INSTALLATION MANUAL

1500x2000xh2100 Sauna Exelia Black
24LE00033036

1. Preparations

- Sauna package must be stored in a heated and dry room.
- Prior to installation ithe package must be opened and stored for 48h to adjust to relative humidity of the room (22^{o}C, 40-60% RH).
- Ensure the sauna model fits in the designated room with sufficient extra room for ease of installation.
- Clean the location of sauna with care in order to not damage any details, elements
- Room must be well ventilated and with water drain on or near the position of the sauna.
- Sauna is intended to be installed on a level surface to ensure proper installation and quality of the installed product.
- Adequate electrical supply must be ensured for electrical components of the sauna. Refer to user manuals of respective products.
- Electrical connections to the power grid and to the sauna may only be carried out by legally competent and certified specialist.
- Producer cannot be held responsible for any errors resulting from disregard to the levelness of substructure, inadequate storing conditions, inadequate power supply, unauthorized alterations to components or any other circumstances occuring from deviations described in this manual and/or good customs.

2. List of tools

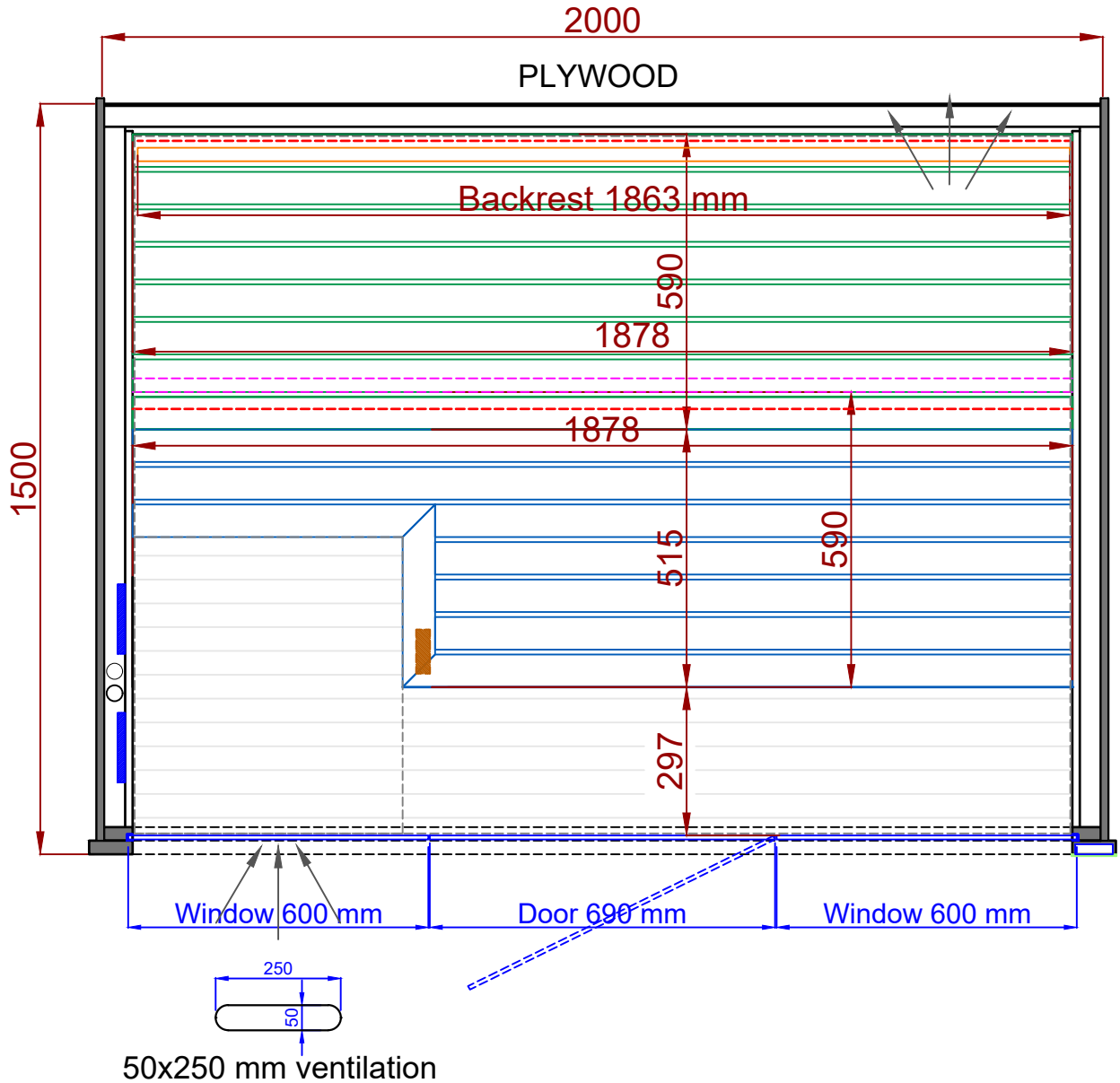
- Water level
- Tape measure
- Power drill
- Rubber or plastic mallet
- Silicone gun
- Screwdriver set

Installation of a sauna requires at least two (2) persons.

3. Installations

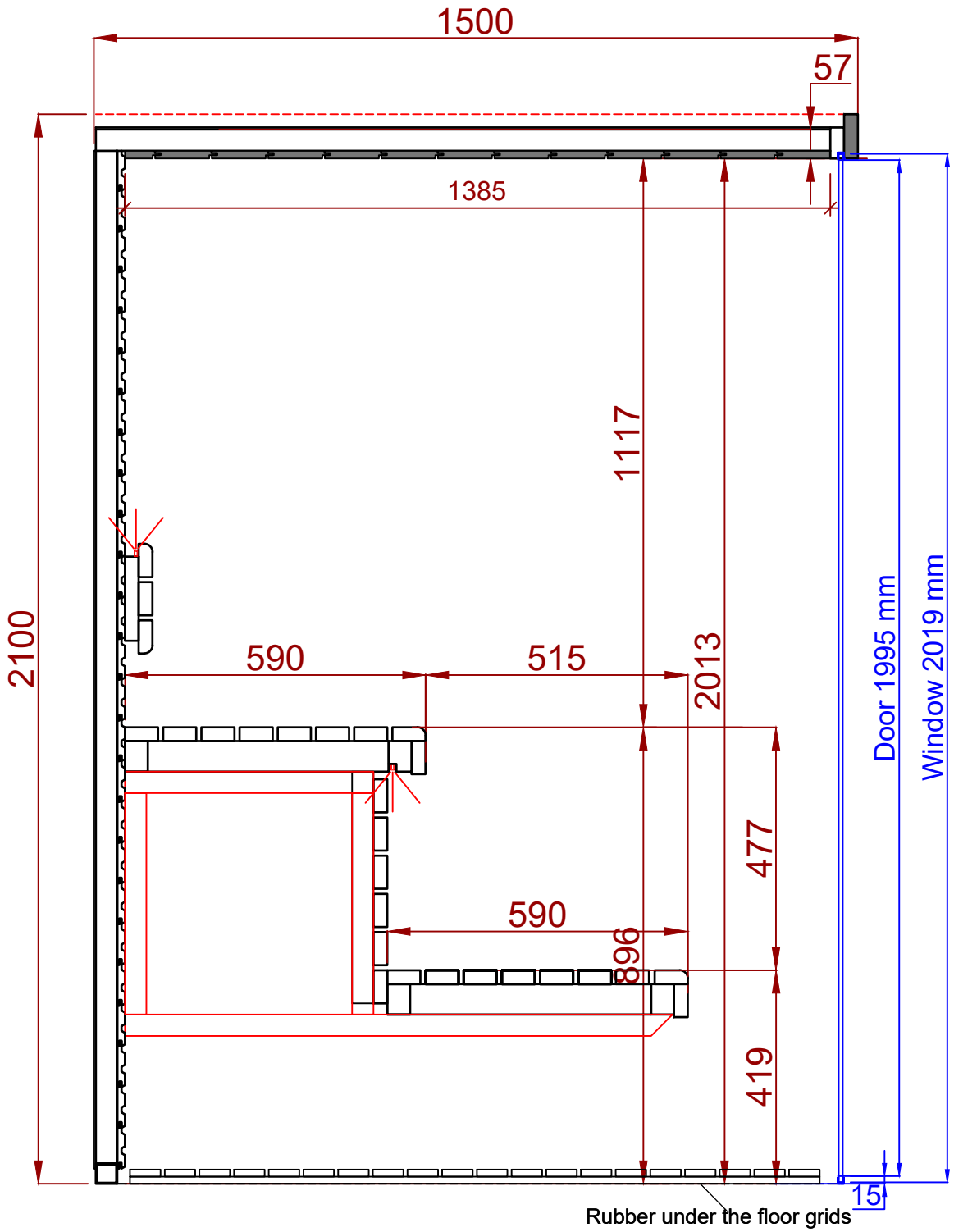
- Follow the instructions precisely.
- Always start from 1 and continuosly move forward in an organized manner.
- Keep the installation site always clean and organized.
- This manual does not take into account any possible peculiarities of the installation site.
- Take care not to damage any components during installation due to dropping, dragging or careless handling.
- Special attention towards elements - they must be stored with care and kept away from any hard or sharp objects. Glasses are tempered and even smallest damages to the surface or corners can lead to concentration of stress and shattering of the glass.

TOP VIEW



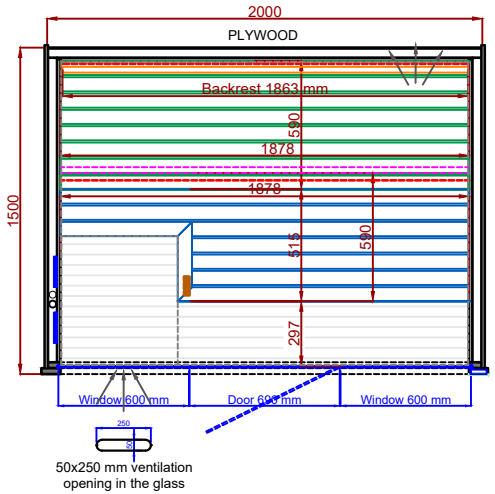
50x250 mm ventilation opening in the glass

CROSS-SECTION

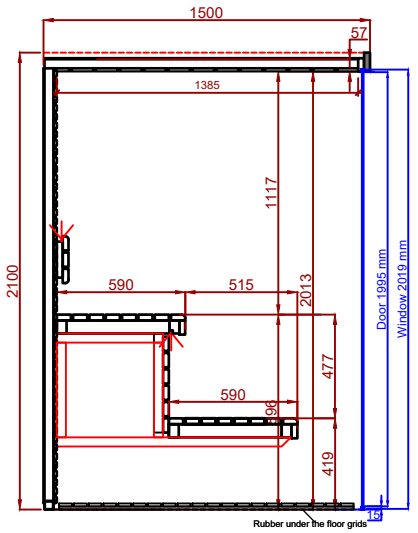


LEGEND	
X	WALL LABELLING
	VENTILATION AIR INLET 50x250 mm NEAR THE FLOOR
	VENTILATION OUTLET 50x250 mm UNDER THE BENCH
	BACKREST
	UPPER BENCH
	LOWER BENCH

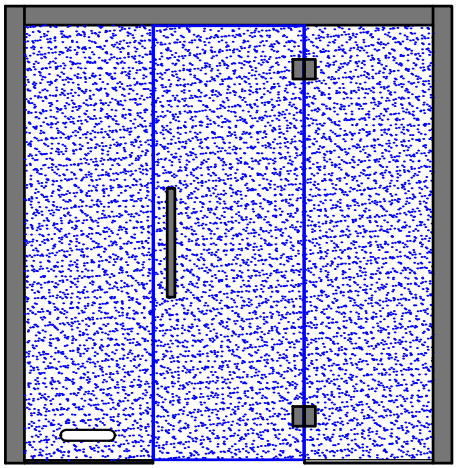
TOP VIEW



CROSS-SECTION



FRONT VIEW



TECHNICAL INFORMATION	
BASE FRAME	40X40 ALUMINIUM BASE FRAME **(BLACK)**
INSIDE WALL & CEILING PROFILE	HORIZONTAL STV VALEURA 15x90 THERMO ASPEN, STS4 15x120 IGNITE (BLACK) (CEILING)
OUTSIDE WALL PROFILE/MATERIAL	HORIZONTAL STS4 15x120 IGNITE (BLACK) (A,C), PLYWOOD (B)
INTERIOR MATERIAL	THERMO ASPEN
INTERIOR (PRIVATE USE)	BENCHES, BENCH SKIRT, BACK GRID, FLOOR GRID (full area)
SAUNA DOOR/WINDOW	CLEAR 8 mm TEMPERED U-Profile **(BLACK)**
HINGES	2x HINGES **(BLACK)**
HANDLE	PREMIUM HANDLE (WOOD / METAL) **(BLACK)**
LIGHTING	LED STRIPS BEHIND THE BACKREST (UP), UNDER THE UPPER BENCH + SWITCH
HEATER	BY CLIENT
CONTROL UNIT	BY CLIENT
PALLET LOADING	HORIZONTALLY PACKED

Project name:	**150x200 (6x8) Sauna Cabin black**	**Code**	**Version**
Client	**SDS Australia**	–	**2 (11.03.2024)**
	Drawing	**Top view/Cross-section 1-1**	
	Remark	**Confirmation**	
	Designer	**R.K**	
	Date	**Ready for production** –	**Loading** –

BASE FRAME

1. Check substructure level. Sauna must be installed on a level surface.
2. Connect the base frame elements
3. Fix the elements with screws
4. Check baseframe diagonals for equality and right corners
5. Apply silicone under basefame and fix in place

NOTE! If the sauna is to be moved after installation, silicone can be installed afterwards.

