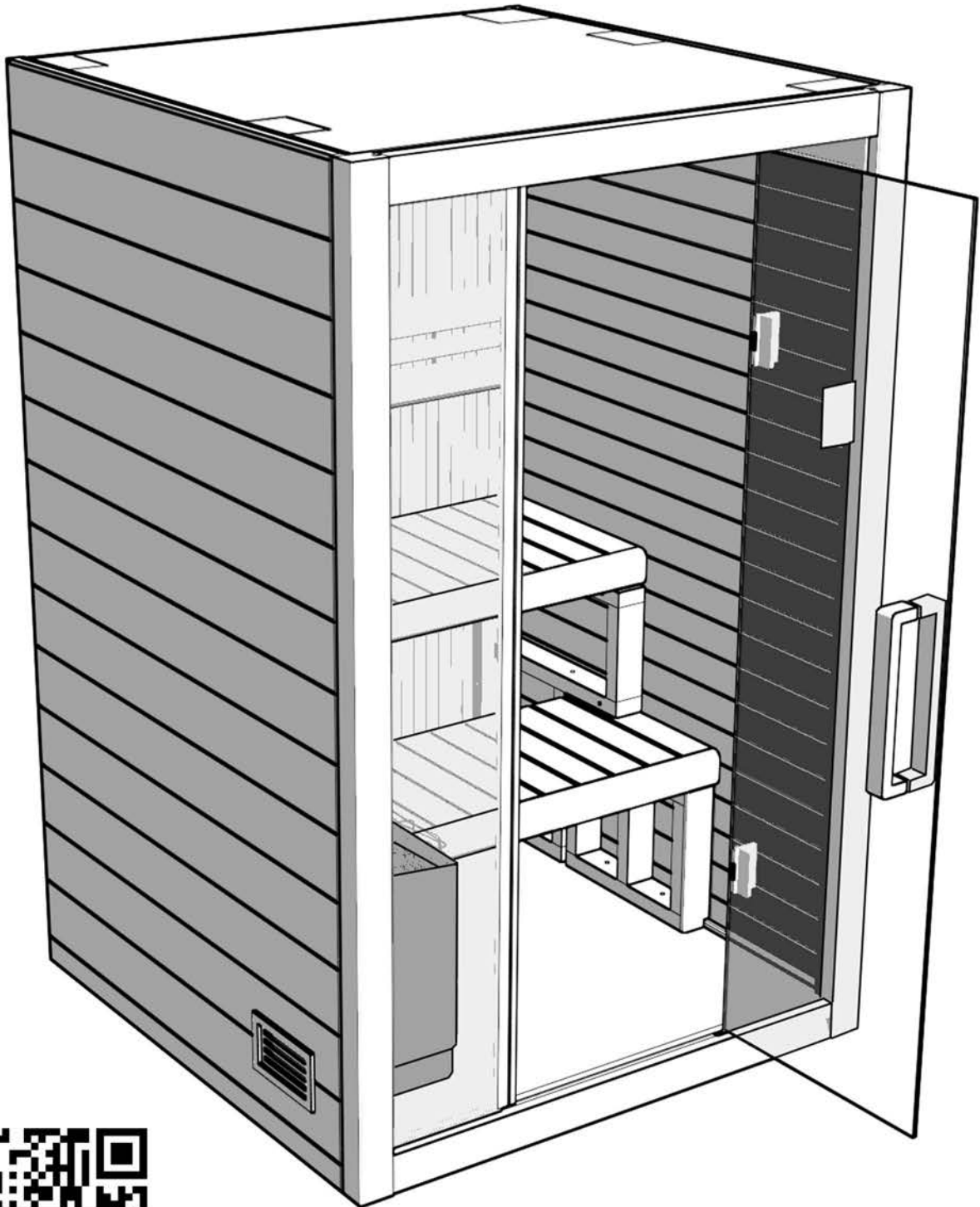


HALMSTAD 2

RETROFIT KIT INSTALLATION



Scan for
Step-by-Step
Installation
Instructions
and Videos

SAUNA360

IMPORTANT SAFETY INFORMATION

WARNING

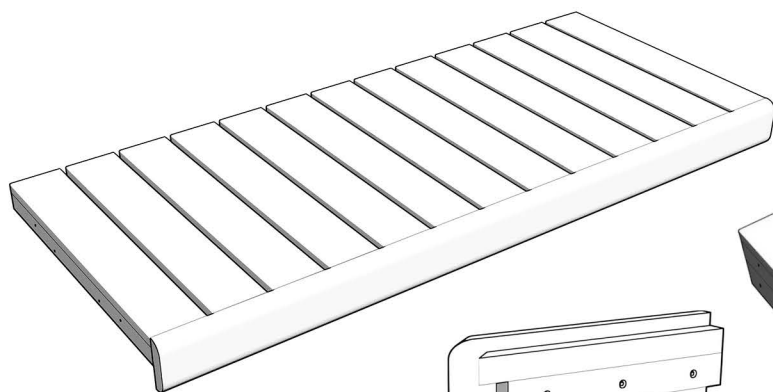
- This instruction sheet provides the procedures for installing the bench support retrofit kit for the Halmstad 2 sauna.
- The retrofit kit reinforces the existing bench support structure to reduce the risk of bench instability or collapse during use.
- Installation must be completed by a technician.
- Read all instructions in this instruction sheet before installing the retrofit kit.
- Do not modify retrofit components.
- Verify that you have all the required parts, tools, and PPE before beginning installation.
- The retrofit kit is designed for use only with the specified sauna models and configurations. Do not use the kit for any other application.
- If any questions arise during installation, please contact 888-780-4427 (Menu Option - 2) before proceeding.
- Direct the owner to the Halmstad 2 Manual for operating instructions and sauna safety information.
- Disconnect power to the sauna before performing any work and follow all applicable electrical and safety codes during installation.
- Ensure heater rocks are cool before beginning to avoid burns and property damage.

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ORIGINAL SAUNA PARTS LIST

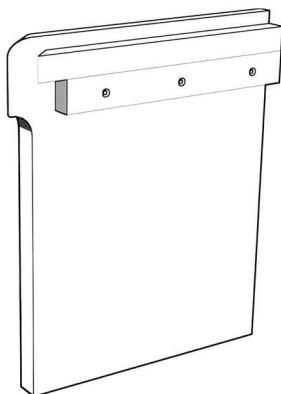
*that are involved in the installation



A Top Bench

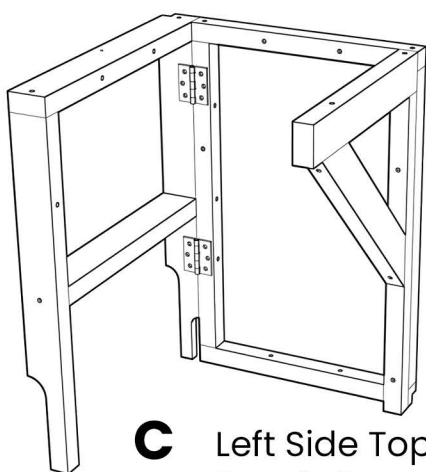


B Lower Bench

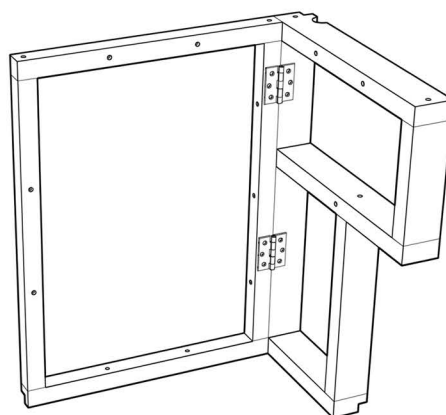


E
Lower Bench Support

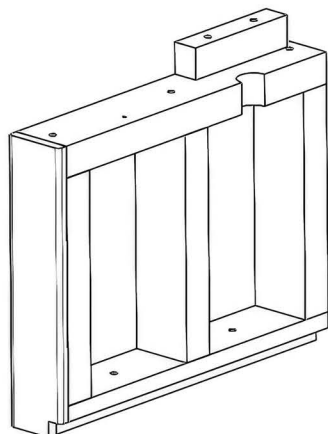
SUPPORT KIT PARTS LIST



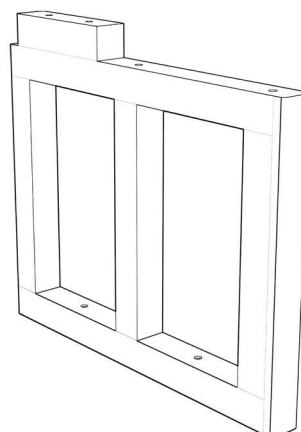
C Left Side Top
Bench Support



D Right Side Top
Bench Support



F
Wall Side Lower Bench Support



G
Lower Bench Midspan Support

MITIGATION KIT HARDWARE

All hardware removed should be replaced with provided mitigation kit hardware.

