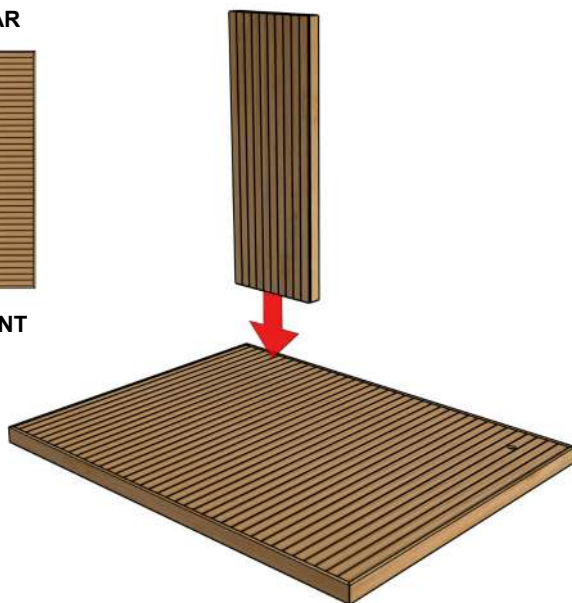
3.5" (89 mm) Robertson



SAUNA REAR



SAUNA FRONT



Place and fasten a wide wall panel to the back corner of the sauna floor (See image above).
Ensure the panel is flush with the floor frame.



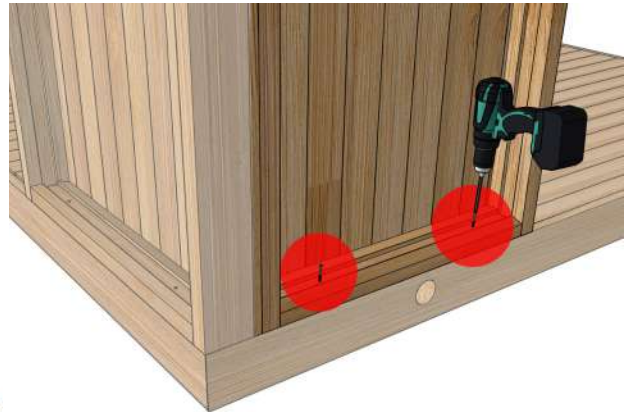
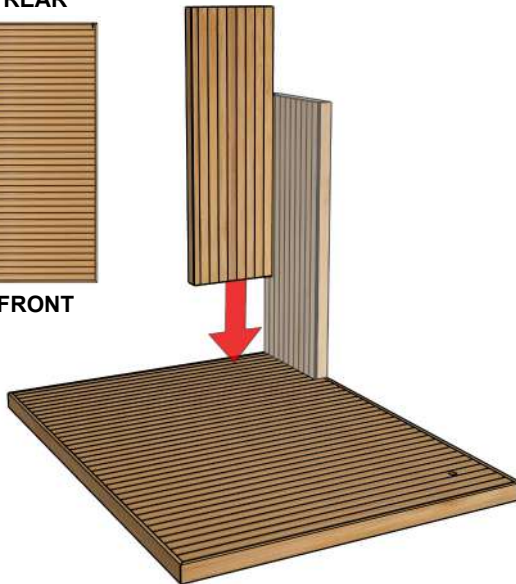
Scan the code for a video of the assembly process:



Wall Assembly

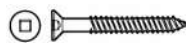
27

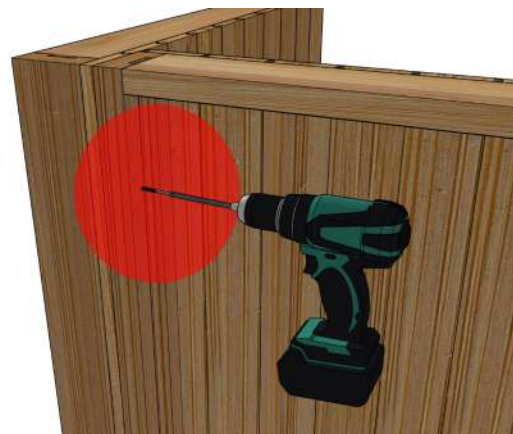
 **2X**
3.5" (89 mm) Robertson



Place and fasten a narrow wall panel to the back corner of the sauna floor (See image above).
Ensure the panel is flush with the floor frame.

28

 **3X**
3.5" (89 mm) Robertson



Fasten the two wall panels together. Ensure both panels are flush with each other before fastening.



Wall Assembly

29

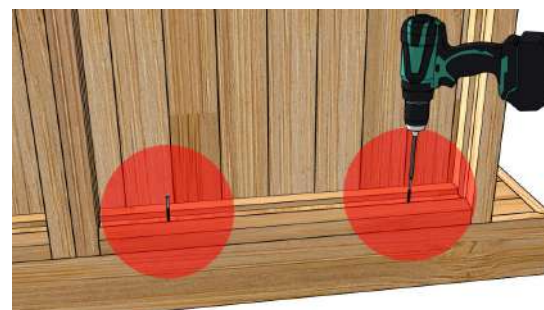
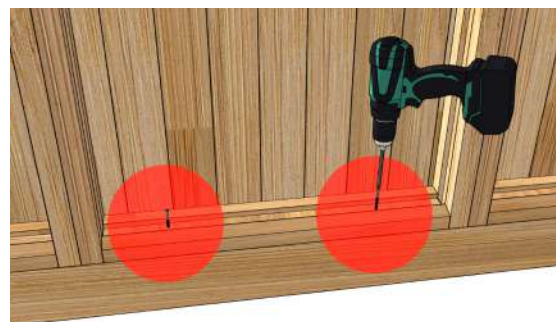
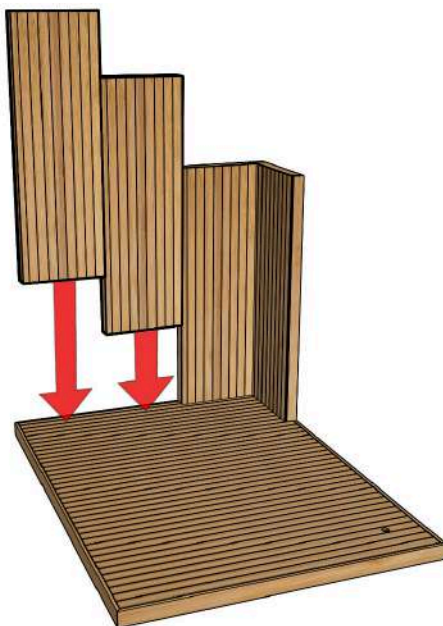
 **4X**
3.5" (89 mm) Robertson



SAUNA REAR



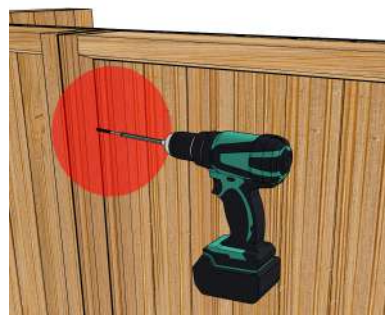
SAUNA FRONT



Place a narrow wall panel to the rear of the sauna. Fasten with two screws on the sauna floor.
Repeat placing and fastening a second narrow panel.

30

 **6X**
3.5" (89 mm) Robertson



Fasten with screws.



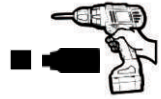
Scan the code for a video of the assembly process:



Wall Assembly

31

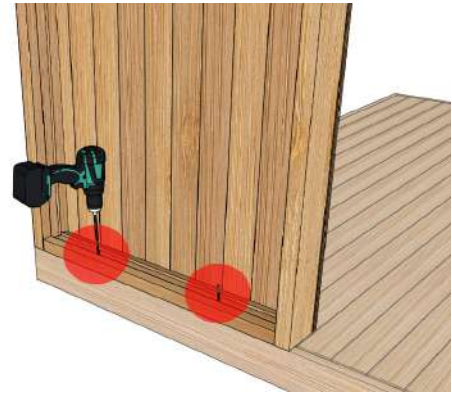
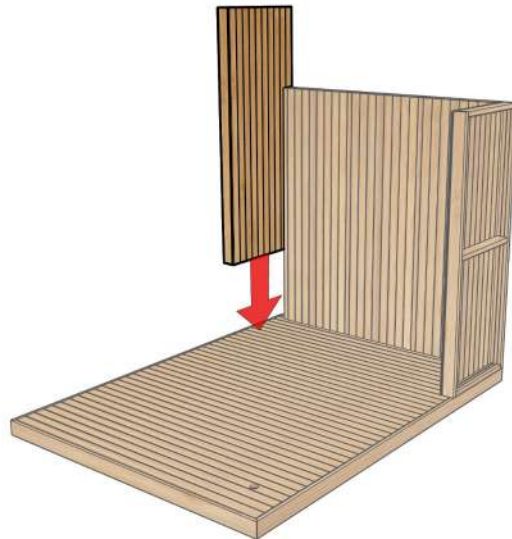
 **2X**
3.5" (89 mm) Robertson



SAUNA REAR



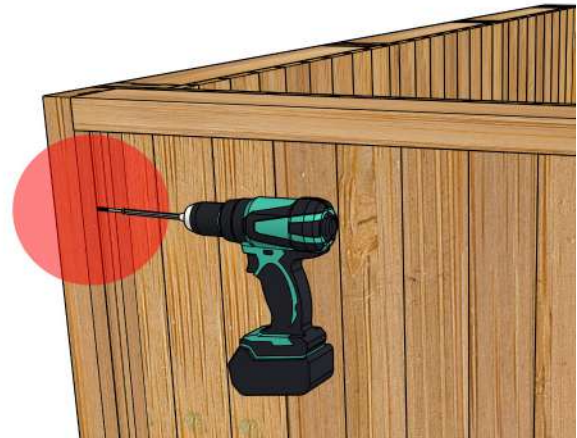
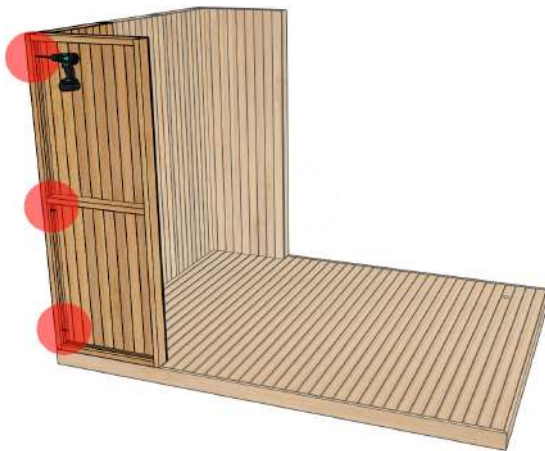
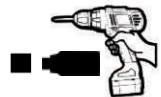
SAUNA FRONT



Place and fasten a wide wall panel to the back corner of the sauna floor (See image above).
Ensure the panel is flush with the floor frame.

32

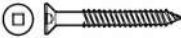
 **3X**
3.5" (89 mm) Robertson



Fasten the corner wall panels together.



Wall Assembly

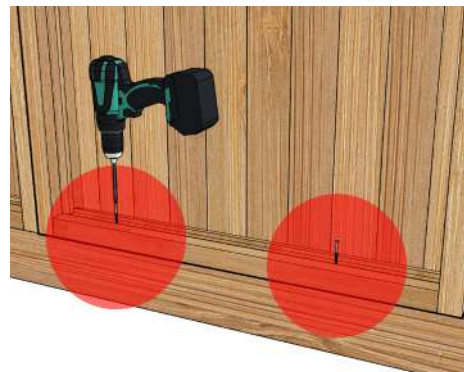
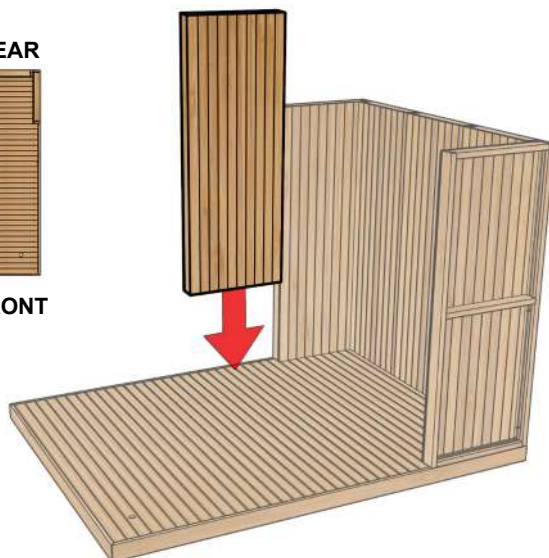
33  **2X**
3.5" (89 mm) Robertson



SAUNA REAR

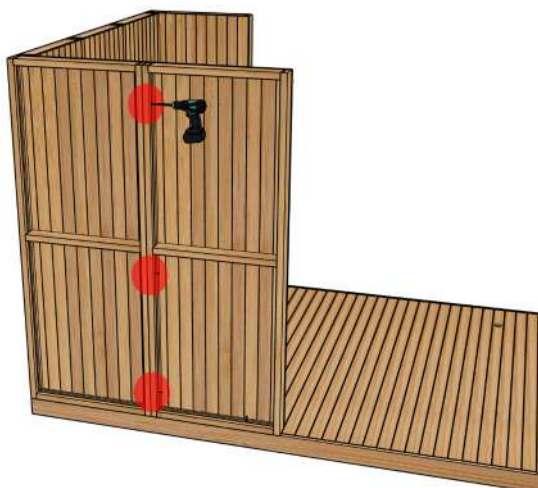


SAUNA FRONT



Place and fasten a wide wall panel to the side of the sauna floor (See image above).
Ensure the panel is flush with the floor frame.

34  **3X**
3.5" (89 mm) Robertson

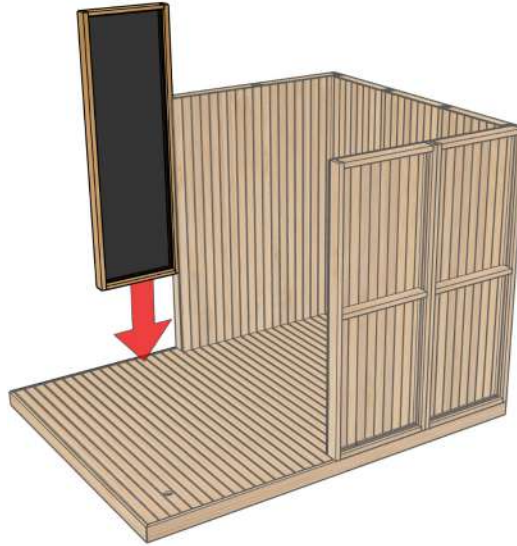


Fasten the side wall panels together.



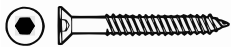
Door & Window Assembly

35



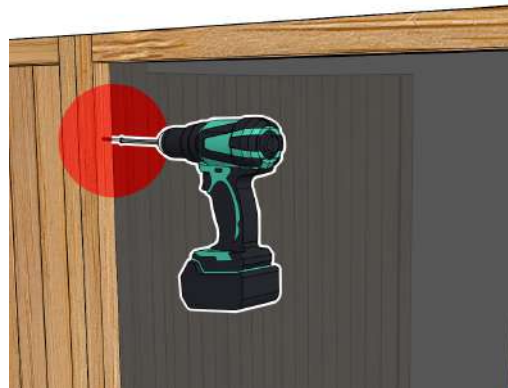
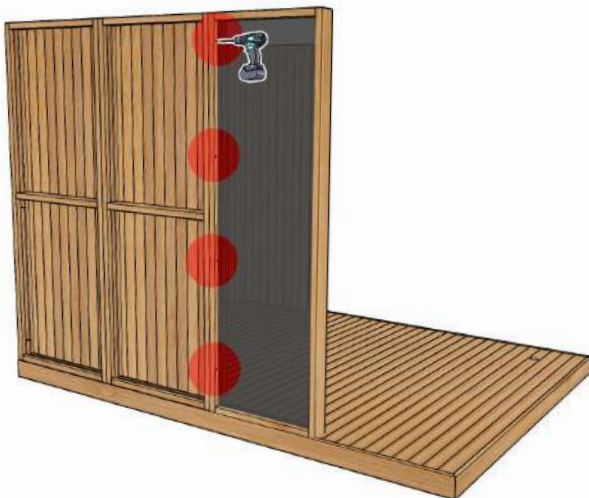
Place the side window panel on the side of the sauna. Ensure it is flush and the pre-drilled holes are facing to the outside of the sauna.

36



Lag Screws

4X

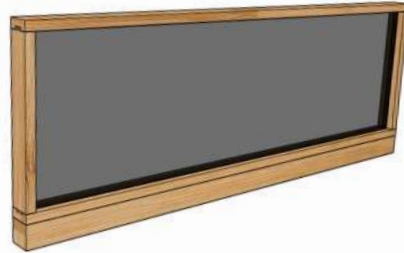
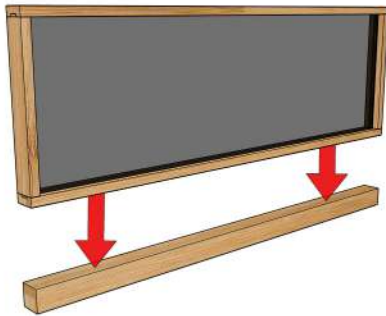


Secure to the previous panel with 4x connector lag screws in the pre-drilled holes. Ensure both panels are flush.



Door & Window Assembly

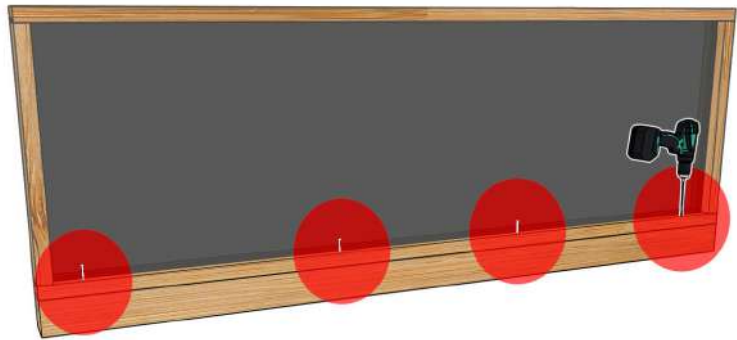
37



Place another glass panel on a short 4x4 post. Ensure it is flush and secure to the post with lag screws in the pre-drilled holes.

38

 **4X**
Lag Screws



Ensure it is flush and secure to the post with lag screws in the pre-drilled holes.

39

SAUNA REAR



SAUNA FRONT



Place the glass panel with the 4x4 post oriented towards the corner of the sauna. Ensure it is flush and the pre-drilled holes are facing to the outside of the sauna.



Door & Window Assembly

40



4X

Connector Bolts & Cap Nuts

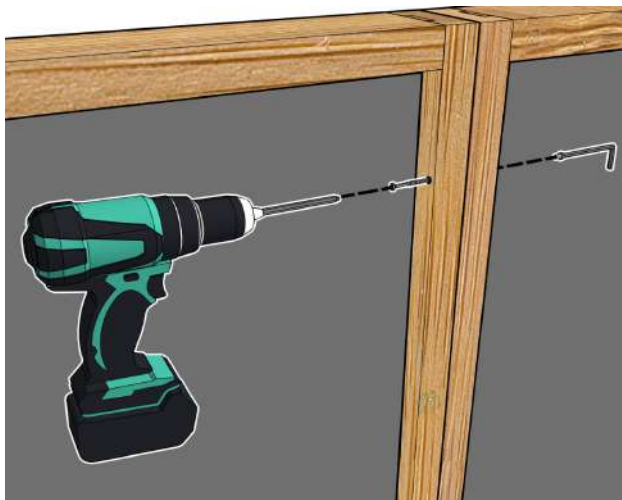


5/32" (4 mm)

OR



5/32" (4 mm)



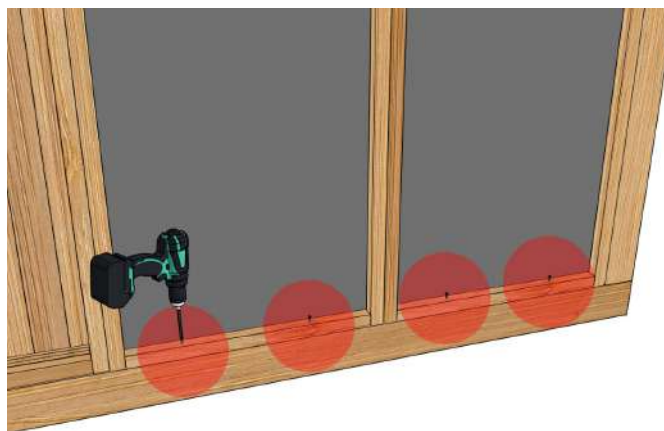
Fasten the two panels with connector bolts and cap nuts in the pre-drilled holes.
Ensure both panels are flush.

41



4X

2.5" (64 mm) Robertson

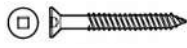


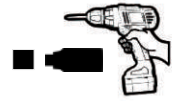
Fasten the bottom of the windows panels with screws.



Door & Window Assembly

42

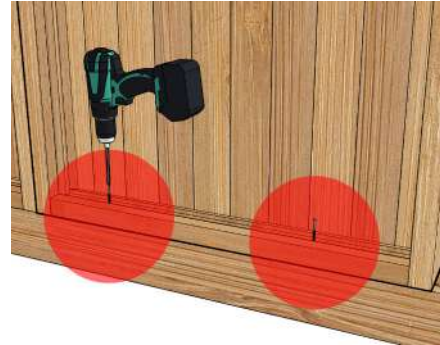
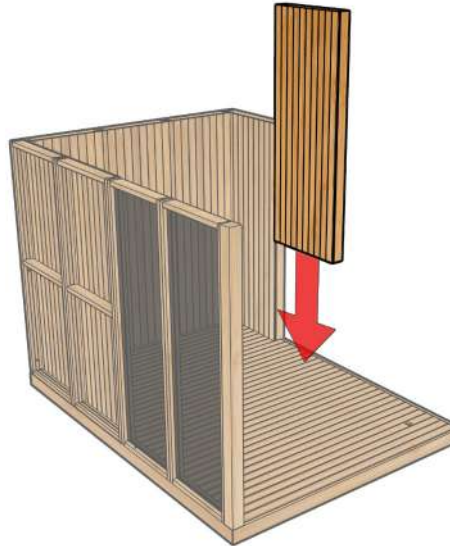
 **2X**
3.5" (89 mm) Robertson



SAUNA REAR

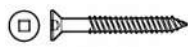


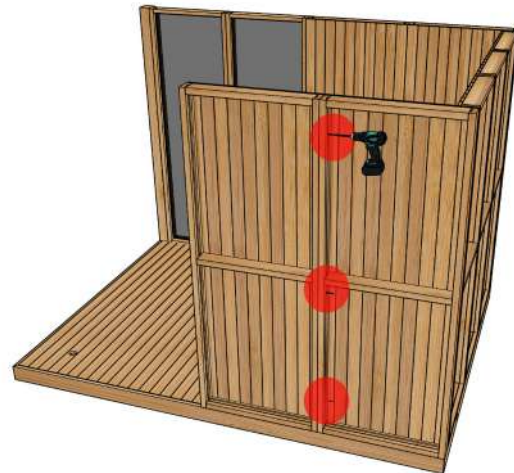
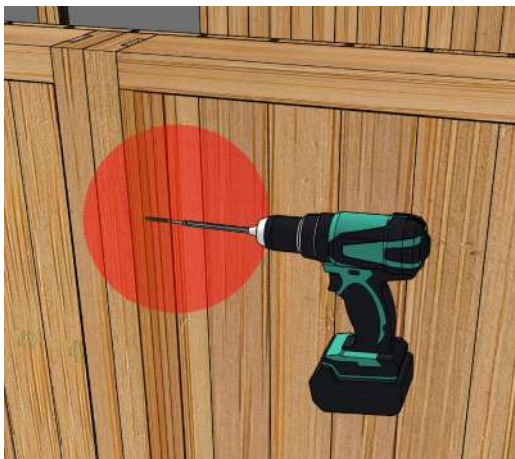
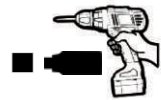
SAUNA FRONT



Place and fasten a wide wall panel to the back corner of the sauna floor (See image above).
Ensure the panel is flush with the floor frame.

43

 **3X**
3.5" (89 mm) Robertson



Fasten the side wall panels together.

