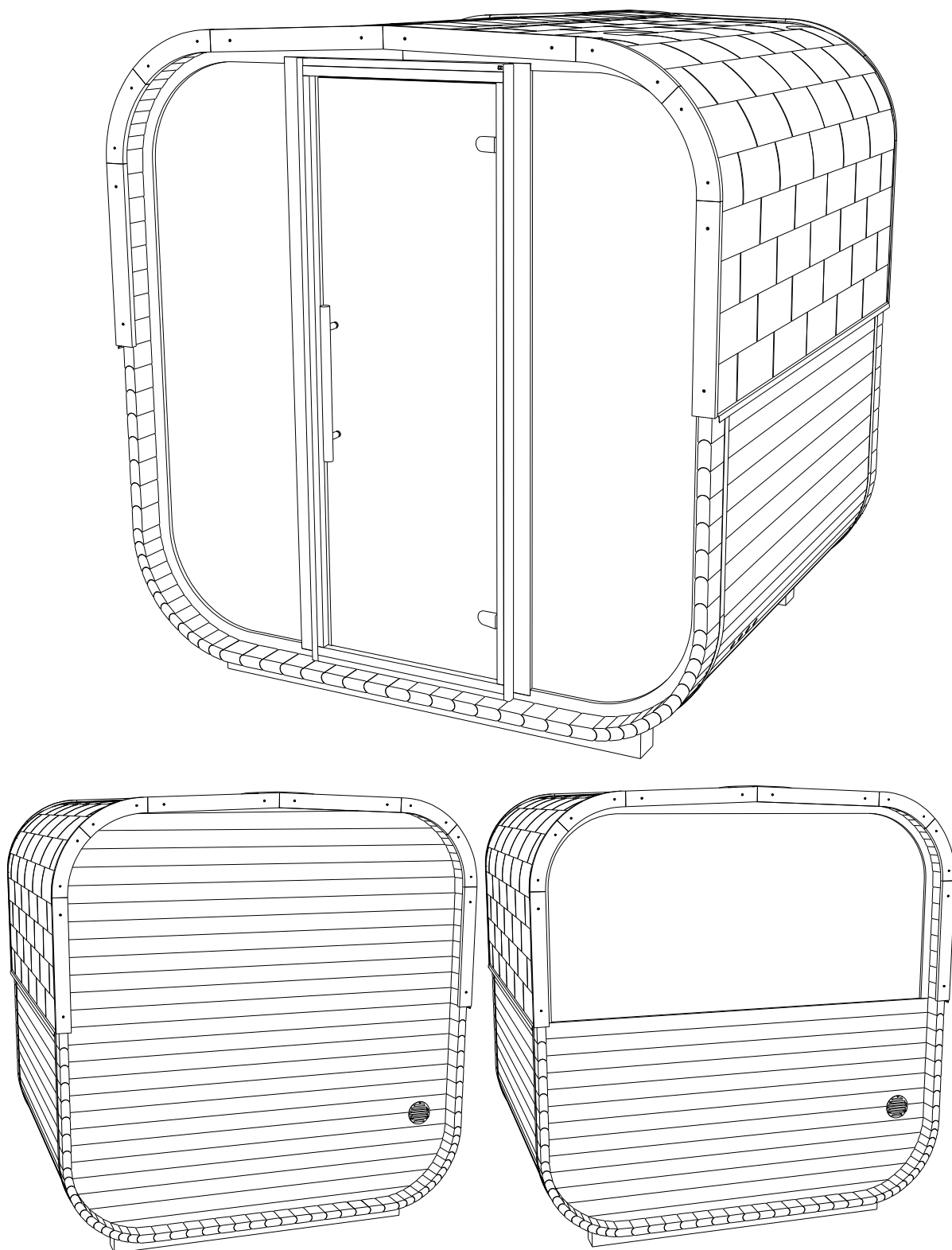


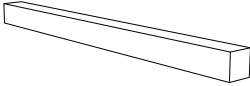
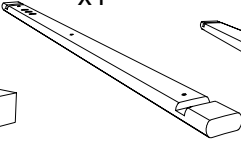
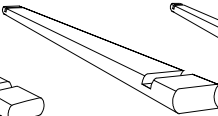
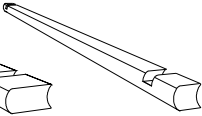
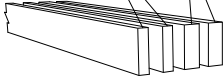
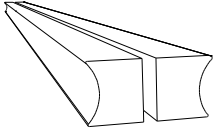
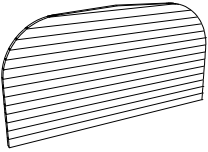
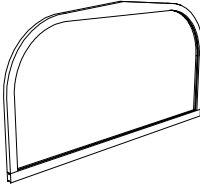
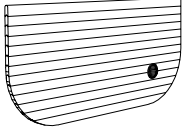
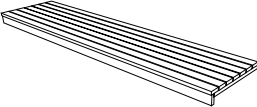
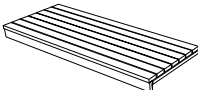
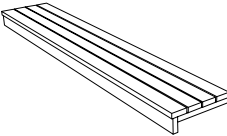
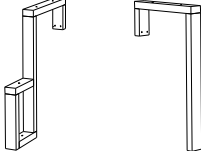
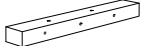
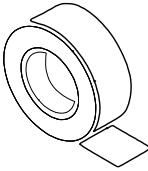
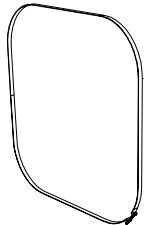
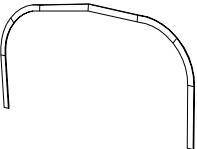
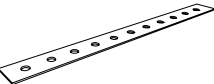
# QUADRA X

## ASSEMBLY INSTRUCTIONS

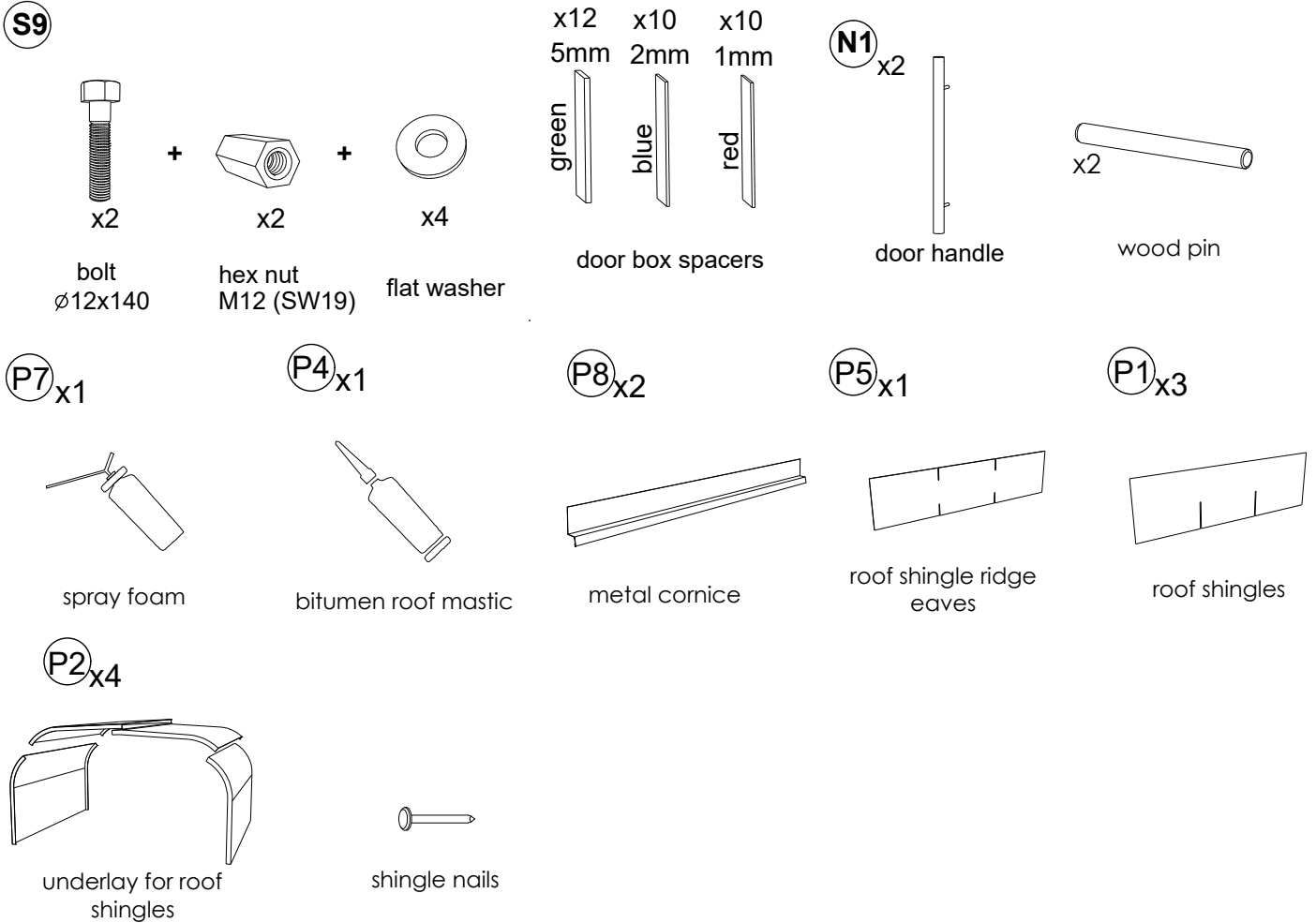


**Note: Please read the manual before construction**

## PARTS LIST

|                                                                                                                                         |                                                                                                                                |                                                                                                                                   |                                                                                                                              |                                                                                                                                                       |                                                                                                                                     |
|-----------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------|
| <b>A</b> x2<br><br>cradle                               | <b>B</b> x1<br><br>center stave               | <b>C</b> x62<br><br>body stave                   | <b>SC</b> x48<br><br>body stave             | <b>H1</b> x4<br>10mm 15mm<br><br>different thickness filling peaces | <b>H</b> x2<br><br>final H tipe stave at the top |
| <b>V3</b> x1<br><br>upper rear panel                    | <b>F</b> x2<br><br>front panel                | <b>V1</b> x1<br><br>upper rear panel (panoramic) | <b>F2</b> x1<br><br>door and door moldings | <b>V</b> x1<br><br>bottom rear panel                               | <b>F2</b> x2<br><br>door and door moldings       |
| <b>J</b> x1<br><br>sauna bench                         | <b>J8</b> x1<br><br>sauna bench(short)       | <b>J4</b> x1<br><br>sauna bench step(long)      | <b>J6</b> x2<br><br>supporting legs      | <b>J1</b> x2<br><br>supporting legs                               | <b>J3</b> x2<br><br>wall mount                 |
| <b>L</b> x2<br><br>sauna floor                       | <b>Y</b> x1<br><br>adhesive tape for panels | <b>Y1</b> x1<br><br>ventilation grill          | <b>O</b> x1<br><br>roof board            | <b>I</b> x2<br><br>metal band                                    |                                                                                                                                     |
| <b>W</b> x14<br><br>decorative roof finishing boards | <b>S1</b> x32<br><br>screw 5.0x100 SS       | <b>S10</b> x204<br><br>screw 4.0x60            | <b>S5</b> x23<br><br>screw 4.0x50 SS     | <b>S4</b> x2<br><br>screw 5.0x120                                |                                                                                                                                     |
| <b>D</b> x1<br><br>metal bracket                     | <b>S6</b> x38<br><br>screw 5.0x70 SS        | <b>S7</b> x34<br><br>screw 4.2x55 brown        | <b>S12</b> x6<br><br>screw 4.0x30       | <b>S14</b> x8<br><br>screw 5.0x80                                |                                                                                                                                     |

## PARTS LIST



## RECOMMENDATION



2 person recommended

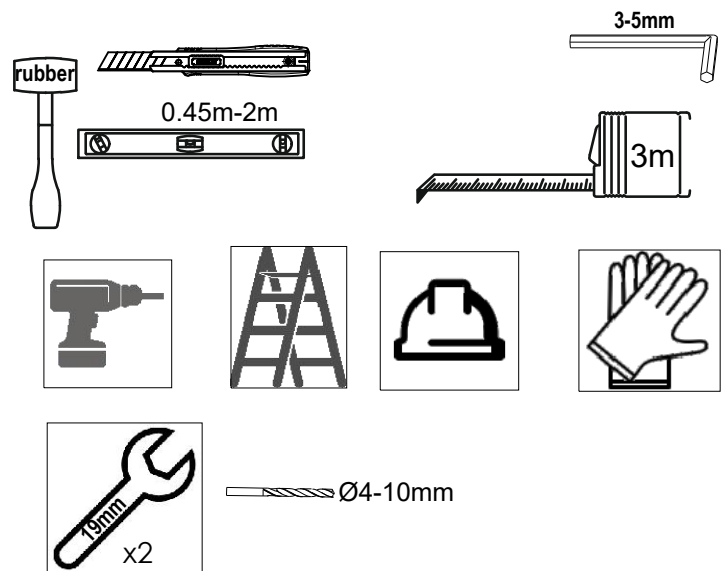
Before you begin, be sure the sauna will fit in your chosen location.

Be sure the site is level and free of standing water after rainfall.

Concrete, pavers or crushed stone is preferred.

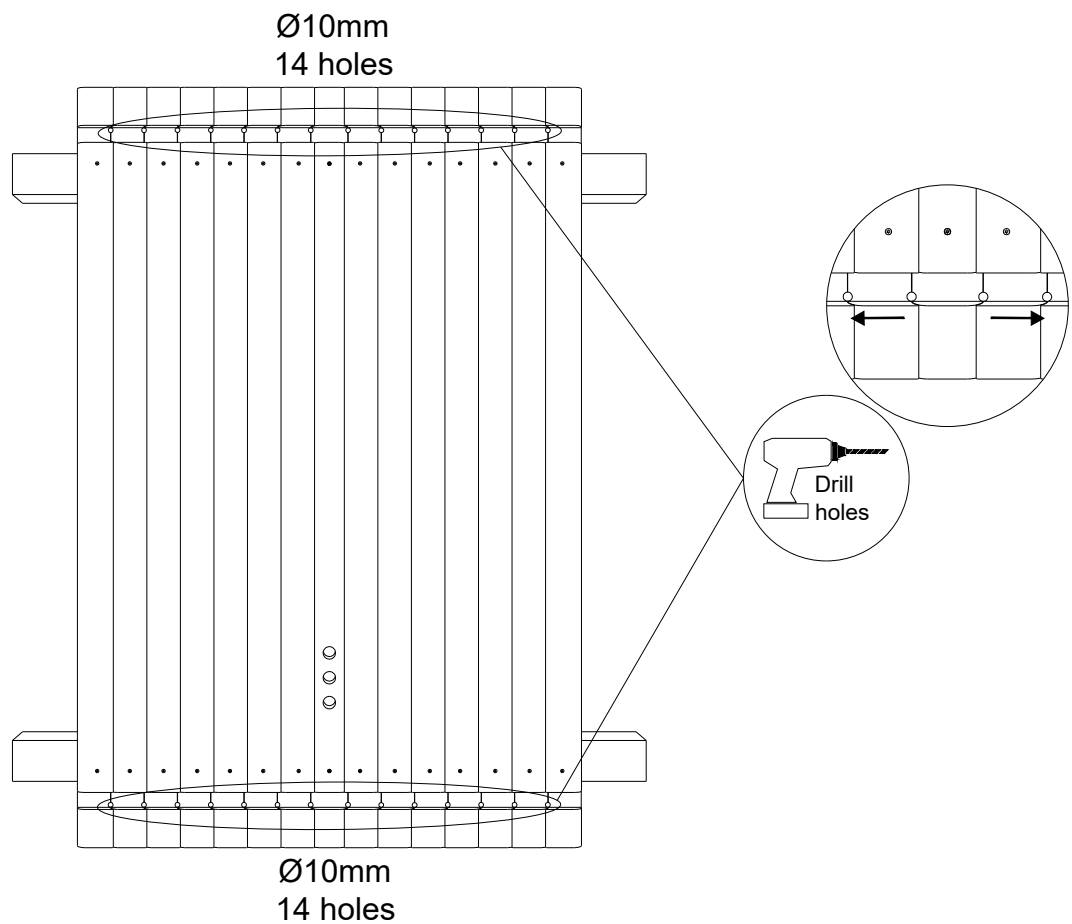
Check parts before construction.