Note: kit may contain extra hardware

H



#9 x 2" Torx Flat-Head screws (2)

I



#9 x 2 1/2" Torx Flat-Head screws (31)

J



#8 Button Head x 2" (2)

K



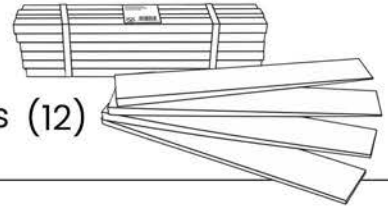
Metal Bracket (2)

L



#6 x 3/4" screw (16)

M

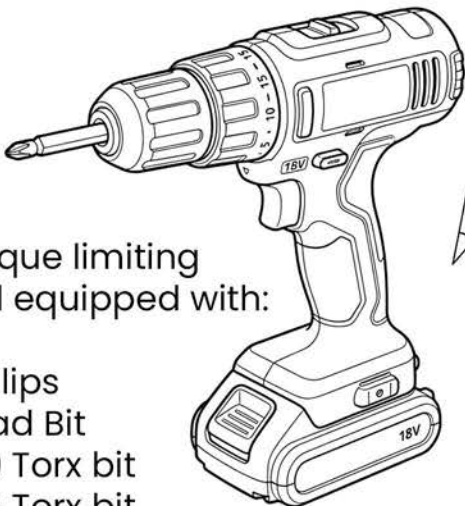


Shims (12)

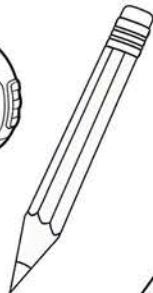
TOOLS NEEDED

Torque limiting
drill equipped with:

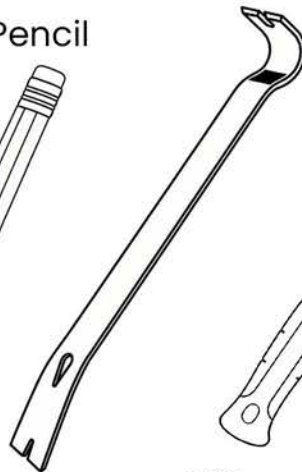
Phillips
Head Bit
T20 Torx bit
T25 Torx bit
3/32 drill bit
9/64 countersink taper drill bit



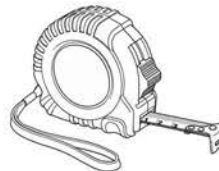
Pencil



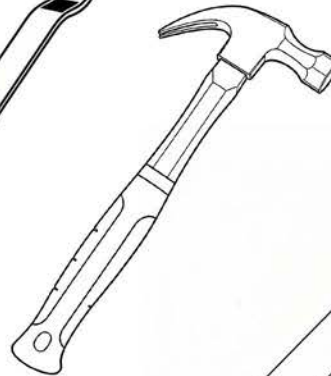
Pry
Bars (2)



Tape Measure

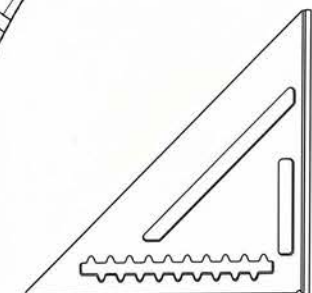


Hammer



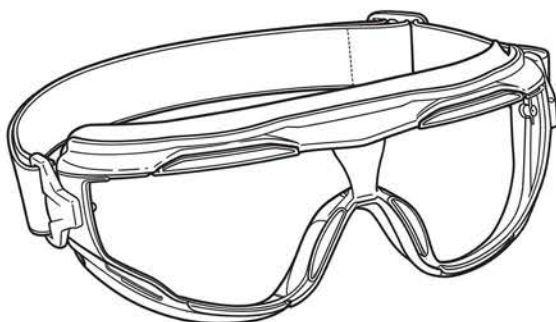
Square
Tool

Small Framing
Square or similar

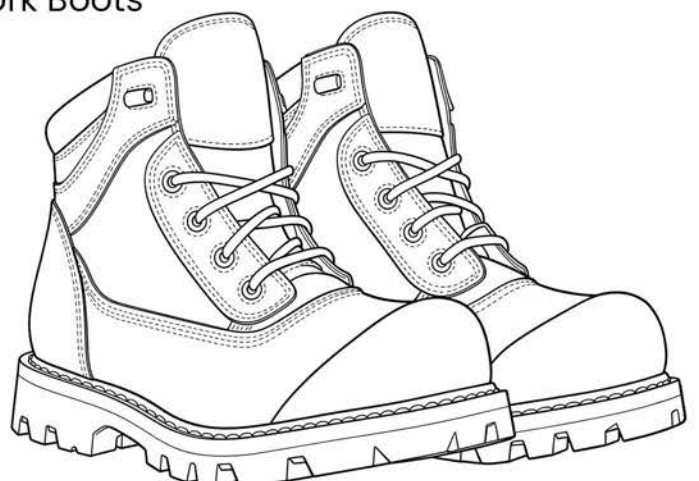


PPE

Safety Glasses



Work Boots



NOTICE

Verify that you have all the required parts, tools,
and PPE before beginning installation.

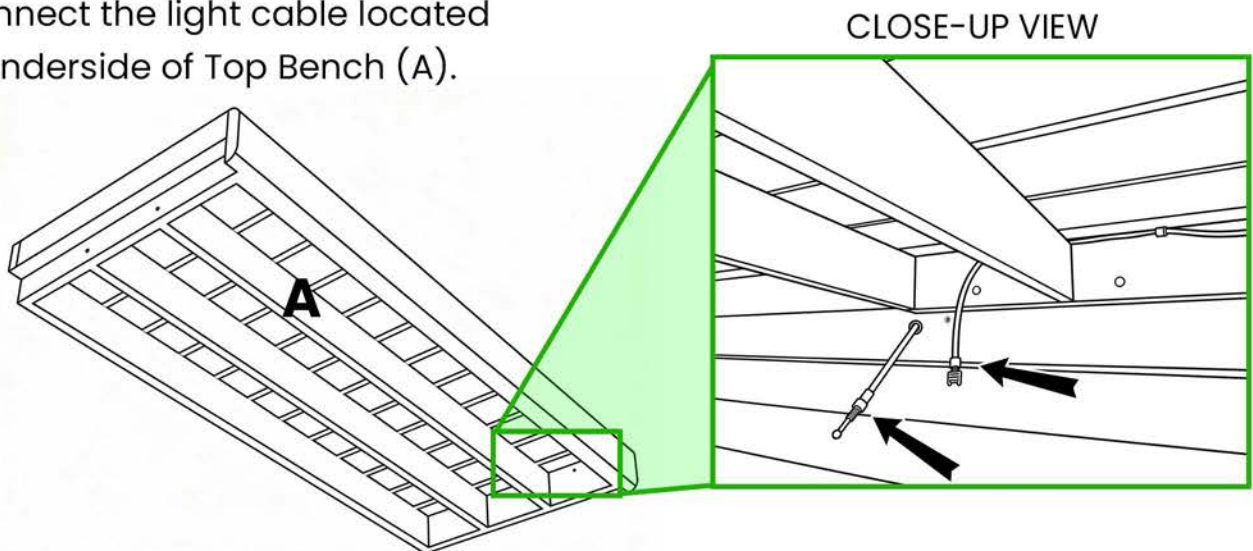
⚠ WARNING

- Disconnect power to the sauna before performing any work and follow all applicable electrical and safety codes during installation.
- Wear WORK BOOTS and SAFETY GLASSES.
- Ensure heater rocks are cool before beginning to avoid burns and property damage.

STEP 1. REMOVE TOP BENCH (A)

Prior to starting the installation, prop the sauna door open and keep it open throughout the installation procedure.

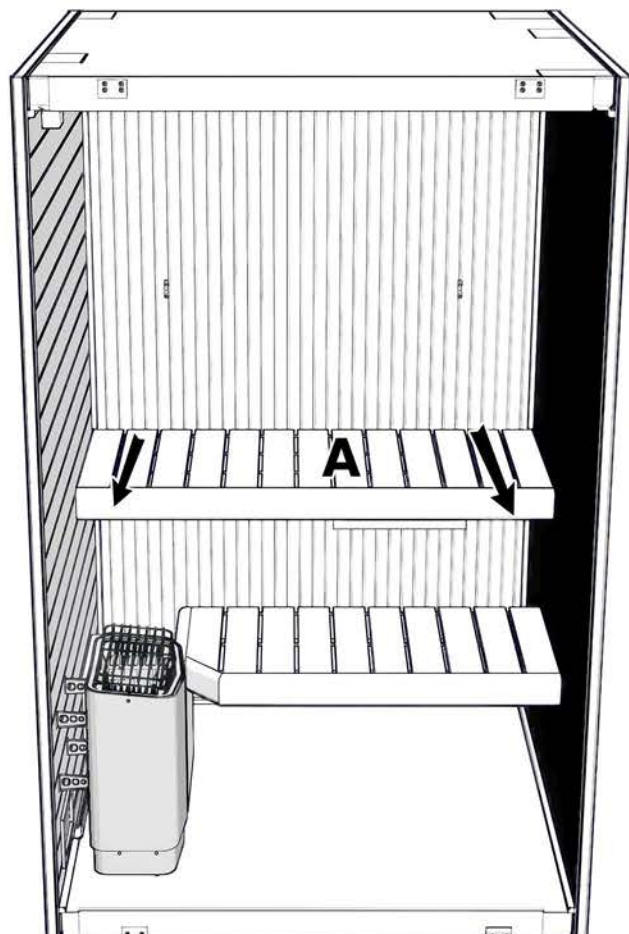
1.1 Disconnect the light cable located on the underside of Top Bench (A).



1.2 Slide Top Bench (A) forward and lift it out. Carefully rotate the bench to be angled vertically for easier removal from the sauna.