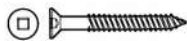


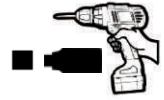
Scan the code for a video of the assembly process:



Door & Window Assembly

44

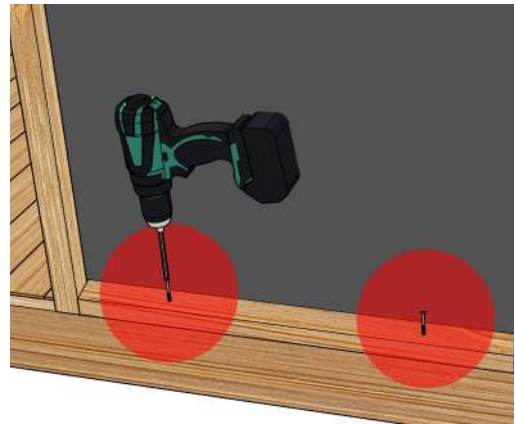
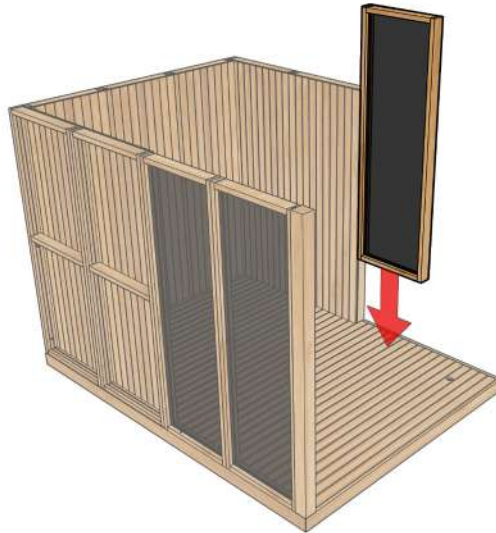
 **2X**
2.5" (64 mm) Robertson



SAUNA REAR



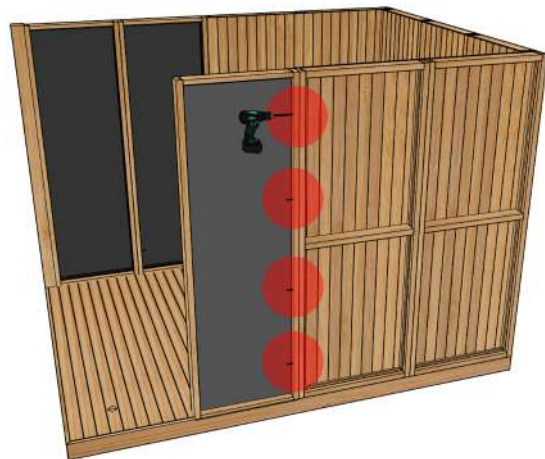
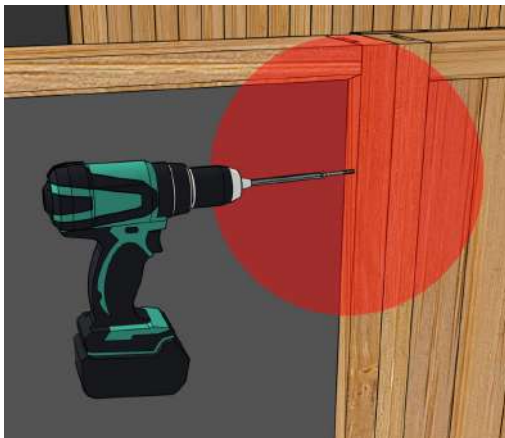
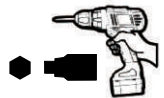
SAUNA FRONT



Place and fasten a window side panel to the side of the sauna floor (See image above).
Ensure the panel is flush with the floor frame.

45

 **4X**
Lag Screws

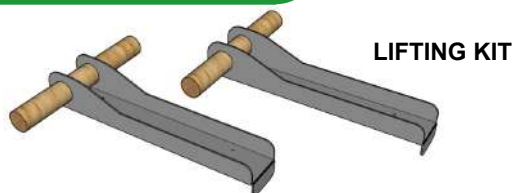


Secure to the previous panel with 4 connector lag screws in the pre-drilled holes.
Ensure both panels are flush.

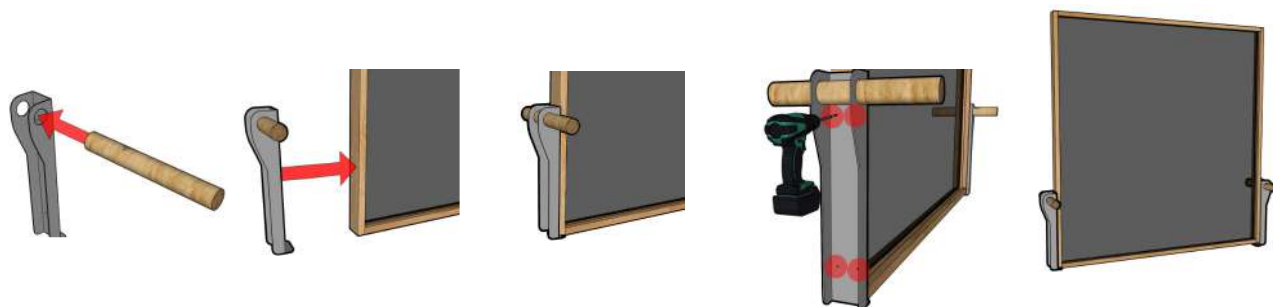


Door & Window Assembly

46 **WARNING:** The front glass panel is heavy



A panel handling lifting device has been provided and can be connected to the bottom of the window to help carry the weight of the glass panel. The lifting kit will include 2 aluminum riggers and 2 dowels 2"(51 mm) in diameter.



Assemble the two riggers and connect them to both sides of the bottom window frame to prepare the window for lifting.

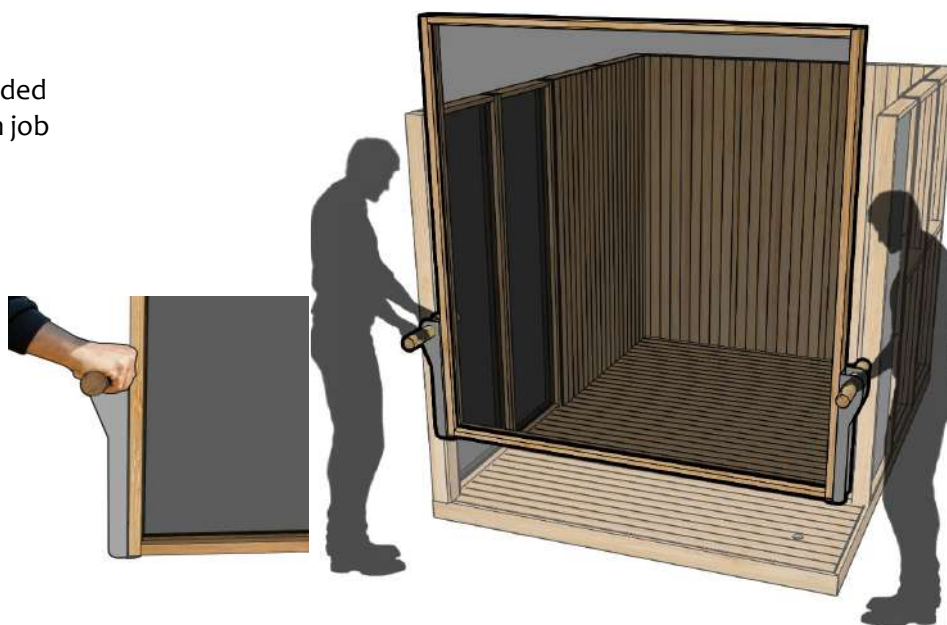


Recommended
two person job

SAUNA REAR



SAUNA FRONT



Place the front glass panel on the sauna. Ensure the pre-drilled holes on the window frame are facing the outside of the sauna frame.



Scan the code for a video of the assembly process:



Door & Window Assembly

47



Recommended
two person job



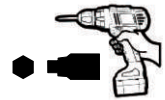
Use a mallet to finesse the front window until it is flush by tapping on the wood of the panel. It is recommended to have someone hold the window from the inside to prevent it from falling.

48



Lag Screws

4X



Secure the front window to the post in the pre-drilled holes.



Door & Window Assembly

49

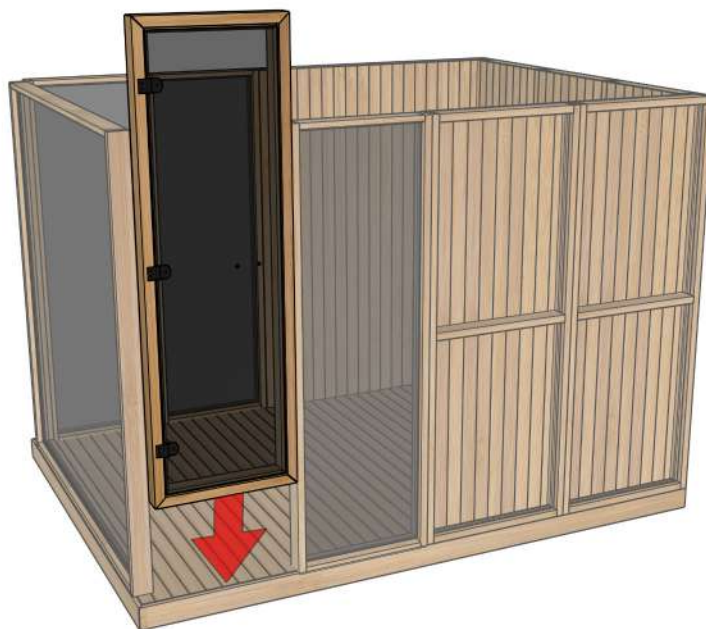


Recommended
two person job

SAUNA REAR



SAUNA FRONT



Place the door panel on the sauna. Ensure the hinges are on the outside of the sauna and it opens in your preferred direction.

50



Lag Screws

4X



Fasten the door with the pre-drilled holes on the glass panel next to the door.

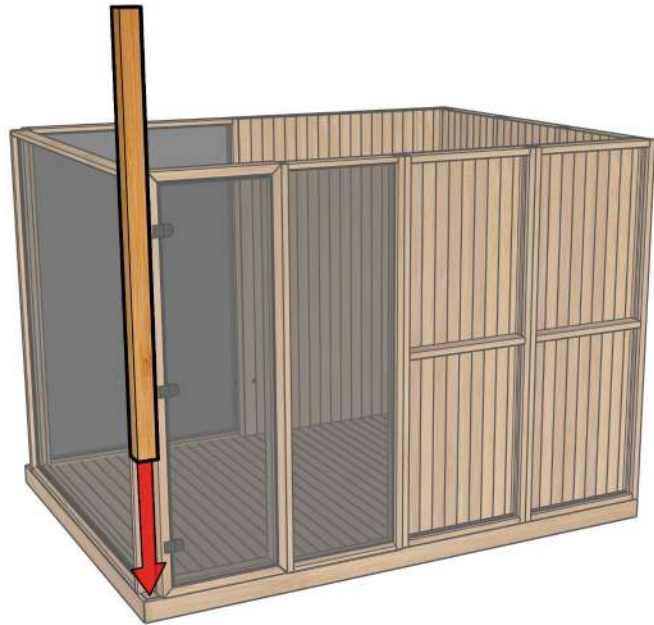


Scan the code for a video of the assembly process:



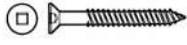
Door & Window Assembly

51



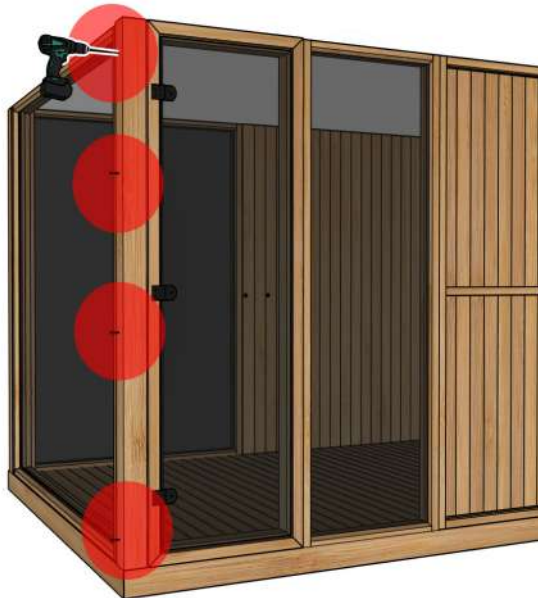
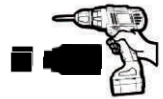
Place a short 4x4 post in the front of the sauna. Ensure it is flush.

52



4X

5" (127 mm) Screw



Fasten the 4x4 to the door panel with screws.



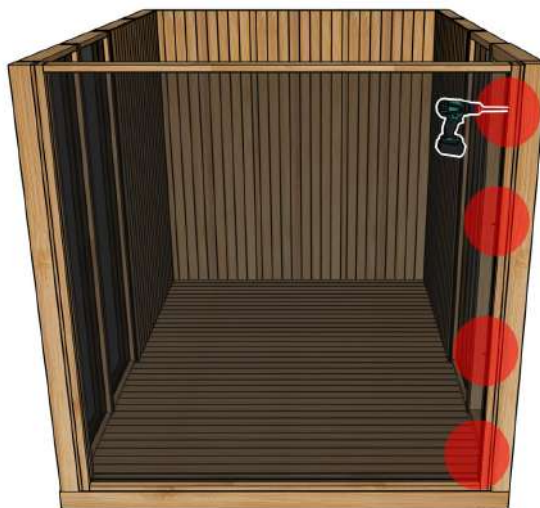
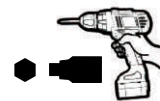
Door & Window Assembly

53



Lag Screws

4X



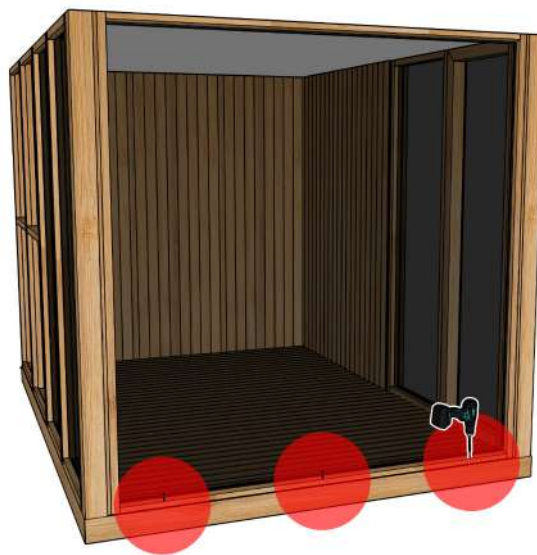
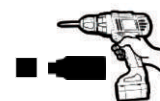
Fasten the front window panel to the 4x4 post with the pre-drilled holes.

54



2.5" (64 mm) Robertson

3X

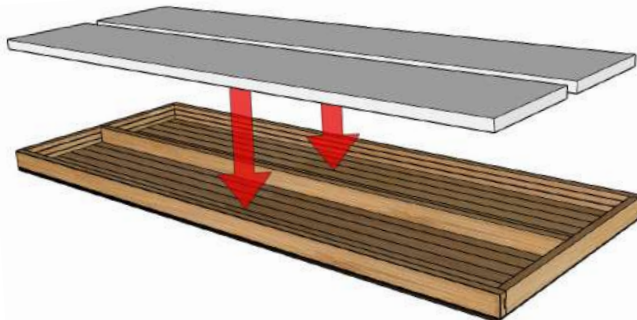


Fasten the front window panel to the 4x4 post with the pre-drilled holes.



Roof Assembly

55

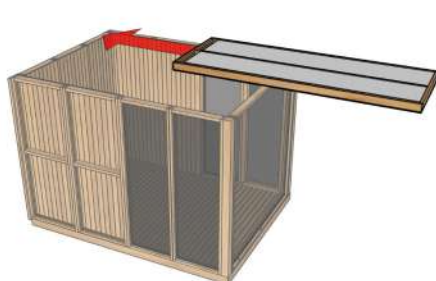


Put the insulation panels inside the roof panels.

56



Recommended
two person job

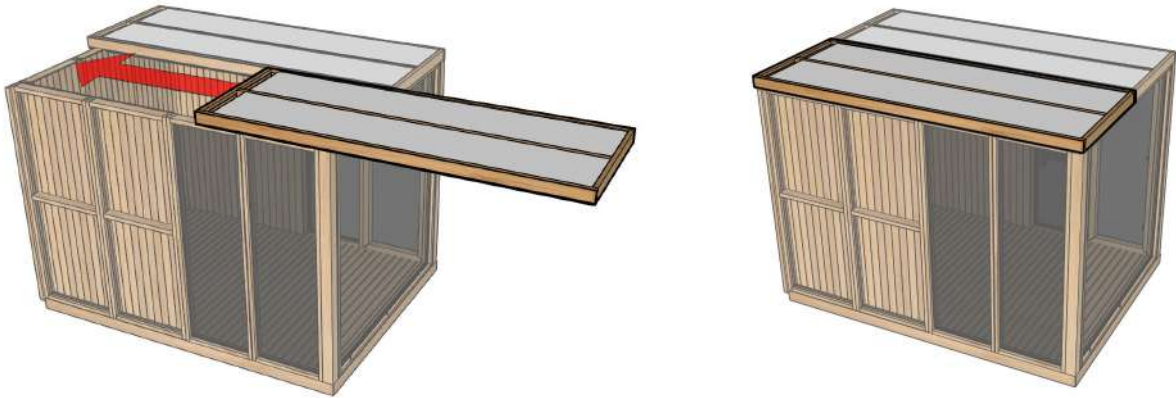


The ends of each roof panel are different in width. Ensure the narrow end is facing the back of the sauna.
Place one of the small roof panels on the roof. Ensure the panel is lined up with one side of the roof.



Roof Assembly

57



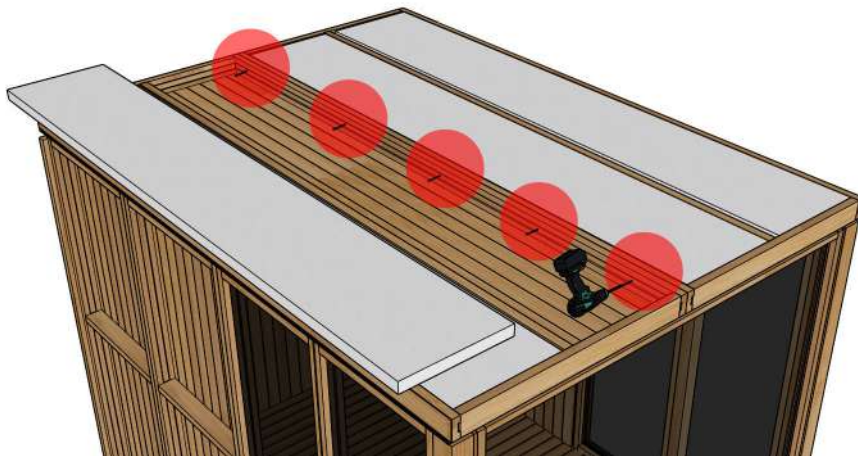
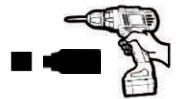
Place the second narrow roof panel on the roof. Ensure the panel is lined up with one side of the roof.

58



5X

2.5" (64 mm) Robertson

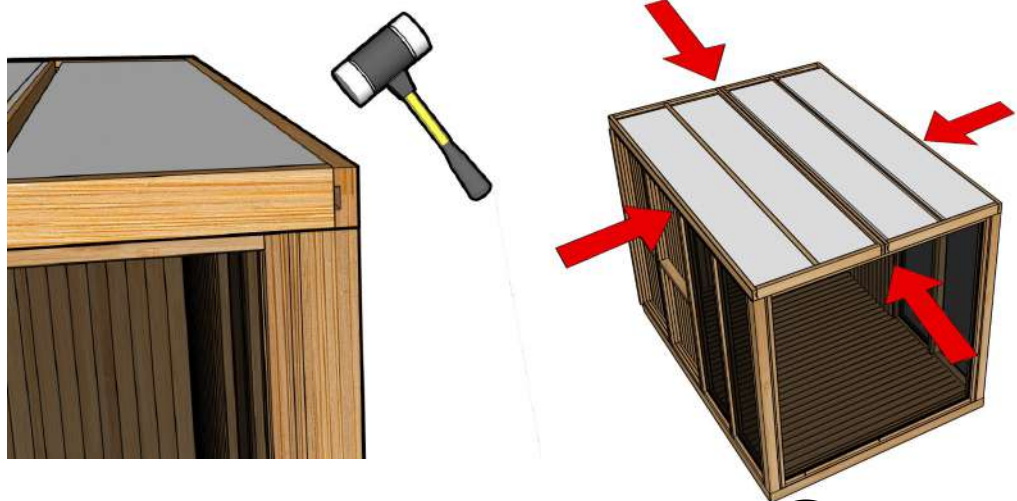


Remove an insulation panel and fasten the narrow panels together. After finished reinsert the insulation panel.



Roof Assembly

59



Roof overhang
at sauna
rear

Roof flush
at sauna
front

Ensure the roof panels are flush with the front and sides of the main sauna frame.

60



5/32" drill bit



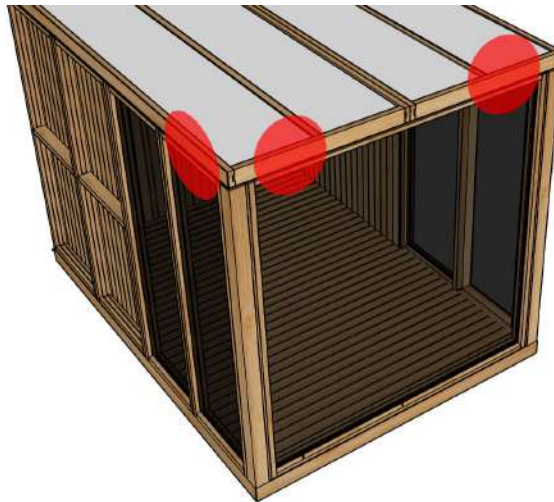
Pre-drill holes from the top of the window/wall frames to fasten the roof to the sauna frame.



Roof Assembly

61

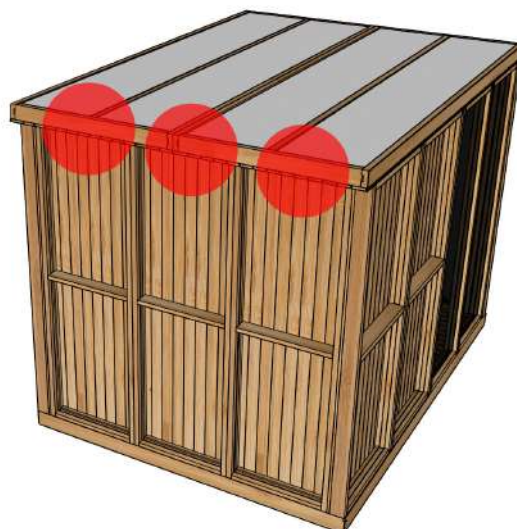
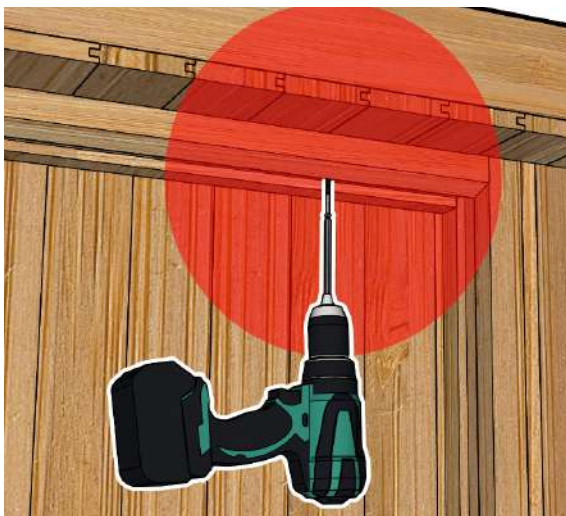
 **3X**
2.5" (64 mm) Robertson



In the pre-drilled areas from **STEP 60** fasten the front window panel and the corner of the side window panel to the roof.

62

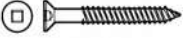
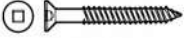
 **3X**
3.5" (89 mm) Robertson

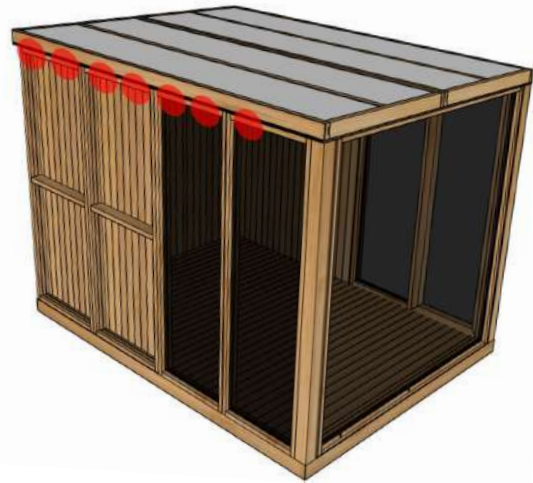
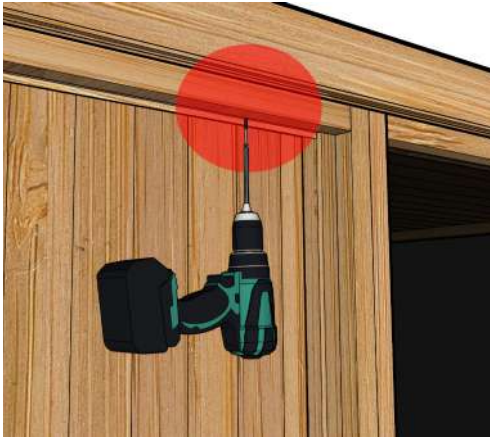
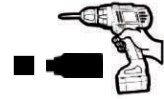


In the pre-drilled areas fasten the rear wall panels to the roof.



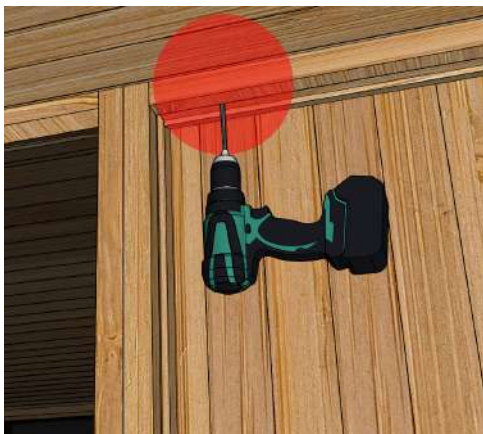
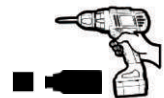
Roof Assembly

- 63**  **3X** 2.5" (64 mm) Robertson  **4X** 3.5" (89 mm) Robertson



In the pre-drilled areas fasten the side walls to the roof with **3.5"** screws and window panels with **2.5"** screws.

- 64**  **2X** 2.5" (64 mm) Robertson  **4X** 3.5" (89 mm) Robertson



In the pre-drilled areas fasten the side walls to the roof with **3.5"** screws and window panels with **2.5"** screws.