## TOOLS REQUIRED

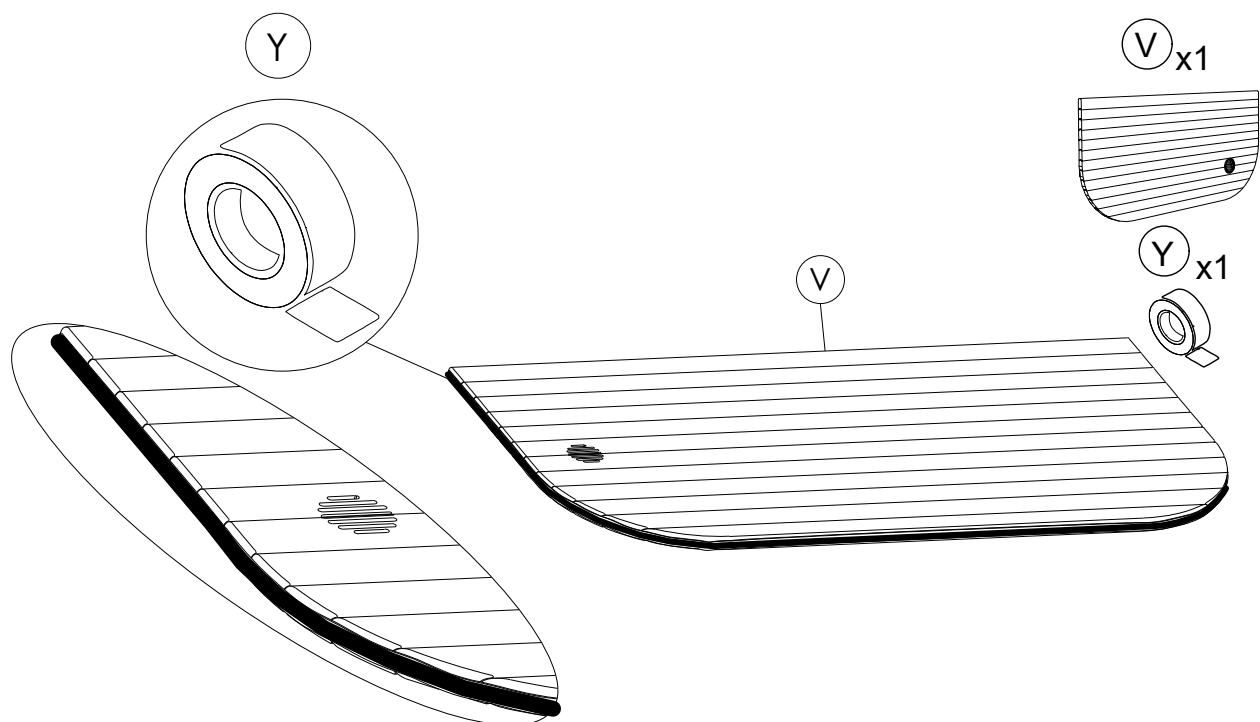




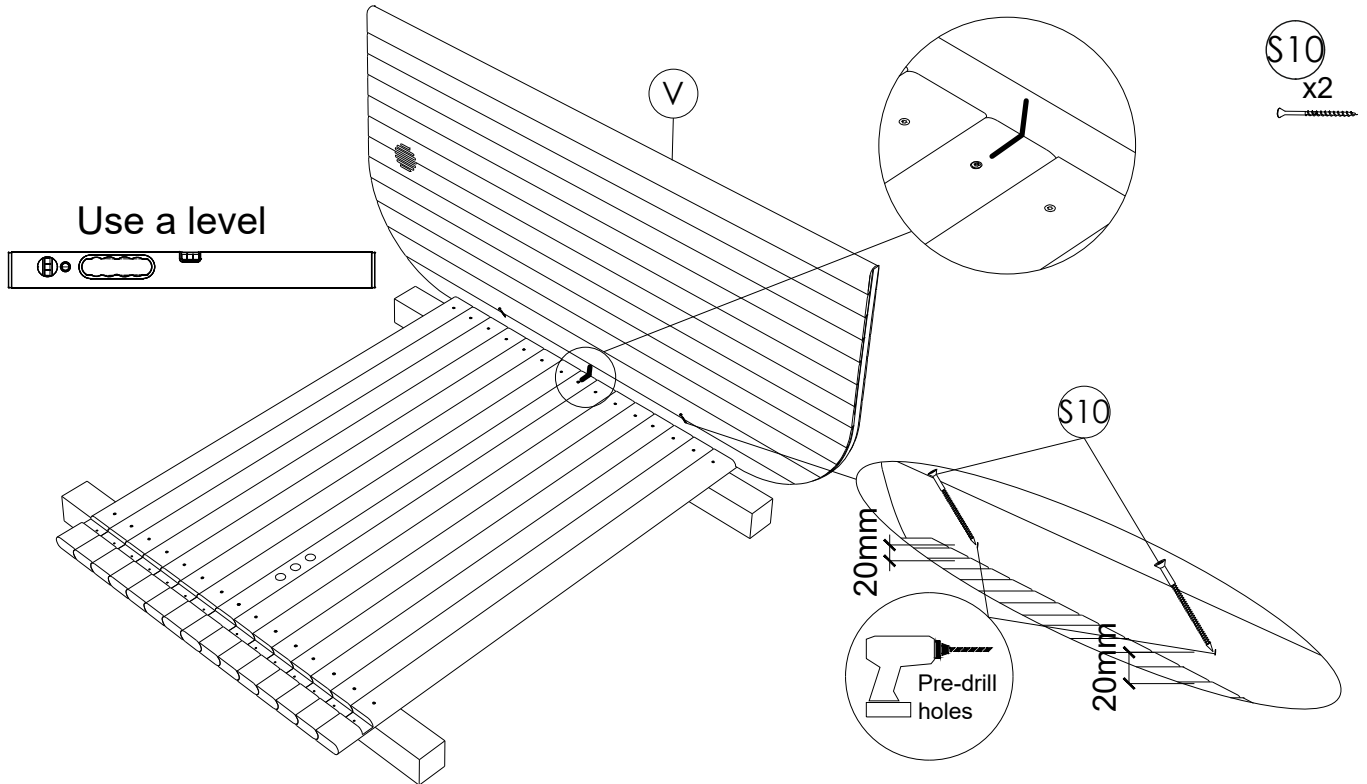
**STEP3:** Drill fourteen 10mm holes in front and back wall groove to the out-side in board connections as shown in the picture. This will help drain excess water faster.



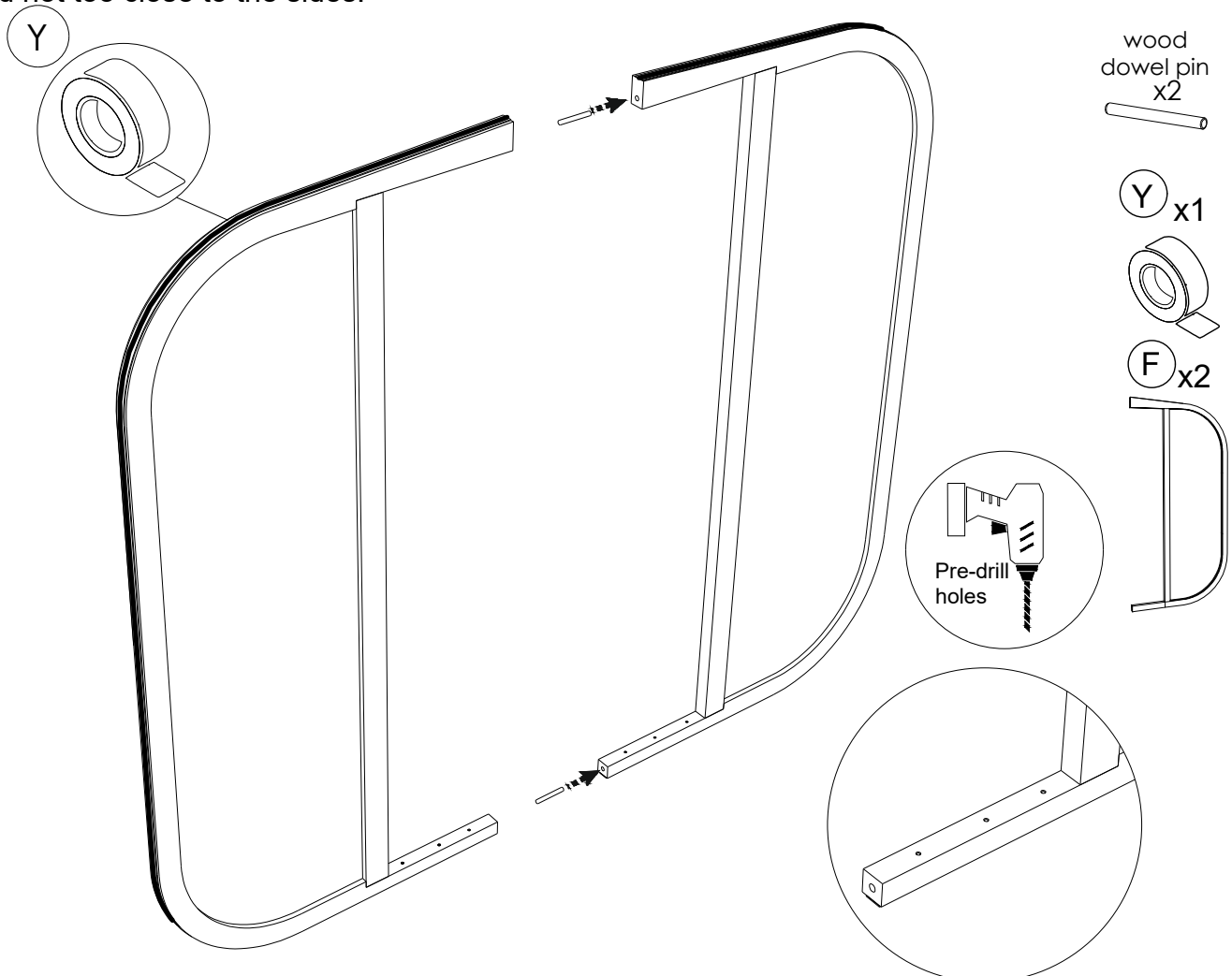
**STEP 4:** Attach adhesive tape along the rear panel's edge. At the bottom of the rear panel (V), draw a line where the centre of the panel is. Do the same on the centre stave of the floor, where the panel will be sitting.



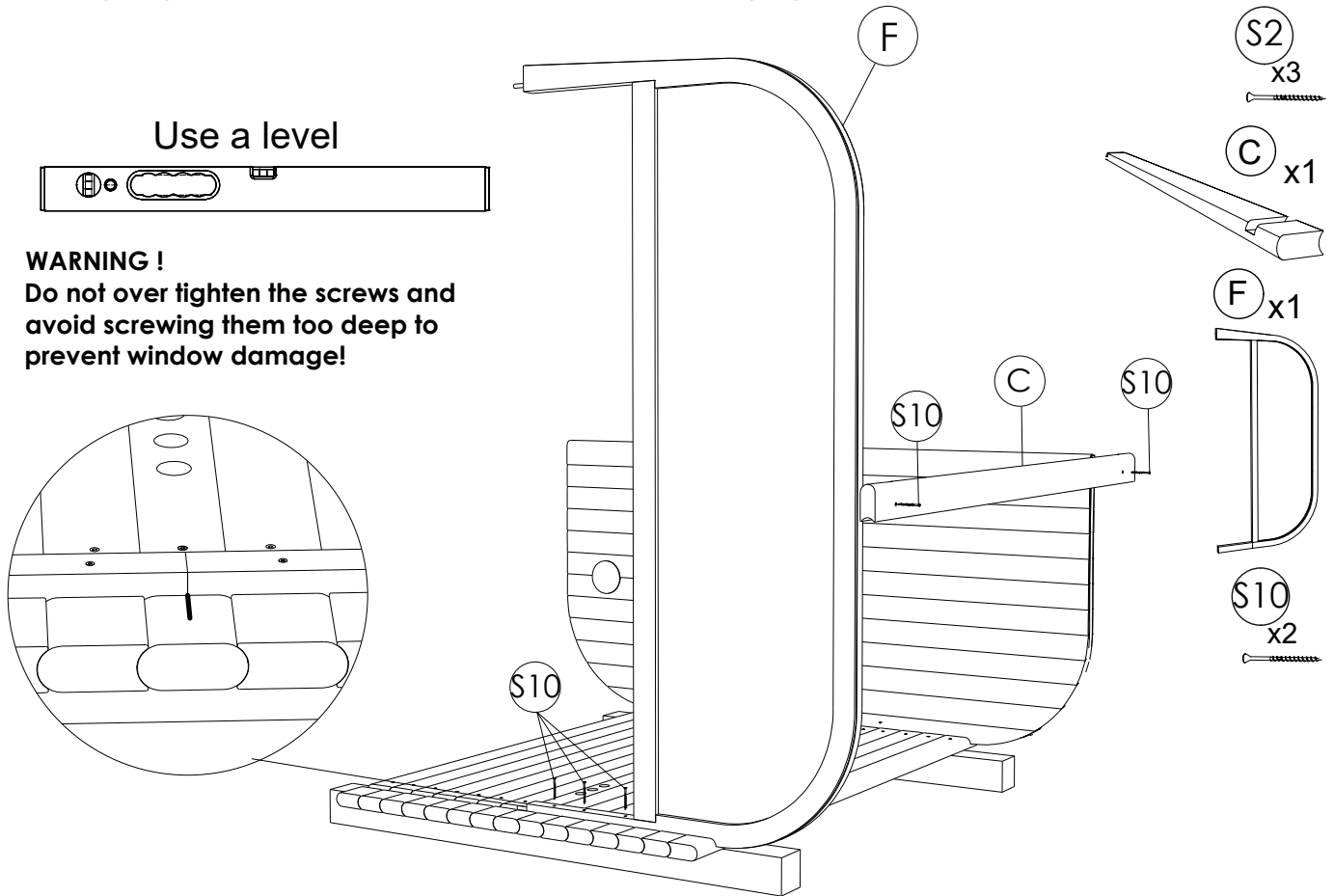
**STEP 5:** Place rear bottom panel (V) in the board groove. Check that the panel is level. Secure panel with screws (S10) at the both corners through the stave.



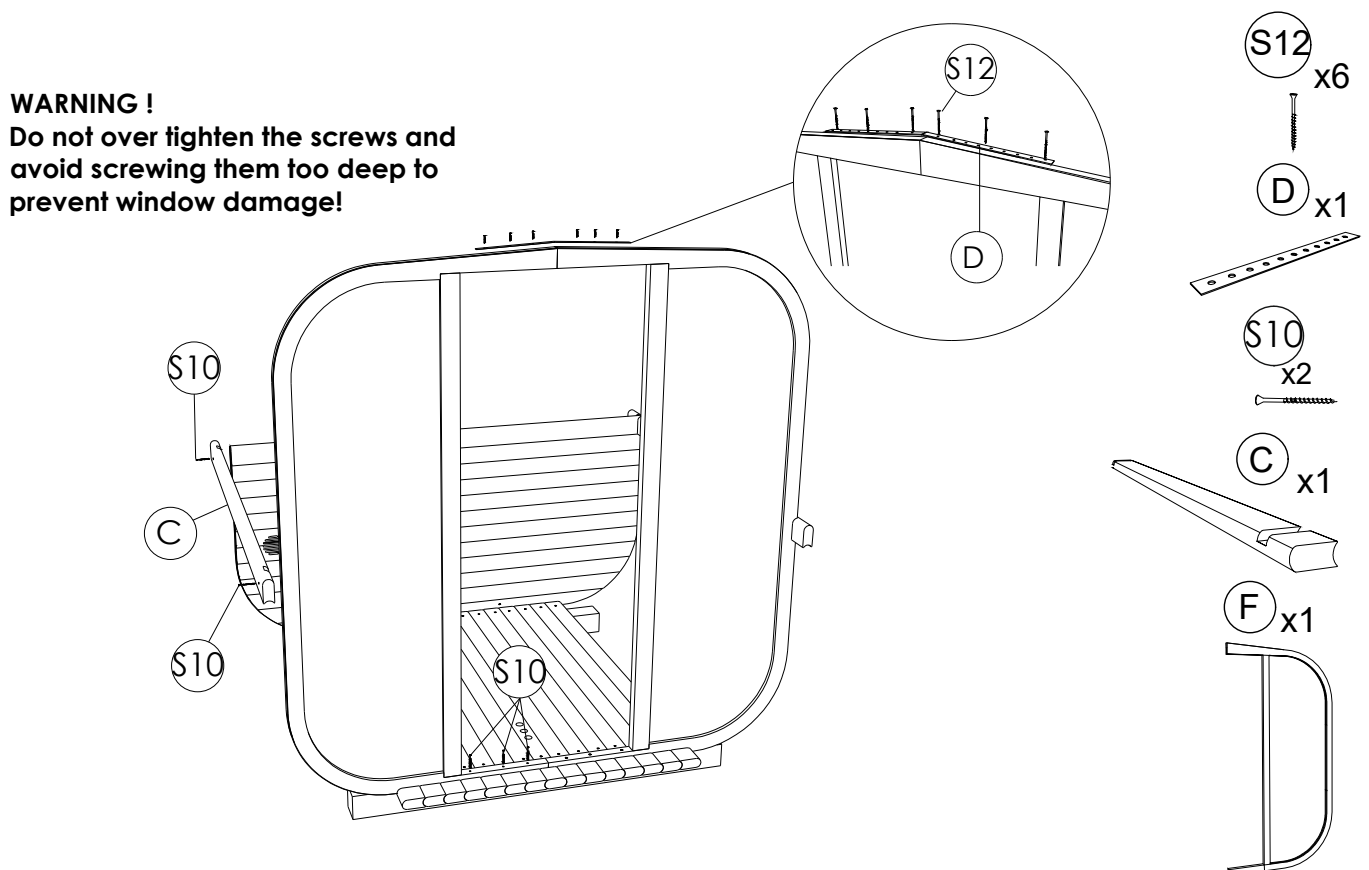
**STEP 6:** Attach adhesive tape along the edge of both front panels (F). Insert wood pin in both holes of the front panel top and bottom. Pre-drill holes in the panel threshold, evenly spaced and not too close to the sides.