⚠ CAUTION

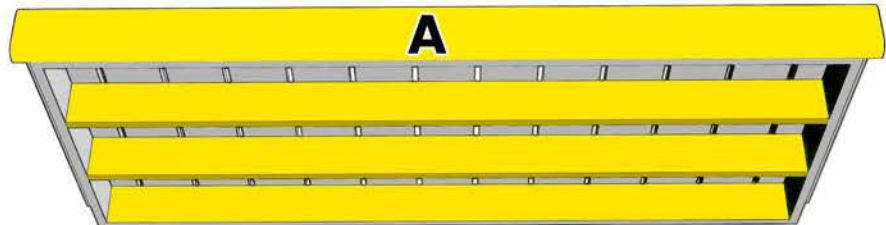
Do not strike glass door, walls, ceiling, or heater with the bench in order to avoid potential damage.



CHECK THE TOP BENCH FOR DAMAGE

WARNING

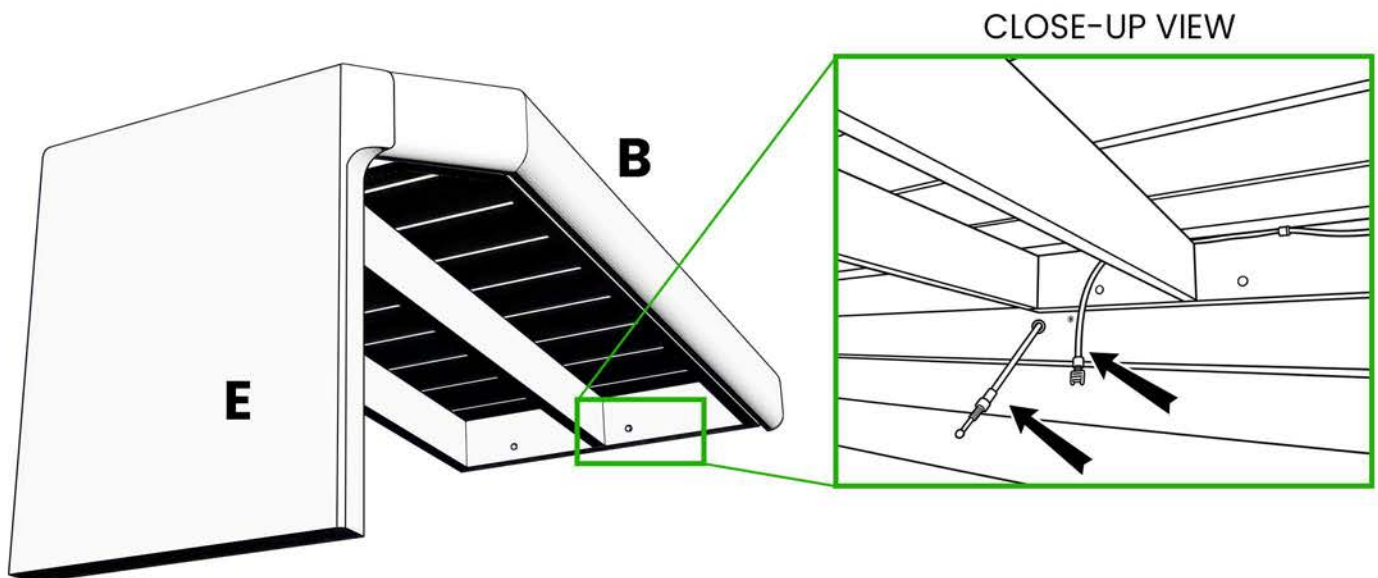
- Damaged stringers (highlighted in yellow) can weaken the bench structure and may result in bench failure, causing injury.
- If there are cracks through the stringers, the bench should be replaced. Contact 888-780-4427 (Menu Option - 2) if you are unsure whether bench needs to be replaced.



STEP 2. REMOVE LOWER BENCH STRUCTURES (B, E)

2.1 Disconnect the light cable located on the underside of the bench.

2.2 Remove the two screws connecting the Lower Bench (B) to the side wall using a Torque limiting drill. If there are screws installed connecting the Lower Bench Support (E) to the floor, remove them using a Torque limiting drill.



2.3 Lift the Lower Bench (B) up and rotate one end of it down to move it out of the sauna.

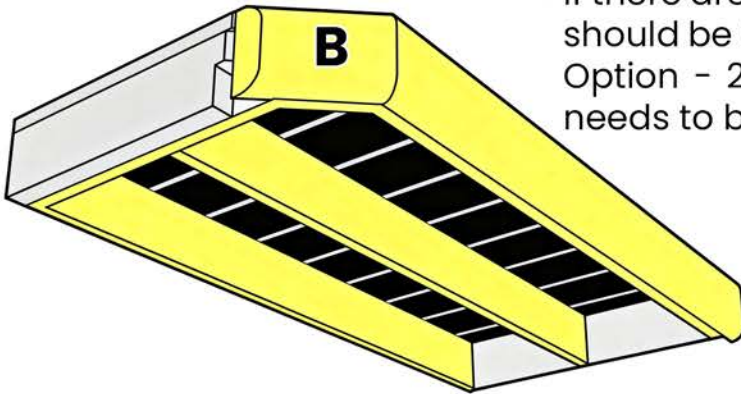
CAUTION

Do not strike glass door, walls, ceiling, or heater with the bench in order to avoid potential damage.

CHECK THE BOTTOM BENCH FOR DAMAGE

WARNING

- Damaged stringers (highlighted in yellow) can weaken the bench structure and may result in bench failure, causing injury.
- If there are cracks through the stringers, the bench should be replaced. Contact 888-780-4427 (Menu Option - 2) if you are unsure whether the bench needs to be replaced.

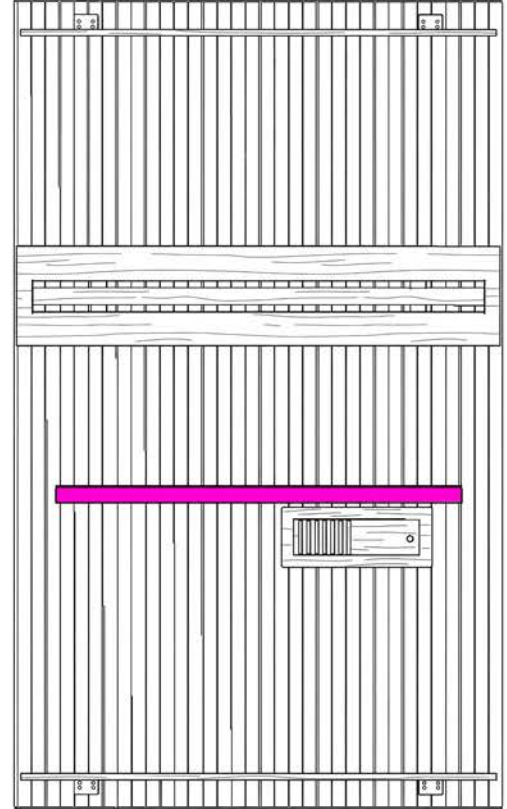


STEP 3: REMOVE BACK WALL CLEAT

3.1 If the back wall of the sauna has cleats installed, remove them before proceeding (highlighted in pink). If there are no back wall cleats, proceed to Step 4.

TO REMOVE BACK WALL CLEATS:

- First, remove all screws.
- After removing the screws, strike cleat with a hammer to break it free from the wall. You may have to strike from the bottom of the cleat to clear other structures.
- As an alternative to the hammer, pry bars may also be used.
- Insert the pry bar between the cleat and the wall at one end of the cleat.
- Apply steady pressure to create a small gap between the cleat and the wall.
- Once a gap is visible, insert the second pry bar a short distance away from the first pry bar and gently pry outward to widen the separation.
- Work along the length of the cleat, using the two pry bars as described to gradually increase the separation until the adhesive releases and the cleat can be carefully removed from the wall.

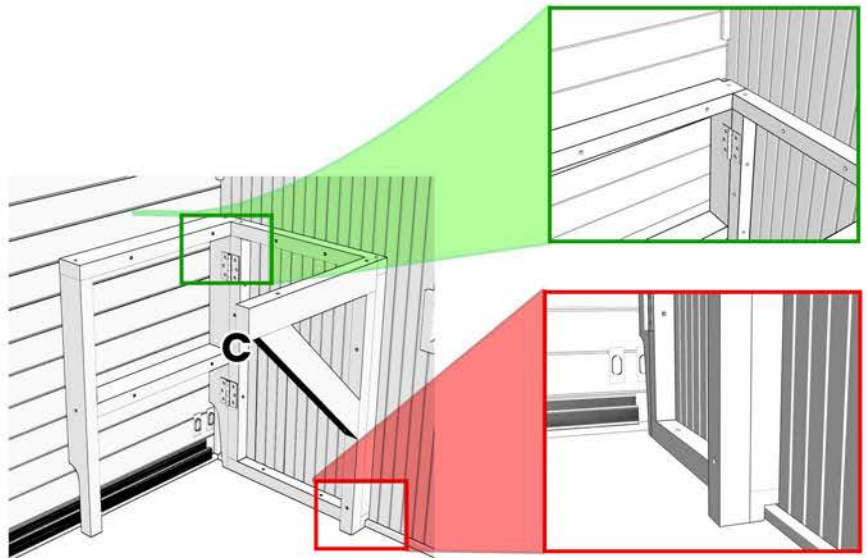


CAUTION

Avoid contact with other structures to avoid damage.

