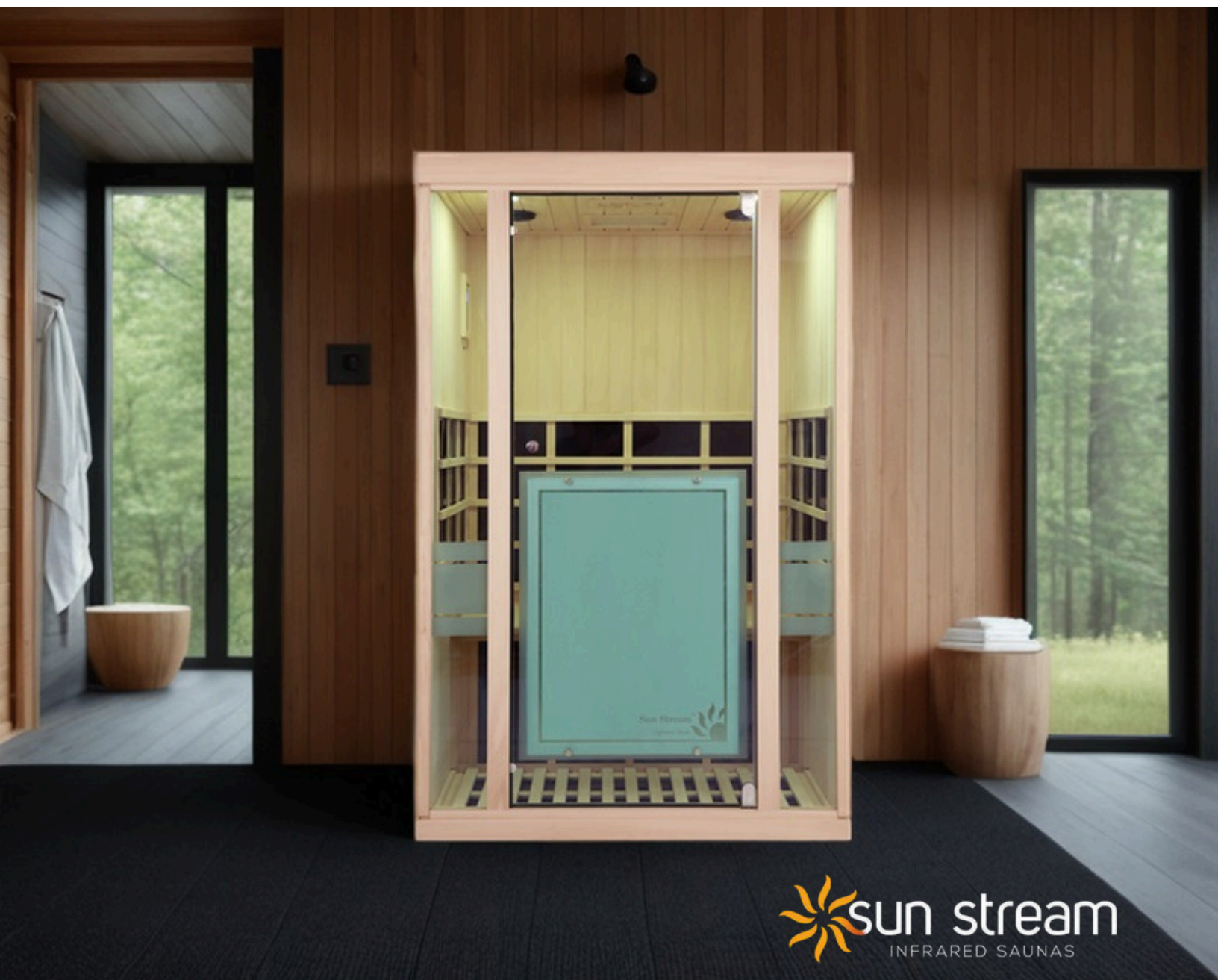


# ASSEMBLY MANUAL

## Evolve 20 EHS Far Infrared Sauna



# Pre-Assembly Checklist

## Selecting a suitable location

Place your sauna on a flat level surface. The sauna can be placed on carpet, tiles, timber flooring, concrete or any other hard, level surface.

A 200mm void above the sauna is required to allow access into the roof, should lighting or audio part need replacing at some point in the future.

## Outdoor Placement

Our saunas are not suitable for placing outdoors.

## Assembly Instructions

Assembly of the sauna will require 2 adults to complete and should take 1-2 hours.

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 +44 (0) 800 86 11 841.