**STEP 7:** Draw a line on the center stave where the middle is. Take one of the panels (F) and put it directly next to the middle line. Take one stave to connect both panels, front and back, using screws (S10). Fix it at the panel threshold with screws (S2). Make sure it's level.

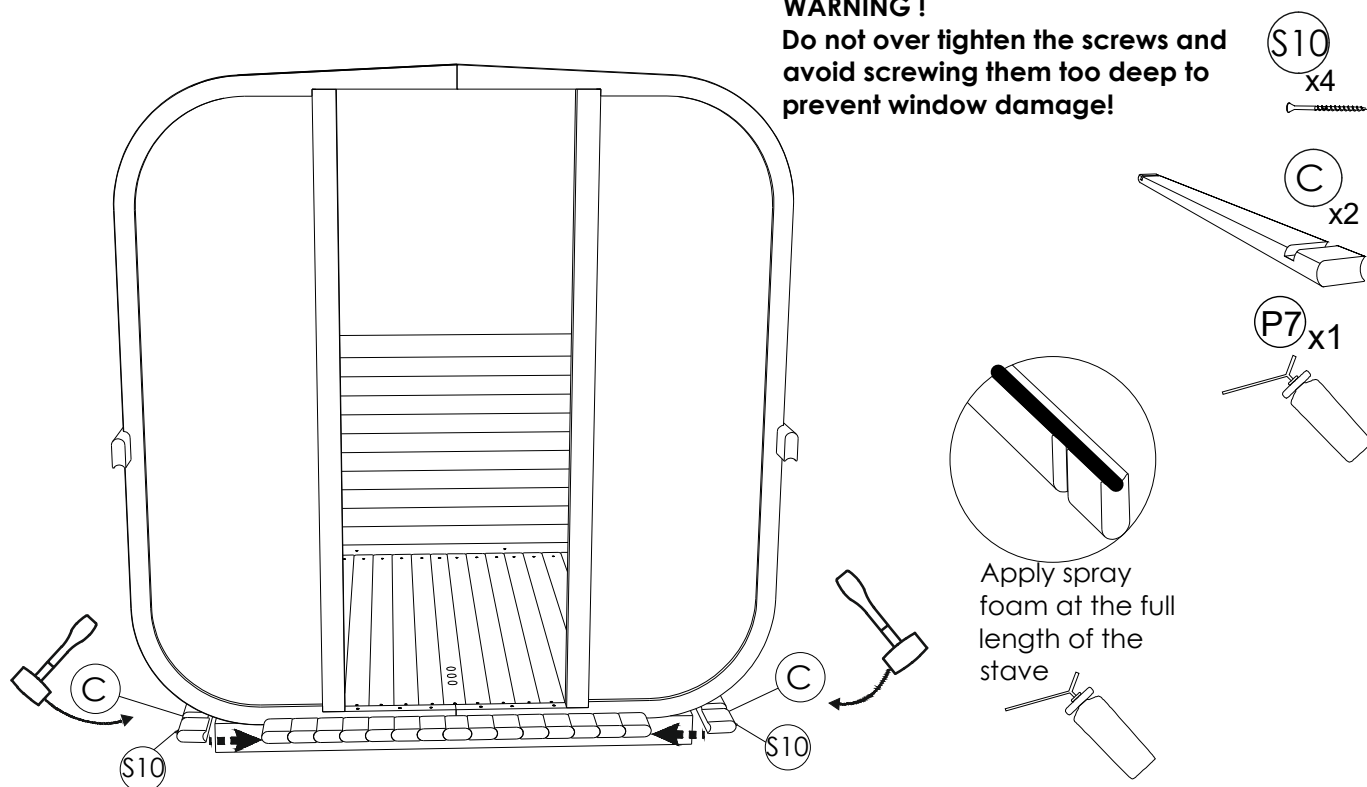


**STEP 8:** Place the second front panel (F). Slide it together that the top and bottom connects. Fix it at the panel threshold with screws (S2). Make sure it's level. Use metal bracket on top of the front panels to fix them together.



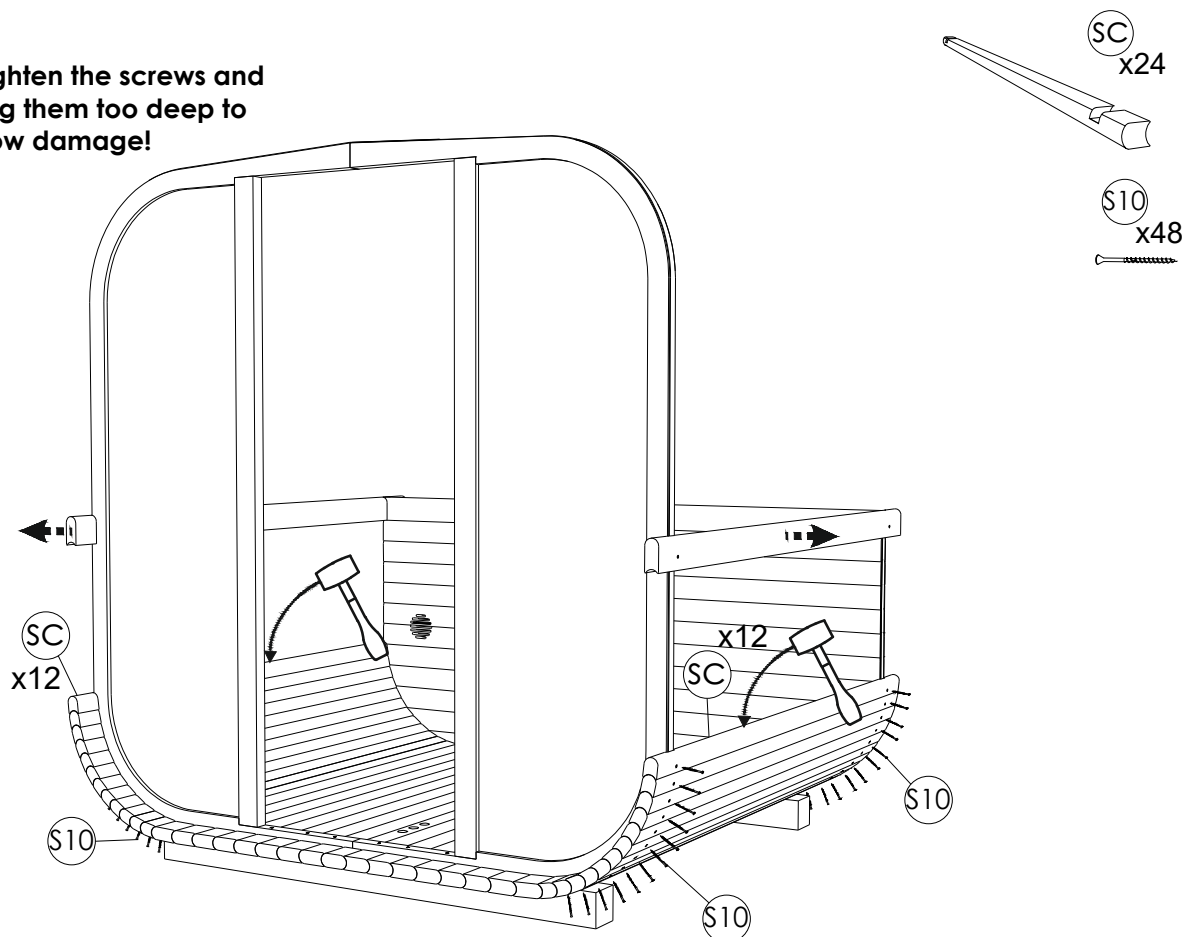
**STEP 9:** Fix one stave (C) on both sides with screws (S10). Use rubber hammer for tighter placement. Use spray foam between every stave.

**WARNING !**  
Do not over tighten the screws and avoid screwing them too deep to prevent window damage!



**STEP 10:** Fix 12 stave (SC) on both sides with screws (S10). Use rubber hammer for tighter placement. Use foam between every stave. When both corners are done, take of connecting staves.

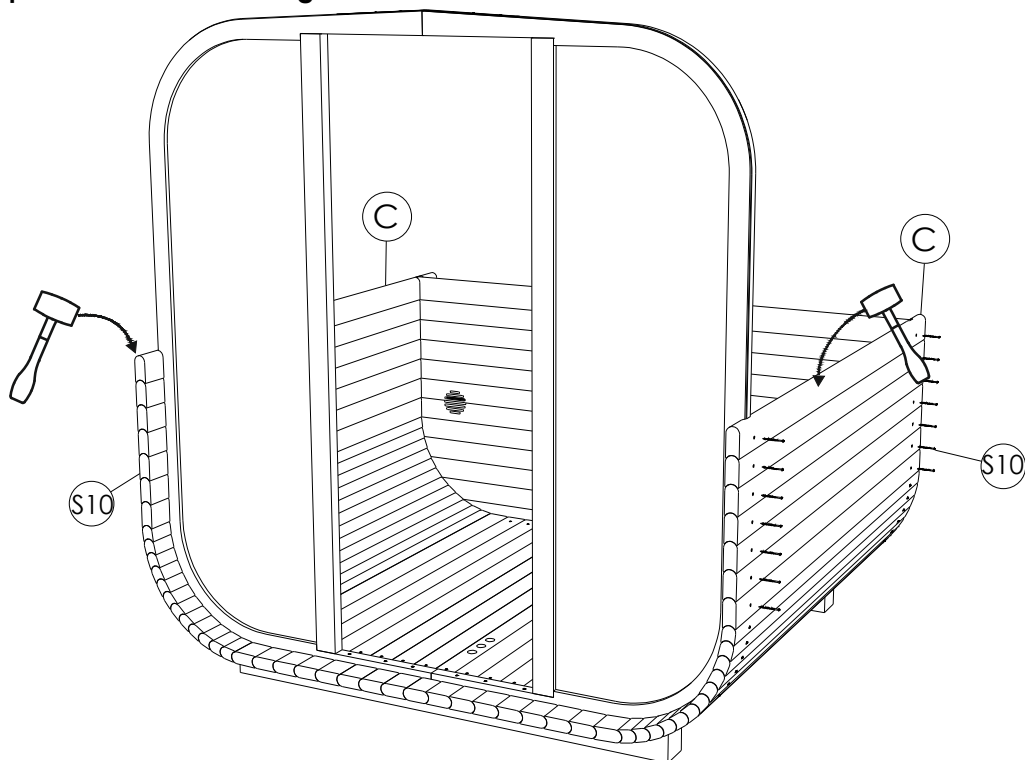
**WARNING !**  
Do not over tighten the screws and avoid screwing them too deep to prevent window damage!



**STEP 11:** Fix one stave (C) on both sides with screws 4x60 (S10). Use rubber hammer for tighter placement. Use foam between every stave. When both corners are done, take of connecting staves. Keep fixing staves till reach top of the rear panel (V).

**WARNING !**

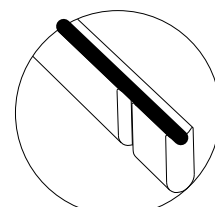
Do not over tighten the screws and avoid screwing them too deep to prevent window damage!



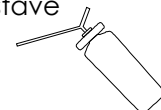
(S10)  
x28

(C)  
x14

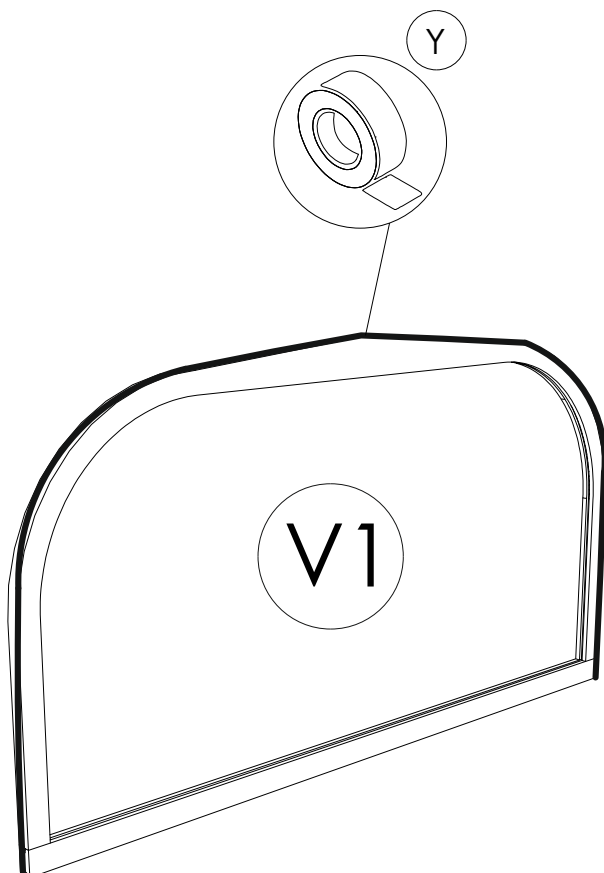
(P7)  
x1



Apply spray foam at the full length of the stave



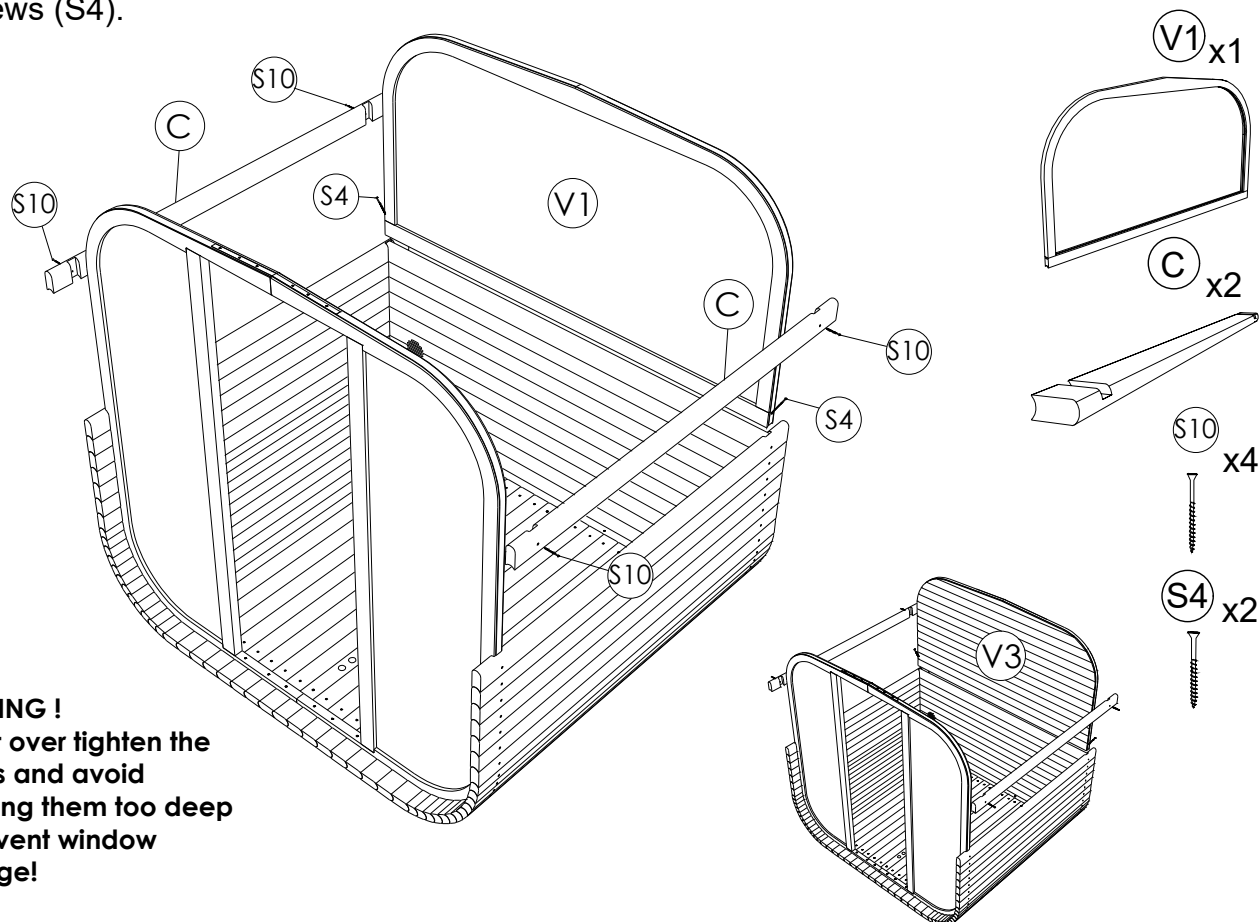
**STEP 12:** Attach adhesive tape along the rear panel with window (V1) or panel (V3) edge.