STEP 4. INSTALL TOP BENCH SUPPORTS (C,D)

4.1 Place Left Side Top Bench Support (C) into the left corner of the sauna. Ensure that the trim is seated entirely in the groove for the top left and bottom right (as pictured in green and red respectively).



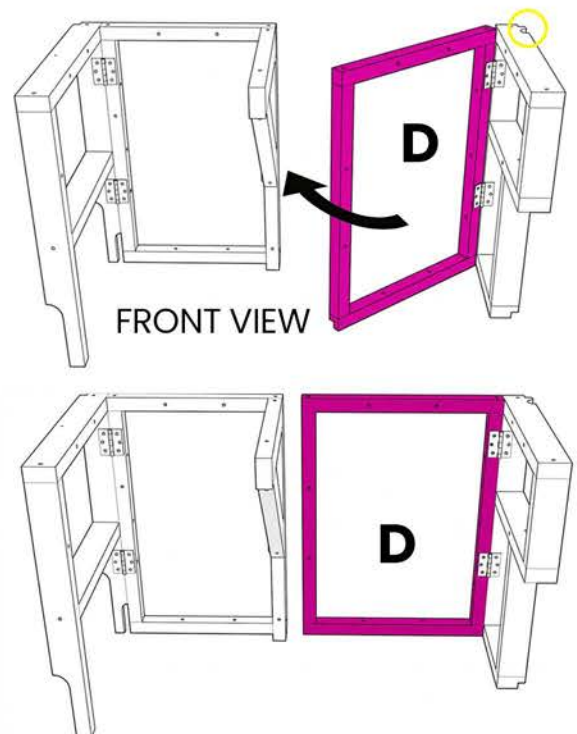
The leg of the support in the left corner will fit between the cables entering the sauna. Route the cable entering the sauna from the back wall to the right of the support leg through the space provided. Route the cables entering the sauna from the left side wall to the left of the support leg through the space provided.

4.2 Place Right Side Top Bench Support (D) into the right corner of the sauna by placing it in the back right corner of the wall.

4.3 Route the lighting cable through the notch in the Right Side Top Bench Support (circled in yellow).

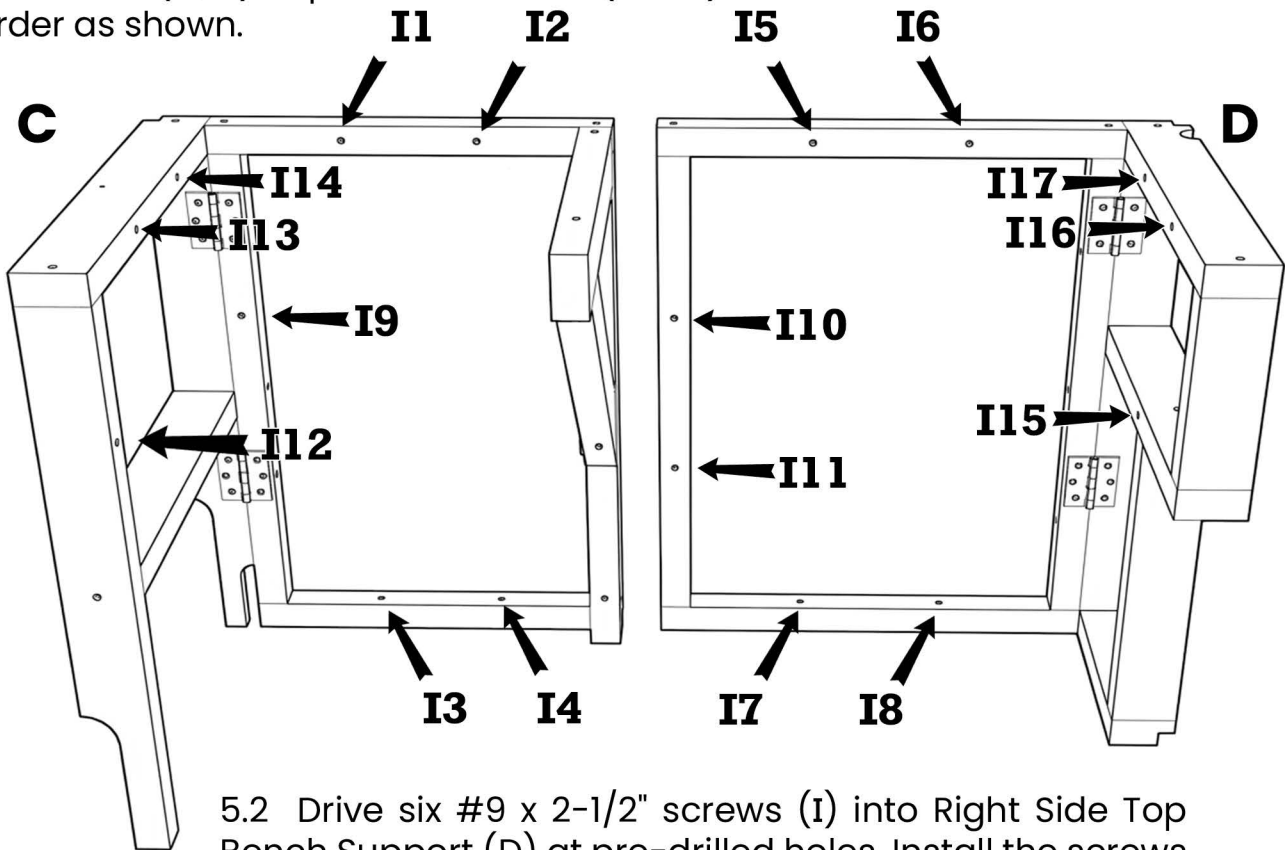
4.4 Ensure that the sauna corner trim along the wall is seated entirely in the groove of Right Side Top Bench Support (D) (highlighted in pink).

4.5 Then, the back side of Right Side Top Bench Support (D) can be pushed back against the back wall of the sauna.

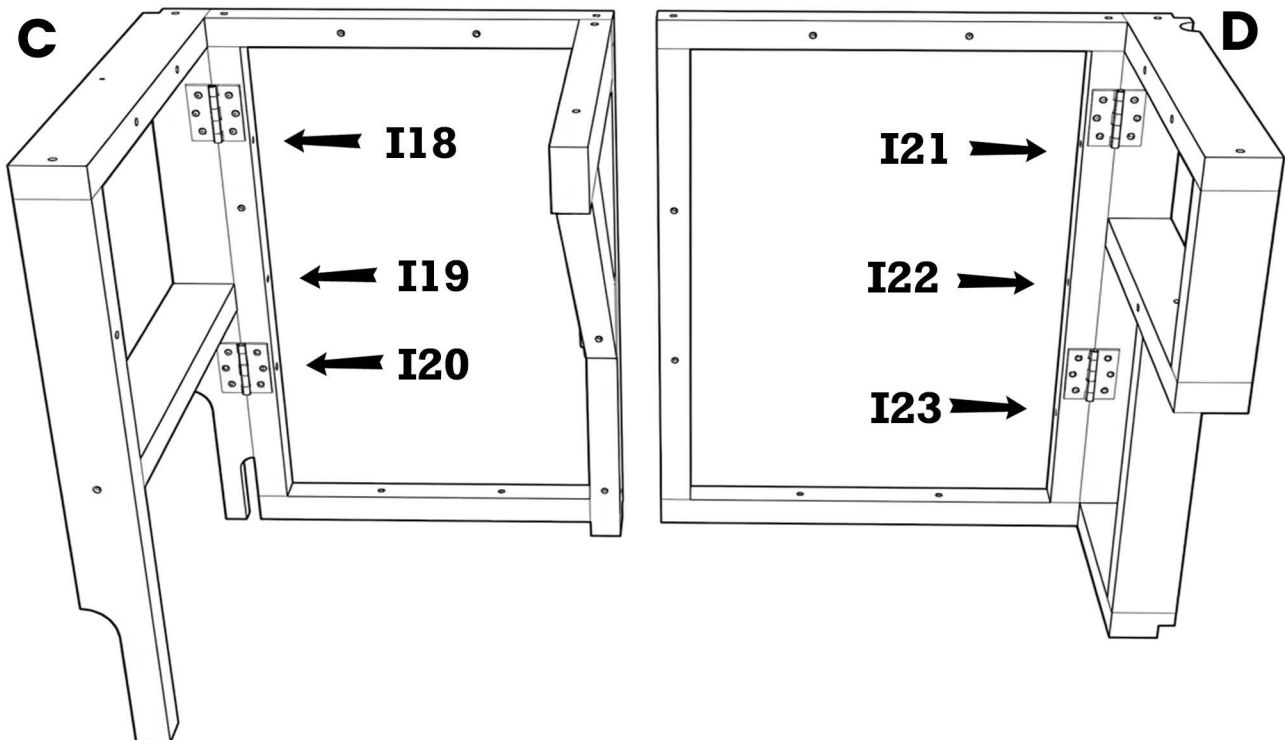


STEP 5: SECURE TOP BENCH SUPPORTS (C, D)