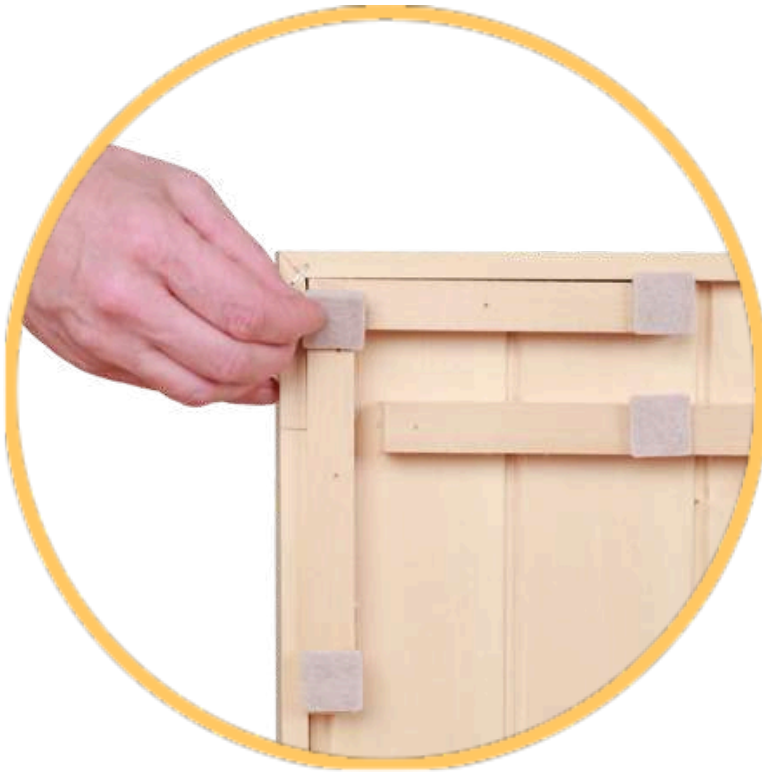
## Assembly Video

We also provide an assembly video (see link below) which will help you with the assembly process. The video is an overview, not entirely comprehensive, so please watch the video in conjunction with reading these assembly instructions.

### [Evolve 20 Assembly Video](#)

Throughout this Assembly Manual, we have included links to specific times in the Assembly Video that match the step in the assembly process that you are currently at.

**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 and Position the Sauna Floor

The sauna needs to be level to ensure the glass door closes flush and tight. Many floors may look level but are actually not.

To ensure the sauna will be level once built, before starting any assembly, first place the floor base in its intended final location and check it is level using a spiritual level. Check it is level on all four sides. If the floor is not level, attach the packers provided to the bottom of the floor panel until the base is level.

[Video Step 1: Floor & Door](#)



Place the sauna Floor Base 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.





### Front Wall Installation

Ensure that the door heater electrical is protruding from bottom of front wall frame



### Position the Front Wall

Lift the front wall into position carefully lowering the bottom of the wall into the channel on the floor base. Prop up one end of the front wall to enable connection of the door heater electrical lead.



**Connect door heater electrical lead to the floor base.**

Ensure that the threaded cuff is fully screwed onto the floor base connector.

**NOTE:**

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



**Four Furniture Bolts**

Screw the 2 furniture bolts through the Front Wall frame into Floor Base  
The furniture bolts will require either a Phillips head screwdriver OR the allen key included with the sauna accessories.

There are also 2 furniture bolts to go through the Front Wall and thread into the Roof later in the assembly.



### **Protect Floor Base**

As a precaution to protect the floor base, place a business card or similar on the floor base before installing glass panel

### Video Step 2: Right Wall

### **Install Right Side Front Wall Glass Panel**





### **Connect Side Wall to Front Wall**

Insert Side Wall into the channel of floor base while aligning the slot in Side Wall with edge of Front Wall glass panel.

**USE EXTRA CARE** fitting the Side Wall to the glass panel





**SIDE  
WALL**

### **Wood Screw**

Use the supplied wood screw and the pre-drilled hole to secure the Side Wall to the Front Wall frame.

**Back Wall**  
Insert back wall into  
channel of floor base

[Video Step 3: Rear Wall](#)



### Connect the Back Wall to Side Wall

Cinch the two walls together by applying pressure on the outside of the Side Wall with the inside of your knee.



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 will connect.



Slide the Back Wall up approx. 3/4" while holding the Side Wall down with your opposite hand. The 2 sets of fasteners for the walls will connect when the back wall is raised sufficiently. When you feel the fasteners connect, slide the Back Wall back down.

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



### **Second Front Glass Panel**

Use the same procedure as for the first glass panel



**Insert the Left Side Wall** into the channel of floor base while aligning the slot in Side Wall with edge of Front Wall glass panel.

[Video Step 4: Left Wall](#)



### **Connectors are NOT Upside Down**

When connecting the final wall to the back panel it will appear as though the connectors are upside down, however they are deliberately fitted this way to avoid placing pressure on the second front glass panel just installed.

So when connecting, please raise up the back panel and drop it down to connect to the side wall whilst applying pressure and clinching them together.



### **Wood Screw**

Use the supplied wood screw and the pre-drilled hole to secure the Left Side Wall to the Front Wall frame.

## Video Step 5: Roof

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### **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.







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



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[Video Step 6: Electrics & Internal Panels](#)

### 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 connector on fully.

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



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

## Power Supply Cord

Feed the main power supply cord in through the hole in back wall and insert in to the power supply box. DO NOT plug power cord into your wall outlet until all electrical connections are complete inside of the sauna.



## Door Heater Electrical

Connect the coiled wire from the door heater to the connector on the door frame. Ensure that the connector is fully inserted and the threaded cuff is fully screwed on to the door frame connector.



