

Luna Sauna

Assembly Instructions



Requirements:

2 People (recommended)

Carpenter Level

Carpenter Square

Step Ladder

Cordless Drill

¼" Nut Driver

11mm Socket

Vice Grips

Tape Measure

Staple Gun

Utility Knife

Rubber Mallet

1 ½" staples , screws or nails to fasten siding

[View the assembly proces:](#) 

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Luna Sauna Assembly Instructions

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Luna Sauna Assembly Instructions

Sauna Base Preparation

Make sure 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 any of the following.



Concrete Pad



Wooden Deck



Crushed Gravel



Patio Stones/Paver Blocks

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

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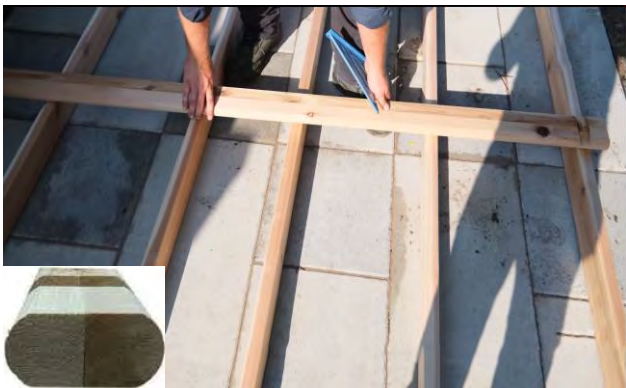
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Luna Sauna Assembly Instructions

Sauna Assembly



Make sure you have a solid base for your Luna sauna and lay out the floor joists.



Lay out the center stave as shown.

This stave will have convex edges on both sides as in inset.1.



Inset. 1



Center the bottom stave ensuring the dado cuts are facing upwards.

It should stick over the front floor joist 2" (51mm)



Using 2 ½" (64mm) screws , secure the center stave to the floor joist.

Repeat at the rear of the sauna.

Space out the remaining floor joists evenly, measure them to center and secure the center stave to the joists using a 2 ½" (64mm) screw per floor joist.

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Luna Sauna Assembly Instructions

Sauna Assembly



Start laying out the bottom staves, there will be 7 staves on either side of the center stave.

The staves for the Luna without the porch option are symmetrical and can be used on the left or right side of the center stave and if a porch option is chosen, there will be left and right sides.



Line up the staves so they are flush to each other.

All of the grooves should line up with each other.



Use a rubber mallet to tap all the staves tight together.

Secure staves into each floor joist using 2 ½ (64mm) screws.



Gather up your pieces for the back wall.

This should consist of 15 straight pcs and 4 pcs with rounded corners of 2x6x80" (5cm x 15cm x 203cm)

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Sauna Assembly



The staves with the rounded corners with the holes closer to the top are for the front wall and the staves with the holes closer to the middle are for the back wall.



Start assembling the back wall.

Use a rubber mallet if required to tap the staves in tight to each other.



Once you get the back wall around halfway assembled, Slide one of the threaded rods through the top holes.

Repeat for the bottom holes.

This will take some finessing.



Add the remaining pieces of the back wall onto the threaded rods.

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Luna Sauna Assembly Instructions

Sauna Assembly



Place a washer and nut on each end of the threaded rods.

Tighten up the nuts with a wrench, socket or impact driver.



Cut any excess threaded rod off from each of the four holes.



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



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

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Assembly Instructions

Sauna Assembly



Continue sliding the rod through the staves until you reach the other side of the wall.



Repeat for the top of the wall.



Place a washer and nut on each end of the threaded rods.

Tighten up the nuts with a wrench, socket or impact driver.

Cut any excess threaded rod off from each of the four holes.



Use a broom or a brush to remove any debris from inside the dado grooves.

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Assembly Instructions

Sauna Assembly



With a helper, stand up front wall and place in groove at the front of the sauna.

Ensure it is centered on either side.

