

# ASSEMBLY MANUAL

## Evolve 30 EHS Far Infrared Sauna



# Pre-Assembly Checklist

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## Selecting a suitable location

For best results, please place your sauna on a flat level surface. Suitable locations could include the garage, bedroom, sunroom. The sauna can be placed on carpet, tiles, timber flooring or concrete.

## Outdoor Placement

For outdoor placement please note that the sauna must go in a covered area to provide protection from direct rainfall, additionally the sauna must be protected by one of our Australian made covers to protect the warranty.

**NB: For more comprehensive information on outdoor placement please see our warranty document.**

## Assembly Instructions

Assembly of the sauna will require 2 adults to complete. Please read through the instructions carefully before beginning the assembly process. Should you encounter any issues along the way, please contact us on free phone 1800 316 962 (Australia) or 0800 21 8020 (New Zealand)

1. Keep all liquids away from the sauna during the assembly process.
2. Install the sauna on a flat level surface.
3. Install the sauna in an area that is dry and protected from the weather.
4. Your sauna is a self-contained free standing unit and should not be built into any structure without consultation with Sun Stream Saunas.
5. Please maintain about 3cm clearance from the walls on all sides of the unit.

**NB: Please exercise great care when handling the front wall assembly and glass door making sure they do not swing open and break whilst securing in place.**