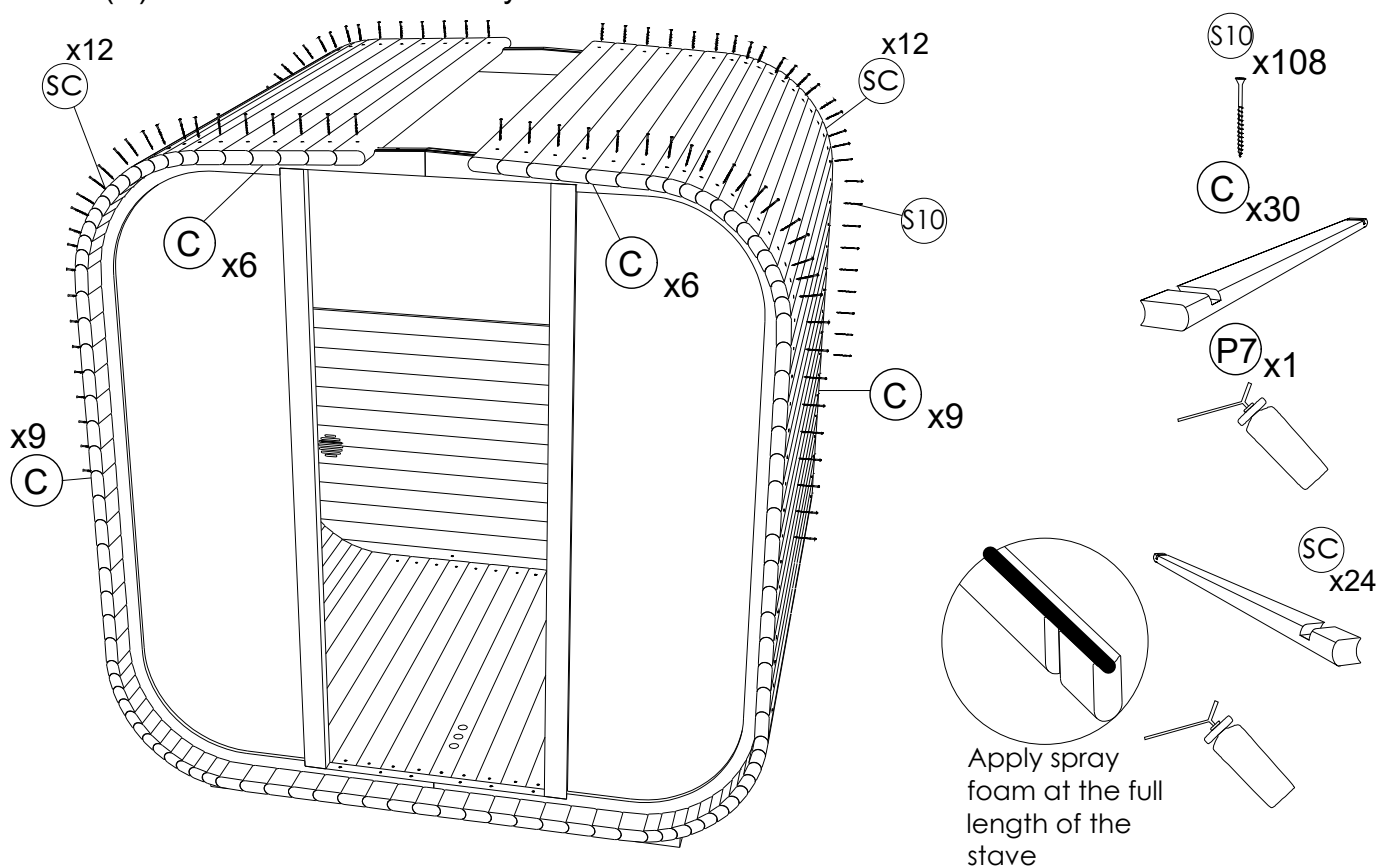
(Y)  
x1



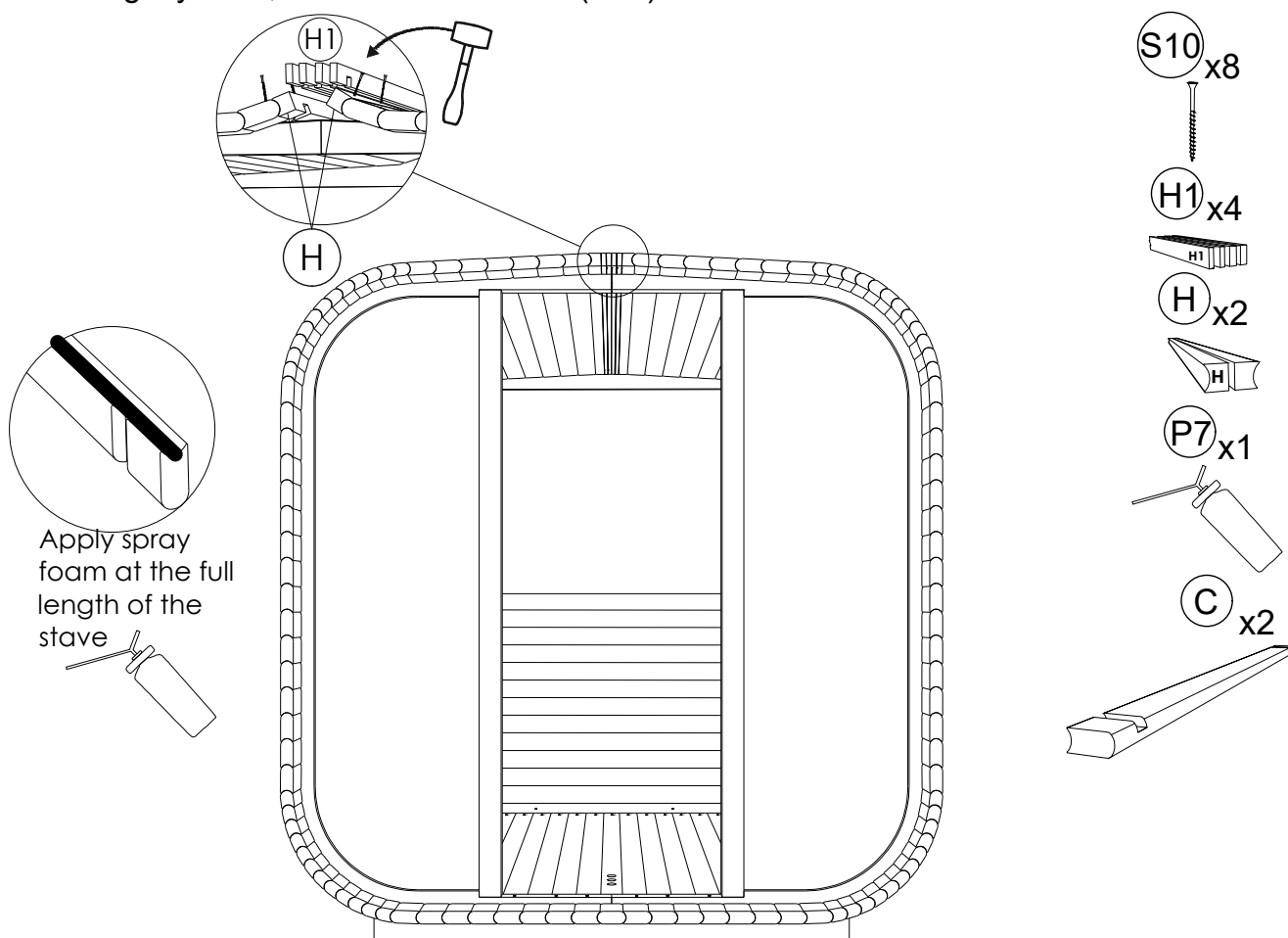
**STEP 13:** Install the panoramic panel (V1) with caution. Use foam between panels for better insulation. Place it on top of the lower back panel (V). Check level and that side edges are aligned with bottom panel. One keeps holding the panel, and the other is fixing the side stave on a curve using screws (S10). Secure the panel (V1) with screws at the both corners using two screws (S4).



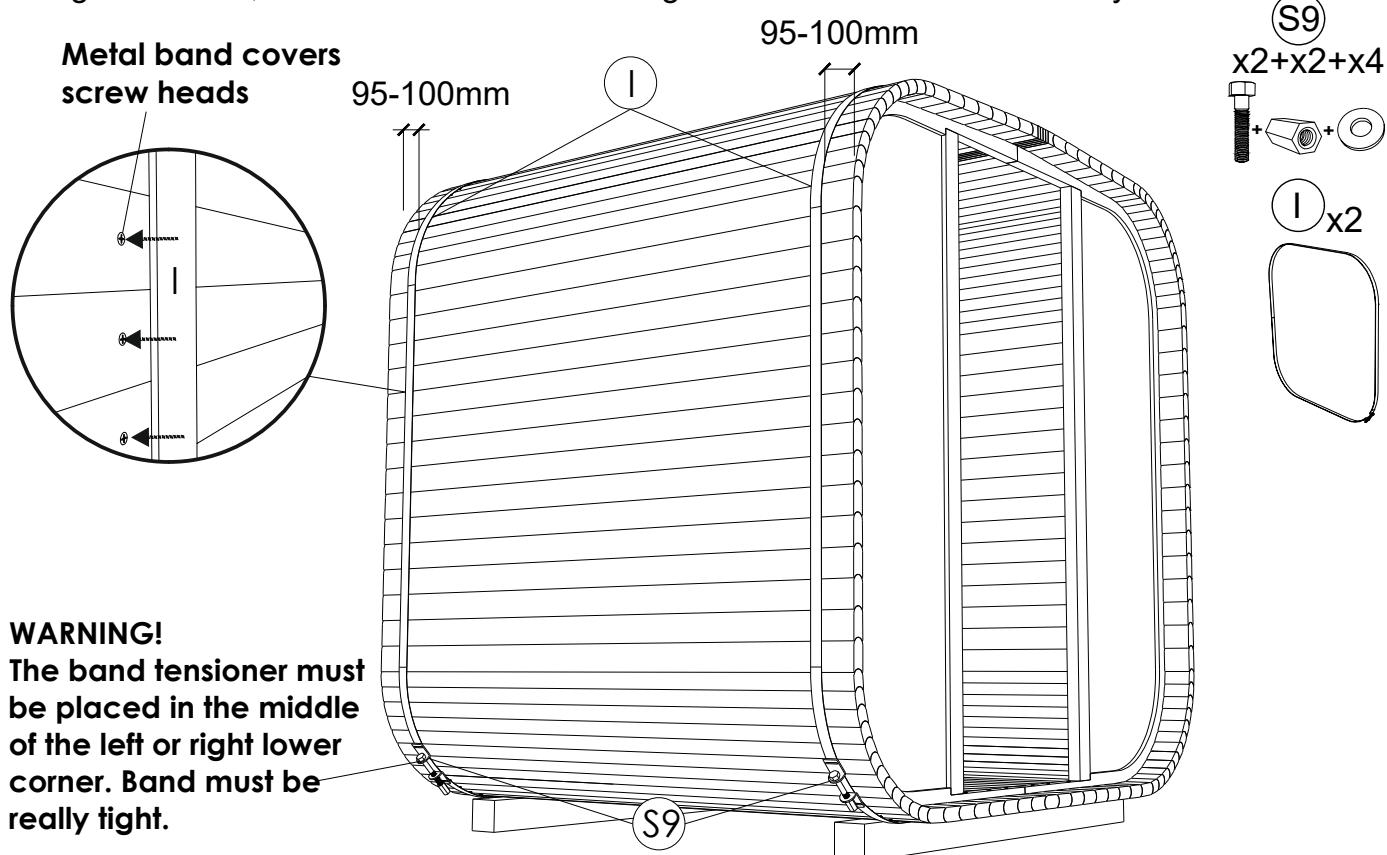
**STEP 14:** Fix 16 staves (C) on both sides using (S10) screws. Use a rubber hammer for tighter placement. On the arches use 12 (SC) staves on both corners using (S10) screws. Fix last 6 staves (C) Use foam between every stave.



**STEP 15:** Finish roof with the 2 (C) staves and final staves (H). If needed, use thinner staves (H1) to fill the gap between (H) staves and apply foam between staves. Make sure that centre of the roof is tightly filled, then fix with screws (S10).

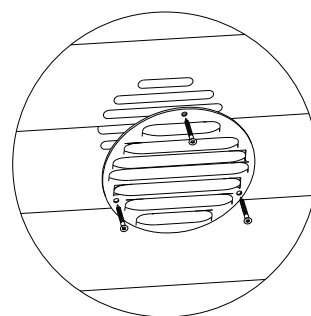
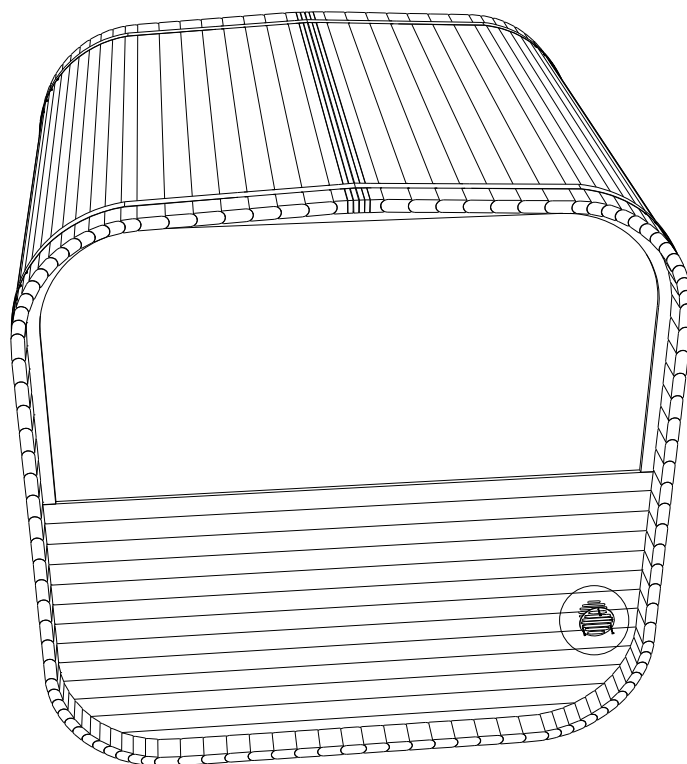
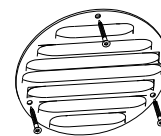


**STEP 16:** Install metal bands over the screw heads. **Screws (S9) must be placed at the saunas lower corner as shown in picture**, then tighten the screws. Check the bands align evenly all round the sauna 95-100mm from both sides. Keep tightening bands till you feel strong resistance, bands can't be loose. Re-tighten the bands after a few days.