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

The wooden lattice work in front of the heaters is referred to as the heater guards. 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 sauna bench.

### **Leg Heater**

Install the leg heater by lowering it into the brackets mounted on the side walls.

Plug 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**



**Glass Glazing Strips** There are 4 strips of flexible glazing material included with your Evolve 20 sauna. These hold the glass panels snugly in the wooden frame. It may not be necessary to use the glazing strips, or not necessary to use the entire length of the strip, if the glass panels are a snug fit in the wooden frame. If required, install the glazing strip by firmly pressing it into the channel along side the glass panel. The glazing can be installed on the inside or outside of the glass panels



A small wooden wedge is included to help push the glazing strip into the channel.

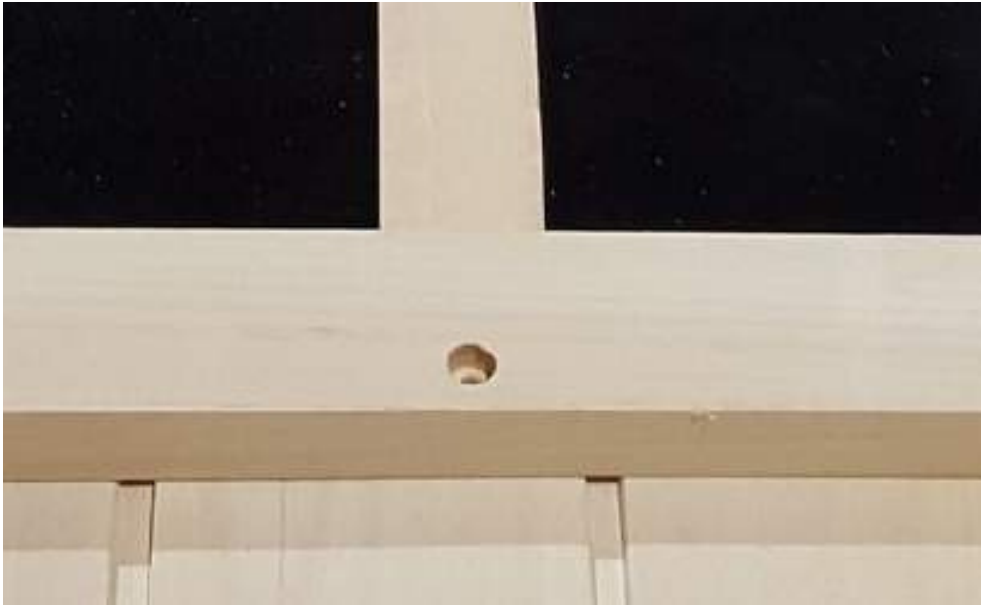
The Chromotherapy LED panel is controlled by the remote control and is NOT connected to the sauna wall control panel.



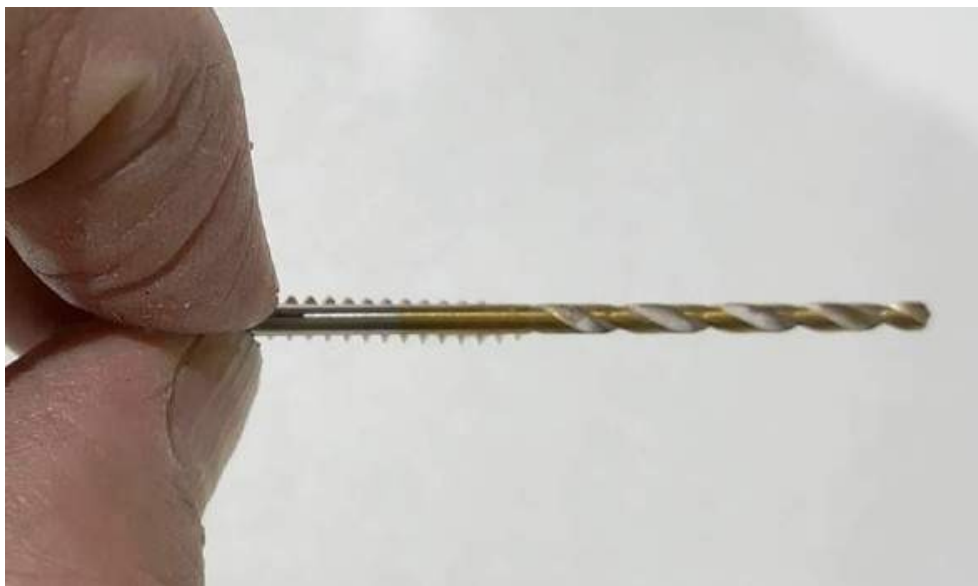
## Heater Guards

The heater guards in your new sauna are held in place to the wall with strong magnets. This allows easy removal for cleaning of the heater panels behind. It is not necessary, and it is NOT recommended, however if you prefer, the heater guards can be screwed directly to the wall for a more permanent attachment. The heater guards are pre-drilled for the attachment screws.

The below instructions involving screwing the guards to the wall are **optional only**.



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





### Optional only

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.

Video Step 7: Assembly Review





### 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.