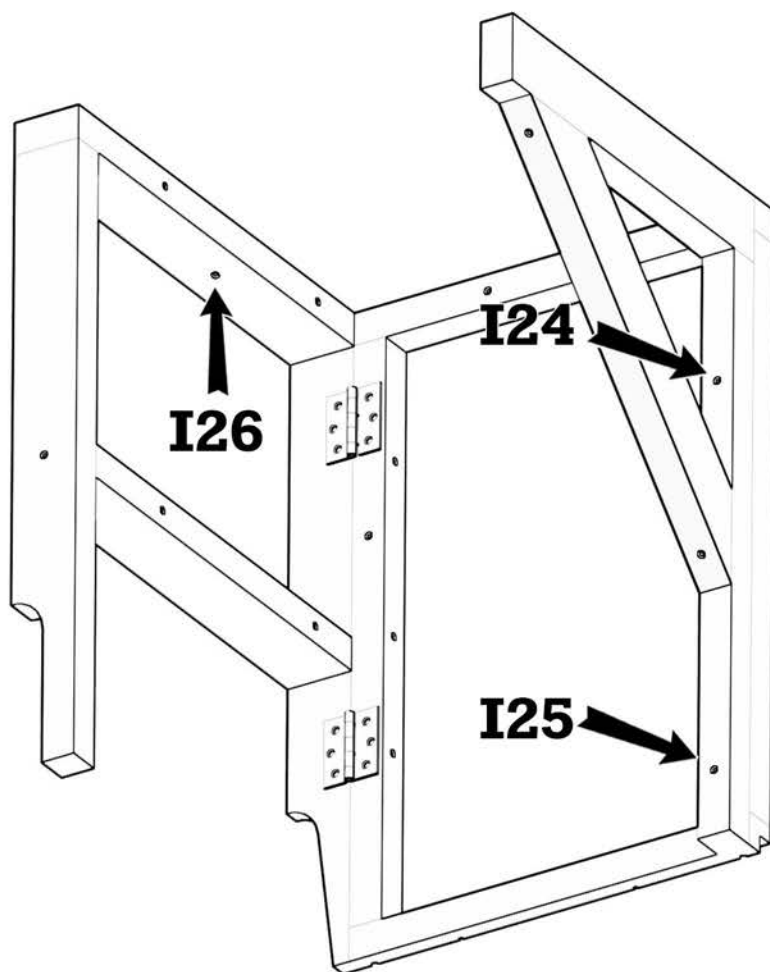
5.1 Drive seventeen #9 x 2-1/2" screws (I) into the Left Side Top Bench Support Structures (C, D) at pre-drilled holes (I1- I17). Install the screws in numerical order as shown.



5.2 Drive six #9 x 2-1/2" screws (I) into Right Side Top Bench Support (D) at pre-drilled holes. Install the screws in numerical order (I18-I23) as shown. Ensure all screws are flush and do not strip screw.



5.3. Drive three #9 x 2-1/2" screws (I) into the Left Side Top Bench Support (C) at pre-drilled holes (I24-I26)

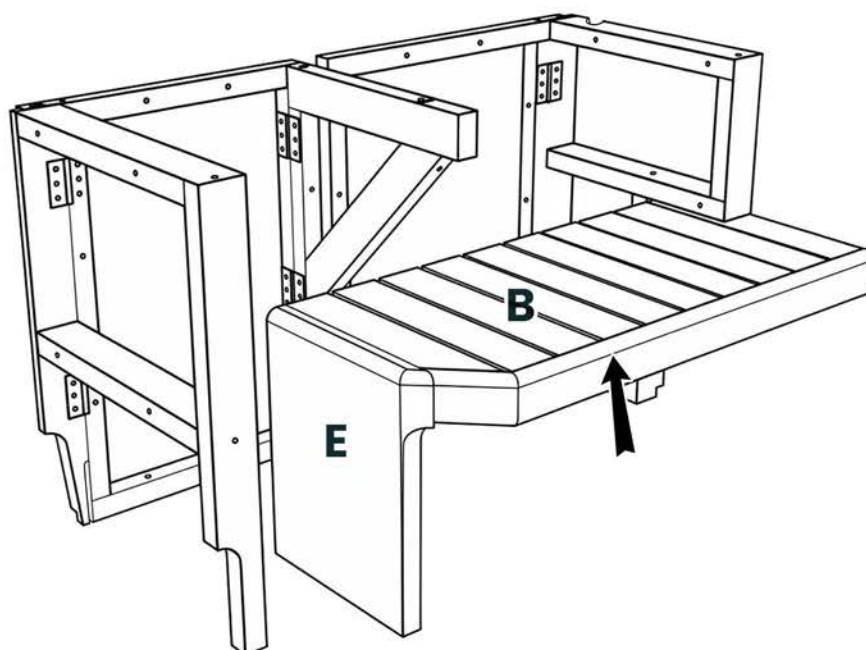


STEP 6. RE-INSTALL LOWER BENCH (B, E)

6.1 Bring the assembled Lower Bench (B+E) into the sauna and slide it between the side cleat and Right Side Top Bench Support (D), flush against the wall on the right.

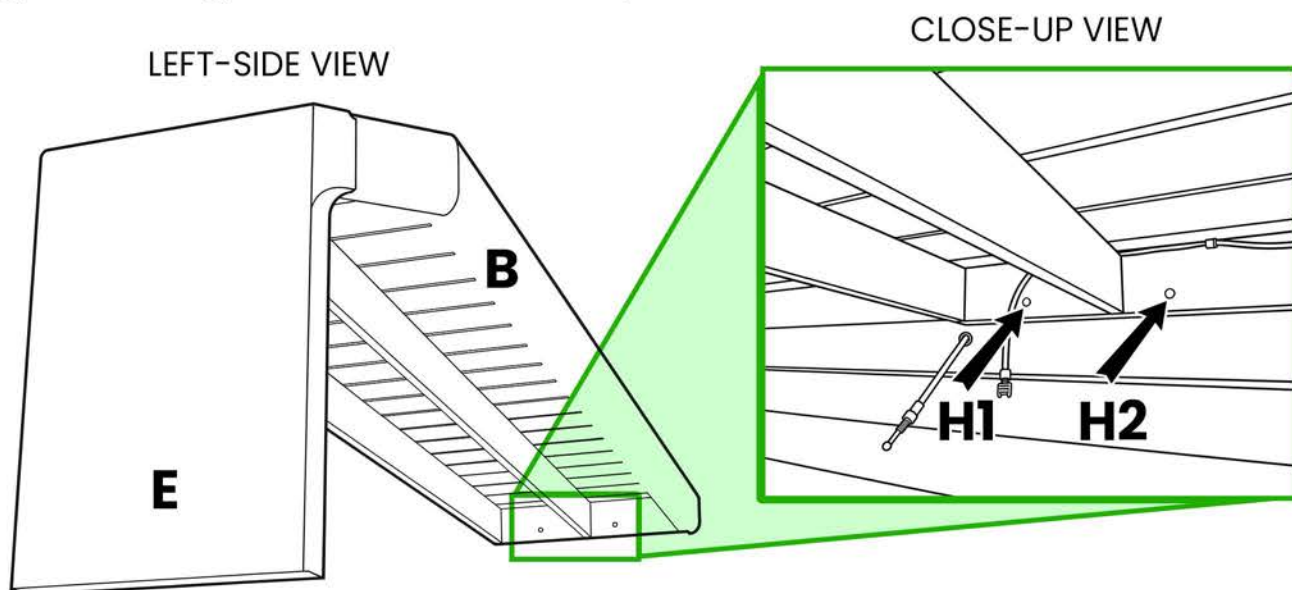
⚠ CAUTION

Do not strike glass door, walls, ceiling, or heater with the bench in order to avoid potential

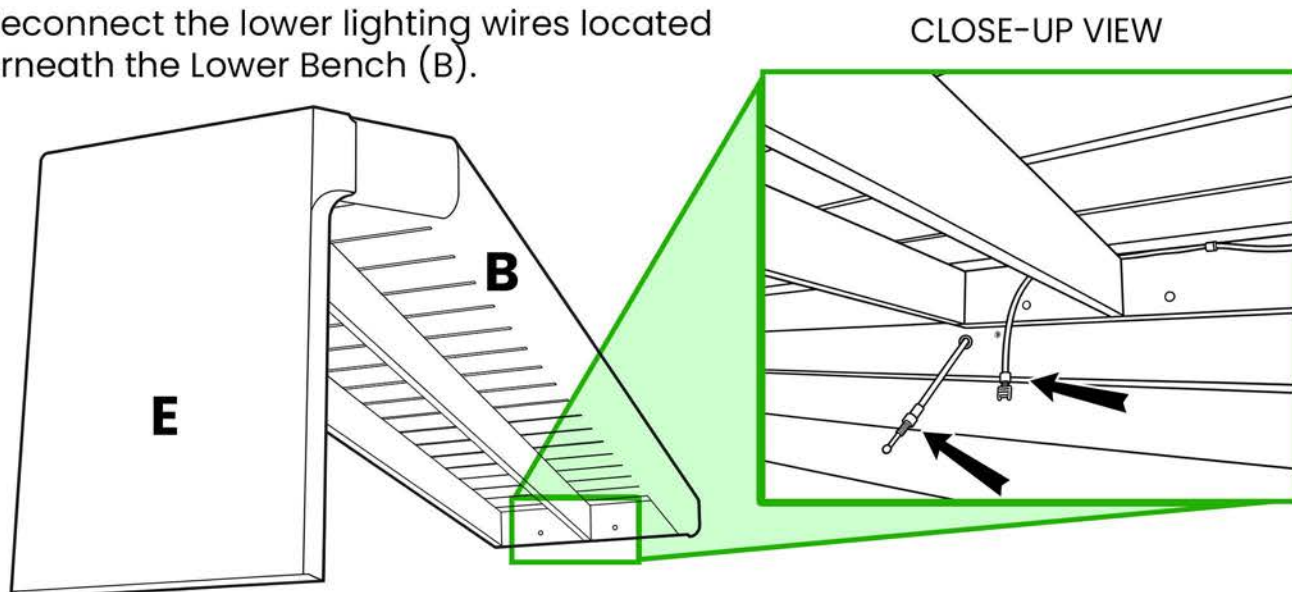


STEP 6. RE-INSTALL LOWER BENCH (B, E)

