



ASSEMBLY INSTRUCTIONS

for

LUNA SAUNA

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



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Table of Contents

Tools Checklist	Pg 4
Sauna Base Preparation	Pg 5
Bottom Frame Assembly	Pg 6-13
Back Wall Assembly	Pg 14-18
Front Wall Assembly	Pg 19-24
Side Wall Assembly	Pg 25-27
Roof Assembly	Pg 28-31
Staves Too Loose	Pg 32
Staves Too Tight	Pg 33
Roof Assembly Continued	Pg 34
Roof Membrane Installation	Pg 35-36
Trim Installation	Pg 36-37
Shingle Installation	Pg 38-40
Door Handle Installation	Pg 41-42
Bench Installation	Pg 43-61
Exterior Bench Installation	Pg 62-66
Vent Installation	Pg 67-70
Accessory Install Section	Pg 71-73
Sauna Stains and Finishes	Pg 77
Maintaining your sauna	Pg 78
Warranty	Pg 79

CONGRATULATIONS

on the purchase of your
Luna Sauna

Just a few things to follow.....

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

All electrical connections must be performed
By a qualified electrician.



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



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



Tools Checklist

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



Cordless Driver



Level



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



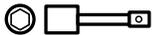
Utility Knife



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



Mallet



Wrench Socket 1/4" (6mm)



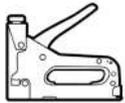
Pencil



Hacksaw



Hammer for optional thermostat



or



Staple Gun or Nail/Staple Gun



Tape Measure



or



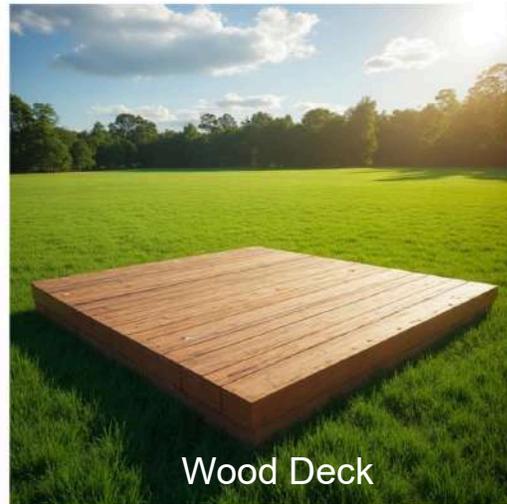
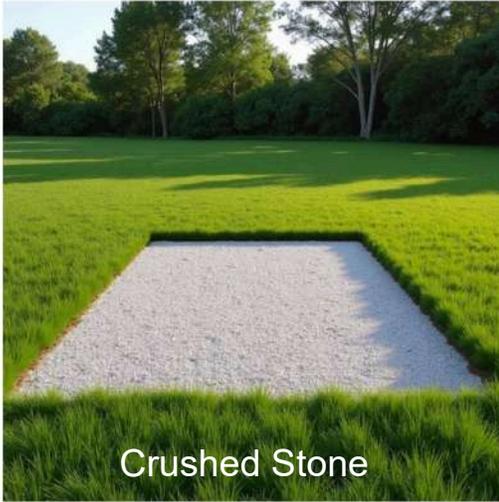
1/4" Wrench or Adjustable



Square

Sauna Base Preparation

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



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

Assembly Instructions

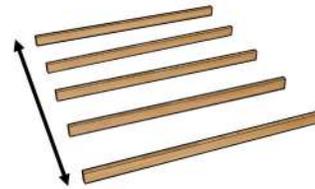


If you are assembling a Luna Sauna without a porch start here. If the Luna Sauna you are assembling contains a porch start at **Step 1P**.

1

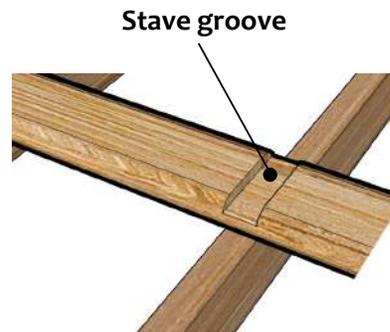
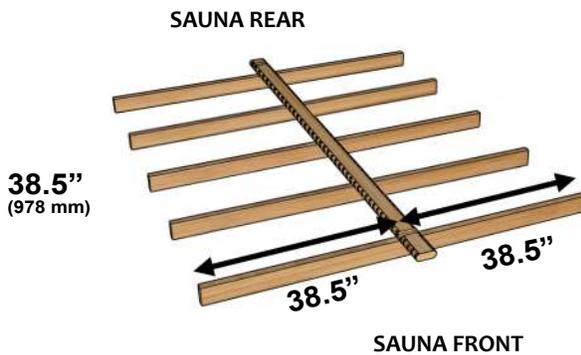


Model	Distance from front to back of Floor Joists
860LU/862LU	66"
870LU/872LU	79"
880LU/882LU	90"



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

2



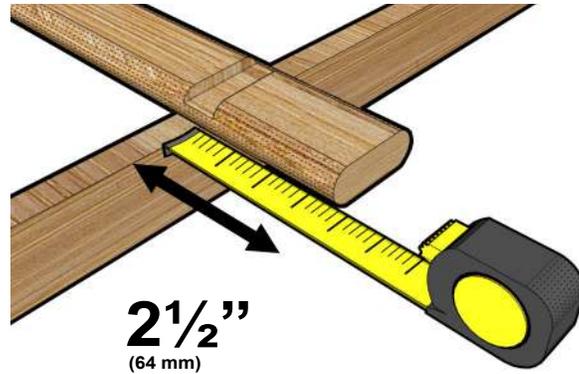
Stave Profile

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



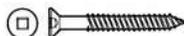
Bottom Frame Assembly (No Porch)

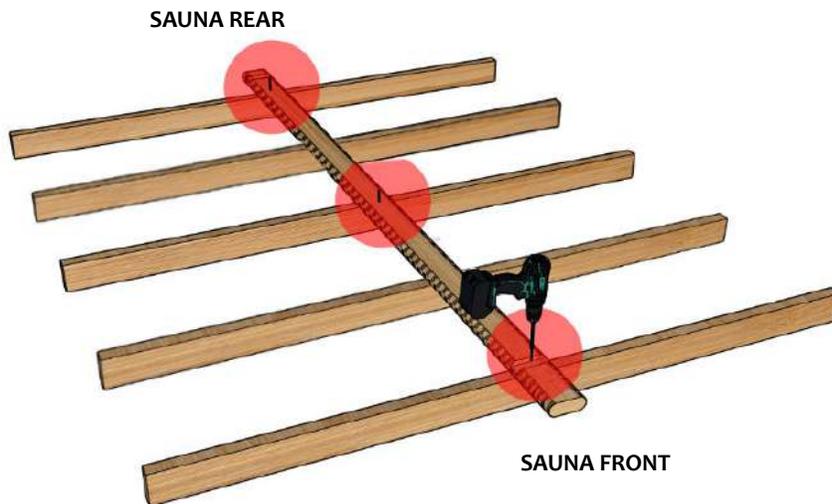
3



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

4

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



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

Continue to **STEP 6**



Bottom Frame Assembly (Porch)

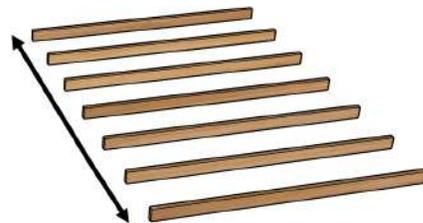


If the Luna you are assembling is a Luna Sauna that contains a porch start at here.

1P

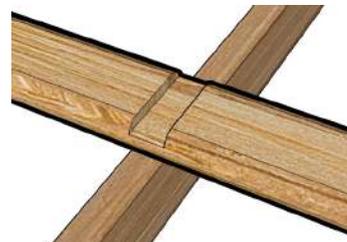
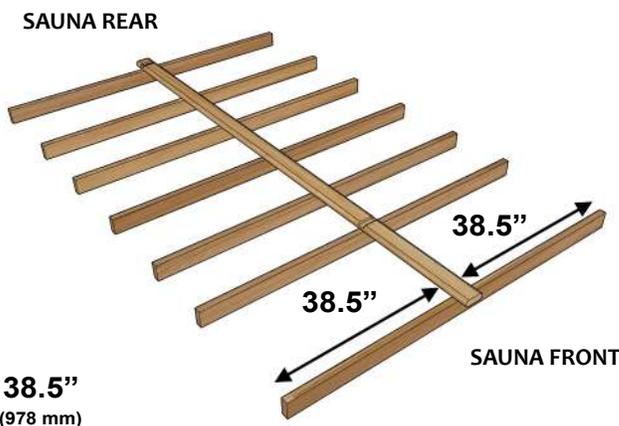


Model	Distance from front to back of Floor Joists
860LUP/862LUP	90"
870LUP/872LUP	103"
880LUP/882LUP	114"



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

2P



Stave Profile

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

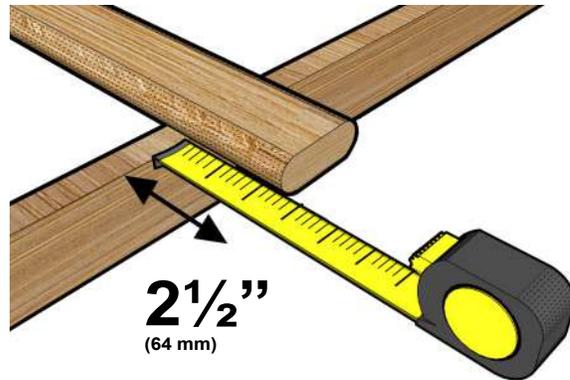


Scan the code for a video of the assembly process:



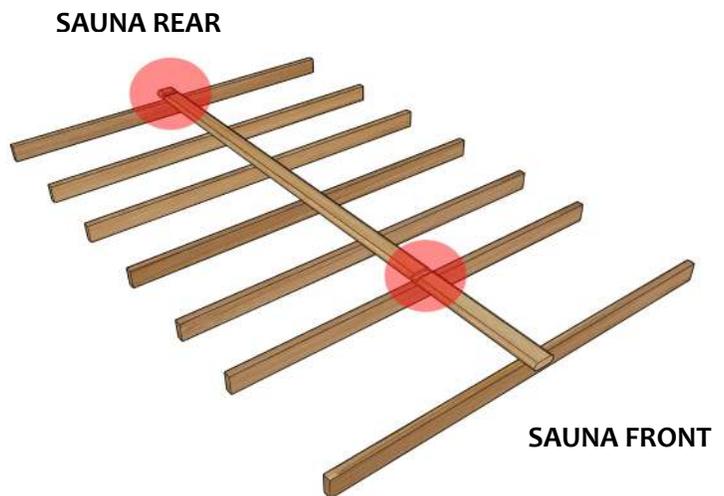
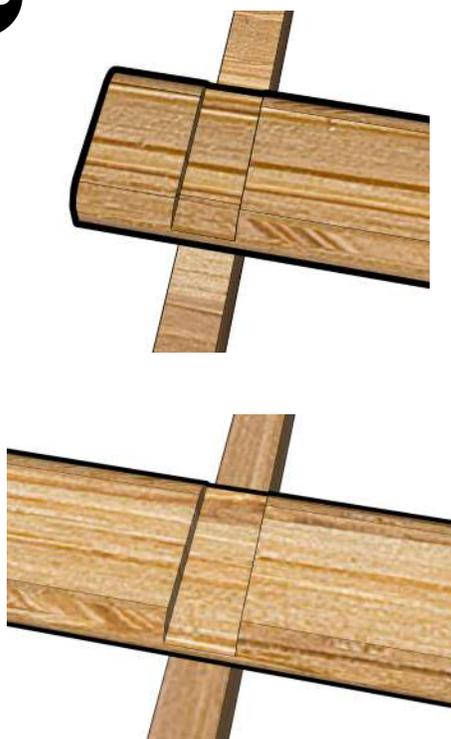
Bottom Frame Assembly (Porch)

3P



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

4P



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



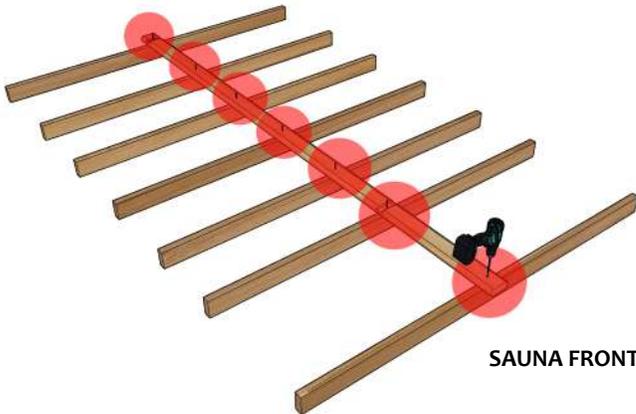
Bottom Frame (Porch)

5P

7X
2.5" (64mm) Robertson



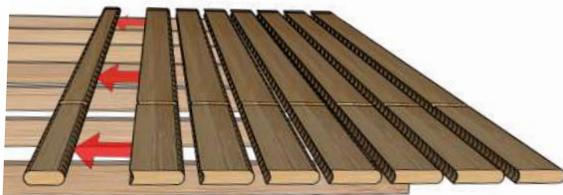
SAUNA REAR



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

Continue to **STEP 6**

6



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

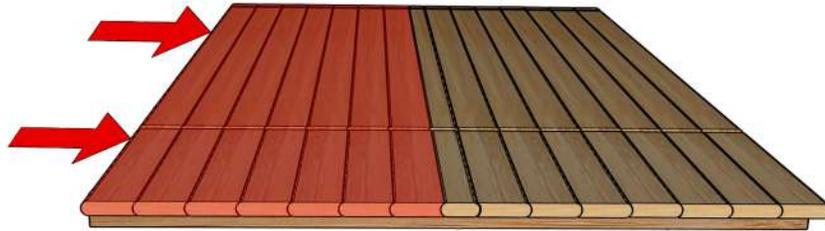


Scan the code for a video of the assembly process:



Bottom Frame Assembly

7



Repeat for the opposite side.

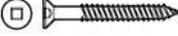
8

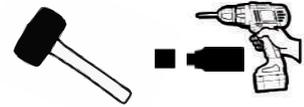


When finished line up the floorboards so they are flush and even with one other.

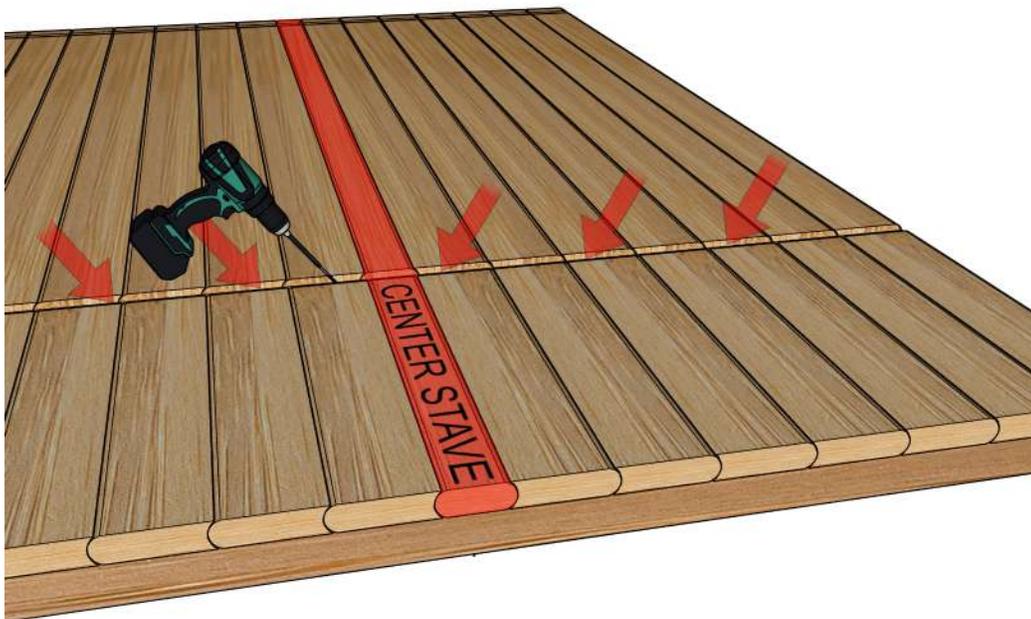


Bottom Frame Assembly

9  **14X**
2 1/2" Robertson



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

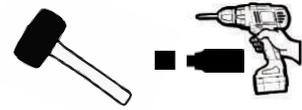


Starting with the stave closest to the center stave tap it tightly towards the centre. Next fasten a screw angled towards the center stave. Repeat this for all staves starting from the center to the outside of the platform. Do this for both sides of the center stave.