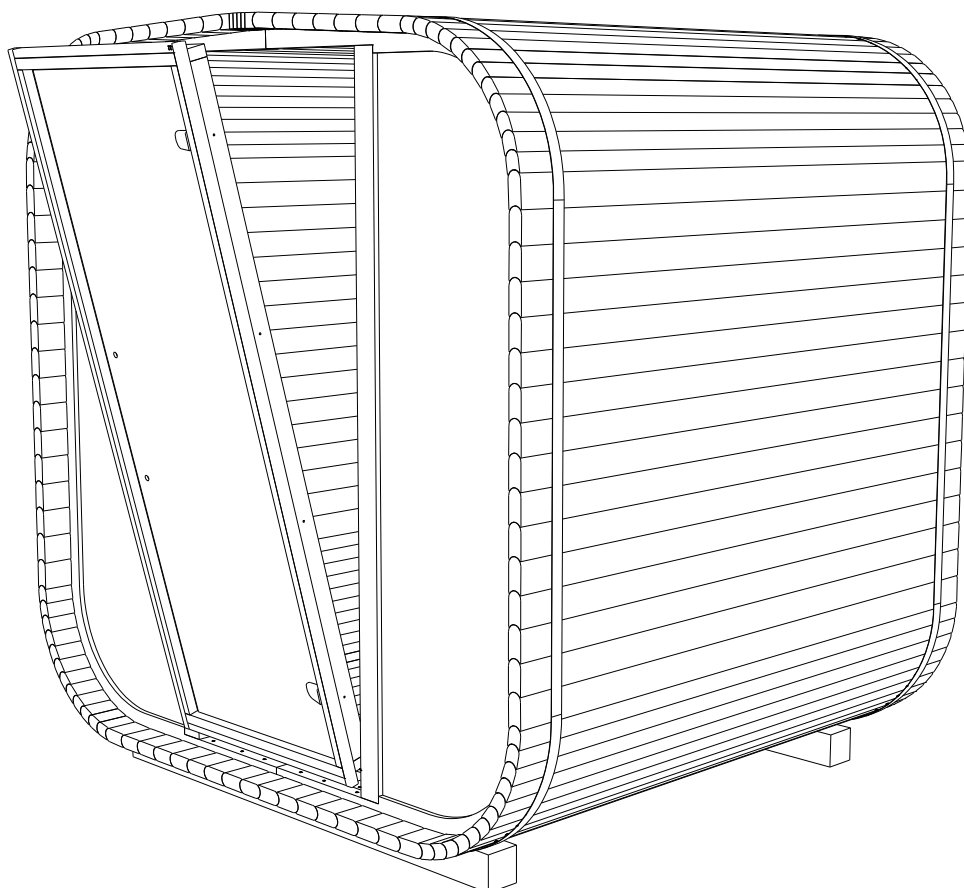
**STEP 17:** Install ventilation grill from outside over ventilation cuts.

Y1 x1

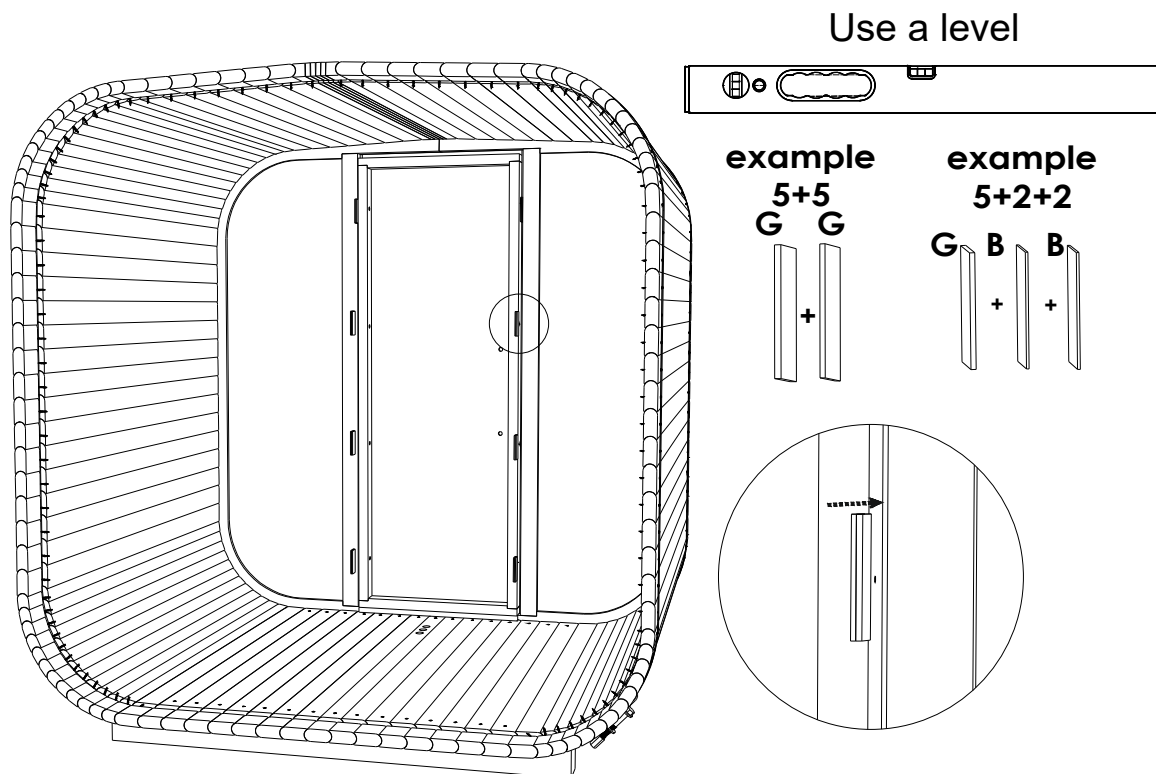


**STEP 18:** Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.

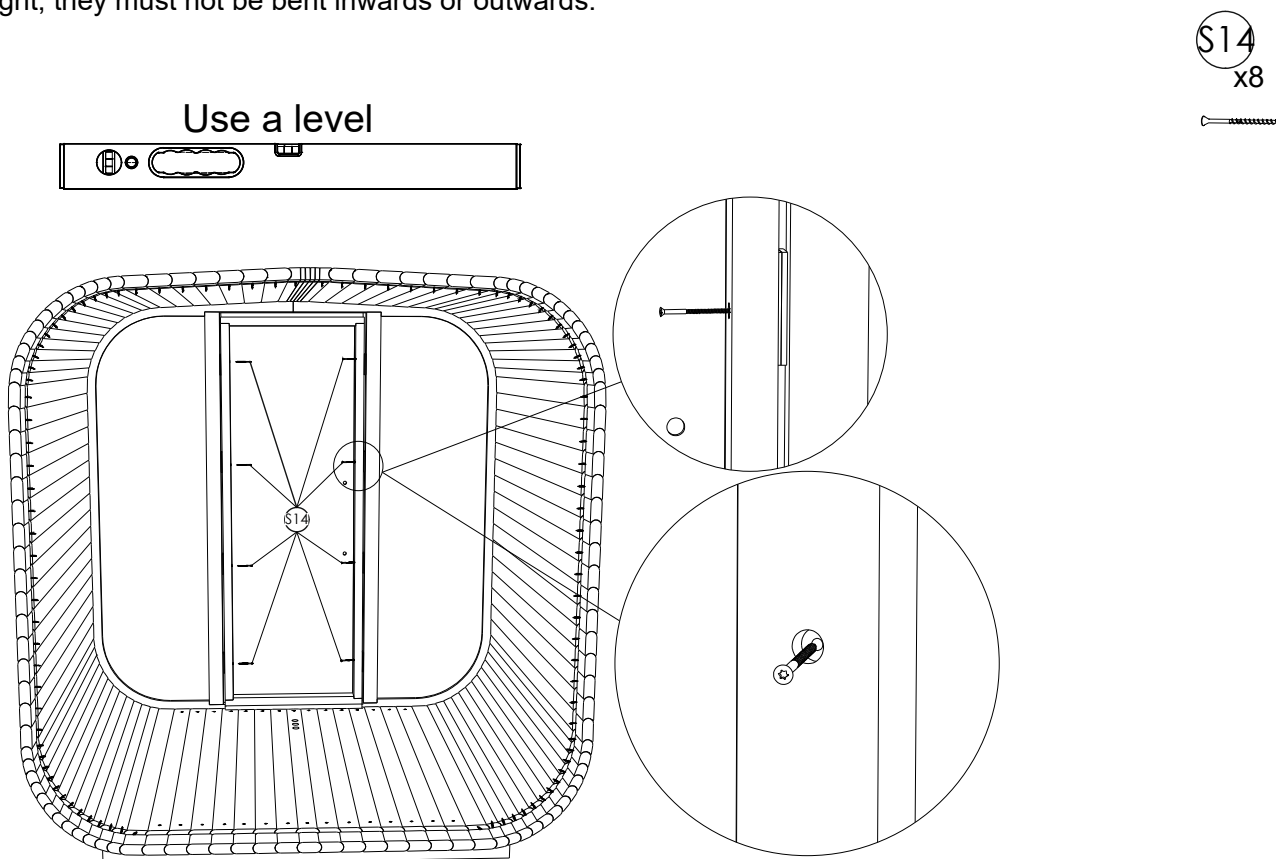
F2 x1



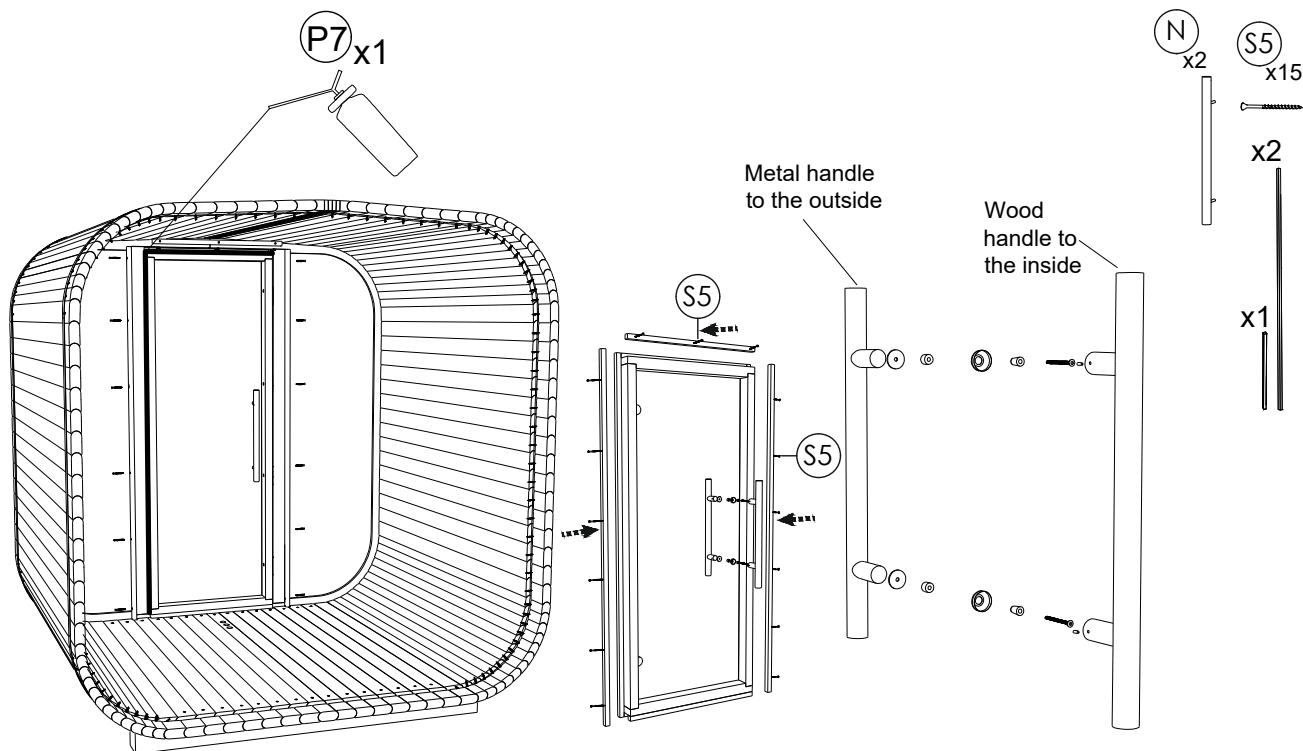
**STEP 19:** Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. Spacer must fit tightly.



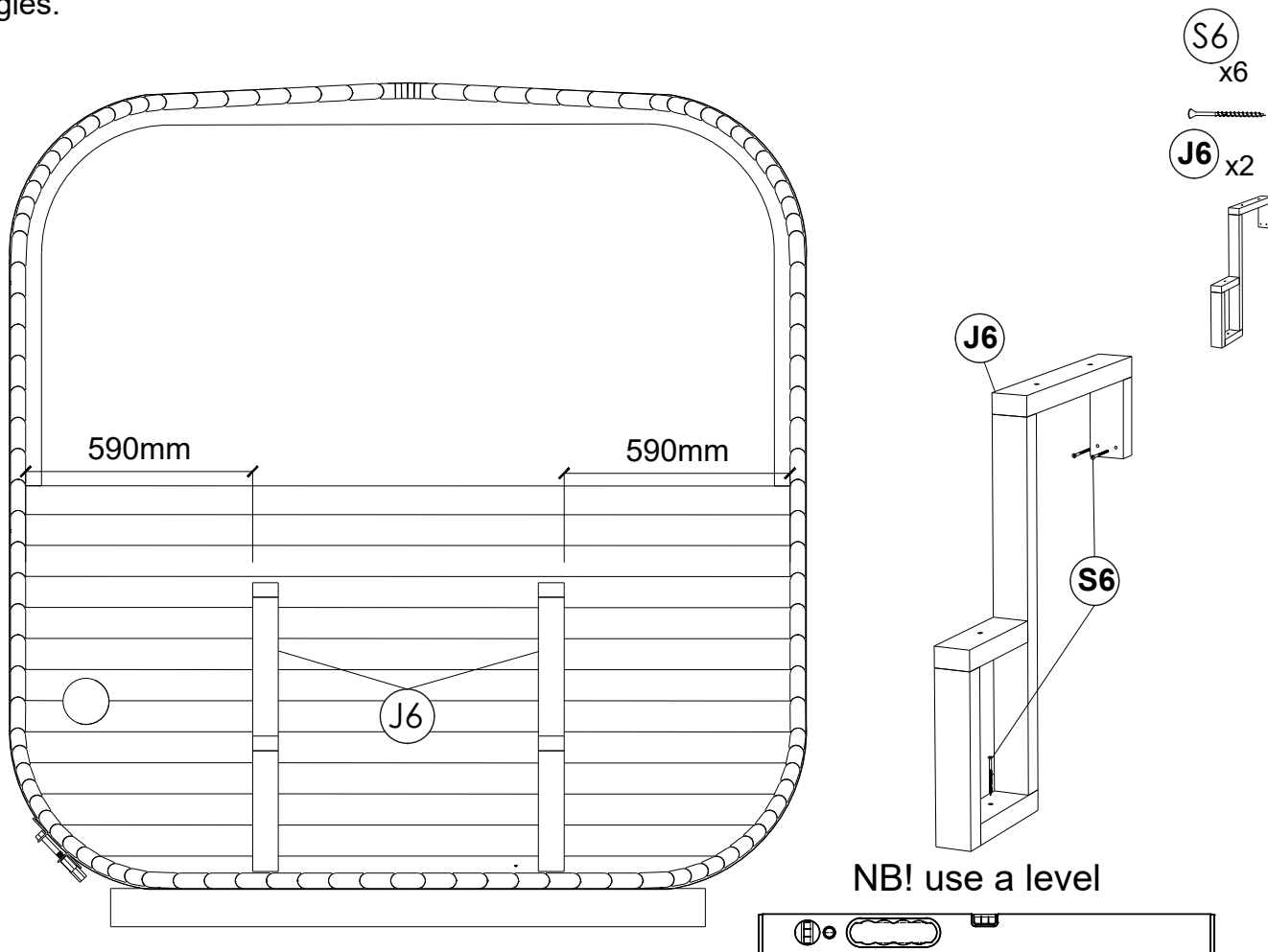
**STEP 20:** Fix one side of the door box with screws (S14) slightly to the outside through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly, they can't slip down before door is fixed with screws. Use screws (S14) to fix doors. Check door box, both sides should be straight, they must not be bent inwards or outwards.