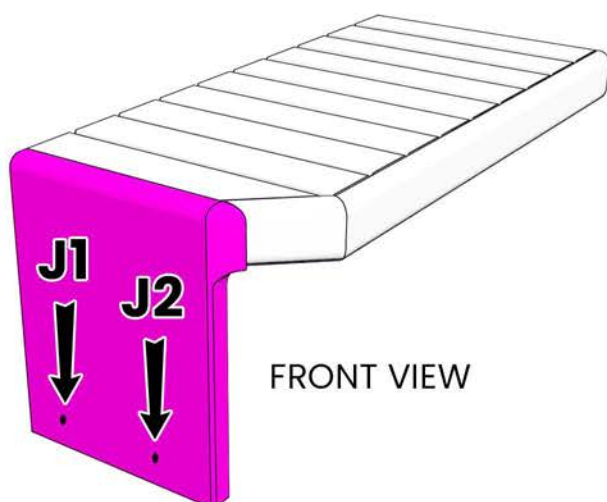
6.2 Drive two #9 x 2" screws (H) into the inner right side of the Lower Bench (B), against the right wall of the sauna at pre-drilled holes.



6.3 Reconnect the lower lighting wires located underneath the Lower Bench (B).



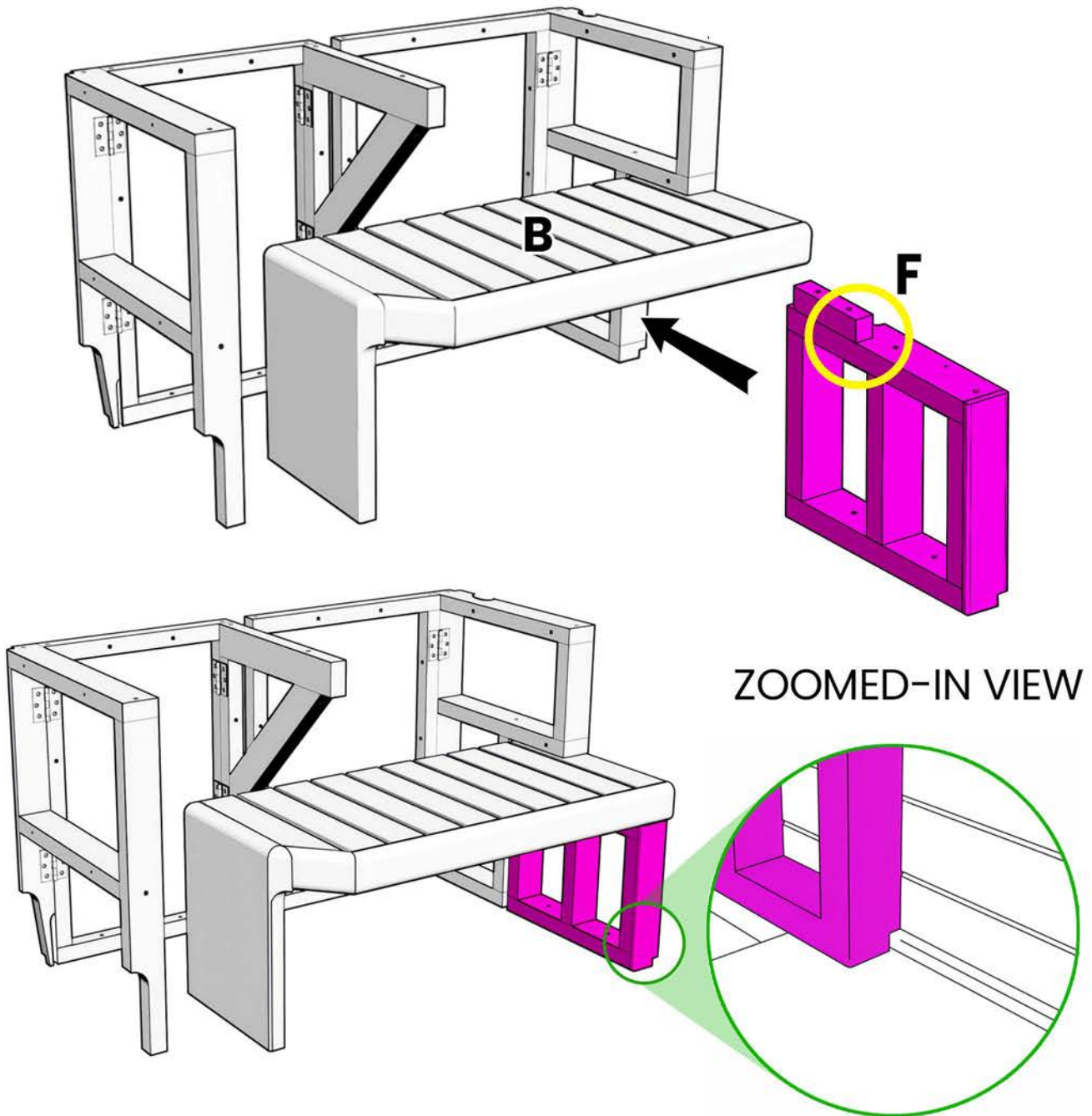
6.4 Drive in two #8 x 2" Button Head screws (J) into the pre-drilled holes on the bottom of the outer left side of the Lower Bench Support (E).



STEP 7. INSTALL THE WALL SIDE LOWER BENCH SUPPORT (F)

7.1 Align Wall Side Lower Bench Support (F) such that the top alignment block sits between the back two stringers of the Lower Bench (B). Route lighting cable through notch in Wall Side Lower Bench Support (F).

Make sure that the front of the Wall Side Lower Bench Support (F) is behind the dark brown front edge of the Lower Bench (B) and beneath the stringer. Make sure that the Wall Side Lower Bench Support (F) is flush with the wall, with the sauna corner trim in the mitigation groove. Ensure the lighting cable is routed through the notch (circled in yellow).



STEP 8. SECURE THE WALL SIDE LOWER BENCH SUPPORT (F)

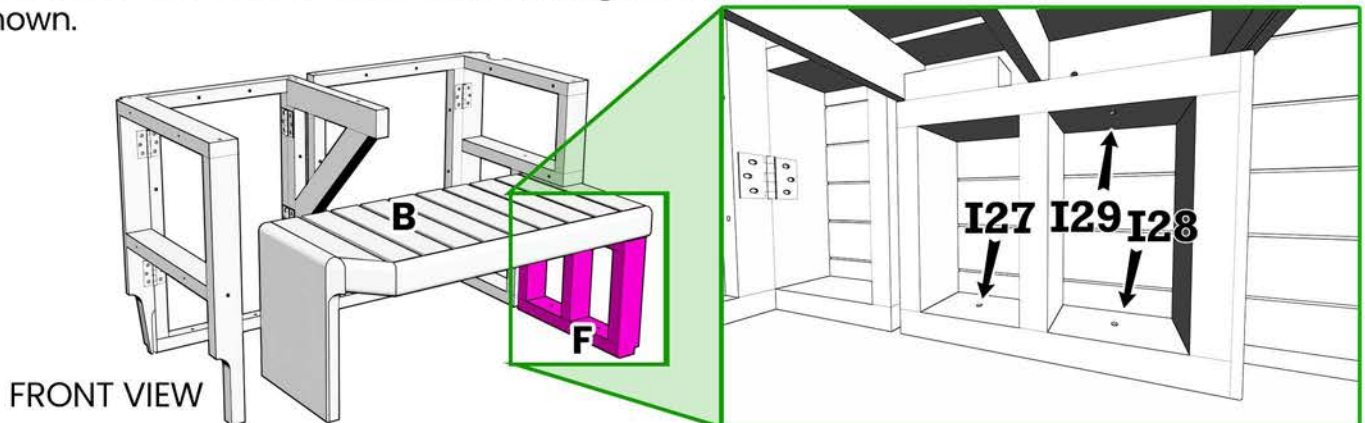


WARNING Gap between Lower Bench (B) and Wall Side Lower Bench Support (F) can result in bench collapse and serious injury.

If there is a gap between the Wall Side Lower Bench Support (F) and the Lower Bench (B) slide in the supplied shims to eliminate the gaps.

To secure shim, drill a pilot hole through the middle of the shim 1 inch deep into the support. Drive a #6 x 3/4" screw (L) into the pilot hole through the shim and support.

8.1 Make sure the Wall Side Lower Bench Support (F) is flush against the wall and confirm that it is underneath all lower bench stringers. Then drive three #9 x 2-1/2" screws (I) as shown.