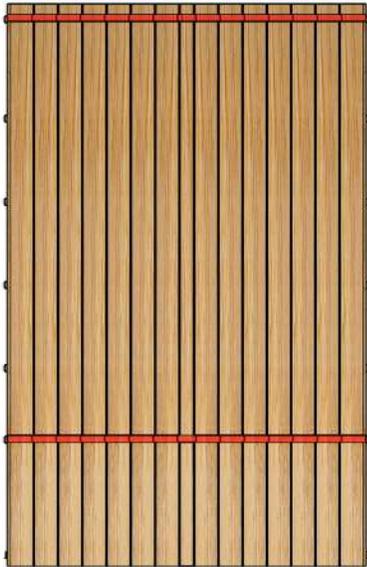


Bottom Frame Assembly

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



Groove B

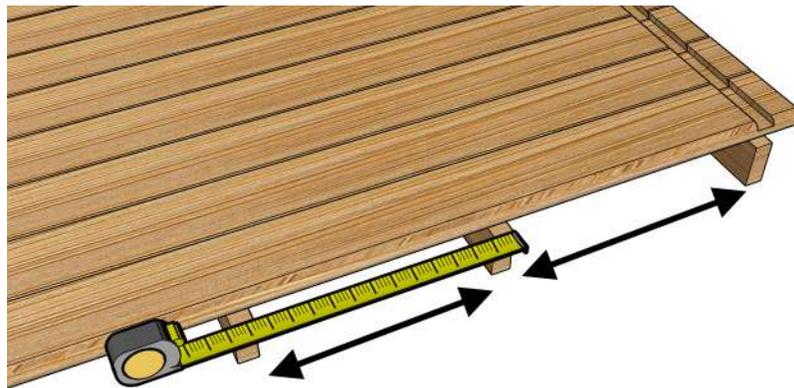


Groove A



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

11



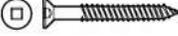
Use a tape measure to evenly space out the remaining cradle boards.

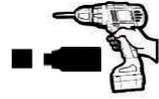


Scan the code for a video of the assembly process:



Back Wall Assembly

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



Fasten the remaining cradle boards with screws.

13

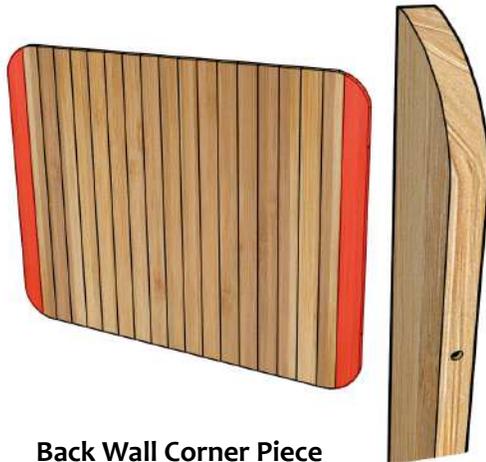


Layout the back wall staves. There should be 4 curved staves for the ends of the wall. There will be 15 straight staves used for the middle of the wall.

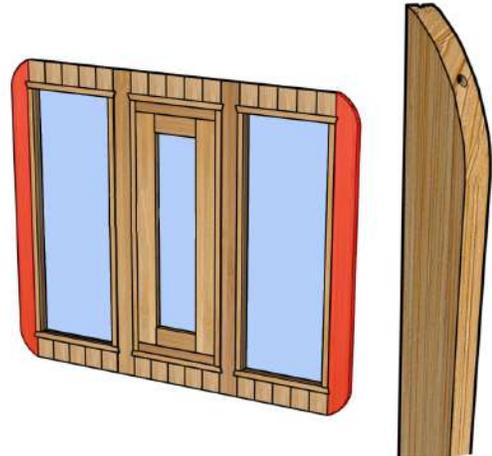


Back Wall Assembly

14



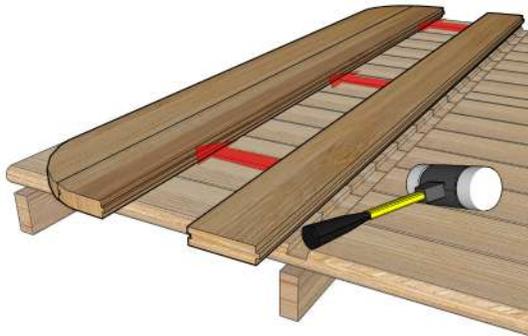
Back Wall Corner Piece



Front Wall Corner Piece

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

15



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



Back Wall Assembly

16



Continue adding staves until the wall is approximately half built.

17



4X

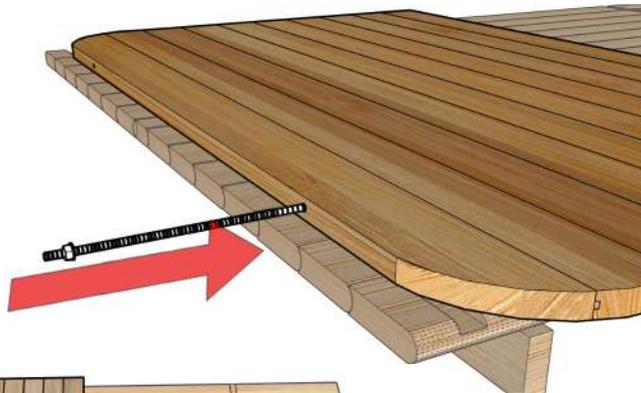
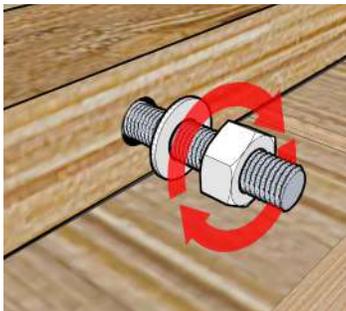


1/4" Wrench

or



Adjustable

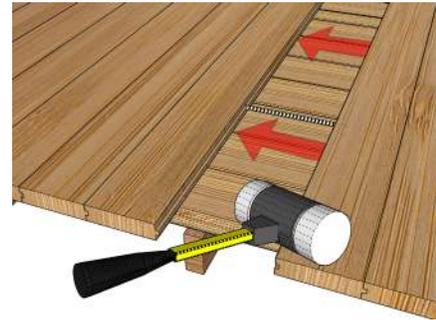
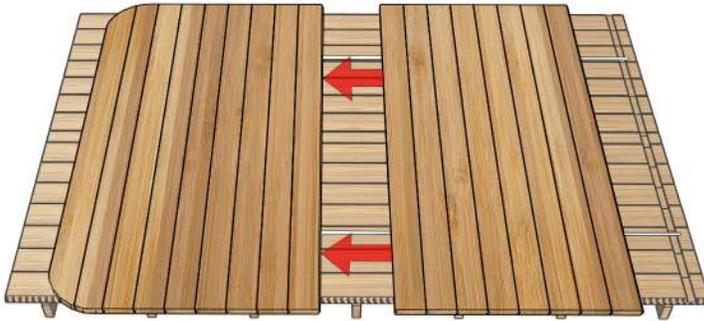


Add a washer & nut to the ends of two threaded rods.
Slide the threaded rods through the holes of both stave ends.



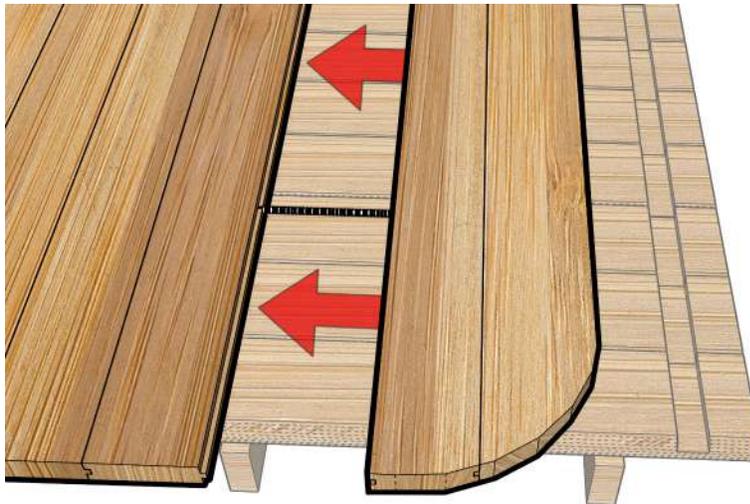
Back Wall Assembly

18



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

19

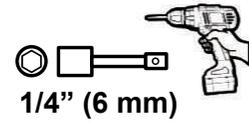


After the straight staves have been added, slide the corner pieces onto the threaded rods. Hammer the corner staves for a tight fit.



Back Wall Assembly

20



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

21

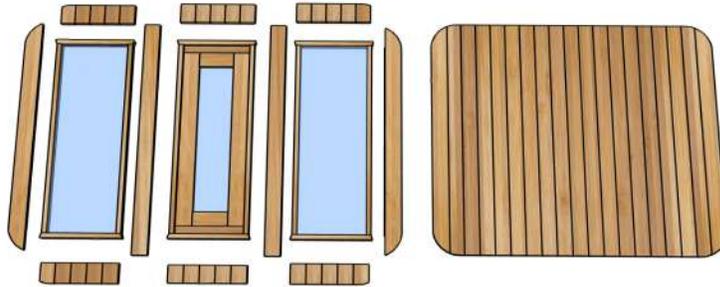


Cut off any threaded rod that is protruding from the four holes with a hacksaw.



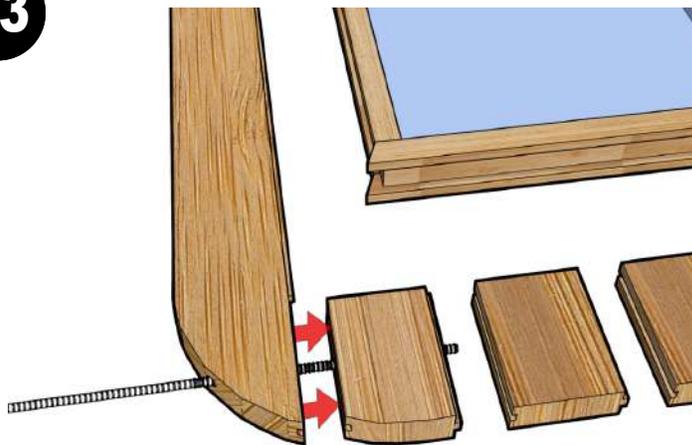
Front Wall Assembly

22



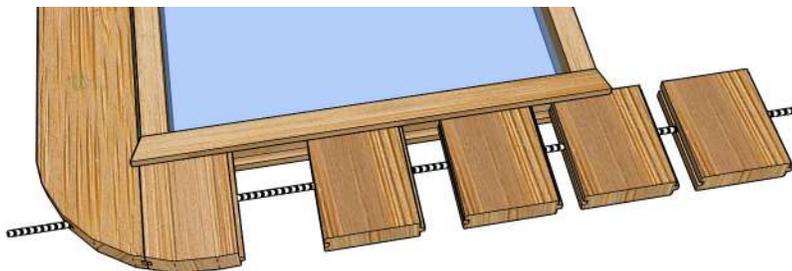
Using the assembled back wall as a guide, lay out the front wall including windows and door.

23



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

24

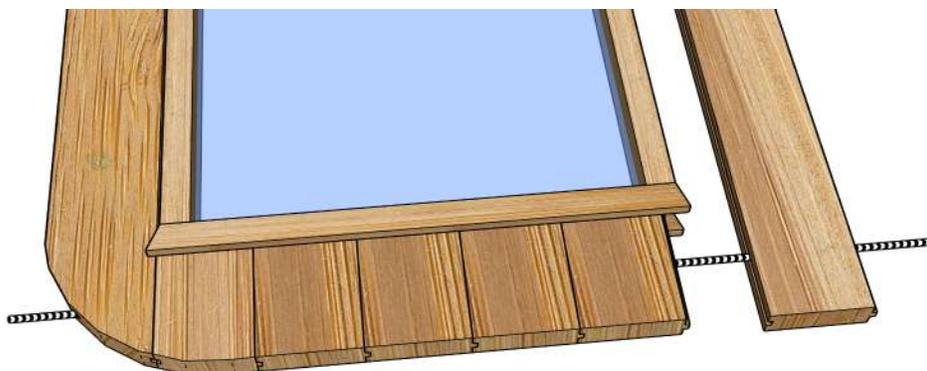


Continue sliding more staves along the threaded rod. Tap each stave to ensure a tight fit between the other staves and the window.



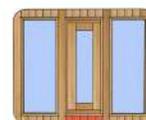
Front Wall Assembly

25



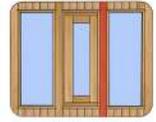
As you continually add staves to the front wall ensure a tight fit between the other staves and the window by tapping staves together.

26

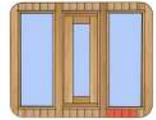
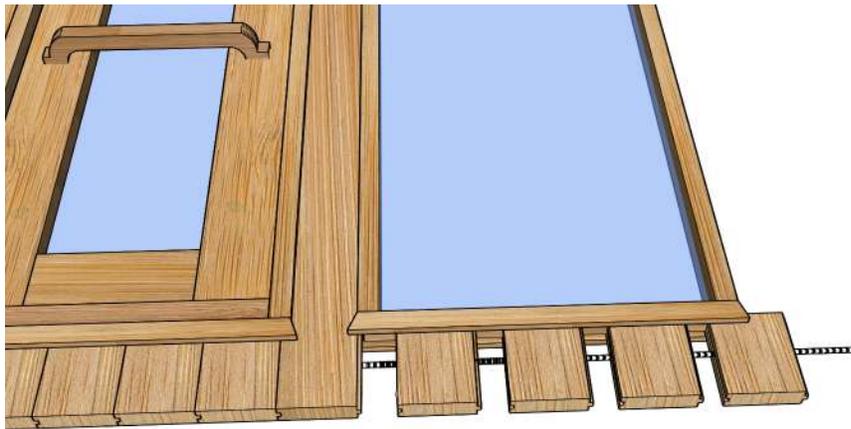


Front Wall Assembly

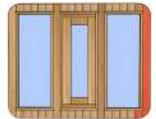
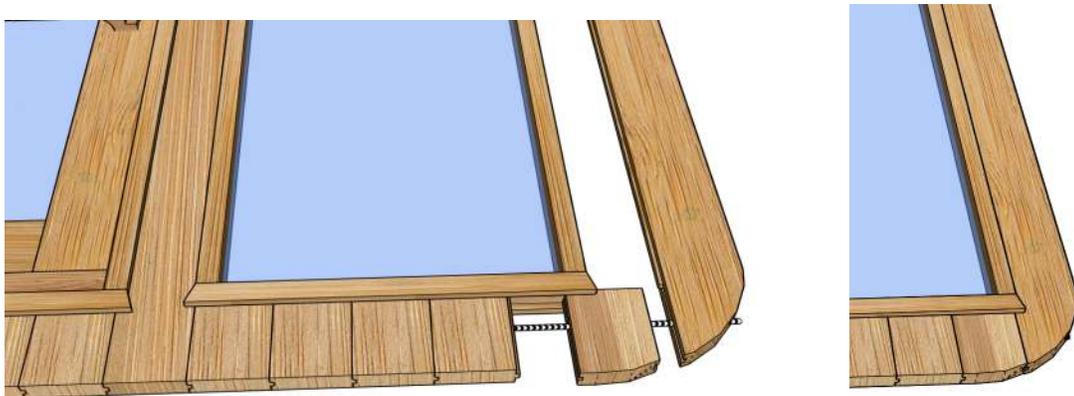
27



28

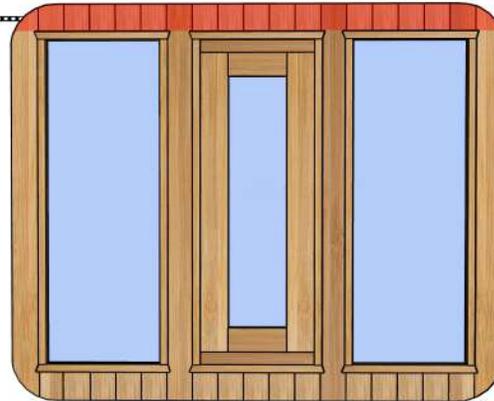


29



Front Wall Assembly

30



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

31



4X

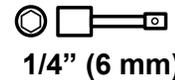


1/4" Wrench

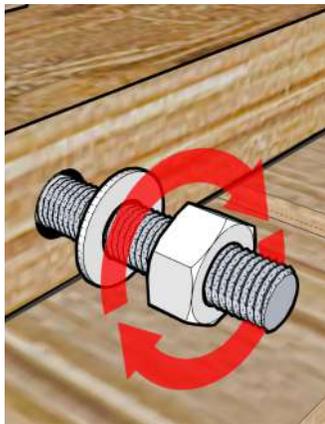
or



Adjustable



1/4" (6 mm)

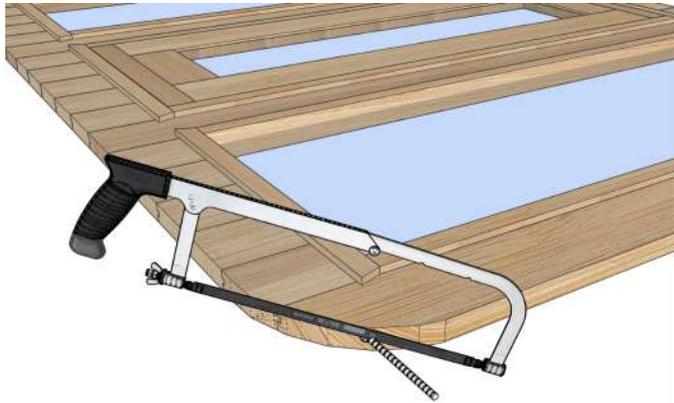


Add a washer and nut on the end of the threaded rod. Do this for both threaded rods at both ends. Tighten all threaded rods.