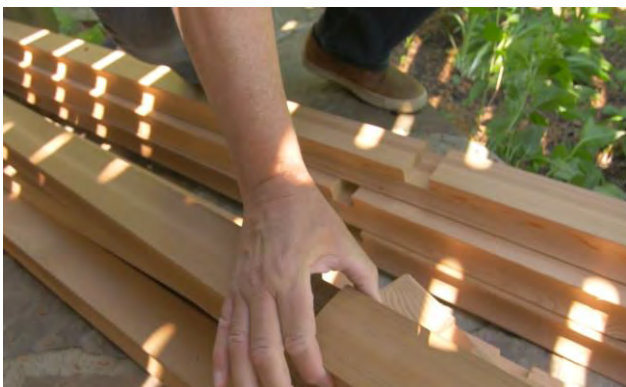


Repeat the process for the back wall.



Once both walls are centered into the grooves, use a stave to temporarily brace the walls to prevent them from falling.

This will provide support while you build the side walls.



Gather the remaining wall staves.

The wider staves are for the flat and the thinner staves are for the corners.

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Luna Sauna

Assembly Instructions

Sauna Assembly



Secure staves to the bottom corners of the sauna wall with 3 ½" (89mm) screws.

The staves on the corners use 3 ½" (89mm) screws while the staves on the flat wall use 2 ½" (64mm) screws.



Once you have the 6 corner 2" x 4" pieces in place to make the corner, start adding the larger 2" x 6" staves to build up each wall.



Install 11 of the full size 2" x 6" staves on the side wall and then build the top corners with 6 of 2" x 4" corner staves in the same manner as the bottom corners.

Repeat on opposite side.



Once the top corners are installed, start installing the 2" x 6" staves on the roof starting from one side.

Do not use screws for the top staves at this point.

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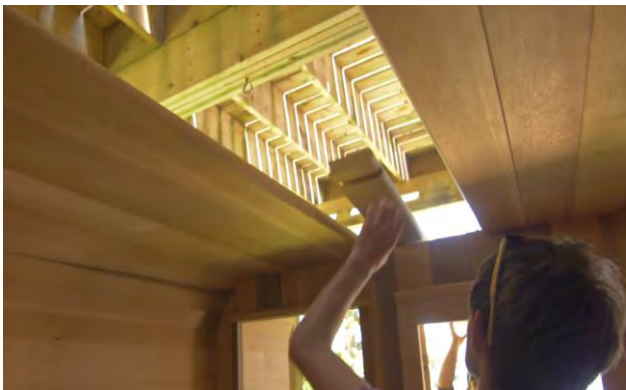
Luna Sauna

Assembly Instructions

Sauna Assembly



Remove the temporary stave and use it on the roof when required.



Once you are halfway across the roof, start installing the roof staves from the opposite side leaving the top center stave for the last.



When you reach the center, you may find that the last roof stave doesn't fit properly, use the rubber mallet to finesse it into place.

Once all staves are installed, secure each stave with 2 ½" (64mm) screws into the walls.



Once all staves are installed, secure each stave with 2 ½" (64mm) screws into the walls.

You can measure where wall is and draw a line with a pencil for easier installation of the screws.

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Luna Sauna

Assembly Instructions

Adding a Spacer to Top Stave (if required)



In your sauna package you will find a spacer stave that is square on both sides that is only required if there happens to be a “gap” after installing all the staves like in the picture on the left.



To add the spacer, start by removing all of the screws from the top stave.



With the top stave in 2 pieces secure the spacer stave to the half of the top stave without the screws with 2” (51mm) screws.



Now screw the other side of the top stave back to the other half top stave and it should now make a “V” shape when wedged with the last stave on the sauna.

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Luna Sauna

Assembly Instructions

Making a Top Stave Narrower (if required)



In rare instances, your sauna staves will be too tight not allowing the staves to settle into the correct position. (as in picture to the left)

This doesn't happen often, and the sauna staves and bands are always better being as tight as possible.



To make the top stave narrower, start by removing all of the screws from the top stave.



Once top stave is apart, Measure from flat edge 3/4 " (2cm) on each piece and safely cut to make staves thinner.



Now screw the 2 cut pieces of the top stave back together.

Reinstall the top stave and it should now make a "V" shape when wedged with the last stave on the sauna.

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Luna Sauna Assembly Instructions

Sauna Assembly



Start applying the ice & water shield on one side of the sauna by removing the film off the back and apply the ice & water shield level with the bottom of the first full stave.



Using your stapler, staple along the top of the ice & water shield and the front and back.



Place the next strip of the ice & water shield.