Figure a.

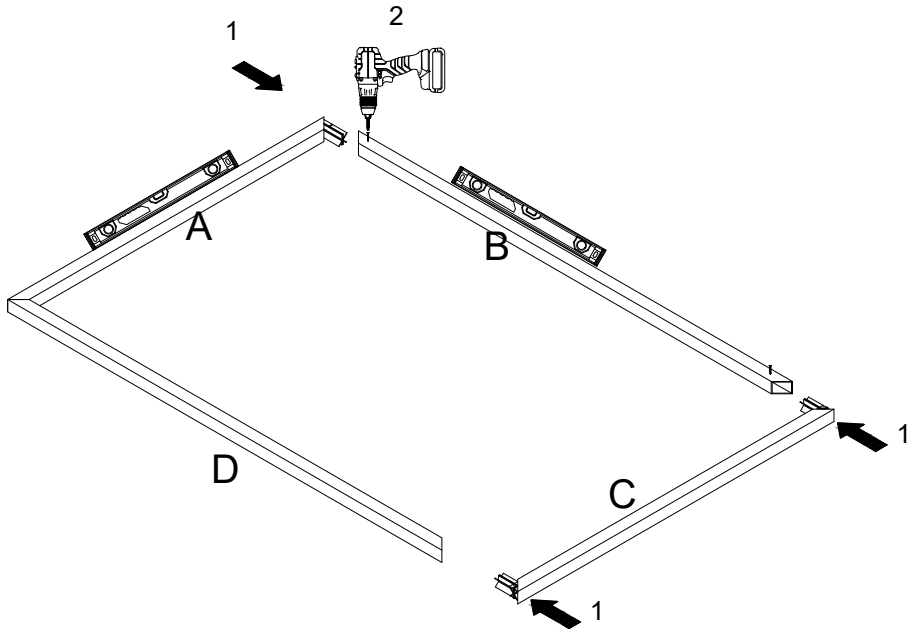
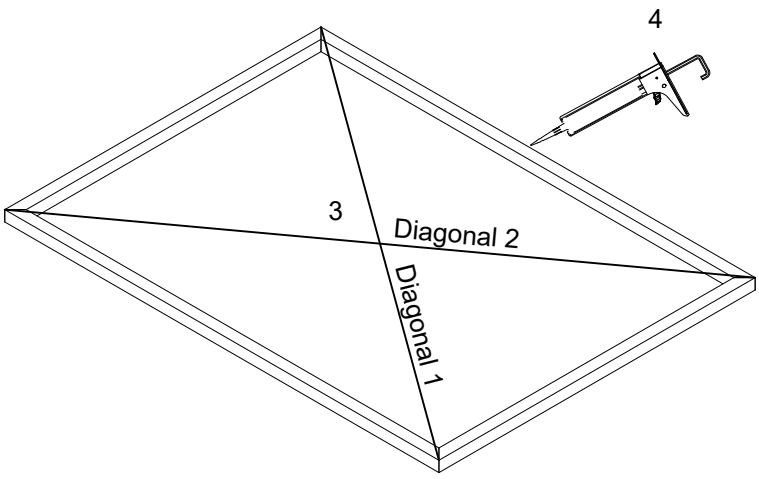
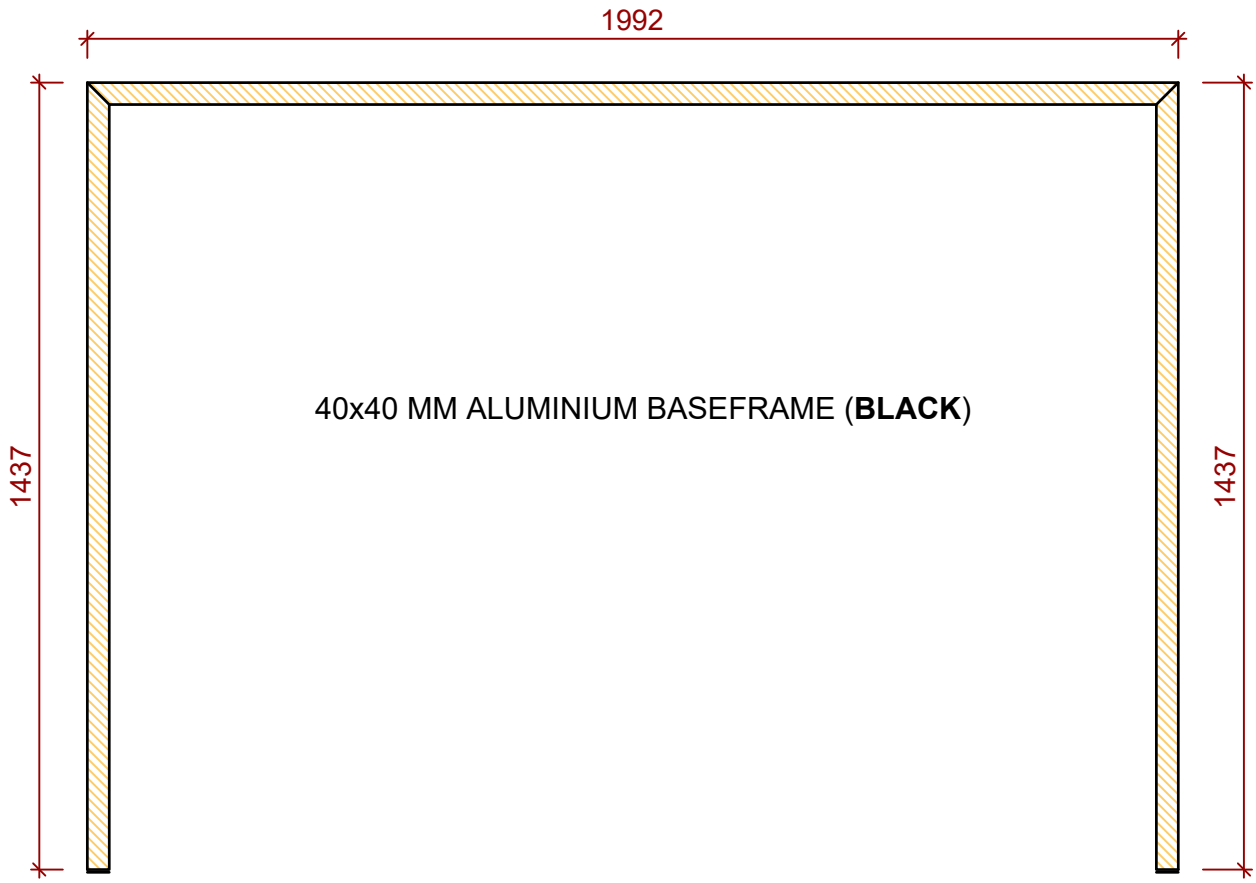


Figure b.