Front Wall Assembly

32



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

33



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



Front Wall Assembly

34



Recommended
two person job

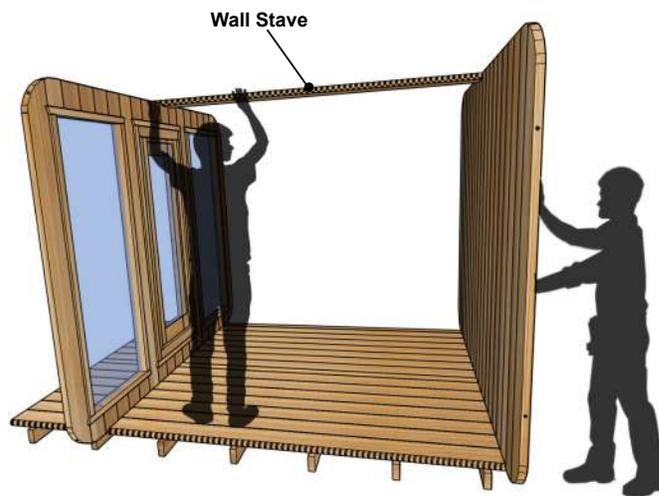


Using a helper, stand up the front wall and place in groove at the front of the sauna.
Ensure it is centered on either side of the floor platform.

35



Recommended
two person job

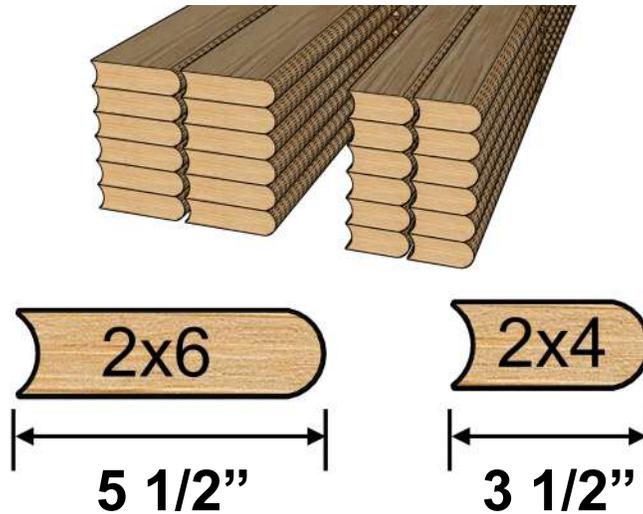


Repeat the process for the rear wall. Once both are centred in the grooves, use any wall stave to temporarily brace the walls to prevent them from falling. This will provide support while you build the side walls.



Side Wall Assembly

36



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

37

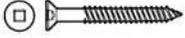


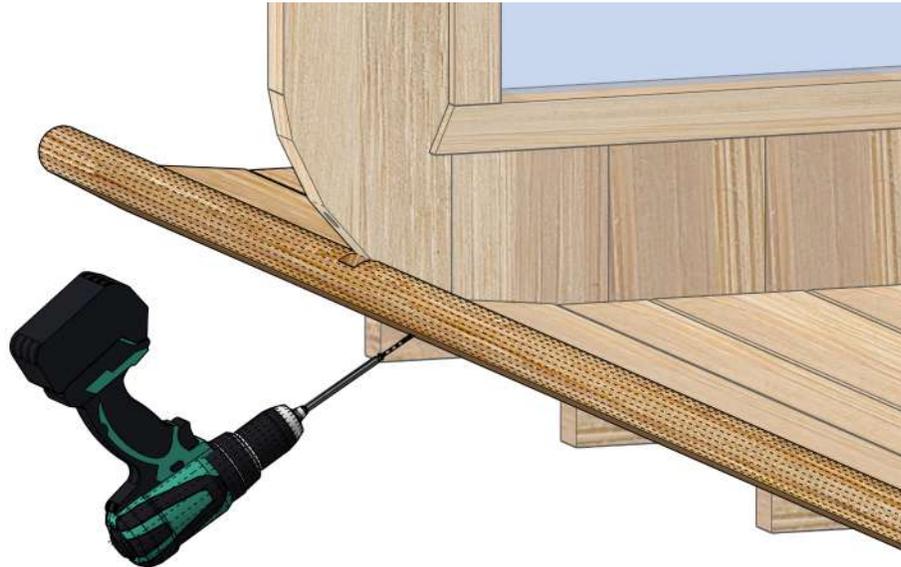
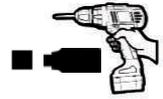
Install six of the thinner **2x4** corner staves along the corner bottom.
Use a mallet to position and tighten each stave to the wall.



Side Wall Assembly

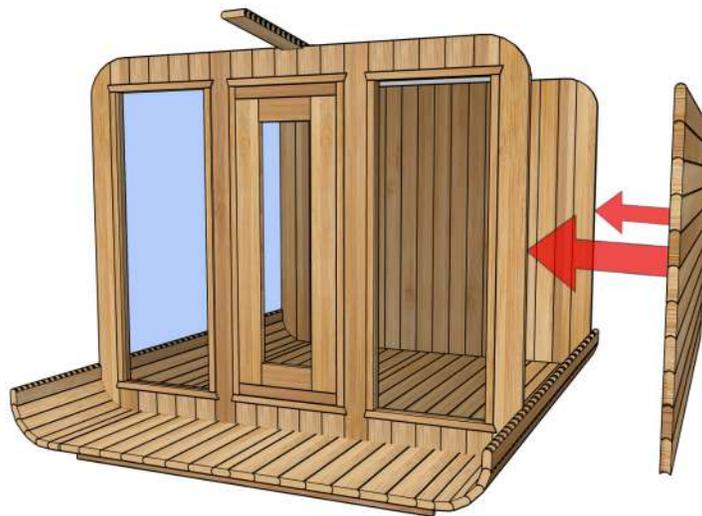
38

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



Fasten the six corner staves with a screw connecting to the edge of both sauna walls.
TIP: A 90 degree screw gun or attachment may be useful.

39



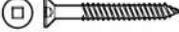
Once the top corners are installed, start installing eleven of the **2x6** wider staves along the sides of the sauna.

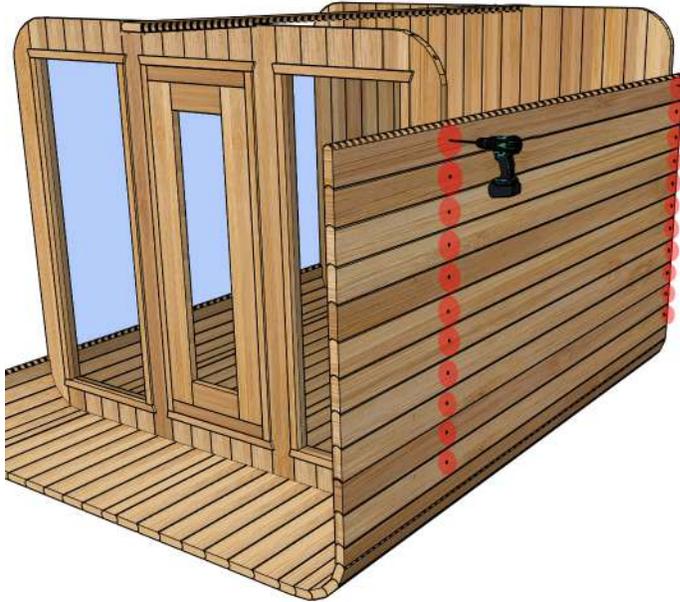
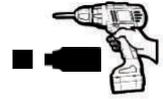


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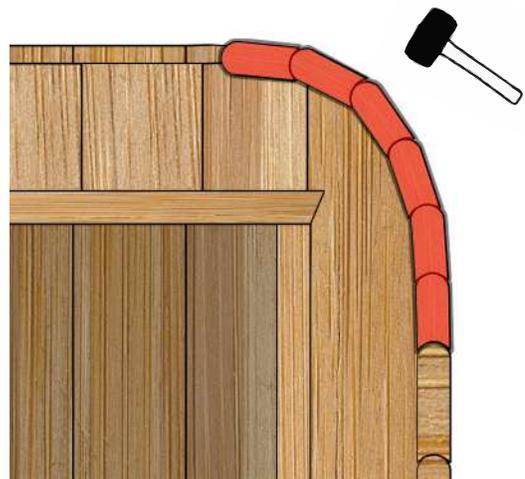


Side Wall Assembly

40  **22X**
2.5" (64mm) Robertson



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

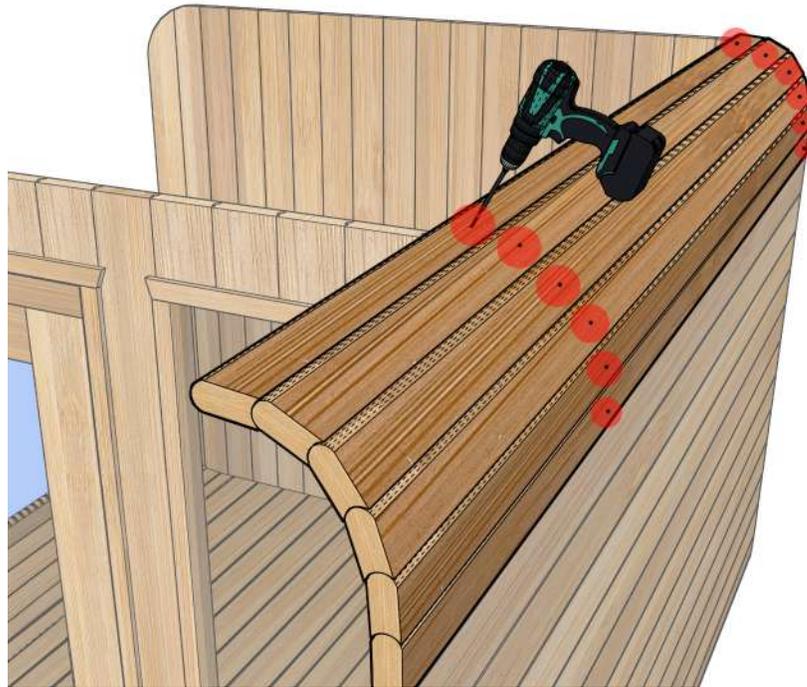
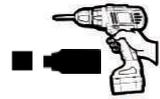


Install six of the **2x4** thinner corner staves along the corner top.
Use a mallet to position and tighten each stave to the wall.



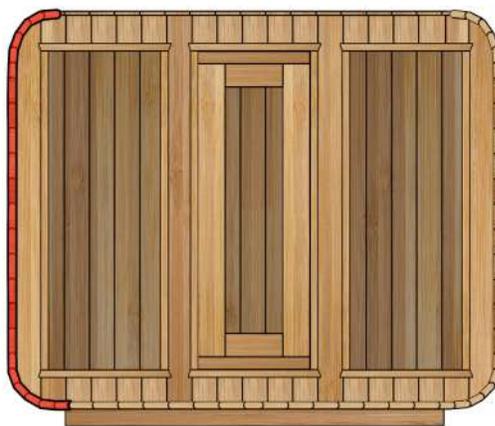
Roof Assembly

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



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

43



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



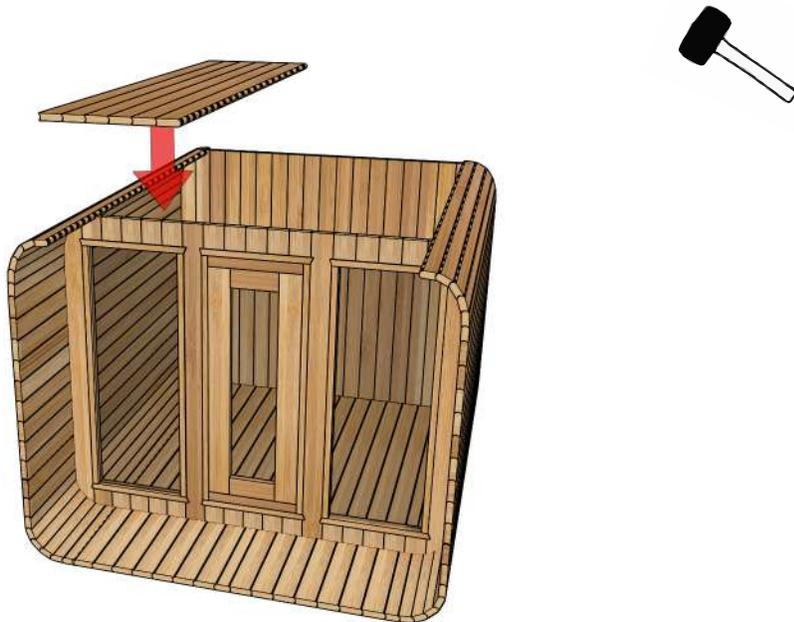
Roof Assembly

44



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

45

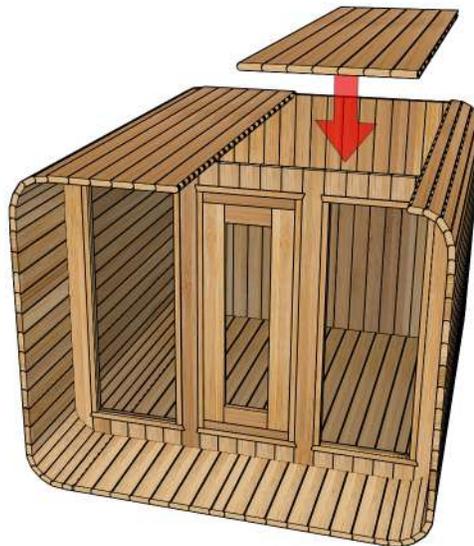


Install staves (**2x6**) on one side of the sauna working towards the middle of the roof.
When you reach close the middle of the roof stop.
Use a mallet as necessary to create a tight fit between staves but do not fasten any roof staves yet.



Roof Assembly

46

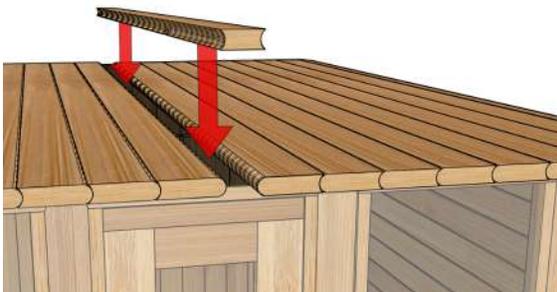


Continue installing staves (**2x6**) to the opposite side of the roof. When you reach close to the middle with a gap for one stave remaining, you may stop. Use a mallet as necessary to create a tight fit between staves but do not fasten any roof staves yet.