Make sure the bottom overlaps the glossy part of the previous strip.

Fold it over the front and back and secure with staples.



Use a utility knife to cut any excess ice & water shield off of the front and back of the sauna.

Repeat the process for the opposite side of the sauna.

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Luna Sauna Assembly Instructions

Sauna Assembly



With 2 people, place the roofing membrane over the sauna ensuring that it is centered side to side and front to back.



Pull the membrane over the front of the sauna and secure with staples.

Repeat the process on the back of the sauna.



Use a utility knife to cut any excess membrane off on the front and back and both sides.



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.

The long trim pieces have grooves cut on either end to assist in the drainage of any excess water.
(as in Picture below)



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Luna Sauna

Assembly Instructions

Sauna Assembly



Center out the corner trim pieces and secure with 3 2" (51mm) screws spaced evenly.



Continue to line up the trim pieces all the way around the front of the sauna and secure with 2" (51mm) screws, 3 screws in the corner trim and 4 screws in the side and top/bottom pieces spaced evenly.

Repeat on the rear of the sauna.



To install the siding, start at the bottom with the top of the siding flush with the bottom wall stave.

You can use staples or nails to secure the siding but nothing longer than 1 ½" (38mm).

Ensure not to hit the previously installed metal bands with the staples or nails.

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Luna Sauna Assembly Instructions

Sauna Assembly



Continue adding the siding until you reach the top of the sauna.

Repeat the process for the other side.



Center the outer door handle (small) in the desired location and secure with 2" (51mm) screws in the predrilled holes.



Repeat the process for the larger inside door handle.



Place the towel hooks in the desired location and secure with 2 ½" (64mm) screws in the predrilled holes.

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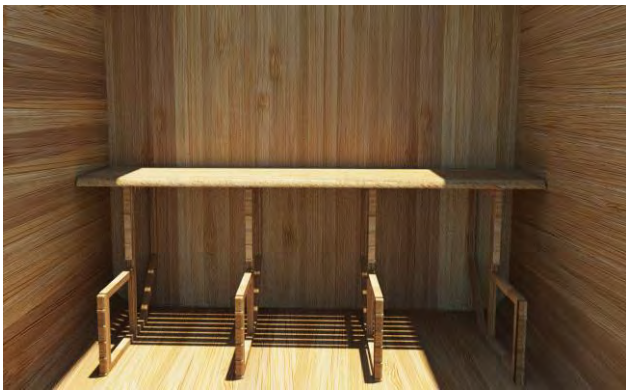
Luna Sauna Assembly Instructions

Back Wall Bench Assembly



Space the 4 bench brackets out along the back wall.

Do not fasten yet.



Place the top bench on to the bench supports.

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



Once bench brackets are lined up with the seat supports, use 2 ½" (64mm) screws to fasten the bench supports up into the curved seat supports.

secure the bench bracket to the back wall using 2 ½" (64mm) screws.



Use 2 ½" (64mm) screws to fasten the bench bracket to the back wall using 2 ½" (64mm) screws.

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Luna Sauna

Assembly Instructions

Back Wall Bench Assembly



Repeat process for the lower bench,

Secure bench brackets to the sauna floor with 2 ½" (64mm) screws as well.



Secure the attached outside brackets of the top and bottom bench to the side walls on each side of the sauna with 2 ½" (64mm) screws.



Attach the front enclosure to the top bench using 2 ½" (64mm) screws.

Ensure to screw in between the slats to make the screws less visible.

Repeat for bottom front enclosure.



Place the backrest at desired height and secure with 2 ½" (64mm) screws in the predrilled holes.

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Luna Sauna

Assembly Instructions

Back Wall Bench with L Bench Assembly



If L bench is not chosen, you may skip ahead the next four steps.

Place the enclosed side bench support against the front wall and secure to back wall and sauna floor with 2 ½" (64mm) screws.



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



Place the top bench on to the bench supports.

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

Once bench brackets are lined up with the supports, secure the bench bracket and small end support to the back wall and floor using 2 ½" (64mm) screws.



Attach the front enclosure to the top bench using 2 ½" (64mm) screws.