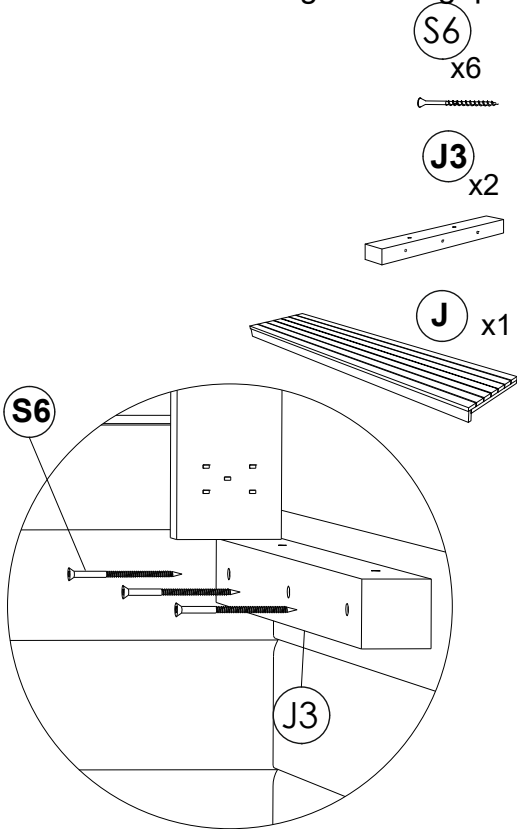
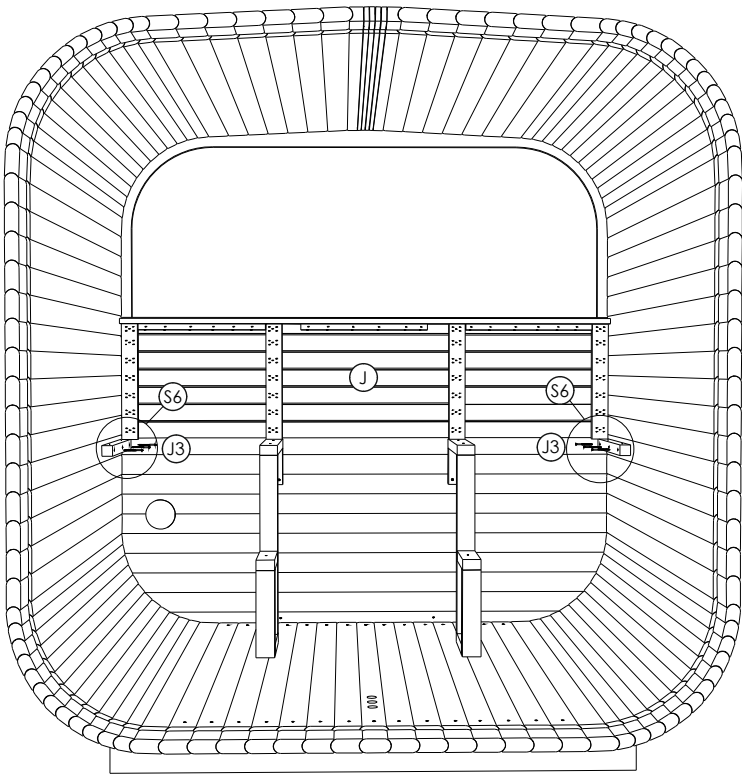
**STEP 21:** Use spray foam around door box. Let the spray foam dry. The excess amount will come off easily if you don't touch it while it's wet. Fix door moldings to both sides and on top of the door with (S5).



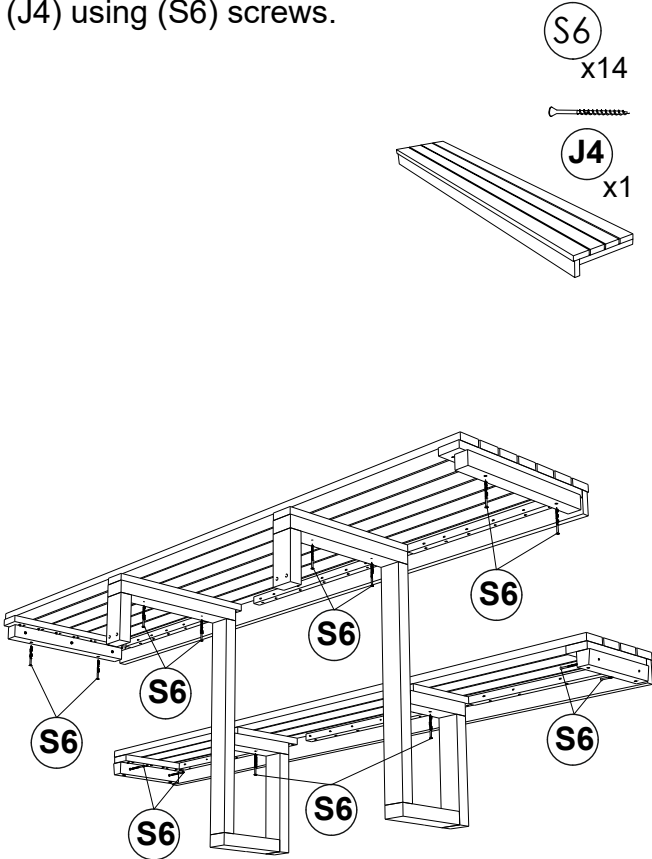
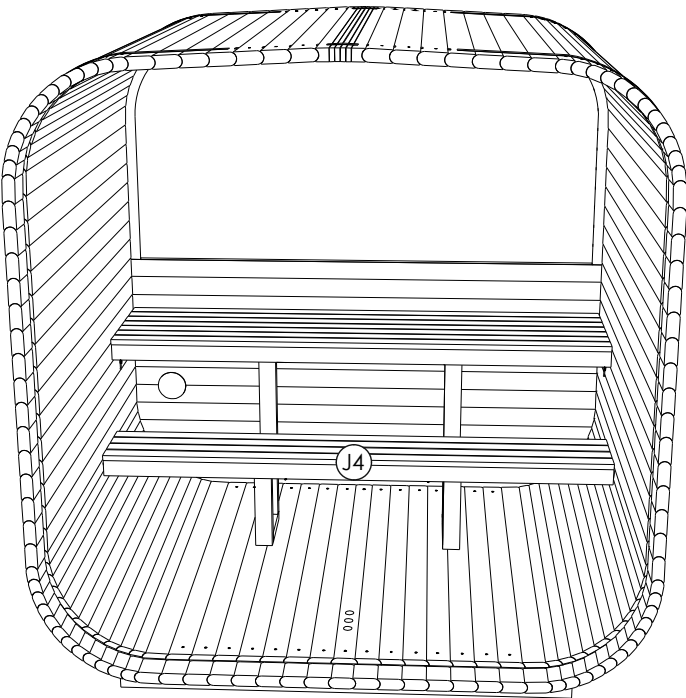
**STEP 22:** Install bench legs (J6;) with (S6) screws. Take measurements as in the picture, both legs (J6) are 590mm from side walls. Check the legs to ensure they are straight from all angles.



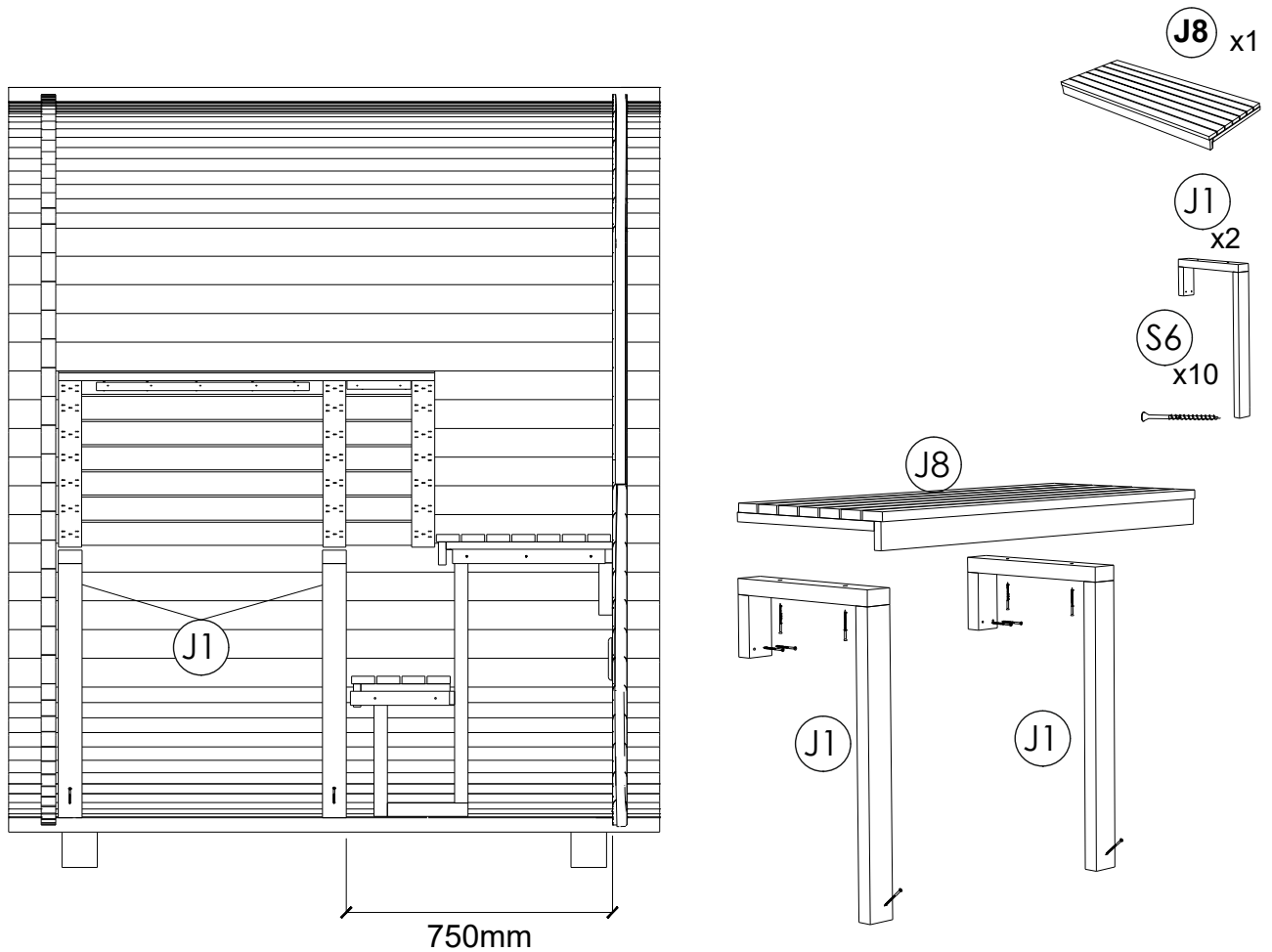
**STEP 23:** Place long sauna bench upwards on the bench legs. Then install bench support boards (J3) on the side walls using S6 screws, at the same level as the bench legs. leave gap from back wall about 20mm.



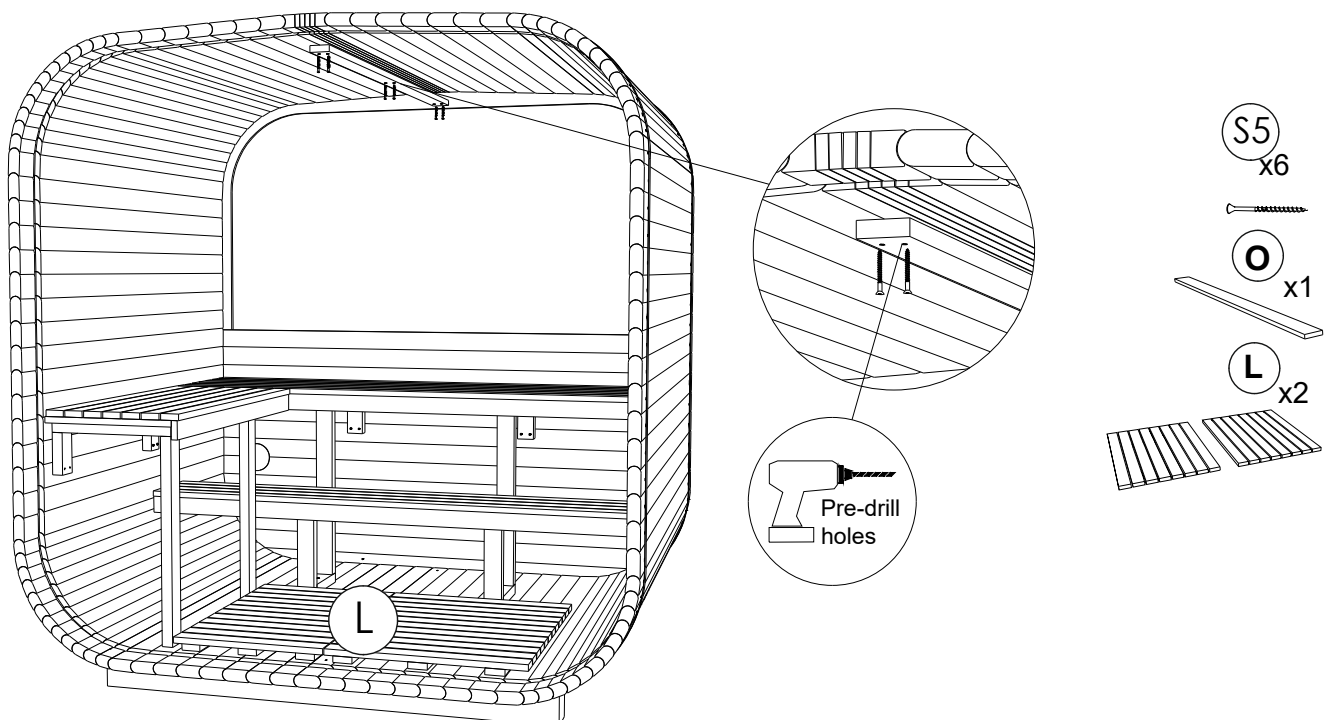
**STEP 24:** Install sauna bench (J) on top of the legs (J6) using (S6). Bench cross boards have to match the tops of the bench legs. Fix Bench step (J4) using (S6) screws.



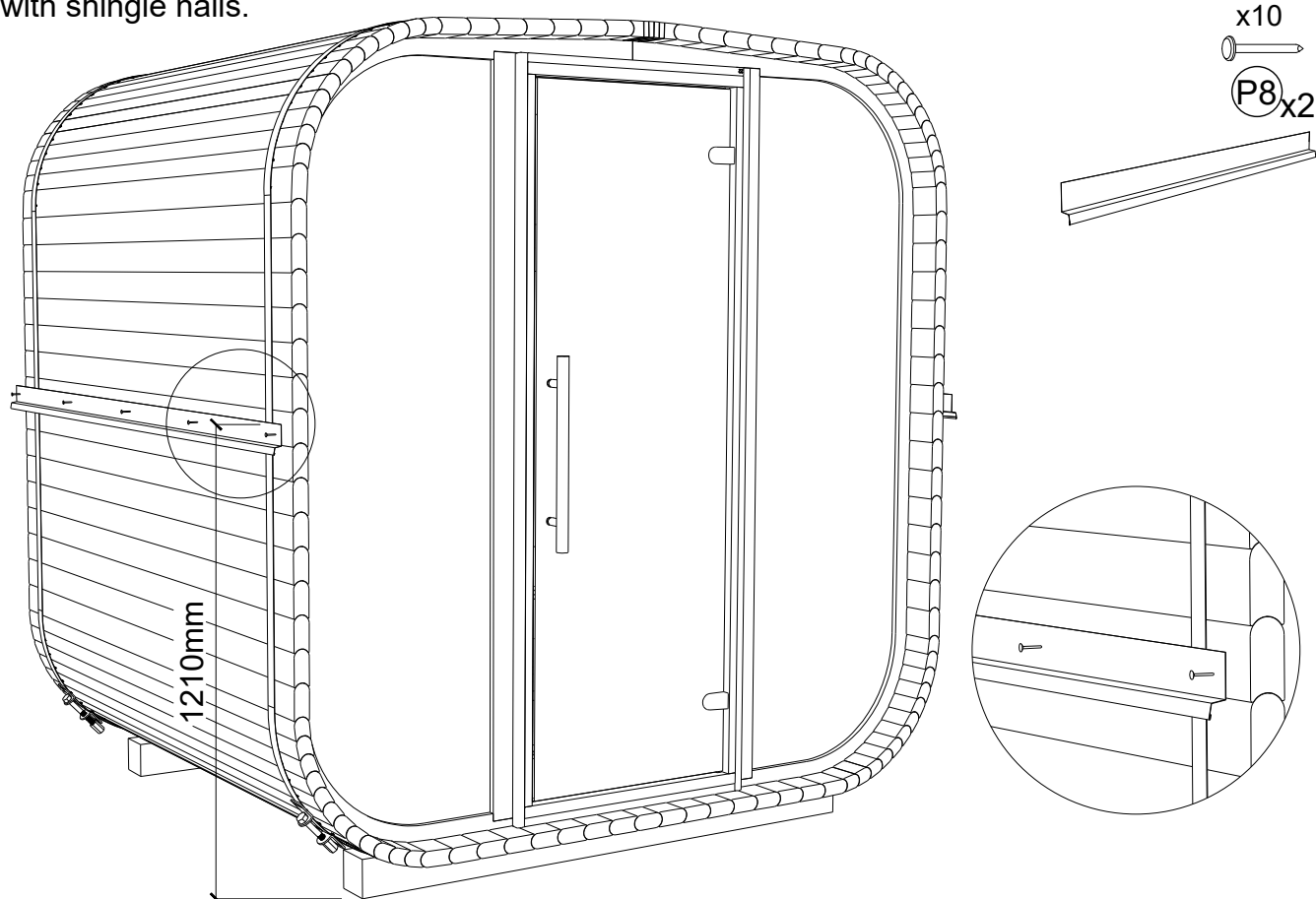
**STEP 25:** Install bench legs (J1;) with (S6) screws. The left leg needs to be installed next the front panel (F), right leg is 750mm from bottom rear panel. Fix sauna bench (J8) using (S6) screws.