47



Center Stave Shape



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



Roof Assembly

48

Gap Between Staves



Staves Too Tight To Flatten



Staves Are Snug And Flat



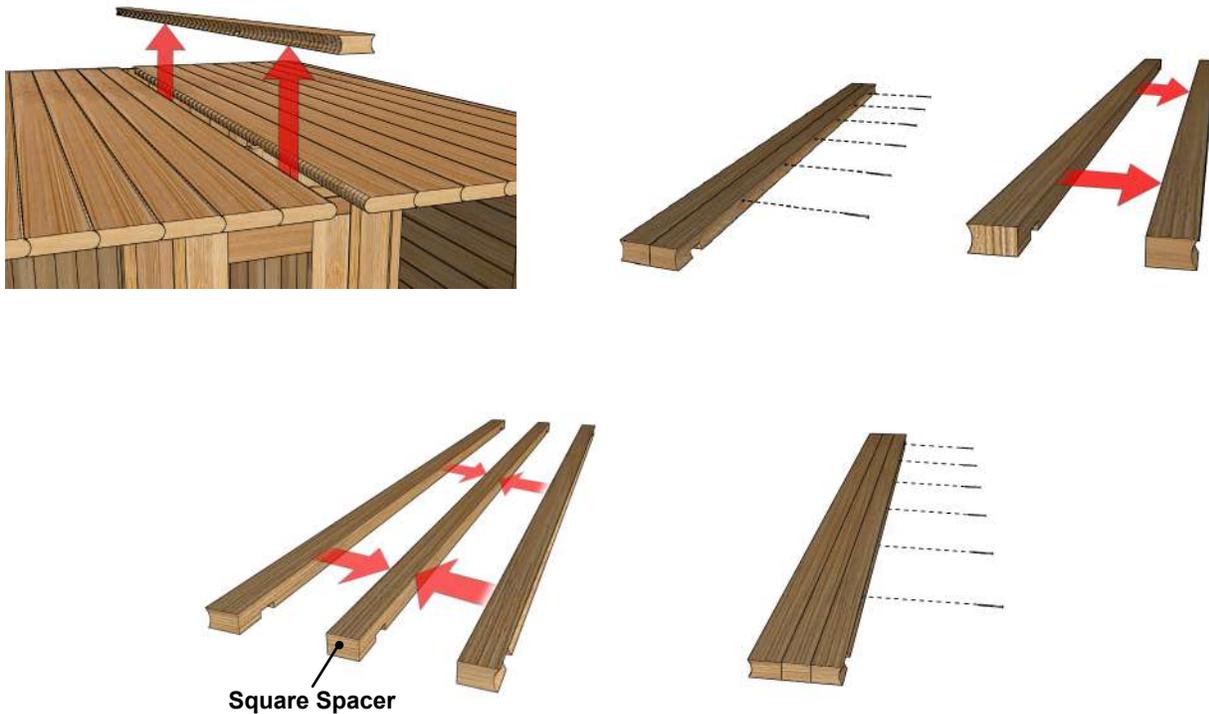
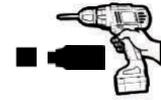
- If you experienced no problems with fitting the staves into the roofline then continue to **Step 52**.
- If the staves are too loose or there is a gap between the staves, you may need to add one of the spacer boards to the top stave. Continue to **Step 49A**.
- If your sauna staves are too tight to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



Staves Too Loose

49A

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



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

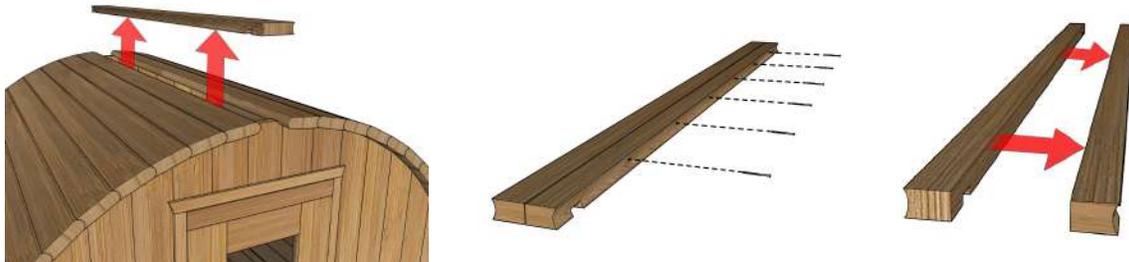
In your sauna package there is a square spacer the same length as the top spacer. Take this stave and position it between the two top stave pieces. Refasten all three pieces with the screws that held the top stave together. See image above for details. Continue to **STEP 51**.



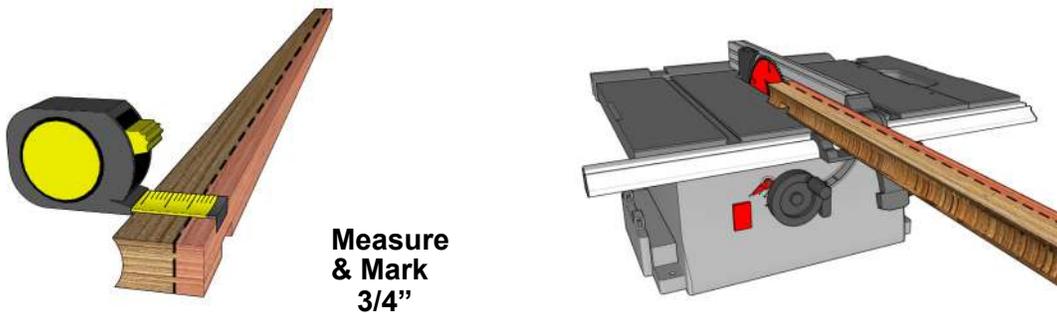
Staves Too Tight

50B

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

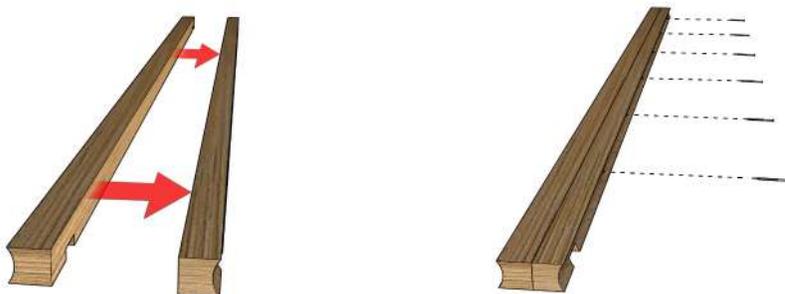


Begin by removing the top stave from the top of the sauna. The top stave is actually two pieces held together by screws. Begin by removing the screws holding the top stave together. Separate the stave into two pieces.



**Measure
& Mark
3/4"**

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

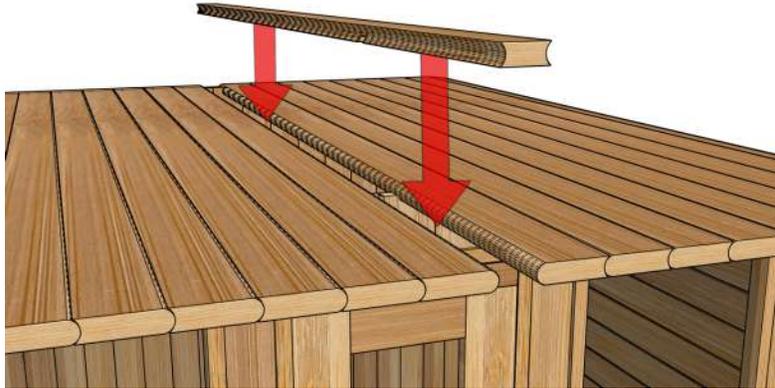


Refasten both stave pieces with the screws that held the top stave together. See image above for details. Continue to **STEP 51**.



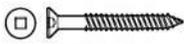
Roof Assembly Continued

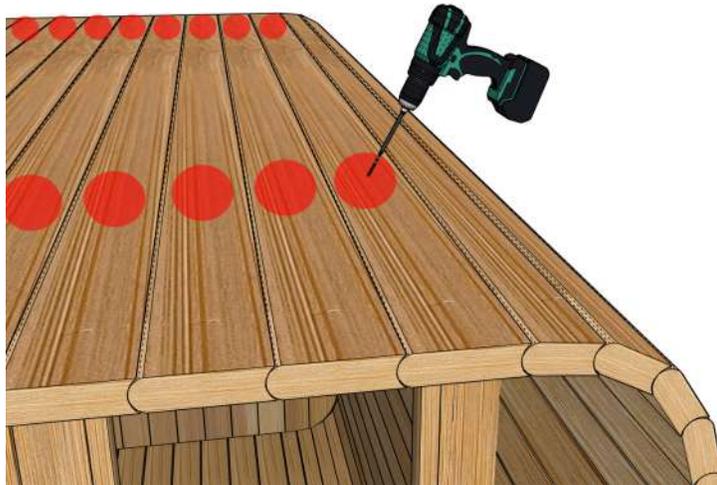
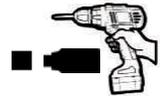
51



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

52

 **32X**
2.5" (64mm) Robertson

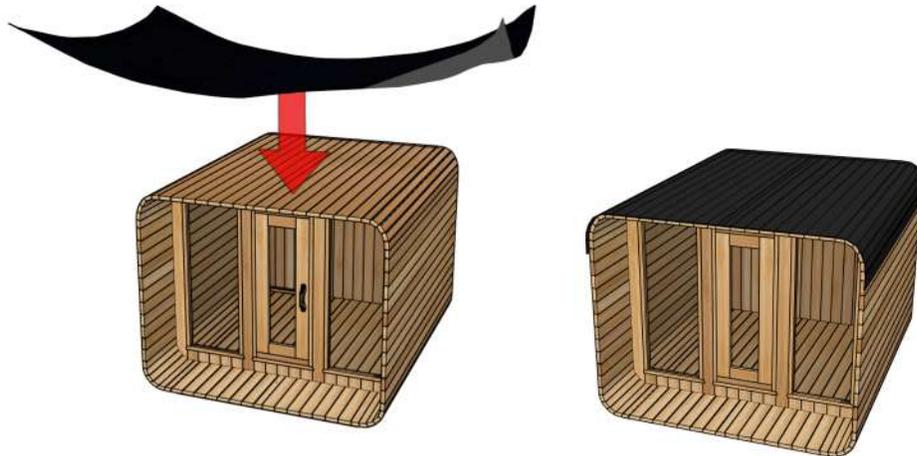


Secure all roof staves with screws into the front and back walls.



Roof Membrane Installation

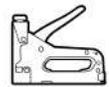
53



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

54

 1 1/4"
Staples



Fold the ends of the sheeting over and staple the ends of the side wall board to the sheeting. Do this for both the front and back of the sauna.



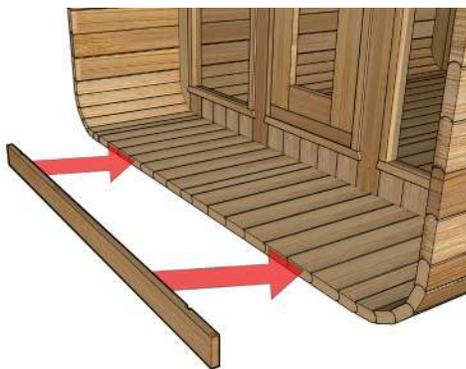
Trim Installation

55



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

56



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

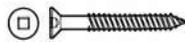


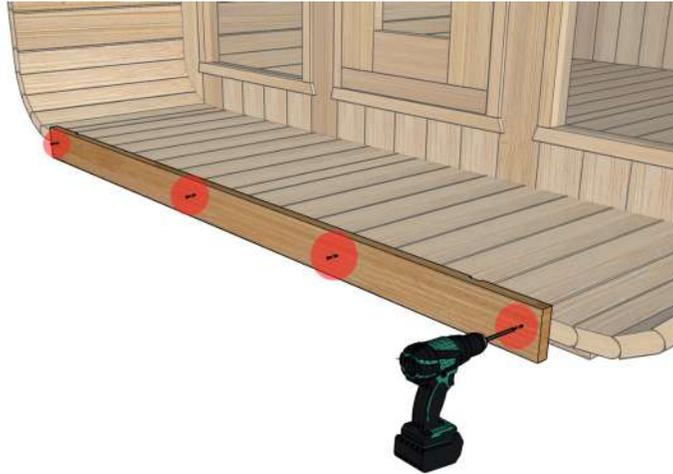
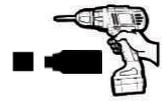
To install the sauna trim, start with the longest piece on the front bottom. Center this piece so the same distance is left on either side.



Trim Installation

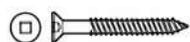
57

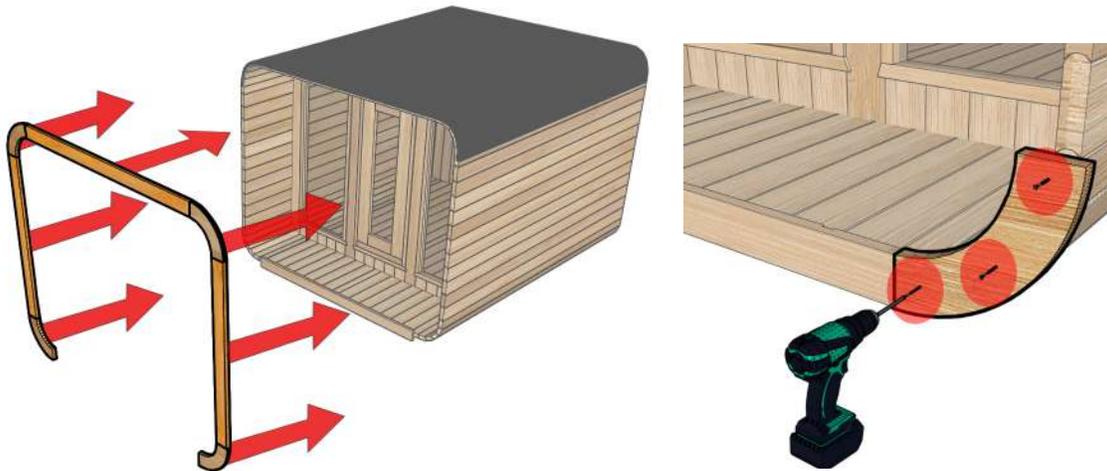
 **4X**
2" (51mm) Robertson



Secure the bottom trim board with screws.

58

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

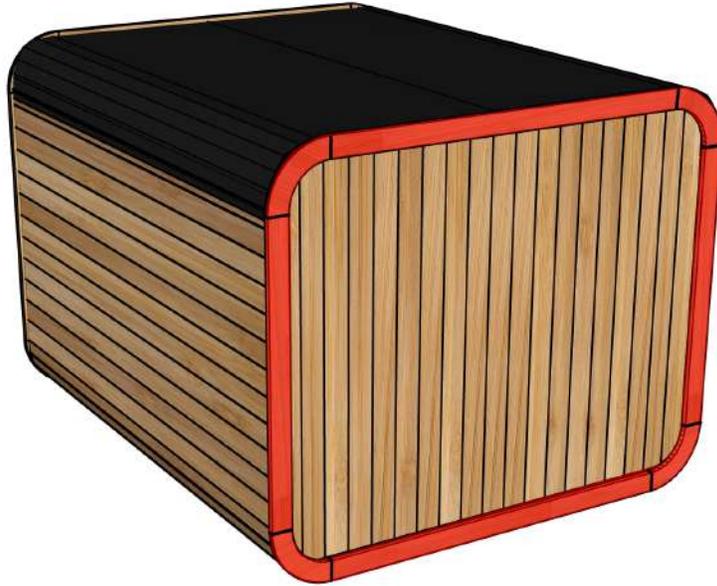


Continue placing and fasten the other trim pieces for the front of the sauna.
Use three screws for the corner trim and 4 screws in the side and top pieces spaced evenly.



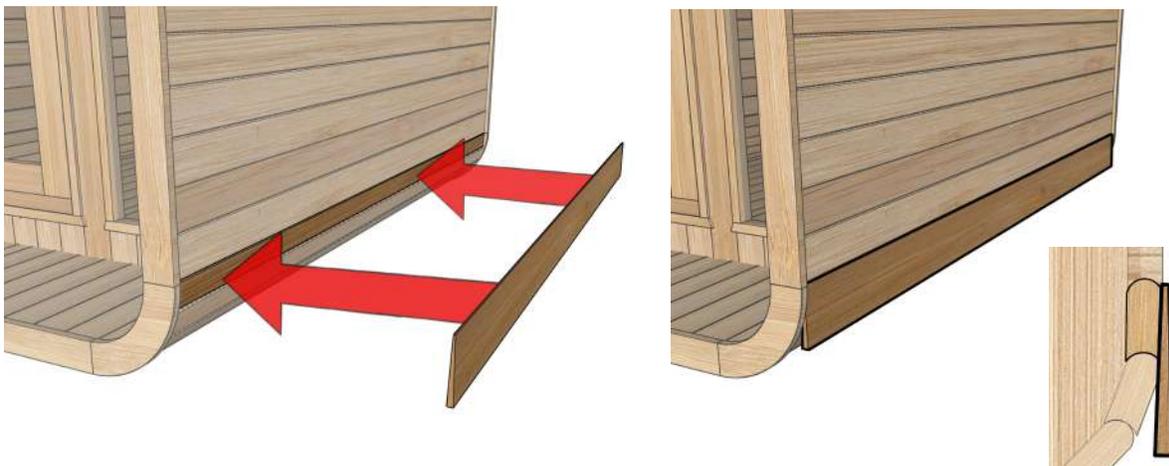
Shingle Installation

59



Repeat **STEP 57-58** for the trim on the rear of the sauna.

60

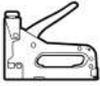


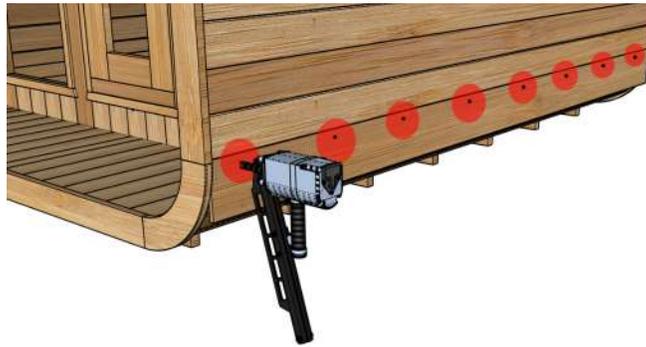
Begin placing the siding boards. Start at the bottom with the top of the siding flush with the bottom wall stave.