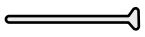
Scan the code for a video of the assembly process:



Roof Installation

65

Finish Nails

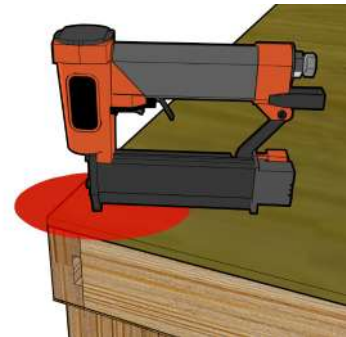
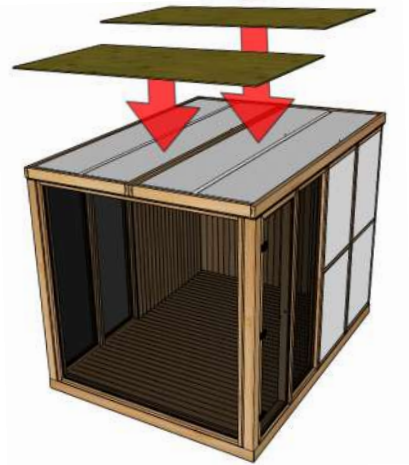


or

1 1/4"
(32 mm)



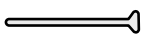
or



Place large plywood panels to cover the roof. Ensure the panels are aligned with the roof joists and fasten in place.

66

Finish Nails

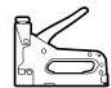


or

1 1/4"
(32 mm)



or



Place small plywood panels to cover the roof. Ensure the panels are aligned with the roof joists and fasten in place.

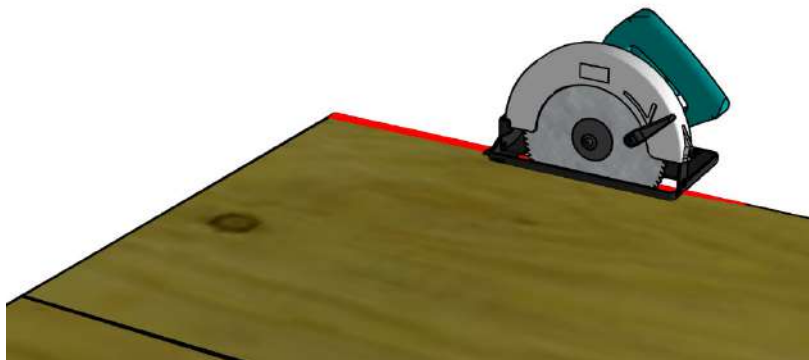


Scan the code for a video of the assembly process:



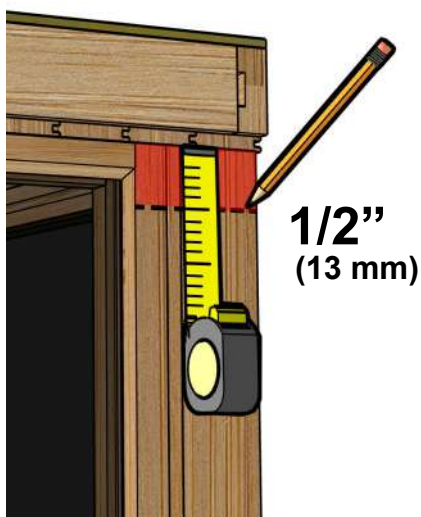
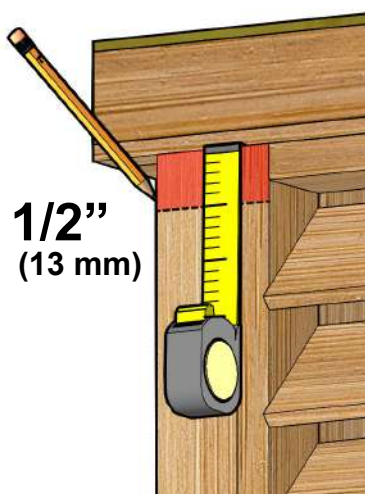
Roof Installation

67



You may need to cut pieces to better align with the joists and trim off any excess.

68

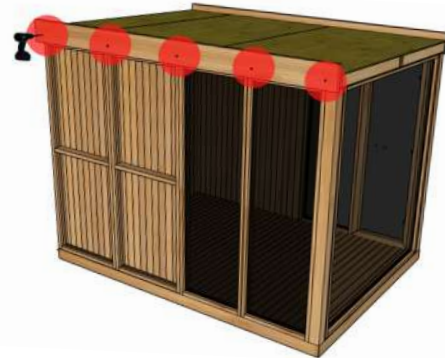
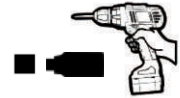


Measure and mark **1/2"** down from bottom of the roof panels on all corners of the sauna.



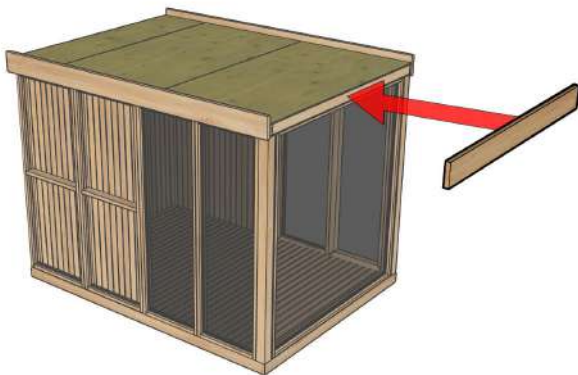
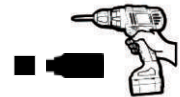
Roof Installation

69  **10X**
2 1/2" (64 mm) Robertson



Place the nosing piece on the side of the sauna. Ensure it is flush at the front and the bottom is aligned from the marks from **STEP 68**. Fasten with screws.
Repeat this for the opposite side of the sauna.

70  **10X**
2 1/2" (64 mm) Robertson

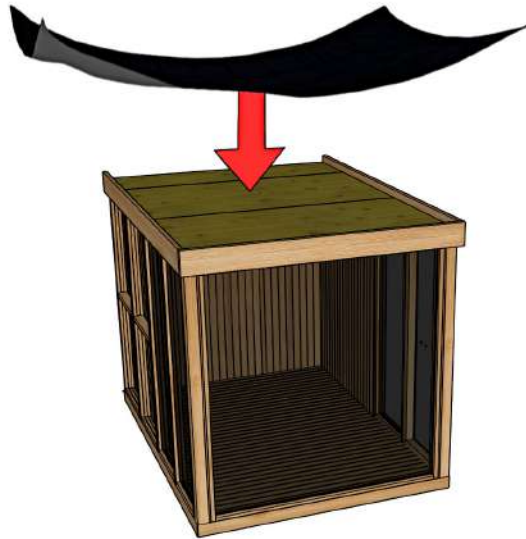


Place the final piece of nosing on the front of the sauna. Ensure it is flush with the side and the bottom is aligned with the marks from **STEP 68**. Fasten with screws.



Roof Installation

71



Place the EPDM membrane on the roof and spread it over the roof area. Ensure there is at least a **12" (305 mm)** of material that hangs over each side of the roof.

72

1 1/4"
(32 mm)



Staple the membrane to the bottom of the nosing. Do this for the whole perimeter of the nosing trim. On the rear of the sauna staple the membrane to the bottom of the roof panels. If necessary tuck and fold any excess membrane material over the corners and staple. Ensure the membrane is tucked in tight.



Scan the code for a video of the assembly process:



Roof Installation

73

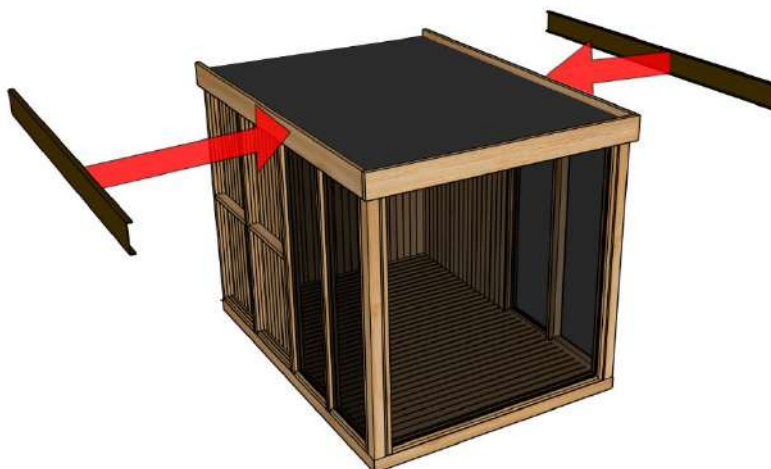


Cut off any excess EPDM membrane along the bottom edge of the nosing and the back of the roof.



If you are assembling a **steel** siding sauna follow **STEPS 74-77**
If you are assembling a **wood villa** siding sauna follow **STEPS 78-81** on **Page 44**

74



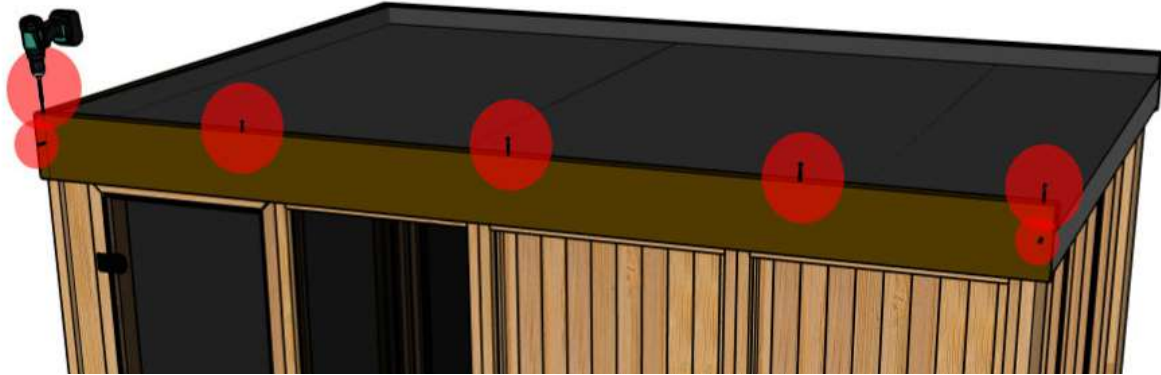
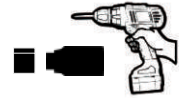
Place the metal trim over the side nosing. Repeat for the opposite side.



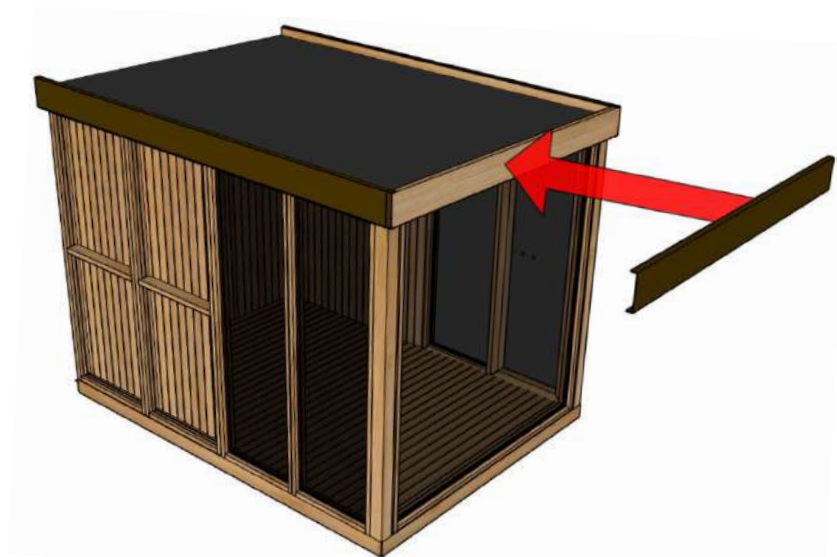
Roof Trim

75

 **7X/SIDE**
3/4" (19 mm) Robertson



76



Place the shorter metal trim piece over the front nosing. Ensure the trim overlaps the side trim and covers the nosing ends. Secure with screws.



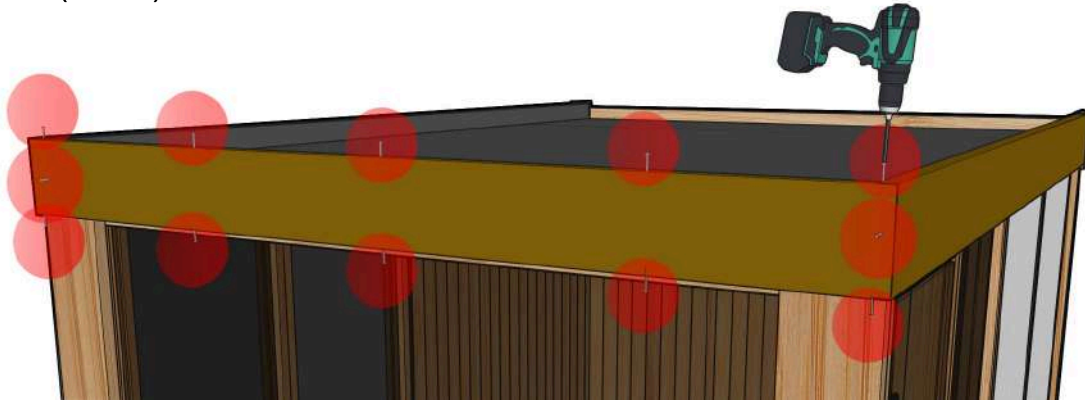
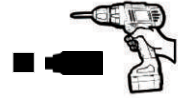
Scan the code for a video of the assembly process:



Roof Trim

77

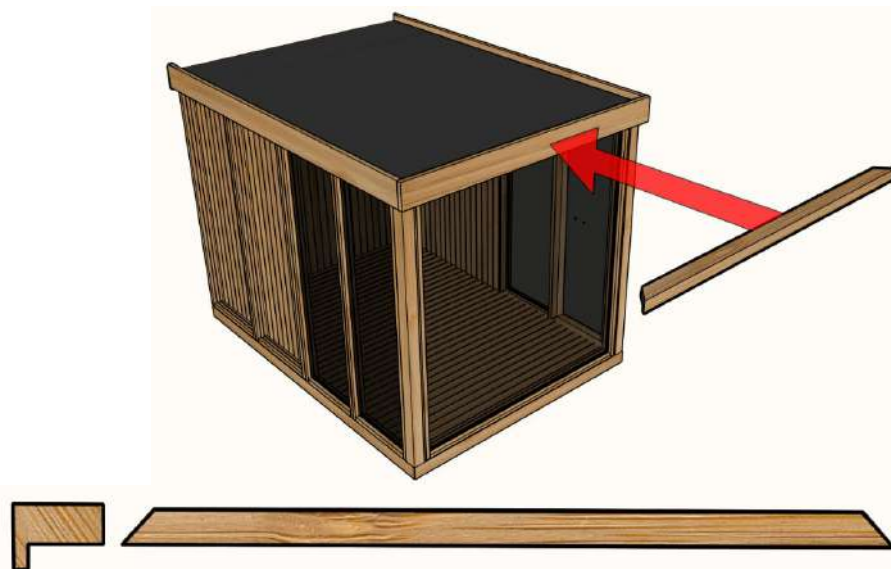
 **12X**
3/4" (19 mm) Robertson



Fasten the front trim with screws.

Please continue to **STEP 82** on **page 46**

78

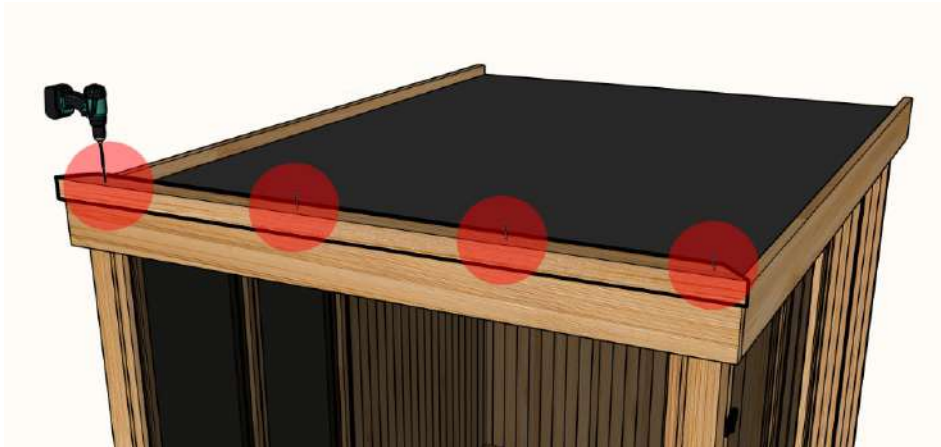


Select the roof trim piece with two angled ends. Place the wood trim over the front nosing with the lip of the trim piece facing towards the outside of the sauna.



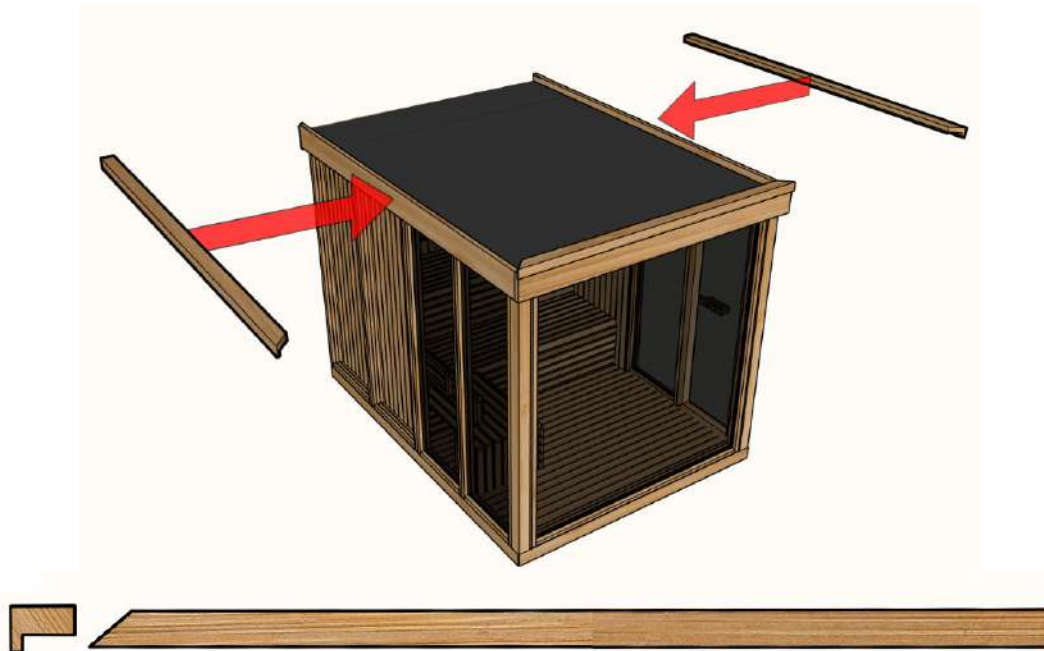
Roof Trim

79  **4X**
2" (51 mm) Robertson



Fasten the front trim with screws.

80



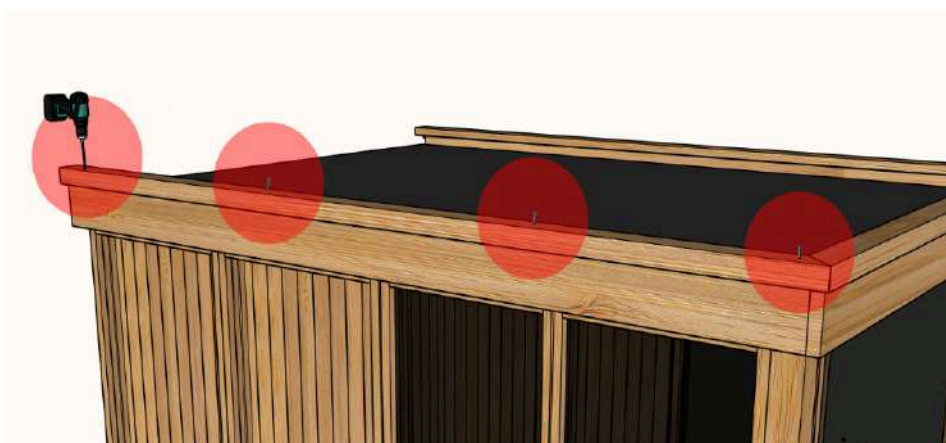
Select the roof trim piece with one angled end. Place the wood trim over the side nosing with the lip of the trim piece facing towards the outside of the sauna.



Insulation Installation

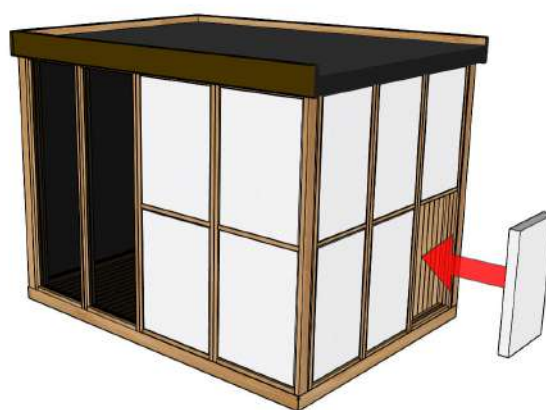
81

 **8X**
2" (51 mm) Robertson



Fasten both side trim pieces with screws.

82

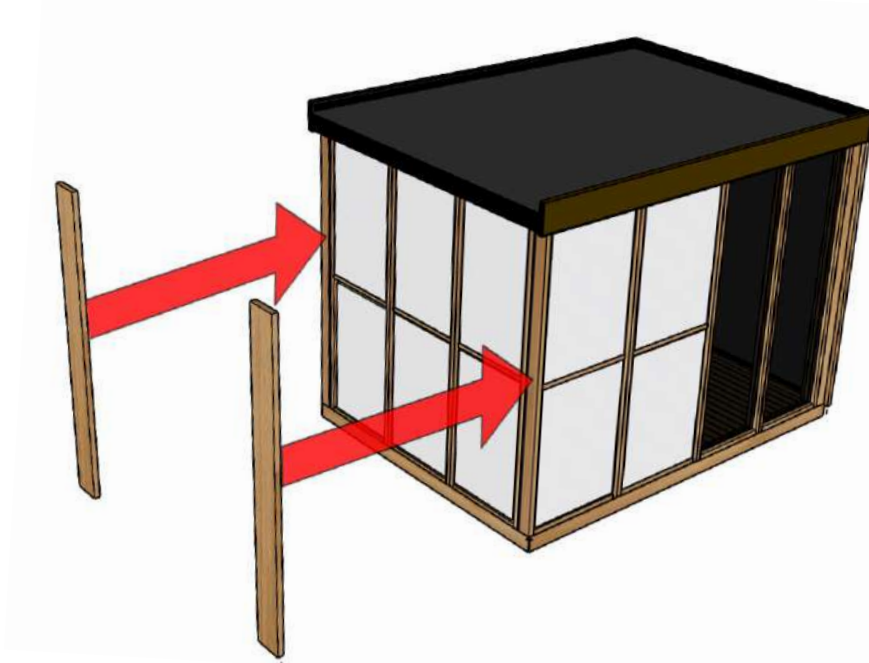


Place the insulation blocks into the wall openings on all three walls.

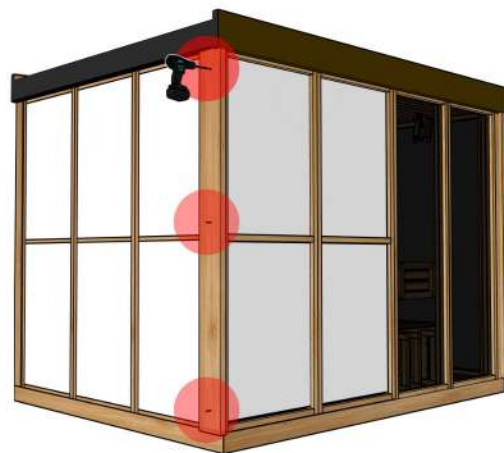
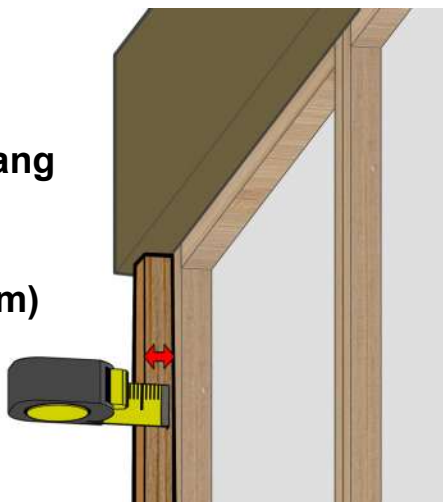
Corner Nosing Installation

83

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



Overhang
1"
(25 mm)



Place the 2 corner nosing boards (**2x8**) on the walls (See image above). Ensure that each board is spaced tight to the roof trim and overhangs on each outside corner by **1" (25 mm)**. Fasten each board with screws.