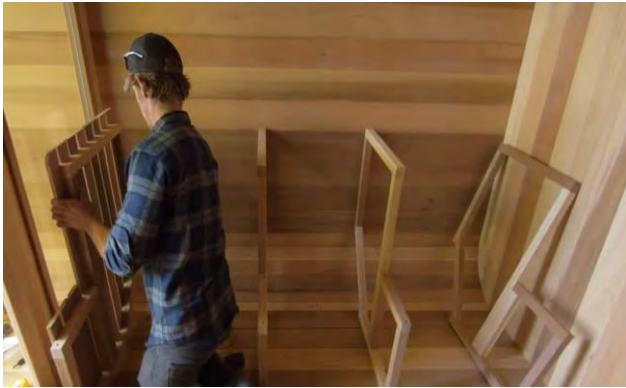
Ensure to screw in between the slats to make the screws less visible.

Repeat for bottom front enclosure.

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Luna Sauna Assembly Instructions

Side Wall Bench Assembly



Place the enclosed side bench support against the front wall and space the bench brackets out along the side wall.

Do not fasten yet.



Place the top bench on to the bench supports.

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



Once bench brackets are lined up with the seat supports, secure the bench bracket to the back wall using 2 ½" (64mm) screws.



Use 2 ½" (64mm) screws to fasten the bench supports up into the curved seat supports.

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Luna Sauna Assembly Instructions

Side Wall Bench Assembly



Repeat process for the lower bench,

Secure the bench brackets

Secure bench brackets to the sauna floor with 2 ½" (64mm) screws as well.



Secure the attached outside bracket of the top and bottom bench to the end of the sauna with 2 ½" (64mm) screws.

Secure the bench brackets to the floor using 2 – 2 ½" (64mm) screws per bracket.



Attach the front enclosures to the top bench using 2 ½" (64mm) screws.

Ensure to screw in between the slats to make the screws less visible.

Repeat for bottom front enclosure.



Place the backrest at desired height and secure with 2 ½" (64mm) screws in the predrilled holes.

Repeat for opposite side of sauna.

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Luna Sauna

Assembly Instructions

Standard Porch Bench Assembly



Assemble the porch seat and front enclosure using 2 ½" (64mm) screws in the predrilled holes ensuring the pieces are flush.



Place the assembled bench between the trim and the front window.



Ensure the bench is level to the porch floor.

Secure the bench to the floor and wall using 2 ½" (64mm) screws.



Place the backrest at desired height and secure with 2 ½" (64mm) screws in the predrilled holes.

Repeat for opposite side of porch.

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Luna Sauna Assembly Instructions

Lounge Bench Assembly



Start the lounge bench assembly by attaching the base supports to the front enclosure.

Repeat on other end.

Attach the long wall support to the inside of the 2 side base supports.



Once the frame is assembled, bring into the sauna and place against the wall.



Ensuring the frame is level, Attach the frame to the back and side walls using 2 ½" (64mm) screws.

Secure the front enclosure to the floor from the inside with 2 ½" (64mm) screws.



Place the assembled lounge bench onto the frame.

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Luna Sauna Assembly Instructions

Lounge Bench Assembly



Line up the lounge bench to the frame ensuring it is flush, lift the lounge up and secure to the frame using 2 ½" (64mm) screws.



Repeat on the back side of the lounge bench.

Repeat on opposite side of the sauna.

The backrest is not available with the lounge bench option as it impedes in the correct operation of bench.



If Lounge bench and two-tier bench are chosen, follow the instructions for side wall bench assembly in the previous section.

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Luna Sauna

Assembly Instructions

Lounge Bench for Porch Assembly



Assemble the porch seat and front enclosure using 2 ½" (64mm) screws in the predrilled holes ensuring the pieces are flush.



Place the assembled bench between the trim and the front window.



Ensure the bench is level to the porch floor.

Secure the bench to the floor and wall using 2 ½" (64mm) screws.

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Luna Sauna Assembly Instructions

Electric Heater Installation (Optional)



Measure the width of the stove mounting holes.



Measure the height of the mounting holes and add 6" (152mm).



Transfer the measurements to the wall of sauna.



Install the two $\frac{1}{4}$ " x $1\frac{1}{2}$ " (6mm x 38mm) hex head lag screws (supplied with the heater) into the holes.

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Luna Sauna

Assembly Instructions

Electric Heater Installation (Optional)



Hang the heater on the 2 screws and tighten to secure stove in position.