Shingle Installation

61 Finish Nails  or 1 1/4" 

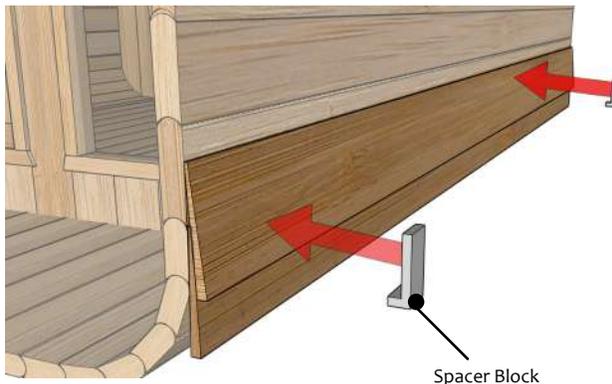
 or 



Secure with finish nails or staples across the top.
PLEASE NOTE: Do not go longer than 1 1/4" for staples or nails.

62 Finish Nails  or 1 1/4" 

 or 

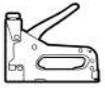


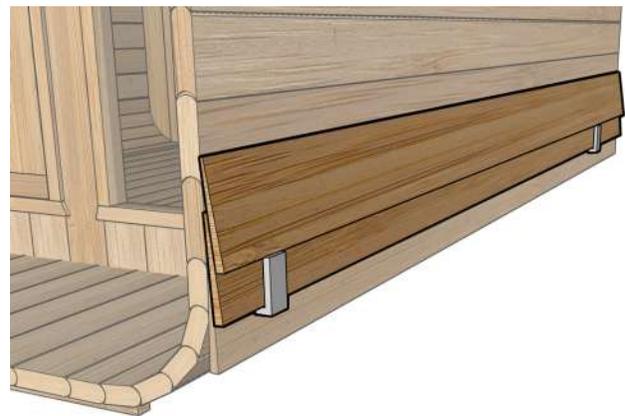
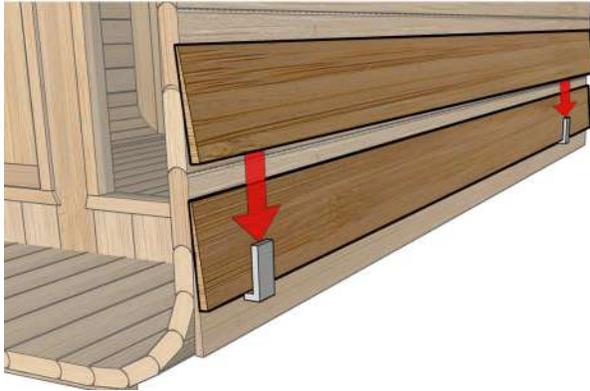
Use the provided spacer blocks to gauge the correct distance for spacing between each board. Position the spacer block underneath the last installed shingle. Do this for both sides of the board.



Shingle Installation

63 Finish Nails  or 1 1/4" 

 or 



Slide the next shingle on top of the spacer block for ends. This will determine where the shingle will be fastened. Continue using the space block adding/fastening shingles until the top of the sauna has been reached. Secure with finish nails or staples across the top.

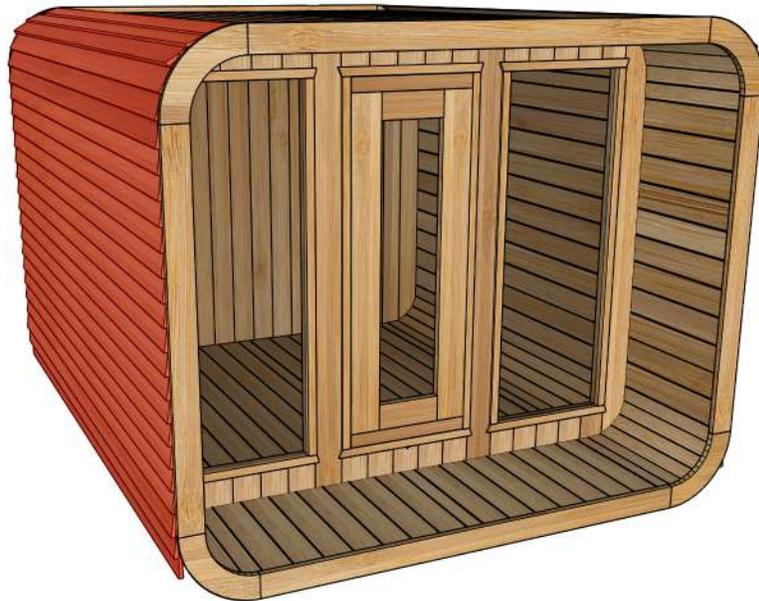


Scan the code for a video of the assembly process:



Door Handle Installation

64



Follow **Steps 60-63** for the shingle on the opposite side of the sauna.

65



Place the outer door handle at desired height.



66

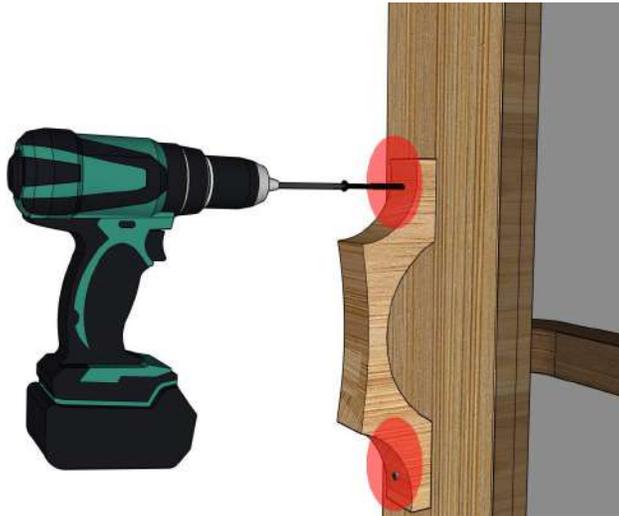


Ensure it is centred and secure with screws.



Door Handle Installation

67  **2X**
2 1/2" (64 mm) Robertson



Fasten with 2 screws in the pre-drilled holes .

68

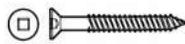


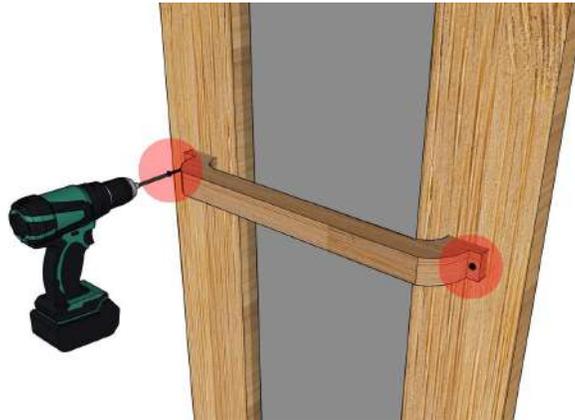
Place the inner door handle at desired height.



Bench Installation

69

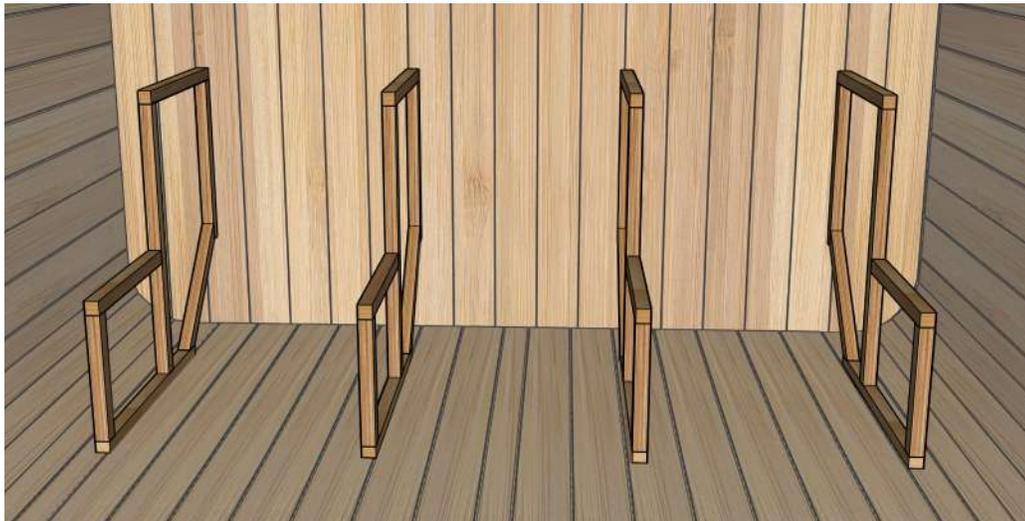
 **2X**
2 1/2" (64 mm) Robertson



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

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

70



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

Do not fasten yet.

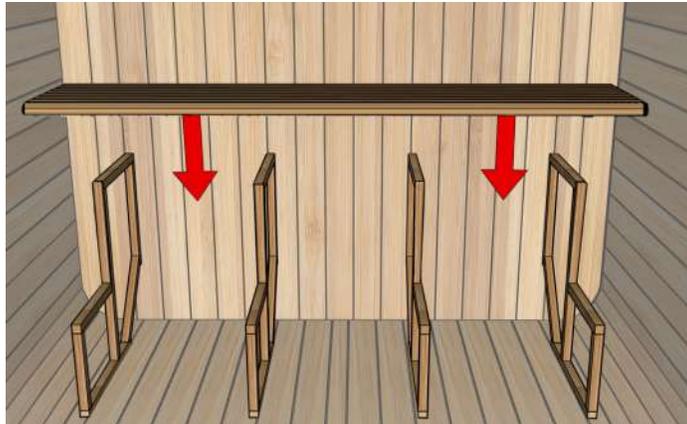


Scan the code for a video of the assembly process:



Bench Installation

71



Seat Support Bracket

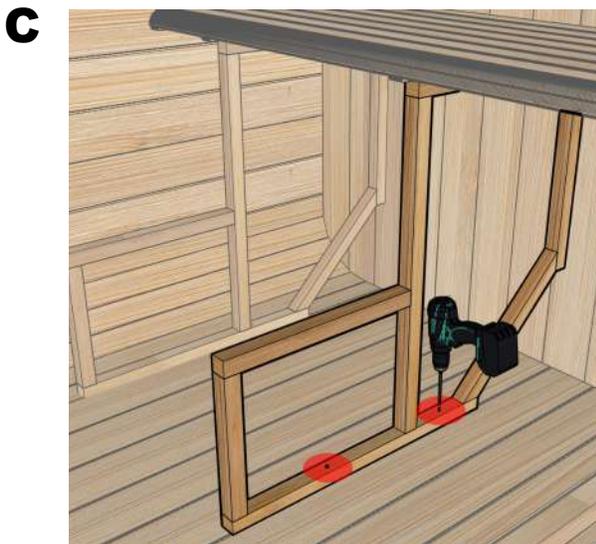
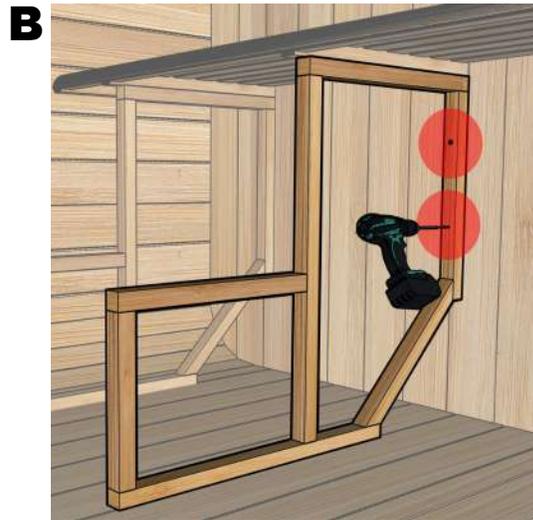
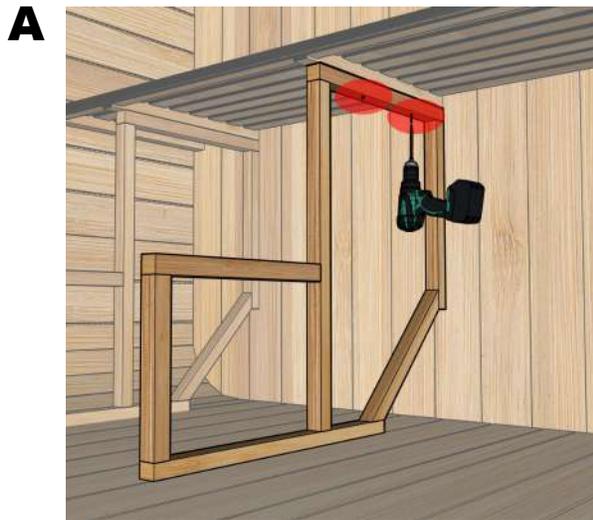
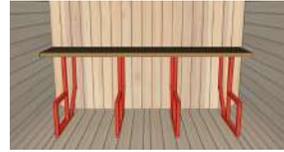
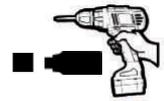
Bench Bracket

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



Bench Installation

72  **12X**
2 1/2" (64 mm) Robertson



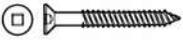
Fasten each of the four supports to the bench, rear wall and floor.

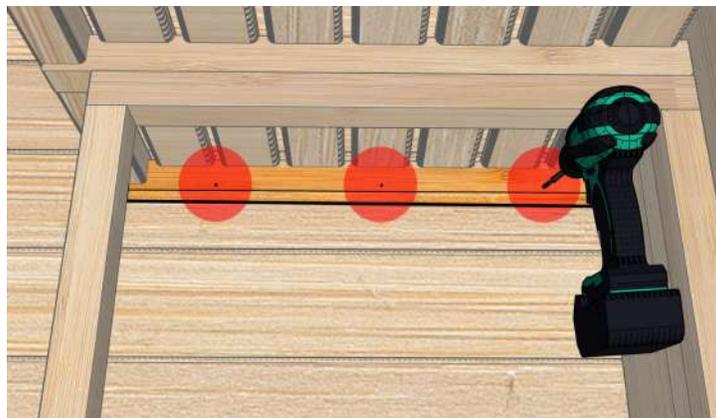
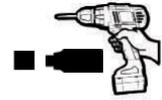


Scan the code for a video of the assembly process:



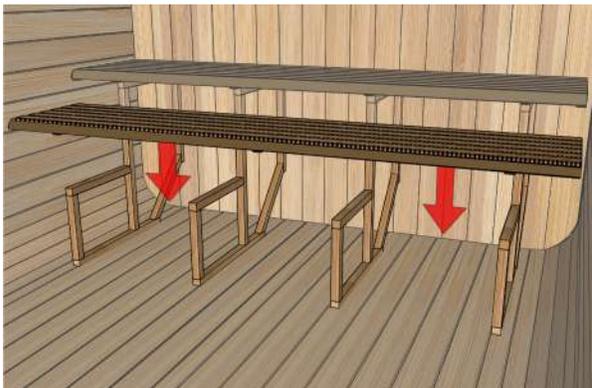
Bench Installation

73  **6X**
2 1/2" (64 mm) Robertson



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

74



Follow **STEP 72-73** for the lower bench fastening the bottom and sides of the bench top .

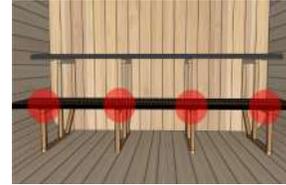


Scan the code for a video of the assembly process:



Bench Installation

75



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

76



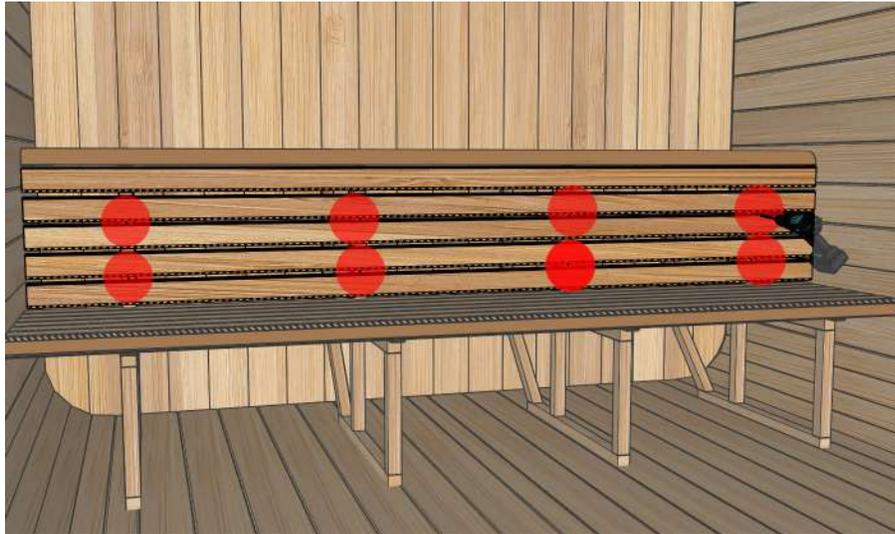
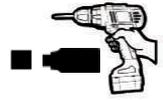
Position the front enclosure on the bench.