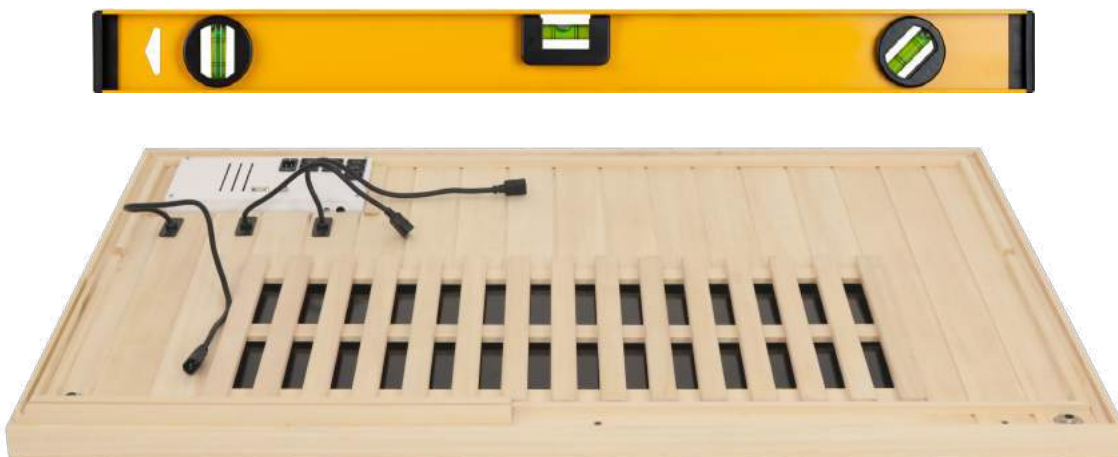


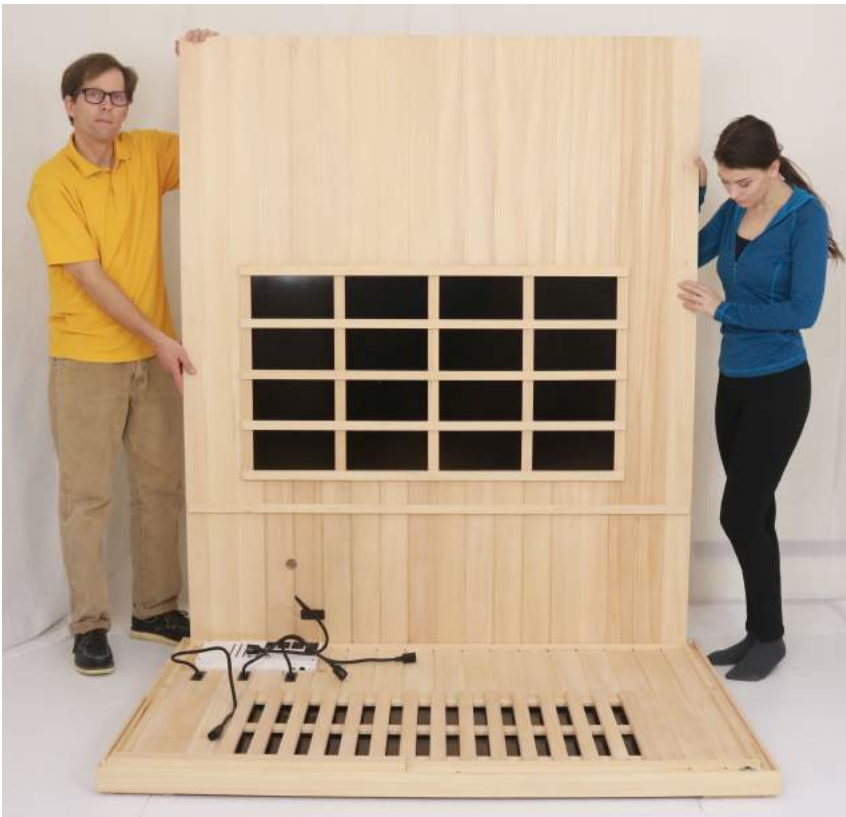
### Prepare & Position the Sauna Floor

If you are assembling your sauna on a hard surface floor it is recommended that you apply the included adhesive felt to the bottom of the sauna floor.

Place the sauna floor in the desired location. It is necessary to position the floor out from your walls for assembly and move the sauna following assembly.

**Please note: It is important that the sauna floor is level. Checking with a large level is recommended. If the floor is not level, shimming or other remedies should be applied before assembling the sauna.**





### **Position the Back Wall**

Lift the back wall into position carefully lowering the bottom of the wall into the channel on the floor base.



### **Position Right Side Wall**

Lift the Right side wall into position wedging the bottom of the wall into the channel in the floor base.



### Back Right Corner Wall

Cinch the Right Side wall and the Back wall together by applying pressure on the outside of the Side wall.

Slide the Right Side wall upward approx. 1/2" while holding the back wall down

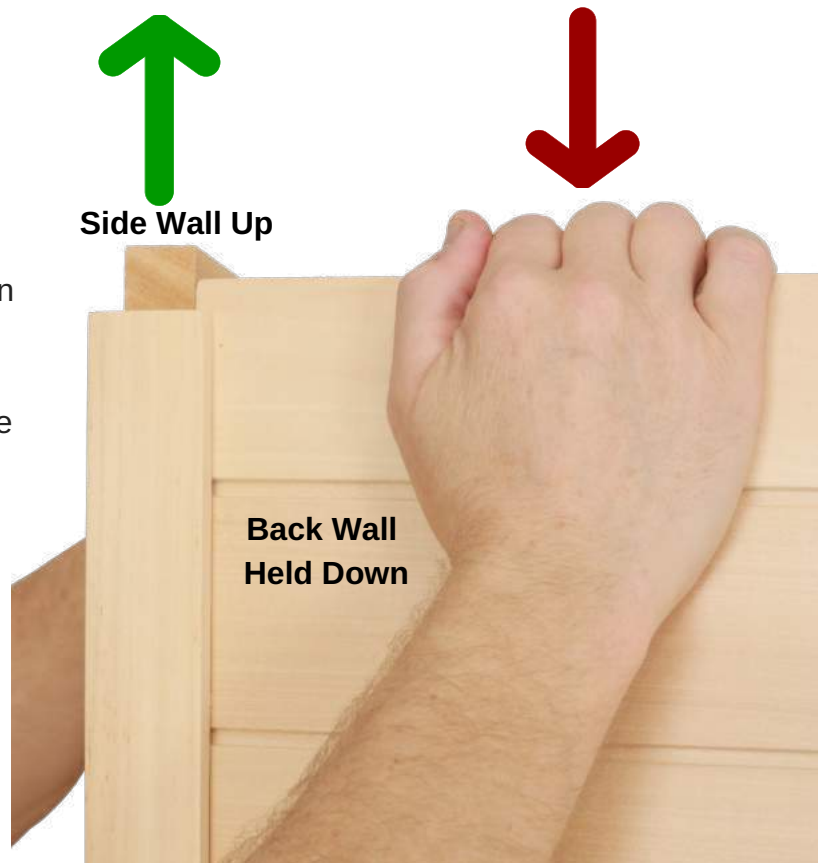
**NOTE:** It is NOT necessary to lift the entire Side Wall. Simply slide the Right Side wall upward at the back corner of the sauna.