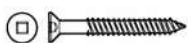
Steel Siding Installation



If you are assembling a **steel** siding sauna follow **STEPS 84-123**

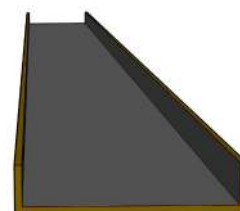
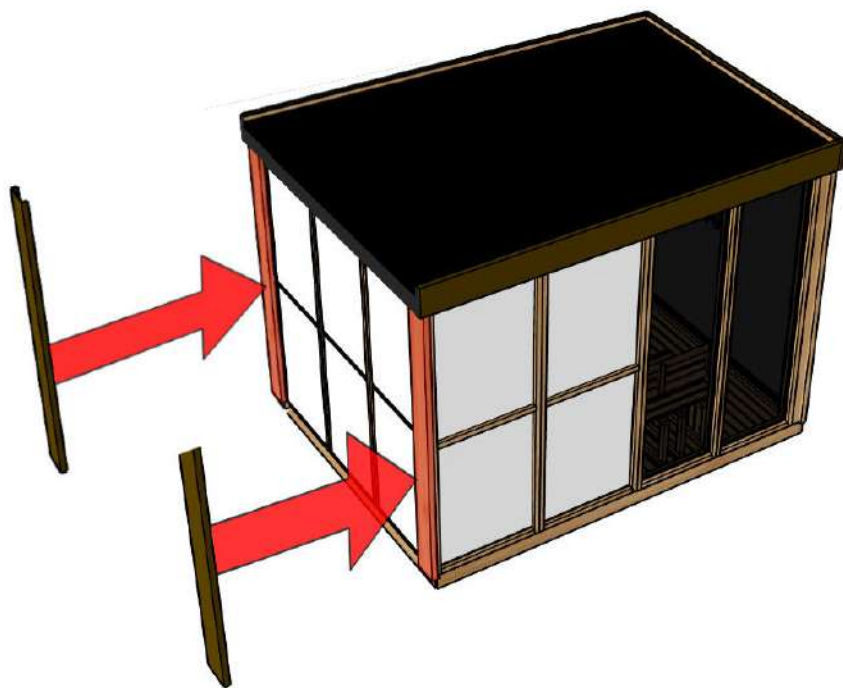
If you are assembling a **wood villa** siding sauna follow **STEPS 124-154** on page 67

84

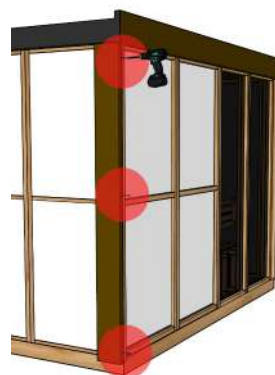


6X

3/4" (19 mm) Robertson



**C-Channel
Nosing Cover**



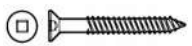
3X For the outside corner of each back post

Place the 2 steel nosing covers over the nosing boards on the walls. Fasten with screws.



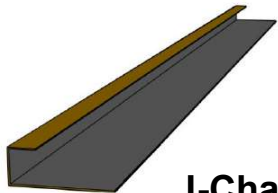
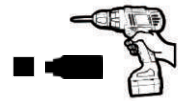
Steel Siding Installation

85

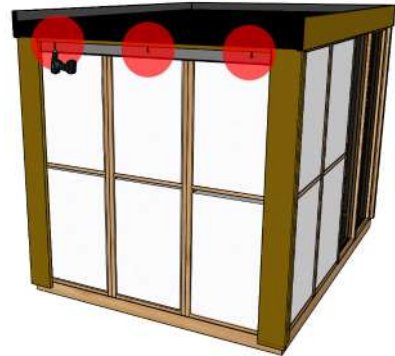
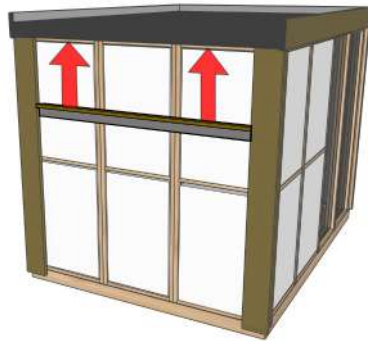


3X

3/4" (19 mm) Robertson

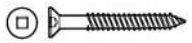


J-Channel



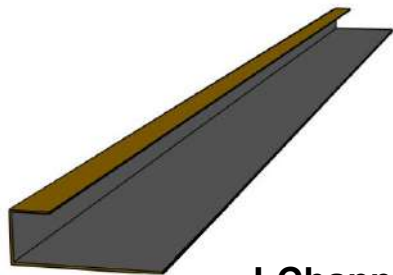
Place a piece of J-Channel under the roof line at the back of the sauna.
Fasten the J-Channel with screws.

86

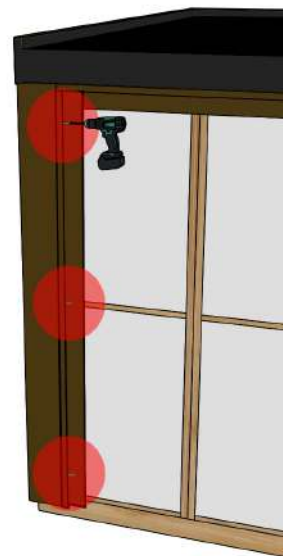
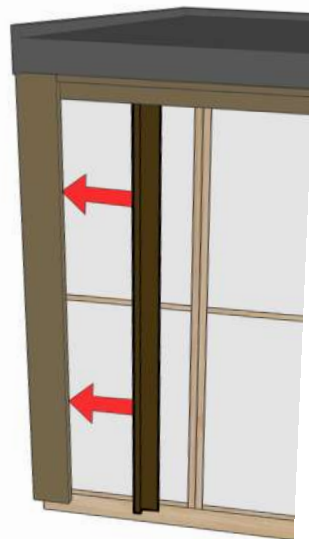


3X

3/4" (19 mm) Robertson



J-Channel

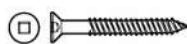


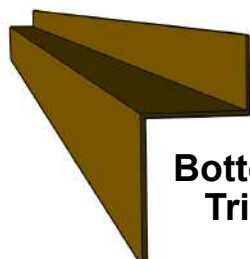
Position and fasten the J-Channel with screws.
Repeat **STEP 86** for the opposite side of the rear wall.



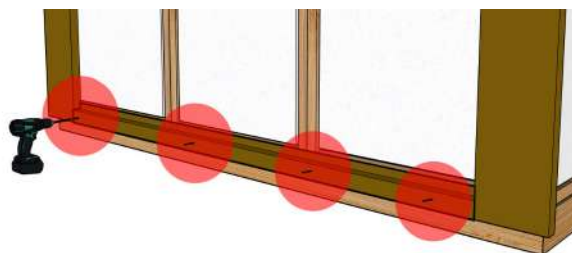
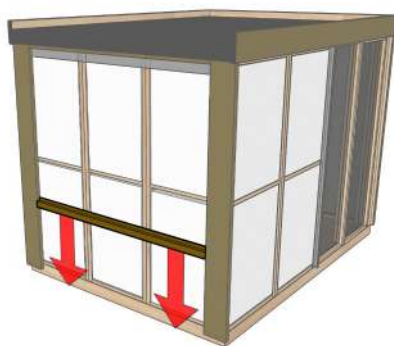
Steel Siding Installation

87

 **4X**
3/4" (19 mm) Robertson

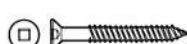


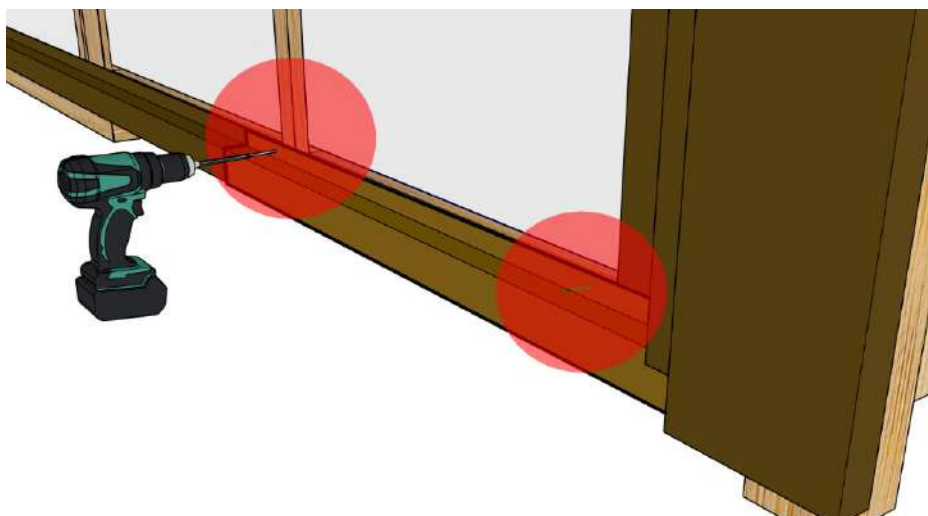
**Bottom
Trim**



Place the bottom trim at the bottom of the wall.
Ensure it is set to the correct height. Fasten with screws.

88

 **2X**
3/4" (19 mm) Robertson



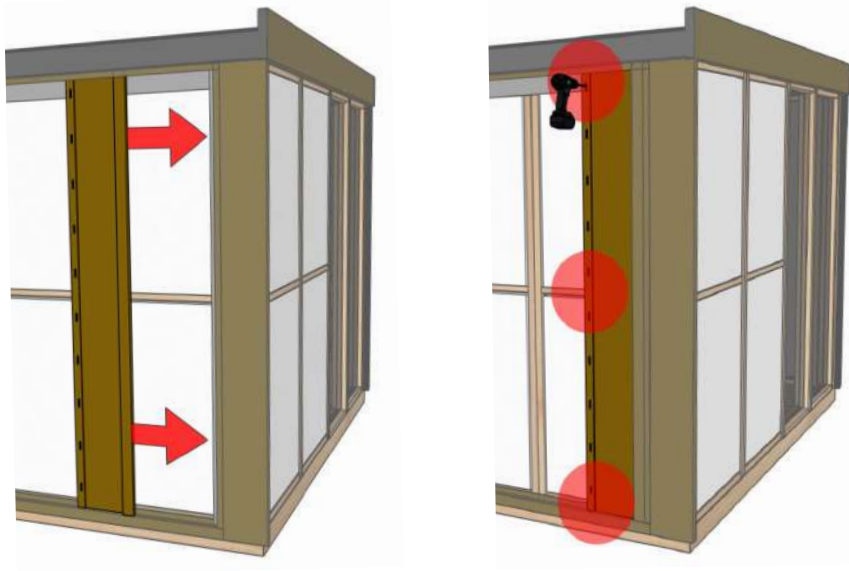
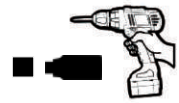
Fasten the bottom trim with screws.



Steel Siding Installation

89

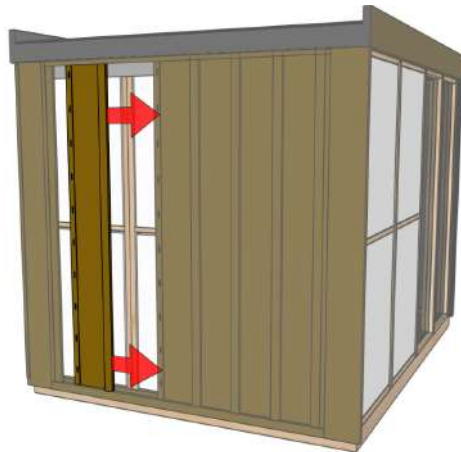
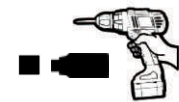
 **3X**
3/4" (19 mm) Robertson



Place a siding piece into the J-channel. Fasten with screws.

90

 **3X** Each siding panel
3/4" (19 mm) Robertson

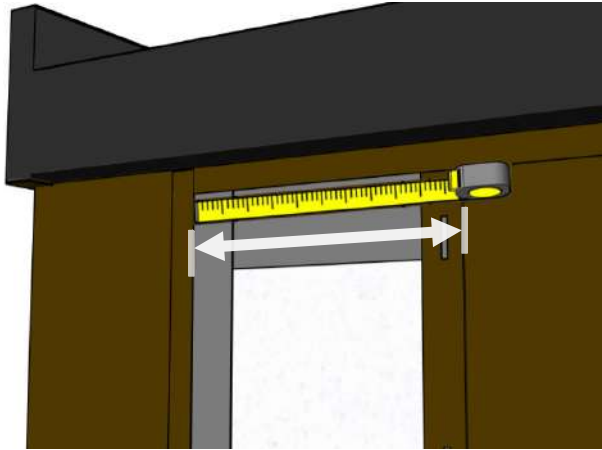


Continue adding and sliding panels in place to cover the wall until you reach the last full panel. Fasten with three screws for each siding panel.



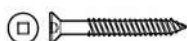
Steel Siding Installation

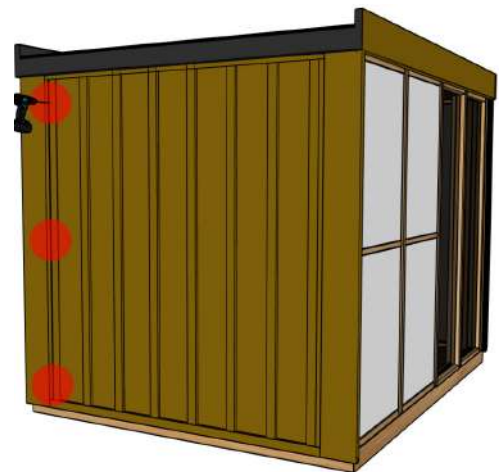
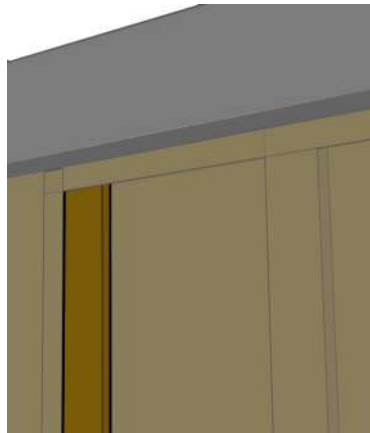
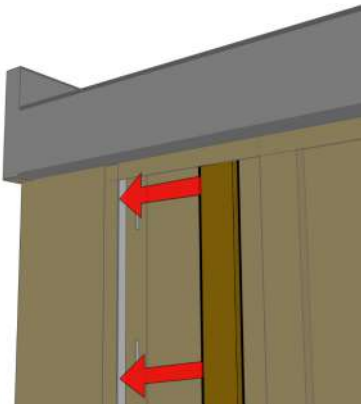
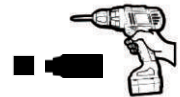
91



Measure the distance of the remaining opening and cut a panel to fit.

92

 **3X**
3/4" (19 mm) Robertson



Place the narrow finisher panel and secure with screws.



Steel Siding Installation

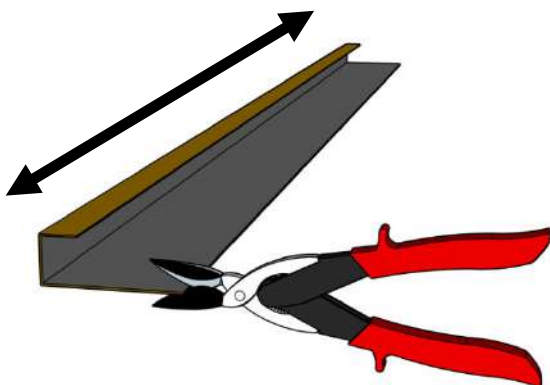
93



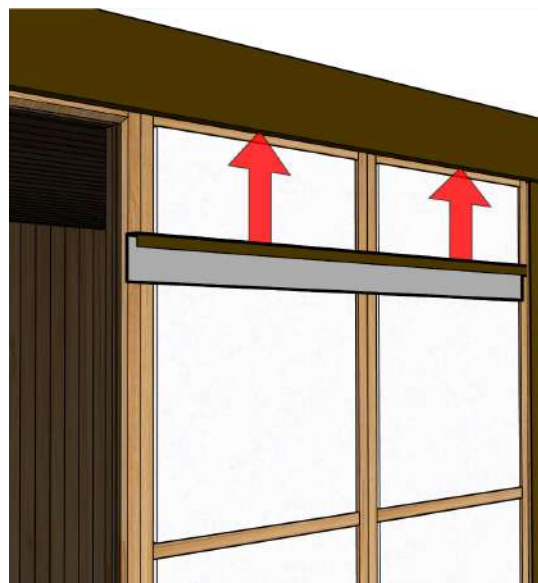
Door Side

Measure the distance from the wall to the glass panel.

94



J-Channel



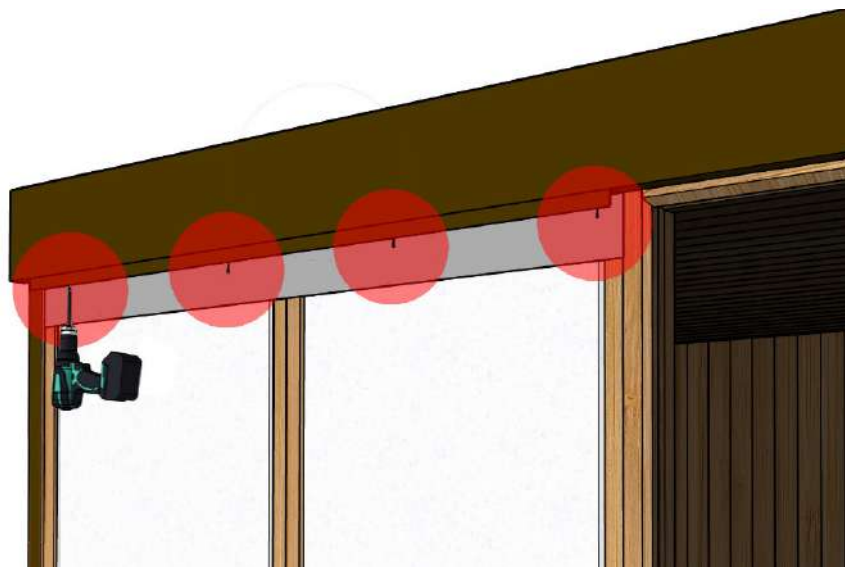
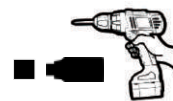
Measure & cut a piece of J-Channel to fit. Position the J-Channel to the ceiling and rear of the wall.



Steel Siding Installation

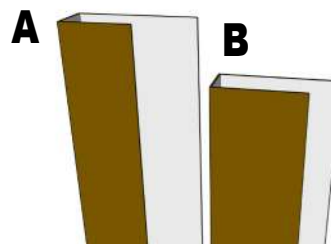
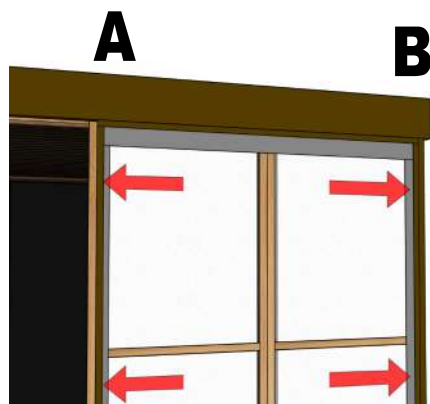
95

 **4X**
3/4" (19 mm) Robertson



Fasten the J-Channel with screws.

96

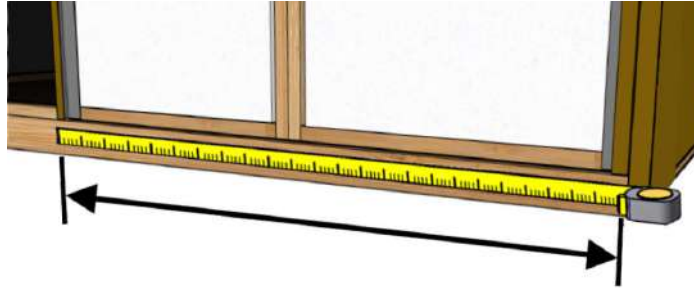


There are two sizes of J-Channel that will be used. The longer piece will be placed on the side closest to the window panel. The shorter piece will be placed on the side closest to the back wall.



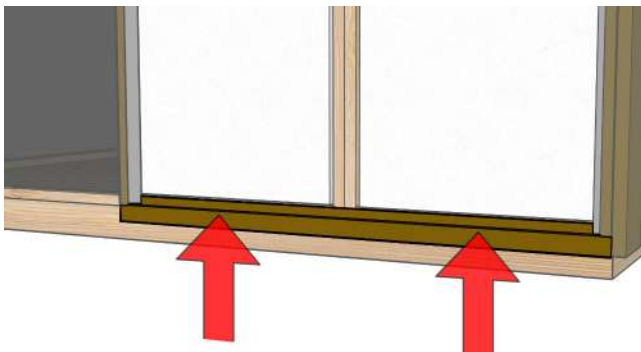
Steel Siding Installation

97

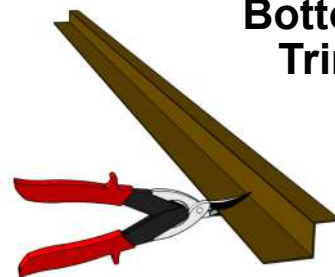


Measure the distance between the two J-Channels

98



**Bottom
Trim**



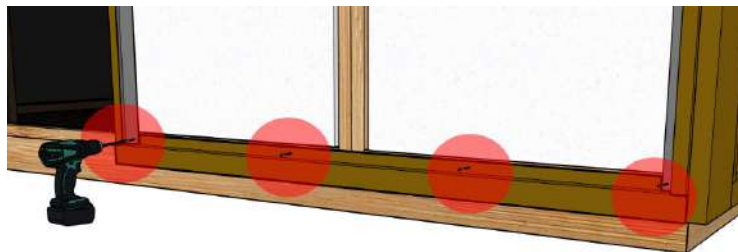
Cut and position a bottom trim piece for the bottom area between the two side J-Channels. Ensure it is set to the correct height.

99



4X

3/4" (19 mm) Robertson

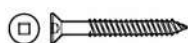


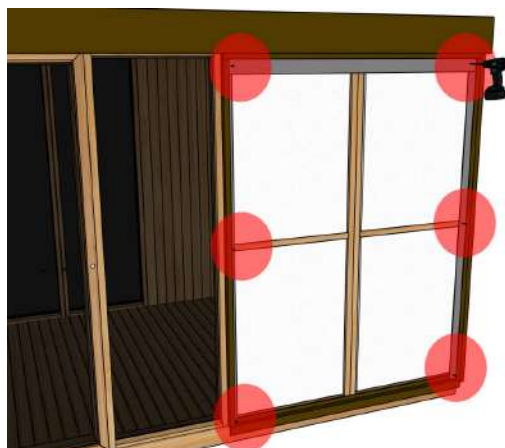
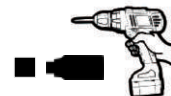
Fasten the bottom piece for the area between the two side J-Channels.



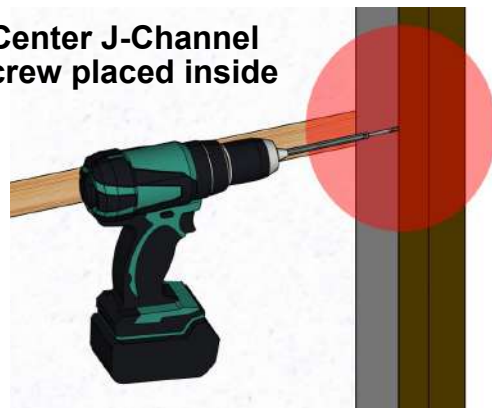
Steel Siding Installation

100

 **3X /side**
3/4" (19 mm) Robertson



Center J-Channel
screw placed inside



Fasten each side with 3 screws. The center of each J-Channel will receive 2 screws.
One screw will be placed on the inside of the J-Channel.

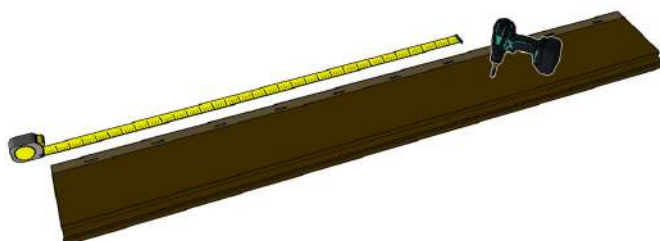


Please check with your local electrician/technician for any wiring setup or routing to be done for your sauna build.

101



 1/2" drill bit
(13 mm)



Measure the height to where your heater control panel wire will poke out and drill an opening in the center of a piece of siding.



Scan the code for a video of the assembly process:



Steel Siding Installation

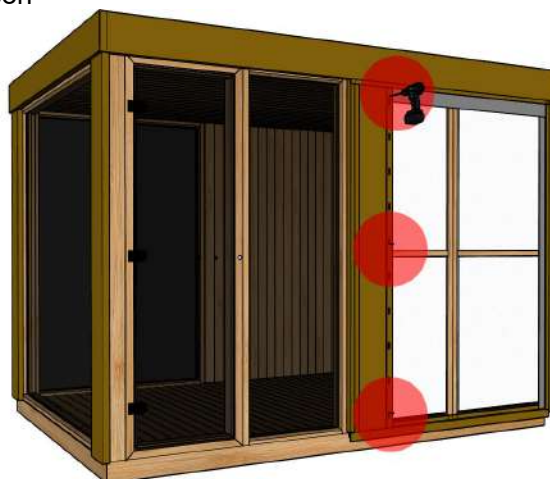
102



Pull the wire through the siding piece. Position the siding piece inside the J-Channel from top to bottom and slide into place.

103

 **3X**
3/4" (19 mm) Robertson



Fasten the panel with screws.

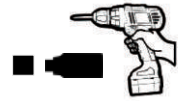
Scan the code for a video of the assembly process:



Steel Siding Installation

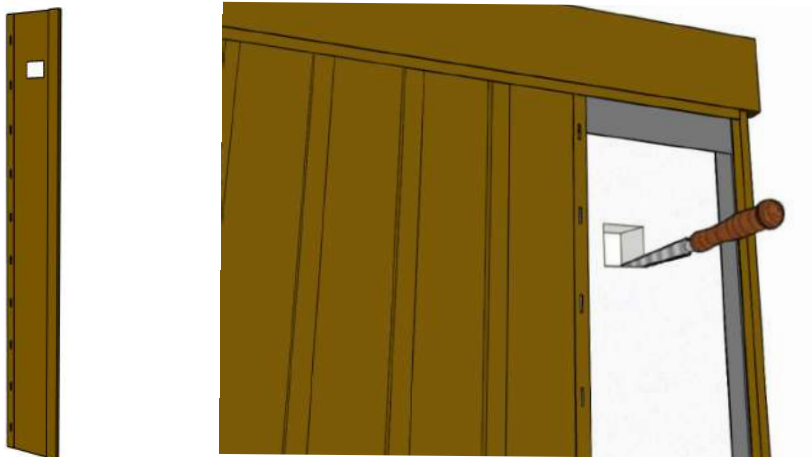
104

 **3X** Each siding panel
3/4" (19 mm) Robertson



Continue adding and sliding panels in place to cover the wall until you reach the last full panel. Fasten each siding panel with three screws.

105



When you reach the last full panel, insert the panel with a vent hole cut into the top. Position the panel with the vent hole and use it as a template to mark the hole in the insulation underneath. Cut a hole in the insulation below. Make the hole slightly larger than the mark.