Bench Installation

77

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



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

78



Follow **STEPS 76-77** for installing the bottom enclosure.

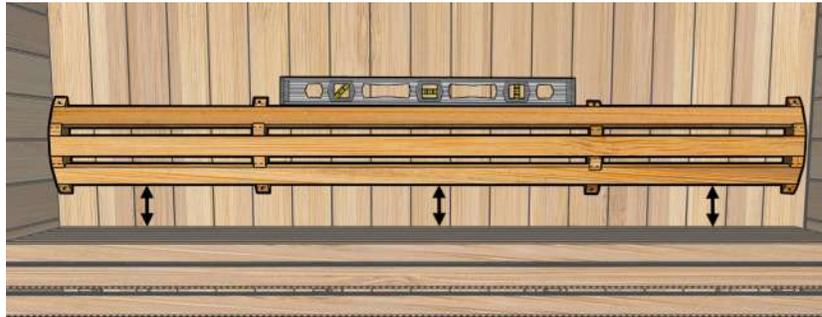


Scan the code for a video of the assembly process:



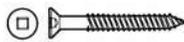
Bench Installation

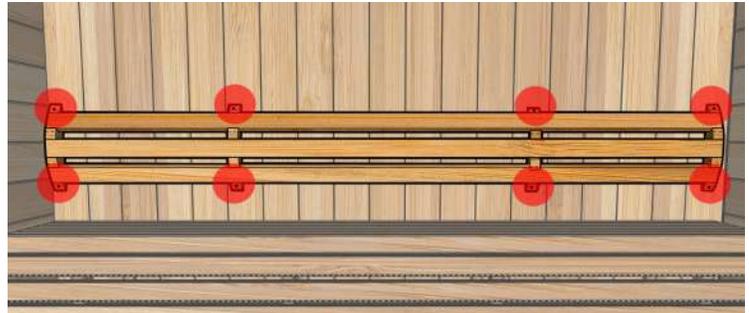
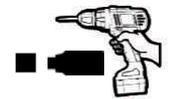
79



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

80

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



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



Scan the code for a video of the assembly process:

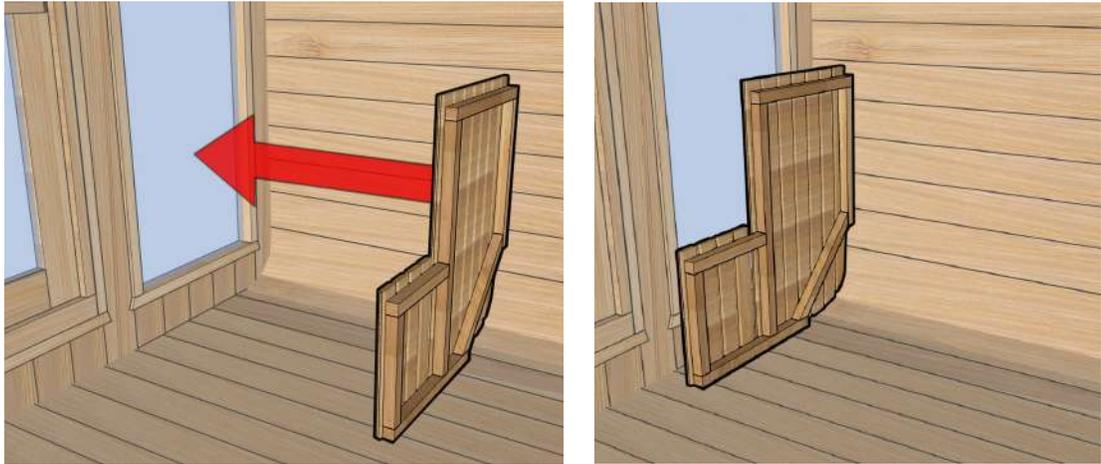


L Bench Installation



Follow **STEPS 81-88** if you are installing an “L” bench assembly

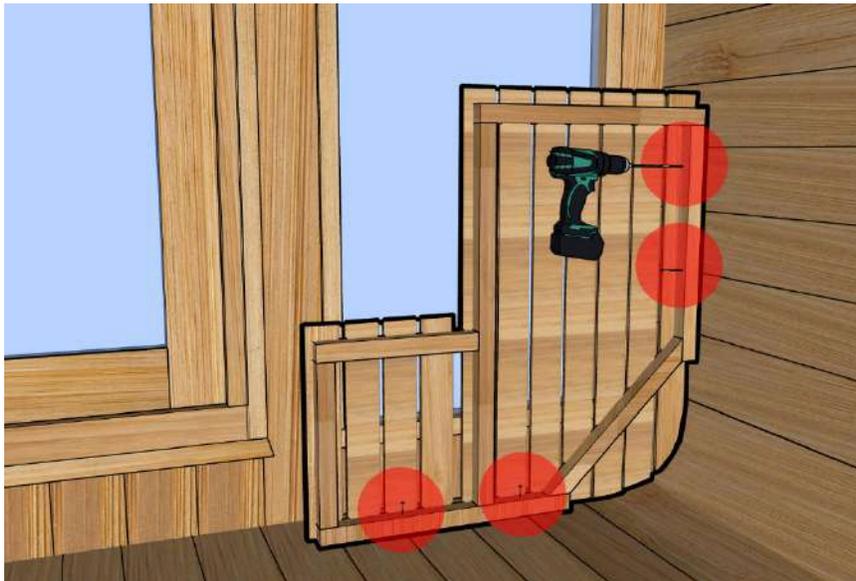
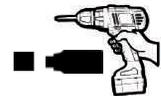
81



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

82

 **4X**
2 1/2" (64 mm) Robertson



Fasten the enclosed side bench support with screws.

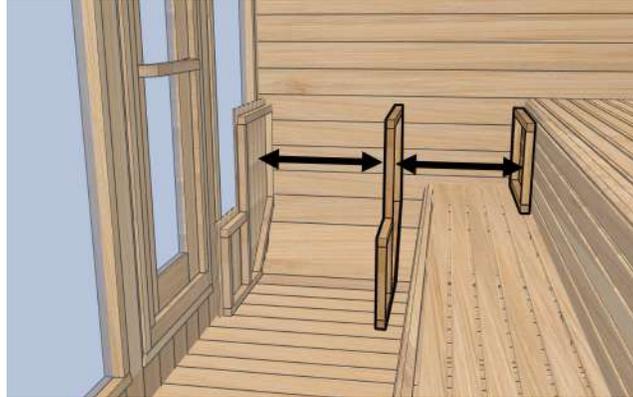


Scan the code for a video of the assembly process:



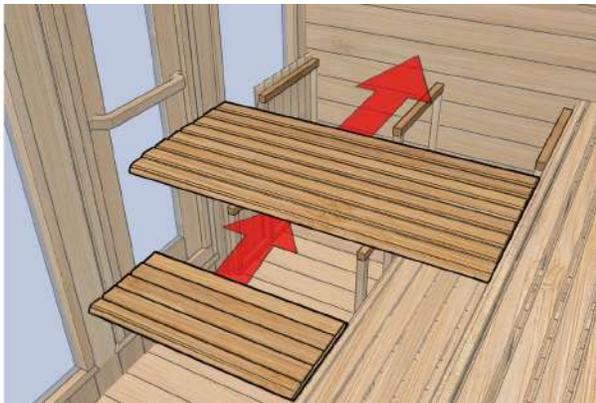
L Bench Installation

83



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

84

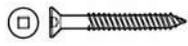


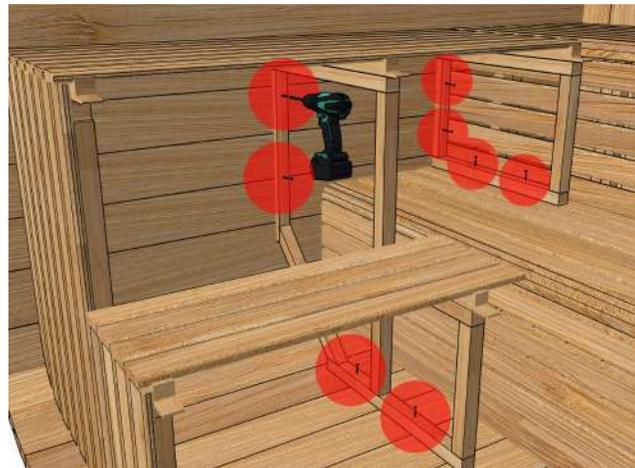
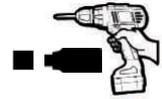
Place the the bench tops on to the bench supports.
Line the bench supports up with the seat support bracket on the bottom of bench.



L Bench Installation

85

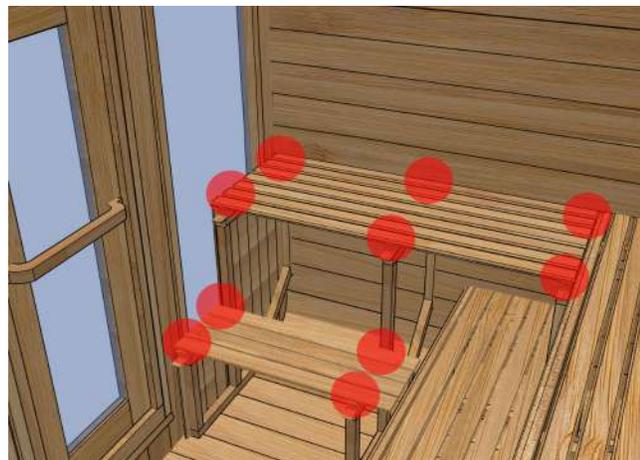
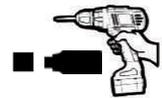
 **8X**
2 1/2" (64 mm) Robertson



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

86

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

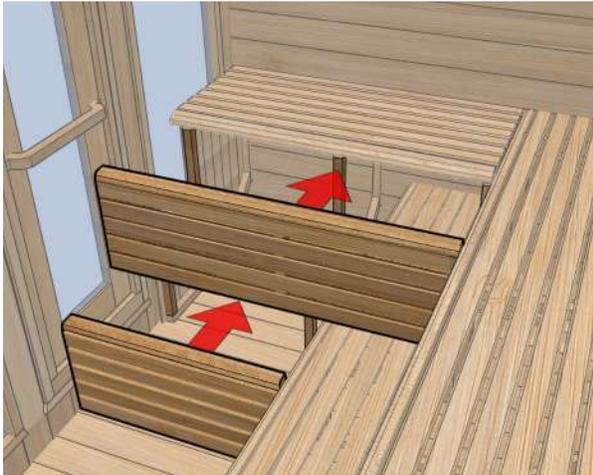


Fasten the bench bracket to the bottom of the bench top.



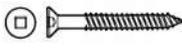
L Bench Installation

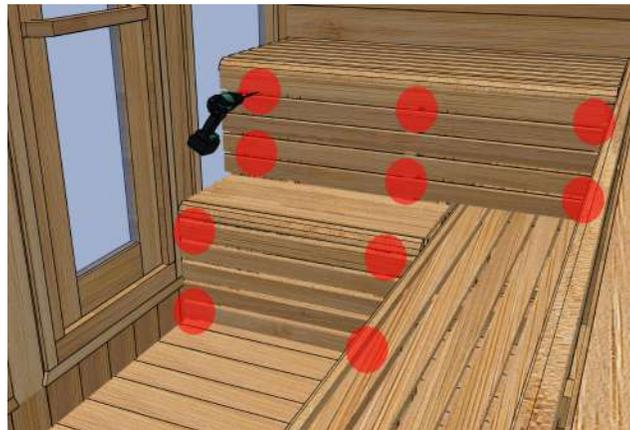
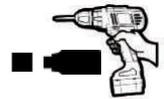
87



Position the front bench enclosures.

88

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



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

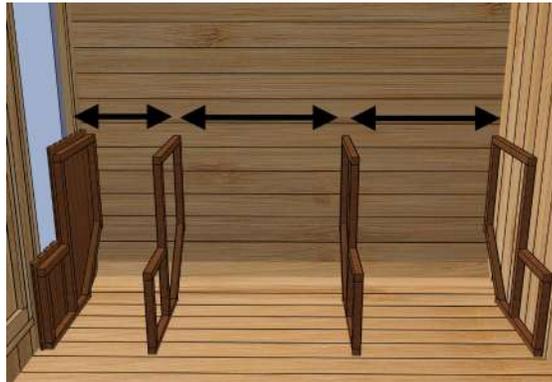


Side Bench Installation



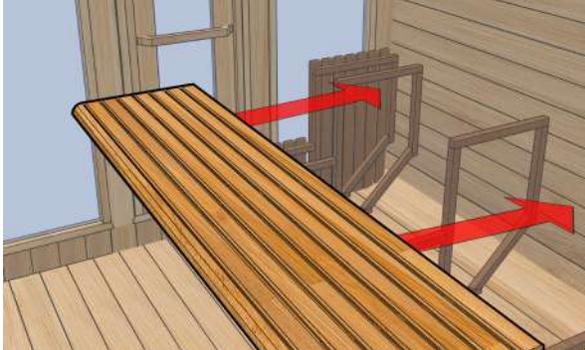
Follow **STEPS 89-98** if you are installing a side bench assembly

89



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

90



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



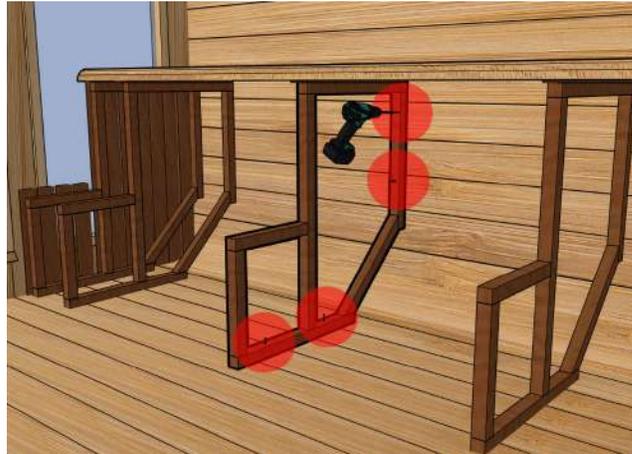
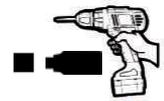
Scan the code for a video of the assembly process:



Side Bench Installation

91

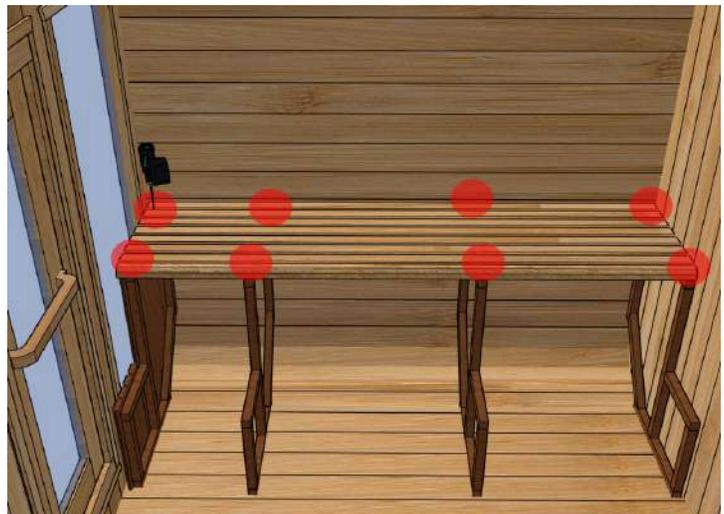
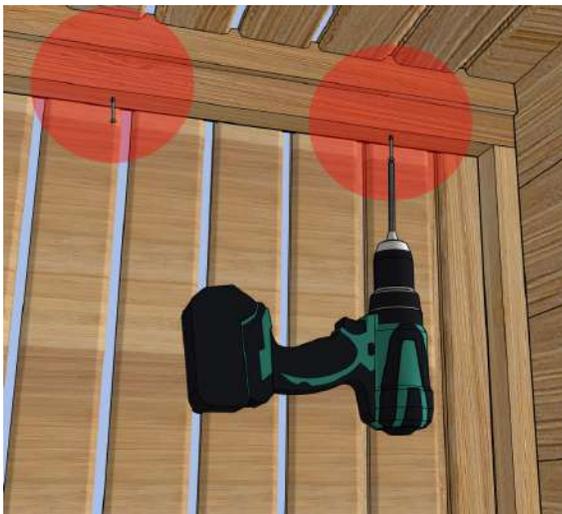
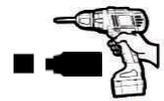
 **16X**
2 1/2" (64 mm) Robertson



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

92

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

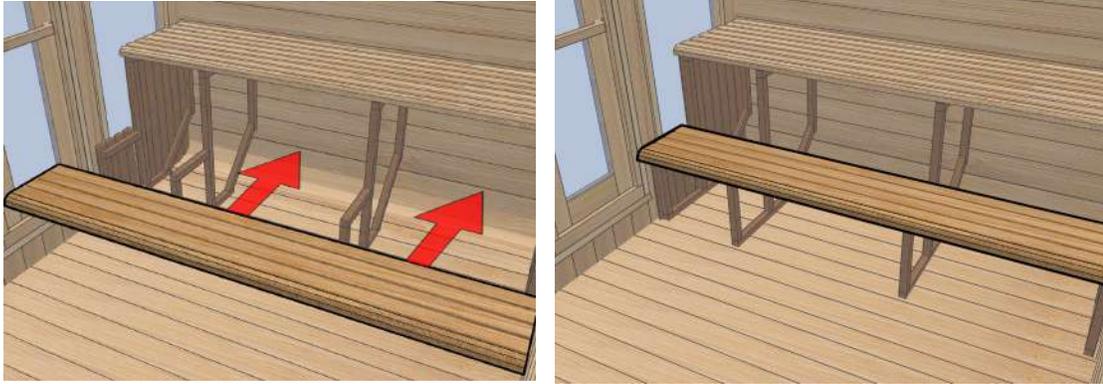


Fasten the bench bracket to the bottom of the bench top.