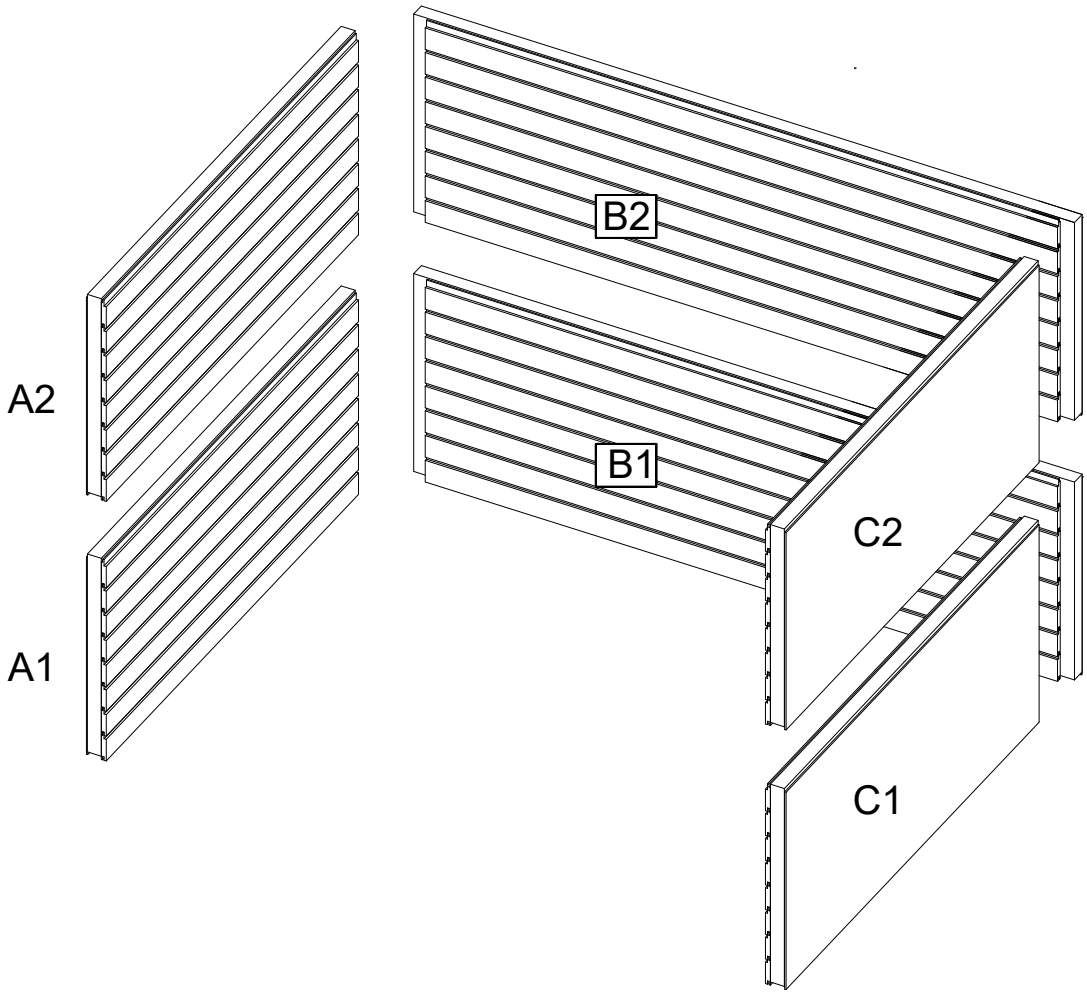


BASE FRAME



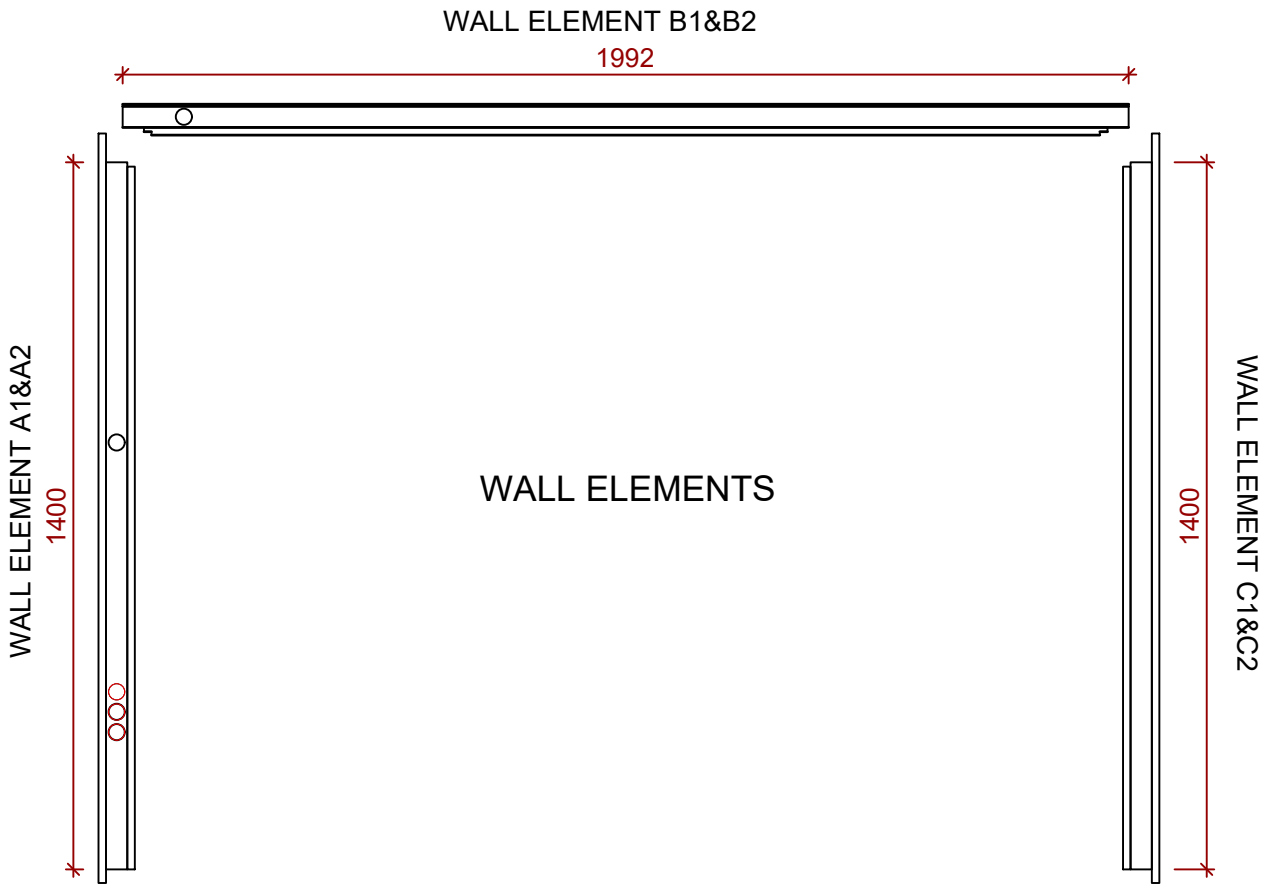
HORIZONTAL WALL ELEMENTS WITH GLASS WALL

1. See your technical drawing on next page
2. Separate walls by letters
3. Control wall symbols on base frame



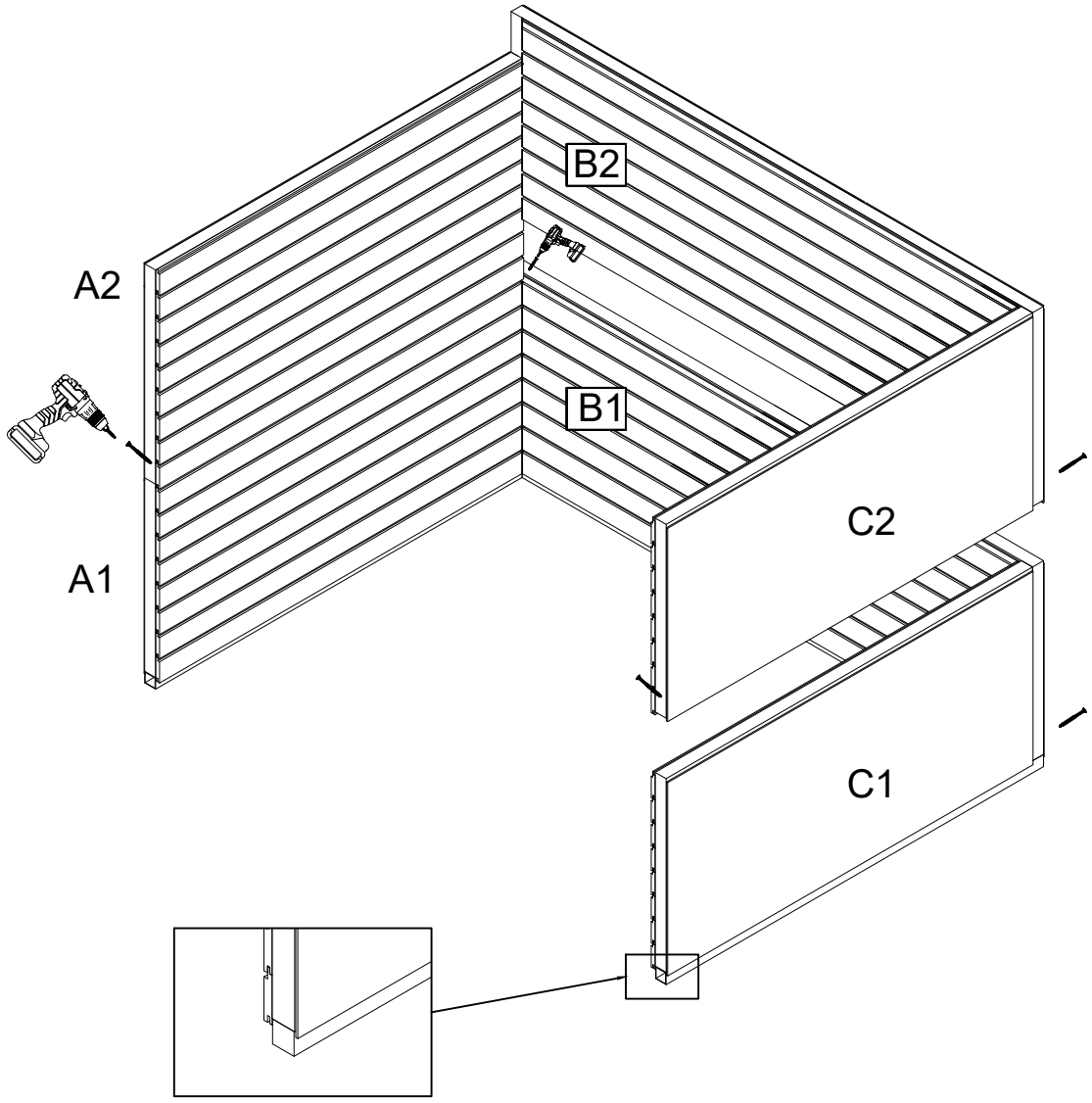
*Example picture

HORIZONTAL WALL ELEMENTS WITH GLASS WALL



HORIZONTAL WALL WITH GLASS WALL FIXING

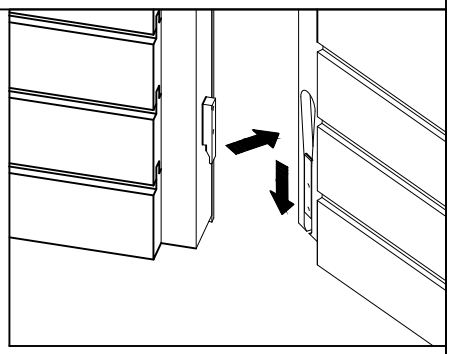
1. Start fixing walls from A-B corner
2. Place walls on base frame
3. Fix screws from top
4. Fix corners outside

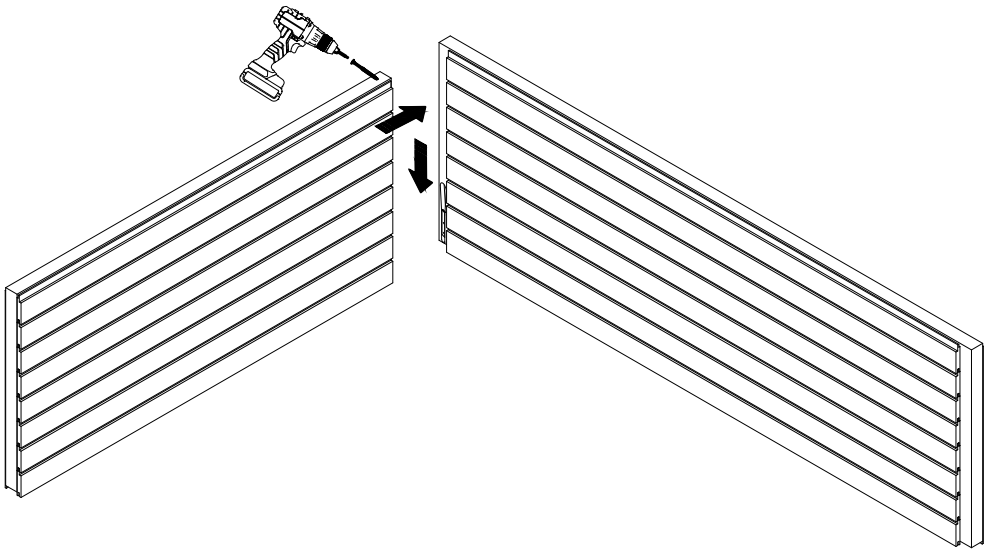


*Example picture

MULTICLIP WALL FIXING

1. Start fixing walls from A-B corner
2. Lift wall for multiclip fixing
3. Make sure it closes
4. Check that wall elements are even on top
5. Fix screws on top