It is helpful if a second person applies pressure against the opposite edge of the back wall. This will help ensure that the two walls remain in contact and the fasteners connect.

The 2 sets of fasteners for the walls will connect when the side wall is raised sufficiently.

Slide the Side Wall down while continuing to cinch the two walls together.



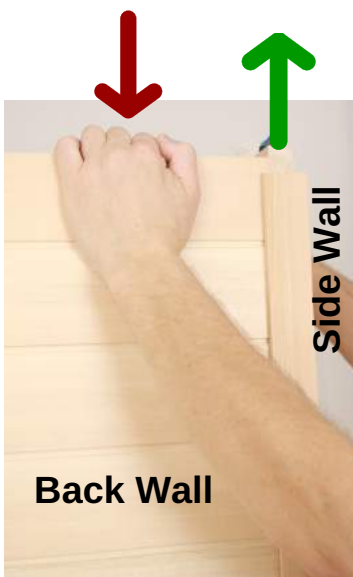


There are two sets of fasteners to join the saunas' corners together. After lowering the Side Wall, check to ensure that both sets of fasteners have connected by looking at the corner inside of the sauna. It is possible to connect one set of fasteners and miss the other. If there is an obvious gap in the corner between the two walls at least one fastener has not connected and the raising and lowering procedure will need to be repeated.



### Back Left Corner

Lift the Left Side Wall into position wedging the bottom of the wall into the channel in the floor base.



Cinch the Left Side Wall and the Back Wall together by applying pressure on the outside of the Left Side wall.

Slide the Left Side wall upward approx. 1/2" while holding the Back Wall down

The 2 sets of fasteners for the walls will connect when the Side wall is raised sufficiently.

Slide the Left Side Wall down while continuing to cinch the two walls together.

**NOTE:**

After installing the Back and 2 Side Walls, you may want to slide the sauna back into its final position before proceeding with Front Wall and Roof. It may be helpful to insert the main power cord through the hole in Back Wall before sliding the sauna back against your homes wall. Move the sauna by pushing horizontally on the Floor Base. DO NOT push upward on the Walls as they are not mechanically connected to the Floor base.

**Door Heater Electrical**

Ensure that the door heater electrical is protruding from bottom of Front Wall Door frame. A bit of plastic wrap can serve to hold the connector out slightly.



**Position the Front Wall/Door Frame**

Lift the Front Wall/Door Frame into position carefully lowering the bottom into the channel on the floor base. Prop up one end of the Front Wall/Door Frame to enable connection of the door heater electrical lead.



Connect door heater electrical lead to the floor base.

**NOTE:**

Be sure that the wire's connector is fully inserted into the floor base connector and that the threaded cuff is fully screwed on to the floor base connector.



**Side Wall**

**Secure the Right Wall**

Use the supplied wood screw and the pre-drilled hole to secure the Right Side Wall to the Front Wall/Door Frame.





### Prepare to install the sauna roof

Pull the single plastic connector down and out of the roof before lifting the roof into place.

If you are unable to grab hold of the connector through the small opening in the ceiling, it may be necessary to remove the first T&G board on the top left side of the roof and feed the connector down through the opening.