Side Bench Installation

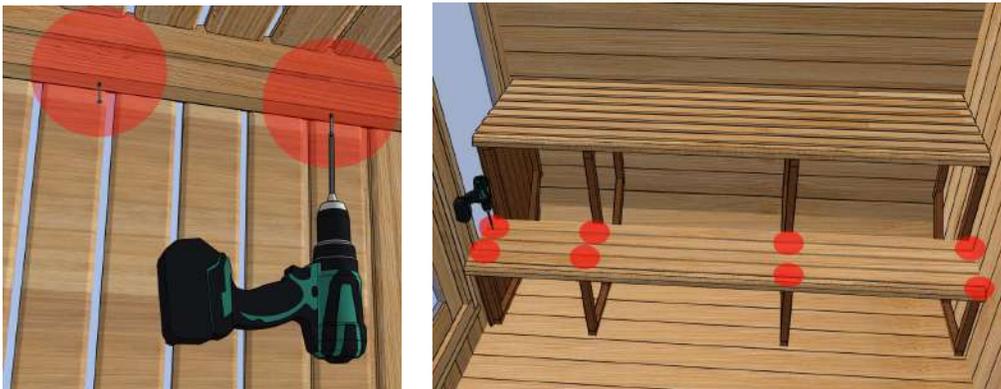
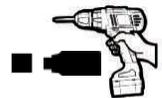
93



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

94

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

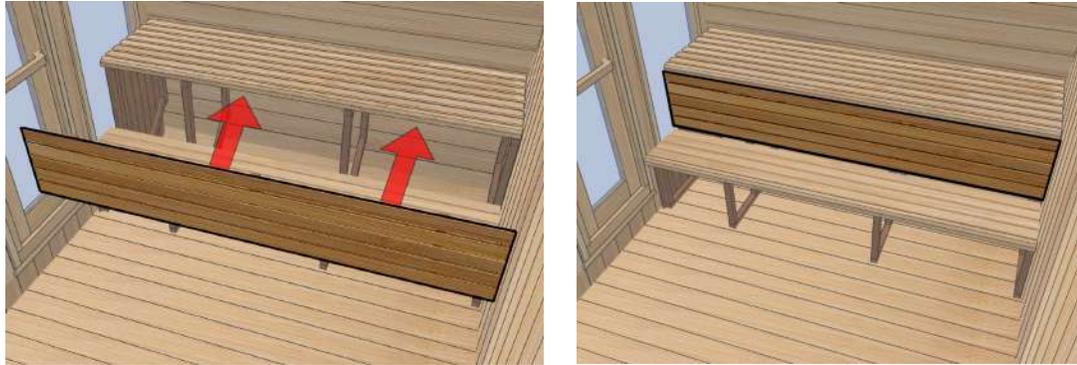


Fasten the bench bracket to the bottom of the bench top.



Side Bench Installation

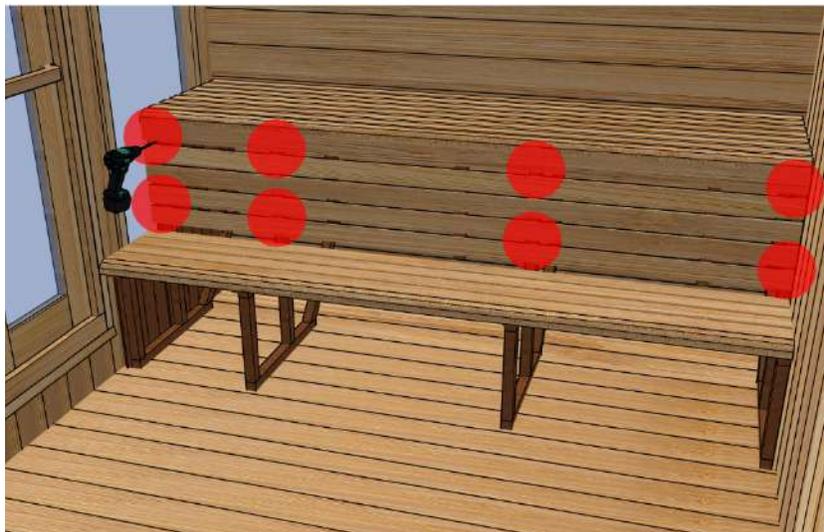
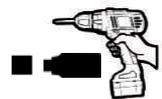
95



Position the front bench enclosures.

96

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



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



Side Bench Installation

97



Follow **STEPS 95-96** for the front bench enclosure for the bottom of the bench.

98

Follow **STEPS 79-80** for the back rest to be placed on the side wall.



Follow **STEPS 99-106** if you are installing an lounge bench assembly



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

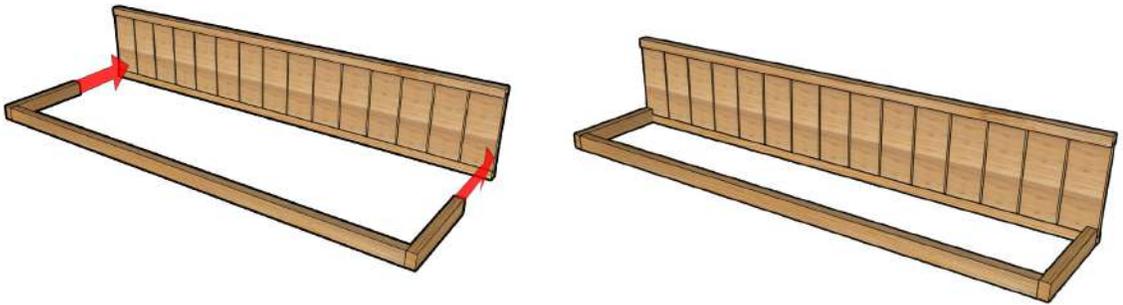


Scan the code for a video of the assembly process:



Lounge Bench Installation

99

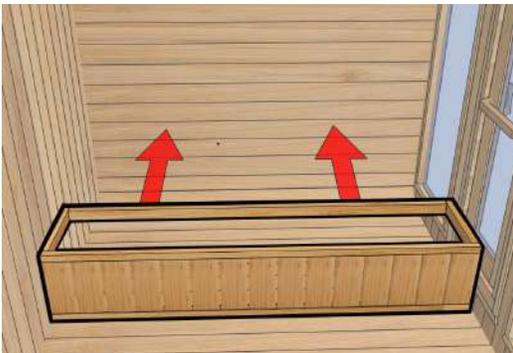


100

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



101



Position the frame against the wall.

Scan the code for a video of the assembly process:



Lounge Bench Installation

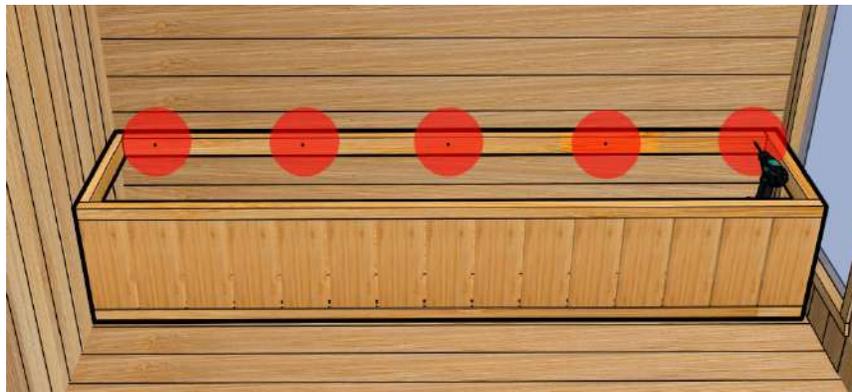
102



Ensure the frame is level before fastening.

103

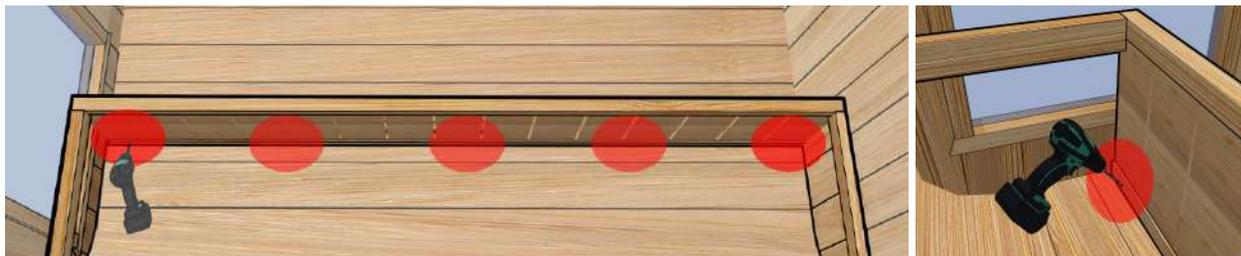
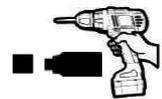
 **5X**
2 1/2" (64 mm) Robertson



Fasten the frame to the sauna with screws.

104

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



Fasten the bottom frame to the sauna with screws.

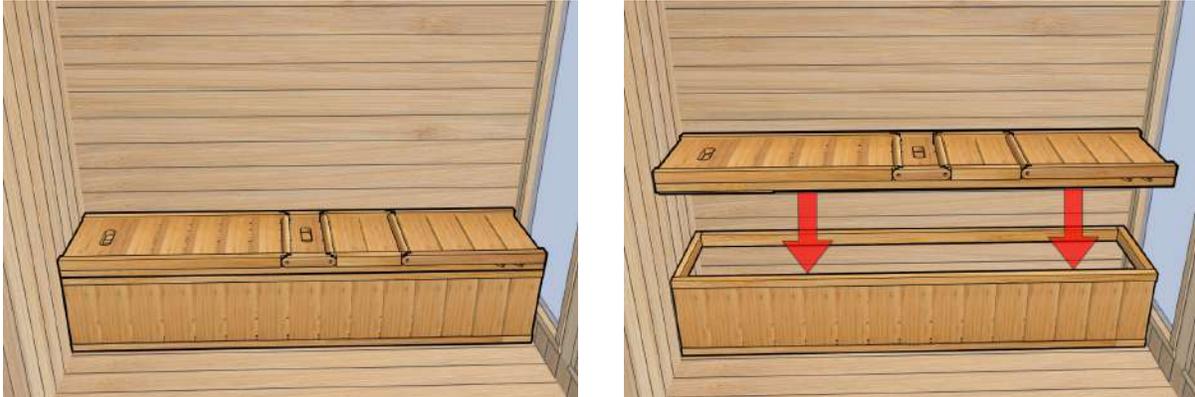


Scan the code for a video of the assembly process:



Lounge Bench Installation

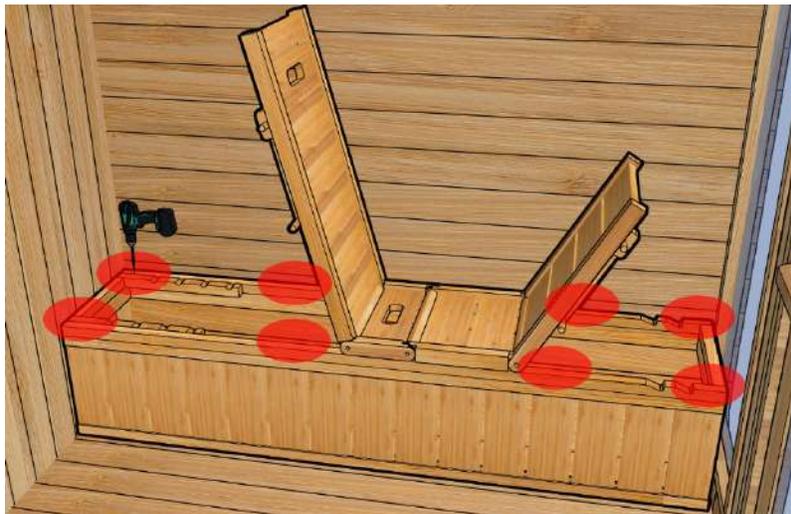
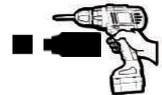
105



Place the assembled lounge bench onto the frame.

106

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



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



Exterior Bench Installation



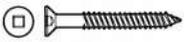
The exterior bench instructions are for Luna models with porches only.

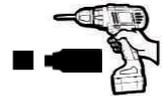
107



Identify the top and bottom sections for both porch benches.

108

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



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



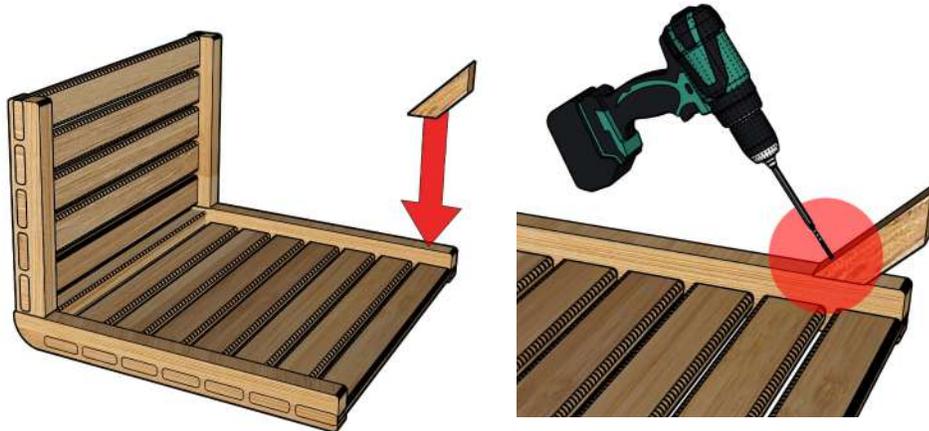
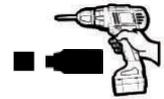
Scan the code for a video of the assembly process:



Exterior Bench Installation

109

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



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



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

110



Repeat **STEP 109** for installing the second gusset on the opposite side of the bench.

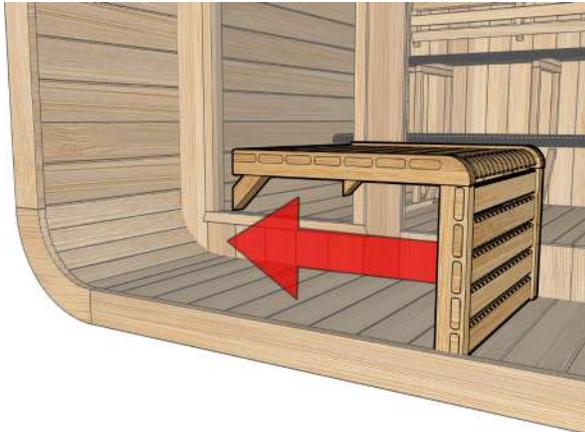


Scan the code for a video of the assembly process:



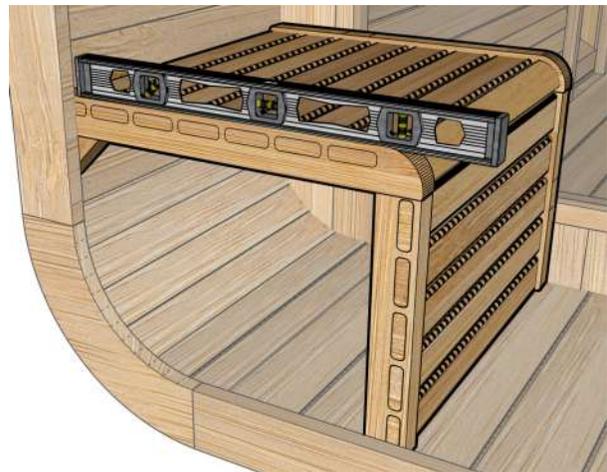
Exterior Bench Installation

111



Fit the bench between the front window and the trim.