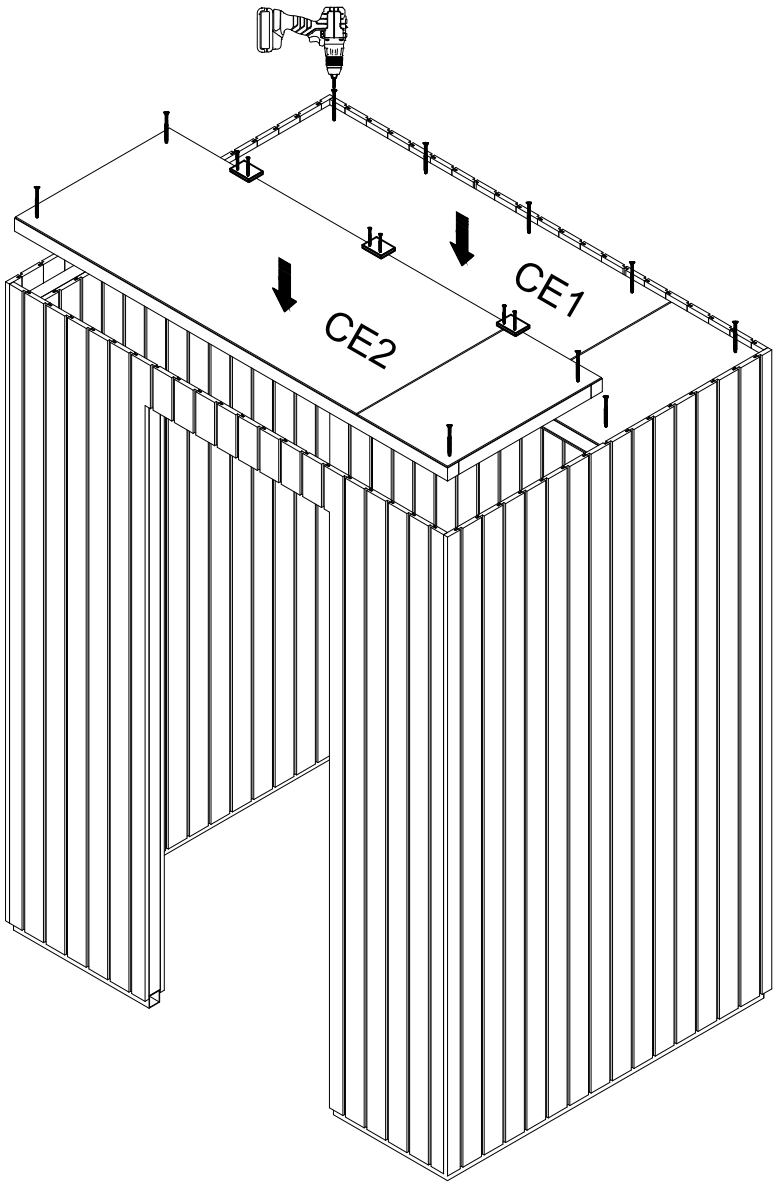




*Example picture

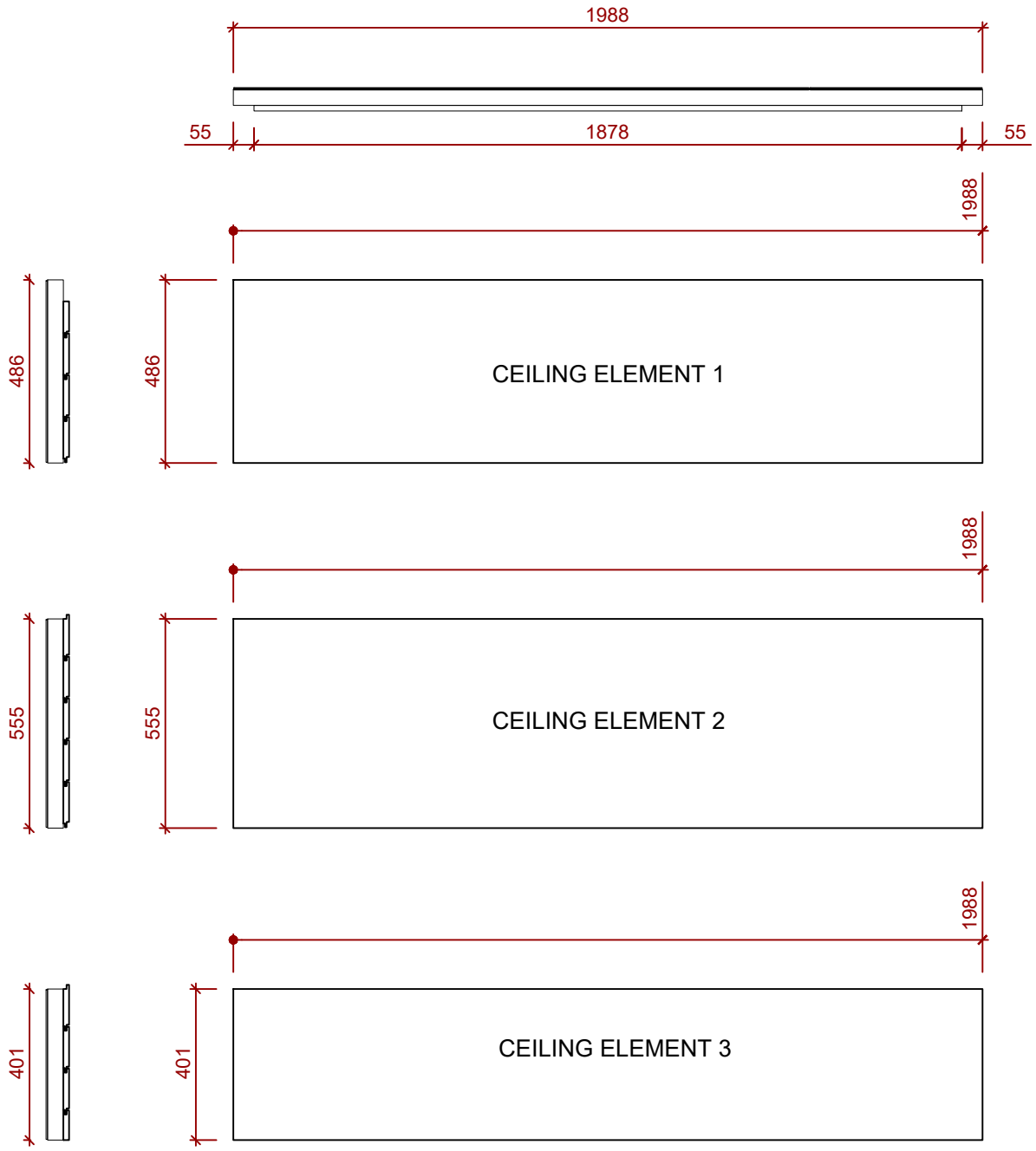
CEILING ELEMENTS FIXING

1. See your technical drawing on next page
2. Start fixing from ceiling element 1
3. Pay attention to inside paneling
4. Fix screws from top
5. Use plywood blocks against paneling bend



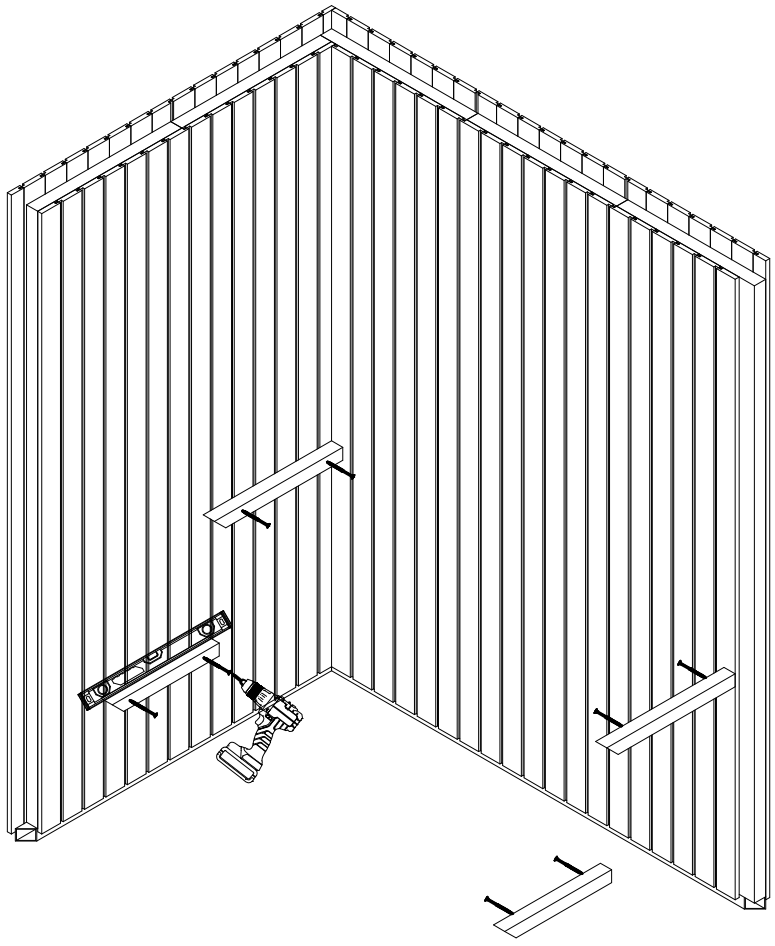
*Example picture

CEILING ELEMENTS



HORIZONTAL BENCH SUPPORTS

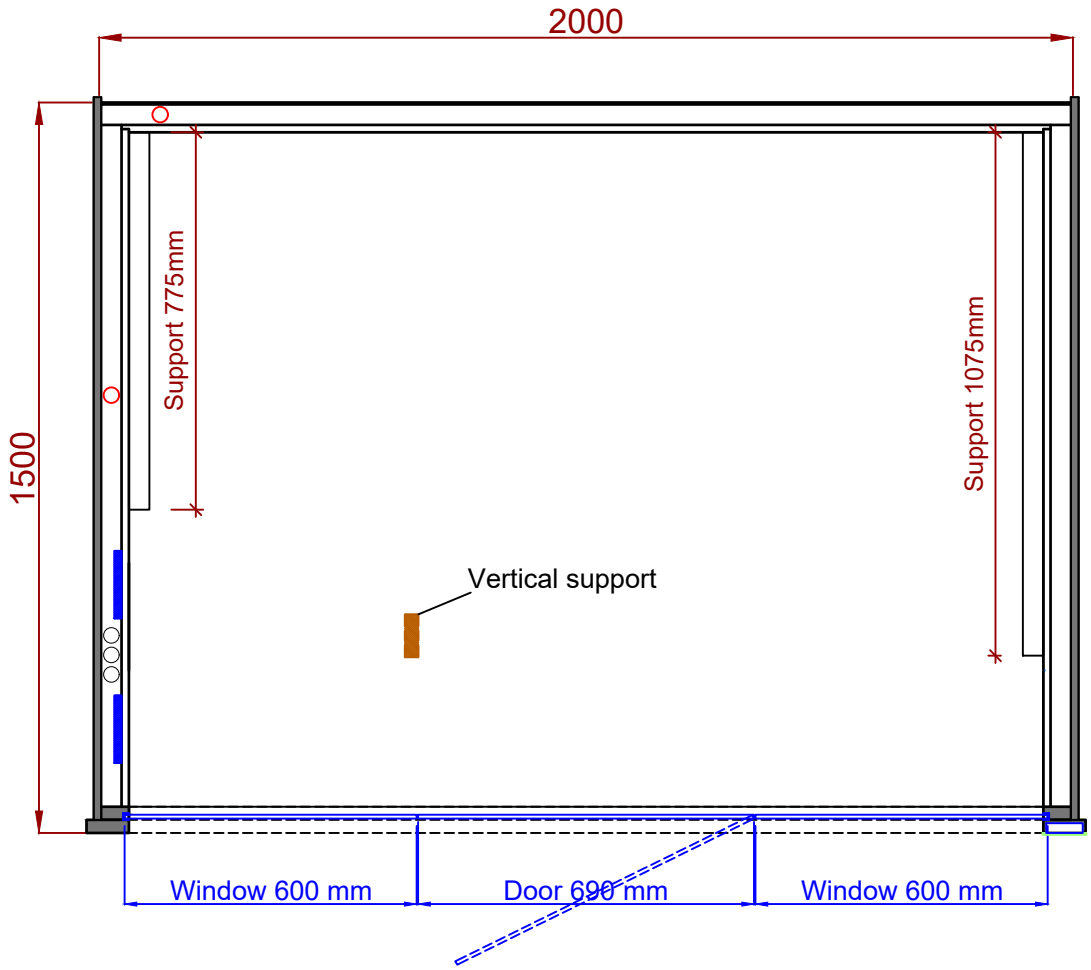
1. See your technical drawing on next page
2. Measure right placement of supports
3. Check level
4. Fix screws