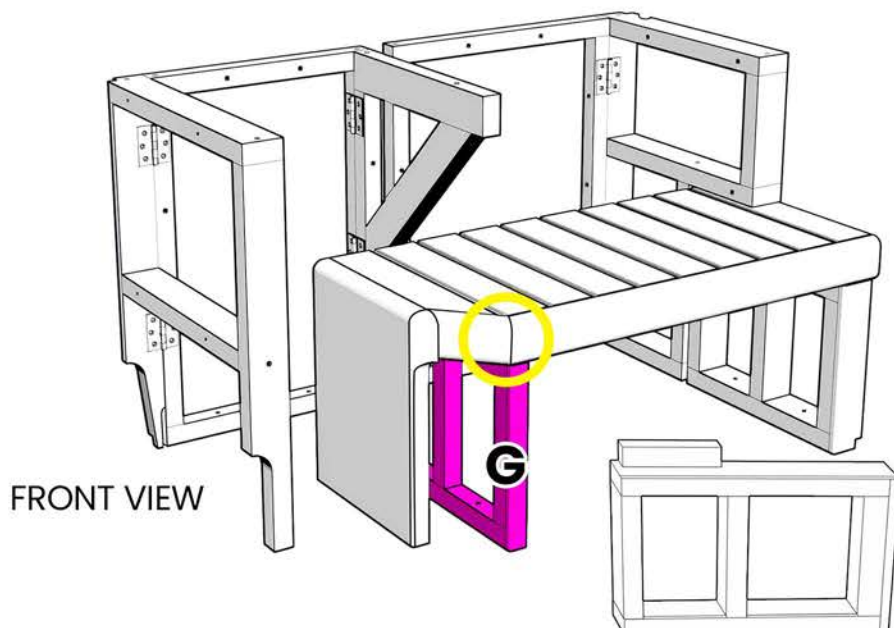
STEP 9. INSTALL THE LOWER BENCH MIDSPAN SUPPORT (G)

9.1 Place Lower Bench Midspan Support (G) underneath the Lower Bench (B) directly underneath the corner of the Lower Bench (B) (circled in yellow).

Align the lower bench midspan support (G) such that the top alignment block (highlighted in pink) sits between the back two stringers.

Slide Lower Bench Midspan Support (G) into place, move it up and down as necessary.

Use a Small Framing Square or similar to ensure the support is perpendicular to the floor and Lower Bench (B).



CANTILEVER (Part of C)



STEP 10. SECURE THE LOWER BENCH MIDSPAN SUPPORT (G)



WARNING Gap between Lower Bench (B) and Lower Bench Midspan Supports (G) can result in bench collapse and serious injury.

If there is a gap between the Lower Bench Midspan Support (G) and the Lower Bench (B) slide in the supplied shims to eliminate the gaps.

To secure shim, drill a pilot hole through the middle of the shim 1 inch deep into the support. Drive a #6 x 3/4" screw (L) into the pilot hole through the shim and support.

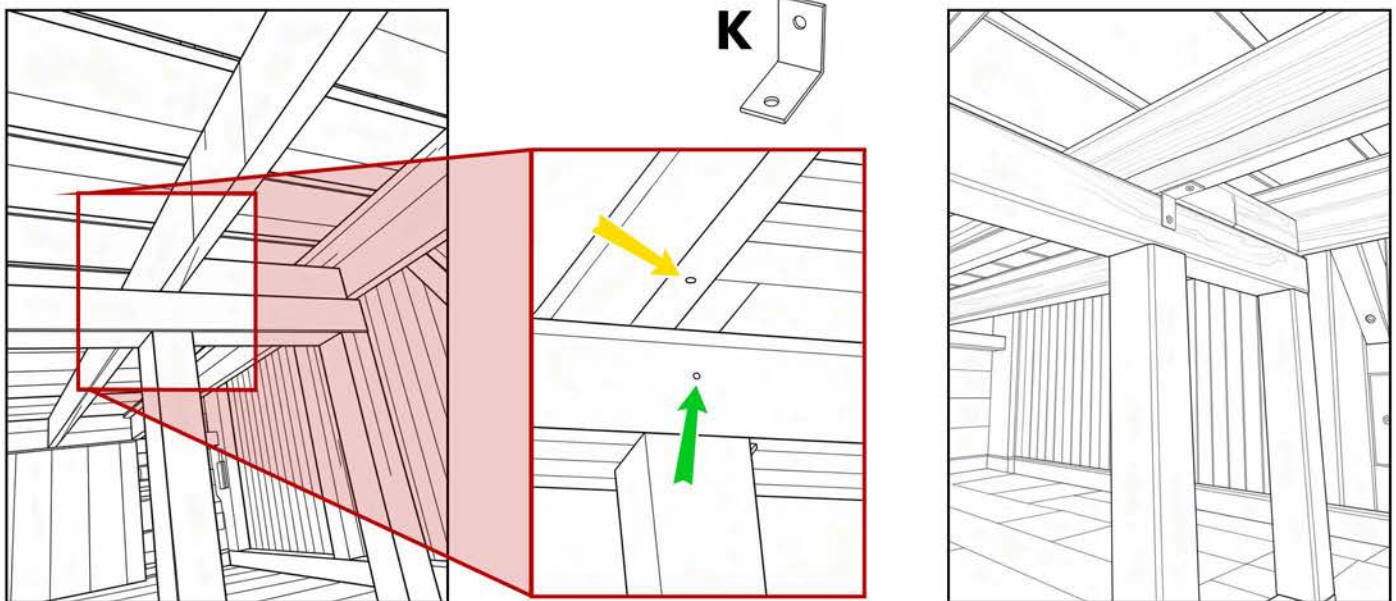
10.1 Install the Metal Bracket (K) in the Lower Bench Midspan Support (G).

10.2 Position the Metal Bracket (K) over the pre-drilled hole (green arrow).

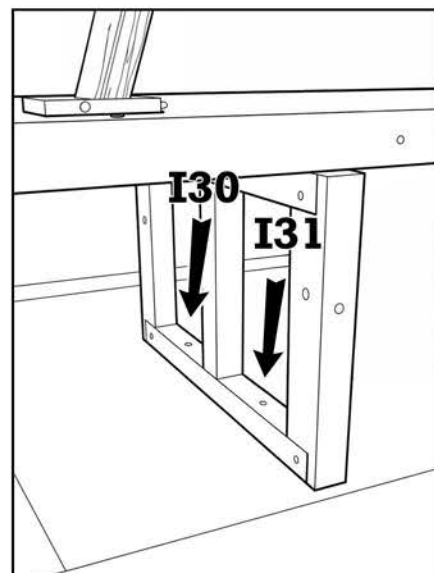
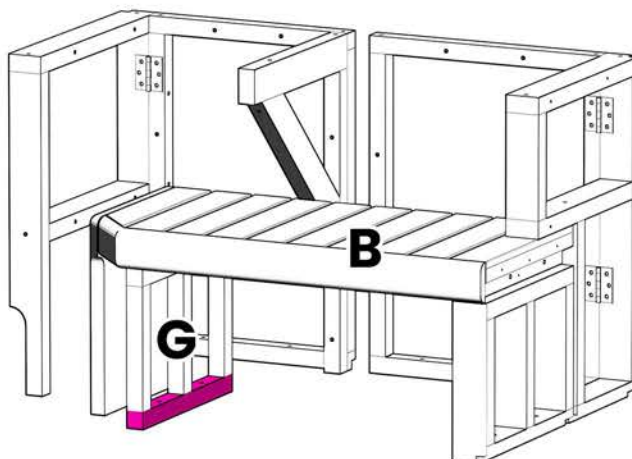
10.3 Mark the location of the upper hole (yellow arrow) through the Metal Bracket (K) using a pencil.

10.4 Drill a pilot hole into the Lower Bench (B) stringer approximately 1" deep (yellow arrow) using a 3/32" Drill Bit.

10.5 With the Metal Bracket (K) aligned over the pilot holes, drive in two #6 x 3/4" screws (L) in using a Torque limiting drill.