Locate the pieces for your heater guard. Stand the 2 Assembled side pieces of the heater guard on edge with pre-drilled holes on the bottom.



Screw heater guard support to either side using (2) – 1 ½" (38mm) screws per side. Repeat for the bottom heater guard support.



Place 2- 2 ½" (64mm) screws into the pre-drilled holes on either side of heater guard to prepare for mounting.

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Luna Sauna Assembly Instructions

Electric Heater Installation (Optional)



Center the guard around the heater and secure to wall with the preplaced screws.



Ensure the guard is level and secure the other side.



Wash the layer of rock dust off of the sauna rocks before using them.

When your sauna is set up and working you should “break-in” the sauna before using it for the first time by turning on the heater to its highest setting and operate it for about 1 hour.

This is recommended to burn off any oils impurities from manufacturing, and it also “cures” the woodwork.

- *All wiring should be installed according to the heater manufacturers instructions and by a licensed electrician.*

- **Do NOT use a G.F.I breaker**

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Luna Sauna Assembly Instructions

Wood Stove Installation



Remove all protective film from stainless steel parts and the plastic wrap from stove pipe pieces before installation.



Install floor heat shield against back wall centered between the benches.



With a helper, bring the stove into the sauna.



Measure the height to the center of the hole on the back of the heater.

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Luna Sauna Assembly Instructions

Wood Stove Installation



Find the center between the benches and mark the height of the heater center hole from the previous step.



Place the back wall heat shield against the wall.

Raise it 2 ¾" (7cm) from the floor, ensure it is level and then trace out the chimney opening onto the wall.



Drill a starter hole, then use a jig saw to cut out the circle.



Place the short chimney piece into the hole on the back of the stove.

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Luna Sauna Assembly Instructions

Wood Stove Installation



Place the rear heatshield onto the back wall. Ensure it is correctly orientated and level.

Fasten it to the wall with 1 ½" (38mm) screws.



Ensure the cap is on the top chimney hole.



Place the stove onto the floor shield.



Attach the stove handle with the provided bolt and nut.

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Luna Sauna Assembly Instructions

Wood Stove Installation



Insert the "T" chimney piece through hole in back of sauna and through the rear wall heat shield on the inside of sauna and into short chimney piece on the back of stove.



Slide the chimney cap into the stack.



Assemble the 2 chimney stacks together.

Ensure the welds are aligned with each other.



Attach the support strap around the 2 chimney stacks and secure with the provided bolt, washer, and nut.

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Luna Sauna Assembly Instructions

Wood Stove Installation



Slide the assemble chimney stacks onto the Chimney "T" piece coming out the back of the sauna.

Ensure the welds are aligned.



Attach a support strap around the joint and secure with the provided bolt, washer, and nut.



Locate the chimney support bracket and remove the back piece.



Fasten the 2 brace supports together with the provided hardware.

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Luna Sauna Assembly Instructions

Wood Stove Installation



Place the bracket on in the center of the rear wall near the roof of the sauna ensuring it and the chimney stack are level.



Secure the bracket to the wall with the provided lag screws.



Wrap the chimney support strap around chimney and use the provided nut and bolt to secure.



Place the bottom chimney cover plate tight to the bottom of the chimney pipe and secure with 1 ½" (38mm) screws ensuring the plate is level.

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Luna Sauna Assembly Instructions

Wood Stove Installation



Repeat the process for the top plate ensuring it is overlapping the bottom plate.



Place the sauna rocks loosely on the top to allow air flow and enjoy your wood burning heater.

Place the sauna rocks loosely on the top to allow air flow and enjoy your wood burning heater.

[View the wood burning heater assembly process](#)



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Luna Sauna Assembly Instructions

Vent Kit Installation

In most cases, venting is not required for proper sauna function, however it increases air flow circulation as well as ventilation when the sauna is not in use.

Many people prefer not to install vents in prefabricated saunas.

Generally, you have access to add a vent to your sauna once assembled if it is deemed necessary.

Vent Kit Contents

Stainless Steel 3" x 7" Grill (X2)

1 ½" Stainless Steel Screws (X12)

Tools Required

Hole Saw or Drill Bit to drill holes.