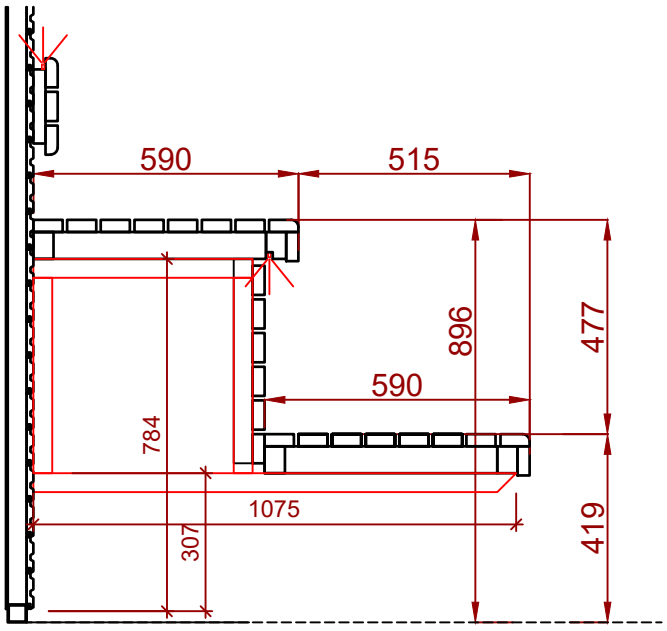
*Example picture

HORIZONTAL BENCH SUPPORTS

TOP VIEW

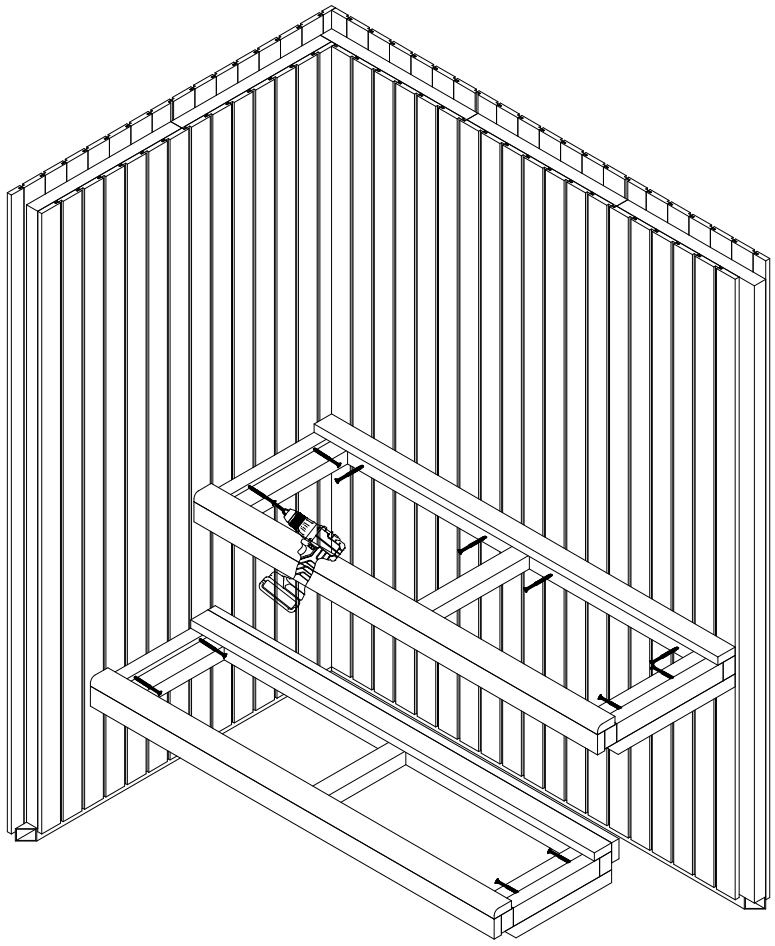


CROSS-SECTION



FIXING BENCH FRAMES

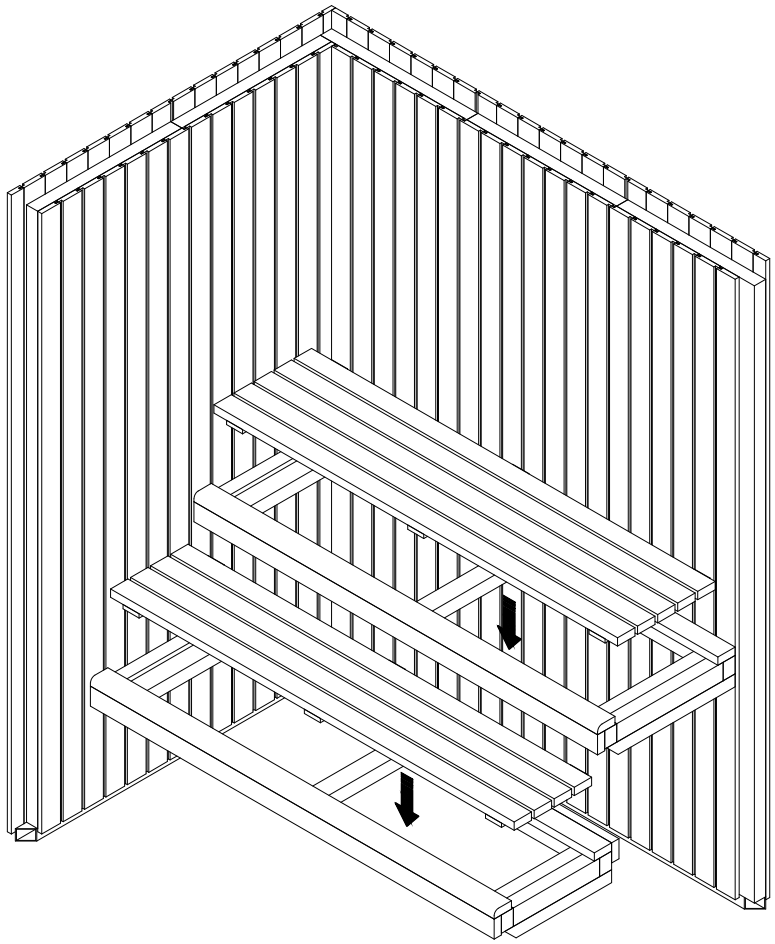
1. Place bench frames on supports
2. Control measures from cross-section drawing
3. Level benches
4. Fix side screws to tighten walls
5. Fix back screws



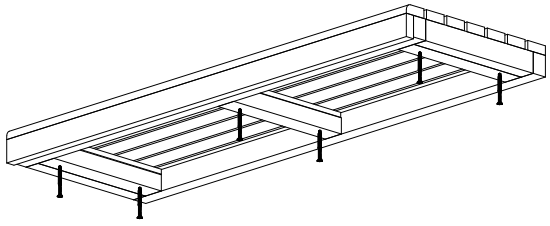
*Example picture

FIXING BENCH GRIDS

1. Place bench grids on bench frames
2. Fix bench grids from below with screws
   *Fixing bench grids helps to prevent bench grid from bending



*View from bottom

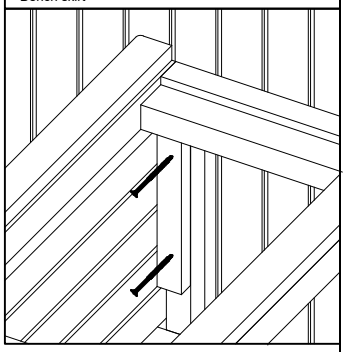


*Example picture

FIXING BENCH SKIRT

1. Control measures from cross-section drawing
2. Fix bench skirt with screws

Figure B.
Bench skirt



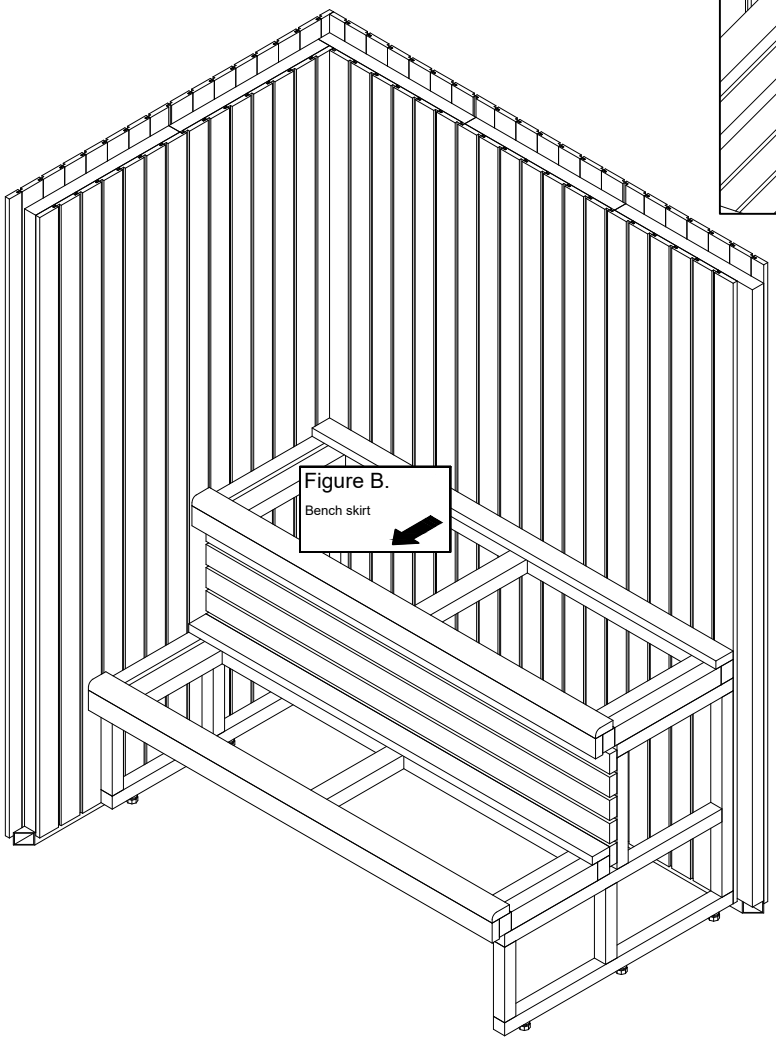
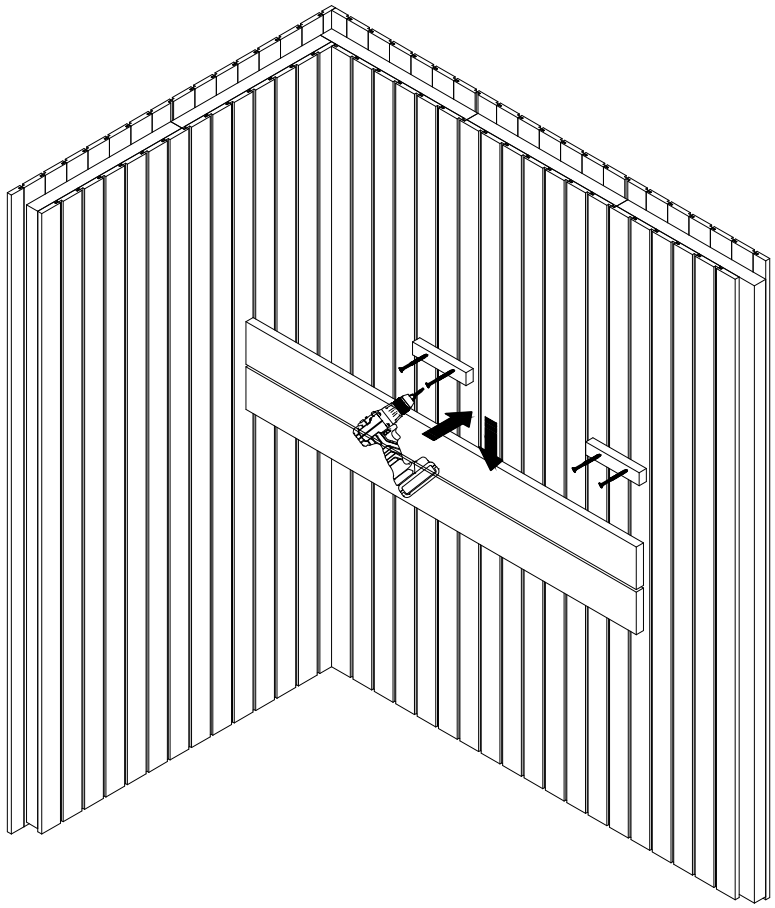