### Install the Sauna Roof

Lift the Roof up and over top of the sauna walls. If you are installing the sauna in a restrictive space and are unable to walk down the sides of the saunas, it may be necessary for one person to go inside the sauna. Hook the right side corners of the Roof over the walls then lower the Roof toward the left of the sauna.

### Lower Roof into Position


It may be necessary to push on the inside or outside of the Back and Side walls to enable to roof to drop into position.



Connect the 12 Volt power supply wire at the back left corner of the sauna.

This wire brings power to the roof for the stereo and lighting components.

Lower the roof on to the walls



### Side Wall Glass

Install Side Wall glass panel.

Glass etching is intended to face inward.

**IMPORTANT**  
For temporary purposes, insert a foot or two of the flexible plastic strip on the inside of the Side Wall glass panel. This will hold the glass panel in place and assist in the following assembly steps.



## Install Front Wall Glass Panel



Carefully insert the bottom edge of the Front Wall glass panel into the slot in the Floor base. The Front Wall glass panel must be positioned so that the heater panel is fitting inside of the Side Wall glass panel.



Carefully tilt the front edge of the Roof upward, about 1/2", just enough to tilt the Front Wall Glass in to position



Lower the Roof so that the Front Wall glass panel fits into the Roof slot.

### **Install Corner Seal**

Firmly press the corner seal on to the edge of the Front Wall glass panel



Remove the temporary plastic glazing strip from the inside of Side Wall glass panel





Firmly press flexible glazing strip into wood channels along the outside of the Side and Front Wall glass panels.

It may not be necessary to use the flexible glazing for the full height of the glass panels. Use the glazing strip where it fits into the channels.



Small wooden block (included) can be used to fully press the glazing strip into channel



Install 4 furniture bolts through top and bottom of door frame using the allen key (included)

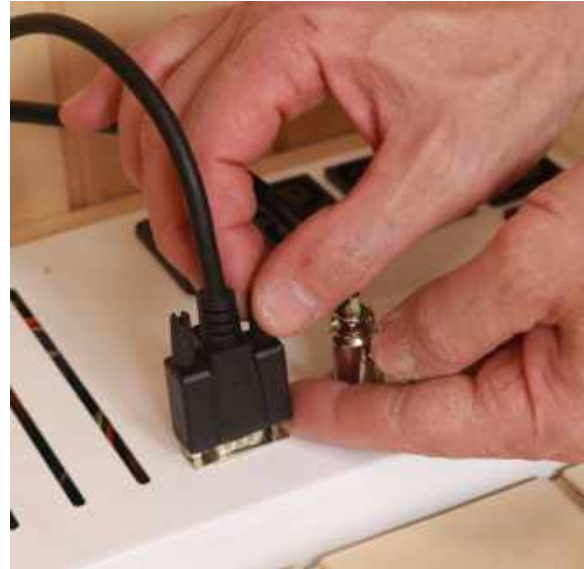
## Under-Bench Electrical

**NOTE: Do not connect main power cord to your wall outlet yet at this time.**



Connect the circular connector to power supply box. Align the groove in connector to properly insert. Thread the cuff of the connector on fully.

Attach the 'D-Sub' computer style connector as shown



Plug in all heater leads to receptacles in the power supply box.



Feed the main power supply cord in through the hole in Back Wall and insert in power supply box. Do NOT plug power cord into your wall outlet until all electrical connections are finished inside of the sauna.



Connect circular connectors for the 2 Front Wall heaters. Thread the cuff of connectors on fully. When all connections are made inside of the sauna, plug the sauna's main power cord into wall outlet.



### **Remove Side Wall Heater Guards**

The wooden lattice work in front of the heaters is referred to as the heater guard.

These are held on with strong magnets. It is necessary to remove the heater guards from the two side walls in order to install the leg heater and the sauna bench.

**Install the Leg Heater**  
Install the leg heater by lowering it into the brackets mounted on the side walls.  
Plug the leg heater into the power supply box in floor.