Steel Siding Installation

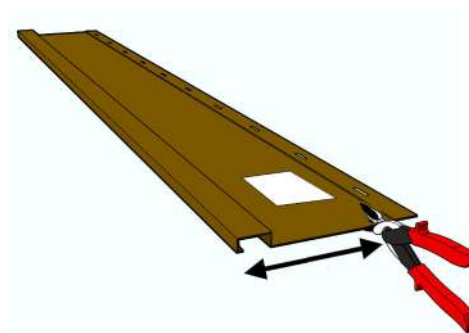
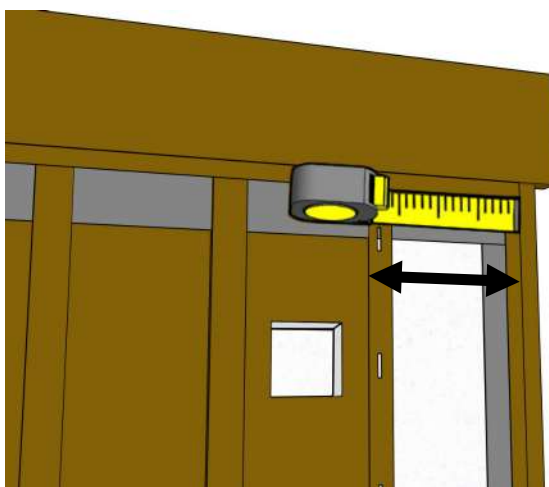
106

 **3X**
3/4" (19 mm) Robertson



Fasten the panel with screws.

107



Measure the distance of the remaining opening and cut a panel to fit.



Steel Siding Installation

108



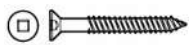
3X

3/4" (19 mm) Robertson



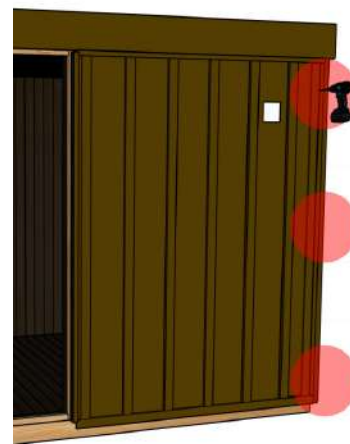
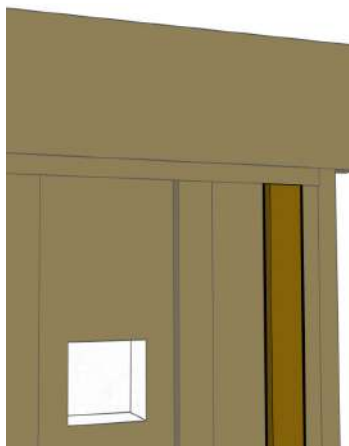
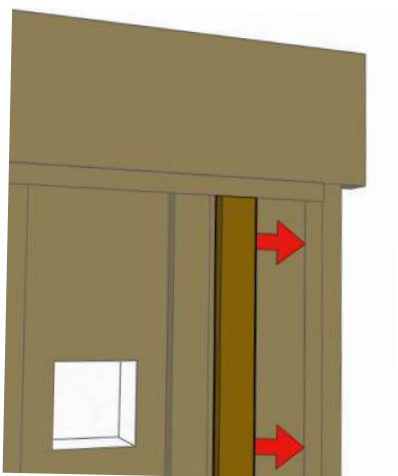
Fasten the panel with screws.

109



3X

3/4" (19 mm) Robertson



Place the narrow finisher panel and secure with screws.

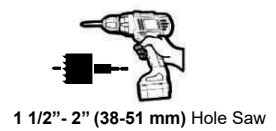
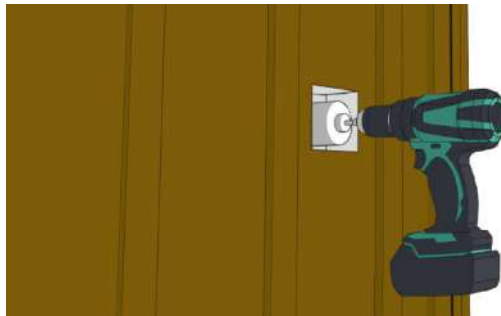


Scan the code for a video of the assembly process:



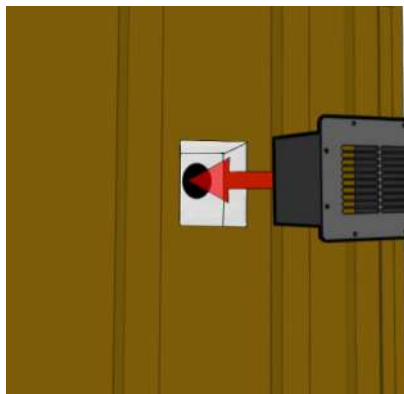
Vent Installation

110



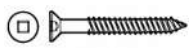
Use a hole saw to cut out the center of the vent hole.

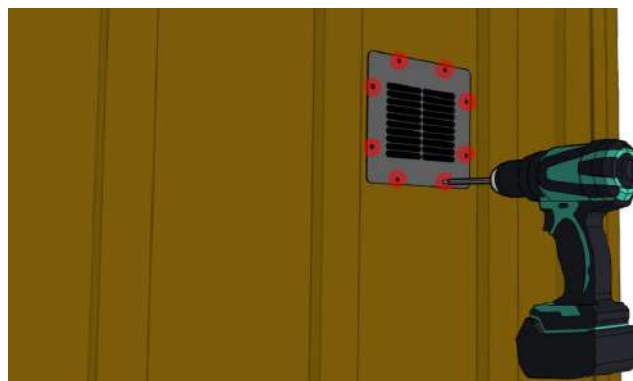
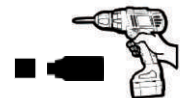
111



Add the steel vent cover.

112

 **8X**
3/4" (19 mm) Robertson



Fasten the steel vent cover with screws.



Vent Installation

113

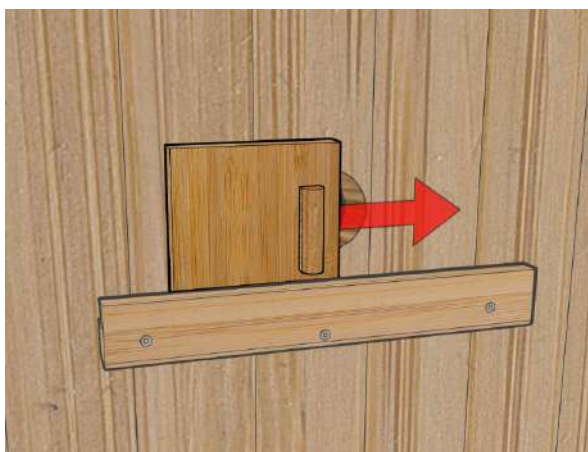
 **3X**
3/4" (19 mm) Robertson



On the other side of the vent wall place the bottom vent support below the hole.
Ensure it is level and fasten with screws .

114

 **3X**
3/4" (19 mm) Robertson

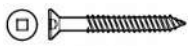


Position the vent cover on the slider of the bottom vent support. Place and fasten the top vent support above the slider. Ensure it is level and aligned with the bottom vent support. Afterwards check to ensure the slider works smoothly. Adjust the top vent support if necessary.



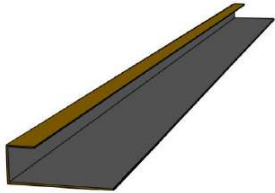
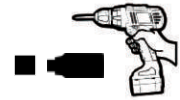
Steel Siding Installation

115

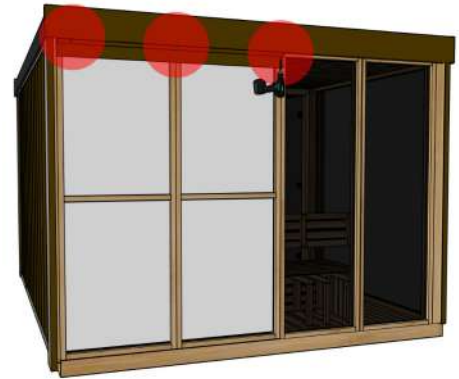
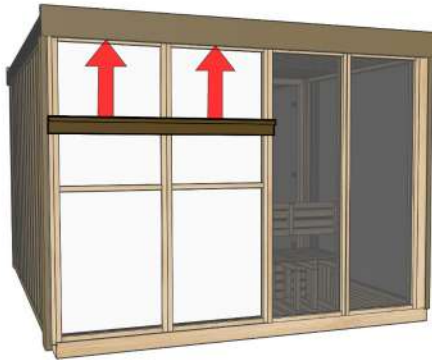


3X

3/4" (19 mm) Robertson



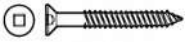
J-Channel



Window Side

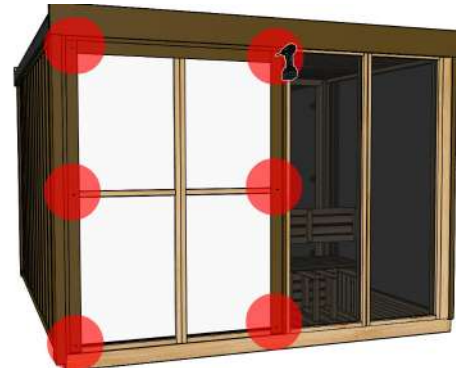
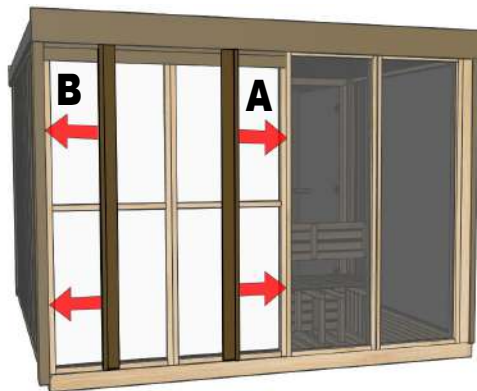
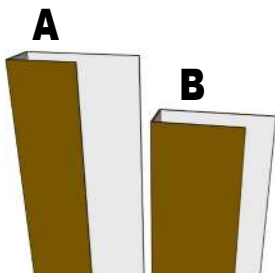
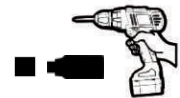
Place a piece of J-Channel under the roof line. Fasten the J-Channel with screws.

116



6X

3/4" (19 mm) Robertson



There are two sizes of J-Channel that will be used. The longer piece will be placed on the side closest to the window. The shorter piece will be placed on the side closest to the back wall. Fasten each piece with 3 screws.

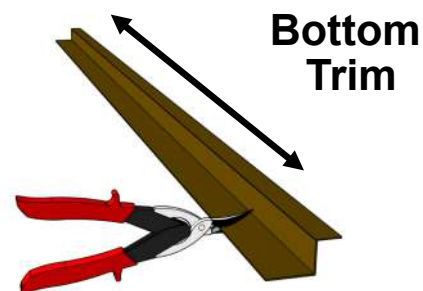
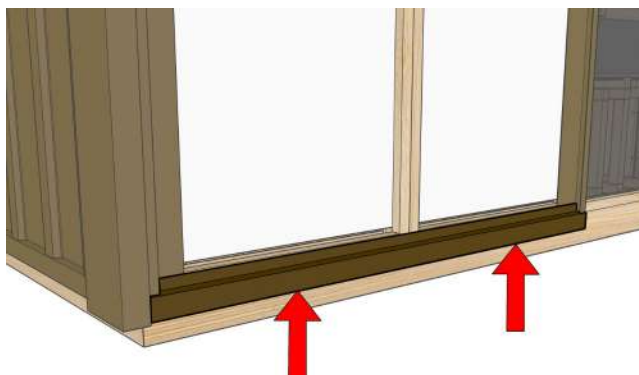


Scan the code for a video of the assembly process:



Steel Siding Installation

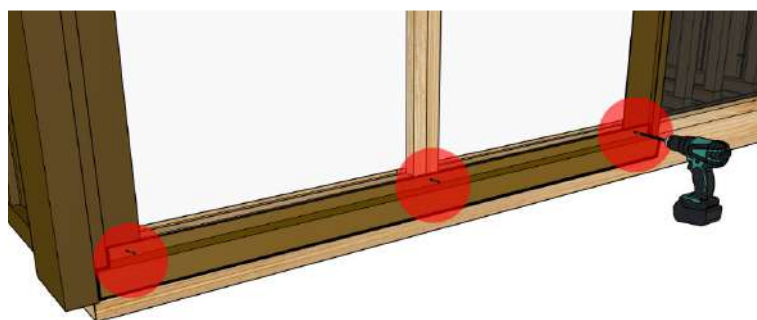
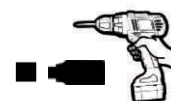
117



Cut and position a bottom trim piece for the bottom area between the two side J-Channels. Ensure it is set to the correct height.

118

 **3X**
3/4" (19 mm) Robertson



Fasten the bottom piece for the area between the two side J-Channels.

119



Follow **STEPS 89-91** as a guideline to fill in the siding pieces. Continue adding and fastening panels in place to cover the wall until you reach the last full panel.

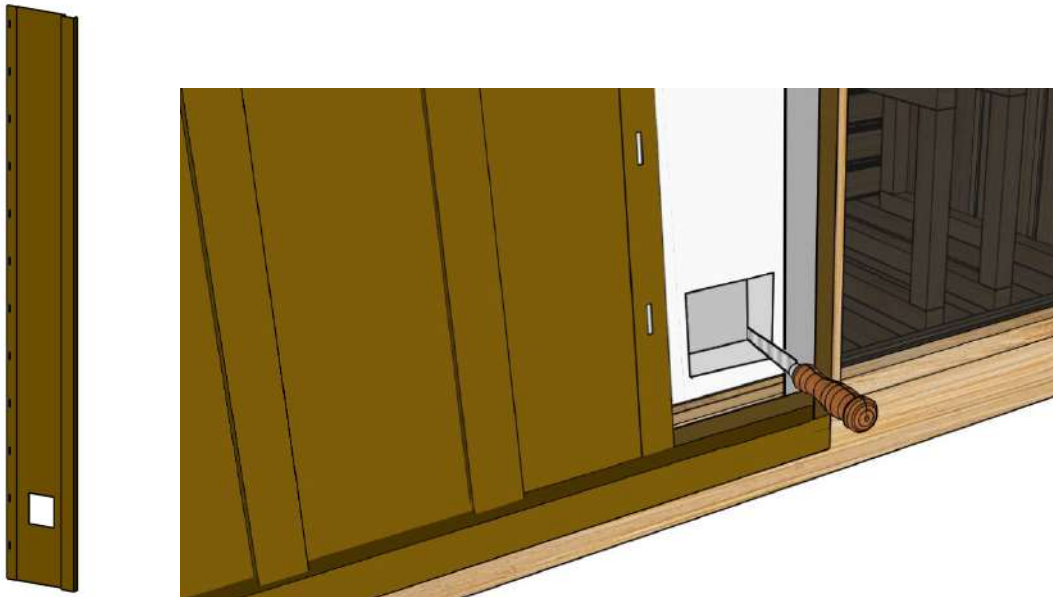


Scan the code for a video of the assembly process:



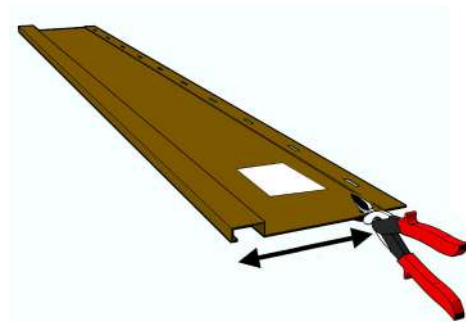
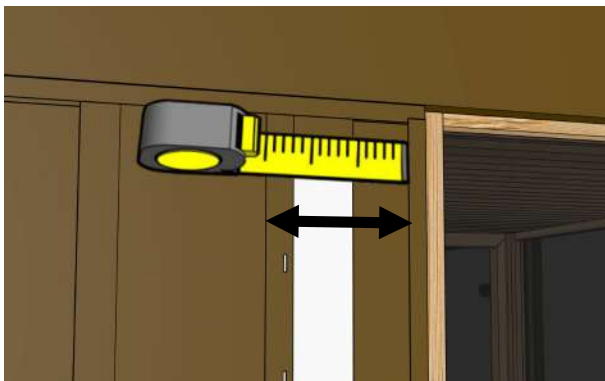
Steel Siding Installation

120



When you reach the last full panel, insert the panel with the bottom vent hole. Position the panel with the vent hole and use it as a template to mark the hole in the insulation underneath. Cut a hole in the insulation below. Make the hole slightly larger than the mark.

121



If necessary measure the distance of the remaining opening and cut the vented hole panel to fit.



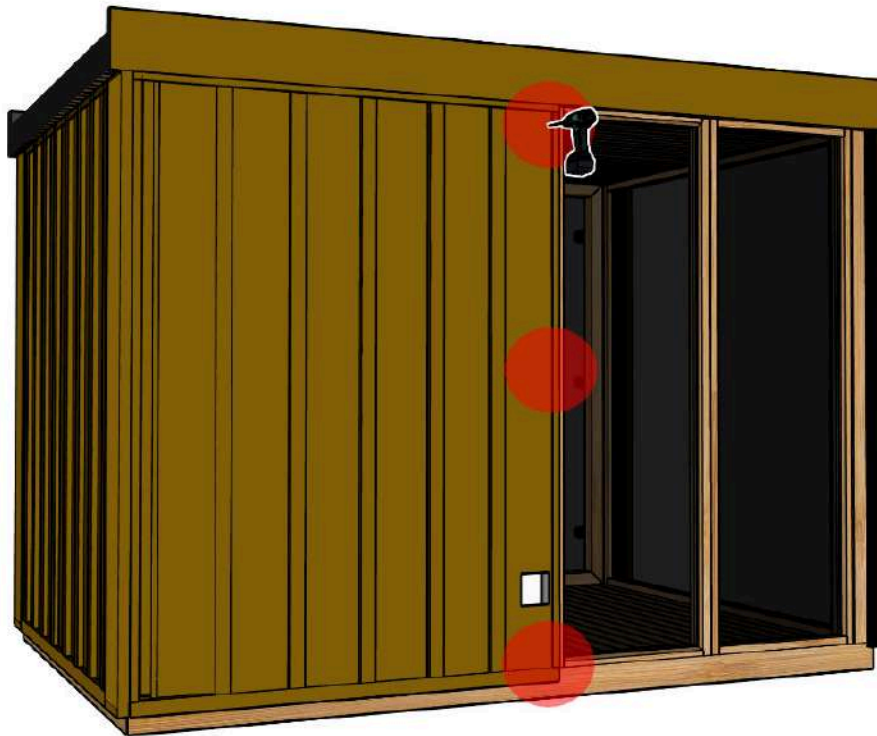
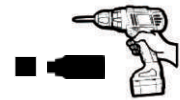
Steel Siding Installation

122



3X

3/4" (19 mm) Robertson



Place and fasten the panel with screws.

123

Follow **STEPS 110-112** as a guideline to install the vent cover on the last siding panel.



Please continue on to **STEP 150** on **page 79**

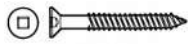


Scan the code for a video of the assembly process:



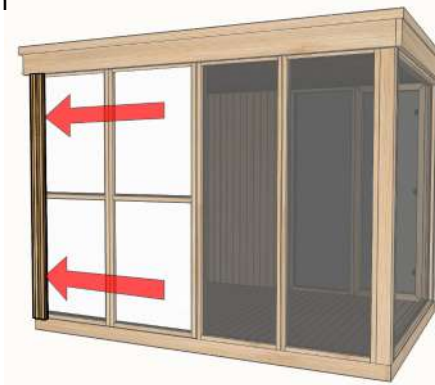
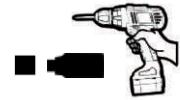
Villa Siding Installation

124



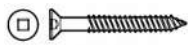
3X

1 1/2" (38 mm) Robertson



Begin placing the wooden panels on the window side of the sauna. Ensure that you are using the longer panels for the side walls. The shorter panels will be used for the back wall of the sauna.

125

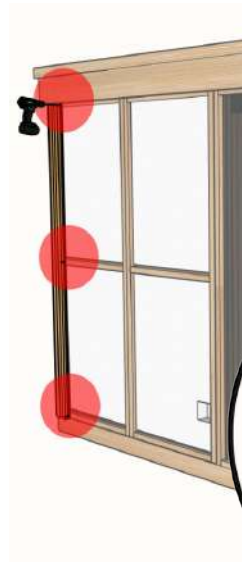
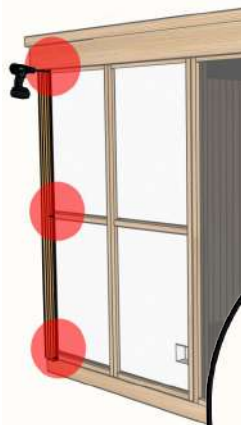
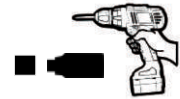


3X

1 1/2" (38 mm) Robertson



1/8" (3 mm) Drill Bit



Pre-drill three holes in the tongue of the board. Fasten screws into studs with the pre-drilled holes.



Scan the code for a video of the assembly process:



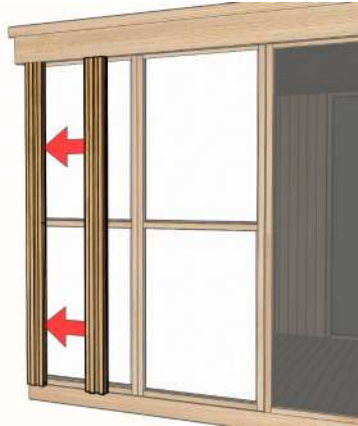
Villa Siding Installation

126

 **3X**/panel
1 1/2" (38 mm) Robertson

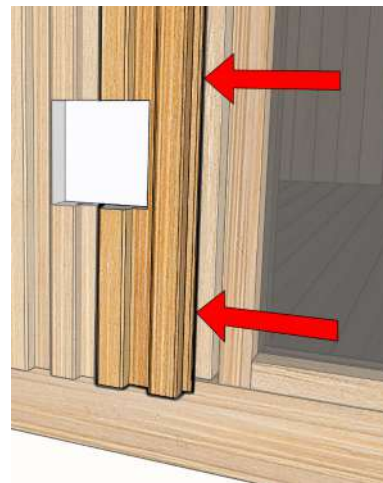
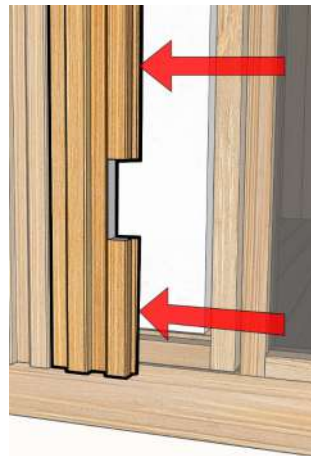


1/8" (3 mm) Drill Bit



Continue placing, pre-drilling & fastening panels in place to cover the wall until you reach the last full panel. Use a mallet to keep each panel tight to the next. Pre-drill and fasten each siding panel with three screws .

127



Locate the two panels with the cutouts. Slid them in place (See above image.)



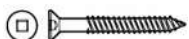
Villa Siding Installation

128



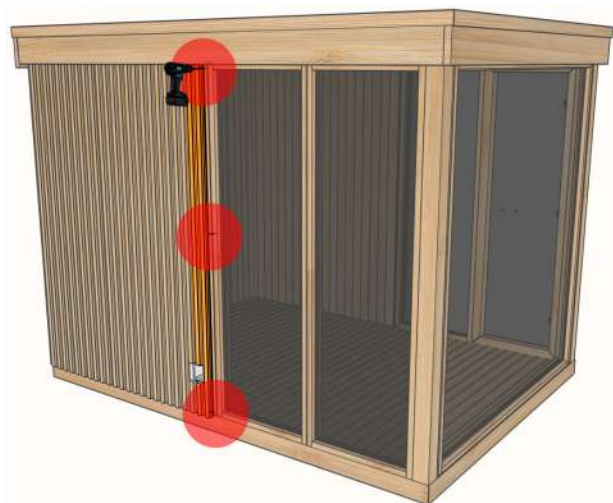
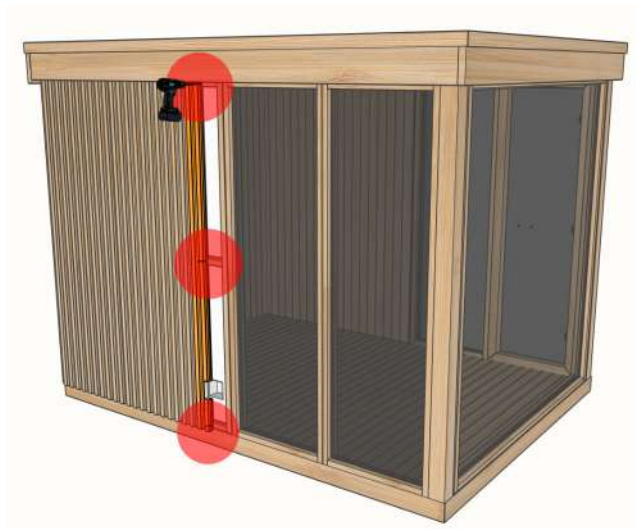
Using the two wooden panels as a template mark out a vent hole on the insulation beneath the panel. Remove the two wood panels and cut out a square vent hole in the insulation. Make the hole slightly larger than the mark.

129

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



 1/8" (3 mm) Drill Bit

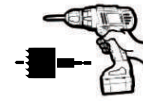


Pre-drill & fasten both panels. Use a mallet to keep each panel tight to the next.