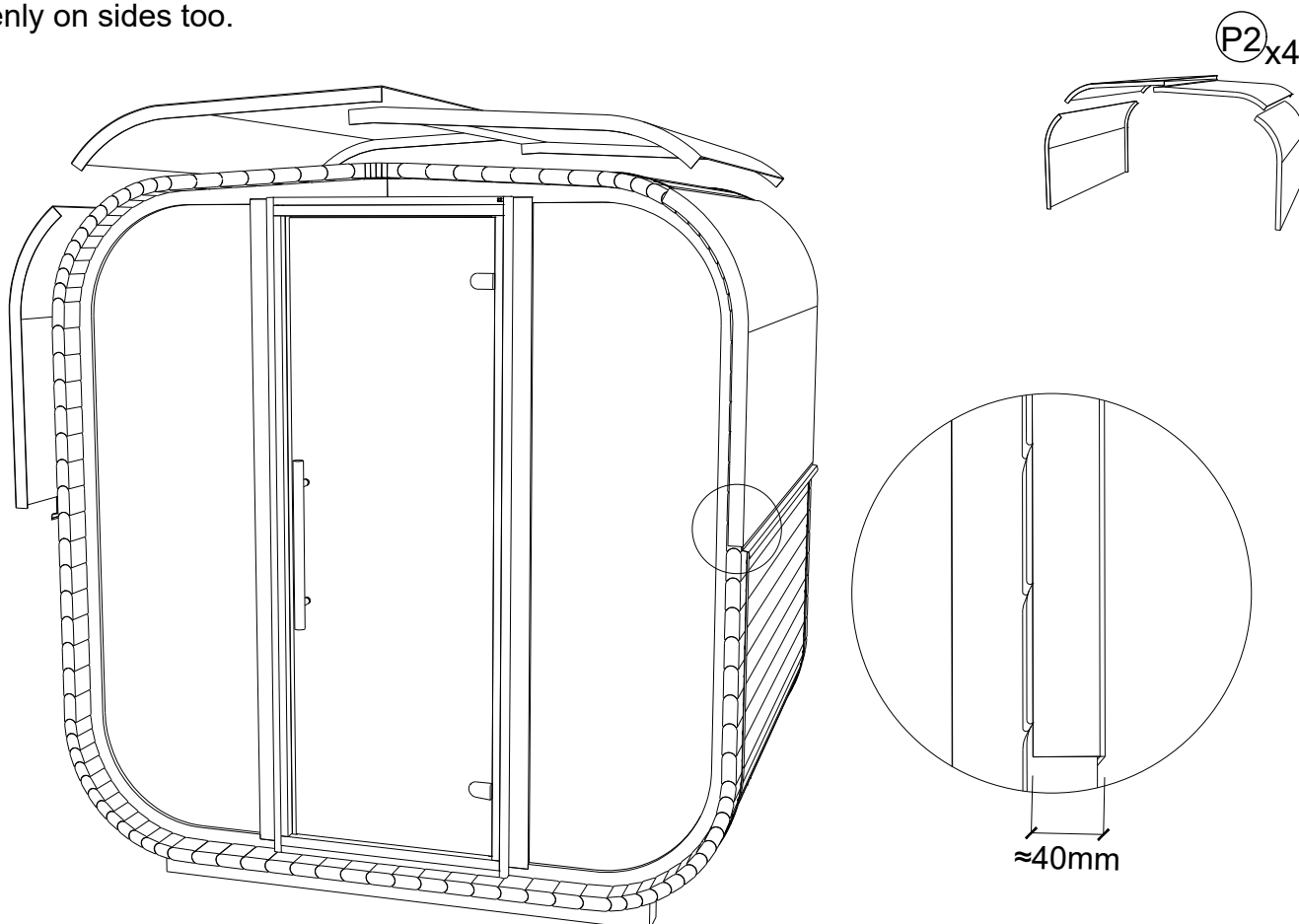
**STEP 26:** Install the ceiling board (O) in the middle of the ceiling, pre-drill holes for screws (S5). Lay in sauna floor (L).



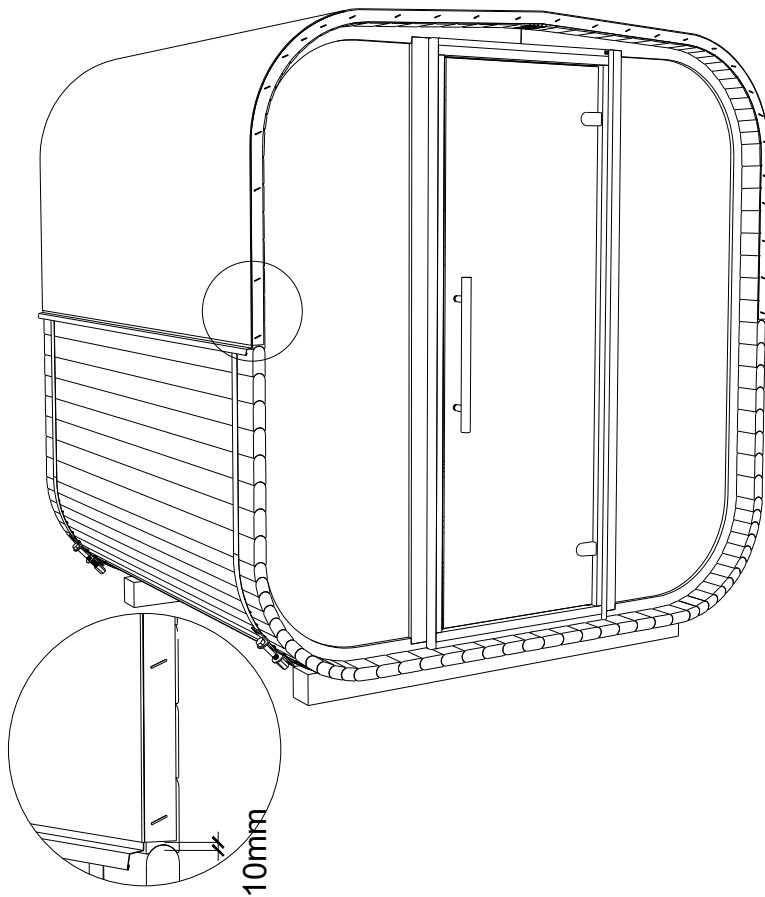
**STEP 27:** Place the rain droplet upper edge 1210mm from ground. Make sure it's leveled. Fix it with shingle nails.



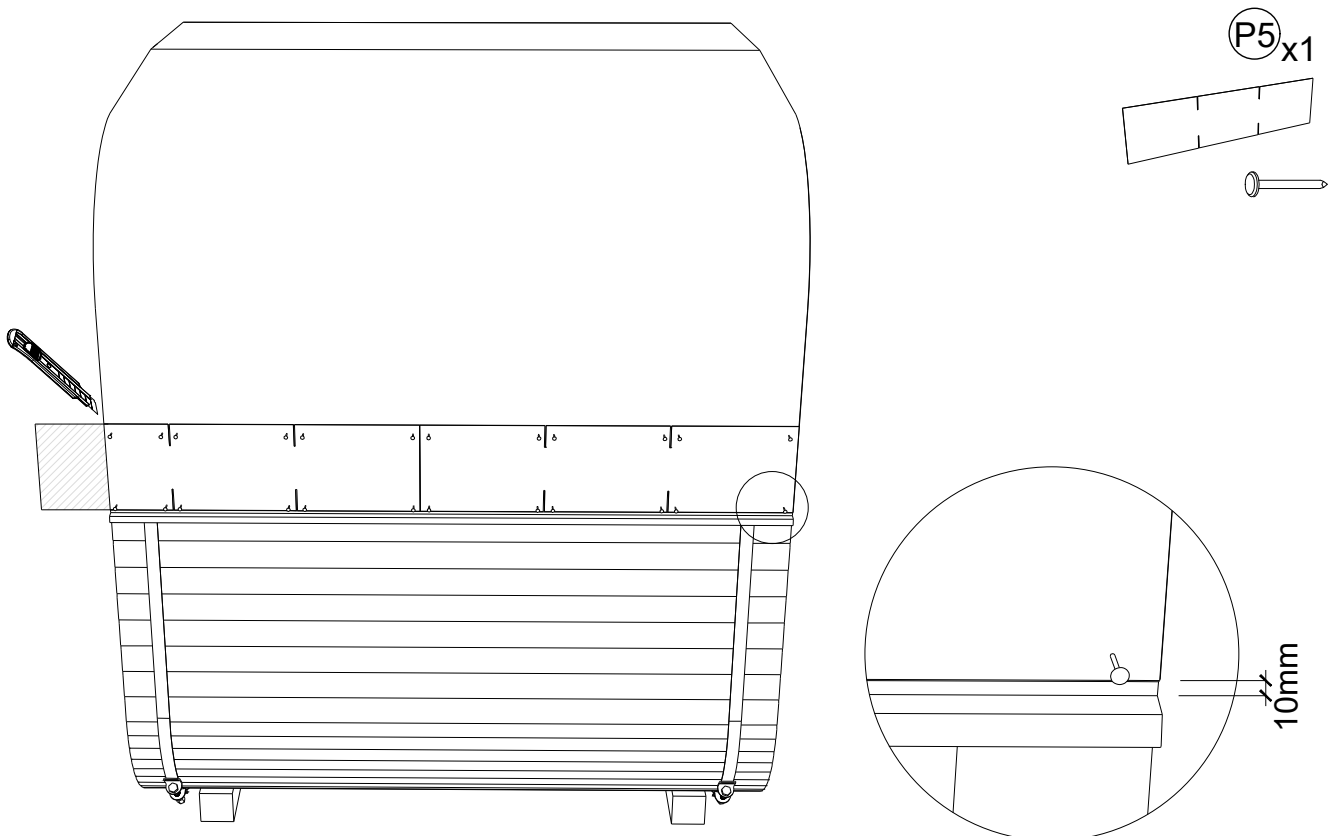
**STEP 28:** Fix underlay on the both sides first. Upper underlays overlaps no less than 100mm on both sides. Leave underlay about 40mm over the back and front edge, make sure it's evenly on sides too.



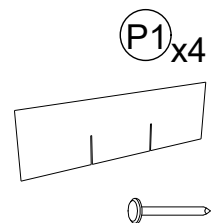
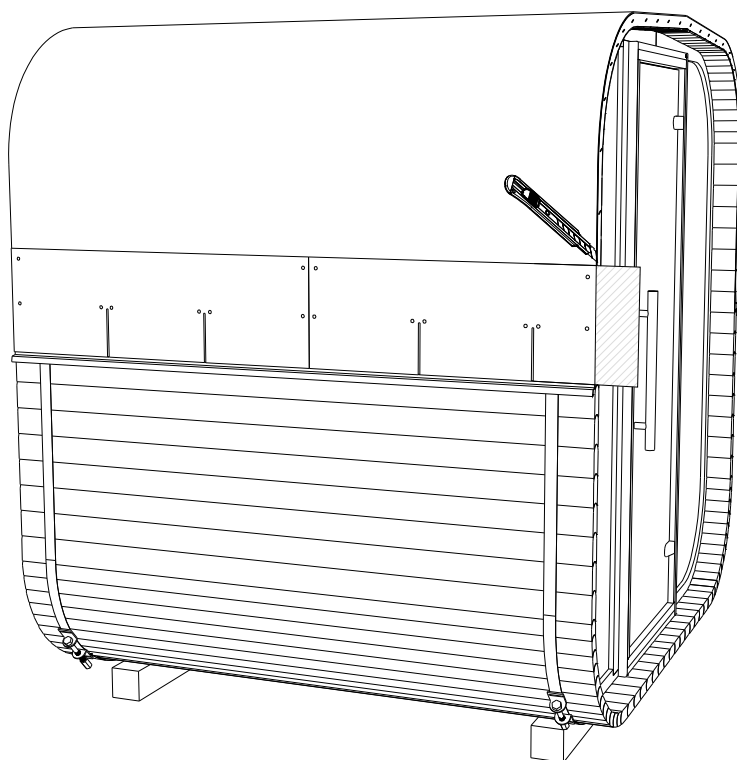
**STEP 29:** Staple underlay at the front and back edges. Cut excess underlay if necessary.



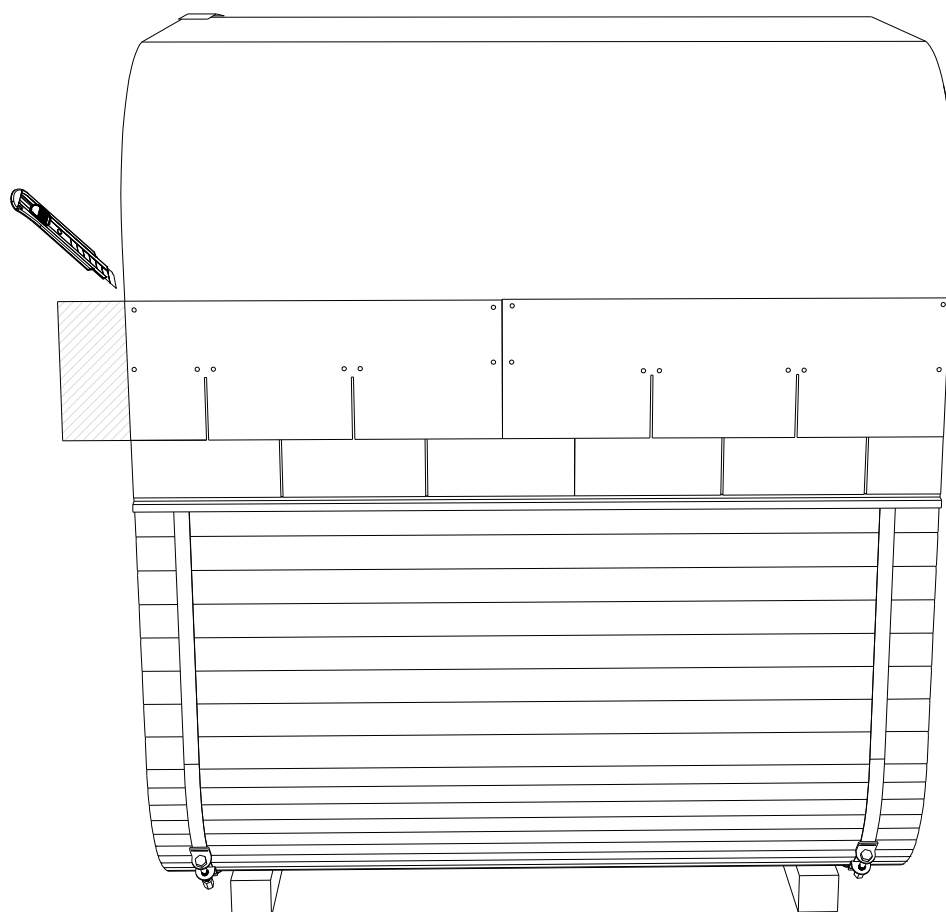
**STEP 30:** Remove protective film from the bottom of the sheet. Place starting shingles next to each other. Then fix with nails as in picture. Cut excess part of the starting shingle before nailing it.