# Connecting the ground wire



## Install Bench

Angle the Bench into place to clear the Side Wall window frames. The Bench installs foil side down.



Connect the **grounding wire** from bottom side of Bench as shown



Lower the Bench into Position



### Install Bench

The bench in your new sauna is reversible. Choose whichever side appeals to you to face upward.



Reinstall the side wall heater guards



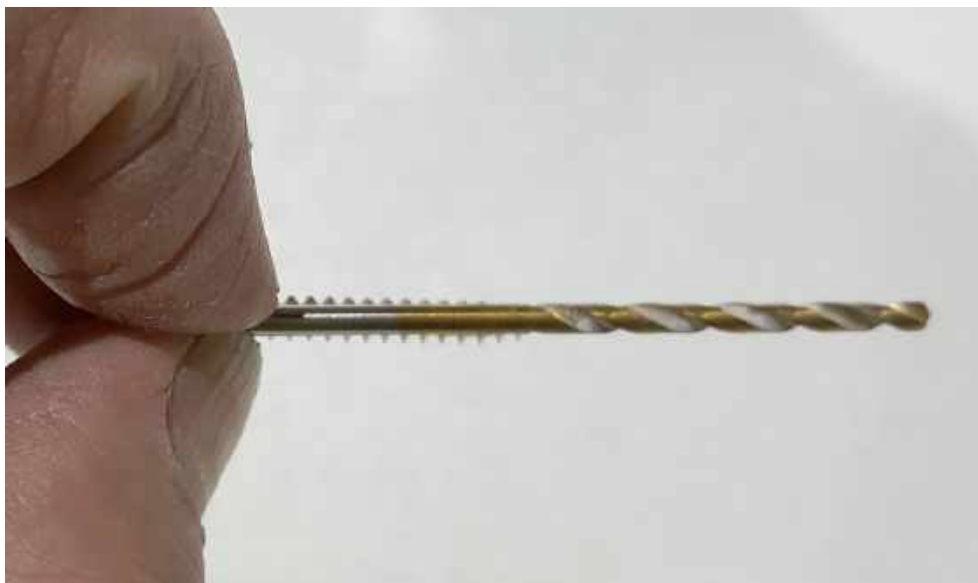
Install the door handle

## Heater Guards

The heater guards in your new Sun Stream Infrared Sauna are held to the wall with strong earth magnets. If preferred, the heater guards can be screwed directly to the wall for a more permanent and secure attachment. The heater guards are pre-drilled for the attachment screws.



Screws are included to attach the heater guard to the wall. Select a drill bit with a smaller diameter than the screw threads to drill a pilot hole





Drill a pilot hole into the wall through the holes in the heater guards. Do not drill deeper than necessary for the length of the screw.

NOTE: The pilot holes are important to ensure that the tongue and groove wall boards do not split when installing screws.

Install screws to firmly attach heater guard to the wall



## Option-L Movable Bench Assembly



Connect bench legs to the inside corners of the frames using supplied wood screws.



Ensure that the legs' ends are flush with the bottom edge of the frames



Attach the leg assembly to the bottom of the bench surface. Choose which surface of the bench you prefer to be the top and bottom.



# Accessories



## Backrests

Your new Sun Stream Sauna comes equipped with backrests constructed from Western Red Cedar. Position the backrest as pictured to provide lower back support and to position yourself a comfortable distance from the Infrared heater panels.



## Cupholder

Many of our customers simply set the cup holder on the bench of the sauna. In the Evolve 10, 20 and 30 saunas, the cup holder can be mounted on the side wall under the heater panels. Be sure to drill pilot holes first for the wood screws to mount cup holder to the T&G wall boards.

## Aromatherapy

Enjoy the aroma of your favorite essential oils, such as eucalyptus or lavender, while in the sauna. Add water and a few drops of your essential oil to the aromatherapy glass which can be hung on the wall heater guard.