Villa Siding Installation

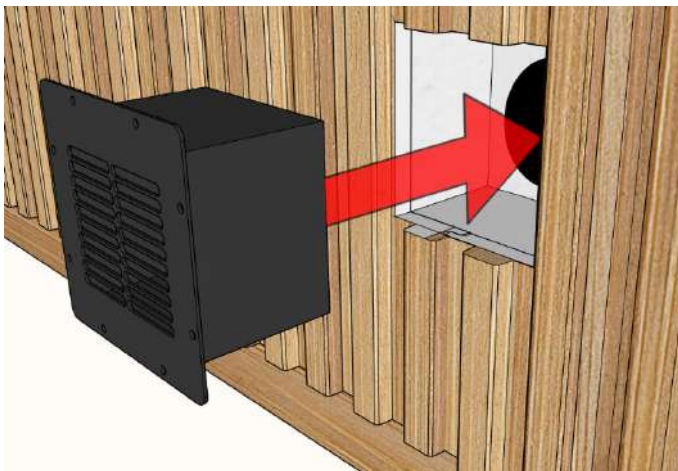
130



1 1/2" - 2" (38-51 mm) Hole Saw

Use a hole saw to cut out the center of the vent hole.

133



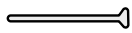
Add the steel vent cover.



Villa Siding Installation

131

Finish Nails

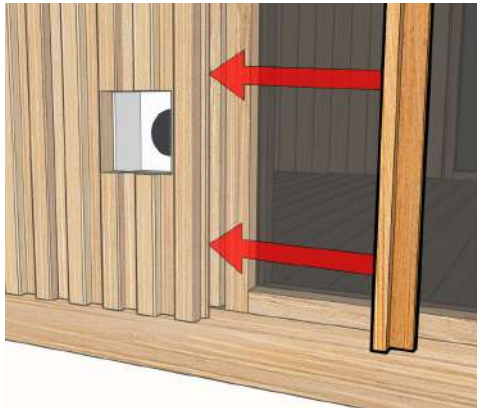


or

1 1/4"



or



FINISHING PIECE

Place the finisher piece. Fasten with staples or finishing nails.

132

Finish Nails

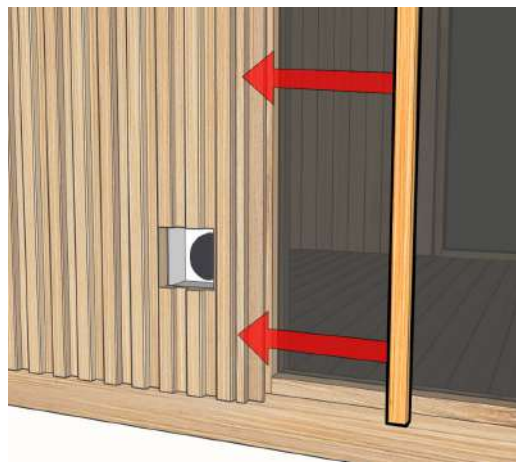


or

1 1/4"



or



TRIM PIECE

Place the trim piece. Fasten with staples or finishing nails.



Scan the code for a video of the assembly process:



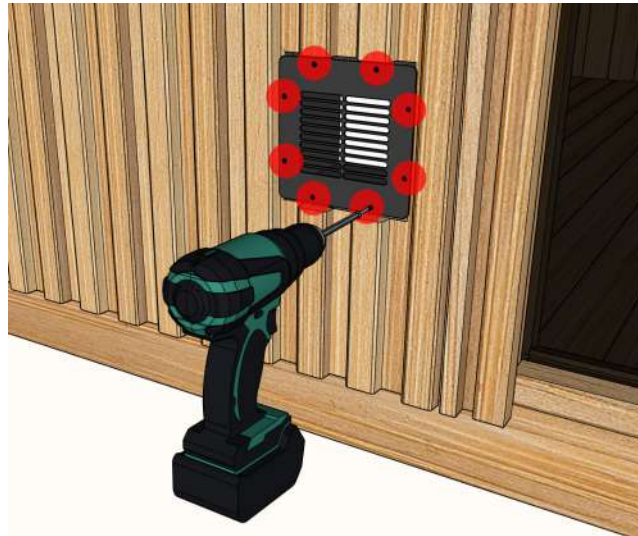
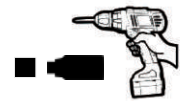
Villa Siding Installation

134



8X

3/4" (19 mm) Robertson



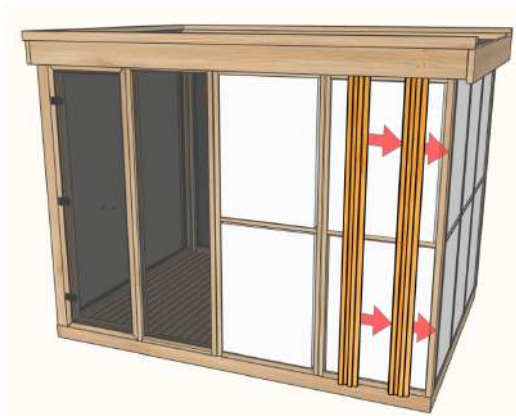
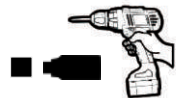
Fasten the steel vent cover with screws.

135



3X/panel

1 1/2" (38 mm) Robertson



On the other side wall continue placing and fastening panels. Fasten each siding panel with three screws. Locate the third panel which will contain a cutout on the top of the panel for a vent.

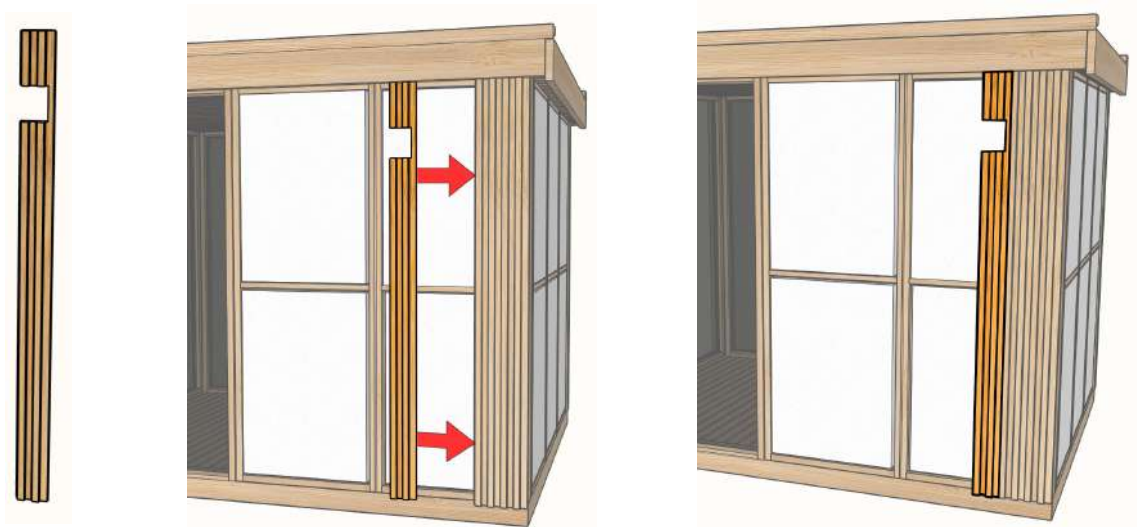


Scan the code for a video of the assembly process:



Villa Siding Installation

136



Place the third panel.

137

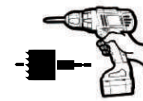
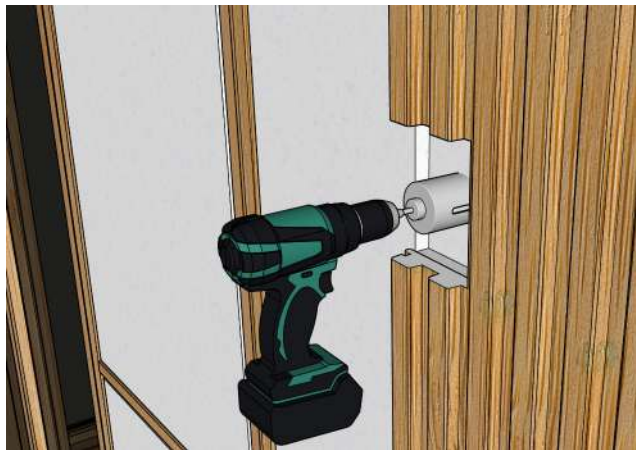


Use the panel's as a template to mark out the vent hole on the insulation beneath the panel.
Remove the panel and cut out a square vent hole from the insulation below.
Make the hole slightly larger then the mark.



Villa Siding Installation

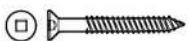
138



1 1/2" - 2" (38-51 mm) Hole Saw

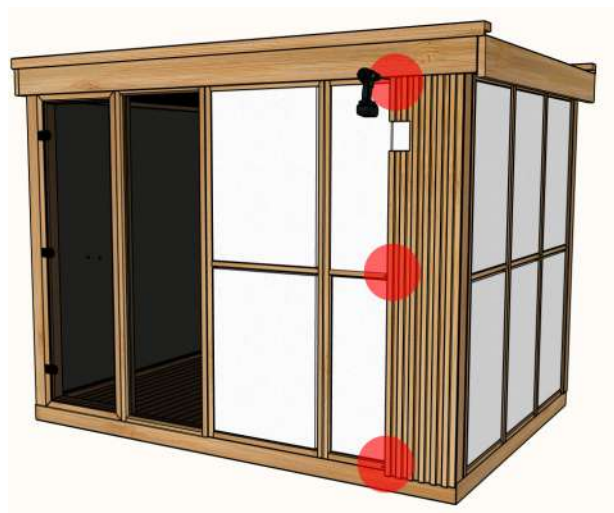
Use a hole saw to cut out the center of the vent hole.

139



3X

1 1/2" (38 mm) Robertson



Pre-drill and fasten the panel with screws.



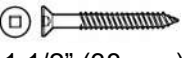
For any wiring setup or routing to be done for your sauna please check your local electrician/technician.



Scan the code for a video of the assembly process:

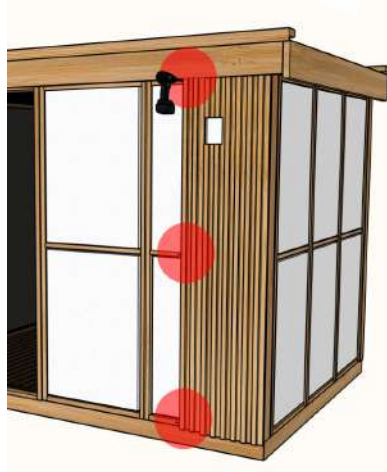
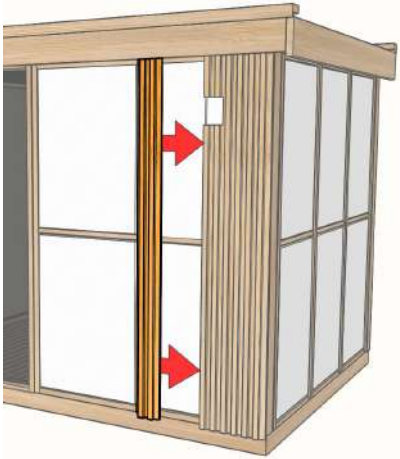
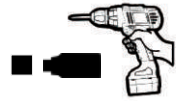


Villa Siding Installation

140  **3X**/panel
1 1/2" (38 mm) Robertson



 1/8" (3 mm) Drill Bit



Continue placing, pre-drilling & fastening panels in place to cover the wall until you reach the last full panel. Use a mallet to keep each panel tight to the next. Pre-drill and fasten each siding panel with three screws.

141 Using **Steps 131-132** as a guideline, place and fasten the finisher and trim piece to complete the siding on this wall.

142



Install the vent cover using **Steps 111-112** as a guideline.

Install the interior vent cover using **Steps 113-114** as a guideline.



Scan the code for a video of the assembly process:

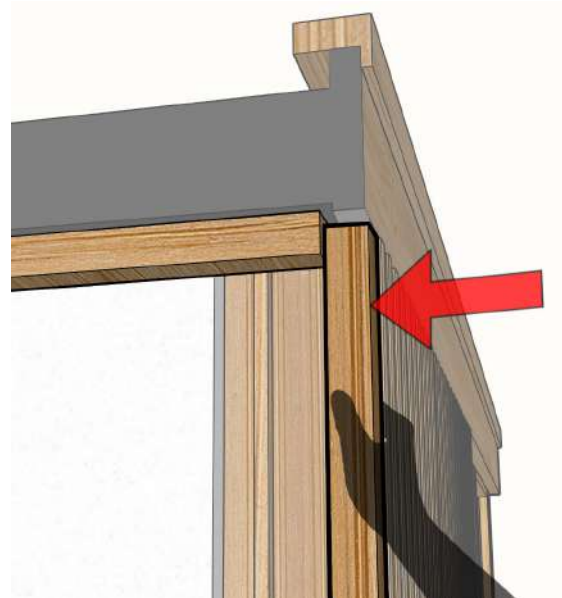
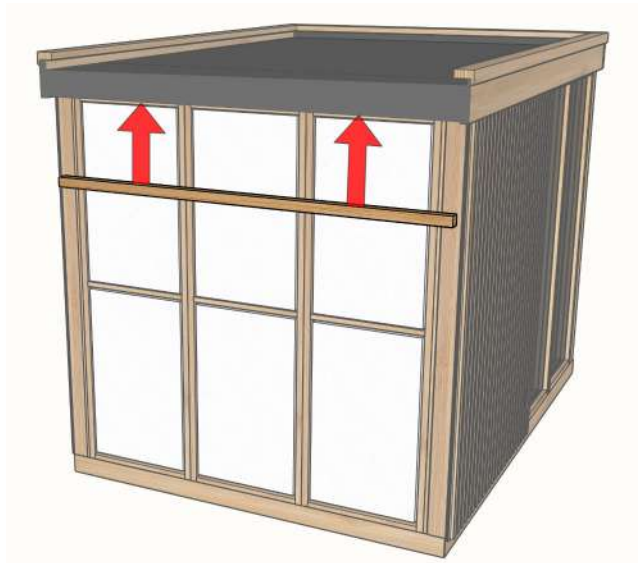


Villa Siding Installation

143

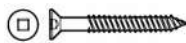


Recommended
two person job

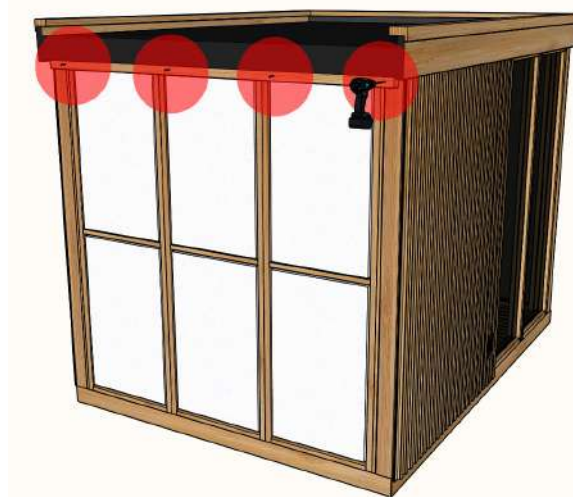
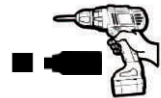


Place the back top trim to the top of the back wall. Temporarily place a back corner trim piece to see where the top piece should line up.

144



4X
2.5" (64mm) Robertson



After lining up the back top trim fasten with screws.

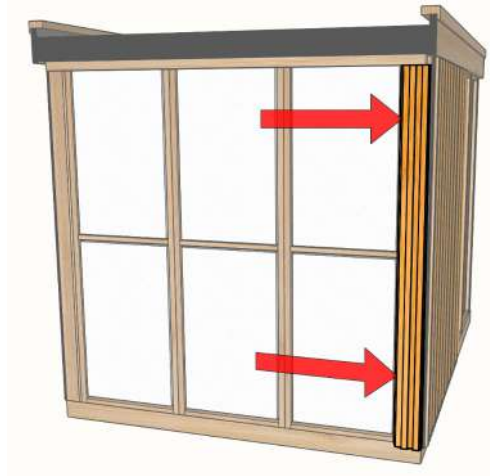


Scan the code for a video of the assembly process:



Villa Siding Installation

145

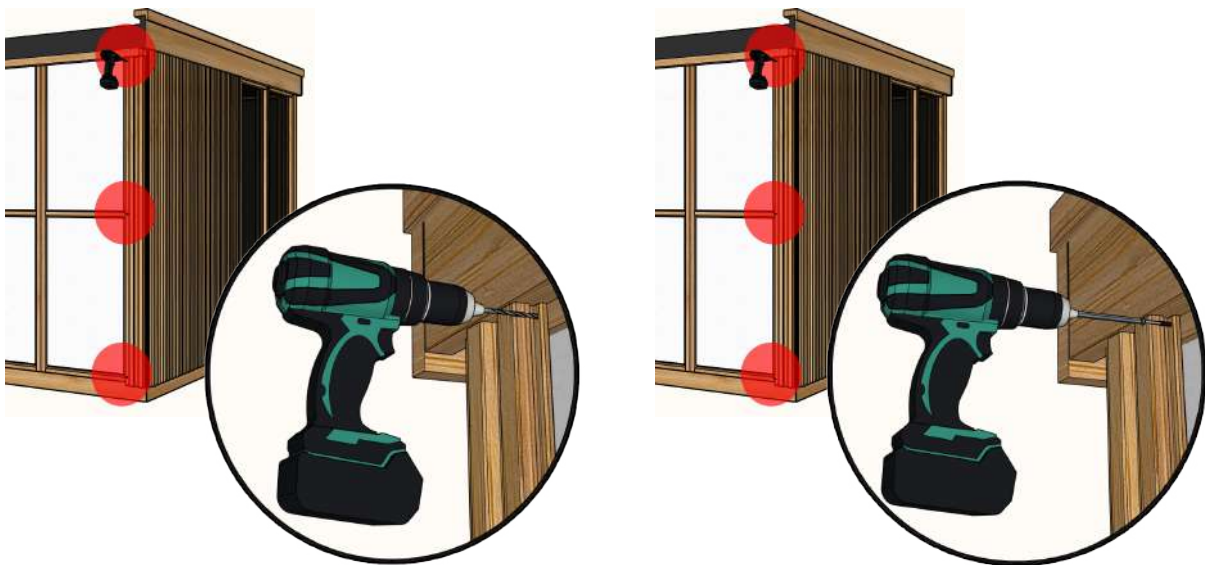


Using the shorter wood panels begin place the first panel on the corner edge of the back wall.

146

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


1/8" (3 mm) Drill Bit



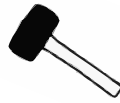
Pre-drill three holes in the tongue of the board. Fasten screws into studs with the pre-drilled holes.



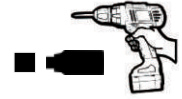
Villa Siding Installation

147

1 1/2" (38 mm) Robertson **3X**/panel



1/8" (3 mm) Drill Bit



Continue placing, pre-drilling & fastening panels in place to cover the wall until you reach the last full panel. Use a mallet to keep each panel tight to the next. Pre-drill and fasten each siding panel with three screws .

148



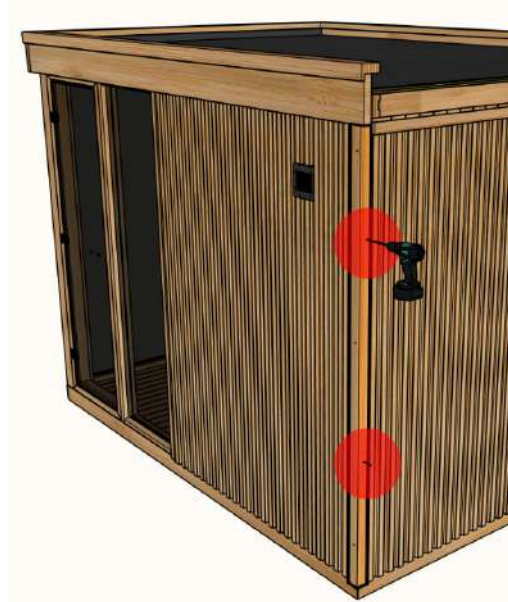
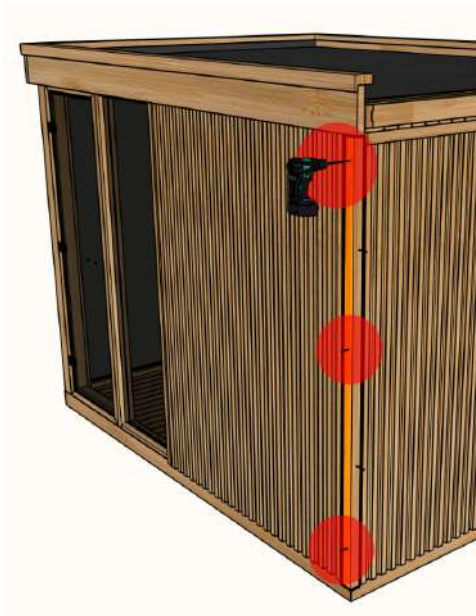
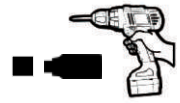
Place a corner trim piece on each rear corner.



Rear Roof Trim Installation

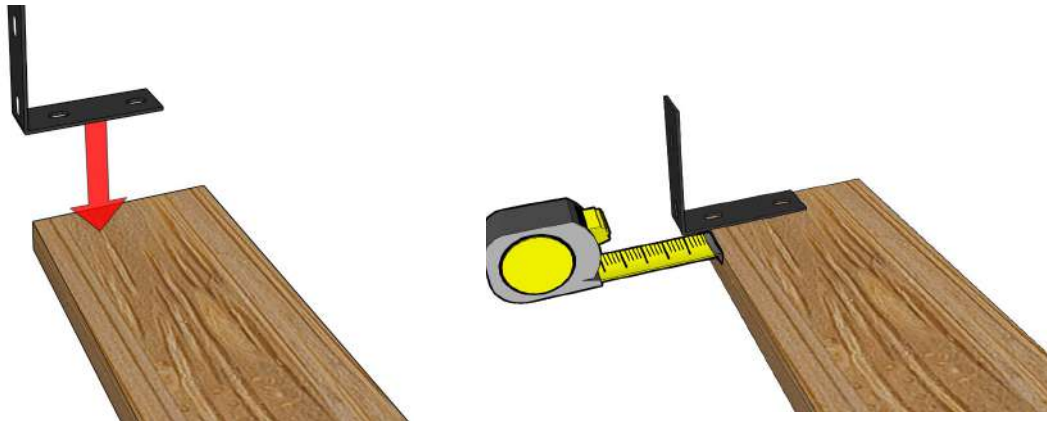
149

 **10X**
2" (38 mm) Robertson



Fasten both corner trim pieces with 5 screws. Each corner trim piece receives 2 screws on the back side of the trim and 3 screws on the other side of the trim.

150



Place a bracket on the edge of the rear nosing. Overhang the bracket by **1" (25 mm)** from the board.

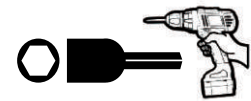


Rear Roof Trim Installation

151



7/16" (11 mm) Hex Head Screws

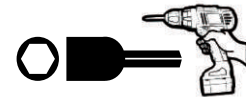


Fasten the bracket with hexagon head screws.

152



7/16" (11 mm) Hex Head Screws



Follow **STEPS 150-151** for opposite side of the nosing board.



If you are assembling a **wood villa** siding sauna follow **STEPS 153** on **page 81**
If you are assembling a **steel** siding sauna follow **STEP 155** on **page 82**



Rear Roof Trim Installation

153



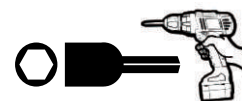
Fasten the bracket onto the side trim pieces on the back of the sauna roof.

154



4X

7/16" (11 mm) Hex Head Screws



Fasten the bracket onto the side nosing of the roof with two screws per side.