Figure B.
Bench skirt

*Example picture

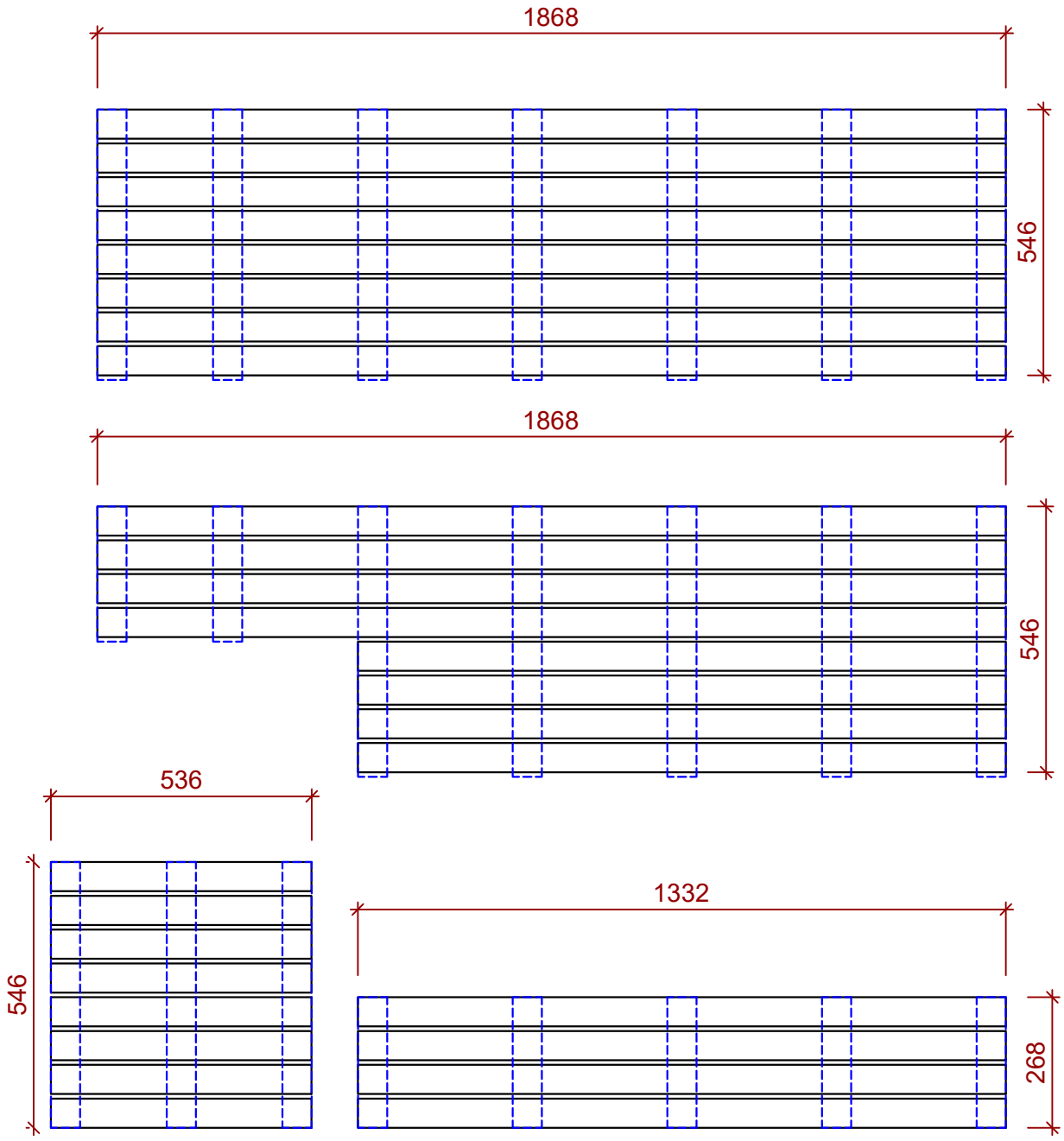
FIXING BACKREST WITH HOLDERS

1. Fix holders on the wall
2. Place backrest on top of holders
3. Fix backrest to holders from top
4. Use wooden covers



*Example picture

FLOOR GRIDS

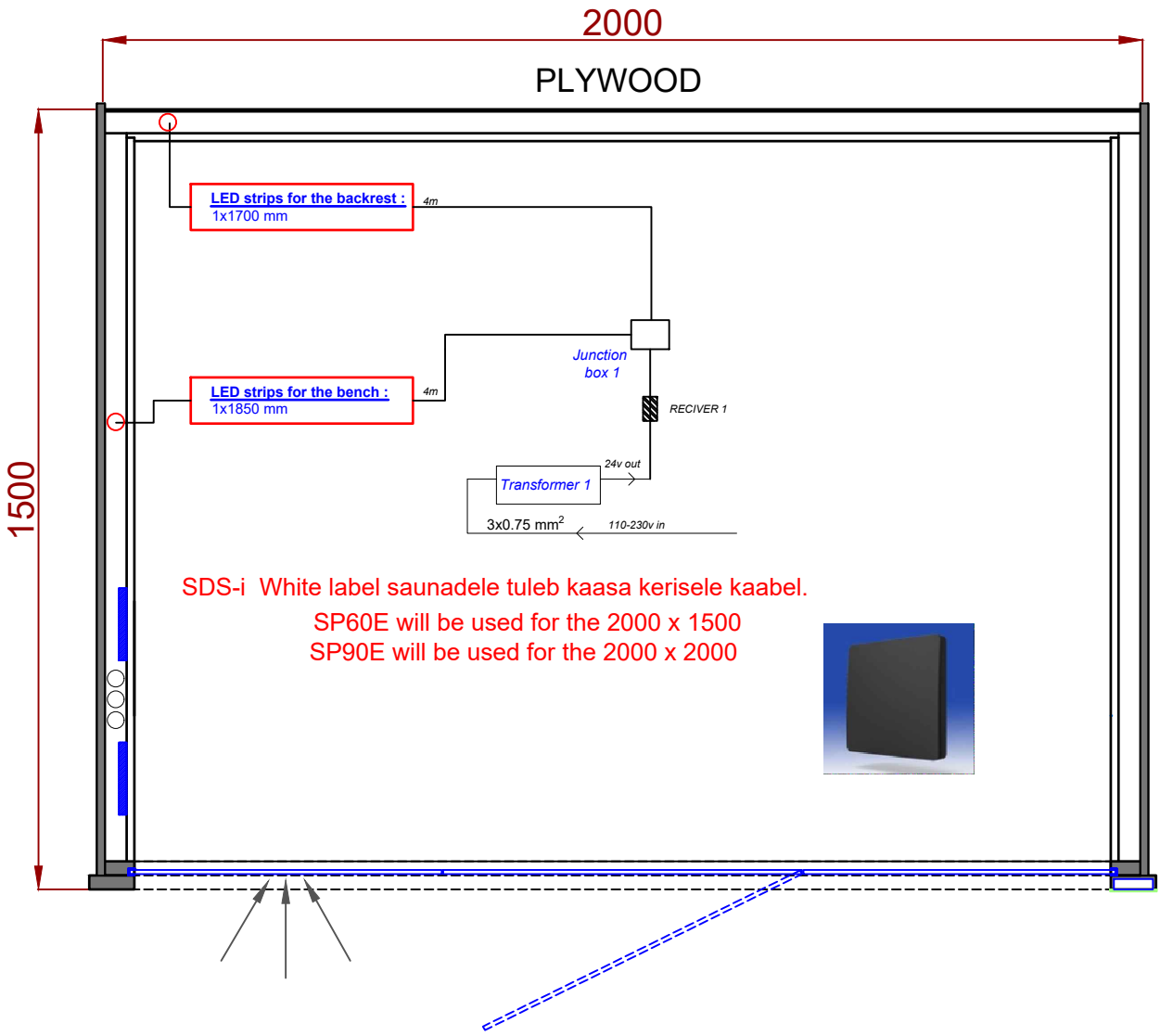


ELECTRICAL

1. Run cables through pre drilled holes in the walls to the ceiling

NOTE! ALL ELECTRICAL CONNECTIONS **MUST** BE MADE BY CERTIFIED ELECTRICIAN!

TOP VIEW



SDS-i White label saunadele tuleb kaasa kerisele kaabel.
SP60E will be used for the 2000 x 1500
SP90E will be used for the 2000 x 2000

Led strips installation

Always use certified electrician!

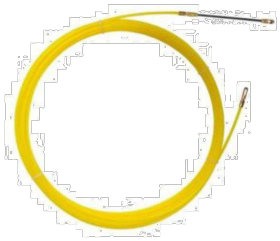
Install the lighting before attaching the benches and backrest.

Pull the led strip cables through the pipes to the ceiling.

Attach the led strips to the clamps.

List of tools:

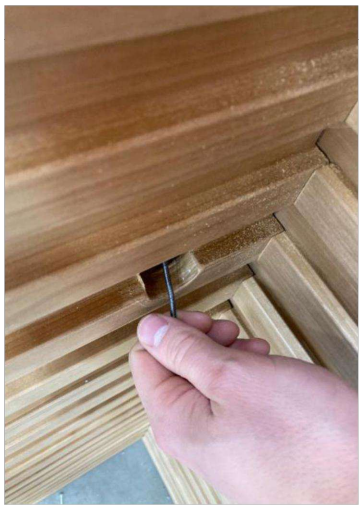
Pull cable



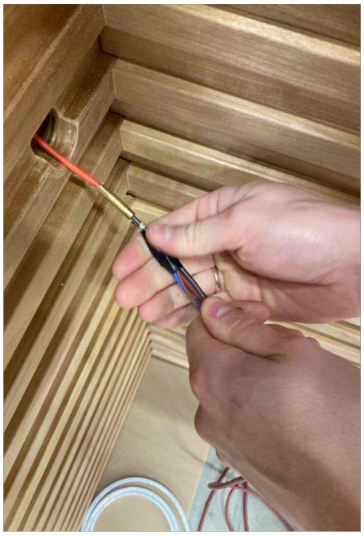
Insulating tape

1. Insert the pull cable to the pipe.

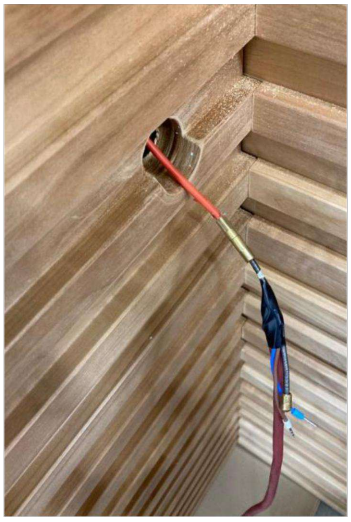
2. Catch the end of the cable through the Led hole.



3. Tie insulating tape tightly around the LED cable. NB! not around the LED strip.



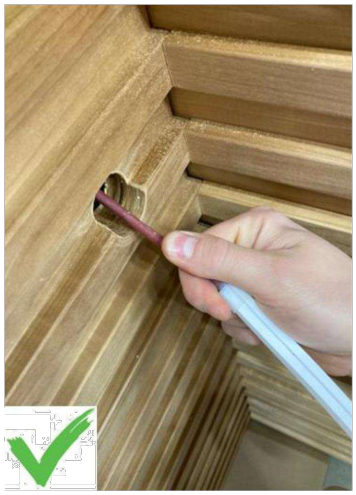
4. Gently pull the cable up.



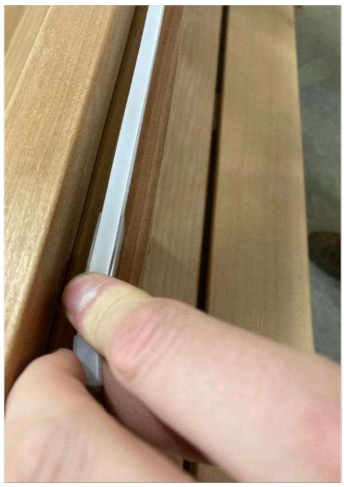
5. Do not remove the tapes. That way it won't get in the way during installation.

6. When installing on the back rest, do not grab LED strip.

5. Grab the cable if necessary.



6. Attach the led strips to the clamps.

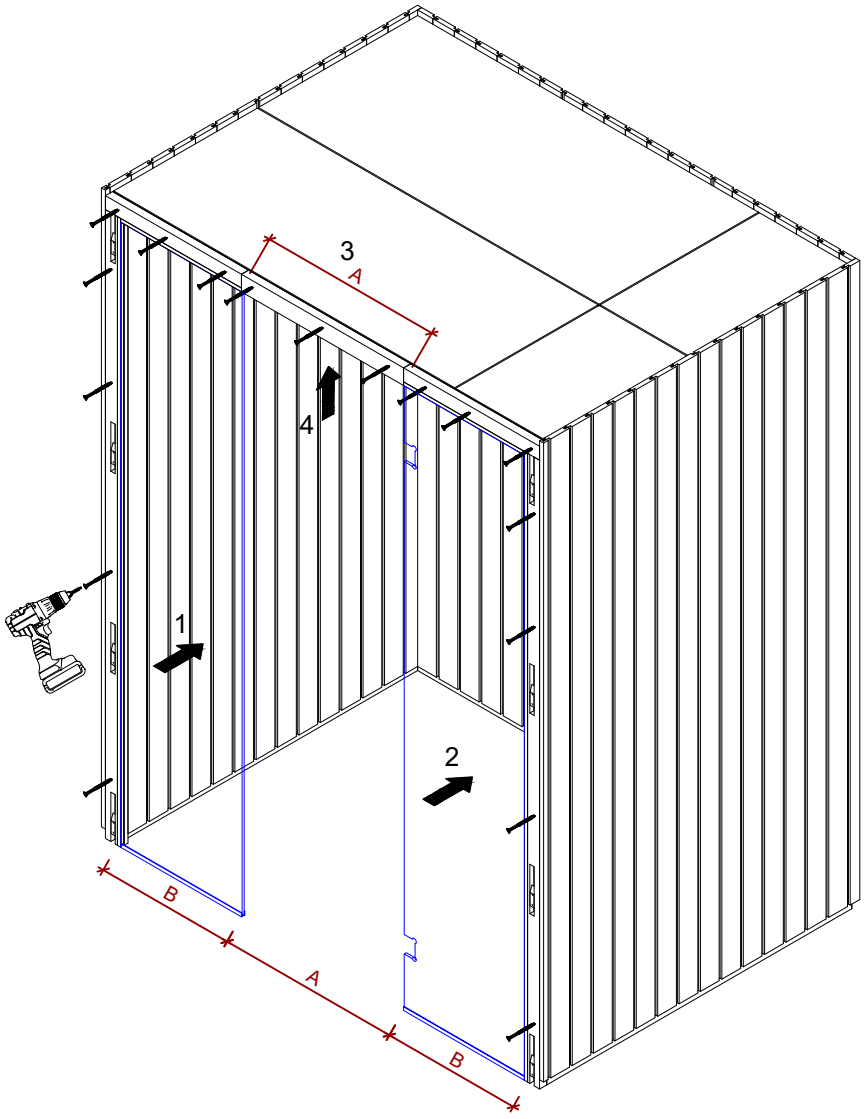


7. Do not press the beginning of the LED strip into the clamp.

8. Pull the led strip straight between the clamps. This can only be done from the LED strip, not from the cable or the cable plugs. Correctly installed LED strip.