112



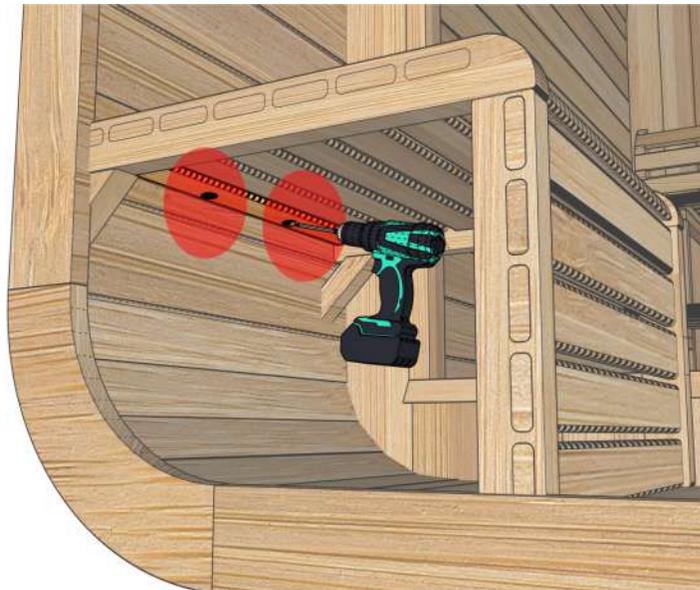
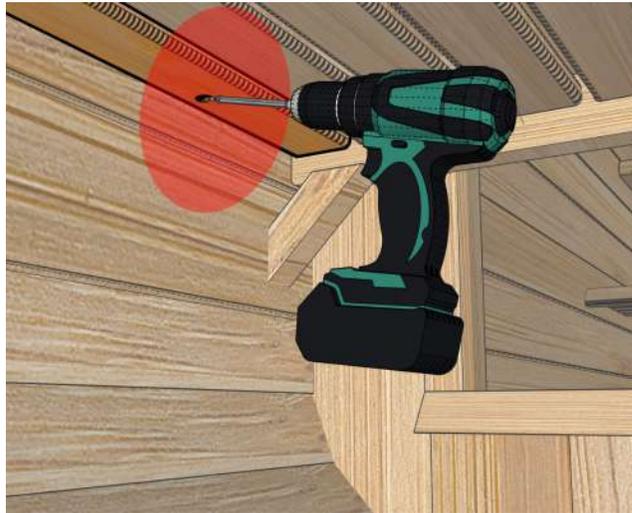
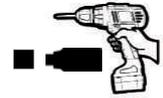
Ensure the bench is level before fastening the bench.



Exterior Bench Installation

113

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



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

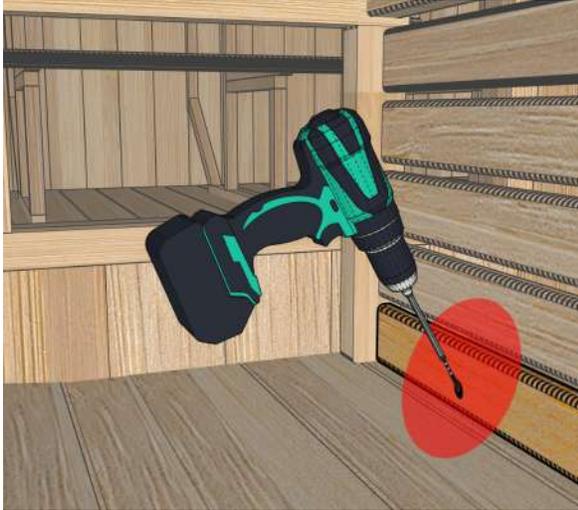
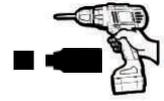


Scan the code for a video of the assembly process:



Exterior Bench Installation

114  **2 X**
2 1/2" (64 mm) Robertson



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

115

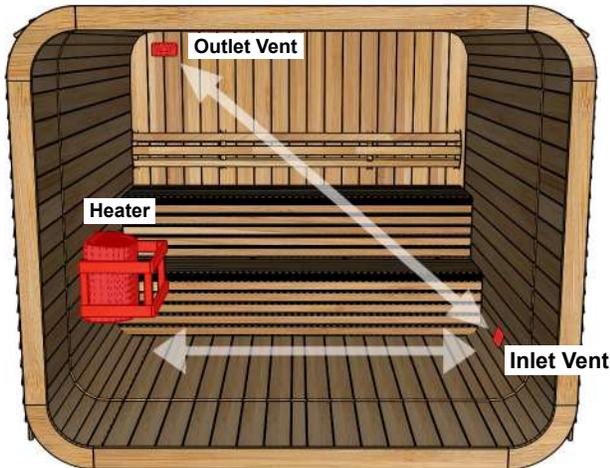


Repeat **STEPS 107-114** for the second bench.

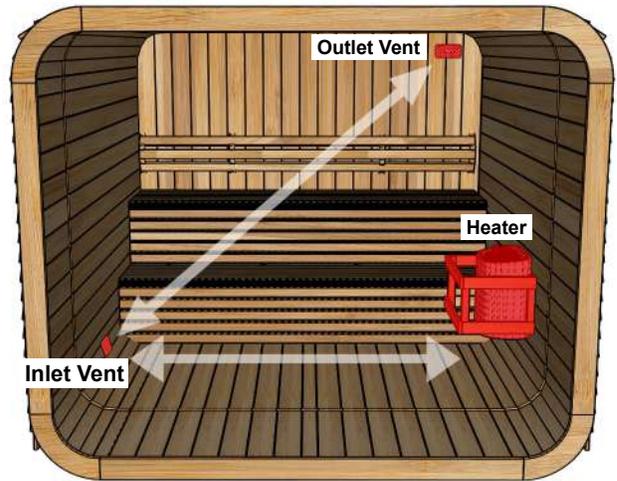


Vent Installation

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



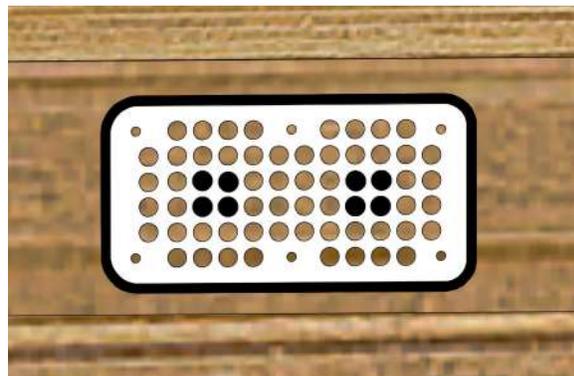
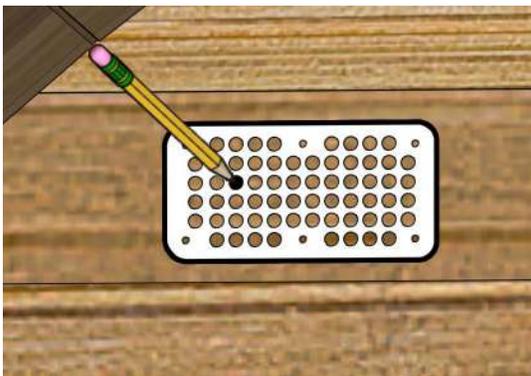
Setup A



Setup B

Place the inlet vent in the lower corner opposite to the heater in the sauna.
Place the outlet vent in the upper corner opposite to the inlet vent.

116



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



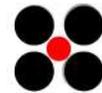
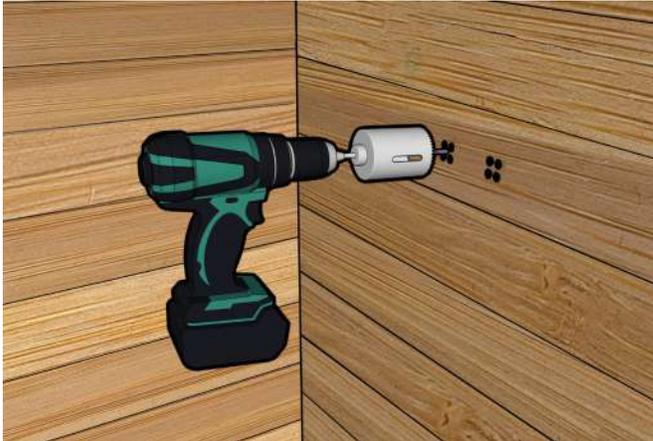
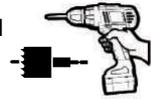
Scan the code for a video of the assembly process:



Vent Installation

117

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



Remove the vent cover and use a two inch hole saw to add two holes side by side for the vent. Create a hole between the four pencil marks etched on the wall from **Step 116**.
PLEASE NOTE: Only drill half way through the wall to avoid splintering the wood.

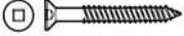
118

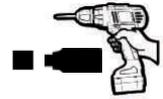


Continue drilling out the holes from the outer wall of the sauna.
On the outer wall of the sauna position put the vent cover over the two holes.



Vent Installation

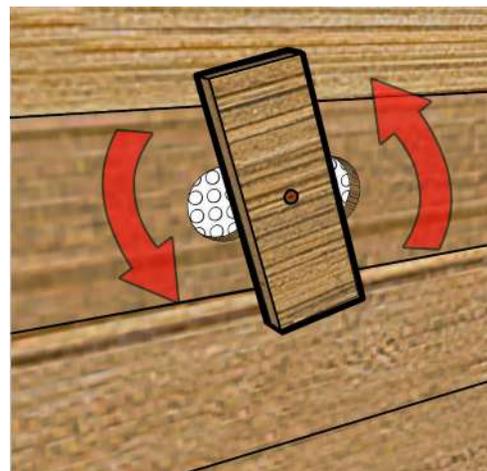
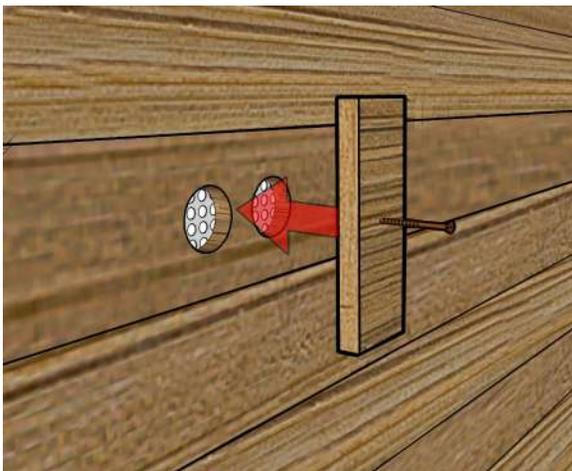
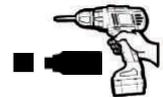
119  **6X**
Provided screws



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

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

120  **1X**
1 1/2" (38 mm) Robertson



Add a screw to the provided wooden block in the pre-drilled hole.
Position and fasten the block between the two cut-out holes.

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



Vent Installation

121



Install the inlet vent in the lower corner opposite to the heater in the sauna.
Use **STEPS 116-119** as a guideline for installation.

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

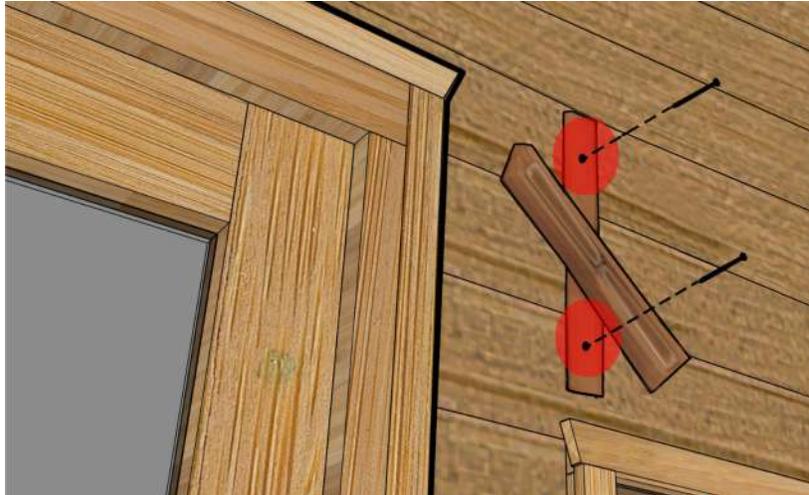
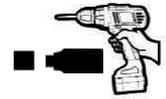
That concludes the basic instructions for the
Dundalk Luna Sauna with front porch.
If you have any accessories left to install or will be in the near
future please continue on to the next section.
We hope you enjoy your sauna.



Accessory Install Section

Sand Timer (Optional)

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

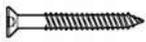


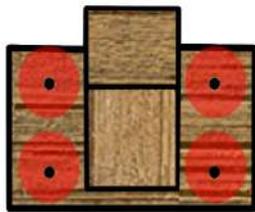
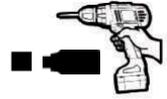
Place the sand timer in the desired location and secure with screws in the pre-drilled holes. Ensure it is in position and level so it may rotate without hitting the wall.



Accessory Install Section

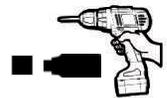
Towel Hook (Optional)

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



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

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



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



Accessory Install Section

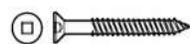
Thermometer (Optional)

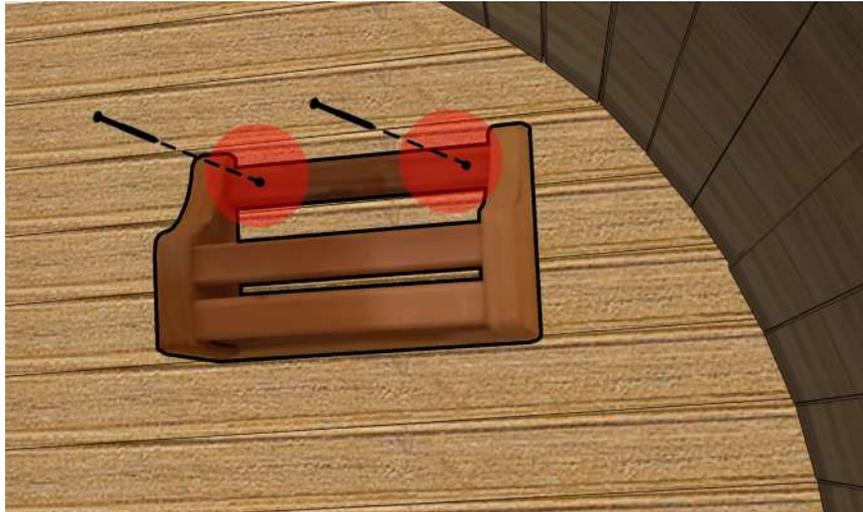
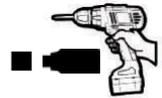
 **1X**
Nail



Place thermometer in desired location and secure with the provided nail.
PLEASE NOTE: The thermometer should be placed in a location away from the heater

Shelf (Optional)

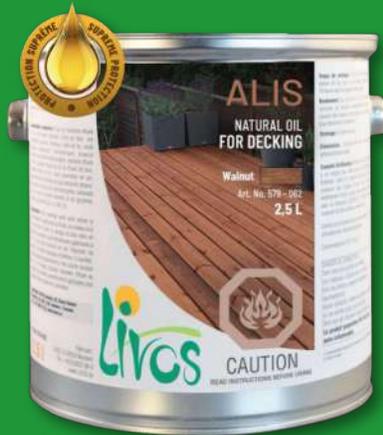
 **2X**
2 1/2" Robertson



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



INTRODUCING OUR SAUNA STAINS & FINISHES



ALIS NATURAL OIL FOR EXTERIOR WOOD

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



Sesame



Light Teak



Elm Dark Brown



Black



MELDOS NATURAL OIL FOR SAUNA INTERIORS

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

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



Scan the code for a video of the assembly process:



Maintaining Your Sauna After Installation

INTERIOR

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

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

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



EXTERIOR

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

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

WATER SEEPAGE

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



Scan the code for a video of the assembly process:





5 Year Residential Limited Warranty Policy

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

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

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

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

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

LIMITED WARRANTY

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

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

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

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

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

Phone: 888-923-9813 Email: support@leisurecraft.com

Please ensure you fill out your warranty card!





Leisurecraft

— BUILDING LUXURY —



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