Please continue to **STEP 158** on **page 85**

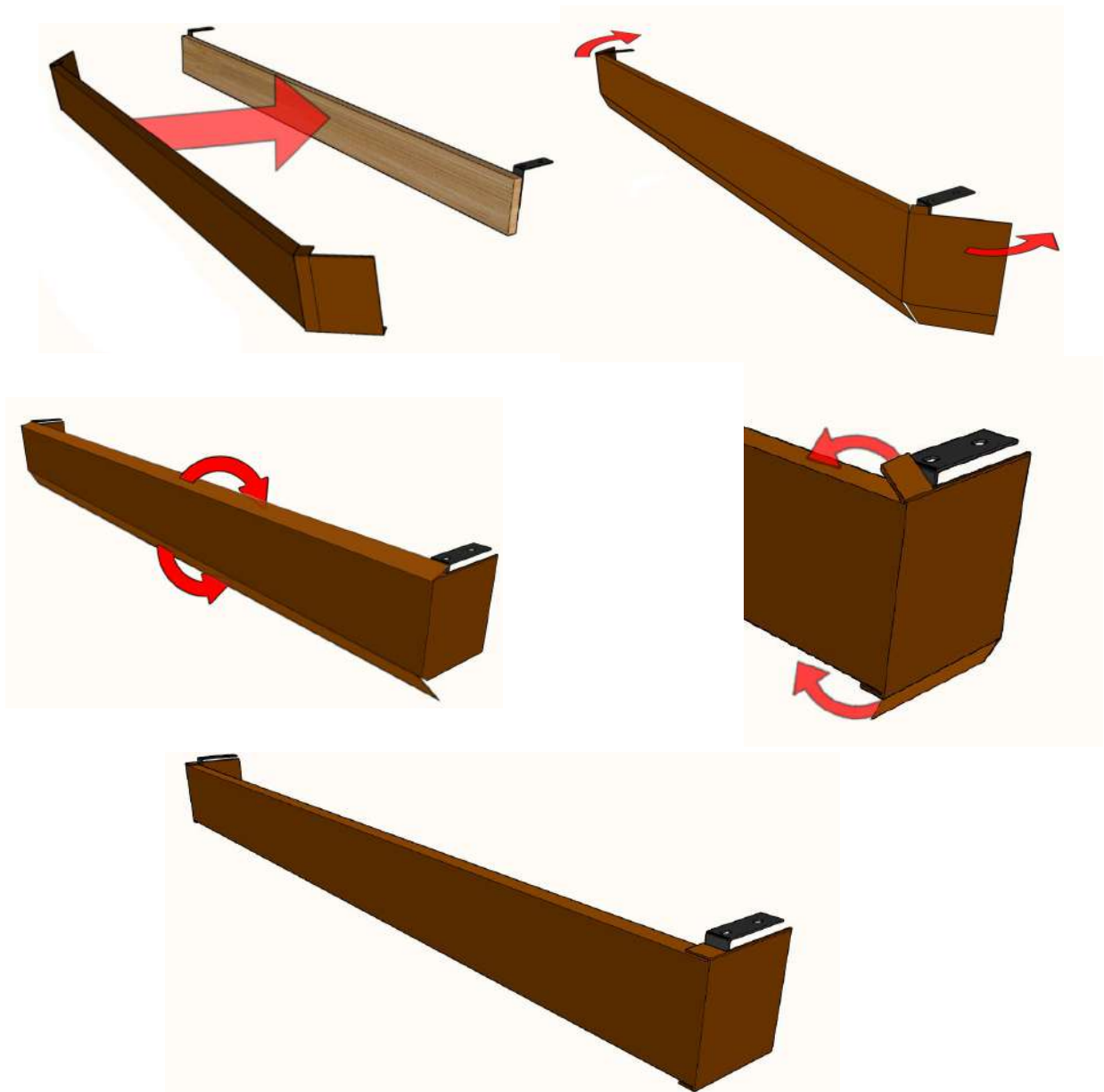


Scan the code for a video of the assembly process:



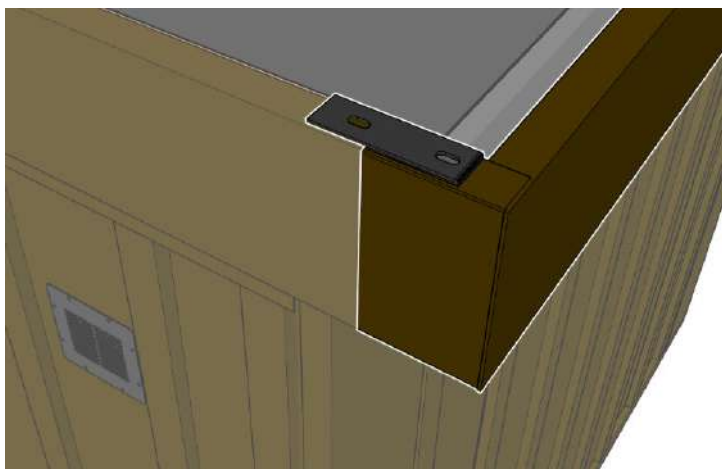
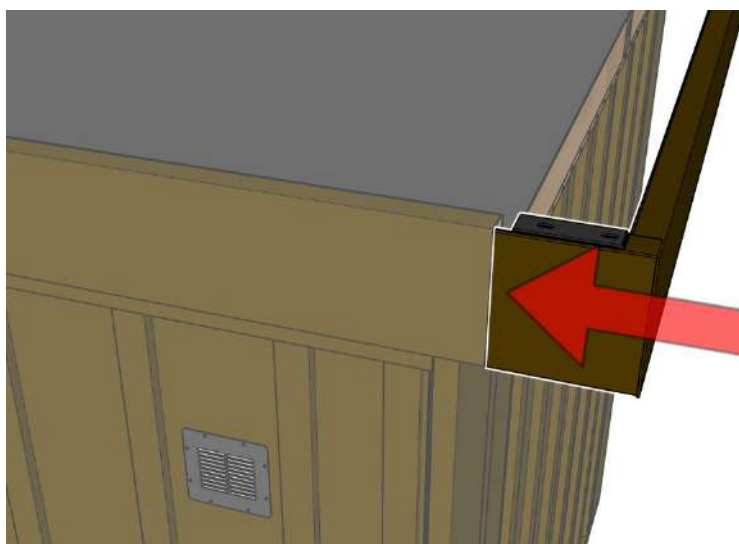
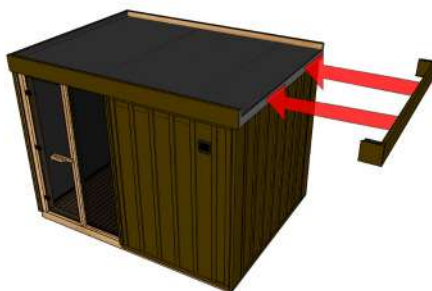
Rear Roof Trim Installation

155



Rear Roof Trim Installation

156



Fasten the bracket onto the side trim pieces on the back of the sauna roof.



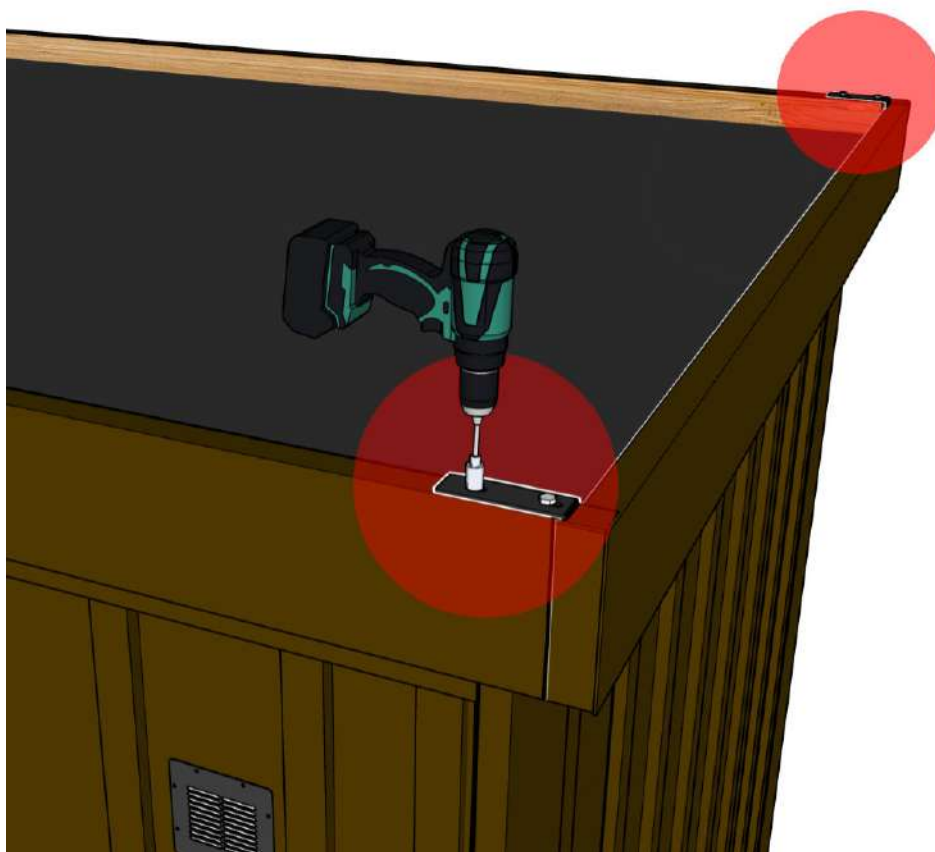
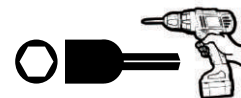
Rear Roof Trim Installation

157



4X

7/16" (11 mm) Hex Head Screws

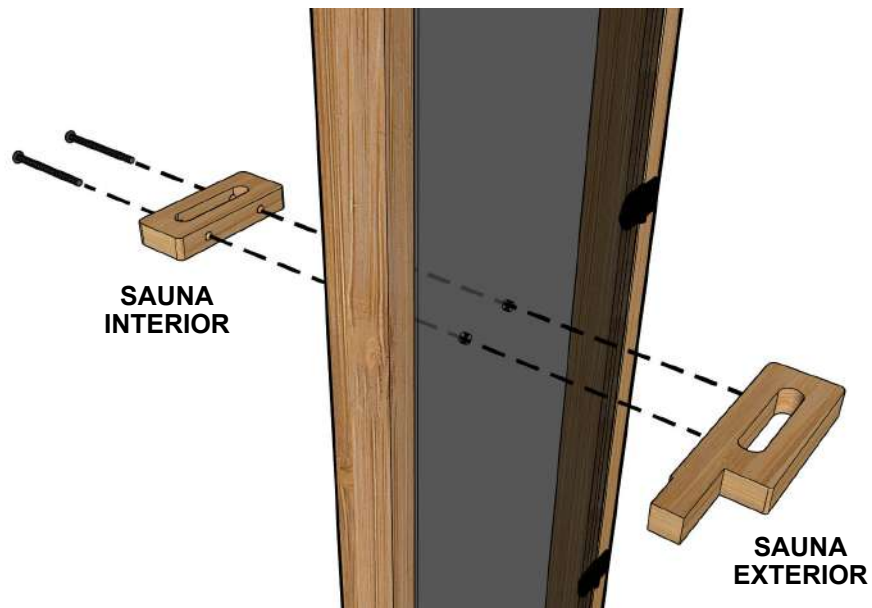


Fasten the bracket onto the side nosing of the roof with two screws per side.

Door Handle Installation

158

Comes in
door handle kit



Assemble the door handle to the glass door frame. Ensure that it is level.

Bench & Trim Installation

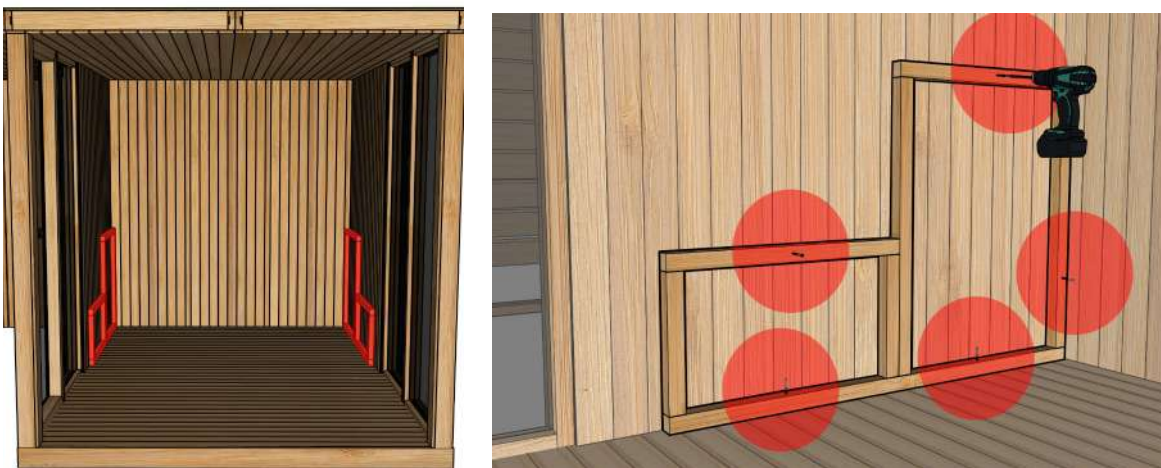
PLEASE NOTE: The following instructions demonstrate the installation of a typical bench setup. Your setup may differ slightly depending on the options you may have for your bench placement and may require a different setup.

159



Position the bench frame to the back and side wall.

160



Fasten the rear bench frame to the back and side wall.

Follow **STEPS 159-160** to install the rear bench support on the opposite wall in the sauna.

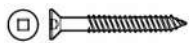
Bench & Trim Installation

161



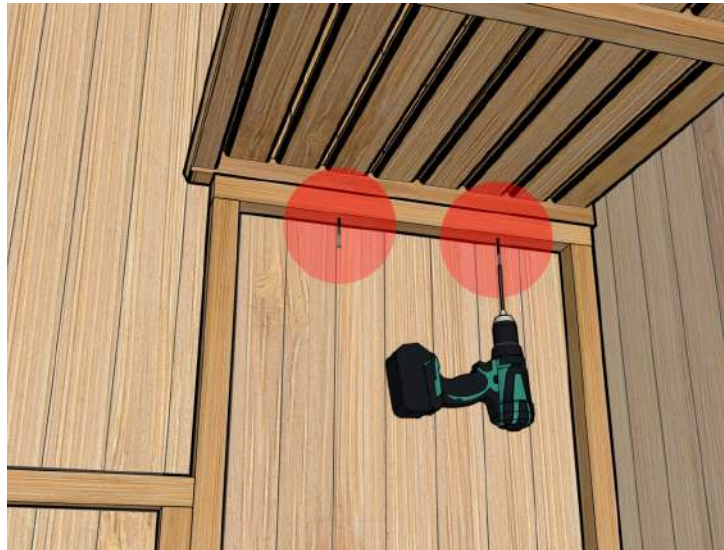
Position the bench top on the bench supports.

162



4X

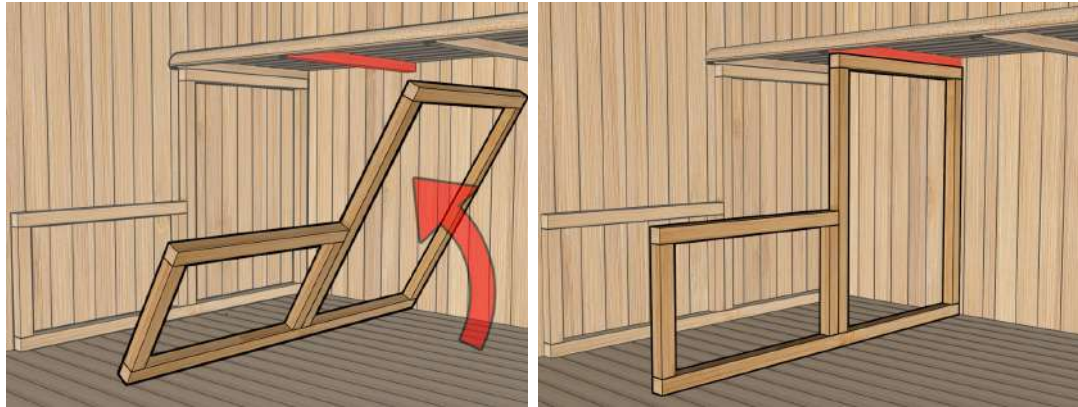
2-2 1/2" (64 mm) Robertson



Fasten the bench support to the bench top with screws.

Bench & Trim Installation

163



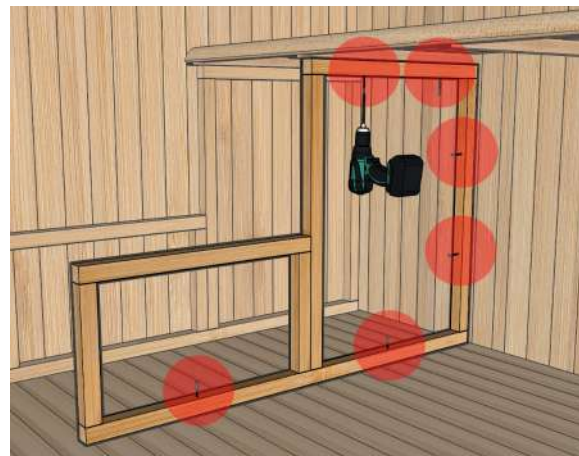
Place a bench support underneath the bench top. The bench support should be sitting directly below the cross support of the bench top.

164



18X

2 1/2" (64 mm) Robertson



Ensure the bench support is level. Fasten the bench support to the sauna with screws. Repeat **Step 160-161** for the two remaining bench supports.

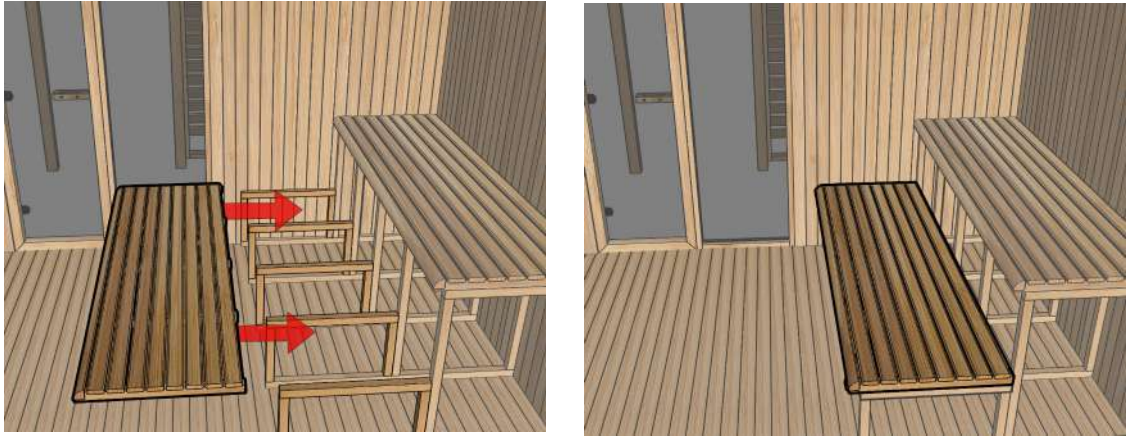


Scan the code for a video of the assembly process:



Bench & Trim Installation

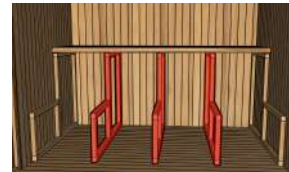
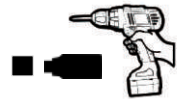
165



Position the second bench top on the bench supports.

166

 **18X**
2 1/2" (64 mm) Robertson

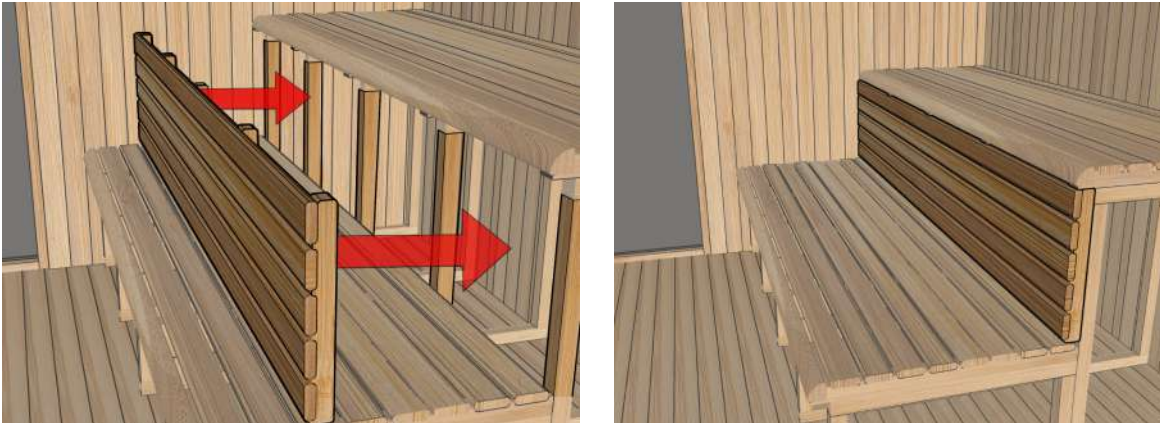


Fasten the bench support to the bench top with screws.



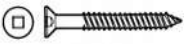
Bench & Trim Installation

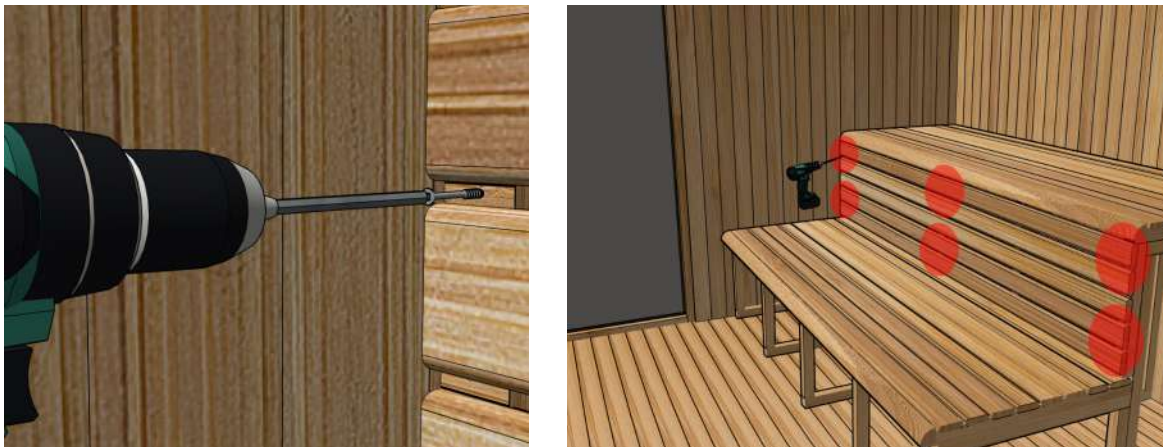
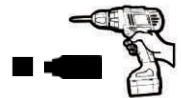
167



Position the top bench enclosure. Ensure the thick part is on the bottom.

168

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



Fasten the top bench enclosure with screws.
Fasten each screw between the slats for a cleaner look to your bench.



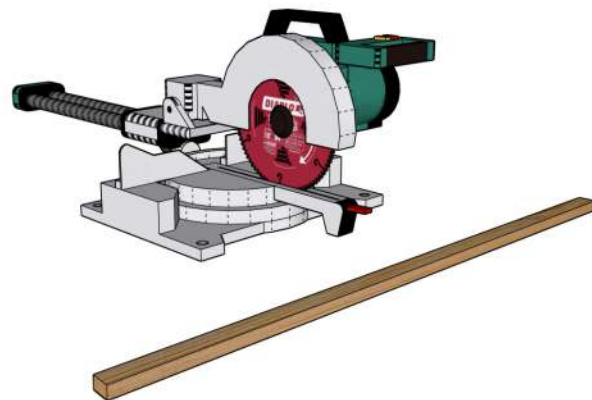
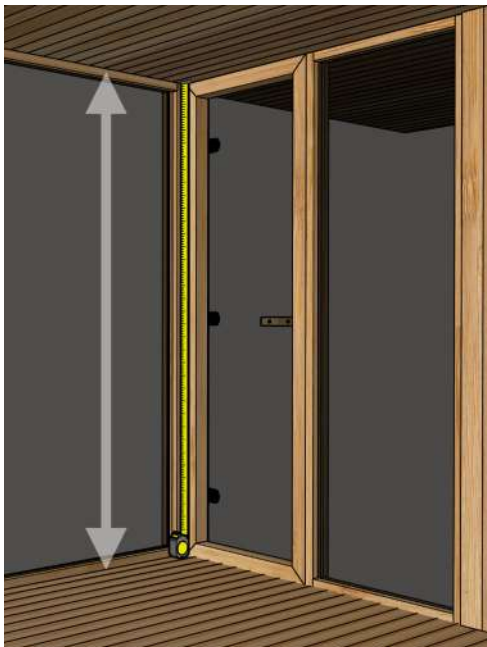
Bench & Trim Installation

169



Follow **STEPS 167-168** for the bottom bench enclosure.

170



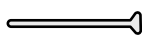
Measure and cut a trim piece to fit in the front corner of the sauna.



Bench & Trim Installation

171

Finish Nails

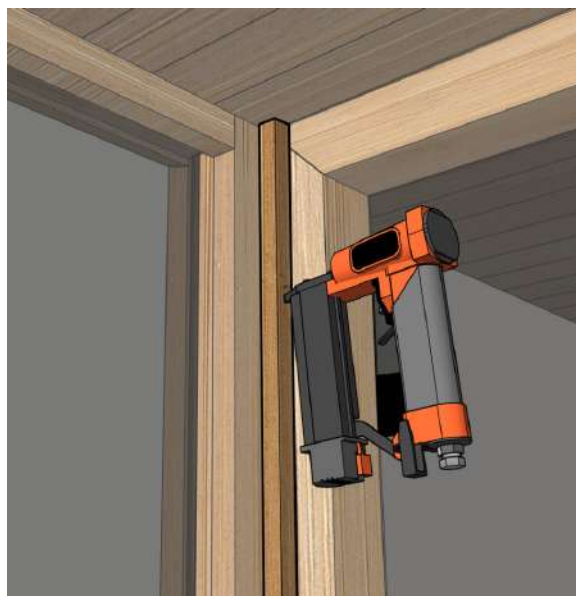
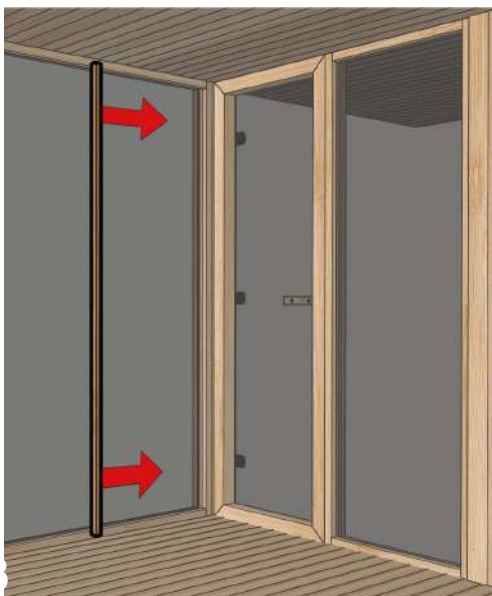


or

1 1/4"
(32 mm)



or

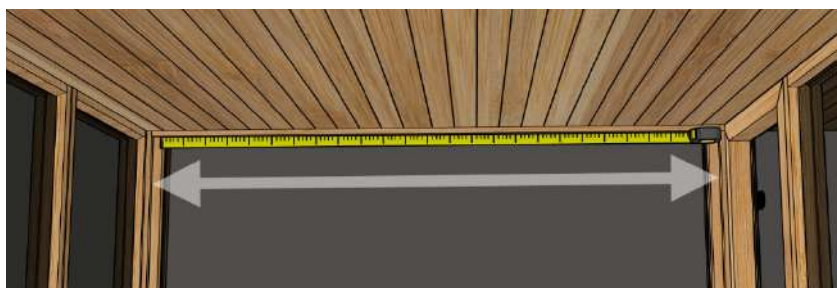


Position the trim piece and fasten with staples or finish nails.

172

Follow **STEPS 170-171** for the corner on the opposite side of the front window.