Cordless Drill w/ Robertson bit.



The Location of the vent depends on the type of sauna purchased and the location of the heater. Use the following instructions as a guide to help you determine where the vent should be located.

Inlet – Low below heater

Outlet – High up at far corner away from heater

Ex. Saunas with the heater on the back wall in the middle, the inlet would go under heater on the back wall and the outlet would go high on the front wall.

Saunas with the heater on the front wall would have the inlet under the heater on the front wall and the outlet high on the back wall for maximum airflow.

For Saunas with wood heaters, get the inlet as close as possible to the wood heater and the outlet high in the opposite corner.



Inlet under electric heater on Back wall



Inlet beside wood heater on Back wall

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Luna Sauna Assembly Instructions

Vent Kit Installation



If an electric heater is being used, Drill inlet holes centered underneath the heater close to the floor. (A 2" diameter hole saw was used in pictures but more holes with a smaller drill size will also work)



If the sauna is being installed with a wood heater, drill inlet holes close to floor and the side of the heater as in the above picture.



Install 1 of the stainless-steel vent grills over the inlet holes on the outside of the sauna centered over the holes using 1 ½" (38mm) screws. (6pcs)

Note that the inlet holes on the inside do not get a stainless-steel cover.



On the wall away from the heater, close to the top, drill the outlet holes in the same manner as the previous step

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Luna Sauna Assembly Instructions

Vent Kit Installation



Install the other Stainless Vent cover over the outlet holes on the outside using 1-1/2" stainless steel screws. (6pcs)



Install the cedar vent cover over the outlet holes on the inside of the sauna with a 1 1/2" (38mm) screw.

Tighten the screw just enough that the vent cover still rotates smoothly.

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MAINTAINING YOUR SAUNA AFTER INSTALLATION

Interior

It is recommended to vacuum or sweep out the inside of your sauna frequently to remove dirt and other debris.

Under normal conditions, a slight wash of the floor and benches with warm soapy water several times a year will maintain its cleanliness. You can use a sheet of fine grit sandpaper or a low pressure wash to remove more stubborn stains or 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. This natural weathering will not harm the wood or impair the sauna's performance.

If you wish to retain the natural color of your Dundalk Leisurecraft Sauna, there are many cedar stains on the market and almost as many opinions as to which is best.

We encourage you to rely on your own research and referrals.

Recommended Stains Include:

Behr Premium Semi-Transparent Waterproofing Stain & Sealer

Sikkens Proluxe Cetol SRD Translucent Stain

<https://www.realcedar.com/outdoor/finishing-choices/>

Note: never treat the interior of the Sauna, and never apply paint or varnish to the exterior.



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 (80 or 100 grit)



HOW TO TAKE A SAUNA

1. Pre-heat your sauna to the desired temperature (usually between 80-100°C)
2. While it's warming up, take a nice hot shower.
3. Enter the pre-heated sauna, relax and allow your body to perspire in the soft dry heat. Do not throw water on the rocks during the first part of the session.
4. Cool off with a cold shower or a quick swim in a lake or pool.
5. Re-enter the sauna and sprinkle water on the rocks. This will increase humidity to assist in perspiration. Half a cup every 5 minutes should be enough. Too much water will just cool off the rocks and you'll get less steam.
6. After a 20–30-minute sauna, cool off in the shower or lake or pool.
7. Repeat this sauna/cold shower process as often as desired.
8. After each use, leave the door fully open for a few hours if possible so the wood can dry out.

**These are guidelines only. Enjoy your sauna in whichever way you desire.
Children must be supervised by an adult.**

WARRANTY

LeisureCraft warrants our saunas against defects in materials and workmanship under normal/residential use for a period of five (5) years, as applicable, from the date of receipt of the product by the original end-user consumer. This warranty does not apply to normal wear and tear and/or natural weather conditions. This warranty does not cover regular required maintenance of the sauna, (eg. Tightening bands on the barrels, cleaning or staining the sauna) refer to your sauna assembly manual for maintenance guidelines. This warranty does not cover misuse or negligence and the manufacturer and associated retailers are not liable for any injury or damage caused by the product. This warranty is a parts only warranty and any service or labor costs would not be considered as part of the 5-year warranty.

Purchaser Name: _____ Date: _____

Purchased From: _____