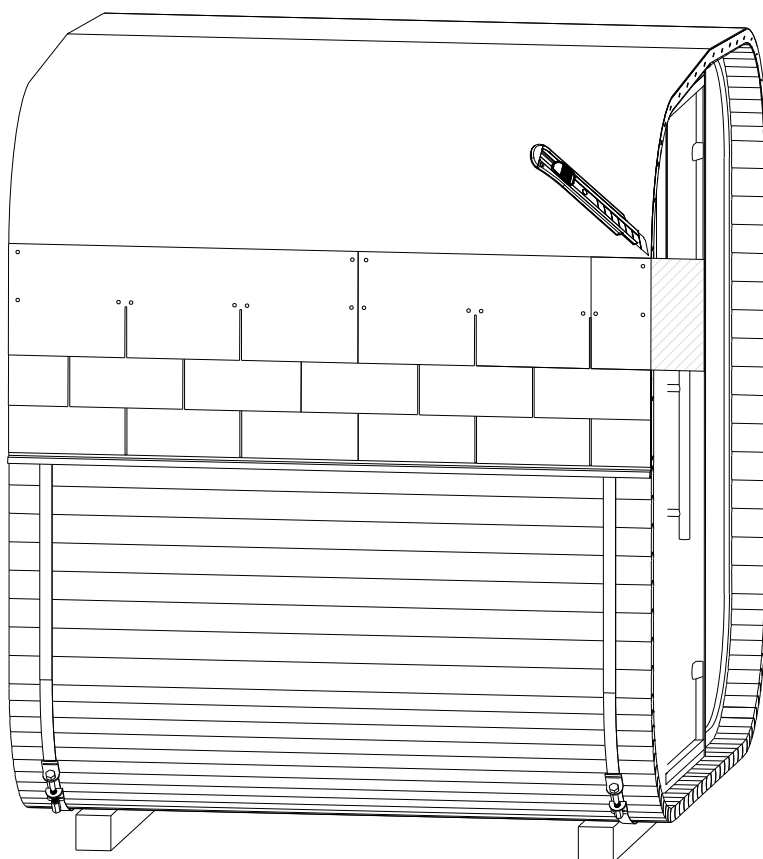
**STEP 31:** Remove protective film from the bottom of the sheet. Start placing shingles over starting shingles. Cut half of the rectangle from whole shingle and fix it with nails. Fix next shingle next to first.



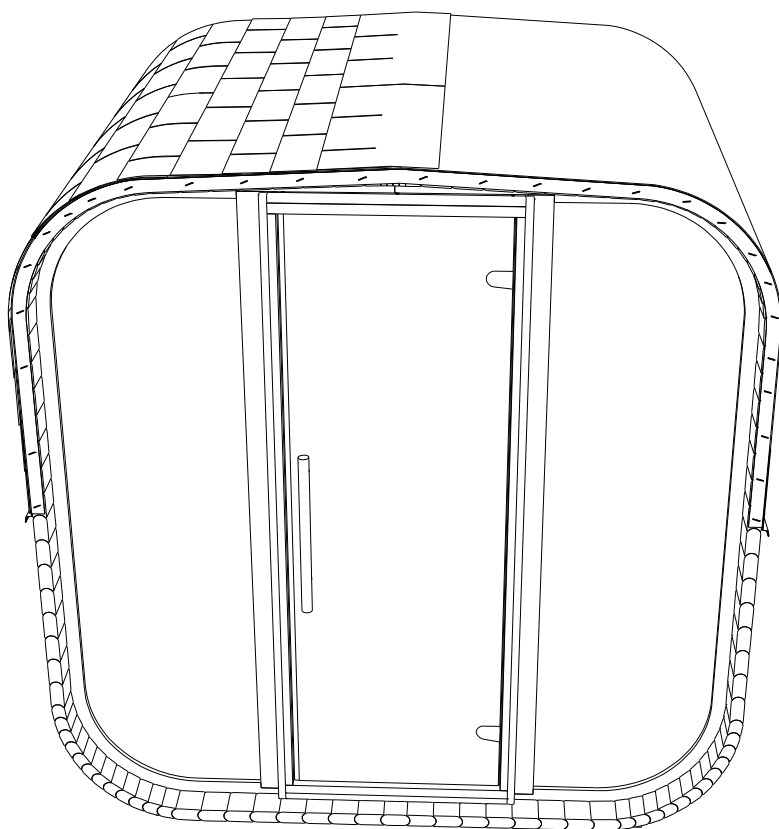
**STEP 32:** Remove the protective film from the bottom of the sheet. The second row starts with the whole shingle, fix it with shingle nails.



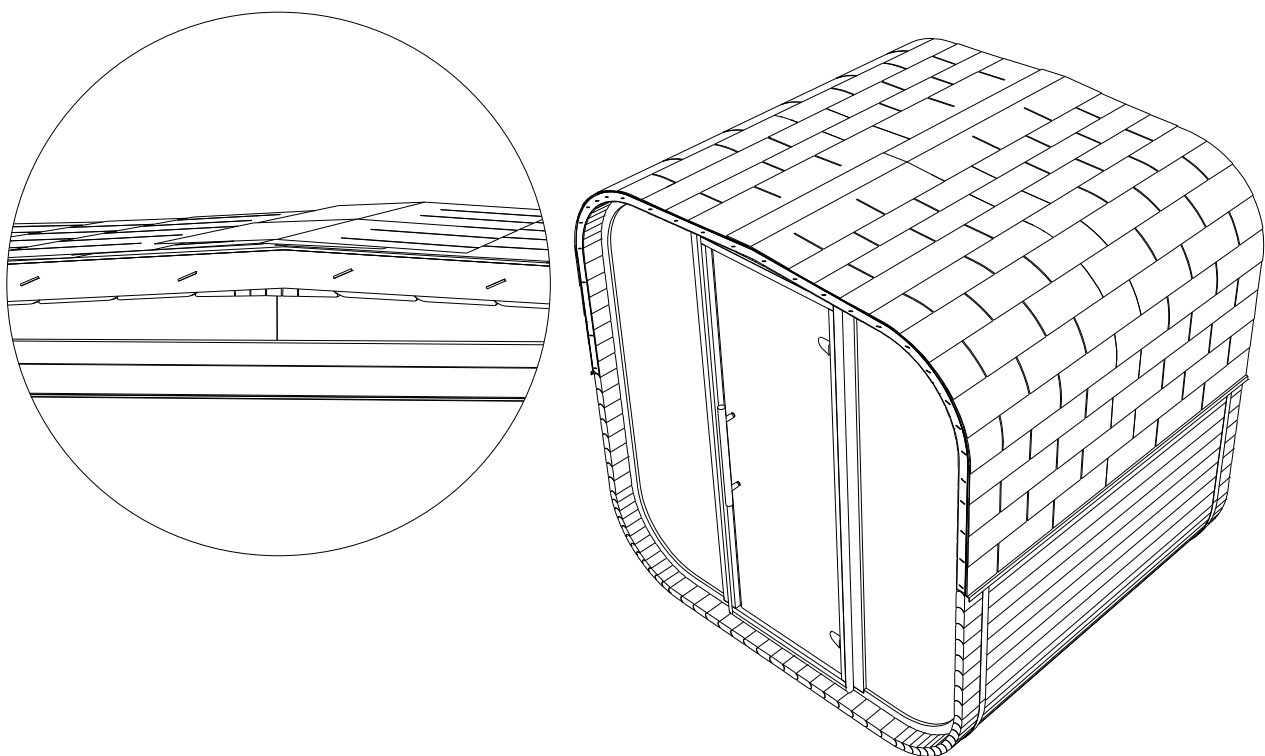
**STEP 33:** Remove protective film from the bottom of the sheet. Third row goes exactly like first row. Cut half rectangle from shingle and fix it with shingle nails.



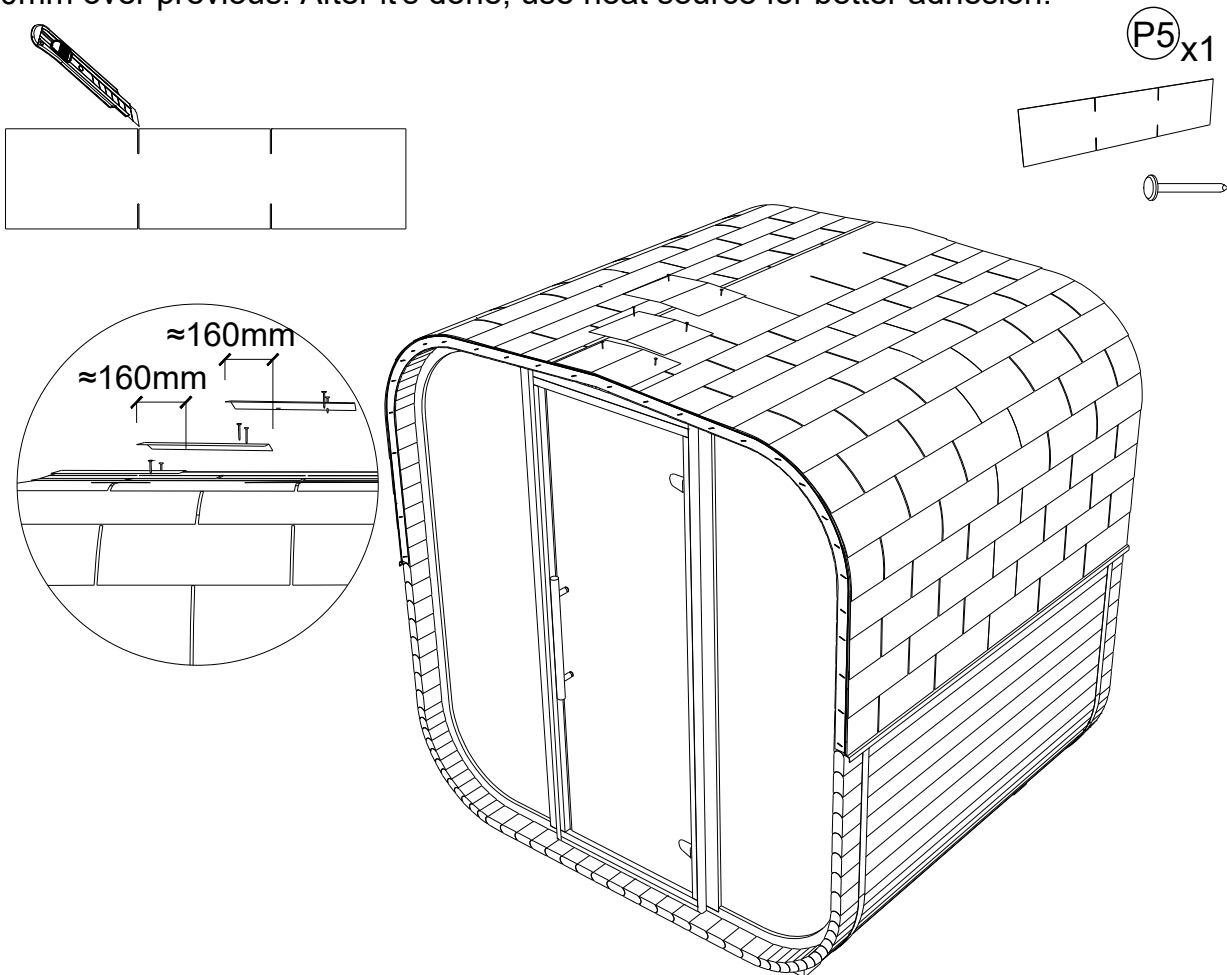
**STEP 34:** Keep placing shingles till last layer goes over the middle of the roof.



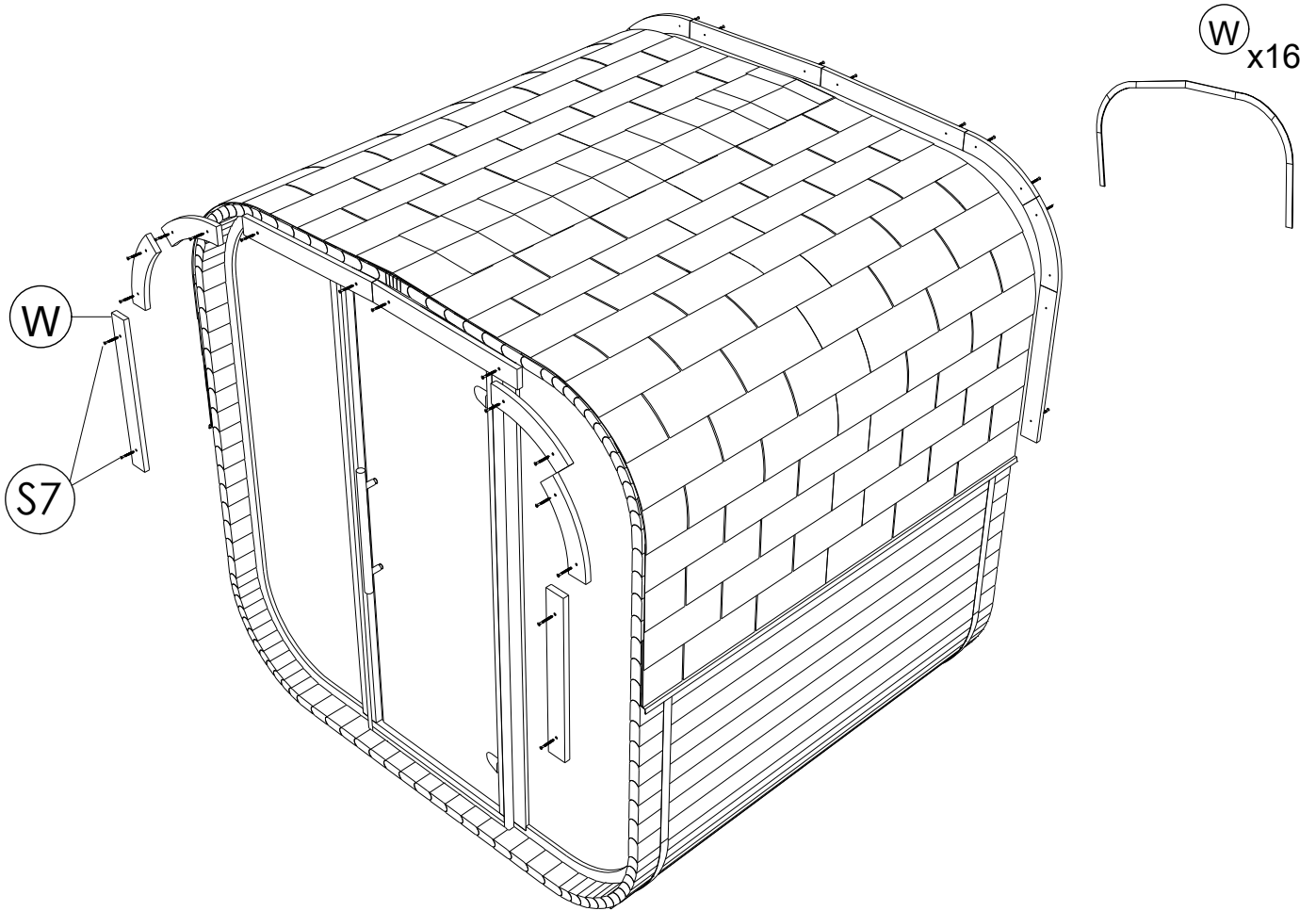
**STEP 35:** Repeat same steps for other side, till last layer goes over middle of the roof. Use heat source for better adhesion. Lift every rectangle, heat a bit and press it to the roof.



**STEP 36:** For top of the roof use starting shingles. Cut some shingles in squares, there are marked lines. Take off protective film. Nail each shingle with two nails. Next shingle goes about 160mm over previous. After it's done, use heat source for better adhesion.



**STEP 37:** Install front and back decorative roof finishing boards using (S7). Start by fixing two top boards, then rest of it goes next to each other.



**STEP 38:** Use bitumen sealant behind decorative boards to fill gap between shingles and boards.