173



Measure and cut a trim piece to fit the top of the front window.



Bench & Trim Installation

174

Finish Nails

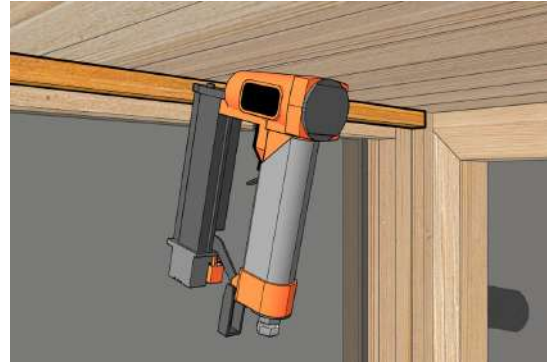
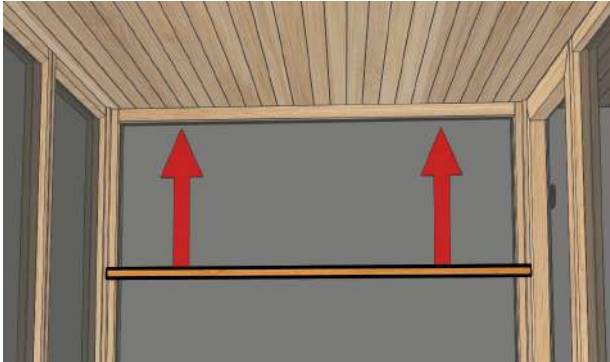


or

1 1/4"
(32 mm)

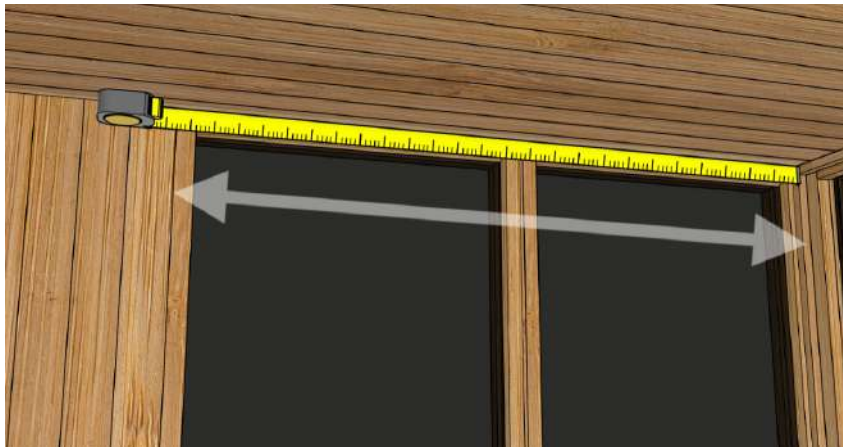


or



Position the trim piece between the front window and ceiling.
Fasten with staples or finish nails.

175



Measure and cut a trim piece above the window panels on the far side of the sauna.



Bench & Trim Installation

176

Finish Nails

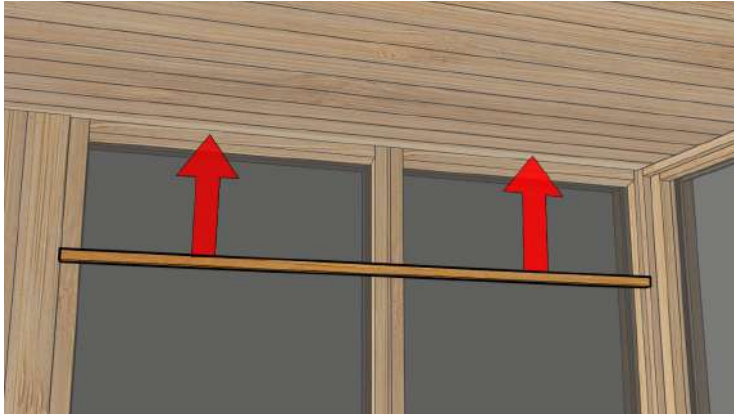
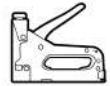


or

1 1/4"
(32 mm)



or



Position the trim piece above the windows and ceiling.
Fasten with staples or finish nails.

177

Finish Nails

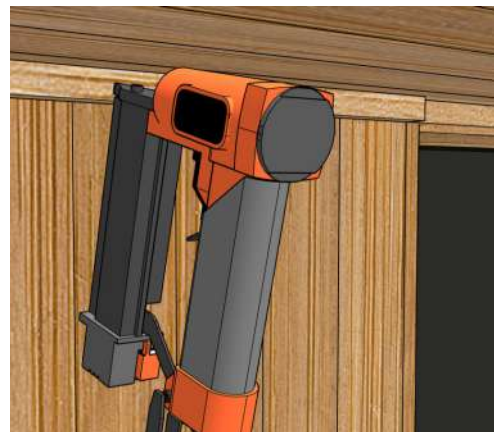
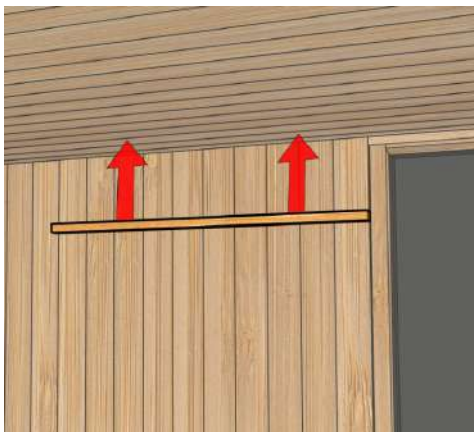
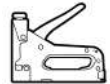


or

1 1/4"
(32 mm)



or



From your last cut take the leftover trim piece and position it as shown.
Fasten it in place with staples or finish nails.



Bench & Trim Installation

178



Measure and cut the remaining trim piece left to be done in this area.

179

Fasten the remaining trim piece in place with **1 1/4"** staples or finish nails.

180

Following **STEPS 175-179** measure and cut trims pieces for the opposite side of the sauna.

181



Measure and cut a trim piece to fit the rear top wall.



Bench & Trim Installation

182

Finish Nails

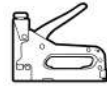


or

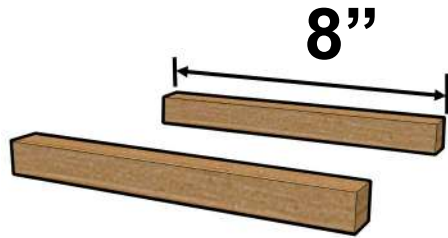
1 1/4"
(32 mm)



or



183



Cut two 8" (203 mm) trim pieces to fit the back wall panels.

184

Finish Nails

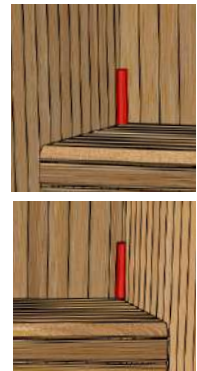
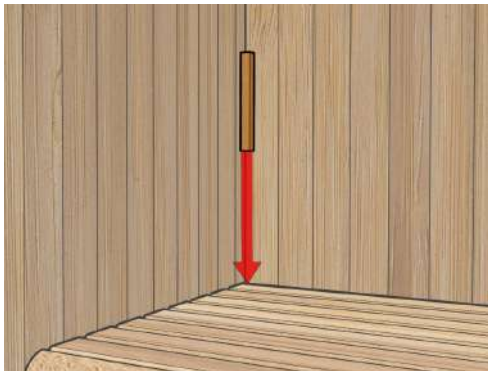


or

1 1/4"



or



Position the trim in the corners of the top bench and fasten with 1 1/4" staples or finish nails.



Bench & Trim Installation

185



Position the back rest on the trim pieces.

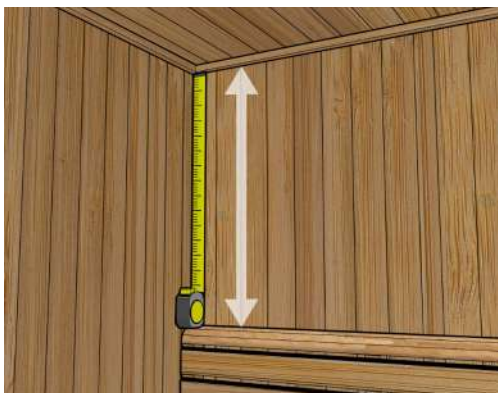
186

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



Fasten the backrest to the sauna with 5 screws. Fasten each screw between the slats for a cleaner look to your bench.

187



Measure and cut a trim piece for the area between the backrest and ceiling trim.



Bench & Trim Installation

188

Finish Nails

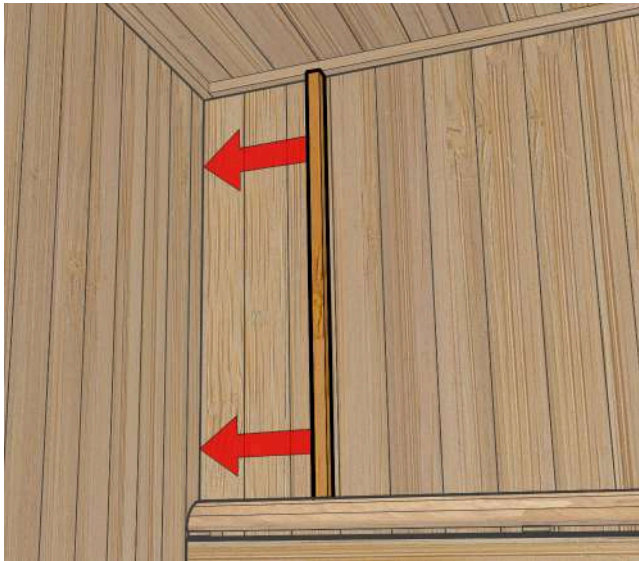
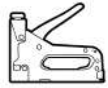


or

1 1/4"
(32 mm)



or

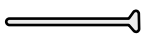


Position and fasten the trim piece.

Repeat **STEPS 187-188** for the opposite corner of the backrest.

189

Finish Nails



or

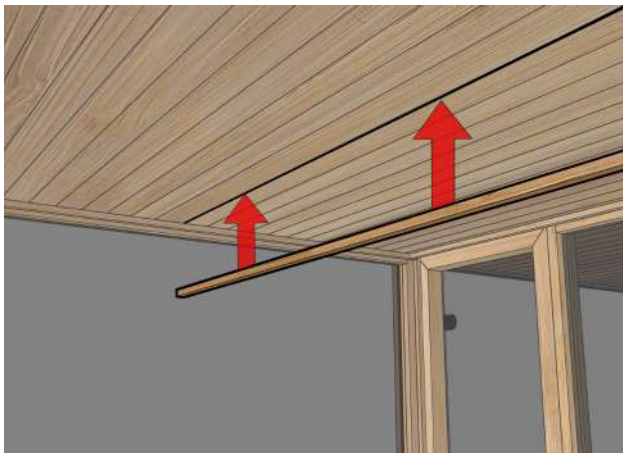
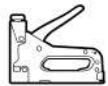
1 1/4"



(32 mm)



or



Position and fasten the center trim piece on the gap in the middle of the ceiling.



Scan the code for a video of the assembly process:



Bench & Trim Installation

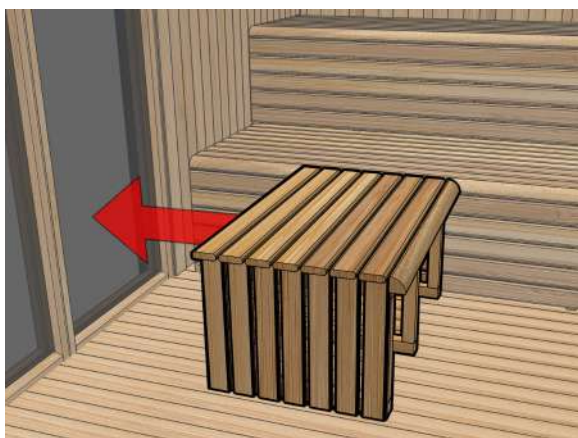
190

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



Assemble the small bench inside the sauna.

191



Position the bench against the window and back bench.



Scan the code for a video of the assembly process:



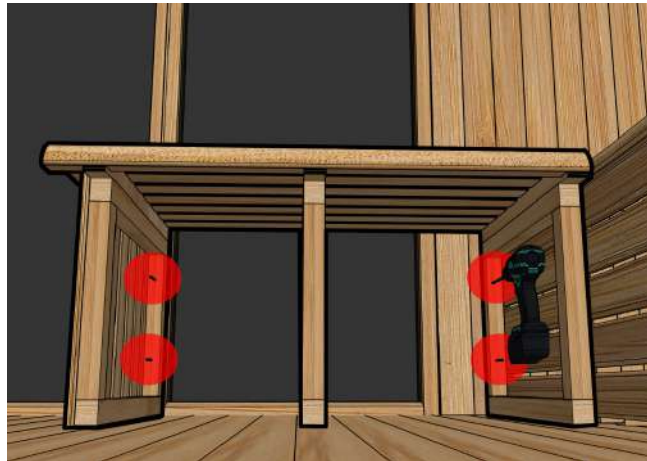
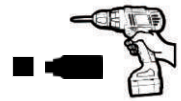
Bench & Trim Installation

192



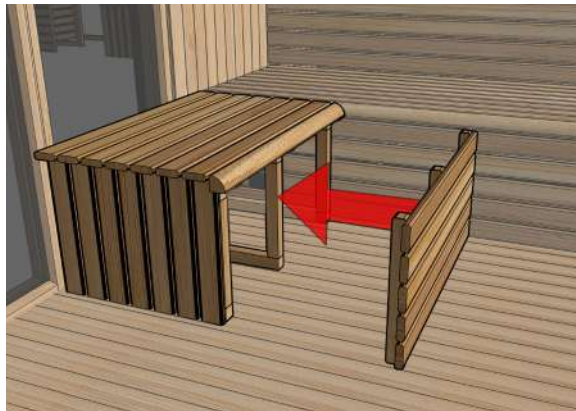
4X

2 1/2" (64 mm) Robertson



Fasten the bench to the sauna.

193

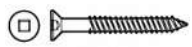


Position the front face of the bench.



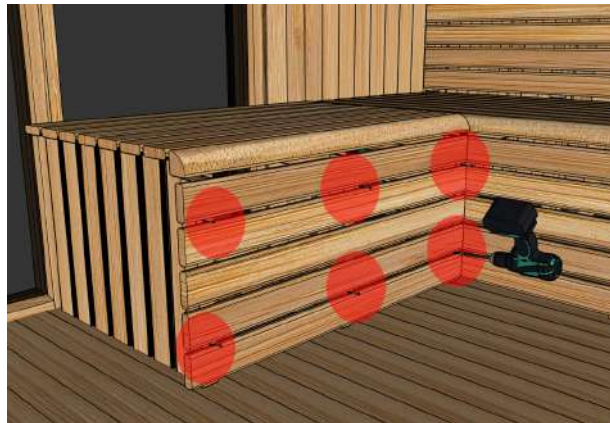
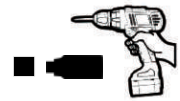
Bench & Trim Installation

194



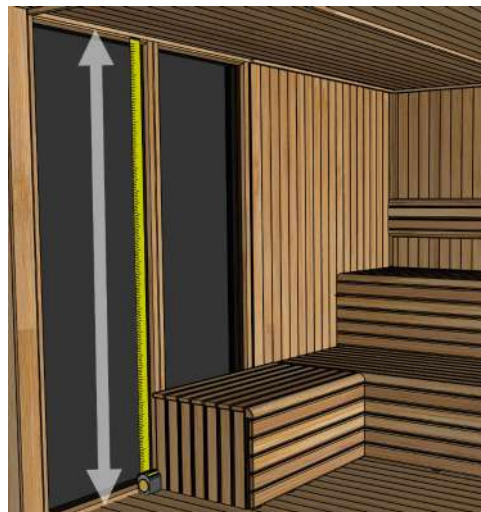
6X

2 1/2" (64 mm) Robertson



Fasten the front face to the bench. Fasten each screw between the slats for a cleaner look to your bench.

195



Measure and cut a wide trim piece to cover the seam behind the small bench.



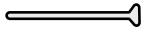
Scan the code for a video of the assembly process:



Bench & Trim Installation

196

Finish Nails

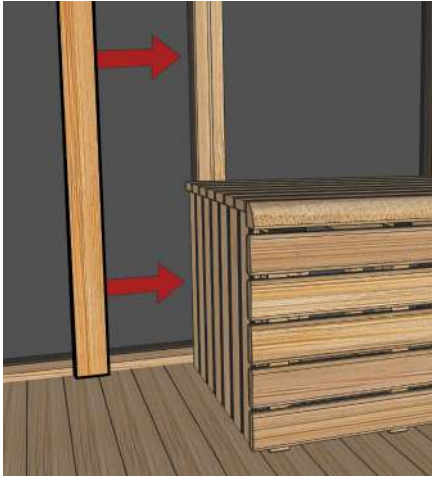
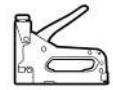


or

1 1/4"
(32 mm)

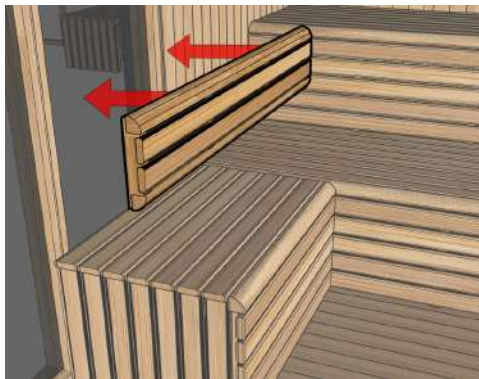


or



Position and center the wide trim piece to cover the seam behind the small bench.
Fasten the trim.

197



Position the small side backrest. Ensure it is aligned with the top bench.



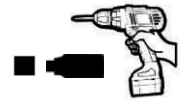
Scan the code for a video of the assembly process:



Bench & Trim Installation

198

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

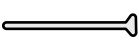


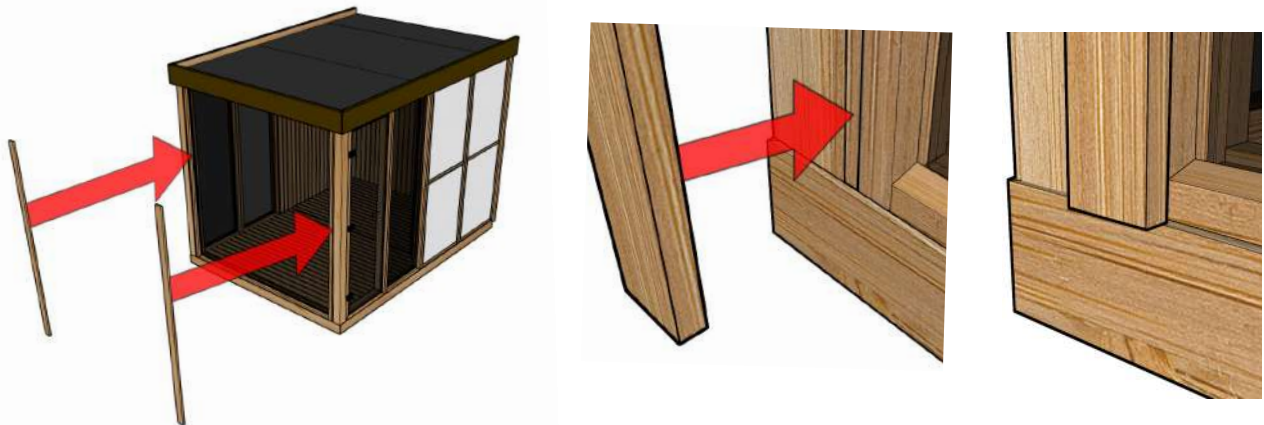
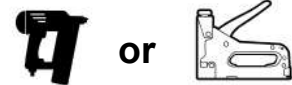
Fasten the small backrest with screws.

199

Following **STEPS 195-196** as a guide measure and cut a piece of trim for the area between the glass panes on the opposite wall.

200

Finish Nails  or 1 1/4" 



Place the 2 trim boards (**1x3**) on the walls (See image above). Ensure that each board is spaced tight to the roof trim and covers the seam between the window frame and 4x4

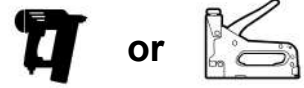


Scan the code for a video of the assembly process:



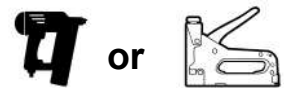
Bench & Trim Installation

201 Finish Nails  or 1 1/4" 



Install trim pieces over the seams of the windows and fasten with finish nails or staples.

202 Finish Nails  or 1 1/4" (32 mm) 



Install 2 medium trim pieces on the seams on both sides of the door. Ensure that the trim is placed and fastened as to not impede with the opening of the door.

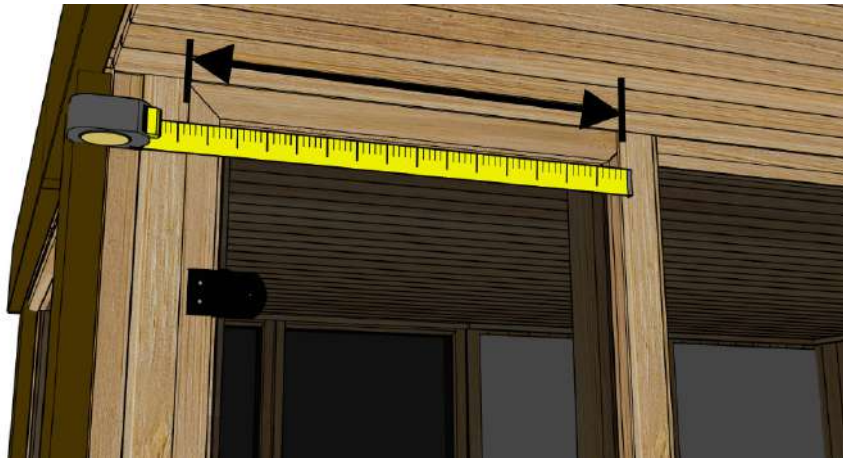


Scan the code for a video of the assembly process:



Bench & Trim Installation

203



Measure the distance between the trim on both sides of the door. Cut a thin piece of trim to fit. Ensure that the trim is placed and fastened as to not impede with the opening of the door.

204

Finish Nails

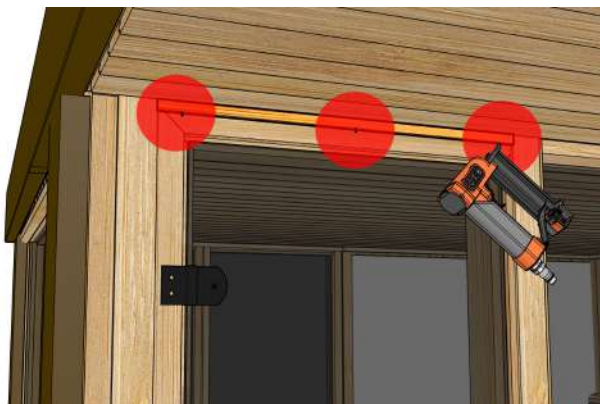


or

1 1/4"
(32 mm)



or



Fasten with finish nails or staples.



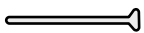
Bench & Trim Installation

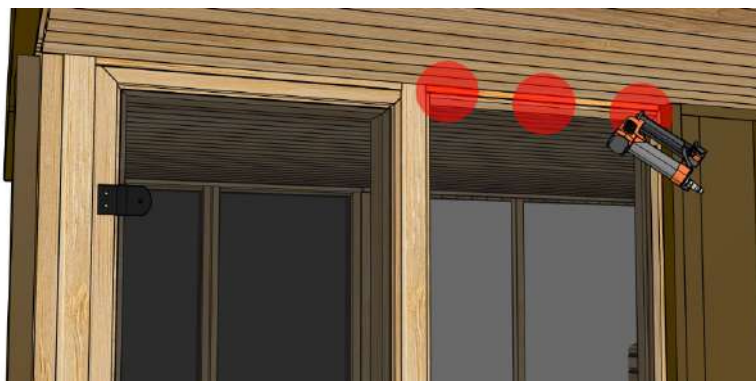
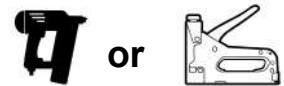
205



Measure the distance between the door trim and the siding. Cut a thin piece of trim to fit.

206

Finish Nails  or 1 1/4" 



Fasten with finish nails or staples.



Conclusion



This concludes the assembly instructions
for the

ORION SAUNA

We hope you enjoy your sauna!



Scan the code for a video of the assembly process:



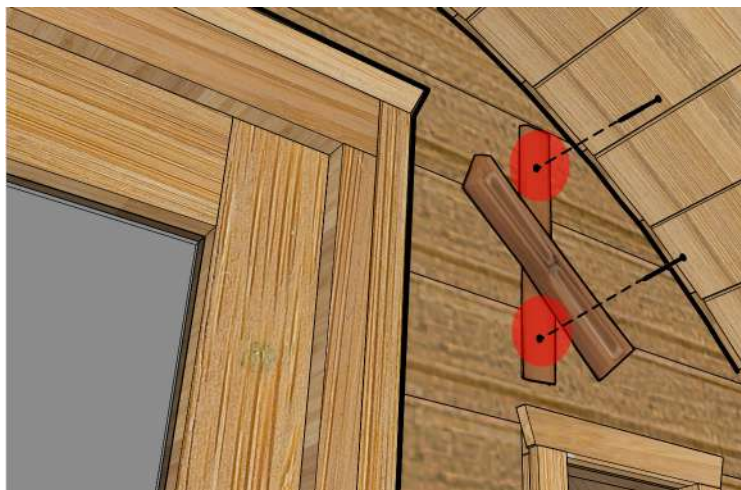
ACCESSORY install section

207

Sand Timer (Optional)



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.

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 5 amazing colors; Sesame, Light Leak, Bongossi, Black and Natural in convenient 2.5 Litre 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:



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:





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

Please ensure you fill out your warranty card!





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