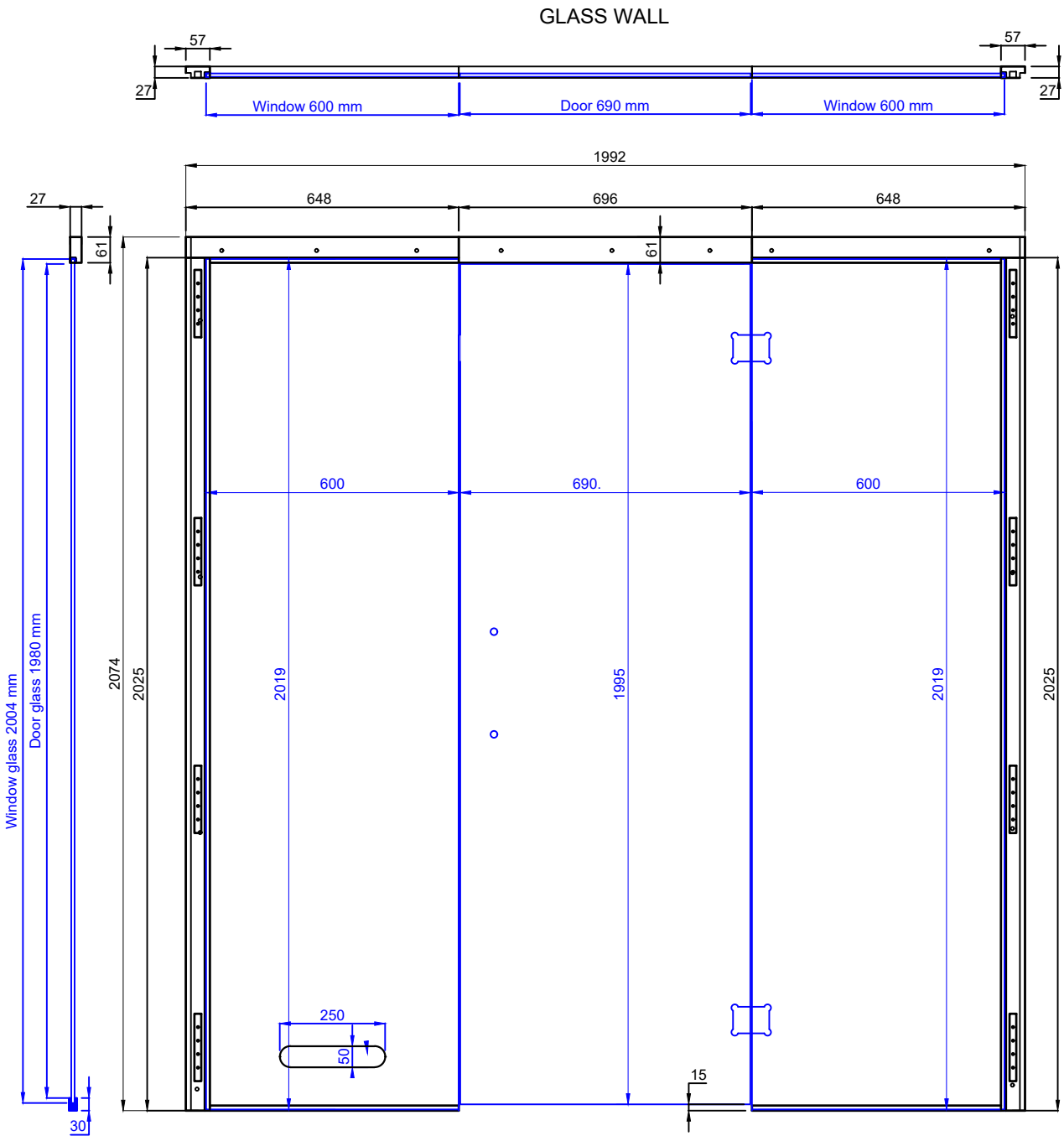
FIXING GLASS WALL

1. See your technical drawing on next page
2. Fix window frames
3. Check the distance (A) between installed walls. They must be equal (A=A) for the door to be installed
4. Fix door frame detail
5. Install door glass



*Example picture

FIXING GLASS WALL



DOOR GLASS

1. Fit the hinges on door according to Figure C.
2. Fit the door to glass wall according to Figure C.
3. Fit the handle to the door according to Figure B.

NOTE! Door must not be supported directly to a hard (tiled, concrete or other) floor due to risk of shattering. Always when not installed rest the door on a protected floor. Do not remove protection material from door until it is finally and properly fitted.

Figure A.

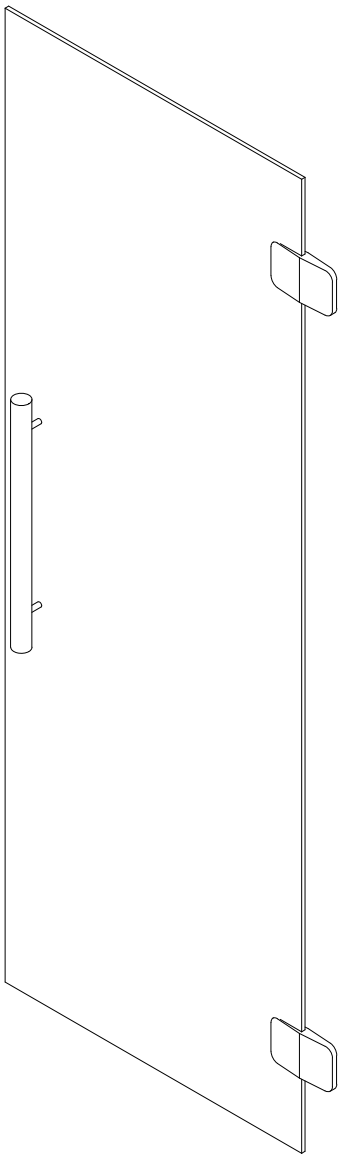


Figure B.

Premium handle

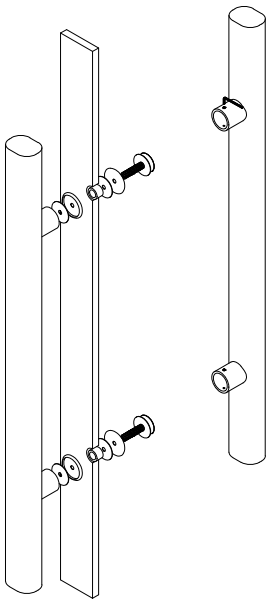
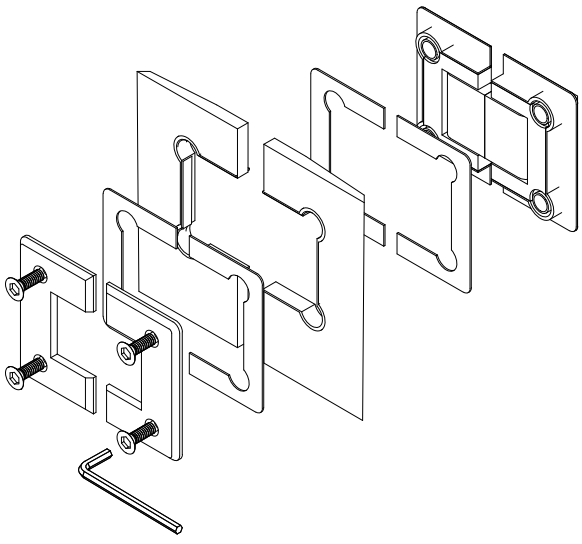


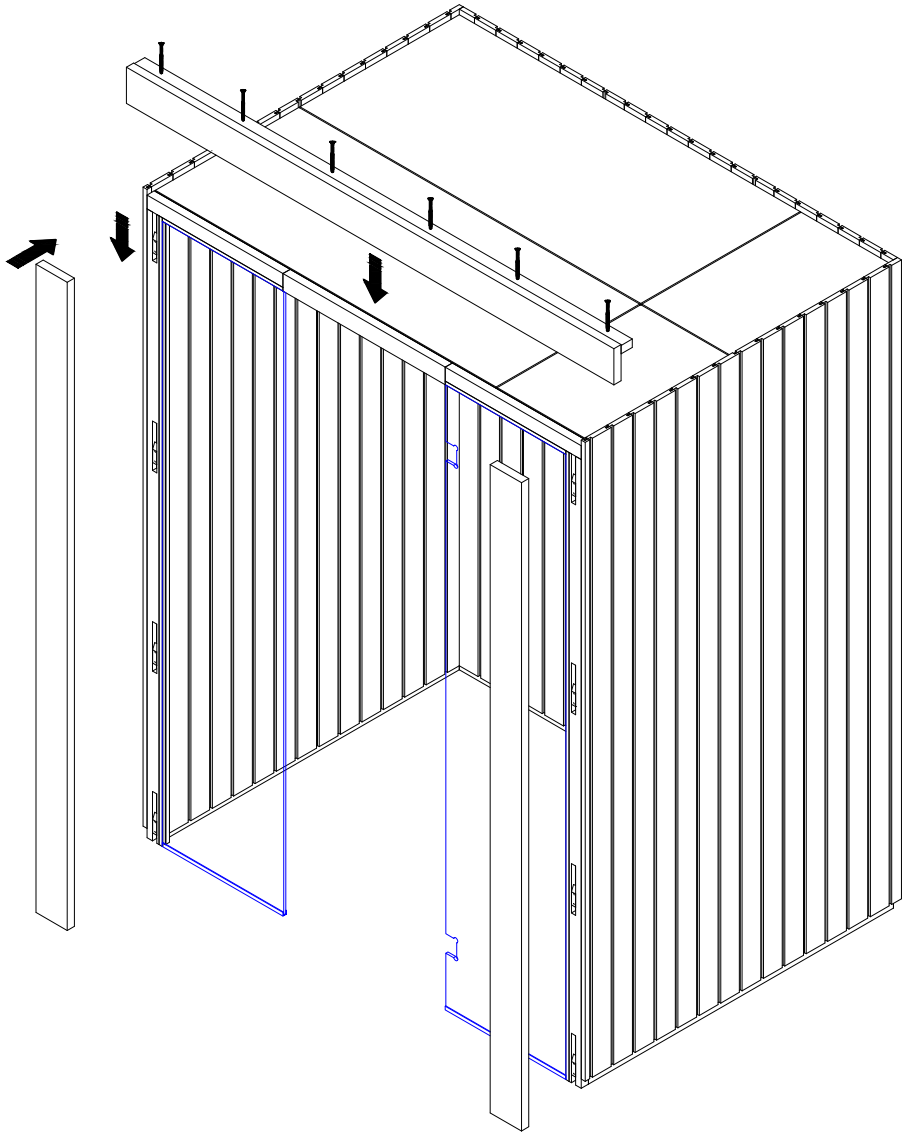
Figure C.

Glass-glass hinges



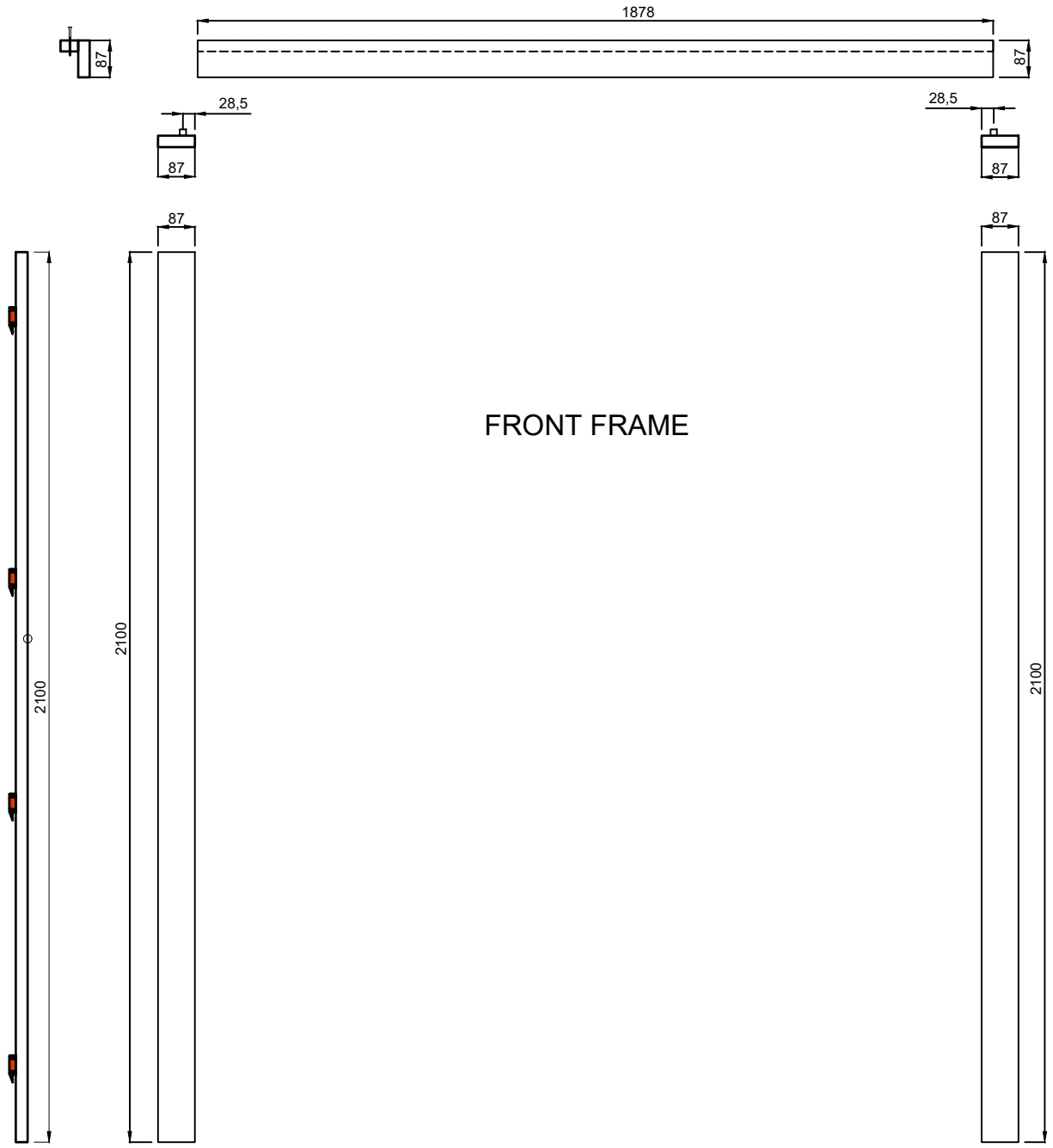
FIXING FRONT FRAME

1. See your technical drawing on next page
2. Fix vertical frames with multiclips
3. Fix horizontal frame with screws from top



*Example picture

FIXING FRONT FRAME



FRONT FRAME

Instructions for use and maintenance of pre-built and pre-assembled indoor and outdoor saunas

1. General installation requirements
   1.1. Your sauna should be installed by a professional installer.
   1.2. The installer of the sauna must have familiarised themselves thoroughly with the manufacturer's warranty terms and the installation instructions of the purchased sauna.
   1.3. The electrical components of the sauna may be installed and connected only by a person with the respective certified competence.
   1.4. The wooden parts of the sauna must not be in permanent contact with water or the structures of the room.
   1.5. The exterior surfaces of the sauna must not be directly exposed to excessive humidity.
   1.6. The installation site must have proper grid connection readiness for supplying power to the electrical components of the sauna. Requirements applicable at the installation location (country).