10.6 Drive two #9 x 2-1/2" screws (I) through the bottom of the lower bench midspan support (G) into the sauna floor.



STEP 11. RE-INSTALL THE TOP BENCH (A)

11.1 Place the Top Bench (A) in the sauna.

⚠ CAUTION

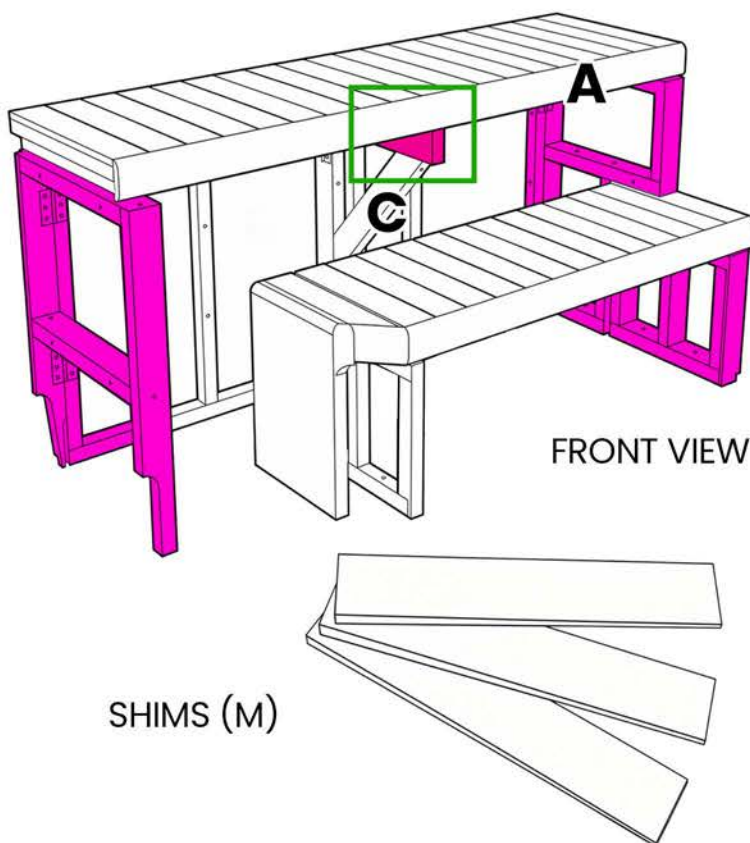
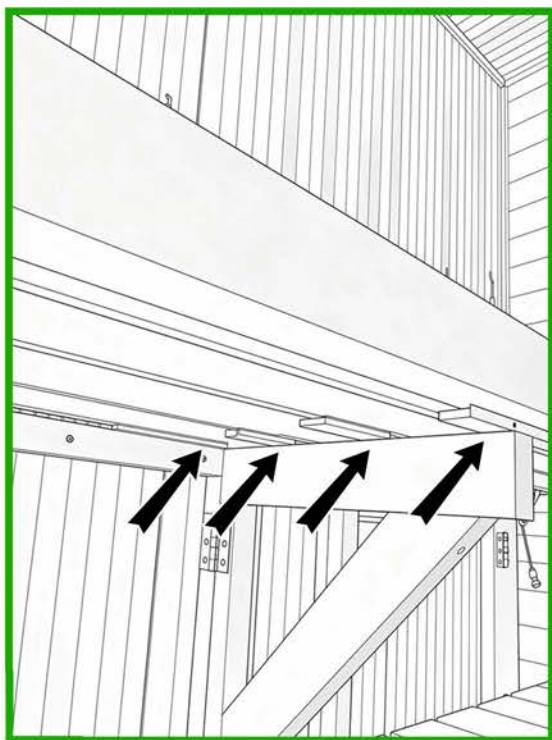
Do not strike glass door, walls, ceiling, or heater with the bench in order to avoid potential damage.

11.2 Check for gaps between the Top Bench (A) and the Left and Right Upper Bench Supports (C,D), including both the sides of the supports attached to the walls and the cantilever. Slide in and secure the supplied shims to eliminate the gaps.

To secure shim, drill a pilot hole through the middle of the shim into the support. Drive a #6 x 3/4 screw (L) into the pilot hole through the shim and support. Once the shims are secure, re-install the Top Bench (A).

⚠ WARNING

Gap between Top Bench (A) and bench supports (C, D) can result in bench collapse and serious injury.



STEP 12. SECURE TOP BENCH (A)

12.1 Connect the light cable located on the underside of Top Bench (A).

12.2 Install the Metal Bracket (K) on the right side of the cantilever of the Left Side Top Bench Support (C).

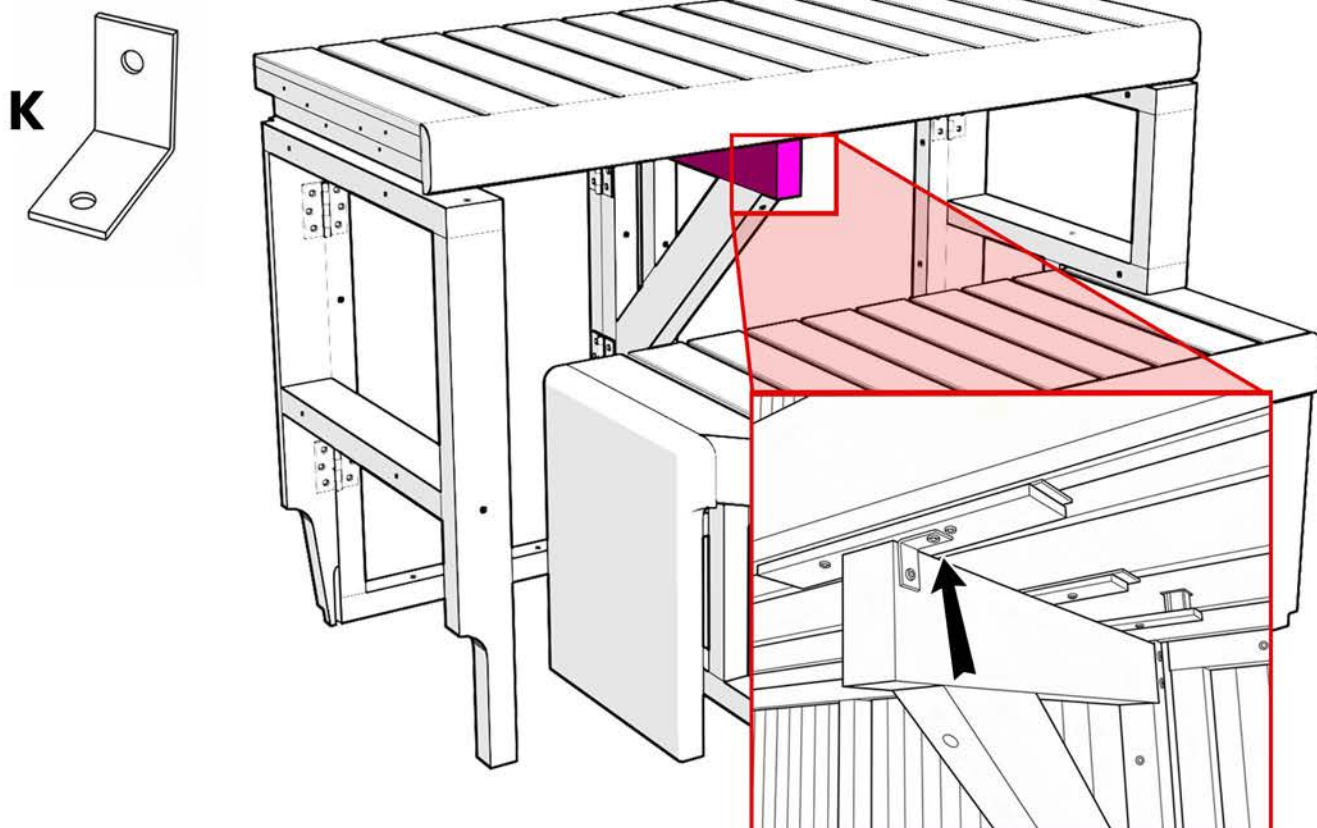
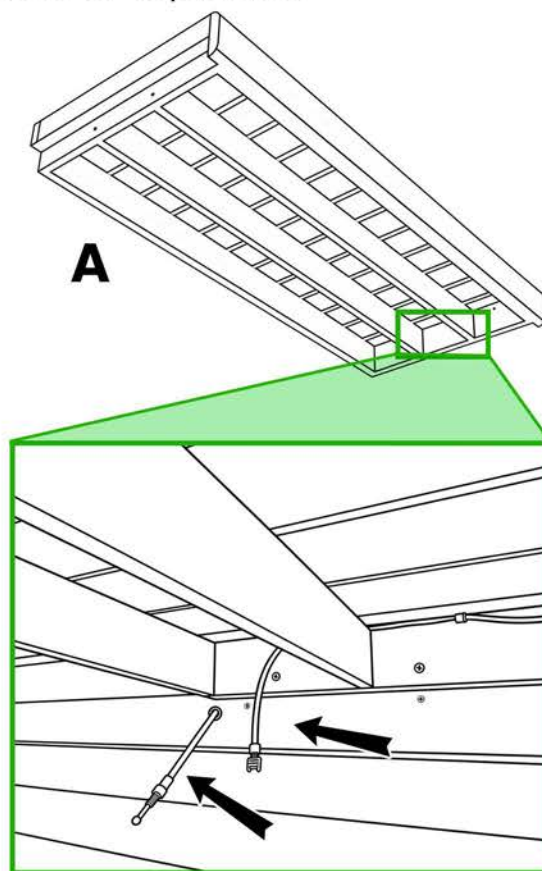
Position the Metal Bracket (K) at the front right side of the cantilever and mark the location of the upper and lower hole through the Metal Bracket (K) with a pencil.

If there is a gap the upper hole location will be on the shims.

If there is no gap, the upper hole location will be on the underside of Top Bench (A).

Drill a pilot hole into Top Bench (A) and cantilever approx. 1" deep (black arrow) using a 3/32" Drill Bit.

With the Metal Bracket (K) aligned over the pilot holes, drive the screws in using #6 x 3/4" screws (L).



INSTALLATION CHECKLIST

- ☐ All screws, bolts, and brackets are installed and fully tightened.
- ☐ Bench components are securely attached and properly aligned.
- ☐ No gaps, loose components, or visible damage are present.
- ☐ The bench and surrounding components are level and stable.
- ☐ All packaging materials, tools, and debris have been removed from the sauna.
- ☐ All wiring is secure.
- ☐ A final visual inspection has been completed and the installation meets all requirements in this manual.

Confirm that the sauna is working properly.

Do not place the sauna into service until all checklist items have been verified.