2. On-site requirements - indoor sauna
   2.1. Make sure adequate ventilation is ensured in the room to be used for installing the sauna to ventilate the humidity and warm air created by the sauna.
   2.2. Fresh air supply for the sauna room and heater must also be ensured. Be sure to leave an air gap between the sauna structures and the boundary structures of the room. This is necessary to avoid formation of excessive condensation between the structures of both the building and the sauna that could damage them and shorten their lifetime. The manufacturer recommends ensuring a minimum distance of 50 mm.
   2.3. The installation surface must be level and stable.

3. On-site requirements - outdoor sauna
   3.1. The outdoor sauna is designed to be installed on a pre-prepared level and stable surface capable of bearing the load.
   3.2. Safety distances - you must leave at least a two-metre clearance around the sauna, unless specified otherwise or provided otherwise by the local requirements for similar buildings.
   3.3. If your sauna is delivered pre-assembled, the installation site must be accessible for heavy machinery.

4. Sauna heater and heating stones
   4.1. Install the sauna heater according to the heater manufacturer's installation instructions.
   4.2. Install the heating stones according to the heater manufacturer's instructions. Installation requirements for the heating stones may vary depending on the sauna heater selected. As a general rule, the heating elements of the heater must be covered with stones. Pouring water directly on the heating elements will shorten the life of the heater and pose a health risk (hot water splashes).
   4.3. It is recommended to wash the heating stones with water before installation. This cleans the stones of any possible processing and production residues.
   4.4. Using the heater without the stones is not allowed.

Instructions for use and maintenance of pre-built and pre-assembled indoor and outdoor saunas

5. Finishing/treating the wooden parts of the sauna with a protective agent
   5.1. Before using the sauna, all wooden surfaces must be treated with a suitable protective agent. The manufacturer recommends using sauna wax or sauna oil (paraffin oil).
   5.2. Depending on the installation method used for your sauna and the free space left in and around the sauna, the wooden surfaces can be treated before or after installing the parts but certainly before using the sauna.
   5.3. Treating the wood will extend the lifetime of the wood and your sauna, preserving its properties and appearance. Treated surfaces repel water and dirt and are easier to clean.

6. Taking the sauna into use
   6.1. Make sure all parts of your sauna are intact and functional after installation and before the first heating.
   6.2. First heating: slowly heat your sauna to a temperature of 100 °C (212 °F) under supervision, keep this temperature for two hours and let the sauna cool down slowly. The sauna must be well ventilated during the first heating - it is recommended to leave the door half-open. This is necessary to allow the wood protecting agent to be absorbed into the wood and any residues from production and processing to evaporate from the surfaces.
   6.3. Staying in the sauna during the first heating is not allowed - substances evaporating from surfaces may cause an unpleasant smell.

7. Using your sauna
   7.1. Use the sauna only for the purpose for which it was manufactured.
   7.2. Pour water only on the heating stones.
   7.3. Use the sauna in moderation - it stimulates circulation, relaxes muscles and cleanses.
   7.4. Rinse yourself with water between sauna sessions.
   7.5. It is recommended to drink mineral water after the sauna to replenish fluids.

8. General sauna maintenance
   8.1. After each use:

- Wipe the bench with a damp cloth after.
- Always remove pools of water from wooden surfaces.
- If the design of the bench allows it, raise the platforms to an upright position to dry.
- Let the heater run under supervision for approximately 20 minutes - wooden parts dry more efficiently this way.

Instructions for use and maintenance of pre-built and pre-assembled indoor and outdoor saunas

8.2. Once a year or as needed:

- Wash the horizontal (and, if necessary, vertical) surfaces of your sauna with a special sauna detergent. Use a soft brush or damp cloth and observe the instructions of the detergent.
- Stronger stains can be removed with fine-grained sandpaper. All treated surfaces must be treated with a protective agent.
- Repeat treatment of the wooden parts with a protective agent.
- Check the structures of the sauna (bench fastenings, wall connections) and, if necessary, tighten the fastenings.
- Have a competent person check the condition of the electrical connections and components.
- Check the functioning of the door and adjust it, if necessary and possible.
- Check the condition of the heating stones: when used intensively and especially as they age, they could emit stone dust that will accumulate on the wooden surface above and behind the heater. Replace the stones, if necessary.
- Do not use substances or working procedures not suited for washing the sauna.
- Washing wooden parts with running water is not allowed.

9. Maintenance of an outdoor sauna

9.1. Trees and bushes growing near the sauna and a shady location may cause mossing on the surfaces. Clean the surfaces with a soft brush and damp cloth, as necessary.

9.2. In areas with thick snow-cover, remove snow from the roof of the sauna. Do not allow more than 50 cm of snow on the roof.

10. Wooden materials in the sauna

10.1. Wood is a natural material and subject to natural phenomena (differences in grain pattern, variations in tone, expansion and contraction due to heat and moisture).

10.2. Wood may develop cracks or deformations over time. This is natural and does not affect the use of the sauna. If in doubt, contact the vendor.

10.3. Thermally modified wood emits some scent during the first three heating periods.

11. Repair works

11.1. Damage to wood - scratches and dents up to 1 mm deep:

- Clean and dry the surface thoroughly.
- Sand down with 500 grit sandpaper or until dispersed.
- Clean off dust and treat with a protective agent. The protective agent will even out the colour difference caused by sanding.

12. The following are not allowed in the sauna:

12.1. Drying clothes or other textiles. Evaporating humidity may damage the wood; and textiles placed near the sauna heater may pose a fire hazard.

12.2. Heating to a temperature higher than 115 °C (239 °F) -fire hazard.

12.3. Placing combustible materials on the sauna heater.

12.4.

GLASS HANDLING, STORAGE AND THE ABC'S OF CLEANING

HANDLING AND STORAGE

1. Taking precautions is generally always cheaper than correcting mistakes later.
2. It is recommended to remove stickers and spacers from the glasses as soon as possible.
3. It is recommended to use suction cups to lift large glasses.
4. When storing both tempered and non-tempered glass for a long time, the supporting edge of the glass must rest on a dry and softened surface (e.g., plastic, cardboard, rubber) - the edges of the glass must not be supported directly on the floor or the ground.
5. When storing several glasses at the same time, there must be spacers between the tempered glasses. Non-tempered glasses of the same size can be supported against each other, in the case of non-tempered glasses of different sizes, pieces of cardboard must be placed in between.
6. Glasses must be stored in a dry and well-ventilated room away from direct sunlight.
7. The storage conditions are important, because if water gets between the glasses (for example, as precipitation from above or evaporating from the bottom), soda starts to separate from the inside of the glasses, as a result of which they form on the surface of the glass white spots that cannot be removed. Such glasses belong to disposal.
8. The corners are the weakest point of the glass, so they must be protected with special attention. The glass must also be protected from the dangerous effects of the external factors listed below.

DANGEROUS EXTERNAL FACTORS FOR GLASS

Construction	First, any glass must be protected on the construction site, where chemical and mechanical factors can permanently damage the glass surface. In the case of glasses in the vicinity, constant air exchange is maintained, the glasses can be covered with a polyethylene film. If there is no air exchange, and the glasses are covered with polyethylene film break due to thermal stress.
Stickers and spacers	The adhesive on stickers and caps hardens under the influence of solar radiation. If the adhesive contains basic (pH=7.1-14) particles, the result may be a matting of the glass. If the adhesive contains acidic (pH=0-6.9) particles that are not visible on the glass damage, but the damage has been caused by the normal aging process of the glass.
Silicones	Chemically and sandblasted frosted glasses must not contact silicones with containing substances, because this way the surface of the glass becomes transparent and needs replacement.
Wall mixes	During of normal hardening, masonry mixtures often release alkaline (pH=7.1-14) particles that can damage and dull the surface of the glass. Petrified mixture removing it from the glass results in scratching the glass surface.
Concrete splashes	Washing off fresh concrete with plenty of clean water can damage the glass save. On the other hand, removing the dried concrete will scratch the surface of the glass and means replacing the glass.
Acid wash	Hydrochloric acid is used to clean brick and concrete surfaces, which can damage reflective surface coatings and glass missile silicones. Acid washing must be carried out before glazing.
Welding and cutting sparks	If these sparks fall on the surface of the glass, the surface of the glass is permanently damaged and needs to be replaced. Therefore, welding and cutting work is important avoid near glass.
Storage of other materials opposite the glass	Different materials against the glass can scratch the surface of the glass – especially glasses with a reflective coating are sensitive in this regard.
Metal constructions	Aging details of constructions secrete oxides (tin, copper, iron, zinc), which can get on the glass surface with both rain and washing water. Oxides can permanently damage the surface of the glass and the glass must be replaced.
Large temperature fluctuations	As a result of excessively large temperature differences, a large internal stress occurs on the glass, as a result of which the glass cracks, i.e. a thermal break occurs. Thermal

	breakage occurs when the temperature difference on the surface of untempered glass is approx. 40-50°C. To prevent thermal breakage, it is recommended to temper the glass, because tempered glass can withstand temperature differences of approx. 150-200°C.
Organic mastics	They can secrete emollients, oils and solvents, which stick very strongly with a glass surface. Organic mastics do not have to be harmful to the glass in direct contact with the glass - it is enough if water with residues flows over one glass on the surface of other glasses.
Running water	If water flows over cement, concrete, plaster before reaching the surface of the glass, organic coatings or mastics, residues remain on the surface of the glass. Scraps and glass a chemical reaction can occur between the surfaces, damaging the glass surface.
Hard water	The minerals in the water settle on the surface of the glass and stick to it strongly. Leaving the dried residues of minerals untreated, their later removal turned out to be impossible and the glass must be replaced.
Air pollution	Air pollution can contain various chemicals, especially in the case of (acid) rain adhere strongly to the glass surface. Leaving air pollution unremoved can create a chemical reaction on the surface of the glass to produce matte spots.

GLASS CLEANING

1. Glass should not be cleaned in direct sunlight.
2. The glass cleaning intervals directly depend on the environment surrounding the glass and the degree of soiling of the glass.
3. Glass cleaning includes washing, rinsing and drying.
3.1 Glass cleaning starts with removing abrasive particles such as dust with clean water.
3.2 Then use a soft cloth, towel or sponge to apply the cleaning agent to the glass using circular motions and applying medium pressure.
3.2.1 When cleaning satin glasses (i.e., frosted glasses), it must be remembered that even if only one spot on the glass is dirty, the entire surface of the glass must be cleaned (to avoid halo formation). Do not use when cleaning frosted glasses excess pressure.
3.3. Rinse with plenty of clean water.
3.4. Use a clean, soft cloth, towel or sponge to dry the glass.
3.5. After cleaning the glass, it is also important to remove the residues of water and cleaning agents from the slats, seals and frames in order to prevent damage to these parts.

REMOVAL OF DIFFERENT STAINS FROM GLASSES

1. Grease stains, oils, fats and various sealants - stains can be removed with a cleaning agent that contains a small amount of alcohol. After using the cleaning agent, be sure to rinse the glass clean with plenty of water.
2. Paints, cement, concrete mix - stains must be removed from the glass as soon as possible, i.e., before they dry, with plenty of clean water.
3. For small and difficult-to-remove dirt residues, a razor blade can be used with extreme caution, keeping it at a right angle to the glass.
4. The stains cannot be removed by sandblasting from frosted and satin glasses, because the surface of the glasses is permanently damaged and needs to be replaced.